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Guillotine Pipe Saw User's Manual



E.H. Wachs Part No. 03-MAN-01
Rev. B, April 2014

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**EU DECLARATION OF CONFORMITY
WITH
COUNCIL DIRECTIVE 2006/42/EC**


Issue Details:	DATE: 1/1/2011	Place: E.H.Wachs, Lincolnshire, IL USA
Directives:	Machinery Safety Directive 2006/42/EC	
Conforming Machinery:	<u>Guillotine Pipe Saw:</u> Model D Guillotine, Wuper C Guillotine, Super D Guillotine	
Model Number:	04-000-02, 04-000-03 (Model D) 24-000-02, 24-000-03 (Super C) 25-000-01, 25-000-03 (Super D)	
Serial Number:		
Manufacturer:	E.H. Wachs 600 Knightsbridge Parkway Lincolnshire IL 60069 USA	
Responsible Representative:	Orbitalum Tools GmbH Josef-Schüttler-Str. 17, 78224 Singen Germany Tel. +49 (0) 7731 - 792 872 Fax +49 (0) 7731 - 792 566	
Harmonised Standards & Other Technical Standards/Specifications Applied or Referenced:	EN ISO 12100-1:2003 + A1:2009 EN ISO 12100-2:2003 + A1:2009 EN 60204-1:2006 (for electric machines) EN ISO 13857:2008 EN 982:1996 + A1:2008 (for hydraulic machines) EN 983:1996 (for pneumatic machines) EN 13732-1:2006 EN ISO 14121-1:2007 EN ISO 13850:2008 (for pneumatic machines)	
Provisions with which Conformity is Declared:	Essential Health and Safety Requirements of Annex 1 of the Machinery Directive	
We hereby certify that the machinery described above conforms to the provisions of Council Directive 2006/42/EC on the approximation of the laws of the Member States relating to the safety of machinery.		
Signed:		
Signatory:	Pete Mullally Quality Manager E.H. Wachs	

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Chapter 1

About This Manual

PURPOSE OF THIS MANUAL

This manual explains how to operate and maintain the Guillotine pipe saw. It includes instructions for set-up, operation, and maintenance. It also contains parts lists, diagrams, and service information to help you order replacement parts and perform user-serviceable repairs.

The Guillotine pipe saw is available in three machine sizes. This manual describes operation and maintenance of all three models; specifications are in Chapter 3.

Carefully read Chapter 2, Safety, and follow all guidelines for safe operation of the Guillotine saw.

HOW TO USE THE MANUAL

This manual is organized to help you quickly find the information you need. Each chapter describes a specific topic on using or maintaining your equipment.

Use these instructions to operate and maintain the equipment.

SYMBOLS AND WARNINGS

The following symbols are used throughout this manual to indicate special notes and warnings. They appear in the outside column of the page, next to the section they refer to. Make sure you understand what each symbol means, and follow all instructions for cautions and warnings.

Throughout this manual, refer to warnings, cautions, and notices with supplementary information.



WARNING

A WARNING alert with the safety alert symbol indicates a potentially hazardous situation that **could** result in **serious injury or death**.



CAUTION

A CAUTION alert with the safety alert symbol indicates a potentially hazardous situation that **could** result in **minor or moderate injury**.



This is the **safety alert symbol**. It is used to alert you to **potential personal injury hazards**. Obey all safety messages that follow this symbol to avoid possible injury or death.



This is the **equipment damage alert symbol**. It is used to alert you to **potential equipment damage situations**. Obey all messages that follow this symbol to avoid damaging the equipment or workpiece on which it is operating.



CAUTION

A CAUTION alert with the damage alert symbol indicates a situation that will result in **damage to the equipment**.



IMPORTANT

An IMPORTANT alert with the damage alert symbol indicates a situation that **may** result in **damage to the equipment**.



NOTE

This symbol indicates a user note. **Notes** provide additional information to supplement the instructions, or tips for easier operation.

MANUAL UPDATES AND REVISION TRACKING

Occasionally, we will update manuals with improved operation or maintenance procedures, or with corrections if necessary. When a manual is revised, we will update the revision history on the title page.

Current versions of E.H. Wachs Company manuals are also available in PDF format. You can request an electronic copy of this manual by emailing customer service at sales@wachSCO.com.

You may have factory service or upgrades performed on the equipment. If this service changes any technical data or operation and maintenance procedures, we will include a revised manual when we return the equipment to you.

TECHNICAL FILE RESPONSIBLE PARTY

The Guillotine pipe saw is manufactured by E.H. Wachs at the following address:

E.H. Wachs
600 Knightsbridge Parkway
Lincolnshire, IL 60069
U.S.A.

The following organization is the responsible party for maintaining the Guillotine technical file in the EU:

Orbitalum Tools GmbH
Josef-Schüttler-Str. 17
78224 Singen
Deutschland

Chapter 2

Safety

E.H. Wachs takes great pride in designing and manufacturing safe, high-quality products. We make user safety a top priority in the design of all our products.

Read this chapter carefully before operating your E.H. Wachs equipment. It contains important safety instructions and recommendations.

SAFE OPERATING GUIDELINES

Follow these guidelines for safe operation of all E.H. Wachs equipment.



Look for this symbol throughout the manual. It indicates a personal injury hazard.

- **READ THE OPERATING MANUAL.** Make sure you understand all setup and operating instructions before you begin. Keep this manual with the machine.
- **INSPECT MACHINE AND ACCESSORIES BEFORE USE.** Before starting the machine, look for loose bolts or nuts, leaking lubricant, rusted components, and any other physical conditions that may affect operation. Properly maintaining the machine can greatly decrease the chances for injury.
- **ALWAYS READ STICKERS AND LABELS.** Make sure all labels and stickers are in place, clearly legible, and in good condition. Refer to “Safety Labels” later in this chapter for label locations on the machine. Replace any damaged or missing safety labels; see Chapter 10 for ordering information.
- **KEEP CLEAR OF MOVING PARTS.** Keep hands, arms, and fingers clear of all rotating or moving parts. Always turn the machine off and disconnect the power source before doing any adjustments or service.
- **SECURE LOOSE CLOTHING AND JEWELRY.** Secure or remove loose-fitting clothing and jewelry, and securely bind long hair, to prevent them from getting caught in moving parts of the machine.
- **FOLLOW SAFE PROCEDURES FOR HANDLING LUBRICANTS.** Refer to the manufacturer’s instructions and the Material Safety Data Sheets.

Safe Operating Environment

- Do not use this equipment in a potentially explosive atmosphere. Fire or explosion could result, with the risk of serious injury or death.
- Provide adequate lighting to use the equipment, in accordance with worksite or local regulations.
- **KEEP WORK AREA CLEAR.** Keep all clutter and nonessential materials out of the work area. Only people directly involved with the work being performed should have access to the area.

Operating and Maintenance Safety

- This equipment is to be operated and maintained only by qualified, trained personnel.
- Make sure the equipment is stable when attached to the workpiece for the operation. Ensuring stability of the installed tool is the responsibility of the operator.
- Make sure the workpiece is supported adequately for installation of the equipment. This includes supporting any workpiece “fall-off” section when severing the workpiece. Ensuring support of the workpiece is the responsibility of the operator.
- Tooling on any cutting equipment—including lathe tools, saw blades, milling tools, etc.—may get very hot. Do not touch tooling until you have made sure it is cool enough to handle.
- Wear gloves when removing or cleaning up chips and cutting debris. Chips can be very sharp and cause cuts.
- Before performing any service on the equipment, disconnect the power source. Follow all lock-out/tag-out procedures required at the worksite.

Hydraulic Powered Equipment

- Hydraulic components such as hoses, motors, and manifolds will get hot during operation and may cause burns. Do not touch hydraulic components, except for operator controls, during or after operating the machine.



WARNING

Injection of hydraulic fluid through the skin is a serious injury that can result in infection, tissue damage, and possible loss of limb. **Seek medical treatment immediately.** First aid is not sufficient treatment for injection injury.

- **Hydraulic injection injury**—A pinhole in a hydraulic hose or fitting can eject fluid with enough force to pierce skin. Check hoses and fittings regularly for leaks. **Do not use bare hands to check for leaks while the system is pressurized.** If you suspect a leak, move a piece of paper or cardboard at least 6 inches (15 cm) over the suspicious area and watch for fluid spraying on the surface.

Pneumatic Powered Equipment

- Air motors may get hot during operation and may cause burns. Do not touch the air motor, except for operator controls, during or after operating the machine.
- Before disconnecting the air line from the equipment, always turn off air at the source and bleed all residual air pressure at the air motor.

Loss or Shut-Off of Power Supply

- If the power source to the equipment is lost, disconnect power from the equipment and lock out the power supply immediately to prevent accidental restarting of the machine.
- **ELECTRIC POWERED EQUIPMENT**—If the electric drive shuts off because of its built-in thermal protection, disconnect the motor from the power source immediately.
- For all power sources, follow all lock-out/tag-out procedures required at the worksite when disconnecting or servicing the equipment.

Safety Alerts in This Manual

The following alerts are used throughout this manual to indicate operator safety hazards. In all cases, these alerts include a notice describing the hazard and the means to avoid or reduce risk. Carefully read all safety alerts.



This icon is displayed with any safety alert that indicates a personal injury hazard.



WARNING

This safety alert, with the personal injury hazard symbol, indicates a potentially hazardous situation that, if not avoided, **could** result in **death or serious injury**.



CAUTION

This safety alert, with the personal injury hazard symbol, indicates a potentially hazardous situation that, if not avoided, **could** result in **minor or moderate injury**.

Protective Equipment Requirements

Protective Clothing

Wear safety shoes when operating or servicing the equipment. Serious injury could result from dropping the machine or its components.

Do not wear gloves while operating the machine. Gloves can become entangled in moving parts, resulting in serious injury. Gloves may be worn when setting up the machine or cleaning up after the operation, but take them off when operating the machine.



NOTE

Gloves should be worn when cleaning up chips and other cutting debris. Chips can be very sharp and can cause serious cuts. **Do not wear gloves when the machine is operating.**

Eye Protection

Always wear impact-resistant eye protection while operating or working near this equipment.

For additional information on eye and face protection, refer to Federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.133., Eye and Face Protection and American National Standards Institute, ANSI Z87.1, Occupational and Educational Eye and Face Protection.

Hearing Protection

This equipment can produce noise levels above 80 dB. Hearing protection is required when operating the equipment. The operation of other tools and equipment in the area, reflective surfaces, process noises, and resonant structures can increase the noise level in the area.

For additional information on hearing protection, refer to Federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.95, Occupational Noise Exposure and ANSI S12.6 Hearing Protectors.

SAFE OPERATION OF THE GUILLOTINE PIPE SAW

Intended Uses

The Guillotine pipe saw is designed to be clamped onto an in-line or open-ended pipe (using either a chain clamp or hydraulic autoclamp), and cut through the pipe using an oscillating saw motion.

Make sure to follow all safety guidelines and procedures required for machining operations at the work site, including personal protective equipment (PPE). Do not use the Guillotine pipe saw in a manner that violates these guidelines.

Proper Use of the Guillotine

- The Guillotine should only be used by trained, qualified operators.
- The workpiece must be within the operating capacity of the Guillotine model you are using. See operating envelope information and drawings in Chapter 3.
- Make sure the operating environment allows you to mount the machine securely and squarely on the workpiece.
- Make sure there is adequate clearance around the Guillotine and workpiece to operate the machine controls as described in the operating instructions (Chapter 5).
- Mount the Guillotine in an orientation that allows convenient connection of the drive power supply (air or hydraulic).
- Mount the Guillotine so that the feed drive can be operated conveniently, without reaching across moving parts.
- Use the Guillotine only on empty, depressurized pipe.

Misuse

- Do not attempt to mount or operate the Guillotine on any workpiece to which it cannot be securely clamped.
- Do not attempt to mount or operate the Guillotine on any workpiece that is not stable enough to hold the machine.
- Do not mount the Guillotine on the “fall-off” side of the cut line, unless you adequately rig and support the Guillotine and workpiece.
- Do not disable any safety feature of the Guillotine or remove any safety labeling. Replace worn or damaged safety labels immediately. (See “Safety and Operation Labels” later in this chapter.)

Potential Hazards

Figure 2-1 illustrates potential hazards of operating the Guillotine pipe saw. Refer to the description of each hazard for guidelines on safe operation.

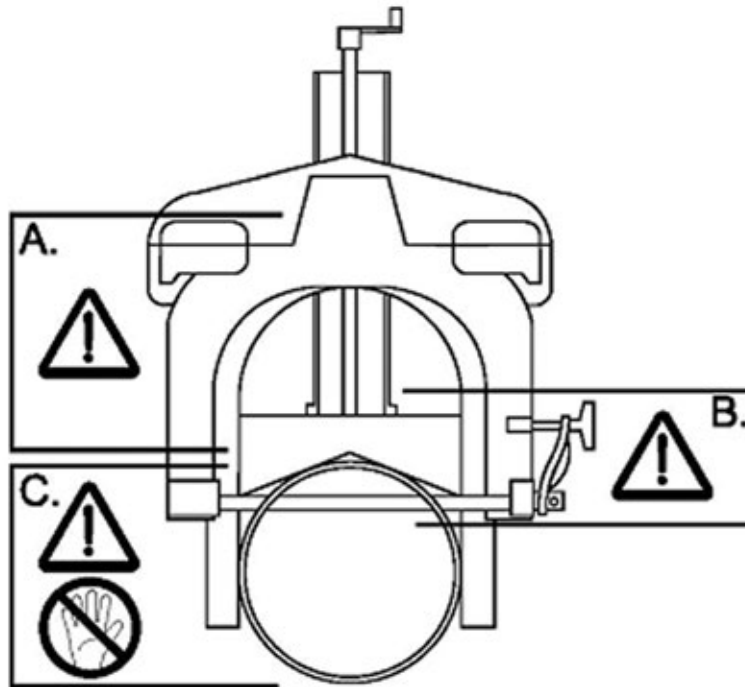


Figure 2-1. Potential operating hazards of the Guillotine saw. See the descriptions in the side column.

- A. Moving Parts Hazard**—Keep away from the oscillating saw bow and all moving parts while the machine is operating.
- B. Pipe Saddle Mounting Point**—Keep hands and feet clear when mounting and moving the saw on the workpiece.
- C. Cutting Zone**—Keep away from the saw blade while the machine is operating. Use care when handling the saw blade and cutting debris.

Guidelines for Safe Setup, Operation, and Service

Pre-Operation Checklist

Every time you use the Guillotine, perform the following checks to make sure it is in good operating condition:

- Check that all safety components are operating properly.
- Inspect it for damage or wear that could affect operation and safe use of the machine. Repair any defective component before using the machine.
- Make sure the machine is clean and properly lubricated.
- Make sure that the blade is sharp and in good condition. A poor quality blade can cause difficult cutting and the possibility of machine malfunction and/or injury.
- Check power connections (pneumatic or hydraulic) to make sure they are in good condition.

Operating Safety

- Stop the Guillotine cutting motion to adjust the workpiece (shim, wedge, clear chips, etc.) or make any machine adjustments.
- Use a support structure or catch device to prevent the cut-off piece of the pipe from falling.
- Keep air and hydraulic hoses away from moving parts while operating the machine.

Service Checklist

- Disconnect power from the Guillotine during service.
- Retract the saw bow before performing service. Do not disassemble any components of the saw with the blade in the workpiece.

Safe Lifting and Handling

Use care when lifting the Guillotine saw to avoid injury. All Guillotine models are too heavy to be lifted by one person. A lifting device (crane or hoist) is required for lifting and mounting the saw. Use the lift eyes on the saw to lift it. Do not attach the lifting device to other components.

- It is the responsibility of the end user to determine whether a machine or assembly can be lifted by two or more people. A lifting device is recommended for machines or assemblies that cannot be handled easily by two people.
- Do not rig or lift the Guillotine while power is attached.

Safety and Operation Labels

The following labels are provided on the Guillotine. If any of these labels is damaged or missing, replace it immediately. See Chapter 10 for ordering information.

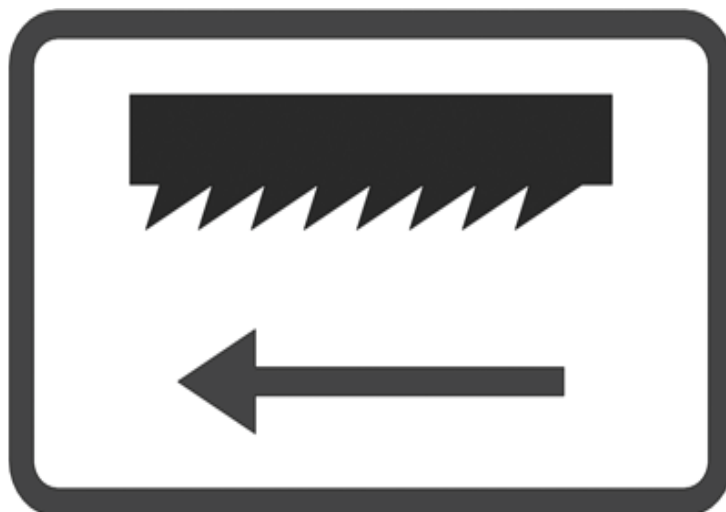


Figure 2-2. The blade direction labels are attached to both sides of the saw frame assembly. Make sure to install the blade with the saw teeth in the correct direction. (Part no. 03-113-00.)



Figure 2-3. The cam wheel label is on the back of the main assembly, illustrating the direction of rotation. (Part no. 03-113-01.)

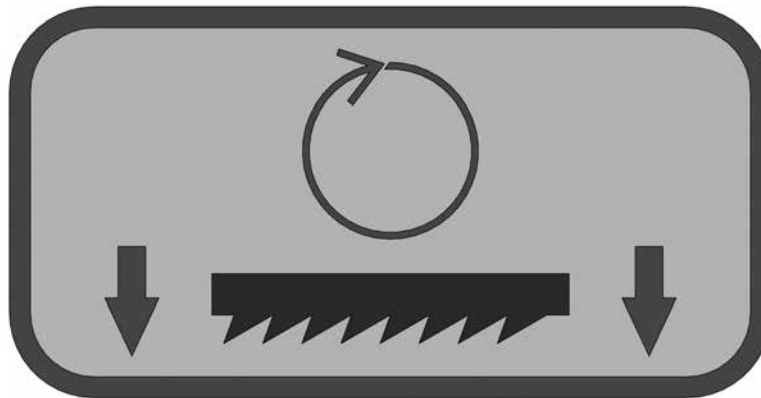


Figure 2-4. The feed direction label shows the operating direction for the feed handle. (Part no. 03-113-03.)



Figure 2-5. The moving parts warning label is attached in 2 places on the saw frame assembly. (Part no. 03-113-04.)



Figure 2-6. The blade hazard label is attached in 2 places on the saw frame assembly. (Part no. 03-113-05.)

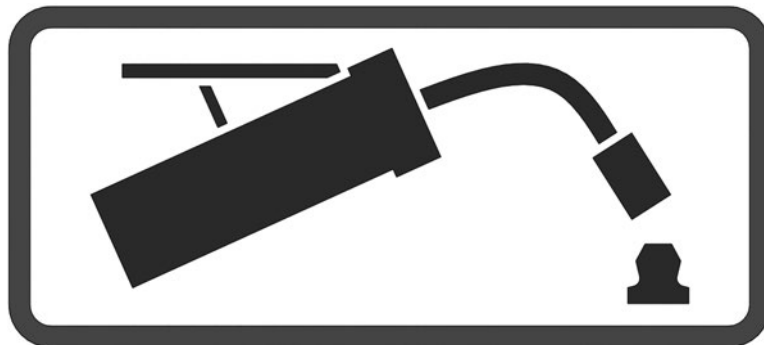


Figure 2-7. The grease fitting label is attached to the yoke grease cover on the saw frame assembly. Remove the cover to grease the yoke. (Part no. 03-113-06.)

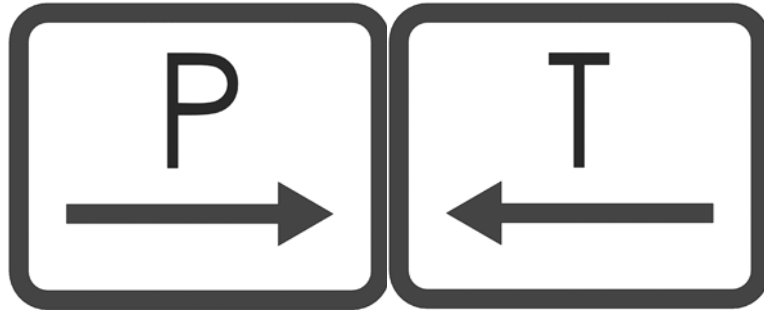


Figure 2-8. The pressure and tank hydraulic fitting labels are attached to the feed weldment of hydraulic Guillotine models. The arrows indicate hydraulic flow direction through the ports. (Part numbers 03-113-07 and 03-113-08.)



Figure 2-9. The Read Manual label is attached at the top of the main frame assembly. (Part no. 90-900-01.)

Chapter 3

Introduction to the Equipment

OVERVIEW OF THE GUILLOTINE

The Guillotine pipe saw product line includes three models for cutting pipes ranging from 2” to 24” (51-610 mm) diameter. The Guillotine will cut pipes of all materials, and can also be used to cut solids such as bar stock and rails.

The Guillotine mounts directly to the pipe using a V-shaped saddle with a clamping chain. The saddle is precisely machined for automatic square alignment when the chain is tightened. The saw can be mounted in any orientation to horizontal or vertical pipe.

The blade operates on an oscillating bow that lifts the blade out of the cut on the return stroke, increasing blade life. On/off and speed controls are provided for the cutting drive.

The oscillating bow is mounted on a feed screw for feeding the saw. A manual feed handle at the top of the machine allows the operator to feed the blade into the workpiece as the machine cuts.

Three standard Guillotine pipe saw models are available:

- Super C, with a pipe capacity of 2”-12” (51-305 mm)
- Model D, with a pipe capacity of 10”-16” (254-406 mm)
- Super D, with a pipe capacity of 10”-24” (254-610 mm).

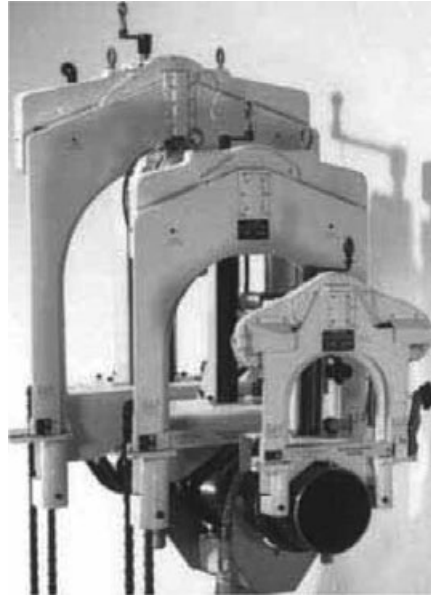


Figure 3-1. The photo shows the Super D, Model D, and Super C Guillotine pipe saws.

Machine Specifications

Table 1 lists the operating capacities of the Guillotine saw models. See the operating envelope drawings at the end of this chapter for all dimensional details.

Table 1: Guillotine Saw Capacities

Model	Pipe Capacity	Solids Capacity	Cutting Stroke	Weight
Super C	2"-12" (51-305 mm)	2"-12.75" (51-324 mm)	2" (51 mm)	135 lb (62 kg)
Model D	10"-16" (254-406 mm)	10"-18.62" (254-473 mm)	2" (51 mm)	325 lb (148 kg)
Super D	10"-24" (254-610 mm)	10"-24.5" (254-622 mm)	4" (102 mm)	415 lb (187 kg)

Power Requirements

Table 2 lists the air and hydraulic power requirements for the Guillotine saw models.

Table 2: Guillotine Saw Power Requirements

Model	Air Requirements	Hydraulic Requirements
Super C	36 cfm @ 90 psi (1019 l/min @ 6.2 bar)	12 gpm @ 1800 psi (45 l/min @ 124 bar)
Model D	95 cfm @ 90 psi (2690 l/min @ 6.2 bar)	12 gpm @ 1800 psi (45 l/min @ 124 bar)
Super D	95 cfm @ 90 psi (2690 l/min @ 6.2 bar)	15 gpm @ 1900 psi (57 l/min @ 131 bar)

Special-Order Options

- *Hydraulic autofeed*—available on hydraulic models.

In this configuration, the saw is operated from a hydraulic control panel with controls for the cutting and feed drives. This allows remote operation in hazardous or hard-to-access work locations.

- *Screw clamping mechanism.*

A screw-driven clamp is available as an option for work environments where the chain clamp is difficult to install.

Call E.H. Wachs sales or your Wachs distributor to discuss your requirements for these special-order options.

Noise Levels

The noise levels in Table 3 were measured at 1 meter high and 1.6 meters away from the machine, equipped with the air motor drive. (Hydraulic drives have lower noise levels.)

Table 3: Guillotine Noise Levels

Continuous “A”-weighted sound pressure level at workstation	72 dBA
Peak “C”-weighted maximum sound pressure	90 dBA
Sound power level emitted by machine	86 dBA

OPERATING ENVELOPES

The drawings on the following pages illustrate the operating envelope for all three Guillotine models. Each model is available with either pneumatic or hydraulic drive; separate drawings are provided for each drive option.

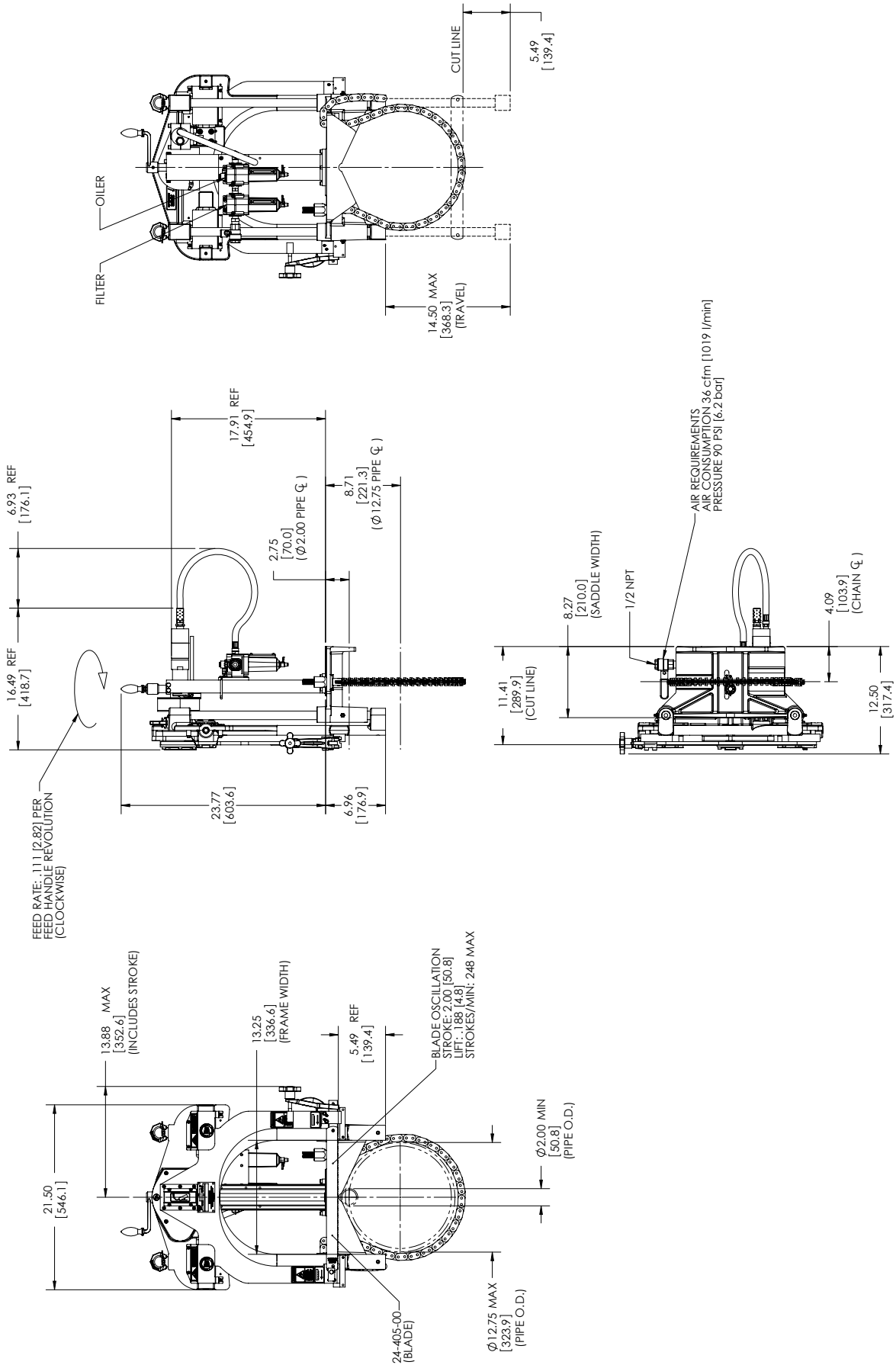


NOTE

The “operating envelope” is the space required around the workpiece to install and operate the machine.

