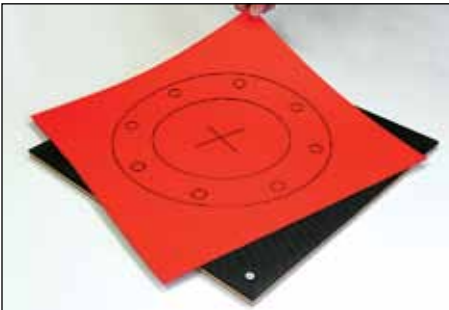


ALLPAX[®]

GASKET CUTTER SYSTEMS

MEDIUM & LIGHT DUTY GASKET CUTTER *GUIDE TO PERFECT GASKETS*

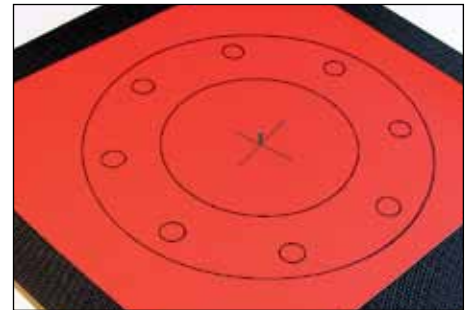
CUTTING GASKETS 1" TO 13" IN DIAMETER:



1. Lay out gasket outer diameter (OD), inner diameter (ID) and bolt holes on template or gasket material. *(For information on drawing bolt holes visit WWW.ALLPAXCORP.COM)*



2. Create a pilot hole by piercing center of the gasket with piercing tool.



3. Place center pin into pilot hole in gasket material. Use appropriate length center pin for thickness of material being cut. Insert protruding center pin into recessed ferrule in middle of cutting board.



4. Loosen thumb screw of cutter block and position cutting blade so it protrudes slightly beyond thickness of gasket material. Tighten thumb screw.



5. Loosen top nut and adjust pivot post to desired cutting diameter by matching pivot post indicator line with appropriate dimension of 0"-13" scale. Secure with top nut.



6. Position pivot post over center pin in gasket material ensuring cutter block is lying flat on gasket material.

CUTTING GASKETS 1" TO 13" IN DIAMETER: (continued)



7. With slight downward pressure on cutting block and material, rotate cutter block clockwise to make cut. For thicker or hard to cut materials, make several passes to make cut. Or cut half way through material, turn over and complete cut. On difficult materials (hard, soft, etc.) consider using Easy Cutting Lubricant.



8. Reset cutter block for bolt holes and cut, or use hole punches to create bolt holes.



9. Reset cutter block for inside diameter dimension.



10. Make inside diameter cut for finished gasket.

CUTTING GASKETS OVER 13" IN DIAMETER:



1. Remove pivot post assembly. Remove washer and install extension arm, thumb nut up.



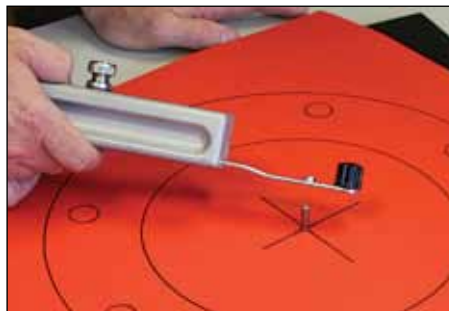
2. Reinstall pivot post assembly into cutter block. Place extension bar without stud in groove on bottom of cutter block with single, large hole in extension bar toward cutting blade.



3. Install additional Extension Bars as needed. Each extension bar adds 12" to capacity of block.



4. Use 0"-13" scale on cutter block. For example, to cut a 16" outside diameter gasket, add one Extension Bar. Match line through pivot post with the number "4" on scale. Secure with top nut.



5. Place sleeved hole in extension bar over center pin in gasket material ensuring cutter block is lying flat on material.



6. With slight downward pressure on cutter block and material, rotate cutter block clockwise to make cut. For thicker or hard to cut materials, make several passes to make cut. Or cut half way through material, turn over and complete cut.



7. Reset cutter block for bolt holes and cut, or use hole punches to create bolt holes.



8. Reset cutter block for inside diameter dimension and cut.

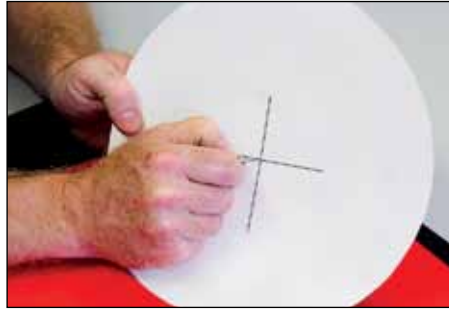
FOR HELPFUL HINTS AND VIDEO INSTRUCTIONS, VISIT

WWW.ALLPAXCORP.COM

CUTTING DISCS OR DIAPHRAGMS:



1. Cut a cardboard template using cutting procedures as outlined in the sections above.



2. Push disc pin through center hole from bottom of template.



3. Place template on gasket material and push disc pin into gasket to make an indentation.



4. Use the disc pin as the pivot post to cut gasket material, as described above. Press down on the cardboard template to secure the gasket material.

MEDIUM & LIGHT-DUTY GASKET CUTTER PARTS

4000 & 3000 SERIES

PARTS*			4000 SERIES MEDIUM-DUTY KITS					3000 SERIES LIGHT-DUTY KITS				REPLACEMENT PART
			AX4000	AX4010	AX4020	AX4030	AX4040	AX3000	AX3010	AX3020	AX3030	
PRODUCT	PART #	DESCRIPTION										
	AX3500	Standard-Duty Cutting Blades	1	1	1	1	1	1	1	1	6	
	AX3501	Heavy-Duty Cutting Blades	1	1	1	1	1	1	1	1	6	
	AX3510	1- $\frac{3}{16}$ " Short Center Pins	1	1	1	1	1	1	1	1	6	
	AX3511	1- $\frac{7}{16}$ " Medium Center Pins	1	1	1	1	1	1	1	1	6	
	AX3512	1- $\frac{11}{16}$ " Long Center Pins	1	1	1	1	1	1	1	1	6	
	AX3513	Disc Pins	0	0	0	0	0	0	0	0	6	
	AX1633	18" x 18" Cutting Board: Center Pin Ferrules (2) installed	0	1	1	1	1	0	1	1	1	
	AX1634	24" x 24" Cutting Board: Center Pin Ferrules (2) installed	0	0	0	0	0	0	0	0	1	
	AX1640	30" x 30" Cutting Board: Center Pin Ferrules (2) installed	0	0	0	0	0	0	0	0	1	
	AX3535	Extension Arm	0	0	1	2	3	0	0	1	2	1
	AX3550	Pivot Post Assembly	1	1	1	1	1	1	1	1	1	
	AX1622	Piercing Tool	1	1	1	1	1	1	1	1	1	
	AX1613	Center Pin Ferrule	0	0	0	0	0	0	0	0	1	

*All parts fully compatible with Spearhead Model 777A and Model 747C gasket cutters formerly made by Zimmerman Packing & Manufacturing, Inc.

ALLPAX[®]
GASKET CUTTER SYSTEMS

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