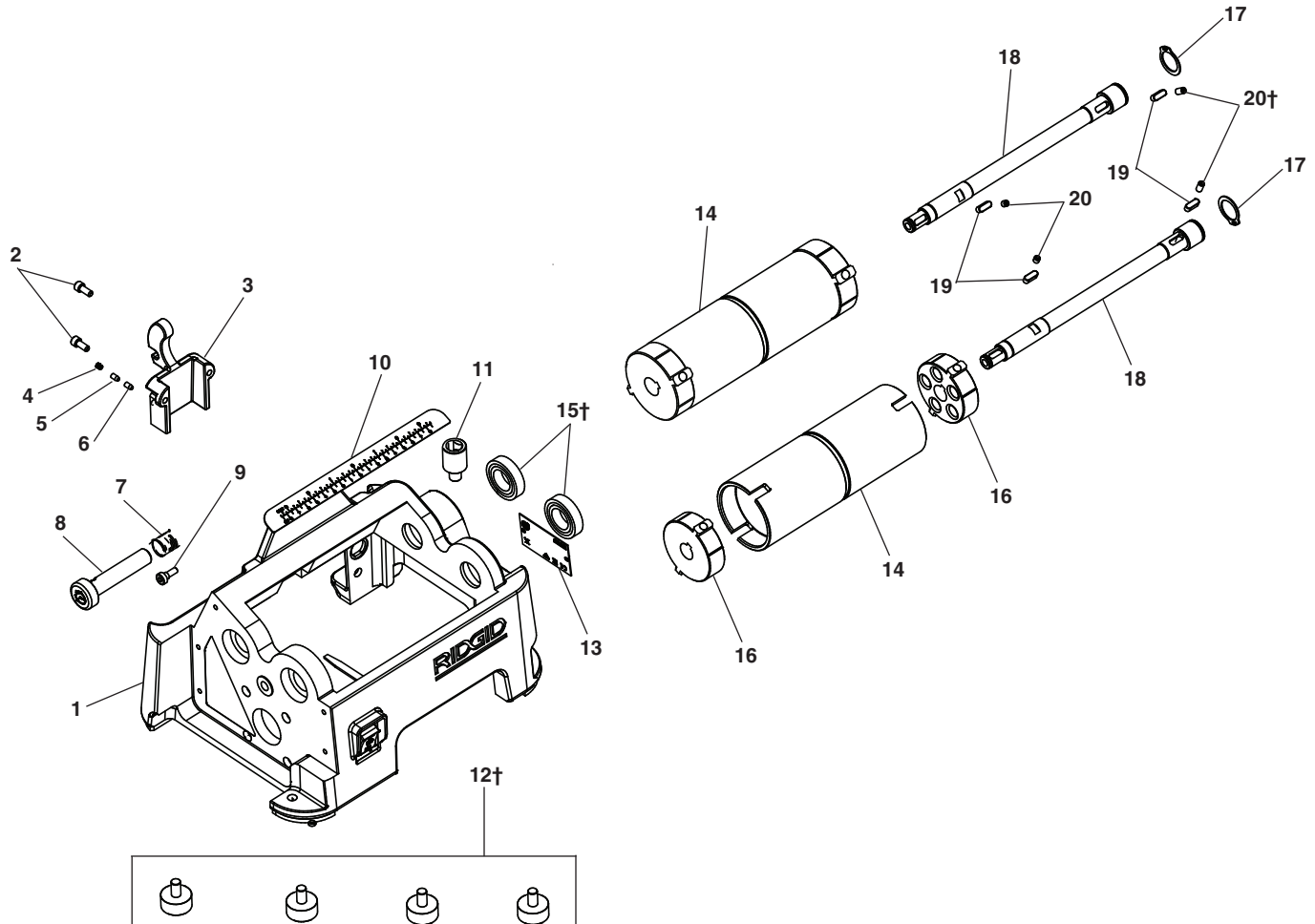


Main Components



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

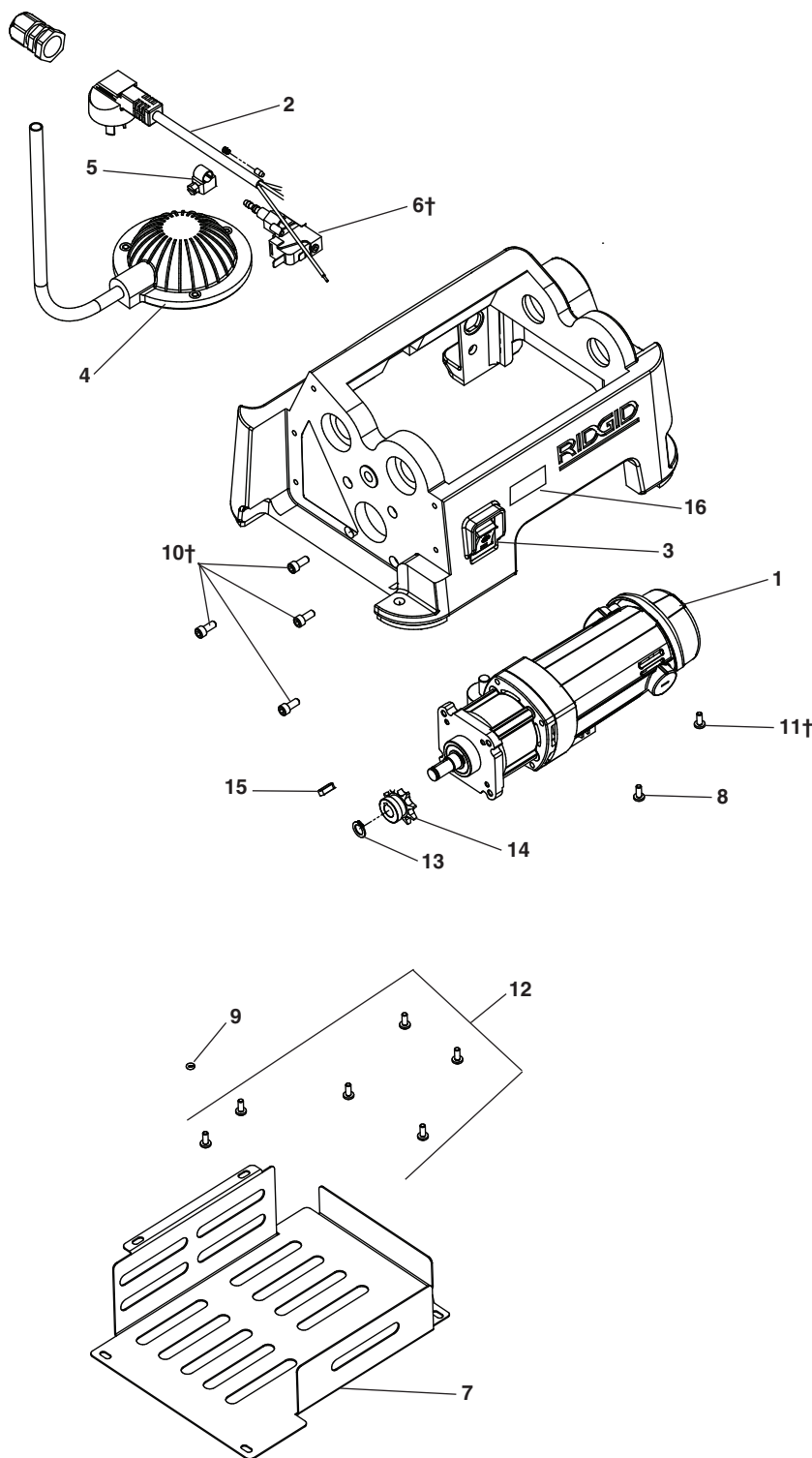
Ref. No.	Catalog No.	Description
1	66138	Base
2	68163	Screw M5 x 12 (15)
3	68013	Hook, Wire
4	68098	Screw, set (3)
5	34190	Spring for release (2)
6	68178	Head, pin release
7	68168	Spring, release
8	68173	Pin, release
9	42008	Capscrew, latch (2)
10	68198	Scale
11	68288	Reamer connect
12†	68118	Rubber feet (4)
13	68258	Nameplate, 100-120V
	68093	Nameplate, 220-240V
14	68293	Roller (2)
15†	67908	Bearing, 61904
16	73763	Cap, Roller (4)
17	68023	E Ring 20mm
18	67993	Shaft, roller (2)
19	68088	Key 5 x 5 (4)
20†	68053	Screw, fix (4)

† Grease bearing bore (15)

