



CustomCrimp HS-150, HS-300 & HS-500 Hose Saws





CustomCrimp® HS Models

The HS150 (1 HP) saw is capable of cutting up to 1-1/4 inch 4 wire hose and up to 1 inch 6 wire hose.

The HS300 (3 HP) saw is capable of cutting up to 1-1/4 inch 6 wire or 2 inch 2 wire hose.

The HS500 (5 HP) saw is capable of cutting up to 2 inch 6 wire hose with the serrated blade installed.

Installation

Mount the saw on a sturdy workbench.

The HS150 Hose Saw is only available in 110V single phase configuration.

For the HS300 and HS500 Saws:

Make certain that the electric service is correct for the saw. The HS 300 and HS 500 saws are available in:

3 HP and 5 HP 220 Volt Single Phase

3 HP and 5 HP 220 Volt 3 Phase

3 HP and 5 HP 480 Volt 3 Phase

Check the blade rotation. The top of the blade should rotate towards the front of the saw. If rotation is not correct on a 3 phase saw, reverse any two of the hot wires.

Always wear safety Glasses

Allow the blade to reach full speed before starting a cut

Periodically examine the blade for cracks and/or broken teeth.

Replace if necessary.

Do not remove or defeat any of the guards or safety features of the saw

Mister Installation (Optional)

A Mister Kit (P/N 103172) is available for both the HS 300 and HS 500 Hose Saws. The mister sprays a fine mist of air tool oil on the saw blade for longer blade life and cleaner cuts. Adjust the air pressure and flow control to spray a fine mist on the blade. Addition of a mister kit will give smoother, cleaner cuts and prolong blade life.

Refer to pages 5 and 6 for installation and setup of the Mister Kit.

Hose Channel System (Optional)

A Hose Channel System (P/N 103073) is available in 5 foot sections for the HS300 & HS500 models. The Hose Channel System both measures and supports the hoses up to 2 inch diameter as they are being cut.

Hose Helper (Standard on HS300 & HS500)

A "Hose Helper" attachment for the HS300& HS500 prevents the hose from being drawn back during a cut and gives the operator the ability to more precisely control the cut length. The "Hose Helper" can be mounted on either end of the saw.

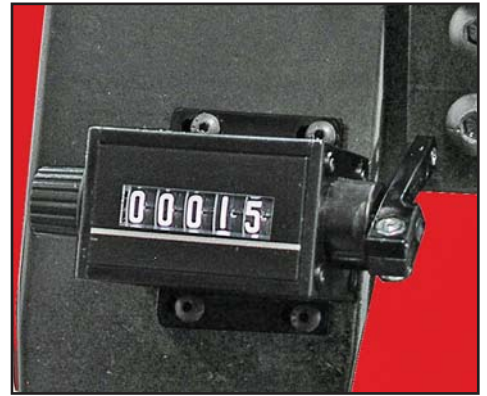
Coolant Flow Adjust

Air Flow Adjust



Counter (HS300 & HS500 Models only)

A resettable counter makes it easy to keep track of the number of cuts made.



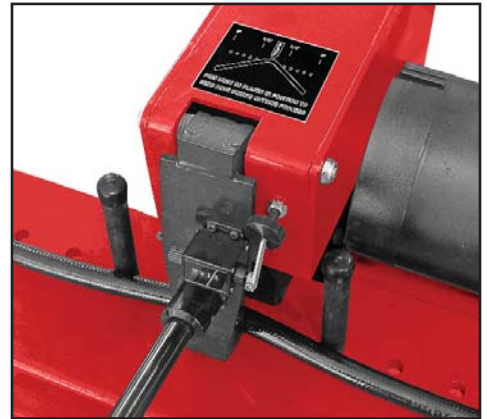
Hose Bending Pins

Hose Bending Pins prevent the blade from binding during a cut.

Pins should be positioned in the holes in the saw table such that the hose opens slightly during the cut. Spread the pins further apart for larger hoses.

The hose should begin to bend before contacting the blade. This will increase blade life and keep the hose from tearing and deforming.

Apply steady downward pressure on the handle in order to force the hose into the blade. Do not apply enough force to stall the blade, and ease up on the pressure before the blade completes the cut. This will keep from separating the wires as the blade exits the hose.



Blade Choice

Two blades are available. Choose the correct blade for the type of hose being cut.

Note: New blades must be properly conditioned to assure long life and clean cuts. For the first ten cuts, feed the blade slowly through a medium size hose. This will properly break in and condition the blade for long life.

Double Bevel Blade with SS Slots

The double bevel smooth blade (P/N 104050) is recommended for braided hose and will give minimal debris in the cut hose.

