



Manual / Instruction

## PORTABLE REBAR CUTTER



Read this instructions carefully before attempting to use .Ignoring proper operating procedure can lead to accidents. If have any doubt about any procedure, contact us.

## Parameters

Models	PF22C	PF25C	PF32C
Voltage±5%	240vac	240vac	240vac
Wattage	1200W	1800W	1800W
Net Machine Weight	12KG	16. 4KG	17KG
Package Shipping Weight	16KG	20.9KG	22KG
Cutting speed	1.5-2.5s	1.5 -3.5 s	3-6s
Max Cutting dia.	Φ22mm	Φ25mm	Φ32mm
Min Cutting dia.	Φ4mm	Φ6mm	Φ6mm
Package size	630*370*200mm	630*370*200mm	630*370*200mm
Note: Don't use the machine to bend steel bars that exceed the maximum cutting size.			

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# 1.Using Attentions

Before using the portable hydraulic cutter, please read this manual for safe operation. The operation methods and safety precautions mentioned in this manual are only applicable to the equipment mentioned in this manual. All safety problems caused by failure to operate according to the prescribed methods are the responsibility of the user.

1.1 Failure to comply with the contents of (Warning!) may cause personal accidents.

1.2 Failure to comply with the contents of (Caution!) may cause machine damaged or malfunction.

## **warning!** ☆ ☆

1.1. Don't use this equipment outside the scope specified in the manual.

1.2. Please strictly follow the instruction manual for correct operation and safe operation. Non-professionals are prohibited from using it. At the same time, for professional operators, please use it after training.

1.3. Because moisture will reduce the insulation of the motor, it may cause an electric shock accident. Therefore, do not perform steel bending operations in the rain, damp places, places with water, and places where water or oil is likely to enter the machine.

1.4. In order to prevent electric shock accidents, please use the power supply through the leakage circuit breaker. In addition, in addition to double insulation, please be sure to install the correct grounding "ground wire".

1.5. Please fully keep the workplace bright, and always pay attention to rectification. Scattered places will become the cause of accidents.

1.6. Rectification sparks may occur during the use of the bending machine, and sparks may also occur when the switch is opened and closed. Therefore, it is dangerous to work in places where paint, paint, volatile oil, gasoline, gas, adhesives, etc. may cause fire or explosion. Please never use it. At the same time, it is forbidden to use this equipment in closed rooms, tunnels and other places with poor ventilation.

1.7. Except operators, other personnel, please do not approach the work site, do not touch power tools and wires, etc.

1.8. Please wear neat clothes for work. Fat clothes, clothes with open cuffs, towels wrapped around the head, knitted gloves, ties, necklaces and other accessories may get caught in the rotating part of the machine and cause personal injury.

1.9. Operators are requested to wear safety helmets and safety shoes.

1.10. Wear protective goggles for work. In addition, in dusty places, please use a dust mask and dust collector (dust collector) at the same time.

1.11. Before turning on the equipment, please make sure that the bolts are not loose or fall off.

1.12. Please use the voltage indicated on the nameplate for the power supply. If the voltage exceeds the indicated voltage, the rotation of the motor will become abnormally high speed, which may damage the motor, body, etc., and cause danger. Conversely, the use of low voltage will also become the cause of motor failure.

1.13. Before inserting the plug into the power supply, please confirm whether the switch is disconnected to avoid sudden start of the machine.

1.14. Do not move the machine when the plug is connected to the power source. Even if you don't put your finger on the switch, if clothes or other things are hung on the switch, accidentally closing the switch will cause an accident.

1.15. Please always pay attention to the soles of your feet and work in a stable posture. Working in an inappropriate posture will bring danger.

1.16. If the machine is found to be in bad condition or abnormal during use, please stop using it immediately and check and repair it immediately.

1.17. Do not use the machine and accessories outside the scope of its use capacity, and do not perform excessive operations. Unsuitable work not only causes damage to the machine, but also is dangerous, please avoid it.

1.18. In order to make the equipment safe and efficient use, please check regularly. If repairs are required, please contact the supplier. In addition, when replacing parts, be sure to use designated parts.

### **Caution!** ☆ ☆

1.1 If the device is dropped, the outer frame may be deformed or cracked or damaged by collision, so be careful. If there is any abnormality, please repair it immediately.

