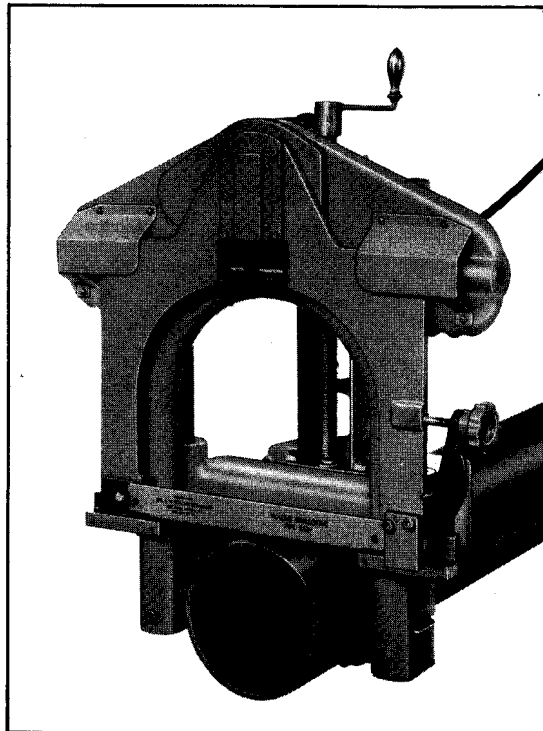


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Note: Limited Parts Available.  
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# Guillotine Pipe Saw Model C

## *Operating Instructions & Parts List*



Serial No. \_\_\_\_\_

Model No. \_\_\_\_\_

## OPERATING MANUAL AND PARTS LIST

### SPECIFICATIONS

MODEL C (2"-8")

MODEL D (6"-18")

SUPER D (10"-24")

### POWER REQUIREMENTS

Air: 80 c.f.m. @90 p.s.i.

Electric: 110 VAC 10 (10 amp)

Hydraulic: 8-10 g.p.m. @ 1800 p.s.i.

The **WACHS GUILLOTINE PIPE SAW** is shipped from the factory completely assembled and lubricated. The cutting blade is installed so it is only necessary to connect the power supply and you are ready to cut.

### OPERATING INSTRUCTIONS

1. Make sure that the blade is raised as high as possible by turning the feed handle (Ref. #45) counter-clockwise until it stops.
2. Place the machine on the pipe and hold it steady. Take the loose end of the chain clamps and pull it tight engaging the closest cross pin all the way in the slot provided. Tighten nuts on chains until machine is solid on the pipe.
3. Check blade to make sure that the teeth are set to cut to the left. The regular **WACHS GUILLOTINE PIPE SAW** blade is always installed with the name facing you. Make sure the blade tensioning knob (Ref. #9) is tight. A sharp, taut blade assures a straight, clean cut.
4. Turn on the power and feed blade through the pipe by turning the feed handle clockwise. Rate of feed depends on the material which is being cut, and the location of the blade in the cut. In cutting through solid material, we recommend that the feed handle be turned approximately

1/12 of a revolution for each cutting stroke. In light cutting, such as through the center of cast iron pipe, it is possible to feed at the rate of 1/4 turn of the feed handle per stroke. After making such a few cuts, the operator can determine the rate at which cutting can be done most effectively with the least strain on the machine.

5. When cut has been completed, turn off the power before raising the blade. If there is not enough clearance to raise the blade through the cut, remove the blade and raise the bow by turning the feed handle counter-clockwise.

### OPERATING SUGGESTIONS

We recommend the use of cutting oil on the blade when cutting steel pipe. It is not necessary to use a lubricant when cutting cast iron, except for spark arresting. When cutting solid bar stock, cut it dry. Use of oil in this operation interferes with chip removal and slows down cutting.

Cement-asbestos pipe can be cut very easily with our special blade. Always cut it dry, and clean the dust from the teeth between cuts. It is good practice to drive wedges into the saw cut to prevent binding the blade when cutting pipe that is installed. We also recommend that you shim up the pipe to hold it in alignment while cutting. If the cut closes due to ground pressure, remove the blade and move the saw over 1/2 inch, and make a second cut. You can then knock out the ring that you cut and have plenty of slack.

