

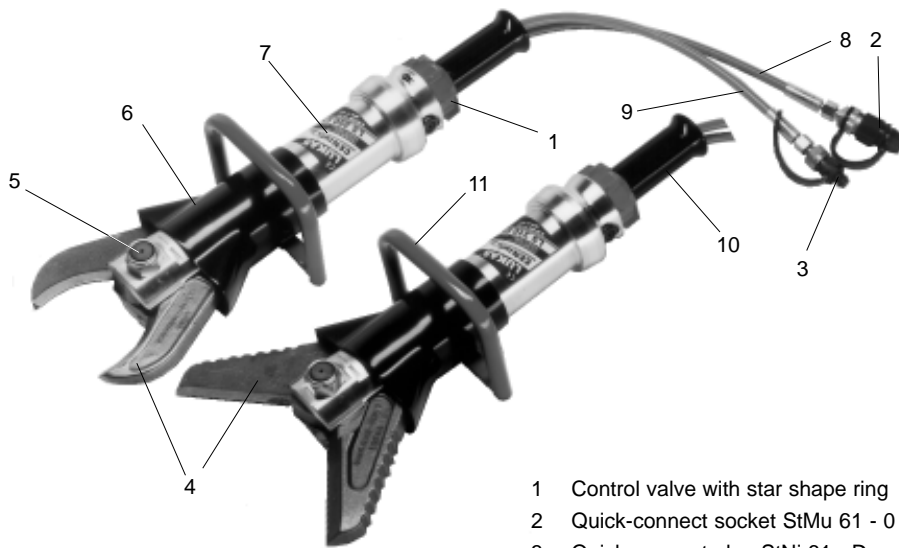
**Operating Instructions
Recycling System**

LUKAS



Cutter Series LSI

84150/1362-85 GB
Issue 6.2004
replaces 8.2003



- 1 Control valve with star shape ring
- 2 Quick-connect socket StMu 61 - 0
- 3 Quick-connect plug StNi 61 - D
- 4 Cutter blades, resp. blade arm
- 5 Central bolt with selflocking nut
- 6 Protecting hose
- 7 Hydraulic cylinder
- 8 Hose, red: Pressure
- 9 Hose, blue: Return
- 10 Handle
- 11 Handle

1 Basic operation and designated use of the machine

1.1 The machine has been built in accordance with state-of-the-art standards and the recognized safety rules. Nevertheless, its use may constitute a risk to life and limb of the user or of third parties, or cause damage to the machine and to other material property.

1.2 The machine must only be used in technically perfect condition in accordance with its designated use and the instructions set out in the operation manual, and only by safety-conscious persons who are fully aware of the risks involved in operating the machine. Any functional disorders, especially those affecting the safety of the machine/plant, should therefore be rectified immediately!

1.3 The machine is exclusively designed for the use described in the operating manual. Using the machine for purposes other than those mentioned in the manual, such as driving and controlling other pneumatic systems, is considered contrary to its designated use. The manufacturer/supplier cannot be held liable for any damage resulting from such use. The risk of such misuse lies entirely with the user.

Operating the machine within the limits of its designated use also involves observing the instructions set out in the operating manual and complying with the inspection and maintenance directives.

2 Organizational measures

2.1 The operating manual must always be at hand at the place of use of the machine!

2.2 In addition to the operating instructions, observe and instruct the user in all other generally applicable legal and other mandatory regulations relevant to accident prevention and environmental protection.

This also applies for wearing protective clothing, helmet with visor or goggles and protective gloves.

2.3 In order to avoid injuries, the machine must only be operated by a specially trained operator who has undergone a safety training.

2.4 Observe all safety instructions and warnings attached to the machine. Make sure that safety instructions and warnings attached to the machine are always complete and perfectly legible.

2.5 Never make any modifications, additions or conversions which might affect safety without the supplier's approval. This also applies to the installation and adjustment of safety devices and valves.

2.6 Spare parts must comply with the technical requirements specified by the manufacturer. Spare parts from original equipment manufacturers can be relied to do so. It is only allowed to use original LUKAS spare parts of LUKAS system components.

2.7 Replace hydraulic hoses at the specified or adequate intervals, even if no defects are detected which might affect safety. This must be done after 10 years, at the latest!

2.8 Adhere to prescribed intervals or those specified in the operating manual for routine checks and inspections.

2.9 Make sure to dispose properly of packing material and dismantled parts!

3 General safety instructions

3.1 In the event of malfunctions, stop the machine immediately and lock it. Have any defects rectified immediately.

3.2 Before starting up or setting the machine in motion and during operation of the machine make sure that nobody is at risk.

3.3 Before transporting the machine always check that the accessories have been safely stowed away.

3.4 Make sure that there is enough lighting during work.

3.5 Avoid any operation that might be a risk to machine stability.

3.6 Check the machine at least after every operation for obvious damage and defects. Report any changes (incl. changes in the machine's working behaviour) to the competent organization / person immediately. If necessary, stop the machine immediately and lock it. All lines, hoses and screwed connections have to be checked for leaks and obvious damage. Repair damage immediately. Splashed oil may cause injury and fire.

3.7 All safety equipment has to be checked for completeness and flawless condition:

- instruction markings and warning signs (safety instructions),
- check safety cover (e.g. motor-safety covers, heat protection etc.) if they are available and if they are in good condition.

3.8 Working under loads is not allowed if they are only lifted by hydraulic cylinders. If the work is indispensable sufficient mechanical supports are needed additionally.

3.9 Do not stress hoses mechanically (pulling, buckling etc.).

4 Instructions for maintenance and service

4.1 For the execution of maintenance and service work, tools and workshop equipment adapted to the task on hand are absolutely indispensable.

Work on the hydraulic system must be carried out only by personnel having special knowledge and experience with hydraulic equipment.

4.2 Before putting into operation clean the machine, especially connections and threaded unions, of any traces of oil, fuel or preservatives before carrying out maintenance/repair. Never use aggressive detergents. Use lint-free cleaning rags and pay attention that the components are meticulously clean during reassembling after repair.

4.3 During dismantling of machines it is necessary to collect the outrunning hydraulic liquids completely, so that they cannot reach the ground. They have to be disposed properly according to the instructions.

4.4 Always tighten any screwed and thread connections that have been loosened during maintenance and repair. Observe the stipulated torques.

4.5 Work on the electrical system or equipment may only be carried out by a skilled electrician himself or by specially instructed personnel under the control and supervision of such electrician and in accordance with the applicable electrical engineering rules.

4.6 The electrical equipment of machines is to be inspected and checked at regular intervals. Defects such as loose connections or scorched cables must be rectified immediately.

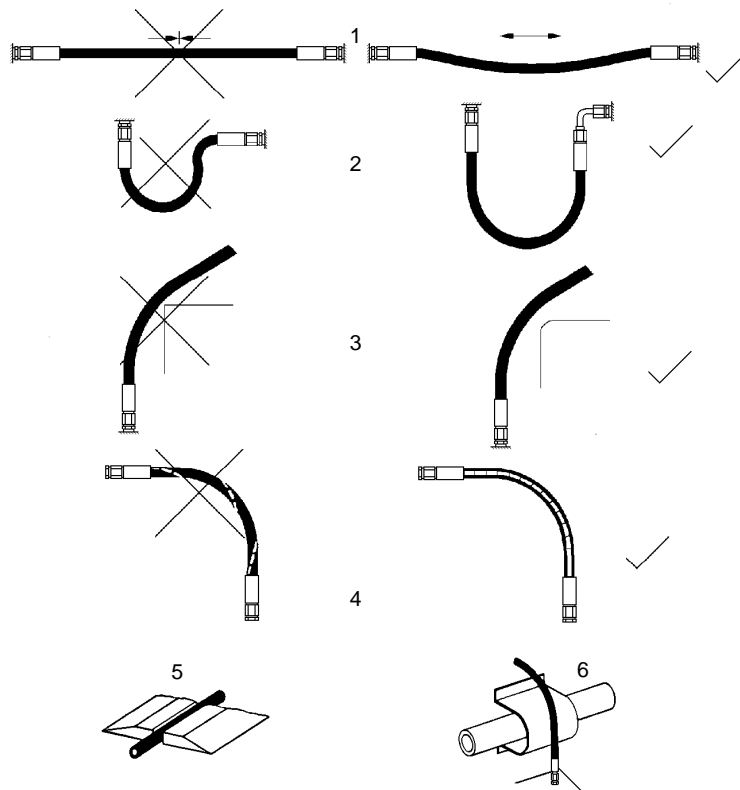
4.7 Aggressive material (acid, lye, solvent, vapour) can damage the machine. It is necessary to clean the whole machine if it must be exceptionally operated under such conditions or gets into touch with these materials. Additionally, the machine must be checked as described under 3.6.

