



Model 88 Chain and Cable Cutter Blade Insert Repair Kit

Parts Included in Kit:

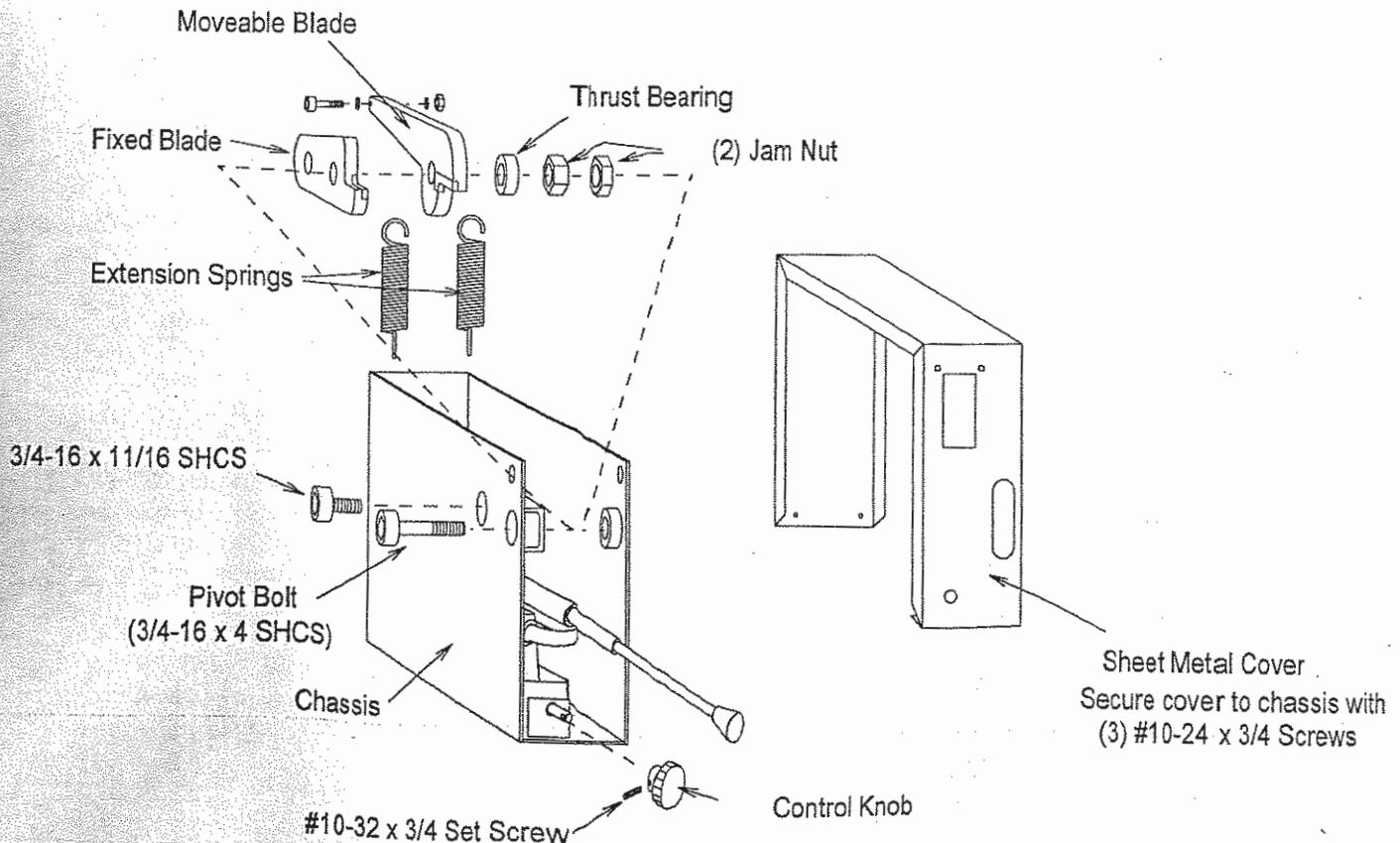
(2) Blade Inserts

(1) 4mm x 25mm Dowel Pin

(2) 3/16" x 5/8" Roll Pins

(1) 1/2 oz Tube of Grease

- 1.) Remove the small set screw securing the Control Knob to the shaft. Remove the knob.
 - 2.) Remove the (3) screws securing the Sheet Metal Cover. Remove the Sheet Metal Cover. The cover may not pass over the Pump Handle Knob. Extending the handle will provide sufficient clearance for your repairs.
- >>Do Not Remove the Pump Handle Knob if it is securely fastened to the Pump Handle<<
- 3.) With the cutter's blades in the Full Open position, grip the upper loops of the (2) Extension Springs with a pair of vise grip pliers and unhook them from back end of the Moveable Blade. To speed later reassembly, do not unhook the lower ends of these springs from the spring anchors in the Chassis base.
 - 4.) Loosen the Jam Nuts and remove the Pivot Bolt. Remove the Moveable Blade, Jam Nuts and Thrust Bearing from the Chassis.
 - 5.) Loosen and remove the bolt securing the Fixed Blade to the Chassis. Remove the Fixed Blade from the Chassis.



- 6.) Lay each blade on a flat surface. Using the 4mm pin as a punch, drive out the 3/16" Roll Pin securing the worn insert in the blade. Remove the worn insert and clean away any dirt or chips in the insert pocket. Fit a new insert into the pocket, carefully lining up the cross holes. Drive a new 3/16" Roll Pin into the cross hole from the insert side of the blade to secure the insert. The insert must be smooth and flush with the surface of the blade. Repeat this procedure with the other blade. These inserts should always be replaced in pairs.
- 7.) Coat the mating surfaces of both blades with the grease provided.
- 8.) Fit the Fixed Blade into the Chassis and thread the bolt several turns into the blade. Do not tighten this bolt until after the other blade is in place.
