



BLADE INSTALLATION INSTRUCTIONS FOR PNEUMATIC GATE CUTTERS

INSTALLATION

- 1) Remove the hex head cap screw as shown in **Figure C**.
- 2) Note the orientation of the two pivot pins that are still in the blade holder. There is a dot on one of the plates and a dot on the blade holder that must remain aligned when you reassemble the unit. Also note that on the top of the plates near the corners are grind lines like the ones shown in **Figure A**. The wide side of the plates must face the blades.

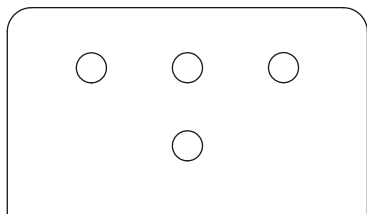
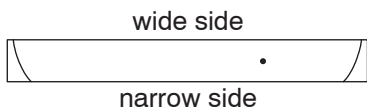


Figure A

- 3) Use a punch to knock the center pin thru and out, be careful this may be difficult.
- 4) Carefully slide the plates and the two pivot pins out of the blade holder.

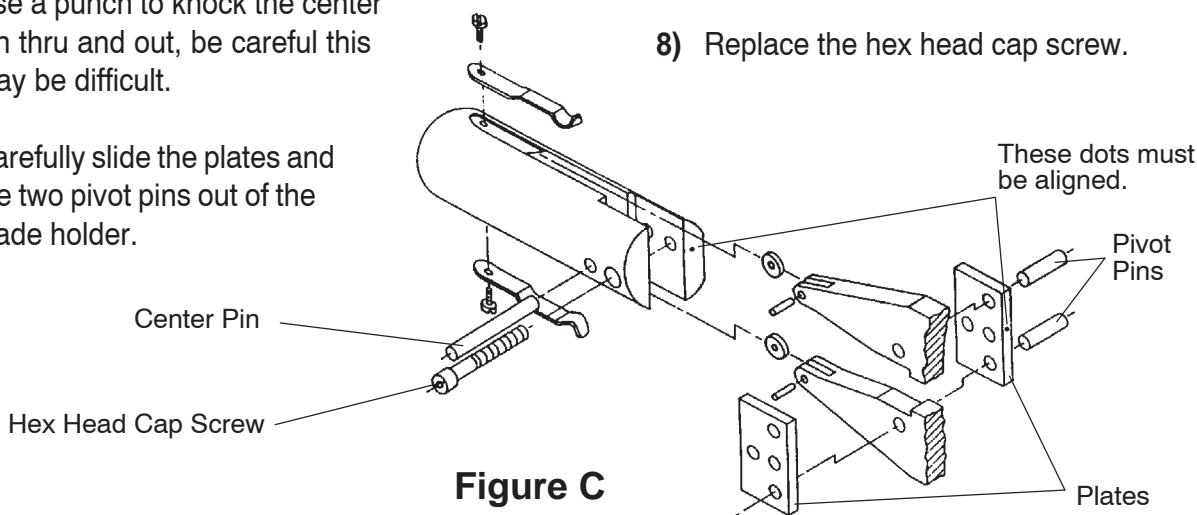


Figure C

- 5) Remove one of the plates off the pivot pins and position the blades on the pins so that the angle on the back of the blades will match the angle ground on the blade holder when reassembled, see **Figure B**. Remember you must line up the dots.

These angles must be aligned.

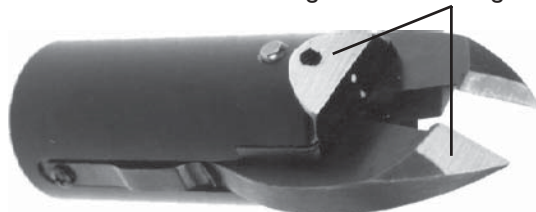


Figure B

- 6) Slide the plate back on top of the blades and replace the assembly in the blade holder making sure that the dots line up and the grind marks are aligned as explained in Step 2.
- 7) Replace the center pin, making sure to put the rounded end in the blade holder first, from the side opposite the hex head cap screw. Make sure the blades still move freely.
- 8) Replace the hex head cap screw.



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OPERATING INSTRUCTIONS FOR PNEUMATIC GATE CUTTERS

OPERATION

- 1) The maximum air pressure is 100 psi. For longest gate cutter and blade life we recommend that you use the lowest pressure to do the job, or as indicated on the gate cutter.
- 2) Gate cutters must be lubricated, either an in line oiler located no more than 6 ft. from the gate cutter or oil directly thru rear of power pack with several drops of good 10 weight non-detergent hydraulic oil weekly or as needed. Do not use penetrating oil which contains kerosine or other solvents.
- 3) Blades should be cleaned and foreign material removed weekly, more often if necessary.
- 4) Gate cutters can be made either right hand or left hand by reversing blades in housing. When blades are in place, pivot screw should fit snug against steel insert.
DO NOT OVERTIGHTEN.
- 5) If gate cutter is used in assembly line production, check pivot screw for tightness daily.



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