5 Safety Instructions for Hydraulic Hoses

● ATTENTION!

- **By no means the hose must be exposed to brake fluid** as this fluid will destroy outer layer of hose
- do not expose the hose to any of the following aggressive fluids:
 - acid, lye or solvent
 - alcohol and fuel
 - battery and automatic transmission fluid
 - phosphate ester

Clean hose immediately with water and detergent when it was exposed to such fluids.



5.1 Handling of hoses

- never exceed the permissible working pressure as stated on hose and/or literature
- avoid any tension (see figure 1) and do not hang any load onto the hose
- never exceed the minimum bend radius as resulting kink will cause failure of hose (see figure 2)
- do not allow hose to contact sharp edges or rough objects (see figure 3)
- avoid any twisting of hose (see figure 4)
- do not run over hose with any vehicle or equipment ! Hoses which are put on the surface of sidewalk or street have to be suitably protected (see figure 5)
- do not allow hose to contact areas of high temperature such as mufflers, exhaust manifold, heaters or burners. Protect the hose as shown in figure 6 or install it in sufficient distance from the source of heat.
- never interline hose with that of a different manufacturer.

5.2 Protection of the working area in case of breakdown of hoses

Hoses have to be installed or protected in such a way that dangers are prevented, if possible, in case of breakdown of the hoses.

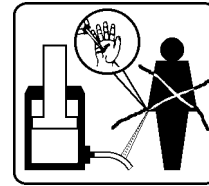
Danger can be caused by:

- Uncontrolled hose movement after a hose rupture caused e.g. by external influence.
- Emerging of the pressure medium under pressure.
- Inflammation of pressure medium near igniting sources.

Dangers can be prevented by e.g. protective coverings or shieldings

5.2.1 Do not go near leaks!

- High pressure oil easily punctures skin causing **serious injury**, gangrene or death!
- If injured, **seek emergency medical help!** Immediate surgery is required to remove oil!
- Do not use finger or skin to check for leaks!
- Lower load or relieve hydraulic pressure before loosening fittings!



5.3 Storage of hoses

- Hoses are subject to a natural aging even if they are stored correctly. Therefore, their storage and service time is limited.

When storing the hoses please observe the following:

- Store them cool, dry and dustless (eventually wrapped with plastics sheeting); prevent direct solar radiation and UV rays; shield heat sources which are near the hoses.
- Do not use any ozone producing lamps (e.g. fluorescent light sources, mercury-vapor lamp) or electrical devices next to the hoses.
- Hoses have to be stored freely of tension and in a horizontal position. If they are stored in rings the smallest bending radius determined by the manufacturer must not fall below.

5.4 Marking of hoses

- The hose is marked with the manufacturer's name and quarter/year of production.
- The max. allowable pressure and month/year of production is indicated on the hose end fitting.

5.5 Inspection and replacement intervals of hoses

- **After each operation the hoses have to be checked for external damages, cracks, kinks and bubbles!**
- The operator has to replace the hoses in appropriate period of times, even if there are no visible security defects on the hoses.
- **The hoses have to be replaced 10 years as from date of manufacture at the latest (see marking on the hose)!**
Hoses are subject to a natural aging even if they are stored correctly. Therefore, their storage and service time is limited.
- **Hoses have to be checked by a skilled person before the first putting into operation of the technical device and afterwards at least once a year for their safe working condition.**

A skilled person is somebody having sufficient knowledge concerning hydraulic hoses due to his special training and knowledge. He/she must be acquainted with the local safety working conditions, accident prevention regulations, technical regulations and approved standards (e.g. DIN-Standards), so that he/she is capable to estimate the safety working conditions of the hydraulic hoses.

5.6 Examples for possible defects of hoses

- Damages of the surface and the interior (e.g. chafe marks, cuts or fissures).
- Embrittlement of the surface (fissuration of the hose material).
- Deformations, which are not in accordance with the natural shape of the hoses, in pressureless condition or under pressure or in case of bendings, e.g. separation of material layers, blister formation, squeezing or break spots.
- Leakage points.
- Instructions for installation were not observed.
- Emerging of the hose from the end fittings.
- Damages or deformations of the end fittings which deteriorate the function and stability of the end fittings or the connection between hose and end fitting.
- Corrosion of the end fittings or the metal inlets, which deteriorates the function and stability.
- Storage and operation periods were exceeded.

6 Intended use

LUKAS LSI cutters are specially designed for cutting steel, sufficiently hard ferrous metals, sheet steel and cables. Depending on the material to be cut, cutter blades in different shapes are available.

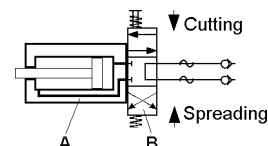
7 Function and performance

7.1 Description

The devices are designed in such a way that a hydraulically actuated piston via mechanical joints symmetrically closes two identical blade arms positioned opposite each other to cut the object in question. The blade geometry is adapted to the application so as to avoid as far as possible a sliding of the material to be cut.

7.2 Connection diagram

For your better understanding the hydraulic diagram is showing in simplified manner the tool's hydraulic cylinder (A) with control valve (B).



7.3 Control of movements in operation

The arm movement is controlled by the firmly mounted star grip control valve (see cover page item 1).

7.4 Hydraulic oil supply

Only LUKAS motor/engine pump or hand pump is used for operating the devices.

If the power pack comes from a manufacturer other than LUKAS, it must be ensured that it fulfils the LUKAS specifications, as otherwise dangers may occur for which LUKAS cannot be held liable. Especially it has to be made sure that the permissible working pressure of 50 MPa (500 bar) is not exceeded without consultation with LUKAS.

7.5 Hoses

The connection between motor pump and cutter unit is normally effected with LUKAS hoses. If pipes are to be used, please contact LUKAS.

8 Connection of the tool

8.1 Hydraulic

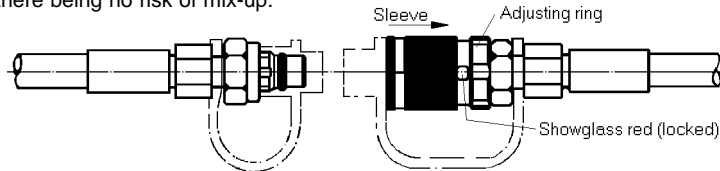
Two short hoses are fitted to the tool; they are connected with the motor pump via a hose pair (5 m / 10 m / 20 m, as is necessary). All hoses are colour marked and have quick-connect couplings so that they can be connected without the risk of mix-up:

HP = High pressure —> red

R = reflux —> blue.

8.2 Connection of the plug-in coupling counterparts for HP and R hoses

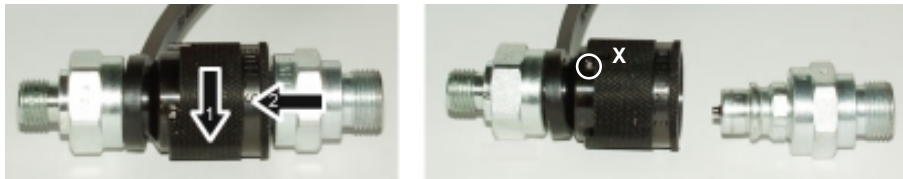
The device is connected to the hydraulic pump with the plug-in coupling counterparts (plug and socket), there being no risk of mix-up.