### LUBRICATION INSTRUCTIONS

There are six (6) Alemite, bayonet type fittings. Review the parts drawing for the location of these grease fittings.

These fittings should all be lubricated with a good grade of soft grease each day before using the saw. Put a small amount of the same kind of grease on the feed screw (Ref. #44), the saw frame guides (Ref. #70), inside surface of the Feed Bracket Assembly (Ref. #49) and inside surface of the Cam Wheel (Ref. #51). The lubricator for the air motor should be filled with a good grade of air motor oil. Oil should be fed at the rate of 6 drops per minute as seen through glass opening at top of the oiler. Rate of oil feed is controlled by adjusting the knurled knob on top of oiler.

## GUILLOTINE SAW FEATURES

**NEW** - Entirely different principle of power saw design - Model C makes machine shop cut in 25" wide ditch, Model D in 32" wide ditch. Super D in 40".

**VERSATILE** - Model C cuts 2" thru 8", Model D 10" thru 16", Super D 10"-24" cast iron or steel pipe and solid bar stock. Can be mounted at any angle permitting cuts previously inaccessible to power cutters or saws.

**ACCURATE** - Chain type pipe vise with accurately machined steel V base gives positive grip and perfect alignment on pipe that assures right angle cuts.

**EASY TO OPERATE** - Simple mounting arrangement - easy blade change - fingertip feed control - light in weight - compact for storage and transportation.

**SAFE** - Flameless "hot cuts" can be made safely where there are fire or explosion hazards.

**PORTABLE** - One man can set up Model C (120 lbs. complete) in a matter of minutes. Model D at 312 lbs. is also easy to set up.

**FAST** - Cuts are fast, clean and square - one diameter/inch per minute. Saws are self aligning, set up in a matter of minutes. Manual finger-tip pressure feed gives maximum cutting speed for all materials.

**LONG BLADE LIFE** - Wachs Guillotine Power Saw Blades are recommended for use with these saws. High speed steel blades - 12", 22" or 31" long - 2" stroke. Blade is lifted from cut on return stroke which extends blade life. Carbide blades are available for cement lined pipe.

## SAFETY INSTRUCTIONS

In order to assure safe operation of Wachs Guillotine Saws, users should follow these standard safety procedures:

1. Wear safety goggles.
2. Dull blades are unsafe. Use only sharp blades.
3. When securing blade on a Guillotine Saw, hand tighten only. Do not use wrench or other tool.
4. Keep fingers and hands out of machine while it is running. Stand on motor side only.
5. Do not stand in front of a Guillotine Saw while it is running. Stand on motor side only.
6. If blade becomes jammed in cut because of pipe compression, follow these steps:
  - A. Shut machine off.
  - B. Cut power to machine.
  - C. Drive wedges into cut to relieve pressure.
  - D. Resume cutting.
7. Do not strike blade with a hammer to free up if it becomes jammed in cut. Use procedure described above.
8. Always cut power before moving or adjusting the Guillotine Saw on the pipe.
9. Never loosen chain holding machine while blade is in a cut.
10. If cut line is out of square for any reason, the blade will bow and jam. To prevent this, stop cutting. Shut off the power and check blade sharpness. Replace if dull. Start a completely new cut. Do not try to force completion of an out-of-square cut.

