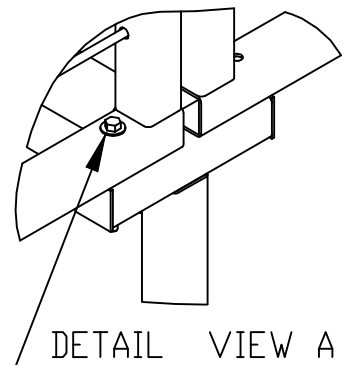
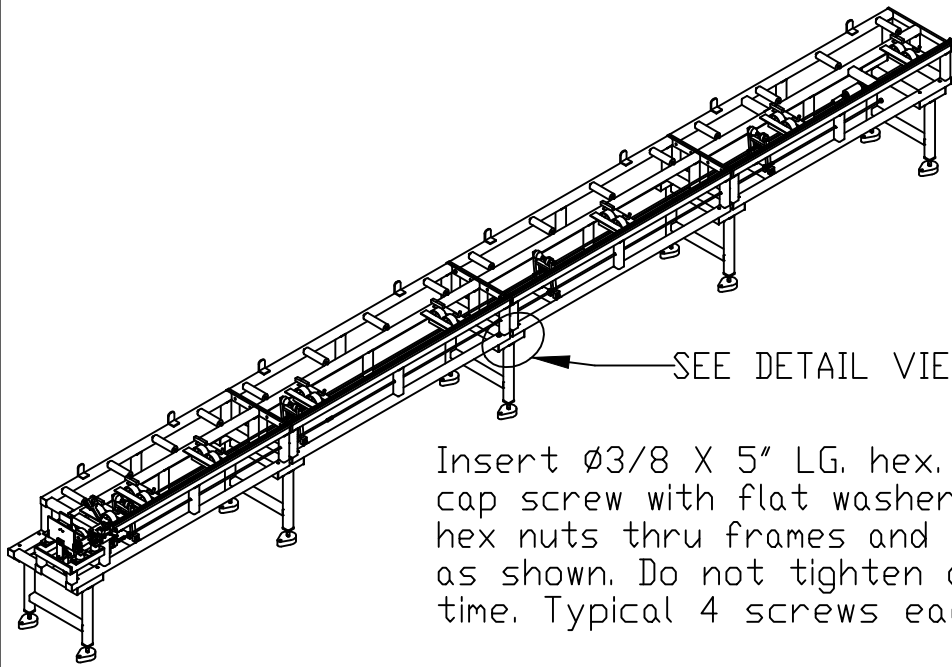


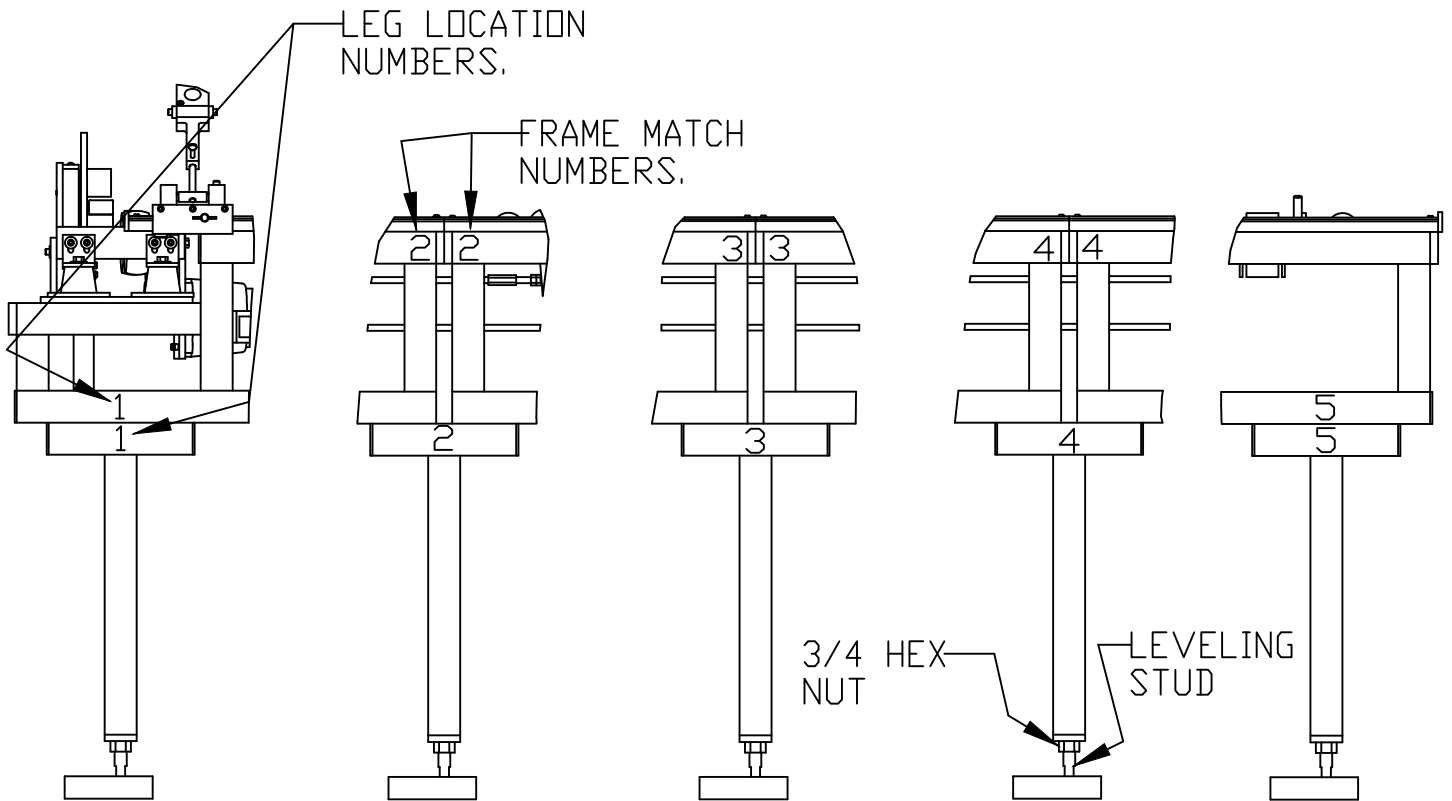
ASSEMBLY INSTRUCTIONS FOR THE QUICKCUT

QUICKCUT 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
2	ø1/4" AIR LINE X 25 FT. LG.	
4	AIR VALVE RODS	
3	LIFT RODS	
5	QUICKCUT LEGS	
4	QUICKCUT SECTIONS	
1	QUICKCUT 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.



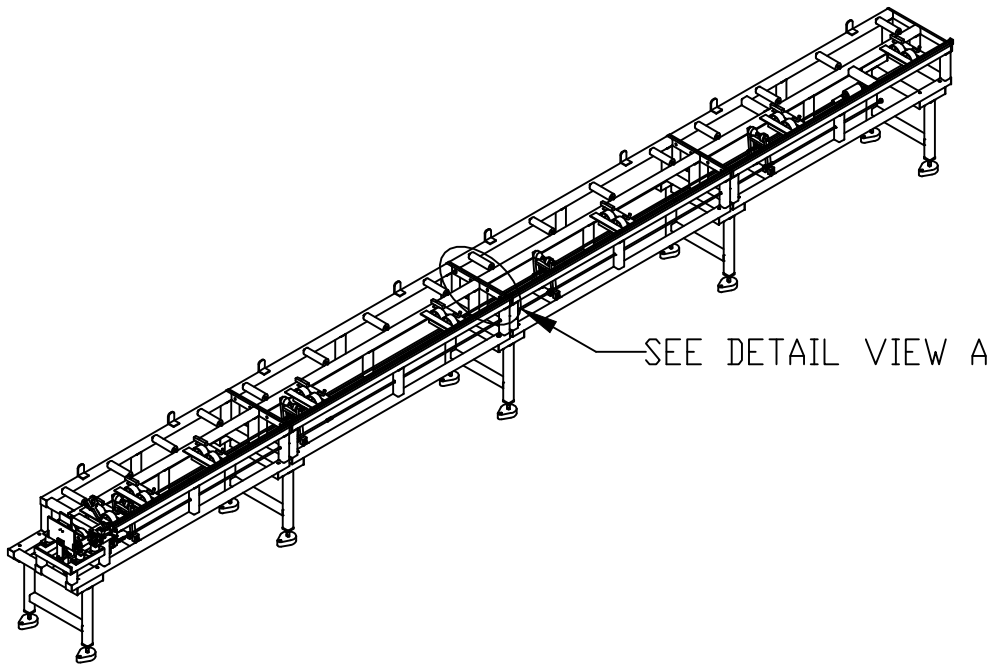
ASSEMBLY INSTRUCTIONS:

Remove legs from shipping pallet. Arrange on floor in area designated for Quickcut (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.

QUICKCUT ASSEMBLY INSTRUCTIONS

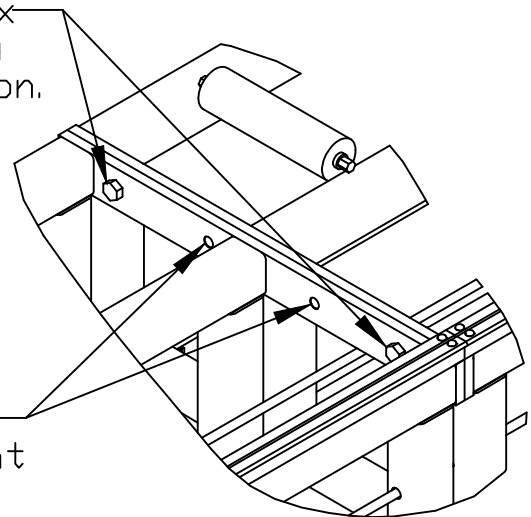


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SEE DETAIL VIEW A

Assemble $\varnothing 1/2 \times 1-1/2$ " LG. hhcs with hex nut and lock washer (nut side only) thru outer 2 holes in each frame joint section. Typical 2 bolts 3 places. Tighten after inserting $\varnothing 1/2$ " dowel pins.



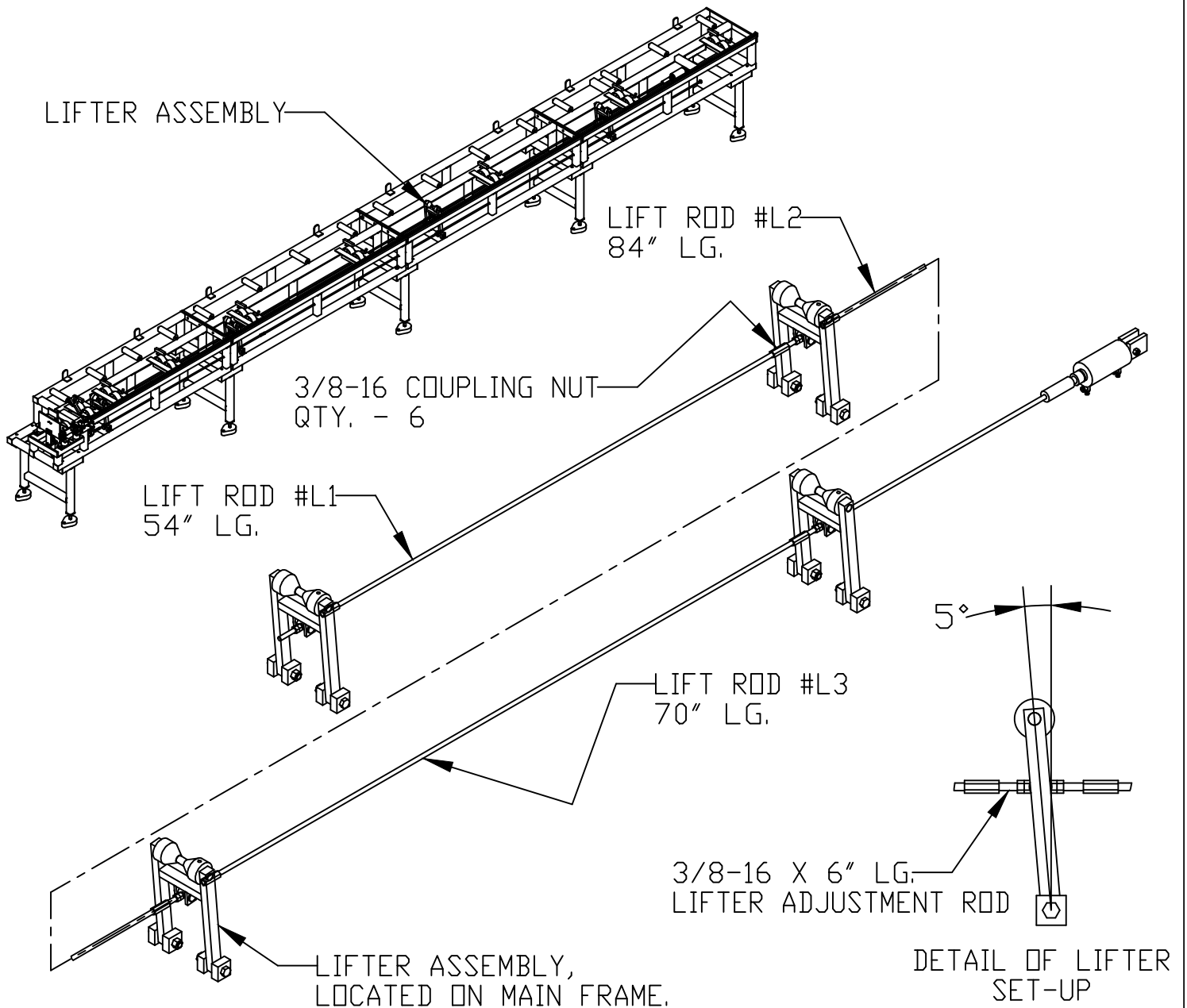
Assemble $\varnothing 1/2 \times 1$ " lg. dowel pins in inner 2 holes in each frame joint section. Typical 2 pins 3 places.

DETAIL VIEW A

Note: tighten the leg screws ($\varnothing 3/8 \times 5$ " lg. hex. hd. cap screws) after completing the above.

 QUICKCUT ASSEMBLY INSTRUCTIONS
North Alabama Pipe Corporation

SHEET #4



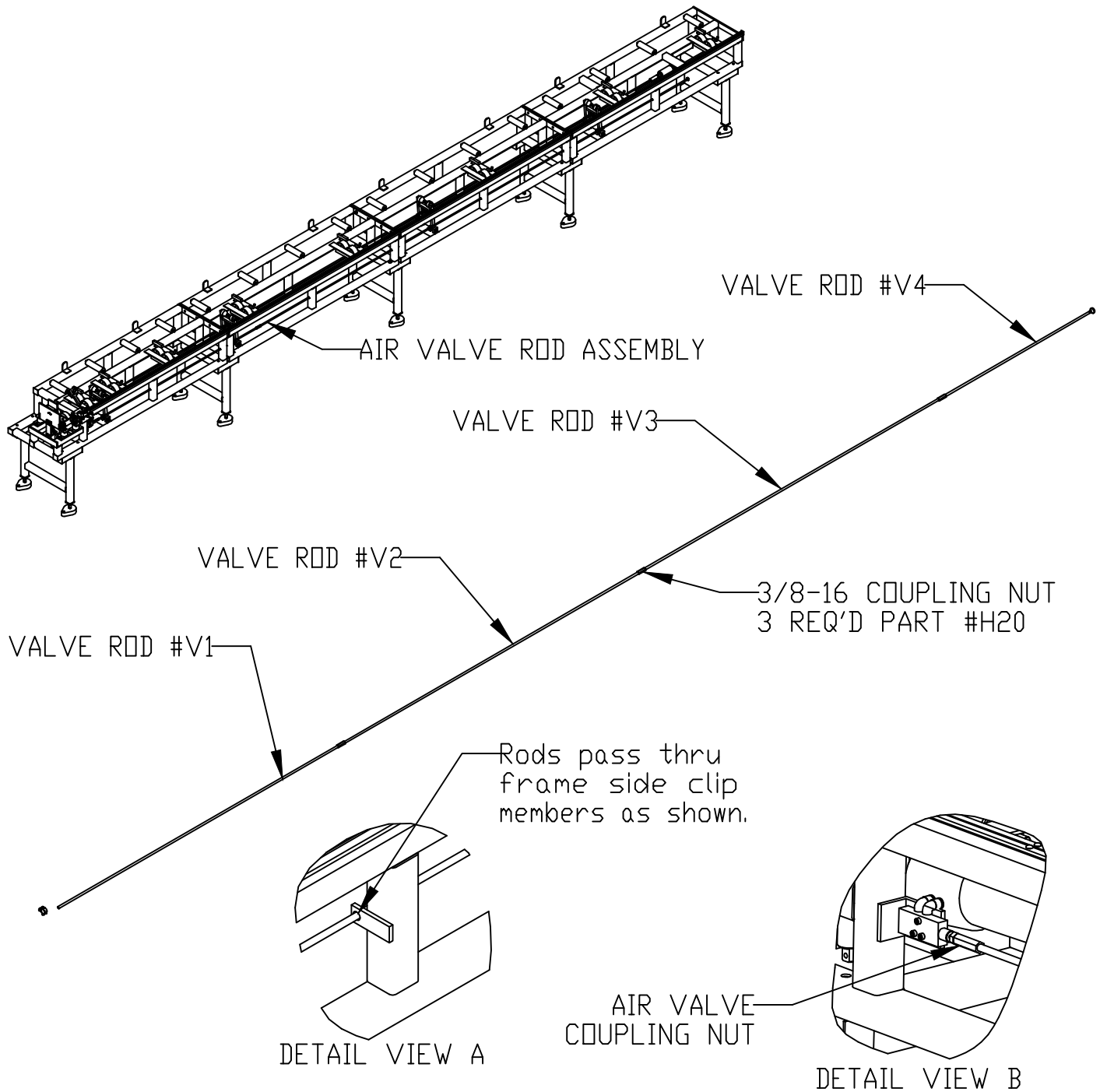
LIFT ROD ASSEMBLY INSTRUCTIONS:

Remove packing tap 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 rod 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.

