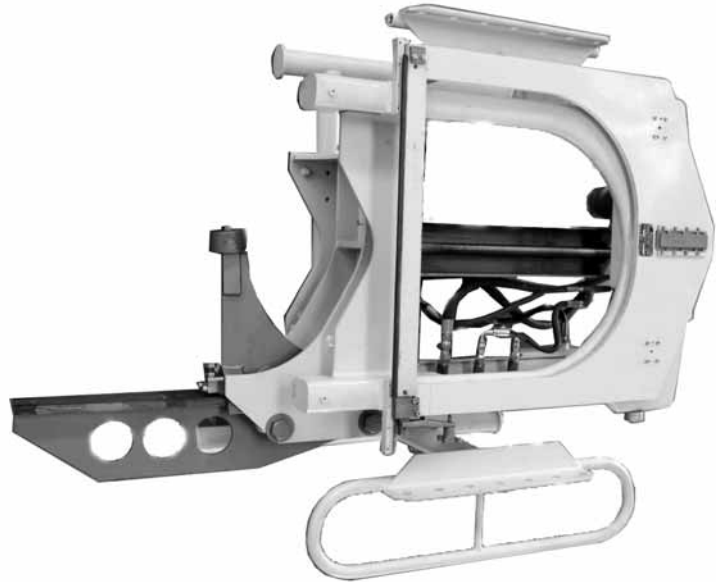




Wachs Subsea  
15331 Vantage Parkway East  
Houston, TX 77032  
[www.ehwachs.com](http://www.ehwachs.com)

# Autoclamp/Autofeed Guillotine® Super D Pipe Saw User's Manual



E.H. Wachs Part No. 06-150-510-MAN  
Rev. A, November 2014

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**EU DECLARATION OF CONFORMITY  
WITH  
COUNCIL DIRECTIVE 2006/42/EC**

<b>Issue Details:</b>	Date: 9/19/2014	Place: E.H. Wachs, Lincolnshire, IL USA
<b>Directives:</b>	Machinery Safety Directive 2006/42/EC	
<b>Conforming Machinery:</b>	Super D Saw Subsea Topside Control Unit	
<b>Model Number:</b>	P06-150-510 H10-023-000	
<b>Serial Number:</b>		
<b>Manufacturer:</b>	<b>E.H. Wachs Company</b> 600 Knightsbridge Parkway Lincolnshire IL 60069 USA	
<b>Responsible Representative:</b>	Orbitalum Tools GmbH Josef-Schüttler-Str. 17, 78224 Singen Germany Tel. +49 (0) 7731 - 792 872 Fax +49 (0) 7731 - 792 566	
<b>Harmonised Standards &amp; Other Technical Standards/Specifications Applied or Referenced:</b>	EN ISO 12100:2010, EN ISO 13849-1-2, EN ISO 61310-1-2:2008, EN ISO 4413:2010, ISO 6149-1-2-3, ISO 11688-1, ISO 19902	
<b>Provisions with which Conformity is Declared:</b>	Essential Health and Safety Requirements of Annex 1 of the Machinery Directive	
<b>We hereby certify that the machinery described above conforms to the provisions of Council Directive 2006/42/EC on the approximation of the laws of the Member States relating to the safety of machinery.</b>		
<b>Signed:</b>		
<b>Signatory:</b>	Pete Mullally Quality Manager E.H. Wachs	

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# Chapter 1

## About This Manual

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### PURPOSE OF THIS MANUAL

This manual explains how to operate and maintain the Guillotine<sup>®</sup> Super D Pipe Saw. It includes instructions for set-up, operation, and maintenance, with special instructions for the optional autoclamping and autofeed accessories. It also contains parts lists, diagrams, and service information to help you order replacement parts and perform user-serviceable repairs.

Before operating the Guillotine<sup>®</sup> Pipe Saw, you should read through this manual and become familiar with all instructions. At a minimum, make sure you read and understand the following chapters:

- Chapter 1, About This Manual
- Chapter 2, Safety
- Chapter 3, Introduction to the Equipment
- Chapter 5, Operating Instructions
- Chapter 9, Accessories

If you will be performing service or repairs, make sure you read and understand these chapters:

- Chapter 1, About This Manual
- Chapter 4, Assembly and Disassembly
- Chapter 6, Routine Maintenance

### In This Chapter

HOW TO USE THE MANUAL

SYMBOLS AND WARNINGS

MANUAL UPDATES AND  
REVISION TRACKING

Throughout this manual, refer to this column for warnings, cautions, and notices with supplementary information.

- Chapter 7, Service and Repair.
- You will also want to refer to Chapter 8, Parts Lists and Drawings.

---

## HOW TO USE THE MANUAL

This manual is organized to help you quickly find the information you need. Each chapter describes a specific topic on using or maintaining your equipment.

Each page is designed with two columns. This large column on the inside of the page contains instructions and illustrations. Use these instructions to operate and maintain the equipment.

The narrower column on the outside contains additional information such as warnings, special notes, and definitions. Refer to it for safety notes and other information.

---

## SYMBOLS AND WARNINGS

The following symbols are used throughout this manual to indicate special notes and warnings. They appear in the outside column of the page, next to the section they refer to. Make sure you understand what each symbol means, and follow all instructions for cautions and warnings.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



### NOTE

This symbol indicates a user notice. **Notices** provide additional information to supplement the instructions, or tips for easier operation.

---

## MANUAL UPDATES AND REVISION TRACKING

Occasionally, we will update manuals with improved operation or maintenance procedures, or with corrections if necessary. When a manual is revised, we will update the revision history on the title page.

You may have factory service or upgrades performed on the equipment. If this service changes any technical data or operation and maintenance procedures, we will include a revised manual when we return the equipment to you.

Current versions of E.H. Wachs Company manuals are also available in PDF format. You can request an electronic copy of this manual by emailing customer service at [sales@wachsco.com](mailto:sales@wachsco.com).





## Chapter 2

# Safety

E.H. Wachs takes great pride in designing and manufacturing safe, high-quality products. We make user safety a top priority in the design of all our products.

Read this chapter carefully before operating your E.H. Wachs equipment. It contains important safety instructions and recommendations.

---

### SAFE OPERATING GUIDELINES

Follow these guidelines for safe operation of all E.H. Wachs equipment.

- **READ THE OPERATING MANUAL.** Make sure you understand all setup and operating instructions before you begin. Keep this manual with the machine.
- **INSPECT MACHINE AND ACCESSORIES BEFORE USE.** Before starting the machine, look for loose bolts or nuts, leaking lubricant, rusted components, and any other physical conditions that may affect operation. Properly maintaining the machine can greatly decrease the chances for injury.
- **ALWAYS READ STICKERS AND LABELS.** Make sure all labels and stickers are in place, clearly legible, and in good condition. Refer to “Safety Labels” later in this chapter for label locations on the machine. Replace any damaged or missing safety labels; see Chapter 10 for ordering information.

### In This Chapter

SAFE OPERATING GUIDELINES

SAFE OPERATION OF THE SUPER  
D GUILLOTINE PIPE SAW

SAFETY AND OPERATION  
LABELS



Look for this symbol throughout the manual. It indicates a personal injury hazard.

- **KEEP CLEAR OF MOVING PARTS.** Keep hands, arms, and fingers clear of all rotating or moving parts. Always turn the machine off and disconnect the power source before doing any adjustments or service.
- **SECURE LOOSE CLOTHING AND JEWELRY.** Secure or remove loose-fitting clothing and jewelry, and securely bind long hair, to prevent them from getting caught in moving parts of the machine.
- **FOLLOW SAFE PROCEDURES FOR HANDLING LUBRICANTS.** Refer to the manufacturer's instructions and the Material Safety Data Sheets.

### Safe Operating Environment

- Do not use this equipment in a potentially explosive atmosphere. Fire or explosion could result, with the risk of serious injury or death.
- Provide adequate lighting to use the equipment, in accordance with worksite or local regulations.
- **KEEP WORK AREA CLEAR.** Keep all clutter and nonessential materials out of the work area. Only people directly involved with the work being performed should have access to the area.

### Operating and Maintenance Safety

- This equipment is to be operated and maintained only by qualified, trained personnel.
- Make sure the equipment is stable when attached to the workpiece for the operation. Ensuring stability of the installed tool is the responsibility of the operator.
- Make sure the workpiece is supported adequately for installation of the equipment. This includes supporting any workpiece “fall-off” section when severing the workpiece. Ensuring support of the workpiece is the responsibility of the operator.
- Tooling on any cutting equipment—including lathe tools, saw blades, milling tools, etc.—may get very hot. Do not touch tooling until you have made sure it is cool enough to handle.
- Wear gloves when removing or cleaning up chips and cutting debris. Chips can be very sharp and cause cuts.
- Before performing any service on the equipment, disconnect the power source. Follow all lock-out/tag-out procedures required at the worksite.

### Hydraulic Powered Equipment

- Hydraulic components such as hoses, motors, and manifolds will get hot during operation and may cause burns. Do not touch hydraulic components, except for operator controls, during or after operating the machine.
- **Hydraulic injection injury**—A pinhole in a hydraulic hose or fitting can eject fluid with enough force to pierce skin. Check hoses and fittings regularly for leaks. **Do not use bare hands to check for leaks while the system is pressurized.** If you suspect a leak, move a piece of paper or cardboard at least 6 inches (15 cm) over the suspicious area and watch for fluid spraying on the surface.

### Loss or Shut-Off of Power Supply

- If the power source to the equipment is lost, disconnect power from the equipment and lock out the power supply immediately to prevent accidental restarting of the machine.
- For all power sources, follow all lock-out/tag-out procedures required at the worksite when disconnecting or servicing the equipment.

### Safety Alerts in This Manual

The following alerts are used throughout this manual to indicate operator safety hazards. In all cases, these alerts include a notice describing the hazard and the means to avoid or reduce risk. Carefully read all safety alerts.



This icon is displayed with any safety alert that indicates a personal injury hazard.

### WARNING

This safety alert, with the personal injury hazard symbol, indicates a potentially hazardous situation that, if not avoided, **could** result in **death or serious injury**.



### WARNING

Injection of hydraulic fluid through the skin is a serious injury that can result in infection, tissue damage, and possible loss of limb. **Seek medical treatment immediately.** First aid is not sufficient treatment for injection injury.

 CAUTION

This safety alert, with the personal injury hazard symbol, indicates a potentially hazardous situation that, if not avoided, **could** result in **minor or moderate injury**.

### Protective Equipment Requirements

#### **Protective Clothing**

**Wear safety shoes** when operating or servicing the equipment. Serious injury could result from dropping the machine or its components.

**Do not wear gloves** while operating the machine. Gloves can become entangled in moving parts, resulting in serious injury. Gloves may be worn when setting up the machine or cleaning up after the operation, but take them off when operating the machine.

#### **Eye Protection**

Always wear impact-resistant eye protection while operating or working near this equipment.