1.2. Grasp the wire to transport the product or pull the wire to unplug it from the socket, which will damage the wire and cause disconnection or short circuit. At the same time, please be careful not to make the lead wire come into contact with blades, hot objects, chemicals, etc. When the wire is damaged, stop the operation immediately and repair it in time.

1.3. The wind window of the machine is a necessary part of cooling the motor, please do not block it due to dust. If it is clogged, the temperature of the motor will rise and become the main cause of burnout.

1.4. Please always pay attention to cleaning the machine and keep it in the best condition. Especially the dust on the motor part and the switch part, and it must be wiped off after each use.

1.5. Please keep the machine and its accessories in the following places:

- A. Places out of reach or locked by children's hands.
- B. A place where the temperature and humidity do not change drastically.
- C. A dry place without humidity.
- D. Don't place the machine in where cause fire and explode easily

## **2、Common safety precautions**

### **2.1 Operating**

2.1.1 The steel bar cutting machine is only suitable for steel bars.

2.1.2. Please note that there will be steel bars splashing when cutting.

2.1.3. Materials exceeding the specified specifications will greatly increase this risk and damage the tool. Don't try to bend steel bars that are harder and thicker than specified.

### **2.2 Caution in using**

2.2.1 Wear safety goggles, use side protective glasses or use protective covers when using protective covers.

2.2.2 Provide a safety barrier. In order to protect colleagues from possible interference at the end of the flight, a safety barrier needs to be erected. When working at high places, place the steel bars under the safety screen.

#### 2.2.3 Appropriate control

Hold the machine firmly and maintain a proper foothold and balance. Do not overextend when working at high places. Use a safety rope to fix the knife on the scaffold. Check whether the power cord is contaminated and keep the cord away from sharp edges and heat.

#### 2.2.4 Protection against electric shock

To avoid electric shock, do not handle the bending machine with wet hands, nor use the bending machine in rainy or humid places. Pay attention to all possible contact wires, circuits and other possible contact hazards. Especially those objects that are below the surface or hidden out of view.

#### 2.2.5 Pay attention to the environment

Do not use knives in the presence of flammable materials (such as paint, thinner, petroleum products, adhesives). Do not use the bending machine where there are no lights and obstacles. The operator should have an unobstructed view of the tool, steel reinforcement and surrounding area at all times.

#### 2.2.6 Wear suitable clothes

Don't wear loose clothes, hanging objects or jewelry, pay attention to long hair. It is recommended to use hard hats and rubber-soled boots. If you wear safety gloves, be especially careful not to let the gloves get stuck on moving parts.

#### 2.2.7 Keep others safe

All visitors should keep a safe distance from the work place to protect themselves and prevent operators from being distracted.

#### 2.2.8 Storage

When not in use, store the cutter and accessories in a dry place out of the reach of unauthorized persons.

## 3、Hydraulic oil functions

### Warning! ☆ ☆

3.1. The hydraulic oil entering the eyes may cause inflammation, so please wear protective glasses during operation to prevent the hydraulic oil from entering the eyes. Contact with the skin may cause inflammation, so please wear protective gloves before operation.

3.2. Emergency treatment:

A. After entering the eyes, please wash with clean water first, and then receive a doctor's diagnosis in time.

B. After touching the skin, please wash it off thoroughly with water and soap.

C. After drinking it by mistake, please do not force it to vomit, please accept the doctor's diagnosis immediately.

3.3. Treatment of waste oil:

Do not dispose of waste oil in the sea, rivers, lakes, other rivers, or in drains to prevent fire hazards from polluting the environment.

### **Cautions!** ☆ ☆

3.4 Please check the oil level before operation. (46# anti-wear hydraulic oil is recommended for this series of products)

3.5 Hydraulic oil is the power medium of the equipment. The reduction of the oil volume will result in the reduction of power and the performance cannot be fully utilized. Therefore, please check the oil volume before operation. In addition, if the temperature of the machine body reaches 70°C or higher, the power will be reduced, so please cool down, and then turn on the machine after the standby body has cooled down.

3.6 Please perform warm-up operation.

In winter, the low-temperature hydraulic oil sometimes freezes and is difficult to start, so please preheat it for about 30-60 seconds without load before bending.

3.7 Please turn off the switch once.

When the switch is kept on, the piston sometimes goes in and out continuously, so after confirming that the piston has reached the top end, be sure to turn off the switch once before using it.

