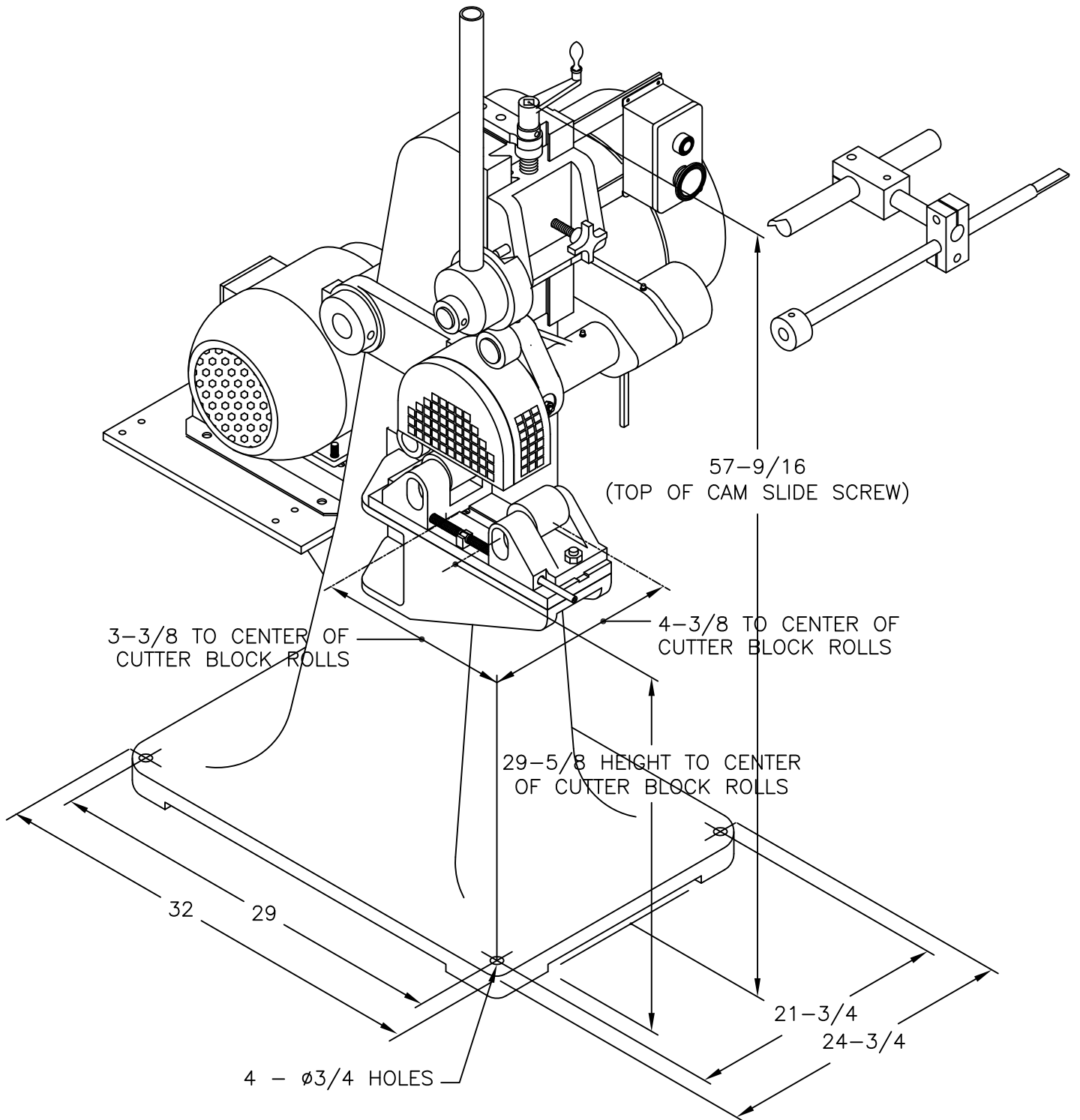


CONTINENTAL MODEL 6H
PIPE AND TUBE CUT-OFF MACHINE
SERIAL NO. _____
INSTRUCTION AND PARTS MANUAL

**CONTINENTAL MODEL 6H
PIPE AND TUBE CUT-OFF MACHINE
INSTRUCTION AND PARTS MANUAL**

TABLE OF CONTENTS	SECTION
SAFETY INSTRUCTIONS	A
INSTALLATION	B
OPERATION	C
CUT-OFF BLADE NOTES	D
MAINTENANCE	E
WIRING DIAGRAM	F
PARTS ILLUSTRATIONS	G
WARRANTY	



CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

OVERALL DIMENSIONS
 MODEL 6H CUT-OFF MACHINE

CURRENT REVISION: B DATE: 2/21/14 DRAWING NUMBER: MODEL 6H OVERALL DIMENSIONS

SECTION A. SAFETY INSTRUCTIONS

1. Read and understand this manual before operating this machine.
2. NEVER operate this machine with any guard or cover open or removed.
3. Provide a fused, switched disconnect for incoming power line in accordance with the National Electrical Code.
4. If starter box cover is removed, high voltage connections are exposed. Customer supplied disconnect switch should be turned off and locked off, before removing starter box cover.
5. This machine is powered by high voltage electricity. Electrical repairs should be made by a qualified electrician.
6. NEVER reach into the work area of the machine while the cuttershaft is turning.
7. This machine will cut a wide range of tubing diameters and lengths. Each customer's layout, method of supporting the tubing, and material flow into and out of the machine is different. As such, it is impossible for the manufacturer to provide a universal guard to keep operator's hands out of the machine. It is the customer's responsibility to:
 - provide a method to catch and collect cut pieces.
 - provide guards to prevent the operator from accidentally placing hands in the cutting area.
 - install guards along the tube being cut to prevent injury.
8. Movement of various parts may create pinch points. Operator must avoid these points.
9. NEVER wear loose clothing or jewelry that could become entangled in the machine or workpiece.
10. When changing a cut-off blade, turn off power at the customer supplied disconnect switch.
11. Be certain to remove wrench after replacing cut-off blade. NEVER leave wrench hanging from the cuttershaft.
12. NEVER push pipe or tube into the cutting area from the front of the machine. A turning cut-off blade may catch and throw it possibly causing personnel injury and equipment damage. ALWAYS slide the tube into the cutting area from the cut-off blade side of the machine.
13. ALWAYS feed pipe or tube into the cutting area from the cut-off blade side of the machine. Feeding material from the opposite side can result in the operator's hand being pinched between the pipe or tube and the underside of the Cutter Arm as the cut is being made.
14. NEVER attempt to cut material that is bent, twisted, or otherwise distorted.
15. The cutting operation may produce sharp edges and considerable heat. NEVER attempt to catch work pieces as they are cut. Take precautions when handling cut pieces.

SECTION B. INSTALLATION

DIMENSIONS

Drawing 6H-D, MODEL 6H DIMENSIONS, shows the overall dimensions of the machine.

LEVELING

Place the machine in the desired location. Transfer the mounting holes in the base to the floor. Then, move the machine and drill the floor for anchor bolts. Place the machine back into position, and check the cutterblock mounting surface for level, particularly in the side-to-side direction. Shim the base as necessary to level and eliminate any rocking. After shimming, bolt the machine securely to the floor.

ELECTRICAL

The electrical characteristics of the machine are stamped on a nameplate attached to the starter box. Connect the incoming lines from a disconnect switch (customer supplied) to the L1, L2, L3 terminals on the motor starter located in the control box. Check to make sure that rotation of the cuttershaft is clockwise when viewed from the cut-off blade side. This will prevent pipe from being thrown out of the machine. If rotation is incorrect, reverse any two of the incoming lines.

CUTTERBLOCKS

Cutterblocks are available for tube sizes within the range of the Model 6A (see current Continental Catalog). Select the appropriate cutterblock for the tube size to be cut, and bolt it to the cutterblock bracket on the machine. Note that slots are provided on the cutterblock base for front-to-back adjustment.

The cutterblock must be set perpendicular to the cut-off blade or "threading" will occur. Threading is a condition where the tube moves sideways as the cut-off blade contacts it. To correct threading, loosen the front cutterblock bolt slightly, then tap the cutterblock to move it in the opposite direction of the threading. (If tube is threading to the right, move the front of the cutterblock to the left and vice versa); then, retighten the cutterblock bolt. Repeat until threading is eliminated.

TUBE SUPPORTS

If a Model 425 or 426 Tube Support Table is to be used with this machine, it should be assembled and installed according to the instructions provided with it.

If pipe supports are to be used, they must be carefully aligned with the machine, and bolted to the floor. First, set the supports in place. They should be spaced so that the tube to be cut does not sag between the supports. NOTE: If short pieces are to be cut, place one of the supports close to the machine. Place a length of tube or barstock in the supports and the cutterblock rolls. Adjust the supports so that the tube is touching the entire length of both cutterblock rolls (front and back), and all pipe support rolls.

At this point, the pipe supports should be bolted to the floor. Carefully mark the center of each hole in the pipe support bases. Then, drill and bolt to floor using 3/8" lag bolts with anchors.

