

5412 Orbital Pipe Machine Cut and Groove Steel



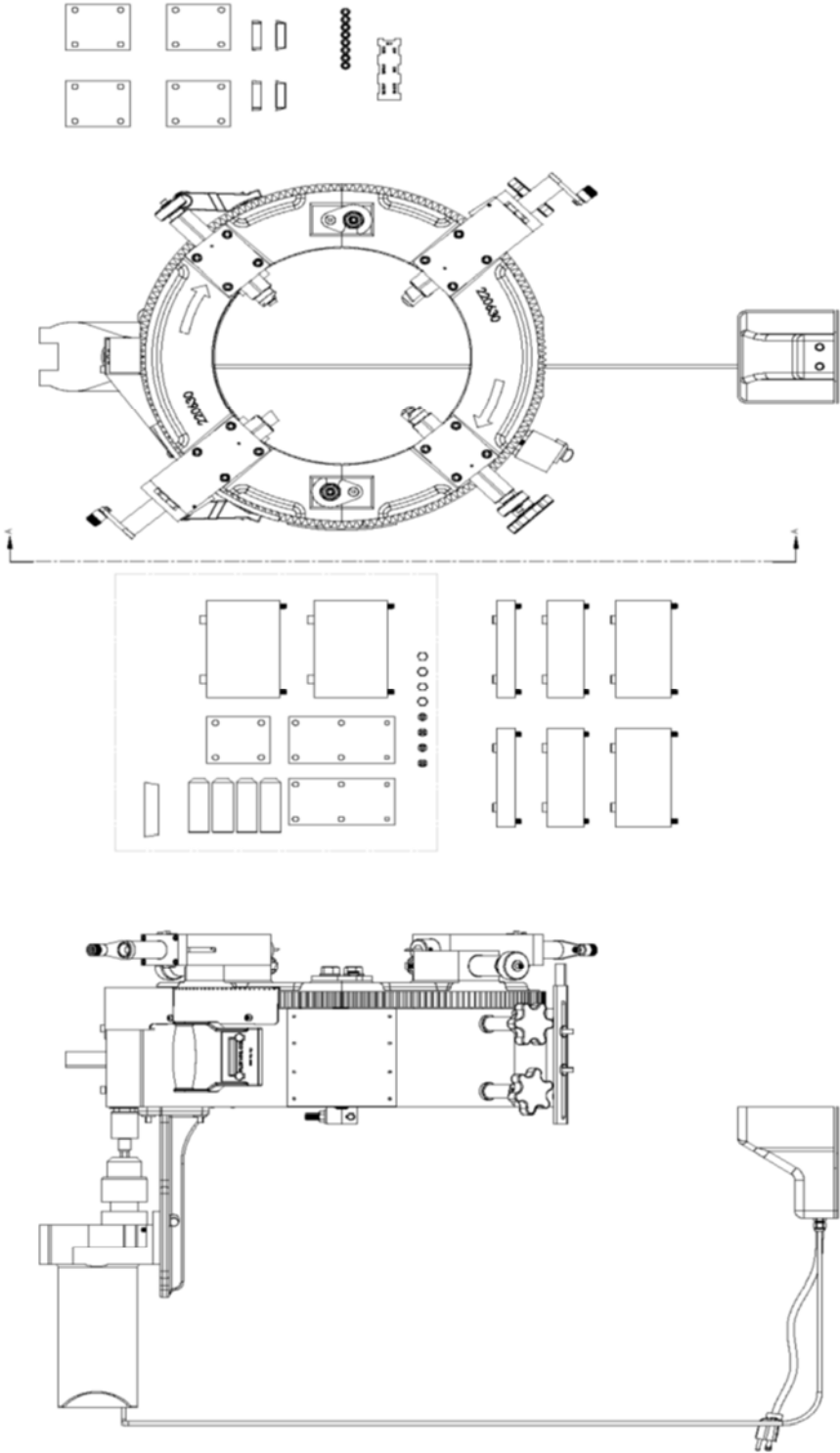
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5412 OPMT Page 1

WHEELER
REX
2740 WASHINGTON AVENUE, SUITE 400
CANA-OTIS & GIBSON STEEL
PART NO. 5412



SECTION A-A

5412 OPMT Page 2



12 INCH STEEL

- (2) 220664 RIFER PLATES
- (4) 220665 UNDERCUT FLAT HEAD MACHINE SCREW
- (2) 221260 BLADE FEED ASS'Y
- (2) 220666 SPACER BLOCKS
- (8) 220667 5/16-18 X 3/4" L SHCS
- (1) 220670 GROOVING BLADE .500
- (1) 220676 GROOVING BLADE .500
- (1) 220658 BLADE FEED ASSY
- (1) 220659 BLADE FEED ASSY
- (1) 220695 CUTOFF BLADE LEFT HAND
- (1) 220696 CUTOFF BLADE RIGHT HAND
- (2) 220736 CUTOFF BLADE HOLDER

10 INCH STEEL

- (2) 220697 10" RIFER ASSEMBLIES
- (2) 221260 BLADE FEED ASS'Y
- (2) 220666 SPACER BLOCKS
- (8) 220667 5/16-18 X 3/4" L SHCS
- (1) 220670 GROOVING BLADE .500
- (1) 220676 GROOVING BLADE .500
- (1) 220658 BLADE FEED ASSY
- (1) 220659 BLADE FEED ASSY
- (1) 220695 CUTOFF BLADE LEFT HAND
- (1) 220696 CUTOFF BLADE RIGHT HAND
- (2) 220736 CUTOFF BLADE HOLDER

8 INCH STEEL

- (2) 220697 8" RIFER ASSEMBLIES
- (2) 221260 BLADE FEED ASS'Y
- (2) 220666 SPACER BLOCKS
- (8) 220667 5/16-18 X 3/4" L SHCS
- (1) 220670 GROOVING BLADE .500
- (1) 220676 GROOVING BLADE .500
- (1) 220658 BLADE FEED ASSY
- (1) 220659 BLADE FEED ASSY
- (1) 220695 CUTOFF BLADE LEFT HAND
- (1) 220696 CUTOFF BLADE RIGHT HAND
- (2) 220736 CUTOFF BLADE HOLDER