## **4、 Refueling hole location and refueling method**

### **4.1 Refueling hole location:**





# RCXXC type Rebar cutter Refueling hole location

## 4.2Refueling method

4.2.1.Place the bender flat on the desktop,the oil hole face upwards.

4.2.2.Unscrew the screw at the oil hole.

4.2.3.Slowly inject hydraulic oil from oil hole.

4.2.4. First add some hydraulic oil, block the hole and press the bender switch to make the bender shaft move forward slowly,then inject the hydraulic oil after moving a certain distance, repeat this operation until the hydraulic oil is filled up when the bender shaft moves to the limit position , And then press the manual pressure relief valve to return bender shaft and repeat the operation until the machine works normally.

4.2.5.Finally, tighten the screws and finish Refueling.

## 5 . Cautions before using

**! Warning:** Meaning the danger that may cause minor personal injury or product damage

**! Cautions:** Meaning the danger that may cause product damage

### 5.1 Check before use

5.1.1.check hydraulic oil quantity.

5.1.2.Check the condition of the blade and the tightness of the blade bolt.

**! Cautions:** Using loose or cracked blades may cause injury to the operator and may cause damage the machine.

5.1.3.Check whether the power supply is suitable for the tool.

**! Cautions:** If the voltage is too high, the motor will burn out. If the voltage is too low, the power will be not enough. Do not use DC power supply.

5.1.4.Check whether the power supply is properly grounded.

**! Cautions:** Failure of the grounded power supply may cause electric shock to the operator.

5.1.5. Check whether the wires are not damaged and the plugs are not loose.

**! Cautions:** Cut or scraped coverings may cause short-term electric shocks to the operator.

If you want to use an extension cable, make sure that the extension cord is not damaged and that the diameter of the extension cord matches the length.

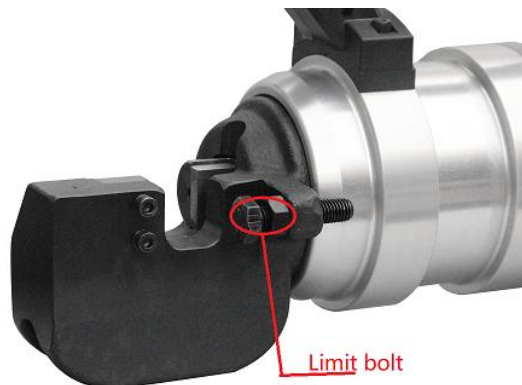
## 5.2 Warm up

### 5.2.1 Warm up

Press switch, let the cutting shaft out, when the shaft reach the front, stop switch, repeat the operation 15-20 times.

### 5.2.2 Limit bolt adjustment

(1) Loosen the lock nut of the limit bolt to make the steel bar have enough clearance, as shown in the figure.



(2) Insert the steel bar fully into the U-shaped groove. Make sure that the rebar is fixed on the end plane of the bolt as shown in the diagram.



(3) Keep the steel bar at the right corner (90°) with the front blade and unscrew the

adjusting screw until it touches the steel bar. After installation, no further adjustment is required when cutting steel bars of the same diameter.

**! Caution:** If the limit bolt is not set correctly, it will cause excessive wear of the tool block and may cause the cutting end to fly out.

### 5.2.3 Cutting

5.2.3.1 Insert the bar between the limit bolt and the front blade to ensure that it is correctly installed in the U-shaped groove, as shown in the figure.



5.2.3.2 Press the switch, the rod will be cut off when the shaft advances. (If the switch is released at the midpoint, the shaft will stop.)

5.2.3.3 After the cutting is complete, release the switch. The shaft automatically contracts. (Note that the switch cannot be pressed again until the piston is fully retracted.)

