

# **FASCUT<sup>®</sup>**

## **Model FC-800 Rebar Cutter** **Serial # 1069 and up**



## **INSTRUCTION MANUAL**

Built in the U.S.A. – Since 1979

**FASCUT<sup>®</sup>** Industries, 7248 Inama Rd., Sauk City, WI 53583

Phone: (608) 643-6678

Fax: (608) 643-2682

Website: [www.fascut.com](http://www.fascut.com)

Email: [info@fascut.com](mailto:info@fascut.com)

# INTRODUCTION

**FASCUT®** incorporates a rugged alloy cast cutting head with a hydraulic cylinder and two stage hydraulic pump. By following the enclosed instructions and maintenance schedule, your **FASCUT®** machine will provide you with years of trouble free service.

**WARNING: DO NOT** attempt to operate until you have read thoroughly and understand completely all instructions, rules, etc., contained in this manual. Failure to comply can and may result in accidents involving fire, electric shock, or serious personal injury. Maintain this instruction manual and review it frequently for continuing safe operation and instructing new or possible third-party users.

**DO NOT: TURN ON MACHINE BEFORE REMOVING THE SHIPPING PLUG ON THE TOP OF THE OIL RESOVOIR AND REPLACING IT WITH THE SUPPLIED BREATHER CAP. FAILURE TO DO THIS WILL RESULT IN DAMAGE TO THE MACHINE!**

**ALWAYS:** wear safety glasses when operating. **ALWAYS:** keep fingers away from cutting blades.

## **Model FC-800 Portable Cutter -- Specifications**

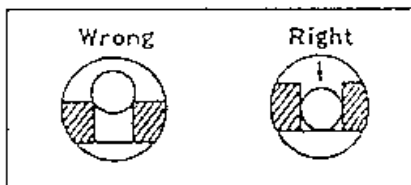
Shear Capacity Grade 60 (420 MPa)	1 bar - #8 (1") 25mm, #7 (7/8") 22mm, or #6 (3/4") 19mm 2 bars - #5 (5/8") 16mm 3 bars - #4 (1/2") 13mm 4 bars - #3 (3/8") 10mm
Shear Method	Open Jaw Shear
Shear Time	Approx. 2 to 4 seconds
Dimensions (L x W x H)	26" x 13" x 19" 66cm x 33cm x 48cm
Weight	190 pounds / 86kg; built in carrying handles
Power Supply	Two stage hydraulic pump driven by a one (1) hp. continuous duty electric motor
Voltage / Amps	110-120 volts @ 15 amps – 50/60 Hz, single phase 220-240 volts @ 7.5 amps – 50/60 Hz, single phase

# NORMAL OPERATION

1. **ALWAYS WEAR SAFETY GLASSES** when operating.
2. **ALWAYS KEEP FINGERS AWAY** from cutting blades.
3. **PLUG UNIT INTO** a 110-120Volt outlet on a circuit with no less than a 20 amp breaker. When using an extension cord, never use less than 12-guage wire. Excessive voltage drop at the unit will cause the motor to burn out.

## *Or if 220 Volt*

- WIRE UNIT TO** a 220-240 Volt, 50/60 cycle, 1 phase power source. Unit will draw approximately 8 amps. When using an extension cord, never use less than 14-guage wire. Excessive voltage drop at the unit will cause the motor to burn out.
4. **GENERATOR MUST BE 5000 WATTS OR LARGER.** Disable idle down feature so generator engine is running at operating speed when turning on rebar cutter.
  5. **TURN ON** using the toggle switch. In cold weather operations (below 32 deg. F), turn unit on and allow to warm up for 5 to 10 minutes before using.
  6. **ALWAYS TURN OFF** unit when not in use. **DO NOT** allow unit to idle for long periods of time.
  7. **KEEP IN UPRIGHT POSITION** to prevent loss of hydraulic oil from the oil tank breather cap.
  8. **TO CUT** a bar or bars, position bar between cutting blades. Bar must rest on the bottom of the cutter opening as shown on the diagram below. Adjust the support on the right side so the bar is held at 90 degrees to the cutting blades. Press the green button until cut is made and then release. **DO NOT CUT VERY SHORT PIECES** (3" OR SHORTER) as they could fly out and cause personal injury to you or someone located close to you.
  9. **USE TYPE 801** cutting blade when cutting a lot of #3 or #4 bar. Your cutting times will be faster because the cutter takes less time to advance and make contact with the bar. Replace the regular 800 type cutting blade for the type 801 cutting blade in the **STATIONARY POCKET**.