QUICKCUT ASSEMBLY INSTRUCTIONS



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AIR VALVE ROD ASSEMBLY INSTRUCTIONS:

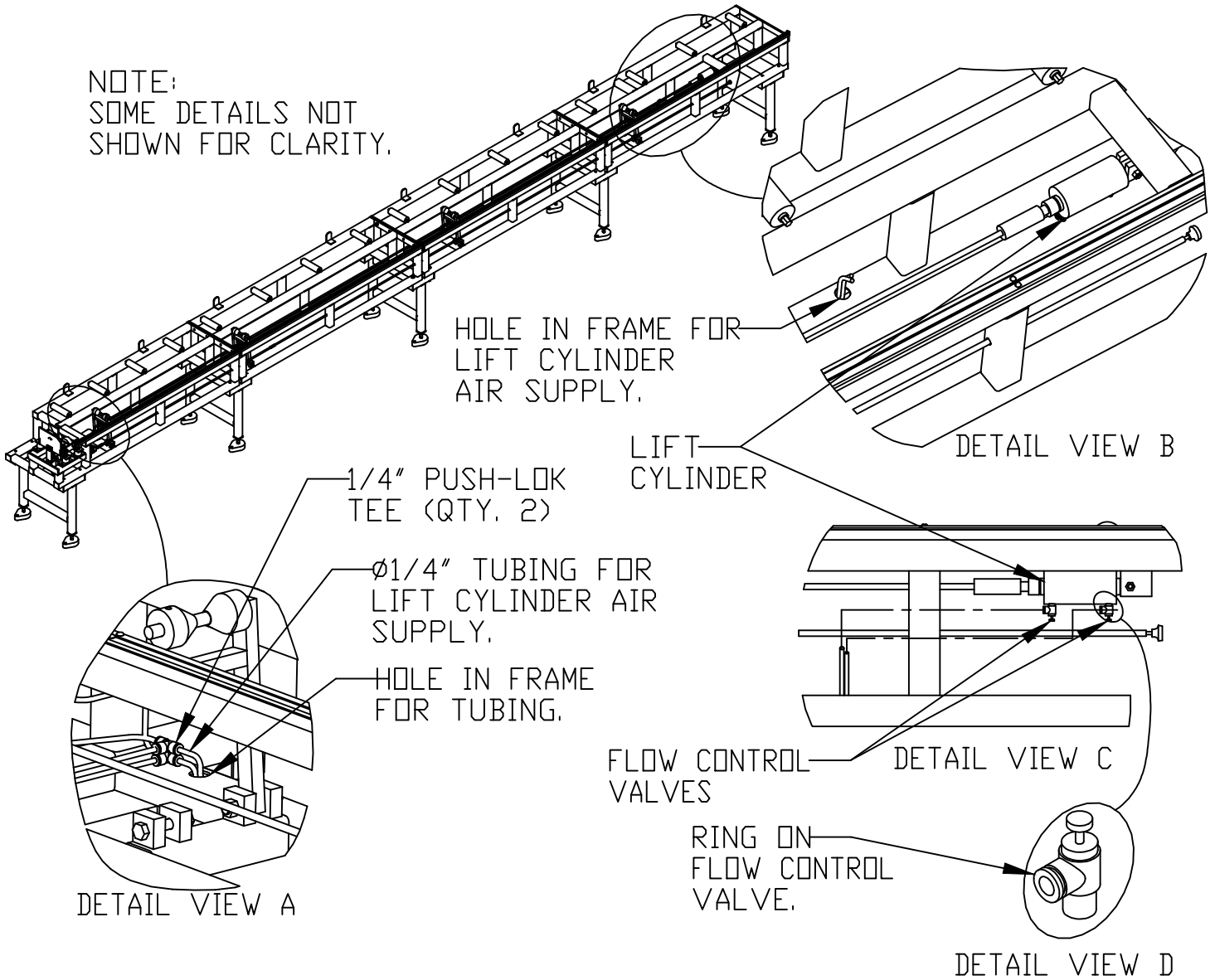
Remove packing tap from rod bundle. Rods should be tagged V1 thru V4. Pass Air Valve rod V1 thru frame side clips as shown in Detail View A. Attach rod to nut on Air Valve, see Detail View B. Locate 3/8-16 coupling nuts (shipped in box with all fasteners). Thread coupling nut to the end of Air Valve rod V1, assemble Air valve rod V2 to the end of rod V1. Assemble remaining rods in order.

QUICKCUT ASSEMBLY INSTRUCTIONS



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NOTE:
SOME DETAILS NOT
SHOWN FOR CLARITY.



AIR TUBING TO LIFT CYLINDER ASSEMBLY INSTRUCTIONS:

Remove air tubing from box, tubing is $\text{Ø}1/4"$ x 25 ft. lg., (2 pieces)
 Thread tubing thru hole in frame as shown in Detail View A, and pull thru at othe 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, then 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 in on the air line and pushing on the 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.

QUICKCUT ASSEMBLY INSTRUCTIONS



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COMPRESSION SPRING

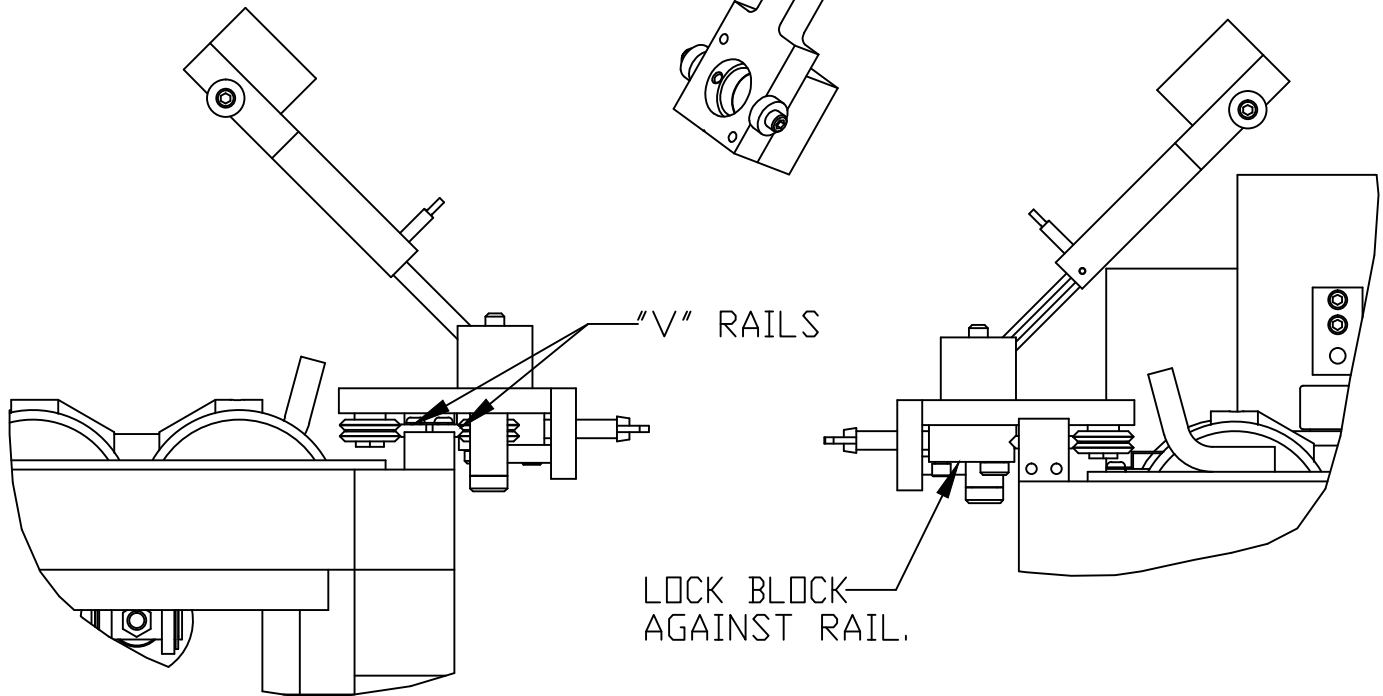
"V" WHEEL
PIVOT MOUNT

TROLLEY LOCK
THUMB SCREW

"V" WHEELS

TROLLEY LOCK
BLOCK

NOTE:
SOME DETAILS NOT
SHOWN FOR CLARITY.



QUICKCUT TROLLEY ASSEMBLY INSTRUCTIONS:

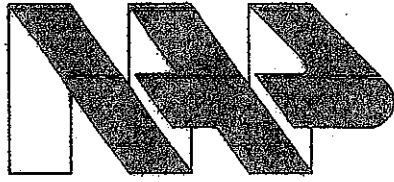
Remove quickcut trolley from box. Loosen Trolley Lock thumb screw, compress spring by pushing "V" Wheel Pivot Mount. Align "V" Wheels with the "V" Rails located on the Main Frame. Release Pivot Mount. Roll the Trolley Assembly back and forth on the rails to make sure "V" Wheels are aligned to the Rails, 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.

QUICKCUT ASSEMBLY INSTRUCTIONS



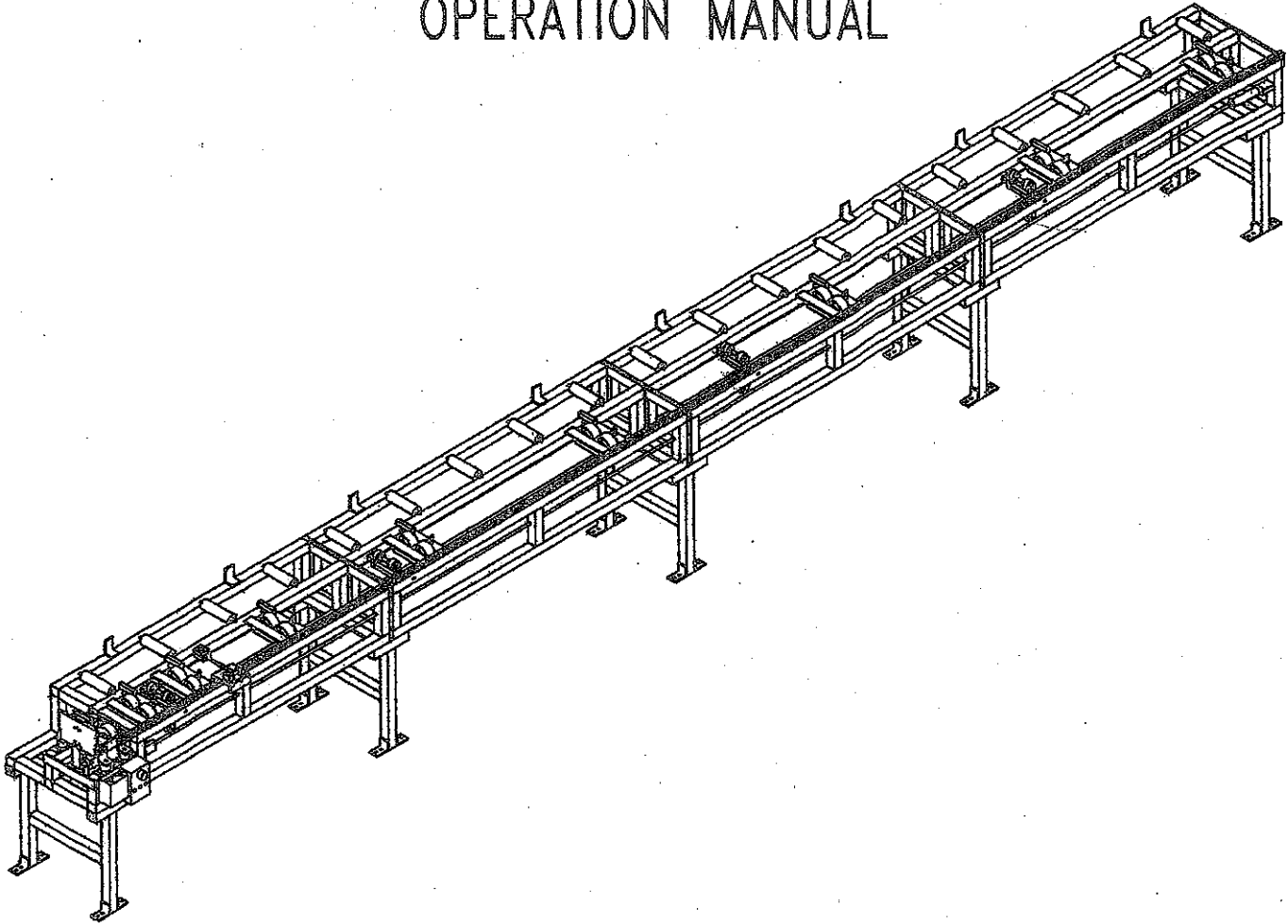
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SHEET #8



THE QUICKCUT

OPERATION MANUAL



North Alabama Pipe Corporation

"Innovators of Pipe Fabrication Equipment"

5010 Swords Street, P.O. Box 750 Guntersville, Al. 35976

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OPERATION

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DRAWINGS & PARTS LIST

PRODUCTS BY N.A.P.

GENERAL INFORMATION

DESCRIPTION

The Quickcut from N.A.P. is a revolutionary new pipe cut off machine that utilizes plasma technology in the process of pipe cutting. Pipe sizes from 1-1/4" to 3" with light to schedule 40 wall thickness can easily be cut to length within seconds. It requires little effort and produces a flawless result. The standard lifting system will allow for easy pipe movement forward and backwards by the operator. The Index Chuck, by N.A.P. is an accessory that adds to the convenience of the Quickcut if it is to be used as a work station for hole cutting or welding. The Index Chuck allows for pipe rotation in 90 degree increments.

DIMENSION

The following dimensions are standard for all Quickcut units. (MAJOR DIMENSIONS ONLY)

OVERALL LENGTH FROM END TO END.....26'-0"
OVERALL WIDTH FROM SIDE TO SIDE.....22-1/2"
OVERALL HEIGHT FROM FLOOR TO PIPE REST.....37-1/4"
OVERALL WEIGHT.....aprox: 1200 lbs.

INSTALLATION

ASSEMBLY

1. Remove the legs from the pallet and set them off to one side.
2. Remove the box of screws and bolts, taking out the twenty 3/8-16 jacking screws.
3. Insert the 3/8-16 jacking screws into the feet of the legs.
4. Mark the area on which the Quickcut will sit. (see fig. #1)
5. Layout the Quickcuts' sections in order on the floor near the marked area. (see fig. #1)
6. Place legs #1 and #2 on the marked area, at the head section end. (see fig. #1)
7. Lift the head section up onto legs #1 and #2.
8. Drop the 3/8-16x5 bolts through the bottom rail of the frame into the legs. Loosely fasten the nuts on.
9. Place leg #3 in position.
10. Lift section #2 up onto the legs. Push this section into the head section until the dowel pins fit. (may be slightly difficult to fit).
11. Place the 1/2" bolts through the holes beside the dowel pins. Loosely fasten the nuts on.
12. Continue steps 9-11 until all sections are in place.
13. Tighten all the 3/8-16x5 bolts that connect the frame and the legs. Also tighten all the 1/2" bolts that fasten section to section.
14. Level the machine by tightening and loosening the 3/8-16 jacking screws in the feet. (Make sure the Quickcut is level along the the front and along the top.)
15. Install the 3/8" actuator and lifter rods. (see fig. #2)
16. Install the trolley. (see fig. #3)
17. Connect the plug cord to a 110 outlet.
18. Connect the air.
19. Connect the ground cord of the plasma unit. (see fig. #4)

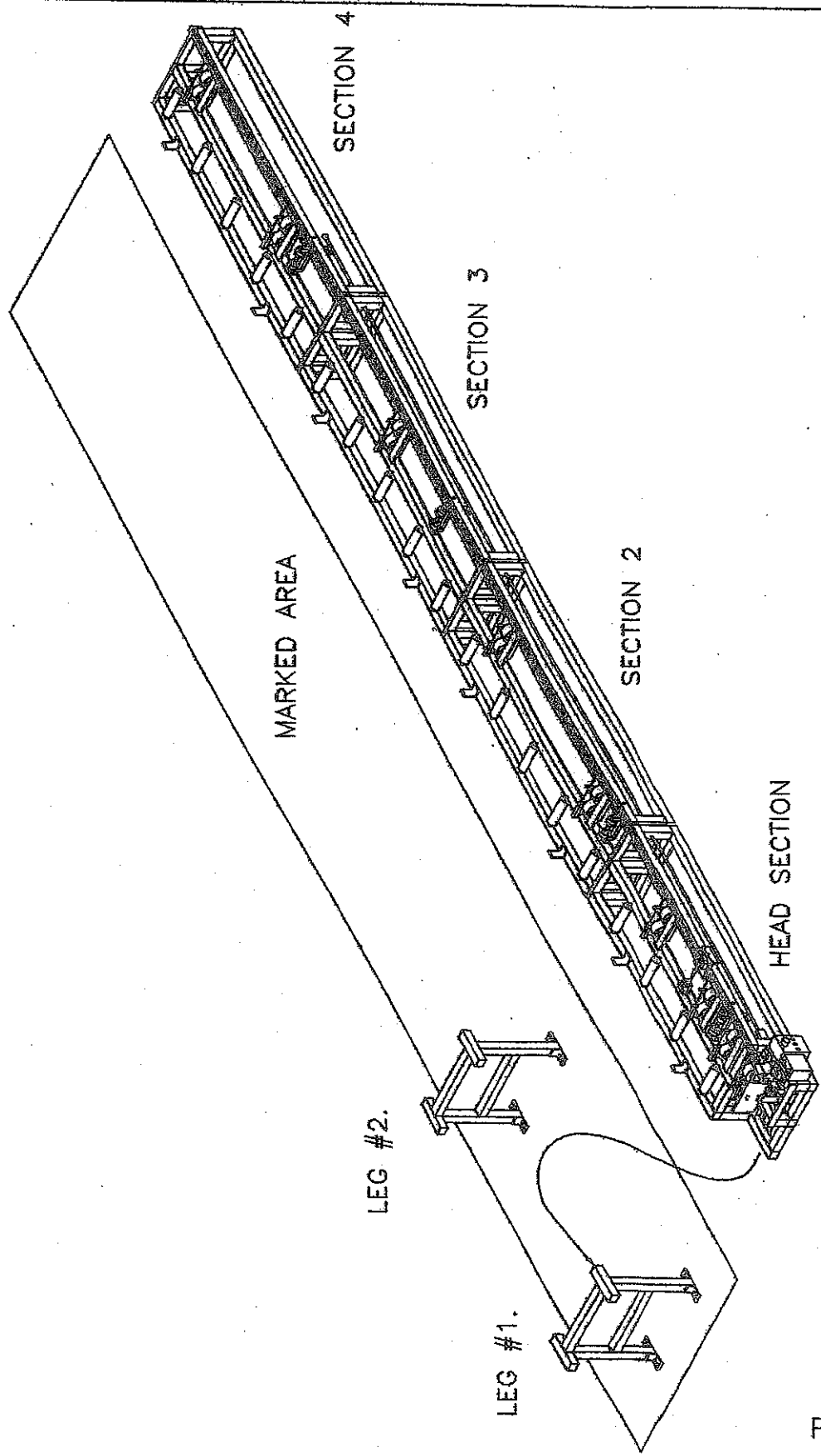


FIGURE # 1.

