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**SOFT LINE CUTTER SL135**

**PRODUCT CODE No. 980249**

**INSTRUCTIONS FOR INSTALLATION,  
OPERATION & MAINTENANCE**

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## **DESCRIPTION**

The SL135 softline cutter is a double acting tool suitable for cutting softlines and ropes up to 127mm (5") in diameter. It requires a dual line hydraulic supply for operation and is suitable for use subsea.

### **1 SAFETY**

Before operation, read and understand this operations manual.

Ensure that the tool and all its associated equipment, including any attached lifting equipment and pipework are in good condition.

Before operating the tool hydraulically, ensure that a return hydraulic line is fitted as well as the pressure line. This is to prevent fluid locks and the possibility of generating very high pressures within the system.

Ensure that suitable pressure regulation equipment is used and that the unit is not subjected to pressures higher than those stated in section 3.

If an operator is adjacent to the tool during trials or other tests, ensure that moving parts are shielded to prevent entrapment. Appropriate personal safety equipment should be worn (e.g. Safety glasses, Helmet & Gloves as a minimum)

If the item to be cut is under tension, a risk assessment must be carried out by a competent person with emphasis on the possible recoil of the severed ends

If in doubt please contact the manufacturer (Allspeeds Ltd) or an authorized distributor for assistance.

### **INSPECT THE TOOL BEFORE USE**

With the cutter isolated from the hydraulic supply, check the condition of the blade edge. If the blade is damaged or blunt replace with a fresh blade before cutting. This procedure is as described in section 6. Ensure that care is taken when checking the blade as the edge may be sharp.

Check the condition of the anvil. It is normal that the anvil will show an indent where the blade is pressed down into it and can withstand multiple cuts, but any excessively damaged anvil should be replaced. This procedure is described in section 6.

Ensure that all retaining bolts are tight.

**IMPORTANT** - Please note the blade material. Should your SL-135 be fitted with a standard steel blade (705071) it should not be used subsea for any period over 24 hours. If your SL-135 is fitted with a stainless steel blade (705071S) it may be used subsea for a period of up to 14 days.

**CAUTION** - Any modification made to this tool will invalidate the warranty and may lead to equipment failure or personal injury.

If in doubt please contact the manufacturer (Allspeeds Ltd) or an authorized distributor for assistance.

**CAUTION - USE OF BLADES & PARTS NOT APPROVED BY WEBTOOL MAY RESULT IN TOOL FAILURE AND CONSEQUENTIAL DAMAGE.**

**CUTTING CAPACITY**

The SL135 cutter is designed to cut softlines up to a diameter of 127mm (5”). This tool is for cutting softlines only and MUST NOT be used to cut wire rope. Cutting unsuitable materials can result in damage to the tool and/or blade.

**2 INSTALLATION**

**HYDRAULIC CONNECTIONS**

Two ports are provided in the tool, one in the end of the cylinder for the cutting stroke, (herein referred to as the power port) and one in the housing block for the return stroke (herein referred to as the return port). Both ports are tapped 1/4” BSPP and are factory fitted with 7/16” JIC male adaptors.

**Table 1:**

Function	Max Working Pressure		Swept Volume	
	psi	bar	ml.	U.S. Gallon
Working Stroke	10,000	690	390	(0.103)
Return Stroke	10,000	690	241	(0.064)

**CAUTION - DO NOT EXCEED THE MAXIMUM STATED PRESSURES AS THIS MAY LEAD TO DAMAGE TO THE TOOL AND LOSS OF HYDRAULIC OIL. IT IS ADVISED THAT ANY HYDRAULIC CIRCUIT THAT THIS TOOL IS ATTACHED TO CONTAINS SUITABLE PRESSURE LIMITING EQUIPMENT.**

