

FASCUT[®]

Model FC-800 Rebar Cutter



INSTRUCTION MANUAL

Built in the U.S.A. – Since 1979

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INTRODUCTION

FASCUT® incorporates a rugged alloy cast cutting head with a hydraulic cylinder and two stage hydraulic pump. By following the enclosed instructions and maintenance schedule, your **FASCUT®** machine will provide you with years of trouble free service.

WARNING: DO NOT attempt to operate until you have read thoroughly and understand completely all instructions, rules, etc., contained in this manual. Failure to comply can and may result in accidents involving fire, electric shock, or serious personal injury. Maintain this instruction manual and review it frequently for continuing safe operation and instructing new or possible third-party users.

DO NOT: TURN ON MACHINE BEFORE REMOVING THE SHIPPING PLUG ON THE TOP OF THE OIL RESOVOIR AND REPLACING IT WITH THE SUPPLIED BREATHER CAP. FAILURE TO DO THIS WILL RESULT IN DAMAGE TO THE MACHINE!

ALWAYS: wear safety glasses when operating. **ALWAYS:** keep fingers away from cutting blades.

Model FC-800 Portable Cutter -- Specifications

Shear Capacity Grade 60 (420 MPa)	1 bar - #8 (1") 25mm, #7 (7/8") 22mm, or #6 (3/4") 19mm 2 bars - #5 (5/8") 16mm 3 bars - #4 (1/2") 13mm 4 bars - #3 (3/8") 10mm
Shear Method	Open Jaw Shear
Shear Time	Approx. 2 to 4 seconds
Dimensions (L x W x H)	26" x 13" x 19" 66cm x 33cm x 48cm
Weight	190 pounds / 86kg; built in carrying handles
Power Supply	Two stage hydraulic pump driven by a one (1) hp. continuous duty electric motor
Voltage / Amps	110-120 volts @ 15 amps – 50/60 Hz, single phase 220-240 volts @ 7.5 amps – 50/60 Hz, single phase

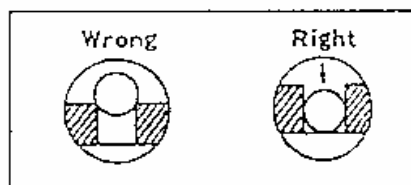
NORMAL OPERATION

1. **ALWAYS WEAR SAFETY GLASSES** when operating.
2. **ALWAYS KEEP FINGERS AWAY** from cutting blades.
3. **PLUG UNIT INTO** a 110-120Volt outlet on a circuit with no less than a 20 amp breaker. When using an extension cord, never use less than 12-guage wire. Excessive voltage drop at the unit will cause the motor to burn out.

Or if 220 Volt

WIRE UNIT TO a 220-240 Volt, 50/60 cycle, 1 phase power source. Unit will draw approximately 8 amps. When using an extension cord, never use less than 14-guage wire. Excessive voltage drop at the unit will cause the motor to burn out.

4. **GENERATOR MUST BE 5000 WATTS OR LARGER.** Disable idle down feature so generator engine is running at operating speed when turning on rebar cutter.
5. **TURN ON** using the toggle switch. In cold weather operations (below 32 deg. F), turn unit on and allow to warm up for 5 to 10 minutes before using.
6. **ALWAYS TURN OFF** unit when not in use. **DO NOT** allow unit to idle for long periods of time.
7. **KEEP IN UPRIGHT POSITION** to prevent loss of hydraulic oil from the oil tank breather cap.
8. **TO CUT** a bar or bars, position bar between cutting blades. Bar must rest on the bottom of the cutter opening as shown on the diagram below. Adjust the support on the right side so the bar is held at 90 degrees to the cutting blades. Press the green button until cut is made and then release. **DO NOT CUT VERY SHORT PIECES** (3" OR SHORTER) as they could fly out and cause personal injury to you or someone located close to you.
9. **USE TYPE 801** cutting blade when cutting a lot of #3 or #4 bar. Your cutting times will be faster because the cutter takes less time to advance and make contact with the bar. Replace the regular 800 type cutting blade for the type 801 cutting blade in the **STATIONARY POCKET**.



