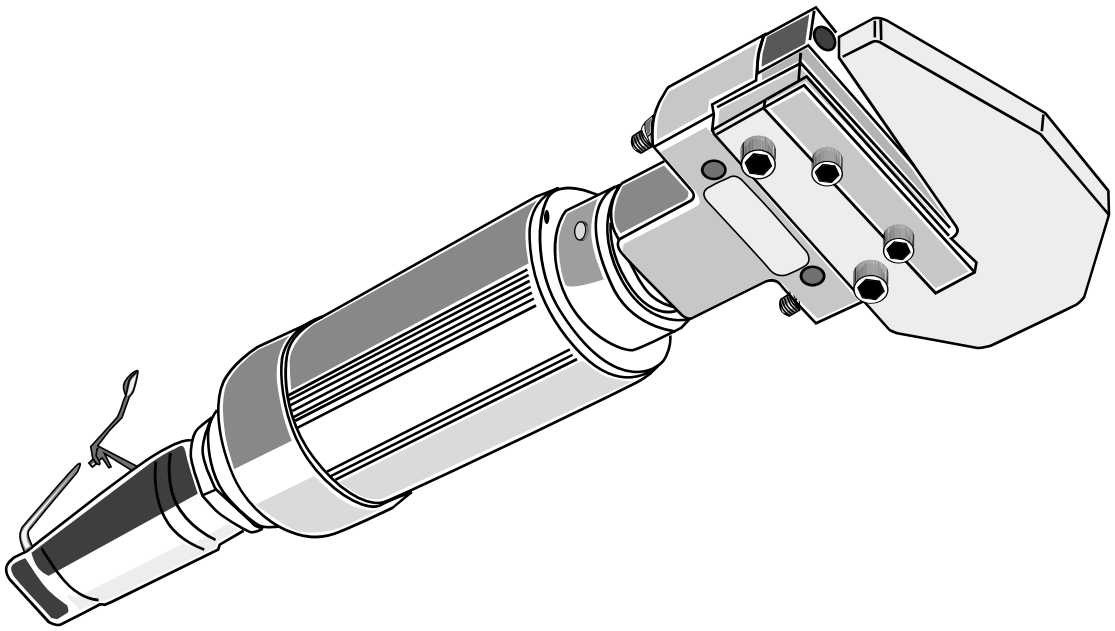
INSTRUCTION MANUAL



BAND CUTTER
TA13-725

Documentation commissioner:
Andreas Bos
Edition: 02-2017

TOOL SPECIFICATIONS

Cutting force	24 kN (6 bar/90Psi)
Stroke maximum	9 mm /0,43 in
Required free air	3,5 l/Zyklus
Weight	3,9 kgs
Working pressure	5-7 bar (75-100 lbf/in²)
Cutting time	< 1 s
Noise level	< 75 dB (A)
Vibration	< 2,5 m/s²

SAFETY RULES

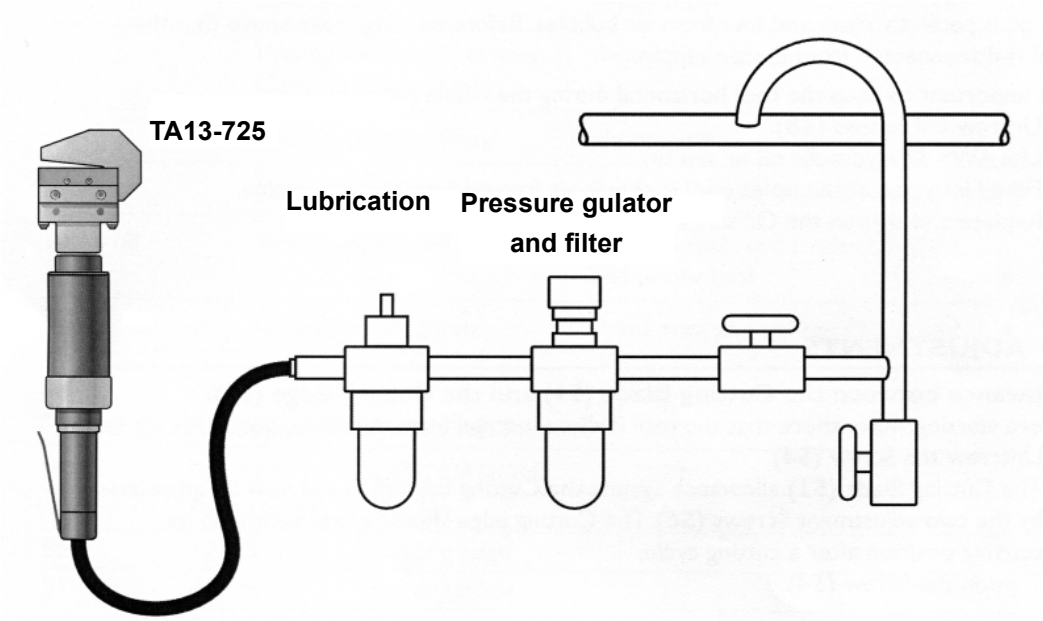
1. Do not use the tool outside the design intent.
2. Always disconnect the airline from the tool inlet before any service or adjustments.
3. Keep fingers and hands away from the working area when operating the tool.
4. The operating air pressure may not exceed 7 bar / 100 Psi.
5. When using the tool, 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, with a maximum dimensions of 1.6 x 80 mm.

