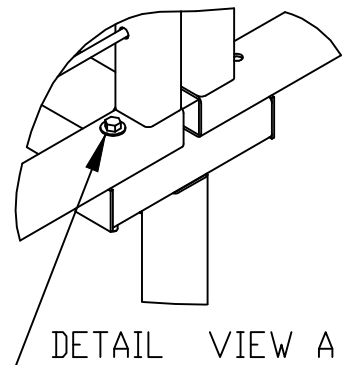
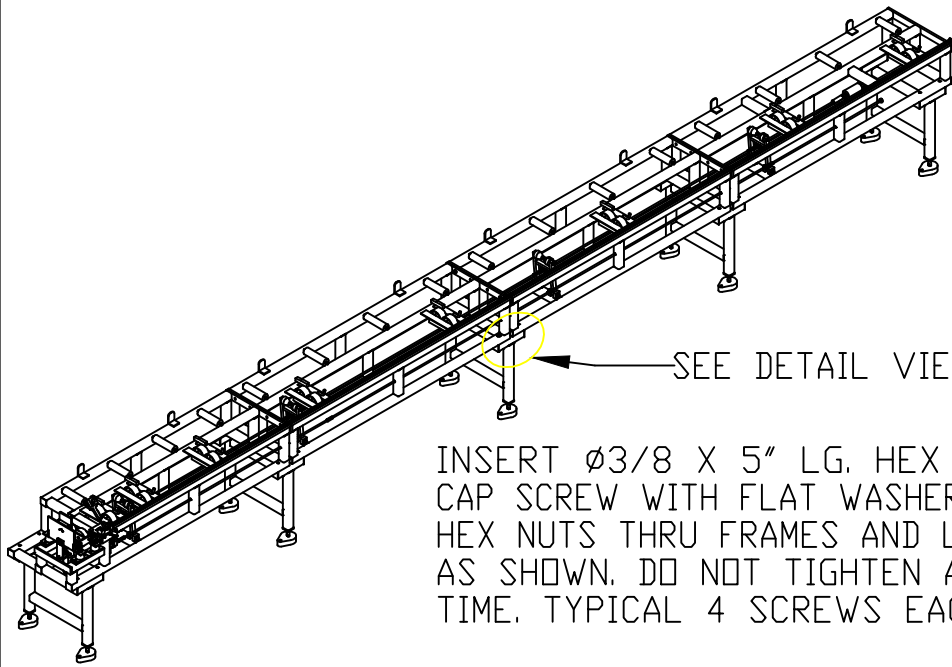


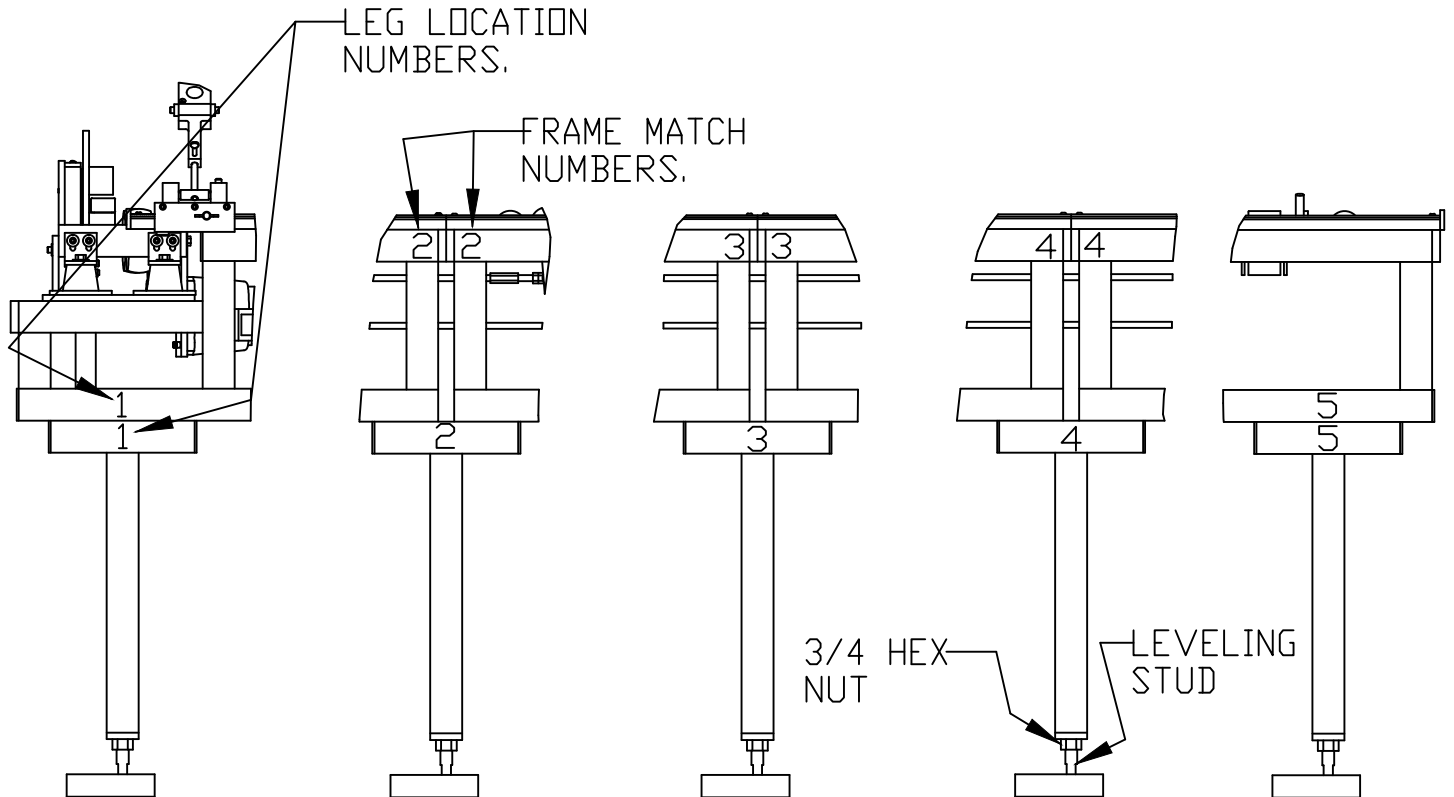
ASSEMBLY INSTRUCTIONS FOR THE BIGCUT

BIGCUT BOLT AND PACKING LIST

QTY.	DESCRIPTION	PART #
20	3/8-16 X 5" LG. H.H.C.S.	HA
40	3/8 FLAT WASHER	H22
40	3/8-16 HEX NUT	H19
6	1/2-13 X 1-1/2" LG. H. H. C.S.	I1
6	1/2 LOCK WASHER	I23
6	1/2-13 HEX NUT	I14
6	ø1/2" X 1 LG. DOWEL PIN	I20
9	3/8-16 COUPLING NUT	H20
8	WHEEL	937
8	1/2-13 X 3-1/2" LG. H.H.C.S.	I4
8	1/2 FLAT WASHER	I22
2	ø1/4" AIR LINE X 25 FT. LG.	
4	AIR VALVE RODS	
3	LIFT RODS	
5	BIGCUT LEGS	
4	BIGCUT SECTIONS	
1	BIGCUT TROLLEY & SPRING	




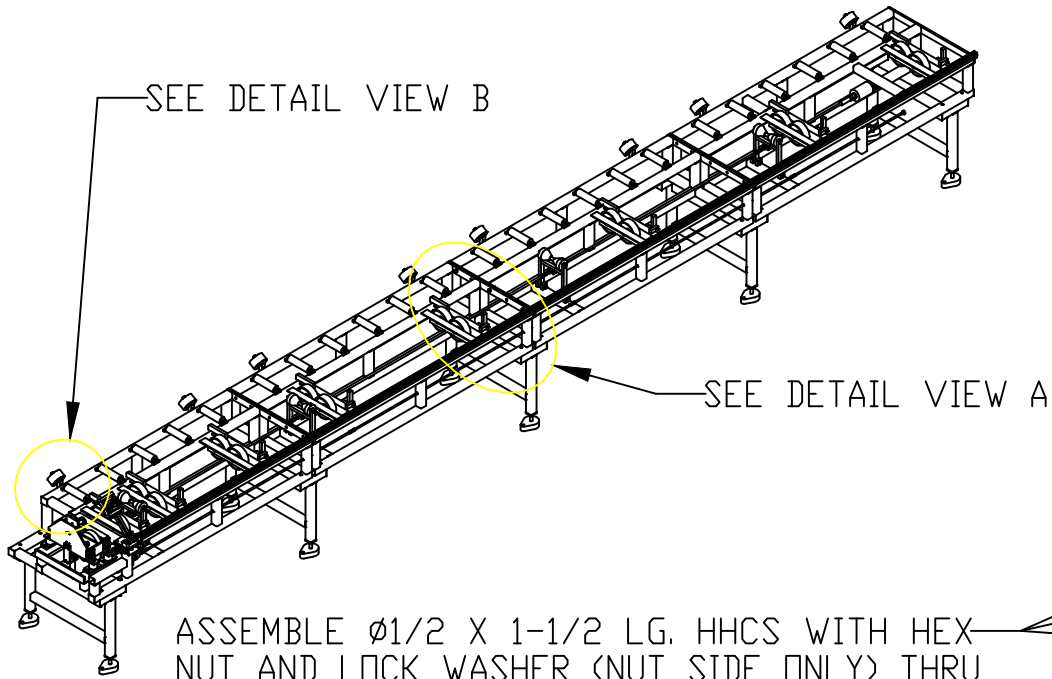
INSERT $\phi 3/8$ X 5" LG. HEX HD. CAP SCREW WITH FLAT WASHERS AND HEX NUTS THRU FRAMES AND LEGS AS SHOWN. DO NOT TIGHTEN AT THIS TIME. TYPICAL 4 SCREWS EACH LEG.



ASSEMBLY INSTRUCTIONS:
 REMOVE LEGS FROM SHIPPING PALLET. ARRANGE ON FLOOR IN AREA DESIGNATED FOR BIGCUT (LEGS ARE IDENTIFIED WITH NUMBERS 1 THRU 5). REMOVE FRAMES FROM PALLET AND PLACE ON LEGS, MATCHING THE ASSEMBLY NUMBERS AS SHOWN ABOVE (FRAME SECTIONS ARE MARKED WITH MATCHING NUMBERS - 2 THRU 4). TO LEVEL QUICKCUT FRAME, LOOSEN 3/4 HEX NUT AS SHOWN AND ROTATE LEVELING STUD TO RAISE OR LOWER FRAME. TIGHTEN HEX NUTS WHEN FINISHED.

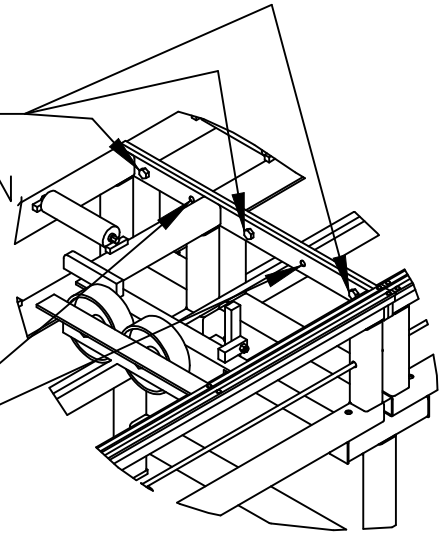
BIGCUT ASSEMBLY INSTRUCTIONS

 North Alabama Pipe Corporation



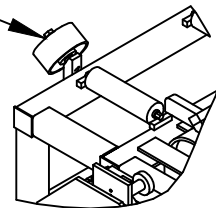
ASSEMBLE $\phi 1/2$ X 1-1/2 LG. HHCS WITH HEX NUT AND LOCK WASHER (NUT SIDE ONLY) THRU 3 HOLES SHOWN IN EACH FRAME JOINT SECTION, TYPICAL 3 BOLTS 3 PLACES, TIGHTEN AFTER INSERTING $\phi 1/2$ " DOWEL PINS.

ASSEMBLE $\phi 1/2$ " X 1" LG. DOWEL PINS IN 2 HOLES SHOWN IN EACH FRAME JOINT SECTION, TYPICAL 2 PINS 3 PLACES.