ROUTINE MAINTENANCE

- 1) **DRAIN & REPLACE HYDRAULIC OIL** at least once each year or 200 operating hours, whichever comes first. Allow unit to run for five minutes before draining to warm up the oil. Remove drain plug and drain oil. Remove breather cap and plug hole with a $\frac{3}{8}$ " pipe plug. Tip unit on end and fill thru drain hole to within one (1) inch of the top and replace plug. ***DO NOT OVERFILL***. Use good quality hydraulic oil with a rating of **ISO-VG 46** for general year round use. Use heavier ISO VG-68 for continuous hot weather operation. The unit will take approximately 6 quarts of oil to refill. Set unit upright again and remove the $\frac{3}{8}$ " pipe plug and re-install the breather cap, hand tightening only.

Failure to re-install the breather cap will result in damage to the machine.

- 2) **GREASE** through grease fitting on the left side of the cutter head before **EACH** use period. Re-bar scale will quickly dry up grease. Removal of this scale, and lubricating often will help to reduce wear.

Failure to remove excessive scale and lubricate machine regularly, will result in increased wear and reduced life of the machine.

- 3) **TIGHTEN** blade securing hex bolts with the supplied Allen wrench before each use period.

Failure to keep cutting blades securing hex bolts tight at all times could result in injury to the operator and/or damage to the machine.

- 4) **CUTTING BLADES** have 4 indexable cutting edges. When one set of edges is worn out, simply remove blade securing bolts and rotate to a new edge. If old edge has mushroomed slightly, grind flat before installation to achieve proper "seating" of the blade in its new position.

Do not attempt to re-sharpen worn edges. Resharpener changes the dimension of the blades, causing them to not seat properly and damage the blade holding socket.

- 5) **CLEANING** machine with a pressure washer routinely will help keep oil and grease from building up and will extend the overall life of the machine.

OPTIONS

STOP BAR ATTACHMENT

The stop bar attachment provides the operator with an adjustable reference fence for cutting uniform lengths. It can be set out to a maximum of approx. 4 feet.

ASSEMBLY

Bolt the fence bracket to the end of the steel bar using the bolt included with the bracket. Next, slide the bar through the holder rings on the machine frame from the LEFT side. Tighten the thumb screw on the holder after adjusting for desired length.

FOOT PEDAL CONTROL

The Foot Pedal comes fully assembled and pre-wired. It can be plugged in at any time.