### **! Cautions**

1. Be especially careful when cutting short lengths (30 cm or less), because the cut ends tend to fly out.

**! Warning:** Splashing steel bars is a danger to all people nearby. Erect safety barriers.

2. Do not cover the aluminum vents.

**! Note:** If the vent is covered, the motor will overheat and may burn out.

3. If the hydraulic oil temperature exceeds 70° (158 F), the power will drop.

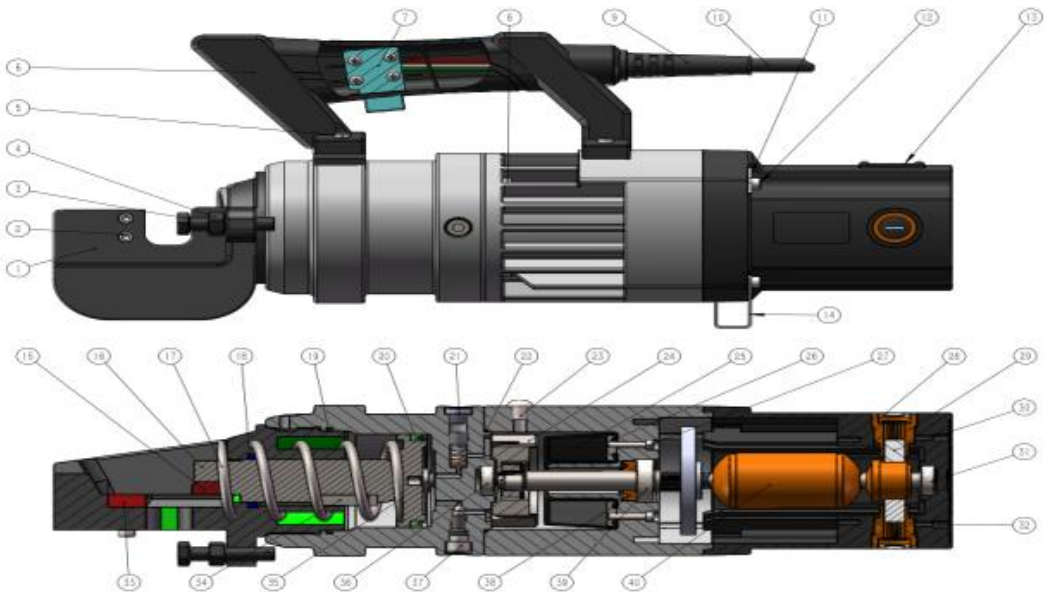
Wait for it to cool down before cutting. (Be especially careful in summer, because the aluminum pump housing heats up faster.)

4. If you observe a power drop and the motor is abnormally hot, please check the carbon brushes.

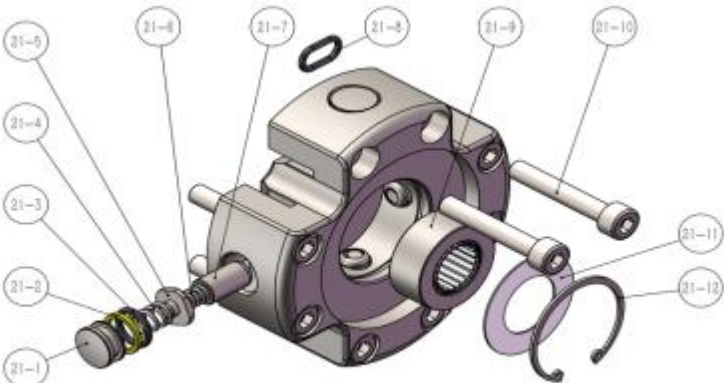
5. If the shaft cannot be fully retracted, Tap the blade backward to manually retract the shaft.

! Note: Use steel bars or flat metal rods. Never push the blade with any part of your hand, even if you wear gloves. If the piston cannot be fully retracted, unplug the power source. And check the dust and iron filings of the shaft and the shell, which may be blocked. After cleaning, if the shaft still does not retract automatically, the shaft itself may be damaged. Contact supplier