Before coupling, remove the dust protection covers and unlock the connect socket with adjusting ring by turning it. Withdraw the sleeve and connect plug and socket while holding the sleeve in this position. Release the sleeve and set the showglass to „red“ with the adjusting ring. Now the parts are connected and locked. Decoupling is done in the reverse order.

Note regarding the modified release mechanism as of June 2003

When connecting the hoses, be aware of the following basic functions of the quick couplers:



Set the sleeve to position X and pull it back • separate plug and socket • for connection of a tool, reverse this procedure.

Connection of the hoses is possible only, when they are **depressurized**.

In order to prevent contamination of the tool lines protect the couplings with delivered dust caps.

Attention!

Quick couplers partly have special functions. Therefore it is **not allowed screwing them off** from the hoses or **to exchange them**.

9 Operation

9.1 Preparatory measures

9.1.1 Initial start-up

Before initial start-up and after repairs, the device must be vented:

- Connect the device to the hydraulic pump (see item 8).
- Fully open and close the device at least twice without load (see item 9.2).

9.1.2 Inspection of operating state of the pump power pack

—> See separate Operating Instructions of the power pack (or manual pump) in question.

Note:

Before working on the motor pump or for coupling/decoupling the hoses, make sure that the motor pump is switched off (electric connection) or disconnected from the mains and that the lines are unpressurized.

9.2 Operating of the star grip 1

Opening of the blades:

Rotate star shape ring **1** to the right hand side and hold it in this position.

Closing of the blades:

Rotate star shape ring **1** to the left hand side and hold it in this position.

Load sustain function:

If released, the star shape ring **1** returns automatically to center position, maintaining fully the load sustain function.

10 Cutting

10.1 Safety advise

In each country, the country-specific safety regulations must be regarded.

When working in an environment which involves a risk of explosions, do not use motor/engine powered pumps. Instead, use hand pumps.

When operating cutter devices, wear

- protective clothing
- helmet with visor or goggles
- protective gloves.

Before any operation of the cutter unit make sure that the movement of the blades does not constitute a risk to persons or that the blades or cut-off parts jerking away cannot damage property.

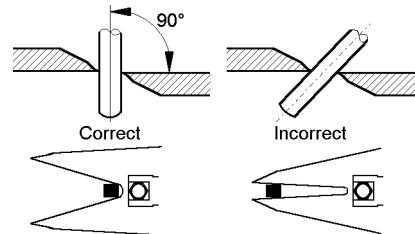
Do not get your hands in between the blade arms.

Do not cut

- live wires,
- pressurized gas or fluid lines,
- prestressed and hardened parts (such as springs, spring steels, steering columns, rolls),
- composite materials (steel/concrete).

10.2 Principles on cutting

The blades must be applied at a right angle to the object to be cut. To enhance cutting performance, cut as close as possible to the blade fulcrum. On cutting, the gap between the blade tips must not be larger than 3 mm (Risk of blade fracture!).



10.2.1 Attention!

With cutters having curved blades the blade tips must by no means be loaded with full cutting capacity. Cutting of profiles of up to 2 mm thickness is permissible.

11 Dismantling of the device / Stop after operation

11.1 Cutter unit

After operation, close the blades to a **distance of a few mm**. This relaxes the unit hydraulically and mechanically.

11.2 Hydraulic power pack

Stop the hydraulic power pack after operation.

This is mandatory before taking one of the following steps:

11.3 Hoses

Uncouple the red hose first and the blue hose second as described under 8.2. Put dust caps over the couplings.

12 Maintenance

After each operation inspect the components for perfect function (when the device is dirty, clean it before inspection):

Visual inspection

Cutter blades

- Cutting edges free from spalling and deformation.
- Distance of blades in transverse direction < 1 mm.
- Cutting surfaces slide past each other without contact.
- Blades free from cracks.
- Corrugation of the tips clean and edged without fissures.

Cutter unit

- No leakages.
- Easy operation of the star grip.
- Handle existing and fast.
- Check of central bolt tightening torque (see also drawing to Section 13.3.1)
 M_A = Torque (see item 15.2).

Hoses

- Check according safety instructions for hoses (see item 5).
- Check for oil leakage.

Function testing

- Perfect opening and closing with the star grip valve.

13 Repairs

13.1 General

Servicing must be carried out only by the device manufacturer or by personnel trained by the manufacturer or the authorised LUKAS dealers.

For replacement on all components, use only genuine LUKAS spare parts as specified in the spare parts list, as here possibly required special tools, mounting information, safety aspects, testing must absolutely be taken into account. See section 4.

Protection of the device against hydraulic overload

Through uncorrect hose connection or temperature increase pressure can be built up in the cylinder unintentionally. Therefore, the return hose (0,5 m / blue) of the tool is equipped with a safety coupling (quick connect plug, colour yellow). Overpressure (approx. 1.5 MPa) is released through this plug: oil comes out. This oil is not a malfunction of the plug!

Should the tool have been equipped with couplers of different brand which do not have this safety function, overpressure would be released through another safety valve (adjusted to approx. 30 MPa) included with the control valve block. In this case oil spill would be observed in the star grip area.

As soon as sufficient pressure is released the valve becomes tight again. Should further constant leakage occur, please have the tool inspected by LUKAS personnel.

13.2 Preventive maintenance

13.2.1 Routine inspections

Regularly check the central bolt tightening torque. $M_A = \text{Torque}$ (see item 15.2).

Damaged blades can be repaired by regrinding of the cutting edge up to a total of 0.5 mm. Special care must be taken to have the inner cutting faces run parallel.

Attention !

When you are working with the cutter blades pointing upwards, it must be made sure that no larger objects are falling into the rubber protection boot. Such objects might get jammed into the lever system which can cause serious damage to the tool.

After each application in upright position the cutter head must be inspected on eventual pollution, and it must be cleaned if necessary



picture 1

Remove handle and pull the protection boot back.



picture 2

Clean the mechanical parts (see picture 2) with compressed air from dirt and metal chips. If the upper sealing lips of the protection boot are damaged too seriously, the boot must be changed against a new one.

13.2.2 General inspections

The mechanical transmission elements of the cutter unit are subjected to very high mechanical stressing and must, therefore, be inspected at certain intervals. This helps to detect wear early so that fractures of these wearing parts can be prevented by replacing them in time.

Parts in perfect condition can be fitted again after careful application of LUKAS special grease for cutter units.

Parts with insignificant wear (fretting marks) can be repaired by polishing and fitted again after greasing.

More pronounced wear marks require replacement of the damaged parts (by pairs).

At these intervals, crack testing of the cutter blades is equally mandatory. For this purpose, a special crack test kit is available.

To protect the device against external corrosion clean its surface from time to time and slightly grease it with oil.

13.2.3 Function and load test

If there is any doubt as to the safety and reliability of the equipment, carry out an additional function and load test. For this purpose, LUKAS offers a test kit as appropriate equipment.

13.2.4 Change of hydraulic oil

- After 200 uses, latest after 2 years, the hydraulic oil has to be changed.
- In any case if the oil of the pump (motor / hand pump) which belongs to the unit is changed. By changing the used oil, it should be avoided that the new oil is polluted by the used oil of the cutter tool.

Procedure:

The cutter tool is in closed (retracted) position • Change of oil has to be effected at the pump.
Screw off the return hose at the pump:

- **in case of hose connection:** screw off the connecting piece of the blue return hose.
- **in case of quick connect couplings:** screw off totally the coupling nut of the quick connect coupling of the blue return hose.

Extend pump with tool slowly • Collect the used oil at the piston rod side in a separate tank and dispose of the used oil (as the used oil of the pump) • Do not operate the pump any longer.

Connect the return hose again to the pump:

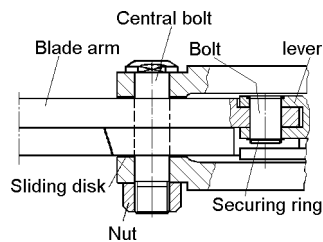
- Tighten the coupling nut of the quick connect coupling according to 13.3.6,
- Screw the hose nipple into the valve bloc with MA = 45 Nm,
- Ventilate the tool according to 9.1.1.

