

REX

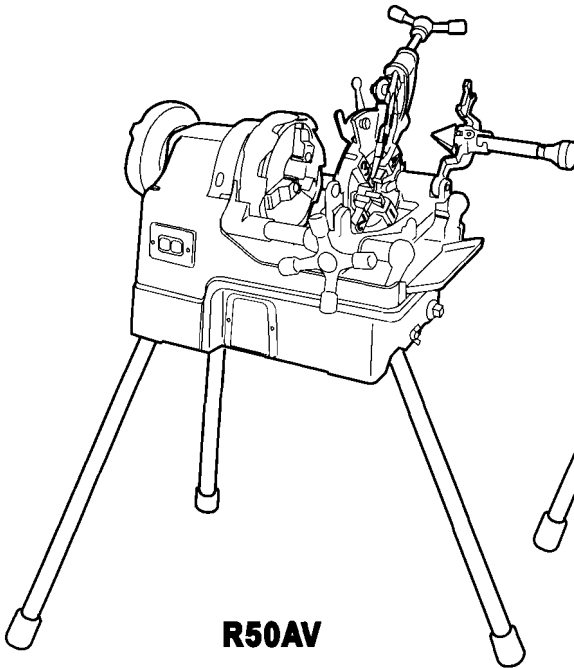
PIPE MACHINE

R50AV / No.7090

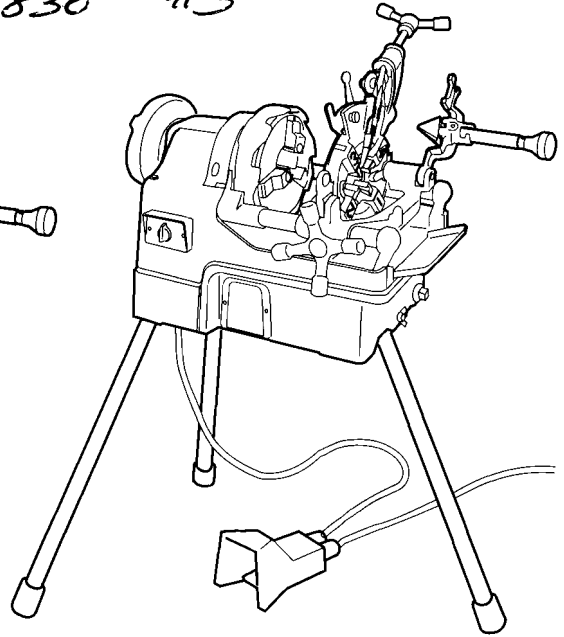
WHEELER REX

OPERATION MANUAL

SN# 041830 #3



R50AV



No.7090



Be sure to read this
Instruction Manual before
using the machine

- Request -

- Be sure to hand this instruction manual to the user.
- Carefully read through this instruction manual before using the machine, to ensure safe and effective use of the machine.
- Be sure to keep this instruction manual where the operator can read it whenever necessary.

Purchasing date:

Year

Month

Sales agent:

4. Working preparation

■ Setting the pipe

1. Open both chucks wider than the size of the pipe to be cut and insert the pipe from the rear chuck side where possible.
2. Close the rear chuck and, holding the pipe in your right hand, close the hammer chuck to grip the pipe. Jerk the hand-wheel sharply towards you to lock.
3. A sharp jerk in the opposite direction will release the pipe after cutting has been completed.

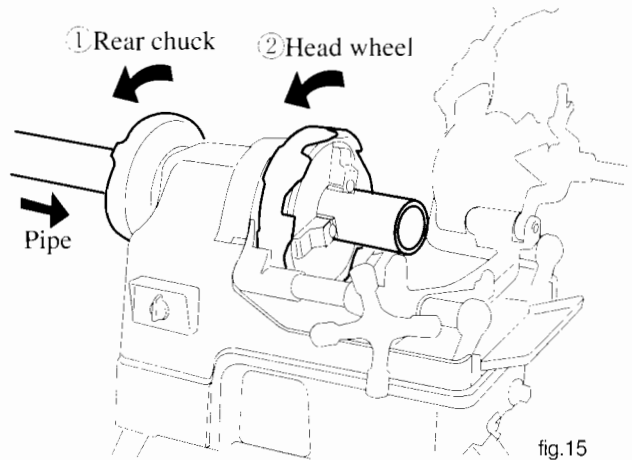


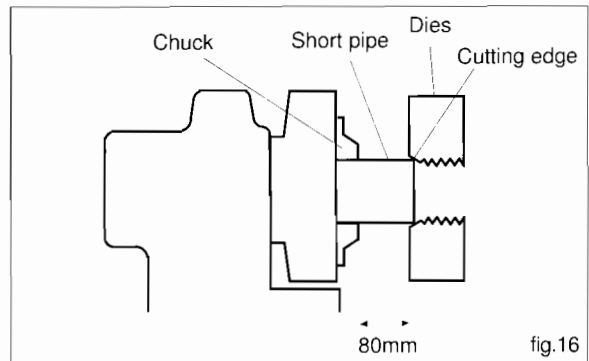
fig.15

■ Hints for Short-pipes

Setting a short pipe (which does not reach the rear chuck).