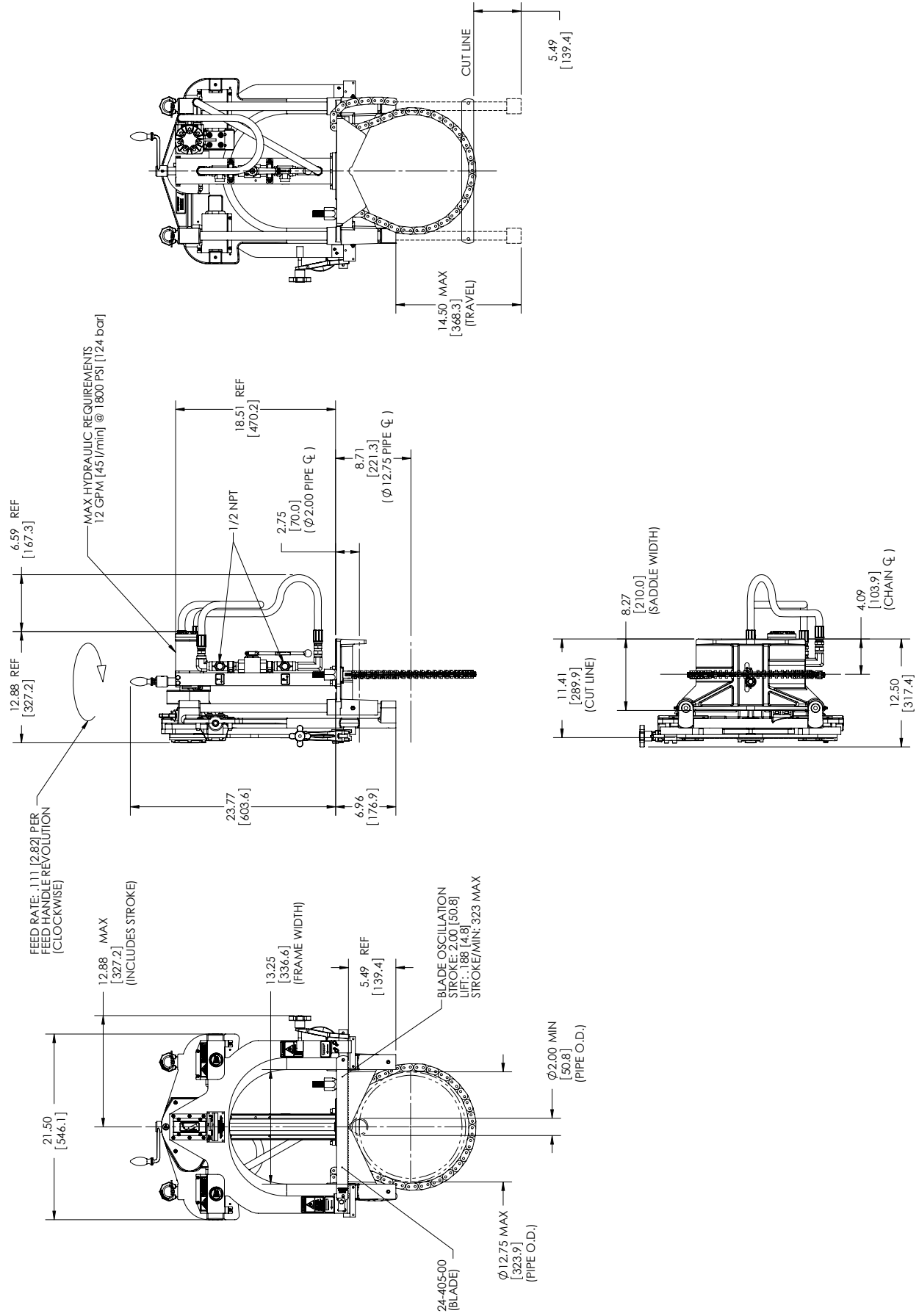
Super C, Pneumatic Drive (24-000-02)

DIMENSIONS IN BRACKETS ARE MILLIMETERS



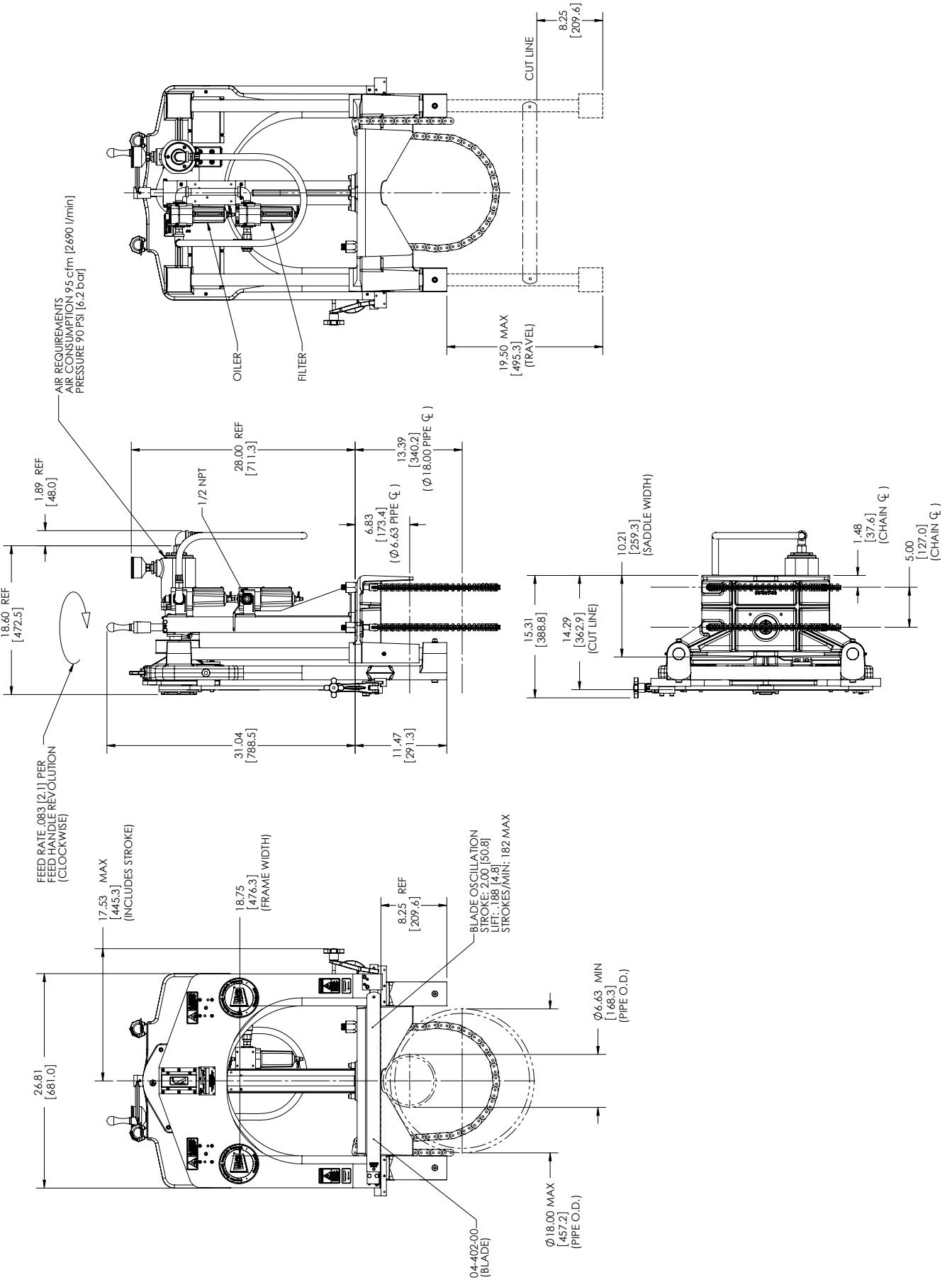
Super C, Hydraulic Drive (24-000-03)

DIMENSIONS IN BRACKETS ARE MILLIMETERS



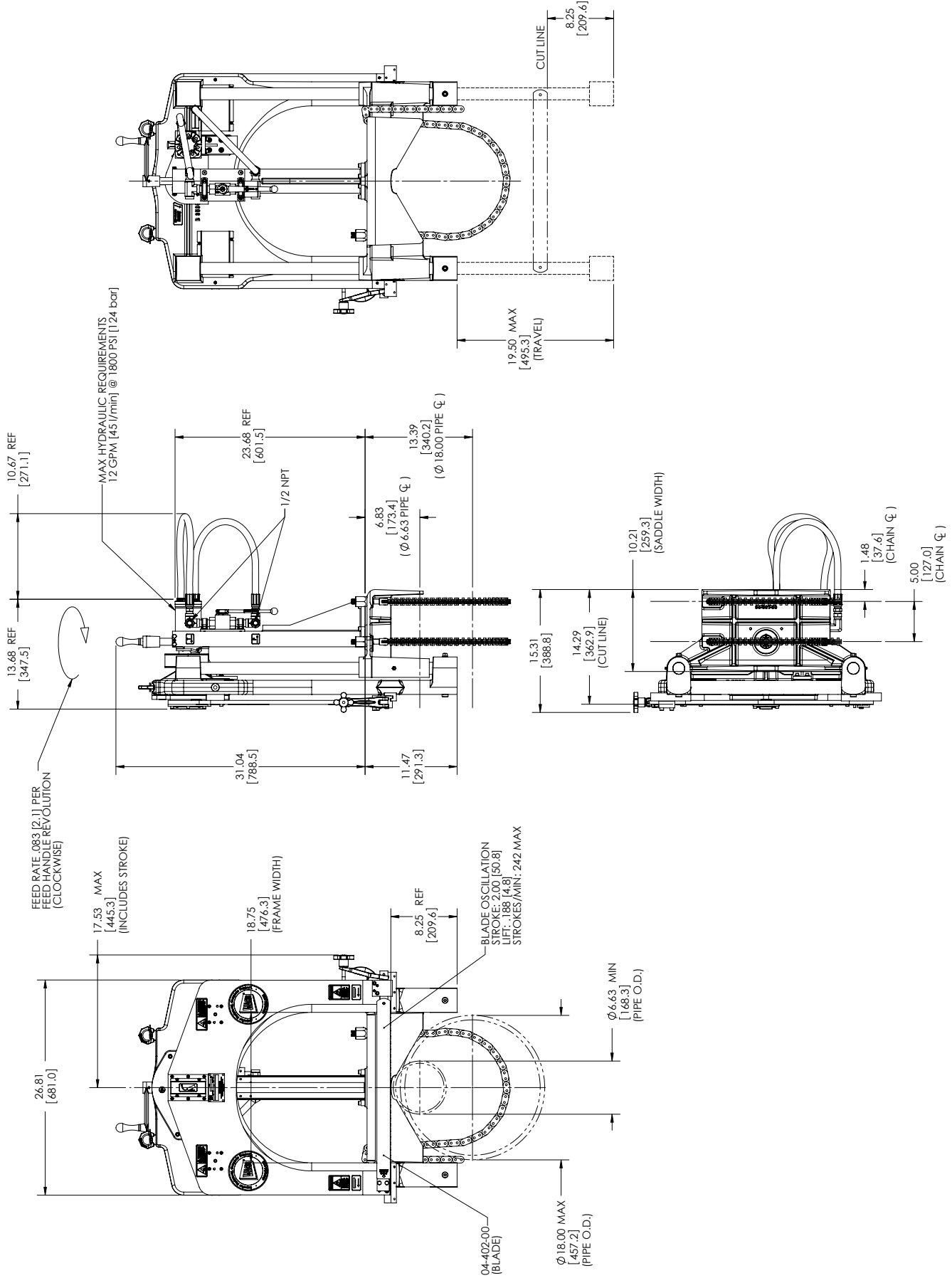
Model D, Pneumatic Drive (04-000-02)

DIMENSIONS IN BRACKETS ARE MILLIMETERS



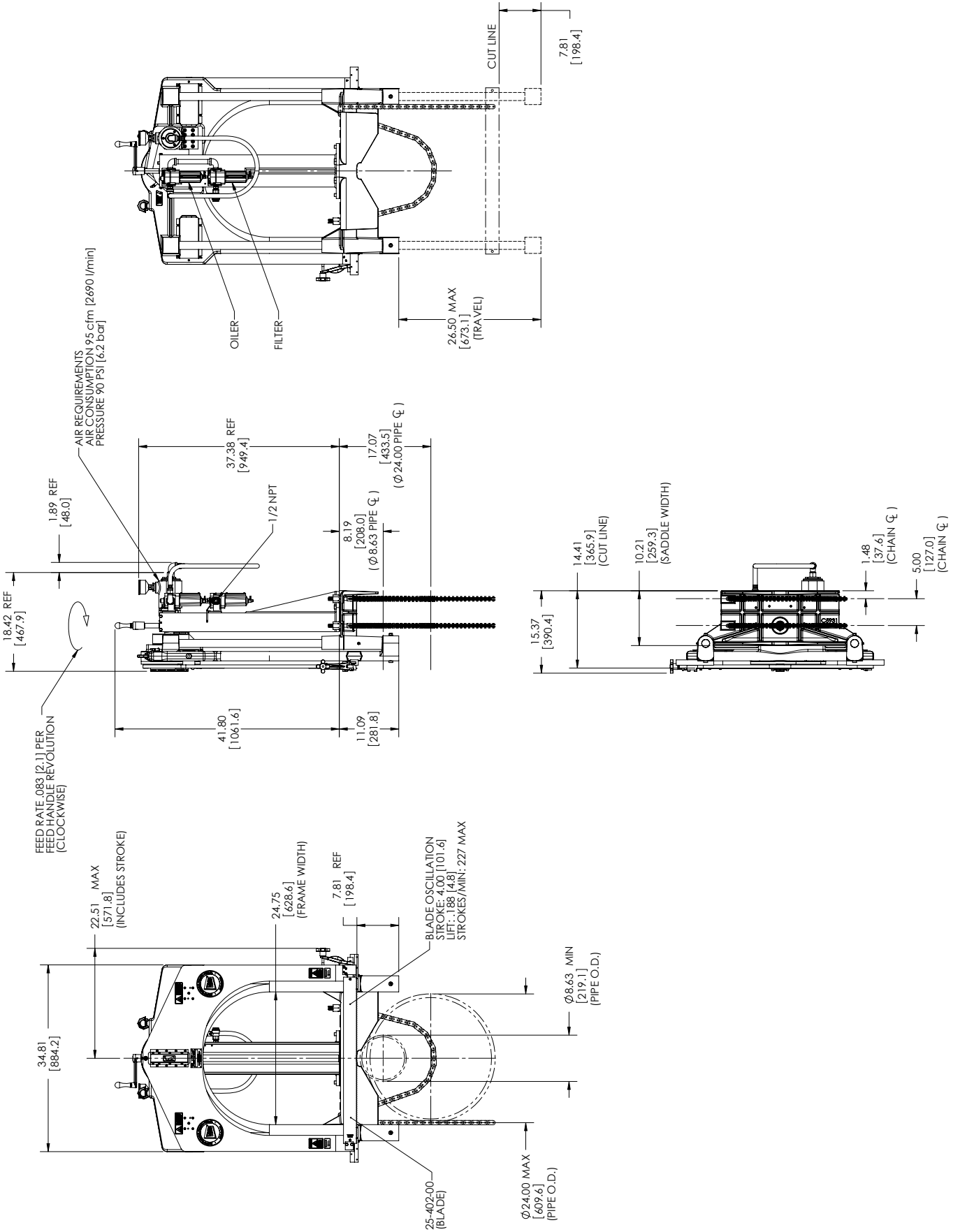
Model D, Hydraulic Drive (04-000-03)

DIMENSIONS IN BRACKETS ARE MILLIMETERS



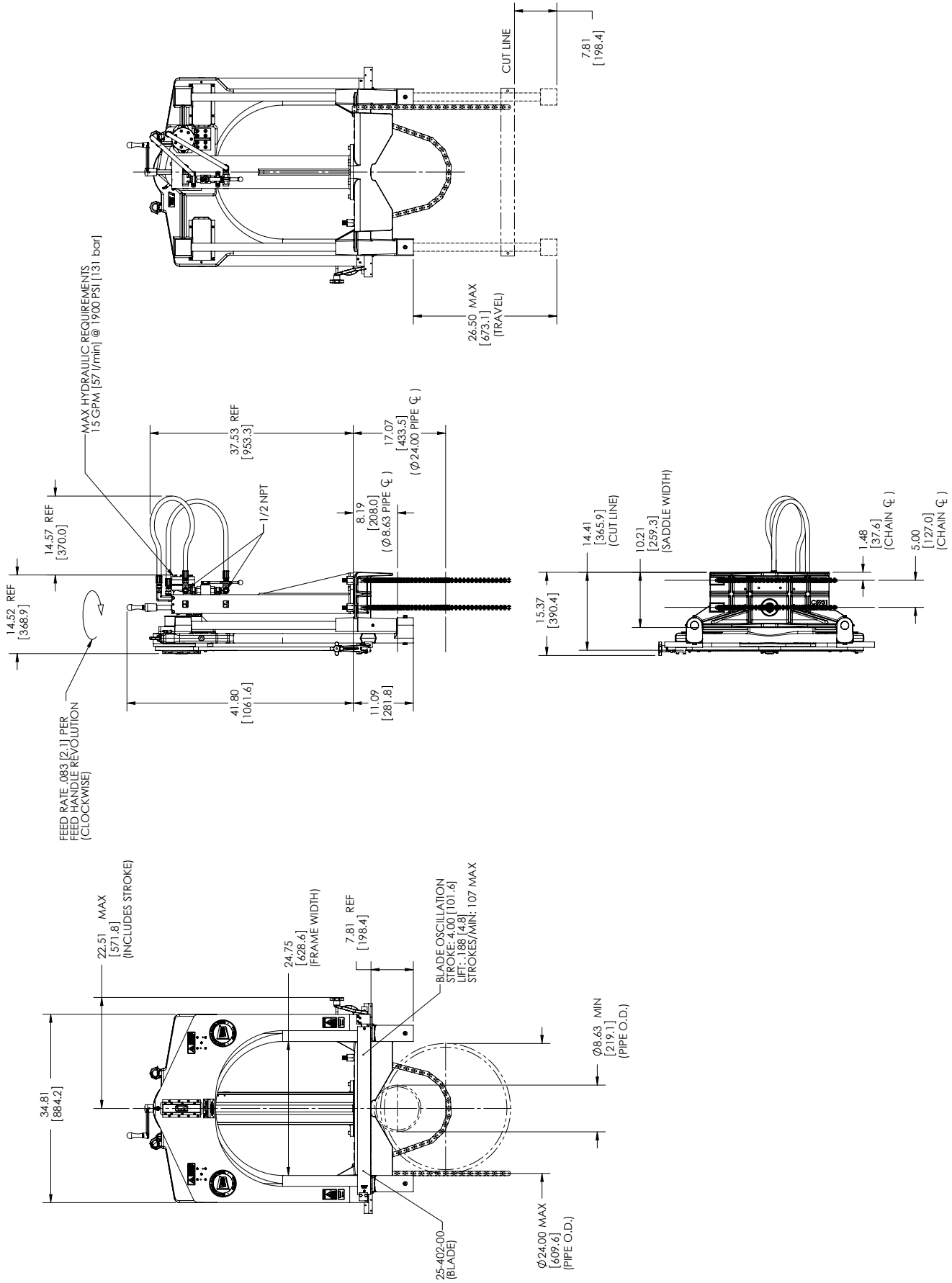
Super D, Pneumatic Drive (25-000-01)

DIMENSIONS IN BRACKETS ARE MILLIMETERS



Super D, Hydraulic Drive (25-000-03)

DIMENSIONS IN BRACKETS ARE MILLIMETERS



Chapter 4

Assembly, Disassembly, and Storage

The Guillotine saw is shipped from the factory completely assembled and lubricated. The blade is pre-installed, so it is only necessary to connect the power source to start using the machine.

Disconnect the Guillotine saw from the power source before storing it. You can leave the saw assembled and the blade installed for storage.

Move the bow all the way up to its storage position by turning the feed handle counter-clockwise until the bow tops out.

STORAGE/SHIPPING CONTAINERS

The Super C Guillotine is provided with a shipping/storage case. Store the Super C as shown in Figure 4-1 and Figure 4-2.

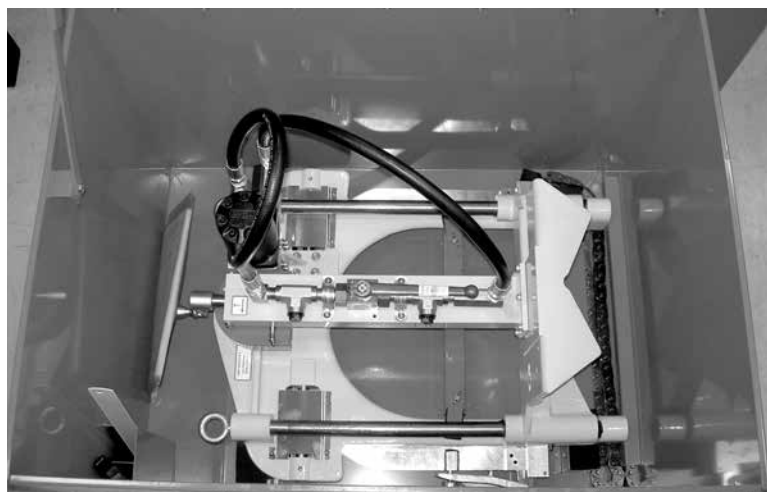


Figure 4-1. The photo shows the Super C Guillotine stored in its case.

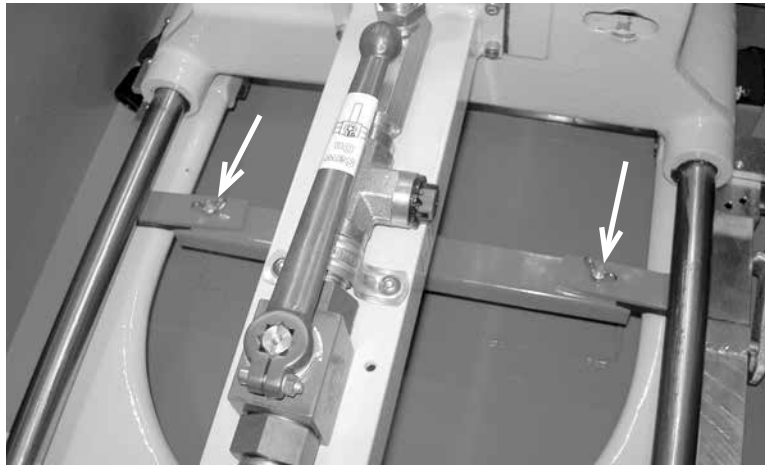


Figure 4-2. Secure the Super C in the case using the wing nuts on the two hold-down latches. Loosen the nuts and swing the latches aside to remove the saw from the case.

The Model D and Super D Guillotines are shipped on wooden shipping pallets. It is recommended that you keep the pallet for shipping and storage of the saw. Secure the machine to the pallet when storing it.

STORAGE GUIDELINES

- Clean the machine by wiping off dirt, debris, and accumulated oil or grease.
- Put oil in the air motor oiler, and operate the motor for a few seconds to lubricate its internal components.
- Lubricate the machine according to the instructions in Chapter 6.
- Spray or wipe a light coating of anti-corrosion lubricant on non-finished, non-painted surfaces.
- Put the machine in its storage case or pallet, with all components stored in their compartments.
- If possible, keep the machine stored indoors and away from moisture.

Chapter 5

Operating Instructions

INSTALLING THE **B**LADE

1. If you are replacing a broken blade, bring the saw bow into its uppermost position by turning the feed handle counter-clockwise.
2. Loosen the blade by turning the tension knob counter-clockwise.
3. Remove the worn blade by pulling it off the mounting pins.
4. Put the new blade onto the mounting pins. Make sure the teeth point to the left as you face the machine; see the blade direction labels on the bow.
5. Turn the blade tension knob clockwise to tighten the blade. A sharp, taut blade will assure a straight, clean cut.

MOUNTING THE **S**AW ON THE **W**ORKPIECE

You can mount the saw with or without the blade installed. It is recommended that you mount the saw with the power source (air or hydraulic) disconnected.

1. Make sure the bow is retracted all the way to the top. Turn the feed handle counter-clockwise to retract the bow.
2. Using a chain or lift straps, attach a lifting device to the saw.
3. Lift the saw into place on the workpiece and position the saddle at the mounting location. Make sure the saddle is snug against the workpiece.
4. Unscrew the chain clamping nut to the end of the clamping screw, so that the top of the nut is flush with the end of the screw.



NOTE

The Super C Guillotine has one clamping chain. The Model D and Super D have two clamping chains.

5. Wrap the clamping chain(s) around the workpiece. Pull the chain tight and engage the closest cross pin in the clamping slot.



Figure 5-1. Fasten the clamping chain (or chains) around the pipe and through the clamping slot in the saddle.

6. Tighten the chain clamping nut until the saw is solidly mounted on the workpiece.



Figure 5-2. Tighten the chain clamping nut to secure the saw to the pipe.

OPERATING THE SAW

Make sure the section of the workpiece that the saw is mounted on is stable and will not fall when the cut is complete.



WARNING

Make sure that the saw, and the workpiece on both sides of the cut line, are securely supported. Severe injury could result if the machine or workpiece are not stable.



WARNING

Keep clear of the blade and moving components of the saw while it is operating. Severe injury could result from contact with the machine.

Make sure the fall-off piece can drop safely after the cut is complete, or that it is supported

1. Turn on the power supply at the source.
2. Start the saw motion using the controls on the drive motor.
3. Feed the blade into 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.
 - When cutting through solid material, turn the feed handle approximately 1/2 of a revolution for each cutting stroke.

- In light cutting, such as through the center of cast iron pipe, feed at the rate of about 1/4 turn of the feed handle per stroke.
 - As you cut, adjust the feed rate for the most effectively cutting with the least strain on the machine.
4. When cut has been completed, turn off the saw drive motor.
 5. Turn the feed handle counter-clockwise to retract the blade. If there is not enough clearance to raise the blade through the cut, remove the blade before retracting the bow.

Cutting Tips

- It is recommended to shim up the pipe to hold it in alignment while cutting.
- It is recommended to drive wedges into the saw cut to prevent the blade from binding.
- If the cut closes due to ground pressure, remove the blade, move the saw over about a half inch, and make a second cut. You can proceed to knock out the ring that you cut, leaving more space for the saw to work.
- Use a carbide blade for cutting cast or ductile iron, or cement-lined or asbestos-lined pipe.
- On cement-asbestos pipe, clean the dust from the teeth between cuts. Wear a respirator when handling asbestos cutting debris.

Cutting Lubrication

- When cutting steel pipe, using cutting oil on the blade is recommended.
- When cutting cast iron, using lubricant is not required, 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.
- When cutting cement-asbestos pipe, cut it dry.

Chapter 6

Routine Maintenance

DAILY MAINTENANCE

After each use, clean debris from all moving parts, including the guide shafts, reciprocating shafts, and saw frame guides. (See assembly drawings in Chapter 8 for identifying components.) This will prolong the life of the machine.

1. Use a brush or compressed air to remove loose debris from all sliding surfaces.
2. Neutralize any corrosive fluids that the machine may have come into contact with during operation, by wiping surfaces with a clean cloth sprayed with a household cleaning solvent.

LUBRICATION

There are 6 grease fittings on the Guillotine saw. Lubricate all fittings with a good grade of soft grease each day before using the saw. The fittings are illustrated in Figure 6-1.

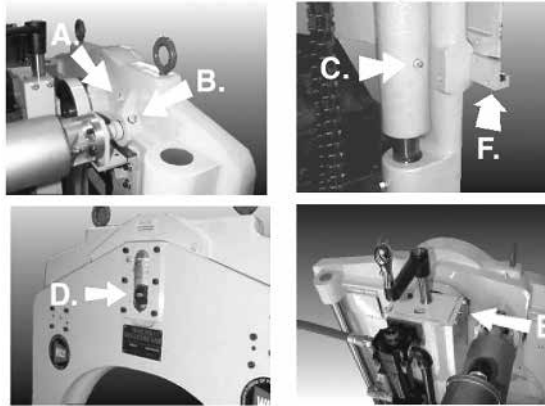


Figure 6-1. The photos illustrate the grease points on the Guillotine saw.

- A. Feed Screw
- B. Cam Wheel
- C. Vertical Guide Shafts
- D. Cam Follower
- E. Feed Bracket Assembly
- F. Saw Frame Guide

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.

Chapter 7

Service and Repair

TROUBLESHOOTING

Table 1 on the following page lists common operating problems and describes possible solutions.

If a problem persists or is not listed in the table, cease operation and contact E.H. Wachs customer service for additional instructions.

Table 1: Guillotine Saw Troubleshooting

Trouble	Possible Cause	Remedy
Drive Motor stalls.	Air Motor is freezing due to cold conditions.	Use an Anti-Freeze oil.
	Insufficient air supply.	Check air supply. (90 psi constant/100 cfm)
	Insufficient hydraulic oil supply	Check Hydraulic unit for proper levels. (see hydraulic machine specifications)
	Infeed too hard or too fast	Retract blade, feed slower.
	Dull Cutting blade.	Change blade.
Machine not cutting straight	Infeed too hard or fast.	Reduce infeed speed.
Machine air motor will not start	Dirt and/or corrosion in drive motor.	Remove motor from saw, flush with a light oil or mineral spirits. Run air through motor, turn on and off several times. Hand turn motor drive shaft to free motor.
Machine shifts from its original position.	Loose tensioning chain.	Tighten chain.
Excessive vibration.	Blade loose	Tighten blade.
	Excessive wear on saddle guide rod bushing.	Return to E.H. Wachs for repair.
Machine stalls	Saw is feeding too fast	Slow feed rate
	Excessive wear on Feed Nut and Screw Assembly.	Return to E.H. Wachs for repair.

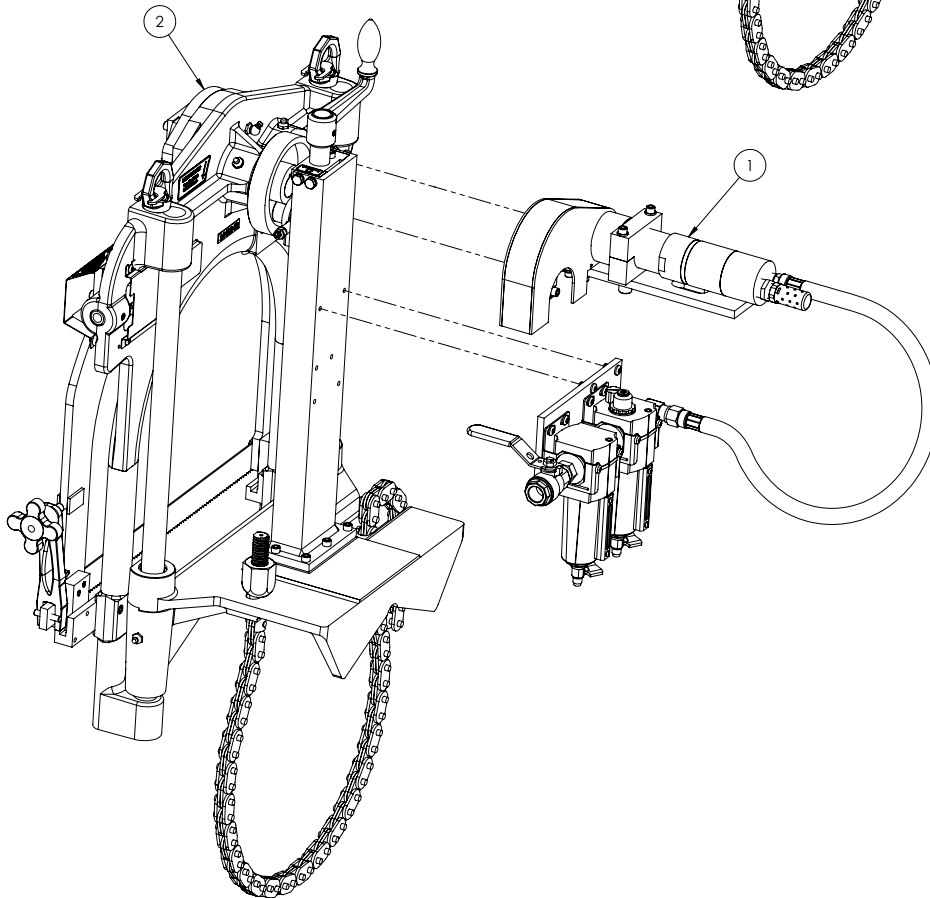
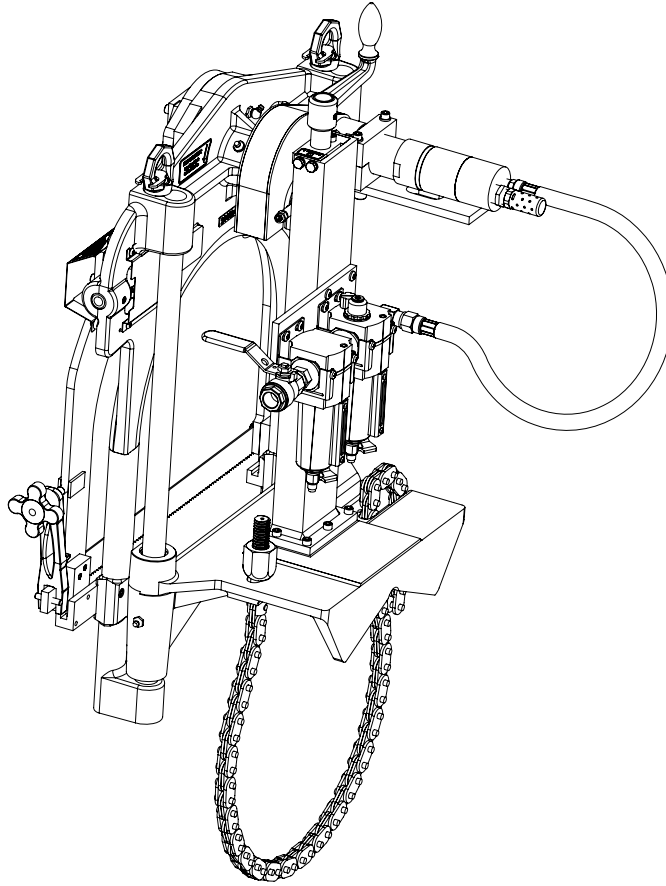
Chapter 8

Parts Lists and Drawings

This chapter contains exploded view drawings with parts lists for all three Guillotine models, including sub-assemblies. To identify and order parts, locate the assembly for your Guillotine model. Sub-assemblies are called out by part number on top-level assemblies.