DETAIL VIEW A

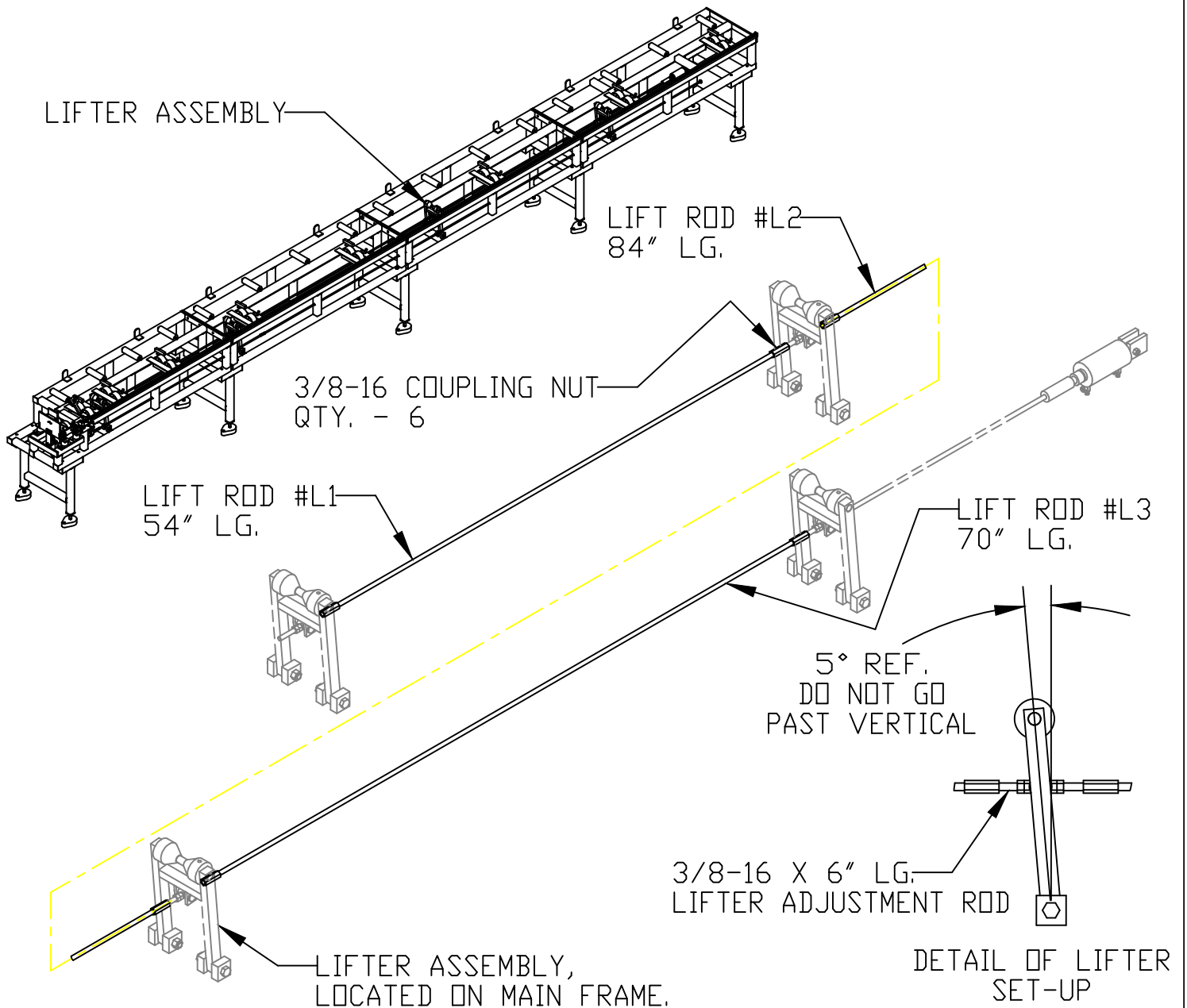
ASSEMBLE WHEELS (PART #937) WITH $\phi 1/2$ X 3" LG. HHCS WITH FLAT WASHER, TYPICAL 8 PLACES



DETAIL VIEW B

NOTE: TIGHTEN THE LEG SCREWS ($\phi 3/8$ X 5" LG. HHCS) AFTER COMPLETING THE ABOVE.

BIGCUT ASSEMBLY INSTRUCTIONS



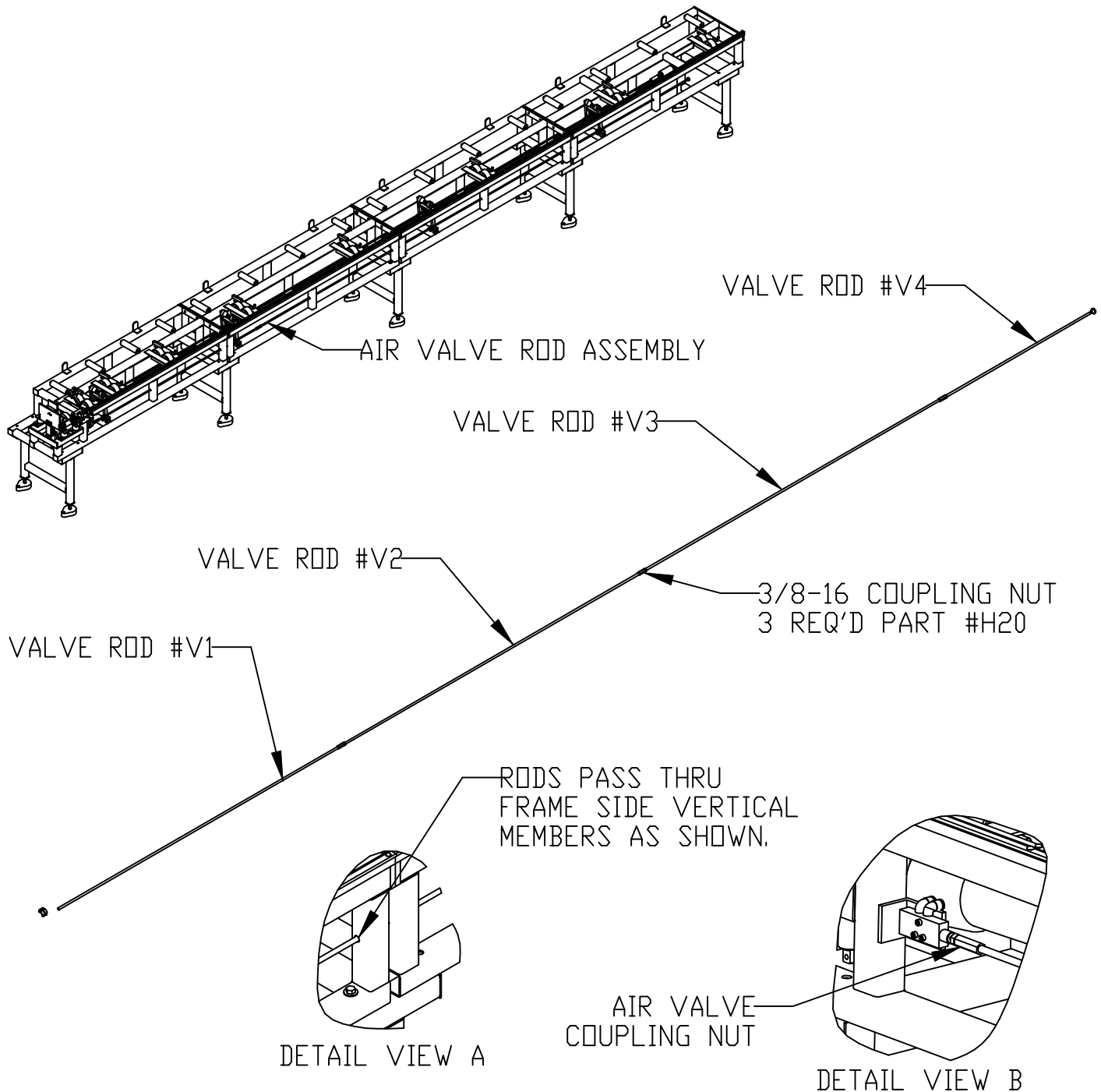
LIFT ROD ASSEMBLY INSTRUCTIONS:

REMOVE PACKING TAPE FROM ROD BUNDLE. RODS SHOULD BE TAGGED L1 THRU L3. LOCATE 3/8-16 COUPLING NUTS (SHIPPED IN BOX WITH ALL FASTENERS), ASSEMBLE 1 COUPLING NUT TO EACH END OF LIFT RODS AND ATTACH TO THREADED ROD IN EACH LIFTER ASSEMBLY. LIFTER RODS SHOULD BE INSTALLED WITH THE ENDS AGAINST THE THREADED ROD IN EACH LIFTER ASSEMBLY. USE THE THREADED RODS IN EACH LIFTER IF ADJUSTMENT IS REQUIRED. ADJUST RODS SO EACH LIFTER ASSEMBLY IS WITHIN 5 DEGREES OF THE VERTICAL POSITION WITH THE LIFT CYLINDER FULLY RETRACTED. DO NOT ALLOW THE LIFTERS TO BE AT VERTICAL OR PAST VERTICAL. SEE LIFTER DETAIL SET-UP VIEW.

BIGCUT ASSEMBLY INSTRUCTIONS



North Alabama Pipe Corporation

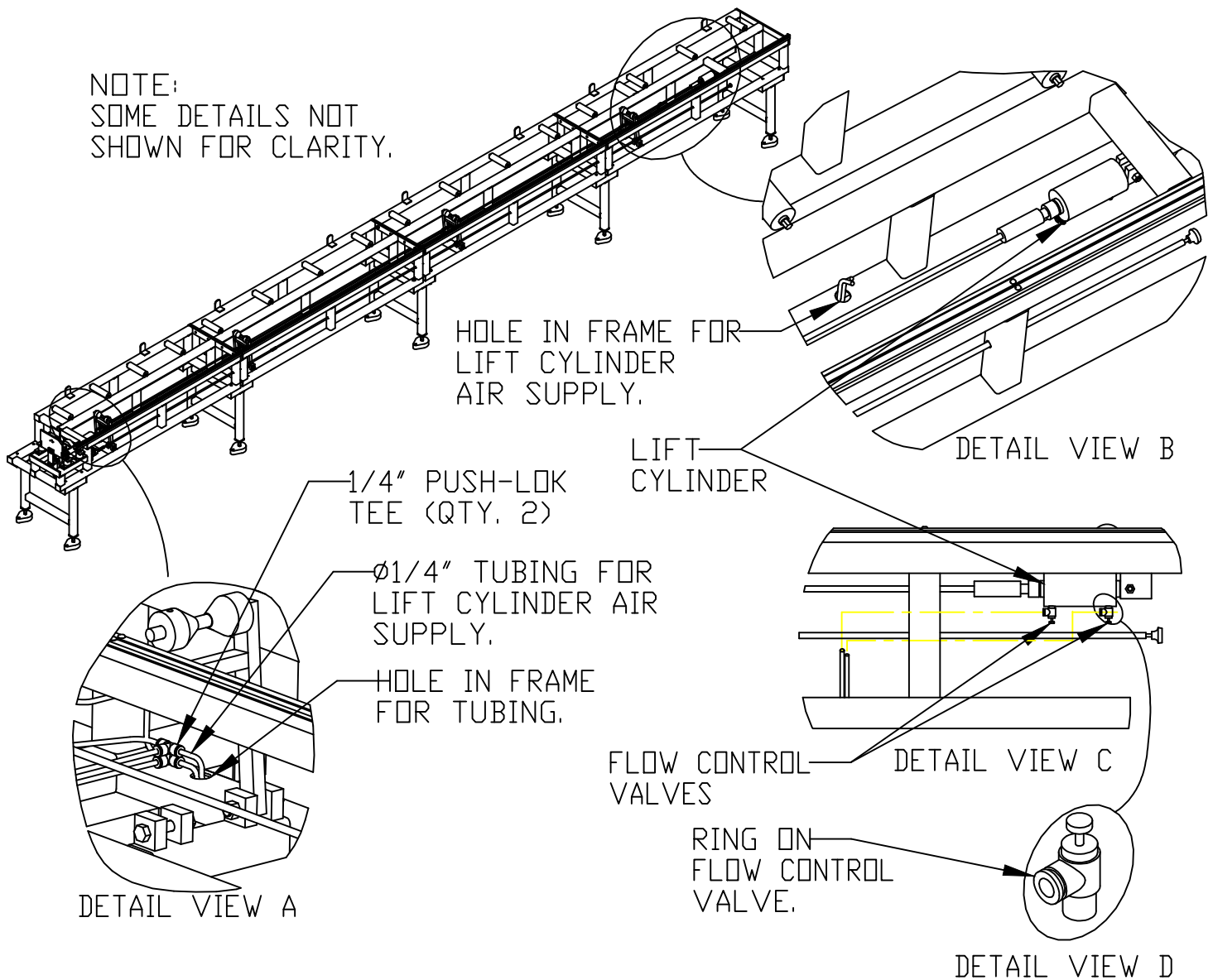


AIR VALVE ROD ASSEMBLY INSTRUCTIONS:
 REMOVE PACKING TAPE FROM ROD BUNDLE. RODS SHOULD BE TAGGED #V1 THRU #V4. PASS AIR VALVE ROD #V1 THRU FRAME AS SHOWN IN DETAIL VIEW A. ATTACH ROD TO NUT ON AIR VALVE, SEE DETAIL VIEW B. LOCATE 3/8-16 COUPLING NUTS (SHIPPED IN BOX WITH ALL FASTENERS). THREAD COUPLING NUT TO THE END OF AIR VALVE ROD V1, ASSEMBLE AIR VALVE ROD #V2 TO THE END OF ROD #V1. ASSEMBLE REMAINING RODS IN ORDER.

