

## INSTRUCTIONS FOR 1-1/2" AND 2" FORD SHELL CUTTERS

These instructions are specific to 1-1/2" and 2" Ford Shell Cutters. For general machine operation and other cutter types, refer to the instructions supplied with the Ford Model 77 Drilling Machine.

1. A practice cut in the shop is advised to ensure familiarity with these instructions and to develop a feel for the cutter's operating characteristics.
2. Handle the Cutter with care to ensure the carbide teeth are not damaged. Place the Cutter in the supplied protective container whenever it is not in use.
3. The Shell Cutter does not use the Arbor (DMA-67) as required with the Ford Holesaws (DMHS-6 and DMHS-7).
4. Only Shell Cutters for Ductile Iron Pipe require a Pilot Drill. The Pilot Drill should not extend more than 3/16" beyond the cutter.
5. A thin film of an approved lubricant on the carbide teeth may improve the cut through Ductile Iron Pipe.
6. To start the cutting process, LOWER THE CUTTER GENTLY onto the pipe; rough handling will damage the carbide teeth.

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7. Make sure the Cutter rotates in the cutting (clockwise) direction only. Rotating in the reverse direction will damage the carbide teeth. ALWAYS ROTATE CLOCKWISE.

8. Begin cutting the pipe with a SLOW FEED-SCREW RATE and light pressure to allow the Cutter to engage the pipe properly. Once all the cutter's teeth are cutting the pipe, make at least 2 quarter turns of the ratchet before applying more pressure on the feed-screw. TURN THE FEEDSCREW ONLY WHILE TURNING THE RATCHET.

9. When nearing the end of the cut, reduce the feedscrew rate and pressure to allow the cutter to finish the cut cleanly and to prevent pushing through the pipe. A clean cut will provide better coupon retention.

10. PVC Coupon retention is enhanced by rotating the cutter in the clockwise direction during retraction.

Note: PVC Shell Cutters may require removing the shavings after making 3/8 to 1/2 of the cut through pipe walls 3/4" thick or more.



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