For additional information on eye and face protection, refer to Federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.133., Eye and Face Protection and American National Standards Institute, ANSI Z87.1, Occupational and Educational Eye and Face Protection.

#### **Hearing Protection**

This equipment can produce noise levels above 80 dB. Hearing protection is required when operating the equipment. The operation of other tools and equipment in the area, reflective surfaces, process noises, and resonant structures can increase the noise level in the area.

For additional information on hearing protection, refer to Federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.95, Occupational Noise Exposure and ANSI S12.6 Hearing Protectors.



#### **NOTE**

Gloves should be worn when cleaning up chips and other cutting debris. Chips can be very sharp and can cause serious cuts. **Do not wear gloves when the machine is operating.**

---

## SAFE OPERATION OF THE SUPER D GUILLOTINE PIPE SAW

### Intended Uses

The Super D Guillotine pipe saw is designed to be clamped onto an in-line or open-ended pipe, using a hydraulic autoclamp mechanism, and cut through the pipe using an oscillating saw motion.

**Make sure to follow all safety guidelines and procedures required for machining operations at the work site, including personal protective equipment (PPE). Do not use the Guillotine pipe saw in a manner that violates these guidelines.**

### Proper Use of the Guillotine

- The Guillotine should only be used by trained, qualified operators.
- The workpiece must be within the operating capacity of the Guillotine model you are using. See operating envelope information and drawings in Chapter 3.
- Make sure the operating environment allows you to mount the machine securely and squarely on the workpiece.
- Make sure there is adequate clearance around the Guillotine and workpiece to operate the machine controls as described in the operating instructions (Chapter 5).
- Mount the Guillotine in an orientation that allows convenient connection of the drive power supply (air or hydraulic).
- Mount the Guillotine so that the feed drive can be operated conveniently, without reaching across moving parts.
- Use the Guillotine only on empty, depressurized pipe.

### **Misuse**

- Do not attempt to mount or operate the Guillotine on any workpiece to which it cannot be securely clamped.
- Do not attempt to mount or operate the Guillotine on any workpiece that is not stable enough to hold the machine.

- Do not mount the Guillotine on the “fall-off” side of the cut line, unless you adequately rig and support the Guillotine and workpiece.
- Do not disable any safety feature of the Guillotine or remove any safety labeling. Replace worn or damaged safety labels immediately. (See “Safety and Operation Labels” later in this chapter.)

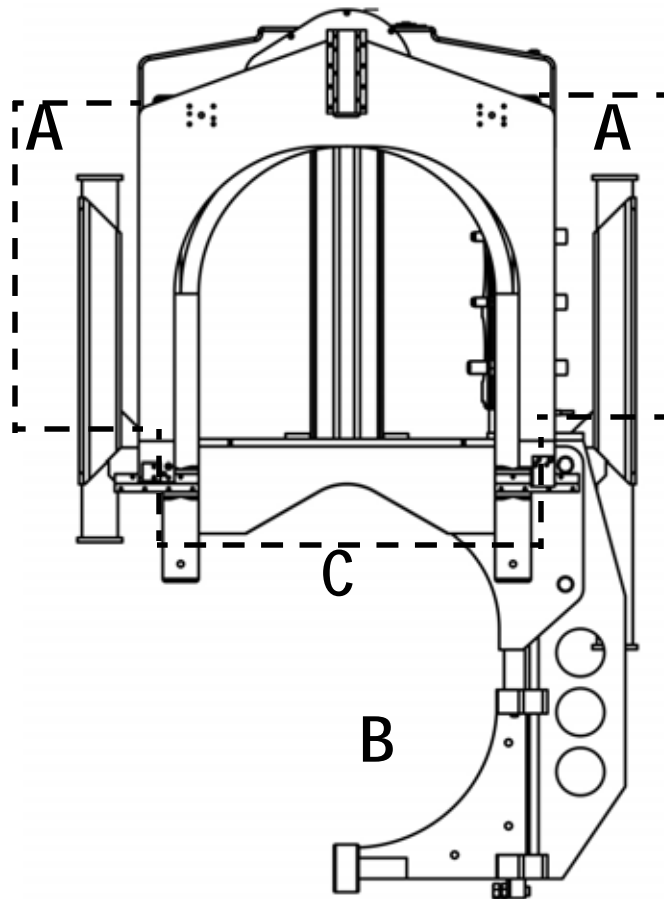
### Potential Hazards

Figure 2-1 illustrates potential hazards of operating the Guillotine pipe saw. Refer to the description of each hazard for guidelines on safe operation.

**A. Moving Parts Hazard**—Keep away from the oscillating saw bow and all moving parts while the machine is operating.

**B. Pipe Saddle Mounting Point**—Keep hands and feet clear when mounting and moving the saw on the workpiece.

**C. Cutting Zone**—Keep away from the saw blade while the machine is operating. Use care when handling the saw blade and cutting debris.



*Figure 2-1. Potential operating hazards of the Guillotine saw. See the descriptions in the side column.*

## Guidelines for Safe Setup, Operation, and Service

### **Pre-Operation Checklist**

Every time you use the Guillotine, perform the following checks to make sure it is in good operating condition:

- Check that all safety components are operating properly.
- Inspect it for damage or wear that could affect operation and safe use of the machine. Repair any defective component before using the machine.
- Make sure the machine is clean and properly lubricated.
- Make sure that the blade is sharp and in good condition. A poor quality blade can cause difficult cutting and the possibility of machine malfunction and/or injury.
- Check power connections to make sure they are in good condition.

### **Operating Safety**

- Stop the Guillotine cutting motion to adjust the workpiece (shim, wedge, clear chips, etc.) or make any machine adjustments.
- Use a support structure or catch device to prevent the cut-off piece of the pipe from falling.
- Keep hydraulic hoses away from moving parts while operating the machine.

### **Service Checklist**

- Disconnect power from the Guillotine during service.
- Retract the saw bow before performing service. Do not disassemble any components of the saw with the blade in the workpiece.

## Safe Lifting and Handling

Use care when lifting the Guillotine saw to avoid injury. A lifting device (crane or hoist) is required for lifting and mounting the saw.

- Use the lift eyes on the saw to lift it. **Do not attach the lifting device to other components.**
- Do not rig or lift the Guillotine while power is attached.

### **Machine Weight**

The weight of the Super D Guillotine is 1,100 lb (500 kg).

---

### **SAFETY AND OPERATION LABELS**

The following labels are provided on the Guillotine. If any of these labels is damaged or missing, replace it immediately. See Chapter 8 for ordering information.



*Figure 2-2. The Lubrication and Safety Harness labels are on the top of the saw bow, with the product plate.*





*Figure 2-3. The crush hazard warning label is attached in 2 places on the saw frame assembly.*



*Figure 2-4. The crush hazard warning label and blade direction label are attached on both sides of the saw bow.*



## Chapter 3

# Introduction to the Super D Pipe Saw

Read this chapter carefully to become familiar with the components of the Guillotine® Super D pipe saw.

---

### USAGE AND APPLICATIONS

The Guillotine® Super D pipe saw is designed for cold-cutting pipes of any material from 10” to 24” diameter, as well as solids such as bar stock and rails. The saw has a “V”-saddle base that ensures square alignment with the workpiece, and an autoclamping mechanism to simplify installation on the workpiece. The Guillotine® Super D will cut approximately one diameter inch per minute.

The reciprocating motion of the Guillotine® saws lifts the blade from the cut on the return stroke, greatly increasing blade life. Blades are easily changed out when worn.

Guillotine® saws are available for hydraulic, electric, and pneumatic power sources. Available accessories include hydraulic autoclamping for fast setup in difficult environments (such as underwater cutting) and adjustable autofeed for automated cutting.

---

### MECHANICAL OVERVIEW

Figure 3-1 and Figure 3-2 illustrate the mechanical components of the Super D pipe saw. Figure 3-3 shows the