† Apply Loctite 263 on thread of rubber feet (12) tighten by hand

† Apply Loctite 263 on thread, tighten screw (20), torque 3Nm

Electrical



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

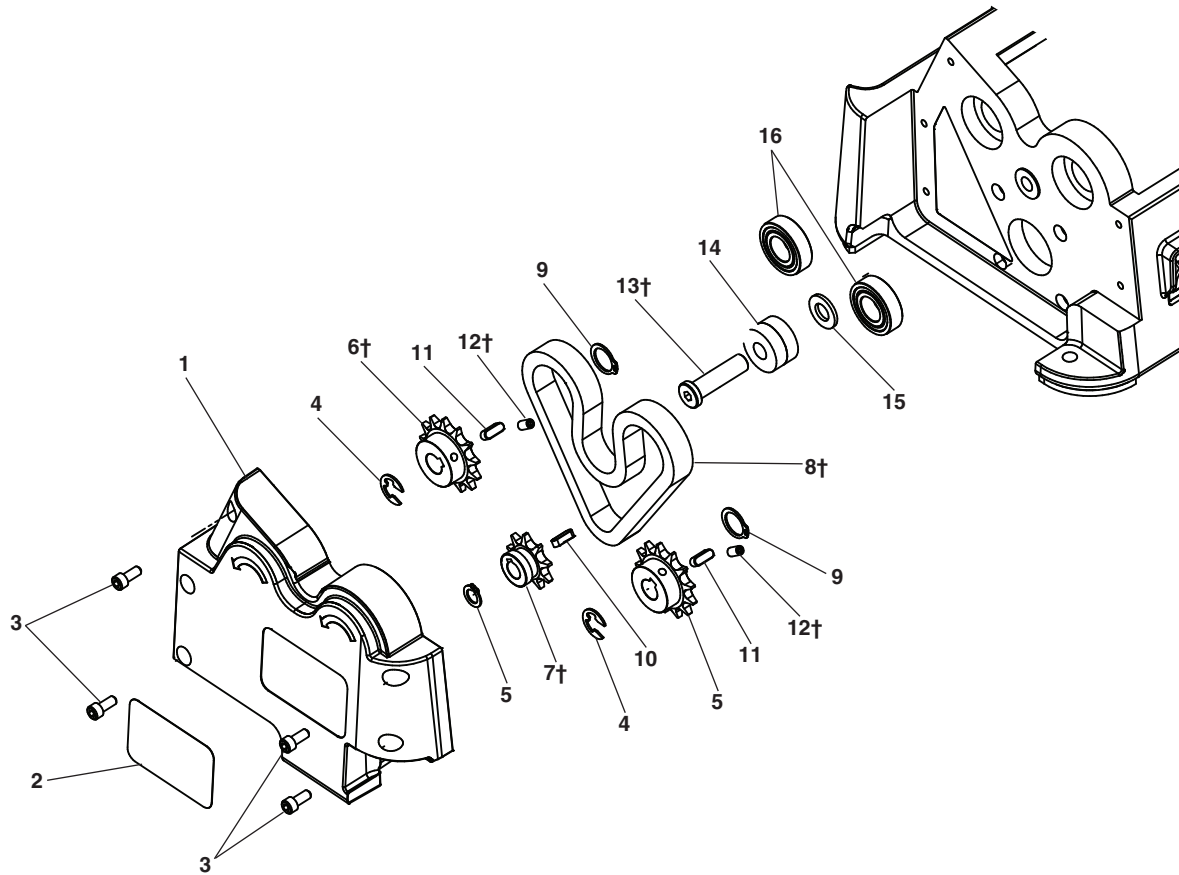
Ref. No.	Catalog No.	Description
1	68108	Motor, assembly 100-120V
	67998	Motor, assembly 220-240V
2	68048	Power line, assembly, US
	68008	Power line, assembly, Korea
	68003	Power line, assembly, China
	68043	Power line, assembly, EU
3	68018	Switch
4	68033	Foot bulb
5	68038	Pipe clamp
6†	68028	Switch, air
7	68183	Sheet, base
8	68263	Screw, ground M4 X 10 (1)
9	73833	O-ring (6)
10†	68163	Screw M5x12 (15)
11†	68143	Screw (PCB) M4x10
12	68143	Screw M4x10 (7)
13	68023	E-RING package
14	68058	Chain wheel, 9 teeth
15	68088	Key package
16	68243	Label Package

