



E-Z CUTTER®

E-Z CUTTER®



Instructions for use



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ORDERING SPARE / REPLACEMENT PARTS

Manufacturing part numbers shown throughout this manual. To order spare parts, please use part numbers from the enclosed separate parts list.

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Operator Safety Information

This E-Z Cutter is designed for cutting pipe and tubing as specified. To accomplish the cutting function requires dexterity and mechanical skills as well as sound safety habits.

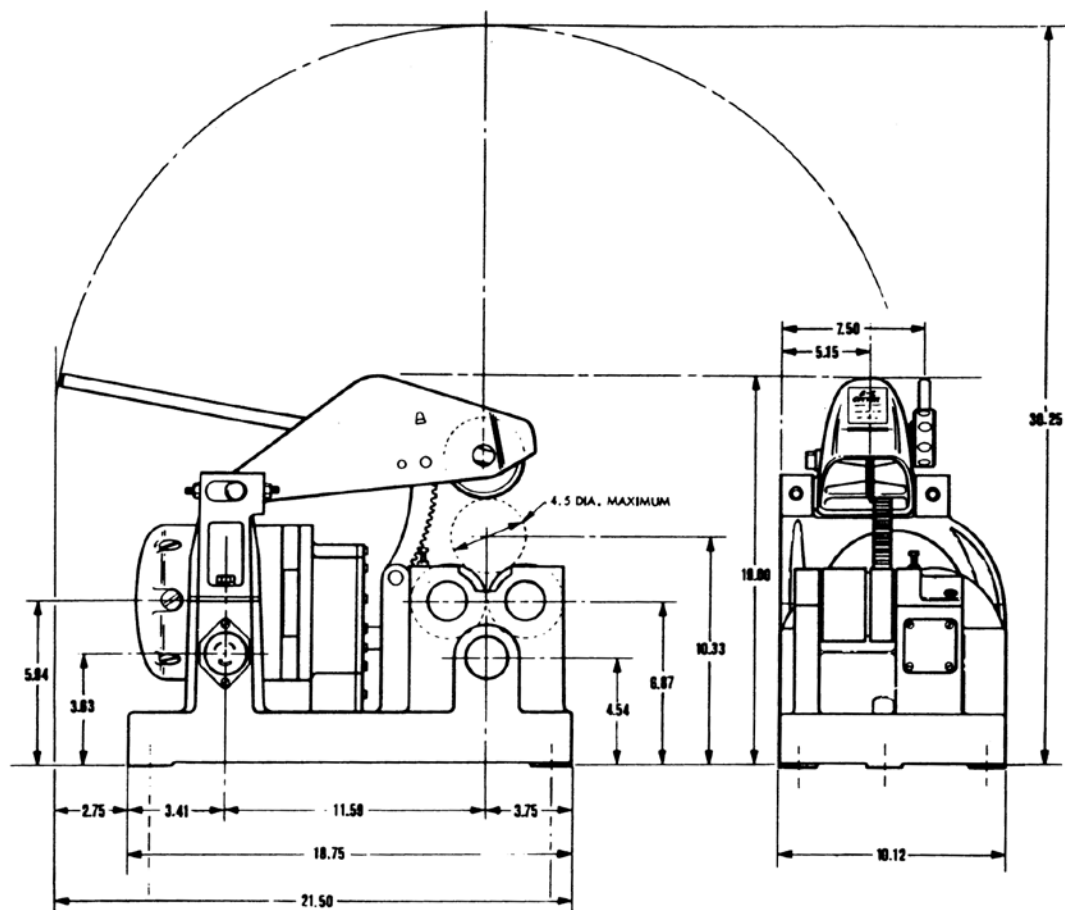
Although this machine is manufactured for safe, dependable operation, it is impossible to anticipate those combinations of circumstances which could result in an accident. The following instructions are recommended for safe operation of the machine.

The operator is cautioned to always practice "Safety First" during each phase of use, including setup and maintenance of this unit.

1. **Read and understand the Instruction Manual.** Before operating or performing maintenance on this machine, read the operator's manual carefully. Become familiar with the machine's operations, applications and limitations. Be particularly aware of its specific hazards. Store the operator's manual in a clean area and always at a readily available location. Additional copies are available for a nominal charge.
2. **Inspect the equipment.** Prior to starting the machine, check the movable parts for obstructions such as rags, packing remnants, etc. Be sure that guards and machine parts are properly installed and secured.
3. **Ground the machine.** The machine power cord includes a plug with a ground connector. Be certain the machine is connected to an internally grounded electrical system.
4. **Keep the work area clean.** Keep the work area adjacent to the machine clear of clutter for unobstructed movement of the operator.
5. **It is mandatory to use a pipe/tubing support system with the Collins E-Z Cutter.** (See pages 6 and 7 for suggested systems.)
6. **Wear proper clothing.** Loose clothing can get easily entangled in moving parts. When operating the machine, do not wear unbuttoned jackets, loose sleeve cuffs, neckties, long hair, etc. Safety glasses and shoes should be worn.
7. **Secure machine and work.** Make certain that the machine is bolted to a heavy work bench or proper stand.
8. **Always maintain machine.** Keep machine clean and cutting tools sharp for safe, dependable operation. Follow lubricating instructions. Report any unsafe condition for immediate correction.
9. **Keep alert.** Do not operate machine if ill or drowsy from medication or fatigue. Avoid horseplay around equipment and keep bystanders a safe distance from equipment.

10. **Operate on switch side only.** Machine should be operated on switch side only. Never reach across moving parts or material being worked on. On/Off Switch should always be accessible to operator.
11. **Operate in proper environment.** Machine should not be operated in damp locations. Wear hearing protection in noisy shop environments. Ensure of proper illumination in work area.
12. **Do not misuse machine.** Perform only the functions for which the machine is designed. Do not force machine.
13. **Disconnect power cord prior to servicing.** Repair should be attempted only by authorized personnel. Always disconnect power cord before making any adjustments or servicing the machine.
14. **Keep visitors away.** All visitors should be kept at a safe distance from work area.
15. **Use recommended accessories only.** Refer to Operator's Manual. Use of improper accessories may be hazardous.