### In This Chapter

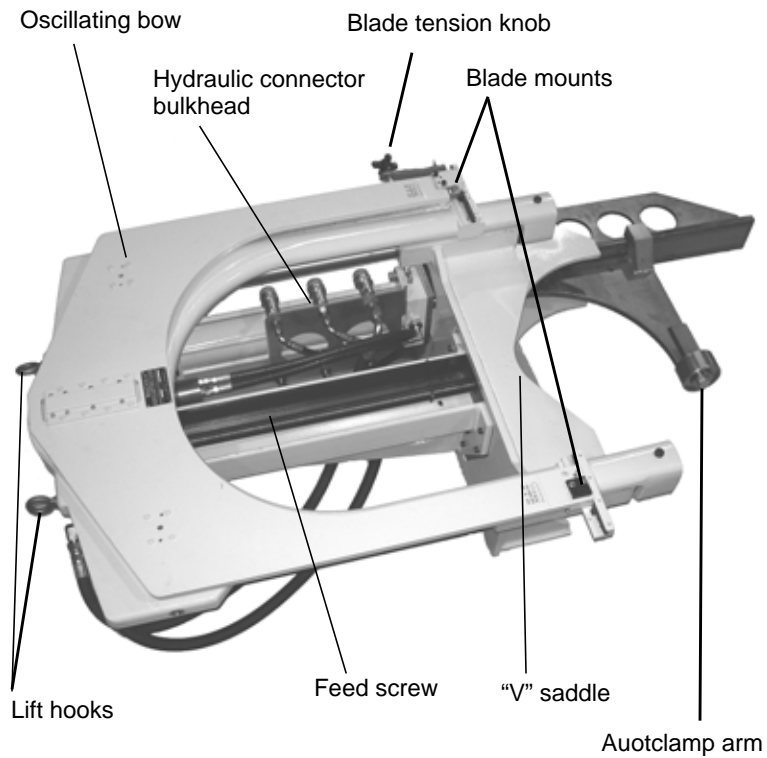
USAGE AND APPLICATIONS

MECHANICAL OVERVIEW

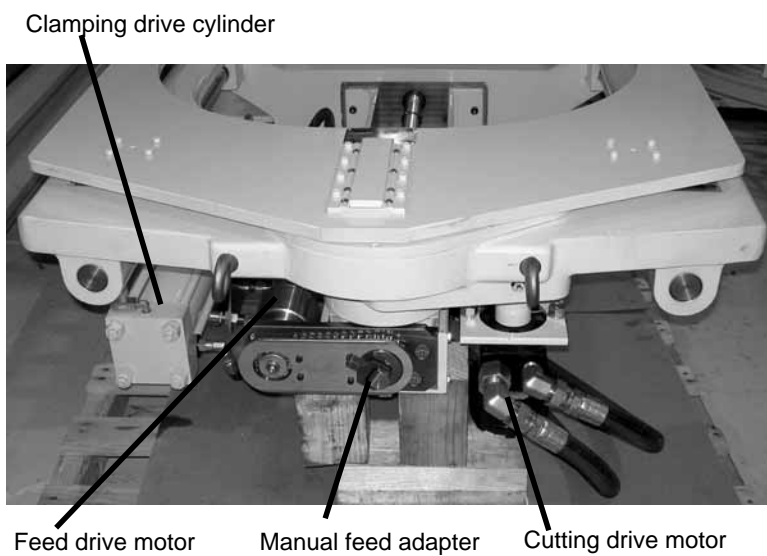
MACHINE SPECIFICATIONS

OPERATING ENVELOPE

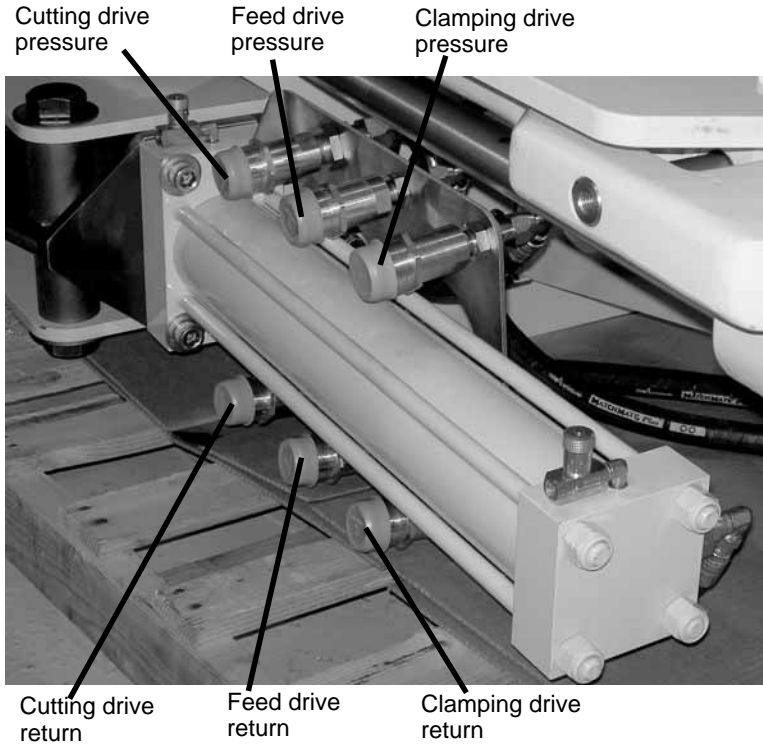
hydraulic connector bulkhead. Refer to them during set-up instructions for identifying the parts of the machine.



*Figure 3-1. The photo illustrates the mechanical components of the Super D pipe saw.*



*Figure 3-2. The Super D drive components are illustrated.*



*Figure 3-3. The photo shows the hydraulic connector bulkhead.*

### Universal Control Panel (UCP)

Figure 3-4 illustrates the controls used to operate the Guillotine. Chapter 5 includes detailed instructions.



### **NOTE**

For CE compliance, the Super D Guillotine must be operated using a Wachs Sub-sea UCP.

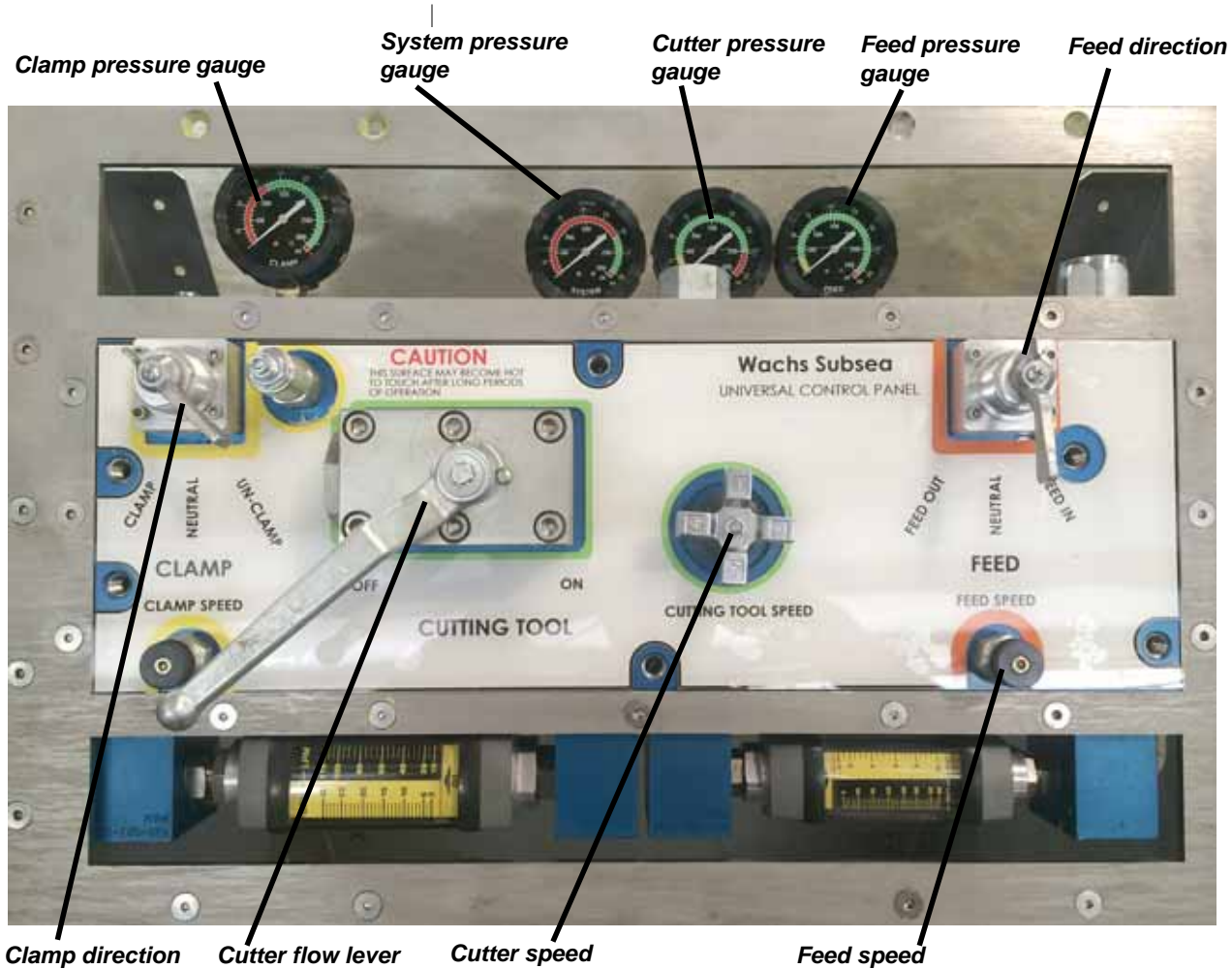


Figure 3-4. The photo illustrates the controls on the universal control panel. (Some UCP models have a different arrangement; see labeling on the UCP.)

## MACHINE SPECIFICATIONS

The following specifications are for the Guillotine® Super D with autofeed and autoclamping accessories installed.

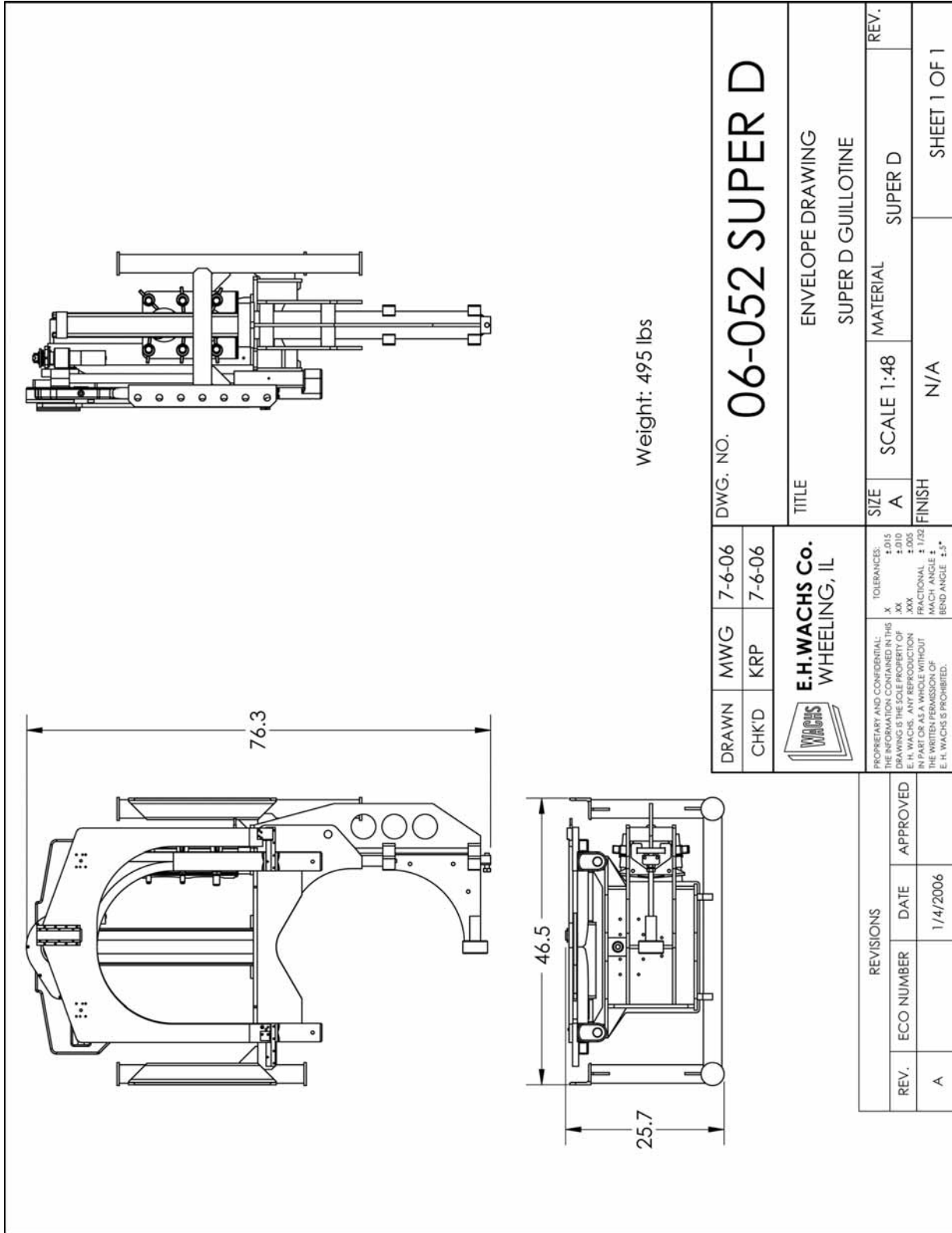
Capacity:	10"-24" (254-610 mm) diameter pipe; solids up to 24-1/2" (622 mm)
Drive:	Hydraulic, 15 gpm @ 1800 psi
Length:	76.3" (1938 mm)
Width:	45" (1143 mm)
Height:	25.7" (653 mm)

Weight:	1500 lb (682 kg) operating 1571 lb (714 kg) shipping
Lubrication:	Grease fittings at all wear points; autoc-lamp rail
Finish:	Paint
Blades:	General purpose and heavy duty
Feed rate:	Variable up to 1" per minute
Noise level:	72 dBA (continuous A-weighted sound pressure at work station) 90 dBA (peak C-weighted maximum sound pressure) 86 dBA (sound power level emitted by machine)

---

## **OPERATING ENVELOPE**

The following drawing shows the operating envelope and required clearances for using the Super D saw.