## ROUTINE MAINTENANCE

- 1) **DRAIN & REPLACE HYDRAULIC OIL** at least once each year or 200 operating hours, whichever comes first. Allow unit to run for five minutes before draining to warm up the oil. To remove the oil tank cover, remove hold down nuts with a 7/16" wrench. Remove drain plug to drain oil. Remove breather cap to fill. Leave one (1) inch of air in the tank. **DO NOT OVERFILL**. Ease the breather cap back into the hole taking care not to push the rubber grommet into the tank. Replace oil tank cover. Use good quality hydraulic oil with a rating of **ISO-VG 46** for general year round use. Use heavier ISO VG-68 for continuous hot weather operation. The unit will take approximately 6 quarts of oil to refill.

***Failure to re-install the breather cap will result in damage to the machine.***

- 2) **GREASE** through grease fitting on the left side of the cutter head before **EACH** use period. Re-bar scale will quickly dry up grease. Removal of this scale and lubricating often will help to reduce wear.

***Failure to remove excessive scale and lubricate machine regularly, will result in increased wear and reduced life of the machine.***

- 3) **TIGHTEN** blade securing hex bolts with the supplied Allen wrench before each use period.

***Failure to keep cutting blades securing hex bolts tight at all times could result in injury to the operator and/or damage to the machine.***

- 4) **CUTTING BLADES** have 4 indexable cutting edges. When one set of edges is worn out, simply remove blade securing bolts and rotate to a new edge. If old edge has mushroomed slightly, grind flat before installation to achieve proper "seating" of the blade in its new position.

***Do not attempt to re-sharpen worn edges. Resharpener changes the dimension of the blades, causing them to not seat properly and damage the blade holding socket.***

# OPTIONS

## REFERENCE FENCE ATTACHMENT

The reference fence attachment provides the operator with an adjustable material stop for cutting uniform lengths. It can be set out to a maximum of approx. 4 feet.

### ASSEMBLY

Bolt the fence bracket to the end of the steel bar using the bolt included with the bracket. Next, slide the bar through the holder rings on the machine frame from the LEFT side. Tighten the thumb screw on the holder after adjusting for desired length.

## FOOT PEDAL CONTROL

The Foot Pedal comes fully assembled and pre-wired. It can be plugged in at any time.

