

ALLPAX[®]

GASKET CUTTER SYSTEMS

HEAVY DUTY GASKET CUTTER *GUIDE TO PERFECT GASKETS*

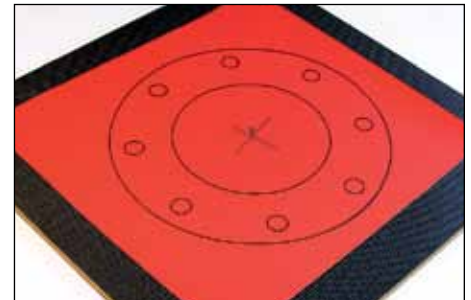
CUTTING GASKETS 1" TO 13" IN DIAMETER:



1. Lay out gasket outer diameter (OD), inner diameter (ID) and bolt holes on template or gasket material. See section 'Using the Bolt Hole Locator'. Ensure the OD of gasket fits the material. If this is not the case, see section 'Using the Dove Tail Designer'.



2. Insert center pin into center pin handle. Pierce center of the gasket with the appropriate length center pin for the thickness of material being cut.



3. Place center pin into pilot hole in gasket material. Use appropriate length center pin for thickness of material being cut. Insert protruding center pin into recessed ferrule in middle of cutting board.



4. Insert thick-headed pivot post without offset pin through cutter block.



5. Loosen knurled nut and adjust pivot post to desired cutting diameter by matching pivot post indicator line with appropriate dimension of 0"-13" scale. Secure with knurled nut.

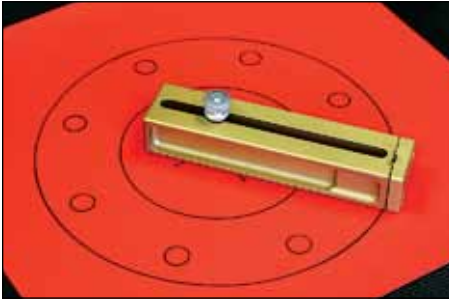


6. Loosen Allen screws of cutter block and position cutting blade so it protrudes slightly beyond thickness of gasket material. Tighten Allen screws.

FOR HELPFUL HINTS AND VIDEO INSTRUCTIONS, VISIT

WWW.ALLPAXCORP.COM

CUTTING GASKETS 1" TO 13" IN DIAMETER: (continued)



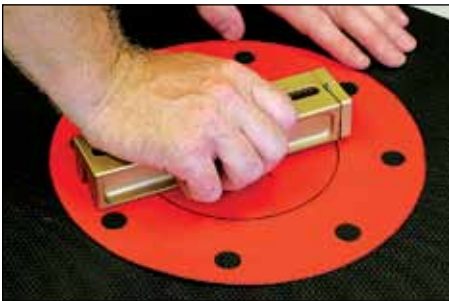
7. Position pivot post over center pin in gasket material ensuring cutter block is lying flat on gasket material.



8. With slight downward pressure on cutting block and material, rotate cutter block clockwise to make cut. For thicker or hard to cut materials, make several passes to make cut. Or cut half way through material, turn over and complete cut. On difficult materials (hard, soft, etc.) consider using Easy Cutting Lubricant.



9. Reset cutter block for bolt holes and cut, or use hole punches to create bolt holes.



10. Reset cutter block for inside diameter dimension and cut as above.

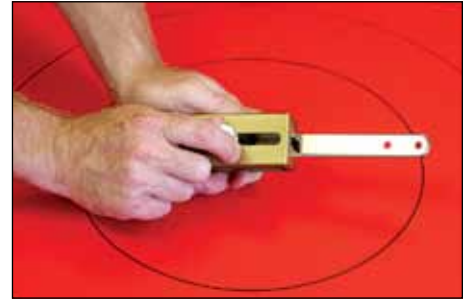
CUTTING GASKETS OVER 13" IN DIAMETER:



1. Place extension bar without stud in groove on bottom of cutter block with single, large hole in extension bar toward cutting blade.



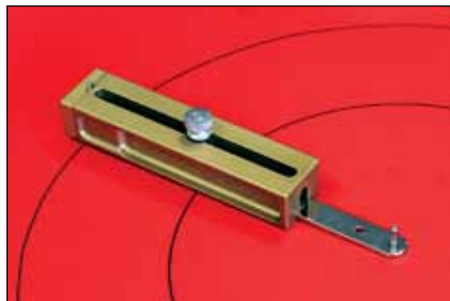
2. Insert thin-headed pivot post through large hole in extension bar, through the cutter block.