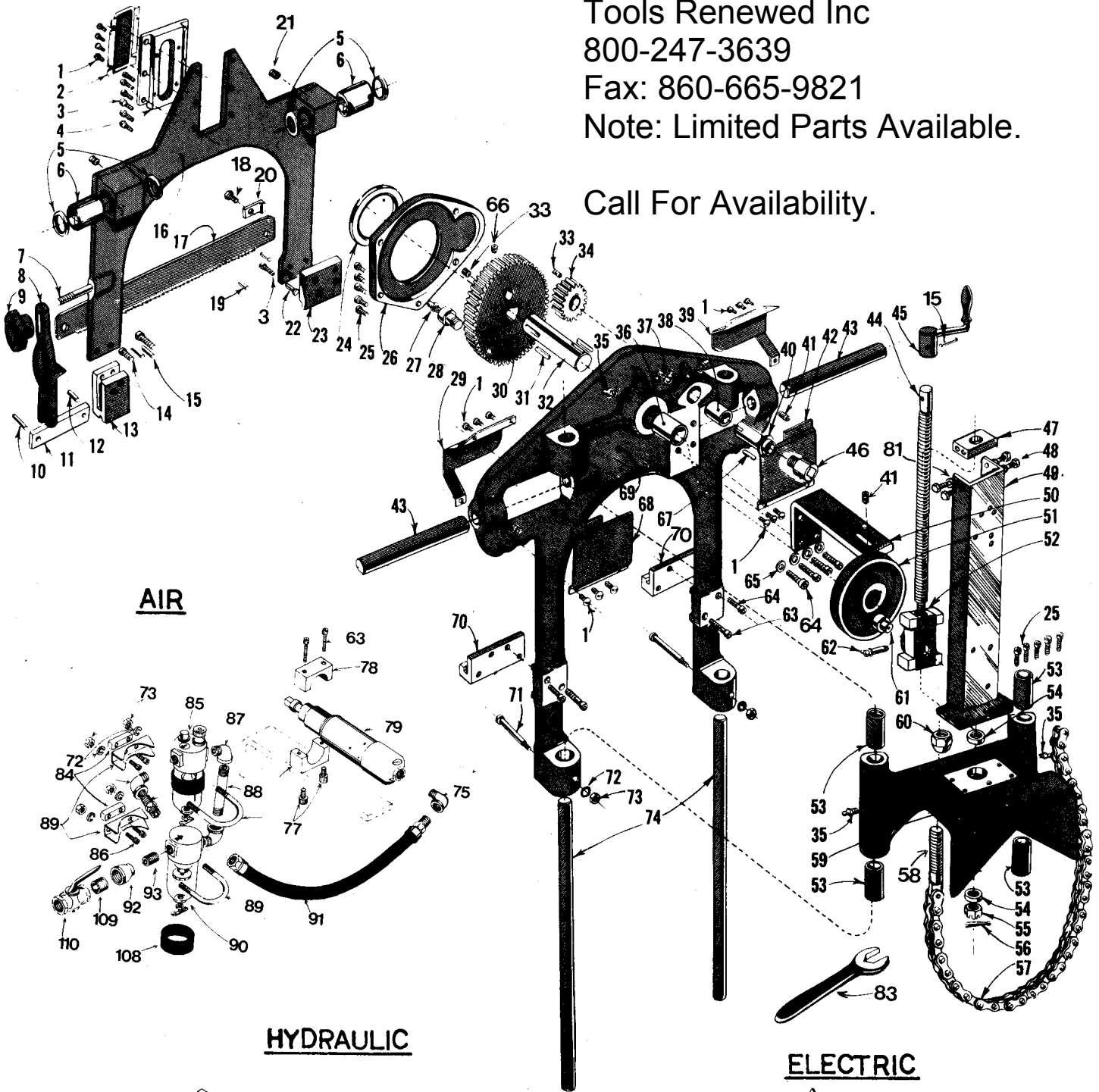
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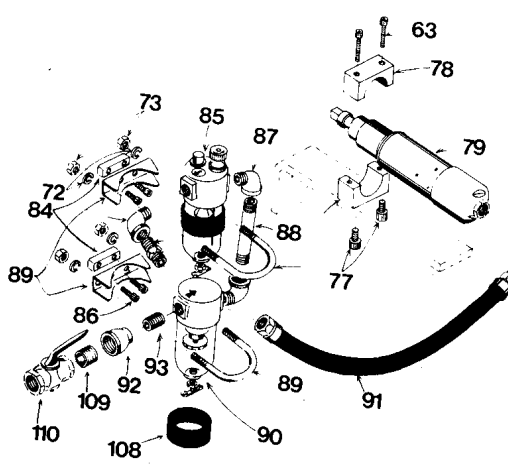
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Note: Limited Parts Available.