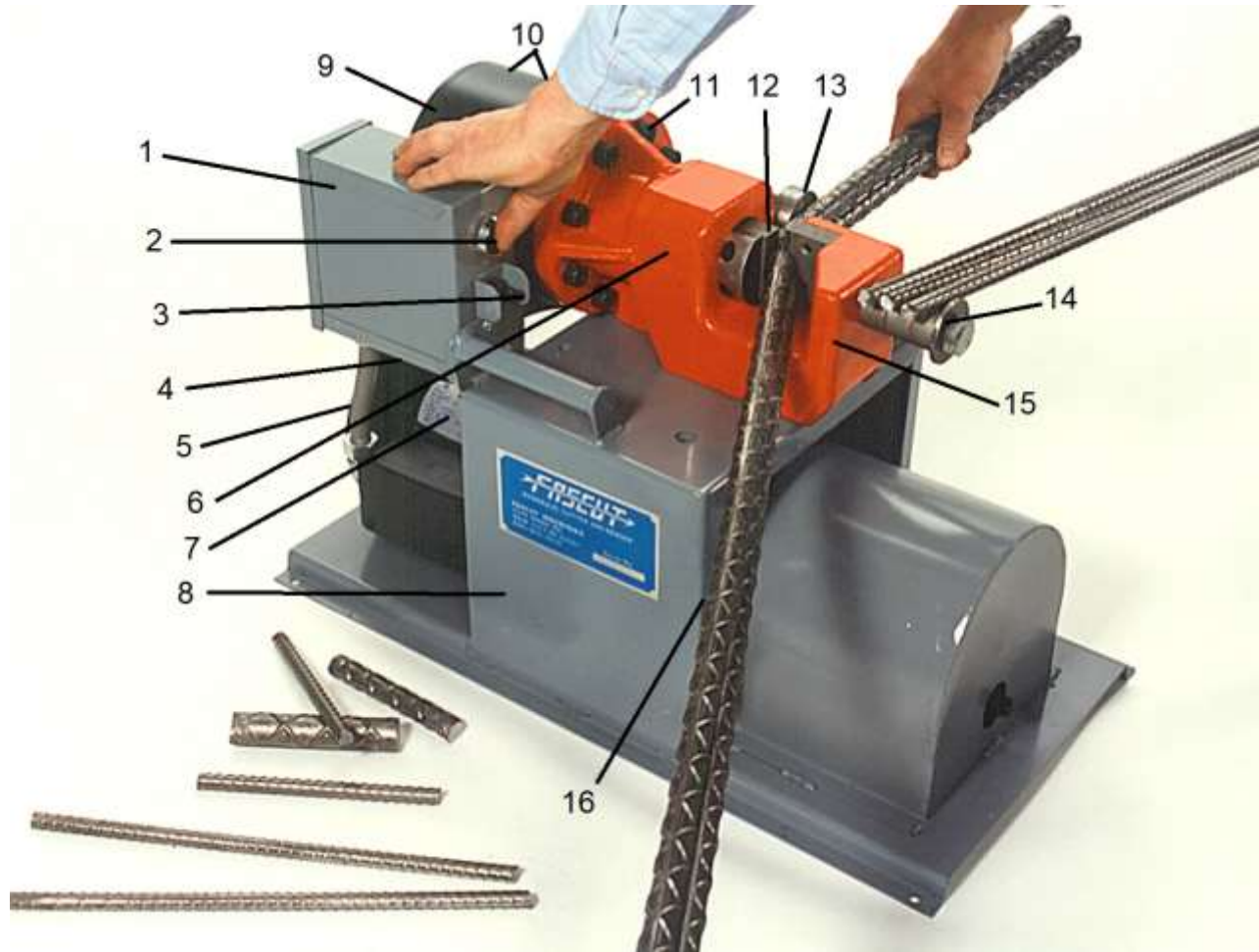
A jack is provided on the underside of the electric box. Push the plug into the jack until it locks in place. To remove, just push the release button on the jack.

When the foot pedal is plugged in, both the push button on the machine and the foot pedal will control the machine.



**Note:**      *Extra caution must be observed when using the foot pedal to keep fingers away from cutting blades.*

**Never:**     *Have one person work the foot pedal or push button while another is feeding rebar into the machine.*



## FC-800 PARTS BREAKDOWN

### Serial # 1069 and up

Prices subject to change without notice. Jan 1, 2019

Index #	Description	Part #	Price/ea.
1	Electric Box only, 110-v	66745	73.65
	Electric Box only, 220-v	66746	86.05
2	Push button control	76882	25.50
3	On/Off switch – 110-v	76619	8.12
	On/Off switch – 220-v	76620	9.60
4	Foot pedal socket	72373	23.66
5	Power cord w/plug – 110-v	76745	12.28
6	Grease fitting, straight	82547	1.24
7	Hydraulic Power unit (complete)	73407	1550.00
8	Frame	80611	208.00
9	Hydraulic Cylinder – see breakdown		
10	Fitting, Elbow (SAE) (2 req'd)	73112	17.52
11	Cylinder mount bolt & lock washer (8 req'd)	80705	1.20