4 INCH STEEL

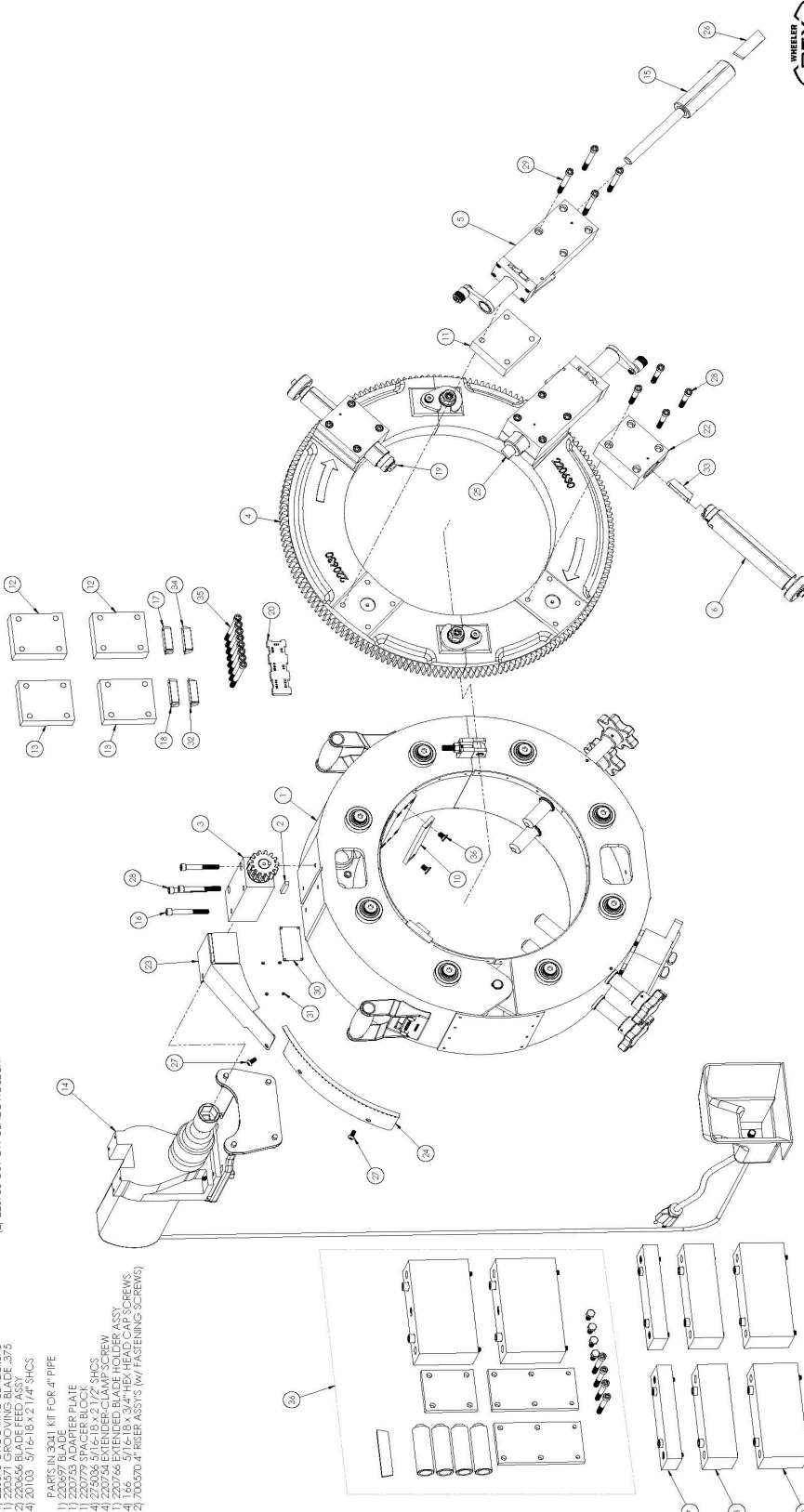
- (2) 220697 4" RIFER ASSEMBLIES
- (2) 221260 BLADE FEED ASS'Y
- (2) 220666 SPACER BLOCKS
- (8) 220667 5/16-18 X 3/4" L SHCS
- (1) 220670 GROOVING BLADE .500
- (1) 220676 GROOVING BLADE .500
- (1) 220658 BLADE FEED ASSY
- (1) 220659 BLADE FEED ASSY
- (1) 220695 CUTOFF BLADE LEFT HAND
- (1) 220696 CUTOFF BLADE RIGHT HAND
- (2) 220736 CUTOFF BLADE HOLDER

4 INCH STEEL

- (1) 220626 BLADE FEED ASSY
- (1) 220644 SPACER BLOCK
- (4) 221540 5/16-18 X 3 1/2" L SHCS
- (1) 220676 GROOVING BLADE .375
- (1) 220677 GROOVING BLADE .375
- (2) 220656 BLADE FEED ASSY
- (2) 220657 BLADE FEED ASSY
- (4) 20103 5/16-18 X 2 1/4" SHCS