Specification

Material	Material Diameter	Wall Thickness	Recommended Blade
Galvanized pipe	¼" - 3" I.D.	Schedule 10-80	03224
Black iron pipe	¼" - 3" I.D.	Schedule 40-80	00535
Steel tubing pipe	⅝" - 3½" O.D.	⅓₂" - ⅝₁₆"	03225
Plastic pipe	¼" - 4" I.D.	Schedule 80	03231
Copper tubing	⅝" - 3½" O.D.	⅓₂" - ⅝₁₆"	03225
Aluminum tubing	⅝" - 3½" O.D.	⅓₂" - ¼"	03225
Stainless Steel (316 S.S.)	⅝" - 2½" O.D.	⅓₂" - ⅝₁₆"	03225

Cutting Capacity:

The factory recommends using the E-Z Cutter only for the material specified above. Cutting of material not specified above may be possible, however. Please contact the factory for an evaluation of the E-Z Cutter's capability to cut the material in question. Using the E-Z Cutter on material not listed above or not approved, voids the machine's warranty.

Motor

- Single phase
 - a 115 V. 50/60 Hz, 15 Amps., 1/2 H.P., 6 brush universal type
 - b 230 V. 50/60 Hz, 8 Amps, 1/2 H.P., 6 brush universal type.

Switch

Foot switch — on/off, heavy duty, oil and water tight, with safety guard.

Gear Box

Motor Gear Box — helical heat treated steel gear construction
 Roller Gear Box — helical heat treated steel gear construction

Roller Speed

Free Running..... 403 RPM
 Under Load..... 375 RPM

Cutter Wheels..... High Speed Tool Steel

Noise Level..... 84 dB max. ("A" scale, slow response)

Shipping Weight 125 LBS

Standard Equipment

The Collins E-Z Cutter (00032) comes complete with heavy duty foot switch and cutter wheel. Two roller supports and two stationary supports are included in #00033.

Accessories

Cutter Wheel with Bearings

Pipe cutter wheel.....	#00034
Tube cutter wheel.....	#00035
Soil pipe cutter wheel.....	#00035

Roller Bearing Pipe Support..... #00069

Weight.....	4 lbs.
Dimensions.....	5½ x 5 x 2"

Stationary Support #00036

Weight.....	3 lbs.
Dimensions.....	6⅛ x 5⅞ x 1½"

Pipe Support Fitting..... #00071

Weight.....	3 lbs.
Dimensions.....	4½ x 4¾ x 2"
Accepts 1¼" steel pipe through support hole and 1" steel pipe for legs.	

E-Z Cutter Stand..... #00037

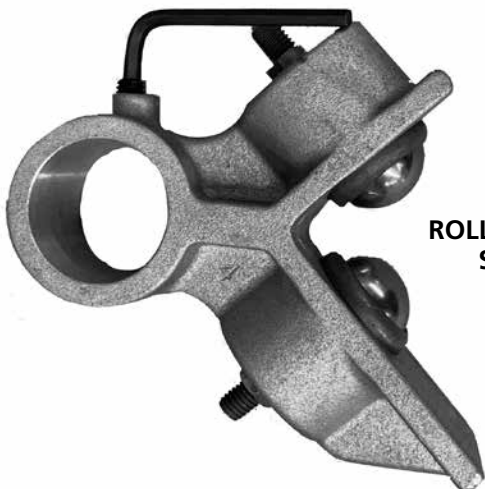
Weight.....	42 lbs.
Dimensions.....	30 x 17 x 27"

Foot Switch (115 V)..... #00079

Weight.....	8 lbs.
Dimensions (packed).....	10 x 5 x 6"

Foot Switch (230 V)..... #02350

Weight.....	8 lbs.
Dimensions (packed).....	10 x 5 x 6"



ROLLER BEARING
SUPPORT
#00069



STATIONARY
SUPPORT
#00036



PIPE SUPPORT
FITTING
#00071



E-Z CUTTER
STAND
#00037



FOOT SWITCH
#00079

Preparing for Operation

Installation

Your E-Z Cutter may be mounted on a bench or on the E-Z Cutter Stand (#00037) which is available as an accessory.

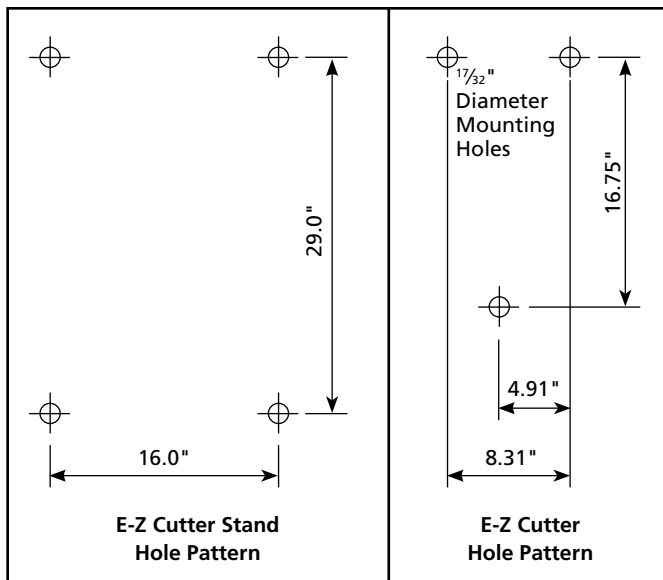
Bench Mounting: Ensure that the E-Z Cutter is mounted on a bench sturdy enough to support the E-Z Cutter's weight and the pressure generated by normal cutting operation. The E-Z Cutter should be bolted solidly to the bench with 1/2" diameter bolts. Bolt the unit at the approximate location relative to your pipe support system (see next pages).

E-Z Cutter Stand Mounting: Ensure that the E-Z Cutter is bolted securely to the stand with 1/2" bolts and that the machine is placed on a level area and bolted to the floor with 1/2" studs after you have established your pipe support system.

Power

Use proper electric current as shown on name plate. To prevent power loss, extension cord of sufficient capacity must be used.