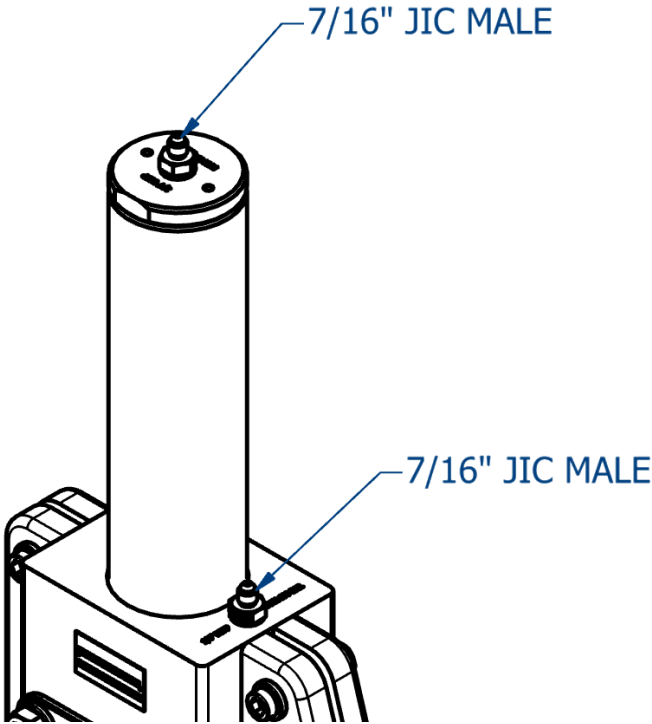


Fig 1 – Hydraulic connection points.

### LIFTING AND MOUNTING POINTS

The cutter has 4 holes, tapped M12 x 20 deep on each side plate. These holes are for the attachment of lifting and mounting equipment or buoyancy (not supplied as standard).

The weight of this tool is approximately 34kg in air and 23.4kg in water (not including oil). Ensure that any attached lifting equipment is capable of lifting the weight of this tool with a suitable safety margin

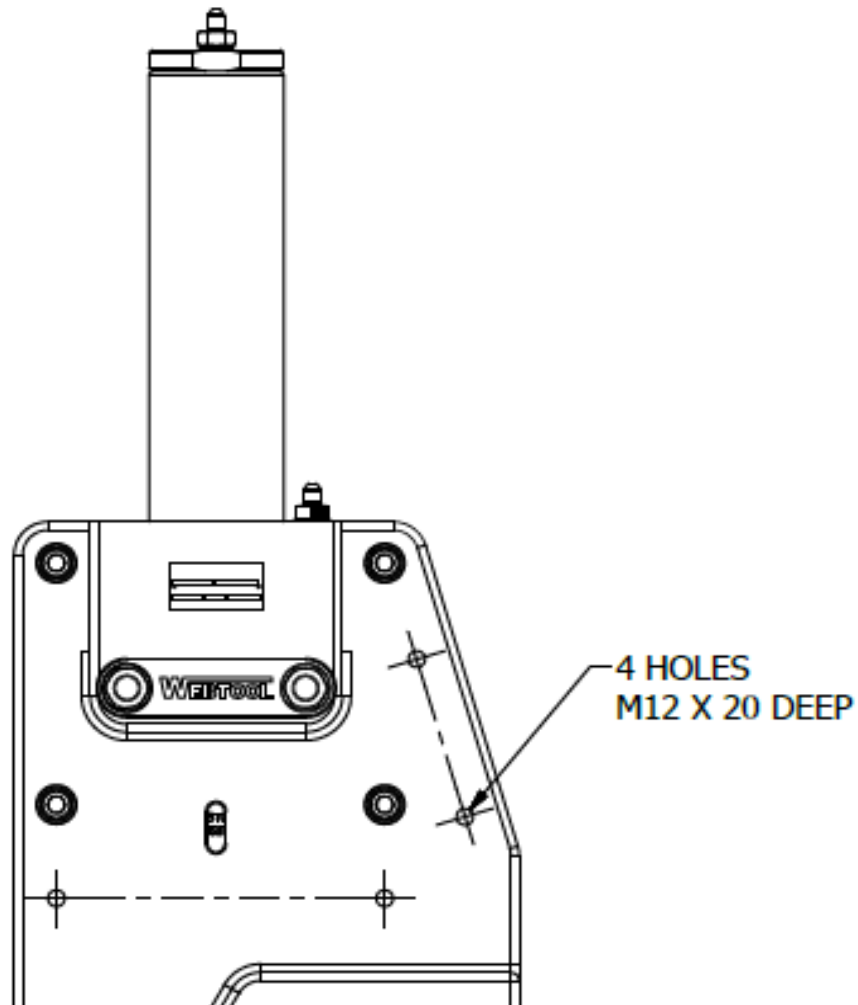


Fig 2 – Mount points.

### 3 SEQUENCE OF OPERATION

IMPORTANT – Before deployment, function test the tool and ensure that all operators are familiar with this procedure. ROV observation of the tool should be maintained at all times during operation.

#### DEPLOYMENT

1. Manoeuvre the cutter around the rope to be cut so that the rope sits fully in the jaw of the tool, against the anvil as shown below.

