



The Benchmark of Service

Service Bulletin No. RC20050713
Subject: Pinched Oil Leveler Sack
Model: HBC19
Product Group: Rebar Cutter
Date: 07/13/2005

SERVICE BULLETIN

Group: RC

- Mandatory, Information (checked), Recommended Change

Series/Parts Affected:
Oil Leveler Sack Part No. H9T43899N1

Machines Affected

Serial Numbers: 491053 - 491177, 491248 - 491387, 491408 - 491487, 681001 - 681110

SERVICE INFORMATION

It was found that several HBC19 Rebar Cutters have an oil leveler sack which could be pinched by the cutter rod return spring. The cutter rod return spring is installed around the cutter rod. Factory instructions state that the cutter rod return spring has to be installed in a way that the end of the spring is positioned at the opposite sides of the oil leveler. Carefully installing the spring will prevent the oil leveler sack from being pinched. The following instructions show the proper installation.

SYMPTOM INFORMATION

If there is a hole pinched in your oil leveler sack you may notice the following:
1. Hydraulic oil leaking from the oil leveler sack bolt (front of rebar cutter).
2. The cutter rod will not move.

TOOLS REQUIRED

- 3/8" Drive Ratchet, 6 mm Allen Socket, 8 mm Allen Socket, 17 mm Combination End Wrench

INSTALLATION INSTRUCTIONS

- 1) Remove the hydraulic oil drain plug with a 17 mm combination end wrench. Drain the oil into an oil pan.



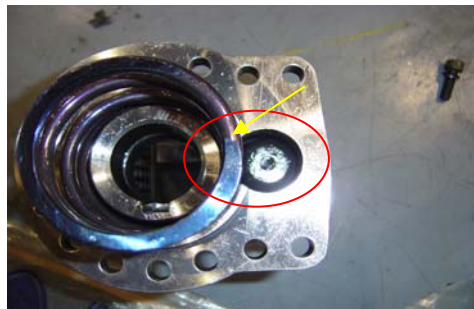
- 2) Once the hydraulic oil has been removed, use a 6 mm Allen socket screw and 3/8" ratchet to remove the 14 bolts that hold the bar holder in place.



CAUTION: Make sure to leave the two bottom bolts and one top bolt for last. Slowly and evenly back the bolts off. This will relieve the tension on the cutter rod return spring.



- 3) Once the rod holder is removed from the rest of the unit, inspect the spring and see if the ending edge rests directly above the oil leveler sack. If so, you may find the oil leveler sack with a hole in it as shown on the right.



4) If a hole is found in the oil leveler sack, replace it with a new one (part number H9T43899N1).



5) To replace the oil leveler sack, remove the allen head bolt found in front of the bar holder using an 8 mm allen socket screw and ratchet. Remove the oil leveler sack from the bar holder.



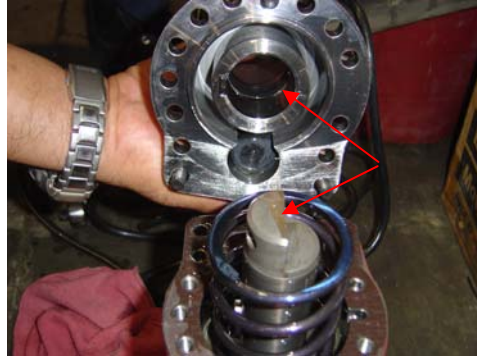
6) Installing the new oil leveler sack is the opposite of its removal. Torque the oil leveler sack bolt to 15 foot lbs.



7) After installing the new oil leveler sack, place the cutter rod return spring so that the ending edge rests off to the side of the unit.



- 8) Place the bar holder over the cutter rod. Make sure that when placing the two together you do not pinch or catch any part of the sack.



- 9) Once aligned correctly, press down on the bar holder end and start replacing the 14 bolts. Start with 3 to 4 bolts to hold the two ends together and then replace the remaining bolts. Retorque the bolts to 25 foot lbs.



- 10) Replace the hydraulic oil with 10.2 oz of Shell Tellus oil # 32 or Exxon Teresstic #32.

Replacing oil:

- a) Turn the cutter so oil fill port is on top side. Fill with oil until it overflows. Shake the cutter up and down to release any air bubbles that may be present and over fill again. Replace bolt in fill port and wipe off any excess oil.
- b) **Note: This step is also for checking oil level and adding make-up oil.** Plug cutter in and place a ¼ rebar in bar holder. Turn on switch to activate the cutter rod and allow the blade to touch the rod, and then release the switch. Turn cutter so that oil fill port is on the top side, remove the oil fill plug and repeat oil fill procedure (step a). When finished, continue the cutting process started earlier.



11) Test the unit and check for leaks.



WARRANTY INFORMATION

Campaign: Reference No. 20050713

Please contact Chris Fairchild or George Manrique @ 1-800-421-1244 for warranty claim number.

Labor Allowance: Flat Rate to install 1 hour