13.3 Repairs

13.3.1 Cutter blades and levers

Cutter blades and levers have to be replaced in the case of visual heavy damage and cracks or when the blades are becoming too weak due to frequent regrinding. (13.2.1).

- Unscrew the nut of the central bolt (size open-jawed spanner see 15.2) and drive out the central bolt.
- Remove the retaining rings with a pair of Seeger ring pliers.
- Replace the blade arms after thorough cleaning and greasing of the sliding surfaces.
- Tighten the nut of the central bolt with the tightening torque specified in 15.2.
- **Note:**
The bolts are accessible with the blade arms closed.



Attention: prior to mounting all sliding surfaces have to be carefully cleaned and greased with LUKAS special grease.

Remark: Faulty parts such as blades, bolts or sliding disks have to be changed pairwise. The levers have to be replaced if e.g. during change of blades damages appear such as wear on the surface, cracks or deformation of the bores. Lever exchange should be made by a authorized LUKAS dealer or the LUKAS service department.

13.3.2 Oil spill out of the control valve handle (see cover page item 10)

Pressure or return hose are not tightened properly.

Procedure:

Loosen the 2 allen screws (SW5) inside the handle sleeve and remove them together with the short plastic isolation sleeves. Pull handle sleeve backwards until the hose connection points become visible and retighten the retaining nut. Change hose connection sealing rings if necessary. Place handle sleeve again and tighten it with the 2 allen screws. Make sure that the plastic isolation sleeves are placed properly on the allen screws before mounting.

13.3.3 Change of protection boot

The rubber protection boot shall protect the operator against injuries caused by the moving levers. If the boot is damaged it has to be replaced.

Procedure:

Remove the carrying handle (held by 2 screws) • Dismount cutter blades / blade arms (see 13.3.1) • pull the faulty boot from the cylinder body and place the new one properly, i.e. that the carrying handle fixing screws go easily through the corresponding holes in the boot. Mount and tighten carrying handle.

13.3.4 Carrying handle (see cover page item 11)

Damaged carrying handles have to be replaced immediately.

Procedure:

Remove the handle (held by 2 screws) and change it against a new one • Change screws and disks if necessary.

13.3.5 Labels

All damaged or illegible identification stickers (Safety instructions, type label a.s.o) have to be replaced.

Procedure:

Remove damaged stickers and clean surface with acetone • Put on new stickers.

13.3.6 Quick couplers

Quick couplers on the hoses have to be replaced when

- external damage can be observed • the locking sleeve doesn't work any more • oil spill occurs even when the coupling is properly connected.

Remark: Faulty couplers have to be changed completely against genuine LUKAS spares, i.e. it is not permissible to make any repair work.

The retaining nut on the hoses has to be tightened with a torque of $M_A = 45 \text{ Nm}$.

14 Troubleshooting

Trouble	Check	Cause	Remedy
Hoses cannot be coupled		Pressurized	Relieve pump pressure
On actuating blades move slowly or by jerks	Hoses correctly connected power pack operating	Air in the hydraulic system	Thoroughly vent pump unit: see 9.1.1
No pressure build-up		Not enough oil in hand resp. motor pump. Vent pump after changing oil	Refill oil and vent the system (see operating instruction 9.1.1)
Star grip doesn't return to middle position when released		Return spring is damaged or return mechanism is dirty	Ask authorized dealer or LUKAS themselves for repair
Oil leakage out of hoses or hose fittings		Untightness, eventually damages	Replace hoses
Surface of hydraulic hoses is dissolved		Contact with aggressive fluids	Change hoses
Blades spread up at tips to a gap of more than 3 mm even if not fully loaded		Torque of the center bolt nut is insufficient	For retightening, see 13.2.1
Leakages on the piston rod		Seal defective piston rod	Replacement of seals by authorized dealer or LUKAS themselves

If the defects cannot be repaired, contact an authorised LUKAS dealer or the LUKAS service department. The address: **LUKAS Hydraulik GmbH**, Weinstraße 39, D-91058 Erlangen, Pf 2560, D-91013 Erlangen, service phone 09131/698 348; fax 09131/698 353.

15 Technical data

Type	LSI 200	LSI 220	LSI 230	LSI 235	LSI 240	LKS 10
Ref. no.	84150/1352	84150/1349	84150/1353	84150/1359	84150/1351	84150/1360
Dimensions l x w x h (mm) without connection hoses	670x190x163	725x190x163	737x190x163	760x190x163	756x190x163	405x112x195
Opening at tips (mm)	125	150	225	265	285	48
Weight incl. oil filling (kg)	13	14.2	15	13.8	15.2	5.3
Operating pressure (MPa)*	max. 50					max. 63
Usable oil quantity (l) **	0.20					0.03

* 1MPa = 10 bar

** Necessary oil quantity in the hydraulic power pack for operating the tool (Difference in quantity piston / rode side)

15.1 Cutting performance / cutting forces

Max. Dimensions of Material						
Type of material	Form of material	Strength Rm (N/mm ²)	LSI 200 max. cutting performance mm	LSI 200 Continous cutting performance mm	LSI 220 max. cutting performance mm	LSI 220 Continous cutting performance mm
	○	750	dia. 23	dia. 18	dia. 23	dia. 18
	○	500	dia. 25	dia. 20	dia. 25	dia. 20
	□	500	40 x 4	30 x 4	40 x 4	30 x 4
Steel	⊙	500	dia. 65 x 3	dia. 60 x 3	dia. 72 x 3	dia. 50 x 3
	└	500	50 x 50 x 5	50 x 50 x 4	50 x 50 x 5	50 x 50 x 4
	—	500	60 x 8	60 x 6	80 x 8	80 x 6
	└	500	60 x 30 x 6	40 x 40 x 4	60 x 30 x 6	40 x 40 x 4
Alu	○	400	dia. 28	dia. 24	dia. 28	dia. 24
Copper	○	200	dia. 35	dia. 28	dia. 35	dia. 28

Max. Dimensions of Material						
Type of material	Form of material	Strength Rm (N/mm ²)	LSI 230 max. cutting performance mm	LSI 230 Continous cutting performance mm	LSI 235 max. cutting performance mm	LSI 235 Continous cutting performance mm
	○	750	dia. 23	dia. 18	dia. 23	dia. 18
	○	500	dia. 25	dia. 20	dia. 25	dia. 20
	□	500	55 x 4	40 x 4	55 x 4	40 x 4
Steel	⊙	500	dia. 72 x 3	dia. 60 x 3	dia. 72 x 3	dia. 60 x 3
	└	500	45 x 45 x 6	50 x 50 x 5	45 x 45 x 6	50 x 50 x 5
	—	500	100 x 10 60 x 15	80 x 8	80 x 10	80 x 8
	└	500	65 x 40 x 6	60 x 30 x 6	65 x 40 x 6	60 x 30 x 6
Alu	○	400	dia. 28	dia. 24	dia. 28	dia. 24
Copper	○	200	dia. 35	dia. 28	dia. 35	dia. 28

Max. Dimensions of Material						
Type of material	Form of material	Strength Rm (N/mm ²)	LSI 240 max. cutting performance mm	LSI 240 Continuous cutting performance mm	LKS 10 max. cutting mm	LKS 10 Continuous cutting performance mm
	○	750	dia. 23	dia. 18	dia. 15	dia. 12
	○	500	dia. 25	dia. 20	dia. 16	dia. 13
	◻	500	55 x 4	40 x 4	20 x 3	20 x 2
Steel	⊙	500	dia. 72 x 3	dia. 60 x 3	dia. 25 x 3	dia. 20 x 3
	└	500	45 x 45 x 6	50 x 50 x 5	20 x 15 x 3	15 x 15 x 3
	—	500	100 x 10 60 x 15	80 x 8	16 x 10	20 x 6
	└	500	65 x 40 x 6	60 x 30 x 6	--	--
Alu	○	400	dia. 28	dia. 24	dia. 20	dia. 16
Copper	○	200	dia. 35	dia. 28	dia. 20	dia. 18

For daily use it is to be distinguished between max cutting performance and cutting performance under continuous duty.