PARTS IN 3041 KIT FOR 4" PIPE

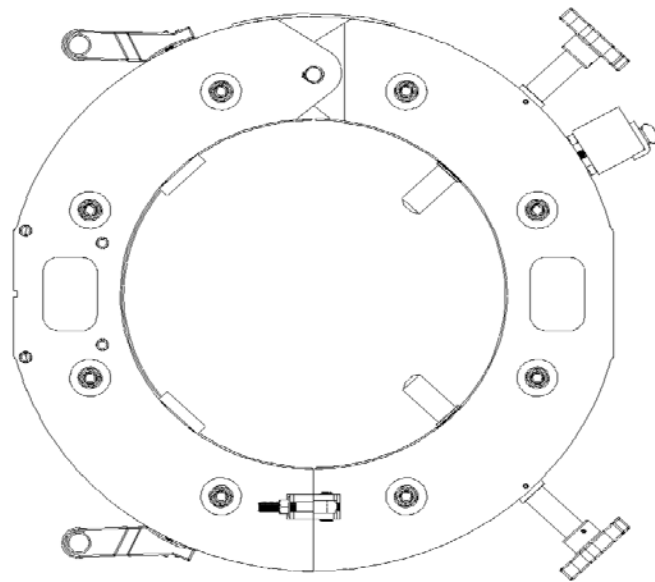
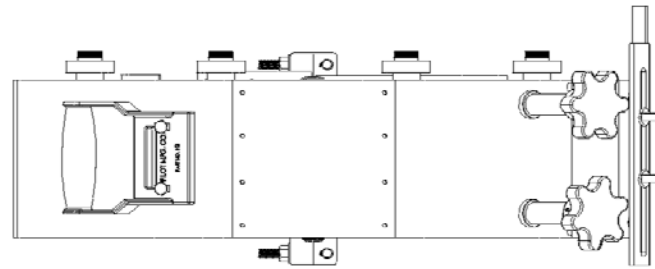
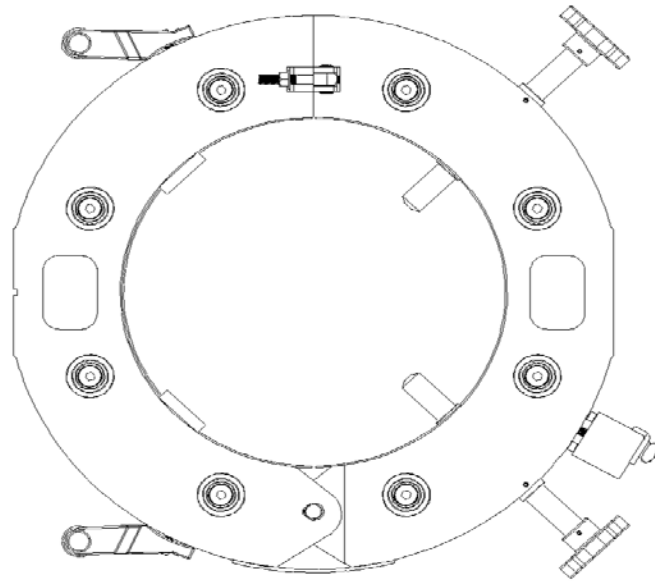
- (1) 220697 BLADE
- (1) 220735 ADAPTER PLATE
- (1) 220735 ADAPTER PLATE
- (4) 220667 5/16-18 X 3/4" L SHCS
- (4) 220666 5/16-18 X 2" L SHCS
- (1) 220766 EXTENDER CLAMP SCREW
- (1) 220766 EXTENDER CLAMP SCREW
- (1) 220766 EXTENDER CLAMP SCREW
- (2) 220670 4" RIFER ASS'Y (W/ FASTENING SCREWS)



5412 OPMT Page 3

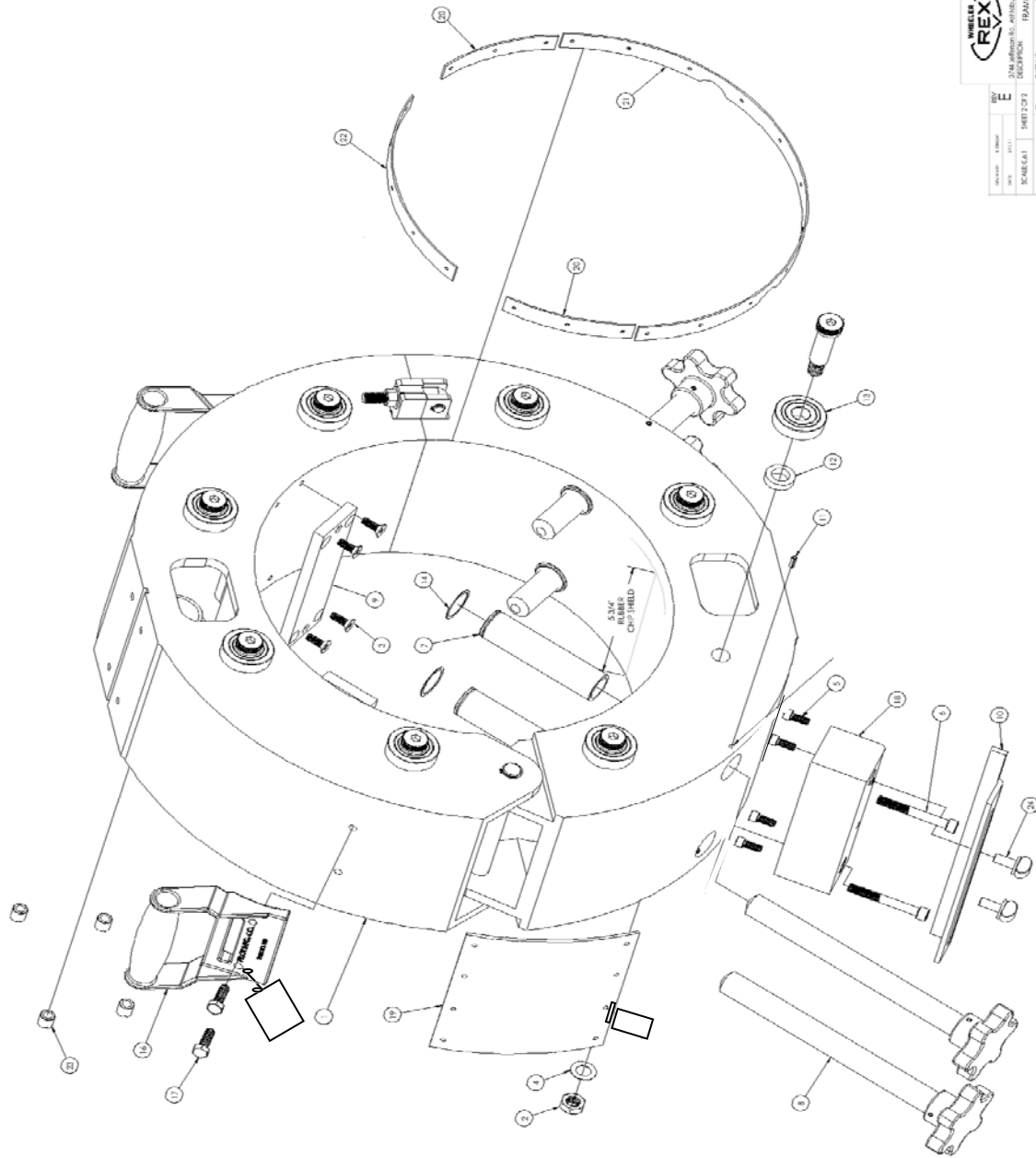
Item	Part No	Description	Qty
1	220101	FRAME ASSEMBLY	1
2	275648	1/4" KEY	1
3	220620	PINION DRIVE ASSEMBLY	1
4	220515	GEAR PLATE ASSEMBLY	1
5	221260	BLADE FEED ASSEMBLY	2
6	220656	BLADE FEED ASSEMBLY	2
7	220687	10" STEEL RISER BLOCK ASSEMBLY	2
8	220691	8" STEEL RISER BLOCK ASSEMBLY	2
9	220695	6" STEEL RISER BLOCK ASSEMBLY	2
10	220684	RISER PLATE - 12" STEEL PIPE O.P.C.	2
11	220666	SPACER BLOCK 10" & 12"	2
12	220665	SPACER BLOCK 8"	2
13	220664	SPACER BLOCK 4" & 6"	2
14	3022	DRILL MOUNT, MOTOR & SWITCH	1
15	220736	CUTOFF BLADE HOLDER ASSEMBLY	2
