

AutoSPLITTER

ANGLE HEAD DOUBLE CUTTING™ MODELS

HYDRAULIC NUT SPLITTER



OPERATIONS AND MAINTENANCE MANUAL

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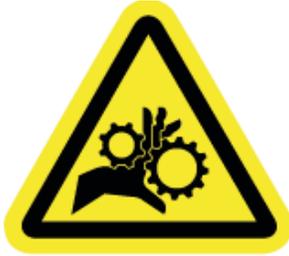
INTRODUCTION

With the FASTORQ AutoSPLITTER you can safely cut through frozen nuts in just seconds. This is achieved by designing in the features listed below.

- ◆ **Adaptability:** AutoSPLITTERS are available with special nut adapters to allow you to split huck nuts, round nuts and 12 point hex nuts.
- ◆ **Versatility:** AutoSPLITTERS come in various sizes and models, including Straight Head Models, Angle Head Models and Double Cut Angle Head Models and each model can split multiple nut sizes.
- ◆ **Flexibility:** AutoSPLITTERS are designed to fit into the tightest spaces and because of our multiple model selection; we can find the right tool for your specific application.
- ◆ **Precision:** AutoSPLITTERS cutting chisels can be positioned so that only the nut is cut leaving the stud and threads unharmed.
- ◆ **Speed:** AutoSPLITTERS can be unpacked from its toolbox assembled and ready to use in less than five minutes and it only takes mere seconds to split a nut.
- ◆ **Safety:** AutoSPLITTERS do not use any sort of hammering or impact or flame to split nuts, as such no specialty permits are required for operation on the job.

WARNINGS AND SAFETY TIPS

****ALWAYS PREFORM A VISUAL INSPECTION OF ANY TOOL AND ITS ACCESSORIES BEFORE USE. NEVER ATTEMPT TO USE EXCESSIVELY WORN, BROKEN OR DULL TOOLS****



IS A CHANCE THAT OCCURS, EYE ENCOURAGED AT ALL SPLIT NUTS INTO ANY ORIGINAL SIZE.

KEEP ALL OBJECTS, OTHER THAN THE NUT BEING SPLIT, OUT OF THE TOOL. TOOL DAMAGE AND INJURY MAY OCCUR



WHEN SPLITTINGS METAL OBJECTS THERE DEBRIS MAY BE EJECTED AS THE SPLIT PROTECTION AND SAFETY GLOVES ARE TIMES WHILE IN OPERATION. DO NOT PIECES SMALLER THAT HALF THE NUTS



NEVER EXCEED 10,000 OPERATING AN AUTO-SPLITTER™.

DO NOT ALLOW THE HYDRAULIC HOSES TO KINK, TWIST, CURL OR BEND SO TIGHTLY THAT THE FLOW OF HYDRAULIC IS BLOCKED OR SLOWED IN ANY WAY.



PSI OF HYDRAULIC PRESSURE WHILE



NEVER ATTEMPT TO GRASP A PRESSURIZED HOSE THAT IS LEAKING.

POWER REQUIREMENTS

The AutoSPLITTER is hydraulically driven. All models require a hydraulic pump that delivers 10,000 PSI pressure. Exceeding 10,000 PSI pressure will void any and all warranties. Any type of hydraulic pump may be used to operate the AutoSPLITTER including air, electric, foot driven or hand driven pumps. Pumps can be purchased separately from FASTORQ and include all the necessary hoses and fittings, see the list below for appropriate pump and AutoSPLITTER combinations.

Available FASTORQ Hydraulic Pumps for Angle Head Double Cutting™ AutoSPLITTER

AutoSPLITTER Model	Available FATORQ Power Units						
	100-H Hand Driven	105-A Air Driven	150-H Hand Driven	150-F Foot Driven	205-A Air Driven	115-E Electric Driven	215-E Electric Driven
AS105AH-DC	X	X					X
AS200AH-DC	X	X	X	X	X	X	X
AS204AH-DC	X	X	X	X	X	X	X
AS210AH-DC	X	X	X	X	X	X	X
AS308AH-DC			X	X	X	X	X

If a FASTORQ hydraulic pump is not used, refer to the chart listed below for the appropriate power requirements.

