

**ALLPAX**<sup>®</sup>  
GASKET CUTTER SYSTEMS

# Guide to Perfect Gaskets

**LIGHT DUTY GASKET CUTTER**  
CUT GASKETS UP TO 13" (330 mm) DIAMETER

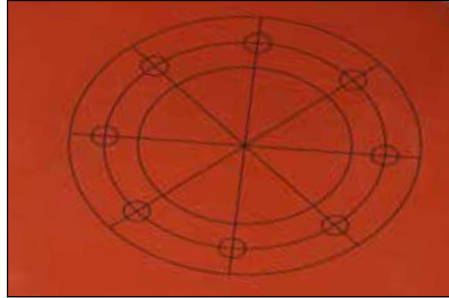


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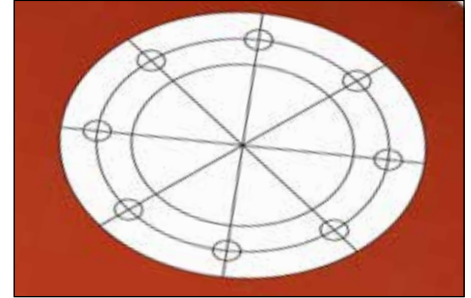
## CUT GASKETS UP TO 13" (330 mm) DIAMETER



**1.** If existing gasket is available, using a pencil or marker, trace outline onto gasket material.



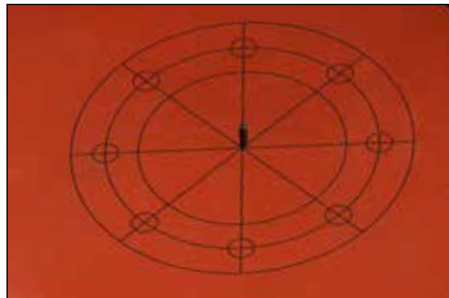
**2.** Otherwise, lay out outer diameter (OD), inner diameter (ID) and pitch circle diameter (PCD) directly onto gasket material. To determine bolt hole locations see **LAYING OUT GASKETS WITH BOLT HOLES**.



**3.** Another way to determine bolt hole locations is using a paper template with OD, ID and PCD. Transfer the bolt hole location center pins with piercing tool or pencil tip.



**4.** Create pilot hole by piercing center of gasket material with piercing tool.



**5.** Choose center pin approximately  $\frac{1}{2}$ " (12 mm) longer than thickness of gasket material. Push center pin through gasket material. Insert protruding center pin into recessed ferrule located in the center of cutting board. Lay gasket material flat on cutting board.



**6.** Loosen cutting blade thumb screw on cutter block. Position cutting blade to protrude slightly beyond thickness of gasket material. Tighten thumb screw.



**7.** Loosen top thumb screw. Slide pivot post indicator to desired OD on cutter block scale. Tighten top thumb screw.



**8.** Position pivot post hole over center pin. Ensure cutter block is lying flat on gasket material.



**9.** With slight downward pressure, rotate cutter block clockwise to make cut. Simultaneously press down on gasket material to prevent rotation.

## CUT GASKETS UP TO 13" (330 mm) DIAMETER (continued)



**10.** For thick or hard to cut gasket materials, make several shallow passes to complete through cut. Alternatively, cut halfway through gasket material, flip material over, and complete cut.



**11.** Punch out bolt holes using hole punch.



**12.** Loosen top thumb screw. Slide pivot post indicator to desired ID. Tighten top thumb screw.



**13.** Make ID finished gasket.

## CUT GASKETS UP TO 37" (940 mm) DIAMETER

**1.** Medium/Light duty gasket cutters accommodate multiple extension arms to increase effective cutting diameter:



**1 extension arm:** Up to 25" (635 mm) diameter.



**2 extension arms:** Up to 37" (940 mm) diameter.

## CUT GASKETS UP TO 37" (940 mm) DIAMETER (continued)



**2.** Completely unthread top thumb screw. Remove pivot post assembly. Remove bottom washer. Orient extension arm with hole labeled "pivot post hole" nearest cutting blade. Slide extension arm into groove on bottom of cutter block.



**3.** Insert pivot post through pivot post hole on extension arm and through cutter block. Slide washer onto pivot post. Thread knurled nut onto pivot post.



**4.** Gasket cutter can now cut up to 25" (635 mm) diameter. For example, cut 16" (406 mm) OD gasket by positioning pivot post indicator at 4" mark on cutter block scale (12" + 4" = 16").



**5.** To cut gaskets over 25" (635 mm) diameter, add additional extension arm(s). Unscrew plastic threaded cap at end of previously installed extension arm. Position dual holes of next extension arm above threaded post and sleeved stud. Secure with plastic threaded cap.



**6.** Position pivot post hole at tip of extension arm over center pin in gasket material. With the other hand, grip the cutter block, ensuring cutter block is lying flat on gasket material.



**7.** With slight downward pressure, rotate cutter block clockwise to make cut. Simultaneously press down on gasket material to prevent rotation.

# MEDIUM & LIGHT-DUTY GASKET CUTTER PARTS

**4000 & 3000 SERIES**

<b>PARTS*</b>			<b>4000 SERIES MEDIUM-DUTY KITS</b>					<b>3000 SERIES LIGHT-DUTY KITS</b>				<b>REPLACEMENT PART</b>
			<b>AX4000</b>	<b>AX4010</b>	<b>AX4020</b>	<b>AX4030</b>	<b>AX4040</b>	<b>AX3000</b>	<b>AX3010</b>	<b>AX3020</b>	<b>AX3030</b>	
<b>PRODUCT</b>	<b>PART #</b>	<b>DESCRIPTION</b>										
	AX3500	Standard-Duty Cutting Blades	1	1	1	1	1	1	1	1	1	6
	AX3501	Heavy-Duty Cutting Blades	1	1	1	1	1	1	1	1	1	6
	AX3510	1-9/16" Short Center Pins	1	1	1	1	1	1	1	1	1	6
	AX3511	1-7/16" Medium Center Pins	1	1	1	1	1	1	1	1	1	6
	AX3512	1-11/16" Long Center Pins	1	1	1	1	1	1	1	1	1	6
	AX3513	Disc Pins	0	0	0	0	0	0	0	0	0	6
	AX1633	18" x 18" Cutting Board: Center Pin Ferrules (2) installed	0	1	1	1	1	0	1	1	1	1
	AX1634	24" x 24" Cutting Board: Center Pin Ferrules (2) installed	0	0	0	0	0	0	0	0	0	1
	AX1640	30" x 30" Cutting Board: Center Pin Ferrules (2) installed	0	0	0	0	0	0	0	0	0	1
	AX3535	Extension Arm	0	0	1	2	3	0	0	1	2	1
	AX3550	Pivot Post Assembly	1	1	1	1	1	1	1	1	1	1
	AX1622	Piercing Tool	1	1	1	1	1	1	1	1	1	1
	AX1613	Center Pin Ferrule	0	0	0	0	0	0	0	0	0	1

\*All parts fully compatible with Spearhead Model 777A and Model 747C gasket cutters formerly made by Zimmerman Packing & Manufacturing, Inc.

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47 VETERANS DRIVE, CHICOPEE, MA 01022 U.S.A.  
TEL: (413) 594-4400 • FAX: (413) 594-4884

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