DRAWN	MWG	7-6-06	DWG. NO.	<b>06-052 SUPER D</b>		
CHK'D	KRP	7-6-06	TITLE ENVELOPE DRAWING SUPER D GUILLOTINE			
<p><b>E.H. WACHS Co.</b> WHEELING, IL</p> <p>PROPRIETARY AND CONFIDENTIAL: THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF E. H. WACHS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF E. H. WACHS IS PROHIBITED.</p>			SIZE	MATERIAL	REV.	
			A	SUPER D		
			FINISH	N/A	SHEET 1 OF 1	
			SCALE	1:48		
			TOLERANCES:	X ±.015 XX ±.010 XXX ±.005 FRACTIONAL ± 1/32 MACH. ANGLE ±.5° BEND ANGLE ±.5°		

REVISIONS		
REV.	ECO NUMBER	DATE
A		1/4/2006
		APPROVED



# Chapter 4

## Assembly, Disassembly, and Storage

---

The Guillotine® Super D pipe saw is factory assembled and ready for set-up. The machine is skidded and crated for shipping and storage.

---

### ENVIRONMENTAL REQUIREMENTS

The Guillotine® Super D pipe saw can be used in any industrial or field service environment, including underwater. The machine can be used for dry cutting or with coolant applied to the workpiece.

---

### LONG-TERM STORAGE

If you will be storing the Guillotine® Super D, take the following steps to prepare it:

- Reverse the feed drive to the end of travel.
- Remove the blade.
- Make sure the machine is thoroughly cleaned and cleared of chips and debris.
- Spray the machine with a rust preventative.
- Grease all fittings according to the instructions in Chapter 6.

### In This Chapter

ENVIRONMENTAL  
REQUIREMENTS

LONG-TERM STORAGE

SHIPPING

---

## **SHIPPING**

The Guillotine® Super D pipe saw is shipped on a skid. To ship the machine, skid it and strap it securely as you would any industrial machinery.

# Chapter 5

## Operating Instructions

---

.....

The Guillotine pipe saw can be installed on a pipe in any orientation—horizontal, vertical, or at an angle. Once the saw is clamped into place, you will release tension on the lift to allow the clamping mechanism to support the saw.

Refer to Chapter 3 if necessary for identification of the machine's components. The Super D is operated universal control panel (UCP).

---

### MACHINE SET-UP

Before lifting the Guillotine Super D, make sure the feed drive is at its starting point. (The saw bow should be retracted all the way back from the V saddle.) Ensure that the blade is sharp; install a new blade if necessary (see Chapter 6 for instructions).

#### Positioning the Saw

1. Attach a lift to the lift hooks at the top of the frame. If you will be setting up the saw vertically (cutting a horizontal pipe), you can lift it into place using just the two lift hooks.

### In This Chapter

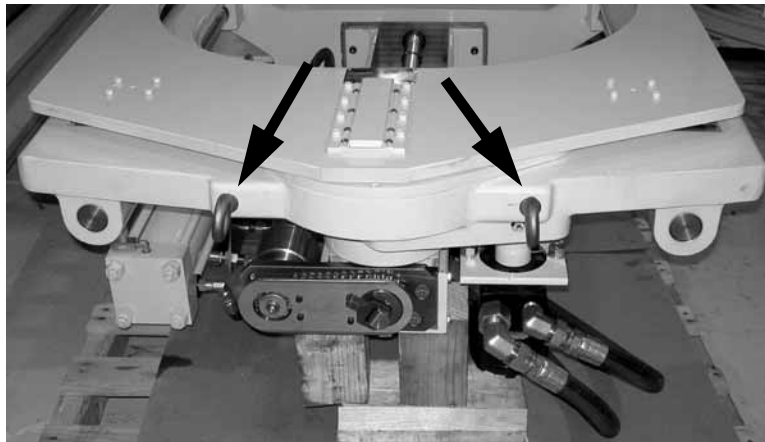
MACHINE SET-UP  
OPERATING THE SAW  
REMOVING THE SAW

**WARNING:**

The saw may slide or shift abruptly when it is lifted.



Proceed slowly and reposition the lift if necessary to keep it over the saw's center of gravity.

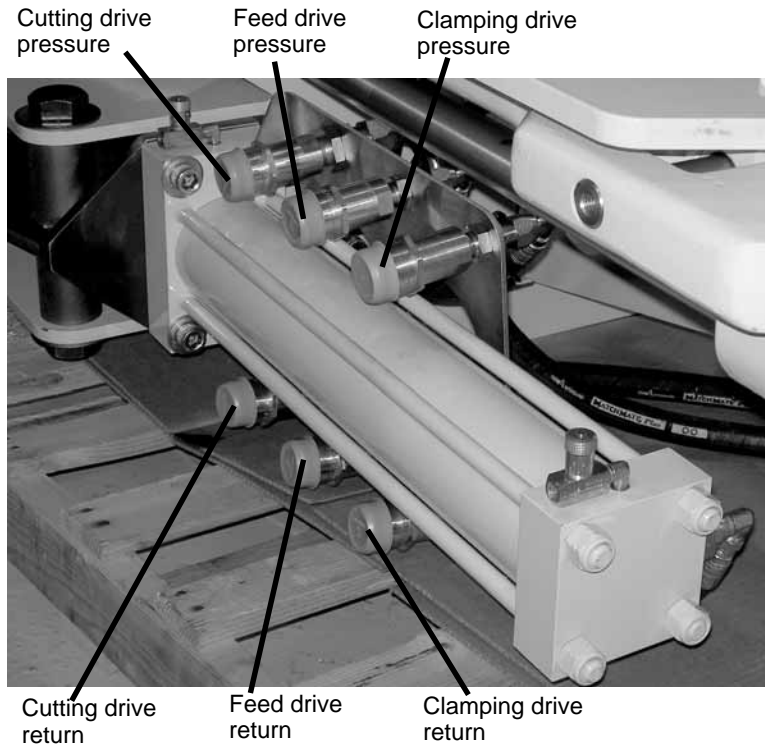


*Figure 5-1. There are two lift hooks at the top of the saw frame.*

2. Lift the saw carefully, positioning the lift so that it is over the center of gravity as you pick it up. If you are lifting from the top of the saw and the other end starts to slide, stop and reposition the lift.
3. Move the saw into position on the pipe so that the V saddle is against the pipe at the cut position. The saw should be close to square with the pipe; the clamping mechanism will precisely square it.

### Connecting the Hoses

1. Wipe all hose couplers with a clean, lint free cloth before making connections.
2. Connect the hoses from the hydraulic power unit (HPU) to the HPU fittings on the UCP.
3. Connect the hoses from the UCP to the fittings on the saw bulkhead as shown in Figure 5-2.



*Figure 5-2. Connect the clamping drive hoses to the saw as shown.*

### Clamping the Saw to the Workpiece

1. Position the saw at the cutting location on the pipe, with the saddle against the pipe surface.
2. Start the hydraulic power unit.
3. Use the clamping controls on the UCP to clamp the saw to the pipe.

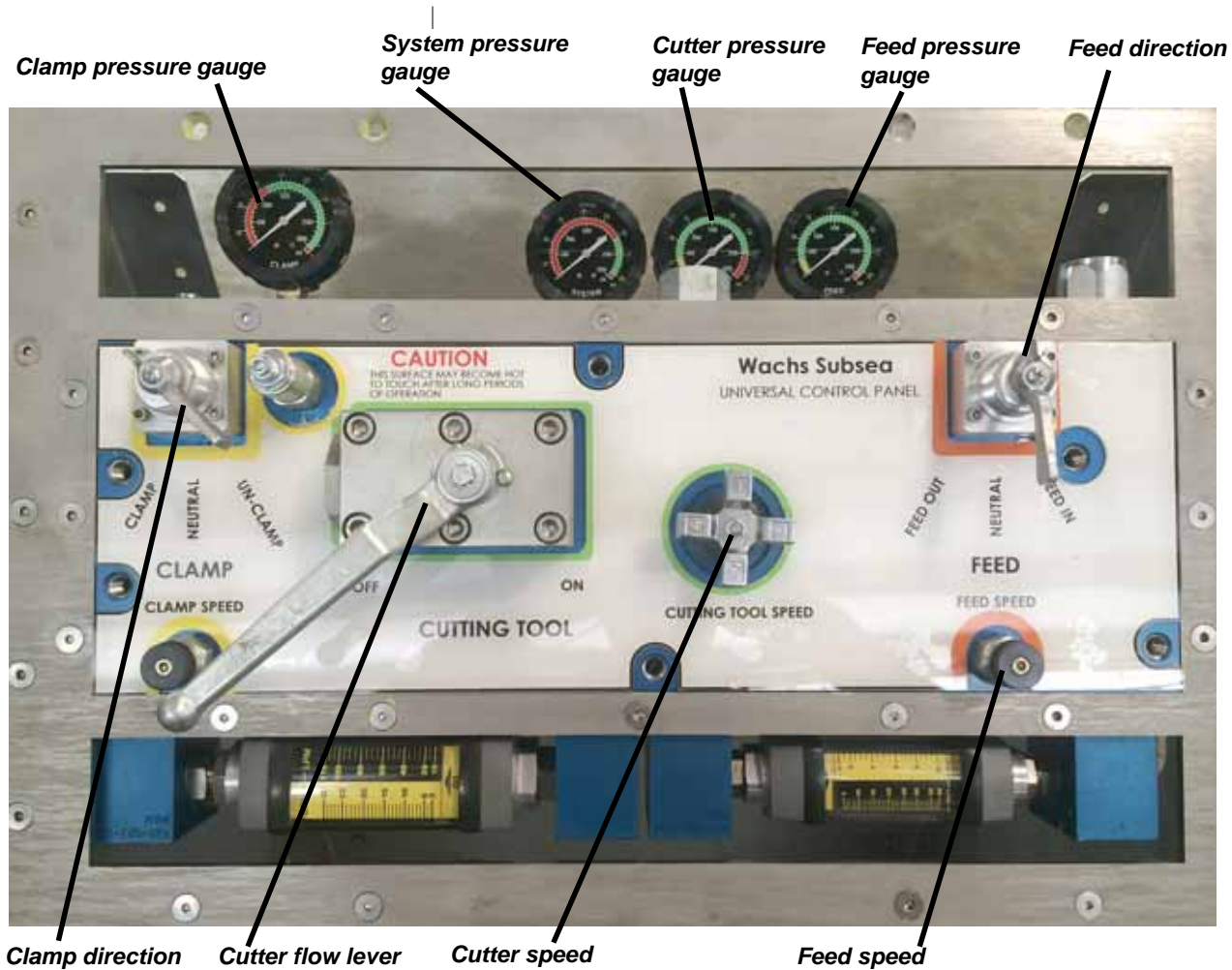
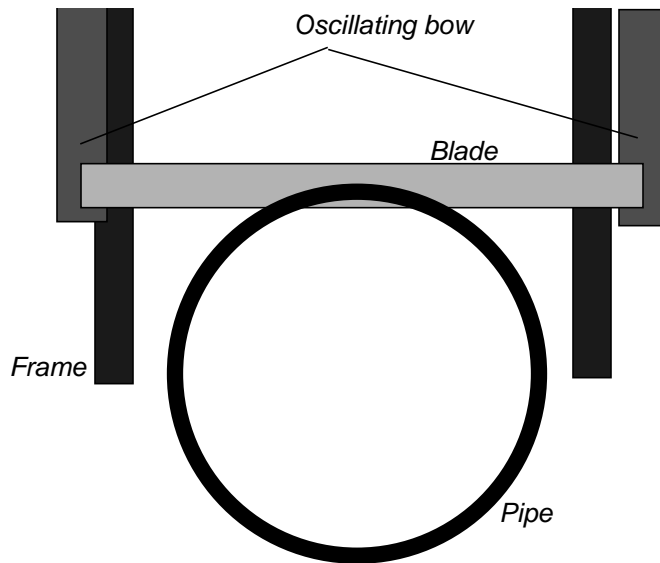


