

PC3110 Cut and Mark Tool



WARNING 

 WARNING



- Failure to follow instructions and warnings could result in death, serious personal injury, property damage, and/or product damage.
- Before operating or servicing any pipe preparation tools, read all instructions in this manual and all warning labels on the tool.
 - Wear safety glasses, hardhat, foot protection, and hearing protection while working around this tool.
 - Save this operating and maintenance manual in a place accessible to all operators of the tool.

If you need additional copies of any literature, or if you have questions concerning the safe and proper operation of this tool, contact Victaulic, P.O. Box 31, Easton, PA 18044-0031, Phone: 1-800-PICK-VIC, E-Mail: pickvic@victaulic.com.

Original Instructions



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HAZARD IDENTIFICATION

Definitions for identifying the various hazard levels are provided below.



This safety alert symbol indicates important safety messages. When you see this symbol, be alert to the possibility of personal injury.

Carefully read and fully understand the message that follows.

DANGER

- The use of the word “DANGER” identifies an immediate hazard with a likelihood of death or serious personal injury if instructions, including recommended precautions, are not followed.

WARNING

- The use of the word “WARNING” identifies the presence of hazards or unsafe practices that could result in death or serious personal injury if instructions, including recommended precautions, are not followed.

CAUTION

- The use of the word “CAUTION” identifies possible hazards or unsafe practices that could result in personal injury and product or property damage if instructions, including recommended precautions, are not followed.

NOTICE

- The use of the word “NOTICE” identifies special instructions that are important but not related to hazards.

OPERATOR SAFETY INSTRUCTIONS

The PC3110 Cut and Mark Tool is designed to be used, in conjunction with a power drive, for the sole purpose of preparing plain-end pipe for joining. These instructions, in addition to the instructions provided by the power drive manufacturer, must be read and understood by each operator PRIOR to working with the tool. These instructions describe safe operation of the tool, including set up and maintenance. Each operator must become familiar with the tool's operations, applications, and limitations. Particular care should be given to reading and understanding the dangers, warnings, and cautions described throughout these operating instructions.

Use of this tool requires dexterity and mechanical skills, as well as sound safety habits. Although these tools are designed and manufactured for safe, dependable operation, it is difficult to anticipate all combinations of circumstances that could result in an accident. The following instructions are recommended for safe operation of this tool. The operator is cautioned to always practice “safety first” during each phase of use, including set up and maintenance. It is the responsibility of the lessee or user of this tool to ensure that all operators read this manual and fully understand the operation of this tool.

Store this manual in a clean, dry area where it is always readily available. Additional copies of this manual are available upon request through Victaulic, or can be downloaded at victaulic.com.

DANGER

1. **Avoid using the tool in potentially dangerous environments.** Do not expose the tool to rain, and do not use the tool in damp or wet locations. Do not use the tool on sloped or uneven surfaces. Keep the work area well lit. Allow sufficient space to operate the tool properly.

2. **Ground the power drive to protect the operator from electric shock.** Verify that the power drive is connected to an internally grounded electrical source.
3. **Disconnect the power cord from the electrical source before servicing the tool.** Only authorized personnel should perform maintenance on the tool. Always disconnect the power cord from the electrical source before servicing or adjusting the tool.

 **WARNING**

1. **Prevent back injury.** Always use proper lifting techniques when handling tool components.
2. **Wear proper apparel.** Do not wear loose clothing, gloves, jewelry, or anything that can become entangled in moving parts.
3. **Wear protective items when working with tools.** Always wear safety glasses, hardhat, and foot protection.
4. **Keep hands and tools away from the power drive chuck and carriage edges during operation.** Rotation of the power drive can pinch or entangle fingers and hands.
5. **Do not reach inside pipe ends during tool operation.** Pipe edges can be sharp and can snag hands and shirt sleeves.
6. **Operate the tool only with a safety foot switch.** The power drive must be operated with a safety foot switch that is located for easy operator access. Never reach across moving parts.
7. **Do not over-reach.** Maintain proper balance at all times. Ensure that the safety foot switch is easily accessible to the operator.
8. **Do not make any modifications to the tool.** Do not remove any safety guarding or any components that would affect tool performance.