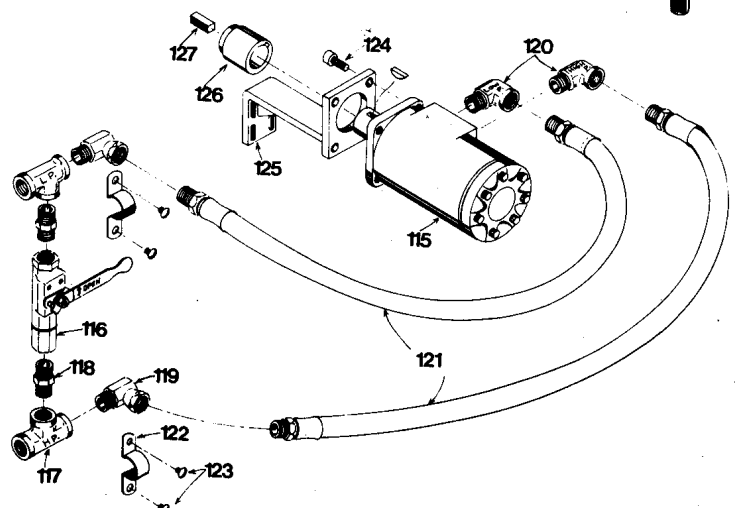
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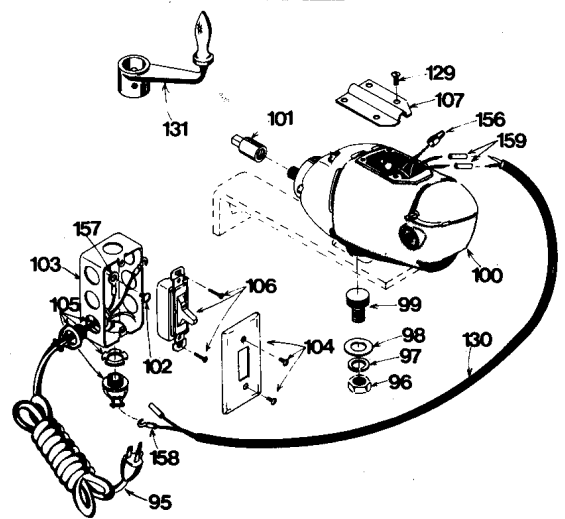
AIR



