

ALLPAX® QUICK GUIDE TO PERFECT GASKETS

GETTING STARTED:

1. Determine dimensions of gasket to be cut. Remember to always cut outside diameter first.
2. Locate center of gasket to be cut and mark your material. (A.) Make sure you have enough material to accommodate the complete outside diameter of gasket to be cut.
3. Puncture gasket material with piercing tool or center pin creating a pilot hole. Use care not to enlarge or elongate pilot hole as oversized or oblong pilot holes lead to oblong or eccentric finished gaskets.
4. Loosen cutter head screws at end of the cutter block. (B.)
5. Extend cutting blade slightly beyond thickness of gasket material and re-tighten cutter head screws.

CUTTING GASKETS 1" TO 13" IN DIAMETER:

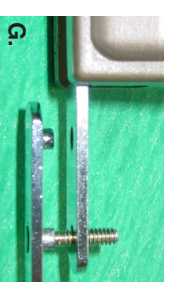
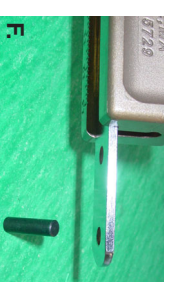
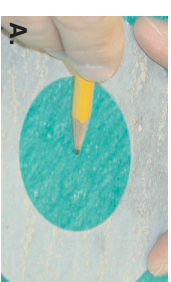
1. Insert thick-headed pivot post without offset pin through cutter block.
2. Use 0 -13 scale on cutter block. Match line through pivot post with desired outside diameter dimension of gasket to be cut on scale. Secure with knurled nut.
3. Place center pin into pilot hole in gasket material. Insert protruding center pin into recessed ferrule in middle of cutting board. (C.)
4. Position pivot post in cutter block over center pin in gasket material (D.) ensuring cutter block is flat on cutting board and material.
5. With slight downward pressure on cutting block and material, rotate cutter block clockwise to make cut.
6. Reset pivot post for inside diameter dimension and cut as above.

CUTTING GASKETS 13" TO 25" 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. (E.) Secure with knurled nut.
4. Place small hole at tip of extension bar over center pin in gasket material (F.) ensuring cutter block is flat on cutting board and material.
5. With slight downward pressure on cutter block and material, rotate cutter block clockwise to make cut.
6. Reset pivot post for inside diameter dimension, and cut as above.

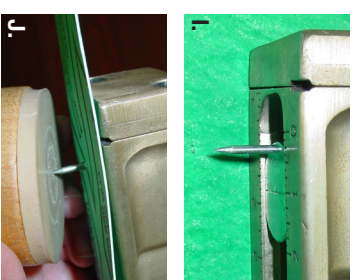
CUTTING GASKETS OVER 25" IN DIAMETER:

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. Each extension bar adds 12 to capacity of block. To cut a 32" outside diameter gasket, match line through pivot post with the number "8" on scale. Secure with knurled nut. Proceed to add an additional extension.
4. To add additional extensions, use extension bar with flush mounted bolt. Insert stud up through the outer hole on extension already in cutter block. (G.) Secure with knurled nut.
5. Follow steps 4 through 6 in above section entitled Cutting Gaskets 13 to 25. (H.)



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

1. Insert pivot post with offset pin through cutter block, keeping pin toward blade.
2. Use 0 -2 scale on cutter block. Match line through pivot post with desired outside diameter dimension of gasket to be cut on the scale. Secure with knurled nut.
3. Place offset pin into pilot hole in gasket material. (1.) Insert protruding offset pin into center of rubber on wooden cutting knob. (J.)
4. Hold cutting knob and material steady, with slight pressure, rotate cutter block clockwise to make cut.
5. Reset pivot post for inside diameter dimension and cut as above.



CUTTING FLANGE BOLT HOLES:

1. Locate center of desired bolt holes and proceed in same manner as cutting small gaskets.

HELPFUL HINTS

- ▶ When cutting thick or dense materials, make several cutting passes, increasing blade depth on successive passes.
 - ▶ For very thick material, in addition to making several, deepening cuts, it is sometimes advisable to turn material over and repeat cuts on reverse side.
 - ▶ For larger diameter cuts, use corner ferrule of the cutting board. Cut a 90 degree arc, rotate block and material counter-clockwise, cut another 90 degree arc, and repeat process until entire gasket is cut.
 - ▶ Many who frequently cut multiple, or large gaskets will insert a ferrule in the top of a worktable, and use the entire table as the cutting board. Using a fiber pad or soft wood workbench surface will prolong blade life.
 - ▶ Store tool with cutting blade recessed in cutter head to enhance blade life and avoid accidents.
 - ▶ Avoid excess pressure on cutting blade and center pins.
 - ▶ Cutting rubber or grabby material is usually made easier by wetting area to be cut with soapy water, or other lubricant.
- Warning: make sure whatever lubricant you use does not adversely affect integrity of gasket material.

Kit Contents

Images Not to Scale	New Part No.	Description	100K13	100K25	100K37	100K49	100K61	100U13
	101X03-1	Cutter Block & Head Assembly	1	1	1	1	1	1
	100H15-1	Cutter Head Screws [pkg of 2]	1	1	1	1	1	1
	100H45K	Regular Cutting Blades [pkg of 6]	1	1	1	1	1	1
	100H47	Pivot Post	1	1	1	1	1	1
	100H47A	Pivot Post For Extension Bar	0	1	1	1	1	0
	100H132	Knurled Nut	2	3	3	3	3	2
	100H132A	Knurled Nut For Extension Bar	0	0	1	2	3	0
	100H164	Fiber Washer	2	3	3	3	3	2
	100P03	1/2" Short Center Pin	1	1	1	1	1	1
	100P04	3/4" Long Center Pin	1	1	1	1	1	1

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	100H19	Center Pin ferrule (Included with 100K018)	2	2	2	2	2	1
	100E012	Extension Bar For 13" - 25" Diameter	0	1	1	1	1	0
	100E024	Extension Bar For Over 25" Diameter	0	0	1	2	3	0
	100K018	Cutting Board 18" x 18"	1	1	1	1	1	0
	1100A118	Fiber Cutting Pad (Included with 100K018)	1	1	1	1	1	0
	100H48	Wooden Cutting Knob	1	1	1	1	1	1
	100H47B	Post With Offset Pin	1	1	1	1	1	1
	100A20	Piercing Tool	1	1	1	1	1	1
	100A21-1	Hex Key	1	1	1	1	1	1