16	275036	5/16-18 x 2 1/2" SHCS	2
17	220571	GROOVING BLADE HSS .375	1
18	220572	GROOVING BLADE HSS .438	1
19	220570	GROOVING BLADE HSS .500	1
20	220699	GAUGE-BLADE EXPOSURE	1
21	3041	4" STEEL ADAPTER PKG.	1
22	220653	BLADE BLOCK ASSEMBLY	2
23	700314	UPPER GUARD	1
24	700313	LOWER GUARD	1
25	220808	R.H. CUTOFF BLADE	1
26	220809	L.H. CUTOFF BLADE	1
27	276651	1/4-20 x 1/2" STAINLESS STEEL BHCS	2
28	20103	5/16-18 x 2 1/4" SHCS	10
29	275111	5/16-18 x 3 1/4" LONG SHCS	8
30	700595	NAME PLATE	1
31	276203	METAL TAK	4
32	220678	GROOVING BLADE HSS .375	1
33	220676	GROOVING BLADE HSS .500	1
34	220677	GROOVING BLADE HSS .438	1
35	275140	5/16-18 x 3 1/2" Long SHCS	8
36	275117	5/16-18 x 1/2" UNDERCUT FLAT HEAD	4
37	124106	SET OF ALLEN WRENCHES ***NOT	1
38	275757	TOOL BOX *** NOT SHOWN***	1
39	220289	SHIPPING CASE ***NOT SHOWN***	1
40	276395	#2 TWIST LINK CHAIN ***NOT SHOWN***	2
41	275303	6" EXTRA HEAVY T-HINGES ***NOT	2
42	275735	1/4 X 3/4 SLOTTED HEAD TAP SCREWS	36
43	275544	5/8-11 NUT ***NOT SHOWN***	3
44	275559	5/8 WASHER ***NOT SHOWN***	3