HYDRAULIC



ELECTRIC



**MODEL "C" GUILLOTINE SAW PARTS LIST**

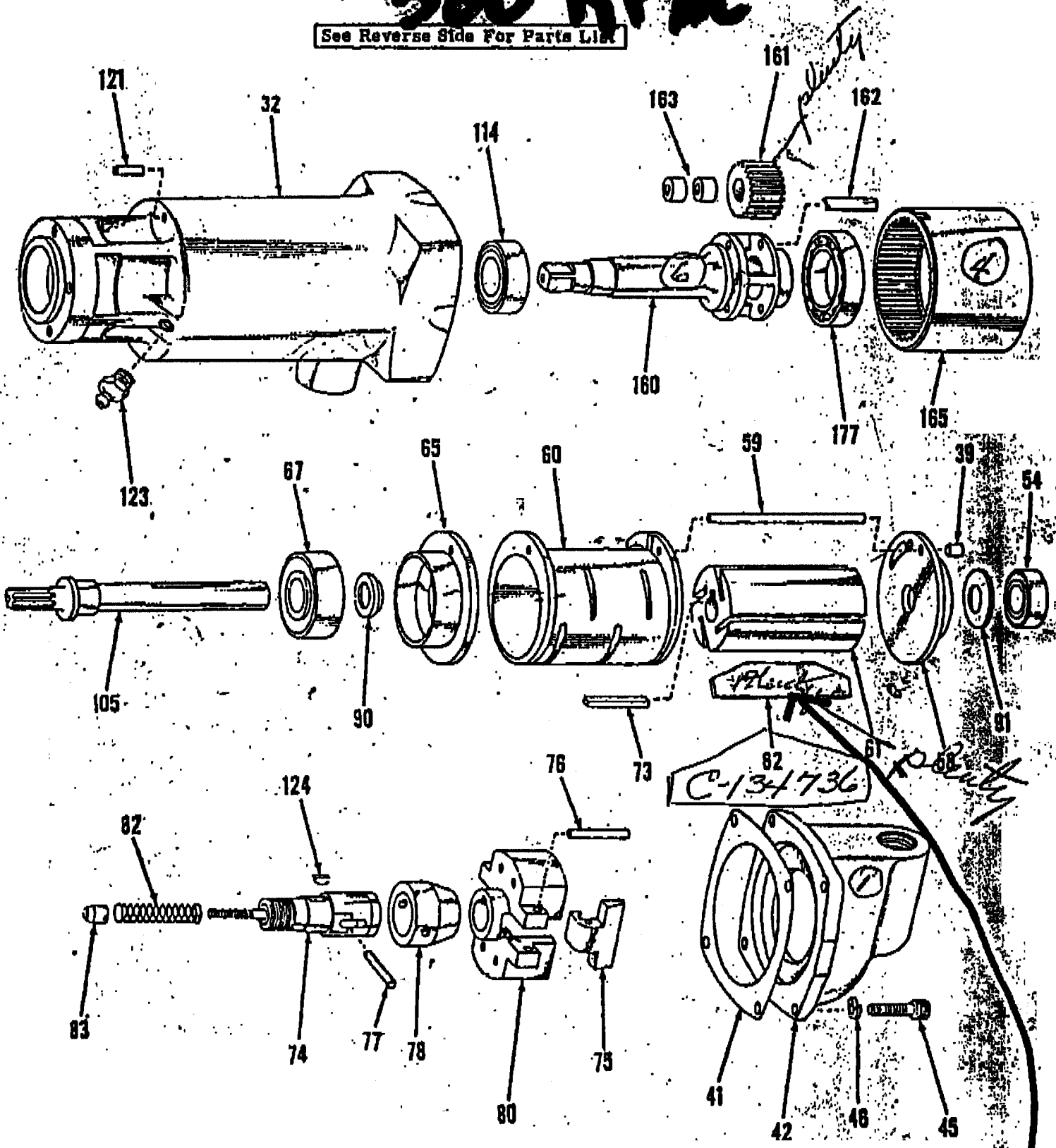
Item	Qty	Part No.	Description	Item	Qty	Part No.	Description	Item	Qty	Part No.	Description
1	16	90-049-02	10-24 x 3/8 Lg RHMS	49	1	03-049-00	Feed Bracket	98	1	90-205-59	5/8 Washer
2	1	03-002-00	Grease Cover Yoke	50	1	03-050-00	Bracket Motor Mount	99	1	03-099-00	Mounting Stud
3	8	90-050-06	1/4-20 x 5/8 Lg SHCS	51	1	03-051-00	Cam Wheel	100	1	03-100-00	Electric Motor
4	1	03-004-00	Yoke	52	1	03-052-00	Feed Nut	101	1	03-101-00	Electric Mtr. Adaptor
5	4	03-005-00	Seal Thompson	53	4	03-053-00	Bronze Bushing	102	2	90-059-01	1/4-20 x 1/4 Lg RHMS
6	2	03-006-00	Bronze Bushing	54	2	03-054-00	Thrust Bearing	103	1	03-103-00	Electric Switch Box
7	1	03-007-00	Tensioning Screw	55	1	03-055-00	5/8-18 Castle Nut	104	1	03-104-00	Electric Box Cover
8	1	03-008-01	Tensioning Bracket	56	1	90-026-91	1/8 x 1-1/2 Cotter Pin	105	2	03-107-00	Cord Grip
9	1	03-009-00	Tensioning Knob	57	2	03-057-01	Clamping Chain	106	1	03-106-00	Switch
10	1	90-056-12	1/4 x1-1/4 Lg Dowel Pin	58	1	03-058-00	Clamping Chain Screw	107	1	03-105-00	Cover Plate, Elec Mtr
11	1	03-011-00	Blade Tensioning Bar	59	1	03-059-00	Saddle	108	2	03-108-00	Oiler Rubber Band
12	1	90-056-06	1/4 x 5/8 Lg Dowel Pin	60	1	03-060-00	Chain Tensioning Nut	109	1	90-218-01	3/4 Close Nipple
13	1	03-013-00	Tensioning Bar Holder	61	1	03-061-00	Cam Follower	110	1	90-219-51	3/4 Gas Cock
14	2	90-060-06	5/16-18 x 5/8 Lg SHCS	62	1	90-500-04	Grease Fitting	111	1	03-111-00	Steel Storage Case
