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Edwards AC1047

Edwards Pipe Notcher Dies 1-1/4" Schedule 40 (AC1047) Instruction Manual

Model: AC1047

1. INTRODUCTION

This manual provides essential information for the safe and effective use of the Edwards Pipe Notcher Dies, specifically the 1-1/4" Schedule 40 (AC1047) model. These dies are designed to cut precise saddles in pipes, ensuring a clean fit for welding or joining applications. Proper installation, operation, and maintenance are crucial for optimal performance and longevity of the dies.

2. SAFETY INFORMATION

WARNING: Before using these dies, it is imperative to read and understand all instructions provided in this manual and the instruction manual for your Edwards Pipe Notcher machine. Failure to follow safety guidelines can result in serious injury or damage to equipment.

- **ALWAYS** wear appropriate personal protective equipment (PPE), including safety glasses, when operating equipment with these dies.
- **ENSURE** all safety guards are in place and functioning correctly on your pipe notcher machine before operation.
- Keep hands and loose clothing clear of moving parts during operation.
- Do not attempt to modify the dies or the notcher machine.
- Ensure the workpiece is securely clamped before notching.

3. PRODUCT DESCRIPTION AND COMPONENTS

The Edwards Pipe Notcher Dies (AC1047) are precision-engineered components designed for use with Edwards pipe notching machines. This specific set is for 1-1/4" Schedule 40 pipe. The dies consist of two main parts: an upper die and a lower die, which work in conjunction to create a clean saddle cut.



Figure 3.1: Edwards Pipe Notcher Dies (AC1047). This image displays the two primary components of the Edwards Pipe Notcher Dies. The larger, block-shaped die features a curved cutting surface and a label indicating 'BEFORE USE PLEASE READ INSTRUCTIONS'. The smaller, U-shaped die also has a curved surface and labels with safety warnings and an instruction regarding blade length.

These dies are part of a series available in various sizes, including 1/2", 3/4", 1", 1-1/4", 1-1/2", and 2" for Schedule 40 pipe. Edwards also offers dies for Schedule 80 and custom applications.

4. SETUP AND INSTALLATION

Proper installation of the dies is critical for accurate notching and to prevent damage to the equipment. Refer to your specific Edwards Pipe Notcher machine's manual for detailed installation steps.

1. Ensure the pipe notcher machine is powered off and disconnected from its power source before beginning installation.
2. Carefully insert the upper and lower dies into their respective positions on the notcher machine. Ensure they are seated correctly and securely fastened according to the machine's instructions.
3. **Critical Alignment:** The length of the upper blade over the lower blade should be approximately 1/8 inch. This precise gap is essential for a clean cut and to prevent premature wear on the dies. Adjust the machine's settings as necessary to achieve this alignment.
4. Once installed, manually cycle the machine (if possible and safe to do so) to confirm smooth movement and proper alignment of the dies before connecting power.

5. OPERATING INSTRUCTIONS

These dies are designed to be used with an Edwards Pipe Notcher machine. Always follow the operating

procedures outlined in your machine's manual.

1. Select the correct die size (e.g., 1-1/4" Schedule 40) that matches the pipe you intend to notch.
2. Securely clamp the pipe in the notcher's vise or clamping mechanism. Ensure the pipe is positioned correctly for the desired notch angle and depth.
3. Activate the pipe notcher machine. The dies will engage the pipe, cutting a saddle profile.
4. Once the notching operation is complete, retract the dies and carefully remove the notched pipe.
5. Inspect the notched pipe for cleanliness and accuracy of the cut.

6. MAINTENANCE

Regular maintenance will extend the life of your Edwards Pipe Notcher Dies and ensure consistent performance.

- **Cleaning:** After each use, clean any metal shavings or debris from the dies using a brush or compressed air.
- **Lubrication:** Periodically apply a light coat of machine oil to the cutting surfaces and moving parts of the dies to prevent rust and reduce friction.
- **Inspection:** Regularly inspect the dies for signs of wear, chipping, or damage. Worn dies can lead to poor cut quality and increased strain on the notcher machine. Replace damaged or excessively worn dies promptly.
- **Storage:** Store dies in a clean, dry environment to prevent corrosion when not in use.

7. TROUBLESHOOTING

If you encounter issues with the notching process, consider the following:

- **Poor Cut Quality / Rough Edges:**
 - Check die alignment: Ensure the 1/8 inch gap between the upper and lower blade is maintained.
 - Inspect dies for wear or damage: Replace if necessary.
 - Verify pipe clamping: Ensure the pipe is securely held and not shifting during the cut.
- **Excessive Force Required:**
 - Check for proper lubrication of dies.
 - Ensure the correct die size is being used for the pipe's schedule and diameter.
 - Inspect dies for wear or damage.

For persistent issues, consult the Edwards Pipe Notcher machine's manual or contact Edwards customer support.

8. SPECIFICATIONS

| Attribute | Value |
|--------------|----------------|
| Manufacturer | JPW Industries |
| Part Number | AC1047 |
| Item Weight | 7 pounds |

| Attribute | Value |
|-----------------------|---|
| Package Dimensions | 9 x 5.75 x 0.38 inches |
| Item Model Number | AC1047 |
| Color | Standard |
| Item Package Quantity | 1 |
| Included Components | Edwards Manufacturing - Pipe Notcher Dies 1-1/4" Schedule 40 (AC1047) |
| Batteries Required? | No |
| Date First Available | January 11, 2017 |

9. WARRANTY AND SUPPORT

Specific warranty information for the Edwards Pipe Notcher Dies (AC1047) is not provided within this manual. For details regarding warranty coverage, technical support, or to purchase replacement parts, please contact Edwards Manufacturing directly or visit their official website.

[Visit the Edwards Store on Amazon](#) for more product information and contact details.

Related Documents - AC1047

| | |
|---|--|
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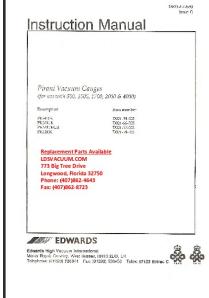
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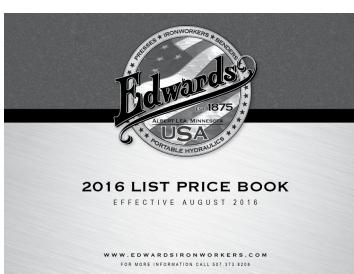
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