HISAKI

Bar Cutter

Operation & Instruction Manual

TROUBLE SHOOTING

When any malfunction is noted, immediately shutdown the machine. Some simple trouble shooting are given as below :

Fault	Cause	Action
Engine stops suddenly or does not run	No fuel in the engine	Refill fuel
	Spark plug carbonized	Clean spark plug
	Containment is being snagged up to fuel strainer	Clean fuel strainer
Engine runs but the machine does not run	Air cleaner is full of dust	Clean air filter
	Shortage of engine power	Refer to engine manual
	Clutch slip	Refer to engine manual
Cutter is slow or erratic	Over flowing of oil in crankcase	Lack of oil
	Loose V-belt	Adjust V-belt

IF THE FAULT PRESISTS, CONTACT YOUR LOCAL DEALER.

FOREWORD

Thank you for your selection of **HISAKI BAR CUTTER**. This manual contains necessary maintenance information for you to ensure proper operation and care for this machine. Thus, it is essential for you to read through this manual thoroughly. Please do not hesitate to contact your local dealer or agent for any problem or suggestion as we always welcome feedback and comments from our valued customers.

! CAUTION

This safety alert symbol identifies important safety messages throughout this manual.
When you see this symbol, carefully read the message that follows.

CONTENTS

Lubrication Tips

DESCRIPTION	LUBRICANT	LUBRICANT FREQUENCY
Cutter	Grease	2 times / shift
Connection Lever NO. 2	Engine Oil No. 20	2 times / shift
Gear s Couple (1st grade)	Graphite Grease	1 time / shift
Gear s Couple (2nd grade)	Graphite Grease	1 time / shift
Gear s Couple (3rd grade)	Graphite Grease	1 time / shift
Eccentric bearing	Grease with Ca Base No.2	1 time / shift

MAINTENACE & STORAGE

! CAUTION

FLAMMABLE LIQUID. When performing maintenance, stop engine and do not smoke in adjacent area.

HIGH TEMPERATURE. Allow machine and engine to cool down before performing maintenance. Contact with hot components can cause serious injury.

Moving part. Shut down engine before maintenance. Contact with moving parts can cause serious injury.

This machine should be :

- used in dry circumstance. When used in working field, the temporary house for the machine should be made.
- If the machine will not be used for long, please coat the metal surface without coat with the rust – proof grease and keep it in dry and airy store – house.
- kept clean, the rust on the cutter should be wiped regularly.
- If the temperature of the bearings is too high, maintenance should be done in time.

SPECIFICATIONS

HISAKI bar cutter is mainly used in architectural engineering, working fields and prefab factories. It is also used to cut the steel materials with round and square section.

It is of good cutting ability and convenient operation, and can be used without fault for long time, and need not be maintained regularly.

Specifications table:

Max. Bar Dia. (mm)	32	42
Continuous Bar Dia.(mm)	28	38
Diesel Engine (hp)	6/7	10/12
Steel Bar Tensile Strength	450N/mm²	
Measurement (LxWxH)	1480 X 875 X 775mm	1828 X 736 X 838mm
Weight (kg)	750	850

Safety Precautions

Before operating this equipment, the operator should read this manual. Whenever possible, he/she should be shown how to operate the unit by an experienced operator. It is dangerous for an inexperience person to operate any machine. Trial and error is not the safe way to become familiar with a piece of equipment.

- **WEAR SAFETY BOOT, HELMET, SHATTER PROOF GLASESS** and other protective devices required by job conditions. Avoid loose clothing. These may trap in moving parts and cause serious injury.
- Be cautious with the ventilation of work place. **AVOID OPERATING MACHINE IN CLOSED AREA**, since engine exhaust contains poisonous gases.
- **BE CAREFUL WITH HOT COMPONENTS**. Mufflers and other parts of engine are hot during operation and right after shut down.
- Fasten fuel cap tightly and closed fuel strainer cock during transportation.
- People are not operators are not allowed to stay in the vicinity of the steel bar cutter and within the moving range of the steel bar.