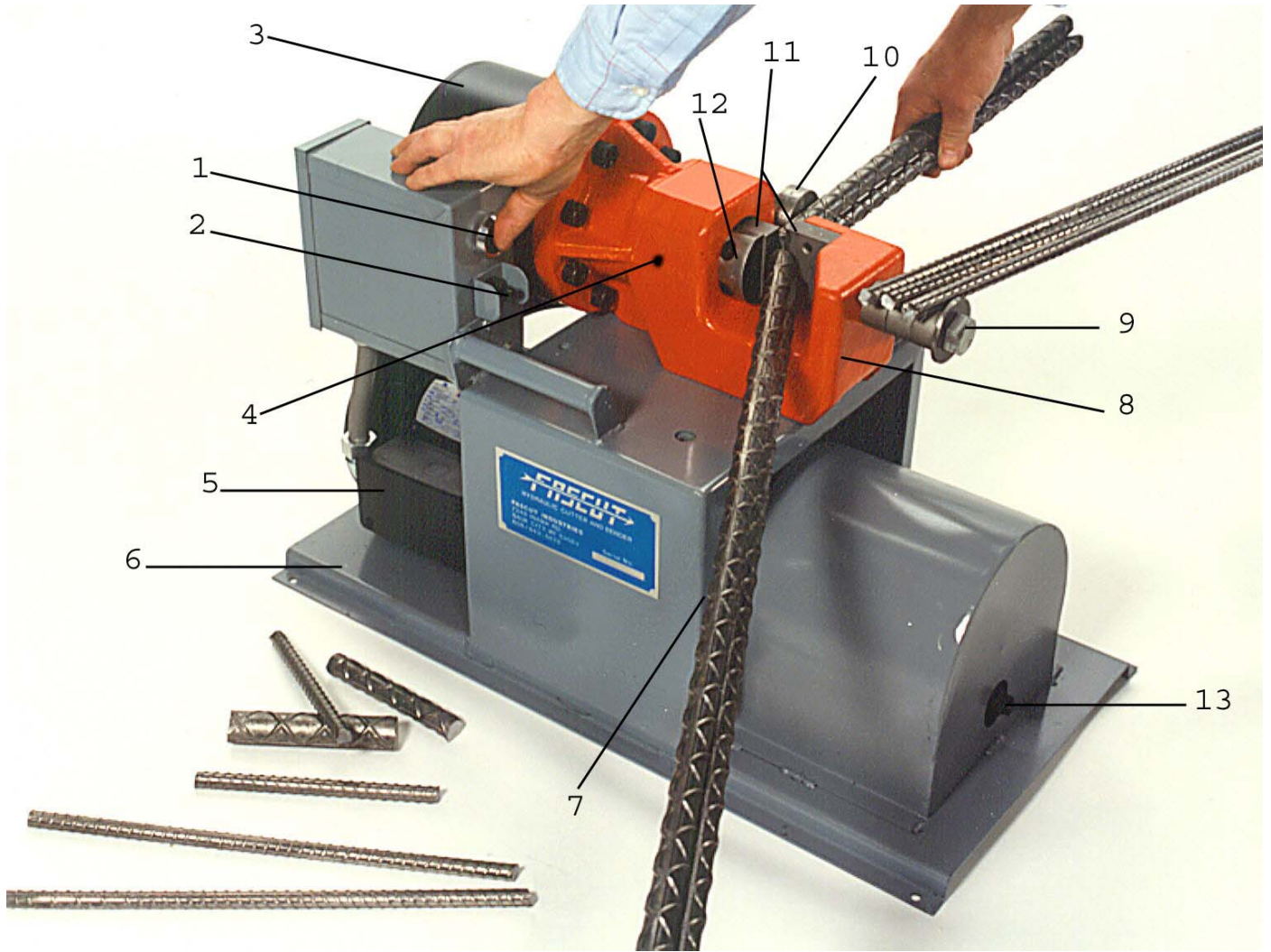
A jack is provided on the underside of the electric box. Push the plug into the jack until it locks in place. To remove, just push the release button on the jack.

When the foot pedal is plugged in, both the push button on the machine and the foot pedal will control the machine.



Note: *Extra caution must be observed when using the foot pedal to keep fingers away from cutting blades.*

Never: *Have one person work the foot pedal or push button while another is feeding rebar into the machine.*