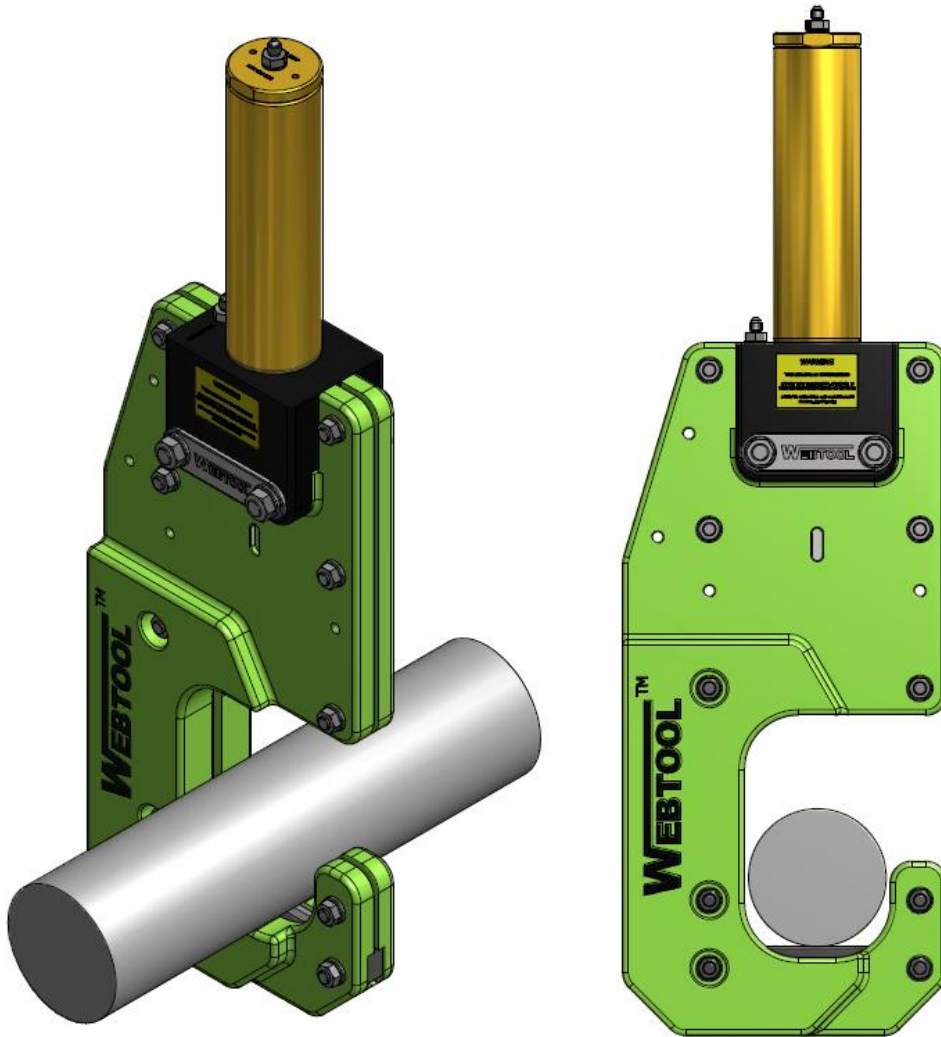


Figure 3 – Rope correctly positioned

2. Operate the hydraulic supply to the power port to drive the blade downwards through the rope.
3. Once the rope is fully cut, retract the blade by pressurising the return port.

## TROUBLESHOOTING

If the rope does not cut through completely on the first attempt, cycle the blade by retracting it slightly and then attempting the cut again.

If the rope does not completely cut after multiple cycles of the blade, check the input pressure to the main input of the cylinder. This can be a maximum of 690 bar (10000 PSI).

If the rope to be cut is still not severed after multiple cycles and at pressure of 690 bar, return the tool to the surface for inspection of the blade and anvil as described in section 6. Replace if necessary.

**IMPORTANT NOTE - ENSURE THAT THE BLADE IS RETRACTED AND THAT ALL PRESSURE TO THE CUTTER IS RELIEVED AS IT IS RAISED TO THE SURFACE. FAILURE TO DO THIS CAN LEAD TO A DANGEROUS BUILD UP OF PRESSURE IN THE CYLINDER.**

### 4 AFTER USE

If the tool has been used in a marine environment, **IT IS ESSENTIAL** that it is fully hosed down with clean water, allowed to drain and sprayed with a de-watering fluid. Before storage inspect the general condition of the tool and make good any damage. Pay particular attention to the blade and anvil as described in section 6.