Super C Guillotine, Pneumatic, 24-000-02

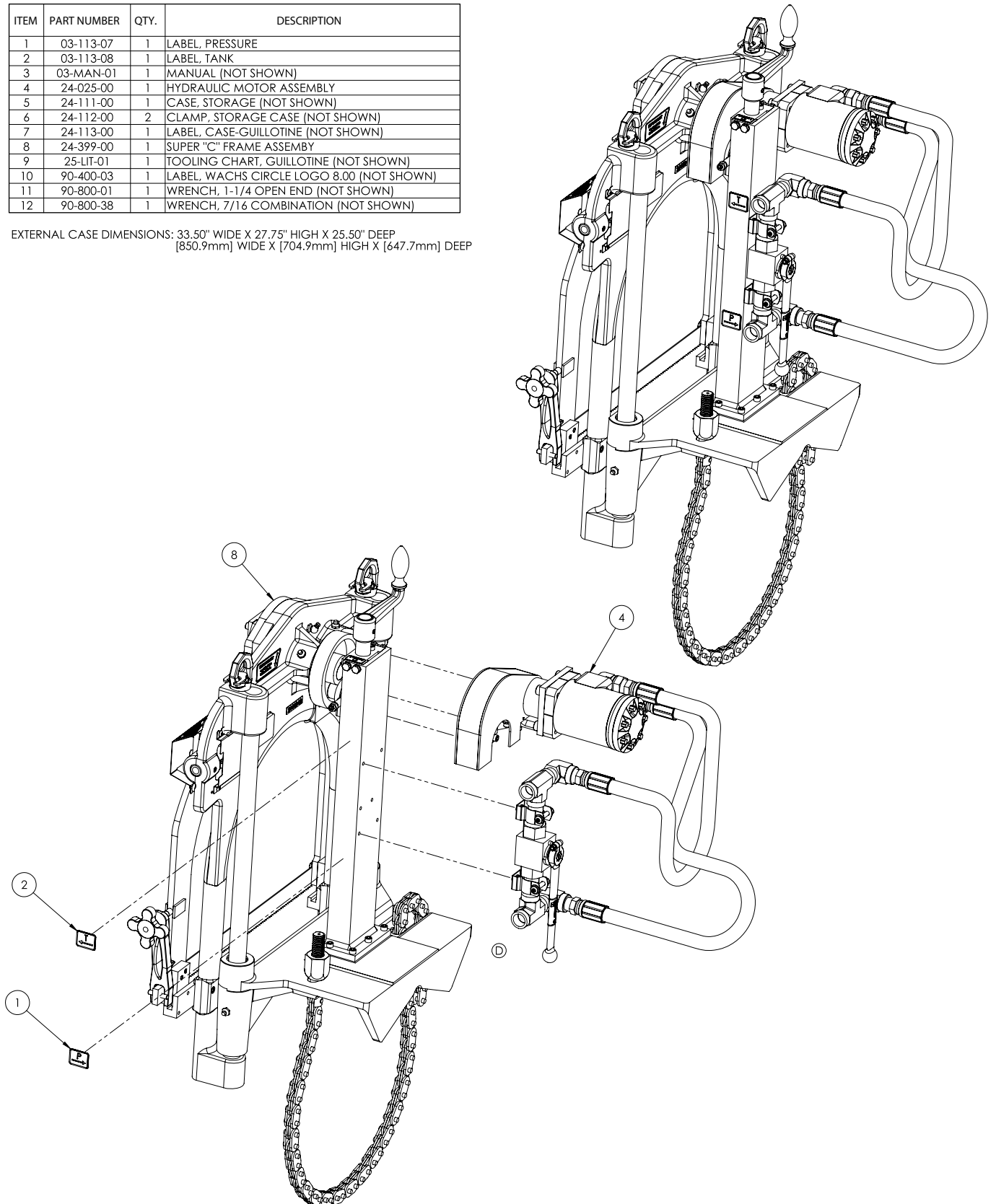
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	24-024-00	1	SUPER "C" AIR MOTOR ASSEMBLY
2	24-399-00	1	SUPER "C" FRAME ASSEMBY
3	03-MAN-01	1	MANUAL (NOT SHOWN)
4	24-111-00	1	CASE, STORAGE (NOT SHOWN)
5	24-112-00	2	CLAMP, STORAGE CASE (NOT SHOWN)
6	90-400-03	1	LABEL, WACHS CIRCLE LOGO 8.00 (NOT SHOWN)
7	90-800-01	1	WRENCH, 1-1/4 OPEN END (NOT SHOWN)
8	90-800-38	1	WRENCH, 7/16 COMBINATION (NOT SHOWN)



Super C Guillotine, Hydraulic, 24-000-03

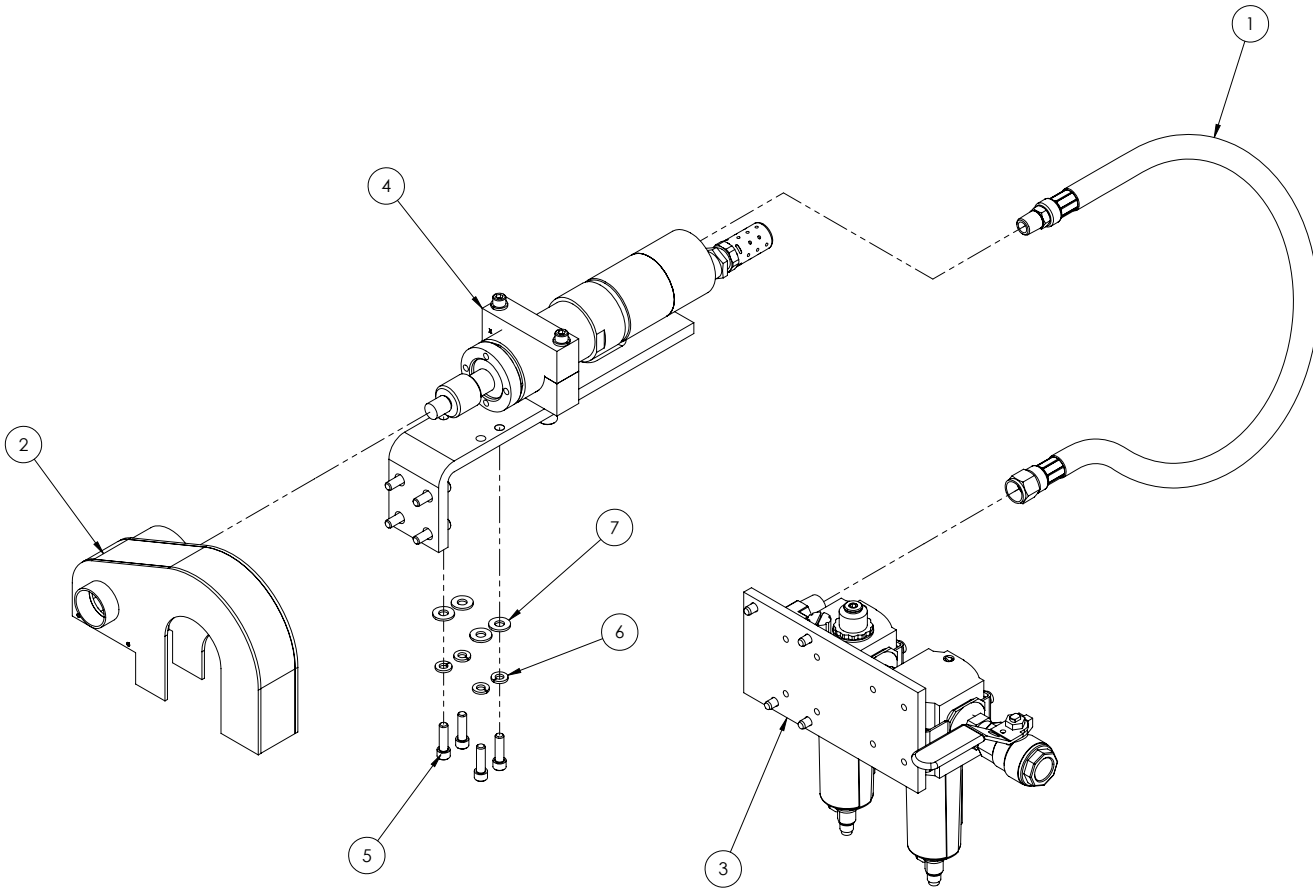
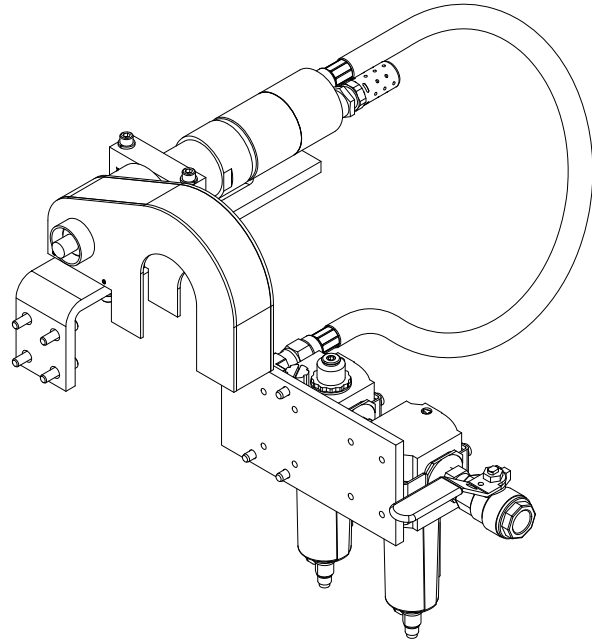
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-113-07	1	LABEL, PRESSURE
2	03-113-08	1	LABEL, TANK
3	03-MAN-01	1	MANUAL (NOT SHOWN)
4	24-025-00	1	HYDRAULIC MOTOR ASSEMBLY
5	24-111-00	1	CASE, STORAGE (NOT SHOWN)
6	24-112-00	2	CLAMP, STORAGE CASE (NOT SHOWN)
7	24-113-00	1	LABEL, CASE-GUILLOTINE (NOT SHOWN)
8	24-399-00	1	SUPER "C" FRAME ASSEMBY
9	25-LIT-01	1	TOOLING CHART, GUILLOTINE (NOT SHOWN)
10	90-400-03	1	LABEL, WACHS CIRCLE LOGO 8.00 (NOT SHOWN)
11	90-800-01	1	WRENCH, 1-1/4 OPEN END (NOT SHOWN)
12	90-800-38	1	WRENCH, 7/16 COMBINATION (NOT SHOWN)

EXTERNAL CASE DIMENSIONS: 33.50" WIDE X 27.75" HIGH X 25.50" DEEP
 [850.9mm] WIDE X [704.9mm] HIGH X [647.7mm] DEEP



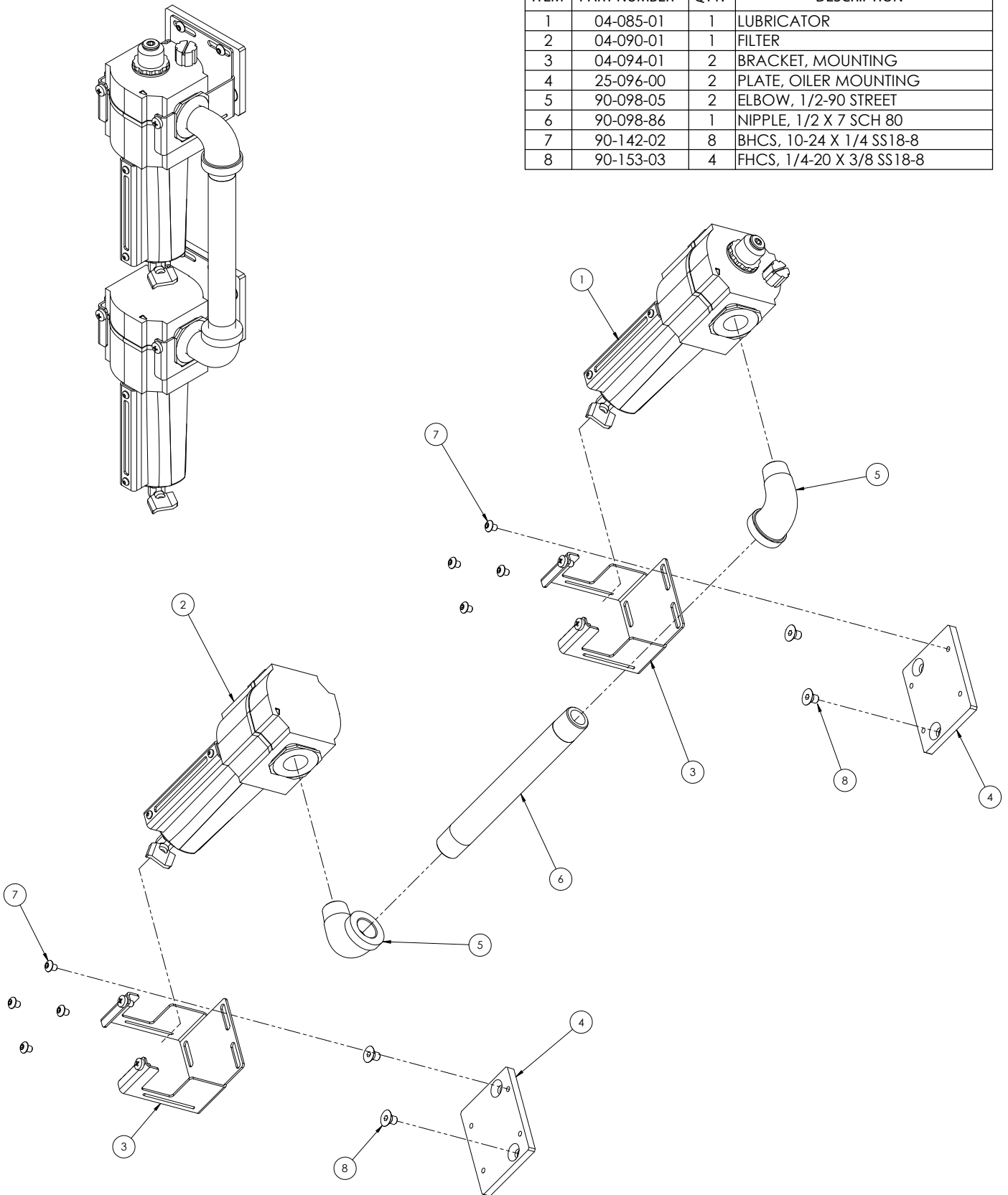
Super C Air Drive Assembly, 24-024-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-091-01	1	AIR HOSE, 3/8 DIA. X 24' LONG
2	24-081-00	1	GUARD, C-SERIES GUILLOTINES
3	24-501-00	1	LUBRICATOR AND FILTER ASSEMBLY
4	24-502-00	1	AIR MOTOR AND MTG. BRKT. ASSEMBLY
5	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
6	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
7	90-155-53	4	WASHER, 1/4 FLAT SS18-8



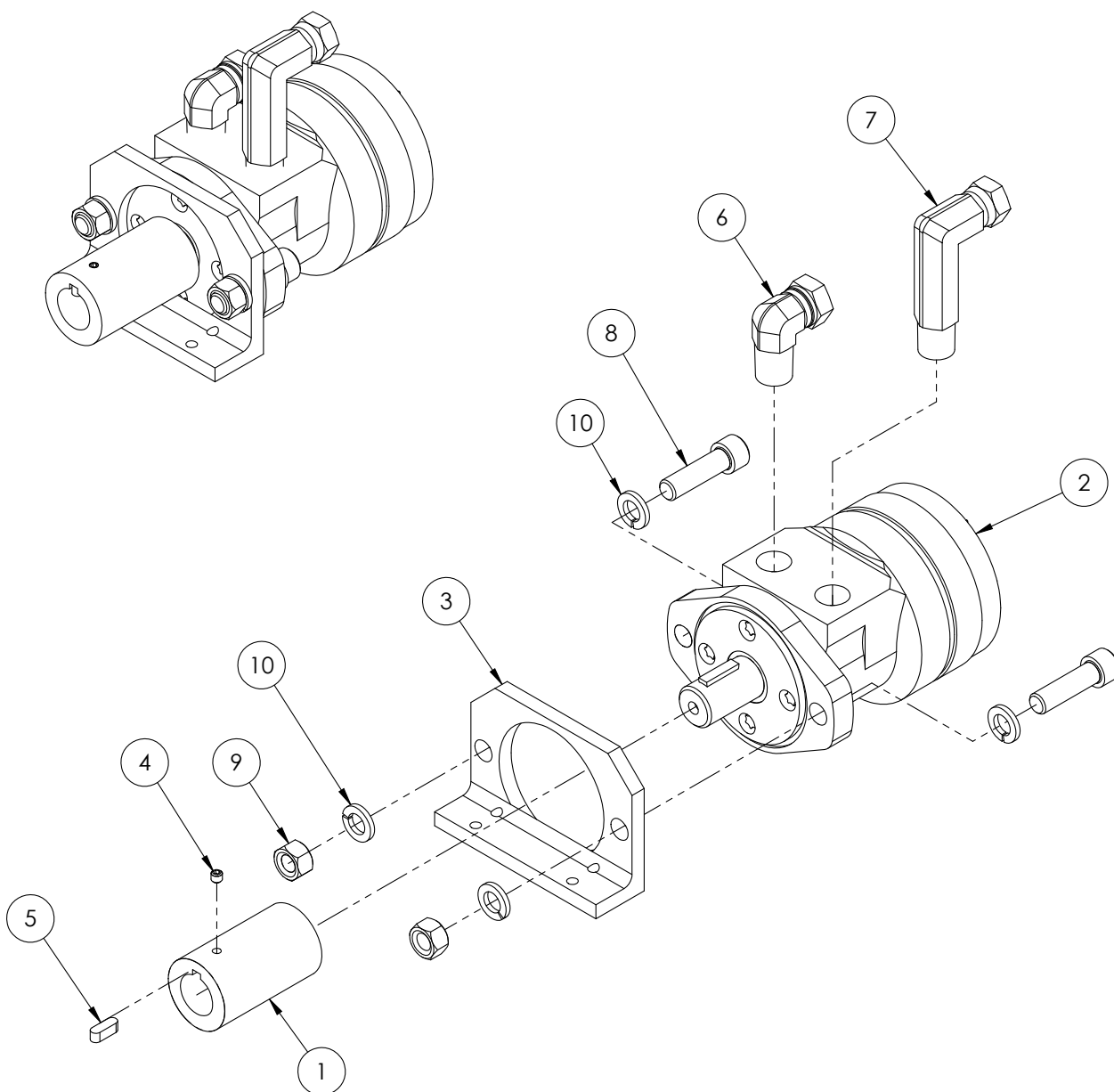
Super C Air Lubricator/Filter Assembly, 24-501-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-085-01	1	LUBRICATOR
2	04-090-01	1	FILTER
3	04-094-01	2	BRACKET, MOUNTING
4	25-096-00	2	PLATE, OILER MOUNTING
5	90-098-05	2	ELBOW, 1/2-90 STREET
6	90-098-86	1	NIPPLE, 1/2 X 7 SCH 80
7	90-142-02	8	BHCS, 10-24 X 1/4 SS18-8
8	90-153-03	4	FHCS, 1/4-20 X 3/8 SS18-8



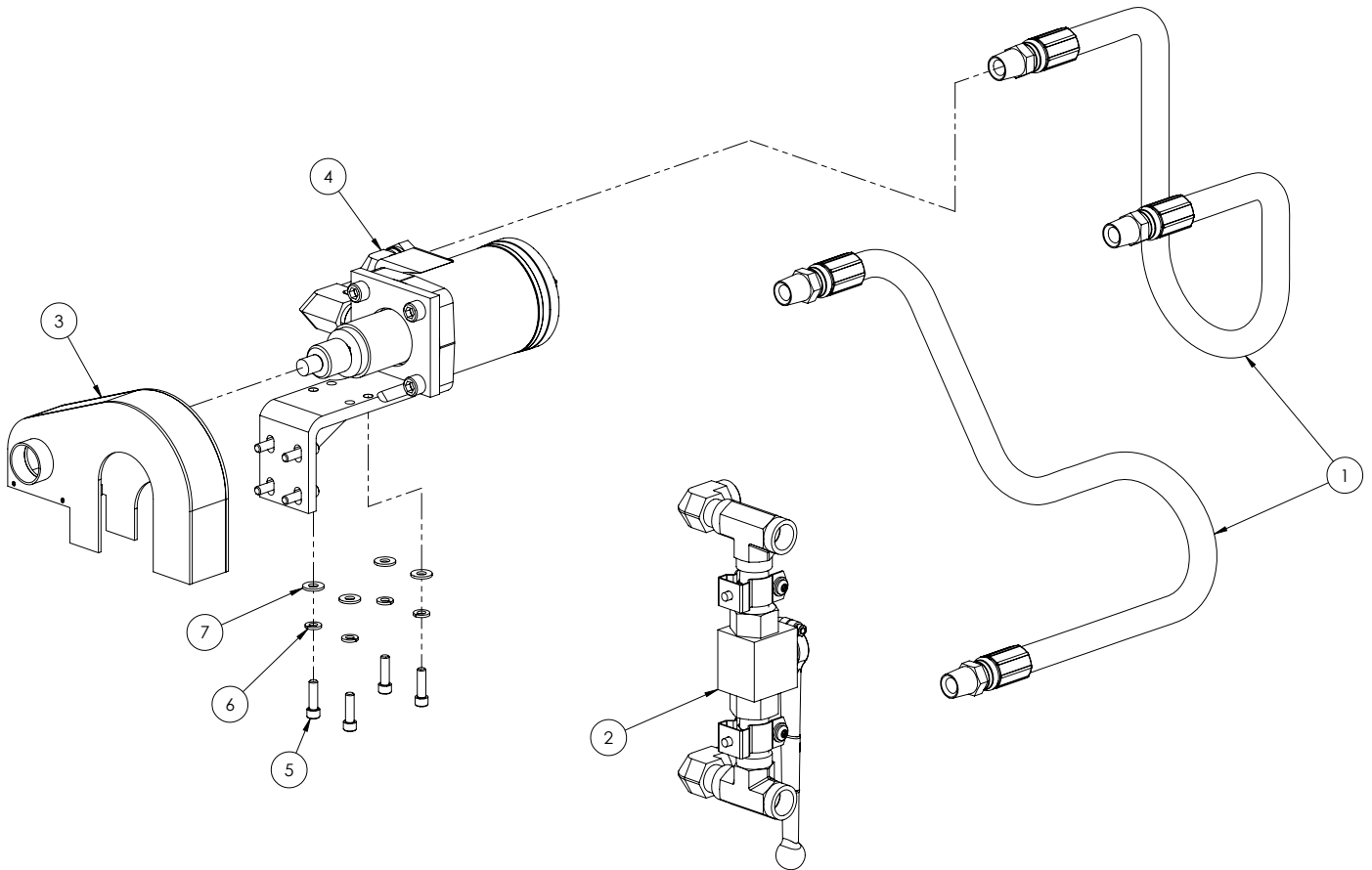
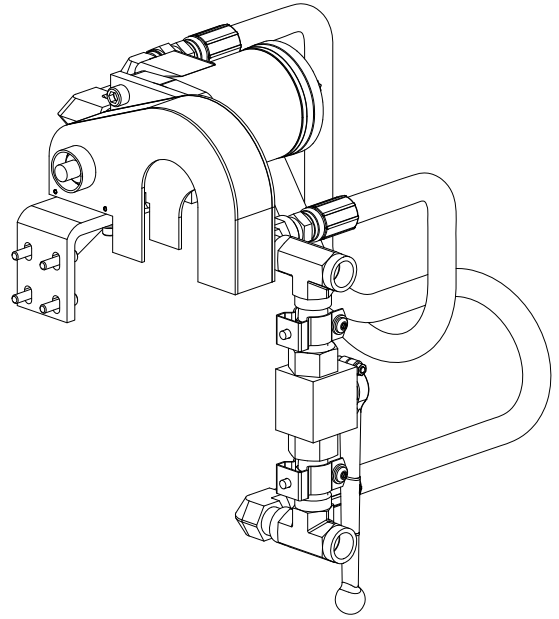
Super C Air Motor Assembly, 24-502-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	25-017-00	1	COUPLING, KEYED
2	25-115-00	1	HYDRAULIC MOTOR
3	25-125-01	1	MOUNTING BRACKET, HYDRAULIC MOTOR
4	90-054-02	1	SSS, 1/4-20 x 1/4
5	90-057-07	1	KEY, 1/4 SQ. X 3/4
6	90-098-55	1	ADAPTER, 1/2" NPT M X 1/2" NPT F SWIVEL-90
7	90-098-93	1	ADAPTER, 1/2" NPT M X 1/2" NPT F SWIVEL LONG-90
8	90-190-17	2	SHCS, 1/2-13 X 1-3/4 SS18-8
9	90-195-01	2	NUT, 1/2-13 HEX SS18-8
10	90-195-58	4	WASHER, 1/2 LOCK SS18-8



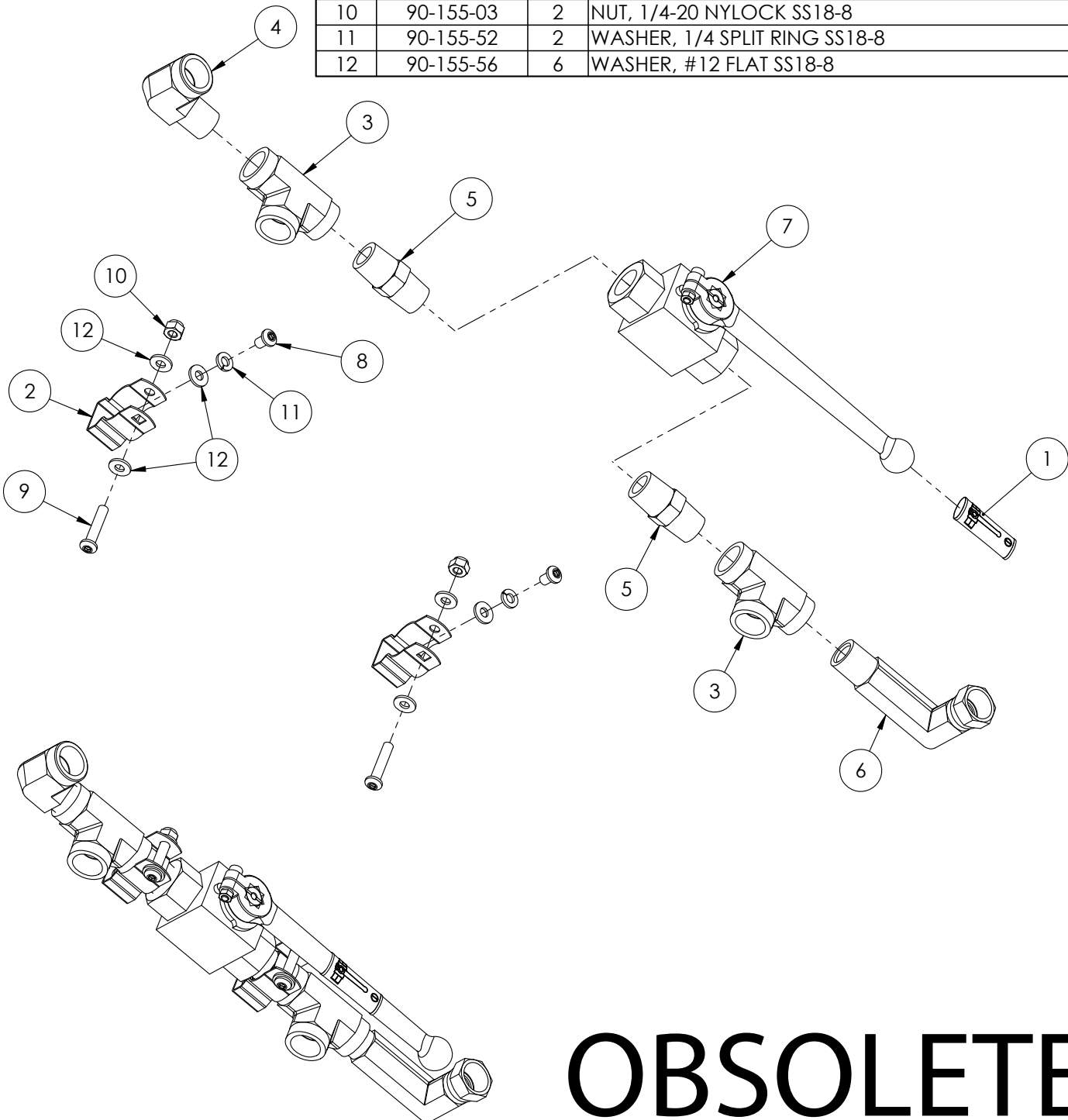
Super C Hydraulic Drive Assembly, 24-025-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-027-02	2	HOSE, 1/2" HP X 30" LONG
2	04-503-00	1	VALVE ASSEMBLY
3	24-081-00	1	GUARD, C-SERIES GUILLOTINES
4	24-504-00	1	HYDRAULIC MOTOR SUB-ASSEMBLY
5	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
6	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
7	90-155-53	4	WASHER, 1/4 FLAT SS18-8