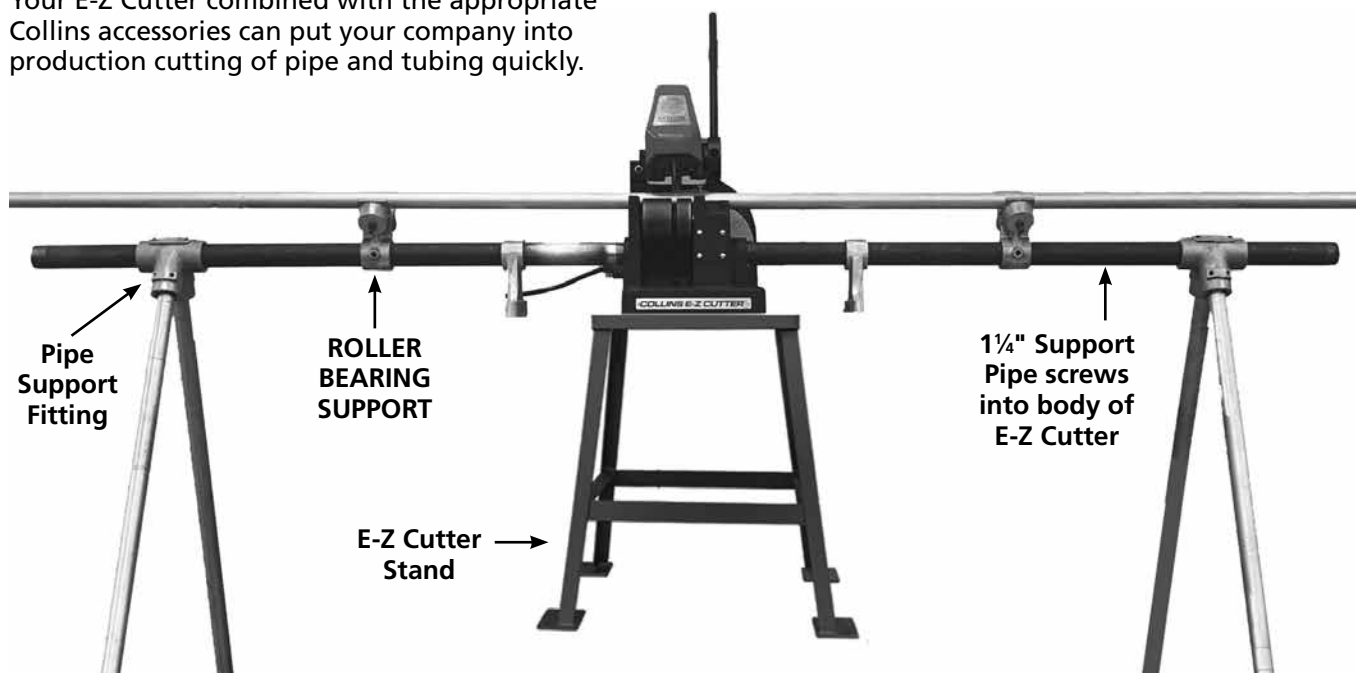
To avoid electrical shocks when operating in the field, connect the ground wire of the extension cord.



Power	Cord Length	Wire Size
115 V	Below 50' 50'-100'	12-3 10-3
230 V 1 Phase	Below 50' 50'-100'	14-3 12-3

Installation of Your Pipe Support System

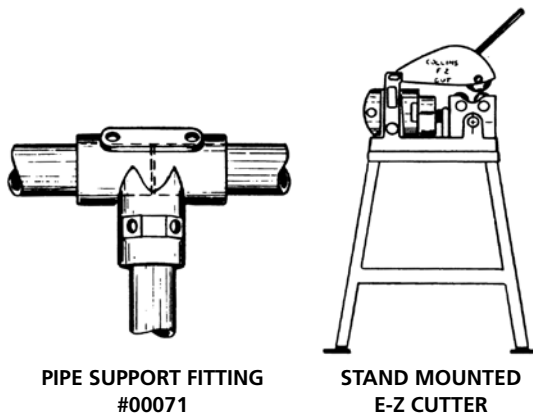
Your E-Z Cutter combined with the appropriate Collins accessories can put your company into production cutting of pipe and tubing quickly.



E-Z Cutter Bench Mounting: There are two tapped holes on either side of the E-Z Cutter that will accept 1¼" NPT threaded pipe. By securing a length appropriate to your needs of 1¼" pipe into the sides of the unit, you can establish a support base as long as required. The 1¼" pipe is maintained stationary and level by the Collins Stationary Support (#00036). Two 3/8" bolts or screws are needed to secure the Stationary Support to the bench.

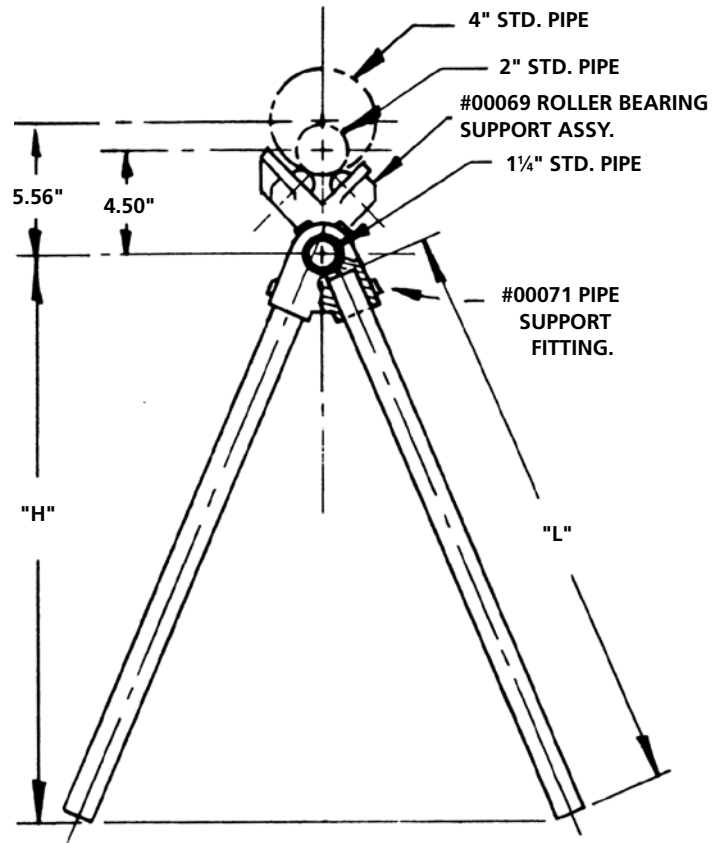
Select either the heavy duty ball bearing support or light duty roller-type support for your feed system. It is best to space the supports every 5'. All supports go easily on the 1¼" pipe and are held stationary by a thumbscrew.

E-Z Cutter Stand Mounting: You can make your own pipe support system for a stand mounted E-Z Cutter. You will need 1" pipe, pipe support fittings and Collins roller bearing supports. The number of accessories you require will depend on your individual needs.