In the interest of a long tool life and acceptable service intervals, we recommend not to exceed permanently the figures given for continuous duty. Applications in the range of the max. cutting performance require a perfect condition of the blades and shortened service intervals.

15.2 Central bolt / Torque

Type	LSI 2..	LKS 10
Central bolt	M 24 x 1.5 (SW 36)	M 20 x 1.5 (SW 36)
Torque (Nm)	120 + 10	80 + 10

15.3 Oil recommendations

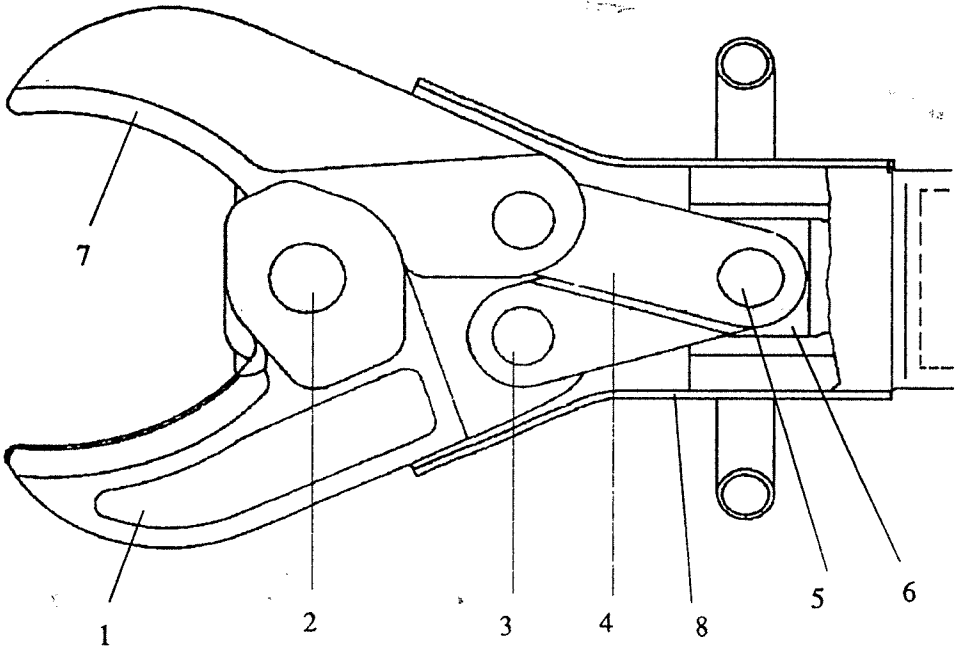
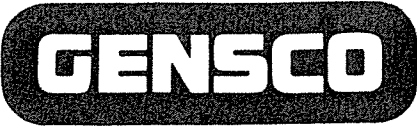
For LUKAS hydraulic devices, use mineral oil in accordance with DIN 51 524 and others

	Range of oil temperature	Viscosity rating	Remarks
A	- 24 ... + 30 °C	HL 5	
B	- 18 ... + 50 °C	HLP 10	
C	- 8 ... + 75 °C	HLP 22	
D	+ 5 ... + 80 °C	HLP 32	
E	- 8 ... + 70 °C	HF - E 15	biodegradable

Recommended viscosity range: 10 ... 200 mm²/s,
delivered with HLP 22 to DIN 51 524

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The logo for LUKAS, featuring the word "LUKAS" in a bold, italicized, sans-serif font.The logo for IDEX CORPORATION, featuring the word "IDEX" in a bold, italicized, sans-serif font above the words "IDEX CORPORATION" in a smaller, all-caps, sans-serif font.



Change of Cutting Blades

Unscrew the nut of the central bolt and drive out the central bolt (fixed spanner 36)

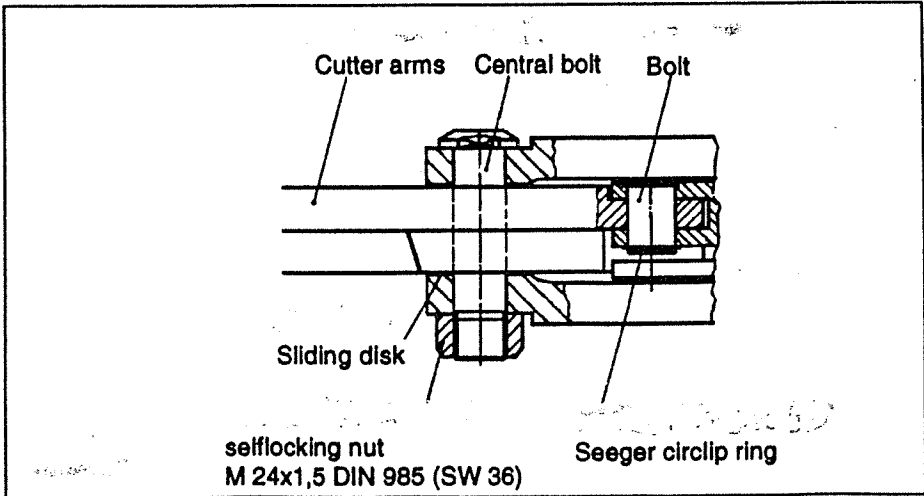
- Remove the Seeger circlip rings
- Grease the new cutting blades properly before mounting
- Tighten nut of central bolt with 120 + 10 Nm

- 1 Cutter blades
- 2 Center bolt with selfsecuring nut
- 3 Bearing bolt for lever
- 4 Lever
- 5 Bearing bolt in the piston attachment
- 6 Piston attachment
- 7 Cutting edge
- 8 Protective hose

The distance between the blade tips can be max. 12 mm during the cutting process (risk of breakage!)

After Operation

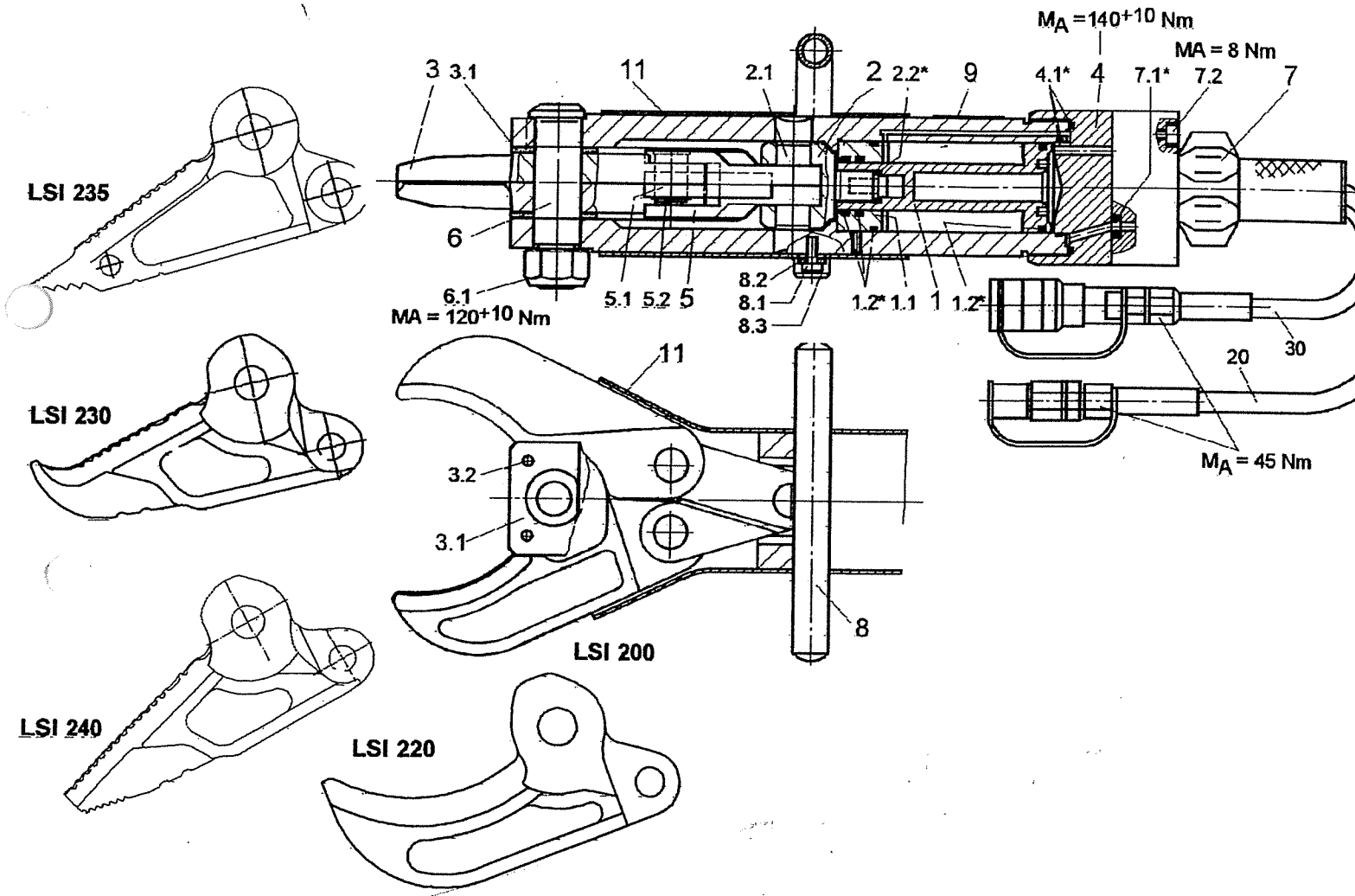
After operation, close the cutter arms until the tips are only a few millimeters apart. This hydraulically relaxes the device.