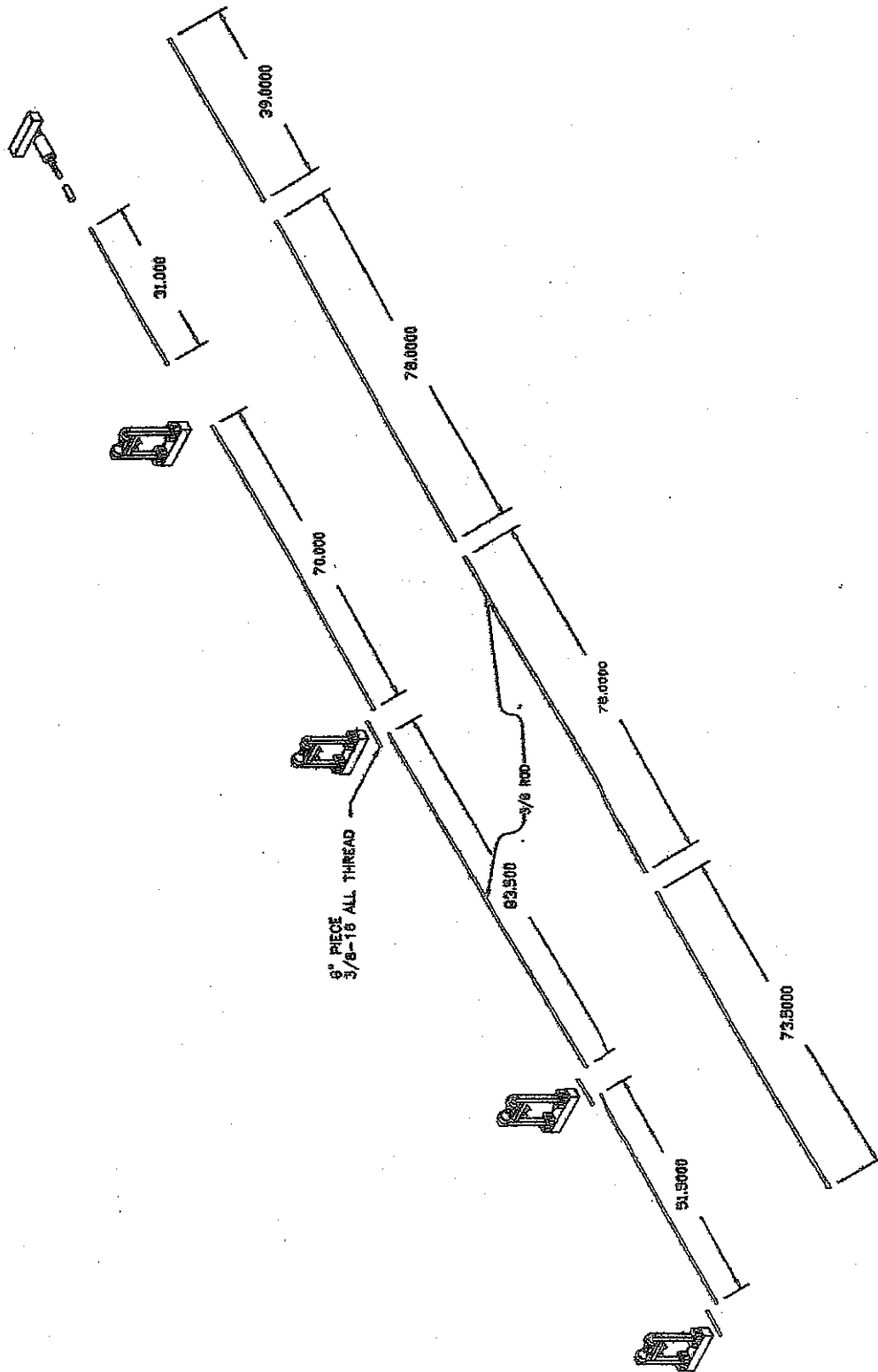


FIGURE #2

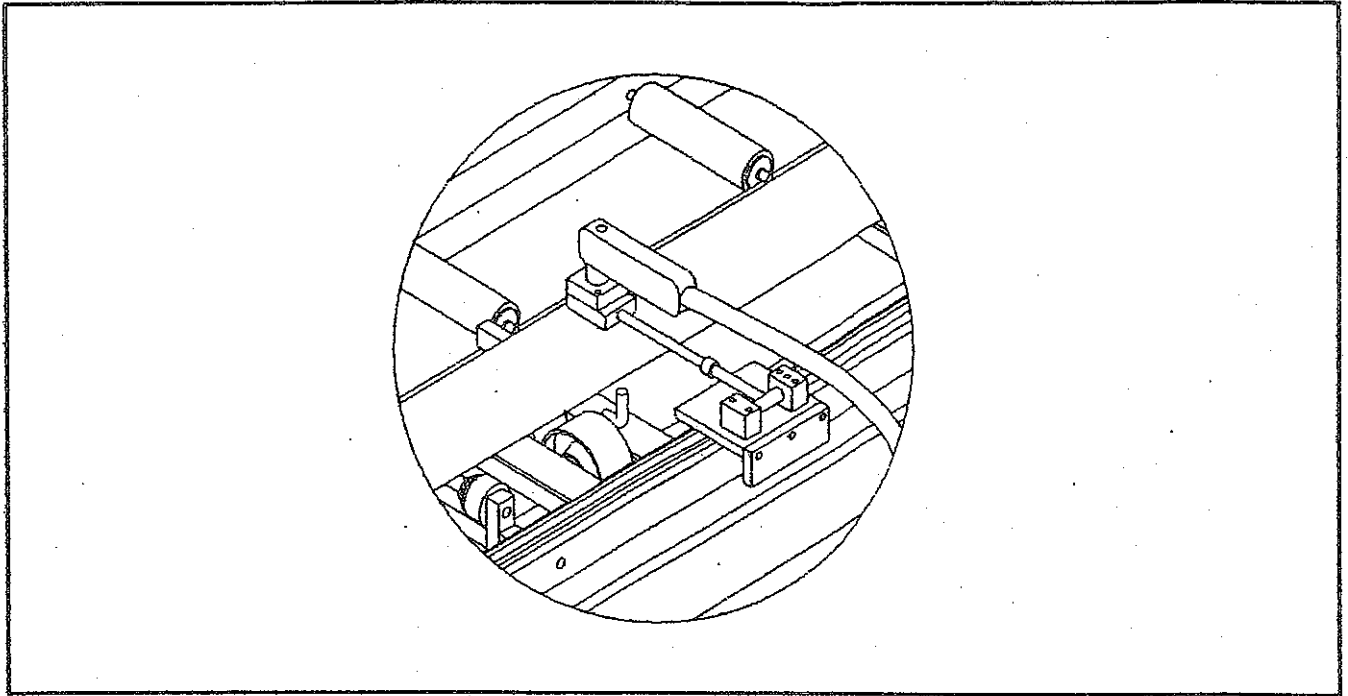


FIGURE # 3

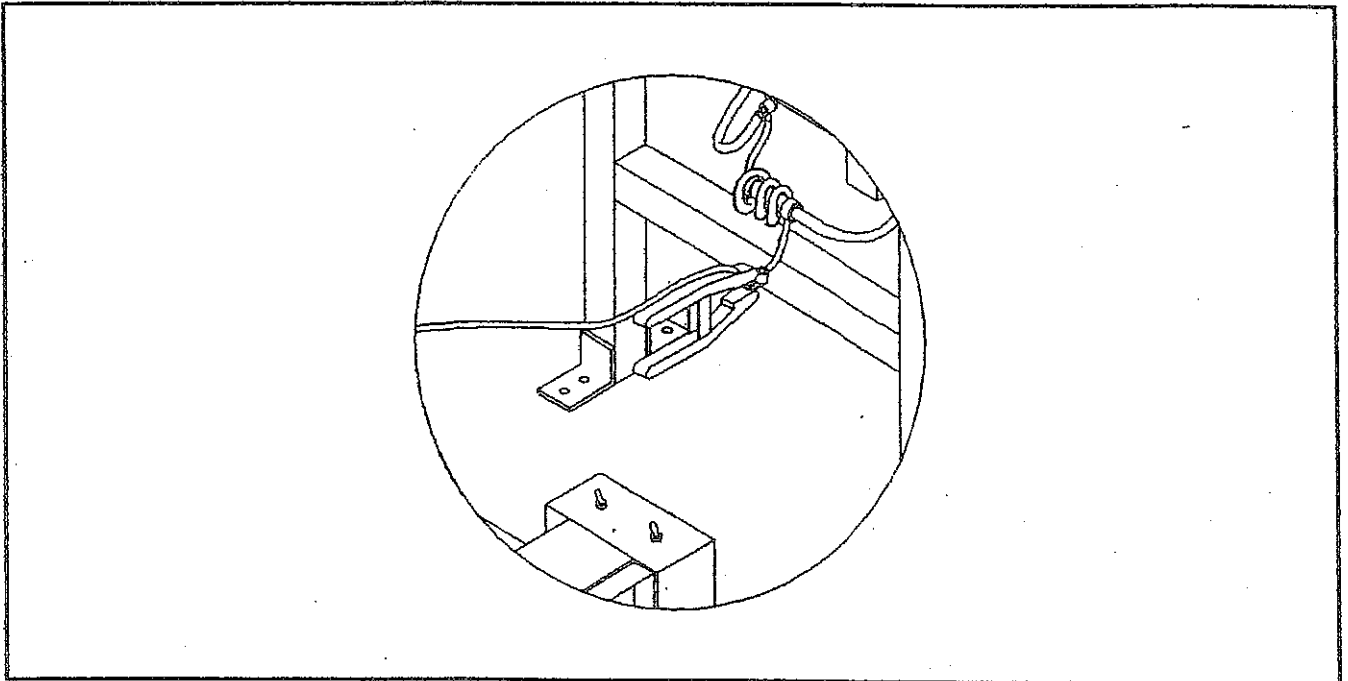
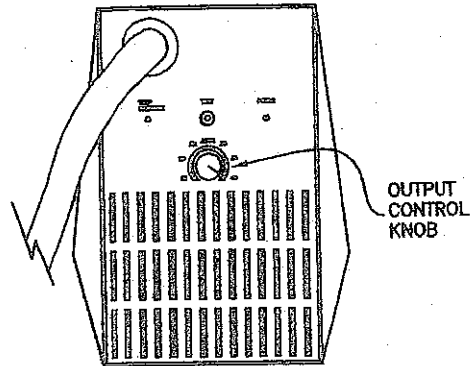


FIGURE #4

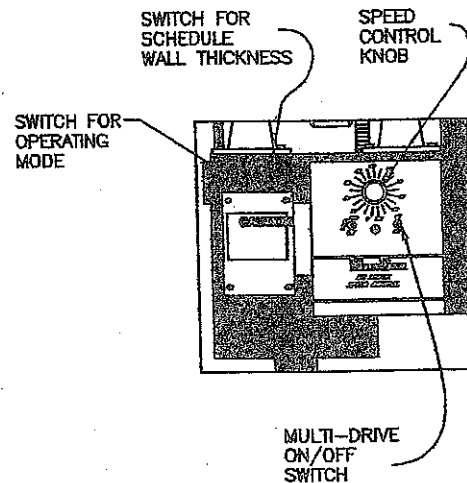
OPERATION

PROCEDURES

1. Turn the MAX 600 plasma unit on.
2. Using the output control knob, select 40 AMPS.

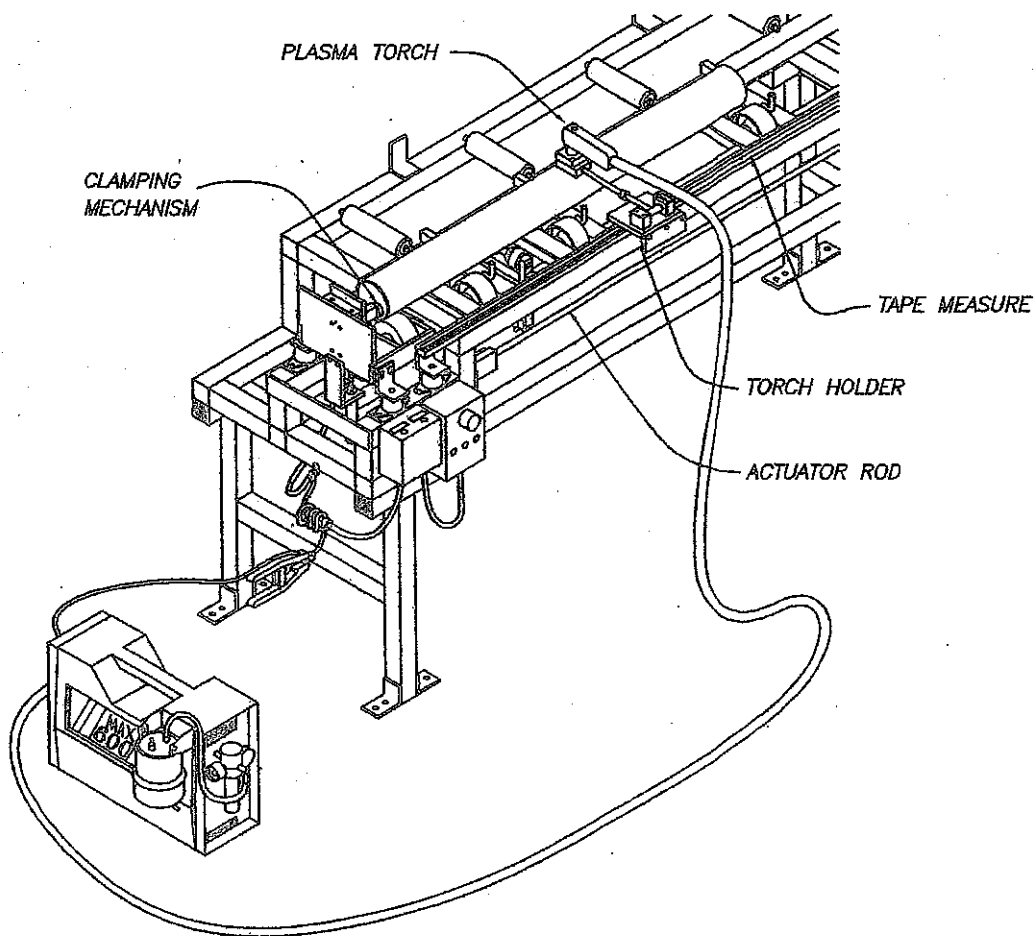


3. Move the first switch on the small grey electrical box marked "caution" from off to the desired operating mode.
4. Move the second switch on the small grey electrical box marked "caution" to the desired wall schedule.
5. Switch the black DC box marked "Multi-Drive" to on.
6. Adjust the control knob on the black DC box marked "Multi-Drive" to the desired speed. (refer to "settings" on page 10.)



OPERATION

7. Take the selected pipe and slide it up flush with the clamping system.
8. Activate the clamping system by pulling the actuator rod away from the head section.
9. Position the torch holder in the desired location using the metal tape measure as a guide.
10. Using the wing nut and the thumb screw, tighten the torch holder in place so that there is no horizontal or vertical movement.
11. Insert the plasma torch.
12. Press the button on the back of the plasma torch.
13. Once the cut has been made and the plasma torch is disabled, pull the the actuator rod back toward the head section. This action will release the pipe for removal.