220101 Frame Assembly Page 1



REX		220101	
REV	DATE	DESCRIPTION	PART NO.
E		220101	
SCALE	SHEET	220101	
	1 OF 2		
UNITS: INCHES		D	

220101 Frame Assembly Page 2

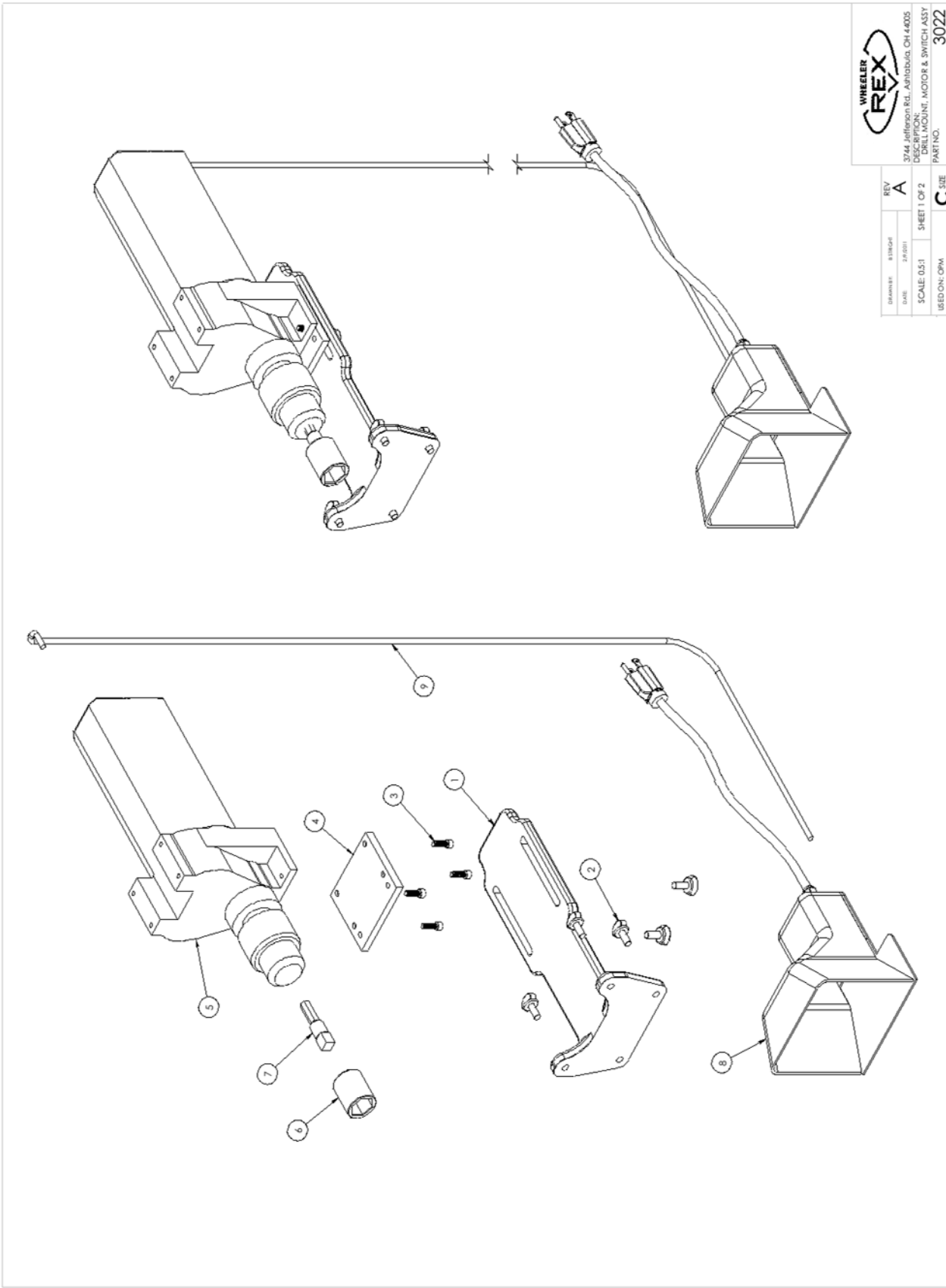


REX	
3744 3744	
REV	E
DATE	10/11
SCALE	1:1
DESCRIPTION	SHIELD 2201
LIBRARY	D
PART NO.	220101

220101 Frame Assembly Page 3

Item	PN	Description	Qty
1	700627	FRAME SUB ASSEMBLY	1
2	3828	1/2"-13 ESNA NUT	8
3	275040	1/4-20 x 3/4" FLAT HEAD CAP SCREW	8
4	119	1/2" washer	8
5	275021	1/4-20 x 5/8" SOCKET HEAD CAP SCREW	4
6	275036	5/16-18 x 2 1/2" SHCS	2
7	220612	SCREW TUBE	4
8	220613	CLAMP SCREW ASSEMBLY	4
9	220683	BASE-RISER BLOCKS	2
10	223096	ACTUATOR BAR	1
11	275428	5/32" DIA x 1/2" ROLL PIN	4
12	221017	SPACER	8
13	275727	BALL BEARING	8
14	275130	RETAINING RING, SPIROLOX	4
15	275726	5/8" x 1 3/4" SHOULDER SCREW	8
16	220713	CARRYING HANDLE	2
17	1020	5/16-18 x 1" HEX HEAD CAP SCREW	4
18	700305	INDEXING BODY	1
19	220767	HINGE OPENING COVER	1
20	220768	CHIP SHIELD	2
21	220769	CHIP SHIELD	1
22	220780	CHIP SHIELD	1
23	275817	THREADED INSERT, EZ LOK	4
24	275707	5/16-18 x 1" THUMBSCREW	2
25	276203	METAL TAK ***(NOT SHOWN)***	33
26	276596	METAL TAK ***(NOT SHOWN)***	8

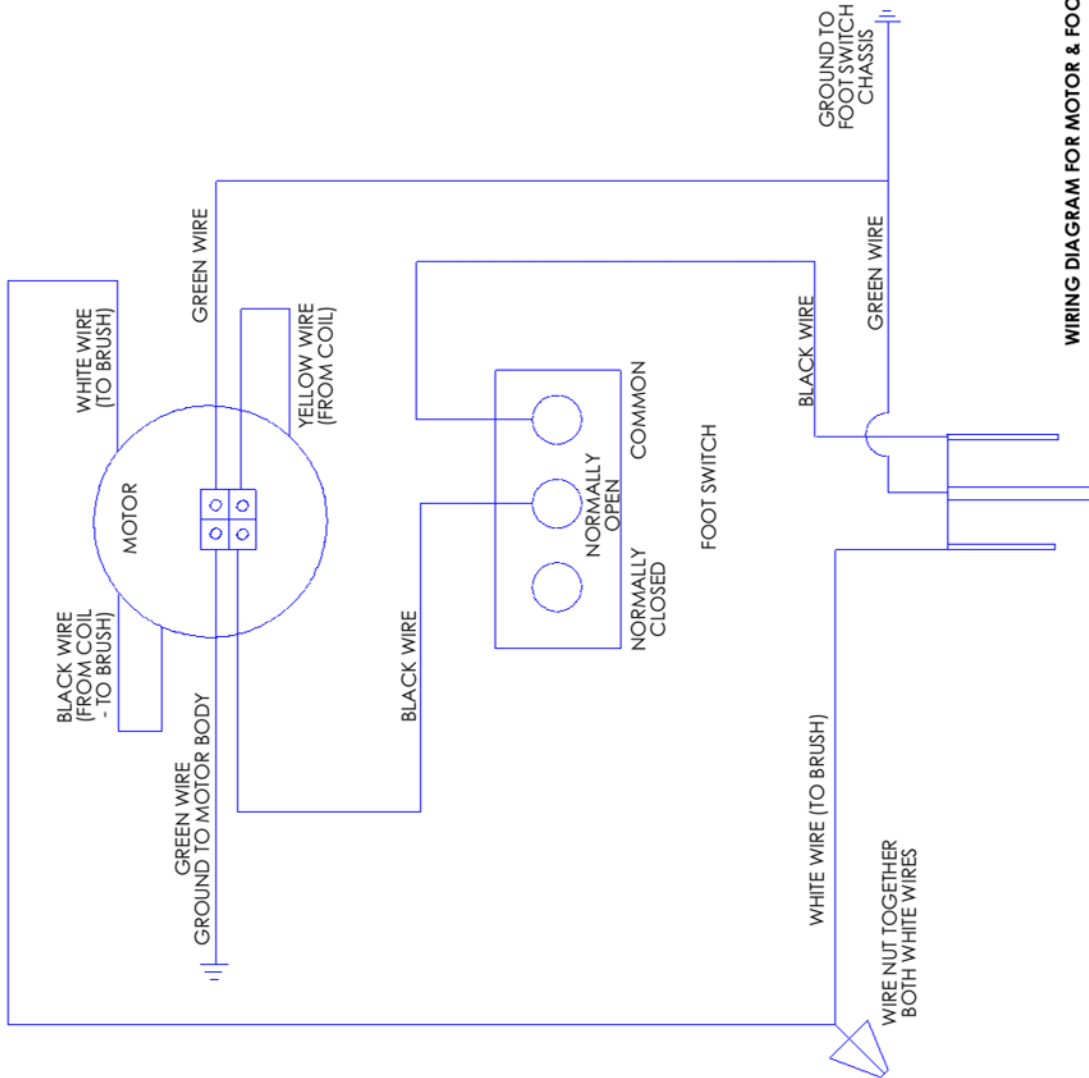
3022 Drill Mount, Motor, Switch Assembly Page 1



		REV	A
		DATE	2/28/01
DRAWN BY	81824P	SCALE	0.5:1
DATE	2/28/01	BY	OPM
3744 Jefferson Rd., Ashford, GA 30405 DESCRIPTION: DRILL MOUNT, MOTOR & SWITCH ASSY PART NO. 3022		SHEET	1 OF 2
WEDON: OPM		SIZE	C