Pump Power Requirements for Non-FASTORQ Pumps

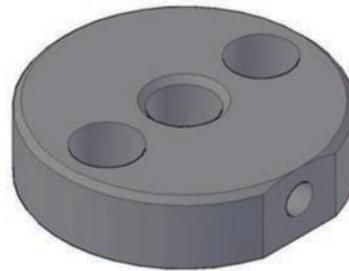
Straight Head Models	Valve Type	Hose Rating	Usable Minimum Capacity
AS105AH-DC	2-Way	10,000 PSI	10 in ³
AS200AH-DC	2-Way	10,000 PSI	10 in ³
AS204AH-DC	2-Way	10,000 PSI	44 in ³
AS210AH-DC	2-Way	10,000 PSI	44 in ³
AS308AH-DC	2-Way	10,000 PSI	82 in ³

ASSEMBLY

Within the AutoSPLITTER there are three “Model” types, they are the Straight Head Models, Angle Head Models and Angle Head Double Cut Models. All three models share similar features of assembly but between the three models there are two different methods of holding the cutting chisels. See the illustration below.



Type 1



Type 2

The assembly instructions are separated based on the chisel holder types. Section 1 assembly shall cover all assemblies involving the “Type 1” chisel holder and Section 2 shall cover all assemblies involving the “Type 2” chisel holders.

Section 1 – Assembly instructions for “Type 1” Chisel Holders

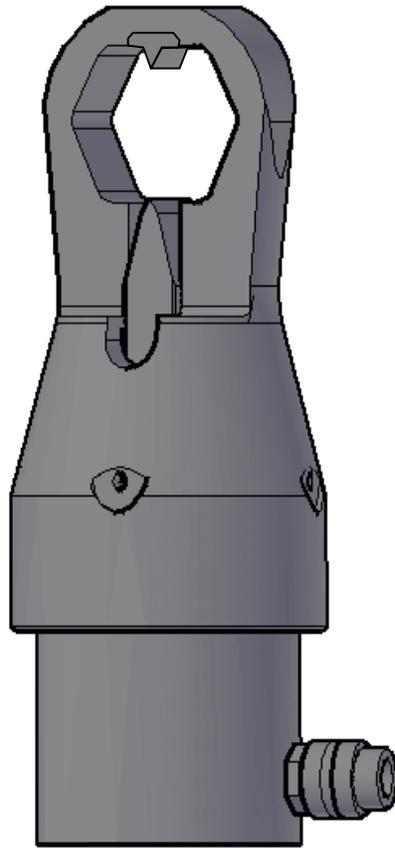
1. Unscrew the chisel holder from the cylinder.
2. Place the knobbed end of the cutting chisel into the center hole of the chisel holder.
3. Insert the set screw into the threaded side hole of the chisel holder. Do not over tighten the set screw, it is provided to hold the cutting chisel inside the chisel holder only, the cutting chisel should be loose enough to spin with minimal friction inside the chisel holder but not fall out.
4. Place the appropriate space for the nut you are cutting inside the cylinder. The spacer shall be placed inside the cylinder in such a way that the engraved side can be read. Only one spacer is required to split a nut. Never split a nut with more than one spacer installed at a time, doing so will damage the stud threads.
5. Screw the chisel holder and chisel assembly from Step 3 into the cylinder until it is seated firmly and bottomed out in the cylinder.
6. Connect the cylinder and pump together via 10,000 PSI hydraulic hose.
7. Pressure up the cylinder until the internal piston has been fully extended from the cylinder. Hold the pressure so that the piston stays in this extended position.
8. Place the AutoSPLITTER housing on the threaded end of the cylinder and screw the housing onto the cylinder. Screw the housing all the way onto the cylinder until it is seated firmly and bottomed out on the cylinder. Once the housing has been seated firmly and bottomed out on the cylinder, unscrew the housing one full turn.
9. Insert the set screw into the threaded side hole of the housing and tighten to secure it into place.
10. Release the held pressure on the cylinder to allow the piston to retract back into the cylinder.
11. Your AutoSPLITTER is now fully assembled and ready for use.