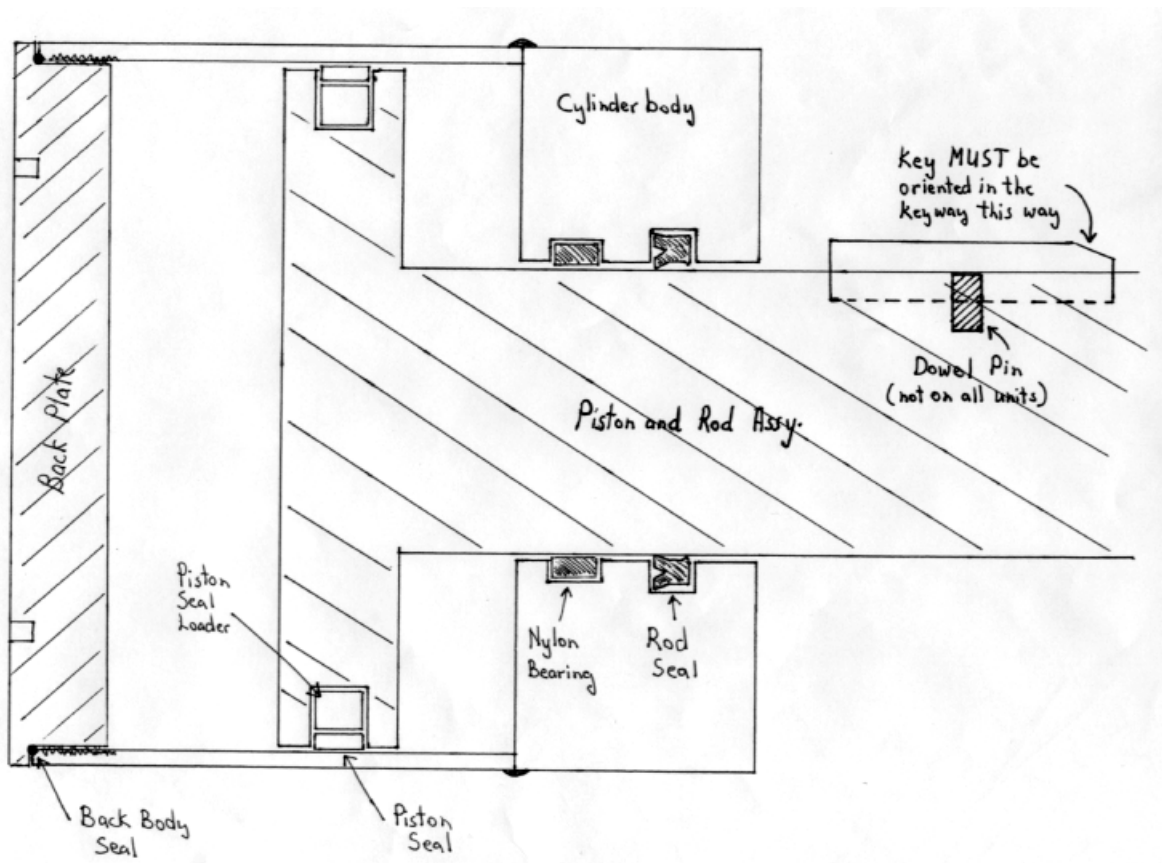
FC-800 PARTS BREAKDOWN

Nov. 1, 2007

Index #	Description	Part #	Price/ea.
1	Push button control	76882	21.42
2	On/Off switch – 110-v	76619	8.12
2	On/Off switch – 220-v	76620	9.60
3	Hydraulic Cylinder (complete) – see next page for breakdown.		
12	Piston and rod assy. w/seal & loader – see cylinder breakdown.		
	Hydraulic tube w/nut & ferrule, pressure	80465	10.50
	Hydraulic tube w/nut & ferrule, return	80466	10.50
	Hydraulic Cylinder elbow fitting (Fascut SAE)	73112	5.25
	Hydraulic Power unit elbow fitting (Lenz)	73662	5.25
4	Grease fitting, straight	82547	1.24