III. PIPE CLAMPING AND ROLLER LIFT OPERATION

The horizontal rod within the frame which runs the entire length of the machine, pneumatically operates the pipe clamping and roller-lift system simultaneously. When the rod is activated the lift rollers retract and the drive clamp bearing is actuated holding the pipe to the drive rollers. When the rod is operated again, the lift rollers rise and the drive clamp bearing releases the pipe.

The "pneumatic roller-lift system" on the "Quick-Cut" machine lifts the pipe clear of the cutting table. The free-wheeling rollers allow for easy insertion and removal of the pipe into the power head. This is especially important on long pieces of large diameter pipe. The roller lift system is raised when the power head clamp is released and lowered when the clamp is activated. In short, when raised, these rollers provide for easy longitudinal movement of the pipe prior to and just after the pipe is cut.

IV MAINTENANCE SCHEDULE

A. Weekly

1. Remove build-up of dust, oil and dirt from the machine.
2. Check red wheels to insure they remain slightly higher than the metal rotation wheels.
3. Check drive belt to insure there is no more than 1/8" play in its tension.

B. Every 6 - 8 Weeks

Grease the metal rotation wheels

C. Precautions

1. Do not allow plasma sparks near the red wheels as they will wear out prematurely.
2. Make sure you select proper speed and pipe schedule settings on the control box for the particular pipe you will be cutting.

V ADJUSTING THE RED WHEELS

- A. Unplug the machine.
- B. Insert a pipe section in the power head.
- C. Loosen the socket head screws in all four (4) of the item #4026. (See Quick-Cut Head Parts List Drawing)
- D. Pull the head upward until the red wheels fit snug against the pipe.
- E. Level the head section.
- F. Tighten the socket head screws in "C" above.

VI ADJUSTING THE DRIVE BELT

- A. Unplug the machine.
- B. Loosen the two 5/8" bolts and the two 5/16" bolts in item #34.
- C. Apply downward pressure on #34 until there is no more than 1/8" play in the belt.
- D. Tighten bolts in "A" above.
CAUTION: Do NOT over tighten 5/8" bolts.

VII REPLACING THE CLAMP BEARING OR GROUND BRUSH

- A. Remove 3/8" bolt from Item #4024 or 4102. (See Pipe Clamps Parts List Drawing)
- B. Remove #904 or 905 (bearing) and/or ground brush.
- C. Replace #904 or 905 (bearing) and/or ground brush.
CAUTION: A ground brush MUST remain behind the bearing.

VIII REPLACING THE DRIVE BELT, PULLEY OR RED WHEELS

- A. Unplug the machine.
- B. Remove the belt cover plate (4 screws)
- C. Remove the Multi-Drive cover plate and disconnect the motor lead (2 wires).
- D. Remove the air cylinder - one screw in front and two in the rear mount.
- E. Remove the mounting bolt in the top of each of the rubber supports.
- F. Remove power head from machine.
- G. Loosen belt adjustment bolts.
- H. Remove red wheel bolts.
- I. Replace belt and/or pulley and/or red wheels.
- J. Tighten belt adjustment bolts.
- K. Replace power head into machine.
- L. Replace mounting bolts on rubber support.
- M. Replace air cylinder.
- N. Reconnect motor leads to Multi-Drive.
- O. Replace the belt cover plate.

IX AUTOMATIC OPERATION SEQUENCES

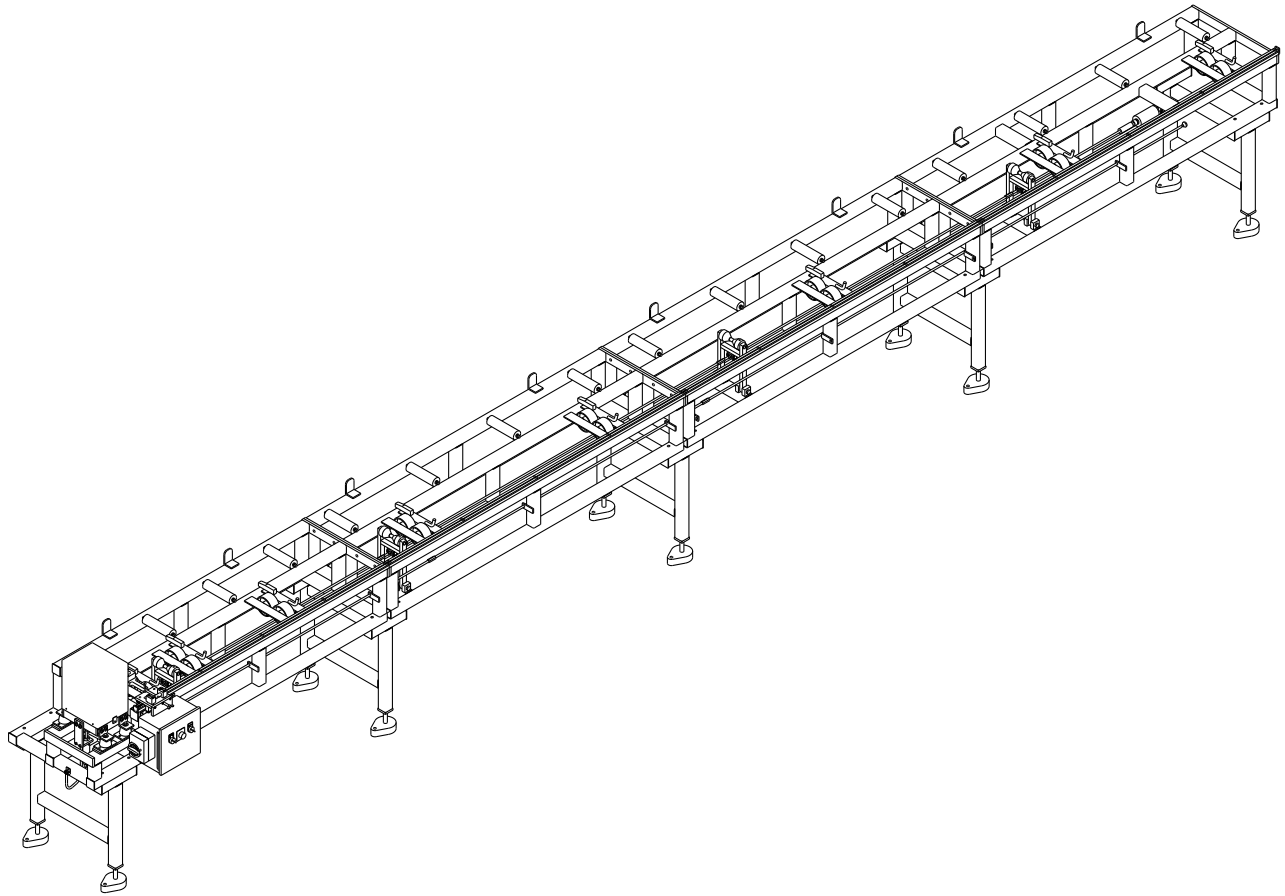
- 1. Turn the air plasma unit on.
- 2. Set the air plasma unit to 40 amps.
- 3. Test for 80 lbs. of air pressure to the air plasma unit.
- 4. Make sure the ground cable of the air plasma unit is clamped to the lug provided on the "Quick Cut" ground cable.
- 5. Make sure the "Auto-Start" sensor has the ground cord wrapped around it.

6. Move the mode selection toggle switch to "Automatic".
- 5-
7. Move the "Schedule 40-Schedule 10" toggle switch to the desired wall thickness.
 8. Switch the D.C. box marked "Multi-Drive" to on.
 9. Adjust the control knob on the "Multi-Drive" to the desired speed. (See recommended settings for each pipe size and wall thickness.)
 10. Place the pipe on the roller lifts and slide the pipe end against the end block in the power head. Activate the clamping system by pulling the horizontal rod in the frame which will engage the clamp and lower the lift-rollers simultaneously.
 11. Move the torch guide to the desired cut-off position as indicated by the built in tape measure and tighten its thumb screw to secure its position.
 12. Insert the plasma torch into the torch guide and activate the plasma unit for one full rotation of the pipe.
 13. Remove the plasma torch and operate the rod which disengages the clamp and raises the roller lifts.
 14. Remove the pipe and repeat the process of #10 - 13 until all the required pipe has been cut to the proper lengths.

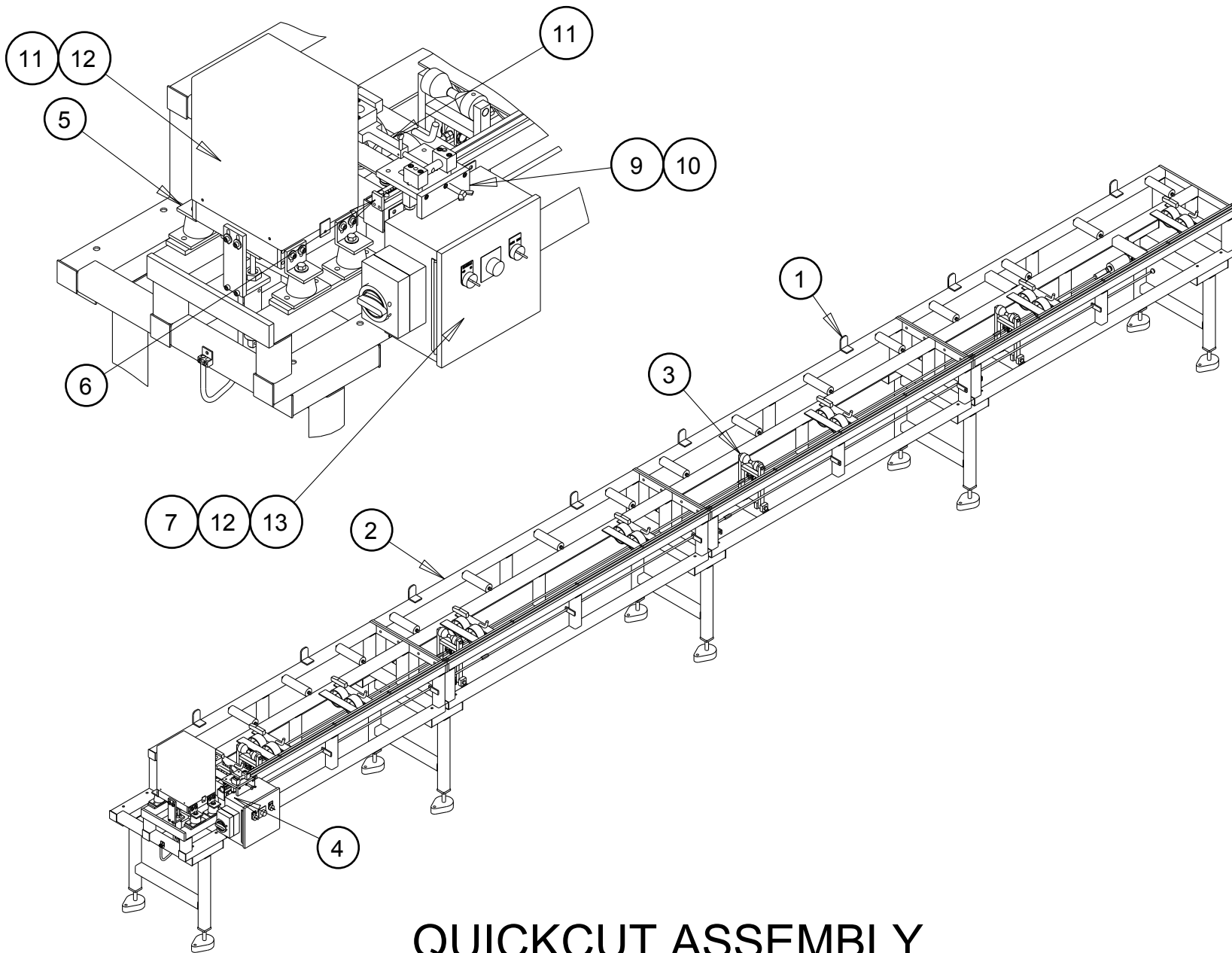
X RECOMMENDED REPLACEMENT PARTS

	Part #
Small Pipe Bearing (1-1/4-1-1/2" pipe)	6201
Large Pipe Bearing (2 - 8" pipe)	6203
Brushes (for clamp bearing)	BBR 1702
Drive Belt	480-8M-30
Torch Guide Roller Bearings	1602

QUICKCUT PARTS LIST



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QUICKCUT ASSEMBLY

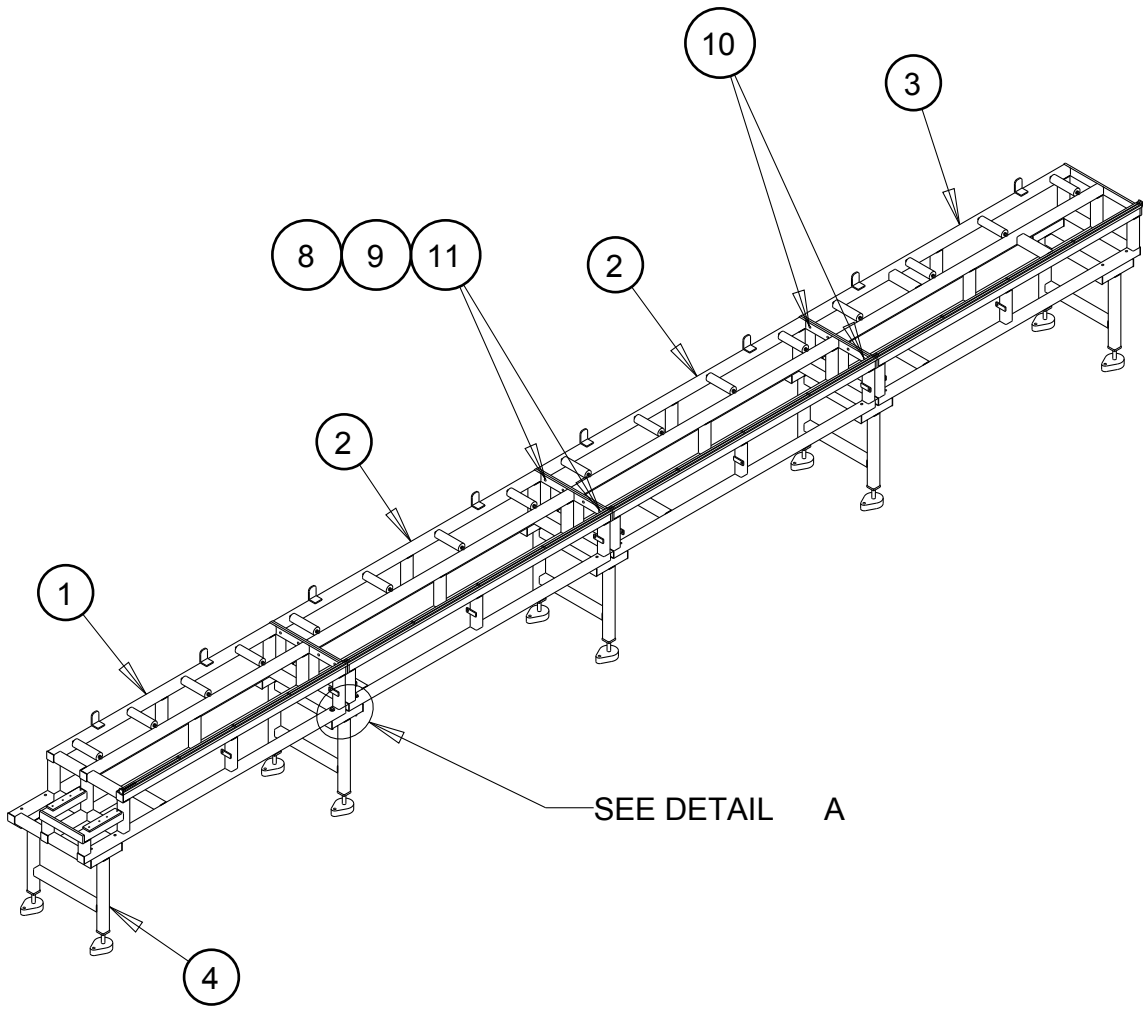


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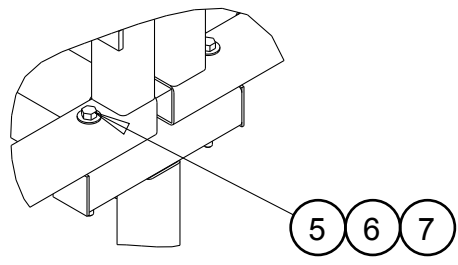
QCA CE

QUICKCUT ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	QCA 01	1	LIFTERS, ROLLERS AND BACK STOP LOCATION
2	QAS-MAIN FRAME	1	MAIN FRAME ASSEMBLY
3	QAS-COMPLETE LIFT	1	COMPLETE QC LIFTER ASSEMBLY
4	QAS-AIR SYS	1	QC AIR SYSTEM
5	QAS-HEAD ASY	1	QUICKCUT HEAD ASSEMBLY
6	QAS-MEASURE	1	QUICKCUT MEASURE
7	QAS CE ELECT BX ASY	1	QC ELECT BOX ASSEMBLY
8	QAS-TORCH GUIDE	1	QC TORCH GUIDE ASSEMBLY
9	QAS-TROLLEY	1	QC TROLLEY
10	QAS ROLLER ASY	8	QUICKCUT ROLLER ASSEMBLY
11	QMP-HEAD GUARD	1	HEAD GUARD
12	FAS-F24	8	1/4-20 X 3/4" LG. SHCS
13	FAS-F38	4	1/4" FLAT WASHER



SEE DETAIL A



DETAIL "A"