 **CAUTION**

1. **The PC3110 tool is designed ONLY for preparing pipe sizes, materials, and wall thicknesses as designated.**
2. **Inspect the equipment.** Before using the tool, check moveable parts for obstructions. Ensure that tool components are installed and adjusted in accordance with setup instructions. Ensure that tool components are stable and secure.
3. **Stay alert.** Do not operate the tool if you are drowsy from medication or fatigue.
4. **Keep visitors, trainees, and observers away from the immediate work area.** All visitors should be kept a safe distance from the equipment at all times.
5. **Keep work areas clean.** Keep the work area around the tool clear of any obstructions that could limit movement of the operator. Clean up any spills on the floor to prevent slips or falls.
6. **Secure the work, tool, and accessories.** Ensure that the tool is stable. Refer to the “Tool Setup” section.
7. **Support the work.** Support long pipe lengths with a pipe stand.
8. **Do not force the tool.** Do not force the tool or accessories to perform any functions beyond the capabilities described in these instructions. Do not overload the tool.
9. **Maintain tool with care.** Keep the tool clean to ensure proper and safe performance. Follow the instructions for matching and lubricating tool components, if applicable.
10. **Use only Victaulic replacement parts and accessories.** Use of any other parts may result in a voided warranty, improper operation, and hazardous situations. Refer to the “Parts Ordering Information” section.
11. **Do not remove any labels from the tool.** Replace any damaged or worn labels.

INTRODUCTION

NOTICE

- Drawings and/or pictures in this manual may be exaggerated for clarity.
- The tool, along with this operating and maintenance instructions manual, contains trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic Company.

The Victaulic PC3110 Cut and Mark Tool is a portable tool used in conjunction with a power drive for preparing plain-end pipe to be joined with Victaulic Installation-Ready™ products. The standard PC3110 tool is equipped to cut and mark ½ – 2 inch Schedule 10 through Schedule 80 carbon steel pipe.



CAUTION

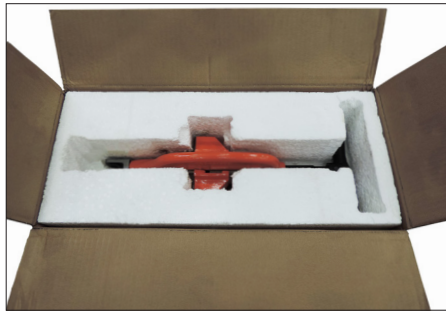
- This tool must be used **ONLY** for preparing pipe with specifications that fall within the designated parameters.

Failure to follow this instruction could overload the tool, resulting in reduced tool life, tool damage, or personal injury.

RECEIVING THE TOOL

PC3110 tools are packed individually in cardboard boxes. Upon receipt of the tool, ensure that all necessary parts are included. If any parts are missing, contact Victaulic.

CONTAINER CONTENTS



Qty.	Description
1	PC3110 Cut and Mark Tool
1	Hinge Pin
5	Cutting Wheel
2	Operating and Maintenance Instructions Manual

RETURNING THE TOOL

Prepare tool for shipment as received. Contact Victaulic with questions.

POWER REQUIREMENTS

DANGER

- To reduce the risk of electric shock, check the electrical source for proper grounding.**
- Before performing any maintenance on the tool, disconnect the power cord from the electrical source.**

Failure to follow these instructions could result in death or serious personal injury.

POWER DRIVE REQUIREMENTS

The PC3110 tool is designed for operation with a power drive. Read and understand the operation of the power drive by referring to the manual provided by the manufacturer.

Power must be supplied to the drive motor through a safety foot switch to ensure safe operation. Ensure that the power drive is grounded properly in accordance with Article 250 of the National Electrical Code and all applicable local electrical codes.

If an extension cord is required, refer to the “Extension Cord Requirements” section that follows for cord sizes.