Rotate the Pipe Support Heads so they are perpendicular to the tube (rolls will be aligned with tube). If the heads are not perpendicular to the tube, threading of the tube can result, particularly if polyurethane coated pipe support rolls are used.

Recheck alignment of pipe supports with the cutterblock rolls. Misalignment may result in cut-off blade breakage, tube threading and poor cuts.

MODEL 444 STANDARD LENGTH GAUGE

Assemble as follows, referring to the appropriate drawings in the PARTS ILLUSTRATIONS section:

Slide the 5515 Gauge Rod into the 1-1/2" bores in the column. Place the 5458 Shaft Collar on the end of the Gauge Rod on the Cut-Off Blade side of the column and tighten set screw. Spread a light coat of grease on the boss on each side of column.

Slide the 5100 Gauge Lever onto the Gauge Bar on the opposite side of the column. Press the 5458 Collar and the 5100 Gauge Lever lightly against the column and tighten the clamp bolt on the 5100 Gauge Lever. There should be no end play in the Gauge Rod.

Attach 5715 Spring at rear of Gauge Lever to 5444 Gauge Lever Spring Pin on column. Install 5425 Gauge Lever Bar and Roller in front of gauge lever.

Assemble 5485 Gauge Support (back), 5372 Gauge Bracket Bar, 5439 Gauge Support (front), and 5354 Gauge Pin with 5516 Pipe Stop. Slide this assembly onto the 5515 Gauge Bar.

NOTE: The 5354 Gauge Pin may be set up with the round pipe stop facing the cutterblocks, or for short cut-off lengths, the narrow blade-shaped end may face the cutterblocks and fit between the cutterblock rolls.

Adjust the length gauge for a particular pipe size and length as follows:

- Set up the cut-off operation itself as described under the OPERATION section.
- Adjust the Gauge Assembly so that the pipe stop is set at the desired length and catches the edge of the tube.
- Adjust the 5425 Gauge Lever Bar and Roller so that the underside of the cut-off arm contacts it and pushes the gauge assembly out of the way just after the cut-off blade engages the tube. This prevents the tube from moving as the length gauge clears the work.

SECTION C. OPERATION

CAUTION:

1. **BEFORE ATTEMPTING TO OPERATE THE MODEL 6H, READ AND UNDERSTAND THIS SECTION COMPLETELY.**
2. **DO NOT ALLOW THE CUT-OFF BLADE TO CONTACT THE CUTTERBLOCK ROLLS. THIS WILL RESULT IN IMMEDIATE DAMAGE TO THE BLADE AND ROLLS.**

Follow the steps below to set-up and operate the Model 6H for the various size pipe and tubes to be cut.

1. Install the appropriate cut-off blade for the tube to be cut. See current Continental Catalog for a description of cut-off blade models. Remove the 5723 Cuttershaft Nut and 5306 Clamp Collar and place the cut-off blade on the Cuttershaft. Replace the Clamp Collar and Nut and tighten. Seat the nut securely by tapping the end of the wrench with a mallet.
2. Select the appropriate Cutterblock for the tubing size to be cut. See the current Continental Catalog for a list of Cutterblocks.
3. Mount the Cutterblock on the machine. Roughly center it in the slots provided, and align with the cut-off blade. Adjust the spacing of the cutterblock rolls so that an angle of approximately 90 degrees is formed by lines from the center of the tube to the center of each roll.
4. Place a length of the tube to be cut in the Cutterblock Rolls and the Pipe Support or Support Table Rolls. Adjust the Pipe Supports or Support Table vertically to align with the Cutterblock Rolls. It may be necessary at this point to slide the Cutterblock forward or backward slightly to achieve this alignment. The Cutterblock must remain aligned with the cut-off blade.
5. Loosen the 5300 Camslide Set Screw and position the 5190 Camslide so that the cut-off blade is about 1/2" above the tube. Tighten camslide set screw.

NOTE: DO NOT ALLOW THE CUT-OFF BLADE TO CONTACT THE CUTTERBLOCK ROLLS. THIS WILL RESULT IN IMMEDIATE DAMAGE TO THE BLADE AND ROLLS.

- .6. Place the material to be cut in the machine and run trial cuts. Adjust as required. Although the characteristics of the cutting process will vary significantly with tube size, wall thickness and particularly material, the following will generally apply:
 - A faster cut will reduce the O.D. burr, and a slower cut will reduce the I.D. burr.
 - Spreading the rolls apart will reduce the O.D. burr; moving them closer together will reduce the I.D. burr.
 - Generally the best cut is the fastest cut that will produce the desired end conditions. A fast cut produces less heat and less wear on the blade.
 - See the CUT-OFF BLADE NOTES section for additional information concerning the cutting process.

CAUTION: NEVER PUSH PIPE OR TUBE INTO THE CUTTING AREA FROM THE FRONT OF THE MACHINE. THE CUT-OFF BLADE CAN CATCH AND THROW THE MATERIAL, CAUSING PERSONAL INJURY AND EQUIPMENT DAMAGE. ALWAYS SLIDE THE MATERIAL INTO THE CUTTING AREA FROM THE CUT-OFF BLADE SIDE OF THE MACHINE.

CAUTION: ALWAYS FEED PIPE OR TUBE INTO THE CUTTING AREA FROM THE CUT-OFF BLADE SIDE OF THE MACHINE. FEEDING MATERIAL FROM THE OPPOSITE SIDE CAN RESULT IN THE OPERATOR'S HAND BEING PINCHED BETWEEN THE PIPE OR TUBE AND THE UNDERSIDE OF THE CUTTER ARM AS THE CUT IS BEING MADE.

7. Adjust the Model 444 Standard Length Gauge as described in the INSTALLATION Section. To make production cuts with the Standard Length Gauge, hold the tubing firmly against the Pipe Stop while pulling the Cam Lever Handle down. Hold the tube against the stop until the blade engages the cut.
8. Lock all adjustments so that they do not change during production.

CUT-OFF BLADE NOTES

Continental Cut-Off Blades are available for almost all tube sizes and wall thicknesses. These blades are manufactured from S-7 Tool Steel. They are held to precise tolerances and heat treated to provide a long life. They may be resharpened using one of the Continental Grinders (see current catalog), or sent to Continental Pipe & Tube Cut-Off Machines for resharpening. With proper care, Continental Cut-Off Blades will provide thousands of cuts.

Following is a checklist of circumstances that can result in shortened blade life. Review this list when blade life is shorter than expected, or when unsatisfactory cutting action is encountered.

1. Make certain correct blade model is being used. Check current Continental Catalog for applications.
2. #5723 Nut must be tightened securely to make certain the Cut-Off Blade is clamped flat and cannot slip.
3. Make certain that the blade does not touch the cutter block rolls at the end of the stroke. This will immediately damage both the blade and the rolls.
4. Check alignment of the tubing in the pipe supports and cutter block roll (see OPERATION Section). This alignment is critical for smooth cuts and long blade life.
5. Make certain that the tube spins freely on the supports. Any drag or binding can cause the Cut-off Blade to slip against the pipe as it cuts.
6. Check adjustment of the Length Gauge to make certain it clears the tube shortly after the Cut-Off Blade engages the cut. As the cut is made, the end of the tube is actually moved towards the Length Gauge. If the gauge has not cleared the end of the tube it will cause binding.
7. On air powered machines, check to be sure the Hydrocheck engages BEFORE the Cut-Off Blade contacts the tube.
8. Make sure that the tubing is not striking the side of the Cut-Off Blade as it is advanced into position.
9. On tough or heavy wall material, a lubricating oil may be required to assist the cut. Use LUBRICATING oil, NOT cutting oil.
10. Do not attempt to cut excessively bent, twisted or otherwise distorted material.
11. Tubing material can vary significantly, even within one lot. Hard areas may be encountered, which can shorten blade life.
12. If material is long (over 20 ft.) or very heavy, the Cut-Off Blade may have difficulty spinning it. This will cause the blade to slip, shortening blade life.
13. During resharpening, the edge of the blade must not become overheated. This will cause the edge to soften.

14. After resharpening, the edge of the blade should be honed with a stone (available as Continental Part No. #5959) to remove the sharp edge, and provide a rounded edge. The sharper the edge the more fragile it is.

NOTE:

- A. If a sharper edge is left on the blade (less honing), the blade will cut faster and with less pressure, but will not last as long between resharpenings. This is more appropriate for thin-walled, softer, materials.
 - B. If a more blunt edge is left on the blade (more honing), the blade will require more pressure to cut, but will last longer between resharpenings. This is more appropriate for heavier walled, tougher materials.
15. If a Cut-Off Blade becomes dull or nicked during use, remove it immediately and have it resharpened. If it is left in service, the damage will become worse. In a relatively short time, the blade will be ruined.