Section 2 – Assembly instructions for “Type 2” Chisel Holders

1. Unbolt the chisel holder from the cylinder.
2. Place the knobbed end of the cutting chisel into the center hole of the chisel holder.
3. Insert the set screw into the threaded side hole of the chisel holder. Do not over tighten the set screw, it is provided to hold the cutting chisel inside the chisel holder only, the cutting chisel should be loose enough to spin with minimal friction inside the chisel holder but not fall out.
4. Place the appropriate spacer for the nut you are cutting inside the cylinder. The spacer shall be placed inside the cylinder in such a way that the engraved side can be read. Only one spacer is required to split a nut. Never split a nut with more than one spacer installed at a time, doing so will damage the stud threads.
5. Align the two bolt holes of the chisel holder and spacer assembly from Step 3 to the two threaded holes on the top of the piston on the cylinder and screw in the two bolts removed from Step 1. Tighten the two bolts until they are seated firmly in the cylinder. Some of the AutoSPLITTER models are packaged with two sets of bolts, this is to accommodate thicker spacers, if during assembly it is discovered that the two bolts are too short use the longer second set to firmly bolt the chisel holder assembly and spacer into the cylinder.
6. Connect the cylinder and pump together via 10,000 psi hydraulic hose.
7. Pressure up the cylinder until the internal piston has been fully extended from the cylinder. Hold the pressure so that the piston stays in this extended position.
8. Place the AutoSPLITTER housing on the threaded end of the cylinder and screw the housing onto the cylinder. Screw the housing all the way onto the cylinder until it is seated firmly and bottomed out on the cylinder. Once the housing has been seated firmly and bottomed out on the cylinder, unscrew the housing one full turn.
9. Insert the set screw into the threaded side hole of the housing and tighten to secure it into place.
10. Release the held pressure on the cylinder to allow the piston to retract back into the cylinder.
11. Slide the stationary chisel into the slot opposite the cutting chisel.
12. Insert and tighten retaining screw in the stationary chisel.
13. Your AutoSPLITTER is now fully assembled and ready for use.

Your completely assembled AutoSPLITTER should resemble the illustration below.

Assembled AutoSPLITTER

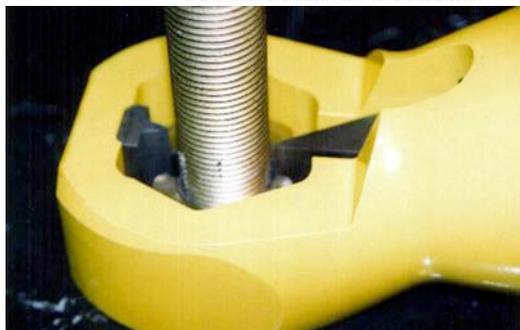
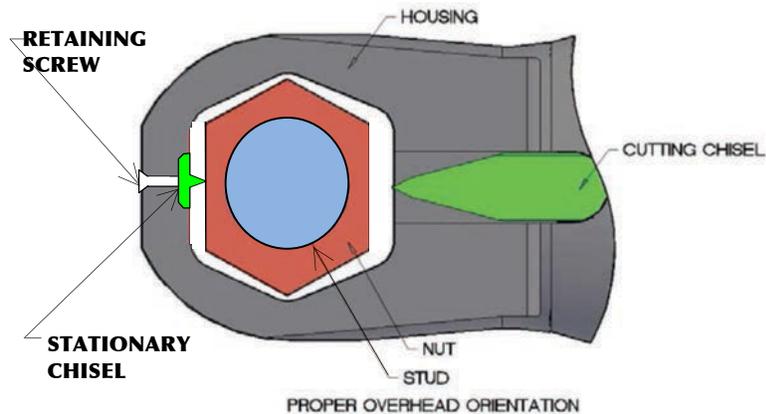


OPERATION

Note

*Before operation read and follow all warnings, safety tips and assembly instructions.

1. Lubricate the cutting edges of both chisels with an anti-seize lubricant before each split it attempted. FASTORQ 70+ lubricant is recommended and can be purchased separately.
2. Place the AutoSPLITTER over the nut to be split. Orientate the AutoSPLITTER in the exact position as illustrated below. The flat side of the AutoSPLITTER should be parallel to the surface of the flange and the cutting chisels should be centered on the flat sides of the nut being split. Refer to the illustrations below for proper alignment.