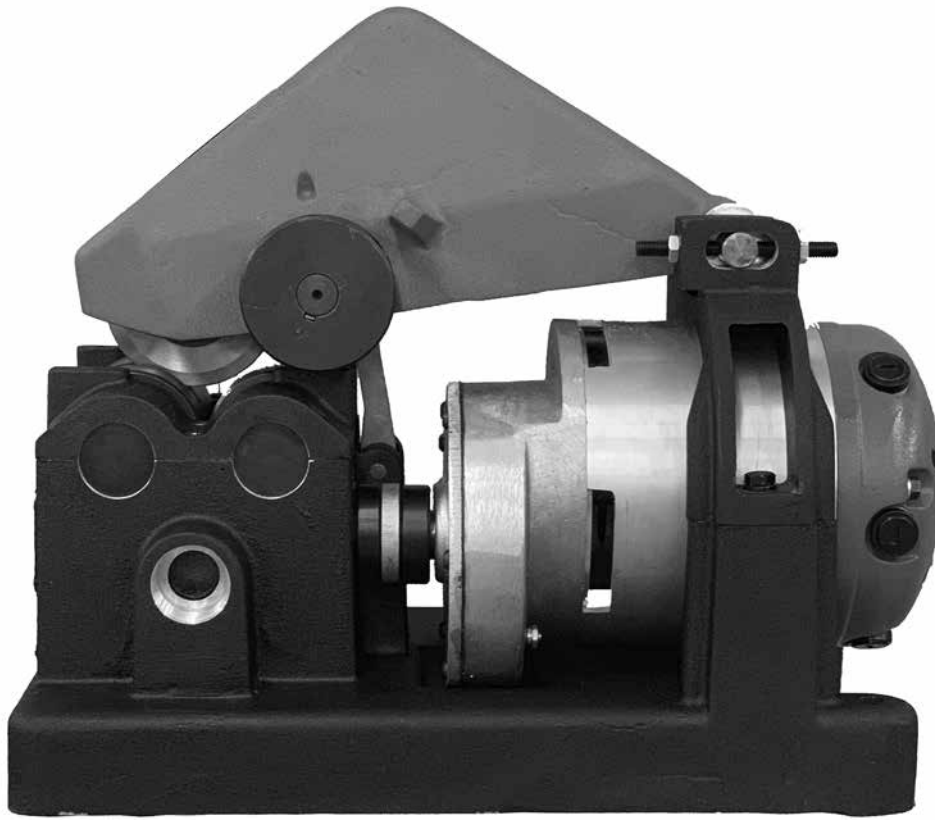
Follow the steps below to set up your pipe support system.

1. Measure the height from the center of the E-Z Cutter Pipe Support mounting hole to the ground.
2. Using the table to the right, determine the length of the 1" pipe support legs.
3. After cutting the legs to the desired length, put a rubber mounting pad at one end of the pipe and insert the other end into the #00071 pipe support fitting. Tighten the attaching screws.
4. Slide two heavy duty roller bearing supports onto a 10-foot length of 1¼" standard pipe. At the non-threaded end of the pipe, mount the pipe support fitting. Do not tighten the attaching screws until the threaded pipe end is installed in the mounting hole of the E-Z Cutter base.
5. The heavy duty roller supports should be located a maximum of five feet apart.
6. There are four attaching screws on the fitting which allow an extra support section to be coupled in the fitting.



1. Determine height "H" required and cut 1" standard pipe to length "L" shown in table below.
2. All dimensions are in inches.

"H"	"L"	"H"	"L"
40.5	42.94	32.0	33.69
40.0	42.37	31.5	33.19
39.5	41.87	31.0	32.62
39.0	41.31	30.5	32.06
38.5	40.75	30.0	31.50
38.0	40.25	29.5	31.00
37.5	39.69	29.0	30.44
37.0	39.12	28.5	29.87
36.5	38.56	28.0	29.37
36.0	38.06	27.5	28.87
35.5	37.50	27.0	28.25
35.0	37.00	26.5	27.75
34.5	36.37	26.0	27.19
34.0	35.87	25.5	26.62
33.5	35.31	25.0	26.06
33.0	34.75	24.5	25.50
32.5	34.25	24.0	25.00



Operating Instructions

WARNING: Do not wear gloves, rings, or loose clothing while operating the E-Z Cutter. Remove all burrs from material to be cut.

1. Before making electrical connection, set the E-Z Cutter for the material you intend to cut:
 - (a) Lift the head casting with feed wheel bar removed from the sprocket.
 - (b) Feed the material underneath the cutter wheel.
 - (c) Lower the head casting until the cutter wheel rests on the material to be cut.
 - (d) Put the feed wheel bar into the appropriate sprocket that allows you to pull down comfortably through the material.
 - (e) Push feed wheel bar back towards the motor until it stops against the rest of the head casting.
2. Make electrical connection: (Voltage of outlet must be the same as voltage indicated on the tag and name plate.) Put twist lock plug into side of E-Z Cutter, position safety foot switch and plug into proper outlet.
3. While E-Z Cutter is off, feed material with left hand to desired cut off location underneath cutter wheel. Bring cutter wheel down with feed wheel bar so it rests easily on your cut off mark and apply slight pressure on the feed wheel bar.
4. Remove left hand from material.
5. Turn machine on with foot switch. Power driven rollers will rotate pipe.
6. Pull down on feed wheel bar until material is cut. Do not force the cut, let the machine do the work.

WARNING: Ensure you have the proper support for the cut material.

7. After material is cut, lift head casting by pushing back on feed wheel bar while turning off machine.

WARNING: Do not grasp rotating stock.

8. After stock stops rotating, feed again and repeat process.

Cutter Wheel Replacement

1. Rotate head casting to full back position.
2. Use appropriate sized adjustable wrench and turn cutter wheel shoulder screw counter clockwise. As you withdraw shoulder screw from head casting, remove wheel as it is released from shoulder screw.
3. Replace cutter wheel by positioning cutter wheel in the head casting over hole for shoulder wheel screw. Insert shoulder screw and tighten with adjustable wrench.

NOTE: If you choose to buy a cutter wheel without a bearing it will be necessary for you to remove the bearing from your existing wheel and press it into your new wheel. Ensure that you use only a Collins #R04201428R bearing.



Head casting in full back position



Positioning cutter wheel

Parts for E-Z Cutters with Serial Number 5851 and Below

NOTE: The parts listed in this catalog can be used on all Collins E-Z Cutters. However, some parts on earlier model E-Z Cutters have been replaced or modified. If you have an E-Z Cutter with a serial number of 5851 or lower please read and follow the instructions below regarding replacement parts.

Foot Switch Assembly

For machines prior to Serial #5851:

Replace #3366 foot switch assembly with #00079 (115 V.) or #02350 (230 V.) foot switch assemblies. In addition to this, the male receptacle connector #3372 must be replaced with #R0420218R (115 V.) or #R0420219R (230 V.) receptacle.