NOTE: PAY CLOSE ATTENTION TO THE DIRECTION OF ROTATION MARKED ON THE BLADE. IT IS THE OPPOSITE OF MOST BLADES OF THIS TYPE.



Scalloped Blade (General Purpose)

The scalloped blade (P/N 104034) is recommended for all spiral hose.

Note: The edges of the blade may appear to be dull. This does not mean that the blade is not effective. As long as the blade is still giving clean cuts, do not replace the blade.

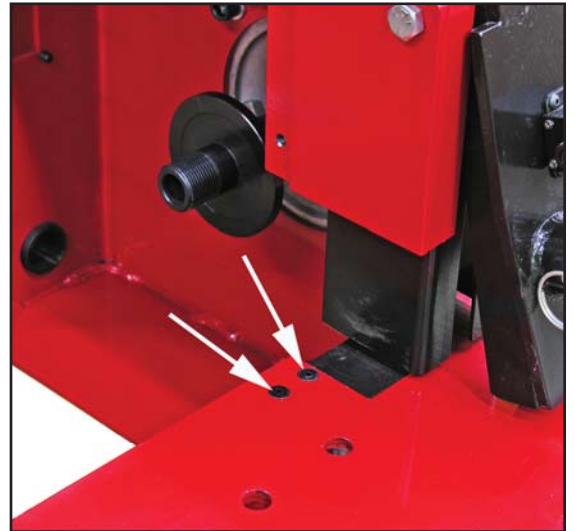




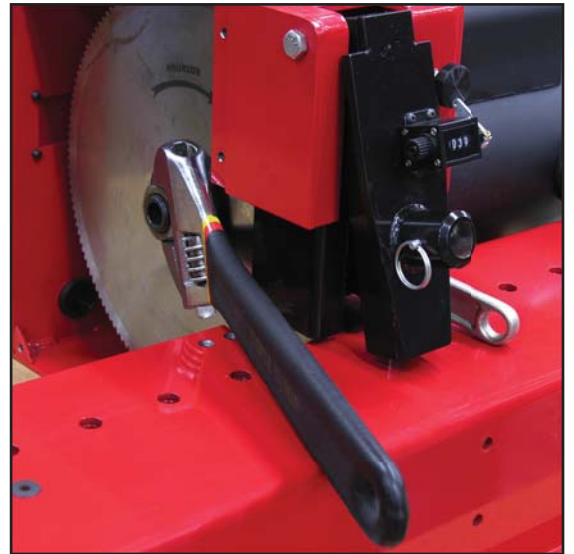
Change Saw Blade

Remove the 5 screws holding the Side cover in place and remove the side cover.

Remove the 2 No 10-24 screws holding the black Saw Blade Access Panel in place and remove the insert in order to provide clearance to remove the blade.

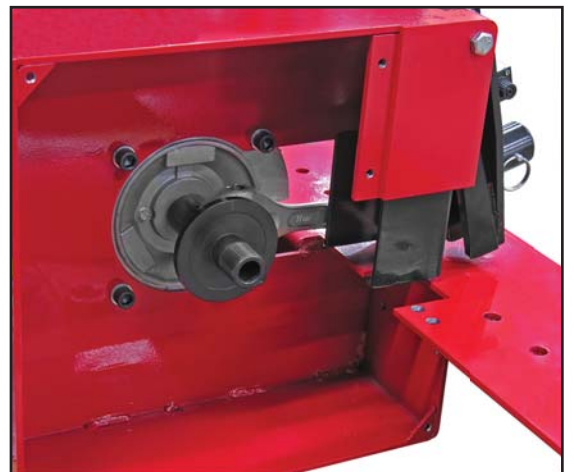


Hold the arbor in place with a wrench and remove the nut holding the saw blade. There are wrench flats on the arbor behind the blade. ***(Note that this is a left handed nut).***



When replacing a blade, if the blade has a rotation arrow, make certain that the blade is mounted so that it rotates in the direction of the arrow.

Replace the Saw Blade Access Panel insert and the Side Cover.



**DO NOT OPERATE THE SAW WITHOUT
ALL OF THE GUARDS IN PLACE**

Insert Vacuum Adaptor

Optional 1 ¼" Vacuum Port located on rear of hose saw.

NOTE: Do not recommend using at the same time as Mister.

Remove Plastic Plug (A).



Insert supplied 1 ¼" Vacuum Adaptor (B)
(for 2 ½" shop vac, or vacuum accessories).

