

*Tubela*TM

TUBELA ENGINEERING Co. Ltd.

Manufacturers and suppliers of Pipe/Tubebending machinery, Pipe Working Equipment

Tube, Pipe & Section Manipulators

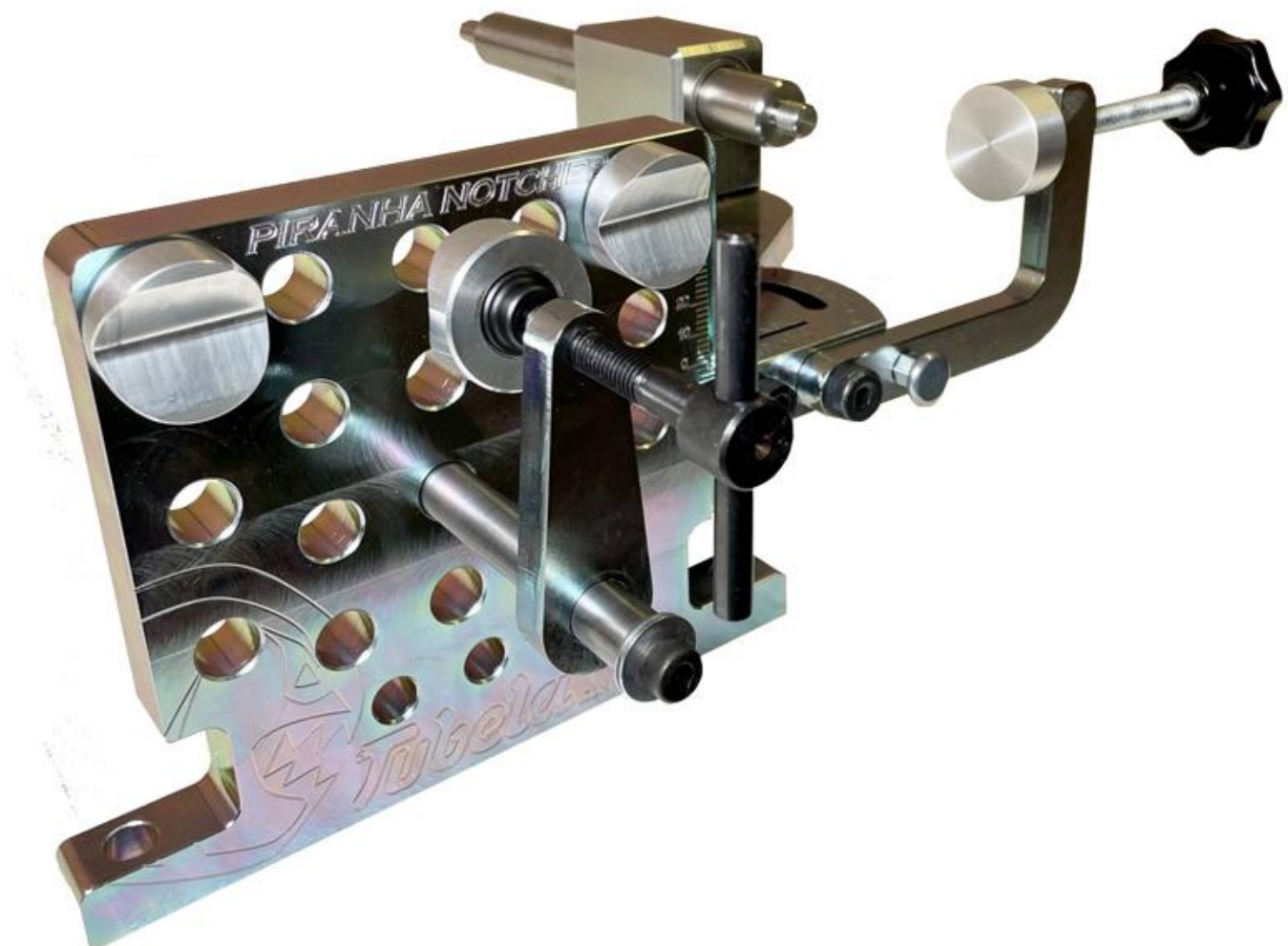
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Piranha Notcher Assembly & Operating Manual

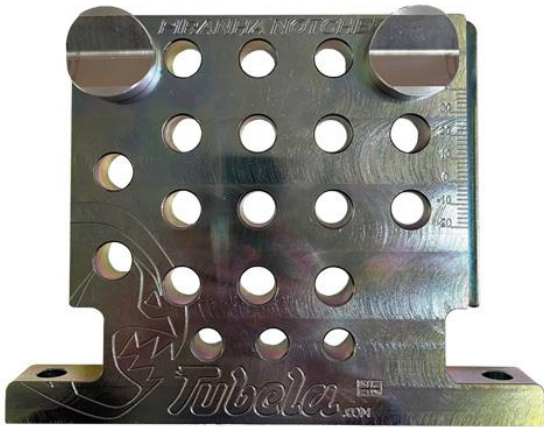


Piranha Tube Notcher Assembly instructions

The Tubela Piranha Tube Notcher is supplied in partially assembled form, and with a few simple final steps you will be ready to go.