Figure 5-3. The photo illustrates the controls on the universal control panel. (Some UCP models have a different arrangement; see labeling on the UCP.)

4. Slightly lower the crane holding the saw to allow the clamp to hold the saw's weight. Leave the crane attached to the saw.

## OPERATING THE SAW

1. On the UCP, use the Cutter Tool lever to turn on the saw motion.
2. Set the Feed Control lever to the Feed In position.
3. Adjust the feed speed lever until the feed motion starts. Set the lever to the desired speed.
4. Set the cutting drive lever for the speed you want. Typically, you can set it to the maximum.
5. Allow the saw to operate at a slow feed rate until the blade has parted through the near wall of the pipe.



*Figure 5-4. Cut at a slow feed rate until the blade parts through the wall of the pipe.*

6. After the blade has parted the near wall, you can speed up the feed rate by adjusting the feed speed lever. You may need to slow the rate down if you are cutting an internal casing. Reduce the feed speed if the machine starts to bind or chatter, or if you see the blade deflecting as it cuts.
7. As the blade approaches the far wall of the pipe, slow the feed rate to the setting used at the start. Finish the cut at this feed rate.



### **WARNING IMPORTANT**

Always support the workpiece securely on both sides of the cutting location. Any unsecured section of the workpiece could shift or fall during cutting, damaging the equipment or causing injury to an operator.

---

## REMOVING THE SAW

1. Slowly raise the lift holding the saw until there is just enough tension to hold the saw in place.
2. Use the clamp controls on the UCP to Un-clamp the saw.
3. Use the crane to remove the saw from the workpiece.
4. If you are finished with the saw, turn off the HPU. Set the saw in its storage location and disconnect the hoses.



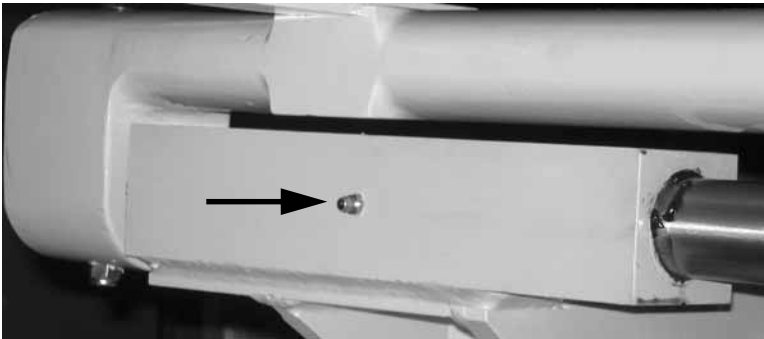
# Chapter 6

## Routine Maintenance

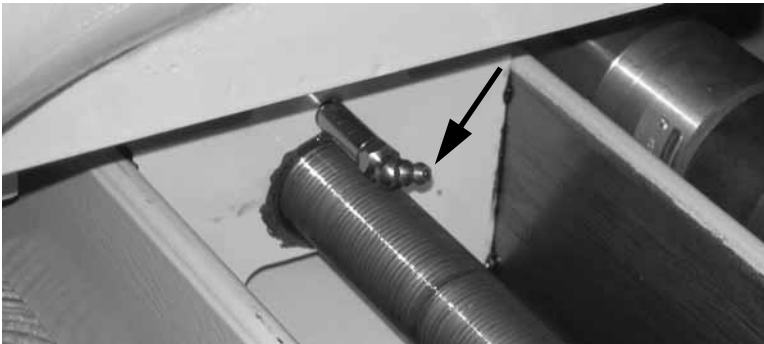
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### LUBRICATION

1. Grease all fittings on the Guillotine® frame every day before using the saw. There are 7 grease fittings on the machine, as shown in the following figures. Use a high-quality grade of soft grease.



*Figure 6-1. Grease the frame guides; there are two fittings, one on each side of the machine.*

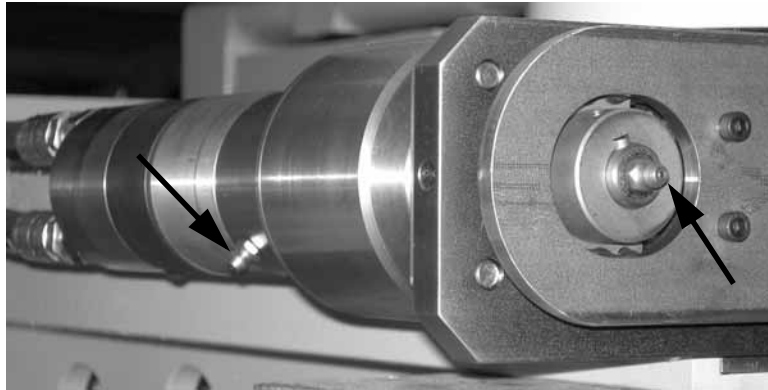


*Figure 6-2. Grease the feed screw.*

### In This Chapter

LUBRICATION

BLADE REPLACEMENT

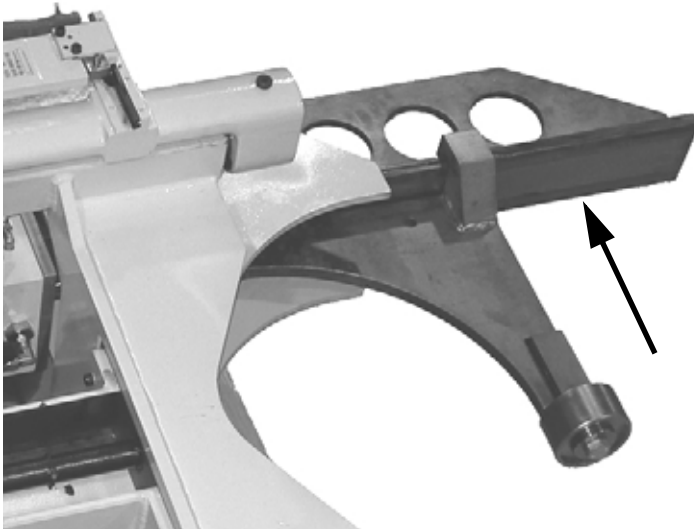


*Figure 6-3. Grease the two fittings on the feed drive motor and gear.*



*Figure 6-4. Grease the two fittings on the cutting gear housing.*

2. Grease the clamp drive rail every day of use.



*Figure 6-5. Apply grease to the top and bottom of the clamp drive rail.*

## BLADE REPLACEMENT

Check the sharpness of the blade after each cutting operation. Replace blades using the following procedure.

1. Return the saw bow to its fully retracted position using the rapid reverse autofeed or using the drive wheel in manual mode.
2. Loosen the blade by turning the blade tension knob counterclockwise.
3. Pull the blade off the mounting pins.
4. Insert the new blade onto the mounting pins. Make sure the teeth point to the left as you face the machine. (See the blade direction labels on the saw bow.)
5. Turn the blade tension knob clockwise until the blade is taut.



**WARNING:**  
Use gloves to remove the worn blade. There may be sharp metal fragments on the blade.



## Chapter 7

# Service and Repair

.....

The Guillotine® Super D saw is a durable system with little required maintenance.

There are no user-serviceable components on the machine (except for replacement of the blade). Contact the E.H. Wachs Company if service is required. (See Chapter 10, “Ordering Information”.) Any service must be performed by a factory-authorized service representative.



## Chapter 8

# Parts Lists and Drawings

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Refer to the parts lists and associated drawing in this chapter for ordering and maintenance.

There are separate part listings for Guillotine® Super D autoclamp machine and for the autofeed and lifting frame accessories. Call service at (800) 323-8185 for assistance in ordering.