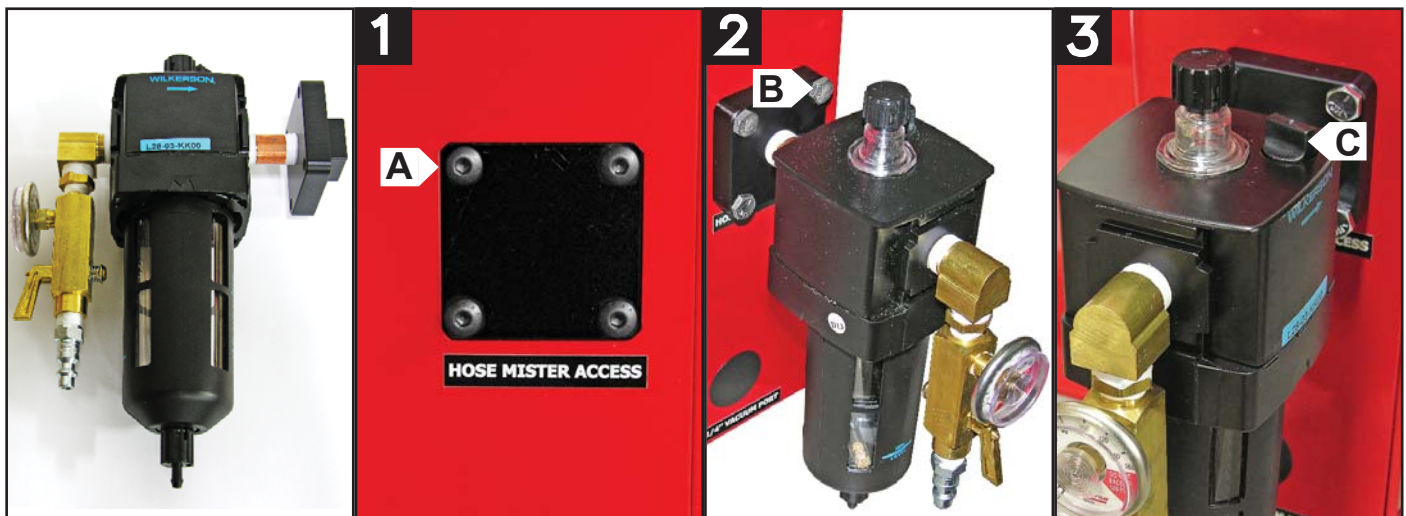


Run vacuum during cutting process.





Installation and Set Up of the HS-300 / HS-500 Mister Kit



Full Assembly
P/N: 103172

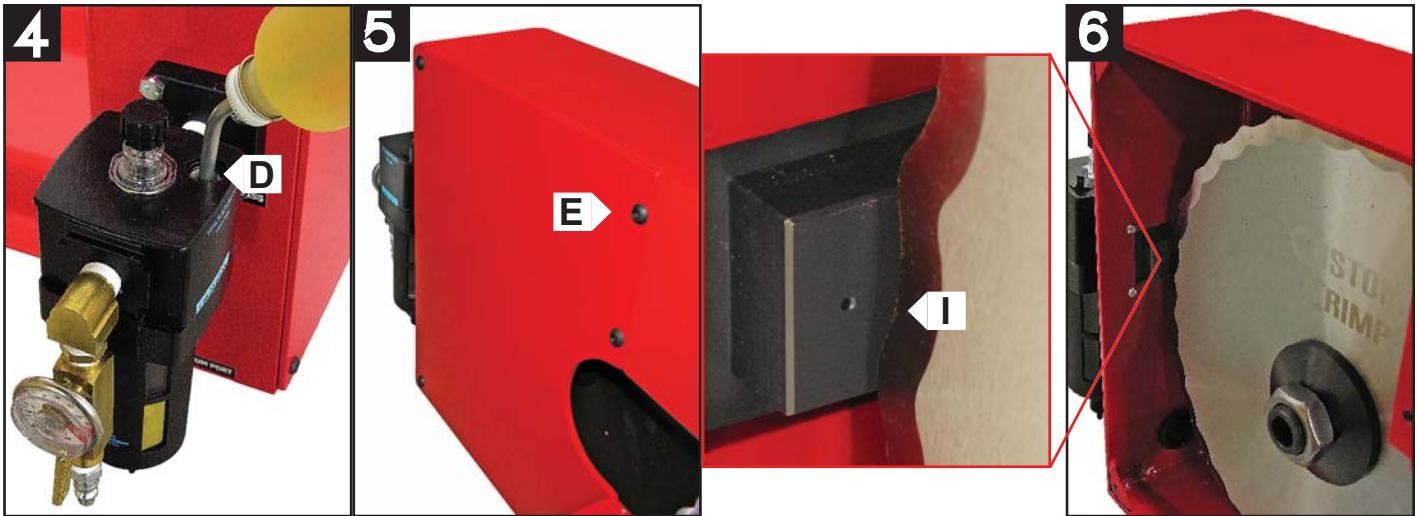
The following procedures can be used to install the Mister Kit on the HS 300 and HS 500 models of Custom Crimp® Hose Saws.