With the hammer chuck slightly loose, move the pipe into contact with the dies as shown in the diagram.

This will help hold the pipe on center while the hammer chuck is tightened. In this way a smooth taper cut is ensured every time.

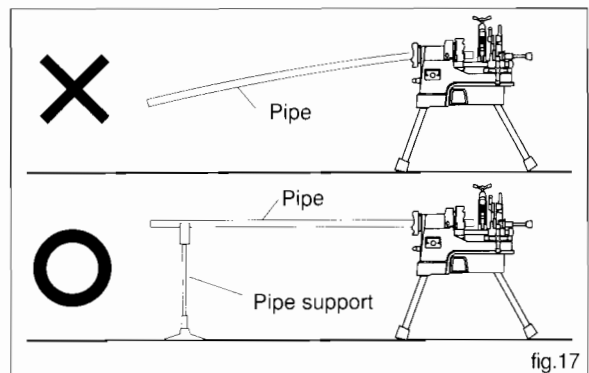


■ Long-pipe

In case of long size pipes.

In case of threading long size pipes, use the pipe support to prevent vibration during rotating due to warping or instability of the machine due to material weight.

If the pipe support is not provided, threading can not be made correctly, or the machine is troubled, causing accidents and injuries.



4. Working preparation

■ Switch, Pipe cutting, Reaming

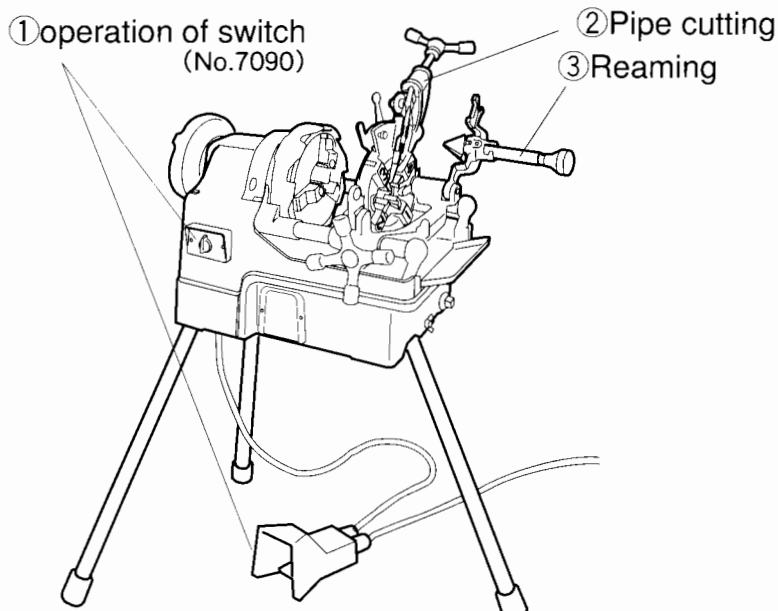


fig.18

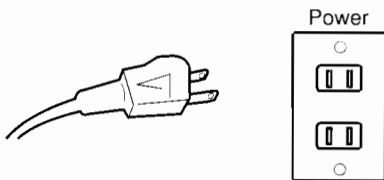


fig.19

Power supply

Before using, check the voltage on the nameplate. Use only an AC power supply and always ground the machine before use. If an extension cord is used, it must be as short as possible and of sufficient capacity for the power supplied.

⚠ CAUTION

Before connecting the plug socket, check that the machine switch is turned OFF, to prevent abrupt moving, causing injuries and accidents.

For No.7090 only

① Operation of switch

Both forward and reverse are operated by switch. Cutting oil is supplied for both directions.