EXTENSION CORD REQUIREMENTS

When pre-wired outlets are not available and an extension cord must be used, it is important to use the proper cord size (i.e. Conductor Size American Wire Gauge). Cord size selection is based upon tool rating (amps) and cord length (feet). Use of a cord size (gauge) thinner than required will cause significant voltage drop at the drive motor while the tool is operating. Voltage drops may cause damage to the drive motor and can result in improper tool operation. **NOTE:** It is acceptable to use a cord size that is thicker than required.

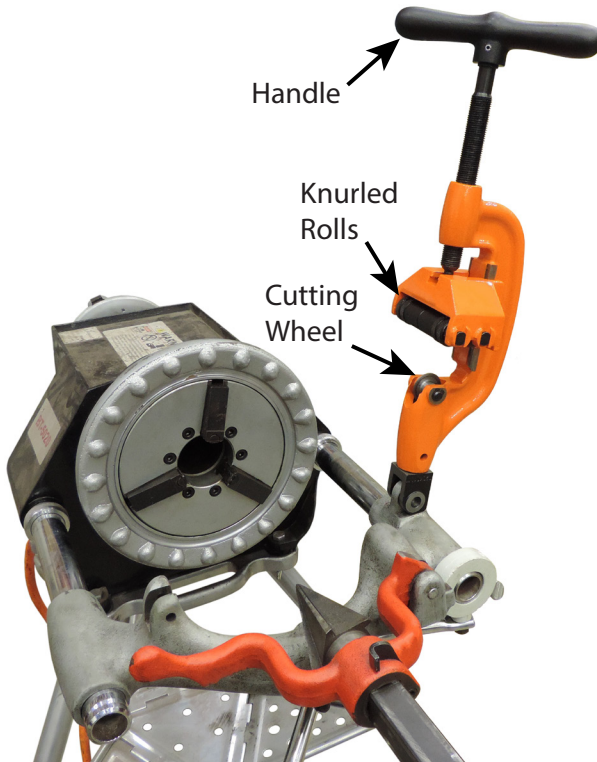
The required cord sizes for cord lengths up to and including 100 ft/31 m are listed in the table below. Use of extension cords longer than 100 ft/31 m must be avoided.

Drive Motor Rating volts/amps	Cord Lengths feet/meters		
	25 8	50 15	100 31
115 15	12 gauge	12 gauge	10 gauge

TOOL NOMENCLATURE

NOTICE

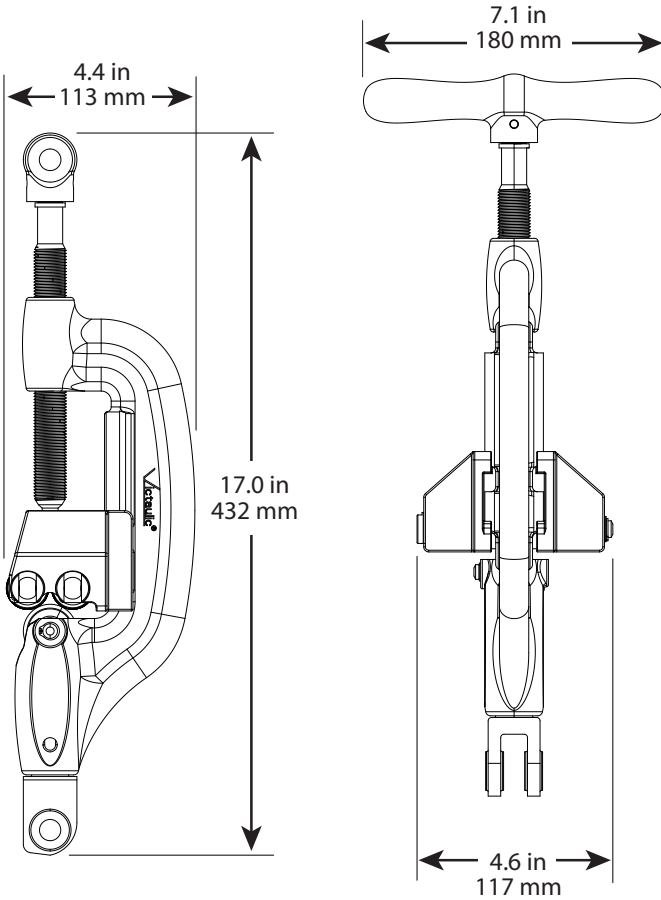
- Drawings and/or pictures in this manual may be exaggerated for clarity.
- The tool, along with this operating and maintenance instructions manual, contains trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic.