QUICKCUT MAIN FRAME ASSEMBLY



North Alabama Pipe

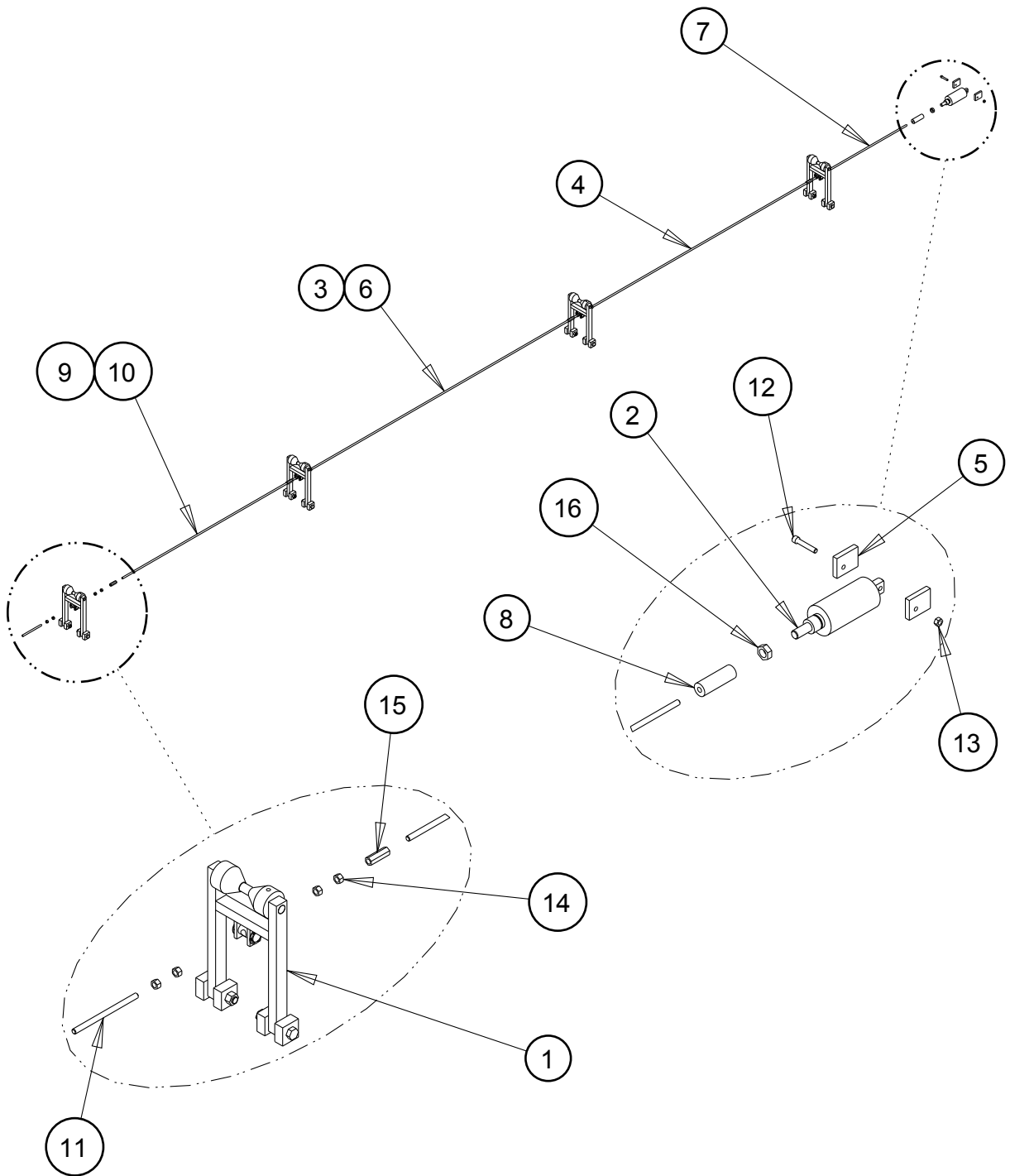
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QAS-MAIN FRAME

QUICKCUT MAIN FRAME ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	QAS-MAIN FRAME 01	1	FRAME WELDMENT DRIVE
2	QAS-MAIN FRAME 02	2	FRAME WELDMENT #1
3	QAS-MAIN FRAME 03	1	FRAME END WELDMENT
4	QAS-MAIN FRAME 04	5	SUPPORT LEG
THE FOLLOWING ITEMS MAKE-UP THE SHIPMENT BOLT PACKAGE #20-QAS-SHIPMENT PKG			
5	FAS-H4	20	3/8-16 X 5" LG. HHCS
6	FAS-H19	20	3/8-16 HEX NUT
7	FAS-H22	40	3/8" FLAT WASHER
8	FAS-I2	6	1/2-13 X 1-3/4" LG. HHCS
9	FAS-I14	6	1/2-13 HEX NUT
10	FAS-I20	6	1/2" \varnothing X 1" LG. DOWEL PIN
11	FAS-I22	12	1/2" FLAT WASHER



QUICKCUT LIFTERS ASSEMBLY



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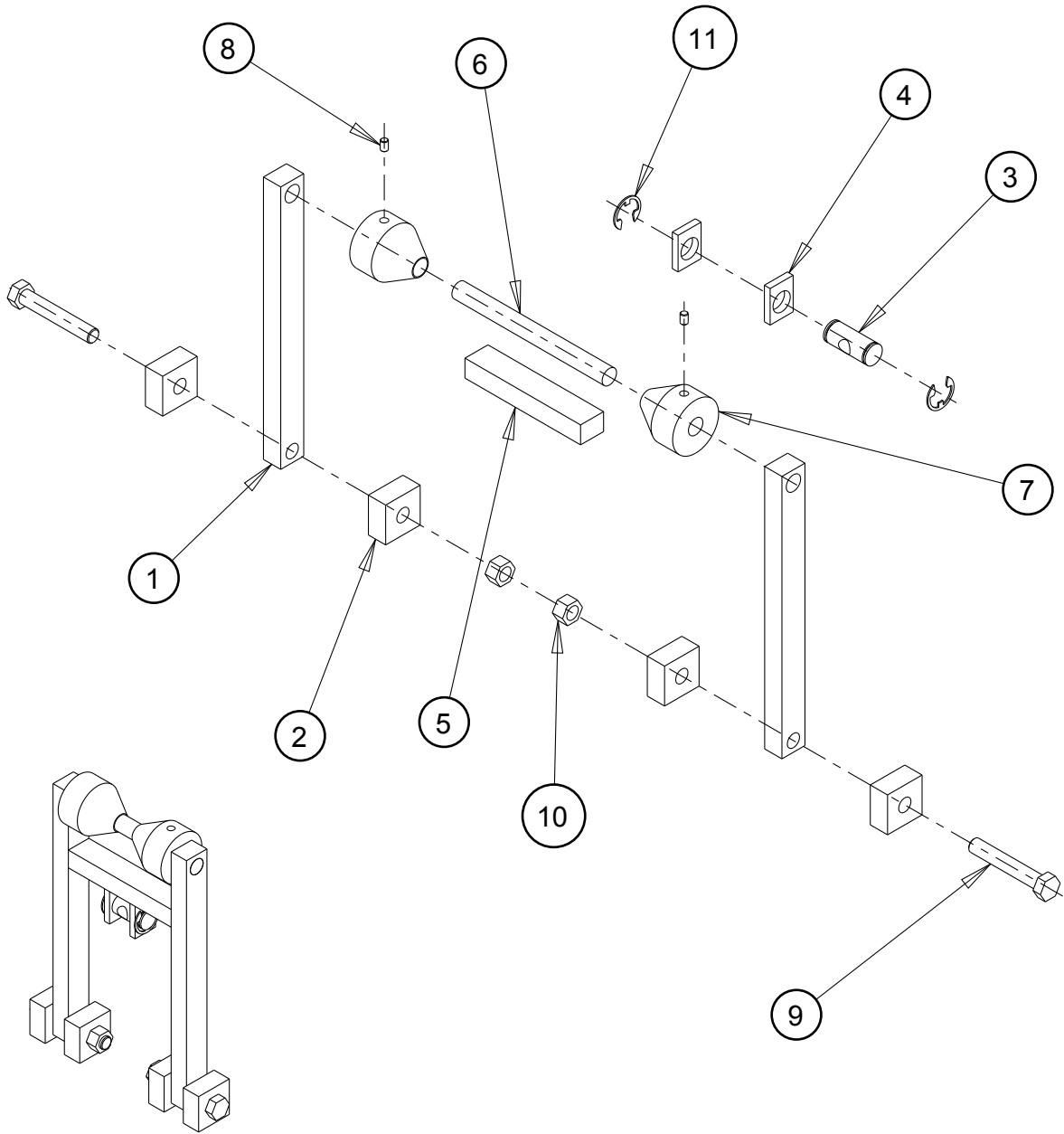
REVISION "B" SEE BOM SHEET

QAS-COMplete LIFT

QUICKCUT LIFTERS PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-QAS-SINGLE LIFTER	4	QC SINGLE LIFTER ASSEMBLY
2	20-AIR-406	1	AIR CYLINDER
3	20-QMP-4520	1	3/8-16 X 83-1/2" LG. ALL THREAD
4	20-QMP-4521	1	3/8-16 X 70" LG. ALL THREAD
5	20-QMP-4525	2	LIFTER CYLINDER MOUNT
6	20-QMP-4526	3	3/8-16 X 6" LG. ALL THREAD
7	20-QMP-4527	1	3/8-16 X 29" LG. ALL THREAD
8	20-QMP-4528	1	CYLINDER ADAPTER COUPLING
9	20-QMP-4560	1	3/8-16 X 54" LG. ALL THREAD
10	20-QMP-4557	1	3/8-16 X 5" LG. ALL THREAD
11	20-QMP-4558	1	3/8-16 X 4" LG. ALL THREAD
12	20-FAS-G26	1	5/16-18 X 2-1/4" LG. S.H.C.S.
13	20-FAS-G29	1	5/16-18 LOCK NUT
14	20-FAS-H19	16	3/8-16 HEX. NUT
15	20-FAS-H20	6	3/8-16 COUPLING NUT
16	20-FAS-J2	1	5/8-11 JAM NUT

REVISION "A" 10/12/10 ITEM #12 WAS FAS-G27 NOW FAS-G26.
 REVISION "B" 9/12/13 ITEM #3 WAS 84" LG. ITEM #7 WAS 30" LG.



QUICKCUT SINGLE LIFTER ASSEMBLY



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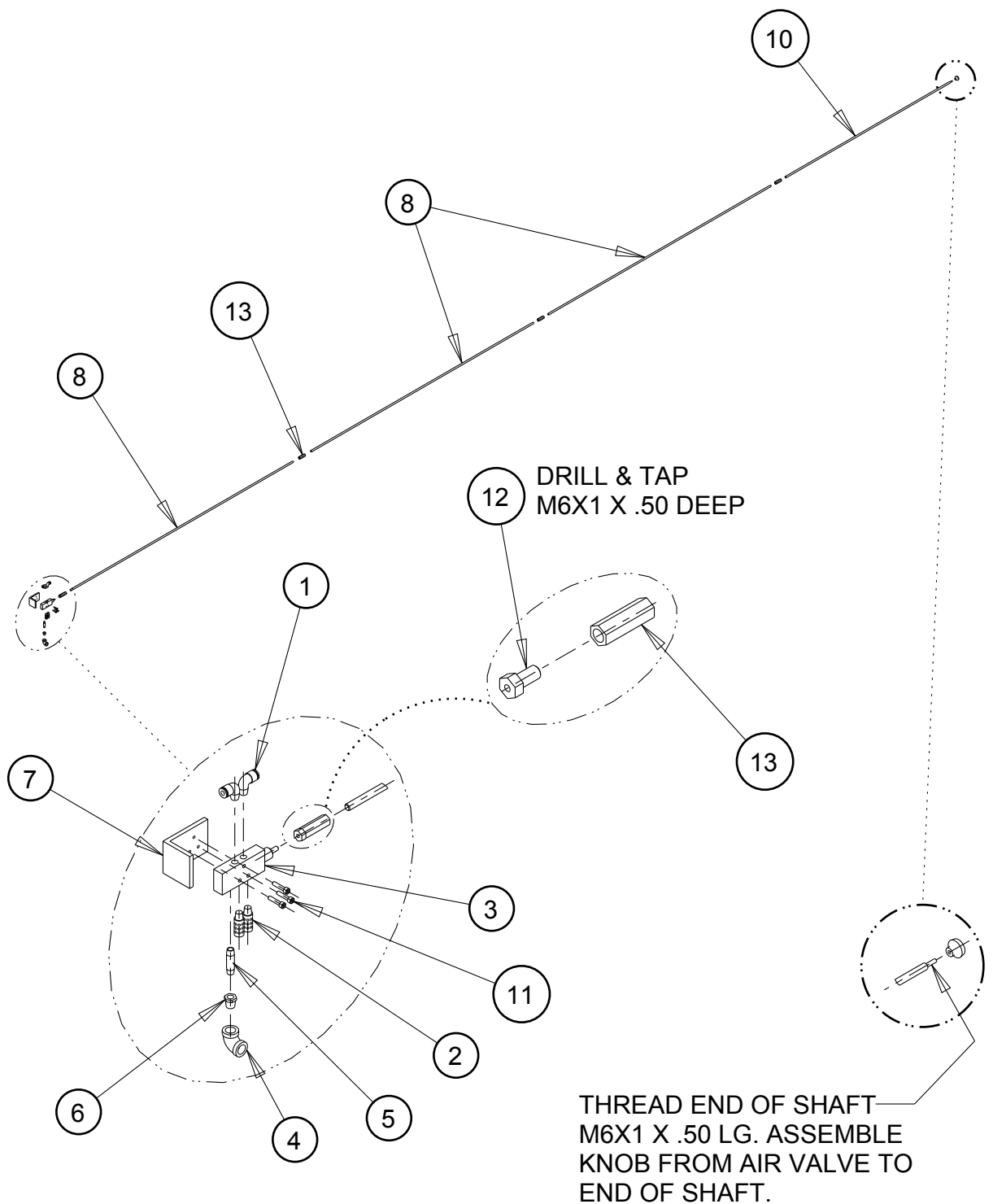
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QAS-SINGLE LIFTER

QUICKCUT LIFTER PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	QMP-4104	2	LIFT ARM
2	QMP-4505	4	LIFTER MOUNTS
3	QMP-4506	1	CONNECTING ROD SHAFT
4	QMP-4507	2	SHAFT MOUNT
5	QMP-4508	1	CROSS BRACE
6	QMP-4509	1	ROLLER SHAFT
7	QMP-4562	2	LIFT ROLLER
8	FAS-F17	2	1/4-20 X 1/2' LG. S.H.S.S.
9	FAS-I4	2	1/2-13 X 3" LG. H.H.C.S.
10	FAS-I13	2	1/2-13 NYLOCK NUT
11	FAS-E-CLIP #4	2	3/4"



QUICKCUT AIR VALVE ASSEMBLY



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REVISION "A" SEE BOM SHEET

QAS-AIR SYS

QUICKCUT AIR VALVE PARTS LIST

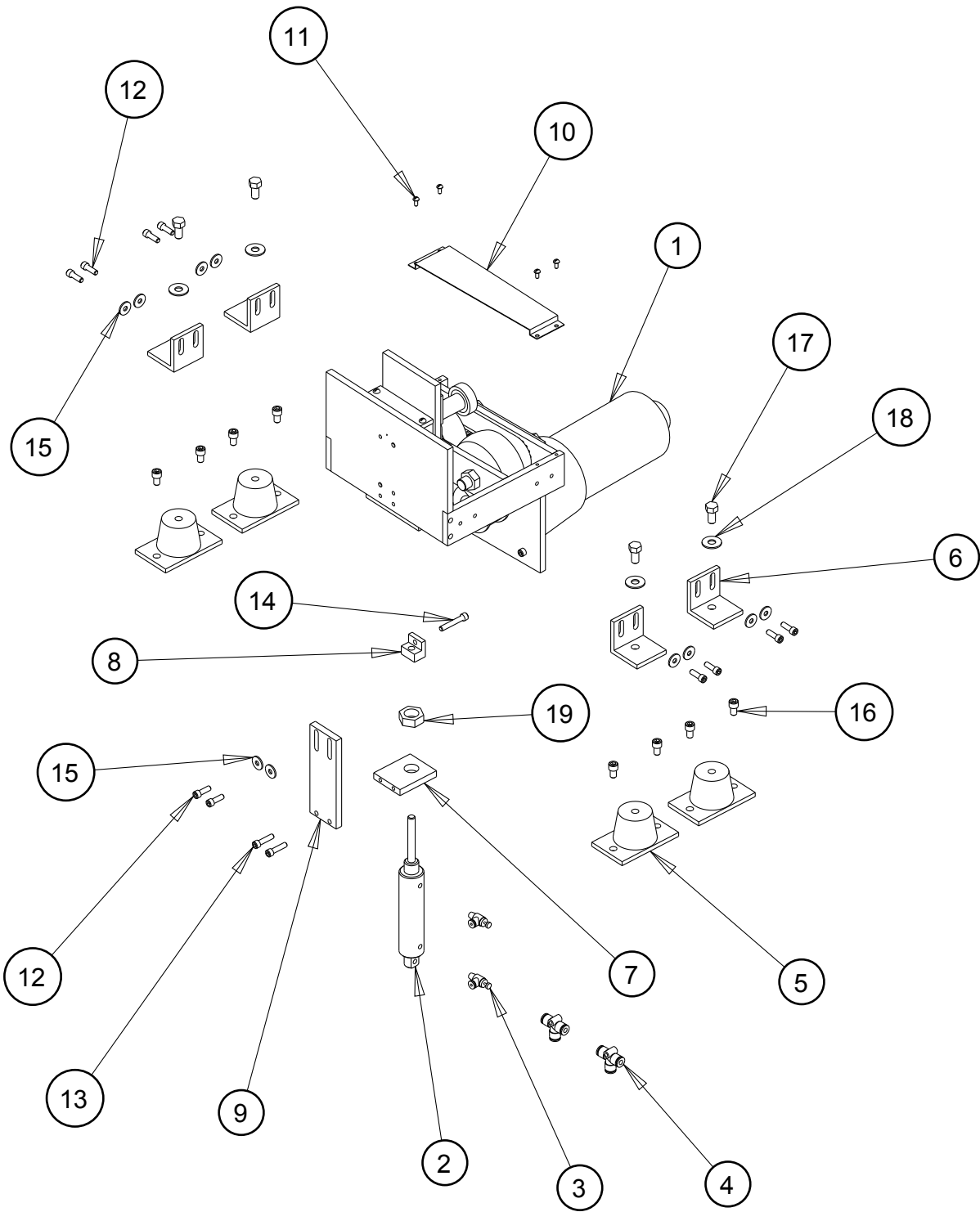
ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-AIR-417	2	1/4 X 1/8M ELBOW
2	20-AIR-419	2	MUFFLER
3	20-AIR-426	1	AIR VALVE
4	20-AIR-431	1	1/4 X 90° ELBOW
5	20-AIR-432	1	1/8 X 2" LG. NIPPLE
6	20-AIR-433	1	1/4 X 1/8 PIPE REDUCER
7	20-QMP-4107	1	MOUNT ANGLE
8	20-QMP-4519	3	3/8-16 X 72" LG. ALL THREAD
10	20-QMP-4560	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.



