

PELL HYDRASHEAR®  
DAPOC2500-94

2-1/2" CAPACITY DOUBLE ACTING  
POWER OPERATED WIRE ROPE CUTTER

OPERATORS MANUAL AND PARTS LIST

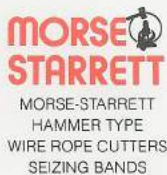
PELL HYDRASHEAR division of  
MORSE-STARRETT PRODUCTS CO.

184 NW 10<sup>TH</sup> ST.

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[www.morse-starrett.com](http://www.morse-starrett.com)



**MORSE-STARRETT PRODUCTS CO.**  
and  
**PELL CABLE CUTTER CO.**



HYDRAULIC CUTTERS  
FOR WIRE ROPE  
PRE-STRESSED STRAND  
REINFORCING BAR  
CHAIN

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The DAPOC2500-94 was designed to cut new and unused wire rope. The maximum capacity is 2-1/2". It is not designed to cut solid bar or rebar.

**Due to the work hardening of used cable, the operating life of the blade may be greatly reduced.**

The electric hydraulic pump is designed to operate at a maximum pressure of 10,000 psi. This unit has a 50 ton double acting cylinder that will cut 2-1/2" cable at about 6,000 psi in 40-45 seconds. A double acting cylinder is powered in both directions for a faster and more positive return.

**FOR SAFE OPERATION:**

**WEAR SAFETY GOGGLES WHEN OPERATING THE CUTTER**

**MONITOR PRESSURE GAUGE WHEN IN OPERATION**

**RELEASE CUTTING PRESSURE WHEN CUT HAS COMPLETED AND AFTER CYLINDER IS FULLY RETRACTED. OTHERWISE, PRESSURE WILL CONTINUE TO BUILD RESULTING IN POSSIBLE DAMAGE.**

**IT IS RECOMMENDED THAT THE OPERATOR BECOME FAMILIAR WITH THE DAPOC2500-94 PRIOR TO MAKING HIS FIRST CUT.**



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**SAFETY GOGGLES ARE REQUIRED WHEN  
OPERATING THE DAPOC2500-94 CABLE CUTTER**

1. Never leave the cutter unattended when it is in the process of cutting cable.
2. The DAPOC2500-94 cable cutter is supplied with an operator activated hand switch. **(DO NOT OPERATE WITHOUT USING THIS SWITCH)**. This switch is required to keep the operator alert and attending to any problems when the cutter is in use.
3. When cutting the maximum capacity cable, pressure should never exceed 7500 psi.
4. When pressure to cut 2-1/2" cable (maximum capacity) reaches 7000+ psi, the blade should be re-sharpened or replaced.
5. Dies in the shear blade holder (#43DA) should be inspected frequently and replaced as necessary.
6. Never attempt to operate the DAPOC2500-94 without the latch (#33DA) being firmly in place. Operating the cutter without the latch (#33DA) in place will cause damage to the blade (#4) and shear blade holder (#43DA).
7. Turn off the pump when the cutter is not in use.
8. **REPLACING THE BLADE:**
  - a. Remove hinge pin (#6) holding the shear blade holder (#43DA)/latch (#33DA) assembly and remove the assembly.
  - b. Under pressure, extend the ram so the blade pin (#5) hole is exposed. Using a 1/4" diameter rod, drive blade pin (#5) out far enough to release the blade (#4).
  - c. Insert new blade (#4), drive blade pin (#5) through hole, retract the cylinder and replace shear blade holder (#43DA)/latch (#33DA) assembly.

When re-sharpening the blade (#4), use a carbide or fine grinding wheel and re-sharpen to the same angle on blade. Pre-dull sharp edge for longer blade life.

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**Note: if the blade is too sharp, it will chip. Do not overheat the blade when sharpening.**

**9. REPLACING DIE SET:**

- a. Remove hinge pin (#6) from shear blade holder (#43DA) and place shear blade holder (#43DA) on solid surface.
- b. Remove guard plate (#42) from shear blade holder (#43DA). Through the slot in the back of the shear blade holder (#43DA), drive dies (#1) out with a 1/2" rod and small hammer.
- c. Using a hammer, drive the new dies (#1) into the slots in the shear blade holder (#43DA) by alternately hitting each end of the die (#1) so as to drive the dies (#1) into the shear blade holder (#43DA) evenly. Be sure the longer leg on the die (#1) matches the longer leg on the shear blade holder (#43DA). Re-attach the guard plate (#42).
- d. Be sure that when re-attaching the shear blade holder (#43DA) to the cutter, the longer leg is on the bottom of the cutter.

## **CYLINDER**

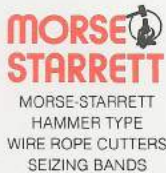
### **REMOVING THE CYLINDER:**

When removing the cylinder from the cutting head, unscrew the two 3/8" set screws (#48) from the head.

### **REPLACING THE CYLINDER:**

Thread in cylinder to the maximum stop on head, then back off the screw boss on the cylinder threads then tighten first 3/8" set screw to boss then lock in the second set screw.