3022 Drill Mount, Motor, Switch Assembly

Page 2



WIRING DIAGRAM FOR MOTOR & FOOTSWITCH ASSY

PLUG


 3744 Jefferson Rd., Ashtabula, OH 44005
 DESCRIPTION:

DATE	ISSUED	REV
SCALE 0.5:1	SHEET 2 OF 2	A
USED ON: OPM	SIZE	C

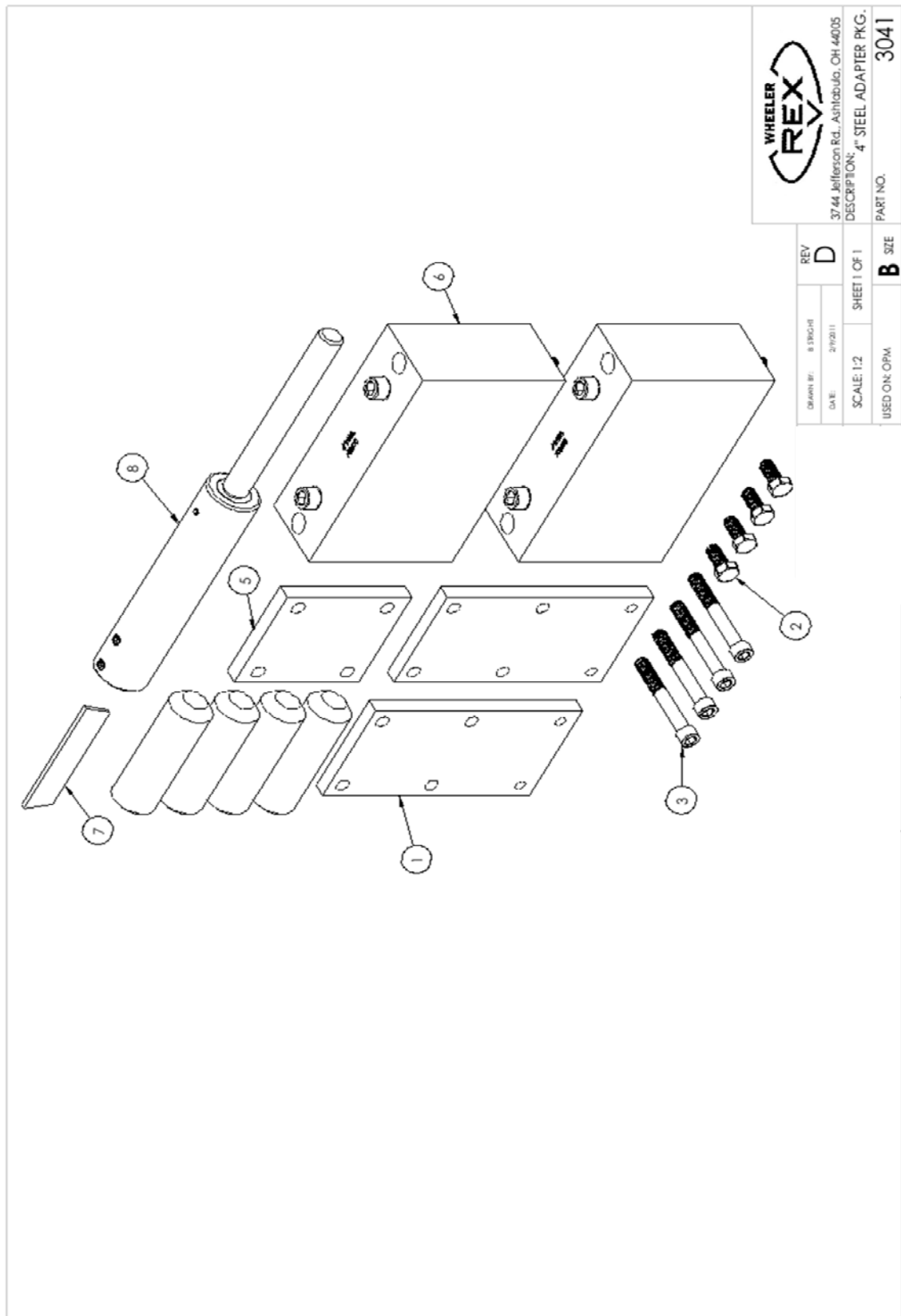
PART NO. 3022

3022 Drill Mount, Motor, Switch Assembly

Page 3

Item	PN	Description	Qty
1	700086	BRACE	1
2	275707	5/16-18 x 1" THUMBSCREW	6
3	4181	1/4-20 x 3/4" SHCS	4
4	220868	PLATE	1
5	275466	MILWAUKEE DRILL MOTOR 4262-1	1
6	275494	1" IMPACT SOCKET	1
7	275576	ADAPTER	1
8	901	FOOT SWITCH	1
9	221448	WIRE	1