**IMPORTANT – DO NOT STORE THE TOOL WITH A COMPLETELY SEALED CYLINDER AS PRESSURE MAY BUILD UP DUE TO TEMPERATURE CHANGES**

### 5 SERVICE

**CAUTION – ENSURE THAT THERE IS NO HYDRAULIC PRESSURE IN THE CYLINDER BEFORE PERFORMING ANY SERVICE OR MAINTENANCE PROCEDURES ON THIS CUTTER**

It is unlikely that service should be required on the hydraulic components of the tool under normal circumstances; however spare seal kits are available if required.

It is normal to have to replace the blade and anvil during the life of the tool, depending on the frequency of use and the materials being cut.

It is advised to keep stock of the following spares at all times

Description	Part Number
Seal Kit	995158
Stainless Blade	705071S
Anvil	761299
Retaining Pin	029528

Table 1 – Recommended spares

If required, the tool can be returned to the manufacturer (Allspeeds Ltd, for servicing and testing.

### INSPECTING THE BLADE

With the cutter isolated from the hydraulic supply, check the condition of the blade edge. If the blade is damaged or blunt replace with a fresh blade before cutting as described below. Ensure that care is taken when checking the blade as the edge may be sharp.

### BLADE REPLACEMENT PROCEDURE

Connect the cutter to a hydraulic supply, and retract or extend the blade so that the retaining pin is fully visible through the slot in the side plate.

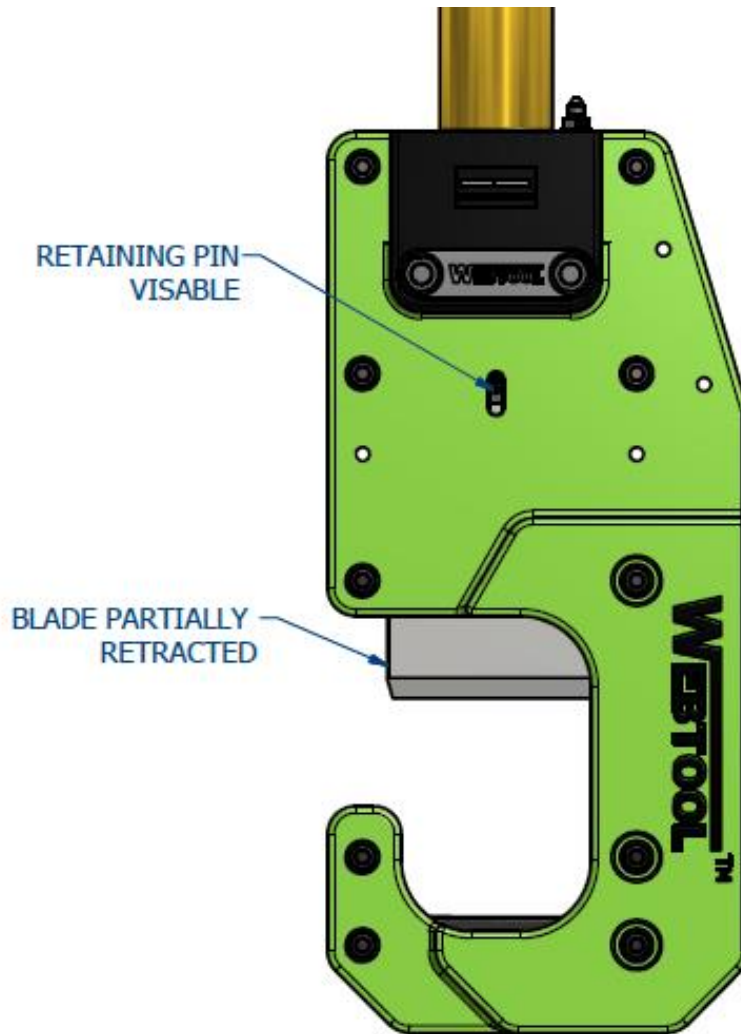


Figure 4 – Retaining pin visible

### IMPORTANT - DISCONNECT THE HYDRAULIC SUPPLY BEFORE PROCEEDING

Ensure that the cutter is led down before carrying out the next stage as the blade will come loose and will drop onto the anvil if the cutter is stood up.

Using a suitable drift and hammer, drive the retaining pin out of the end of the piston rod. The blade will now be loose but retained within the body of the tool.