What's in the box...

1 x Tube Notcher Main Plate.
Complete with 2 V-Pads.



1 x Tube Notcher Swivel Base assembly



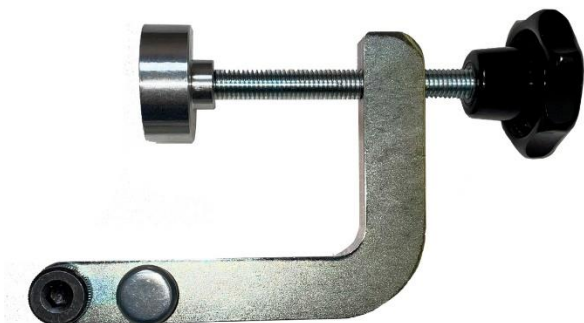
1 x Stainless Steel Hole Saw Drive Shaft



1 x adjustable Tube Clamp complete with Magnetic V-Pad



1 x adjustable Tube Stop



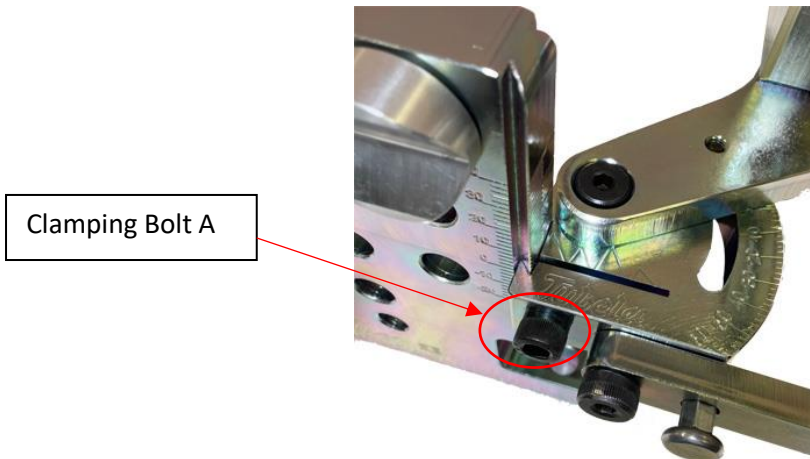
1 x Arbour Thread Adaptor



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The 4 Simple Steps to start Notching tube

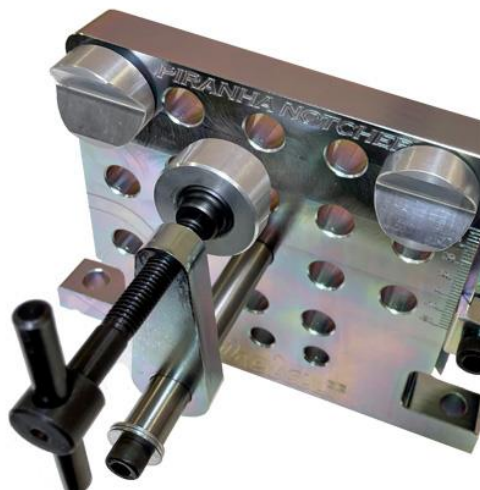
Step 1: Slide the Swivel Base onto the Dovetail slot of the Main Plate. And secure this into position with the clamping bolt (A), using an 8mm Allen Key, at the desired height while using the scale.



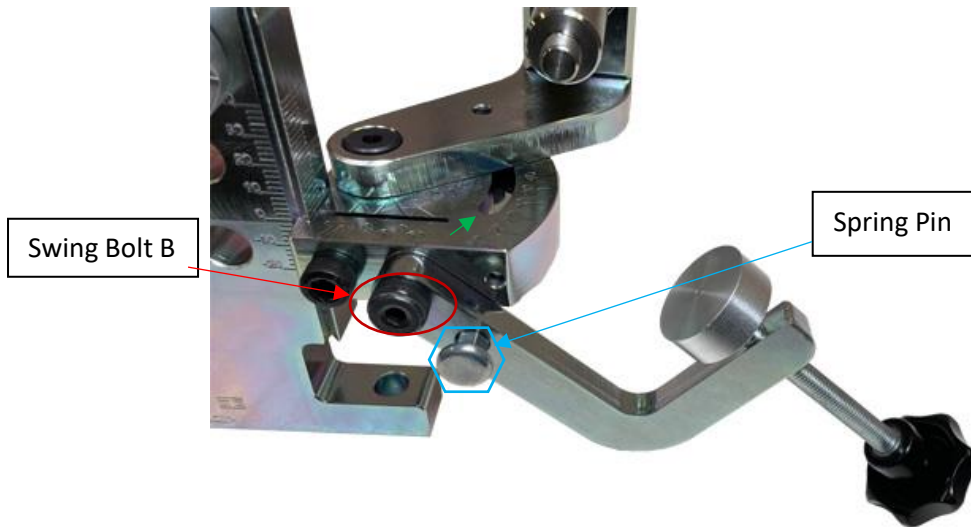
Step 2: Insert the Stainless Steel Holesaw Drive Shaft into the bearing block. Apply some grease to the bearings first.