For machines prior to Serial #5000:

Replace #3044 rack gear and/or #3213 pinion gear-shaft with #R04203444R rack gear and pinion conversion kit since individual parts are not interchangeable. This conversion kit includes the following parts:

- #R04201448R guide roller (replaces #3219)
- #R04201449R gear rack (replaces #3044)
- #R04201450R pinion gearshaft (replaces #3213)
- #03220 guide roller pin (replaces #3220)
- #R04201268R Woodruff key (replaces #1385)
- #R04201238R rack gear pin (replaces #3045)

Rollers

For machines prior to Serial #5645 (October 1974):

Although the #3019 grooved roller and the #3021 smooth roller can be directly replaced with the new #R04201776R grooved roller and the #R04201777R smooth roller, since the old #3024 grease retainer felt, it is recommended that the #3024 grease retainer felt also be replaced with the #R04201837R Seal Bushing and the #R04201849R "O"-ring seal for better grease retention. Order one seal bushing and one "O" ring seal per roller.

Base, Motor Yoke and Bearing Caps

For machines prior to Serial #5645 (October 1974):

If any one of the #3012 base, #3013 motor yoke, #3054 R.H. bearing cap or #3055 L.H. bearing cap needs replacement it is recommended that the complete #R0421846R base assembly be ordered. This base assembly includes the following parts:

#R04201014R	2	Screw, hex, hd. cap, $\frac{3}{8}$ -16 x $1\frac{1}{4}$ "
#R04201123R	2	Screw, soc, hd. cap, $\frac{5}{16}$ -18 x $1\frac{1}{2}$ "
#R04201121R	2	Screw, soc, hd. cap, $\frac{5}{16}$ -18 x 1"
#R04201775R	1	Cap, bearing, left hand
#R04201846R	1	Base

Maintenance

Lubrication Instructions

Motor Gear Case: It is lubricated permanently and requires no periodic lubrication. The lubrication oil used in the motor gear case is SAE 90.

Roller Gear Case: It is packed with grease and sealed, and requires no periodic lubrication. If service is required, replenish lubricant with Moly-Shield ST-200 or equivalent.

Hinge Bar: Directly above the hinge bar located on the head casting are two 1/8" lubricating holes. Fill holes with lubricating oil (SAE 30) every 8 hours of operation.

Pinion Gear: On the outside of the head casting directly opposite the pinion gear are two 1/8" lubricating holes for the oiling of the pinion gear shaft. Lubricate every 8 hours of operation with lubricating oil (SAE 30).

Motor: Requires no lubrication. All ball bearings are sealed.

Cutter Wheel Alignment

Your E-Z Cutter wheel is aligned professionally by our factory assemblymen prior to its shipping. If for some reason your E-Z Cutter becomes out of alignment, you will observe that the wheel is not cutting but making thread marks on your stock.

To align the E-Z Cutter, loosen the appropriate head aligning set screws and adjust the head to the right or left as required. Tighten the set screws once the wheel is aligned.



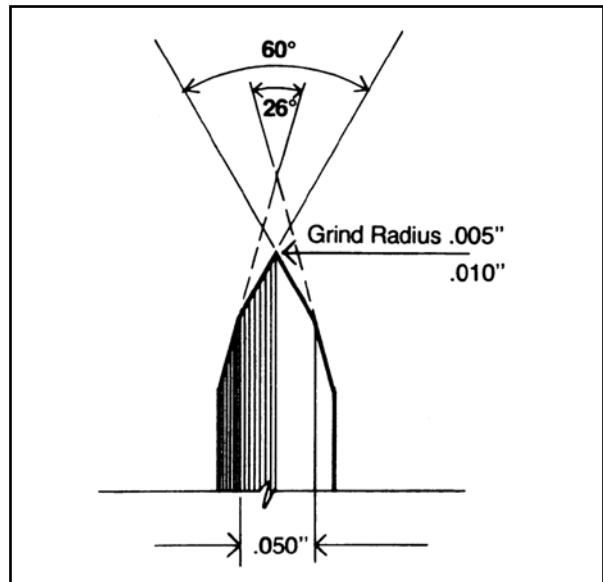
E-Z Cutter as seen from rear

Motor Brushes

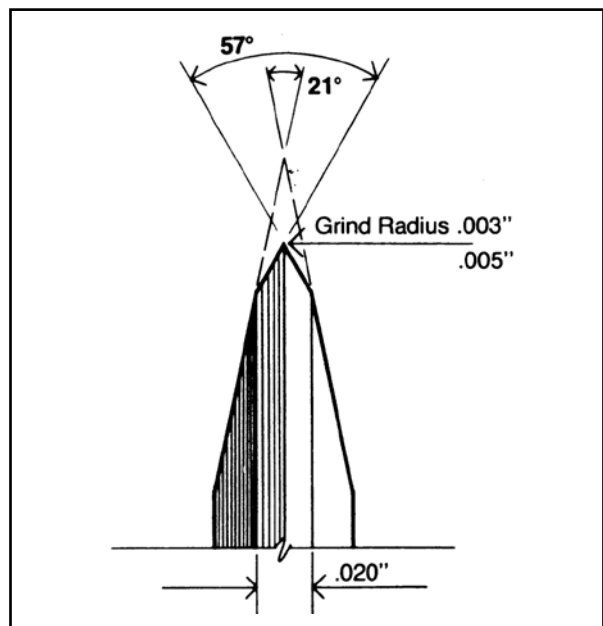
Check motor for brush wear every six months. If motor lacks power due to a dirty commutator, use a commutator cleaner stick or fine emery cloth.

Cutter Wheel Sharpening

If you have resharpening capability locally, the following drawings are provided for your convenience.