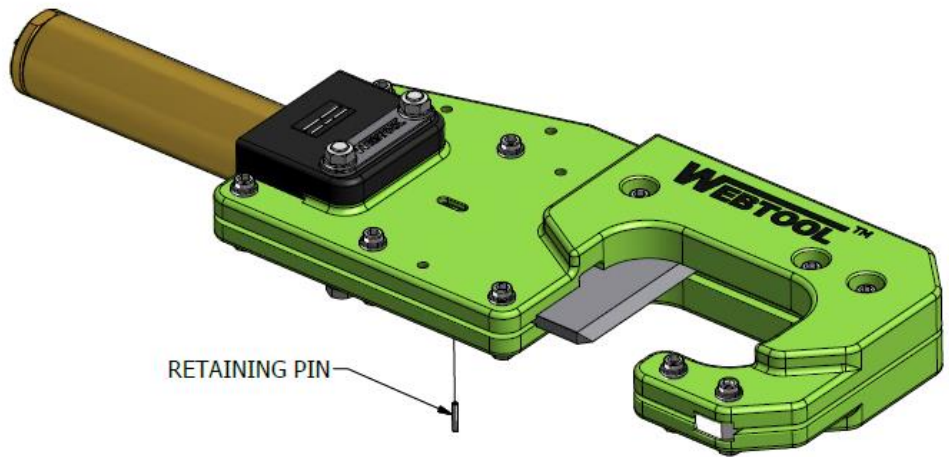


Fig 5 – Retaining pin removed

Remove the 2 off 16mm bolts with nuts that connect the cylinder housing to the side plates using two 24mm spanners. Lift the retaining plate away and knock out the two dowels, taking care not to damage the anodized aluminium cylinder housing.

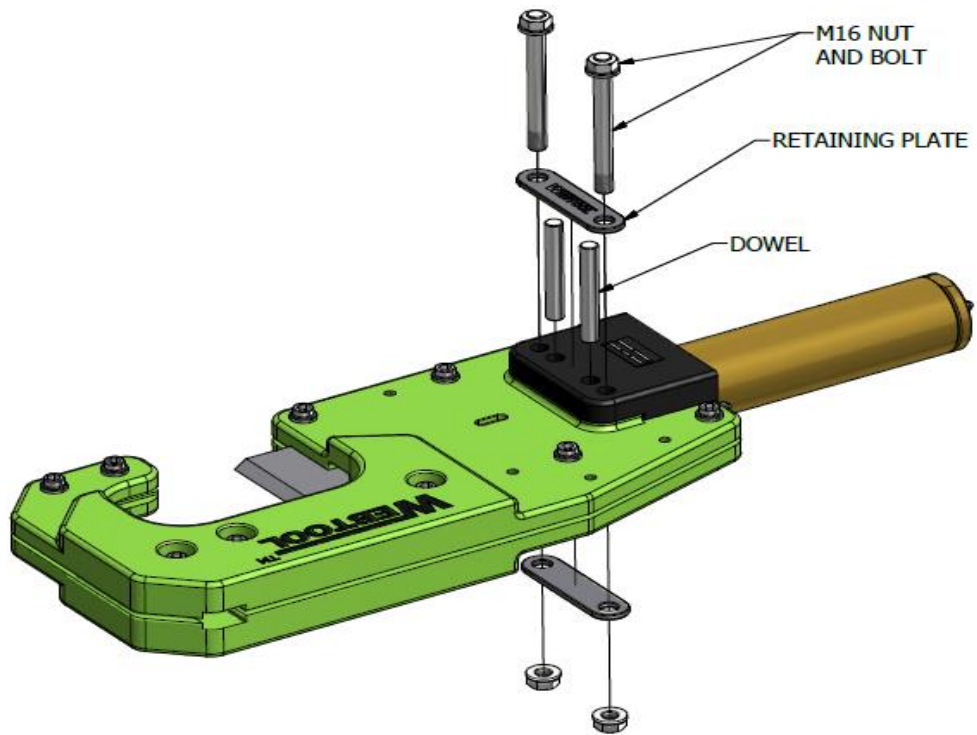


Fig 6 – Removal of 16mm bolts



Slide the housing and piston assembly from the side plates. Care must be taken to avoid damage to the piston rod during this procedure.

