HYDRAULIC ROD CUTTER

All PPT Rod Cutters are designed for heavy duty rod cutting operations for various applications in steel industries and also for longer service life.

Model No: HRC-40

FEATURES

- Forged alloy steel heat treated “C” frame type cylinder body used.
- Single return spring design
- Special quality sealing for specified pressure
- High wear resistant Moving cutter guide square bushing for accurate cutter alignment
- Easy to operate & maintain
- Lighter in weight than Cast Steel design
- Unique design of cutters and special steel used for longer life
- Wide range of Power Pack used for different application of the user requirement
- Single piece ram & piston design for easy maintenance
- Suitable tool hanger fitted to positioning the tool at any angle for easy to operate

SPECIFICATION:

There are three types of cutters available for hydraulic rod cutters

<table>
<thead>
<tr>
<th>TYPE-C</th>
<th>TYPE-S</th>
<th>TYPE-P</th>
</tr>
</thead>
<tbody>
<tr>
<td>SQUARE CUT OR CLEAN CUT CUTTER</td>
<td>STANDARD CUTTER</td>
<td>“V” OR PINCH CUTTER</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Weight</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>lb</td>
<td>inch</td>
<td>mm</td>
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<tr>
<td></td>
<td>kg</td>
<td>mm</td>
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<td>mm</td>
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<tr>
<td>HRC-40</td>
<td>99</td>
<td>24.2</td>
<td>615</td>
<td>7.8</td>
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<td></td>
<td>45</td>
<td></td>
<td></td>
<td>200</td>
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<td>15.7</td>
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<td></td>
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<td>400</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Dia capacity (in.)</th>
<th>Grade of steel to be cut</th>
<th>Tensile strength N/mm²</th>
<th>Shear Strength N/mm²</th>
<th>Cutting Force reqd. kN</th>
<th>Cutting force generated by cutter kN</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRC-40</td>
<td>1.57” (40mm)</td>
<td>Mild Steel</td>
<td>700</td>
<td>420</td>
<td>528</td>
<td>830</td>
</tr>
<tr>
<td>Model No.</td>
<td>Dia capacity (in.)</td>
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<td>HRC-40</td>
<td>1.30” (33mm)</td>
<td>Low Alloy Steel</td>
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<td>600</td>
<td>513</td>
<td>830</td>
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<td>HRC-40</td>
<td>1.14” (29mm)</td>
<td>Medium Alloy Steel</td>
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<td>780</td>
<td>515</td>
<td>830</td>
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<tr>
<td>HRC-40</td>
<td>1.02” (26mm)</td>
<td>High Alloy Steel</td>
<td>1600</td>
<td>960</td>
<td>510</td>
<td>830</td>
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</tbody>
</table>

**Note:**
1. Considering shear strength to be 60% of tensile strength.
2. Radial Piston pump and directional controlled solenoid valve of capacity 550 bar, Imported from Switzerland.
3. If you send us the specification (Tensile strength and diameter of Bar) we shall recommend the right cutter for your application.

**OPERATIONAL MANUAL**
1. Check the hose and control cable connectors match with that of the Rod Cutter.
2. Attach the hydraulic hose from the power pack to the machine properly so that there can be no leaking of hydraulic fluid.
3. Connect the control cable from the power pack solenoid valve to the Rod Cutter.
4. Connect the power cable of the power pack to a suitable wall mounted power outlet and switch on the power pack, **do not press the switch on the handle of the Rod Cutter right now.**
5. Let the power pack idle (oil flowing from pump to tank) for a couple of minutes.
6. Now place the rod to be cut between the moving and stationery cutter pushing the rod so that it touches the side wall of the housing.
7. This is to ensure that the **full diameter of the job is within the width of the cutters.**
8. Adjust the **stopper screw** so that the rod sits flat on the stationery cutter.
9. Hold the job with a gloved hand and see that nobody is standing on the other side. Press the trigger.
10. Wait for the moving cutter to retract fully before advancing the rod between the cutters for the next cut.
11. Switch off the power pack and disconnect the power pack from the wall out-let after you finish.

**MAINTENANCE**
1. Keep all the bolts tight and joints oiled at all times.
2. Whenever the hydraulic fluid is changed, **also change the filter and clean the tank before filling up.**
3. Never drop the machine which may cause serious damage to it.
SAFETY INSTRUCTIONS
As for any high power cutting machine, the following safety precautions should be strictly observed during use of this machine:

1. Wear your safety shoes, gloves and safety glasses at all times. Remove oil or grease from your hand, tools and from the floor and area you will be working.
2. Use proper cutting tool as per type, size and hardness of metal to be cut.
3. While the machine is not in use, keep the power pack switched off, so that accidental pressing of trigger cannot cause any injury in case one keeps fingers between the cutters by mistake.
4. See that nobody is standing on the other end of the rod, because depending on the tensile strength of the material and flow rate of the power pack, the parted portion of the rod may shoot out at high speed causing injury.
5. Check that the balancer and hanging arrangement is strong enough to hold the combined weight of the cutter and the job.

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