5	Hydraulic Power unit (complete)	73405	980.00
	Electric Motor – serial #953 and up	75705	415.00
	Electric Motor – serial #952 and down	75706	517.00
	Motor Starting Capacitor	77253	12.58
	Motor Fan	75734	19.95
	Motor Fan Shroud	75721	37.50
	Motor drive coupling	75715	12.75
	Hydraulic Pump	73424	394.00
	Oil tank	76406	64.20
	Oil tank o-ring	76421	9.00
	Breather Cap	71062	9.00
13	Oil drain plug	76245	.79
	Valve (directional)	78919	62.90
	Valve (kick-down)	78989	78.63
	Valve coil – 110-v	78937	47.60
	Valve coil – 24-v for 220-v unit	78938	47.60
6	Frame	80611	169.00
	Electric box only, 110-v	66745	49.00
	Electric box only, 220-v	66746	59.00
7	Allen wrench (1/4")	80310	3.36
8	Cutter Head Casting	80700	675.00
	Cylinder to Cutter bolts/lock washers	80705	.79
	Safety cover plate	80720	12.84
	Safety Decal, cover plate	78643	.98
9	Bar rest	80710	9.50
10	Bar support (adjustable)	80715	21.00
11	Cutting blade w/bolts & lockwashers (2 req.)	85666	37.50
	Cutting blade type 801 w/bolts & lw	85667	59.00
	Foot Pedal Control	72365	129.00
	Foot pedal cord w/plug	72369	18.79
	Foot pedal jack	72373	15.00
	Power cord w/plug (110-volts)	76745	12.28
	Stop Bar Attachment	89725	75.00

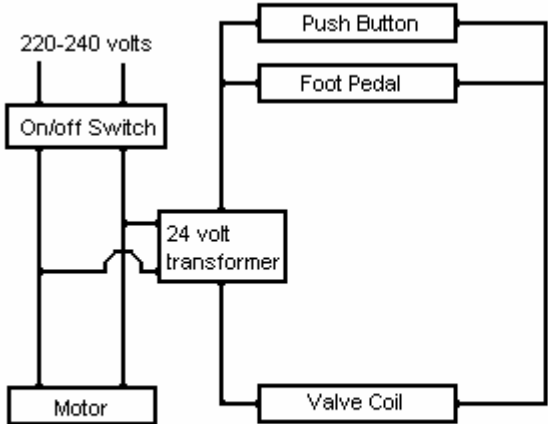
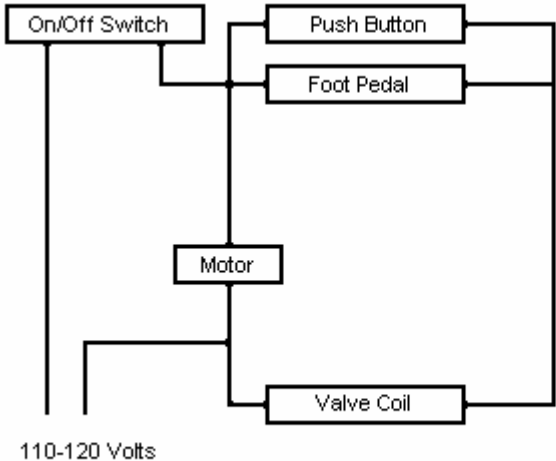
Cutter Hydraulic Cylinder



Nov. 1, 2007

Description	Part #	Price/ea.
Hydraulic Cylinder (complete)	80430	550.00
Back body seal	80438	9.00
Piston Seal w/square loader ring	80436	34.90
Nylon Bearing	80440	4.95
Rod Seal	80442	15.50
Piston & rod assy. w/seal & loader	80434	219.00
Cylinder body w/back plate	80432	302.00
Key, 1/2" sq, #18380, #918 and up	80451	14.50
Key, 1/2" sq, #18379, #917 and down	80452	14.50
Spanner wrench, flat	80461	15.00

WIRING DIAGRAMS



The on/off switch turns power on to both the electric motor and the valve coil circuit. The switch must be 1 HP rated.

Pressing the push button or foot switch completes the circuit to energize the valve coil which makes the hydraulic cylinder extend out to make a cut.