Step 3: Insert the Adjustable Tube Clamp into the Main Plate



Step 4: Attach the adjustable Tube Stop to the Swivel Base by tightening Swing Bolt B with a 6mm Allen Key and locating the quick release Spring Pin in the locking hole by pulling the Spring Pin out.



Now the Piranha Notcher is fully assembled; it is ready for action. The Piranha Notcher can be mounted either in a standard workshop vice by clamping securely on the bottom of the main plate or bolted to a welding table of your choice (The mounting bolts are set for 50mm and 100mm hole centre tables).

Guidance For Safe Operation

Always wear eye protection! And all relevant items of PPE when operating the Piranha Notcher. Insure the notcher is securely mounted and cannot move during operation.

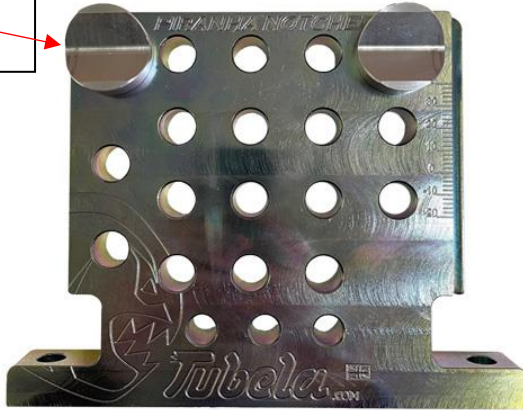
Attach the chosen hole saw cutter to the cutter shaft and firmly tighten by hand. There is an arbour thread adapter supplied to mount the larger 5/8" hole saws to the Drive Shaft if required.

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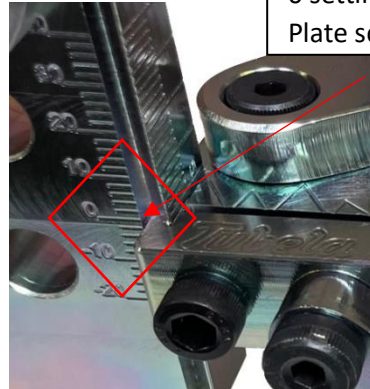
Notes on Use

When a parallel cut is required through the centre of the given tube the aluminium V-pads need to be located on the top row of holes on the Notcher Main Plate and the Swivel Base locked at the 0 position on the Main Plate scale, as shown below.

V-Pads on top row for parallel cutting

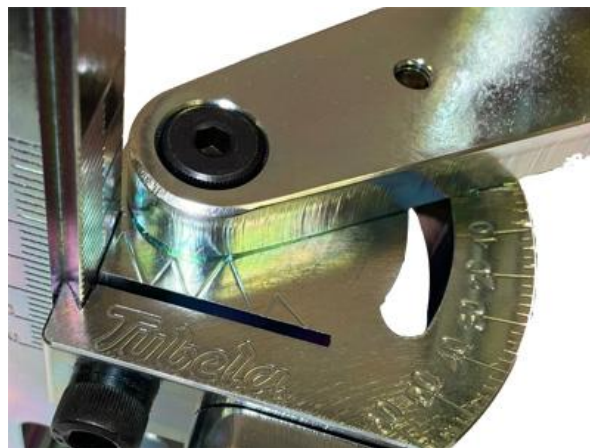


0 setting on Main Plate scale



To adjust the angle of the cutting head, release the Swivel Arm locking bolt which is located under the block with a 6mm Allen key. See picture below. And rotate the Swivel Arm until the chosen angle is lined up with the front edge of the arm. Then lock back into position firmly.

The scale on the block starts at 0 degrees, which is for a 90 degree cut in the tube and then goes down from this upto 60 degrees in 1 degree increments.



When a compound angle is required the V-Pads and both scales can be adjusted to suit the required angles, please ensure both the tube and all locking bolts are firmly secured before operating the Piranha Notcher.

****CAUTION – When operating this Notcher always wear Safety Glasses, protective Gloves and appropriate clothing that will not get caught. And ensure it is securely mounted****