- 9.) Insert the Pivot Bolt through the Chassis, Fixed Blade, Moveable Blade, Thrust Bearing, (2) Jam Nuts, and into the opposite side of the Chassis. Thread the Pivot Bolt into the opposite side of the Chassis and tighten until the sides begin to bow inward slightly. Do not over tighten.
- 10.) Fit the top of the Hydraulic Piston into the round pocket in the edge of the Moveable Blade. Grip the upper loops of the (2) Extension Springs with a pair of vise grip pliers and hook them over the cross bolt at the back end of the Moveable Blade.
- 11.) Tighten the bolt securing the back edge of the Fixed Blade.

>> Important <<

The pressure between the blades is controlled by the tightness of the jam nuts. This adjustment is very critical. The Moveable Blade must return to the "Full Open" position easily but there must be sufficient pressure to cut cable cleanly without smearing the strands.

- 12.) Tighten the inner Jam Nut on the Pivot Bolt against the Moveable Blade as tightly as possible. Turn the Control Knob shaft clockwise to the "Cut" position. Pump the handle to raise the Moveable Blade until it stops at the "Full Cut and Bend" position. Turn the control shaft counterclockwise 2 turns to "Release" the Moveable Blade. The Moveable Blade must stop somewhere before the blades fully open.
- 13.) If the blade does not stop and opens completely to the "Full Open" position, tighten Jam Nut further and repeat step 12. The Jam Nut pressure must stop the Moveable Blade somewhere within the cut cycle with the Control Knob shaft "Released" (turned counter-clockwise). Slowly loosen the Jam Nut until the Moveable Blade returns smoothly to the bottom of its stroke. Test and repeat as needed to be certain that the Jam Nut and Pivot Bolt are as tight as possible, but still allow the blade to fully return every cycle.
- 14.) Tighten the outer Jam Nut against the other to lock the Pivot Bolt. Repeat a test cycle to be certain that the Pivot Bolt adjustment has not changed.
- 15.) Reinstall the sheet metal cover with (3) screws. Reinstall the Control knob on the shaft.

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