† Apply Loctite on thread (10) torque screw 3Nm

† Fit air switch (6) torque to 5.5Nm

† Screws (11), torque 1Nm

Gearbox



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

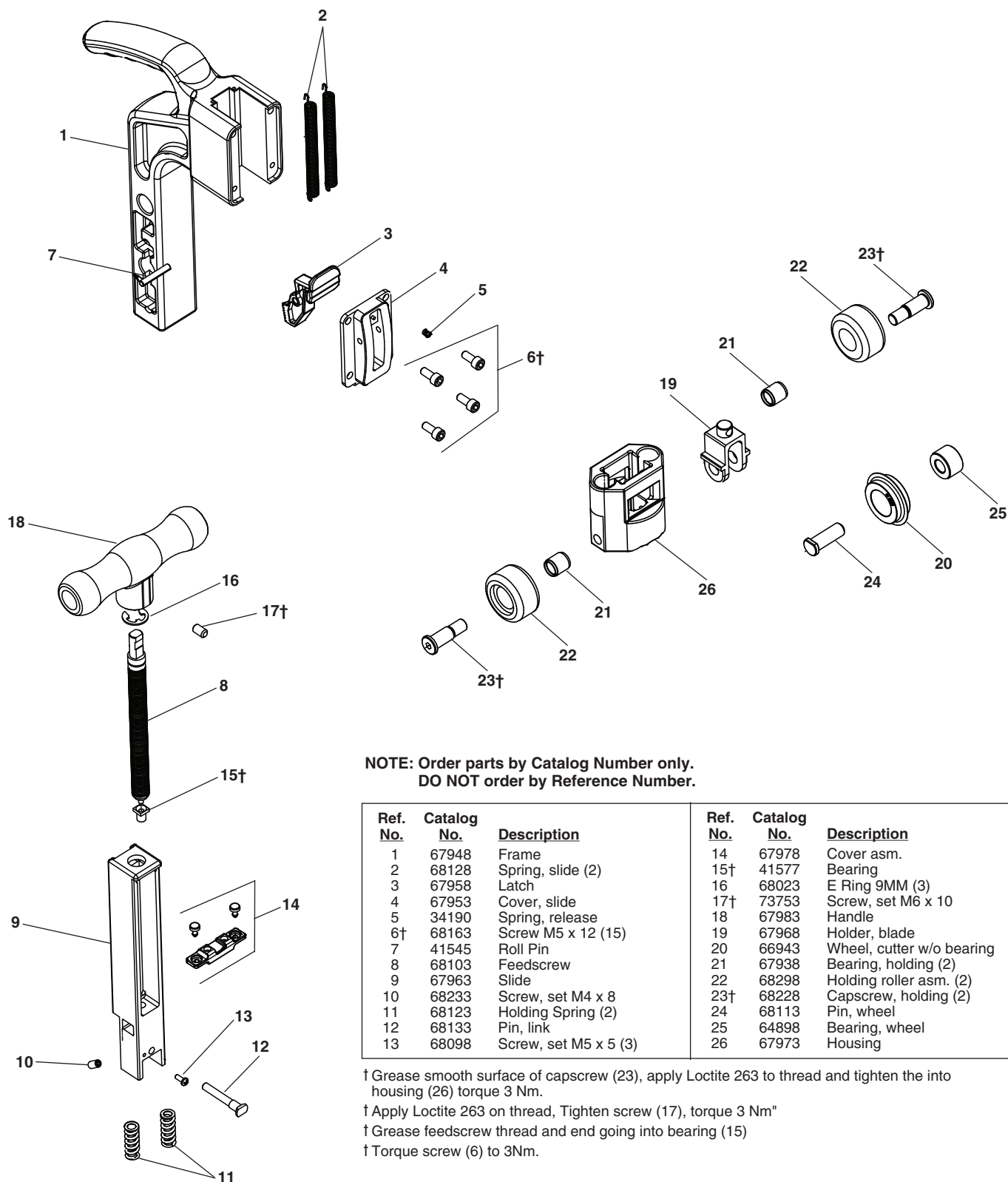
Ref. No.	Catalog No.	Description
1	67943	Cover
2	68243	Warning Label
3	68163	Screw M5 x 12 (14)
4	68023	E-Ring 9mm (3)
5	68023	Ring, Retaining (1)
6†	68063	Chain Wheel, 13 teeth
7†	68058	Chain Wheel, 9 teeth
8†	68068	Chain
9	68023	E-Ring 15mm (2)
10	68088	Key 4 x 4
11	68088	Key 5 x 5 (4)
12†	68098	Screw, Set M 5 x 5 (3)
13†	68208	Tension Pad
14	68193	Bearing
15	68213	Pad
16	67913	Bearing, 6002 (2)