Remove the HS-300 / HS-500 Mister Kit from its packaging and verify that all components are properly installed and all fittings are securely tightened as shown above, and then follow the steps below to install the Mister Kit Lubricator.

Step 1. Unplug hose saw. Remove the bolts and black cover from the Hose Mister Access (A).

Step 2. Insert the Hose Manifold Mister into the Hose Mister Access, and secure it with the 1/4 - 20 x 3/4" Hex Bolts provided (B).

Step 3. Remove the Fill Plug located on the top of the Mister Lubricator (C).



Step 4. Pour 1 bottle of 4 oz of mister oil into the fill port (D). Then thread the Fill Plug back in. 2 bottles of 4 oz of mister oil are included, please note reservoir only holds 4 oz (Mister Oil part number P/N: 104156).

Once the Mister Lubricator has been installed follow the steps below to adjust the air pressure and oil drops:

Step 5. Make sure hose saw is still unplugged, and remove side panel (E) (5 screws) and follow the steps below:

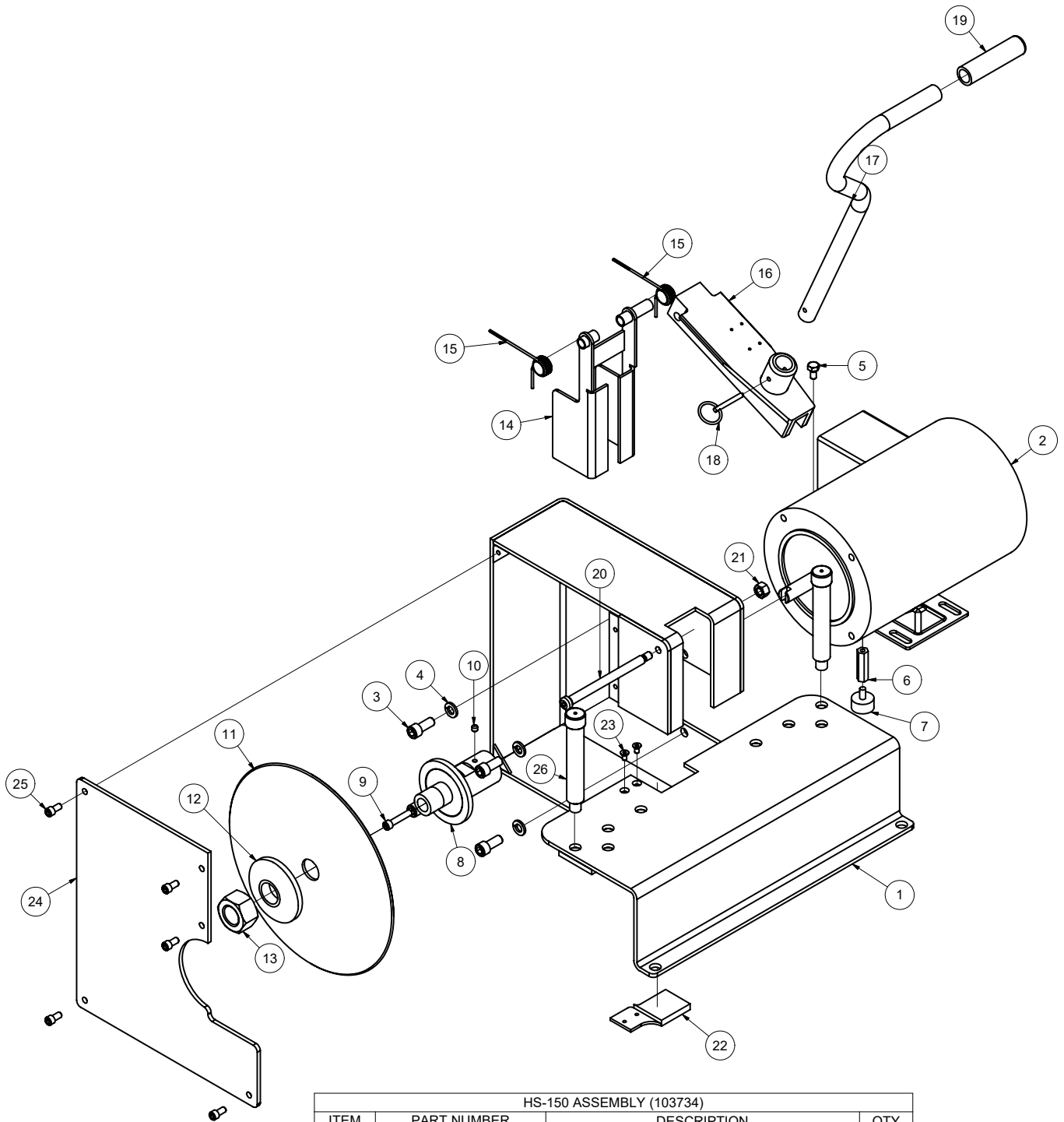
1. Connect air line using quick connect (F)
2. Set air pressure by adjusting valve on the air regulator (G)
3. Adjust the oil drops (H) so that after approximately 10 seconds you see a small film appear onto the hose saw blade (I).