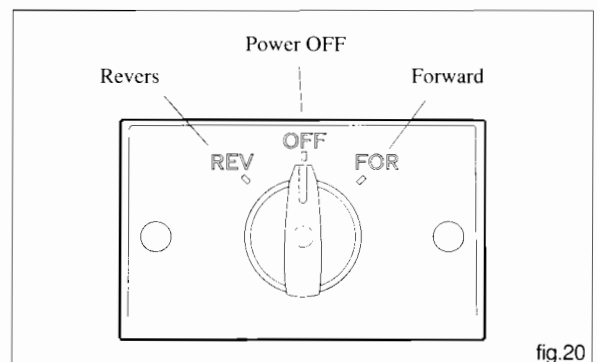


fig.20

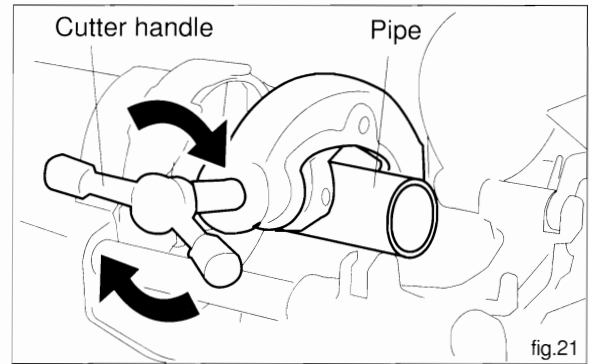
4. Working preparation

② Pipe cutting

1. Raise the die head and reamer out of the way and set the pipe at the length to be cut.
2. Open the pipe cutter wider than the diameter of the pipe and lower it into position.
3. Tighten by turning the handle to the right until the cutter wheel firmly engages the pipe, (see diagram 21), start the machine, and turn the handle 1/4 of a revolution for each revolution of the pipe being cut until the pipe is completely cut.

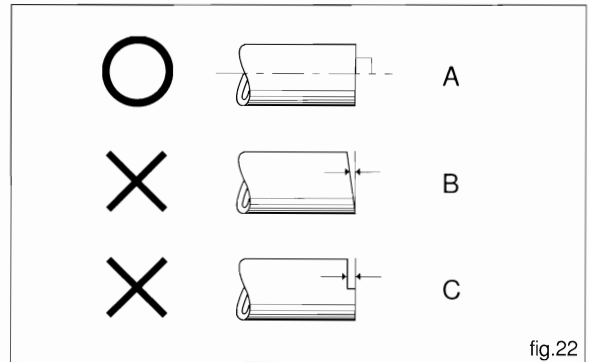
Warning:

If the cutter handle is turned too violently, when the cutter wheel cuts into pipe, it can distort the shape of the pipe.



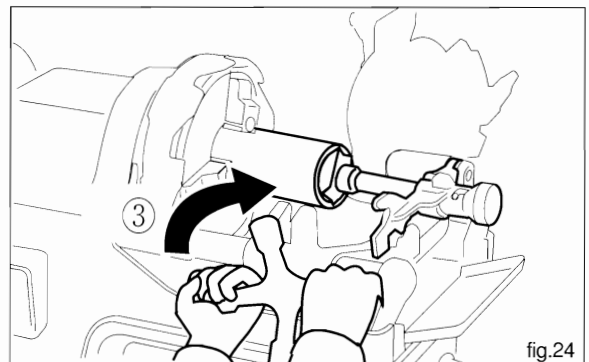
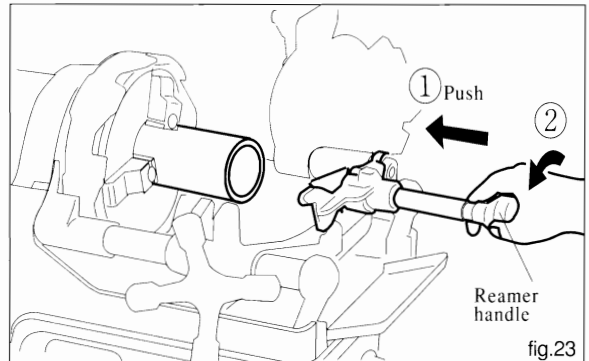
■ Special Cut Grinder Precautions

We strongly recommend that only the pipe cutter attached to the machine be used to cut pipes that are to be threaded. If a grinder is used, make sure that the cut face is square and without steps as in diagram 22.



③ Reaming

1. When cutting is complete, raise the cutter out of the way. Lower reamer arm and push the reamer handle toward the pipe.
2. Long-chucked pipe can sometimes be reamed with the reamer handle in the recessed position.
3. Lock the reamer in position by turning the reamer handle anti-clockwise.
4. Start the machine and turn the carriage handle to the right to advance the reamer.
5. When reaming is complete turn off the machine, retract the reamer handle and raise the reamer arm into the rest position.



4. Working preparation

■ Threading Instructions

(Self-opening die head)

Push the cam-plate up and set the auto-open pin in position. As the dies travel along the pipe, the end of the pipe comes into contact with and pushes the pin out of its groove to release the dies.

■ Setting the Thread Size

Loosen the lever nut and set the index line to the desired thread size and tighten firmly.