FIG. 1 — RECOMMENDED CUT-OFF BLADE BEVELS

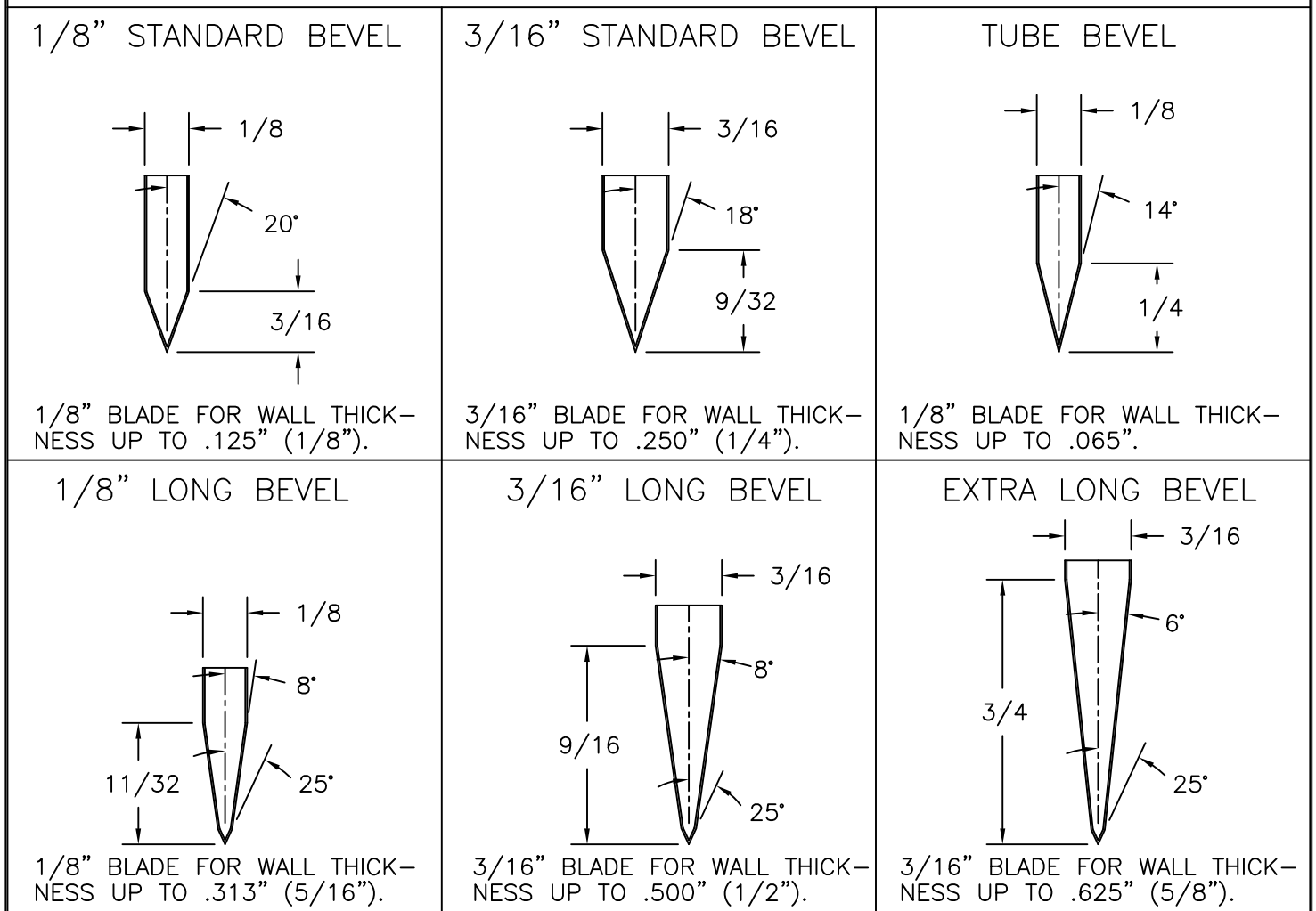


FIG. 2 — CONTINENTAL CUT-OFF BLADE MODELS

MODEL NO.	BORE (IN.)	THICKNESS (IN.)	DIA. (IN.)	BEVEL (SEE FIG. 1)	REMARKS
7170	1-7/16	1/8	7	STD.	FOR USE ON CONTINENTAL MODEL 2B, 2A, 3H, 3A, 6H, & 6A. NO PIN HOLES OR KEYWAYS.
7171	1-7/16	1/8	7	TUBE	
7172	1-7/16	1/8	7	LONG	
7370	1-7/16	3/16	7	STD.	
7372	1-7/16	3/16	7	LONG	
7373	1-7/16	3/16	7	EXTRA LONG	
7120	1-1/2	1/8	7	STD.	ONE (1) 13/32 DIA. PIN HOLE ON 1-1/8" RADIUS.
7121	1-1/2	1/8	7	TUBE	
7122	1-1/2	1/8	7	LONG	
7320	1-1/2	3/16	7	STD.	
7322	1-1/2	3/16	7	LONG	
7140	1-3/4	1/8	7	STD.	TWO (2) 13/32 DIA. PIN HOLES, ONE (1) ON 1-13/32" RADIUS, ONE (1) ON 1-29/64" RADIUS.
7340	1-3/4	3/16	7	STD.	
7342	1-3/4	3/16	7	LONG	
8140	1-3/4	1/8	8	STD.	
8340	1-3/4	3/16	8	STD.	

SECTION E. MAINTENANCE

This machine is completely adjusted and lubricated at the factory. Performing the following maintenance checks will assure trouble-free operation and a long service life. Use an N.L.G.I. #2 Lithium based, Extreme Pressure (EP) grease where indicated:

DAILY CHECKS

1. Lubricate Cutterblock Roll bearings. Use #2 EP grease.

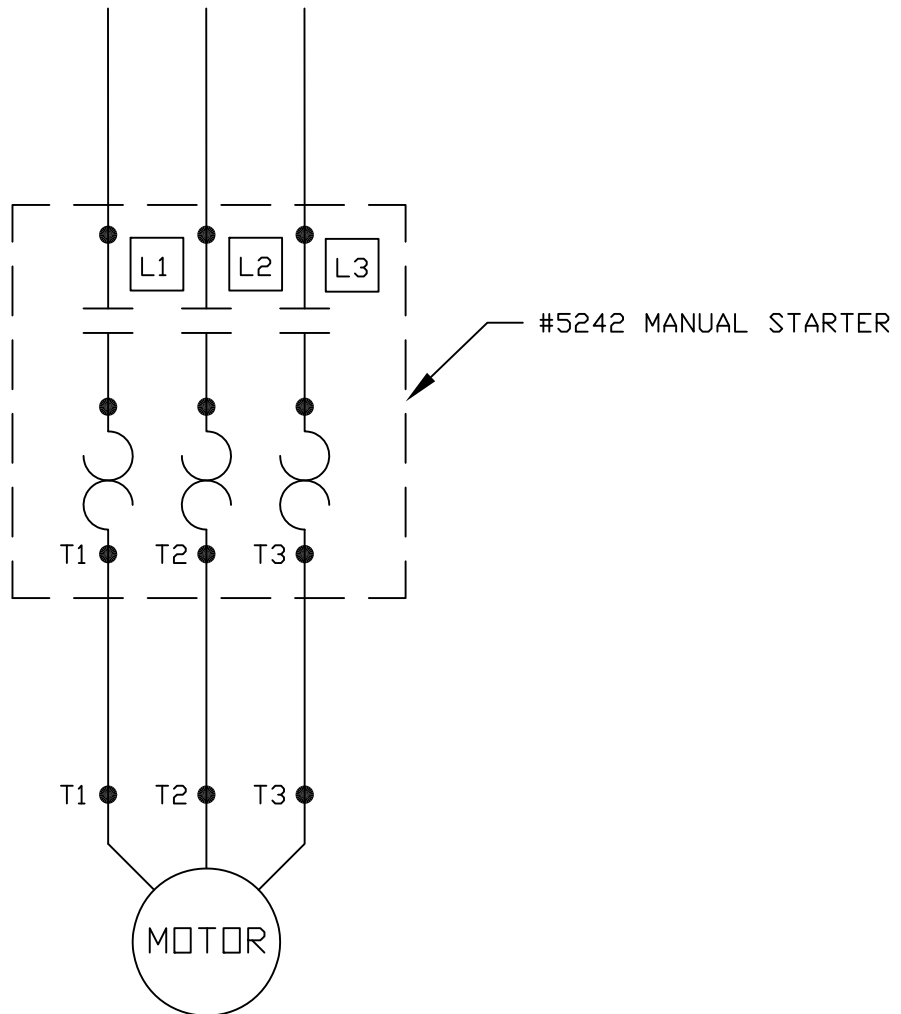
WEEKLY CHECKS

1. Lubricate front and rear Cutter Arm Bearings. Seven grease fittings are provided on the cutter arm. One (1) grease fitting is located at the back of the machine column. Use #2 EP grease.
2. Lubricate 5403 Cam Roll. A grease fitting is provided in the 5355 Cam Roll Stud.
3. If equipped with Model 444 Standard Length Gauge, lubricate both pivot points for the 5515 Gauge Rod. Two grease fittings are provided, one on each side of the column. Use #2 EP grease.