TROUBLESHOOTING FC-800 Rebar Cutter

TROUBLE	PROBABLE CAUSE	REMEDY
Motor will not start	<ol style="list-style-type: none"> 1. No power to unit. 2. Power cord or plug damaged. 3. On/off switch bad. 4. Motor wire connections loose. 	<ol style="list-style-type: none"> 1. Check supply cord, fuses, or circuit breaker. 2. Replace power cord w/plug. 3. Replace on/off switch. 4. Tighten motor wire connections.
Motor hums, then blows circuit breaker, or motor is smoking	<ol style="list-style-type: none"> 1. Extension cord too long or not heavy enough. 2. Starting capacitor bad. 3. Starting switch bad. 4. Generator too small. 5. Generator running at idle before starting unit. 6. Motor windings burnt out. 	<ol style="list-style-type: none"> 1. Extension cord must be min. 12 gauge wire and no longer than 100 feet. 2. Replace starting capacitor. 3. Replace starting switch. 4. Use a 5 KW generator or larger. 5. Turn off or disconnect idle down feature. 6. Replace motor.
Motor runs, but nothing happens when push button is depressed.	<ol style="list-style-type: none"> 1. Push Button is bad. 2. Loose wire. 3. Valve coil is bad. 4. Directional valve is bad. 	<ol style="list-style-type: none"> 1. Replace push button. 2. Check all wiring for loose connections. 3. Replace valve coil. 4. Replace directional valve.
Foot Pedal does not work. (push button does)	<ol style="list-style-type: none"> 1. Foot pedal cord or plug is damaged. 2. Jack is bad. 3. Switch inside foot pedal is bad. 	<ol style="list-style-type: none"> 1. Replace foot pedal cord w/plug. 2. Replace jack. 3. Replace inside switch.
Cutting blade bolts breaking	<ol style="list-style-type: none"> 1. Cutting blade bolts are loose. 2. Cutting blades are dull. 3. Blade socket is deformed. 	<ol style="list-style-type: none"> 1. Retighten blade bolts regularly. 2. Turn blades to new cutting edge or replace blades. 3. Replace casting or piston and rod assembly.

Cutting blades breaking	<ol style="list-style-type: none"> 1. Blades are dull. 2. Blade bolts are loose. 3. Rebar is being dropped into the cutter. 4. You are cutting “no grade” steel 5. Bar is being cut on the top corner of the cutting blade 	<ol style="list-style-type: none"> 1. Turn blades to a new edge sooner. 2. Check blade bolts for tightness more often. 3. Place rebar into the cutter with greater care. 4. Only cut grade 40 or grade 60 rebar. 5. Bar must rest on the bottom of the cutter opening.
Oil is leaking	<ol style="list-style-type: none"> 1. Hydraulic tubes and fittings are loose or damaged. 2. Hydraulic cylinder body seals or rod seal is leaking 	<ol style="list-style-type: none"> 1. Check fittings for tightness. Replace damaged fittings or tube. 2. Install new body and/or rod seals in hydraulic cylinder.
Cutting is slow and lacks power	<ol style="list-style-type: none"> 1. Oil level is low. 2. Oil is contaminated. 3. Hydraulic pump is worn. 	<ol style="list-style-type: none"> 1. Add oil to tank. 2. Drain and refill oil tank with fresh ISO-46 hydraulic oil. 3. Replace hydraulic pump.

FASCUT® Industries, Inc.

LIMITED WARRANTY

This product has been thoroughly inspected and tested before leaving the factory. It is guaranteed against defective workmanship and materials for a period of 1 year to the original owner. Should any trouble develop, return defective part transportation prepaid to the factory. If inspection shows trouble is caused by defective workmanship or material, all repairs will be made without charge and returned, transportation prepaid. The guarantee does not apply where: repairs or attempted repairs have been made by persons other than the factory; repairs are due to normal wear; the tool has been abused or in an accident; misuse is evident – caused by overloading the tool beyond its rated capacity; use on improper voltage or current; use of the tool after partial failure or use with improper accessories.

This warranty is in lieu of all other warranties, expressed or implied, and there are no warranties on merchantability or fitness for a particular purpose. In no event shall seller be liable for incidental, consequential or special damages. This warrantee is void if Warrantee/Registration card is not filled out and returned. This warranty gives you specific legal rights, and you may also have other rights, which vary from state to state.

SERIAL NUMBER _____ **DATE** _____

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