3. Pressurize the cylinder to extend the chisel slowly until both cutting edges make contact with the flat nut face. Verify that the cutting edges are centered on the flats of the nut before continuing.
4. Continue to pressurize the cylinder slowly to begin splitting the nut. You will hear a loud pop; this noise indicates that the nut has been successfully split. Once you hear the loud pop, stop pressurizing the cylinder.

A successfully split nut should look like the illustration below.



MAINTENANCE

The FASTORQ AutoSPLITTER is designed to be a low maintenance tool. Following the steps below will help ensure a long useful shelf life of the tool for years to come.

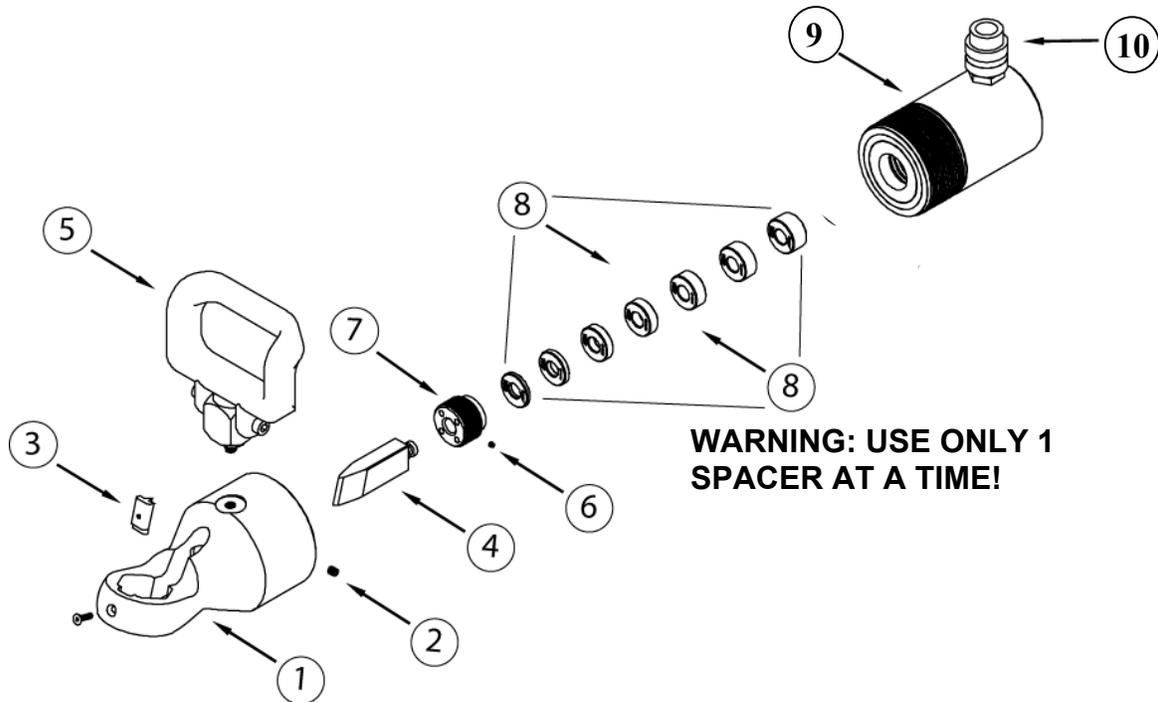
- ◆ Always lubricate the cutting edges of the chisels with an anti-seize lubricant before each split it attempted. FASTORQ 70+ lubricant is recommended and can be purchased separately.
- ◆ Do not let the cutting chisels get dull. The cutting chisels can be re-sharpened by hand with a whetstone or on a bench grinder using a slow rpm and a fine ground wheel. Keeping the cutting chisel well lubricated and cool during sharpening will allow you to sharpen the cutting edge quickly and safely.
- ◆ After each use thoroughly clean the tool and its accessories before storage.
- ◆ Replace all thread protectors and dust covers on the tool when not in use or during storage. This will help keep any debris from entering the hydraulic system and keep the oil clean. And ready for use.
- ◆ For storage always keep your AutoSPLITTER in its supplied tool box. The supplied tool boxes have been manufactured to keep the tool and its accessories safe from any accidental damage and will increase the longevity of the tool.