Remark:
The bolts are freely accessible when the cutter arms are closed.



Ersatzteilliste / Spare parts list
Schneidergerät / Cutter
LSI 200; LSI 220; LSI 230; LSI 235; LSI 240



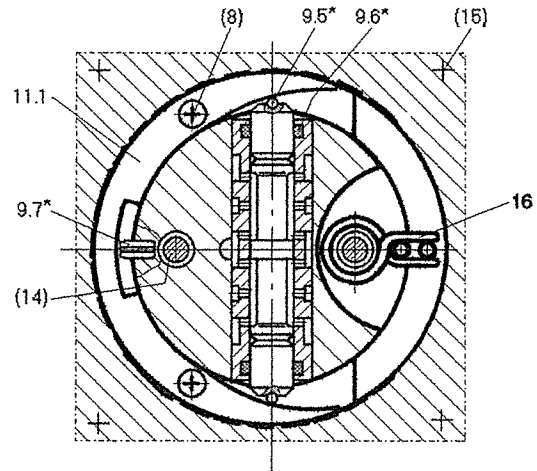
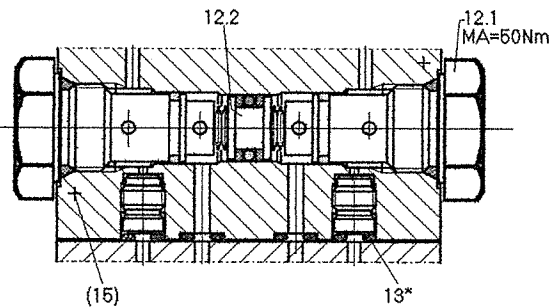
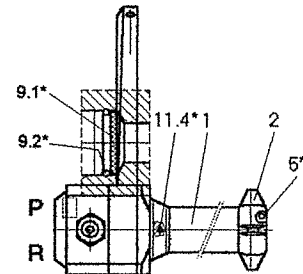
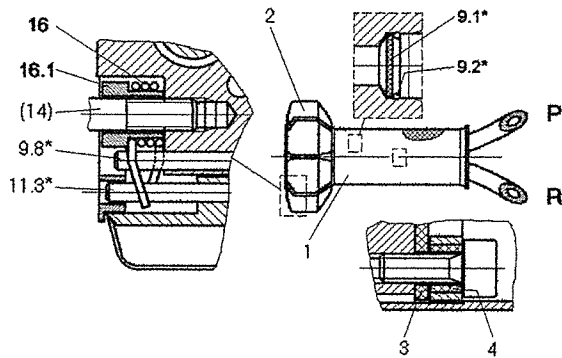


gütig für / valid for

Pos. Item	Bestellbezeichnung	Description	Bestellnummer Ref. no.	Menge Quant.					DM/Stü DM/pie			
				LSI 200	84150/1352	LSI 220	84150/1349	LSI 230		84150/1353	LSI 235	84150/1359
1	Kolben, inklusive:	piston, including:	V84150/1255-02	1	1	1	1	1	1	1	1)
1.1	Führungsbuchse	guiding bushing		1	1	1	1	1	1)
1.2*	Dichtungen	sealing		4	4	4	4	4	4)
2	Druckstück, inklusive:	pressure piece, including:	V84150/1255-03	1	1	1	1	1	1	1	1)
2.1	Zylinderstift	cylinder pin		1	1	1	1	1	1)
2.2*	Dichtung	sealing		1	1	1	1	1	1)
3	Schermesser, inklusive:	cutting blade, including:	V84150/1352-05	1)
3.1	Gleitscheibe (1 Stück)	sliding plate (1 piece)	V84150/1349-01		1)
3.1	Spannhülse (2 Stück)	tightening sleeve (2 pieces)	V84150/1353-12			1)
			V84150/1359-01				1)
			V84150/1351-22							1)
4	Anschlußboden, inklusive:	cylinder bottom, including:	V84150/1255-06	1	1	1	1	1	1	1	1)
4.1*	Dichtungen	sealings		3	3	3	3	3	3)
5	Hebelglied, inklusive:	lever, including:	V84150/1255-08	2	2	2	2	2	2	2	2)
2.1	Zylinderstift	cylinder pin		1	1	1	1	1	1)
1	Bolzen	bolt		2	2	2	2	2	2)
2	Sicherungsring	securing ring		2	2	2	2	2	2)
6	Lagerbolzen / Mutter, inklusive:	bearing bolt / nut, including:	V84150/1256	1	1	1	1	1	1	1	1)
6.1	Mutter	nut		1	1	1	1	1	1)
7	4/3-Wegeventil, inklusive:	4/3-way control valve, including:	V84150/0813	1	1	1	1	1	1	1	1)
7.1*	Dichtungen	sealings		6	6	6	6	6	6)
7.2	Schrauben	screws		2	2	2	2	2	2)
7.3	Haube	hood	V84150/0813-01	1	1	1	1	1	1)
8	Bügelgriff, inklusive:	handle, including:	V84150/1257	1	1	1	1	1	1)
8.1	Schrauben	screws		2	2	2	2	2	2)
8.2	Scheiben	disks		2	2	2	2	2	1)
8.3	Stopfen	plug		2	2	2	2	2	1)
9	Schildersatz-Stanzbogen	set of labels	V84150/1352-90	1	1	1	1	1	1)
10	Zylinderkörper, inklusive: 10	cylinder body, including:	V84150/1255-41	1	1	1	1	1	1)
4.1*	Dichtungen	sealings		3	3	3	3	3	3)
11	Schutzschlauch	protective hose	84150/6202-05	1	1	1	1	1	1)
20	Schlauch 3 m blau, kpl.	hose 3 m blue, cpl.	V84150/7075	1	1	1	1	1	1)
30	Schlauch 3 m rot, kpl.	hose 3 m red, cpl.	V84150/7076	1	1	1	1	1	1)
*	Bestandteil des Dichtungssatzes	component of sealing set	84150/1255-99	1	1	1	1	1	1)
1)	Gleitscheibensatz, bestehend aus 2 Gleitscheiben und 4 Spannhülsen	Sliding plate kit, consisting of 2 sliding plates and 4 tightening sleeves	V84150/1352-12)

Bei Bestellung Bestellbezeichnung und Bestellnummer angeben. · When ordering please indicate description and ref. no.
 Nur Ersatzteile und Teile mit XX sind einzeln lieferbar. · Only spare parts and parts with XX are available as single parts.