CONNECTION TO THE AIR SUPPLY

We recommend the use of pressure regulators and oiling/ fi lter 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

TA13 is a hydro-pneumatic tool. Its consist of a power unit and a tool head. The hydropnumatic 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 560 bar. The oil pressure gives the Hydraulic Piston a force of 24 kN and in this tool a stroke of 9 mm/ 0.43 inch. It is a one-way Air Piston with spring return.

The tool is supplied with a Safety Lever **(11)**, which makes it impossible to accidentally active the tool.

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 shore that the tool is disconnected from the air supply.

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

- Unsrew Oil screws **(38)**.
- 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 **(38)**.

ADJUSTMENTS

Allowance between the Cutting Blade (51) and the Cutting Edge (55).
Before starting, make sure that the tool is disconnected from the air supply.

- Unscrew the screw **(54)**
- The Cutting Blade (51) allowance against the Cutting Edge **(55)** can now be adjusted by the two adjustment Screws **(56)**. The Cutting Edge should easely return to its starting position after a cutting cycle.
- Tighen the Screw **(54)**.

REPLACING CUTTING BLADE AND CUTTING EDGE

Dismantling

- Unscrew nuts **(40)**
- Unscrew and remove the Screw **(54)**, and the Cutting Edge **(55)** is lose.
- Remove the Pins **(44)**, to be able to losen the Springs **(43)** from the Cutting Edge.
- Unscrew Screwa **(48)**

Assembly

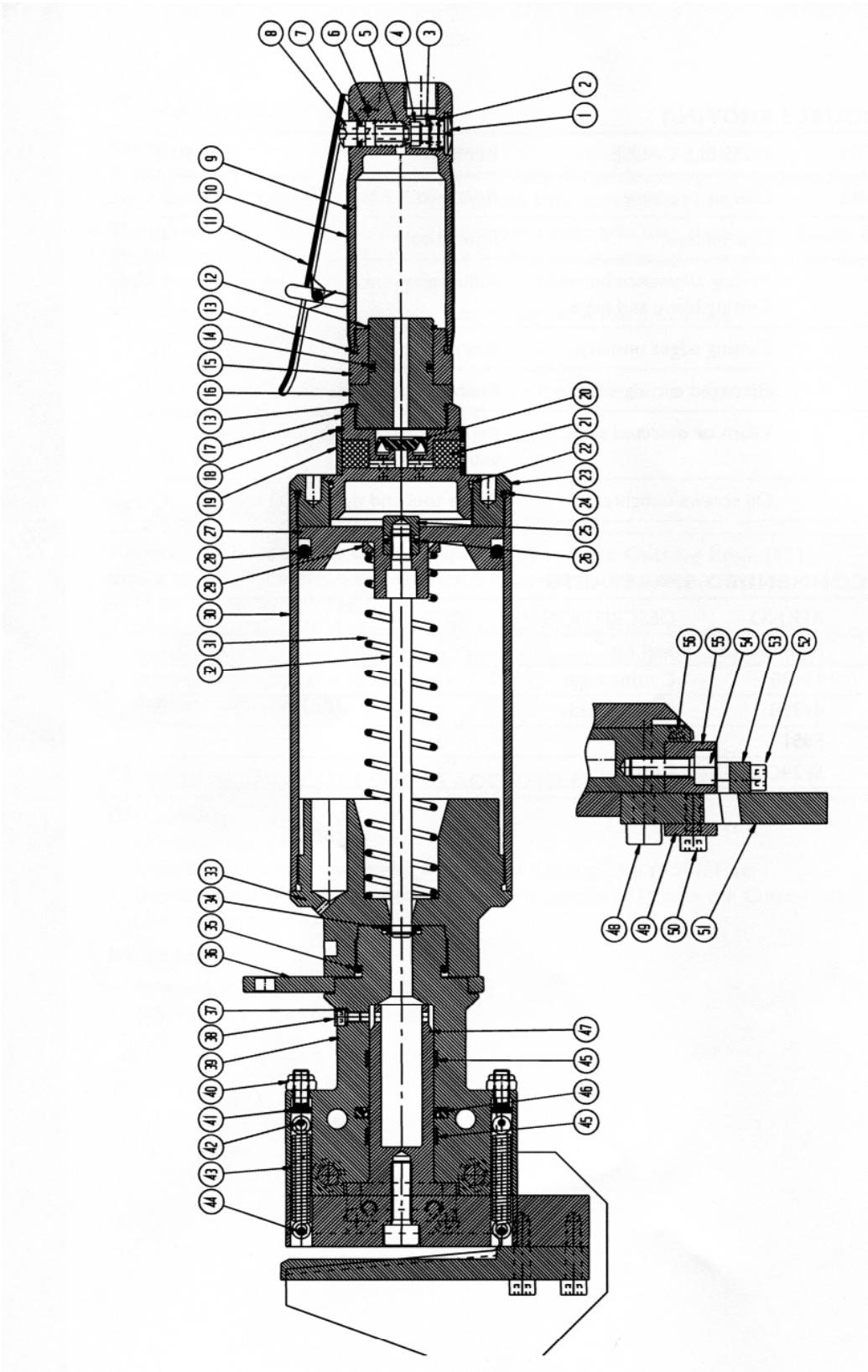
- Assembly in reverse order of dismantling.
- Adjustment of allowance, see above.