12	Cutting blade set w/bolts & lockwashers	FAS800	85.00
	Cutting blade type 801 w/bolts & lw	FAS801	64.00
13	Bar support – adjustable	80715	21.00
14	Bar rest	80710	13.80
15	Cutter Head Casting (FC800)	80701	748.00
16	Allen wrench (1/4")	80310	3.36
	Foot Pedal Control	72365	129.00
	Foot pedal cord w/plug	72369	27.50

# Cutter Head and Hydraulic Cylinder

## Breakdown B





# FASCUT™ Model FC-800

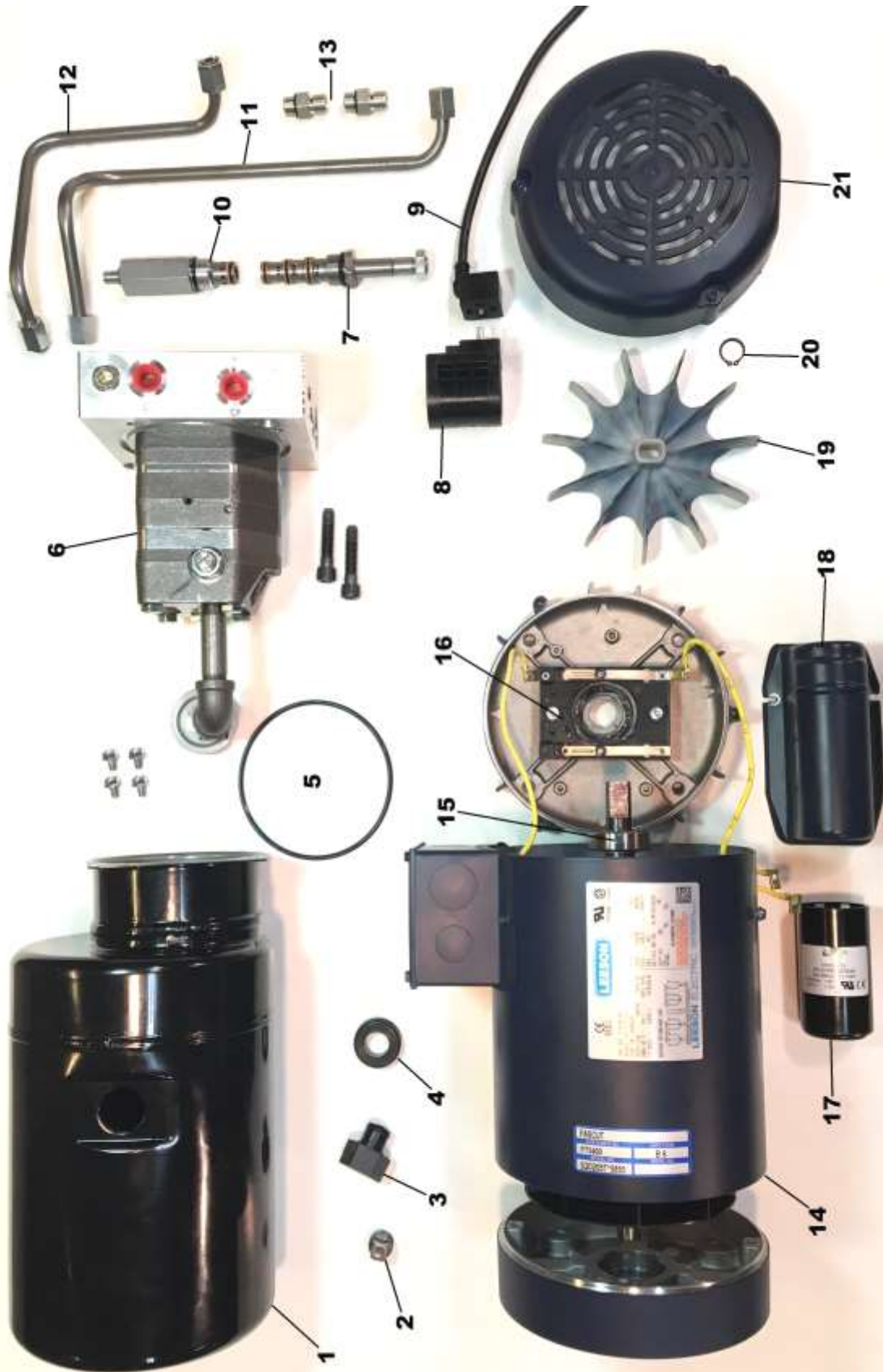
## Parts List

### Cutter Head and Hydraulic Cylinder Breakdown B

Prices subject to change without notice. Jan 1, 2019

Index #	Description	Part #	Price/ea.	Qty Req'd
	Hydraulic cylinder – <b>Complete</b> Includes: #1, #2, #4, #5, #6, #7	80430	711.00	
1	Cylinder body w/back plate	80432	434.00	1
2	Piston & rod assy. w/seal and loader	80434	310.00	1
3	Piston seal w/square loader ring	80436	34.90	1
4	Back body seal	80438	9.00	1
5	Nylon bearing	80440	4.95	1
6	Rod seal	80442	15.50	1