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## **ATTENTION**

WHEN INSTALLING THE BLADE HOLDER (#45), IT IS VERY IMPORTANT TO ALIGN THE BLADE WITH THE CENTER OF THE SHEAR BLADE HOLDER (#43DA).

TO DO THIS, YOU MUST FIRST REMOVE THE SHEAR BLADE HOLDER (#43) AND THE LATCH (#33DA). THEN BOLT THE BLADE HOLDER (#45) ON THE RAM OF THE CYLINDER. AFTER THE BLADE HOLDER (#45) IS INSTALLED, THE BLADE (#4) CAN BE INSERTED AND SECURED WITH THE BLADE PIN (#5). AFTER THE BLADE (#4) IS SECURED WITH THE BLADE PIN (#5), THE RAM CAN BE TWISTED INTO POSITION BY USING A CRESCENT WRENCH ON THE BLADE (#4).

TWIST THE RAM UNTIL THE BLADE IS IN A VERTICAL POSITION THEN REINSTALL THE SHEAR BLADE HOLDER (#43DA) AND THE LATCH (#33DA).

MAKE SURE THAT THE BLADE (#4) IS IN A VERTICAL POSITION AND IN ALIGNMENT WITH THE CUTTING DIES (#1).

**IMPORTANT: DO NOT ATTEMPT TO OPERATE THIS CUTTER UNTIL THE BLADE HAS BEEN PROPERLY ALIGNED.**

**MISALIGNMENT OF THE BLADE CAN CAUSE DAMAGE TO THE CUTTER AND INJURY TO THE OPERATOR.**



MORSE-STARRETT  
HAMMER TYPE  
WIRE ROPE CUTTERS  
SEIZING BANDS

# MORSE-STARRETT PRODUCTS CO. and PELL CABLE CUTTER CO.

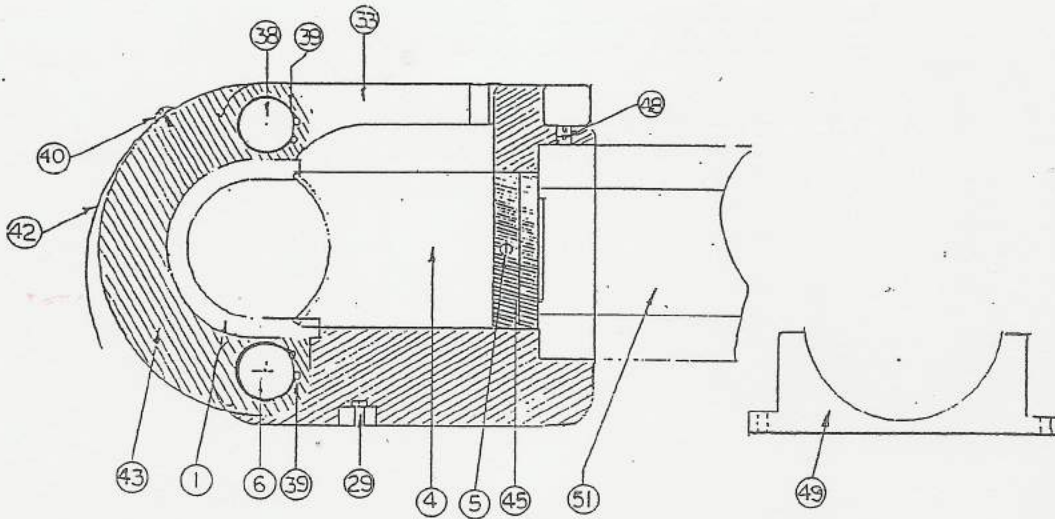
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PART NUMBER	DESCRIPTION
M-1	DIE SET
M-4	BLADE
M-5	BLADE PIN
M-6	HINGE PIN
M-29	HOLD DOWN BOLTS (2)
M-33DA	LATCH
M-38 & M-6	LATCH PIN & HINGE PIN
M-39	SNAP RINGS (4)
M-40	GUARD SCREWS (2)
M-42	GUARD PLATE
M-43DA	SHEAR BLADE HOLDER
M-45	BLADE HOLDER
M-48	CYLINDER LOCKING SCREWS (2)
M-49	CYLINDER SUPPORT
M-51	CYLINDER
M-82	HOSE SET
M-83	BASE PLATE
M-84	ELECTRIC PUMP
M-85	PRESSURE GAUGE WITH ADAPTER



To Protect Your Warranty, Use Only ENERPAC Hydraulic Oil.  
Enerpac recommends that all kit components be installed to insure optimum performance of the repaired product.