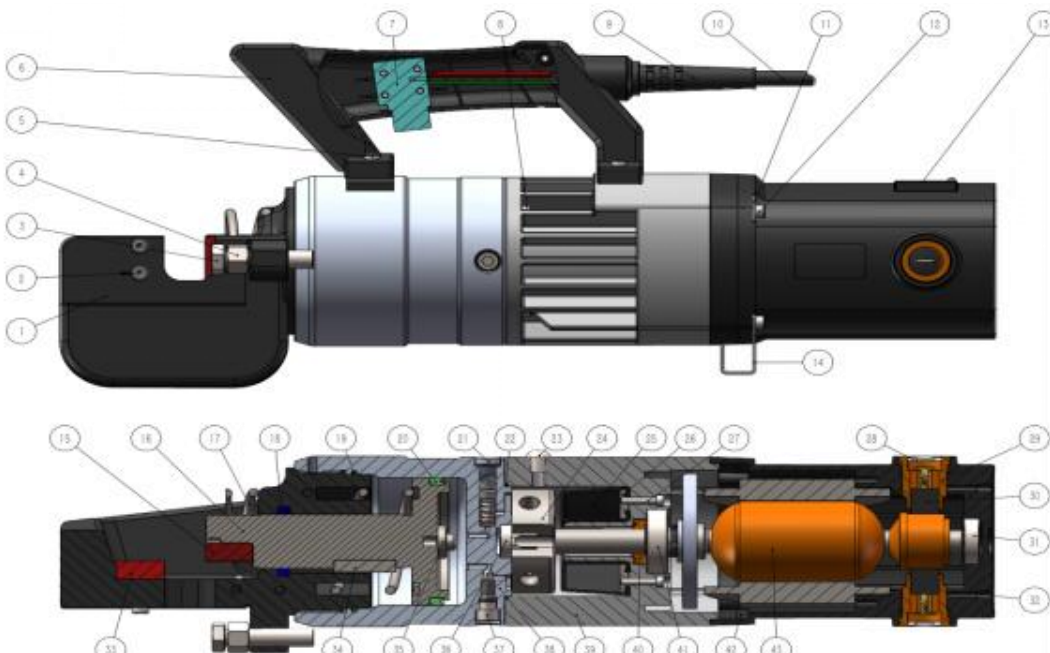
## 6 . Machine assembly drawings and accessories

PF22C accessories list					
					
Num ber	Name	Amo unt	Num ber	Name	Amo unt
1	Headstock	1	24~3	O-ring outer diameter Φ11X1.5	4
2	Hexagon socket bolt M5X25 (with spring washer)	2	24~4	Plunger check valve compression spring	4
3	Hexagonal bolt M10X45	1	24~5	Plunger check valve	4
4	Hexagonal nut M10	1	24~6	Plunger return compression spring	4
5	Hexagon socket head bolt M5X25	4	24~7	Piston Φ7	4
6	Handle	1set	24~8	O-ring outer diameter Φ11X1.5	4

7	power switch button	1	24~9	Needle bearing 12x24x10	1
8	Hexagon socket bolt M5X20 (with spring washer)	4	24~10	Hexagon socket bolt M5X30	8
9	Power cord rubber sheath	1	24~11	Wear-resistant sheet	1
10	Power cord 3X2.5mm <sup>2</sup> (with plug)	1	24~12	Internal circlip Φ28	1
11	Shaped gasket	2	24~13	Plunger body φ73	1
12	Hexagon socket bolt M5X35	4	25	Annular oil bag	1
13	Nameplate	1	26	Oil bag pressure plate	1
14	Bracket	1	27	Hexagon socket head bolt M4X20	6
15	Movable blade 26x20x9.5 with chamfer	1	28	Carbon brush holder cap	2
16	Piston shaft	1	29	Carbon brush holder	2
17	Compression spring outer diameter Φ61X wire diameter Φ5.5X98	1	30	Carbon brush	2
18	Seal ring UN Φ32*Φ40*5	1	31	Bearing 608	1
19	O-ring inner diameter Φ75X2.65	1	32	Set bolt M4X8	2
20	Sealing ring UHS Φ60*Φ70*6	1	33	Fixed blade 26x20x9.5	1
21	Pressure regulating valve assembly	1set	34	Flat key pin 10x8x35	1
<div style="display: flex; justify-content: space-around; align-items: flex-end;"> <div style="text-align: center;">  <p><b>Pressure regulating valve shaft assembly</b></p> </div> <div style="text-align: center;">  <p>Manual pressure relief valve assembly</p> </div> <div style="text-align: center;">  <p>Piston relief valve assembly</p> </div> </div>					
21~1	Hexagon socket bolt M10X1.0-10	1	35	Pressure relief pin assembly	1set
21~2	Rubber pad	1	35~1	Piston pressure relief shaft	1
21~3	Hexagon socket set bolt M10X1.0-6	2	35~2	Relief shaft compression spring	1
21~4	Flat washer outer diameter Φ8.5	1	35~3	Relief shaft return pressure spring	1
21~5	Compression spring	1	36	Bearing 608	1
21~6	Spring drag	1	37	Manual pressure relief valve assembly	1set
21~7	Steel ball Φ3	1	37~1	Manual pressure relief bolt	1
22	O-ring inner diameter Φ73X2	1	37~2	O-ring outer Φ10X1.5	1