15	3	90-056-62	1/4 x1-1/4 Lg Roll Pin	63	2	90-500-15	1/4-20x1-1/2" Lg SHCS	112	4	90-049-01	Drive Screw
16	1	03-016-00	Saw Frame	64	6	90-050-10	1/4-20 x 1 Lg SHCS	113	2	03-113-00	Blade Direction Decal
17	1	03-405-00	Saw Blade #1206-6D	65	4	90-055-53	1/4 Washer	114	1	90-900-01	Instruction Manual Label
18	1	90-051-05	1/4-20 x 1/2" HHCS	66	1	90-054-02	1/4-20 x 1/4" Lg SSS	115	1	03-115-00	Hydraulic Motor
19	2	90-056-58	1/4 x 7/8 Lg Roll Pin	67	1	90-047-07	3/16 Sq x 3/4 Lg Key	116	1	90-099-52	1/2" HP Valve
20	1	03-020-00	Blade Hold Down Clamp	68	1	03-068-00	L.H. Rear Guard	117	2	90-098-54	1/2" HP Tee
21	2	90-074-05	3/8-16 x 1/2 Lg SSS	69	1	03-069-00	Main Frame	118	2	90-098-51	1/2" HP Close Nipple
22	1	03-022-00	Blade Holder Pin	70	2	03-070-00	Saw Frame Guide	119	2	90-098-55	1/2 x90° HP St Elbow w/Swivel
23	1	03-023-00	Guide Rail	71	2	90-077-82	3/8" Stripper Bolt 3-1/4" Lg	120	2	90-098-56	1/2 x90° HP St Elbow
24	1	03-024-00	Grease Seal	72	2	90-065-51	5/16 Lockwasher	121	2	02-027-01	1/2" HP Hose
25	10	90-050-07	1/4-20 x 3/4 Lg SHCS	73	2	90-065-01	5/16-18 Hex Nut	122	2	03-122-00	Mounting Clamp
26	1	03-026-00	Cover, Gear Box	74	2	03-074-00	Vertical Guide Shaft	123	4	90-059-02	1/4-20 x 3/8 Lg RHMS
27	1	90-500-01	Grease Fitting	75	1	90-058-06	1/4" x 90° St. Elbow	124	4	90-070-09	3/8-16 x 3/4 Lg SHCS
28	1	03-028-00	Cam Follower	77	2	90-070-06	3/8-16 x 5/8 Lg. SHCS	125	1	03-125-00	Mounting Bracket, Hydraulic Motor
29	1	03-029-00	R.H. Front Guard	78	1	03-078-00	Air Motor Clamp	126	1	02-203-00	Motor Coupling, Hyd.
30	1	03-030-00	Gear	79	1	03-079-00	Air Motor	127	1	02-199-00	Drive Pin, Mtr. Coupling