QUICKCUT HEAD ASSEMBLY

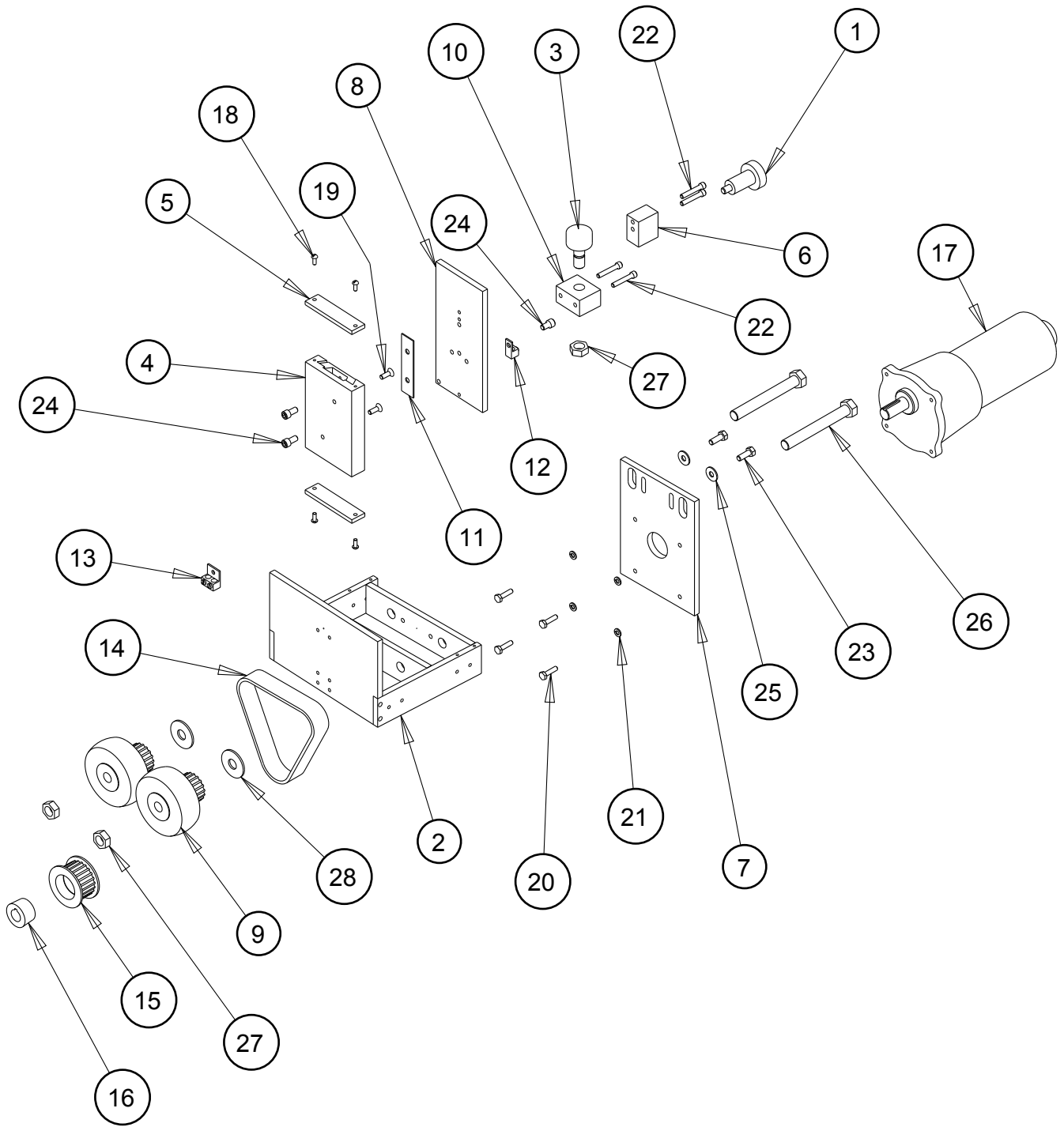


North Alabama Pipe
 A Division of Anvil International
 Innovators Of Pipe Fabrication Equipment

QAS-HEAD ASY

QUICKCUT HEAD ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-QAS-HEAD ASY 01	1	HEAD ASSEMBLY
2	20-AIR-405	1	AIR CYLINDER #1125DV200
3	20-AIR-412	2	FLOW CONTROL
4	20-AIR-422	1	1/4" TEE
5	20-MS-521	4	RUBBER SUPPORTS
6	20-QMP-4026	4	ANGLE ADJUSTMENT
7	20-QMP-4029	1	AIR CYLINDER MOUNT
8	20-QMP-4031	1	AIR CYLINDER BRACKET
9	20-QMP-4103	1	AIR CYLINDER PLATE
10	20-QMP-4502	1	BELT GUARD (BLK-620)
11	20-FAS-D3	4	#8-32 X 3/8" LH. R.H.M.S.
12	20-FAS-F24	11	1/4-20 X 3/4" LG. S.H.C.S.
13	20-FAS-F25	2	1/4-20 X 1" LG. S.H.C.S.
14	20-FAS-F27	1	1/4-20 X 1-1/2" LG. S.H.C.S. (CUT OFF)
15	20-FAS-F38	10	1/4" FLAT WASHER
16	20-FAS-G7	4	5/16-18 X 1/2" LG. SHCS
17	20-FAS-H1	4	3/8-16 X 1" LG. H.H.C.S.
18	20-FAS-H22	4	3/8" FLAT WASHER
19	20-FAS-K1	1	3/4-16 HEX JAM NUT

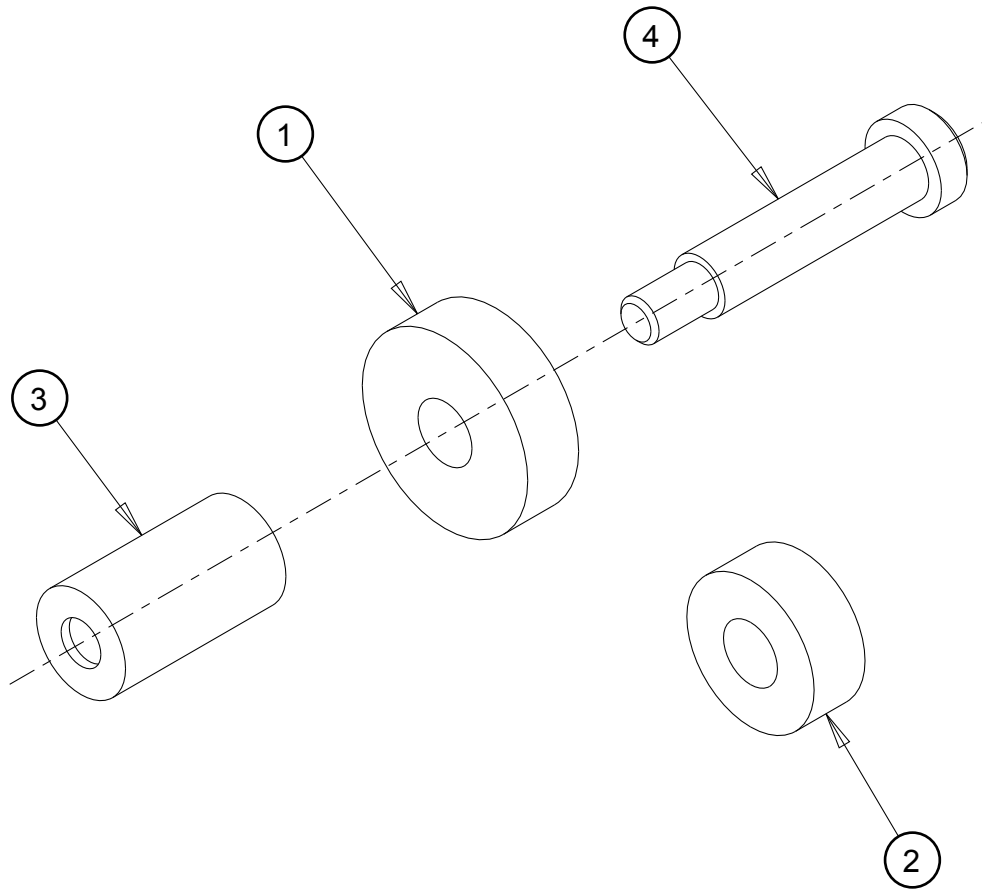


QUICKCUT HEAD ASSEMBLY



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QAS-HEAD ASY 01



QUICKCUT PIPE CLAMP ASSEMBLY

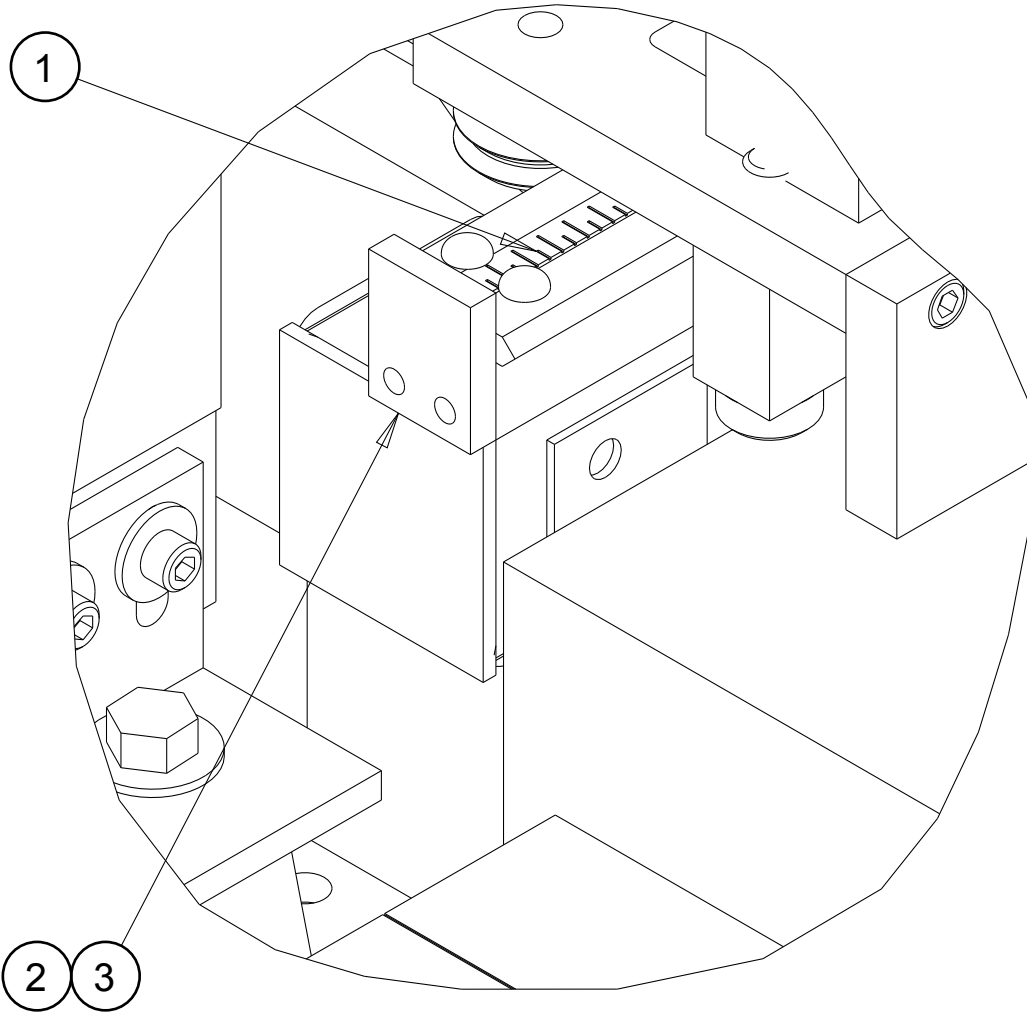


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QAS-PIPE CLAMP

QUICKCUT PIPE CLAMP PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	QMP-4554	1	LARGE GROUND WHEEL
2	QMP-4555	1	SMALL GROUND WHEEL
3	QMP-4556	1	WHEEL BLOCK
4	FAS-112	1	∅ 1/2 X 2" LG, SHOULDER BOLT



QUICKCUT MEASURE

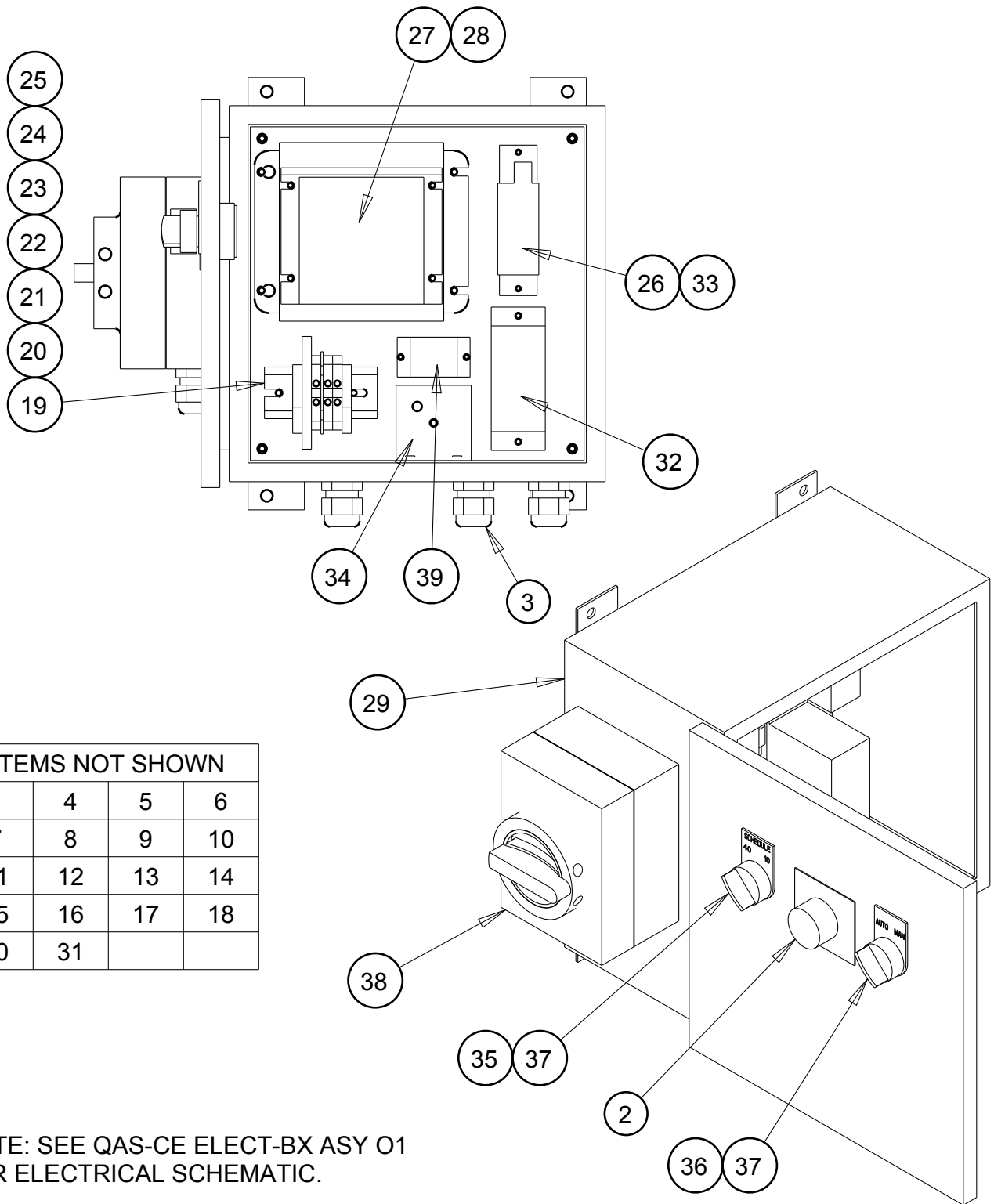


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QAS-MEASURE

QUICKCUT MEASURE PARTS LIST


ITEM	PART NUMBER	QTY	DESCRIPTION
1	MSC-522	1	50 FT. METAL TAP
2	QMP-4533	2	RAIL END CAP
3	FAS-E17	4	#10-24 X 5/8" LG. S.H.C.S.