IMPORTANT INFORMATION LABELS PROVIDED ON THE TOOL



TOOL DIMENSIONS AND SPECIFICATIONS



Tool weight is 10.3 pounds/4.7 kilograms. Tool weight includes the tool head assembly only.

PIPE SETUP

For proper tool operation and production of pipe ends that are within Victaulic specifications, the following guidelines must be followed.

1. Victaulic requires square-cut pipe for use with plain-end pipe products.
2. Raised external weld beads, seams, and burrs must be ground flush with the pipe surface 2 inches/50 mm back from the pipe ends.
3. All coarse scale, dirt, and other foreign material must be removed from the interior and exterior surfaces of the pipe ends.

CAUTION

- For maximum tool life, remove foreign material from the interior and exterior surfaces of the pipe ends.

Foreign material may interfere with or damage the tool, resulting in property damage or personal injury.

4. Place pipe stands at locations appropriate for the length of pipe to be cut.

NOTICE

- The pipe must extend a minimum of 5 inches/127 mm from the front of the chuck for proper tool operation.
- When marking pipe long enough to extend into the rear chuck of the power drive, tighten the rear chuck to center the pipe length.
- When marking pipe 3 feet/0.9 meters or longer, a pipe stand must be used to support the pipe.



5. Insert the pipe into the power drive and tighten the chuck at the proper pipe length.

While holding the pipe with one hand, use the other hand to firmly pull the power drive hand wheel in a counterclockwise motion until the chuck securely grips the pipe.

DRIVE SETUP



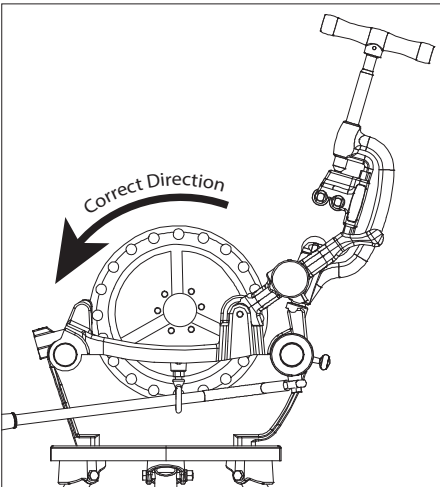
1. Plug the power drive cord into a safety foot switch, as shown above. Refer to the power drive manufacturer's operating manual for additional information.
2. Place the safety foot switch on the same side of the tool as the power drive switch, with adequate clearance for ease of use and to avoid a tripping hazard.

⚠ WARNING

- The power drive must be operated with a safety foot switch.

Operating the tool without a safety foot switch could result in serious personal injury.

3. Turn the switch on the side of the power drive to FWD (forward).



4. Depress the safety foot switch. Ensure that the pipe rotates counterclockwise when viewed from the front power drive chuck. Remove foot from the safety foot switch.

If the pipe rotates clockwise when viewed from the front power drive chuck, return to the previous step and verify the direction of the power drive.

TOOL SETUP

⚠ WARNING

- Always use proper lifting techniques when handling the tool.

Failure to follow this instruction could result in personal injury.



1. Place the cutter over the bracket on the carriage assembly.



2. Insert the hinge pin into the bracket slot.



3. Using a hammer or mallet, gently tap the hinge pin into the bracket slot until it is secure. Do not force the hinge pin farther into the slot than is necessary to secure the tool.

CUTTING OPERATION

DANGER



- To reduce the risk of electric shock, check the electrical source for proper grounding.

- Before operating the tool, review the “Operator Safety Instructions” section of this manual.

Failure to follow these instructions could result in death or serious personal injury.

CAUTION

- This tool must be used **ONLY** for preparing pipe as designated.