BIGCUT ASSEMBLY INSTRUCTIONS


 North Alabama Pipe Corporation

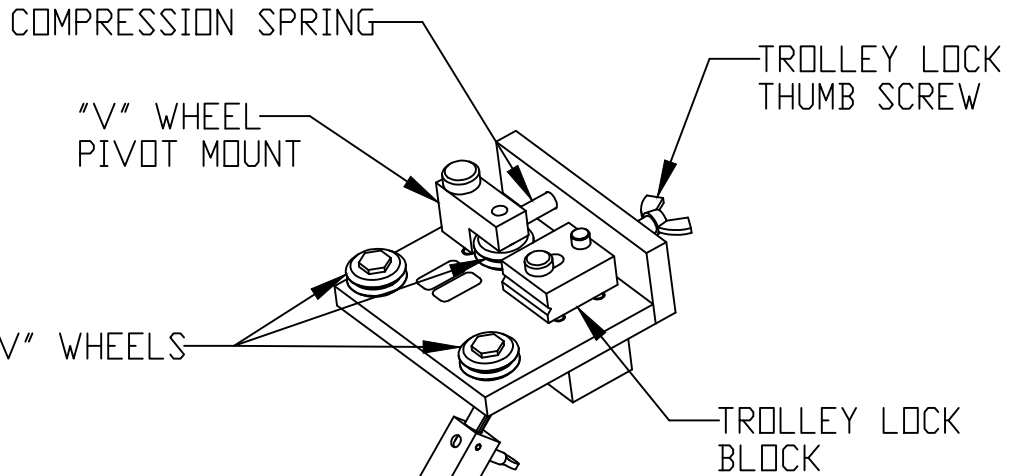
NOTE:
SOME DETAILS NOT
SHOWN FOR CLARITY.



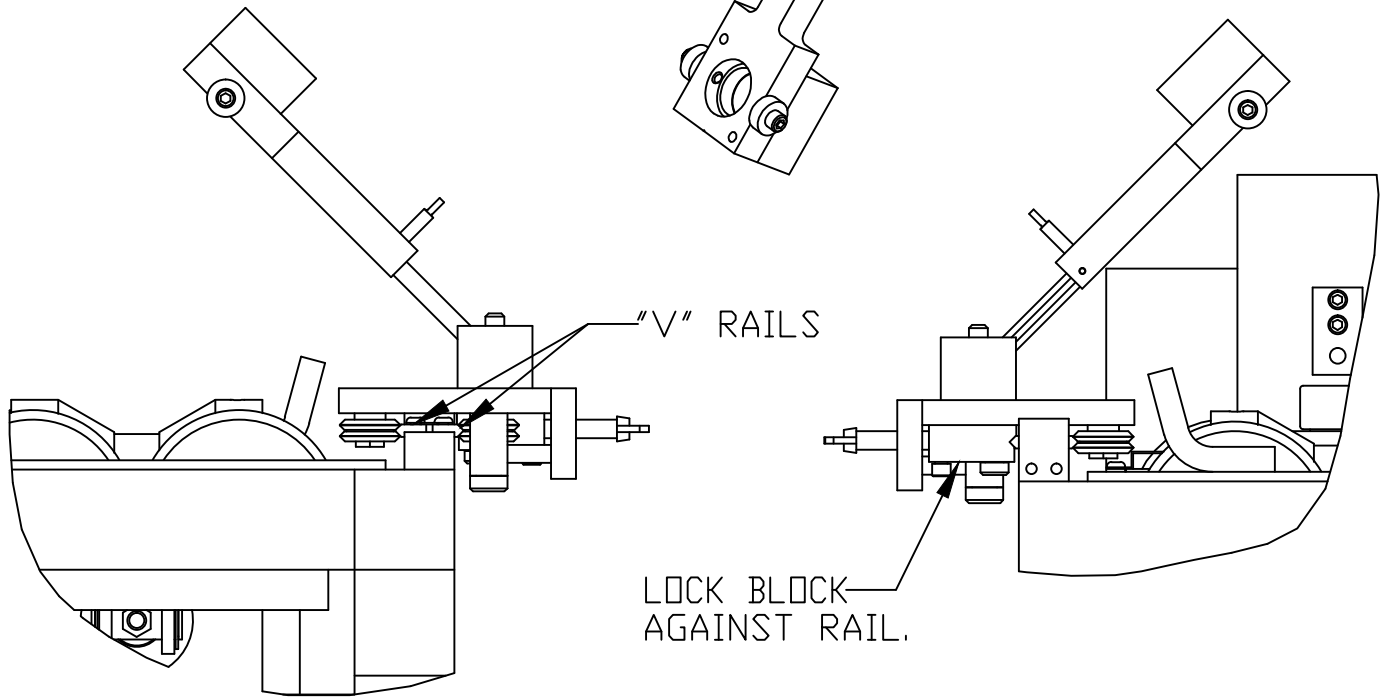
AIR TUBING TO LIFT CYLINDER ASSEMBLY INSTRUCTIONS:
 REMOVE AIR TUBING FROM BOX, TUBING IS 1/4" X 25FT LG. (2 PIECES).
 THREAD TUBING THRU HOLE IN FRAME AS SHOWN IN DETAIL VIEW A, AND PULL
 THRU HOLE AT OTHER END - SEE DETAIL VIEW B. INSERT TUBING INTO THE
 TEES -SEE DETAIL VIEW A, TUBING MUST BE FULLY INSERTED INTO THE TEES.
 PULL ON THE TUBING AND TEE TO MAKE SURE THE TUBING IS LOCKED IN PLACE.
 INSERT THE OTHER ENDS INTO THE FLOW CONTROL VALVES LOCATED ON THE
 LIFT CYLINDER - SEE DETAIL VIEW C. CONNECT AIR SUPPLY TO THE AIR VALVE,
 AND PULL ON THE AIR VALVE ROD TO RAISE THE LIFTERS, AND PUSH ON THE
 AIR VALVE ROD TO LOWER THE LIFTERS. IF THE LIFT CYLINDER OPERATES IN
 REVERSE, SWITCH THE AIR LINES AT THE LIFT CYLINDER. REMOVE THE TUBING
 BY PUSHING ON THE AIR LINE, AND PUSHING ON THE RING THE TUBING GOES
 THRU ON THE FLOW CONTROL VALVE - SEE DETAIL VIEW D, THEN PULL OUT ON
 THE TUBING WHILE HOLDING THE RING IN. REINSERT TUBING AS NOTED ABOVE.

BIGCUT ASSEMBLY INSTRUCTIONS

 North Alabama Pipe Corporation



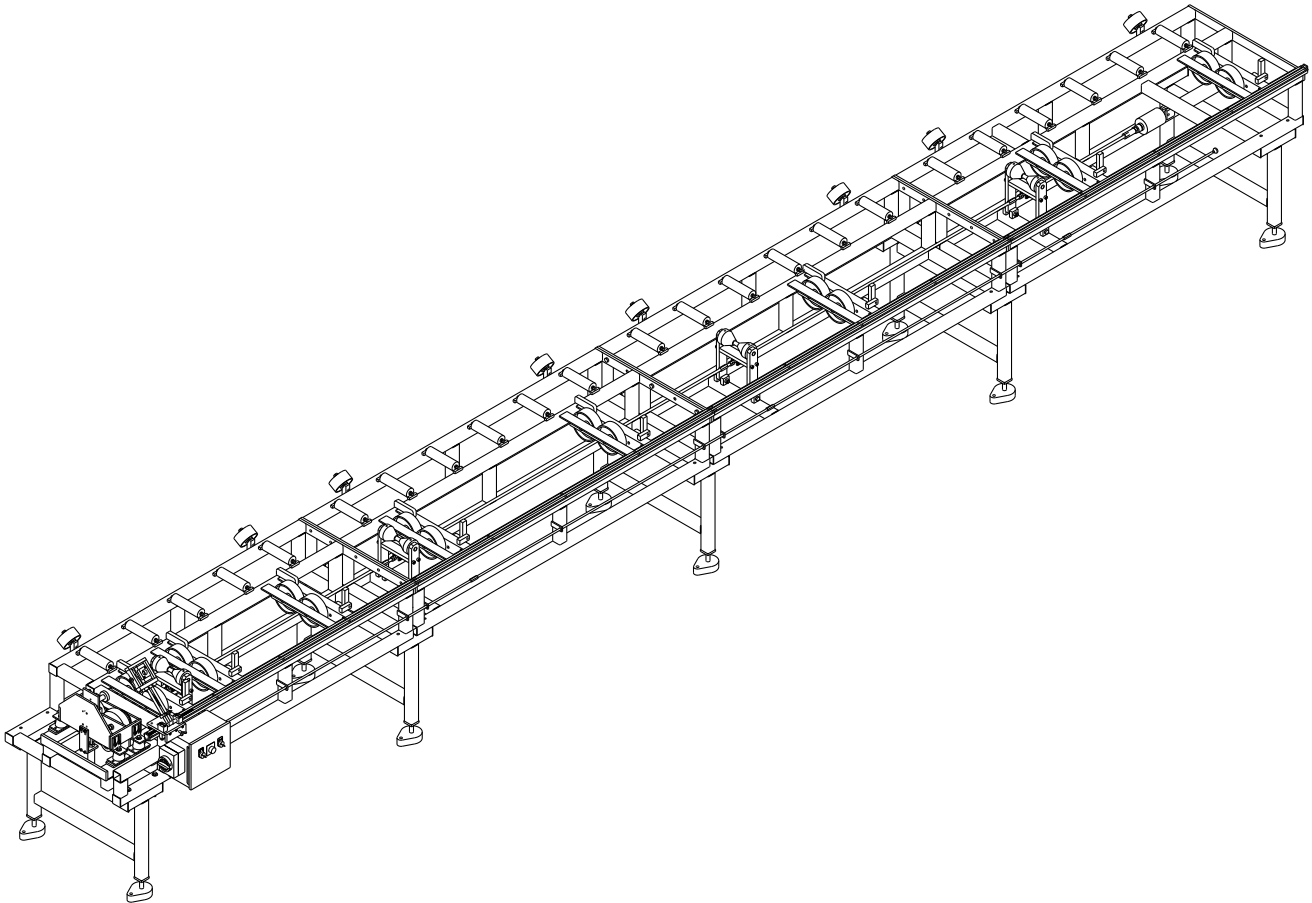
NOTE:
SOME DETAILS NOT
SHOWN FOR CLARITY.



BIGCUT TROLLEY ASSEMBLY INSTRUCTIONS:
REMOVE BIGCUT TROLLEY FROM BOX. LOOSEN TROLLEY LOCK THUMB SCREW. COMPRESS SPRING BY PUSHING "V" WHEEL PIVOT MOUNT. ALIGN "V" WHEELS WITH THE "V" RAILS LOCATED ON THE MAIN FRAME. RELEASE PIVOT MOUNT. ROLL THE TROLLEY ASSEMBLY BACK AND FORTH ON THE RAILS TO MAKE SURE "V" WHEELS ARE ALIGNED WITH THE RAILS. SPRING PRESSURE WILL HOLD TROLLEY IN POSITION TO THE RAILS. TO LOCK TROLLEY IN CUTTING POSITION, TIGHTEN THE TROLLEY LOCK THUMB SCREW, THIS WILL TIGHTEN THE LOCK BLOCK AGAINST THE RAILS.