3041 4" Steel Adapter Pkg Page 1



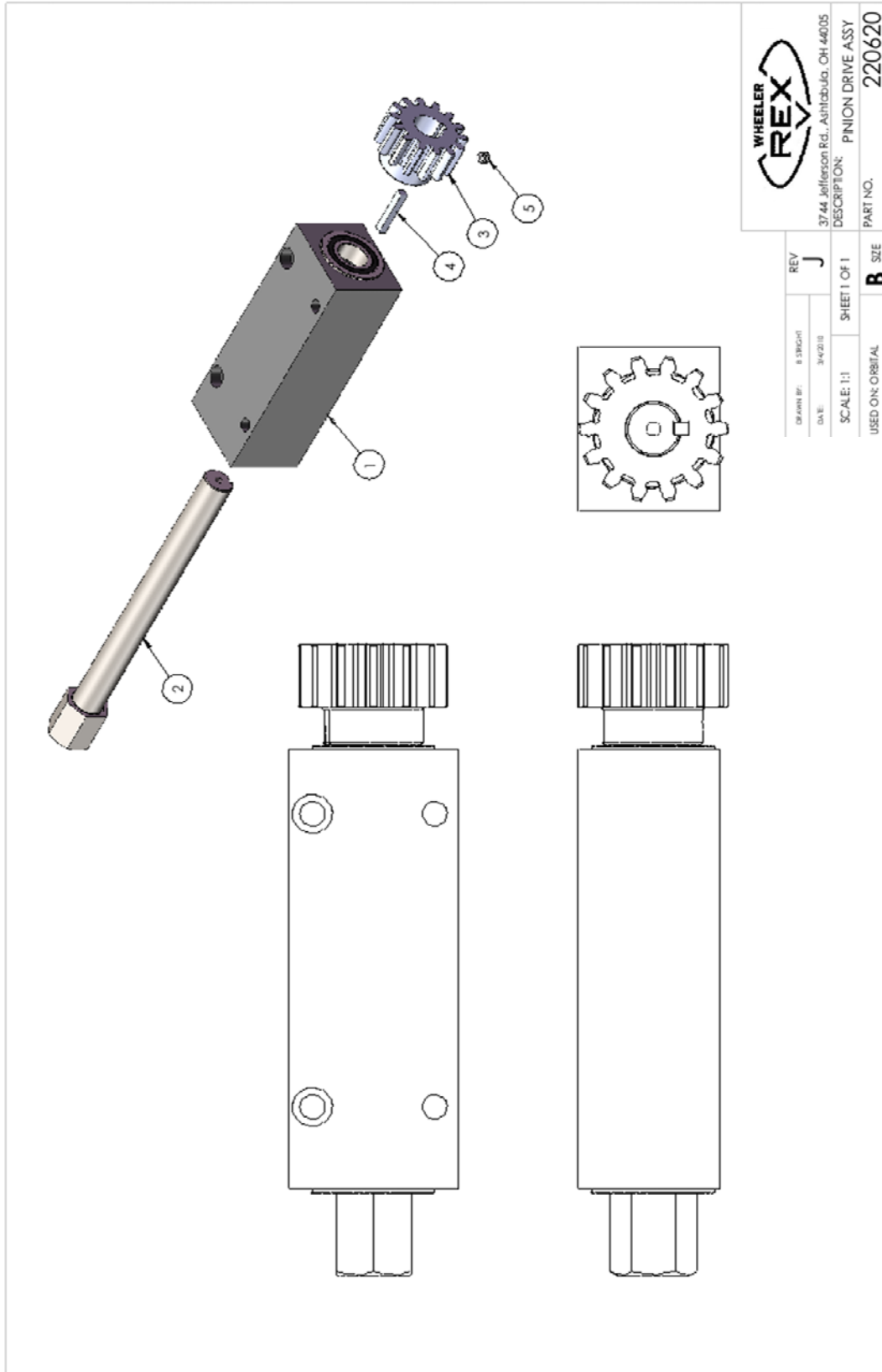

 3744 Jefferson Rd., Ashland, OH 44005
 DESCRIPTION: 4" STEEL ADAPTER PKG.
 PART NO. 3041

REV	D	SIZE	B
DRAWN BY: B. SINGH	DATE: 2/19/2011	SHEET 1 OF 1	USED ON: OPM

3041 4" Steel Adapter Pkg Page 2

Item	PN	Description	Qty
1	220753	ADAPTER PLATE	2
2	166	5/16-18 x 3/4 HEX HEAD CAP SCREW	4
3	275036	5/16-18 x 2 1/2" SHCS	4
4	220754	EXTENDER-CLAMP SCREW	4
5	220779	SPACER BLOCK 3" & 4" PIPE OPM CUT & BEVEL	1
6	700570	4" STEEL RISER ASSEMBLY	2
7	220697	BLADE BLANK	1
8	220766	EXTENDED BLADE HOLDER ASSEMBLY	1

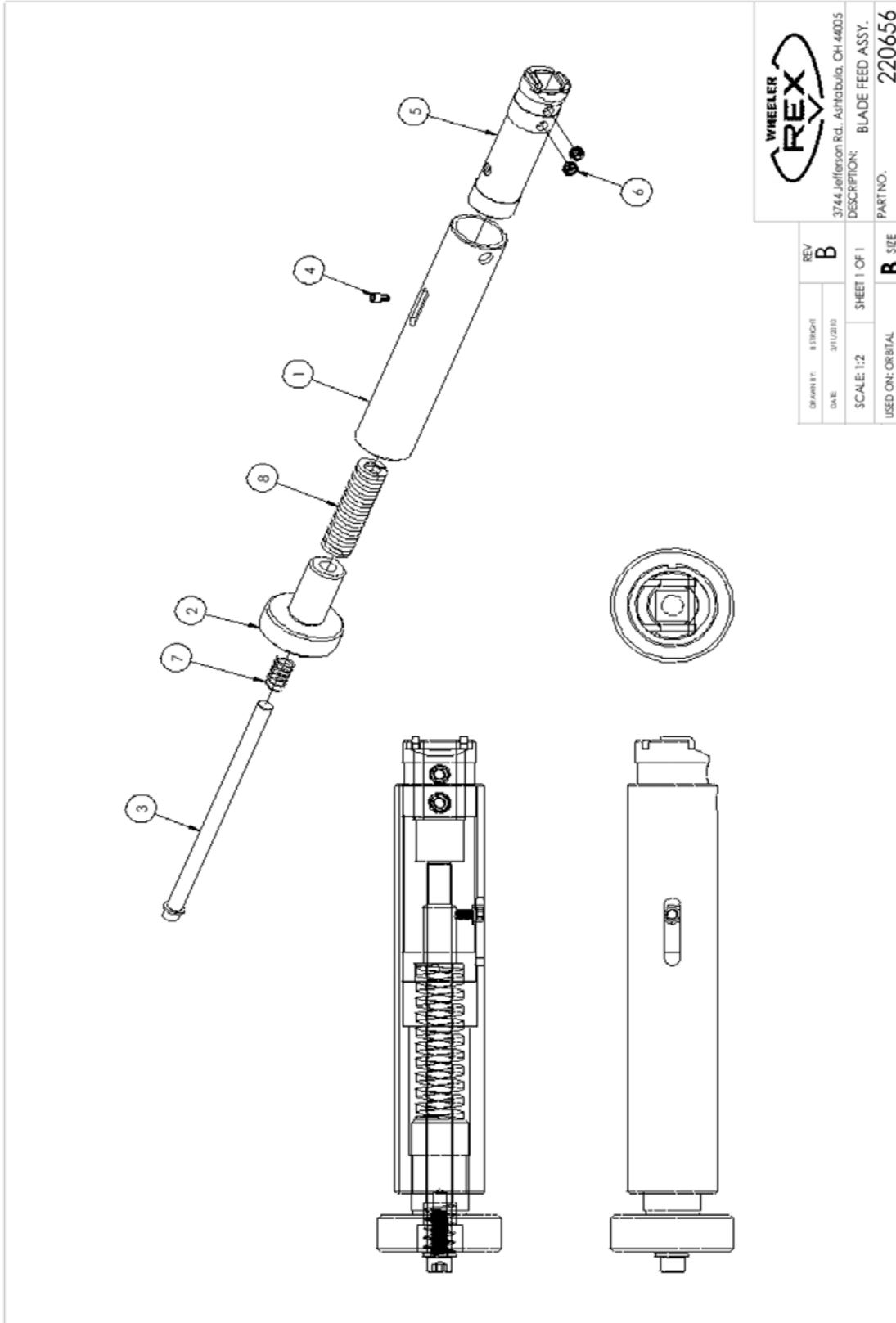
220620 Pinion Drive Assy Page 1



220620 Pinion Drive Assy Page 2

Item	PN	Description	Qty
1	220621	PINION BLOCK ASSEMBLY	1
2	221283	PINION SHAFT OPMT	1
3	220626	PINION GEAR	1
4	275083	KEY	1
5	275019	1/4-20 x 1/4" LONG SET SCREW	1