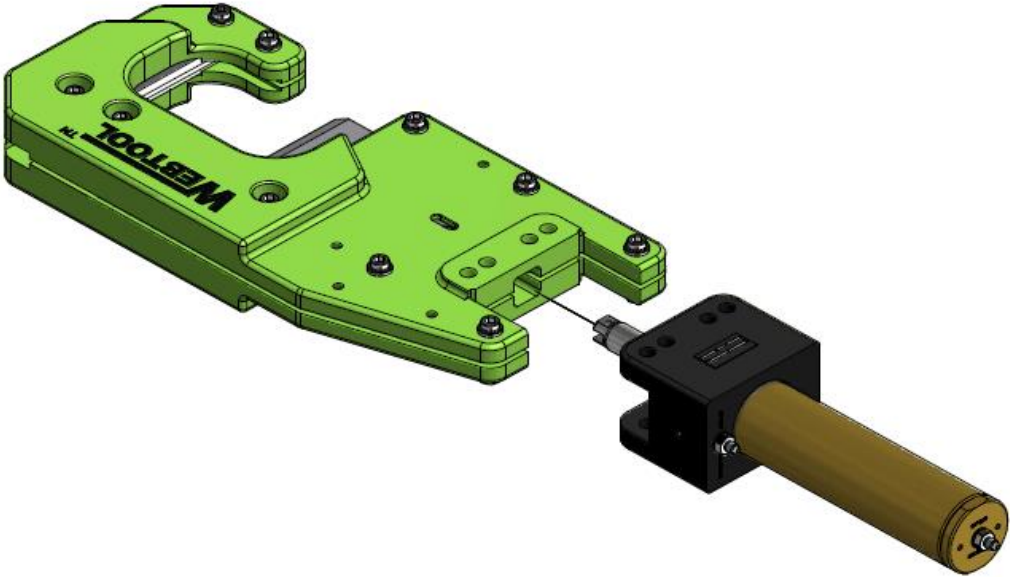


Fig 7 – Removal of piston housing assembly

Remove the 10 off 12mm bolts that hold the side plates together using a 10mm hex key and 19mm socket

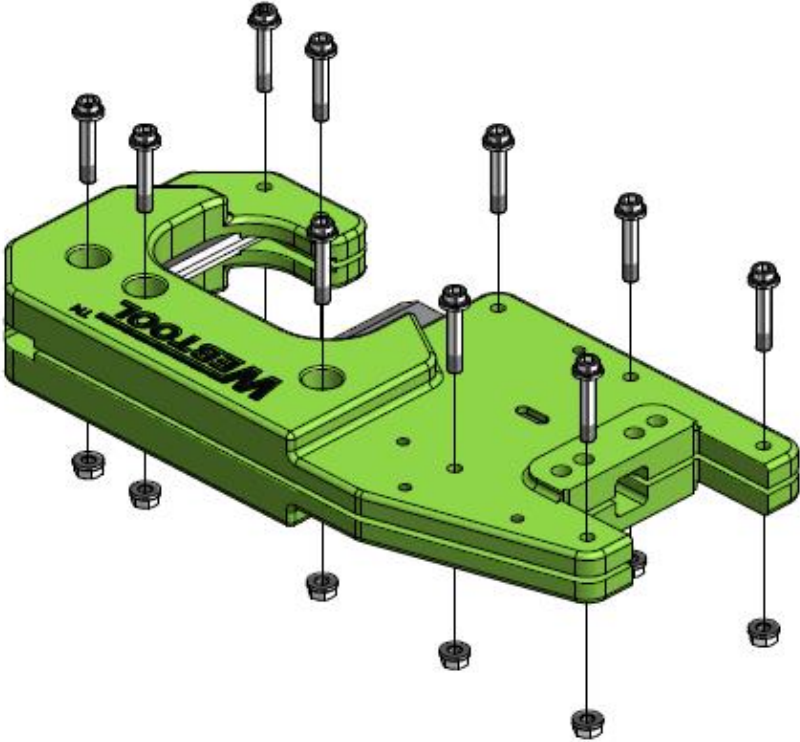


Fig 8 – Removal of 10mm bolts

Lift the side plate off, taking care not to lose the spacers.