SHUTDOWN

Step 1. Push the red stop button, the engine stops completely.

Step 2. Close engine fuel cock.

Step 3. Cover the machine after the muffler had cooled off and keep the bender in dry place.

EMERGENCY SHUT DOWN :

Move throttle lever to OFF.

Step 3. Clutch Step

- After the former steps have been made, step on the clutch step (refer Figure 3) to cut the steel bar. It is unnecessary to let clutch step reset when successive cutting is done.

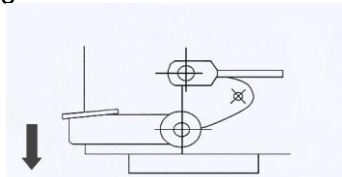

Figure 3

NOTE : Please check the lubricant level before start the machine. Cutting operation can not be done until the engine starts and runs for over 10min. Cutting operation should be stopped if the power turns off (See Figure 4)

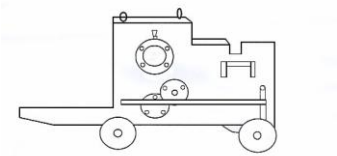

Figure 4

Step 4. The steel bar which dia. And strength is larger than the stipulation & the red – hot steel bar should not be cut. When a few steel bars are cut once, the total size of the section should not be larger than the stipulation.

IMPORTANT : The machine is not allowed to be adjusted when running. If faults such as cutter loosing abnormal running and /or noise are found, the machine must be stopped to maintenance.

PRE START UP CHECKING

i. Install the diesel engine and check the running direction:

- The installed diesel engine should be connected to the transmission of the machine, then check the running direction by rotating the diesel engine with the handle. The big gear should run clockwise when looking down, and is not allowed to run reversely.

ii. Lubricate According to the Requirements

- Check the connection reliability of the operative system and check if the nuts are loose. When new machine or one which is in store for long time is used; please check the function of operative system: Step on the step (Fig 1, NO.4) and see if the clutch is in gear (if the step don't move, please rotate the diesel engine with the handle and make the big gear run slightly), then check if the roller arm runs respondent when rotate the diesel engine with handle. At last, move the handle of dial (Fig. 1. NO. 3) Clockwise for abort 50mm and see if the clutch is separated.

STARTING

CAUTION

Make sure nobody is in front of the bar bender when starting the engine; it might jerk forward with force.

Step 1. Open engine fuel cock.

Step 2. Set engine leveler to 70% “START” position.

Step 3. For engine starting, open valve choke (below engine air filter)

Step 4. While holding open valve choke, use hand crank to rotate crank pulley clockwise from slow to fast revolution.

IMPORTANT : Do not rotate crank pulley from fast to slow as starting of the engine depends on the rotating inertia of crank pulley, the faster the crank pulley, the more inertia it builds to start the engine.

Step 5. Close choke when smoke comes out of exhaust and rotate crank pulley faster until engine starts.

OPERATION

CAUTION

Be careful with hot components, mufflers and other engine parts are hot during operation. Do not touch them.

Step 1. Check the turning direction

- Check the power connection, and make sure that the flying wheel turns in direction as per *Figure 1*.

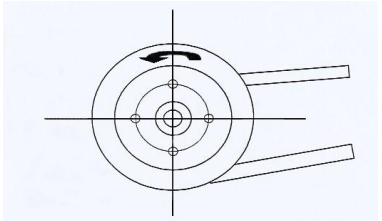

Figure 1

Step 2. Steel Bar Location

- The location of steel bar to be cut should be adjusted properly so that it can be cut accurately as per Figure 2.

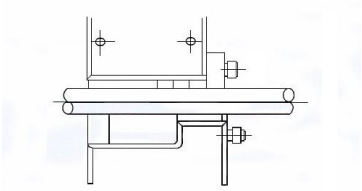

Figure 2