TROUBLE SHOOTING

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
Cylinder does not hold pressure	<ol style="list-style-type: none"> 1. Cylinder seal is leaking. 2. Leaking fitting connection 3. Pump malfunction 	<ol style="list-style-type: none"> 1. Change cylinder 2. Tighten fitting connections 3. Change pump
Cylinder does not advance or only advances partially	<ol style="list-style-type: none"> 1. Pump release valve is open 2. Not enough fluid in pump 3. Air in hose lines 4. Couplers not tight 5. Pump reservoir too small 	<ol style="list-style-type: none"> 1. Close valve 2. Add fluid to pump 3. Bleed air from hose lines 4. Tighten couplers 5. Change pump to one with larger reservoir
Cylinder advances slowly	<ol style="list-style-type: none"> 1. Leaking fitting connection 2. Clogged fitting or hose 3. Loose coupler 4. Pump flow rate too slow 	<ol style="list-style-type: none"> 1. Tighten fitting connections 2. Change out fittings or hoses 3. Tighten couplers 4. Change pump to one with faster flow rate
Cylinder does not retract, retracts slowly or retracts partially	<ol style="list-style-type: none"> 1. Pump release valve closed 2. Coupler not fully closed 3. Clogged fitting or hose 4. Damaged retraction spring (AS314 Model Only) 5. Pump reservoir overfilled 	<ol style="list-style-type: none"> 1. Open valve 2. Close coupler 3. Change out fittings or hoses 4. Replace spring 5. Drain out excess fluid
Cutting chisel does not penetrate the nut	<ol style="list-style-type: none"> 1. Inadequate pump pressure 2. Incorrect spacer used 3. Cutting chisel edge dull 4. Housing not fully threaded onto cylinder 	<ol style="list-style-type: none"> 1. Increase pump pressure to 10,000 psi, MAX. 2. Change spacers 3. Sharpen or replace cutting chisel 4. Thread housing fully on cylinder as per assembly instructions
Cutting chisel splits the nut and damages the stud threads	<ol style="list-style-type: none"> 1. Incorrect spacer used 2. Housing threaded more than necessary 	<ol style="list-style-type: none"> 1. Change spacer 2. Thread housing fully on cylinder as per assembly instructions