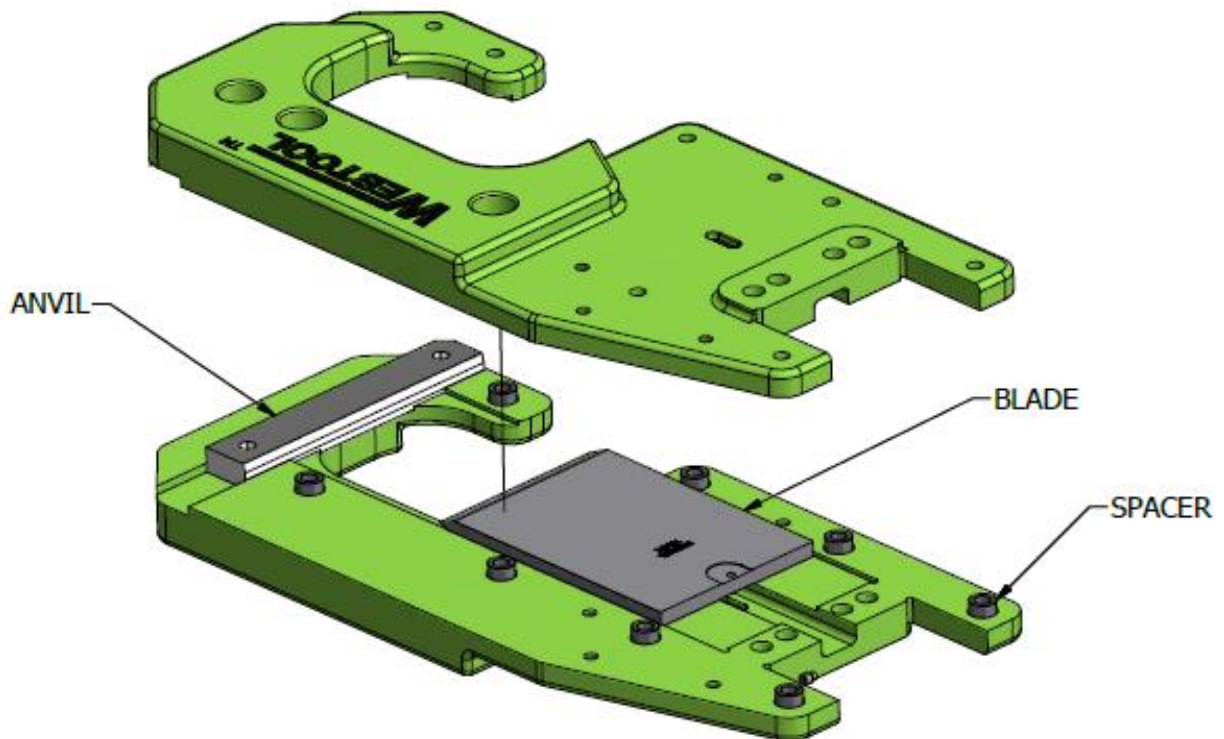


Fig 9 – Removal of side plate

Remove the blade and replace with a new one.

Visually inspect all components before reassembling.

Reassembly is the reverse of disassembly. Ensure that the retaining pin is driven into the piston and blade correctly and does not stand proud of the outer diameter of the piston.

After reassembly, function test the tool by connecting it to a hydraulic supply and cycling the blade up and down.

**CAUTION – ENSURE THAT ALL PERSONNEL ARE KEPT AT A SAFE DISTANCE FROM THE TOOL DURING FUNCTION TESTING**

#### **INSPECTING THE ANVIL**

Check the condition of the anvil. It is normal that the anvil will show an indent where the blade is pressed down into it and can withstand multiple cuts, but any excessively damaged anvil should be replaced as described below.

#### **ANVIL REPLACEMENT PROCEDURE**

Ensure that the blade is NOT in contact with the anvil before carrying out this procedure, and that the tool is disconnected from the hydraulic supply

Remove the 2 off 12mm bolts that pass through the side plates and anvil using a 10mm hex key and 19mm socket. Loosen off the 2 off 12mm bolts as shown below.

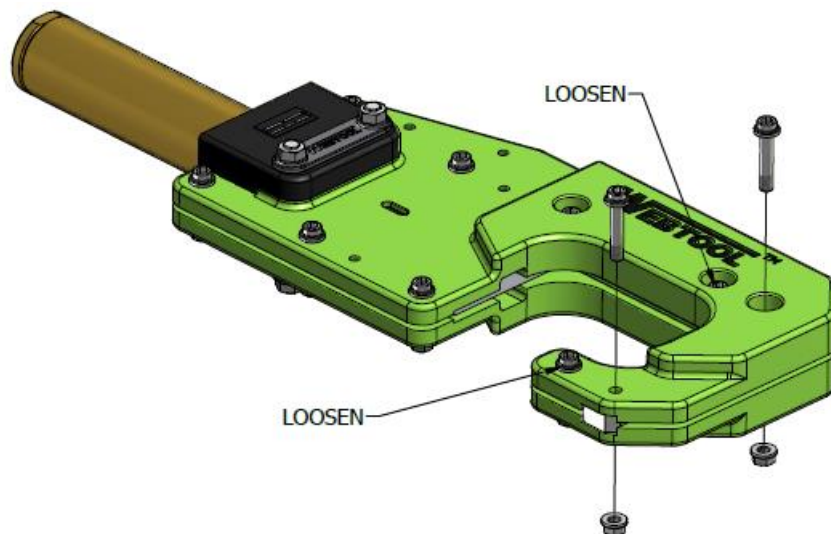


Figure 10 – Bolt removal

Remove the anvil by sliding it out of the side plates.