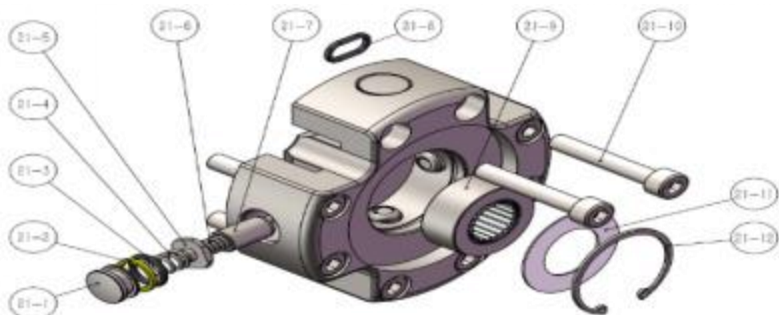
23	Hexagon socket head bolt M8X10-10	1	37~3	Steel ball Φ5	1
24	Plunger assembly	1set	38	Skeleton oil seal TC15*30*7	1
 <p style="text-align: center;">Plunger assembly</p>					
24~1	Plunger cap	4	39	Bearing 6002	1
24~2	Fluorine rubber retaining ring	4	40	Motor rotor stator assembly 1.1KW	1set

## PF25C accessories list

					
Num ber	Name	Amo unt	Num ber	Name	Amo unt
1	Headstock	1	24~5	Plunger check valve	4
2	Hexagon socket bolt M6X30 (with	2	24~6	Plunger return compression	4

	spring washer)			spring	
3	Hexagonal bolt M12X50	1	24~7	Piston Φ7	4
4	Hexagonal nut M12	1	24~8	O-ring outer diameter Φ11X1.5	4
5	Hexagon socket head bolt M5X25	4	24~9	Needle bearing 12x24x10	1
6	handle	1set	24~1 0	Hexagon socket head bolt M5X25	8
7	Push button switch HY79-21	1	24~1 1	Wear-resistant sheet	1
8	Hexagon socket bolt M5X20 (with spring washer)	4	24~1 2	Internal circlip Φ28	1
9	Power cord rubber sheath	1	24~1 3	plunger body φ73	1
10	Power cord 3X2.5mm <sup>2</sup> (with plug)	1	25	Annular oil bag	1
11	Shaped gasket	2	26	Oil bag pressure plate	1
12	Hexagon socket bolt M5X35	4	27	Hexagon socket head bolt M4X20	6
13	Nameplate	1	28	Carbon brush holder cap	2
14	Bracket	1	29	Carbon brush holder	2
15	Movable blade 32x27x12 with chamfer	1	30	Carbon brush	2
16	Piston shaft	1	31	Bearing 6200	1
17	Compression spring outer diameter Φ70X wire diameter Φ6X109	1	32	Set bolt M4X8	2
18	Seal ring UN Φ36XΦ48X4	1	33	Fixed blade 26x20x9.5	1
19	O-ring outer diameter Φ95X2.65	1	34	Flat key pin 10x8x35	1
20	Seal ring UN Φ75XΦ85X8	1	35	Pressure relief pin assembly	1set
21	Pressure regulating valve assembly	1set	35~1	Piston pressure relief shaft	1
 <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;"> <p>Pressure regulating valve shaft assembly</p> </div> <div style="text-align: center;"> <p>Manual pressure relief valve assembly</p> </div> <div style="text-align: center;"> <p>Piston pressure relief assembly</p> </div> </div>					
21~1	Hexagon socket bolt M10X1.0-10	1	35~2	Relief shaft compression spring	1
21~2	Rubber pad	1	35~3	Relief shaft return pressure spring	1
21~3	Hexagon socket set bolt M10X1.0-6	2	36	Bearing 608	1
21~4	Flat washer outer diameter Φ8.5	1	37	Manual pressure relief valve	1set



				assembly	
21~5	Compression spring	1	37~1	Manual pressure relief bolt	1
21~6	Spring drag	1	37~2	O-ring outer $\Phi 10 \times 1.5$	1
21~7	Steel ball $\Phi 3$	1	37~3	Steel ball $\Phi 5$	1
22	O-ring inner diameter $\Phi 73 \times 2$	1	38	Cylinder	1
23	Hexagon socket head bolt M8X10-10	1	39	Back cavity	1
24	Plunger assembly	1set	40	Skeleton oil seal TC17x30x7	1
 <p style="text-align: center;">Plunger assembly</p>					
24~1	Plunger cap	4	41	Bearing 6004	1
24~2	Fluorine rubber retaining ring	4	42	Motor plastic shell	1
24~3	O-ring outer diameter $\Phi 11 \times 1.5$	4	43	Motor rotor stator assembly 1.6KW	1set
24~4	Plunger check valve compression spring	4			