7	Key, 1/2" sq. #918 and up	80451	14.50	1
	Key, 1/2" sq. #917 and down	80452	14.50	1
8	Cutter head casting (FC800)	80701	748.00	1
9	Cylinder to cutter head bolts/lock washers	80705	1.20	8
10	Bar rest	80710	13.80	1
11	Bar support (adjustable)	80715	21.00	1
12	Safety cover plate	80720	27.64	1
13	Safety decal for cover plate	78643	.98	1
14	Safety cover plate attach bolt/washer	80724	.15	2
15	Grease fitting – straight	82547	1.24	1
16	Cutting blades 800 type / set	FAS800	85.00	1
special	Cutting blade 800 chain modified	FAS800CM	62.50	1
special	Cutting blade 801 type	FAS801	64.00	1
special	Cutting blade 801 chain modified	FAS801CM	84.00	1
17	Blade bolts & lockwashers / set	FAS800b	2.30	1
	<b>Special tools for cylinder dis-assembly</b>			
	Spanner wrench – flat	80461	15.00	

## Breakdown C



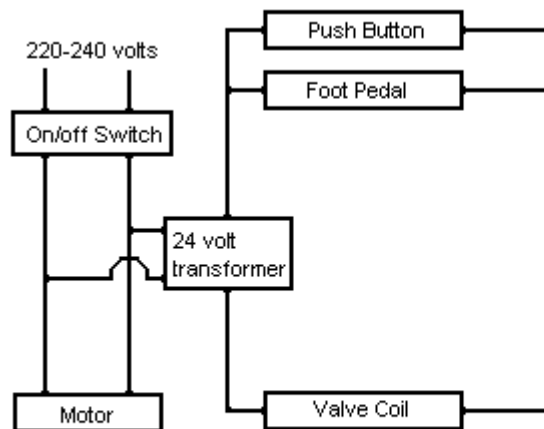
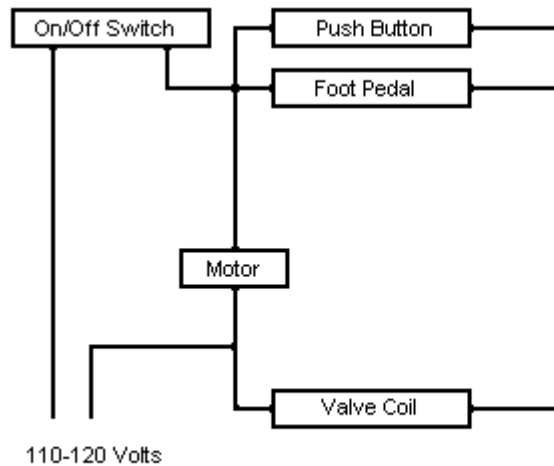
# **FASCUT™**    **Model FC-800 Rebar Cutter**