BIGCUT ASSEMBLY INSTRUCTIONS

 North Alabama Pipe Corporation



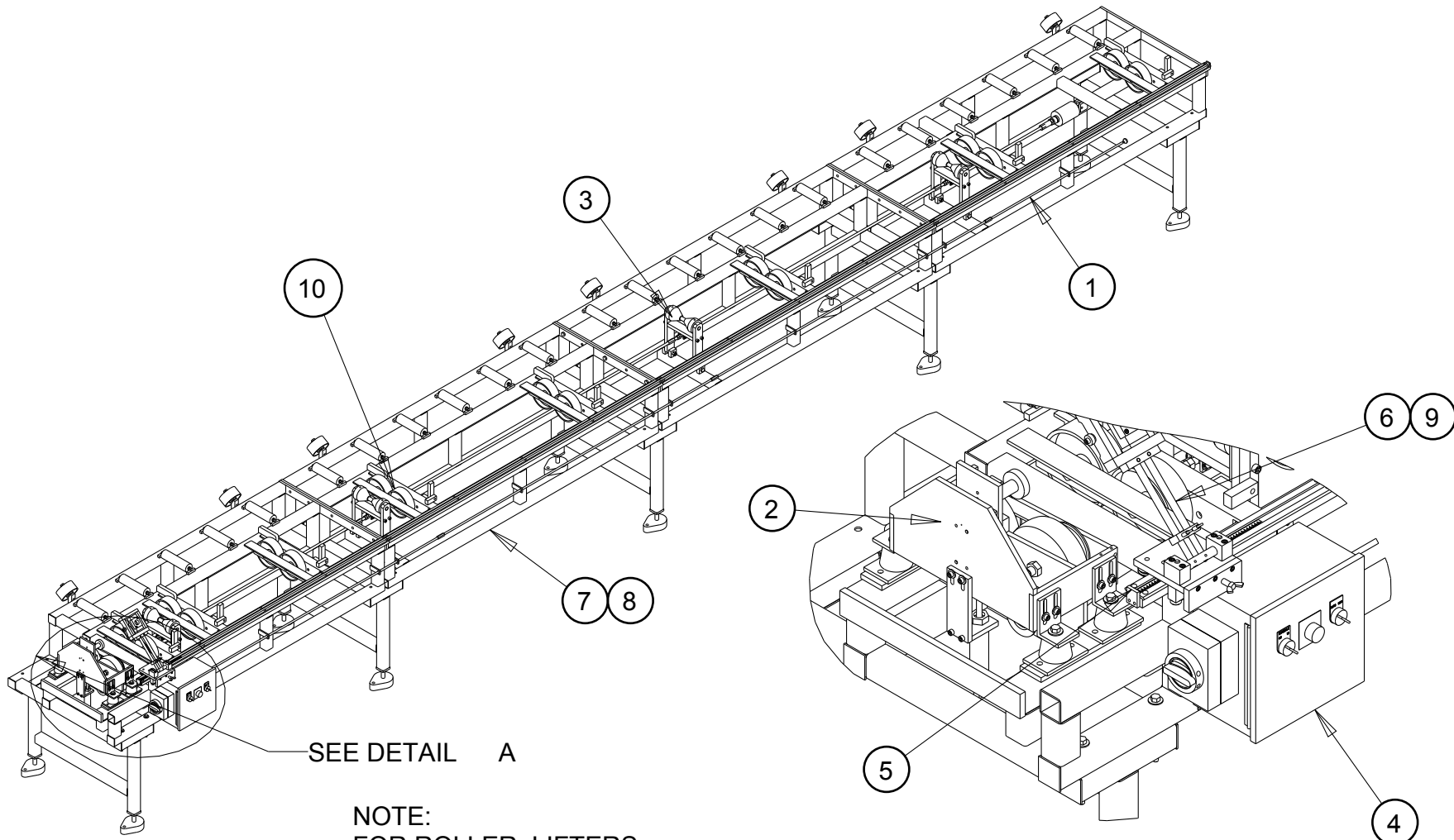
BIGCUT ASSEMBLY PARTS MANUAL



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BIGCUT DRAWING SHEET INDEX

SHEET NUMBER	DESCRIPTION	PART NUMBER
SHEET #1	BIGCUT PARTS MANUAL COVER SHEET	
SHEET #2	BIGCUT DRAWING INDEX SHEET	
SHEET #3 & #4	BIGCUT ASSEMBLY	20-BCA
SHEET #5 & #6	QUICKCUT AIR SYSTEM ASSEMBLY	20-QAS-AIR SYS
SHEET #7 & #8	BIGCUT HEAD ASSEMBLY	20-BAS-HEAD ASSY
SHEET #9 & #10	BIGCUT PIPE CLAMP ASSEMBLY	20-BAS-PIPE CLAMP
SHEET #11 & #12	BIGCUT LIFTERS ASSEMBLY	20-BAS-COMPLETE LIFTER
SHEET #13 & #14	BIGCUT SINGLE LIFTER ASSEMBLY	20-BAS-SINGLE LIFTER
SHEET #15 & #16	BIGCUT MEASURE ASSEMBLY	20-BAS-MEASURE
SHEET #17 & #18	BIGCUT TROLLEY ASSEMBLY	20-BAS-TROLLEY
SHEET #19 & #20	BIGCUT MAIN FRAME ASSEMBLY	20-BAS-MAIN FRAME
SHEET #21 & #22	QUICKCUT ELECTRICAL BOX ASSEMBLY	20-QAS-ELECT BX ASY
SHEET #23 & #24	BIGCUT TORCH GUIDE ASSEMBLY	20-BAS-TORCH GUIDE
SHEET #25 & #26	BIGCUT ROLLER ASSEMBLY	20-BAS-ROLLER ASSY
SHEET #27	ELECTRICAL BOX SCHEMATIC	20-QAS-ELECT BX ASY 01
SHEET #1	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #2	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #3	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #4	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #5	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #6	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #7	BIGCUT ASSEMBLY INSTRUCTIONS	
SHEET #8	BIGCUT ASSEMBLY INSTRUCTIONS	



SEE DETAIL A

NOTE:
 FOR ROLLER, LIFTERS,
 BACKSTOP & WHEEL LOCATIONS
 SEE DRAWING #20-BCA-01.

DETAIL A
 SCALE 0.094

BIGCUT ASSEMBLY

Revision "A"
 See BOM Sheet

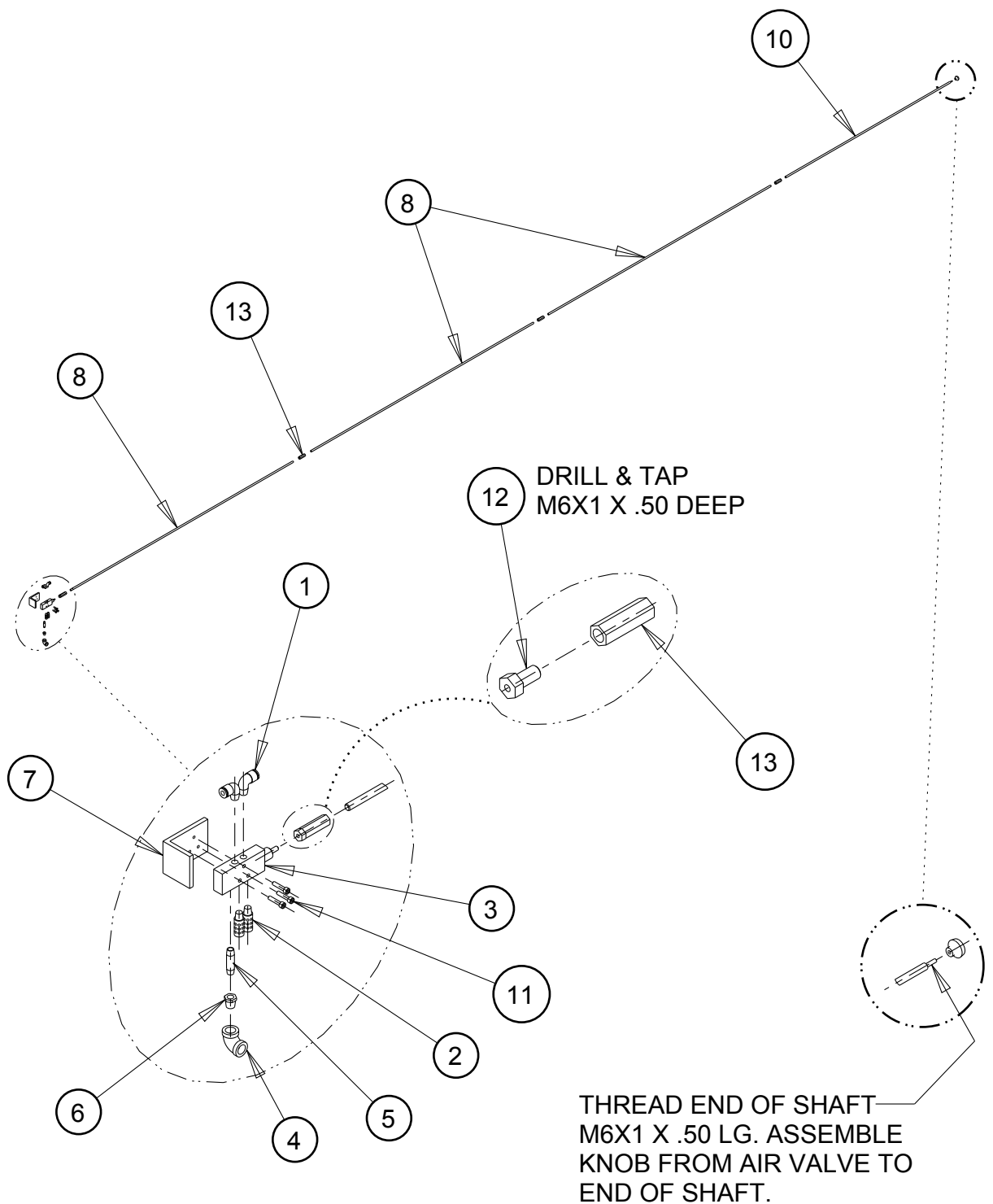
BIGCUT PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-QAS-AIR-SYS	1	AIR SYSTEM ASSEMBLY
2	20-BAS-HEAD-ASY	1	HEAD ASSEMBLY
3	20-BAS-COMPLETE LIFT	1	LIFT ASSEMBLY
4	20-QAS-ELECT BX ASY	1	ELECTRICAL BOX ASSEMBLY
5	20-BAS-MEASURE	1	MEASURE ASSEMBLY
6	20-BAS-TROLLEY	1	TROLLEY ASSEMBLY
7	20-BAS-MAIN FRAME	1	MAIN FRAME ASSEMBLY
8	20-BAS-SHIPMENT PKG	1	SHIPMENT PACKAGE
9	20-BAS-TORCH GUIDE	1	BIGCUT TORCH GUIDE ASSEMBLY
10	20-BAS-ROLLER ASY	8	BIGCUT ROLLER ASSEMBLY

Revision "A" 1/22/15

Item #4 was 20-BAS-Multi Drive, now 20-QAS-Elect Bx Asy

Items #9 & #10 were Items #10 & #11.



QUICKCUT AIR VALVE ASSEMBLY



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REVISION "A" SEE BOM SHEET

20-QAS-AIR SYS

QUICKCUT AIR VALVE PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-AIR-417	2	1/4 X 1/8M ELBOW
2	20-AIR-419	2	MUFFLER
3	20-AIR-426	1	AIR VALVE
4	20-AIR-431	1	1/4 X 90° ELBOW
5	20-AIR-432	1	1/8 X 2" LG. NIPPLE
6	20-AIR-433	1	1/4 X 1/8 PIPE REDUCER
7	20-QMP-4107	1	MOUNT ANGLE
8	20-QMP-4519	3	3/8-16 X 72" LG. ALL THREAD
10	20-QMP-4560	1	3/8-16 X 54" LG. ALL THREAD
11	20-FAS-E26	3	#10-24 X 1" LG. S.H.C.S.
12	20-FAS-H1	1	3/6-16 X 1" LG. HHCS
13	20-FAS-H20	4	3/8-16 COUPLING NUT

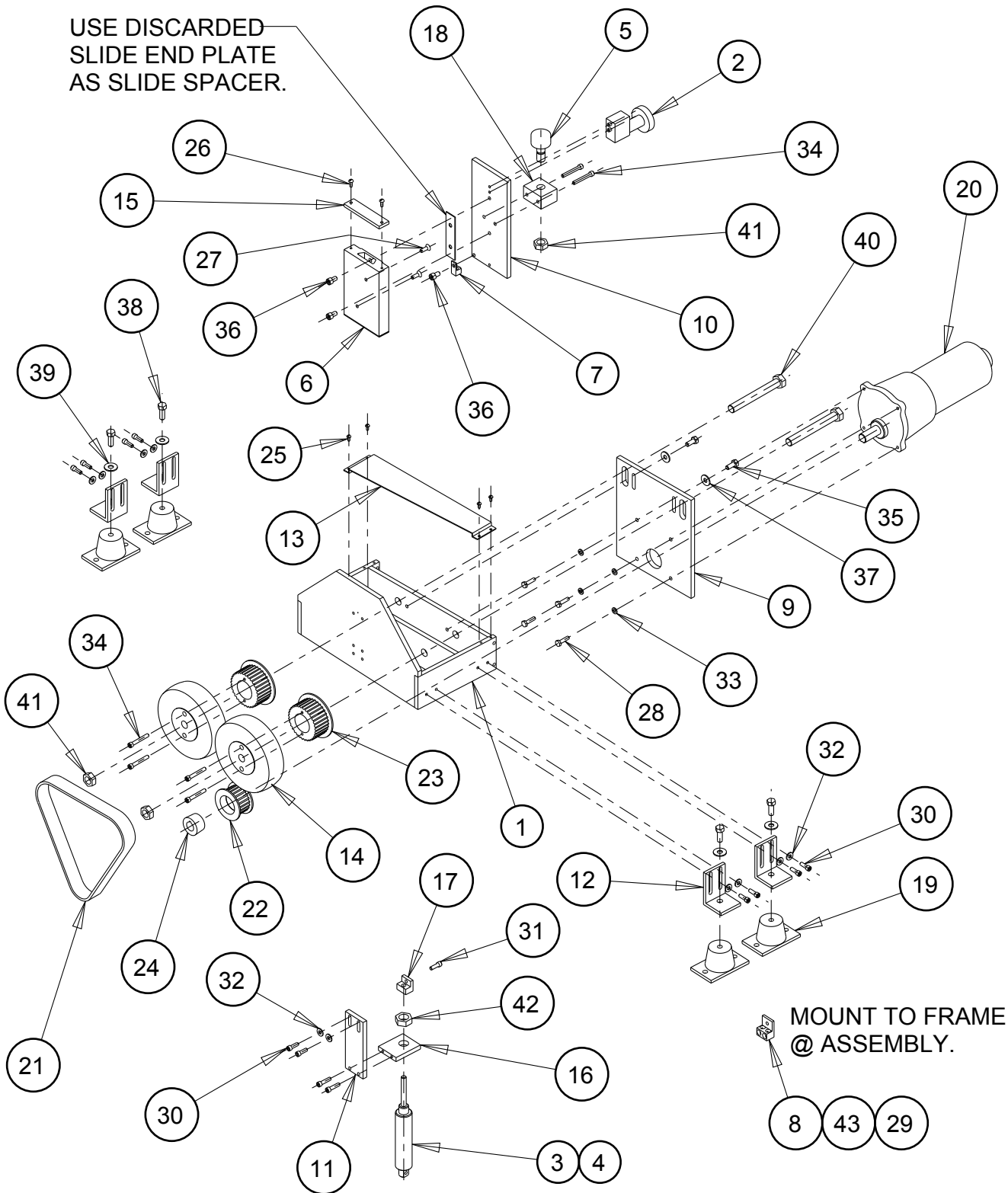
REVISION "A" 9/13/13

ITEM #8 WAS 1 REQ'D @ 73-1/2" LG. NOW 3 REQ'D @ 72" LG.

ITEM #9 REMOVED.

ITEM #10 WAS 20-QMP-4524, NOW 20-QMP-4560 3/8-16 X 54" LG.

USE DISCARDED
SLIDE END PLATE
AS SLIDE SPACER.