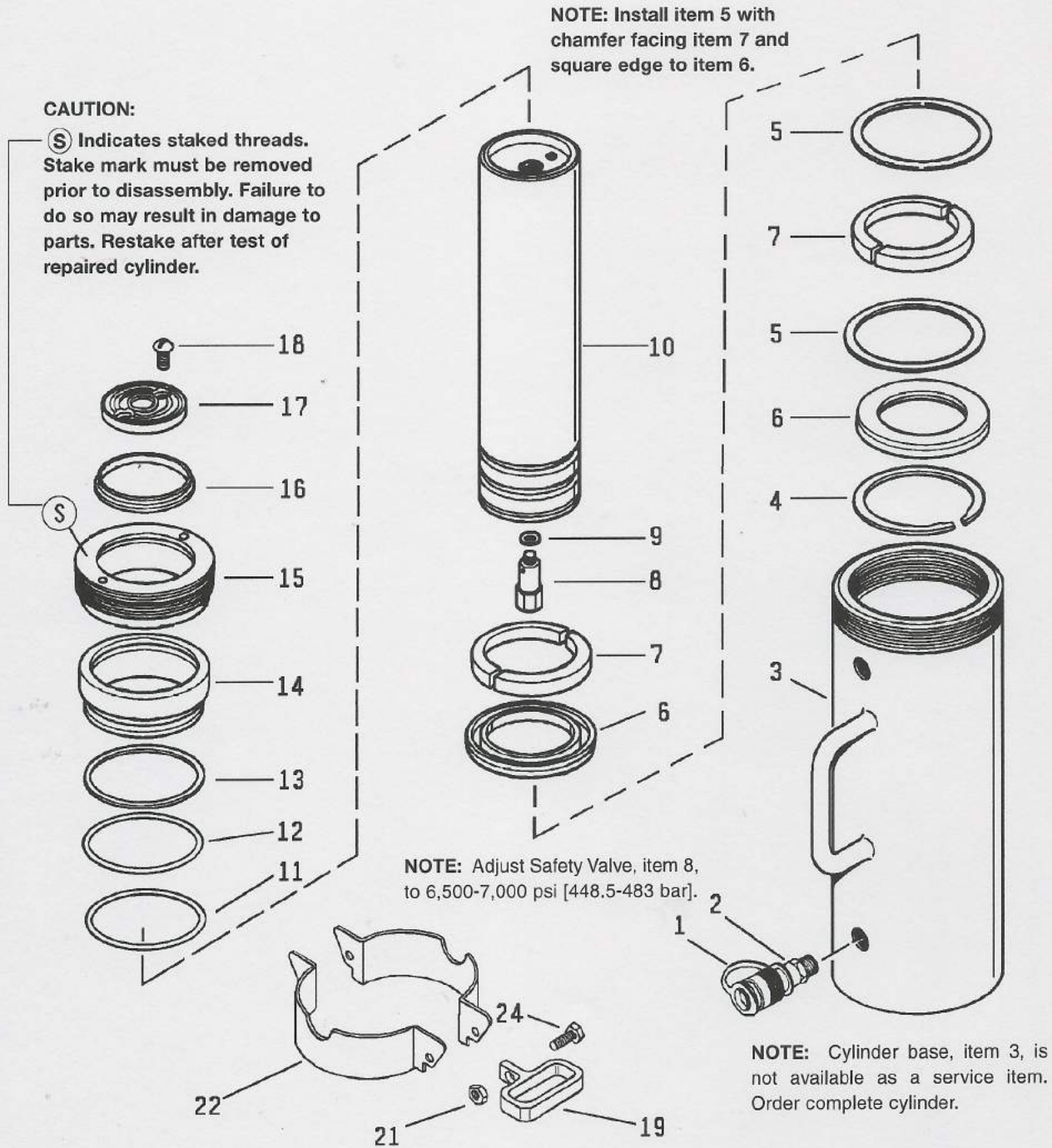


Figure 1, 50-Ton Double-Acting Solid Plunger Hydraulic Cylinder



## Repair Parts List for Figure 1

Item	Part Number		Qty.	Description
	RR-506	RR-5013		
1	CD411	CD411	2	Dust Cap
2	CR400	CR400	2	Coupler
3	Not available as a service item. Order complete cylinder. Cylinder			
4	★	★	1	Retaining Ring
5	★	★	2	Washer
6	★	★	2	U-Cup
7	L341107	L341107	2	Rod Bearing
8	G586900SR-7000	G586900SR-7000	1	Relief Valve Assembly (incl. item 9)
9	★	★	1	Gasket
10	M23040	M24040	1	Plunger
11	★	★	1	O-Ring
12	★	★	1	O-Ring
13	★	★	1	Back-Up Washer
14	M28044	M28044	1	Stop Ring
15	Y193044	Y193044	1	Stop Ring Assembly
16	★	★	1	Wiper Ring
17	L345045	L345045	1	Saddle
18	L661028	L661028	2	Machine Screw
19	---	DA5184070SR	2	Cylinder Handle (incl. item 20,21,23,24)
21	---	DC4453021	2	Hex Nut
22	---	CL1052950SR	2	Collar (incl. item 19,20,21,23,24)
25	CL401271	---	1	Threaded Protector (not shown)

★ Items included in and available only as part of Repair Kit RR5013K1. (For Viton order Kit RR5013KV.)

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