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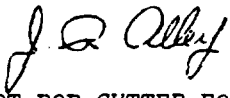
CT-1598

Technical Bulletin

FOR INTERNAL USE ONLY

March 16, 1981

TO: All A/C Technical Bulletin Binder Copyholders

FR: J.R. Alley 

RE: WHEELER PILOT POP CUTTER FOR A/C PIPE
MODEL #5591

Recently, our Research and Development Department at Blue Bell, Pa. conducted tests to evaluate the subject pop cutter for use with A/C Pipe. The cutter used for testing was model #5591 as it is designed for use with A/C pipe up to 24" diameter.

The test results indicate that the model #5591 pop cutter performs satisfactorily on our A/C Sewer and Pressure Pipe. From the data gained through the test program, it can be assumed that the cutter can be used for our entire range of sizes and classes of pipe. The amount of debris caused by the cutting action is very small and air sampling results indicate fiber release is well within the current O.S.H.A. regulations.

At least one cut was made on 6" Class 3300, 8" Class 150, 12" Class 150, 16" Class 3300, 20" Class 150 and 24" Class 2400 pipe. In cutting the sewer (thin wall) pipe, it was necessary to pop twice for each cut taking the slack out of the chain between pops. Cutting pressure pipe was much simpler requiring only one pop. The model #5591 cutter is quite cumbersome when cutting small diameter pipe. There are smaller model cutters available to cut smaller diameter pipe that would make the cutting easier, but these cutters were not tested. After each cut the pipe sections were examined using a magnifying glass and black light magnetic particle inspection and no visual damage or cracking was observed.

Crush tests were conducted on the 6" Class 3300 and 8" Class 150 pipe sections. Hydro burst tests were conducted on the 8" Class 150. Results of the crush and hydro burst tests indicated no loss of strength of the pipe due to the pop cutting process.

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The pop cutting operation was monitored for airborne dust and particle collection to document the exposure created. The fiber count of the air samples taken in the immediate vicinity when cutting 6" sewer pipe and 8" pressure pipe was 0.07 to 0.08 fibers per cubic centimeter which is well within the current O.S.H.A. permissible limit of 2 fibers per cubic centimeter. The weight of the debris from cutting the pipe sections varied from 0.25 to 0.50 grams for the 6" sewer pipe and 0.55 to 1.45 grams for the 8" pressure pipe. This is approximately 1% of the debris that would be generated from a cut using 1/8" abrasive wheel.

The pop cutter is one of the methods of cutting A/C pipe in the ACPFA's "Recommended Work Practices for A/C Pipe" manual.

Attached for your information is a copy of Wheeler's Brochure describing the pop cutters that are available.

Attachment

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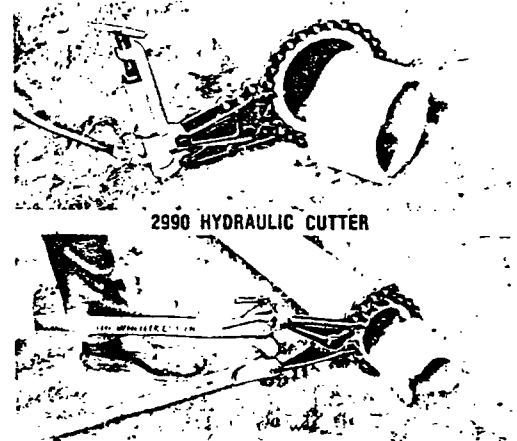
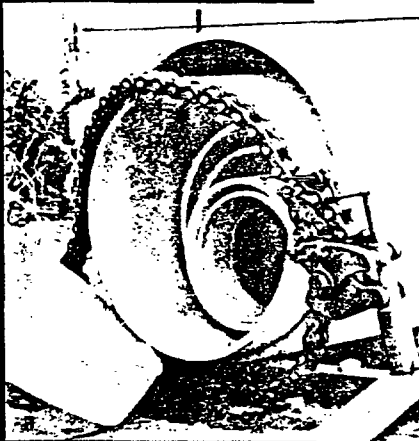
Wheeler PILOT

NATIONAL

Squeeze & Pop!

PIPE CUTTERS

FOR
ASBESTOS-CEMENT, VENT PIPE
AIR DUCT, CONDUIT,
TELEPHONE DUCT, SEWER PIPE
AND PRESSURE PIPE



2990 HYDRAULIC CUTTER

CUTTER

590 MANUAL CUTTER

SNAP CUTS PRODUCE LITTLE ASBESTOS-CEMENT DUST!

CAPACITIES CHART

X—Means tool will cut indicated size of Asbestos-Cement, Vent, Conduit, Air Duct, Telephone Duct, Sewer Pipe.

O—Means tool will cut indicated size of Asbestos-Cement Pressure Pipe.

SIZE OF PIPE	490 or 590 MANUAL	1790	2990	3890	5590	5591
2"	X	X	X			
3"	X	X	X			
4"	XO	XO	XO	XO	XO	XO
5"	XO	XO	XO	X	XO	XO
6"	XO	XO	XO	XO	XO	XO
8"		XO	XO	XO	XO	XO
10"			X	XO	XO	XO
12"			X	XO	XO	XO
14"			X	XO	XO	XO
15"-20"				X	XO	XO
24"					XO	XO
24"-36"				X	X	X

To obtain the exact Model No. for a given job, add the maximum diameter to be cut to the tool number. For example, a 2990-15 has sufficient chain to cut pipe through 15" diameter. A 3890-24 has chain to cut 24" diameter pipe, etc.

BE CERTAIN ALL TOOLS ARE OPERATED UNDER O. S. H. A. STANDARDS. Wear Hard Hat! Never approach pipe cutter head when pressure is applied.

Wheeler PILOT

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Form No. AS20