3. Use 0"-13" scale on cutter block. The extension bar adds 12" to capacity of block. To cut a 16" outside diameter gasket, match line through pivot post with the number "4" on scale. Secure with knurled nut.



4. To cut gaskets over 25" in diameter, add an additional extension. Use extension bar with stud. Each extension bar adds an additional 12" to capacity of block. Insert stud up through the outer hole on extension already in cutter block. Secure with knurled nut.



5. Place small hole at tip of extension bar over center pin in gasket material ensuring cutter block is lying flat on material.



6. With slight downward pressure on cutter block and material, rotate cutter block clockwise to make cut. For thicker or hard to cut materials, make several passes to make cut. Or cut half way through material, turn over and complete cut.



9. Reset cutter block for bolt holes and cut, or use hole punches to create bolt holes.



6. Reset cutter block for inside diameter dimension and cut as above.

CUTTING SMALL GASKETS, WASHERS OR BOLT HOLES 1/4" TO 2" IN DIAMETER:



1. Insert pivot post with offset pin through cutter block, keeping pin toward blade.



2. Loosen knurled nut and adjust pivot post to desired cutting diameter by matching pivot post indicator line with appropriate dimension of 0"-2" scale. Secure with knurled nut.



3. Place offset pin into pilot hole in gasket material. Insert protruding offset pin into center hole on wooden cutting knob.



4. Hold cutting knob and material steady, with slight pressure, rotate cutter block or cutter knob clockwise to make cut. For thicker or hard to cut materials, make several passes to make cut. Or cut half way through material, turn over and complete cut.



5. Reset cutter block for inside diameter dimension and cut as above.

FOR HELPFUL HINTS AND VIDEO INSTRUCTIONS, VISIT

WWW.ALLPAXCORP.COM

CUTTING DISCS OR DIAPHRAGMS:



1. Cut a cardboard template using cutting procedures as outlined in the sections above.



2. Push disc pin through center hole from bottom of template.



3. Place template on gasket material and push disc pin into gasket to make an indentation.



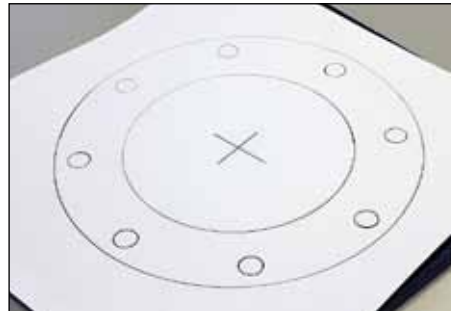
4. Use the disc pin as the pivot post to cut gasket material, as described above. Press down on the cardboard template to secure the gasket material.

USING THE DOVETAIL DESIGNER*:

Use this device when cutting from material smaller than gasket to be cut. More than one piece of gasket material can be used by dovetailing the pieces together.



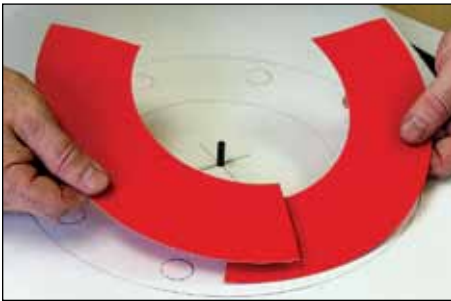
1. There are three dovetail sizes. Centering lines on each of the sizes permits accurate use on any width gasket.



2. On a piece of paper or cardboard, layout OD, ID and bolt holes of desired gasket.



3. From gasket material, cut arcs of gasket material with desired OD and ID.



4. Lay arcs onto template, overlapping each end by at least $5/8$ ". Position overlaps away from bolt-hole locations. As overlaps are made, tape down gasket material to template on either side of overlap.



5. Center dovetails on overlapping material and outline with sharp pencil or awl. Cut along outline with knife or scissors. Top and bottom materials will now have mating dovetails. Tape the dovetail joints together for easy handling.

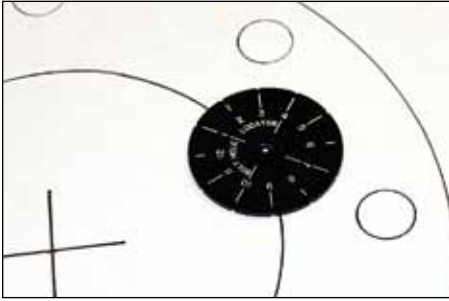


6. If gasket is very wide, design two or more side by side dovetails per joint.

* For gasket material thicker than $1/8$ ", consider using the 3-Piece Dove-tail Punch Kit (AX1855).