BIGCUT HEAD ASSEMBLY

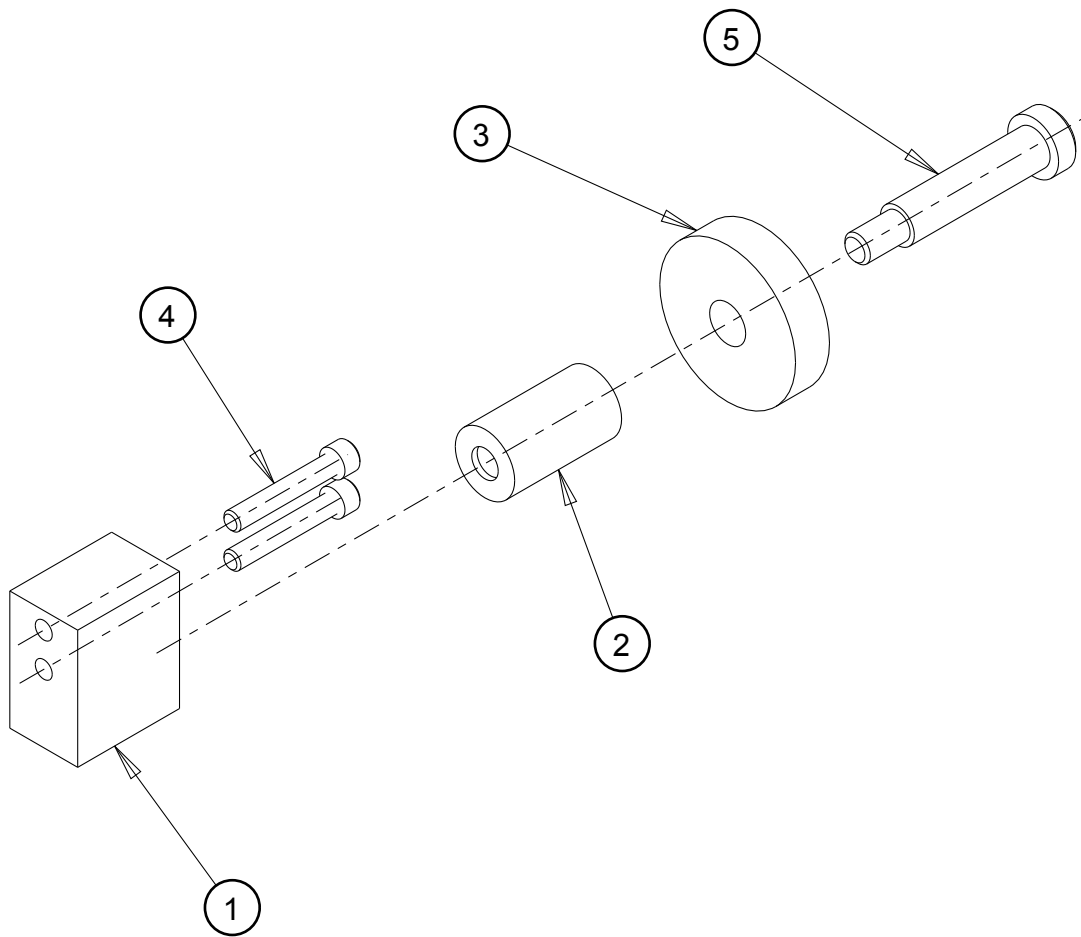


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20-BAS-HEAD ASSY

BIGCUT HEAD ASSEMBLY PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	20-BAS-HEAD WELD	1	BIG CUT HEAD WELDMENT
2	20-BAS-PIPE CLAMP	1	BIG CUT PIPE CLAMP ASSEMBLY
3	20-AIR-405	1	QC PIPE CLAMP CYLINDER
4	20-AIR-412	2	FLOW CONTROL VALVE
5	20-BRG-906	1	THRUST BEARING
6	20-BRG-925	1	6" UNISLIDE (20-BLK-648)
7	20-EPP-0164	2	GROUND LUG 1 HOLE
8	20-EPP-0165	1	GROUND LUG 2 HOLE
9	20-BMP-6000	1	MOTOR PLATE
10	20-BMP-6002	1	SLIDE PLATE
11	20-BMP-6005	1	AIR CYLINDER PLATE
12	20-BMP-6502	4	ANGLE ADJUSTMENT
13	20-BMP-6519	1	BELT GUARD
14	20-BMP-6520	2	RED WHEELS
15	20-QMP-4025	1	UNISLIDE END PLATE
16	20-QMP-4029	1	AIR CYLINDER MOUNT
17	20-QMP-4031	1	AIR CYLINDER BRACKET
18	20-QMP-4501	1	THRUST BEARING MOUNT
19	20-MS-521	4	RUBBER SUPPORTS
20	20-MTR-103	1	MOTOR BIGCUT
21	20-PLY-304	1	BELT 7208M30
22	20-PLY-313	1	DRIVER PULLEY P22-8M-1108
23	20-PLY-314	2	BC PULLEY RED WHEELS
24	20-PLY-324	1	TAPERLOCK BUSHING 1108X3/4
25	20-FAS-D3	4	#8-32 X 3/8" LG. RSLMS
26	20-FAS-E14	2	#10-32 X 1/2" LG. RSLMS
27	20-FAS-F5	2	1/4-20 X 3/4" LG. FHSCS
28	20-FAS-F10	4	1/4-28 X 1" LG. HHCS
29	20-FAS-F23	2	1/4-20 X 1/2" LG. SHCS
30	20-FAS-F24	11	1/4-20 X 3/4" LG. SHCS
31	20-FAS-F27	1	1/4-20 X 1-1/2" LG. SHCS
32	20-FAS-F38	10	Ø 1/4" FLAT WASHER
33	20-FAS-F40	4	Ø 1/4" LOCK WASHER
34	20-FAS-F47	6	1/4-20 X 1-3/4 LG. SHCS
35	20-FAS-G3	2	5/16-18 X 3/4" LG. HHCS
36	20-FAS-G7	11	5/16-18 X 1/2" LG. SHCS
37	20-FAS-G21	2	Ø 5/16" FLAT WASHER
38	20-FAS-H10	4	3/8-16 X 1" LG. SHCS
39	20-FAS-H22	4	Ø 3/8" FLAT WASHER
40	20-FAS-J1	2	5/8-18 X 5" LG. HHCS
41	20-FAS-J4	3	5/8-18 JAM LOCK NUT
42	20-FAS-K1	1	3/4-10 JAM NUT
43	20-WIR-800	1	#4 BLACK GROUND CABLE X 3-1/2" Ft.



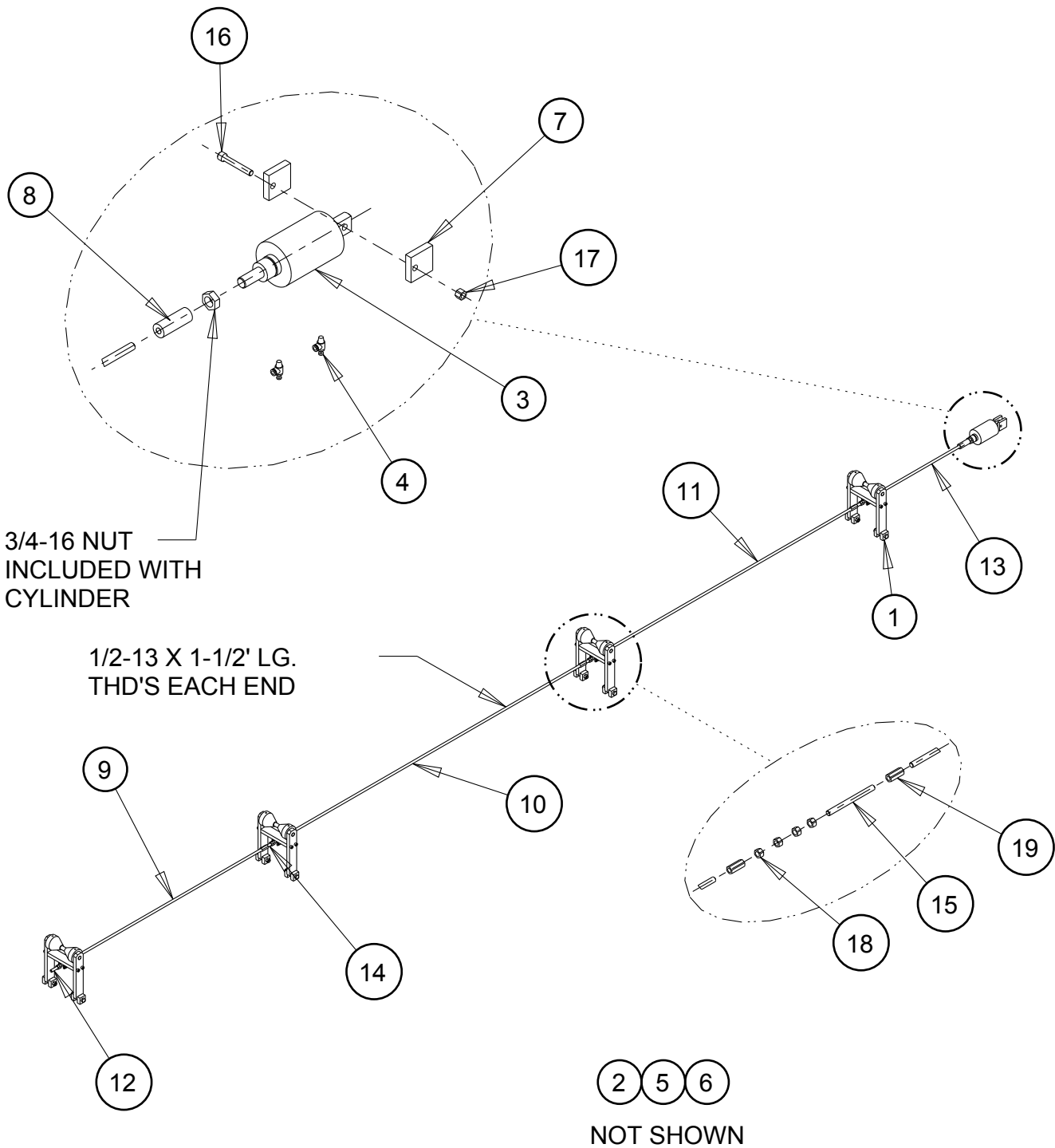
BIGCUT PIPE CLAMP ASSEMBLY

SHEET #4A Division of Anvil International
Innovators Of Pipe Fabrication Equipment

20-BAS-PIPE CLAMP

BIGCUT PIPE CLAMP ASSEMBLY PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	20-QMP-4028	1	PIPE CLAMP BLOCK
2	20-QMP-4556	1	CLAMP WHEEL ADAPTER
3	20-BMP-6542	1	∅ 2.00 GROUND WHEEL
4	20-FAS-F27	2	1/4-20 X 1-1/2" LG. S.H.C.S.
5	20-FAS-I12	1	∅ 1/2 X 2" LG. SHOULDER BOLT



