

Thank you for purchasing a Florian Precision FP-1535 Wire Chopper.

Installation of the FP-1535 is similar to the original except our module features an integrated flywheel. The flywheel must be oriented properly in order to not interfere with the aspirator and the clamping screw when sliding module into place. Vice versa when removing module for maintenance. (CAUTION! do not tighten clamping screw excessively, doing so will cause misalignment of the module and put undue stress on the motor causing motor stoppage.)

The FP-1535 is setup at our factory to wear in one of 4 places on the (4) moving inserts, and 1 of 16 places on the (1) fixed insert.

WE RECOMMEND INSPECTION AND INDEXING CUTTERS EVERY 500 HOURS

To change the FP-1535 wire chopper to the next wear position. First begin by removing the fixed insert holder from the body pins. To do this, locate the jackscrew located above the wire orifice hole. Use a 1.5mm. hex key wrench . Turn screw in until holder "pops" off of pin. To change wear area simply push carbide insert flush to the opposite side it was on. When both sides wear, carbide insert must be removed from the slot in the holder and reinstalled in another area. (Don't be concerned that the insert seems loose. The holder is designed to clamp the insert secure when the holder is "snapped" between the body pins. Also note that the holder can not be installed backwards or wrong.) To reinstall holder , back out jackscrew until flush with holder surface. Install on stepped body pin first and push on the holder with force to "snap" holder into place. Make sure jack screw is loose to ensure holder is completely locked into the pin. (CAUTION! if this is not done, cutting clearance will be incorrect and you will not successfully chop wire.) Reinstallation of the fixed insert should be done last so there will be plenty of clearance for your fingers to move or replace the (4) moving inserts.

To change the wear area on the moving inserts, note the extra set of groves on the shaft . This will determine the next location of the inserts. First roll one o-ring then move the inserts against the o-ring you just moved, then move the other o-ring to retain the insert in its new position. Once both areas have worn, remove the insert from the shaft by rolling the o-ring to the end of the square part of the shaft, then slide the insert off. The insert can now be flipped upside-down and reinstalled with two fresh cutting areas available for wear. (These inserts can not be installed backwards or wrong.) This can become a bit tedious and be accomplished better with a pair of tweezers. On a final note... To prolong the wear on all inserts, make sure the moving inserts are staggered to the fixed insert. This insures that the next wear area never re-chops wire, causing unnecessary wear on a fresh wear area... Happy Chopping.