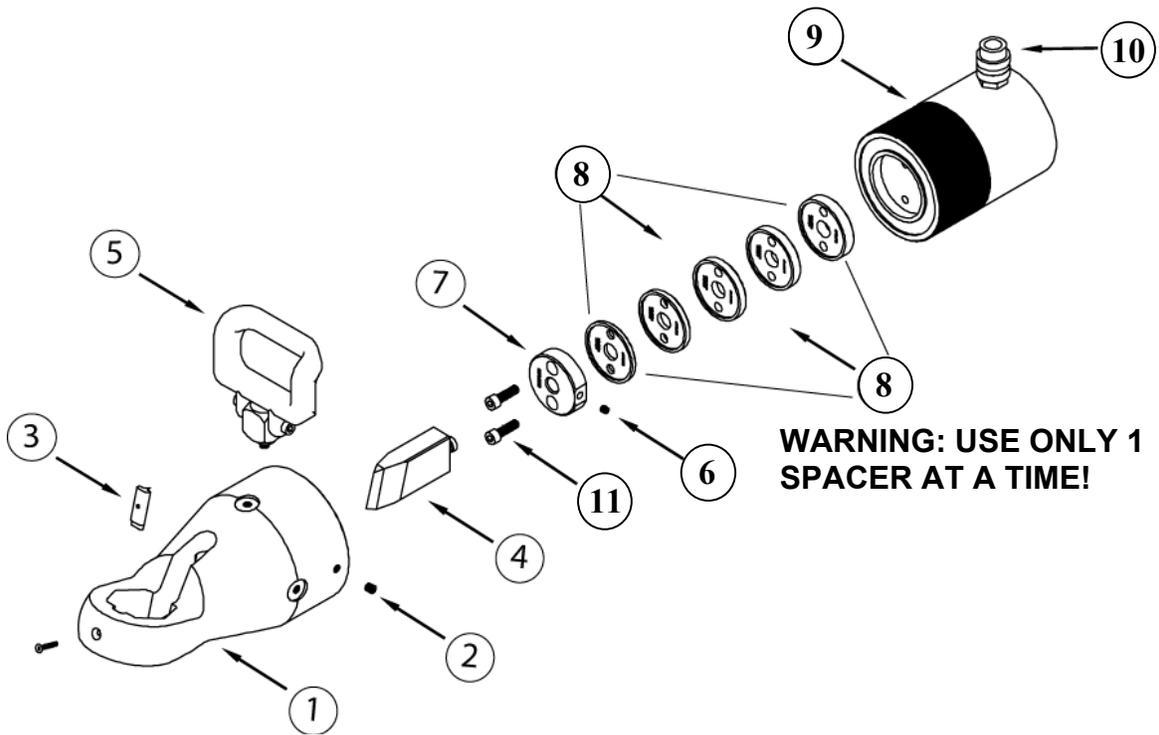
PARTS LIST

TYPE 1 CHISEL HOLDER MODELS



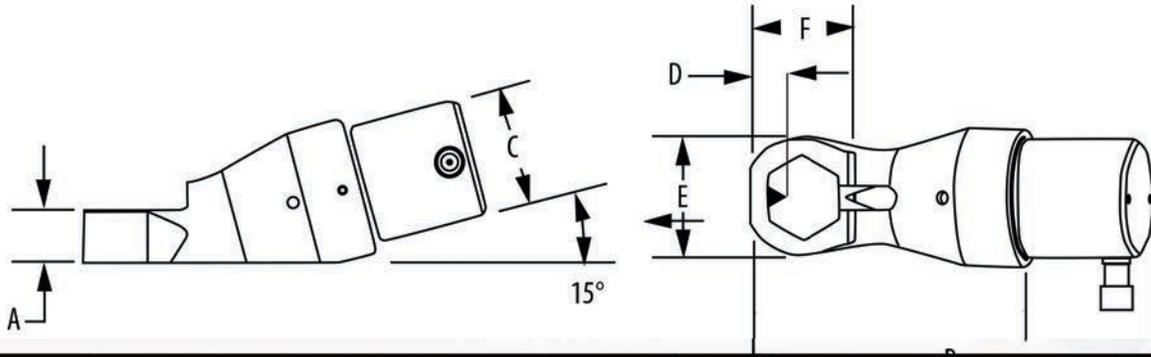
PARTS LIST

TYPE 2 CHISEL HOLDER MODELS



PARTS LIST

AutoSPLITTER ANGLE HEAD DOUBLE CUTTING MODEL NUMBERS						
ITEM #	DESCRIPTION	AS105AH-DC	AS200AH-DC	AS204AH-DC	AS210AH-DC	AS308AH-DC
1	HOUSING	A2K647	B2K1000	B2K974	C97001	B2K1056
2	HOUSING SET SCREW	SSN04-20X05	SSN04-20X05	SSN6-16X12	SSN6-16X12	SSN6-16X12
3	STATIONARY CHISEL	A2K646	B2K1001	B2K978	A97058	A2K705
4	CUTTING CHISEL	A94057	A94057	A92031	A92031	A92032
5	HANDLE	H55-3-1806-106	H55-3-1806-106	H55-3-1806-106	H55-3-1806-106	H55-3-1806-106
6	CHISEL HOLDER SET SCREW	SSN6-32X04	SSN6-32X04	SSN04-20X05	SSN04-20X05	SSN04-20X05
7	CHISEL HOLDER	B86215	B86215	B87089	B87089	B87089
8	SPACER SET	A99077	A92K966	A99001	A99001	A91001
9	CYLINDER	C-25	C-25	C-55	C-55	C-100
10	FEMALE QUICK DISCONNECT	C604	C604	C604	C604	C604
11	CHISEL HOLDER BOLT SET A	N/A	N/A	SHCS06-16X12	SHCS06-16X12	SHCS06-16X12
	CHISEL HOLDER BOLT SET B	N/A	N/A	SHCS06-16X20	SHCS06-16X20	SHCS06-16X20
12	CHISEL HOLDER ALLEN KEY	WSS1	WSS1	WSS2	WSS2	WSS2
13	CHISEL HOLDER BOLT SET ALLEN KEY	N/A	N/A	SHCS06-16X20	SHCS06-16X20	WSS5
14	HOUSING ALLEN KEY	WSS2	WSS2	WSS3	WSS3	WSS3
15	TOOLBOX WITH FOAM INSERT	25TB / 25TBI	25TB / 25TBI	55TB / 55TBI	55TB / 55TBI	100TB28 / 100TBI28