Note: If the sound of the air going against the blade is too loud, reduce the air pressure and increase the oil drop. Adjust the air pressure to a more comfortable level, then verify that you are getting your small film coverage in approximately 10 seconds.

4. When the hose saw is not in use you can turn off the mister by either option:
 - a. Un-hook the air disconnect (this allows you not to have to adjust the air pressure each time).
 - b. Turn off the air regulator (If you use this option we recommend making a mark on your air pressure gage to show what the desired setting is for quick setup).
5. Place the side panel and bolts back on the hose saw.

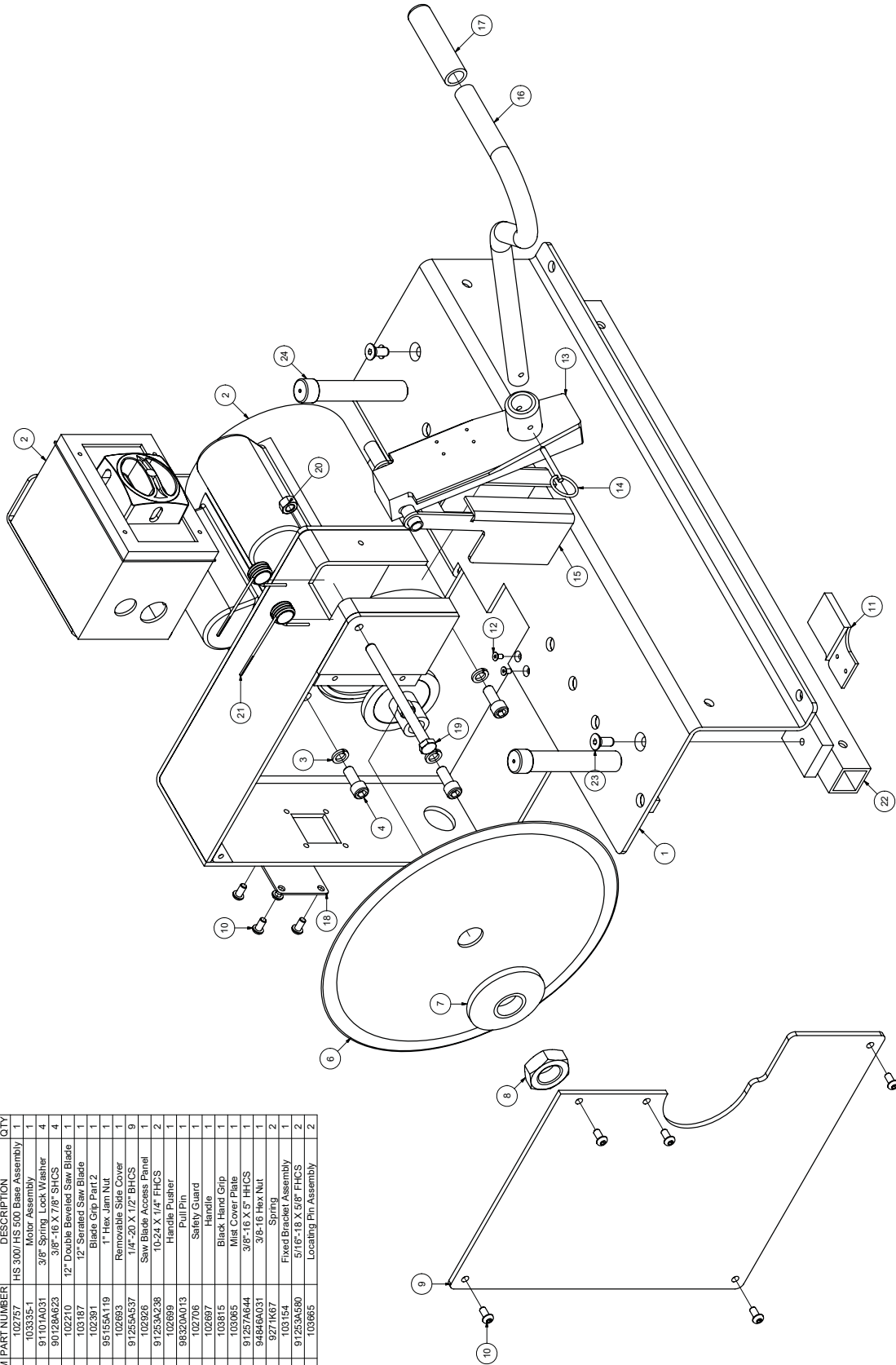


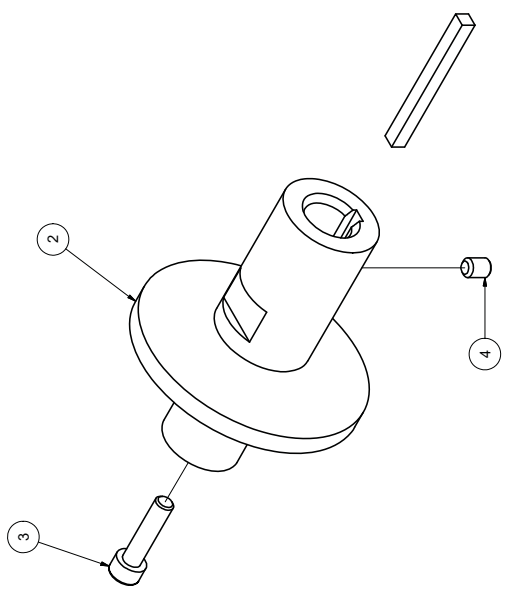
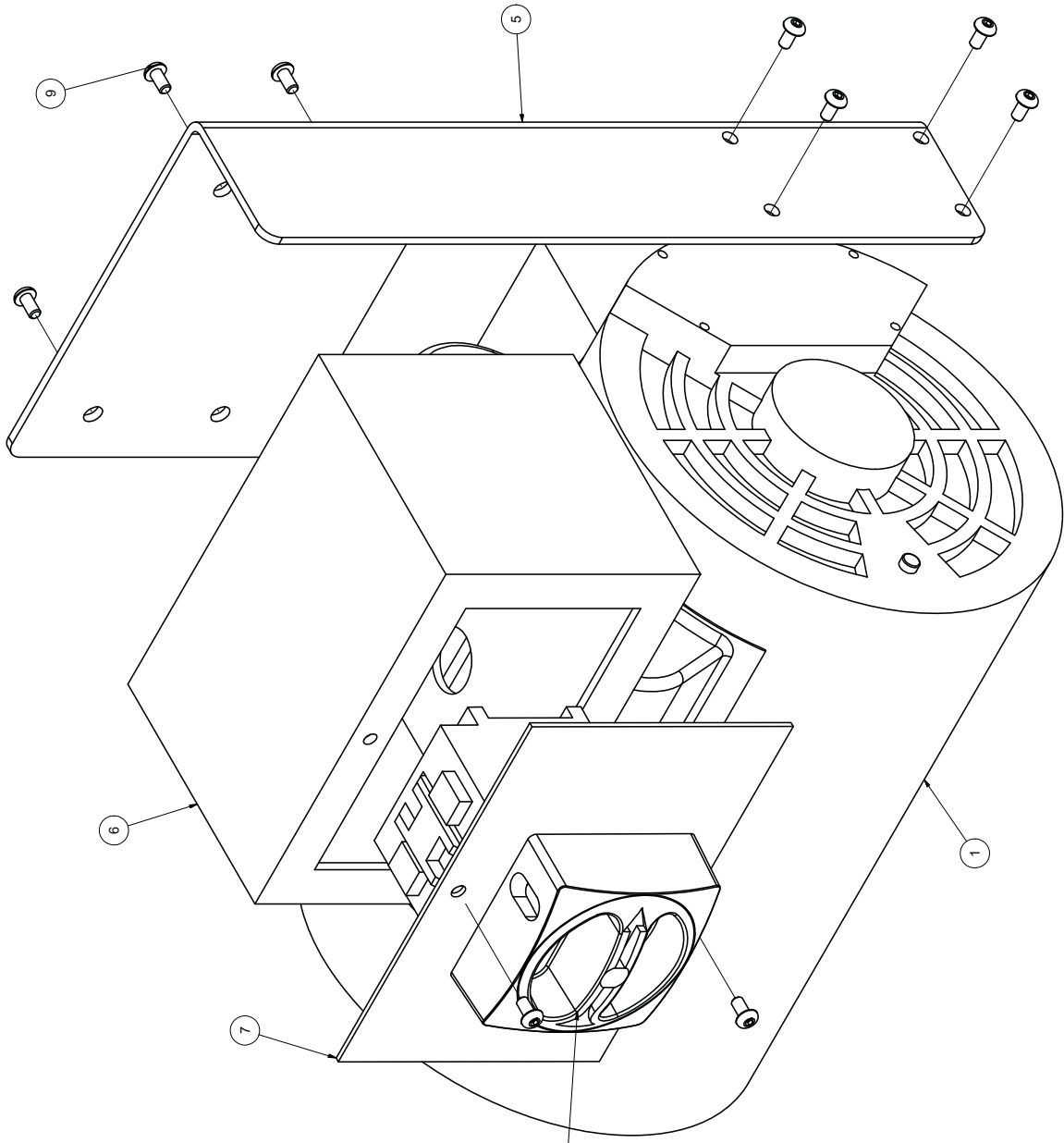
The installation and setup of the Mister Kit have been completed.