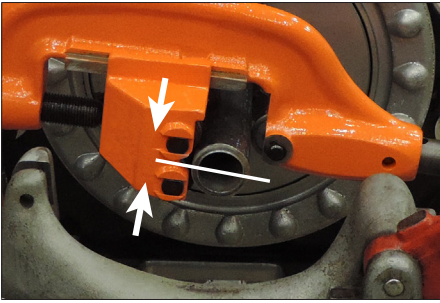
Failure to follow this instruction could overload the tool, resulting in reduced tool life, damage to the tool, or personal injury.

Before proceeding, ensure that all instructions in the previous sections of this manual have been followed.

Prepare for pipe ends and cut lengths of pipe to fall during the cutting operation. Ensure that these cuttings do not interfere with operator movement.



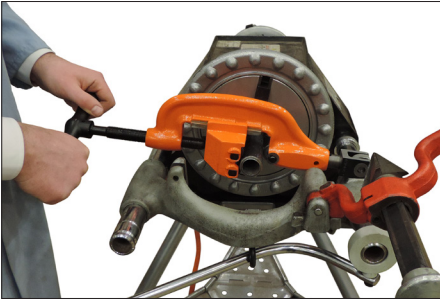
1. Using the handle, bring the cutter down over the pipe end.



2. Ensure that the two knurled rolls are centered on the pipe.



4. Using the handle, lift the cutter back to its storage position.



3. Depress the safety foot switch to start the power drive, then turn the handle of the cutter in a steady motion until the pipe end is cut and falls off. Remove foot from the safety foot switch.



5. Inspect the finished pipe end. Ensure that the knurling is clearly defined and is consistent around the entire OD of the pipe.

STORAGE OPERATION

If the cut and mark tool will be stored on the carriage assembly when not in use, it can be rotated to provide additional room for alternate carriage accessories.



1. To turn the cutter for carriage storage, lift the body of the cutter away from the shaft.



2. Twist the body of the cutter 90 degrees counterclockwise so that the knurled rolls face the front of the carriage, then lower the body of the cutter back down towards the shaft.

MAINTENANCE

⚠ DANGER	
	<ul style="list-style-type: none"> • Before performing any maintenance on the tool, disconnect the power cord from the electrical source. <p>Failure to follow this instruction could result in death or serious personal injury.</p>

This section provides information about keeping the tool in proper operating condition. Replacement parts must be ordered from Victaulic to ensure proper and safe operation of the tool. See the “Accessories” section for replacement part kits.

The tool must be cleaned after use to remove dust and debris from all components. Pay particular attention to the knurled rolls, where debris can build up and interfere with pipe marking. If any debris is visible on the knurled rolls, clear away the material with a wire brush.

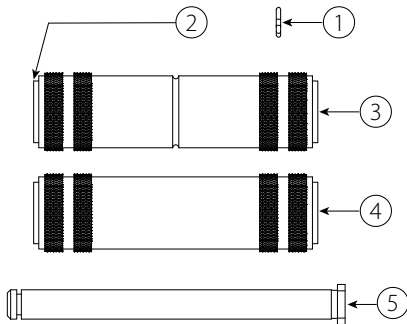
PARTS ORDERING INFORMATION

When ordering parts, the following information is required for Victaulic to process the order and send the correct part(s). Parts can be ordered by calling 1-800-PICK-VIC.

1. Tool Model Number
2. Tool Serial Number
3. Quantity, Item Number, Part Number, and Description
4. Where to send the part(s) – Company Name and Address
5. To whose attention to send the part(s) – Person’s Name
6. Purchase Order Number
7. Billing Address

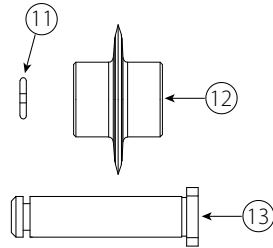
ACCESSORIES

KNURLED ROLLS KIT



Item No.	Part No.	Qty.	Description
1	R000311KRL	2	C Clip
2		4	Bushing
3		1	Knurled Roll with Line Takeout
4		1	Knurled Roll
5		2	Roll Shaft