Pipe Cutter Wheel #00034

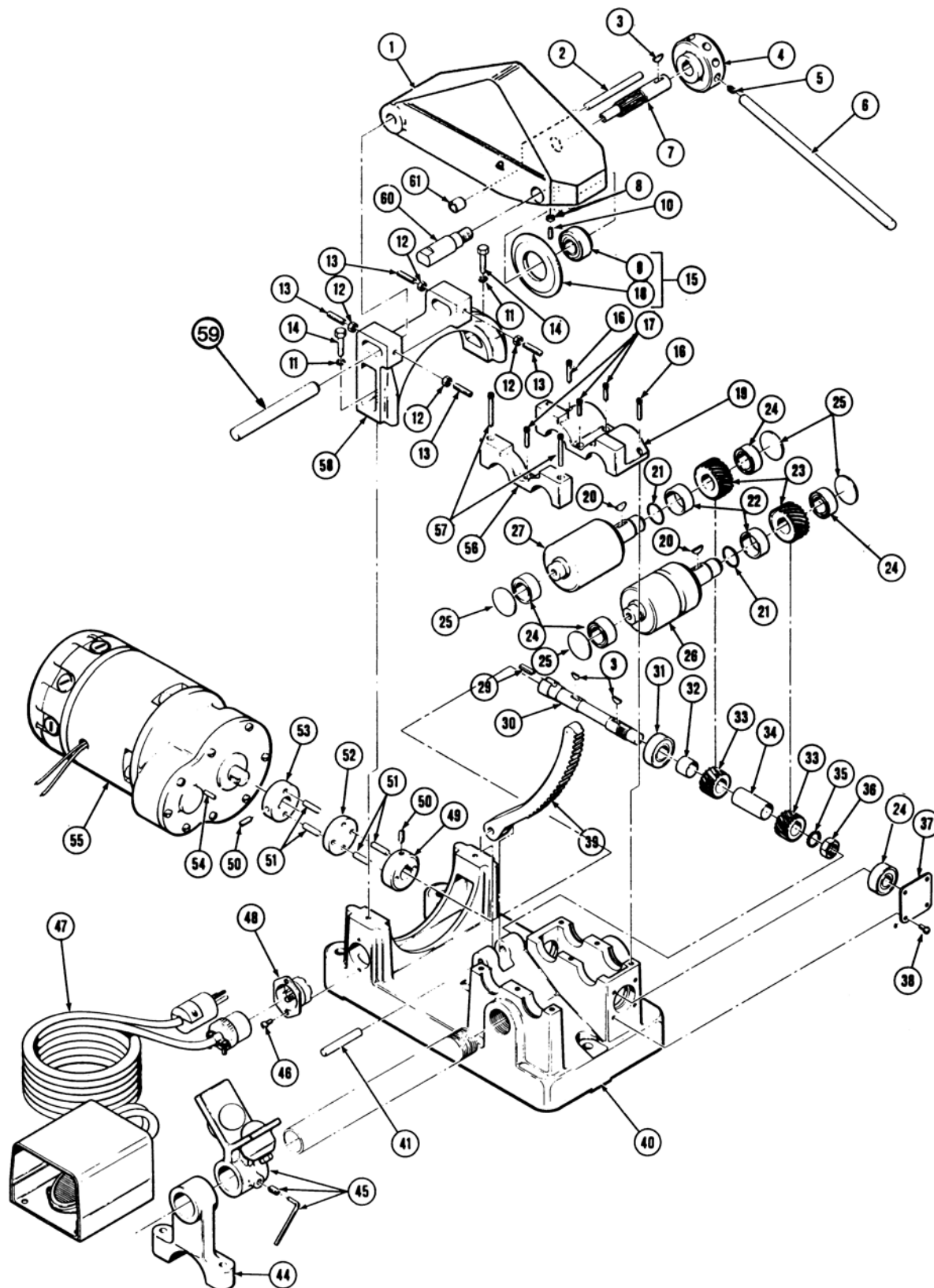


Tube Cutter Wheel #00035

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ACTION	DATE
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E-Z Cutter Main Assembly