Super C Hydraulic Valve Assembly, 24-503-00

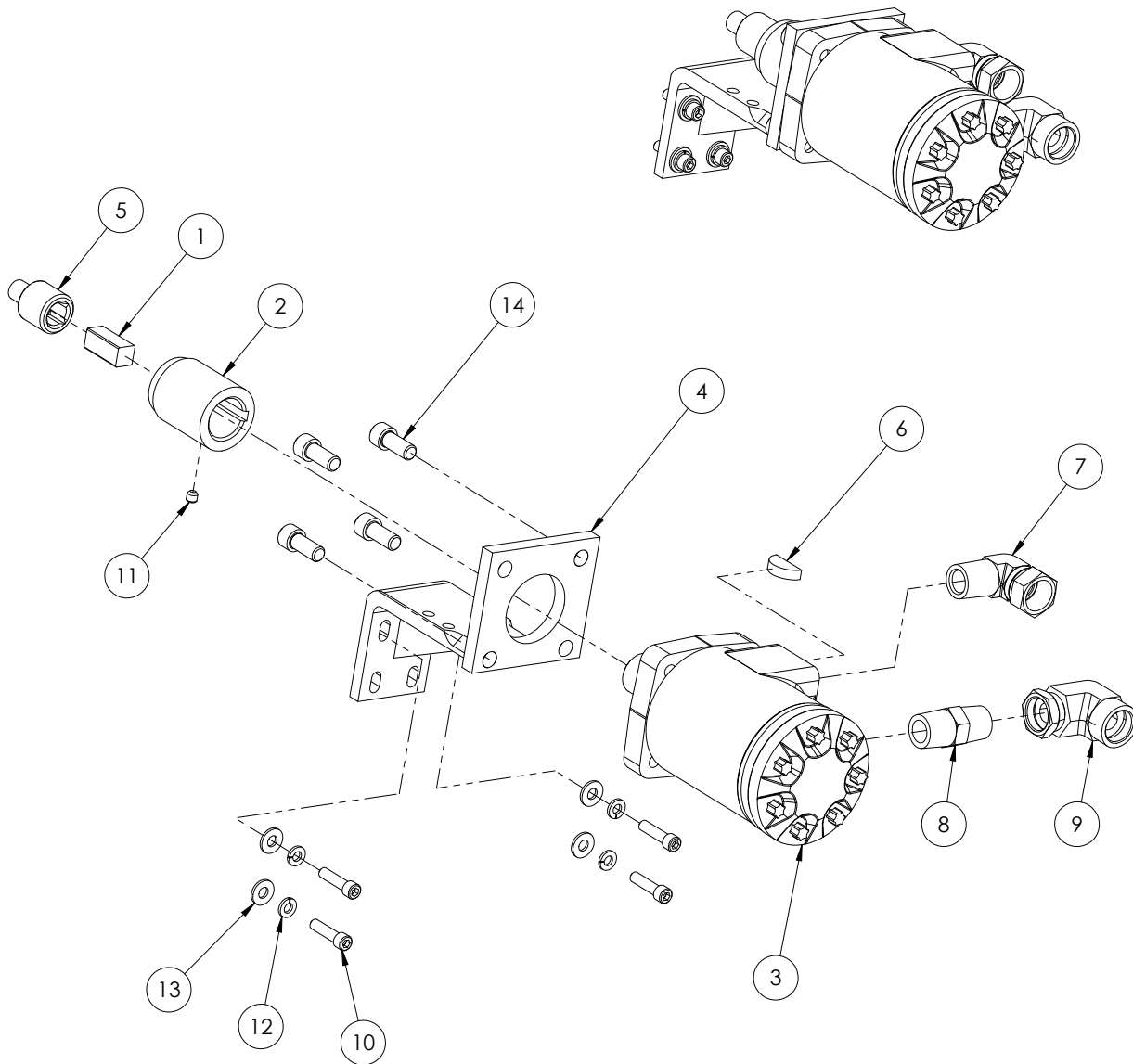
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-113-02	1	LABEL, SAW ON
2	03-154-00	2	HANGER, 1/2" CONDUIT
3	90-098-54	2	TEE, 1/2" NPT F - 1/2" NPT F X 1/2" NPT F HP
4	90-098-56	1	STREET ELBOW, 1/2 X 1/2
5	90-098-58	2	1/2 HEX HP NIPPLE
6	90-098-93_OBS	1	ADAPTER, 1/2" NPT M X 1/2" NPT F SWIVEL LONG-90
7	90-099-52	1	VALVE, 1/2" BALL HP
8	90-130-03	2	BHCS, 1/4-20 X 3/8 SS18-8
9	90-130-12	2	BHCS, 1/4-20 X 1-1/4 SS18-8
10	90-155-03	2	NUT, 1/4-20 NYLOCK SS18-8
11	90-155-52	2	WASHER, 1/4 SPLIT RING SS18-8
12	90-155-56	6	WASHER, #12 FLAT SS18-8



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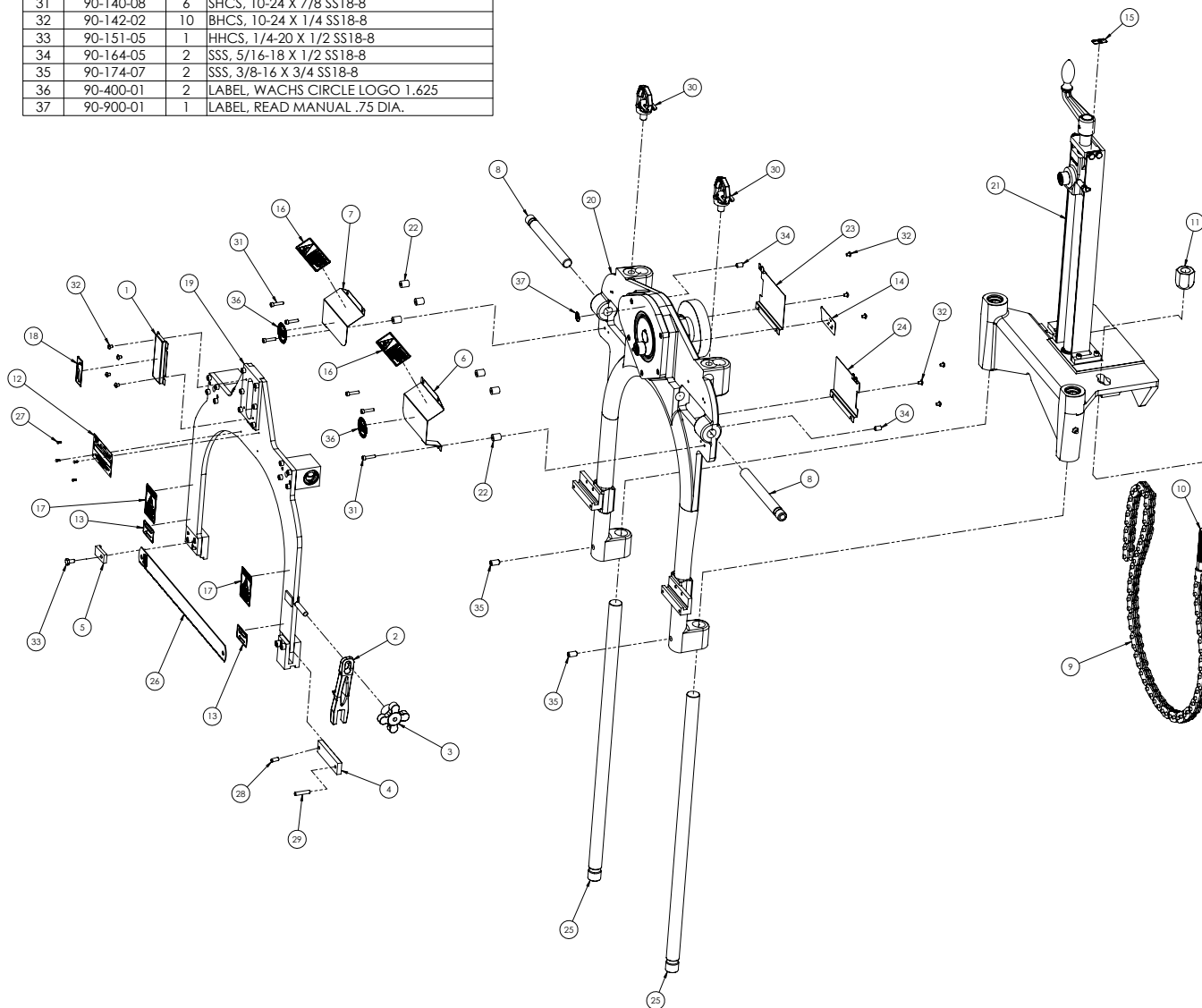
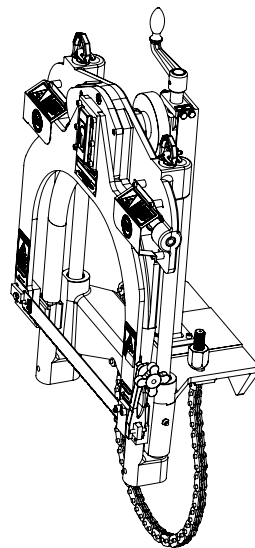
Super C Hydraulic Motor Assembly, 24-504-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-199-00	1	MOTOR COUPLING, DRIVE PIN
2	02-203-00	1	ADAPTOR, DRIVE MOTOR
3	03-115-00	1	HYDRAULIC MOTOR
4	03-125-00	1	BRACKET ASSEMBLY, HYDRAULIC MOTOR
5	04-101-00	1	COUPLING, FEMALE
6	90-059-48	1	1/4 x 1 (#808) WOODDRUFF KEY
7	90-098-55	1	ADAPTER, 1/2" NPT M X 1/2" NPT F SWIVEL-90
8	90-098-58	1	1/2 HEX HP NIPPLE
9	90-098-64	1	ADAPTER, 1/2" NPT F X 1/2" NPT F SWIVEL-90
10	90-150-10	4	SHCS, 1/4-20 X 1 SS18-8
11	90-154-02	1	SSS, 1/4-20 X 1/4 SS18-8
12	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
13	90-155-53	4	WASHER, 1/4 FLAT SS18-8
14	90-170-09	4	SHCS, 3/8-16 X 7/8 SS18-8



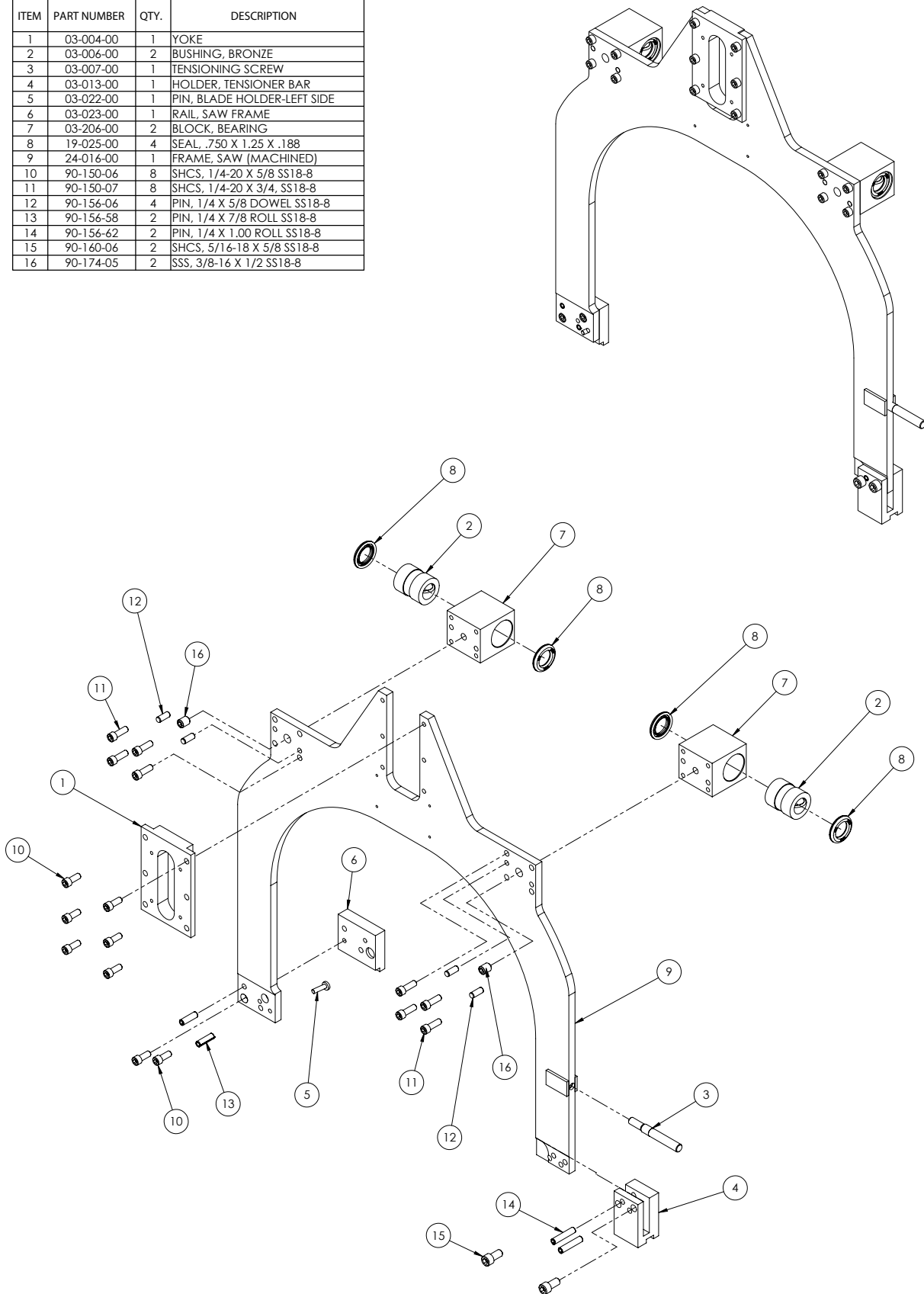
Super C Frame Assembly, 24-399-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-002-00	1	GREASE COVER, YOKE
2	03-008-02	1	BRACKET, TENSIONING
3	03-009-00	1	KNOB, BLADE TENSIONING
4	03-011-00	1	BAR, BLADE TENSIONER
5	03-020-00	1	BLADE HOLD-DOWN
6	03-029-00	1	GUARD, FRONT-RIGHT
7	03-039-00	1	GUARD, FRONT-LEFT
8	03-043-00	2	SHAFT, RECIPROCATING
9	03-057-03	1	CHAIN ASSEMBLY
10	03-058-00	1	SCREW, CHAIN TENSIONING
11	03-060-00	1	NUT, CHAIN TENSIONING
12	03-082-00	1	NAME PLATE
13	03-113-00	2	LABEL, BLADE DIRECTION
14	03-113-01	1	LABEL, CAM WHEEL
15	03-113-03	1	LABEL, FEED
16	03-113-04	2	LABEL, WARNING-MOVING PARTS
17	03-113-05	2	LABEL, WARNING-BLADE
18	03-113-06	1	LABEL, GREASE FITTING
19	24-017-00	1	SAW FRAME ASSEMBLY
20	24-018-00	1	MAIN FRAME ASSEMBLY
21	24-021-00	1	SADDLE ASSEMBLY
22	24-031-00	6	SPACER, GUARD
23	24-042-00	1	GUARD, REAR-RIGHT
24	24-068-00	1	GUARD, REAR-LEFT
25	24-074-00	2	SHAFT, VERTICAL GUIDE
26	24-405-00	1	BLADE-MODIFIED
27	90-048-01	4	SCREW, #4 X 1/4 ROUND U-DRIVE SS18-8
28	90-056-06	1	PIN, 1/4 X 5/8 DOWEL
29	90-056-12	1	PIN, 1/4 X 1-1/4 DOWEL
30	90-099-92	2	EYE BOLT
31	90-140-08	6	SHCS, 10-24 X 7/8 SS18-8
32	90-142-02	10	BHCS, 10-24 X 1/4 SS18-8
33	90-151-05	1	HHCS, 1/4-20 X 1/2 SS18-8
34	90-164-05	2	SSS, 5/16-18 X 1/2 SS18-8
35	90-174-07	2	SSS, 3/8-16 X 3/4 SS18-8
36	90-400-01	2	LABEL, WACHS CIRCLE LOGO 1.625
37	90-900-01	1	LABEL, READ MANUAL .75 DIA.



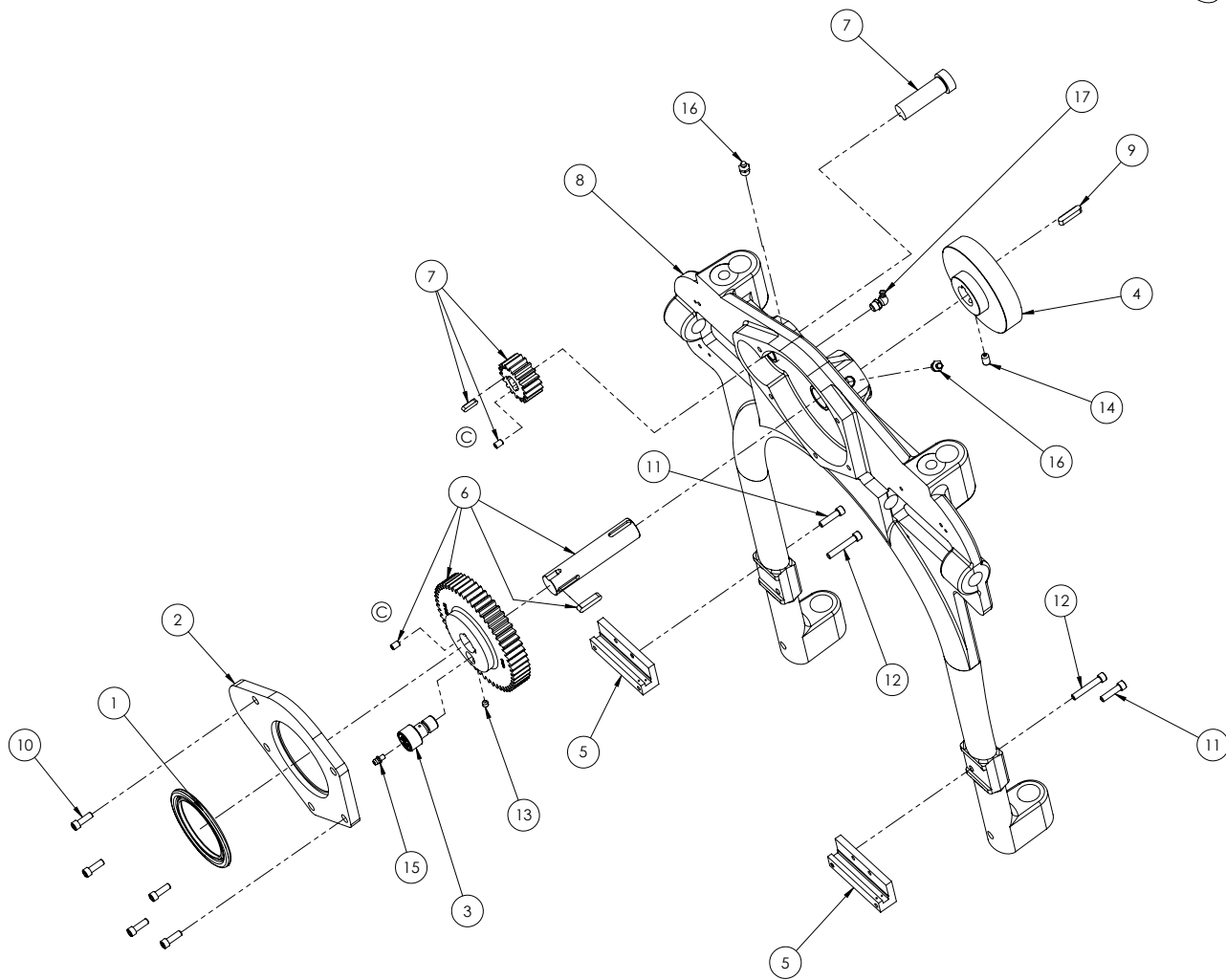
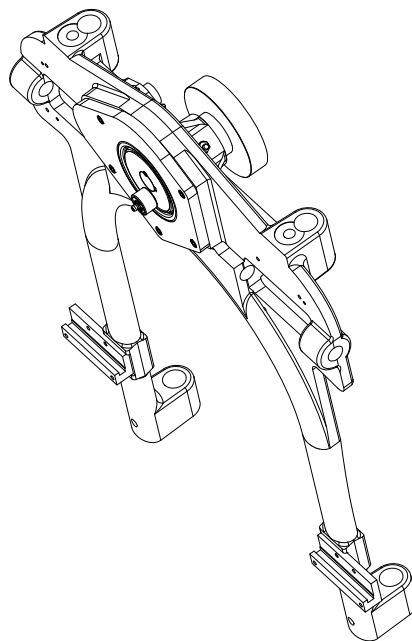
Super C Saw Frame Assembly, 24-017-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-004-00	1	YOKE
2	03-006-00	2	BUSHING, BRONZE
3	03-007-00	1	TENSIONING SCREW
4	03-013-00	1	HOLDER, TENSIONER BAR
5	03-022-00	1	PIN, BLADE HOLDER-LEFT SIDE
6	03-023-00	1	RAIL, SAW FRAME
7	03-206-00	2	BLOCK, BEARING
8	19-025-00	4	SEAL, .750 X 1.25 X .188
9	24-016-00	1	FRAME, SAW (MACHINED)
10	90-150-06	8	SHCS, 1/4-20 X 5/8 SS18-8
11	90-150-07	8	SHCS, 1/4-20 X 3/4, SS18-8
12	90-156-06	4	PIN, 1/4 X 5/8 DOWEL SS18-8
13	90-156-58	2	PIN, 1/4 X 7/8 ROLL SS18-8
14	90-156-62	2	PIN, 1/4 X 1.00 ROLL SS18-8
15	90-160-06	2	SHCS, 5/16-18 X 5/8 SS18-8
16	90-174-05	2	SSS, 3/8-16 X 1/2 SS18-8



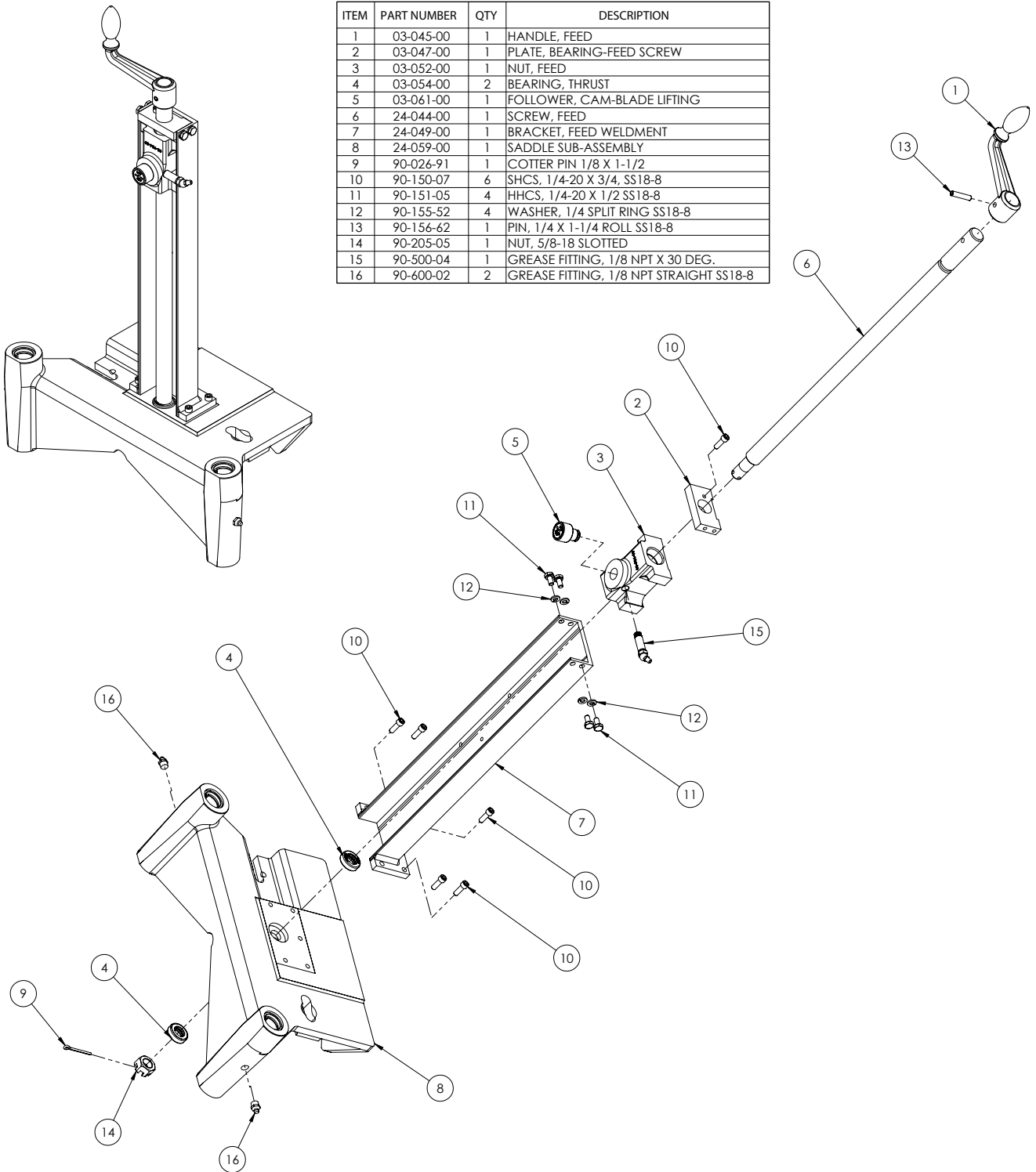
Super C Main Frame Assembly, 24-018-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-024-00	1	GREASE SEAL
2	03-026-00	1	COVER-GEARBOX
3	03-028-00	1	CAM FOLLOWER ROLLER
4	03-051-00	1	WHEEL, CAM
5	03-070-00	2	GUIDE, SAW FRAME
6	24-019-00	1	MAIN GEAR ASSEMBLY-MACHINED
7	24-020-00	1	PINION GEAR ASSEMBLY-MACHINED
8	24-069-00	1	FRAME SUB-ASSEMBLY
9	90-057-11	1	KEY, 1/4 SQ. X 1-3/16
10	90-150-07	5	SHCS, 1/4-20 X 3/4, SS18-8
11	90-150-10	2	SHCS, 1/4-20 X 1 SS18-8
12	90-150-15	2	SHCS, 1/4-20 X 1-1/2 SS18-8
13	90-154-02	1	SSS, 1/4-20 X 1/4 SS18-8
14	90-164-05	1	SSS, 5/16-18 X 1/2 SS18-8
15	90-600-01	1	GREASE FITTING, 3/16 STRAIGHT DRIVE SS18-8
16	90-600-02	2	GREASE FITTING, 1/8 NPT STRAIGHT SS18-8
17	90-600-03	1	GREASE FITTING, 1/8 NPT X 65 DEG. SS18-8



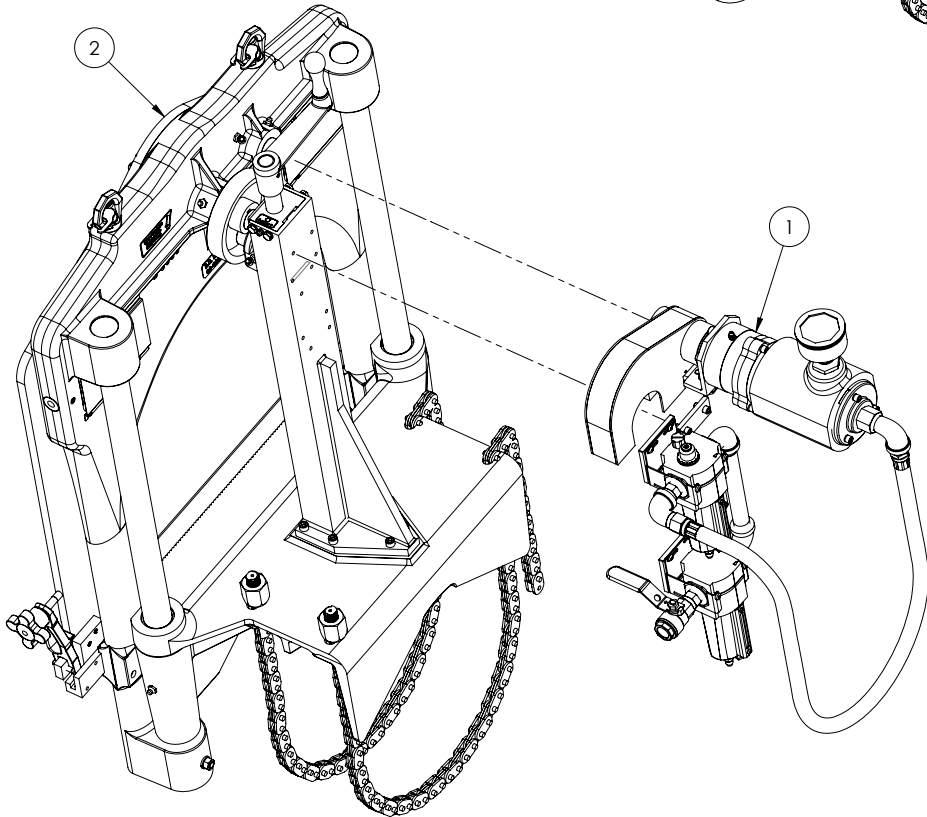
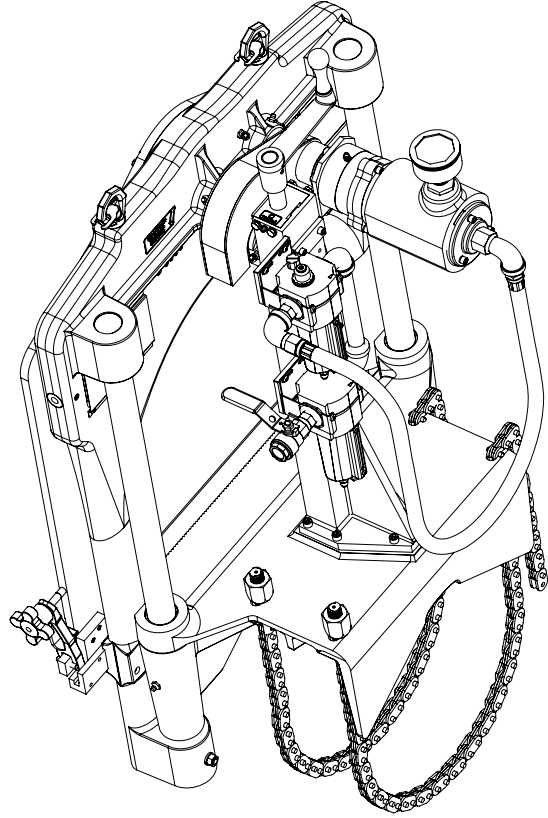
Super C Saddle Assembly, 24-021-00

ITEM	PART NUMBER	QTY	DESCRIPTION
1	03-045-00	1	HANDLE, FEED
2	03-047-00	1	PLATE, BEARING-FEED SCREW
3	03-052-00	1	NUT, FEED
4	03-054-00	2	BEARING, THRUST
5	03-061-00	1	FOLLOWER, CAM-BLADE LIFTING
6	24-044-00	1	SCREW, FEED
7	24-049-00	1	BRACKET, FEED WELDMENT
8	24-059-00	1	SADDLE SUB-ASSEMBLY
9	90-026-91	1	COTTER PIN 1/8 X 1-1/2
10	90-150-07	6	SHCS, 1/4-20 X 3/4, SS18-8
11	90-151-05	4	HHCS, 1/4-20 X 1/2 SS18-8
12	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
13	90-156-62	1	PIN, 1/4 X 1-1/4 ROLL SS18-8
14	90-205-05	1	NUT, 5/8-18 SLOTTED
15	90-500-04	1	GREASE FITTING, 1/8 NPT X 30 DEG.
16	90-600-02	2	GREASE FITTING, 1/8 NPT STRAIGHT SS18-8