## **Hydraulic Power Unit** **Breakdown C** **serial # 1069 and up**

Prices subject to change without notice. Jan 1, 2019

<b>Index #</b>	<b>Description</b>	<b>Part #</b>	<b>Price/ea.</b>
1	Oil Tank, steel	76407	89.00
2	Oil tank drain plug	76245	.79
3	Breather cap	71063	9.00
4	Breather cap grommet	71064	2.70
5	Oil tank o-ring (steel tank) (serial #1074 and up)	76423	9.00
	Oil tank o-ring (plastic tank) (serial #1069 – 1072)	76424	9.00
6	Hydraulic Pump/valve block	73425	634.00
7	Valve, directional #8 (serial #1069 – 1072)	78920	94.35
	Valve, directional #10 (serial #1074 and up)	78921	94.35
8	Valve coil, 110-v, #8 (serial #1069 – 1072)	78935	71.40
	Valve coil, 110-v, #10 (serial #1074 and up)	78936	71.40
	Valve coil, 24-VAC for 220-v units (serial #1074 and up)	78934	71.40
9	Valve coil cable	78940	27.48
10	Valve, pressure shut down	78989	102.11
11	Rear pressure tube w/nuts-ferrules (serial #1069 – 1072)	67951	12.60
	Elbow fitting (SAE) for serial #1069 – 1072. (not shown on breakdown)	73112	17.52
	Rear pressure tube w/nuts-ferrules (serial #1074 and up)	67953	12.60
12	Front return tube w/nuts-ferrules (serial #1069 – 1072)	67927	12.60
	Elbow fitting (NPT) with SAE extension for serial #1069 – 1072. (not shown on breakdown)	73114	19.65
	Front return tube w/nuts-ferrules (serial #1074 and up)	67929	12.60
13	Fitting, straight connector (SAE) (serial #1074 and up) (two required)	73119	15.20
14	Electric Motor	75703	673.00
15	Motor shaft bearing (2 req'd)	75872	16.02
16	Motor starting switch	75890	29.50
17	Motor starting capacitor (540-648 uf)	77256	18.07
18	Motor starting capacitor cover	77255	26.45
19	Motor fan	75736	27.09
20	Motor fan retaining ring	75737	.50
21	Motor fan guard	75723	37.62

## WIRING DIAGRAMS



The on/off switch turns power on to both the electric motor and the valve coil circuit. The switch must be 1 HP rated.

Pressing the push button or foot switch completes the circuit to energize the valve coil which makes the hydraulic cylinder extend out to make a cut.

## TROUBLESHOOTING FC-800 Rebar Cutter

<b>TROUBLE</b>	<b>PROBABLE CAUSE</b>	<b>REMEDY</b>
<b>Motor will not start</b>	<ol style="list-style-type: none"> <li>1. No power to unit.</li> <li>2. Power cord or plug damaged.</li> <li>3. On/off switch bad.</li> <li>4. Motor wire connections loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check supply cord, fuses, or circuit breaker.</li> <li>2. Replace power cord w/plug.</li> <li>3. Replace on/off switch.</li> <li>4. Tighten motor wire connections.</li> </ol>
<b>Motor hums, then blows circuit breaker, or motor is smoking</b>	<ol style="list-style-type: none"> <li>1. Extension cord too long or not heavy enough.</li> <li>2. Starting capacitor bad.</li> <li>3. Starting switch bad.</li> <li>4. Generator too small.</li> <li>5. Generator running at idle before starting unit.</li> <li>6. Motor windings burnt out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Extension cord must be min. 12 gauge wire and no longer than 100 feet.</li> <li>2. Replace starting capacitor.</li> <li>3. Replace starting switch.</li> <li>4. Use a 5 KW generator or larger.</li> <li>5. Turn off or disconnect idle down feature.</li> <li>6. Replace motor.</li> </ol>
<b>Motor runs, but nothing happens when push button is depressed.</b>	<ol style="list-style-type: none"> <li>1. Push Button is bad.</li> <li>2. Loose wire.</li> <li>3. Valve coil is bad.</li> <li>4. Directional valve is bad.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace push button.</li> <li>2. Check all wiring for loose connections.</li> <li>3. Replace valve coil.</li> <li>4. Replace directional valve.</li> </ol>
<b>Foot Pedal does not work. (push button does)</b>	<ol style="list-style-type: none"> <li>1. Foot pedal cord or plug is damaged.</li> <li>2. Jack is bad.</li> <li>3. Switch inside foot pedal is bad.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace foot pedal cord w/plug.</li> <li>2. Replace jack.</li> <li>3. Replace inside switch.</li> </ol>
<b>Cutting blade bolts breaking</b>	<ol style="list-style-type: none"> <li>1. Cutting blade bolts are loose.</li> <li>2. Cutting blades are dull.</li> <li>3. Blade socket is deformed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Retighten blade bolts regularly.</li> <li>2. Turn blades to new cutting edge or replace blades.</li> <li>3. Replace casting or piston and rod assembly.</li> </ol>