PARTS LIST

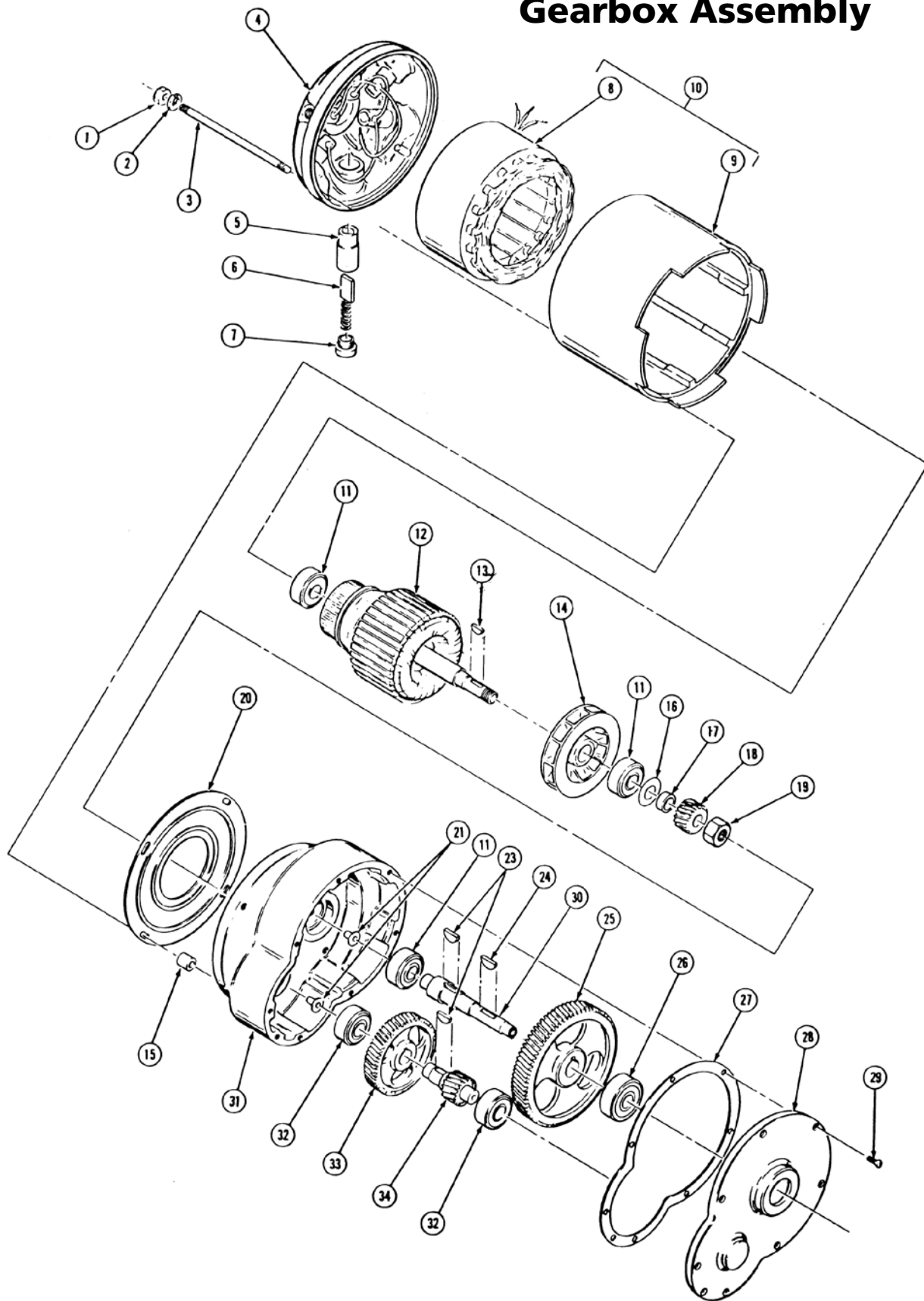
E-Z Cutter Main Assembly

115 V. — PART #00032

230 V. — PART #00534

Item	Part No.	Description	Req'd	Item	Part No.	Description	Req'd
1.	R04202079R	Head, E-Z Cutter	1	34.	R04201417R	Spacer, Gear	1
2.	03220	Pin, Roller Guide	1	35.	R04201083R	Washer, Starlock, 3/4" Ext.....	1
3.	R04201268R	Key, Woodruff.....	3	36.	R04201061R	Nut, Jam, Drive Shaft, 3/4" - 16 x Hex	1
4.	R04201426R	Hub, Feed Wheel	1	37.	R04883038R	Cover, Bearing Shaft	1
5.	R04201159R	Set Screw, Wheel Hub, 5/16"-18 x 1/4"	1	38.	R04201222R	Screw, bearing Cover, #10-24 x 1/2" Self-Tap. Mach.	1
6.	R04201427R	Handle, Feed Wheel.....	1	39.	R04201449R	Gear Rack 1	
7.	R04201450R	Gearshaft, Spur, 8T.....	1	40.	R04201846R	Base Assembly w/Bearing Caps	1
8.	R04201035R	Nut, Gearshaft Locking, 5/16" - 18	1	41.	R04201238R	Pin, Pivot, Rack Gear.....	1
9.	R04201428R	Bearing, Cutting Wheel — See Item #15		44.	00036	Support, Stationary	2
10.	R04201163R	Set Screw, Gearshaft Locking, 5/16" - 18 x 3/4"	1	45.	00069	Support Assembly, Ball Bearing Type.....	2
11.	CC-111-AP	Washer, Lock, 3/8"	2	Each Assembly Includes:			
12.	R04201053R	Nut, Jam, 3/8"-16 Hex	4		R04201890R	Body, Pipe Support, Ball Bearing Type (1)	
13.	R04201172R	Set Screw, Head Aligning, 3/8"-16 x 1 3/4"	4		R04201891R	Castor, Ball Bearing (2)	
14.	R04201014R	Screw, Yoke Att., 3/8"-16 x 1 1/4" Hd. Cap	2		R04201054R	Nut, Jam, 3/8" - 16 hex x 2 (2)	
15.	00034	Cutting Wheel Assembly, Pipe (Std. Equipment).....	1		CC-111-AP	Washer, Lock, 3/8" - Int-Ext Tooth (2)	
	00035	Cutting Wheel Assembly, Tubing (Optional. Equipment)			R04201054R	Set Screw, 3/8"-16 x 3/4" Cup Point (1)	
	00535	Cutting Wheel Assembly, Soil Pipe			R04201170R	Wrench, Allen, Set Screw, 3/16" (1)	
16.	R04201121R	Screw, Bearing Cap, 5/16" - 18 x 1" Soc. Hd. Cap	2	46.	R04201220R	Screw, #6-32 x 1/2" Pan Hd. Self Tap	2
17.	R04201120R	Screw, Bearing Cap, 5/16" - 18 x 3/4" Soc. Hd. Cap	3	47.	00079	Foot Switch Assembly, Heavy Duty, 115V. or	1
18.	—	Cutting Wheel, Various Types, See Item #15 Cutting Wheel Assemblies			02350	Foot Switch Assembly, Heavy Duty, 230V. or	
20.	R04201270R	Key, Woodruff.....	2	48.	R04202018R	Connector, Receptacle, Elect. 115V. or.....	1
21.	R04201849R	Seal, O-Ring	2		R04202019R	Connector, Receptacle, Elect. 230V.	
22.	R04201837R	Bushing, Seal	2	49.	R04201422R	Coupling, Gear Shaft.....	1
23.	R04201412R	Gear, Helical, 20T	2	50.	R04201161R	Set Screw, 5/16"-18 x 1/2" Hex Soc.....	2
24.	R04202245R	Bearing, 203 SZZ.....	5	51.	R04201230R	Pin, Coupling, Dowel, 5/16" x 1"	4
25.	R04201414R	Shield, Bearing.....	4	52.	R04201424R	Insert, Coupling.....	1
26.	R04201776R	Roller, Drive, Grooved (Complete Grooved Roller Assembly #13070)	1	53.	R04201423R	Coupling, Motor Shaft	1
27.	R04201777R	Roller, Drive, Smooth (Complete Smooth Roller Assembly #13071)	1	54.	03043-4	Key, Square, Coupling, 1/4" x 1/2"	1
29.	03043-5	Key, Square, 1/4" x 5/8"	1	55.	R04201430R	Motor and Gear Case Assembly 115V. or	1
30.	R04201415R	Shaft, Roller Drive	1		R04203108R	Motor and Gear Case Assembly 230V.	
31.	R04201364R	Bearing, 204 SZZ.....	1	56.	R04201775R	Cap, Bearing, L.H.....	1
32.	R04201418R	Spacing, Bearing	1	57.	R04201122R	Screw, Bearing Cap, 5/16"-18 x 1 1/4" Hex. Soc.	2
33.	R04201416R	Gear, Helical, 15T	2	58.	R04201846R	Yoke, Motor.....	1
				59.	R04201425R	Bar, Hinge, Head Assembly.....	1
				60.	R04201429R	Screw, Shoulder, Cutting Wheel.....	1
				61.	R04201448R	Roller, Rack Guide	1