HS-150 ASSEMBLY (103734)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103454	HS150 BASE ASSEMBLY	1
2	103814	1 HP 110V 3600RPM MOTOR	1
3	91251A623	3/8-16 X 7/8 SHCS	4
4	91101A031	3/8 LOCK WASHER	4
5	92620A537	1/4-20 X 1/2 HHS	1
6	92230A330	1/4-20 X 1-1/2" HEX STANDOFF	1
7	103774	1/4-20 RUBBER VIBRATION FOOT	1
8	103127	HS-150/300/500 5/8" MOTOR SHAFT ARBOR	1
9	91251A544	1/4-20 X 1 1/4 SHCS	1
10	91375A533	1/4-20 X 1/4 SET SCREW	1
11	103502	10 INCH SERRATED BLADE	1
12	102391	HS-150/300/500 BLADE GRIP	1
13	90083A260	1/14 LEFT HAND JAM NUT	1

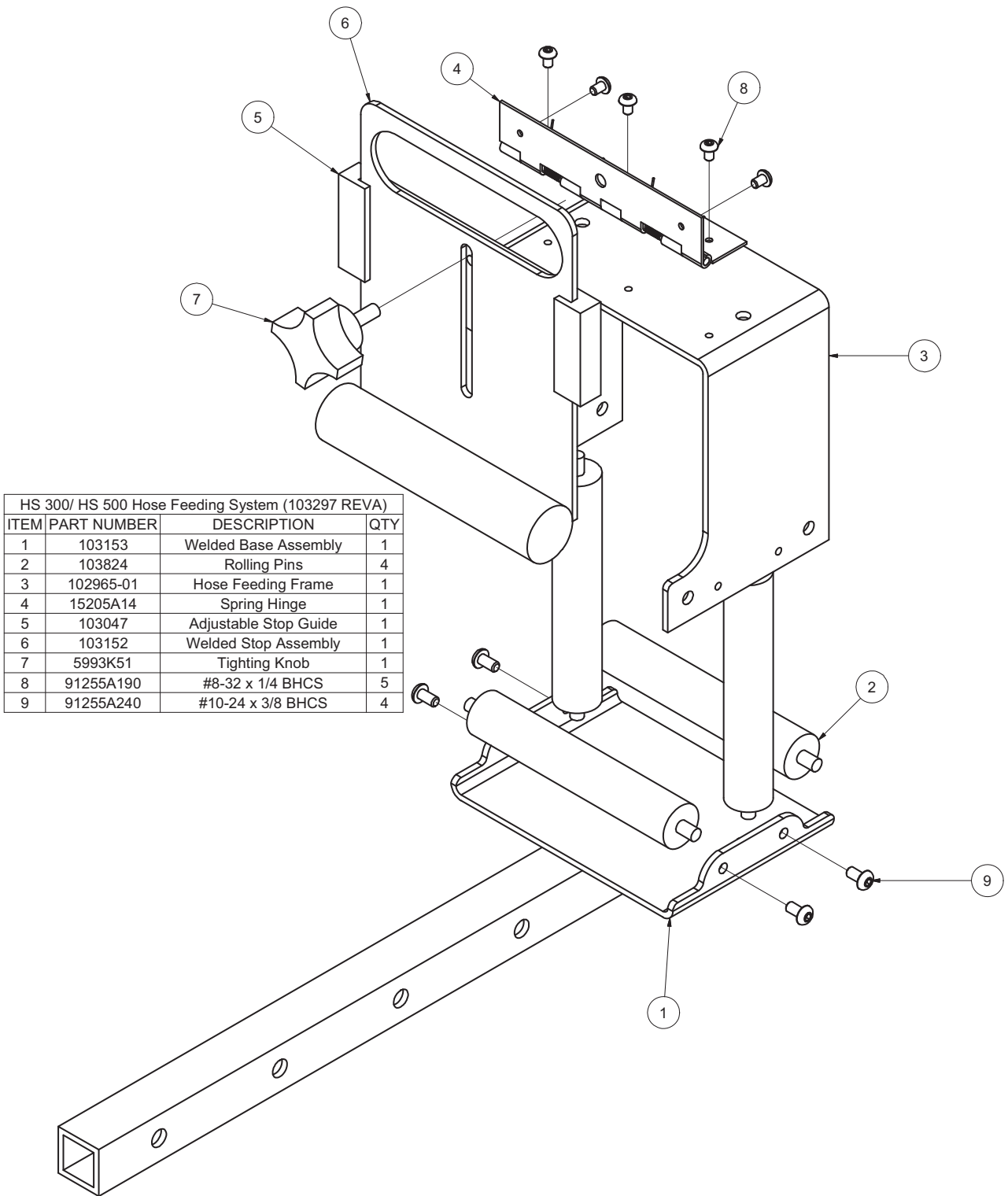
HS-3000 HS 500 ASSEMBLY (103335)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	102757	HS 3000 HS 500 Base Assembly	1
2	103335-1	Motor Assembly	1
3	91101A031	3/8" Spring Lock Washer	4
4	90128AG23	3/8"-16 X 7/8" SHCS	4
5	102210	12" Double Beveled Saw Blade	1
6	103187	12" Serrated Saw Blade	1
7	102391	Blade Grip Part 2	1
8	95155A119	1" Hex Jam Nut	1
9	102693	Removable Side Cover	1
10	91255A537	1/4"-20 X 1/2" BHCS	9
11	102926	Saw Blade Access Panel	1
12	91253A238	10-24 X 1/4" FHCS	2
13	102699	Handle Pusher	1
14	98320A013	Pull Pin	1
15	102706	Safety Guard	1
16	102697	Handle	1
17	103815	Black Hand Grip	1
18	103965	Mist Cover Plate	1
19	91257AG44	3/8"-16 X 5" FHCS	1
20	94846A031	3/8-16 Hex Nut	2
21	9271K67	Spring	1
22	103154	Fixed Bracket Assembly	1
23	91253A580	5/16"-18 X 5/8" FHCS	2
24	103965	Locating Pin Assembly	2





