

# Installation Guide — AB&I Foundry Cutting Instructions

## Cutting Instructions

For better results, use a Twin-Lever Snap Cutter or a ratchet-type cutter equipped with a sharp chain and equally-spaced beveled cutting wheels. There are several methods that work well to cut Cast Iron Soil Pipe. When using the Twin-Lever Snap Cutter or ratchet-type cutter equipped with a chain and cutter wheels, make sure that they are sharp and the wheels will rotate in the chain. When using a cutoff-type abrasive saw, make sure to follow all safety procedures recommended by the manufacturer. At all times, read the safety instructions on any tool that is used to cut cast iron pipe.

## Cutting Procedure

1. Position chain around pipe so that the maximum number of wheels are in contact with the pipe. Too much space between the first and last wheel in contact with the pipe will produce a poor quality cut, so be careful when positioning the chain around the pipe.
2. Score the pipe before making the final cut, applying only enough pressure to make the cutter wheel create a deep scratch in the pipe.
3. Release the pressure and rotate the tool slightly; then apply a quick final pressure to complete the cut. To produce the best result, it may be necessary to score the pipe several times before making the final cut.



Note: If the cutter wheels become flattened or dull, it will be very difficult (if not impossible) to obtain a satisfactory cut. The life of the chain can be extended by reversing the chain to obtain equal use of all the wheels. It is also important to keep the mechanical features of a cutter in good working order. Proper safety equipment and attire is required.