BIGCUT LIFTERS ASSEMBLY



North Alabama Pipe

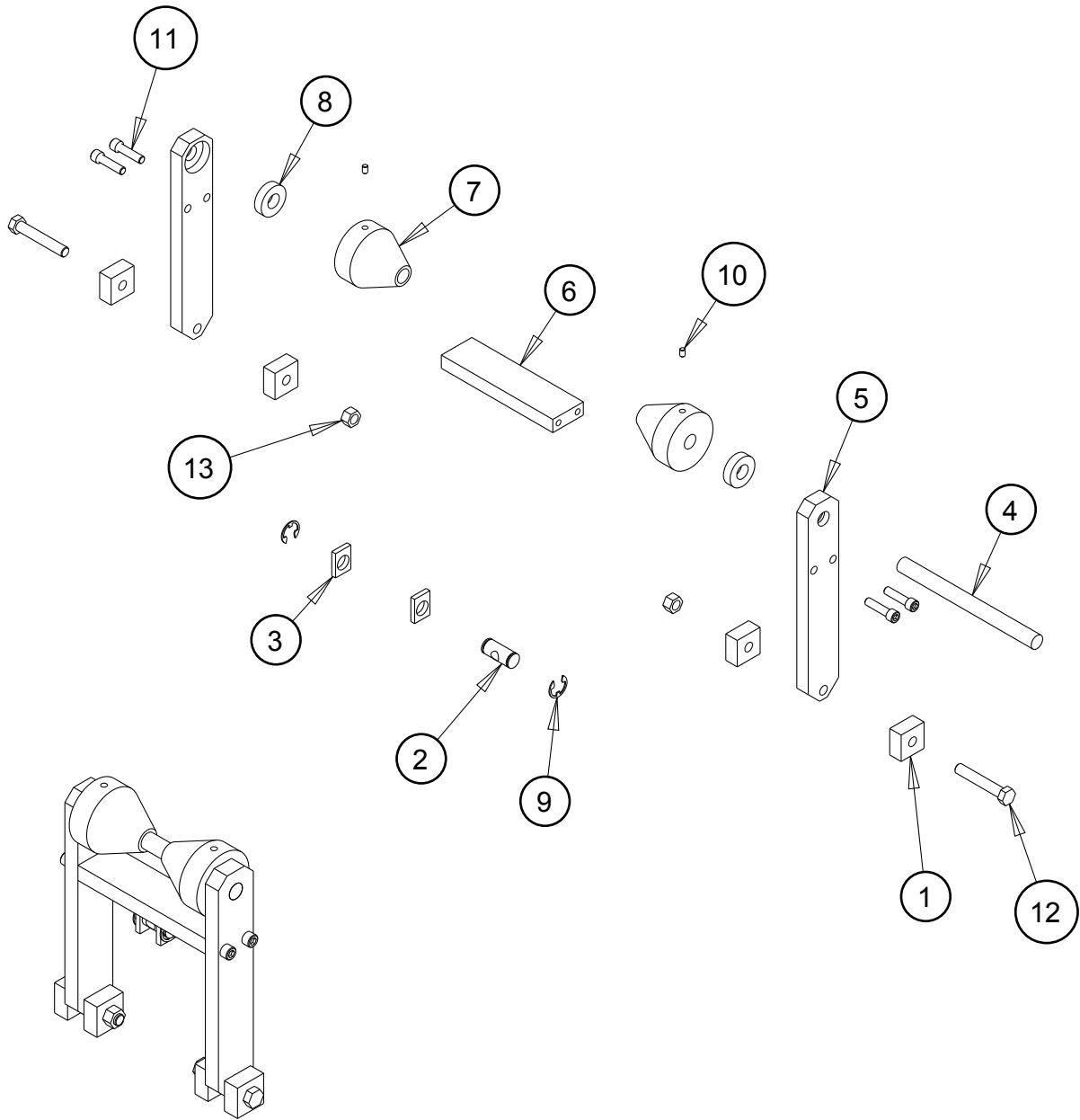
SHEET #5

A Division of Anvil International
Innovators Of Pipe Fabrication Equipment


20-BAS-COMplete-LIFTER

BIGCUT LIFTERS PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	20-BAS-SINGLE LIFTER	4	BIGCUT SINGLE LIFTER
2	20-AIR-403	1	1/4" AIR LINE 50 Ft.
3	20-AIR-407	1	AIR CYLINDER #13X2
4	20-AIR-412	2	FLOW CONTROL
5	20-AIR-422	2	1/4" TUBE TEE
6	20-AIR-532	2	3/8" TO 1/8" NPT REDUCER BUSHING
7	20-BMP-6537	2	CYLINDER MOUNT PLATE
8	20-BMP-6538	1	CYLINDER COUPLING NUT
9	20-BMP-6544	1	∅ 1/2" X 54" LG. CRS ROD
10	20-BMP-6545	1	∅ 1/2" X 84" LG. CRS ROD
11	20-BMP-6547	1	∅ 1/2" X 70" LG. CRS ROD
12	20-BMP-6548	1	1/2-13 X 4" LG. ALL THREAD
13	20-BMP-6549	1	∅ 1/2" X 30" LG. THREAD
14	20-BMP-6550	1	1/2-13 X 5" LG. ALL THREAD
15	20-BMP-6551	1	1/2-13 X 6" LG. ALL THREAD
16	20-FAS-H14	1	3/8-16 X 2-1/2" LG. SHCS
17	20-FAS-H18	1	3/8-16 LOCK NUT
18	20-FAS-I14	18	1/2-13 NUT
19	20-FAS-I15	6	COUPLING 1/2-13 X 1-3/4" LG.



BIGCUT SINGLE LIFTER ASSEMBLY

 **North Alabama Pipe**
 SHEET #6A Division of Anvil International
 Innovators Of Pipe Fabrication Equipment

Revision "A"
 See BOM Sheet

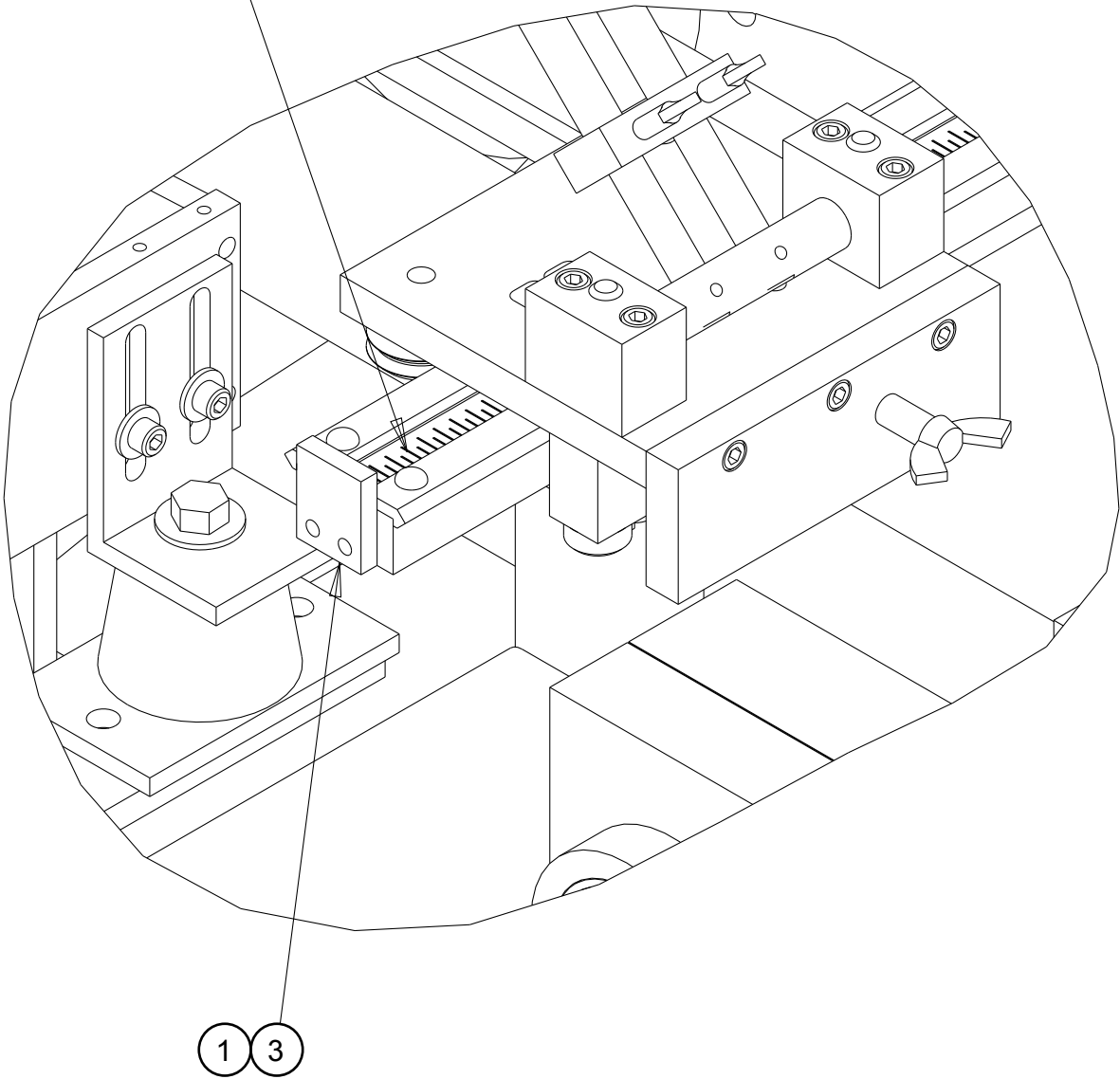
20-BAS-SINGLE LIFTER

BIGCUT LIFTER ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-QMP-4505	4	MOUNTING BLOCKS
2	20-QMP-4506	1	CONNECTING ROD SHAFT
3	20-QMP-4507	2	SHAFT MOUNT
4	20-BMP-6516	1	ROLLER SHAFT
5	20-BMP-6517-A	2	LIFT ARM
6	20-BMP-6518-A	1	CROSS BRACE
7	20-BMP-6536	2	LIFT ROLLER
8	20-BRG-984	2	BIGCUT LIFTER BEARING
9	20-FAS-ECLIP #4	2	3/4"
10	20-FAS-F17	2	1/4-20 X 1/2" LG. SHSS
11	20-FAS-H12	4	3/8-16 X 1-1/2" LG. SHCS
12	20-FAS-I4	2	1/2-13 X 3" LG. HHCS
13	20-FAS-I13	2	1/2-13 NYLOCK NUT

Revision "A" 1/22/15
 Updated per addition of Item #8.

2 GLUE TAPE BETWEEN
TROLLEY TRACKS.



BIGCUT MEASURE



North Alabama Pipe

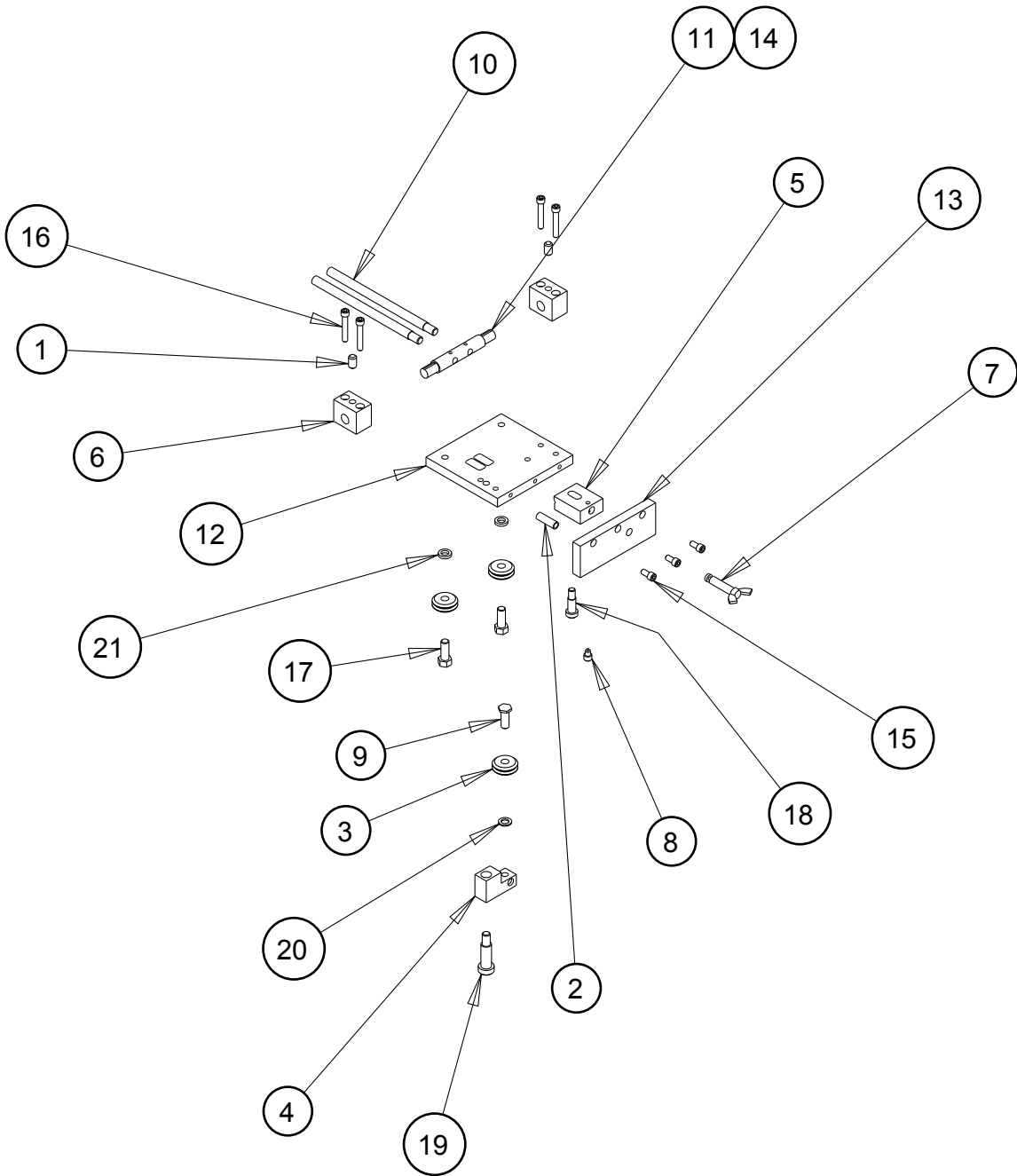
SHEET #8A Division of Anvil International

Innovators Of Pipe Fabrication Equipment

20-BAS-MEASURE

BIGCUT MEASURE PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	20-QMP-4533	2	RAIL END CAP
2	20-MS-522	1	50' METAL TAPE
3	20-FAS-E2	4	#10-24 X 1/2" LG. SHCS