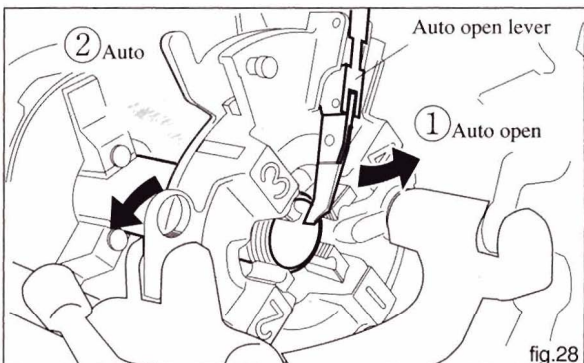
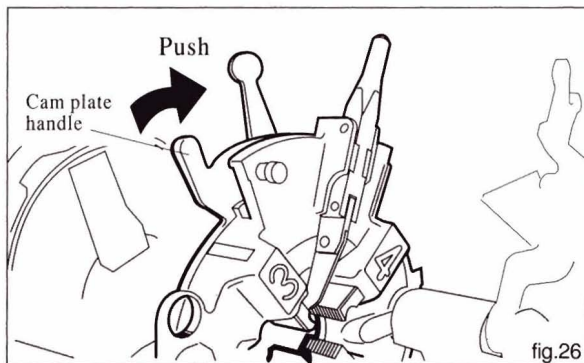
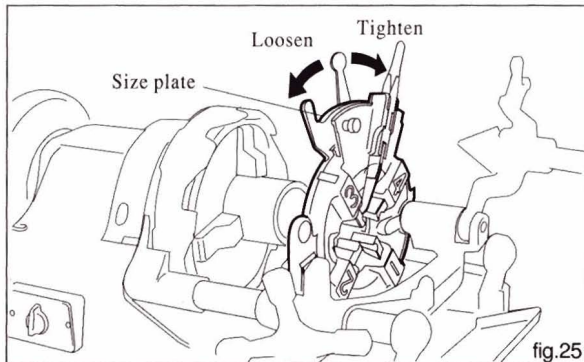
1. Fit the appropriate die head as shown in the fig.25.

2. Push the cam plate handle forward to set the auto-open lever then set the thread size by fitting the lever nut to the appropriate position.

3. Switch on the machine and the thread cutting oil will automatically flow out from the die head.

4. Turn the carriage handle clockwise until the dies have engaged the pipe for 3 or 4 threads. From this point the carriage handle may be released. A standard taper thread will then be cut automatically.

5. Once threading has been completed, switch OFF, and turn the carriage handle to the left. Retract the die head from the pipe.



4. Working preparation

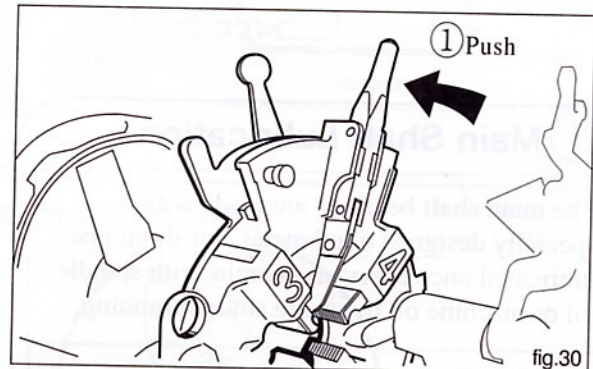
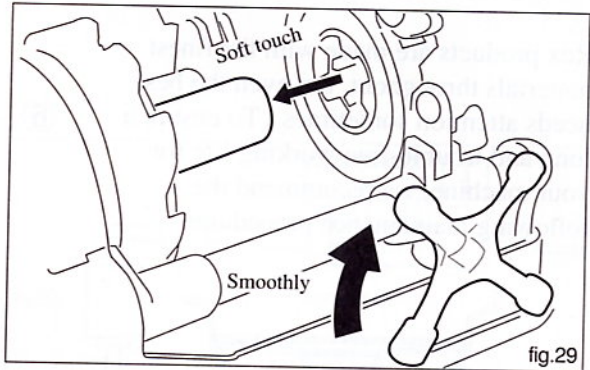
■ Precautions for Threading

1. As the dies come into contact with the pipe, the lever should be turned with gradually increasing strength until the dies are biting firmly. After the dies fully engage the pipe they will travel smoothly by themselves, but optimum cutting will be assured if the lever is turned with slight pressure to keep pace with die movement.

⚠ CAUTION

If the machine suddenly stops during threading, turn off immediately (a delay will result in the motor burning up).

2. To stop threading, turn the auto-open lever to the left.



■ Adjustment of the Threading Length

A device for adjustment of the threading length is attached. Use this for making threads of the desired length as follows.

Adjustable capacity 1-2" (3 threads)
1/2-3/4" (4 threads)

■ Method of Adjustment

1. Loosen the socket head cap screw on the auto-open lever (C).
2. Move the auto-open lever to the right for longer threads or to the left for shorter threads as indicated by the arrows in the diagram.
3. Retighten the socket head cap screw.