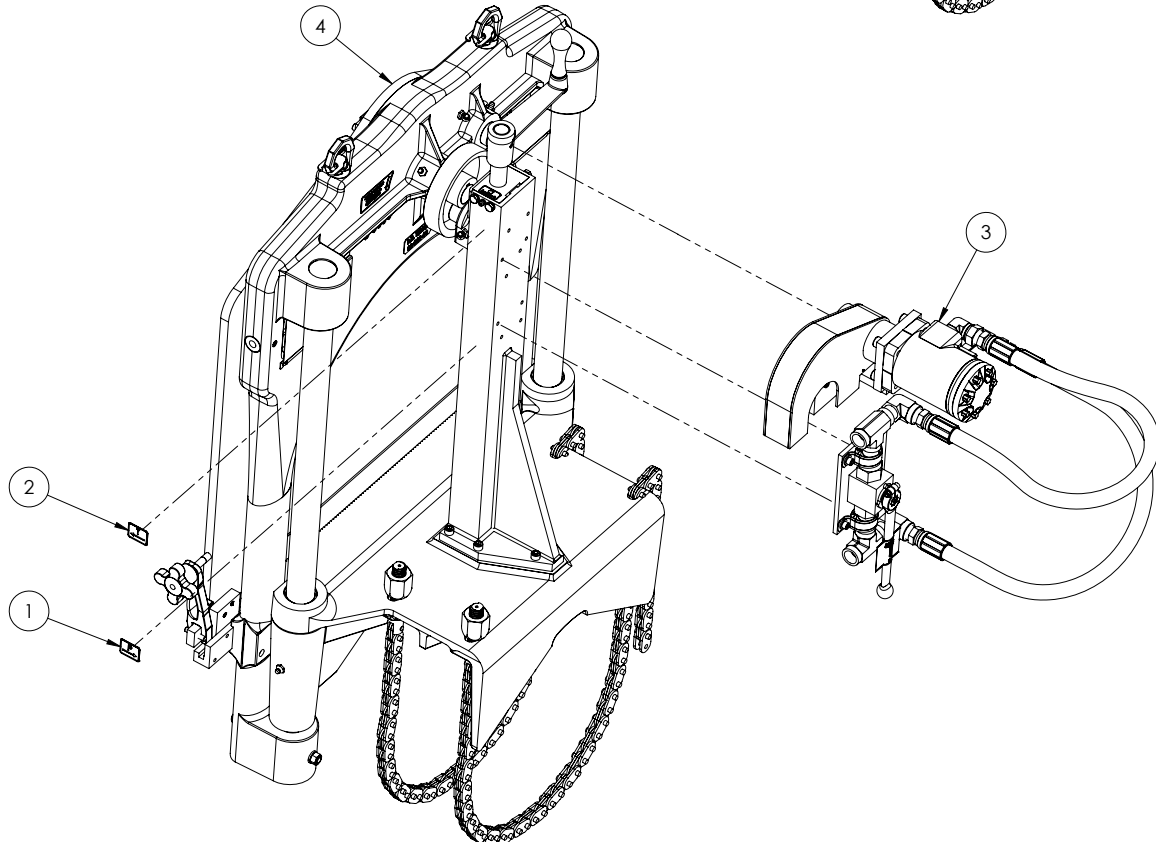
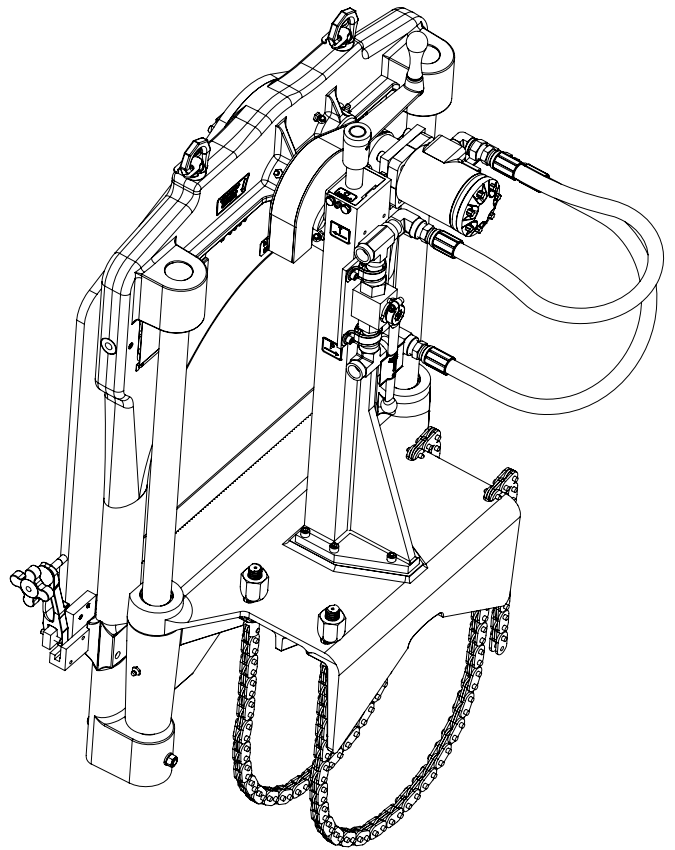
Model D Guillotine, Pneumatic, 04-000-02

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-137-00	1	AIR DRIVE ASSEMBLY
2	04-399-00	1	MODEL "D" FRAME ASSEMBLY
3	02-155-00	1	STEEL CABLE (NOT SHOWN)
4	03-MAN-01	1	MANUAL (NOT SHOWN)
5	25-130-00	1	SKID, SHIPPING (NOT SHOWN)
6	90-800-01	1	WRENCH, 1-1/4 OPEN END (NOT SHOWN)
7	90-800-38	1	WRENCH, 7/16 COMBINATION (NOT SHOWN)



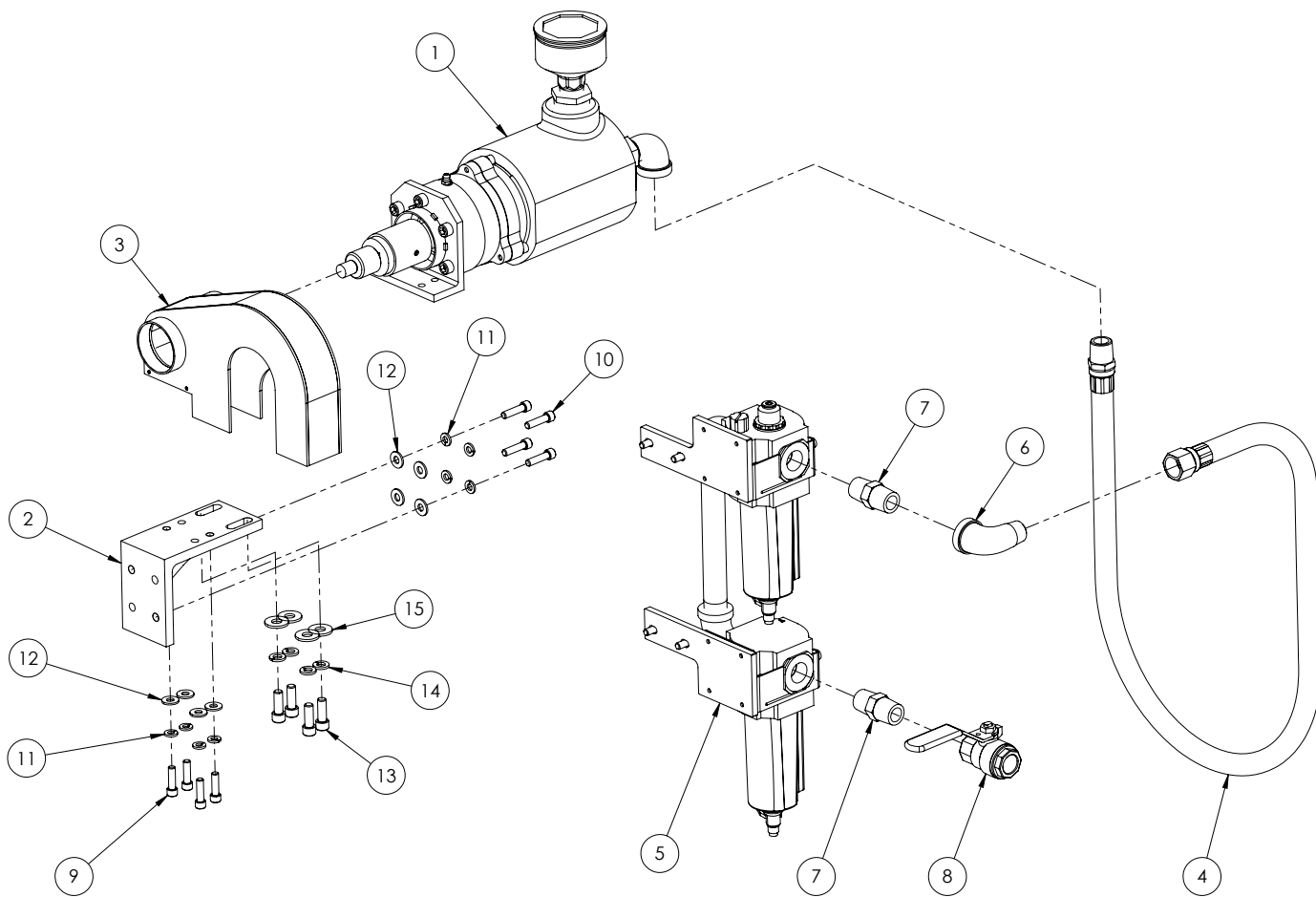
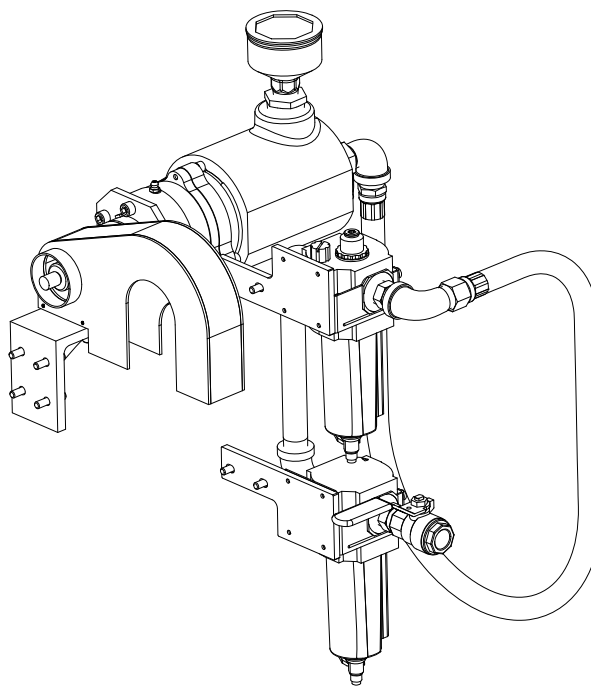
Model D Guillotine, Hydraulic, 04-000-03

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-113-07	1	LABEL, PRESSURE
2	03-113-08	1	LABEL, TANK
3	04-305-00	1	HYDRAULIC MOTOR ASSEMBLY
4	04-399-00	1	MODEL "D" FRAME ASSEMBLY
5	02-155-00	1	STEEL CABLE (NOT SHOWN)
6	03-MAN-01	1	MANUAL (NOT SHOWN)
7	25-130-00	1	SKID, SHIPPING (NOT SHOWN)
8	90-800-01	1	WRENCH, 1-1/4 OPEN END (NOT SHOWN)
9	90-800-38	1	WRENCH, 7/16 COMBINATION (NOT SHOWN)



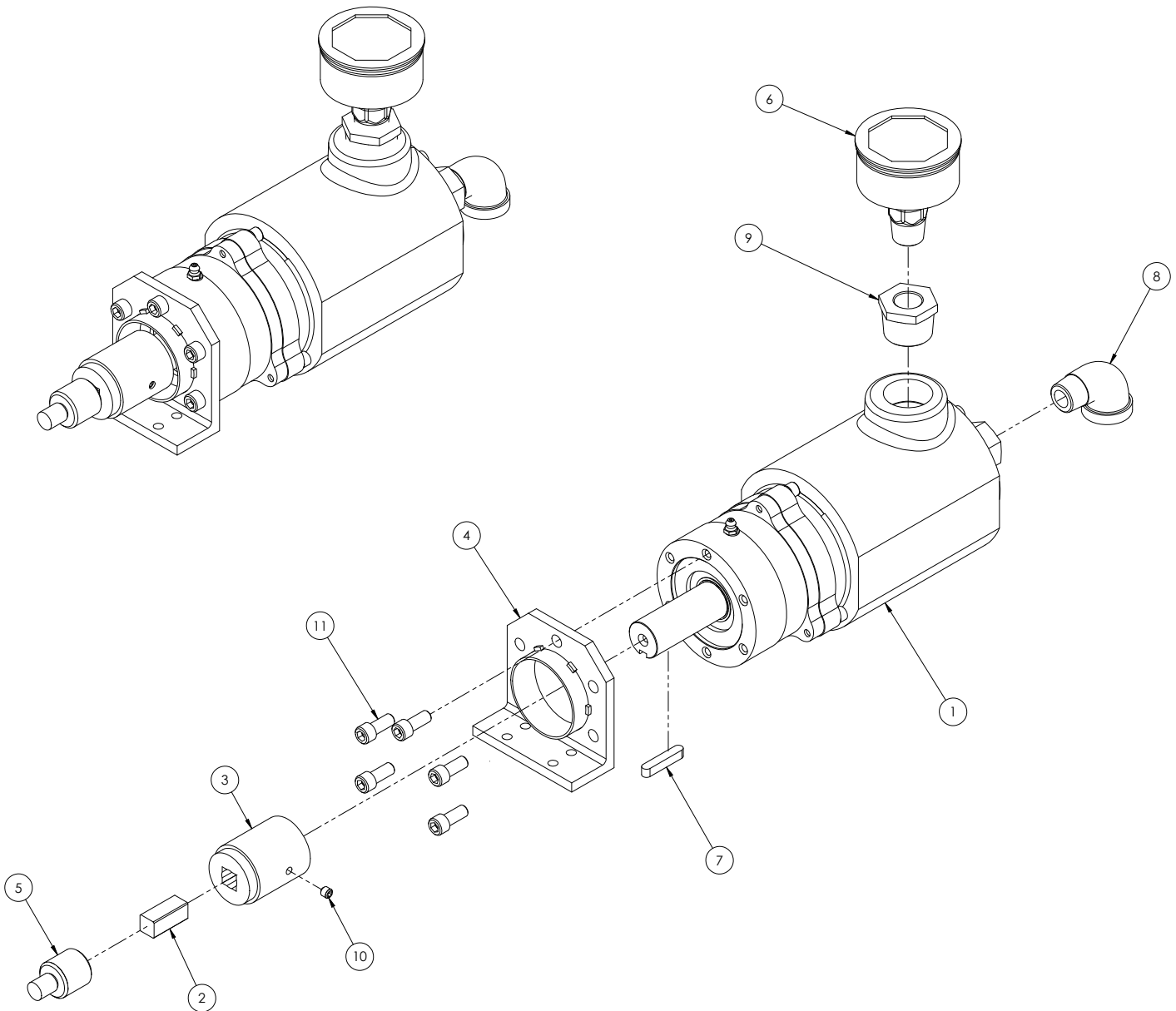
Model D Air Drive Assembly, 04-137-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-029-00	1	AIR MOTOR SUB-ASSEMBLY
2	04-081-01	1	BRACKET, AIR MOTOR-WELDMENT
3	04-086-00	1	GUARD, MODEL-D SERIES GUILLOTINES
4	04-091-00	1	AIR HOSE, 1/2 DIA. X 42" LONG
5	04-501-00	1	LUBRICATOR AND FILTER ASSEMBLY
6	90-098-05	1	ELBOW, 1/2-90 STREET
7	90-098-58	2	1/2 HEX HP NIPPLE
8	90-099-51	1	VALVE, 1/2" BALL LP
9	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
10	90-150-10	4	SHCS, 1/4-20 X 1 SS18-8
11	90-155-52	8	WASHER, 1/4 SPLIT RING SS18-8
12	90-155-53	8	WASHER, 1/4 FLAT SS18-8
13	90-160-08	4	SHCS, 5/16-18 X 7/8 SS18-8
14	90-165-51	4	WASHER, 5/16 SPLIT RING SS18-8
15	90-165-52	4	WASHER, 5/16 FLAT SS18-8



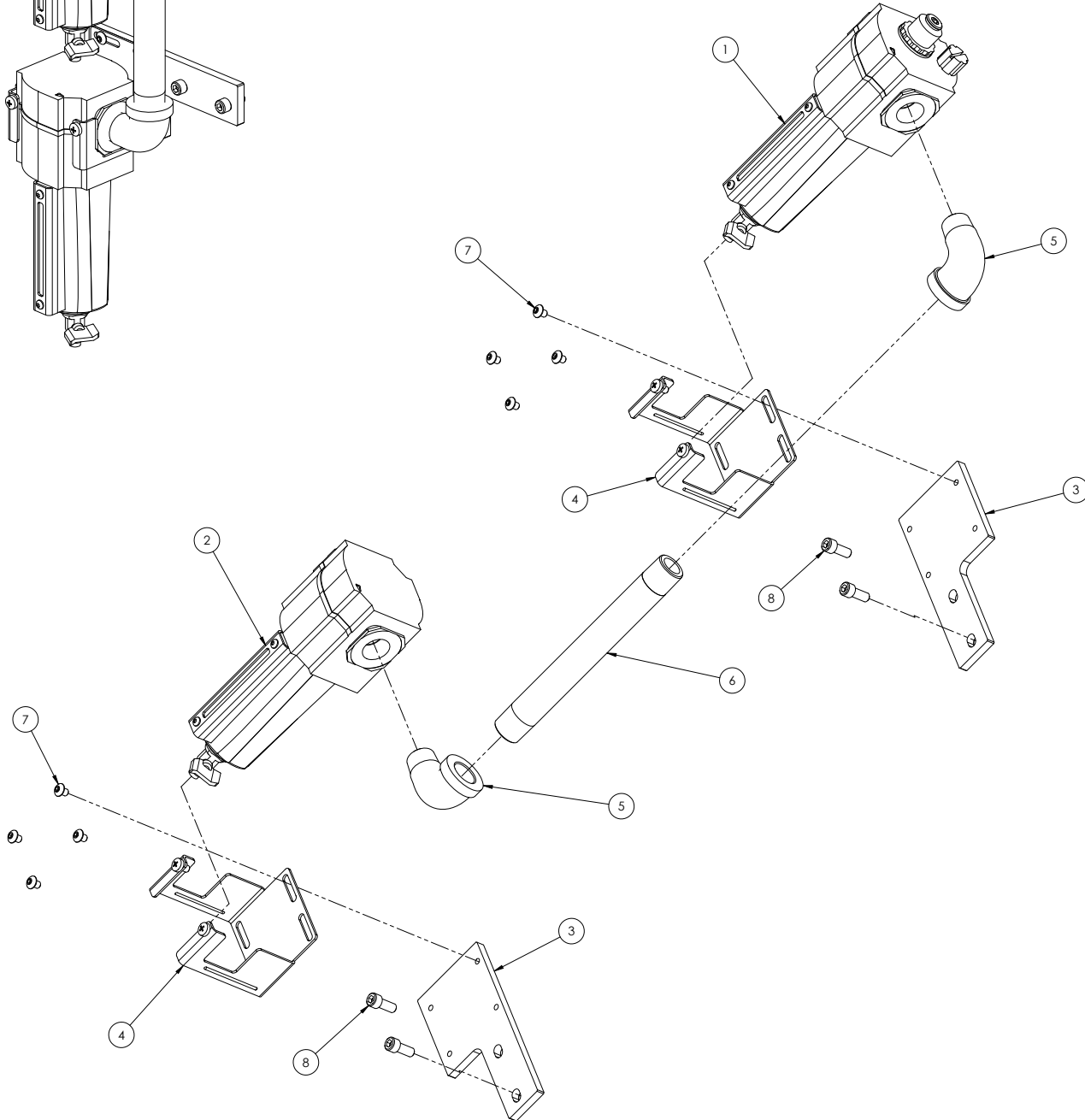
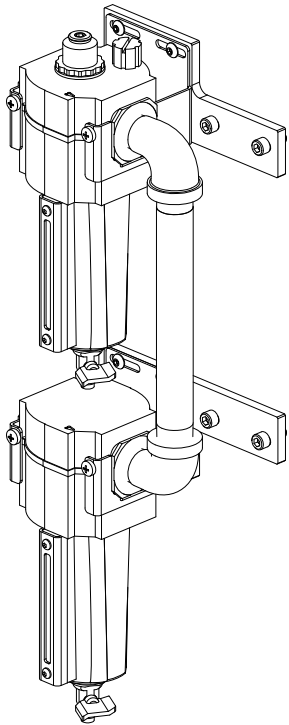
Model D Air Motor Assembly, 04-029-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-030-00	1	AIR MOTOR
2	02-199-00	1	MOTOR COUPLING, DRIVE PIN
3	02-203-00	1	ADAPTOR, DRIVE MOTOR
4	04-080-01	1	MOTOR MOUNTING BRACKET-WELDMENT
5	04-101-00	1	COUPLING, FEMALE
6	23-181-00	1	MUFFLER
7	90-057-13	1	KEY, 1/4 SQ. X 1-3/8
8	90-098-05	1	ELBOW, 1/2-90 STREET
9	90-098-75	1	BUSHING, 1/2 X 1 REDUCING
10	90-154-02	1	SSS, 1/4-20 X 1/4 SS18-8
11	90-160-07	5	SHCS, 5/16-18 X 3/4 SS18-8



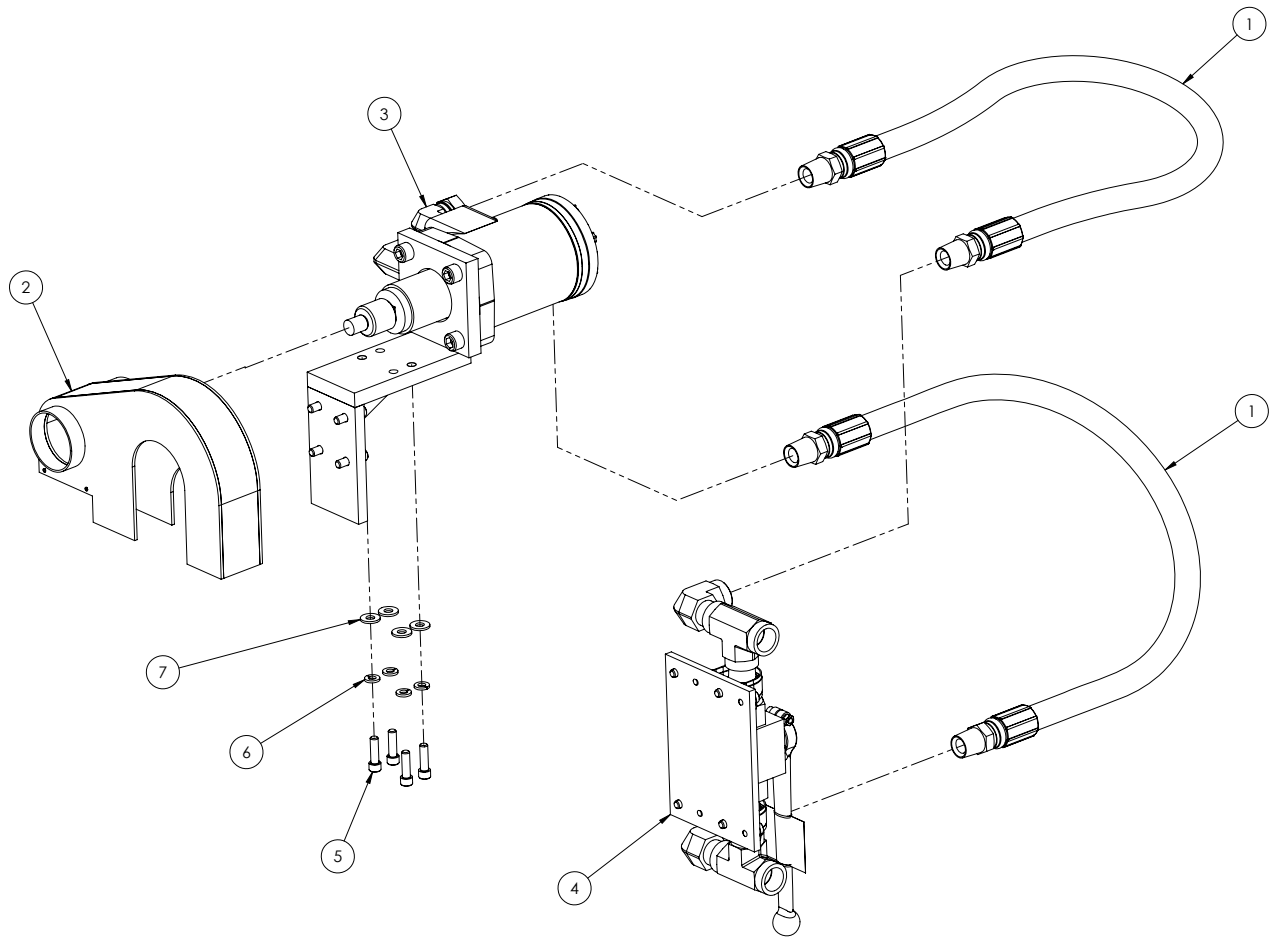
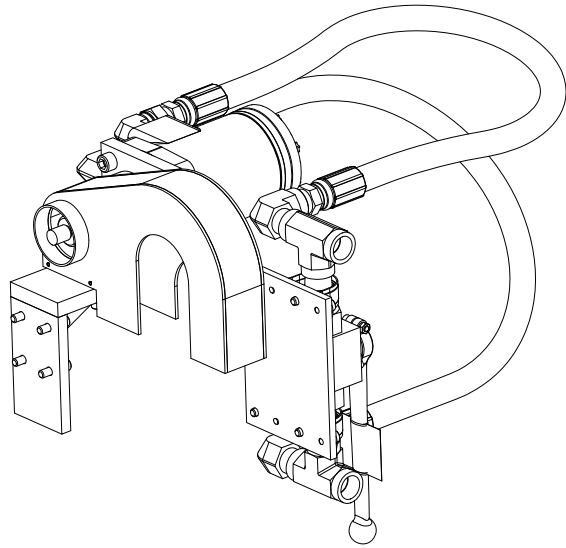
Model D Air Lubricator/Filter Assembly, 04-501-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-085-01	1	LUBRICATOR
2	04-090-01	1	FILTER
3	04-093-01	2	PLATE, OILER MOUNTING
4	04-094-01	2	BRACKET, MOUNTING
5	90-098-05	2	ELBOW, 1/2-90 STREET
6	90-098-86	1	NIPPLE, 1/2 X 7 SCH 80
7	90-143-02	8	BHCS, 10-32 X 1/4 SS18-8
8	90-150-06	4	SHCS, 1/4-20 X 5/8 SS18-8



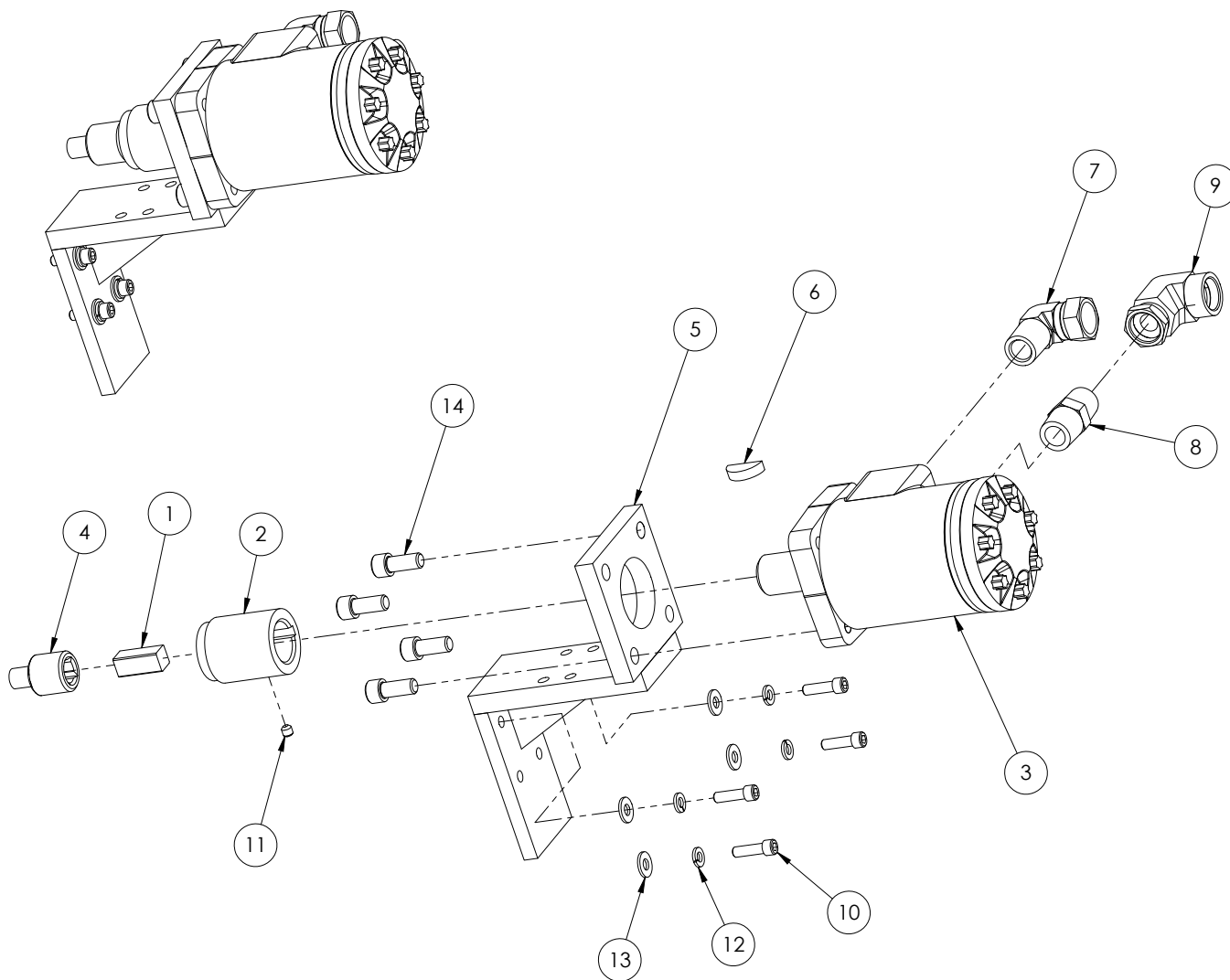
Model D Hydraulic Drive Assembly, 04-305-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-027-02	2	HOSE, 1/2" HP X 30" LONG
2	04-086-00	1	GUARD, MODEL-D SERIES GUILLOTINES
3	04-502-00	1	HYDRAULIC MOTOR SUB-ASSEMBLY
4	04-503-00	1	VALVE ASSEMBLY
5	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
6	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
7	90-155-53	4	WASHER, 1/4 FLAT SS18-8