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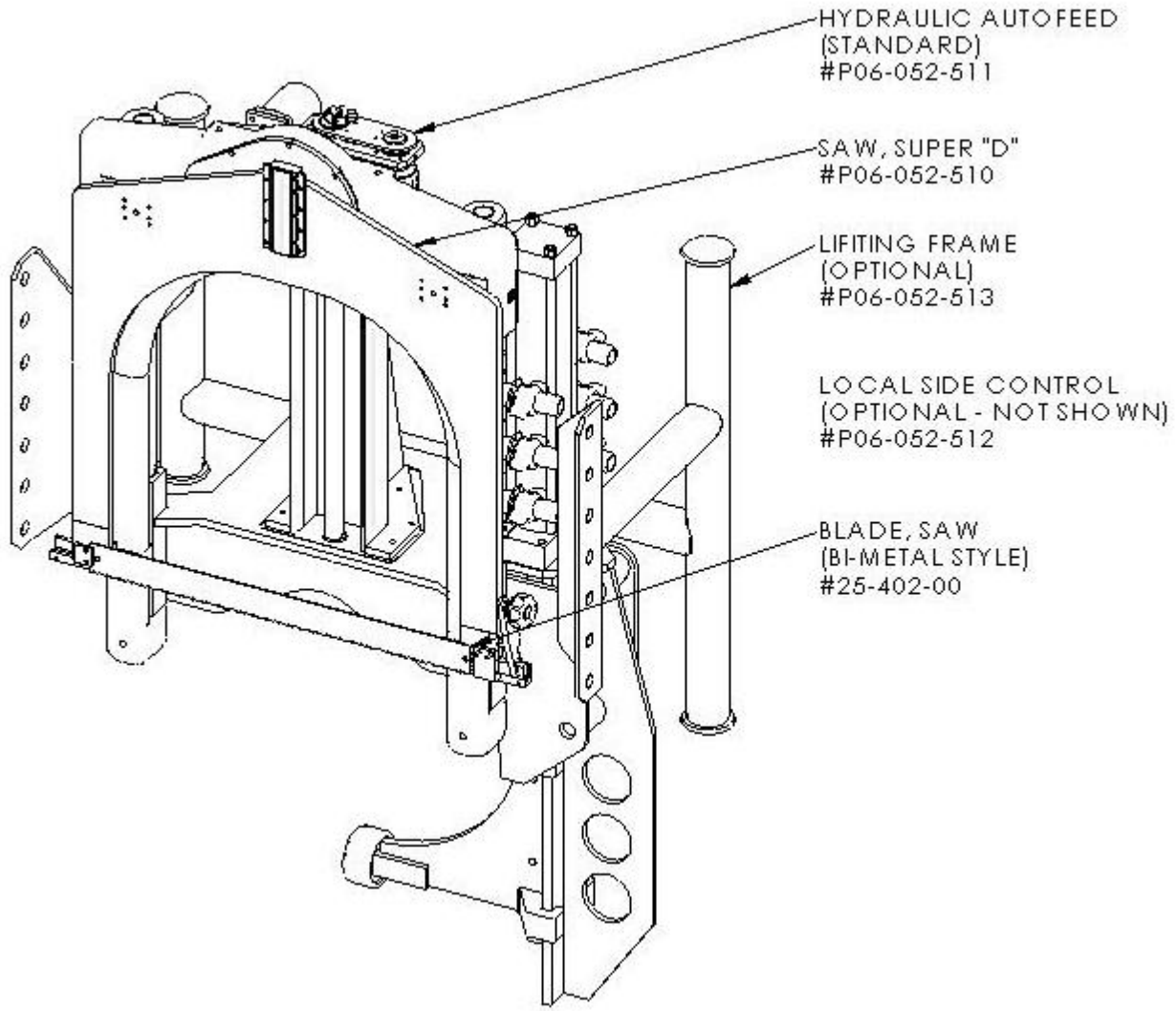
### **DRAWINGS**

The following drawings illustrate the Super D Guillotine®'s components. Refer to the Parts List for part descriptions.

