

***AIR HYDRAULIC CUTTING TOOL  
TA14S-530/730***

Documentation commissioner:  
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**BAHCO**

Cutting force	40 kN (6 bar/90 psi)
Stroke maximum	6,5 mm / 0,26 in
Required free air	2,5 l /zyklus
Weight	2,6 kg
Working pressure	5 – 7 bar (75 – 100 lbf/in <sup>2</sup> )
Cutting time	< 1 s
Noise level	< 75 dB (A)
Vibration	< 2,5 m/s <sup>2</sup>

### **SAFETY RULES**

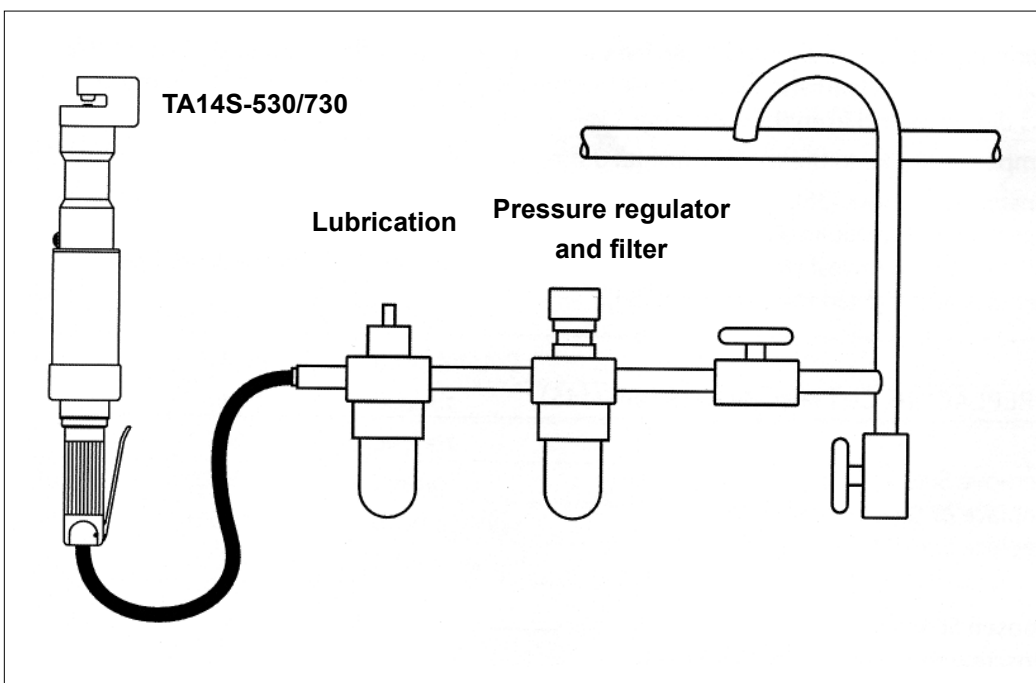
1. Do not use the tool outside the design intent.
2. Always disconnect the airline from the tool inlet before any service or adjustments.
3. Keep fingers and hands away from the working area when operating the tool.
4. The operating air pressure may not exceed 7 bar / 100 Psi.
5. When using the tool, 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 firm 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 and supplied by BAHCO.
10. Any modification undertaken by the customer to the tool, shall be the customer's entire responsibility.

### **INTENSION OF USE**

This tool is designed to cut metal wires, with a maximum diameter of 8 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

TA14S 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 572 bar/8580 Psi. The oil pressure gives the Hydraulic Piston a force of 40 kN and in this tool a stroke of 6.5 mm/ 0.27 inch. It is a one-way Air Piston with spring return.

## **MAINTENANCE**

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### **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 (35).
- 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 (34).