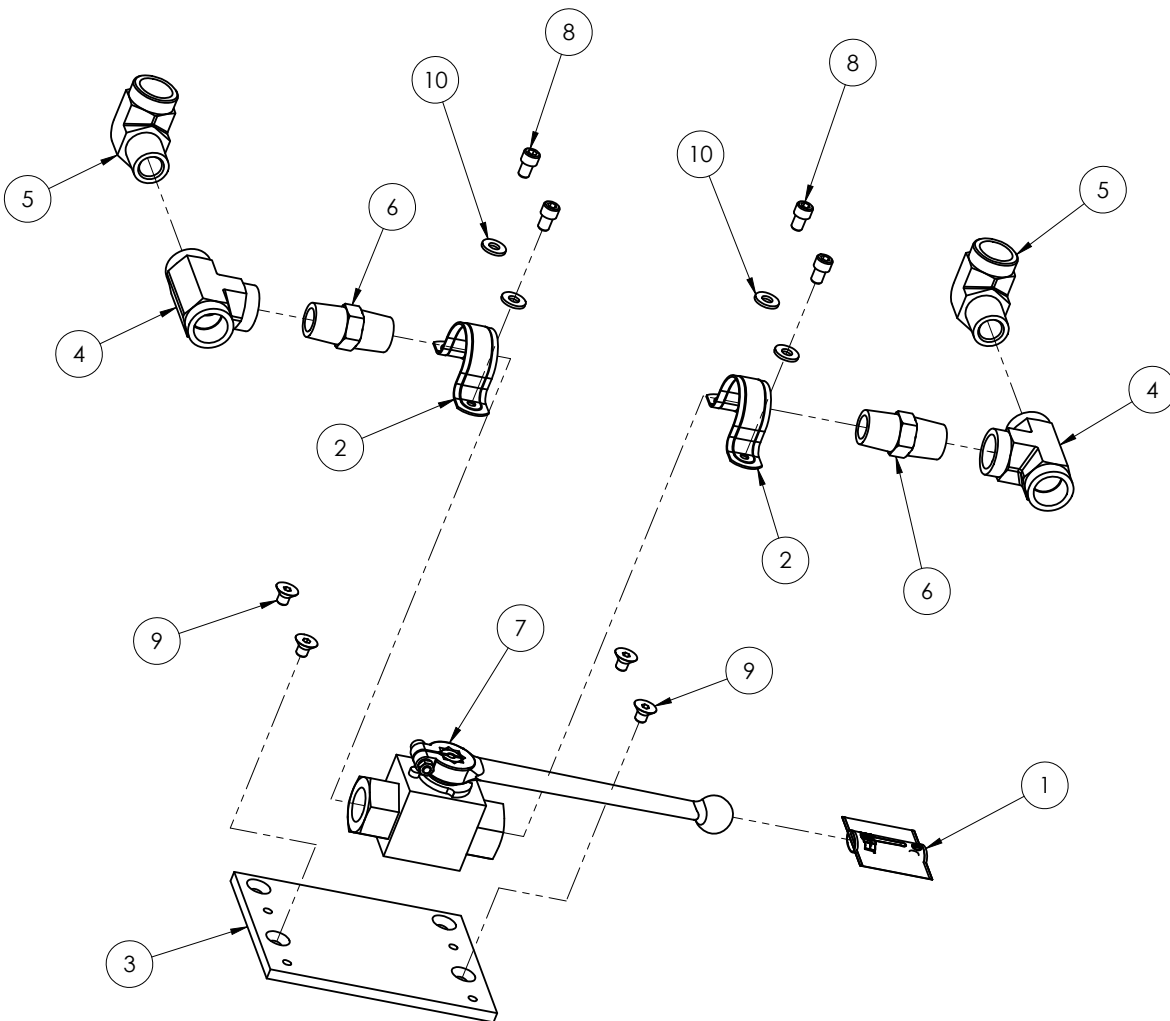
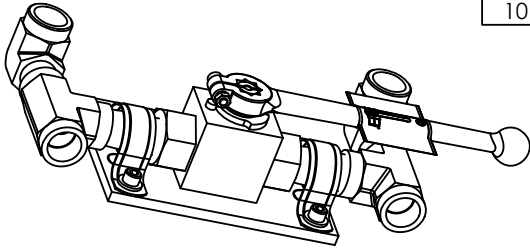
Model D Hydraulic Motor Assembly, 04-502-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-199-00	1	MOTOR COUPLING, DRIVE PIN
2	02-203-00	1	ADAPTOR, DRIVE MOTOR
3	03-115-00	1	HYDRAULIC MOTOR
4	04-101-00	1	COUPLING, FEMALE
5	04-125-00	1	MOUNTING BRACKET ASSEMBLY
6	90-059-48	1	1/4 x 1 (#808) WOODDRUFF KEY
7	90-098-55	1	ADAPTER, 1/2" NPT M X 1/2" NPT F SWIVEL-90
8	90-098-58	1	1/2 HEX HP NIPPLE
9	90-098-64	1	ADAPTER, 1/2" NPT F X 1/2" NPT F SWIVEL-90
10	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
11	90-154-02	1	SSS, 1/4-20 X 1/4 SS18-8
12	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
13	90-155-53	4	WASHER, 1/4 FLAT SS18-8
14	90-170-09	4	SHCS, 3/8-16 X 7/8 SS18-8



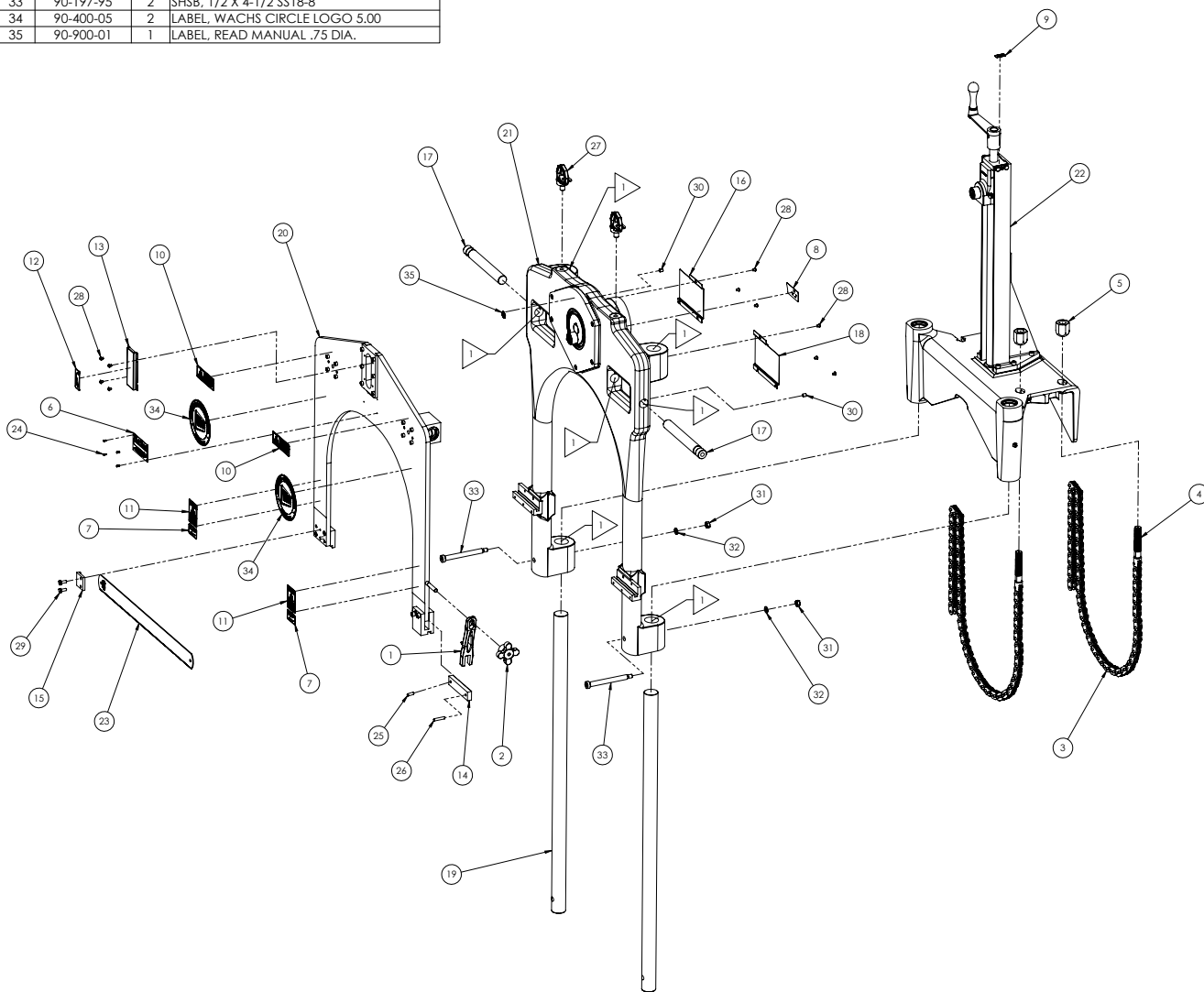
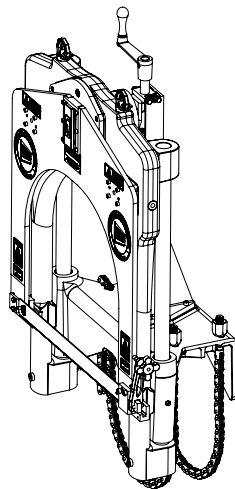
Model D Hydraulic Valve Assembly, 04-503-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-113-02	1	LABEL, SAW ON
2	03-122-00	2	MOUNTING CLAMP
3	04-145-00	1	PLATE, MOUNTING
4	90-098-54	2	TEE, 1/2" NPT F - 1/2" NPT F X 1/2" NPT F HP
5	90-098-56	2	ADAPTER, 1/2" NPT F X 1/2" NPT M HP-90
6	90-098-58	2	1/2 HEX HP NIPPLE
7	90-099-52	1	VALVE, 1/2" BALL HP
8	90-150-03	4	SHCS, 1/4-20 X 3/8 SS18-8
9	90-153-03	4	FHCS, 1/4-20 X 3/8 SS18-8
10	90-155-56	4	WASHER, #12 FLAT SS18-8



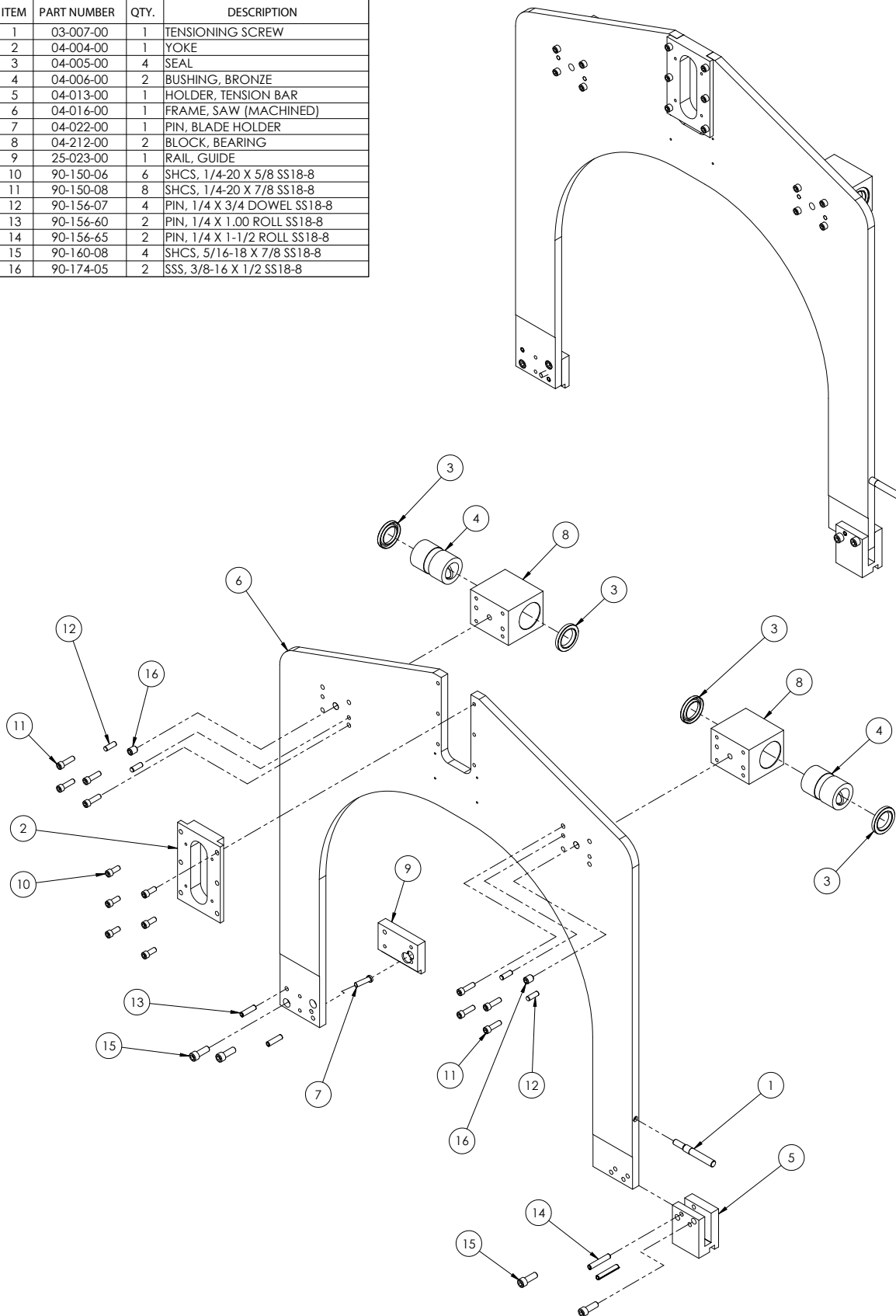
Model D Frame Assembly, 04-399-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-008-02	1	BRACKET, TENSIONING
2	03-009-00	1	KNOB, BLADE TENSIONING
3	03-057-02	2	CHAIN ASSEMBLY
4	03-058-00	2	SCREW, CHAIN TENSIONING
5	03-060-00	2	NUT, CHAIN TENSIONING
6	03-082-00	1	NAME PLATE
7	03-113-00	2	LABEL, BLADE DIRECTION
8	03-113-01	1	LABEL, CAM WHEEL
9	03-113-03	1	LABEL, FEED
10	03-113-04	2	LABEL, WARNING-MOVING PARTS
11	03-113-05	2	LABEL, WARNING-BLADE
12	03-113-06	1	LABEL, GREASE FITTING
13	04-002-00	1	GREASE COVER, YOKE
14	04-011-00	1	BAR, BLADE TENSIONER
15	04-020-00	1	BLADE CLAMP
16	04-042-00	1	GUARD, REAR-RIGHT
17	04-043-01	2	SHAFT, RECIPROCATING
18	04-068-00	1	GUARD, REAR-LEFT
19	04-074-01	2	SHAFT, GUIDE-VERTICAL
20	04-301-00	1	SAW FRAME ASSEMBLY
21	04-302-00	1	MAIN FRAME ASSEMBLY
22	04-303-00	1	SADDLE ASSEMBLY
23	04-402-00	1	STANDARD BLADE
24	90-048-01	4	SCREW, #4 X 1/4 ROUND U-DRIVE SS18-8
25	90-056-07	1	PIN, 1/4 X 3/4 DOWEL
26	90-056-12	1	PIN, 1/4 X 1-1/4 DOWEL
27	90-099-92	2	EYE BOLT
28	90-142-02	10	BHCS, 10-24 X 1/4 SS18-8
29	90-151-06	2	HHCS, 1/4-20 X 5/8 SS18-8
30	90-164-03	2	SSS, 5/16-18 X 3/8 SS18-8
31	90-175-01	2	NUT, 3/8-16 HEX SS18-8
32	90-175-52	2	WASHER, 3/8 SPLIT RING SS18-8
33	90-197-95	2	SHSB, 1/2 X 4-1/2 SS18-8
34	90-400-05	2	LABEL, WACHS CIRCLE LOGO 5.00
35	90-900-01	1	LABEL, READ MANUAL .75 DIA.



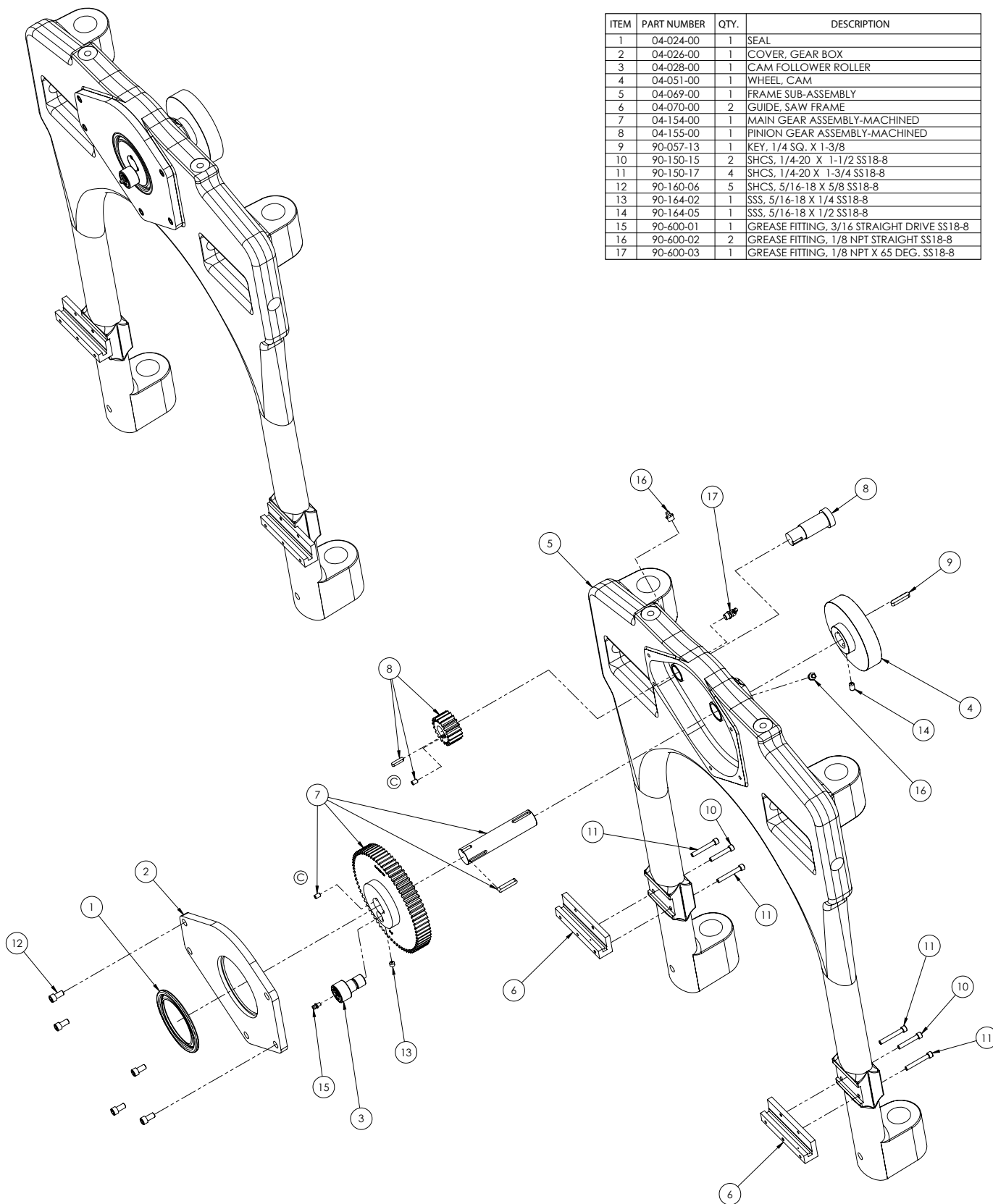
Model D Saw Frame Assembly, 04-301-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-007-00	1	TENSIONING SCREW
2	04-004-00	1	YOKE
3	04-005-00	4	SEAL
4	04-006-00	2	BUSHING, BRONZE
5	04-013-00	1	HOLDER, TENSION BAR
6	04-016-00	1	FRAME, SAW (MACHINED)
7	04-022-00	1	PIN, BLADE HOLDER
8	04-212-00	2	BLOCK, BEARING
9	25-023-00	1	RAIL, GUIDE
10	90-150-06	6	SHCS, 1/4-20 X 5/8 SS18-8
11	90-150-08	8	SHCS, 1/4-20 X 7/8 SS18-8
12	90-156-07	4	PIN, 1/4 X 3/4 DOWEL SS18-8
13	90-156-60	2	PIN, 1/4 X 1.00 ROLL SS18-8
14	90-156-65	2	PIN, 1/4 X 1-1/2 ROLL SS18-8
15	90-160-08	4	SHCS, 5/16-18 X 7/8 SS18-8
16	90-174-05	2	SSS, 3/8-16 X 1/2 SS18-8



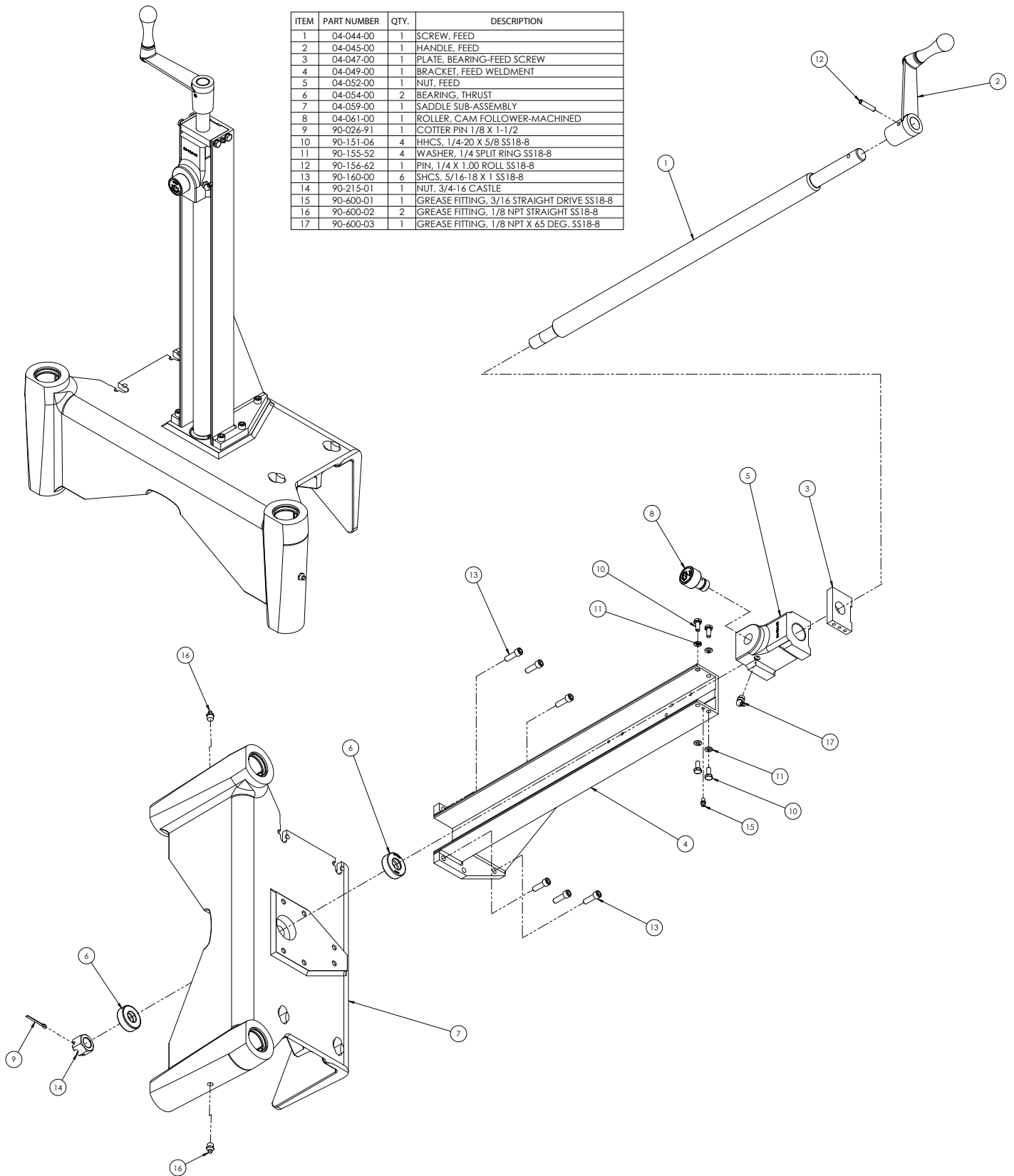
Model D Main Frame Assembly, 04-302-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-024-00	1	SEAL
2	04-026-00	1	COVER, GEAR BOX
3	04-028-00	1	CAM FOLLOWER ROLLER
4	04-051-00	1	WHEEL, CAM
5	04-069-00	1	FRAME SUB-ASSEMBLY
6	04-070-00	2	GUIDE, SAW FRAME
7	04-154-00	1	MAIN GEAR ASSEMBLY-MACHINED
8	04-155-00	1	PINION GEAR ASSEMBLY-MACHINED
9	90-057-13	1	KEY, 1/4 SQ. X 1-3/8
10	90-150-15	2	SHCS, 1/4-20 X 1-1/2 SS18-8
11	90-150-17	4	SHCS, 1/4-20 X 1-3/4 SS18-8
12	90-160-06	5	SHCS, 5/16-18 X 5/8 SS18-8
13	90-164-02	1	SSS, 5/16-18 X 1/4 SS18-8
14	90-164-05	1	SSS, 5/16-18 X 1/2 SS18-8
15	90-600-01	1	GREASE FITTING, 3/16 STRAIGHT DRIVE SS18-8
16	90-600-02	2	GREASE FITTING, 1/8 NPT STRAIGHT SS18-8
17	90-600-03	1	GREASE FITTING, 1/8 NPT X 65 DEG. SS18-8



Model D Saddle Assembly, 04-303-00

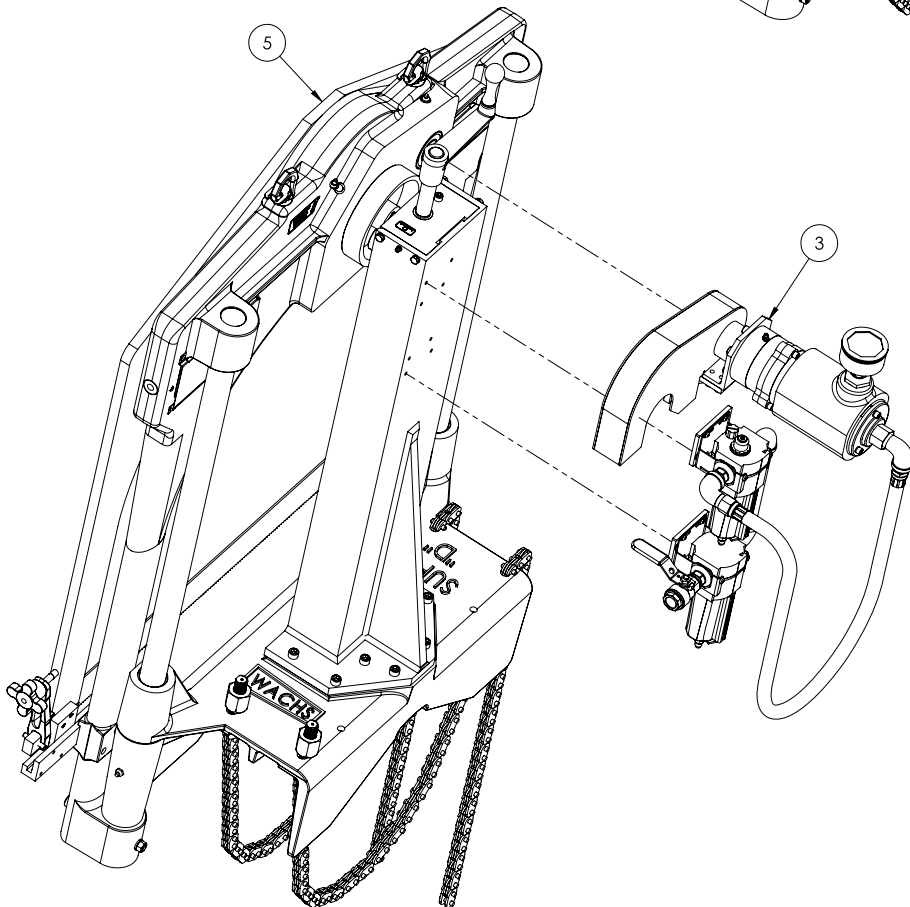
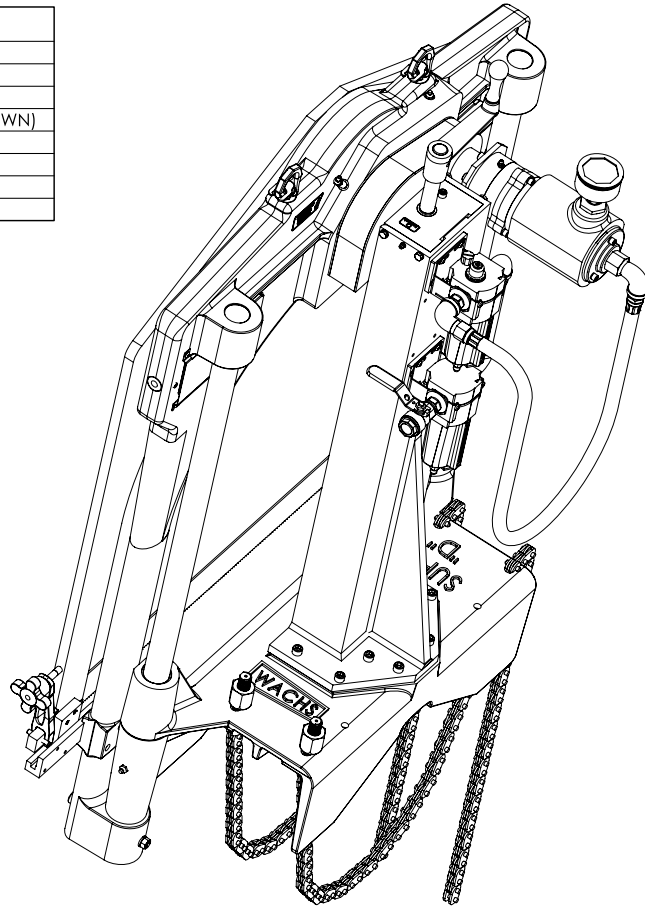
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-044-00	1	SCREW, FEED
2	04-045-00	1	HANDLE, FEED
3	04-047-00	1	PLATE, BEARING-FEED SCREW
4	04-049-00	1	BRACKET, FEED WELDMENT
5	04-052-00	1	NUT, FEED
6	04-054-00	2	BEARING, THRUST
7	04-059-00	1	SADDLE SUB-ASSEMBLY
8	04-061-00	1	ROLLER, CAM FOLLOWER-MACHINED
9	90-026-91	1	COTTER PIN 1/8 X 1-1/2
10	90-151-06	4	HHCS, 1/4-20 X 5/8 SS18-8
11	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
12	90-156-62	1	PIN, 1/4 X 1.00 ROLL SS18-8
13	90-160-00	6	SHCS, 5/16-18 X 1 SS18-8
14	90-215-01	1	NUT, 3/4-16 CASTLE
15	90-600-01	1	GREASE FITTING, 3/16 STRAIGHT DRIVE SS18-8
16	90-600-02	2	GREASE FITTING, 1/8 NPT STRAIGHT SS18-8
17	90-600-03	1	GREASE FITTING, 1/8 NPT X 65 DEG. SS18-8



Super D Guillotine, Pneumatic, 25-000-01

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-155-00	1	STEEL CABLE (NOT SHOWN)
2	03-MAN-01	1	MANUAL (NOT SHOWN)
3	25-137-00	1	AIR DRIVE ASSEMBLY
4	25-156-00	1	CRATE, L 59-1/2" X W 46-1/2" X H 30-1/4" (NOT SHOWN)
5	25-399-00	1	SUPER "D" FRAME ASSEMBLY
6	25-LIT-01	1	TOOLING CHART, GUILLOTINE (NOT SHOWN)
7	90-800-01	1	WRENCH, 1-1/4 OPEN END (NOT SHOWN)
8	90-800-38	1	WRENCH, 7/16 COMBINATION (NOT SHOWN)

