

***BAND CUTTER
TA10-D327***

Documentation commissioner:
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Edition: 02-2017

BAHCO

TOOL SPECIFICATIONS

Cutting force	10 kN(6 bar / 90 Psi)
Stroke maximum	6,5 mm / 0,26 in
Required free air	1,6 l / Zyklus
Weight	1,3 kgs
Working pressure	5-7 bar
Cuttin gtime	< 1 s
Noise level	< 75 dB (A)
Vibration	< 2,5 m/s ²

SAFETY RULES

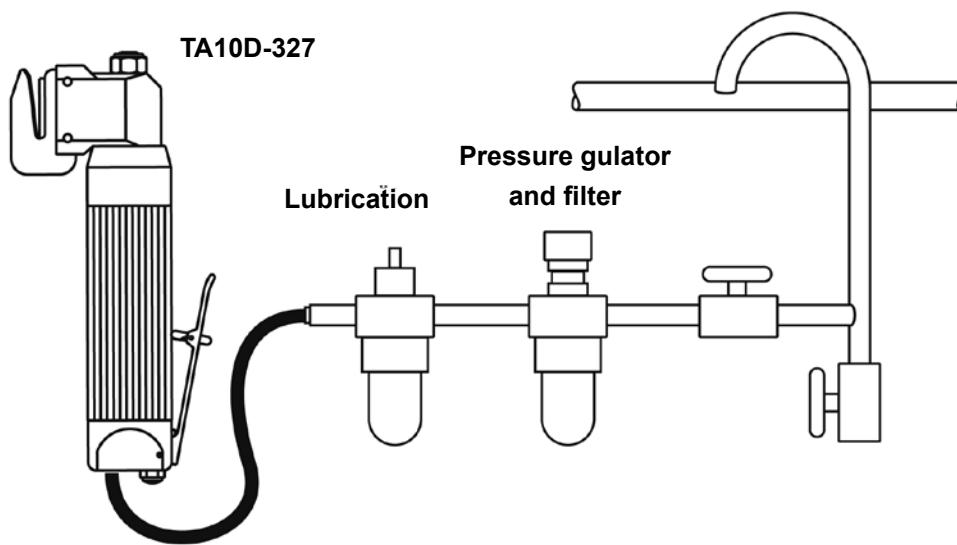
1. Do not use the tool outside the design intent.
2. Always disconnect the airline from the tool inlet before any service or adjustments.
3. Keep fingers and hands away from the working area when operating the tool.
4. The operating air pressure may not exceed 7 bar / 100 Psi.
5. When using the tool, the wearing of safety glasses is required both by the operator and others nearby the tool. We recommend the operator to wear gloves.
6. Always adopt a fi rm footing before operating the tool.
7. The precautions to be observed when using this tool shall be explained by the customer to all operators.
8. The tool shall be maintained in a safe working condition and examined regularly by trained and competent personnel.
9. Use only parts with this tool, which are recommended an supplied by BAHCO.
10. Any modifi cation undertaken by the customer to the tool, shall be the customers entire resonsibility.

INTENTION OF USE

This tool is designed to cut sheet metal / steel band, with a maximum dimensions of 2.5 x 33 mm.

CONNECTION TO THE AIR SUPPLY

We recommend the use of pressure regulators and oiling/ filter systems on the main air supply (see diagram below). All air hoses must have a minimum inner diameter of 6 mm or 1/4 inch. The tool is operated at an optimum pressure of 6 bar or 90 Psi.



TECHNICAL DESCRIPTION

TA10 is a hydro-pneumatic tool. Its consist of a power unit and a tool head. The hydro-pneumatic power unit has an air cylinder connected to a hydraulic cylinder. This gives a booster effect.

An input of 6 bar/90 Psi air pressure, gives a oil pressure of 177 bar/2655 Psi. The oil pressure gives the Hydraulic Piston a force of 10 kN and in this tool a stroke of 6.5 mm/ 0.26 inch. It is a one-way Air Piston with spring return.

The tool is supplied with a Safety Lever **(15)**, which makes it impossible to accidentally active the tool.

By unscrewing the screws **(33)**, the handle can be adjusted to the most comfortable working position.