<b>Cutting blades breaking</b>	<ol style="list-style-type: none"> <li>1. Blades are dull.</li> <li>2. Blade bolts are loose.</li> <li>3. Rebar is being dropped into the cutter.</li> <li>4. You are cutting "no grade" steel</li> <li>5. Bar is being cut on the top corner of the cutting blade</li> </ol>	<ol style="list-style-type: none"> <li>1. Turn blades to a new edge sooner.</li> <li>2. Check blade bolts for tightness more often.</li> <li>3. Place rebar into the cutter with greater care.</li> <li>4. Only cut grade 40 or grade 60 rebar.</li> <li>5. Bar must rest on the bottom of the cutter opening.</li> </ol>
<b>Oil is leaking</b>	<ol style="list-style-type: none"> <li>1. Hydraulic tubes and fittings are loose or damaged.</li> <li>2. Hydraulic cylinder body seals or rod seal is leaking</li> </ol>	<ol style="list-style-type: none"> <li>1. Check fittings for tightness. Replace damaged fittings or tube.</li> <li>2. Install new body and/or rod seals in hydraulic cylinder.</li> </ol>
<b>Cutting is slow and lacks power</b>	<ol style="list-style-type: none"> <li>1. Oil level is low.</li> <li>2. Oil is contaminated.</li> <li>3. Hydraulic pump is worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Add oil to tank.</li> <li>2. Drain and refill oil tank with fresh ISO-46 hydraulic oil.</li> <li>3. Replace hydraulic pump.</li> </ol>

## **FASCUT® Industries, Inc.**

### **LIMITED WARRANTY**

This product has been thoroughly inspected and tested before leaving the factory. It is guaranteed against defective workmanship and materials for a period of 1 year to the original owner. Should any trouble develop, return defective part transportation prepaid to the factory. If inspection shows trouble is caused by defective workmanship or material, all repairs will be made without charge and returned, transportation prepaid. The guarantee does not apply where: repairs or attempted repairs have been made by persons other than the factory; repairs are due to normal wear; the tool has been abused or in an accident; misuse is evident – caused by overloading the tool beyond its rated capacity; use on improper voltage or current; use of the tool after partial failure or use with improper accessories.

This warranty is in lieu of all other warranties, expressed or implied, and there are no warranties on merchantability or fitness for a particular purpose. In no event shall seller be liable for incidental, consequential or special damages. This warrantee is void if Warrantee/Registration card is not filled out and returned. This warranty gives you specific legal rights, and you may also have other rights, which vary from state to state.

**SERIAL NUMBER** \_\_\_\_\_ **DATE** \_\_\_\_\_

**FASCUT® Industries, Inc.**  
7248 Inama Rd.  
Sauk City, WI 53583

Phone: (608) 643-6678  
Fax: (608) 643-2682

Website: [www.fascut.com](http://www.fascut.com)