6 MONTH CHECKS

1. Check drive belts for wear and tightness. Adjust accordingly. All belts should be tightened evenly.

SECTION F
WIRING DIAGRAM



CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

SCHMATIC WIRING DIAGRAM
 MODEL 3H AND 6H CUT-OFF MACHINES

CURRENT REVISION: *	FILE NAME: 4028	DRAWING NUMBER: 4028
---------------------	-----------------	----------------------

SECTION G

PARTS ILLUSTRATIONS

BILL OF MATERIALS

ITEM	PART NO.	DESCRIPTION	QTY.
2	5140	COLUMN	1
3	5190	CAM SLIDE	1
4	5124	COUNTERWEIGHT PULLEY	1
5	5147	COUNTERWEIGHT	1
6	5144	CUTTERBLOCK BRACKET	1
7	5128	MOTOR BRACKET	1
8	5281	V-BELT GUARD & COVER	1
9	5300	CAM SLIDE SET SCREW	1
10	5356	CAM SLIDE ADJ. SCR. & COLLAR	1
11	5407	CAM SLIDE GIB	1
12	5412	SLIDE SCREW PLATE	1
13	5411	COUNTERWEIGHT PULLEY SHAFT	1
14	201-64279	3/8-16 X 1-1/2 LG. HHCS, GR. 5	1
15	5451	PUSH BUTTON BOX BRACKET	2
17	5465	CAM BRACKET SCREW COLLAR	1
18	5549	COUNTERWT. CABLE & CONNECTOR	1
19	5702*	WRENCH - CUTTERSHAFT NUT	1
20	5705	#4 HANDLE	1
21	5715	SPRING	1
22	5724	GIB SCREW	2
23	6304	FEED OILER	1
24	5146 (2)	CAM	1
25	5404 (2)	CAM SHAFT	1
26	5704 (2)	CAM LEVER HANDLE	1
29	6305	OILER HOSE & FITTINGS	1
30	5922	OILER BRACKET	1
31	5986 (1)	BLADE GUARD ASSY.	1
32	5990 (3)	CAM	1
33	5991 (3)	CAM SHAFT	1
34	5987 (3)	CAM LEVER HANDLE	1
35	5355	CAM ROLL STUD	1
36	5403	CAM ROLL	1
37	5409	CAM STOP	1
38	5458	CAM COLLAR	1
39	5242	MANUAL STARTER	1
40	5868	GREASE FITTING, STRAIGHT	1
41	5875	TAG, ELECTRICAL CHARACTERISTICS	1
42	5880	TAG, DANGER	1
43	5877	TAG, CAUTION	1
44	5961	NAMEPLATE, SERIAL NUMBER	1

(*) ITEM NOT ILLUSTRATED.

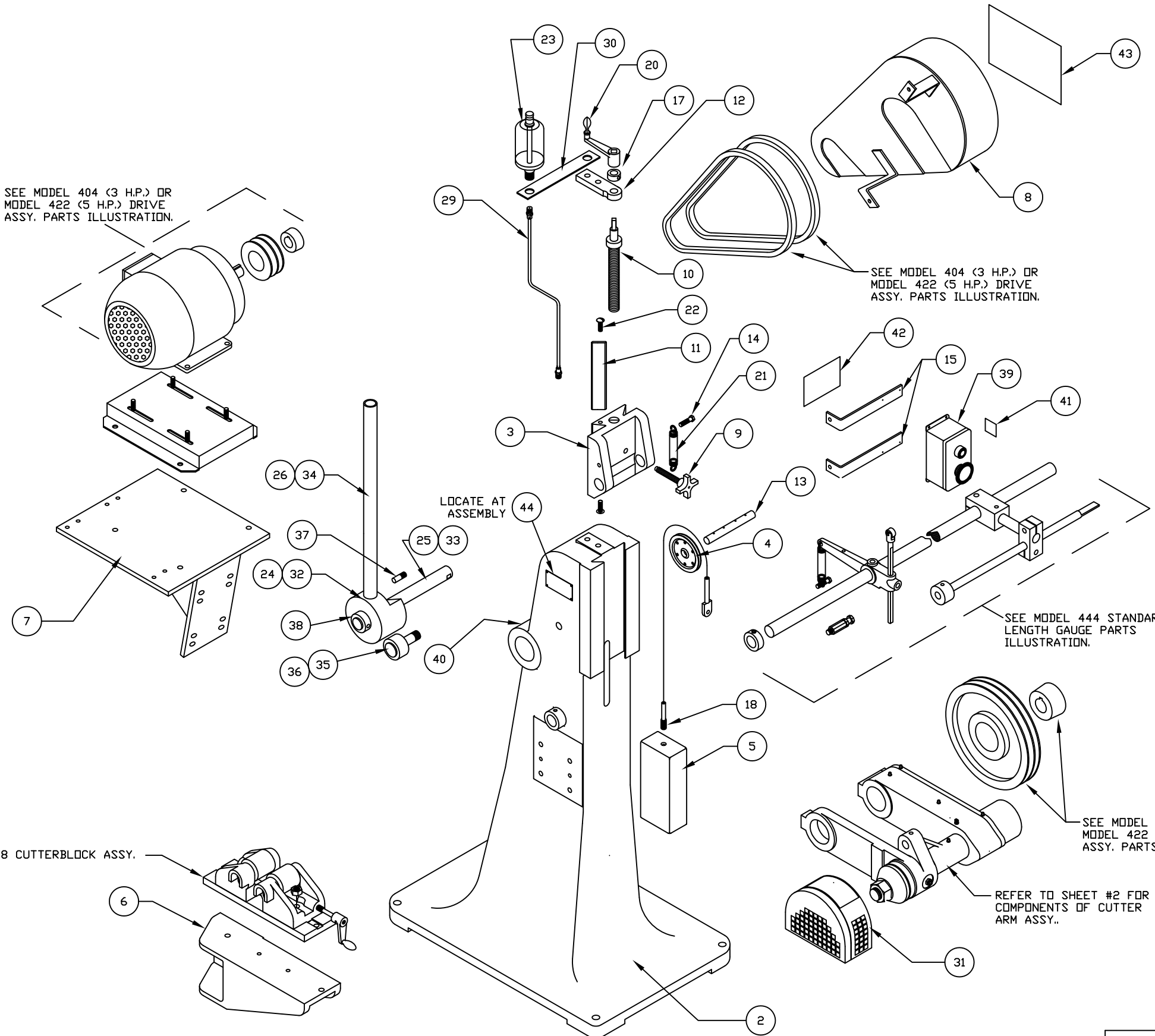
SEE MODEL 404 (3 H.P.) OR MODEL 422 (5 H.P.) DRIVE ASSY. PARTS ILLUSTRATION.

SEE MODEL 404 (3 H.P.) OR MODEL 422 (5 H.P.) DRIVE ASSY. PARTS ILLUSTRATION.

SEE MODEL 444 STANDARD LENGTH GAUGE PARTS ILLUSTRATION.

SEE MODEL 404 (3 H.P.) OR MODEL 422 (5 H.P.) DRIVE ASSY. PARTS ILLUSTRATION.

REFER TO SHEET #2 FOR COMPONENTS OF CUTTER ARM ASSY..



MODEL 468 CUTTERBLOCK ASSY.

LOCATE AT ASSEMBLY

NOTE APPLICATION:
 (1) FIRST USED ON MACHINE WITH S/N 6X-61710.
 (2) USED ON MACHINES BEFORE S/N 6X-61724.
 (3) FIRST USED ON MACHINE WITH S/N 6X-61724.

CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

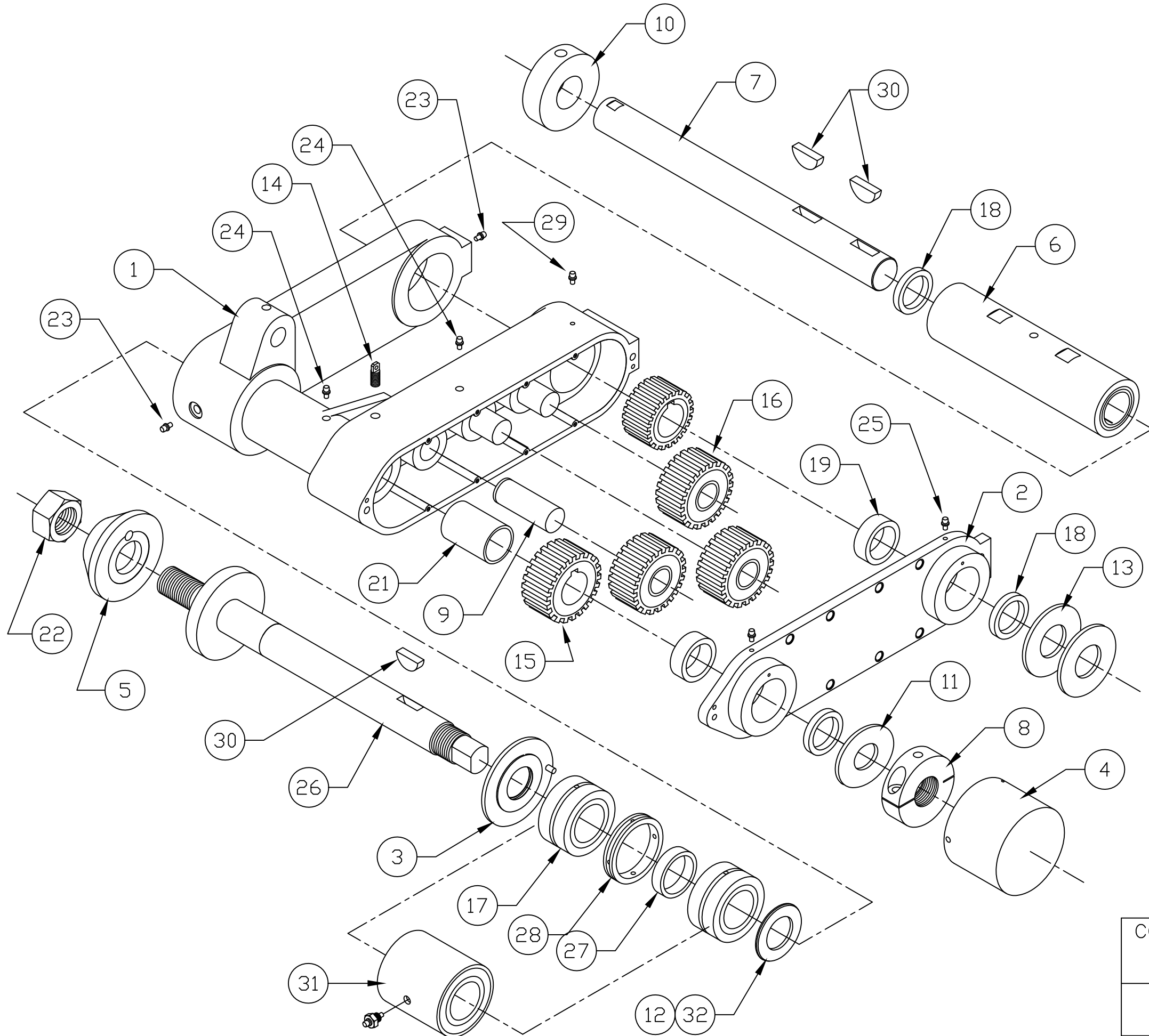
PARTS ILLUSTRATION
 MODEL 6H, SHEET 1 OF 2

CURRENT REVISION: F FILE NAME: PI6H-1 DRAWING NUMBER: PI6H - SHT 1

BILL OF MATERIALS

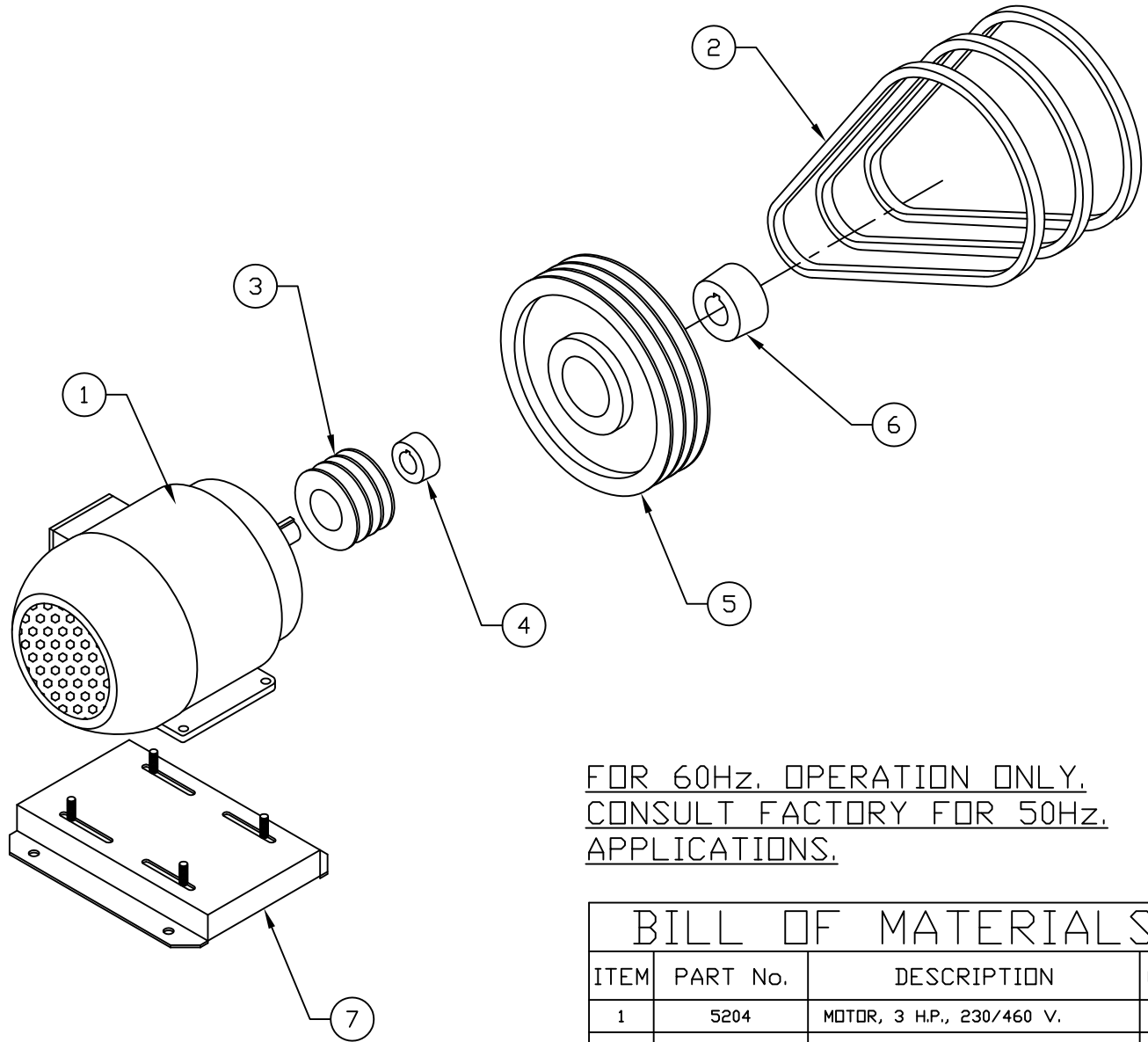
ITEM	PART NO.	DESCRIPTION	QTY.
1	5142	CUTTER ARM	1
2	5143	GEAR CASE COVER	1
3	5151	CUTTERSHAFT THRUST WASHER	1
4	5293	SPLIT COLLAR GUARD	1
5	5306	CUTTERSHAFT CLAMP COLLAR	1
6	5320	DRIVE SHAFT SLEEVE	1
7	5324	DRIVE SHAFT	1
8	5321	CUTTERSHAFT SPLIT COLLAR	1
9	5336	IDLER GEAR STUD	3
10	5388	DRIVE SHAFT COLLAR	1
11	5434	THRUST WASHER	1
*	12	5589 (2) NEEDLE BEARING WASHER	1
13	5528	SHEAVE SPACER	2
14	5542	SPRING SCREW	1
15	5603	DRIVE GEAR	2
16	5604A	IDLER GEAR ASSY.	3
*	17	5588 (2) NEEDLE BEARING	2
18	5612	GREASE SEAL	3
19	5647	GEAR CASE COVER BUSHING	2
21	5648	CUTTERSHAFT BUSHING	1
22	5723	HEX CUTTERSHAFT NUT	1
23	5868	GREASE FITTING, STRAIGHT	2
24	5855	GREASE FITTING, STRAIGHT, RELIEF	2
25	300-01129	GREASE FITTING, DRIVE	2
26		CUTTERSHAFT - SEE BELOW	1
	5285	CUTTERSHAFT (1-7/16 DIA.)	
	5323	CUTTERSHAFT (1-1/2 DIA.)	
	6000	CUTTERSHAFT (1-3/4 DIA.)	
*	27	5586 (2) INNER SPACER, CUTTERSHAFT BRG.	1
*	28	5587 (2) OUTER SPACER, CUTTERSHAFT BRG.	1
29	5869	GREASE FITTING, ANGLE	1
30	5873	WOODRUFF KEY	3
*	31	5617 (1) REPLACEMENT CUTTERSHAFT BRG ASSY	1
*	32	5400 (1) NEEDLE BEARING WASHER	1

* NOTE APPLICATION:
 (1) USED ON MACHINES BEFORE SERIAL NUMBER 6A-61494.
 (2) USED ON MACHINES BEGINNING WITH SERIAL NUMBER 6A-61494 AND LATER.



CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 6H - SHEET 2 OF 2



FOR 60Hz. OPERATION ONLY.
 CONSULT FACTORY FOR 50Hz.
 APPLICATIONS.