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.

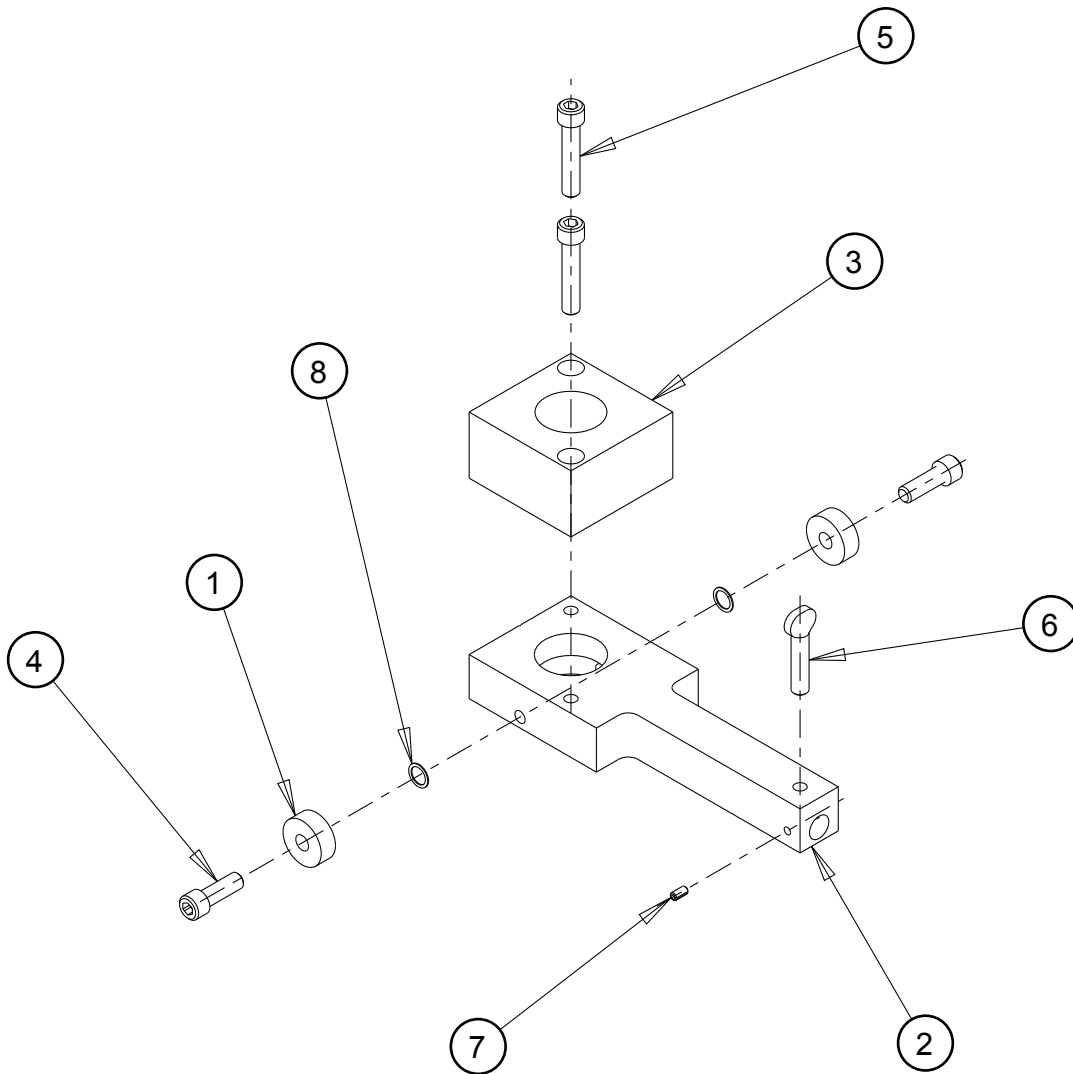
QUICK CUT ELECTRICAL BOX ASSEMBLY

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

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



REVISION "A" 12/10/13
SEE BOM SHEET FOR REVISION.

QUICKCUT TORCH GUIDE ASSEMBLY



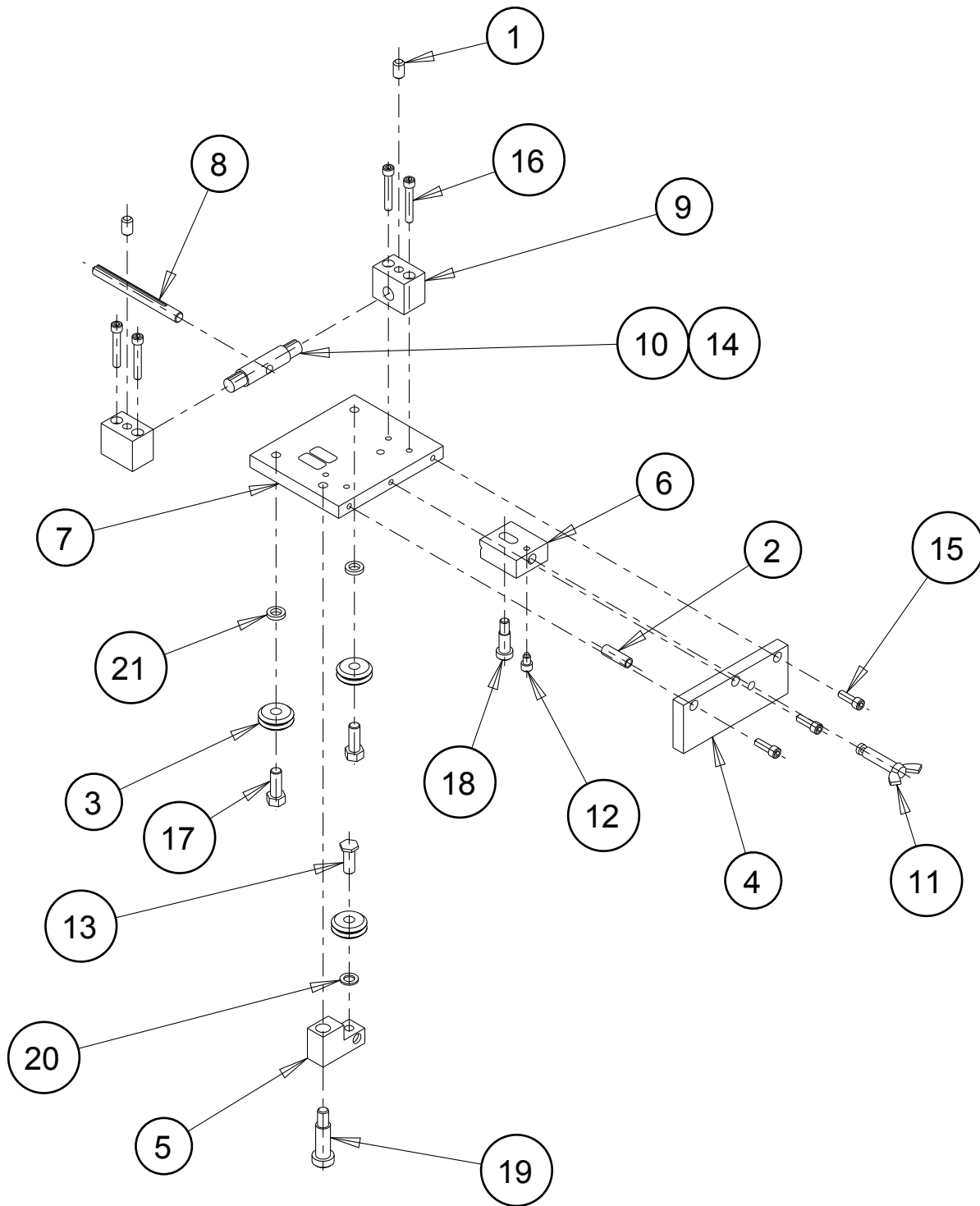
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QAS-TORCH GUIDE

QUICKCUT TORCH GUIDE ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	BRG-903	2	BEARING Z99R4A
2	QMP-4038	1	TORCH GUIDE MOUNT
3	QMP-4552	1	TORCH GUIDE
4	FAS-F24	2	1/4-20 X 3/4' LG. SHCS
5	FAS-F26	2	1/4-20 X 1-1/4" LG. SHCS
6	FAS-F30	1	1/4-20 X 1' LG. THUMB SCREW
7	FAS-RPIN #2	1	∅ 1/8" X 1" LG. ROLL PIN
8	FAS-SHIM #1	2	∅ 1/4 X .015

REVISION "A" 12/10/13
 ITEM #5 WAS FAS-F25 1/4-10 X 1" LG. SHCS.



QUICKCUT TROLLEY ASSEMBLY

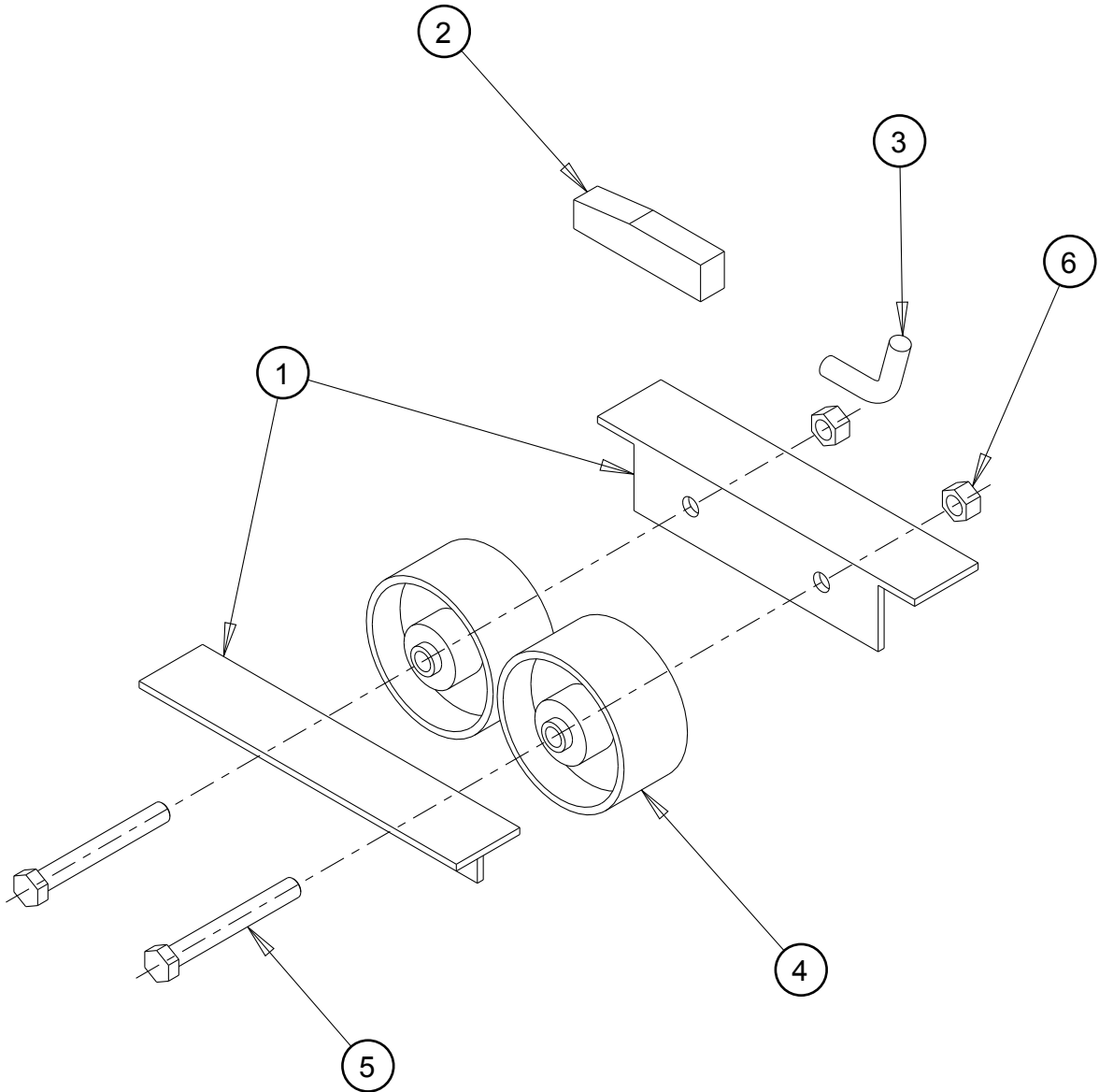


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QAS-TROLLEY

QUICKCUT TROLLEY ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	MSC-501	2	BALL DETENT
2	MSC-516	1	COMPRESSION SPRING
3	BRG-934	3	"V" WHEEL
4	QMP-4023	1	BACK PLATE
5	QMP-4033	1	WHEEL MOUNT
6	QMP-4035	1	WHEEL ADJUSTMENT
7	QMP-4100	1	BASE PLATE
8	QMP-4513	1	TORCH SLIDE TUBE
9	QMP-4515	2	G-10 MOUNT
10	QMP-4516	1	PIVOT SHAFT
11	QMP-4517	1	ADJUSTMENT SCREW
12	QMP-4518	1	SCREW
13	QMP-4551	1	'V' WHEEL SCREW
14	FAS-E27	1	#10-24 X 1/4" LG. SHSS
15	FAS-F23	3	1/4-20 X 1/2" LG. SHCS
16	FAS-F26	4	1/4-20 X 1-1/4" LG. SHCS
17	FAS-H1	2	3/8-16 X 1" LG. HHCS
18	FAS-H5	1	∅ 3/8 X 3/4" LG. SHSB
19	FAS-I9	1	∅ 1/2 X 1-1/4" LG. SHSB
20	FAS-SHIM #3	1	∅ 3/8 X .062
21	FAS-SHIM #4	2	∅ 3/8 X .125



QUICKCUT ROLLERS ASSEMBLY

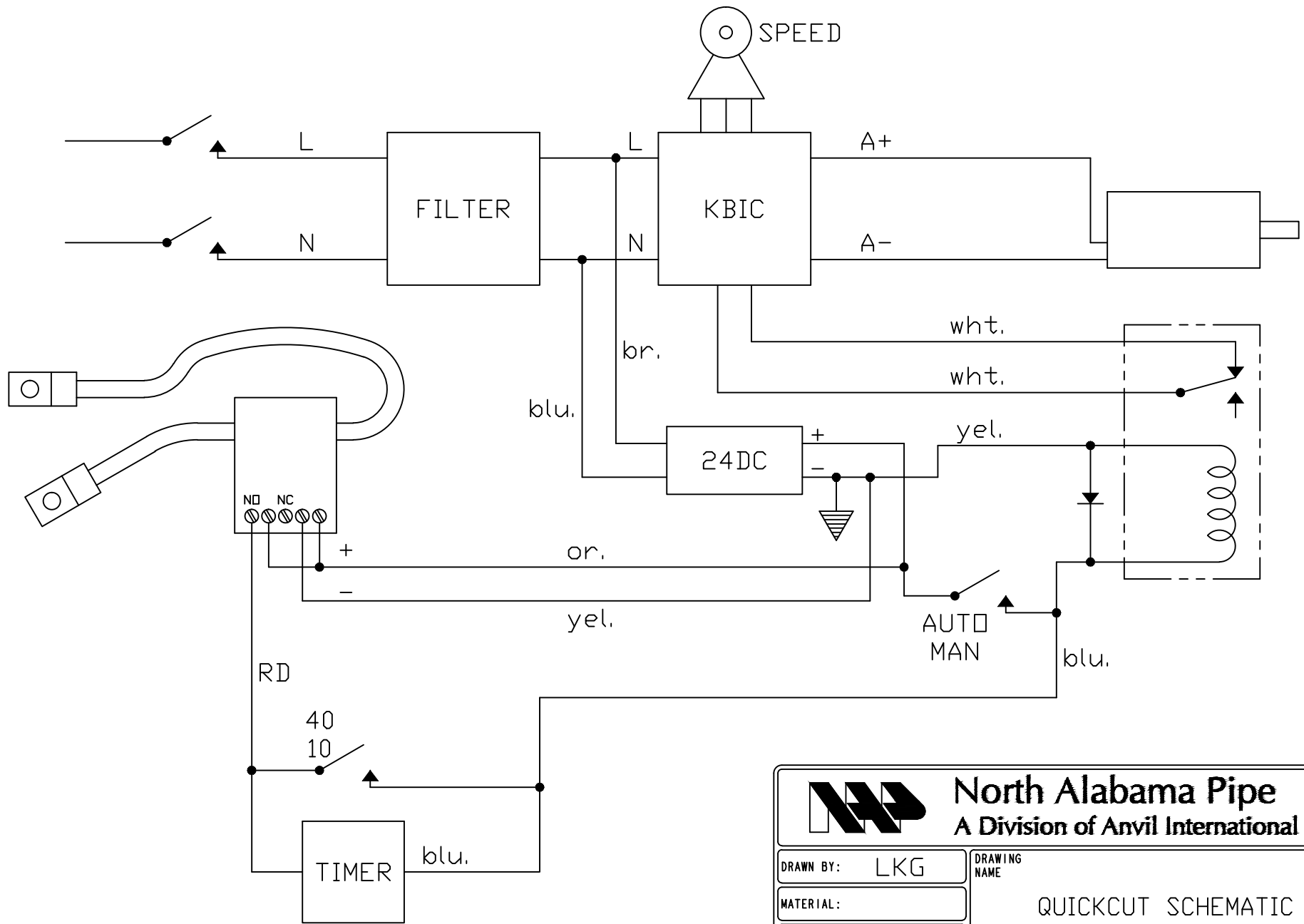


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QAS-ROLLER ASY

QUICKCUT ROLLERS PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	QMP-4017	2	WHEEL MOUNT ANGLES
2	QMP-4529	1	PIPE TRANSFER
3	QMP-4530	1	PIPE STOP
4	BRG-937	2	∅ 4"STEEL WHEEL
5	FAS-I5	2	1/2-13 X 4' LG. H.H.C.S.
6	FAS-I14	2	1/2-13 HEX NUT



North Alabama Pipe
A Division of Anvil International

DRAWN BY: LKG	DRAWING NAME
MATERIAL:	QUICKCUT SCHEMATIC
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

INSTALLATION

UNPACKING EQUIPMENT

Remove the selafane wrapping from the contents and pallet. Inspect the contents for any damages that might have occurred during shipping. Make sure that all items on the packing list are accounted for and identified. Any claims for loss or damage that might have occurred during transit must be filed by the purchaser with the carrier. When requesting information concerning this equipment, it is essential that the model description, serial number and/or part number of the equipment be supplied.

