HOLTE
MANUFACTURING

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CASING CUTTER
USER GUIDE

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CONSTRUCTION
ABOUT HOLTE CASING CUTTERS

HOLTE CASING CUTTERS are designed for cutting large steel pipe using a round cutting blade. The Casing Cutter can be lowered to the desired depth by threading the Casing Cutter to the end of drill pipe. Air pressure is used to activate the blade while rotating. Most cuts are made in under two minuets.

CONSTRUCTION

Holte Casing Cutter housings are made of a thick-gauge steel. Casing Cutters must be made very durable to withstand the extreme forces while cutting. Holte uses high quality alloy materials. Critical parts are heat treated, including the cutter blade.

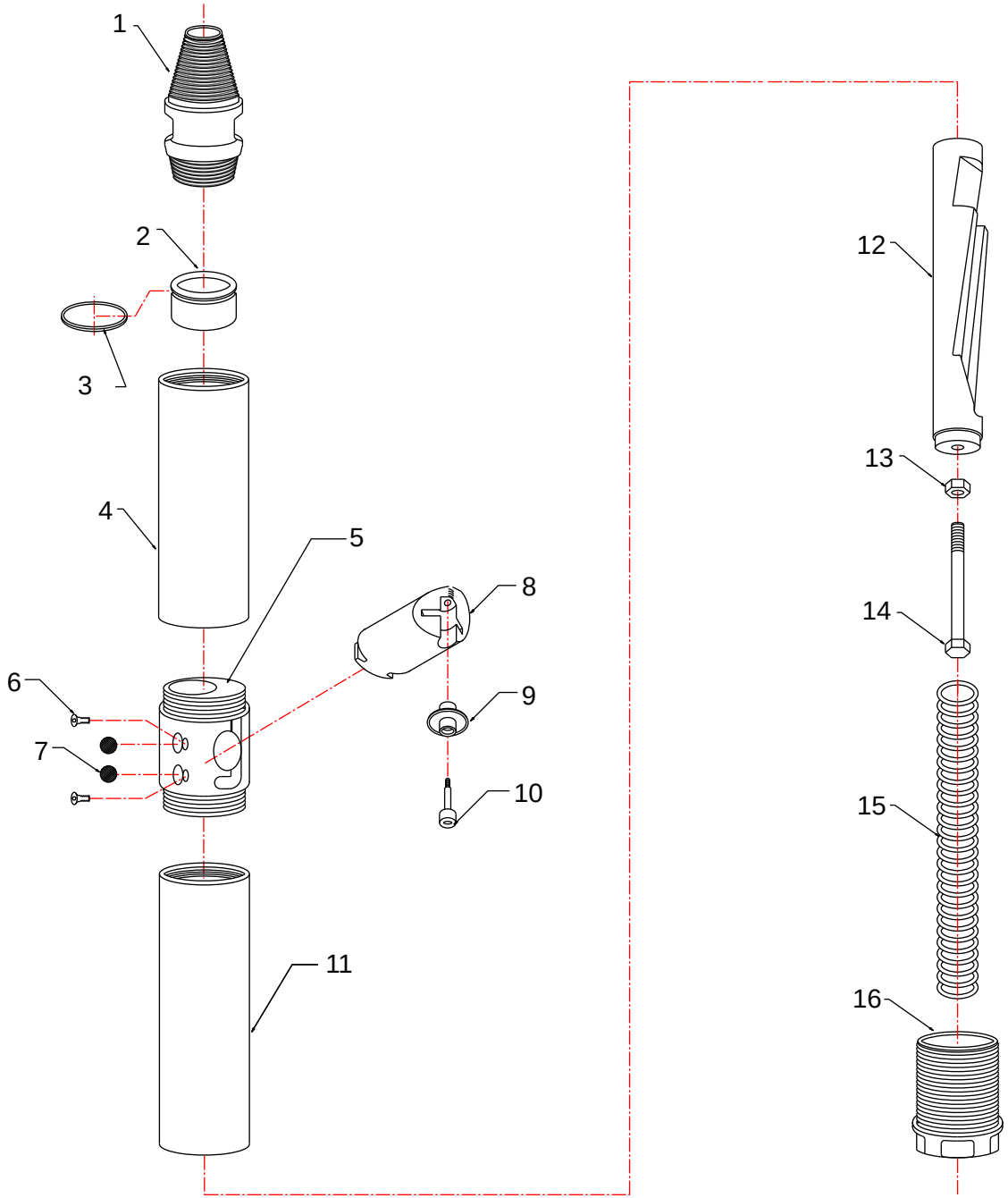
SIZES

Holte Manufacturing makes Casing Cutters for 6” to 14” pipe. Custom sizes for 16” pipe and larger are also available. So far, Holte has made any size a customer has asked for, including a 28” Casing Cutter.