BILL OF MATERIALS

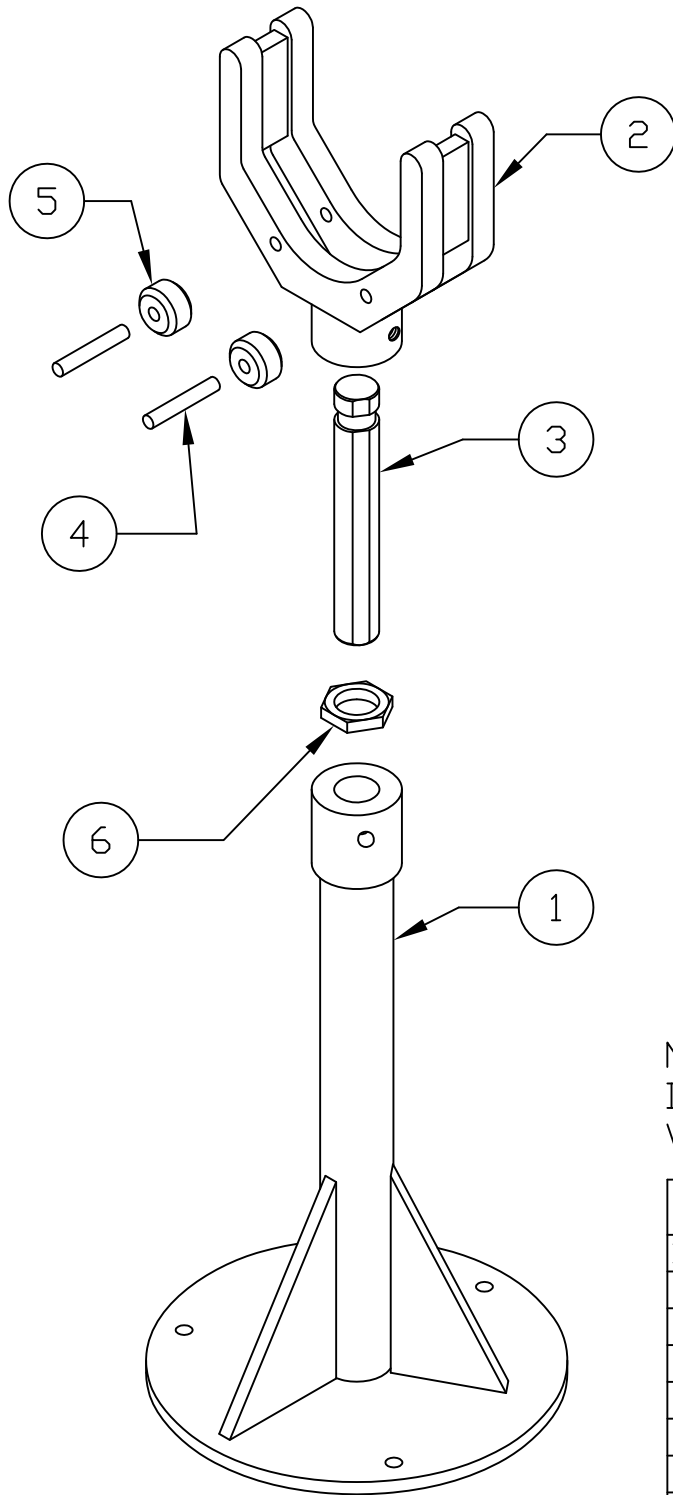
ITEM	PART No.	DESCRIPTION	QTY.
1	5204	MOTOR, 3 H.P., 230/460 V.	1
2	5744	V-BELT	3
3	5751	SHEAVE (MOTOR)	1
4	5752	BUSHING, TAPERLOCK (MOTOR)	1
5	5753	SHEAVE (DRIVE SHAFT)	1
6	5754	BUSHING, TAPERLOCK (DRIVE SFT.)	1
7	5204-1	MOTOR SLIDE BASE	1
8	5993	THERMAL OVERLOAD RELAY	3

NOT SHOWN

CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 404, 3 HP DRIVE ASSEMBLY

CURRENT REVISION: C FILE NAME: PI404 DRAWING NUMBER: PI 404



NOTE: ITEMS MARKED (*) ARE NOT ILLUSTRATED; ITEMS ARE INCLUDED WITH PIPE SUPPORT.

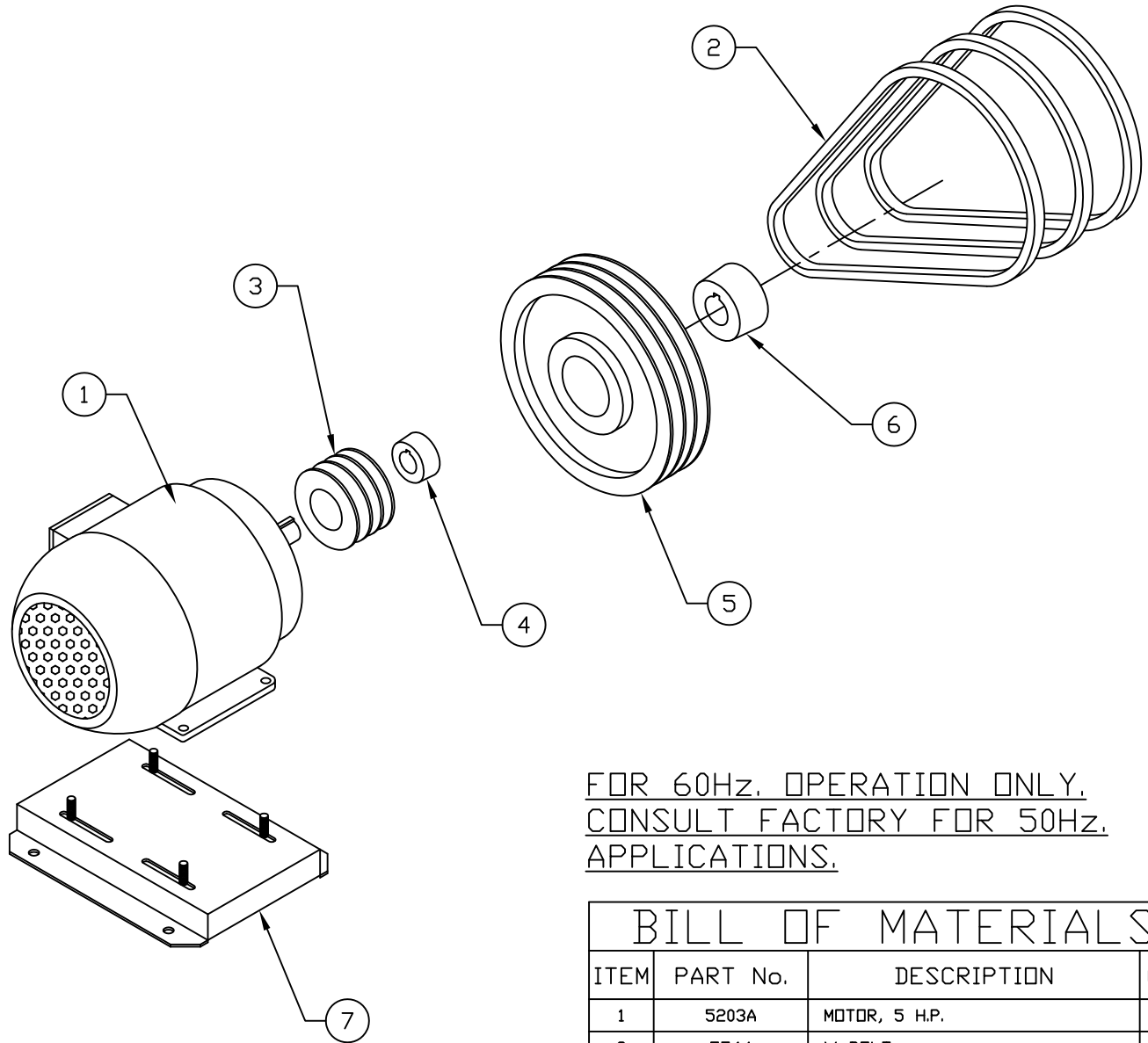
BILL OF MATERIALS

ITEM	PART NO.	DESCRIPTION	QTY.
1	5103	SUPPORT STAND	1
2	5149	PIPE SUPPORT FORK	1
3	5340	PIPE SUPPORT STUD	1
4	5382	PIPE SUPPORT ROLL PIN	2
5	5379	PIPE SUPPORT ROLL	2
6	5845	HEX JAM NUT	1
*	7	201-64418 1/2-13 X 1 1/4 HEX HD CAP SCREW	1
*	8	201-64532 5/8-11 X 1" HEX HD CAP SCREW	1

CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 415 PIPE SUPPORT

CURRENT REVISION: A FILE NAME: PI415 DRAWING NUMBER: PI 415



FOR 60Hz. OPERATION ONLY.
CONSULT FACTORY FOR 50Hz.
APPLICATIONS.