31	2	90-057-11	1/4" Sq x1-3/16 Lg Key	81	4	90-055-52	1/4 Lock Washer	129	4	90-059-09	1/4-28 x 1/2 RHMS
32	1	03-032-00	Gear Shaft	82	1	03-082-00	Name Plate	130	24"	03-130-00	Jumper Cord
33	2	90-054-03	1/4-20 x 3/8 Lg SSS	83	1	90-800-01	1-1/4 Open End Wrench	131	1	03-131-00	Feed Handle Elec.
34	1	03-034-00	Pinion	84	2	03-084-00	Spacer	156	1	90-501-04	Closed End Splice
35	4	90-500-02	Grease Fitting	85	1	03-085-00	Lubricator	157	1	90-501-02	1/4 Ring Terminal
36	1	03-036-00	Bronze Bushing	86	4	90-050-07	1/4-20 x 3/4 SHCS	158	2	90-501-03	Hook Terminal
37	1	90-500-03	Grease Fitting	87	3	90-078-02	3/8 x 90° St. Elbow	159	3	90-501-05	Butt Splice
38	1	03-038-00	Bronze Bushing	88	1	90-078-03	3/8 x 5-1/2 Lg Nipple				
39	1	03-039-00	L.H. Front Guard	89	2	03-089-00	Clamp Assy.				
40	1	03-040-00	Drive Shaft	90	1	03-090-00	Filter				
41	3	90-064-05	5/16-18 x 1/2" Lg SSS	91	1	03-091-01	Air Hose				
42	1	03-042-00	R.H. Rear Guard	92	1	90-078-05	3/8 x 3/4 Reducer Coupling			02-402-00	Motor Oil 1 Gal
43	2	03-043-00	Shaft	93	1	90-078-01	3/8 Close Nipple			02-403-00	Anti Freeze 1 Gal
44	1	03-044-00	Feed Screw	94	1	90-078-04	3/8 x 3/8 Double Male Adaptor			03-409-00	12" Carbide Saw Blade
45	1	03-045-00	Feed Handle	95	1	03-095-00	Electric Cord			03-406-00	Saw Blade 1210-6D
46	1	04-101-00	Adaptor, Machine Drive	96	1	90-205-01	5/8-11 Nut			03-407-00	Saw Blade 1204-6D
47	1	03-047-00	Bearing Plate	97	1	90-205-51	5/8 Lockwasher			03-408-00	Saw Blade 1206-8D
48	4	90-051-06	1/4-20 x 5/8 Lg HHCS							03-410-00	Saw Blade 1406-6D
										03-411-00	Saw Blade 1306-7H