FAQ

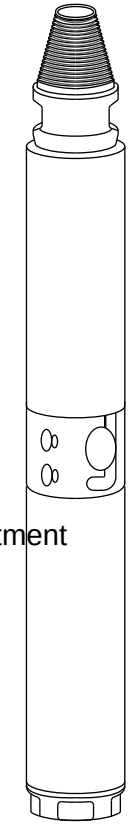
Q. How may cutter wheels/blades are in the Casing Cutter?
A. One
Q. How long will a cutter blade last?
A. Several cuts if you are carful but sometimes only one
Q. How do you know if the cutter blade needs replaced?
A. Visual inspection, see if the sharp edge is gone
Q. How long do the Roller Balls last?
A. Longer than the blades, they are hard chrome ball bearings
Q. How thick of pipe will the Casing Cutter cut?
A. 1/4” to 3/8”. Also ½” with special tooling
Q. What thread connector is at the top of the Casing Cutter?
A. 3 ½” API pin

Please send any questions to drilling@drilling.com.



PARTS LIST

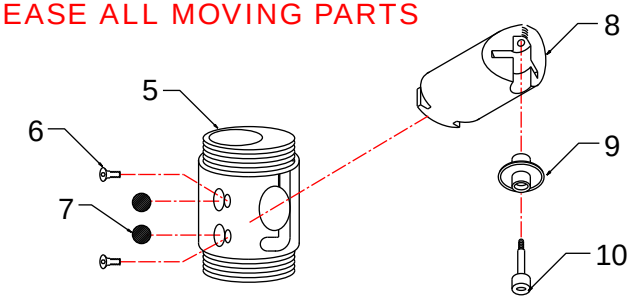
1.Top Pin Connector
2.Piston
3.Piston Seal
4.Cylinder Top Barrel
5.Main Center Body
6.Roller Ball Retainer Bolt
7.Roller Ball
8.Blade Holder Cross Slide
9.Cutter Blade
10.Cutter Blade Retaining Bolt
11.Spring Can Bottom Barrel
12.Vertical Slide
13.Locking Nut for stroke adjustment
14.Stroke Adjustment Bolt
15.Main Spring
16.Bottom Cap



ASSEMBLY
BOTTOM

Insert **Vertical Slide #12** from the bottom.

GREASE ALL MOVING PARTS



Look into hole opening to see the **Blade Holder Cross Slide #8**.

Rotate the **Vertical Slide #12** so the flat spot at the end of the track is centered in the opening.

ASSEMBLY
BOTTOM

Insert the **Blade Holder Cross Slide #8** into the pocket with the slope on the bottom matching the slope of the **Vertical Slide #12**.

Push the **Vertical Slide #12** upward and trap the Blade Holder Cross Slide #8 in the T-slot track.

The **Stroke Adjustment Bolt #14** is pre-adjusted and locked by the **Locking Nut #13** at the factory .

Screwing in the **Stroke Adjustment Bolt #14** a little further makes the cutter blade come out a little further.

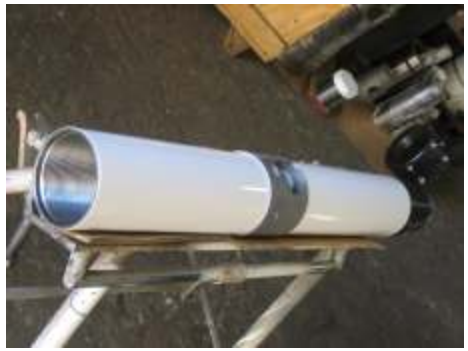
ASSEMBLY
TEST AND ADJUST

These parts should be oiled (Rock Drill oil works well).

Push the slide up and down to make sure it slides easily and the cutter blade goes in and out.

ASSEMBLY
BOTTOM

Screw on the **Spring Can Bottom Barrel #11**.



Insert **Main Spring #15**.

It may take two strong people to push the spring in and start threading the **Bottom Cap #16**. To change the blade, unscrew the Bottom Cap far enough to allow the **Vertical Slide #12** to be pushed down by air (or by broom stick) allowing the cross slide to be pulled out.

CAUTION: do not unscrew the Bottom Cap #16 all the way! It could surprise or injure you. The **Blade Holder Cross Slide #8** can be removed when the bottom cap is half way unscrewed.

OPERATING

MAKING A CUT

After the Casing Cutter is places at the desired depth, begin rotation before turning on the air. **Rotation speed** should not be over 12 RPM for 6" pipe and not more that 6 RPM for 12" pipe.

As air pressure builds, the Casing Cutter will be making it's cut through the pipe. The cut is often complete before the air reaches full **air pressure** which should be about 200 to 300 PSI. 150PSI will take perhaps 15 seconds longer.

HOW DO YOU KNOW WHEN THE PIPE IS CUT THROUGH?

You may see the pipe move or jerk. With thin wall pipe, the cut is usually made in less than one minute. Pipe has been cut in as little as 20 seconds. Thicker wall pipe like 3/8", may take 2 minutes. For pipe thicker than 3/8", consult with a Holte representative.

RETRACTING THE BLADE

Rotating with the air bled off will push the blade back into the Casing Cutter. Do this before pulling out of the hole.

STORING THE CASING CUTTER

It is important to remember that Casing Cutter might be stored long enough to rust, in between uses. You will thank yourself later when you take out a good working tool when you need it. There are 3 main areas to grease.

1. **Roller Ball Retainer Bolt #6**
2. **Roller Ball #7**
3. **Blade Holder Cross Slide #8**

If you disassemble your Casing Cutter, be sure to grease the threads as you put it back together.