BILL OF MATERIALS

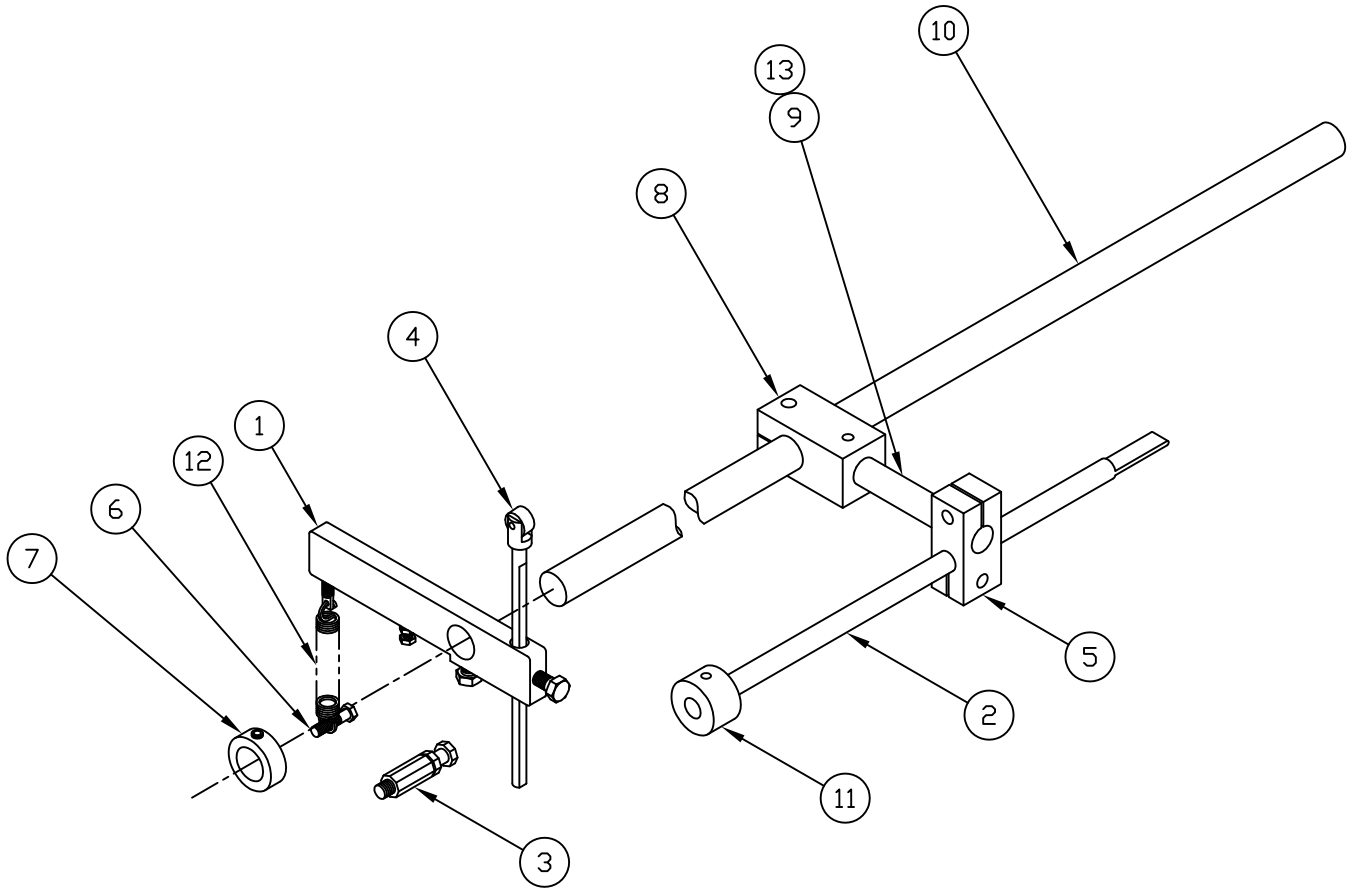
ITEM	PART No.	DESCRIPTION	QTY.
1	5203A	MOTOR, 5 H.P.	1
2	5744	V-BELT	3
3	5751	SHEAVE (MOTOR)	1
4	5752	BUSHING, TAPERLOCK (MOTOR)	1
5	5753	SHEAVE (DRIVE SHAFT)	1
6	5754	BUSHING, TAPERLOCK (DRIVE SFT.)	1
7	5203-1	MOTOR SLIDE BASE	1
8	5993	THERMAL OVERLOAD RELAY	3

NOT SHOWN

CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 422, 5 HP DRIVE ASSEMBLY

CURRENT REVISION: C FILE NAME: PI422 DRAWING NUMBER: PI 422



NOTES:

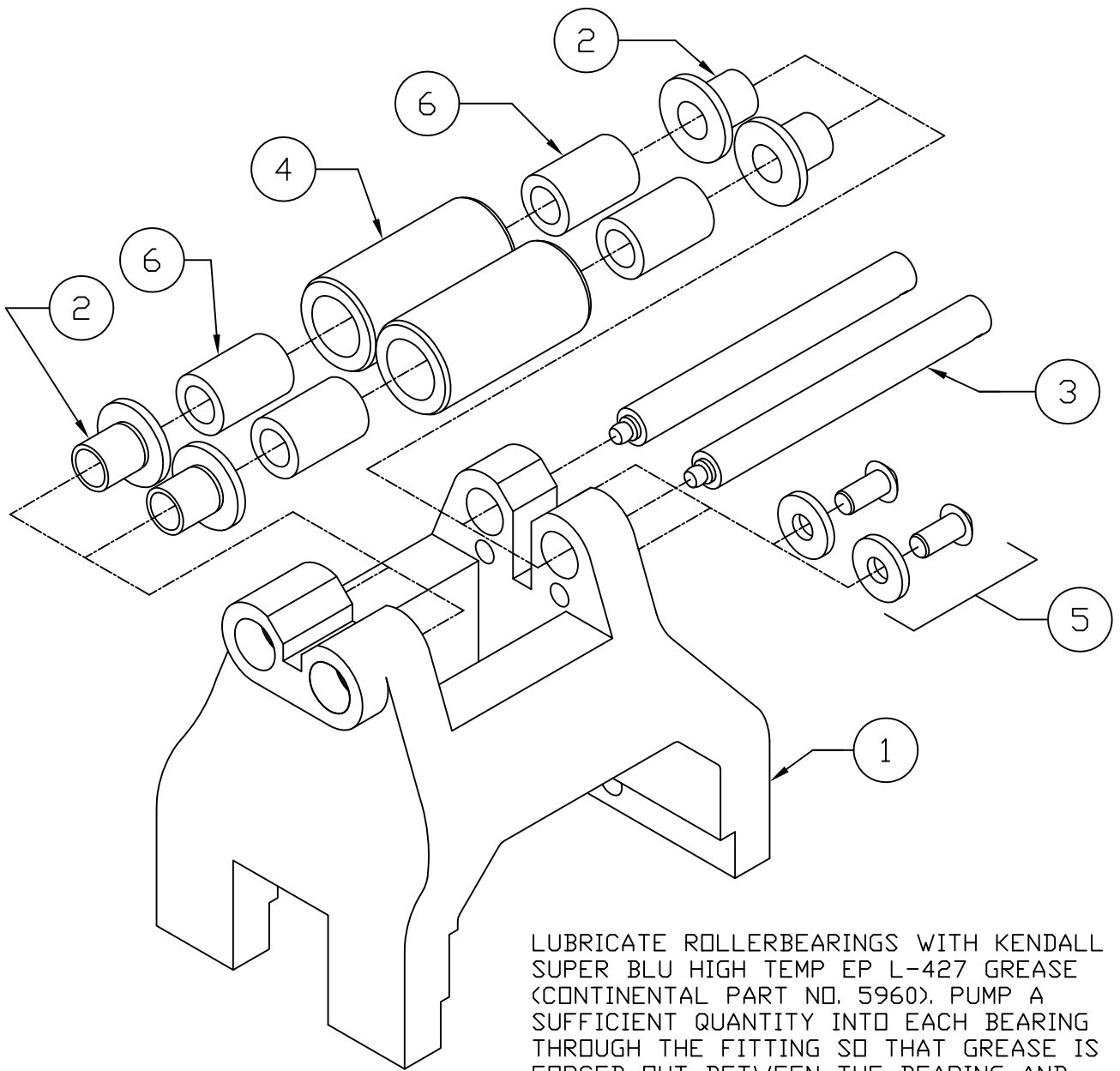
1. ITEM 9 IS A COMPONENT OF THE MODEL 443 LENGTH GAUGE ASSEMBLY.
2. ITEM 13 IS A COMPONENT OF THE MODEL 444 LENGTH GAUGE ASSEMBLY.
3. INSTALL GREASE FITTINGS, ITEM 14 IN THE MACHINE COLUMN.