USING THE BOLT HOLE LOCATOR:

Use this device to quickly locate bolt hole centers regardless of number of holes or size of gasket.



1. Lay out bolt holes on cardboard, paper or gasket material before gasket is made.



2. From center point of gasket, scribe the bolt hole circle. The gasket cutter can be used as a compass by either holding a pencil against it, or using the cutter blade to create a very shallow cut.



3. Center bolt hole locator over center point using center pin and press down firmly on its non-slip gripping points. It is essential that bolt hole locator does not move in any way.



4. Equally space marks around bolt hole locator for the number of bolt holes to be made. Use the number notches on bolt hole locator for reference. For 4 bolt holes, make marks at 1, 4, 7 and 10. For 8 holes make marks at 1, 4, 7, 10 and directly between 2-3, 5-6, 8-9 and 11-12. For 12 holes make marks at 1 through 12. For 24 holes make marks at 1 through 12 and directly between each number.



5. Place straight edge over two opposite marks and mark bolt hole locations.

FOR HELPFUL HINTS AND VIDEO INSTRUCTIONS, VISIT

WWW.ALLPAXCORP.COM

HEAVY-DUTY GASKET CUTTER PARTS

6000 & 6100 SERIES

PARTS			6000 SERIES STANDARD KITS						6100 SERIES METRIC KITS					REPLACEMENT PART
			AX6000	AX6010	AX6020	AX6030	AX6040	AX6050	AX6100	AX6110	AX6120	AX6130	AX6140	
PRODUCT	PART #	DESCRIPTION												
	AX1600	Standard-Duty Cutting Blades	6	6	6	6	6	6	6	6	6	6	6	6
	AX1601	Heavy-Duty Cutting Blades	6	6	6	6	6	6	6	6	6	6	6	6
	AX1610	Boron Carbide-Coated Cutting Blades	0	0	0	0	0	0	0	0	0	0	0	6
	AX3510	1-3/16" Short Center Pins	1	1	1	1	1	1	1	1	1	1	1	6
	AX3511	1-7/16 Medium Center Pins	1	1	1	1	1	1	1	1	1	1	1	6
	AX3512	1-11/16" Long Center Pins	1	1	1	1	1	1	1	1	1	1	1	6
	AX3513	Disc Pins	1	1	1	1	1	1	1	1	1	1	1	6
	AX1613	Center Pin Ferrule	0	0	0	0	0	0	0	0	0	0	0	1
	AX1615	Post With Offset Pin	1	1	1	1	1	1	1	1	1	1	1	1
	AX1616	Pivot Post	1	1	1	1	1	1	1	1	1	1	1	1
	AX1617	Extension Bar Pivot Post	0	0	1	1	1	1	0	0	1	1	1	1
	AX1618	Knurled Nut For Pivot Post	2	2	3	3	3	3	2	2	3	3	3	1
	AX1619	Knurled Nut For Extension Bar	0	0	0	1	2	0	0	0	1	2	3	1
	AX1620	13"-25" Dia. Extension Bar	0	0	1	1	1	1	0	0	1	1	1	1
	AX1621	> 25" Dia. Extension Bar	0	0	0	1	2	3	0	0	0	1	2	3
	AX1623	Cutter Block Fastener Kit: Contains Hex Key (1), Socket Head Cap Screws (2), Fiber Washers (2)	0	0	0	0	0	0	0	0	0	0	0	1
	AX1628	Cutting Knob	1	1	1	1	1	1	1	1	1	1	1	1
	AX1633	18" x 18" Cutting Board: Center Pin Ferrules (2) installed	0	1	1	1	1	1	0	1	1	1	1	1
	AX1634	24" x 24" Cutting Board: Center Pin Ferrules (2) installed	0	0	0	0	0	0	0	0	0	0	0	1
	AX1640	30" x 30" Cutting Board: Center Pin Ferrules (2) installed	0	0	0	0	0	0	0	0	0	0	0	1
	AX1641	Cutter Block Assembly	1	1	1	1	1	1	0	0	0	0	0	1
	AX1650	Cutter Block Assembly, Metric	0	0	0	0	0	0	1	1	1	1	1	1
	AX1651	Storage Case	1	1	1	1	1	1	1	1	1	1	1	1
	AX3540	Center Pin Handle	1	1	1	1	1	1	1	1	1	1	1	1
	AX5500	Dove Tail Designer Template	1	1	1	1	1	1	1	1	1	1	1	1
	AX5502	Bolt Hole Locator Template	1	1	1	1	1	1	1	1	1	1	1	1