† Apply Loctite 263 to set screws (12), torque 3Nm

† Apply Loctite 263 on thread hole of base before tightening Tension Pad (13)

† Apply EP2 grease on chain (8) and chain wheels (6,7)

Cutting Components



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	67948	Frame	14	67978	Cover asm.
2	68128	Spring, slide (2)	15†	41577	Bearing
3	67958	Latch	16	68023	E Ring 9MM (3)
4	67953	Cover, slide	17†	73753	Screw, set M6 x 10
5	34190	Spring, release	18	67983	Handle
6†	68163	Screw M5 x 12 (15)	19	67968	Holder, blade
7	41545	Roll Pin	20	66943	Wheel, cutter w/o bearing
8	68103	Feedscrew	21	67938	Bearing, holding (2)
9	67963	Slide	22	68298	Holding roller asm. (2)
10	68233	Screw, set M4 x 8	23†	68228	Capscrew, holding (2)
11	68123	Holding Spring (2)	24	68113	Pin, wheel
12	68133	Pin, link	25	64898	Bearing, wheel
13	68098	Screw, set M5 x 5 (3)	26	67973	Housing

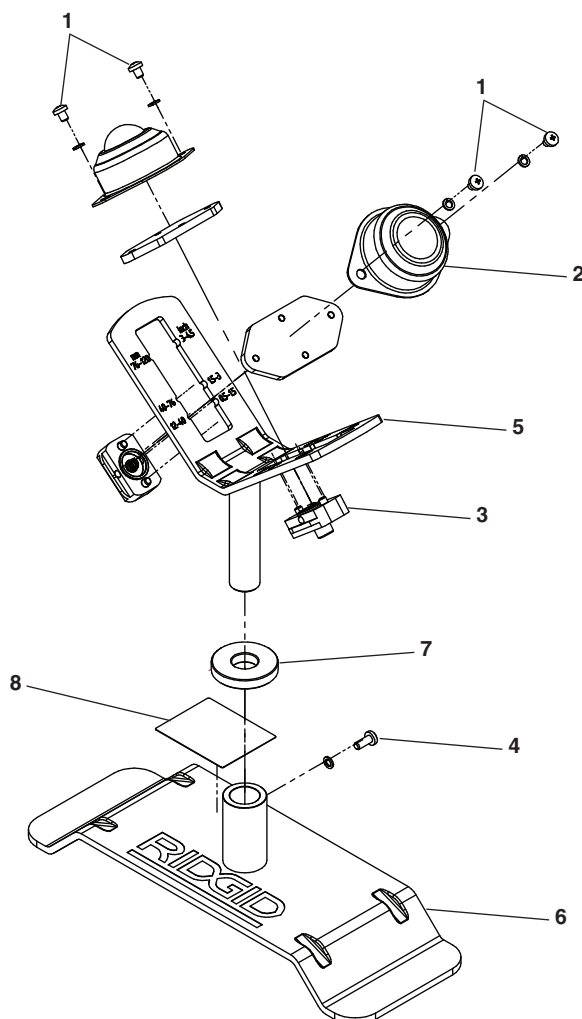
† Grease smooth surface of capscrew (23), apply Loctite 263 to thread and tighten the into housing (26) torque 3 Nm.

† Apply Loctite 263 on thread, Tighten screw (17), torque 3 Nm"

† Grease feedscrew thread and end going into bearing (15)

† Torque screw (6) to 3Nm.

Stand and Accessories



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
1	73793	Screw, M4 x 5 (4)
2	73823	Ball, Transfer
3	73828	Button, Assembly (Includes Bearing Base)
4	73788	Screw (1)
5	73773	Base, V
6	73768	Base
7	73783	Nut, Knurled Screw Adj.
8	75578	Decal, Capacity
ITEMS NOT SHOWN		
	66943	E855 Cutter Wheel for Plastic Tubing
	66938	E850 Cutter Wheel for Metallic Tube
	64908	137S Reamer for PTC-400
	67988	Storage, Cutter Wheel