84150/0813SP gültig für / valid for: Spreizer / Spreader LSP 100; LSP 40B; LSP 40; LSP 44C; LSP 40 EN; LSP 60 EN
 84150/0813 gültig für / valid for: Schneidgeräte / Cutters LS 200B; ..300B; ..300C; ..200; ..300; LSI ...;
 Kombiwerkzeug / Combi tool LKS 35C; ...35B; LKS 35; LSI ...;
 84150/0866 gültig für / valid for: Schneidgeräte / Cutters LS 120 EN; LS 130 EN; LS 200 EN; LS 300 EN; LS 310 EN; LS 330 EN
 Kombiwerkzeug / Combi tool LKS 20 EN, LKS 35 EN
 84150/6086 gültig für / valid for: Rettungszyylinder / Rescue rams LZR 12/... DIN; LTR 12/...;
 Teleskop-Rettungszyylinder / Telescopic-rescue ram LTR 6/570;
 Schälzylinder / Peeling ram LZR 12/550 PS;
 V84150/6104 gültig für / valid for: Rettungszyylinder / Rescue rams LZR 12/... EN;
 84150/0820 gültig für / valid for: Spreizer / Spreader LSP 44B; LSP 80;



Montagehinweise:

- 1 Alle mechanisch bewegten Teile (Schiebergehäuse 9, Schaltsegment 7 und 11.1, Sterngriff 2, Schaltglocke 11) an den Gleitflächen mit Montagepaste KT 1746 49 006 einfetten.
Achtung! Nicht im hydraulischen Teil verwenden.
- 2 Beim Wechseln der Dichtungen 9.6 zuerst Kolben einsetzen und nur soweit nach innen drücken, bis Dichtungen eingelegt werden können.
Achtung! Steuerkanten des Kolbens nicht über die neuen Dichtungen schieben.

Mounting instructions:

- 1 All mechanically operated parts (casing 9, shifting quadrants 7 and 11.1, star grip 2, shifting gate 11) have to be greased in the sliding areas with grease KT 1746 49 006
Attention! Don't use any grease with hydraulic parts
- 2 Before changing seals 9.6 insert piston first and push it inwards just as far as necessary for placing the seals.
Attention! Do not slide piston edges over the new seals.

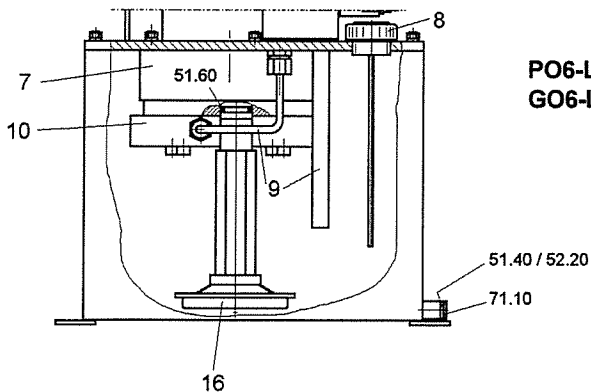
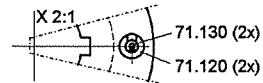
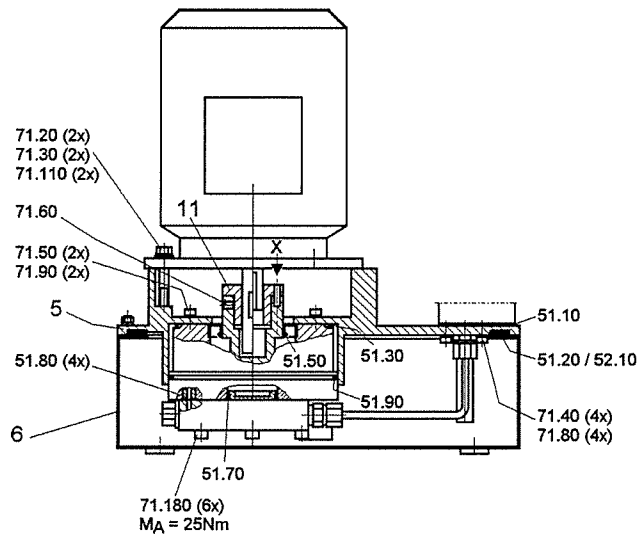
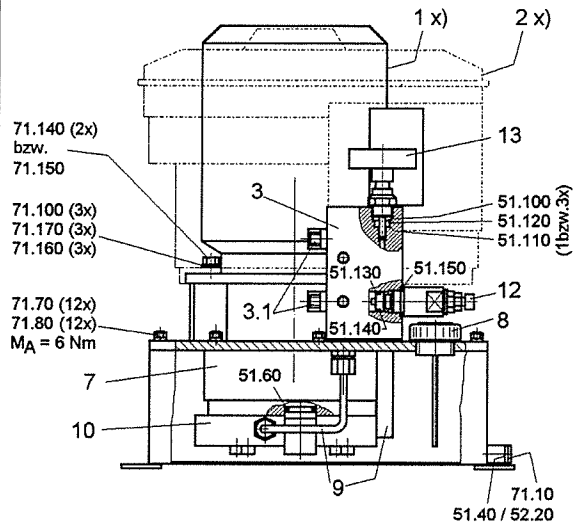
Pos. Item	Bestellbezeichnung	Description	Bestellnr. Ref. no.	Menge / Quantity						lieferb. avall.
				Gültig für / valid for:	84150/0813SP	84150/0813	84150/086	84150/0820	84150/0866	
1	Griffrohr	handle pipe	84150/0818-11	1	1	1		1	1	XX
	Griffrohr	handle pipe	84150/9-0823				1			XX
2	Sterngriff, schwarz	star grip, black	84150/0816-01	1	1	1				XX
	Sterngriff, schwarz	star grip, black	84150/0820-02				1			XX
	Sterngriff, rot - EN	star grip, red - EN	84150/0816-11					1	1	XX
3	Isolierscheibe	insulating disk	84150/0816-07	1	1	1		1	1	XX
4	Isolierrohr	insulating pipe	84150/0816-08	2	2	2		2	2	XX
5 *	Spannhülse DIN 1481-2,5x18	tightening sleeve 2,5x18	KT 4840 14 100				1			--
(8)	Schraube DIN 7985-M3x6	screw M3x6	KT 4062 51 300	2	2	2	2	2	2	--
9.1 *	Sieb PH03.27	sieve PH03.27	KT 1492 48 294	1	1	1	1	1	1	XX
9.2 *	Sprengring DIN 7993-B10-BRAF	spring ring B10-BRAF	KT 4766 01 020	1	1	1	1	1	1	--
9.5 *	Kugel DIN 5401-2mm	ball -2mm	KT 1490 55 011	2	2	2	2	2	2	--
9.6 *	Quadring 4012A-366Y	sealing ring 4012A-366Y	KT 1495 14 925	2	2	2	2	2	2	--
9.7 *	Spannhülse DIN 1481-3x6	tightening sleeve 3x6	KT 4840 16 500	1	1	1	1	1	1	--
9.8 *	Spannhülse DIN 1481-3x14	tightening sleeve 3x14	KT 4840 16 900	1	1	1	1	1	1	--
11.1	Schaltsegment	shifting quadrant	84150/0816-02	1	1	1	1	1	1	XX
11.3 *	Spannhülse DIN 1481-3x22	tightening sleeve 3x22	KT 4840 17 300	1	1	1	1	1		--
11.4 *	Spannhülse DIN 1481-2,5x16	tightening sleeve 2,5x16	KT 4840 14 000				1			XX
12.1	Rückschlagventil kpl.	check valve cpl.	84150/0815	2	2	2	2	2	2	XX
12.2	Aufsteuerkolben kpl.	control piston cpl.	84150/2-0554	1	1	1	1	1	1	XX
13 *	O-Ring 5x1,5 - NBR 90	o-ring 5x1,5 - NBR 90	KT 1500 40 707	6	6	6	6	6	6	--
(14)	Schraube DIN 912-M6x45-8.8-A2E	screw M6x45-8.8-A2E	KT 4110 24 600	2	2	2		2	2	--
	Schraube DIN 912-M6x30-8.8-A2E	screw M6x30-8.8-A2E	KT 4110 24 300				2			--
(15)	Schraube DIN 912-M5x40-12.9-A2E	screw M5x40-12.9-A2E	HR 4110 20 540	4	4					--
	Schraube DIN 912-M5x60-8.8-A2E	screw M5x60-8.8-A2E	KT 4110 20 900				4			--
	Schraube DIN 912-M6x85-8.8-A2E	screw M6x85-8.8-A2E	KT 4110 25 400			2			2	--
16	Schenkelfeder, inkl..	spring, incl.	V84150/0816-03	1	1	1	1	1	1	XX
16.1	Federlager	spring bearing		1	1	1	1	1	1	--
*	Bestandteil des Ersatzteilbeutels	* component of spare parts bag	84150/0819-99	1	1	1	1	1	1	XX
()	Bestandteil des Normteilkpakets	() component of standard parts bag	84150/0819-96	1	1			1		XX
			84150/6086-96			1			1	XX
			84150/0834-96				1			XX