Motor Assembly (103335-1)

ITEM	PART NUMBER	DESCRIPTION	QTY
1	102256	HS 300 1 Phase	1
1	101964	HS 300 3 Phase	1
1	103341	HS 500 1 Phase	1
1	103342	HS 500 3 Phase	1
2	103299	HS-500 1 Ph/3 PH 5/8" Shaft Arbor	1
2	103127	HS-300 1 PH/3 PH 7/8" Shaft Arbor	1
3	91251A544	1/4"-20 X 1 1/4" HHCS	1
4	91375A533	1/4"-20 x 1/4" Set Screw	1
5	103151	HS 500 Electrical Box Bracket	1
5	102920	HS 300 Electrical Box Bracket	1
6	102919-01	Electrical Box	1
7	102919	Electrical Enclosure Panel	1
8	103050	50 Amp Disconnect Switch	1
9	91255A537	1/4"-20 X 1/2" BHCS	10



HS 300/ HS 500 Hose Feeding System (103297 REVA)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103153	Welded Base Assembly	1
2	103824	Rolling Pins	4
3	102965-01	Hose Feeding Frame	1
4	15205A14	Spring Hinge	1
5	103047	Adjustable Stop Guide	1
6	103152	Welded Stop Assembly	1
7	5993K51	Tightening Knob	1
8	91255A190	#8-32 x 1/4 BHCS	5
9	91255A240	#10-24 x 3/8 BHCS	4



CustomCrimp “No-Nonsense” Warranty Statement

All CustomCrimp Products are warranted to be free of defects in workmanship and materials for one year from the date of installation. This warranty ends when the product becomes unusable for reasons other than defects in workmanship or material.

Any CustomCrimp Product proven to be defective in workmanship or material will be repaired or replaced at no charge. To obtain benefits of this warranty, first, contact Warranty Repair Department at Custom Machining Services at **(219) 462-6128** and then deliver via prepaid transportation the complete hydraulic product to:

**ATTN: WARRANTY REPAIR DEPT.
Custom Machining Services, Inc.
326 North Co. Rd 400 East
Valparaiso IN 46383**

If any product or part manufactured by CustomCrimp is found to be defective by CustomCrimp, at its option, CustomCrimp will either repair or replace the defective part or product and return via ground transportation, freight prepaid. **Custom Crimp will not cover any incoming or outgoing freight charges for machines sold outside The United States.**

This warranty does not cover any product or part which is worn out, abused, altered, used for a purpose other than for which it was intended, or used in a manner which was inconsistent with any instructions regarding its use.

Electric motors are separately warranted by their manufacturer under the conditions stated in their separate warranty.

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CustomCrimp®

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