Discontinued- Some Parts Available

CP-8054 AIR MOTOR Model "A"

**500 RPM**

See Reverse Side For Parts List

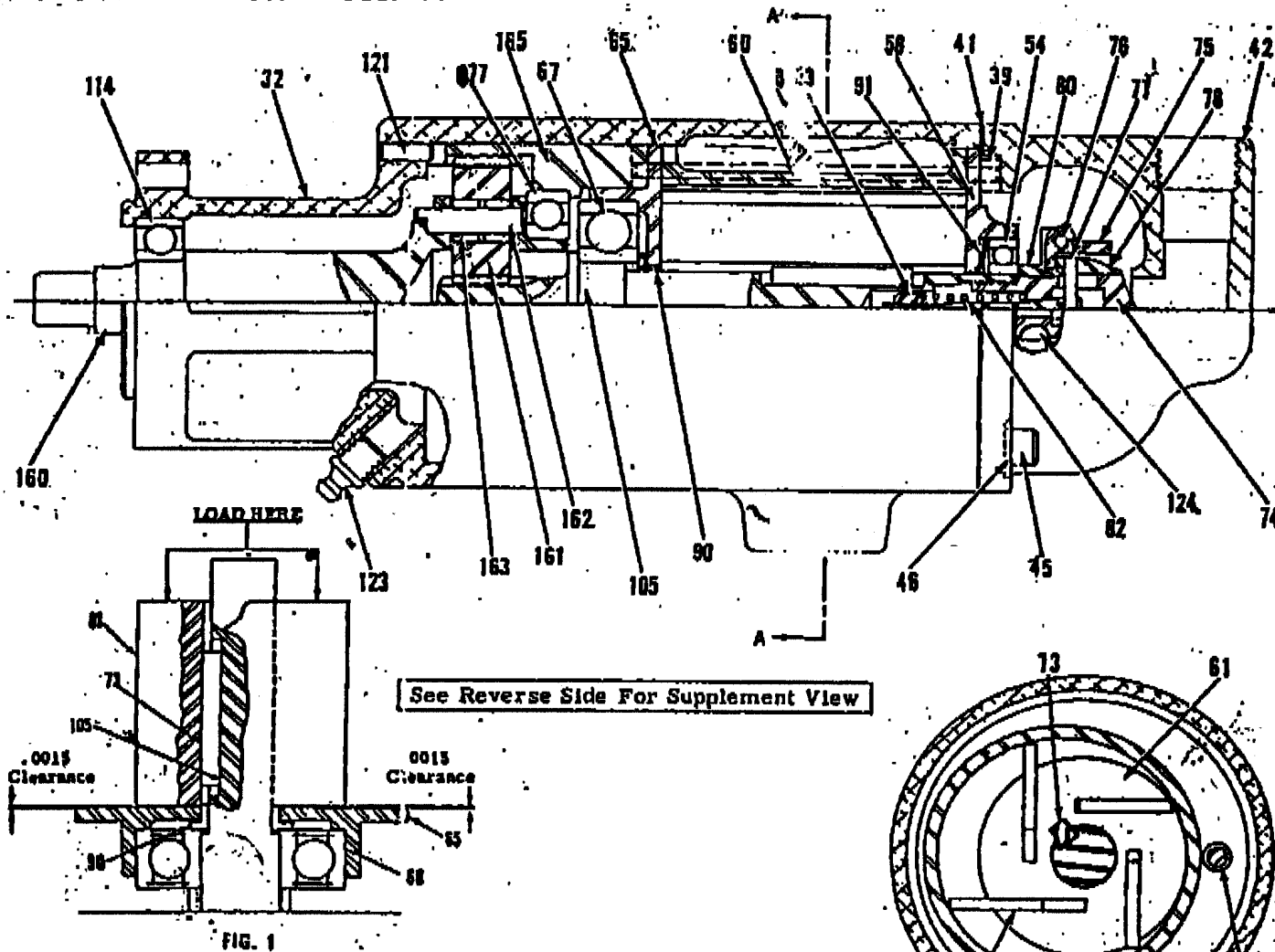


All Threads Are Right Hand Unless Otherwise Specified.

**NEW Rotor Blade No. C-134736**

# Discontinued- Some Parts Available

## CP-3754 AIR MOTOR Model "A"



When repairing motor, refer to Fig. 1. The rotor (81) is positively positioned off the lower endplate (85) by the use of a spacer (90). To set the clearance, assemble the parts as shown in Fig. 1, stand the rotor shaft on end, load the rotor and check the clearance with two .0015" feeler gages, one on each side of the rotor. If there is too much clearance, polish the length of the spacer (90) until a medium drag is felt on the .0015" feeler gages. If there is not enough clearance, a new spacer (90) is required.

All Threads Are Right Hand Unless Otherwise Specified.

Index No.	CP Part No.	Description	No. Req'd
32	XC-130270	Housing-Motor	1
30	XC-130285	Tube-Dowel	1
41	XC-130281	Gasket-Inlet Housing	1
42	XC-130280	Housing-Inlet	1
45	C-086343	Screw	4
46	S-000271	Lockwasher	4
54	C-108759	Bearing-Ball	1
58	C-127747	Plate-Upper End	1
59	C-127783	Pin-Dowel	1
60	C-127787	Liner	1
61	C-127785	Body-Rotor	1
62	C-127782	Blade-Rotor	4
65	C-127751	Plate-Lower End	1
67	C-126191	Bearing-Ball	1
70	C-127743	Key-Rotor Body	1
74	C-127735	Body-Governor	1
75	C-129539	Weight-Governor	2
76	C-127889	Pin-Governor Weight	2

Index No.	CP Part No.	Description	No. Req'd
77	G-071660	Pin-Roll	1
78	C-127733	Collar-Governor	1
80	XC-130331	Cage-Governor	1
82	XC-131945	Spring-Compression	1
83	C-127887	Nut-Governor Spring	1
90	C-128003	Spacer-Rotor	1
91	C-127742	Spring-Belleville	1
105	XC-130282	Shaft Rotor	1
114	C-116323	Bearing-Ball	1
121	C-094837	Pin	1
123	S-521215	Fitting-Zerk	1
124	S-016822	Key-Woodruff	1
160	XC-130290	Spindle	1
161	XC-130289	Gear-Idler	3
162	C-092261	Pin-Idler Gear	3
163	C-092260	Bearing-Needle	6
165	XC-130283	Gear-Internal	1
177	C-064765	Bearing-Ball	1