LOCATION SPECIFICATION

- Refer to major dimensions for shop layouts.
- Locate in well ventilated area.
- Maintain a 4' walk way to the front for the operator access.
- Provide room enough for easy access to head section.
- Locate away from damp or saturated areas.

FINAL CHECK LIST

1. Check to make sure the entire Quickcut is absolutely level.
2. Check to see that the air supply is on and properly connected to the air valve found at the head section.
3. Check to make sure the plasma unit is properly grounded at the head section. Also make sure the plug cord for the plasma unit is plugged into the proper outlet.
4. Check to see that the power plug cord leading from the electrical box is plugged into a 110 volt outlet.

OPERATION

SETTINGS

The Quickcut from N.A.P. is uniquely designed for cutting pipe with schedule 10 to schedule 40 wall thickness.

1. For schedule 10 wall thickness set the plasma unit to 40 amps. Set the DC speed control between 50 and 65.
2. For schedule 40 wall thickness set the plasma unit to 40 amps. Set the DC speed control between 20 and 45.
3. The small gray electrical box marked "caution" controls the operating modes.
 - The "AUTO" Selection will result in pipe rotation only when the plasma torch is cutting the pipe.
 - The "MANUAL" Selection will result in constant pipe rotation regardless if the plasma torch is cutting the pipe. (*This method is for marking*)
 - The "OFF" selection disables pipe rotation regardless if the plasma torch is activated.

N. A. P. QUICK CUT OPERATION INSTRUCTIONS

I CONTROL BOX OPERATION

- A. The three-position toggle switch controls the mode of operating the rotation of the pipe.
1. "Automatic" Mode. The rotation of the pipe will begin and end with the initiation and ceasing of the plasma burn. The plasma cut must actually begin before the pipe will start to rotate and the pipe will stop rotating when the plasma cut of the pipe ceases. (When the "auto-start" assembly of the "Quick-Cut" senses electrical current in the plasma unit's ground cable, pipe rotation begins. When there is no current, pipe rotation stops.
 2. "Off" Mode. This mode cuts off the power to the rotation motor.
 3. "Manual" Mode. This mode will cause the pipe to rotate constantly until the switch is placed in the "Off" or "Automatic" position.
- B. The two-position toggle switch controls the time delay for pipe penetration of the plasma energy stream. This switch should be set for "Schedule 40" for schedule 40 pipe and on "Schedule 10" for schedule 10 or thinner wall thicknesses.

II. SPEED CONTROL BOX OPERATION

- A. The "On" - "Off" toggle switch controls the electrical power to the rotation motor. It must be in the "On" position for the machine to operate.
- B. The Speed Control dial sets the rotation speed of the pipe. The speed should be set at approximately 55 for schedule 10 pipe and at approximately 30 for schedule 40 pipe. Slight increases or decreases in speed settings may improve the plasma cut depending on actual pipe thicknesses and coatings.

QUICKCUT HEAD ASSEMBLY PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	20-QAS-PIPE CLAMP	1	PIPE CLAMP ASSEMBLY
2	20-QAS-HEAD WELDMENT	1	HEAD WELDMENT
3	20-BRG-906	1	CAM FOLLOWER
4	20-BRG-925	1	6" UNISLIDE (BLK-648)
5	20-QMP-4025	2	UNISLIDE END PLATE
6	20-QMP-4028	1	CLAMP MOUNT BLOCK
7	20-QMP-4041	1	MOTOR PLATE
8	20-QMP-4042	1	SLIDE PLATE
9	20-QMP-4500	2	RED WHEELS
10	20-QMP-4501	1	THRUST BEARING MOUNT
11	20-QMP-4561	1	UNISLIDE SPACER
12	20-EPP-0164	2	GROUND LUG
13	20-EPP-0165	1	GROUND LUG
14	20-PLY-303	1	BELT #4808M30
15	20-PLY-313	1	DRIVER PULLEY #P22-8M-1108 HTTL
16	20-PLY-324	1	TAPERLOK BUSHING #1108X3/4
17	20-MTR-102	1	GEARMOTOR
18	20-FAS-E14	4	#10-24 X 5/8" LG. S.H.C.S.
19	20-FAS-F5	2	1/4-20 X 3/4" LG. F.H.C.S.
20	20-FAS-F10	4	1/4-28 X 1" LG. H.H.C.S.
21	20-FAS-F40	4	1/4 LOCK WASHER
22	20-FAS-F47	4	1/4-20 X 1-3/4" LG. S.H.C.S.
23	20-FAS-G3	2	5/16-18 X 3/4" LG. H.H.C.S.
24	20-FAS-G7	4	5/16-18 X 1/2" LG. S.H.C.S.
25	20-FAS-G21	2	5/16" FLAT WASHER
26	20-FAS-J1	2	5/8-18 X 5" LG. H.H.C.S.
27	20-FAS-J4	3	5/8-18 JAM NUT
28	20-FAS-J5	2	5/8" FLAT WASHER

NORTH ALABAMA PIPE

QC

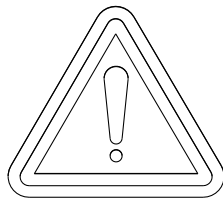
MACHINE MANUAL

CONTENTS

SAFETY INFORMATION	3 THRU 7
MANUAL INDEX	8
QUICKCUT ASSEMBLY INSTRUCTIONS	SECTION #1
OPERATOR AND MAINTENANCE MANUAL	SECTION #2
PARTS LIST	SECTION #3

CAUTION:

To ensure the safe operation of this machine and the safety of the operator this manual must be read and understood before proceeding.



THIS DOCUMENT HAS BEEN PREPARED BY:

NORTH ALABAMA PIPE

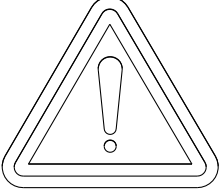
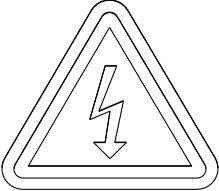
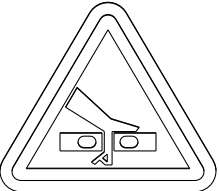
185 GRIMES DRIVE

GUNTERSVILLE, ALABAMA

35976

U.S.A.

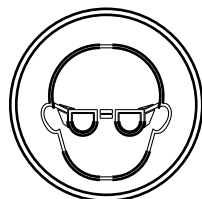
ISO SAFETY SYMBOLS - DEFINED

	<p style="text-align: center;"><u>CAUTION - GENERAL</u></p> <p>Do not operate machine until operators manual has been read.</p> <p>Use forklift to move machine into area machine is to be used. There is a risk of personal injury if attempted to move by hand</p> <p>Be sure machine is connected to building electrical safety ground.</p> <p>Be sure to disconnect and lock out and tag out the power before performing machine maintenance.</p> <p>Do not operate machine with guards removed.</p> <p>Do not wear loose clothing or jewelry while operating this machine.</p> <p>Do not operate this machine in a manner for which it is not intended to be used.</p>
	<p style="text-align: center;"><u>CAUTION - ELECTRICAL</u></p> <p>High voltages present inside electrical box.</p> <p>To reduce the risk of electrical shock, do not attempt to open cabinet while power is on..</p> <p>Do not operate this equipment from any power source that does not match the voltage rating stamped on the equipment. refer to the manufacturer's identification label for operational requirements.</p> <p>Refer servicing to qualified service personnel only.</p>
	<p style="text-align: center;"><u>CAUTION - CRUSH HAZARD</u></p> <p>Pipe Lift Device poses threat of Crush Hazard.</p> <p>Keep hands and other objects not intended to be near pipe lift device away during operation.</p> <p>Severe personal injury and or dismemberment may occur.</p>

ISO SAFETY SYMBOLS - DEFINED

	<p style="text-align: center;"><u>CAUTION - DO NOT REMOVE GUARDS</u></p> <p>Moving and rotating parts contained behind guards.</p> <p>Do not operate machine with guards removed. Except for maintenance purposes.</p> <p>Do not wear loose clothing or allow long hair to hang loose at head end of machine, these can get caught between the rotation wheels and pipe.</p> <p>Severe injury and or dismemberment may occur.</p>
	<p style="text-align: center;"><u>MANDATORY</u></p> <p>This machine must be locked out before proceeding.</p>
	<p style="text-align: center;"><u>MANDATORY</u></p> <p>Supporting documentation must be read before operating or maintaining this machine.</p> <p>Failure to do so may result in severe personal injury and or dismemberment.</p>
	<p style="text-align: center;"><u>GLOVES</u></p> <p>Gloves must be worn while operating this machine.</p> <p>There is a risk of personal injury if gloves are not worn.</p>
	<p style="text-align: center;"><u>DANGER - HOT SURFACES</u></p> <p>Hot surfaces are present during operation of this machine.</p> <p>Temperatures on the end of the pipe can exceed 1000° F/538° C.</p> <p>Severe burns can result.</p>

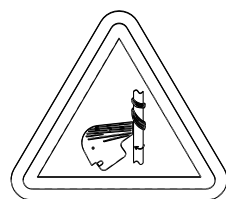
ISO SAFETY SYMBOLS - DEFINED



CAUTION - SHADED LENSE EYE PROTECTION

Use of shaded lense #8 or #9 is required when operating this machine.

This machine uses a Plasma Cutting Torch to cut the pipe and produces a spark flash that can harm the eyes while cutting.

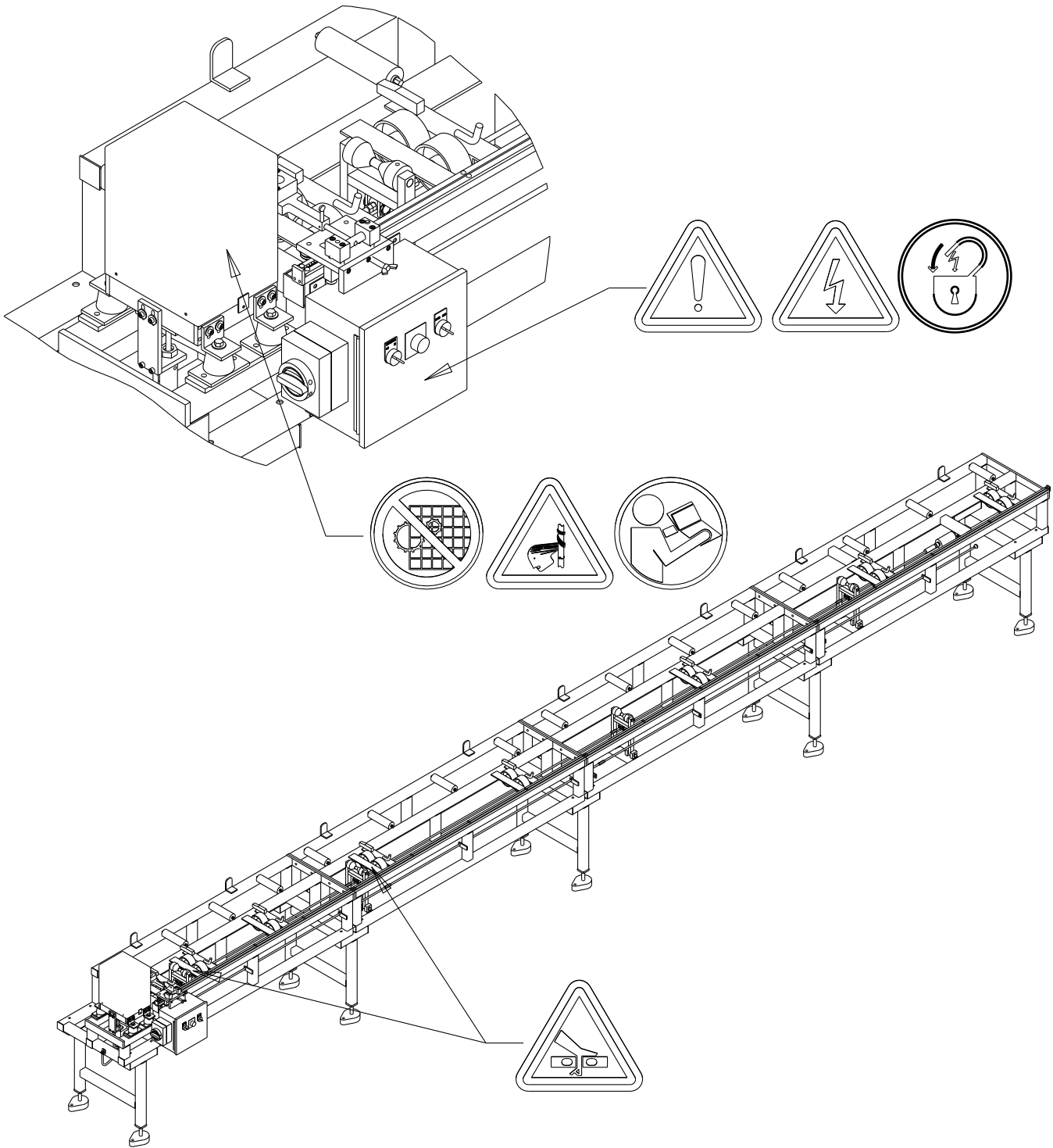


CAUTION - ENTAINGLEMENT

Do not wear loose clothing or allow hair to hang loose, these can become entangled between the rotation wheels and pipe at the Head end of machine.

Do not place hand near drive rollers while in operation.

Severe personal injury and or dismemberment may occur.



ISO SYMBOLS LOCATIONS



North Alabama Pipe
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Innovators Of Pipe Fabrication Equipment

MANUAL SHEET INDEX

SHEET NUMBER	DESCRIPTION	PART NUMBER
	INDEX SHEET	
QUICKCUT ASSEMBLY INSTRUCTIONS SECTION #1		
SHT #1.1	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.2	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.3	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.4	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.5	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.6	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.7	QUICKCUT ASSEMBLY INSTRUCTIONS	
SHT #1.8	QUICKCUT ASSEMBLY INSTRUCTIONS	
OPERATION AND MAINTENANCE MANUAL SECTION #2		
SHEET #2.1	OPERATION MANUAL	
SHEET #2.2	OPERATION MANUAL	
SHEET #2.3	OPERATION MANUAL	
SHEET #2.4	OPERATION MANUAL	
SHEET #2.5	OPERATION MANUAL	
SHEET #2.6	OPERATION MANUAL	
SHEET #2.7	OPERATION MANUAL	
SHEET #2.8	OPERATION MANUAL	
SHEET #2.9	OPERATION MANUAL	
SHEET #2.10	OPERATION MANUAL	
SHEET #2.11	OPERATION MANUAL	
SHEET #2.12	OPERATION MANUAL	
SHEET #2.13	OPERATION MANUAL	
SHEET #2.14	OPERATION MANUAL	
SHEET #2.15	OPERATION MANUAL	
SHEET #2.16	OPERATION MANUAL	
PARTS LIST SECTION #3		
SHEET 3.1	PARTS MANUAL COVER SHEET	
SHT #3.2 & #3.3	QUICKCUT ASSEMBLY	QCA-CE
SHT #3.4 & #3.5	QUICKCUT MAIN FRAME ASSEMBLY	QAS-MAIN FRAME
SHT #3.6 & #3.7	QUICK CUT LIFTERS ASSEMBLY	QAS-COMplete LIFT
SHT #3.8 & #3.9	QUICKCUT SINGLE LIFTER ASSEMBLY	QAS-SINGLE LIFTER
SHT #3.10 & #3.11	QUICKCUT AIR SYSTEM ASSEMBLY	QAS-AIR SYS
SHT #3.12 & #3.13	QUICKCUT HEAD ASSEMBLY	QAS-HEAD ASY
SHT #3.14 & #3.15	QUICKCUT HEAD ASSEMBLY	QAS-HEAD ASY 01
SHT #3.16 & #3.17	QUICKCUT PIPE CLAMP ASSEMBLY	QAS-PIPE CLAMP
SHT #3.18 & #3.19	QUICKCUT MEASURE ASSEMBLY	QAS-MEASURE
SHT #3.20 & #3.21	QUICKCUT ELECTRICAL BOX ASSEMBLY	QAS-CE ELECT BX ASY
SHT #3.22 & #3.23	QUICKCUT TORCH GUIDE ASSEMBLY	QAS-TORCH GUIDE
SHT #3.24 & #3.25	QUICKCUT TROLLEY ASSEMBLY	QAS-TROLLEY
SHT #3.26 & #3.27	QUICKCUT ROLLER ASSEMBLY	QAS-ROLLER ASY
SHT #3.28	ELECTRICAL BOX SCHEMATIC	QAS-ELECT BX ASY 01