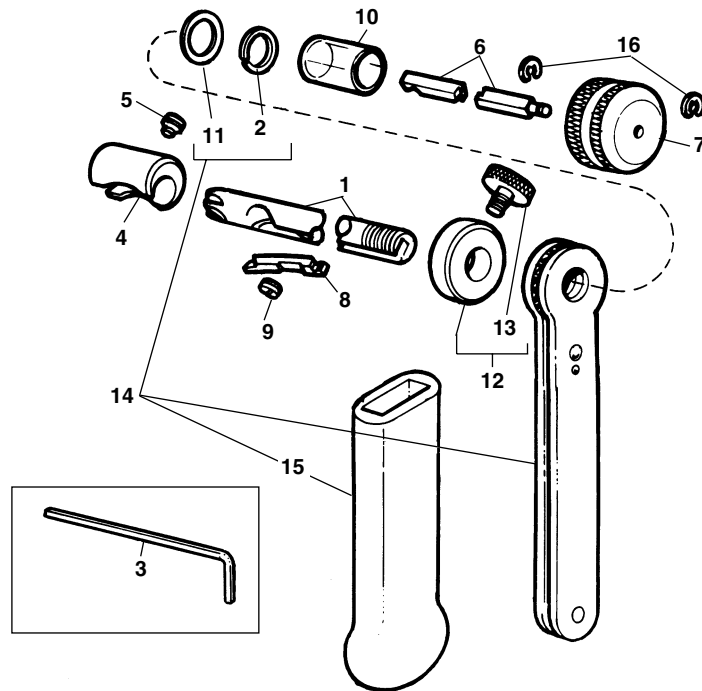


## No. 102 Copper Tubing Cutter

Capacity: 1/2" through 3/4" I.D.

**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
—	32970	102 Tubing Cutter
1	32735	Cutter Bar
2	33685	Retaining Ring (2)
3	46015	5/32" Socket Head Wrench
4	33780	3/4" Guide Bushing
5	33785	Set Screw
6	33810	Feed Rod
7	33815	Knob
8	33820	Cut-Off Tool
9	33825	Lock Screw
10	33835	Finger Guard
11	33840	Nylon Washer (2)
12	33845	Stop Collar Assembly
13	33850	Thumb Screw
14	33855	Ratchet Assembly
15	33860	Handgrip
16	33830	Clip (2)



**Min. Cut Off Length –  $\frac{5}{16}$ ". Max. Cut Off Length –  $4\frac{3}{16}$ " ( $4\frac{1}{2}$ " if Stop Collar is removed).**

### **To Cut-Off**

*Steps 1 through 7 are for  $\frac{1}{2}$ " tube.*

*See step 8 for  $\frac{3}{4}$ " tube.*

1. Determine length of tube to be cut off.
2. Add 1" to this length and measure from the end of the Cutter Bar (*Ref. No. 1*) to the Stop Collar Assembly (*Ref. No. 12*).
3. Tighten the Thumb Screw (*Ref. No. 13*) in the Stop Collar (*Ref. No. 12*) on the flat of the Cutter Bar.
4. Insert the Cutter Bar in the tube until the Stop Collar butts against the end of tube.
5. Turn the Feed Knob (*Ref. No. 7*) clockwise until the Cut-Off Tool (*Ref. No. 8*) is just snug inside the tube.
6. Begin and continue ratcheting while slowly turning the Feed Knob clockwise to feed out the Cut-Off Tool.
7. When the cut is completed, turn the Feed Knob counter-clockwise to retract the Cut-Off Tool, allowing the

severed tube remnant to be slipped over the end of the Cutter Bar.

8. To cut  $\frac{3}{4}$ " tube, install the Guide Bushing (*Ref. No. 4*) on the Cutter Bar. Tighten the Set Screw (*Ref. No. 5*) into the recess provided on the side of the bar opposite the Cut-Off Tool, then proceed as outlined in *Steps 1 through 7*.

### **To Replace Cut-Off Tool**

1. Remove the Lock Screw (*Ref. No. 9*) so the Cut-Off Tool can be disengaged from the interlock in the Feed Rod.
2. Insert the new Cut-Off Tool, engaging it with the interlock in the Feed Rod, and replace the Lock Screw. Turn the Lock Screw until it is snug in undercut of the Cut-Off Tool, then back it off slightly so the Cut-Off Tool moves freely but, is not loose.