CUTTING WHEEL KIT



Item No.	Part No.	Qty.	Description
11	R000311CWL	1	C Clip
12		1	Cutting Wheel
13		1	Cutting Wheel Shaft

CUTTING WHEELS

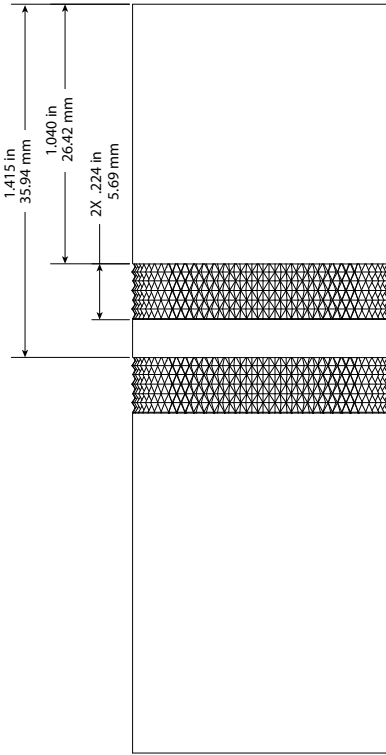
Item No.	Part No.	Qty.	Description
12	R000311WHL	5	Cutting Wheel

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
Pipe stops rotating during pipe preparation.	Pipe is slipping in the power drive chuck.	Securely tighten the power drive chuck.
	The circuit breaker/GFI has tripped or a fuse has blown out on the electrical circuit that supplies the power drive.	Test/reset the jobsite GFI/breaker, or replace the fuse. Upon restoration of power, resume pipe preparation.
	Facility has lost power.	Upon restoration of facility power, resume pipe preparation.
Tool will not cut pipe.	Tool is not fully pushed onto the pipe.	Push the tool all the way onto the pipe.
	Pipe does not extend far enough out of the chuck.	Rechuck pipe so that the end to be prepared extends a minimum of 5 inches/127 mm past the edge of the chuck.
	Knurled rolls are not centered on pipe.	Center knurled rolls on the pipe.
	Cutting wheel is dull.	Replace cutting wheel.
Pipe markings are not clearly defined.	Knurling on rolls is filled with debris.	Clean knurling surface with a wire brush.
	Knurled rolls are worn.	Replace knurled rolls.

In the event of tool malfunction outside the scope of the troubleshooting section, contact Victaulic for assistance.

KNURLING/MARKING SPECIFICATIONS PLAIN-END IR FOR STEEL PIPE



1/2 inch – 1 1/4 inch insertion depth aligns with the first knurling

1 1/2 inch – 2 inch insertion depth aligns with the second knurling

EC DECLARATION OF INCORPORATION

In Accordance with the Machinery Directive 2006/42/EC

Victaulic Company, headquartered at 4901 Kesslersville Road, Easton, PA 18040, USA, hereby declares that the machinery listed below complies with the essential safety requirements of the Machinery Directive, 2006/42/EC.

Product Model:	PC3110	
Serial No. :	Refer to Machinery Nameplate	
Product Description:	Portable pipe cutting and marking tool	
Conformity Assessment:	2006/42/EC, Annex I	
Technical Documentation:	The relevant technical documentation prepared in accordance with Annex VII (B) of the Machinery Directive 2006/42/EC, will be made available upon request to the governing authorities.	
Compatible Power Drives:	When installed with the following power drive unit, having an appropriate EC Declaration of Conformity in accordance with Annex II (A) of the Directive 2006/42/EC, the PC3110 model listed above may be commissioned for the full intended purpose: <table border="1"><tr><td>Ridgid 300</td></tr></table>	Ridgid 300
Ridgid 300		
Authorized Representative:	Victaulic Company c/o Victaulic Europe BVBA Prijkelstraat 36 9810, Nazareth Belgium	

Signed for and on behalf of Victaulic Company,



Mr. Len R. Swantek
Director – Global Regulatory Compliance
Machinery Manufacturer Representative

Place of Issue: Easton, Pennsylvania, USA

Date of Issue: April 24, 2018

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UPDATED 04/2018

TM-PC3110 11646 REV B RM00PC3110

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