BILL OF MATERIALS			
ITEM	PART NO.	DESCRIPTION	QTY.
1	5100	GAUGE LEVER	1
2	5354	GAUGE PIN	1
3	5410	GAUGE LEVER STOP	1
4	5425	GAUGE LEVER BAR, PIN & ROLL	1
5	5439	GAUGE SUPPORT, FRONT	1
6	5444	GAUGE LEVER PIN	1
7	5458	GAUGE ROD COLLAR	1
8	5485	GAUGE SUPPORT, BACK	1
9	5508	GAUGE BRACKET BAR	1
10	5515	GAUGE ROD	1
11	5516	HARDENED PIPE STOP	1
12	5715	SPRING	1
13	5372	GAUGE BRACKET BAR	1
14	5869	1/8NPT 65° GREASE FITTING, NO RELIEF	2
	NOT SHOWN		

CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 443 & 444 STANDARD LENGTH GAUGE ASSEMBLY

CURRENT REVISION: D FILE NAME: PI443-44 DRAWING NUMBER: PI 443/444



LUBRICATE ROLLERBEARINGS WITH KENDALL SUPER BLU HIGH TEMP EP L-427 GREASE (CONTINENTAL PART NO. 5960). PUMP A SUFFICIENT QUANTITY INTO EACH BEARING THROUGH THE FITTING SO THAT GREASE IS FORCED OUT BETWEEN THE BEARING AND CUTTER BLOCK ROLL. REMOVE EXCESS GREASE.

NOTE:

- 1. THIS CUTTERBLOCK ASSEMBLY IS FOR USE WITH A MODEL 467 OR 468 CUTTERBLOCK ASSEMBLY.
- 2. ITEMS MARKED (*) ARE NOT ILLUSTRATED. ITEMS ARE INCLUDED WITH ASSEMBLY.

BILL OF MATERIALS			
ITEM	PART NO.	DESCRIPTION	QTY.
1	5148	STATIONARY CUTTER BLOCK	1
2	5313	CUTTER BLOCK ROLL PIN BUSHING	4
3	5314	CUTTER BLOCK ROLL PIN	2
4	5315	CUTTER BLOCK ROLL	2
5	5361	CUTTER BLOCK PIN CLAMP SCREW	2
6	5615	CUTTER BLOCK ROLLERBEARING	4
*	7	201-64275 3/8-16 X 3/4 HEX HD CAP SCREW	1

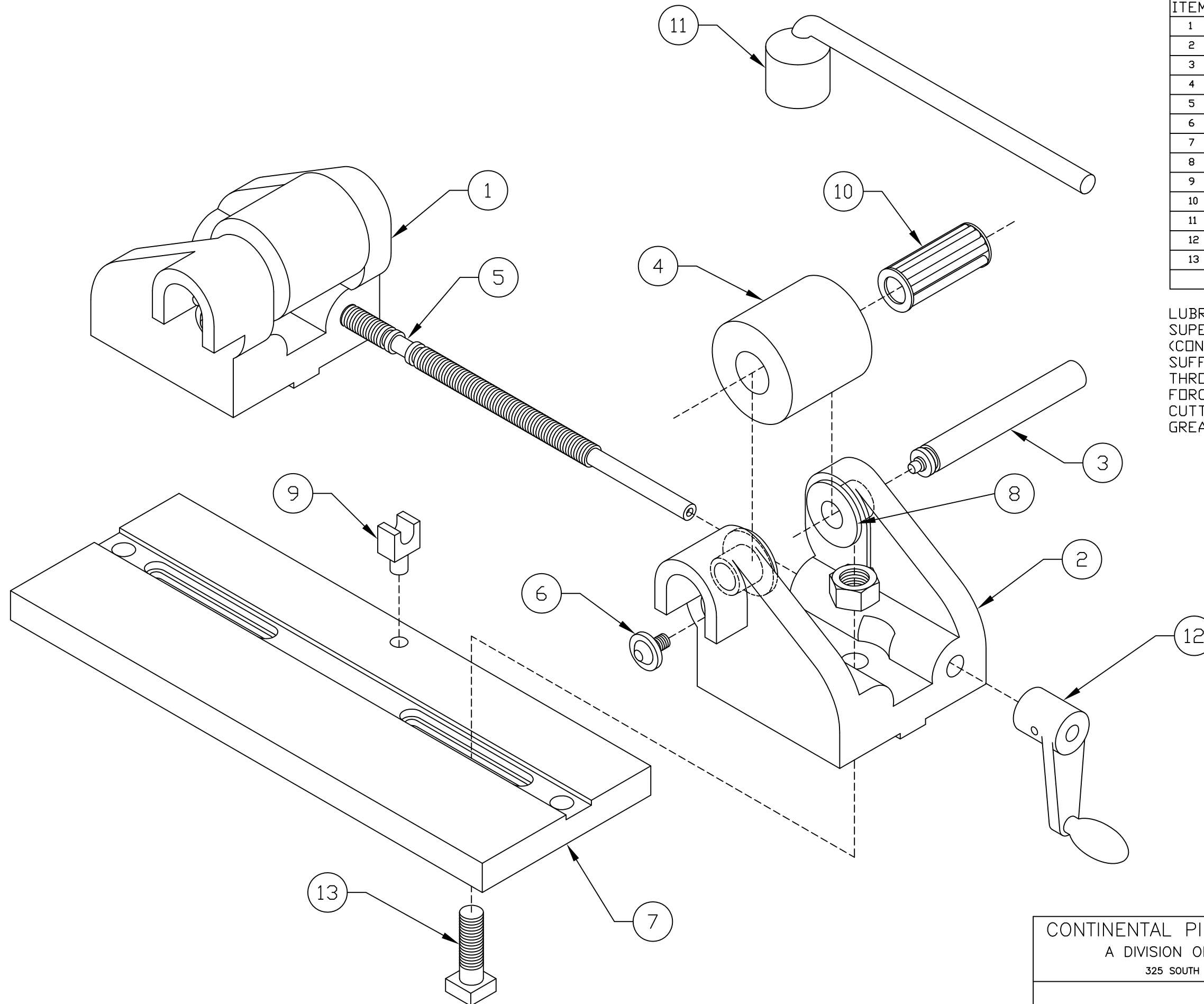
CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 465 CUTTERBLOCK ASSEMBLY

BILL OF MATERIALS

ITEM	PART NO.	DESCRIPTION	QTY.
1	5141-L	CUTTER BLOCK, LH	1
2	5141-R	CUTTER BLOCK, RH	1
3	5304	CUTTER BLOCK ROLL PIN	2
4	5305	CUTTER BLOCK ROLL	2
5	5301	CUTTER BLOCK ADJUSTING SCR	1
6	5302	CUTTER BLOCK PIN CLAMP SCR	2
7	5406	CUTTER BLOCK BASE PLATE	1
8	5303	CUTTER BLOCK ROLL PIN BUSHING	4
9	5459	ADJUSTING SCR STUD	1
10	5618	CUTTER BLOCK ROLLER BEARING	2
11	5707	CUTTER BLOCK WRENCH	1
12	5706	HANDLE, #2	1
13	5759	SQ HD BOLT & HVY HEX NUT	2

LUBRICATE ROLLERBEARINGS WITH KENDALL SUPER BLU HIGH TEMP EP L-427 GREASE (CONTINENTAL PART NO. 5960). PUMP A SUFFICIENT QUANTITY INTO EACH BEARING THROUGH THE FITTING SO THAT GREASE IS FORCED OUT BETWEEN THE BEARING AND CUTTER BLOCK ROLL. REMOVE EXCESS GREASE.



CONTINENTAL PIPE & TUBE CUT-OFF MACHINES
 A DIVISION OF KIENE DIESEL ACCESSORIES, INC.
 325 SOUTH FAIRBANK STREET - ADDISON, ILLINOIS 60101

PARTS ILLUSTRATION
 MODEL 468 CUTTERBLOCK ASSEMBLY

CURRENT REVISION: A FILE NAME: PI468 DRAWING NUMBER: PI 468

WARRANTY

The equipment delivered hereunder is guaranteed to be free from defective material and workmanship for a period of six (6) months from date of delivery, when given normal and proper usage, and when used by the original purchaser.

Notice of any claimed defect must be given to seller within thirty (30) days after discovery of any claimed defect. During warranty period, seller's obligation shall be limited to delivering to the buyer, F.O.B. seller's plant, replacements of any equipment or parts, or repairing such equipment or parts, found defective by inspection.

Any article not of seller's manufacture included in this proposal is sold under such warranty only as the makers give us, and we are able to enforce, but it is not guaranteed by seller in any way. No equipment or material shall be returned to seller except on our specific instructions and no claim will be honored unless we have been given an opportunity for inspection on site and in the claimed defective condition. The determination of seller's representative will be final. Seller assumes no responsibility for reimbursing repair or replacement costs incurred without our prior written authorization, or prior to a determination of seller's authorized representative. Seller assumes no liability for the cost of installation of repaired or replacement parts. All costs of packing and shipping defective parts and/or replacement of repaired parts shall be paid by buyer. In no event shall our liability under this warranty exceed the purchase price paid for the products.

THE WARRANTY STATED HEREIN IS IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SELLER SHALL HAVE NO LIABILITY WHATSOEVER IN ANY EVENT FOR PAYMENT OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, INCLUDING DAMAGES RESULTING IN PERSONAL INJURY.

Any action for breach of this warranty or other action under this contract must be commenced within one (1) year after such cause of action arises.