E-Z Cutter Motor and Gearbox Assembly



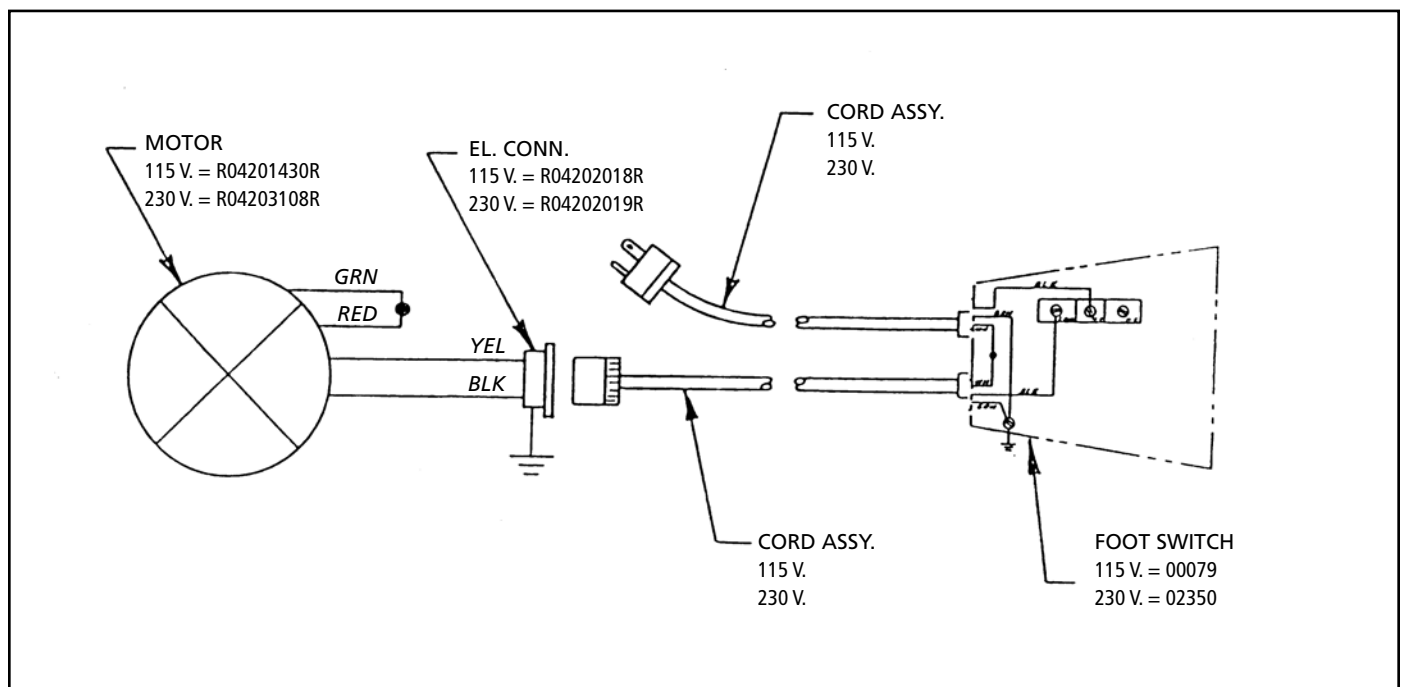
PARTS LIST

E-Z Cutter Motor and Gearbox Assembly

115 V. — PART #R04201430R

230 V. — PART #R04203108R

Item	Part No.	Description	Req'd	Item	Part No.	Description	Req'd
1.	R04201034R	Nut, 1/4" -20 Hex. Hd.	4	14.	R04201331R	Fan, armature.....	1
2.	R04203209R	Washer, Lock 1/4"	4	15.	R04201325R	Retainer, stator baffle, neoprene	4
3.	R04201341R	Tie Rod, Motor	4	16.	R04201328R	Space, slinger.....	2
4.	R04201432R	End Bell Assembly (includes brush holders, but brushes and caps not included)	1	17.	R04201329R	Spacer, 20-T helical gear	1
5.	R04201337R	Holder, brush, electrical contact (included in Item 4, R04201432R)	6	18.	R04201332R	Gear, helical, armature shaft, 20-T	1
6.	R04201340R	Brush, elect. contact (115V. & 230V.)	6	19.	R04201330R	Nut, armature shaft	1
7.	R04201338R	Cap, brush holder.....	6	20.	R04201324R	Baffle, stator	1
8.	01321	Stator, 115V., single phase or		21.	R04201347R	Plug, gear case, plastic.....	2
	R04201320R	Stator, 230V., single phase	1	23.	R04201268R	Key, woodruff, 1/4" x 3/4"	2
9.	R04201323R	Housing, stator (115V. & 230V.)	1	24.	3043-4	Key, square 1/4"	1
10.	R04201322R	Stator & Housing Assembly, 115V. single-phase or		25.	R04201354R	Gear, helical, 96-T	1
	R04201321R	Stator & Housing Assembly, 230V. single-phase	1	26.	R04201364R	Bearing, 204 SZZ.....	1
11.	R0420245R	Bearing, gear case, 203 SZZ	3	27.	R04201345R	Gasket, gear case housing	1
12.	01330	Armature, 115V., single phase, or		28.	R04201346R	Cover, gear case housing	1
	01330-1	Armature, 230V., single phase	1	29.	R04201206R	Screw, cover att., 1/4" -20 c 5/8"	8
13.	R04201265R	Key, woodruff, 20-T helical gear.....	1	30.	R04201442R	Shaft, output, gear box	1
				31.	R04201344R	Housing, gear case.....	1
				32.	R04201333R	Bearing, 201 SFF	2
				33.	R04201351R	Gear, helical, 60-T	1
				34.	R04201355R	Gearshaft, helical, 22-T	1



ROTHENBERGER LIFETIME WARRANTY

ROTHENBERGER USA LLC warrants our products against defects in material and workmanship for the life of the product. Warranty coverage ends when the product becomes unusable for reasons other than defects in material and workmanship. This warranty covers replacement or repair of defective parts for the lifetime of the products provided that failure is not due to abuse, misuse, abnormal use, neglect or normal wear and tear. Lifetime warranty excludes motors, switches,

and electrical parts, which are warranted for a period of one

year from the date of sale. Warranty is null and

void if maintenance instructions and operating procedures are not followed or if product

has been repaired or altered outside

ROTHENBERGER or our authorized

service centers. No other warranty

shall apply. This warranty is in lieu

of other warranties, expressed

or implied, of merchantability,

fitness for a particular purpose,

performance or otherwise.

Products returned must be approved

in advanced and returned freight

prepaid to ROTHENBERGER, Loves Park,

IL or to a ROTHENBERGER independent

service center. Hand tools should be returned to

the place of purchase. ROTHENBERGER or their approved

independent service center will decide whether a returned product is covered by this limited warranty. ROTHENBERGER liability does not extend beyond the repair or replacement of its product as warranted above. In no event shall ROTHENBERGER be liable for claims based upon breach of expressed or implied warranty, negligence or otherwise for any damages whether direct, immediate, incidental, foreseeable, consequential, or special.