BIGCUT TROLLEY ASSEMBLY



North Alabama Pipe

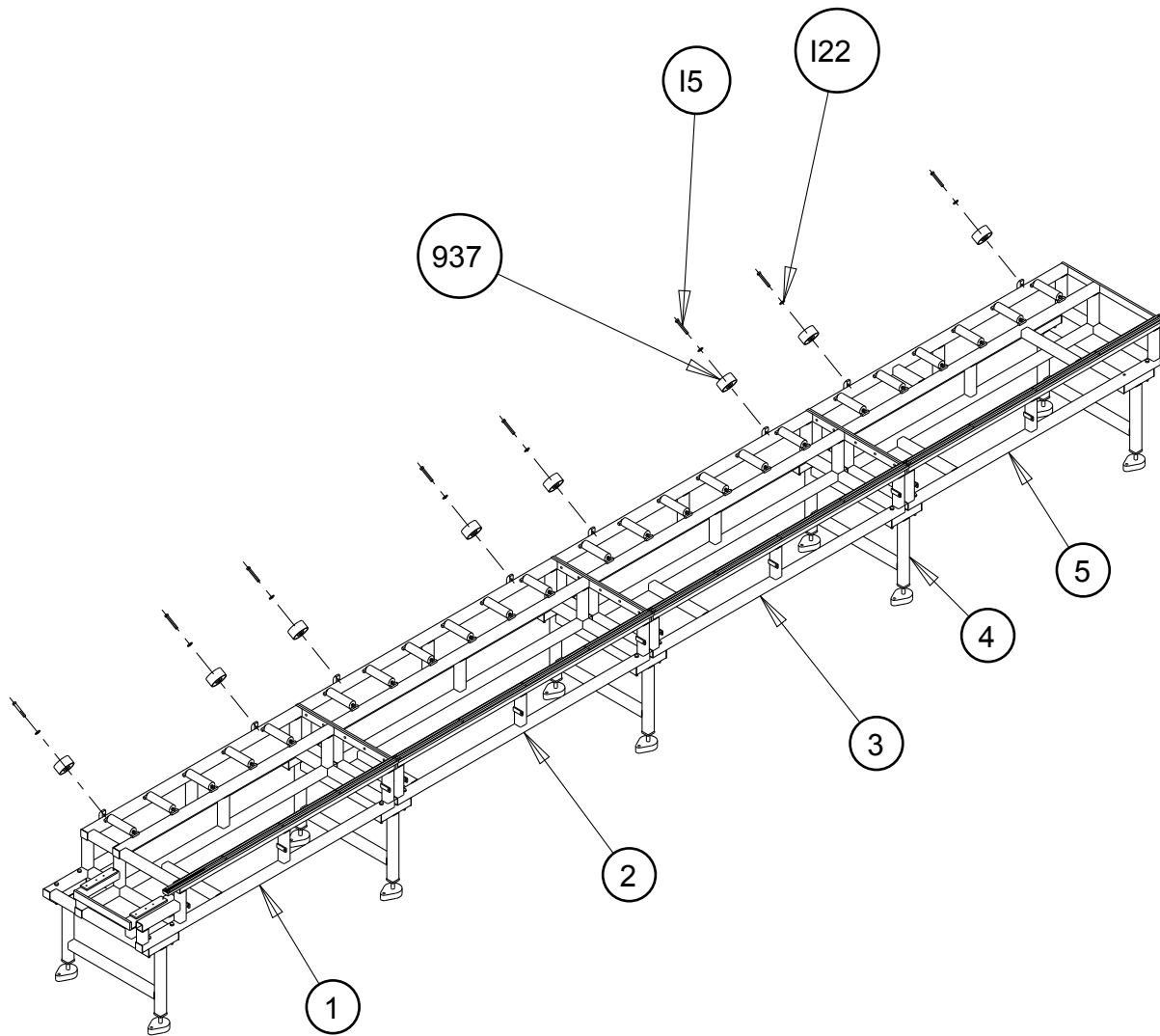
SHEET #9A Division of Anvil International

Innovators Of Pipe Fabrication Equipment

20-BAS-TROLLEY

BIGCUT TROLLEY ASSEMBLY PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	20-MSC-501	2	BALL DETENT
2	20-MSC-516	1	COMPRESSION SPRING
3	20-BRG-934	3	"V" WHEEL
4	20-QMP-4033	1	"V" WHEEL MOUNT BLOCK
5	20-QMP-4035	1	LOCK BLOCK
6	20-QMP-4515	2	PIVOT BLOCK
7	20-QMP-4517	1	LOCK THUMB SCREW
8	20-QMP-4518	1	KEEPER SCREW (MODIFY 1/4-20 S.H.C.S.)
9	20-QMP-4551	1	"V" WHEEL BOLT (MODIFY 3/8-16 H.H.C.S.)
10	20-BMP-6510	2	EXTENSION ROD ARM
11	20-BMP-6512	1	ARM PIVOT SHAFT
12	20-BMP-6513	1	TROLLEY PLATE
13	20-BMP-6514	1	TROLLEY END PLATE
14	20-FAS-E27	2	#10-24 X 1/4" LG. SHSS
15	20-FAS-F23	3	1/4-20 X 1/2" LG. SHCS
16	20-FAS-F26	4	1/4-20 X 1-1/4" LG. SHCS
17	20-FAS-H1	2	3/8-16 X 1" LG. HHCS
18	20-FAS-H5	1	∅ 3/8" X 3/4" LG. SHSB
19	20-FAS-I9	1	∅ 1/2" X 1-1/4" LG. SHSB
20	20-FAS-SHIM #3	1	.625 O.D. X .383 I.D. X .062 TH'K
21	20-FAS-SHIM #4	2	.625 O.D. X .383 I.D. X .125 TH'K



BIGCUT MAIN FRAME ASSEMBLY



North Alabama Pipe

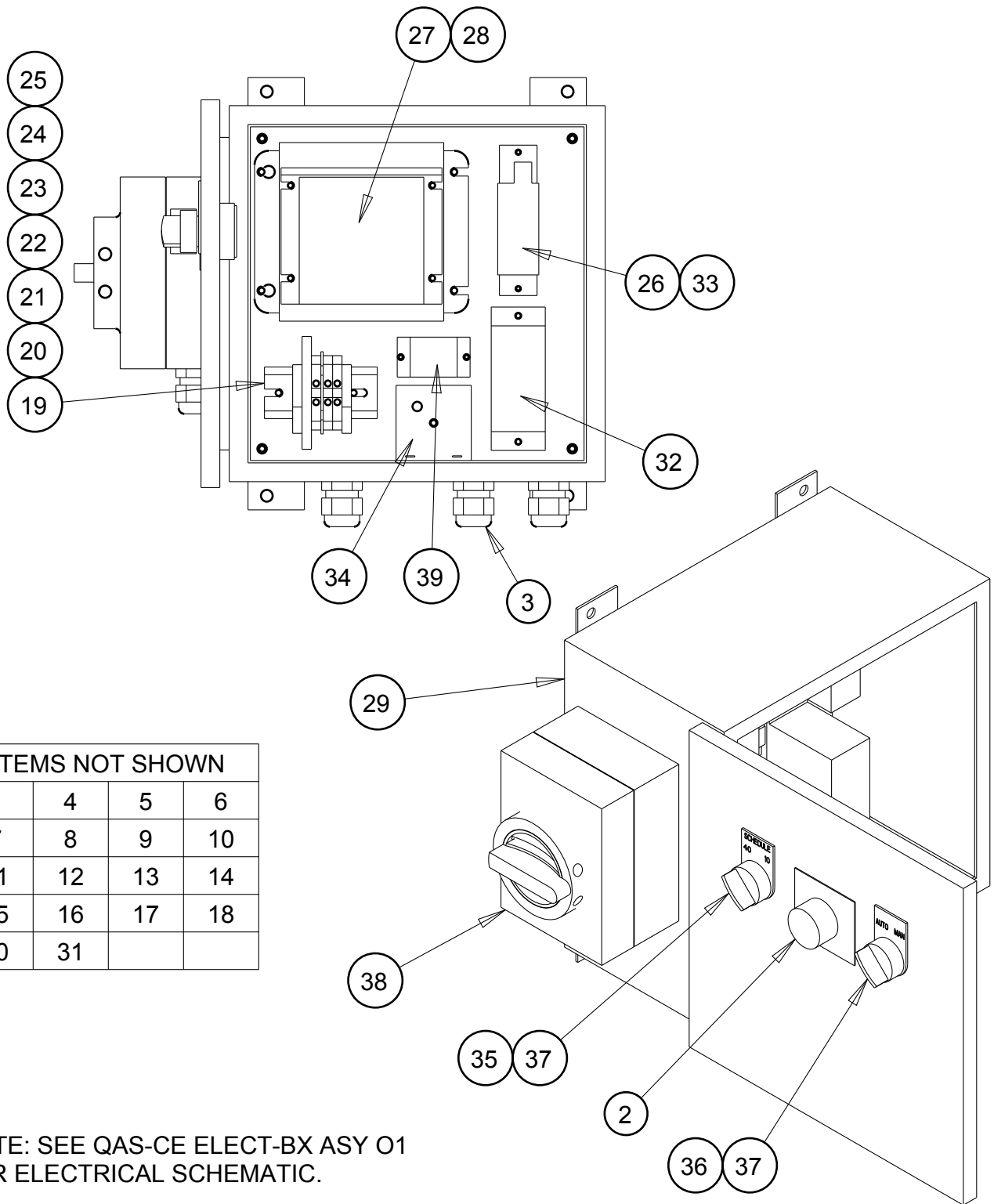
SHEET #10 A Division of Anvil International

Innovators Of Pipe Fabrication Equipment

20-BAS-MAIN FRAME

BIGCUT MAIN FRAME PARTS LIST


ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-BAS-MAIN FRAME 01	1	HEAD FRAME WELDMENT
2	20-BAS-MAIN FRAME 02	1	FRAME WELDMENT #1
3	20-BAS-MAIN FRAME 03	1	FRAME WELDMENT #2
4	20-BAS-MAIN FRAME 04	5	LEG WELDMENT
5	20-BAS-MAIN FRAME 05	1	END FRAME WELDMENT
	20-BRG-937	8	∅ 4" STEEL WHEEL
	20-FAS-I5	8	1/2-13 X 4" LG. HHCS
	20-FAS-I22	8	∅ 1/2" FLAT WASHER



ITEMS NOT SHOWN			
1	4	5	6
7	8	9	10
11	12	13	14
15	16	17	18
30	31		

NOTE: SEE QAS-CE ELECT-BX ASY 01 FOR ELECTRICAL SCHEMATIC.