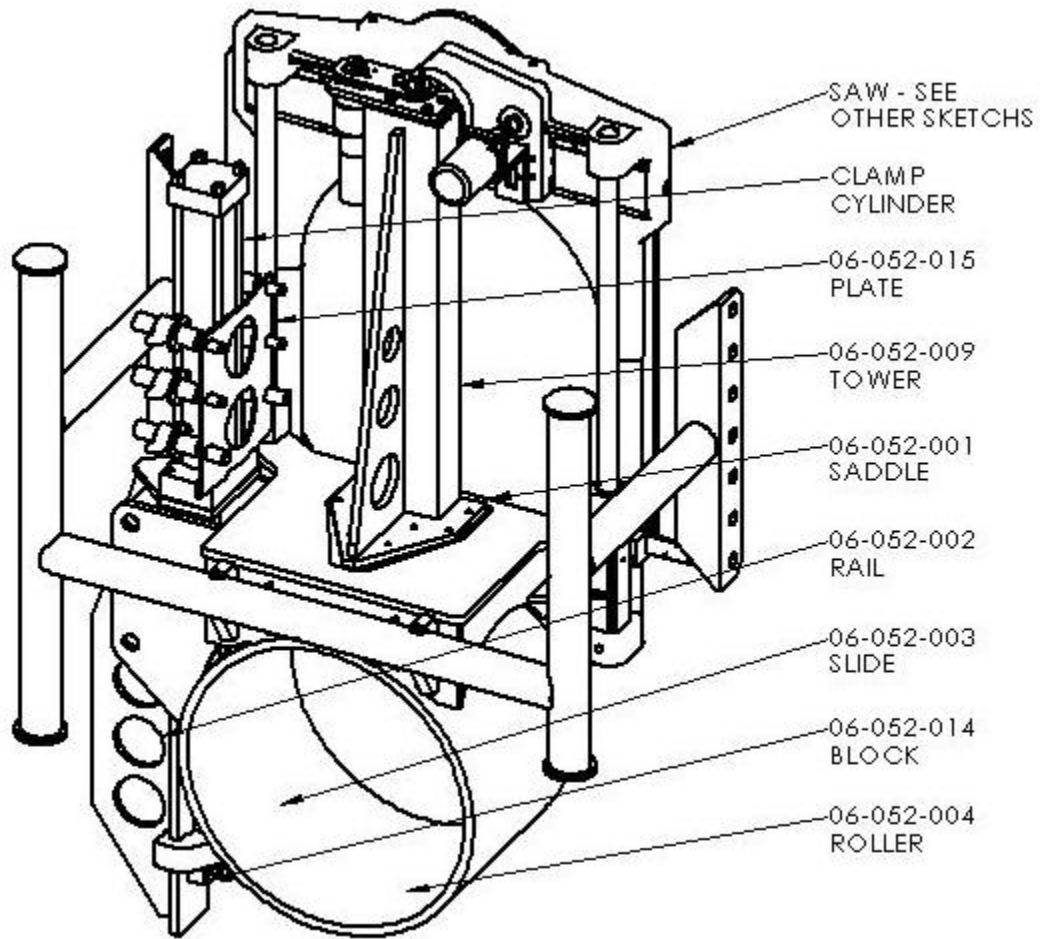
### **In This Chapter**

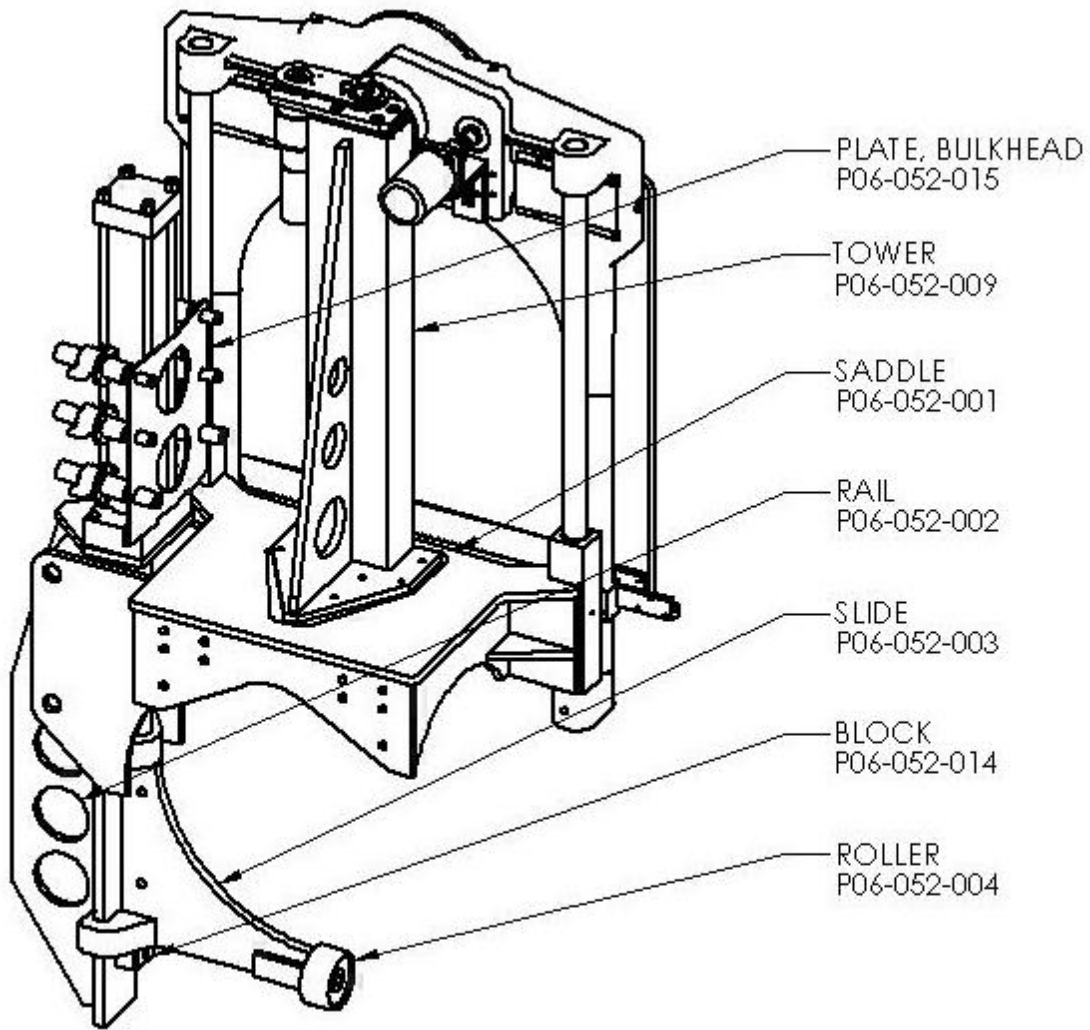
DRAWINGS

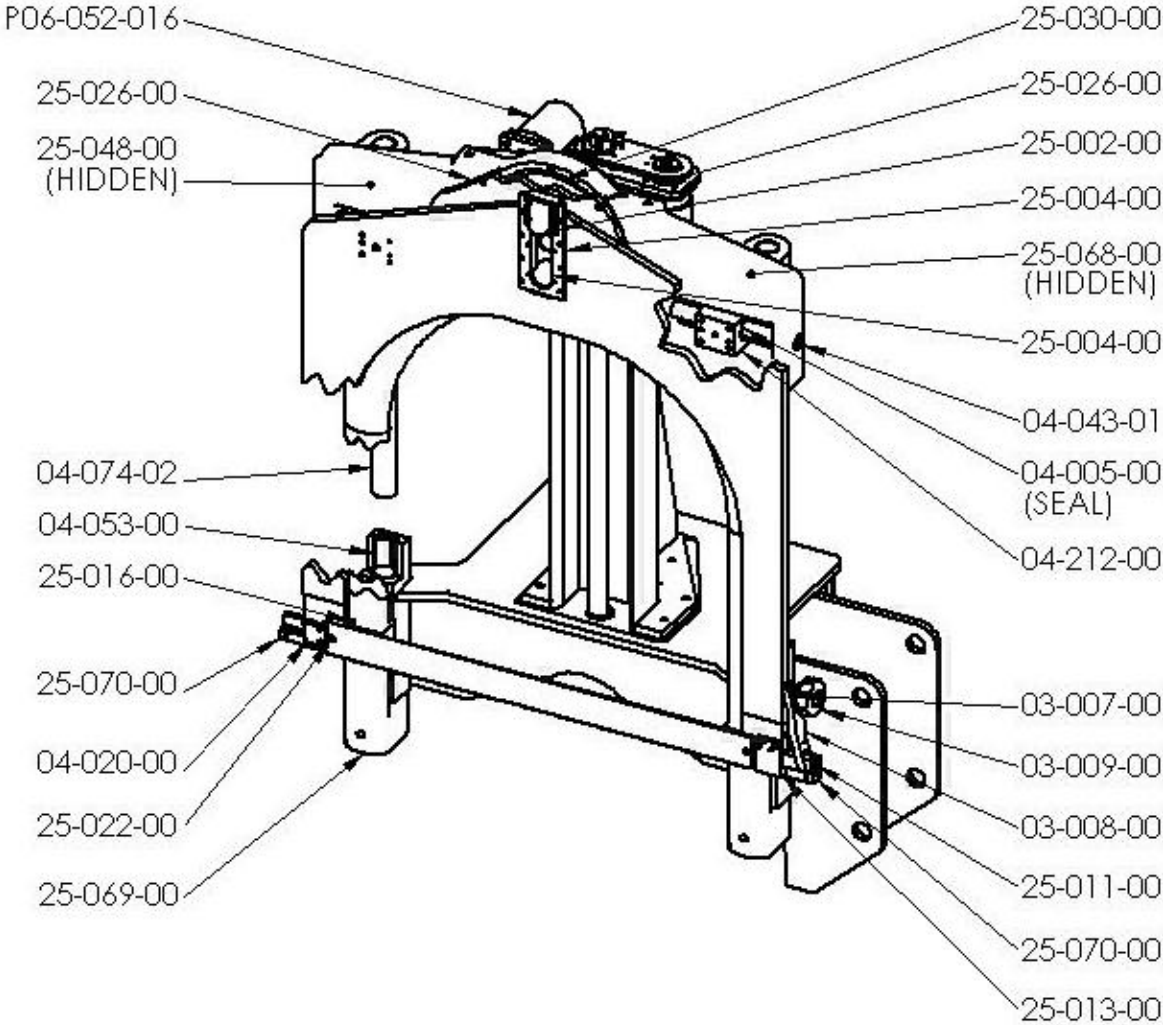
PARTS LIST

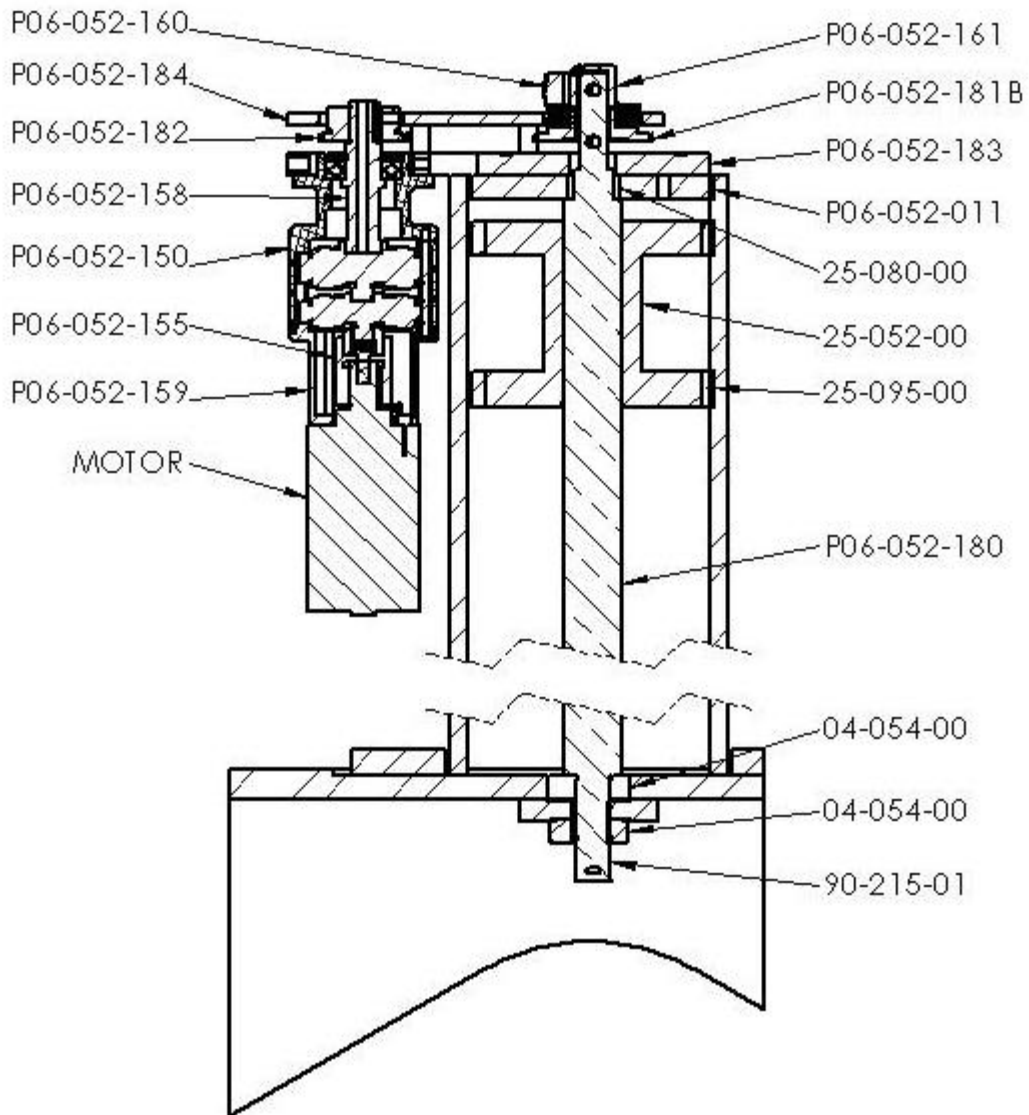


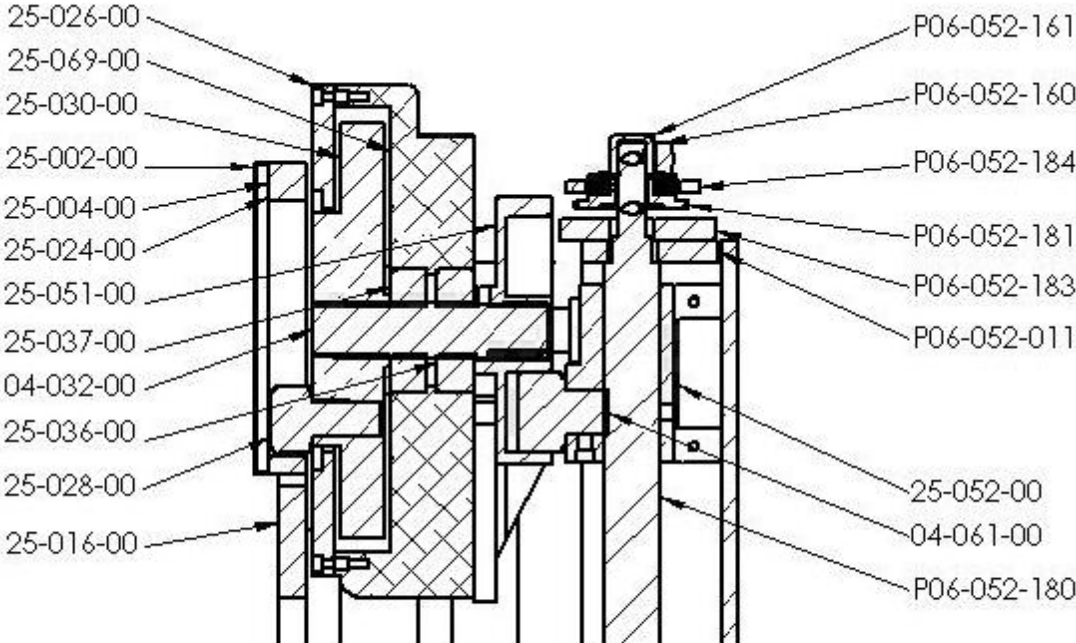




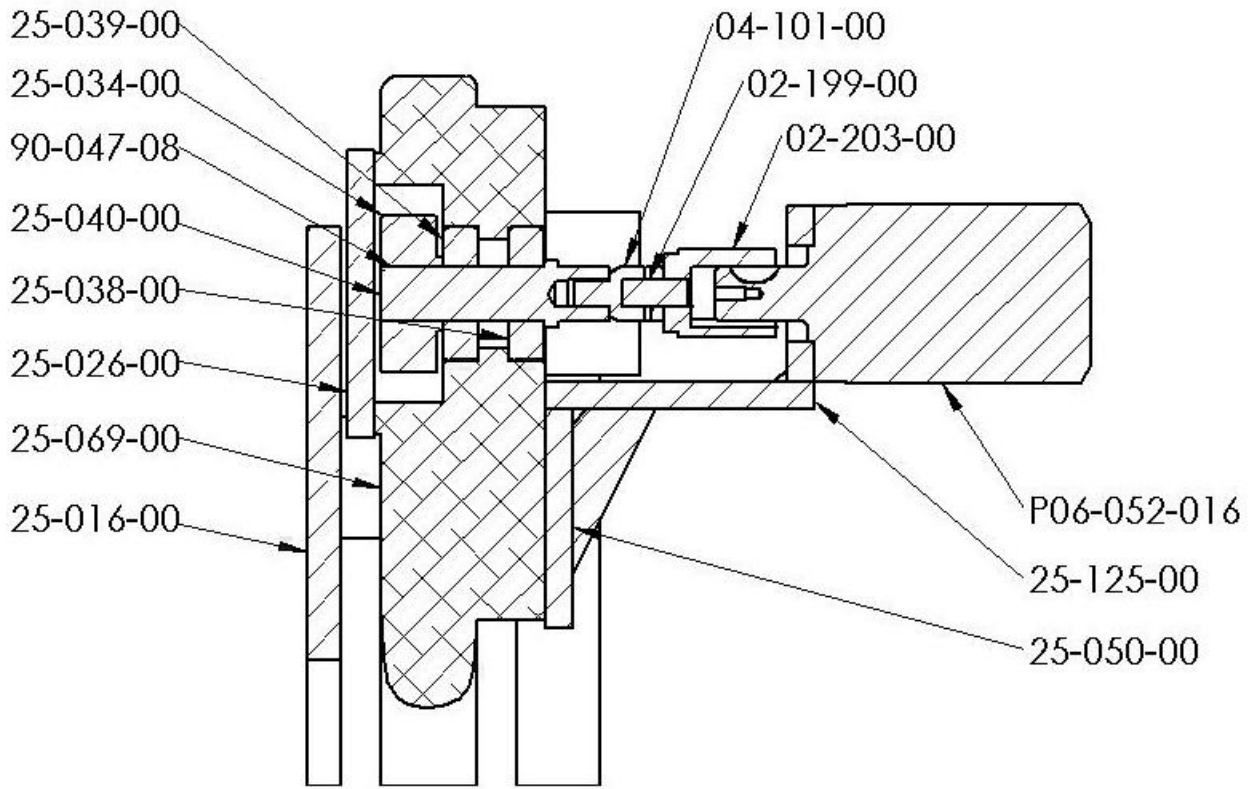








SECTION C-C  
SCALE 1 : 4



## PARTS LIST

<b>P06-052-510 AUTOCLAMPING MODEL SUPER D</b>		
<b>Quantity</b>	<b>Part No.</b>	<b>Description</b>
1	P06-052-001	SADDLE
1	P06-052-002	RAIL
1	P06-052-003	SLIDE
1	P06-052-004	ROLLER
1	P06-052-009	TOWER
1 REF.	P06-052-010	WELDMENT, TOWER
1	P06-052-011	PLATE, BEARING
1	P06-052-014	BLOCK, SUPER D RAIL LOCKDOWN
1	P06-052-015	PLATE, BULKHEAD MOUNTING
1 REF	P06-052-300	PLATE, SADDLE TOP
1 REF	P06-052-301	PLATE, SADDLE FRONT
2 REF	P06-052-302	PLATE, SADDLE CLAMPING
1 REF	P06-052-303	PLATE SADDLE REAR
1 REF	P06-052-304	BLOCK, SADDLE BEARING
2 REF	P06-052-305	PLATE, SADDLE GUSSET 1
1 REF	P06-052-306	PLATE, SADDLE SIDE
2 REF	P06-052-307	PLATE, SADDLE GUSSET 2
1 REF	P06-052-308	PLATE, SADDLE GUSSET 3
2 REF	P06-052-309	BLOCK, SADDLE SHAFT SUPPORT
1 REF	P06-052-310	PLATE , RAIL
1 REF	P06-052-311	PLATE, RAIL BOW
1 REF	P06-052-312	BAR, RAIL MOUNTING
1 REF	P06-052-313	PLATE, RAIL CYLINDER MOUNTING
1 REF	P06-052-314	PLATE, SLIDE BOW
2 REF	P06-052-315	PLATE, SLIDE END
1 REF	P06-052-316	BLOCK, SLIDE ROLLER
1 REF	P06-052-317	PLATE, TOWER BASE
1 REF.	P06-052-318	PLATE, FEED TOWER GUSSET
1	25-002-00	GREASE COVER YOKE
1	25-004-00	YOKE
4	04-005-00	SEAL
2	04-006-00	BRONZE BUSHING
1	03-007-00	TENSIONING SCREW
1	03-008-01	TENSIONING BRACKET
1	03-009-00	BLADE TENSIONING KNOB
1	25-011-00	BLADE TENSION BAR
1	25-013-00	BLADE TENSIONING BAR HOLDER
1	25-016-00	SAW FRAME
1	04-020-00	BLADE HOLD DOWN CLAMP
1	25-022-00	BLADE HOLDER PIN
1	25-023-00	GUIDE RAIL
1	25-024-00	GREASE SEAL
1	25-026-00	COVER, GEAR BOX
1	25-028-00	CAM FOLLOWER
1	04-101-00	ADAPTER MACHINE DRIVE
1	25-030-00	GEAR

1	04-032-00	GEAR SHAFT
1	25-034-00	PINION
4	90-500-00	GREASE FITTING
1	25-036-00	BEARING
1	25-037-00	BEARING
1	25-038-00	BEARING
1	25-039-00	BEARING
1	25-040-00	DRIVE SHAFT
1	25-042-00	REAR GUARD
2	04-043-01	SHAFT
1	25-044-00	FEED SCREW
1	25-051-00	CAM WHEEL
1	25-052-00	FEED NUT
4	04-053-00	BRONZE BUSHING
2	04-054-00	THRUST BEARING
1	90-215-01	CASTLE NUT
1	04-061-00	CAM FOLLOWER MODIFIED
1	25-068-00	REAR GUARD (L.H.)
1	25-069-00	MAIN FRAME
2	25-070-00	SAW FRAME GUIDE
2	04-074-02	VERTICAL GUIDE SHAFT
1	03-082-00	NAME PLATE
1	25-080-00	BUSING, BEARING PLATE
4	25-095-00	WEAR PLATE
2	04-212-00	BLOCK, BEARING
1		Hydraulic Cylinder 20" stroke
1		Hydraulic Motor
4		FITTING, BULKHEAD -8 JIC(M) x -8 NPT (M)
2		FITTING, BULKHEAD -12 JIC(M) x -12 NPT(M)
4		NUT, BULKHEAD -8
2		NUT, BULKHEAD -12
4		QUICK DISCONNECT, 1/2" NPT(F) x 3/4" BODY MALE W/ FLANGE
2		QUICK DISCONNECT, 3/4" NPT(F) x 3/4" BODY MALE W/FLANGE
2		NEEDLE VALVE, 1/8" NPT
2		FITTING, ADAPTER 1/8" NPT(M) x 1/8" NPT(M) -90 DEG

**Fasteners**

4		HHCS, 1-1/4"-7 x 2-1/2" LNG.
24		HHCS, 1/2-13 x 1-1/2" LNG.
1		HHCS, 3/4-10 x 1-1/2" LNG.
4		SHCS, 1/2-13 x 2-3/4" LNG.
24		NUT, HEX 1/2-13
48		WASHER, 1/2"
1		WASHER, 3/4"
4		WASHER, 1-1/4"
24		LOCKWASHER, SPLIT RING 1/2"
2		SHCS, 3/4-16 x 2-1/2" LNG
2		NUT, HEX JAM 3/4-16
2		HHCS, 1/2-13 x 2-1/2" LNG.
2		PIN, DOWEL 3/8" DIA x 1-1/2" LNG.
1		SSS, 5/16-18 x 3/4" LNG (316 STAINLESS STEEL)
1		NUT, JAM 5/16-18 (316 STAINLESS STEEL)



**P06-052-511 MODEL SUPER D HYDRAULIC AUTOFEED**

<b>Quantity</b>	<b>Part No.</b>	<b>Description</b>
1	P06-052-150	HOUSING, FEED BOX OUTPUT
1	P06-052-155	COUPLING MATEX MOTOR
1	P06-052-158	COUPLER, DRIVE
1	P06-052-159	HOUSING, FEED BOX INPUT
1	P06-052-160	YOLK, FEED
1	P06-052-161	BUSHING, FEED CLUTCH