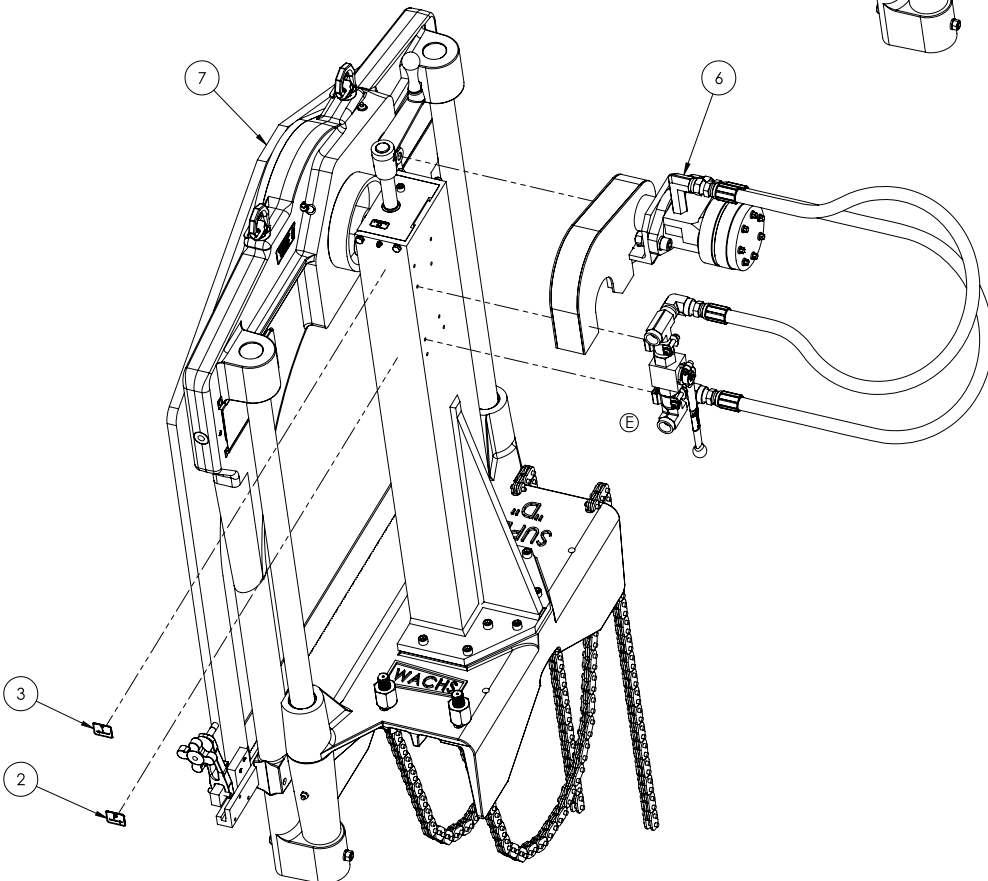
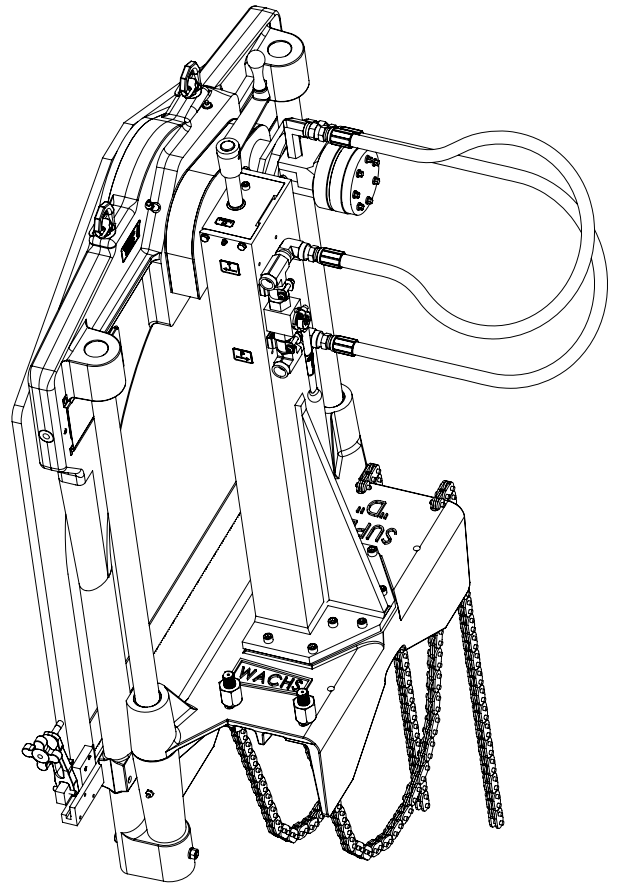
EXTERNAL SHIPPING DIMENSIONS: L=60-1/2" X W=47-1/2" X H=31-1/4"
 [L=1537mm] X [W=1207mm] X [H=794mm]



Super D Guillotine, Hydraulic, 25-000-03

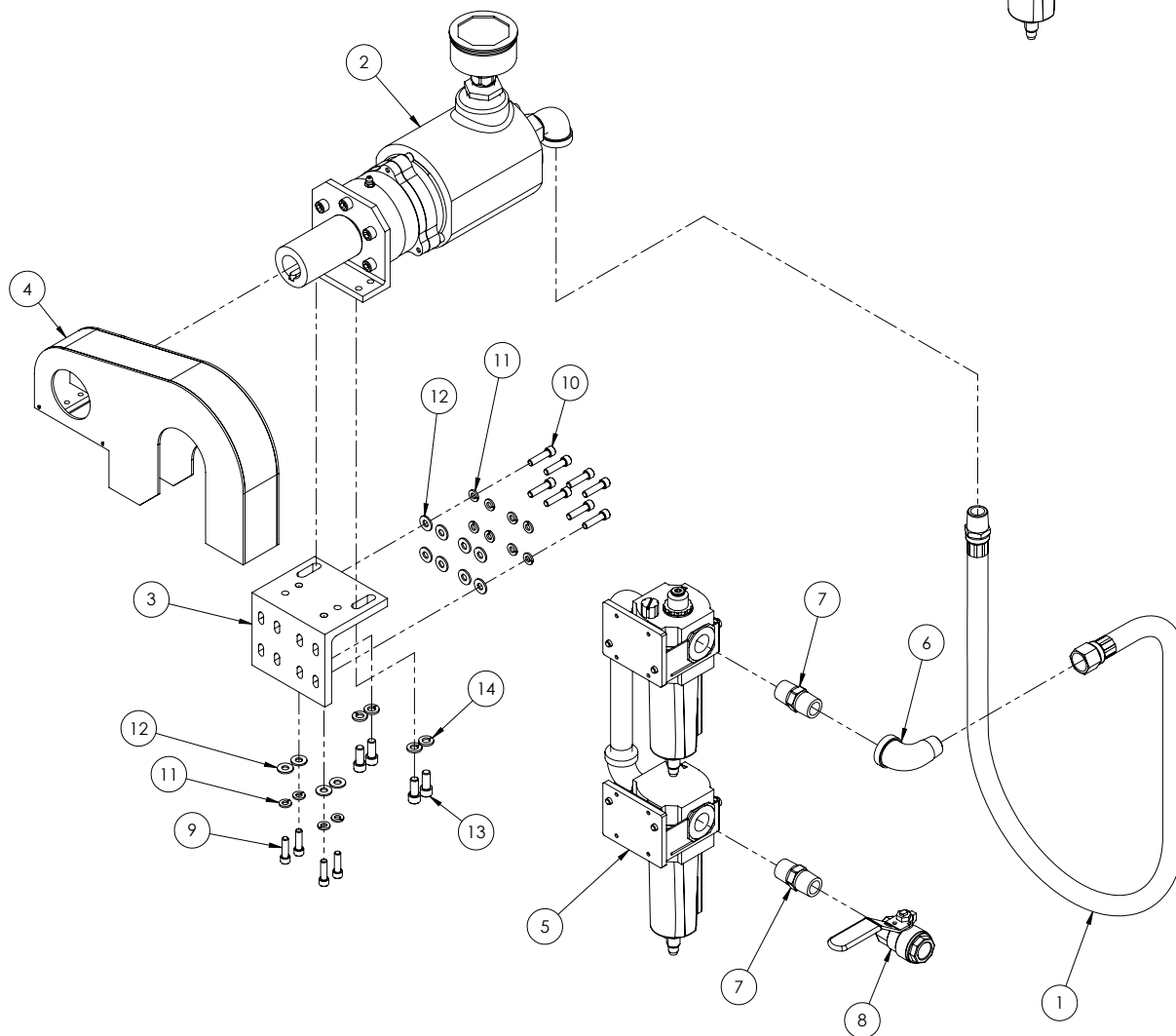
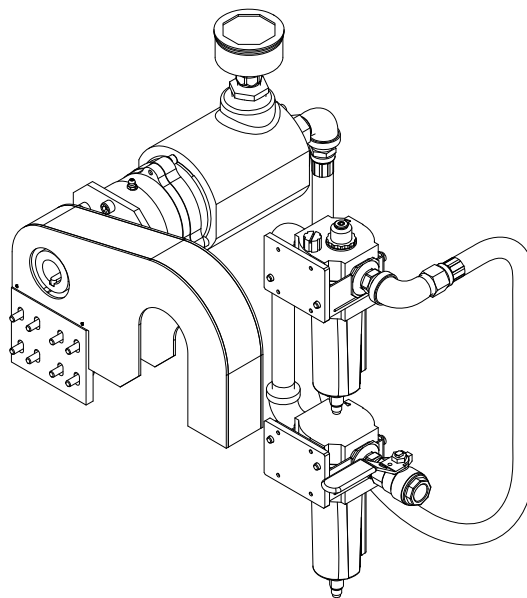
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-155-00	1	STEEL CABLE (NOT SHOWN)
2	03-113-07	1	LABEL, PRESSURE
3	03-113-08	1	LABEL, TANK
4	03-MAN-01	1	MANUAL (NOT SHOWN)
5	25-156-00	1	CRATE, L 59-1/2" X W 46-1/2" X H 30-1/4" (NOT SHOWN)
6	25-305-00	1	HYDRAULIC MOTOR ASSEMBLY
7	25-399-00	1	SUPER "D" FRAME ASSEMBLY
8	25-LIT-01	1	TOOLING CHART, GUILLOTINE (NOT SHOWN)
9	90-800-01	1	WRENCH, 1-1/4 OPEN END (NOT SHOWN)
10	90-800-38	1	WRENCH, 7/16 COMBINATION (NOT SHOWN)

EXTERNAL SHIPPING DIMENSIONS: L=60-1/2" X W=47-1/2" X H=31-1/4"
 [L=1537mm] X [W=1207mm] X [H=794mm]



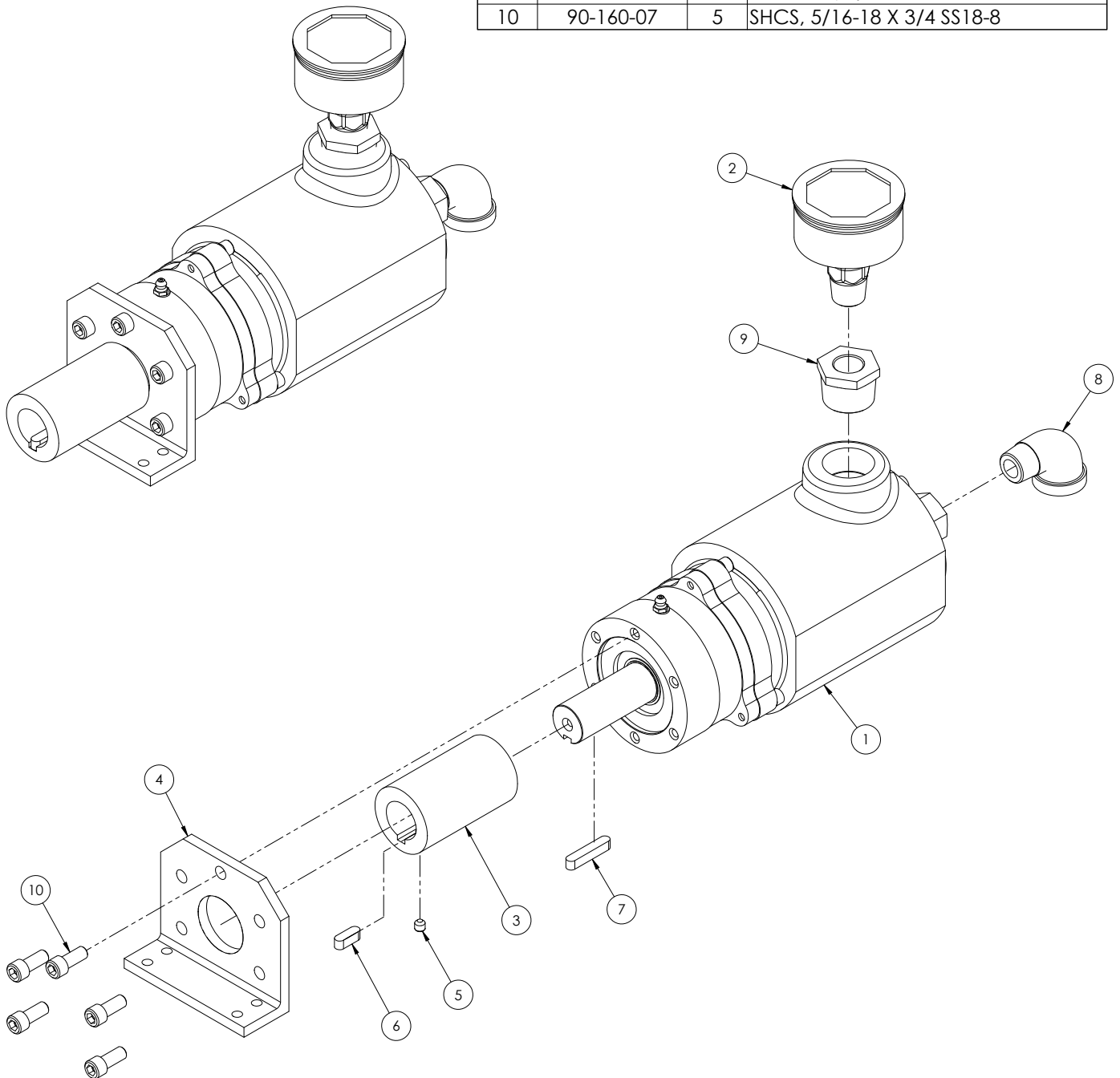
Super D Air Drive Assembly, 25-137-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-091-00	1	AIR HOSE, 1/2 DIA. X 42" LONG
2	25-029-00	1	AIR MOTOR SUB-ASSEMBLY
3	25-050-01	1	BRACKET, WELDMENT
4	25-086-00	1	GUARD, SUPER-D SERIES GUILLOTINES
5	25-501-00	1	LUBRICATOR AND FILTER ASSEMBLY
6	90-098-05	1	ELBOW, 1/2-90 STREET
7	90-098-08	2	NIPPLE, 1/2" BRASS HEX
8	90-099-51	1	VALVE, 1/2" BALL LP
9	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
10	90-150-10	8	SHCS, 1/4-20 X 1 SS18-8
11	90-155-52	12	WASHER, 1/4 SPLIT RING SS18-8
12	90-155-53	12	WASHER, 1/4 FLAT SS18-8
13	90-160-07	4	SHCS, 5/16-18 X 3/4 SS18-8
14	90-165-51	4	WASHER, 5/16 SPLIT RING SS18-8



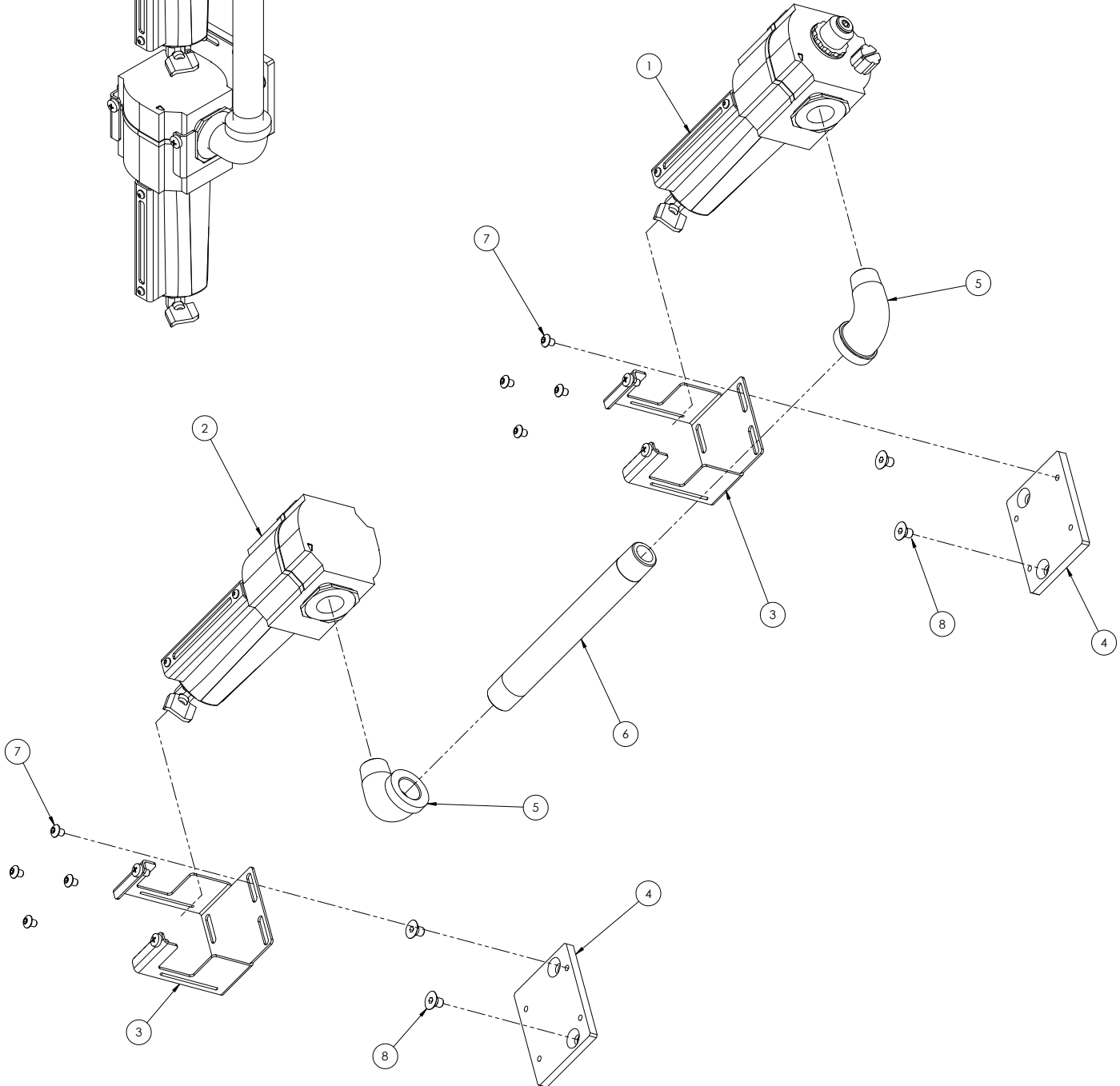
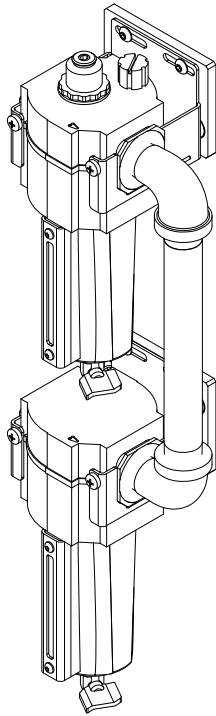
Super D Air Motor Assembly, 25-029-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-030-00	1	AIR MOTOR
2	23-181-00	1	MUFFLER
3	25-017-00	1	COUPLING, KEYED
4	25-078-01	1	MOTOR MOUNTING BRACKET
5	90-054-02	1	SSS, 1/4-20 x 1/4
6	90-057-07	1	KEY, 1/4 SQ. X 3/4
7	90-057-13	1	KEY, 1/4 SQ. X 1-3/8
8	90-098-05	1	ELBOW, 1/2-90 STREET
9	90-098-75	1	BUSHING, 1/2 X 1 REDUCING
10	90-160-07	5	SHCS, 5/16-18 X 3/4 SS18-8



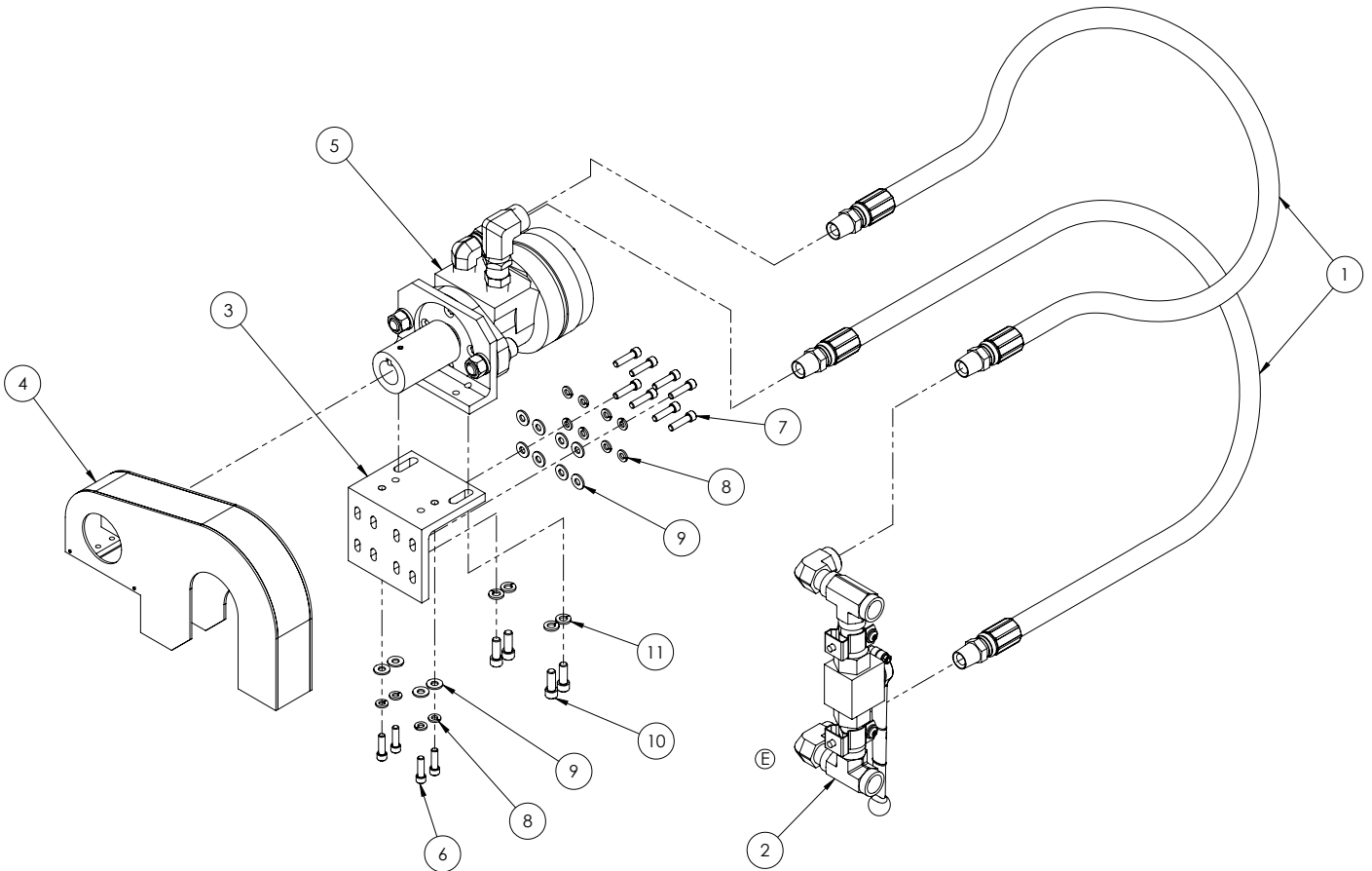
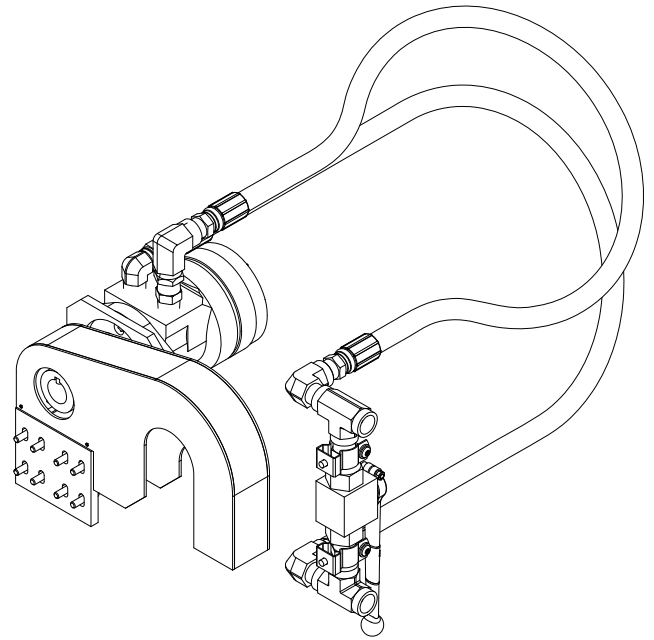
Super D Air Lubricator/Filter Assembly, 25-501-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-085-01	1	LUBRICATOR
2	04-090-01	1	FILTER
3	04-094-01	2	BRACKET, MOUNTING
4	25-096-00	2	PLATE, OILER MOUNTING
5	90-098-05	2	ELBOW, 1/2-90 STREET
6	90-098-86	1	NIPPLE, 1/2 X 7 SCH 80
7	90-142-02	8	BHCS, 10-24 X 1/4 SS18-8
8	90-153-03	4	FHCS, 1/4-20 X 3/8 SS18-8



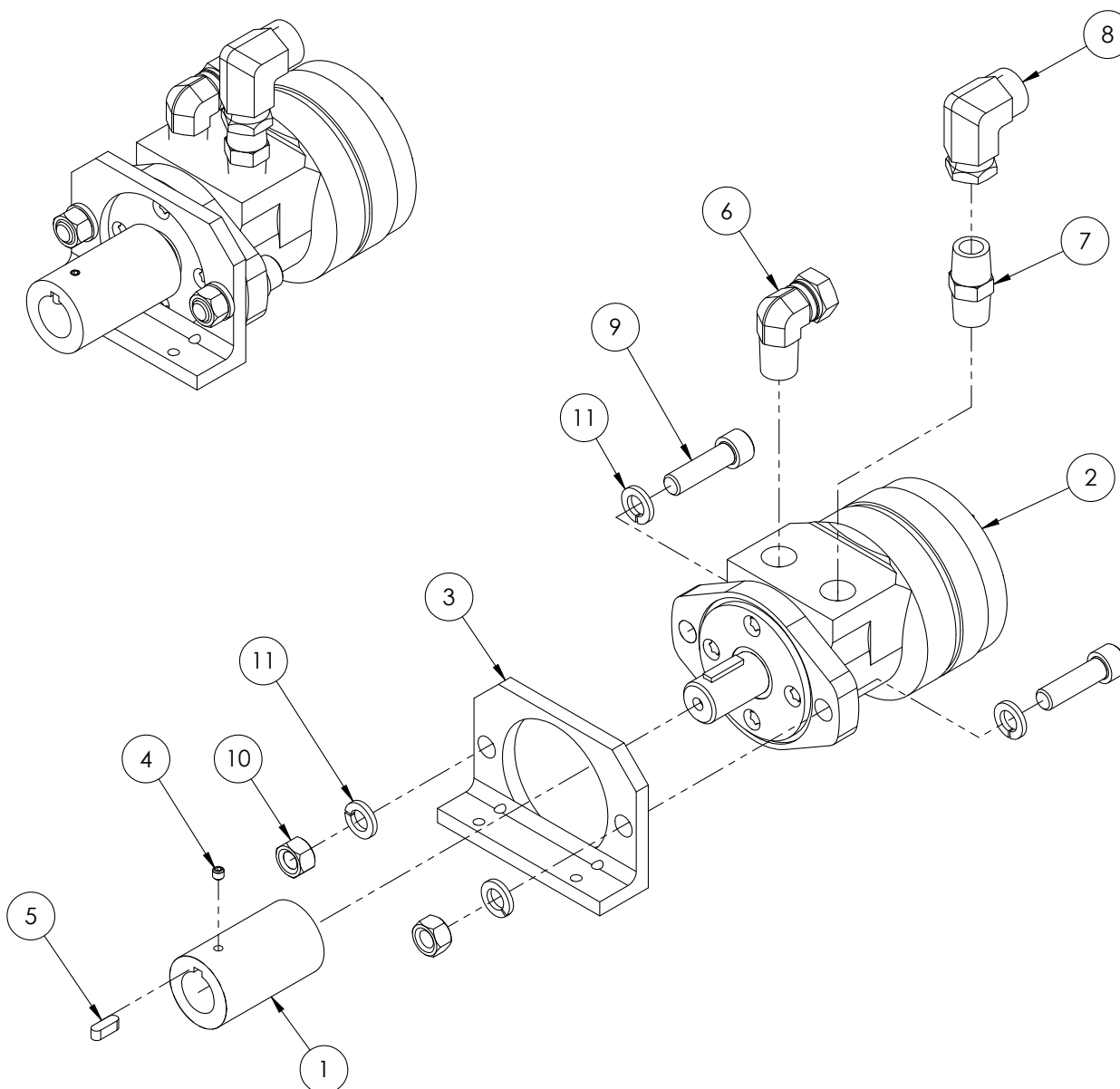
Super D Hydraulic Drive Assembly, 25-305-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	02-027-05	2	HOSE, 1/2" HP X 40" LONG
2	04-503-00	1	VALVE ASSEMBLY
3	25-050-01	1	BRACKET, WELDMENT
4	25-086-00	1	GUARD, SUPER-D SERIES GUILLOTINES
5	25-502-00	1	HYDRAULIC MOTOR SUB-ASSEMBLY
6	90-150-08	4	SHCS, 1/4-20 X 7/8 SS18-8
7	90-150-10	8	SHCS, 1/4-20 X 1 SS18-8
8	90-155-52	12	WASHER, 1/4 SPLIT RING SS18-8
9	90-155-53	12	WASHER, 1/4 FLAT SS18-8
10	90-160-08	4	SHCS, 5/16-18 X 7/8 SS18-8
11	90-165-51	4	WASHER, 5/16 SPLIT RING SS18-8