Duo Kit	Model	Stud Diameter inches (metric)	Nut Size ATF inches (mm)	A inches (mm)	B inches (mm)	C inches (mm)	D inches (mm)	E inches (mm)	F inches (mm)	Weight lb. (kg)
AS-DUO25AH-DC	AS105AH-DC	7/16 - 3/4 (M8-M20)	5/8 - 1-1/4 (16 - 34)	1.13 (29)	11.00 (280)	3.97 (101)	0.72 (18)	2.87 (73)	7.44 (189)	20.0 (9.1)
	AS200AH-DC	7/8 - 1 (M22-M24)	1-7/16 - 1-5/8 (36 - 41)	1.38 (35)	11.75 (299)	3.97 (101)	1.06 (27)	3.62 (92)	7.94 (202)	21.0 (9.5)
AS-DUO55AH-DC	AS204AH-DC	1-1/4 - 1-3/8 (M33-M36)	1-7/8 - 2 -016 (50 - 60)	1.75 (45)	16.00 (409)	5.97 (152)	1.07 (27)	3.99 (102)	11.49 (292)	61.0 (27.7)
	AS210AH-DC	1-3/8 - 1-1/2 (M36-M39)	2-1/16 - 2-3/8 (55 - 65)	2.00 (51)	16.10 (409)	5.97 (152)	1.50 (38)	4.50 (115)	12.07 (307)	62.0 (28.1)
AS-DUO100AH-DC	AS308AH-DC	1-3/4 - 2-1/4 (M45-M52)	2-5/8 - 3-1/2 (65 - 90)	2.50 (64)	19.64 (499)	7.25 (185)	2.14 (55)	6.25 (159)	13.25 (337)	95.0 (43.1)
	AS314AH-DC	2 - 2-1/4 (M52-M56)	3 - 3-1/2 (80 - 90)	2.50 (64)	20.14 (512)	7.25 (185)	2.51 (64)	6.75 (172)	13.75 (450)	100.0 (45.4)



Warranty

All **AutoSPLITTER** models are covered by the FASTORQ NO B.S. Lifetime Guarantee Program. It's as simple as the name implies: any product covered by our No B.S. Lifetime Guarantee is covered for life. Period. Warranty includes seal replacement on cylinders.

The "fine print"

All products manufactured by FASTORQ are warranted against defects of material or workmanship for the period defined by product line/model from the date shipped when these products are used within the service, specification and pressure range for which they were designed and manufactured. Warranty programs vary in length of time of coverage by product line.

All products are potentially eligible for the Warranty Extension Program. Warranty programs are for customers in the U.S. and Canada but may be extended to customers in other countries under certain circumstances. Customers must complete online or mail-in product registration. Warranties do not cover loss or theft, abuse, misuse, overloading or alteration of product or components. Freight costs to deliver product to FASTORQ is the customer's responsibility; FASTORQ pays for the return shipping costs on warranty repairs/replacements. Repair or replacement will be determined by FASTORQ technicians.

Warranties are limited to repair or replacement of parts found by FASTORQ to be defective in material or workmanship and does not extend to claims for labor, expense, or other loss or damage occasioned by such defect of material or workmanship. No unauthorized back charges will be accepted. Warranties do not cover deterioration by corrosion, erosion, or any cause of failure other than defect of material or workmanship. Purchasers are expected to determine the suitability of FASTORQ products of their particular purposes. No other warranty, expressed or implied, will be allowed without the written agreement of FASTORQ. Any adjustments to this warranty must first be approved in writing by FASTORQ.