Bei Bestellung Bestellbezeichnung und Bestellnummer angeben. · When ordering please indicate description and ref. no.
Nur Ersatzteile und Teile mit XX sind einzeln lieferbar. · Only spare parts and parts with XX are available as single parts.


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x) Hinweis:
Motor vor dem Festziehen
der Schrauben einmal auf
dem Pumpenträger um
360° gedreht.
Remark:
Rotate motor once for 360°
on the pump support before
tightening screws.

**PO6-LSI-10-50
GO6-LSI-10-50**



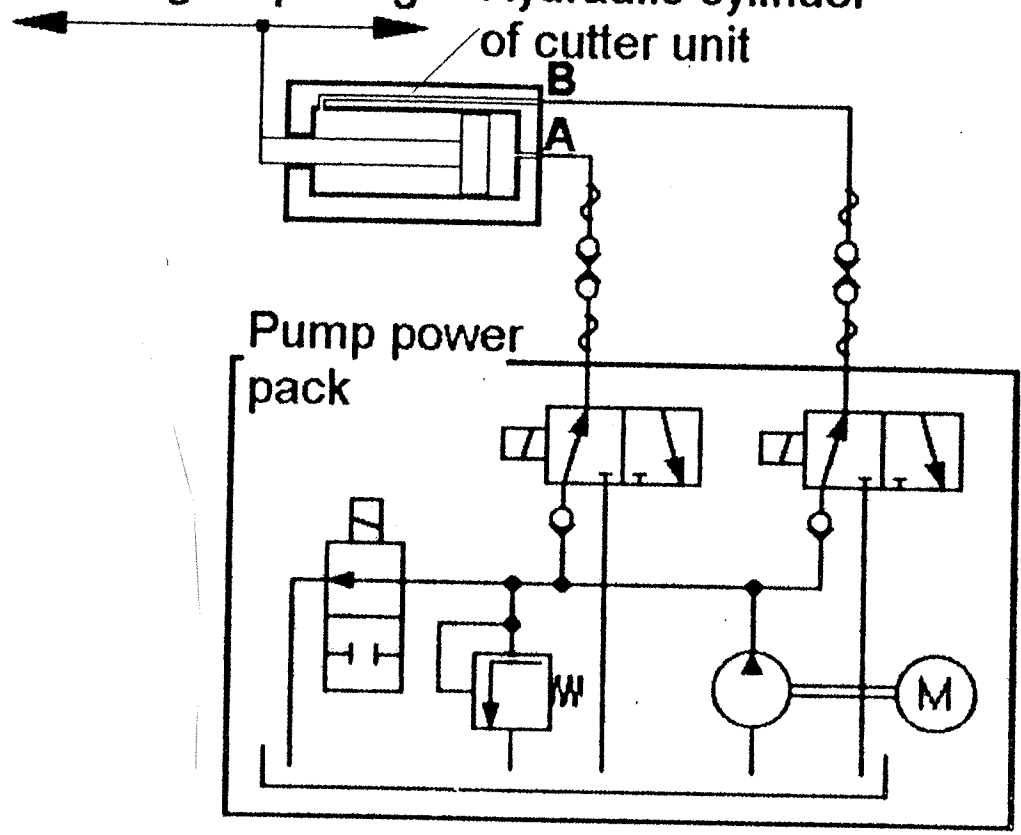
**PO6-LSI-25-50
GO6-LSI-25-50**

		Ersatzteilliste / Spare parts list		84112/5646-88								
		Recycling - Aggregat Baureihe 6 - LSI		Ausgabe / Issue 03.00								
		Recycling Power packages series 6 - LSI										
							Menge/Quantity					
							84112/56..					
							PO6-LSI-10-50 ..46	GO6-LSI-10-50 ..47	PO6-LSI-25-50 ..48	GO6-LSI-25-50 ..49		
Pos. Item	Bestellbezeichnung	Description	Bestellnummer Ref. no.							DM/Stück DM/piece		
1	Einh. Motor 1,5kW 230/50-3000, kpl.	single phase motor, cpl.	V84112/5601-10	1		1				XX		
2	Benzinmotor 3,35 kW	gasoline engine	V84150/7621-10		1		1			XX		
3	Ablaßventil 1E kpl.	drain valve 1E cpl.	V84112/0702	1	1	1	1			XX		
3.1	Nippel G1/4 / M14x1,5	nipple G1/4 / M14x1,5	84071/2-3380	2	2	2	2			--		
5	Pumpenträger, kpl.	pump plate, cpl.	V84150/7601-02	1	1	1	1			XX		
6	Öbehälter 10l, kpl.	oil container 10l, cpl.	V84150/7601-01	1	1					XX		
	Öbehälter 25l, kpl.	oil container 25l, cpl.	V84072/9230-99			1	1					
7	RK-Pumpe RK2-12/3,3+2-8/1,5, kpl.	radial piston pump, cpl.	V84136/1409	1	1	1	1			XX		
8	Einfülldeckel mit Ölmeßstab (10l)	filling cap with dipstick (10l)	V84150/7601-04	1	1					XX		
	Einfülldeckel mit Ölmeßstab (25l)	filling cap with dipstick (25l)	V84150/7801-11			1	1			XX		
9	Verrohrung, kpl. (10l)	pipe, cpl. (10l)	V84150/7601-06	1	1					XX		
	Verrohrung, kpl. (25l)	pipe, cpl. (25l)	V84150/7801-06			1	1			XX		
10	Druckschaltventil, kpl.	pressure valve, cpl.	V84136/0039	1	1	1	1			XX		
11	Kupplung E, kpl.	coupling, cpl.	V84136/0867-03	1		1				XX		
	Kupplung B4, kpl.	coupling, cpl.	V84136/0868-04		1		1			XX		
12	Druckbegrenzungsventil DVB06DRE/500	pressure relief valve	V84132/7005	1	1	1	1			XX		
13	Ablaßschraube, kpl.	drain screw, cpl.	V84072/0285-20	1	1	1	1			XX		
	hierzu Montagewerkzeug Pos.91 erforderlich / for assembly mounting tool 91 is required											
16	Saugstutzen	suction pipe	V84072/9230-08			1	1					
51	Ersatzteilbeutel Aggr. Baureihe 6	spare parts bag power pack. series 6	84112/5601-99	1	1	1	1			XX		
52	Ersatzteilbeutel Ölbehälter	spare parts bag oil container	84150/7601-98	1	1	1	1			XX		
71	Normteipaket Aggr. Baureihe 6	stand. parts bag pow. pack. ser. 6	84112/5601-96	1	1	1	1			XX		
91	Montagewerkzeug für Nutring	mounting tool for grooved ring	84072/0296	1	1	1	1			XX		

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Cutting Opening Hydraulic cylinder of cutter unit



Hydraulic diagram