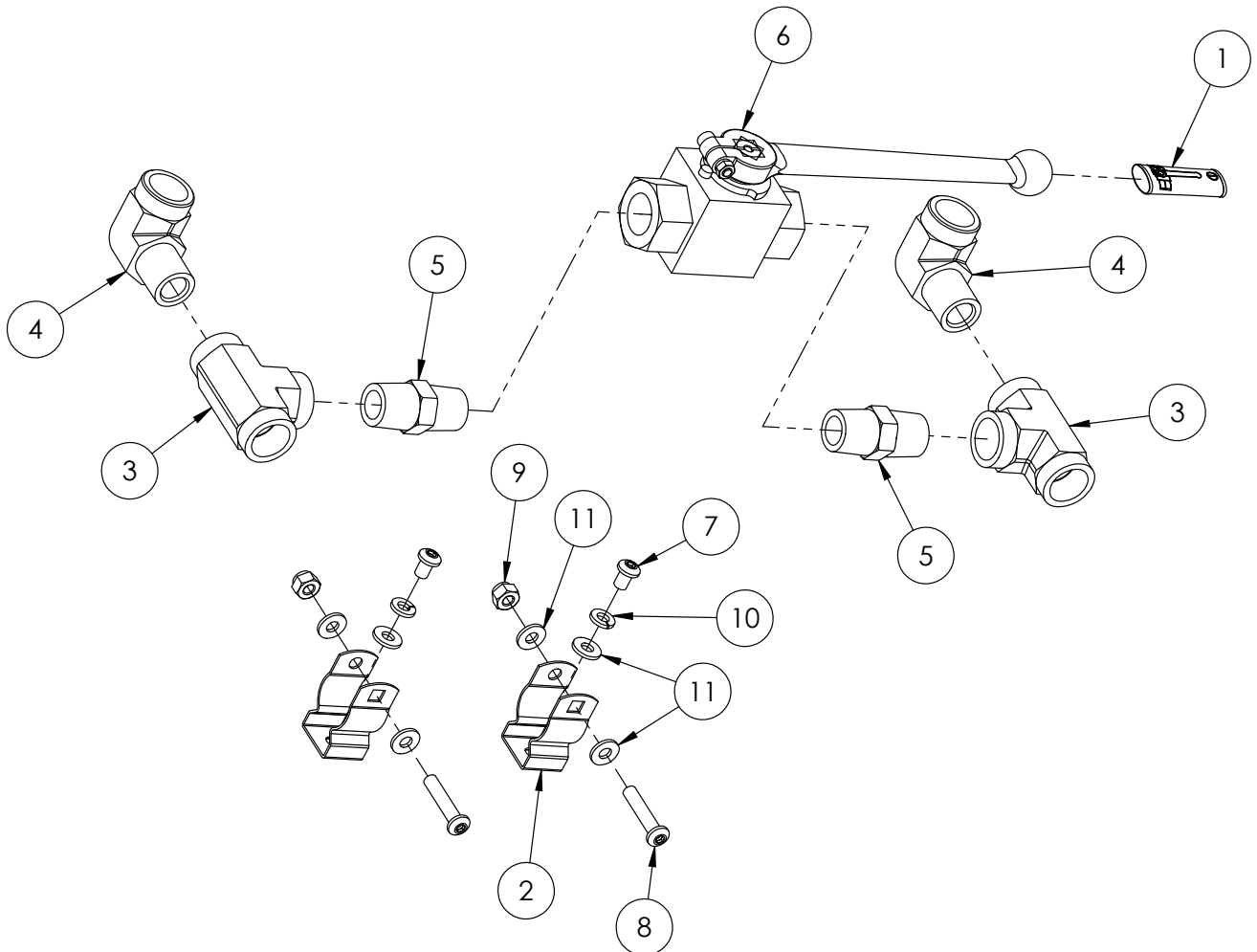
Super D Hydraulic Motor Assembly, 25-502-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	25-017-00	1	COUPLING, KEYED
2	25-115-00	1	HYDRAULIC MOTOR
3	25-125-01	1	MOUNTING BRACKET, HYDRAULIC MOTOR
4	90-054-02	1	SSS, 1/4-20 x 1/4
5	90-057-07	1	KEY, 1/4 SQ. X 3/4
6	90-098-55	1	ADAPTER, 1/2" NPT M X 1/2" NPT F SWIVEL-90
7	90-098-58	1	1/2 HEX HP NIPPLE
8	90-098-64	1	ADAPTER, 1/2" NPT F X 1/2" NPT F SWIVEL-90
9	90-190-17	2	SHCS, 1/2-13 X 1-3/4 SS18-8
10	90-195-01	2	NUT, 1/2-13 HEX SS18-8
11	90-195-58	4	WASHER, 1/2 LOCK SS18-8



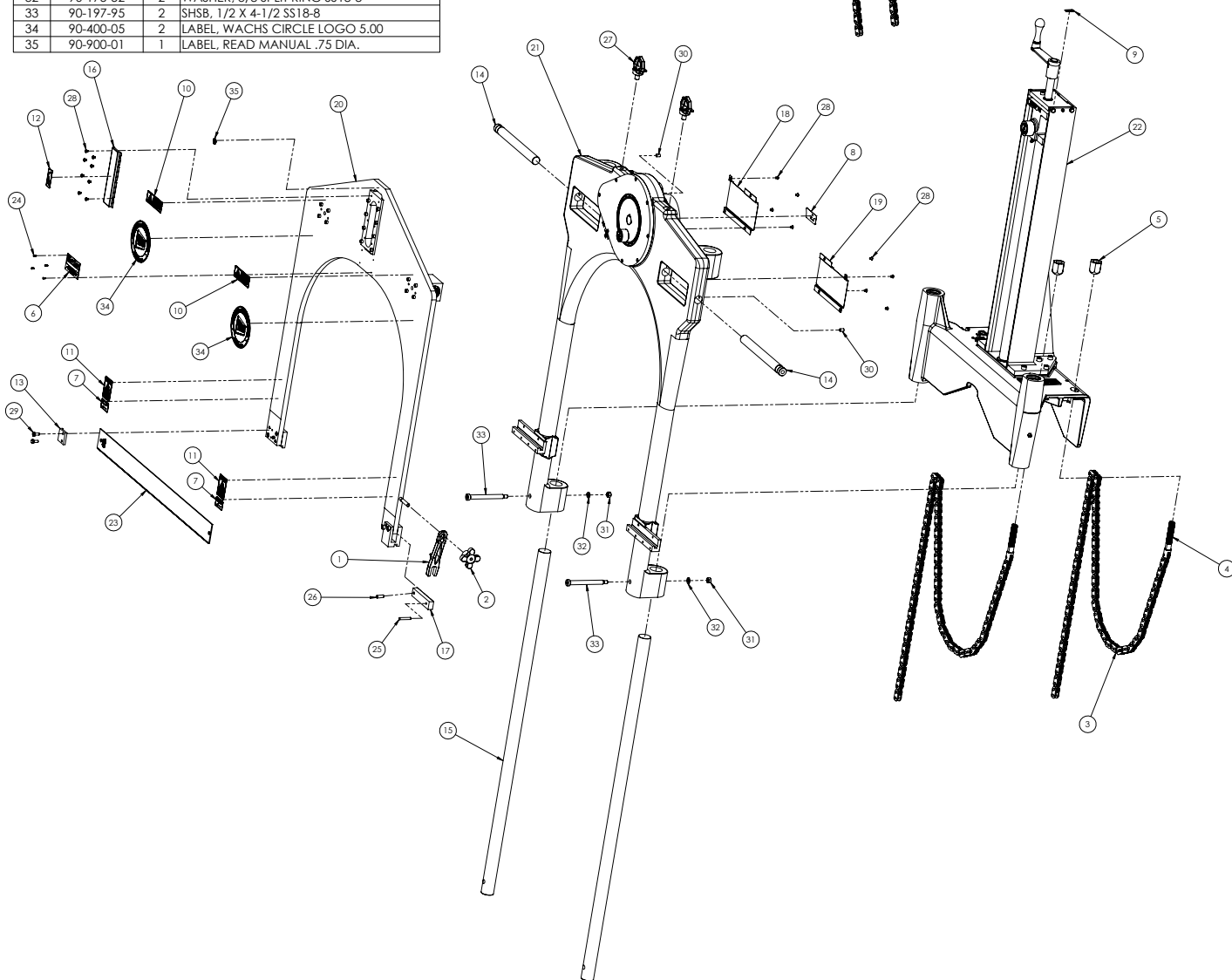
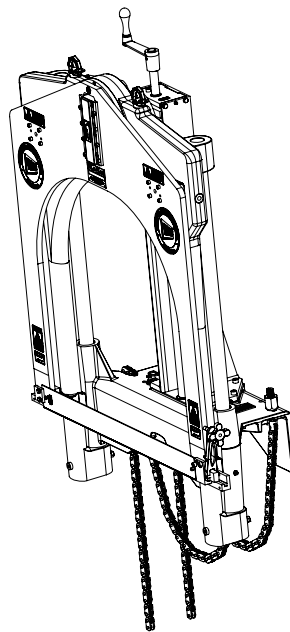
Super D Hydraulic Valve Assembly, 25-503-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-113-02	1	LABEL, SAW ON
2	03-154-00	2	HANGER, 1/2" CONDUIT
3	90-098-54	2	TEE, 1/2" NPT F - 1/2" NPT F X 1/2" NPT F HP
4	90-098-56	2	STREET ELBOW, 1/2 X 1/2
5	90-098-58	2	1/2 HEX HP NIPPLE
6	90-099-52	1	VALVE, 1/2" BALL HP
7	90-130-03	2	BHCS, 1/4-20 X 3/8 SS18-8
8	90-130-12	2	BHCS, 1/4-20 X 1-1/4 SS18-8
9	90-155-03	2	NUT, 1/4-20 NYLOCK SS18-8
10	90-155-52	2	WASHER, 1/4 SPLIT RING SS18-8
11	90-155-56	6	WASHER, #12 FLAT SS18-8



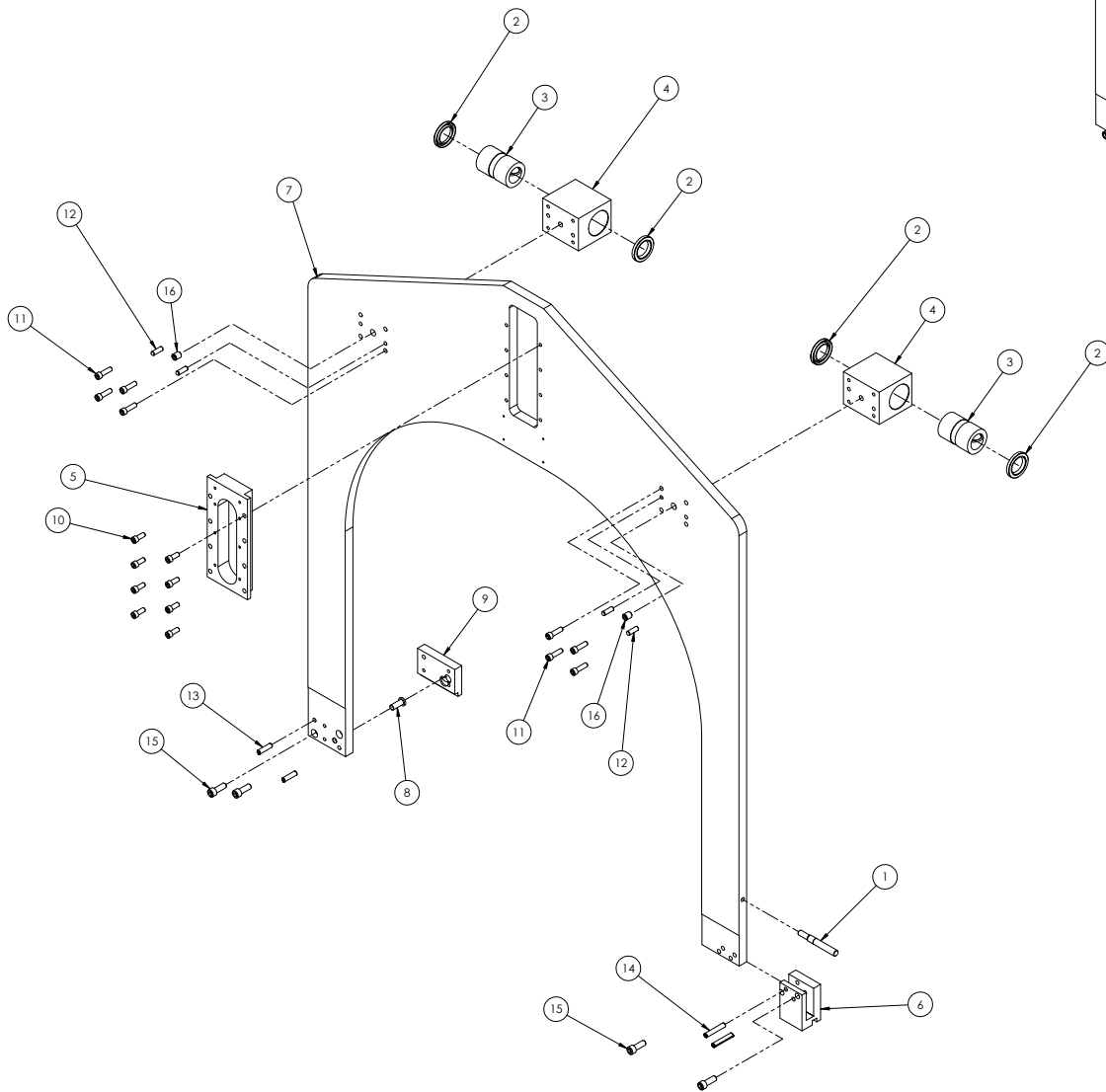
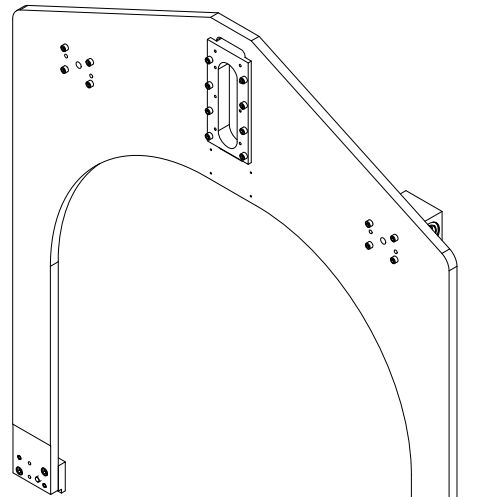
Super D Frame Assembly, 25-399-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-008-02	1	BRACKET, TENSIONING
2	03-009-00	1	KNOB, BLADE TENSIONING
3	03-057-04	2	CHAIN ASSEMBLY
4	03-058-00	2	SCREW, CHAIN TENSIONING
5	03-060-00	2	NUT, CHAIN TENSIONING
6	03-082-00	1	NAME PLATE
7	03-113-00	2	LABEL, BLADE DIRECTION
8	03-113-01	1	LABEL, CAM WHEEL
9	03-113-03	1	LABEL, FEED
10	03-113-04	2	LABEL, WARNING-MOVING PARTS
11	03-113-05	2	LABEL, WARNING-BLADE
12	03-113-06	1	LABEL, GREASE FITTING
13	04-020-00	1	BLADE CLAMP
14	04-043-02	2	SHAFT, RECIPROCATING
15	04-074-02	2	SHAFT, GUIDE-VERTICAL
16	25-002-00	1	GREASE COVER, YOKE
17	25-011-00	1	BAR, BLADE TENSIONER
18	25-042-00	1	GUARD, SD-1 REAR-RIGHT
19	25-068-00	1	GUARD, SD-1 REAR-LEFT
20	25-301-00	1	SAW FRAME ASSEMBLY
21	25-302-00	1	MAIN FRAME ASSEMBLY
22	25-303-00	1	SADDLE ASSEMBLY
23	25-402-00	1	BLADE, SAW-HSS
24	90-048-01	4	SCREW, #4 X 1/4 ROUND U-DRIVE SS18-8
25	90-056-15	1	PIN, 1/4 X 1-1/2 DOWEL
26	90-066-10	1	PIN, 5/16 X 1.0 DOWEL
27	90-099-92	2	EYE BOLT
28	90-142-02	16	BHCS, 10-24 X 1/4 SS18-8
29	90-151-06	2	HHCS, 1/4-20 X 5/8 SS18-8
30	90-164-05	2	SSS, 5/16-18 X 1/2 SS18-8
31	90-175-01	2	NUT, 3/8-16 HEX SS18-8
32	90-175-52	2	WASHER, 3/8 SPLIT RING SS18-8
33	90-197-95	2	SHSB, 1/2 X 4-1/2 SS18-8
34	90-400-05	2	LABEL, WACHS CIRCLE LOGO 5.00
35	90-900-01	1	LABEL, READ MANUAL .75 DIA.

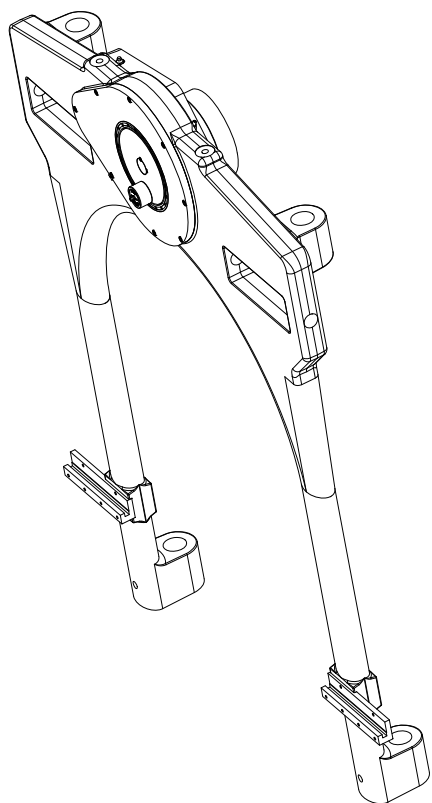


Super D Saw Frame Assembly, 25-301-00

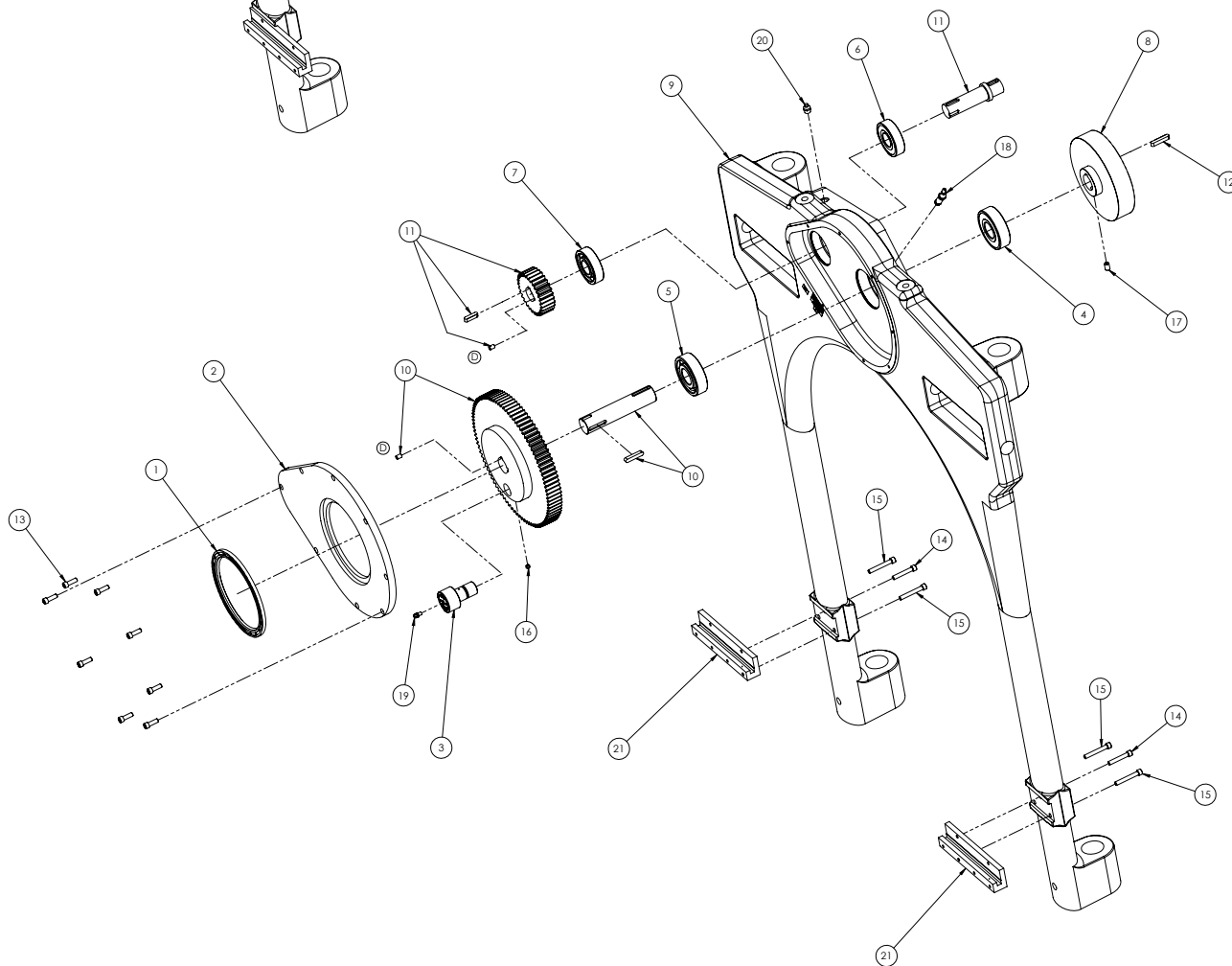
ITEM	PART NUMBER	QTY.	DESCRIPTION
1	03-007-00	1	TENSIONING SCREW
2	04-005-00	4	SEAL
3	04-006-00	2	BUSHING, BRONZE
4	04-212-00	2	BLOCK, BEARING
5	25-004-00	1	YOKE
6	25-013-00	1	HOLDER, BAR-BLADE TENSIONING
7	25-016-01	1	FRAME, SAW (SUPER "D")
8	25-022-00	1	PIN, BLADE HOLDER
9	25-023-00	1	RAIL, GUIDE
10	90-150-06	8	SHCS, 1/4-20 X 5/8 SS18-8
11	90-150-08	8	SHCS, 1/4-20 X 7/8 SS18-8
12	90-156-07	4	PIN, 1/4 X 3/4 DOWEL SS18-8
13	90-156-60	2	PIN, 1/4 X 1.00 ROLL SS18-8
14	90-156-65	2	PIN, 1/4 X 1-1/2 ROLL SS18-8
15	90-160-08	4	SHCS, 5/16-18 X 7/8 SS18-8
16	90-174-05	2	SSS, 3/8-16 X 1/2 SS18-8



Super D Main Frame Assembly, 25-302-00

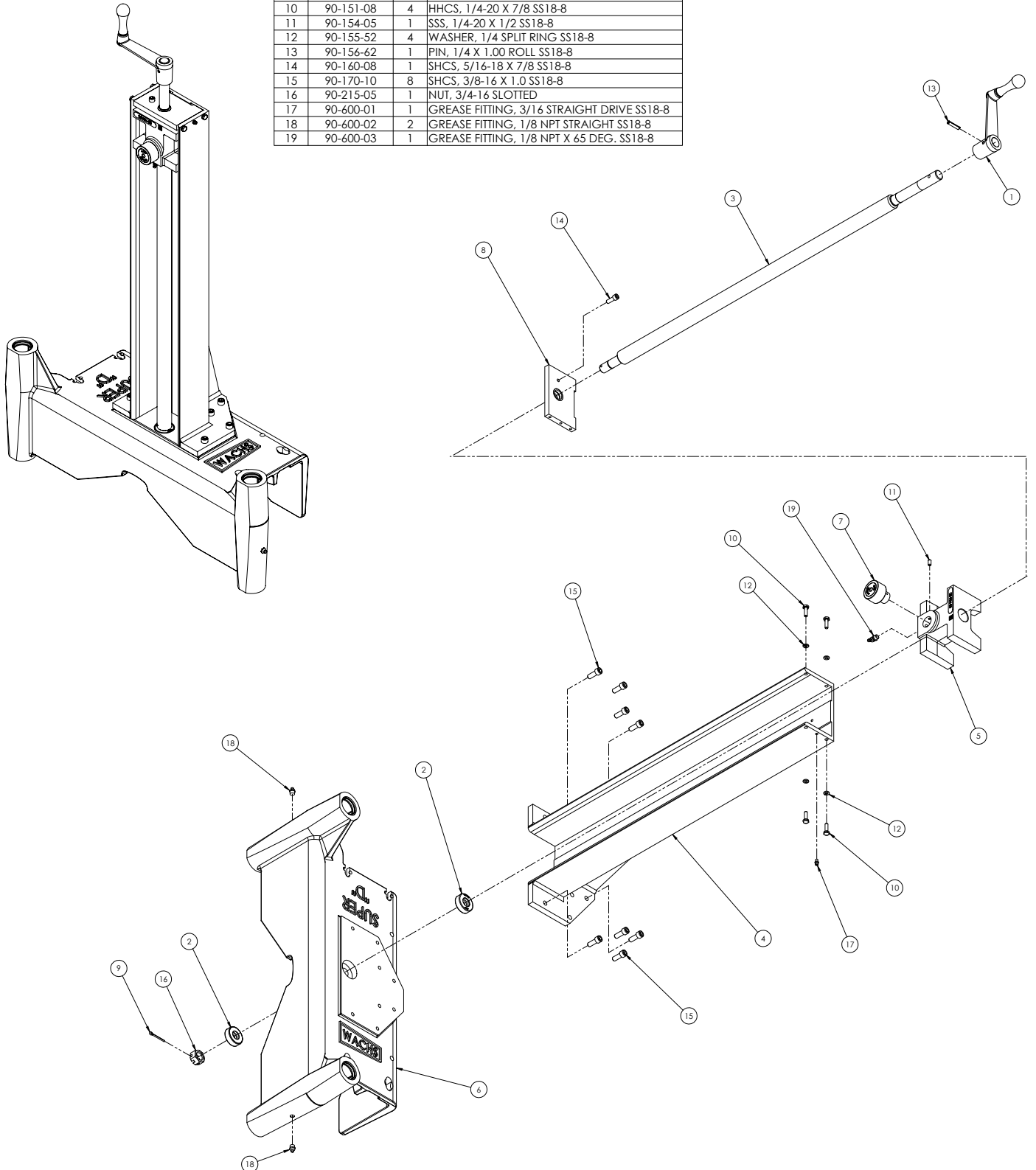


ITEM	PART NUMBER	QTY.	DESCRIPTION
1	25-024-00	1	SEAL
2	25-026-00	1	COVER
3	25-028-00	1	CAM FOLLOWER ROLLER
4	25-036-00	1	BALL BEARING-SEALED
5	25-037-00	1	BALL BEARING-NOT SEALED
6	25-038-00	1	BALL BEARING-SEALED
7	25-039-00	1	BALL BEARING-NOT SEALED
8	25-051-00	1	WHEEL, CAM
9	25-069-00	1	FRAME SUB-ASSEMBLY
10	25-154-00	1	MAIN GEAR ASSEMBLY-MACHINED
11	25-155-00	1	PINION GEAR ASSEMBLY-MACHINED
12	90-057-13	1	KEY, 1/4 SQ. X 1-3/8
13	90-150-07	8	SHCS, 1/4-20 X 3/4, SS18-8
14	90-150-15	2	SHCS, 1/4-20 X 1-1/2 SS18-8
15	90-150-17	4	SHCS, 1/4-20 X 1-3/4 SS18-8
16	90-154-01	1	SSS, 1/4-20 X 3/16 CUP SS18-8
17	90-164-05	1	SSS, 5/16-18 X 1/2 SS18-8
18	90-500-04	1	GREASE FITTING, 1/8 NPT X 30 DEG.
19	90-600-01	1	GREASE FITTING, 3/16 STRAIGHT DRIVE SS18-8
20	90-600-02	1	GREASE FITTING, 1/8 NPT STRAIGHT SS18-8
21	25-070-00	2	RIGHT HAND SAW FRAME



Super D Saddle Assembly, 25-303-00

ITEM	PART NUMBER	QTY.	DESCRIPTION
1	04-045-00	1	HANDLE, FEED
2	04-054-00	2	BEARING, THRUST
3	25-044-00	1	SCREW, FEED
4	25-049-00	1	BRACKET, FEED WELDMENT
5	25-052-01	1	NUT, FEED
6	25-059-00	1	SADDLE SUB-ASSEMBLY
7	25-061-00	1	ROLLER, CAM FOLLOWER-MACHINED
8	25-153-00	1	BEARING PLATE ASSEMBLY
9	90-026-91	1	COTTER PIN 1/8 X 1-1/2
10	90-151-08	4	HHCS, 1/4-20 X 7/8 SS18-8
11	90-154-05	1	SSS, 1/4-20 X 1/2 SS18-8
12	90-155-52	4	WASHER, 1/4 SPLIT RING SS18-8
13	90-156-62	1	PIN, 1/4 X 1.00 ROLL SS18-8
14	90-160-08	1	SHCS, 5/16-18 X 7/8 SS18-8
15	90-170-10	8	SHCS, 3/8-16 X 1.0 SS18-8
16	90-215-05	1	NUT, 3/4-16 SLOTTED
17	90-600-01	1	GREASE FITTING, 3/16 STRAIGHT DRIVE SS18-8
18	90-600-02	2	GREASE FITTING, 1/8 NPT STRAIGHT SS18-8
19	90-600-03	1	GREASE FITTING, 1/8 NPT X 65 DEG. SS18-8



Chapter 9

Accessories and Spare Parts

SPARE PARTS

Table 1 lists the spare parts available for all Guillotine saw models.

Table 1: Guillotine Spare Parts Kits

Description	Part No.
Super C spare parts kit	03-500-01
Model D spare parts kit	04-500-01
Model D spare parts kit with air motor	04-500-02
Super D spare parts kit	25-500-01
Super D spare parts kit with air motor	25-500-02

BLADES

Table 2 lists the blades available for all Guillotine saws. High-speed steel (HSS) blades are for general use. Carbide tooth blades are for cast, ductile, or cement-lined pipes.

Table 2: Guillotine Saw Blades

Description	Part No.
Super C HSS blade	24-405-00
Super C carbide tooth blade	24-405-01
Model D HSS blade	04-402-00
Model D HSS thin-wall blade (3/16" max. wall)	04-403-00
Model D HSS heavy wall blade (over 1" wall)	04-404-10
Model D carbide tooth blade	04-405-01
Super D HSS heavy duty blade	25-402-00

Chapter 10

Ordering Information

To place an order, request service, or get more detailed information on any E.H. Wachs products, call us at one of the following numbers:

U.S.: 800-323-8185

International: 847-537-8800

You can also visit our Web site at:

www.ehwachs.com

ORDERING REPLACEMENT PARTS

When ordering parts, refer to the drawings and parts lists in Chapter 8. Please provide the part description and part number for all parts you are ordering.

REPAIR INFORMATION

Please call us for an authorization number before returning any equipment for repair or factory service. We will advise you of shipping and handling. When you send the equipment, please include the following information:

- Your name/company name
- Your address
- Your phone number
- A description of the problem or the work to be done.

Before we perform any repair, we will estimate the work and inform you of the cost and the time to complete it.

WARRANTY INFORMATION

Enclosed with the manual is a warranty card. Please fill out the registration card and return to E.H. Wachs. Retain the owner's registration record and warranty card for your information.

RETURN GOODS ADDRESS

Return equipment for repair to the following address.

E.H. Wachs
600 Knightsbridge Parkway
Lincolnshire, Illinois 60069 USA



E.H.WACHS

Superior Equipment. Complete Support.

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847-537-8800 • www.wachsco.com