1	P06-052-180	SCREW, SUPER D PLANET FEED
1	P06-052-181B	SPROCKET, 2.40 PITCH x .375 PITCH
1	P06-052-182	SPROCKET, 1.80 PITCH x .375 PITCH
1	P06-052-183	PLATE, SUPER D HYD MOTOR MOUNTING
1 REF	P06-052-184	PLATE, SUPER D GUILLOTINE CHAIN COVER
1 REF		PLANET OUTPUT BLANK - FOR TEST
1		PLANET INPUT BLANK - FOR TEST
1		PLANET SPACER
1		PLANET SET (3:1)
1		PLANET SET (4:1)
1		BEARING (.75 x 1.625 x .438)
1		SNAP RING (3/4" O.D. SHAFT)
4		SNAP RING (1-5/8" I.D. BORE)
1		STANDOFF, 3/8" OD x 5/8" LNG. (SPECIFY 10-24 THD)
1		O-RING -033 2" ID x 2-1/8" OF x 1/16 WIDE
24"		O-RING -041 3" ID x 3-1/8" OD x 1/16" WIDE
1		#35 CHAIN (SS)
1		#35 CHAIN CONNECTING LINK
4		BEARING, SLEEVE 5/8" ID x 23/32" OD x 1/2" LNG
2		WASHER, BELLEVILLE SPRING 2" OD x 1" ID x .065 THICK
1		ZERK, GREASE 1/4-28
		FEED MOTOR

**Fasteners**

16		SHCS, 8-32 x 1/2" LNG.
7		SHCS, 8-32 x 2" LNG.
1		SHCS, 1/4-28 x 5/8" LNG.
5		SHCS, 1/4-28 x 7/8" LNG.
4		SHCS, 5/16-18 X 5/8" LNG.
4		SHCS, 10-24 x 1-1/4" LNG.
2		SSS, 1/4-20 x 5/16" LNG.
1		PIN, SPRING 3/32" DIA x 3/8" LNG (SS)
1		PIN, CLEVIS 1/4" OD x 1-1/2" LNG. (316SS)
2		KEYWAY 3/16" x 3/4" LNG. ROUND ENDS
4		FHCS, 3/8-16 x 3/4" LNG.
1		PIN, DOWEL 1/4" DIA. X 1-1/4" LNG

**P06-052-513 MODEL SUPER D LIFTING FRAME (AUTOCLAMPING FRAME ONLY)**

1	P06-052-012	WELDMENT, LIFTING FRAME
1 REF.	P06-052-319	TUBE, LIFT FRAME BOTTOM
2 REF.	P06-052-323	PLATE, LIFT FRAME BOTTOM MOUNT
1 REF.	P06-052-324	TUBE, LONG LIFT FRAME FOOT
1 REF.	P06-052-325	TUBE, SHORT LIFT FRAME FOOT
2 REF.	P06-052-320	TUBE, LIFT FRAME ARM
2 REF.	P06-052-321	CHANNEL, LIFT FRAME ARM
4 REF.	P06-052-326	PLATE, LIFT FRAME FOOT END

**Fasteners**

8		NUT, HEX 1/2-13
16		WASHER, 1/2"
8		LOCKWASHER, SPLIT RING 1/2"
8		HHCS, 1/2-13 x 1-1/2" LNG.

## Chapter 9

# Accessories

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The Super D Guillotine® can be supplied with the following accessories:

- autofeed drive
- lifting frame
- hydraulic connector bulkhead for topside control .

You should keep a supply of spare blades.



# Chapter 10

## Ordering Information

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To place an order, request service, or get more detailed information on any E.H. Wachs Company products, call us at one of the following numbers:

U.S.            800-323-8185

International: 847-537-8800

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### ORDERING REPLACEMENT PARTS

When ordering parts, refer to the parts lists in Chapter 8. Please provide the part description and part number for all parts you are ordering.

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### REPAIR INFORMATION

Please call us for an authorization number before returning any equipment for repair or factory service. We will advise you of shipping and handling. When you send the equipment, please include the following information:

- Your name/company name
- Your address
- Your phone number
- A brief description of the problem or the work to be done.

### In This Chapter

ORDERING REPLACEMENT PARTS

REPAIR INFORMATION

WARRANTY INFORMATION

RETURN GOODS ADDRESS

Before we perform any repair, we will estimate the work and inform you of the cost and the time required to complete it.

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## **WARRANTY INFORMATION**

Enclosed with the manual is a warranty card. Please fill out the registration card and return to E.H. Wachs Company. Retain the owner's registration record and warranty card for your information.

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## **RETURN GOODS ADDRESS**

Return equipment for repair to the following address.

Wachs Subsea LLC  
11050 West Little York—Building N  
Houston, TX 77041 USA