220656 Blade Feed Assy Page 1



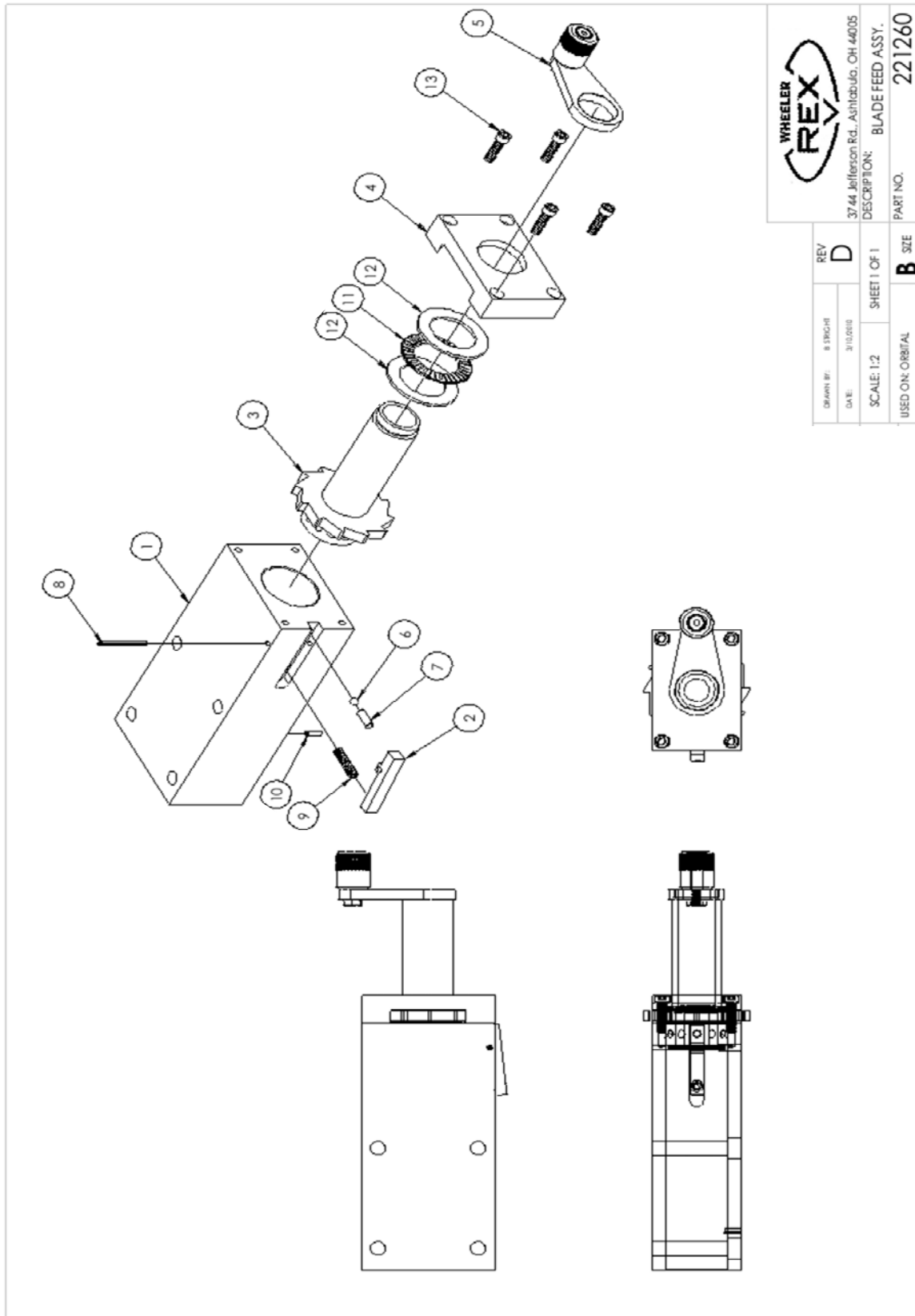
3744 Jefferson Rd., Ashtabula, OH 44005
 DESCRIPTION: BLADE FEED ASSY.
 PART NO. 220656

DRAWN BY:	8/3/00	REV	B
DATE:	9/11/01	SHEET 1 OF 1	
SCALE:	1:2	USED ON:	ORBITAL
		SIZE	B

220656 Blade Feed Assy Page 2

Item	PN	Description	Qty
1	220657	BLADE FEED BODY	1
2	220659	HAND KNOB	1
3	220658	GUIDE/ADJUST ROD ASSEMBLY	1
4	220115	GUIDE SCREW	1
5	220660	BLADE HOLDER ASSEMBLY	1
6	275009	5/16-24 x 1/4" SET SCREW	2
7	1531	SPRING	1
8	275108	SPRING	1

221260 Blade Feed Assy Page 1



3744 Jefferson Rd., Ashland, OH 44005
 DESCRIPTION: BLADE FEED ASSY.
 PART NO. 221260

DRAWN BY: 81904T	REV
DATE: 3/10/2010	D
SCALE: 1:2	SHEET 1 OF 1
USED ON: ORBITAL	B SIZE

221260 Blade Feed Assy Page 2

Item	PN	Description	Qty
1	221261	BLADE BLOCK	1
2	221262	DETENT LEVER	1
3	221265	STARWHEEL TUBE ASSEMBLY	1
4	221267	CAP PLATE	1
5	221268	CRANK ARM ASSEMBLY	1
6	203197	3/16" DIAMETER BALL	1
7	275807	DOWEL PIN	1
8	275053	1/8" DIA x 1 1/4" ROLL PIN	1
9	275052	SPRING	1
10	275574	1/8 DIA x 3/8" SPRING PIN	1
11	275801	THRUST BEARING, NTA-613	1
12	275802	THRUST RACE	2
13	6513	#10-24 SHCS	4



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