### **REPLACING CUTTING EDGES (44)+(45).**

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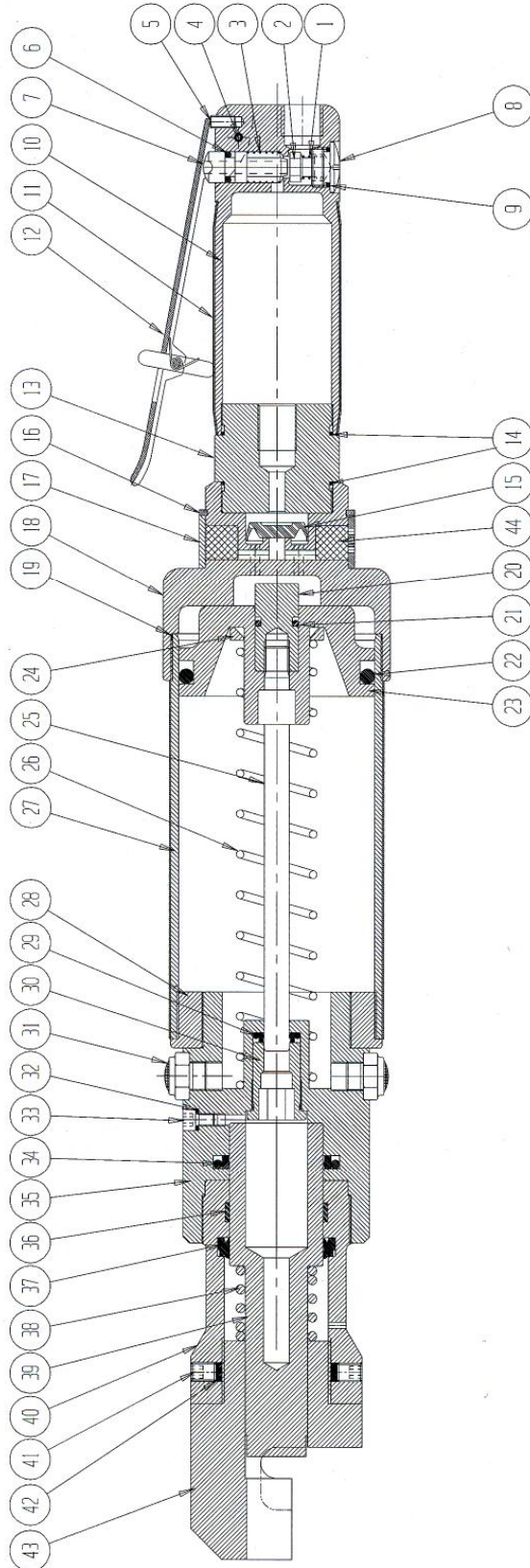
- Remove Screws (47)
- Replace or turn Cutting edge (45)
- Replace Screw (47)
- Loosen Screw (42)
- Unscrew the Clamb by turning it left.
- Remove Screw (49) and Cutting edge (44)
- Replace Cutting edge (44) with Screw (49)
- Replace the tool Clamb and secure Screws (42)

## TROUBLE SHOTING

SYMPTOM	POSSIBLE CAUSE	REMEDY	REF PAGE
Do not cut	Low air pressure	Adjust to 5-7 bar / 75-100 Psi	2
	Low oil level	Prime tool	4
	Damaged punch edges	Replace Punch and Punch Die	4
Leaks oil	Worn or defected seals	Replace seals, use Lindova Seal-kit, and prime tool	4

## RECOMMENDED SPARE PARTS

POSITION	ART. No.	DESCRIPTION	QTY
	P-TX30	Seal kit	1
	P-700	Seal kit	1
26	5846	Spring	1
44	10001	Cutting edge	1
45	10092	Cutting edge	1



## PARTS LIST, TA14S-530/730

POS.	PART NO.	DESCRIPTION	QTY
1	1336	Spring	1
2	1337	Valve	1
3	1339	Spring	1
4	5448	Pin	1
5	5023	Screw	1
6	6320 *	O - Ring	1
7	2362A	Valve rod	1
8	1334	Plug	1
9	6315 *	O - Ring	1
10	2358	Handle	1
11	2361	Plastic cover	1
12	3236	Lever	1
13	2928	Middle piece	1
14	6318 *	O - Ring	2
15	2785 *	Membrane	1
16	5624	Locking ring	1
17	2927	Sleeve	1
18	4323	Rear plate	1
19	6387	O - Ring	1
20	4196	Nut	1
21	6324	O - Ring	1
22	6382 *	O - Ring	1
23	4198	Air piston	1
24	4804	Support plate	1
25	4221-107	High pressure piston	1
26	5828C	Spring	1
27	3836	Air cylinder	1
28	3838	Front plate	1
29	6560 **	Packing	1
30	3791	Piston guide	1
31	1565	Damper	2
32	6514 **	Packing	2
33	5047	Oil screw	2
34	6561 **	Packing	1
35	3790-1	Hydraulic cylinder	1

POS.	PART NO.	DESCRIPTION	QTY
36	6037	Guide	1
37	6511 **	Wiper	1
38	5841A	Spring	1
39	3788	Hydraulic piston	1
40	3790-2	front Hydraulic cylinder	1
41	5016	Screw	2
42	1537	Nylon-plug	2
43	3789	Cutting head	1
44	1869	Damper	2
*	P-TX30	Seal kit	
**	P-500	Seal kit	

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