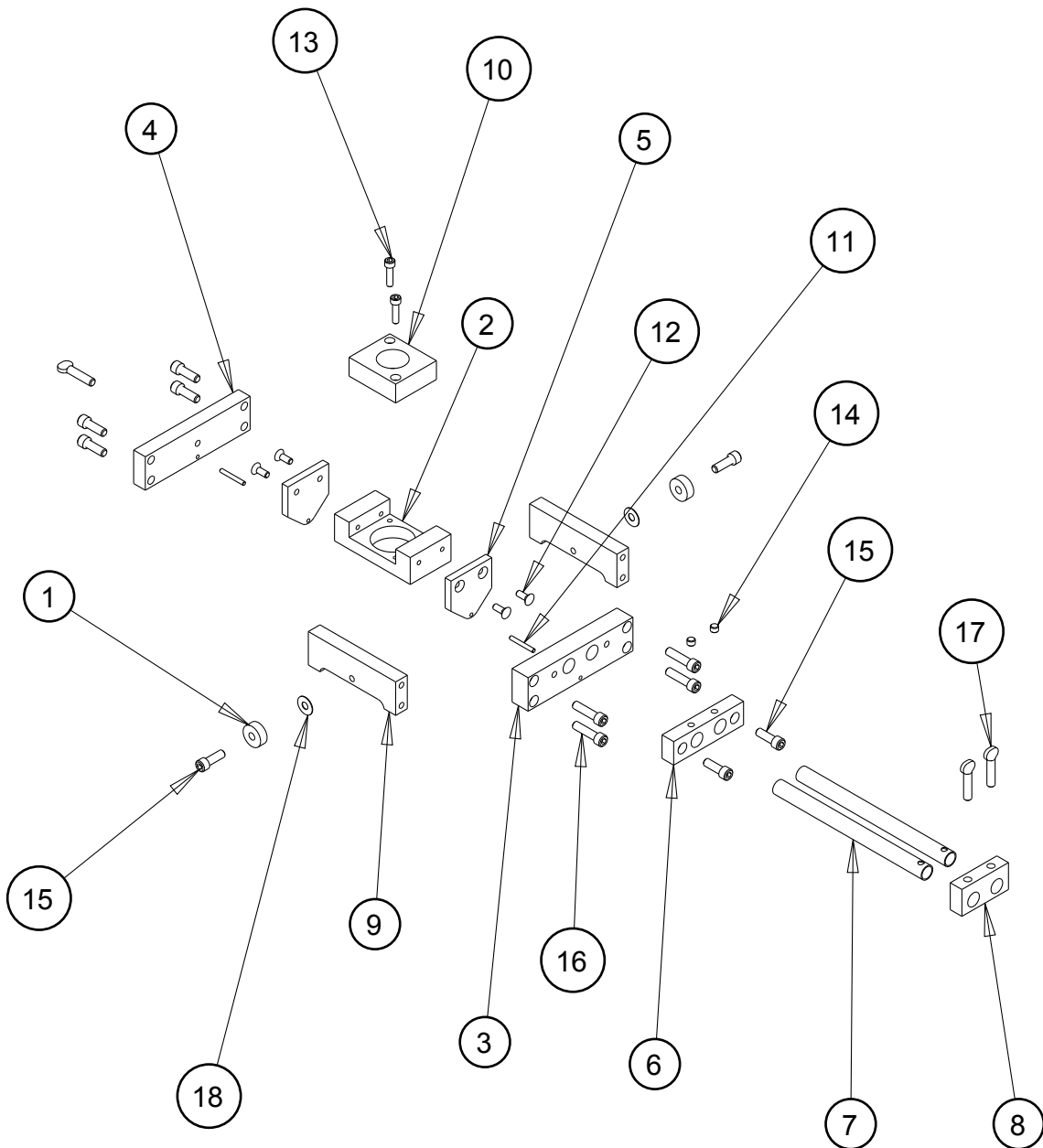
QUICK CUT ELECTRICAL BOX ASSEMBLY

 **North Alabama Pipe**
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QAS-CE ELECT BX AS

QUICK CUT ELECTRICAL BOX PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	EPP-0102	1	.1 OHM HP RESISTOR
2	EPP-0104	1	KNOB-DIAL KIT
3	EPP-0135	5	SMALL STRAIN RELIEF
4	EPP-0153	12	3-3/4 CABLE TIE
5	EPP-0156	1	TIE WRAP MOUNT .75
6	EPP-0157	2	1/8 HEAT SHRINK
7	SWT-0239	3	TIE WRAP MOUNT 1"
8	EPP-0262	1	DIODE 568-0273
9	EPP-0321	10"	1/4" HELI-TUBE
10	FAS-C06	4	#6-32 X 1/2" LG. RSLMS
11	FAS-D03	2	#8-32 X 3/8" LG. RSLMS
12	FAS-D09	4	#8-32 X 1/2" LG. SHCS
13	FAS-D15	4	#8-32 NUT
14	FAS-D16	6	#8 FLAT WASHER
15	FAS-E05	1	#10-24 X 1" BHSCS
16	FAS-E10	6	#10-24 X 1/4" LG. SHCS
17	FAS-F23	4	1/4-20 X 1/2" LG. SHCS
18	FAS-F38	4	1/4" FLAT WASHER
19	PLC-209	2	WEI END SECTION
20	PLC-210	1	DIN RAIL 3" LG.
21	PLC-216	1	3 AMPERES FUSE
22	PLC-230	2	TERMINAL BLOCK
23	PLC-231	1	TERMINAL BLOCK END CAP
24	PLC-236	1	250 VAC FUSE TERM BLOCK
25	PLC-255	1	GROUND TERMINAL BLOCK
26	PLC-267	1	POWER SUPPLY
27	PLC-272	1	KB DRIVE
28	PLC-273	1	KB CE FILTER
29	PLC-274	1	ENCLOSURE
30	PLC-275	1	TURNLOCK FEMALE CONNECTOR
31	PLC-276	1	TURNLOCK MALE CONNECTOR
32	PLC-277	1	CURRENT SWITCH
33	QMP-4580	1	POWER SUPPLY MOUNT PLATE
34	SWT-0014	1	TIMER DELAY RELAY
35	SWT-0015	1	SCH 40/10 SWITCH LABLE
36	SWT-0017	1	AUTO/MANUAL SWITCH LABLE
37	SWT-0027	2	2 POSITION SWITCH
38	SWT-0061	1	ENCLOSED DISCONNECT SWITCH
39	SWT-0064	1	RELAY: 24VDC



BIGCUT TORCH GUIDE ASSEMBLY



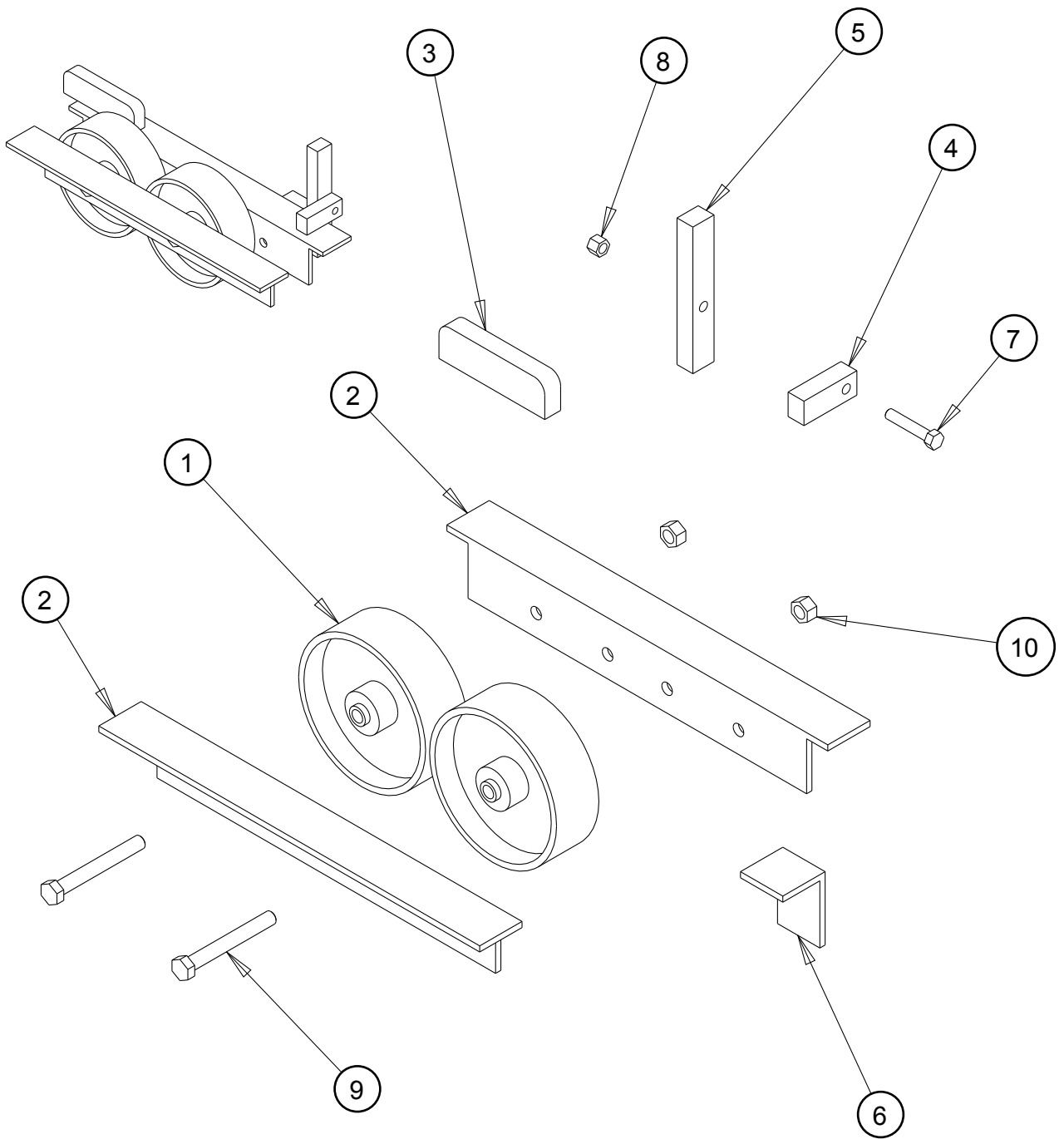
North Alabama Pipe

SHEET #12A Division of Anvil International
 Innovators Of Pipe Fabrication Equipment

20-BAS-TORCH GUIDE

BIGCUT TORCH GUIDE PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-BRG-903	2	QC TROLLEY BEARING
2	20-BMP-6503	1	TORCH HOLDER MOUNT
3	20-BMP-6504	1	ADAPTER PLATE
4	20-BMP-6505	1	END PLATE
5	20-BMP-6506	2	PIVOT PLATE
6	20-BMP-6507	1	SLIDE ROD MOUNT PLATE
7	20-BMP-6508	2	SLIDE ROD
8	20-BMP-6509	1	SLIDE ROD PLATE
9	20-BMP-6515	2	ROLLER PLATE
10	20-BMP-6526	1	TORCH HOLDER BLOCK
11	20-FAS-RPIN #2	2	∅ 1/8" X 1" LG. ROLL PIN
12	20-FAS-E6	4	#10-24 X 1/2" LG. FHSCS
13	20-FAS-E18	2	#10-24 X 3/4" LG. SHCS
14	20-FAS-F15	2	1/4-20 X 3/16" LG. SHSS
15	20-FAS-F24	8	1/4-20 X 3/4" LG. SHCS
16	20-FAS-F25	4	1/4-20 X 1" LG. SHCS
17	20-FAS-F30	3	1/4-20 X 1" LG. THUMB SCREW
18	20-FAS-SHIM #1	2	1/4" ID X .020 THICK SHIM



BIGCUT ROLLER ASSEMBLY



North Alabama Pipe

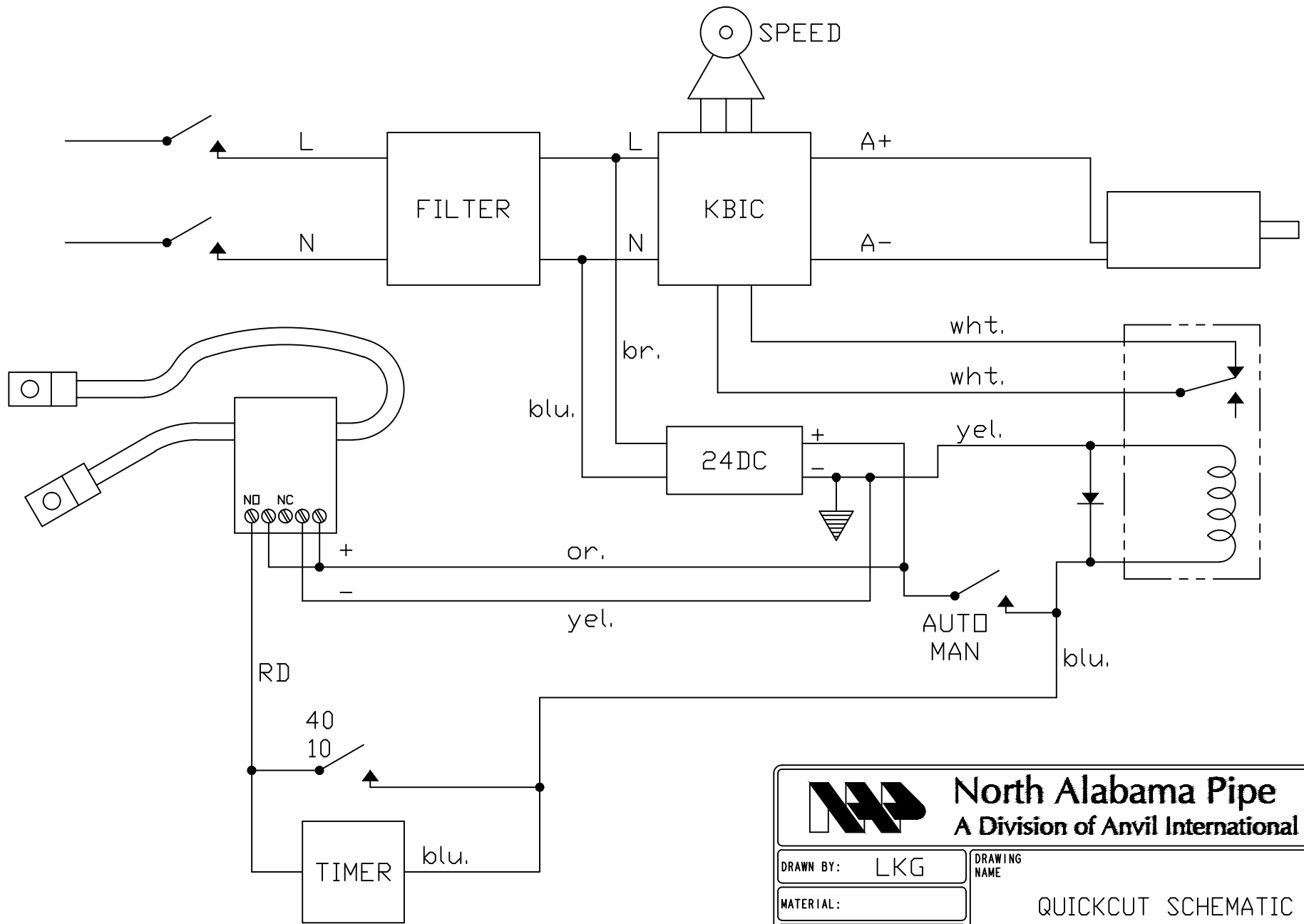
SHEET #13A Division of Anvil International

Innovators Of Pipe Fabrication Equipment

20-BAS-ROLLER ASSY

BIGCUT ROLLER ASSEMBLY PARTS LIST

ITEM	PART No.	QTY	DESCRIPTION
1	20-BRG-938	2	∅ 6" STEEL WHEEL
2	20-BMP-6006	2	WHEEL MOUNT
3	20-BMP-6501	1	PIPE TRANSFER
4	20-BMP-6540	1	PIPE STOP BLOCK
5	20-BMP-6541	1	PIPE STOP ARM
6	20-BMP-6546	1	STOP ANGLE 2" X 3" X 1/4" X 2" LG. ANGLE
7	20-FAS-H13	1	3/8-16 X 2" LG. H.H.C.S.
8	20-FAS-H18	1	3/8-16 NYLOCK NUT
9	20-FAS-I5	2	1/2-13 X 4" LG. H.H.C.S.
10	20-FAS-I13	2	1/2-13 NYLOCK NUT



North Alabama Pipe
A Division of Anvil International

DRAWN BY: LKG	DRAWING NAME: QUICKCUT SCHEMATIC
MATERIAL:	
SCALE:	
DATE: 2/4/14	DRAWING NUMBER: QAS-CE ELECT BX ASY 01
REVISION: "A"	CHECKED BY:
	SHEET OF

DO NOT SCALE DRAWING
TOLERANCE UNLESS
OTHERWISE SPECIFIED

FRACTIONS	± 1/64
2 PL DEC.	± .010
3 PL DEC.	± .002
ANGLES	± 1/2°

A	2/4/14	LKG	CHANGED PER NEW DESIGN
REV.	DATE	BY	CHANGE