MAINTENANCE

PRIMING.

Priming is always necessary after the tool has been dismantled and prior to operating. It may also be necessary to restore the full stroke after considerable use.

The priming procedure should be carried out in a clean area with clean hands. Ensure that the oil is perfectly clean and free from air bubbles. Before starting, make sure that the tool is disconnected from the air supply.

It is important to keep the tool horizontal during the whole procedure.

- Unscrew Oil screws **(32)**.
- Use AWS 32 Hydraulic oil or similar.
- Fill oil into the lowest positioned hole until it comes air free oil from the other hole.
- Replace and tighten the Oil screws **(32)**.

SHARPENING OF THE CUTTING BLADE 3405D.

The Cutting Blade can be used on both sides. Here is how to change side.

- Remove the Pins **(36)**.
- Remove the Cutting Blade **(39)**.
- Move the support bar **(41)** to the opposite side.
- Turn the piston **(37)** 180 degree.
- Assemble the Cutting blade **(39)**.
- Assemble the pins **(36)**.
- Priming
- Test

REPLACING CUTTING BLADE AND CUTTING EDGE.

Dismantling

- Remove the Pins **(36)**
- Remove the Cutting blade **(39)**

Assembly

- Assembly in reverse order of dismantling.
 - Priming, see above.
-

Dismantling Power Unit

- Loosen nut **(33)**
- Remove cross head **(28)** from hydraulic piston **(27)**.
Take care of the hydraulic oil.
- Push out pins **(36)** and remove Cutting blade **(39)**.
- Take away hydraulic piston **(37)**.
- Remove seals **(29)**, **(30)**, **(34)** and **(35)**. Be careful with seal surfaces!
- Remove hydraulic cylinder **(24)** together with hydraulic piston **(27)**.
- Unscrew guide **(21)** and remove seals **(22)**, **(23)** and **(25)**.
- Remove spring **(17)**, Spring guide **(18)** pull out air piston **(14)** together with high pressure piston **(16)** and take out O-Ring **(13)**.
- Press out pin **(6)** and remove lever **(15)**, Valve rod **(8)**, Spring **(3)** and O-Ring **(7)**.
- Loosen plug **(9)** and take away spring **(1)**, valve **(2)** and O-Ring **(10)**.

Assembly

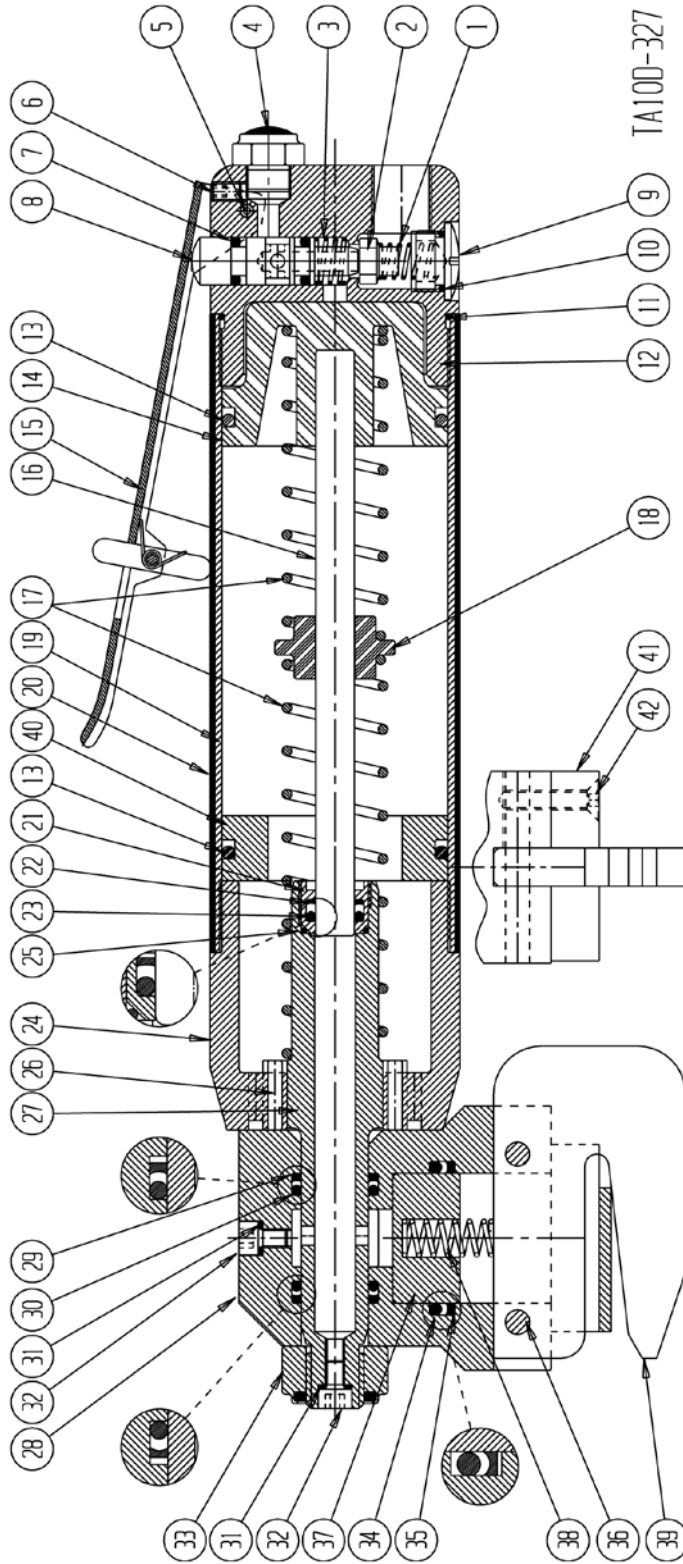
Assembly in reverse order of dismantling.
Priming, see above.