TROUBLE SHOOTING

SYMPTOM	POSSIBLE CAUSE	REMEDY	PAGE
Do not cut	Low air pressure	Adjust to 5-7 bar / 75-100 Psi	2
	Low oil level	Prime tool	4
	Wrong allowance between Cutting Blade and Edge	Adjust allowance	4
	Cutting Edges unsharp	Sharpening	4
	Damage Cutting Edges	Replace Cutting Blade and Edge	4
Leaks oil	Worn or defected seals	Replace seals and prime tool	4
	Oil screws untighten	Prime tool and tighten oil screws	4

RECOMMENDED SPARE PARTS

POSITION	ART. NO.	DESCRIPTION	QTY.
	P-TA13-725	Seal kit	1
55	12138	Cutting edge	1
51	4439B	Cutting edge	1
43	5851	Spring	2
31	5828C	Spring	1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SPARE PART LIST - TA13-725

NO.	QTY	DESCRIPTION	PART-NO.
1	1	Plug	1334
2	1	O-Ring	6315
3	1	Spring	1336
4	1	Valve	1337
5	1	Spring	1339
6	1	Pin	5404
7	1	O-Ring	6320
8	1	Valve stem	2362A
9	1	Handle	2358
10	1	Plastic cover	2361
11	1	Safety lever	3236
12	1	Locking ring	5632
13	2	O-Ring	6318
14	1	O-Ring	6351
15	1	Sleeve	10658
16	1	Adapter	10657
17	1	Housing	2925
18	1	Locking ring	5324
19	1	Air direction sleeve	2927
20	1	Membrane	2785
21	2	Silencer	1869
22	1	O-Ring	6319
23	1	Rear housing	3784S
24	1	O-Ring	6381
25	1	Nut	4196
26	1	O-Ring	6324
27	1	Air piston	4199
28	1	O-Ring	6386
29	1	Washer	4804
30	1	Air cylinder	4846-157

NO.	QTY	DESCRIPTION	PART-NO.
31	1	Spring	5828C
32	1	Piston stem	4221-133
33	1	Sleeve	12123
34	1	Seal	6560
35	1	O-Ring	6349
36	1	Suspension ring	10461
37	2	Seal	6514
38	2	Oil screw	5047
39	1	Hydr.-cylinder	12045
40	2	Nut	5201
41	2	Screw	4277
42	2	Pin	5439
43	2	Spring	5851
44	2	Pin	5511
45	2	Guiding ribbon	6041
46	1	Seal	6562
47	1	Piston	12079
48	2	Screw	5070-46
49	1	Support bar	4441
50	2	Screw	5007
51	1	Cutting blade	4439B
52	2	Screw	5078
53	1	Guard	12139
54	1	Screw	5076
55	1	Cutting edge	12138
56	2	Screw	5016
		Seal kit	P-TA13-523

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