## 7. Inspection and maintenance

Before using the blade, check whether the two bolts on each cutter block are properly tightened. It is also necessary to check the status of the blade. If the cutting edge is blunt or chipped, remove the fixing bolt and rotate the two blocks to use two new cutting edges. Replace and tighten the bolts (each block has two cutting edges) When all two cutting edges have been used, or if one of the blades has cracks or other damage, replace both blades.

**! Warning:** A loose or cracked blade may cause injury to the operator.

### 7.1 Cleaning (clean the blades after use)

**! Note:** Wear gloves to protect your hands from metal fragments. Do not use air guns, high-pressure air can cause metal files and/or dust to enter the eyes and respiratory system.

#### 7.1.1 Disconnect electric

7.1.2. Wipe or brush off all dirt and metal shavings. Pay special attention to the lower part of the piston, where dirt is more likely to accumulate.

### 7.2 Oil level check

Since the tool is hydraulically operated, the oil level must be checked regularly, preferably



once a day. If the oil is not maintained at an appropriate level, it will result in a drop in pressure and loss of cutting power.

**! Note:** Hydraulic oil is highly flammable. Keep away from sparks and do not smoke.

**! Note:** Hydraulic fluid may cause inflammation of the eyes and skin. If ingested, it can cause diarrhea and vomiting. If it gets into the eyes, rinse in clean water for at least 15 minutes and consult a doctor. In case of skin contact, wash thoroughly with soap and water. After drinking, please do not force it to vomit, please consult a doctor immediately.

### 7.3 Oil change

The hydraulic oil should be replaced at least once every six months.

7.3.1. Unplug the power supply. Remove the oil filler bolt. Turn the cutter over and drain the hydraulic oil into a suitable container. When the oil stops flowing out, tilt the device to the rear so that the oil trapped in the piston housing can flow out. When the casing is empty, tilt it in the opposite direction to empty the residue in the pump casing.

7.3.2. The oil filling hole is located at the top, and new oil is slowly injected into the equipment. Connect the unit to the power supply and push the piston 2-3 times.

7.3.3. Finally, follow the oil level check procedure.

Note: Dispose of hydraulic oil in accordance with local regulations. Do not pour into the sea, rivers, lakes or drains.

### 7.4 Bolt tightness

After cutting every 500 times a week, check the tightness of all bolts. Loose bolts will cause power loss.

### 7.5 Carbon brush

Check the carbon brushes at least twice a month. (The normal time is 200 hours.)

Note: Worn carbon brushes will cause power loss, cause the motor to heat up, and cause irreparable damage to the motor commutator.

7.5.1. Disconnect the electric

7.5.2. Unscrew the brush cap and pull out the carbon brush.

7.5.3. If the length of the brush is less than 6 mm, it should be replaced immediately.

## 8 . Common malfunction and solutions

malfunction	Reason	solutions
Push shaft speed slow and push force small	1. the hydraulic oil is not enough or have air inside 2. The pressure relief valve is damaged	1. Let the oil hole face upwards, continuous start the switch with no load, refueling, press the pressure relief valve until the push shaft can move normally 2. Replace the pressure relief valve
The push shaft can't	1. The flat key in the head is	1. Replace falt key

push out and return normally	stuck 2. The push shaft expands	2.Let the shaft push out.Sand the high point with sandpaper so that the shaft can be retracted and extended normally
Carbon brush sparks is big	1. Carbon brush wear Severe 2. copper pieces on the rotor wear Severe 3. Short circuit	1. Replace the carbon brush 2. Replace the rotor 3. Check whether the circuit is short-circuited
The sound is unnormal when the equipment is running	1. needle bearings Broken 2. Parts loose	1. Replace the needle bearing 2. Check the connection status of each part equipment without power
Blade collapse	1. The bar is not placed in the correct position when cutting the rebar	1. Operate correctly according to the operation steps in the manual

Note: malfunction not mentioned, please contact supplier

## 9 . Accessories

1. Manual instruction 1 copy
2. Tool kit 1 set
3. Oil can 1pcs
4. Certificate 1 pcs