TROUBLE SHOOTING

SYMPTOM	POSSIBLE CAUSE	REMEDY	PAGE
Does not cut	Low air pressure	Adjust to 5-7 bar / 75-100 Psi	2
	Low oil level	Prime tool	4
	Cutting edges unsharp	Sharpening	4
Leaks oil	Damaged cutting edges	Replace cutting blade and edges	4
	Worn or defected seals	Replace seals and prime tool	5

RECOMMENDED SPARE PARTS

POSITION	ART. NO.	DESCRIPTION	QTY
*	P-TA10-327	Seal kit	1
17	5830	Spring	2
37	3897	Piston	1
38	5835	Spring	1
39	3405D	Cutting blade	1



SPARE PART LIST - TA10D-327

NO.	QTY	DESCRIPTION	ART. NO.	NO.	QTY	DESCRIPTION	ART. NO.
1	1	Spring	1336	26	2	Pin	5406
2	1	Valve	1337	27	1	Hydraulic-piston	3402-1
3	1	Spring	1339	28	1	Cross bar	3403
4	1	Silencer	1565	29	2	Bearing *)	6363
5	1	Pin	5448	30	2	O - Ring *)	6328
6	1	Screw	5023	31	2	Seal *)	6514
7	2	O - Ring *)	6320	32	2	Oil screw	5047
8	1	Valve rod	1553	33	1	Nut	5204
9	1	Plug	1334	34	1	O - Ring *)	6355
10	1	O - Ring *)	6315	35	1	Bearing *)	6364
11	1	O - Ring *)	6303	36	2	Locking pin	5505
12	1	Valve housing	2087	37	1	Hydraulic-piston	3897
13	1	O - Ring *)	6353	38	1	Spring	5835
14	1	Air piston	2086	39	1	Cutting blade	3405D
15	1	Safety lever	3236	40	1	Distance sleeve	4588-13
16	1	Piston stem	5466	41	1	Support bar	3842-10
17	2	Spring	5830	42	2	Screw	5088
18	1	Guide	2198				
19	1	Air piston	2194	*)		Part of Seal kit REF P-TA10-327	
20	1	Plastic cover	2441				
21	1	Guide	2734-2-8				
22	1	Bearing *)	6360				
23	1	O - Ring *)	6322				
24	1	Hydraulic-cylinder	3402-2				
25	1	O - Ring *)	6317				

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