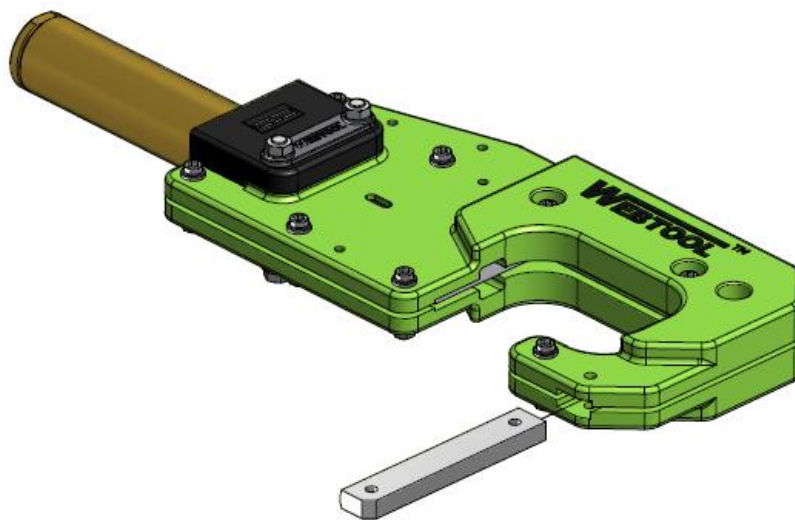


Figure 11 – Anvil removal

Replace the anvil, and the 2 off 12mm bolts. Ensure that all 4 bolts are correctly tightened. Check that all other bolts are correctly tightened.

## 6 CYLINDER PROOF TESTING

If at any time it is necessary to carry out proof tests on the tool, e.g. after service on the hydraulic cylinder, the following procedure should be followed.

**CAUTION – ENSURE THAT ALL PERSONNEL ARE KEPT AT A SAFE DISTANCE FROM THE TOOL DURING PROOF TESTING**

- 6.1 A return line as well as a pressure line must be connected at all times, and the tool must be guarded during the test operation.
- 6.2 The proof test should not exceed the following pressures:
- 750 bar for the power port
  - 750 bar for the return port

Note - The relief valve blow off pressure for this model of cutter is 760 Bar, any significant, sharp drop in pressure will be down to the activation of the relief valve.

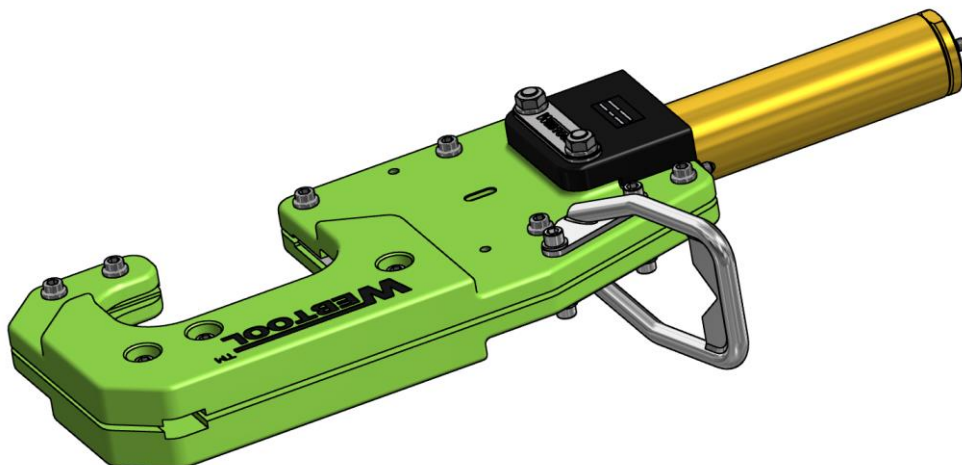
- 6.3 The proof test pressure should be applied gradually by means of a handpump, until the maximum test pressure is reached.

Also available as optional extras for this tool are:-

**Webtool Hydraulic Intensifier – HP690A** (available in a range on intensification ratios)



**Webtool handle kit** - part number 999025 an optional add on available for this cutter shown below



For further information contact the manufacturer (Allspeeds Ltd) or an authorised distributor.

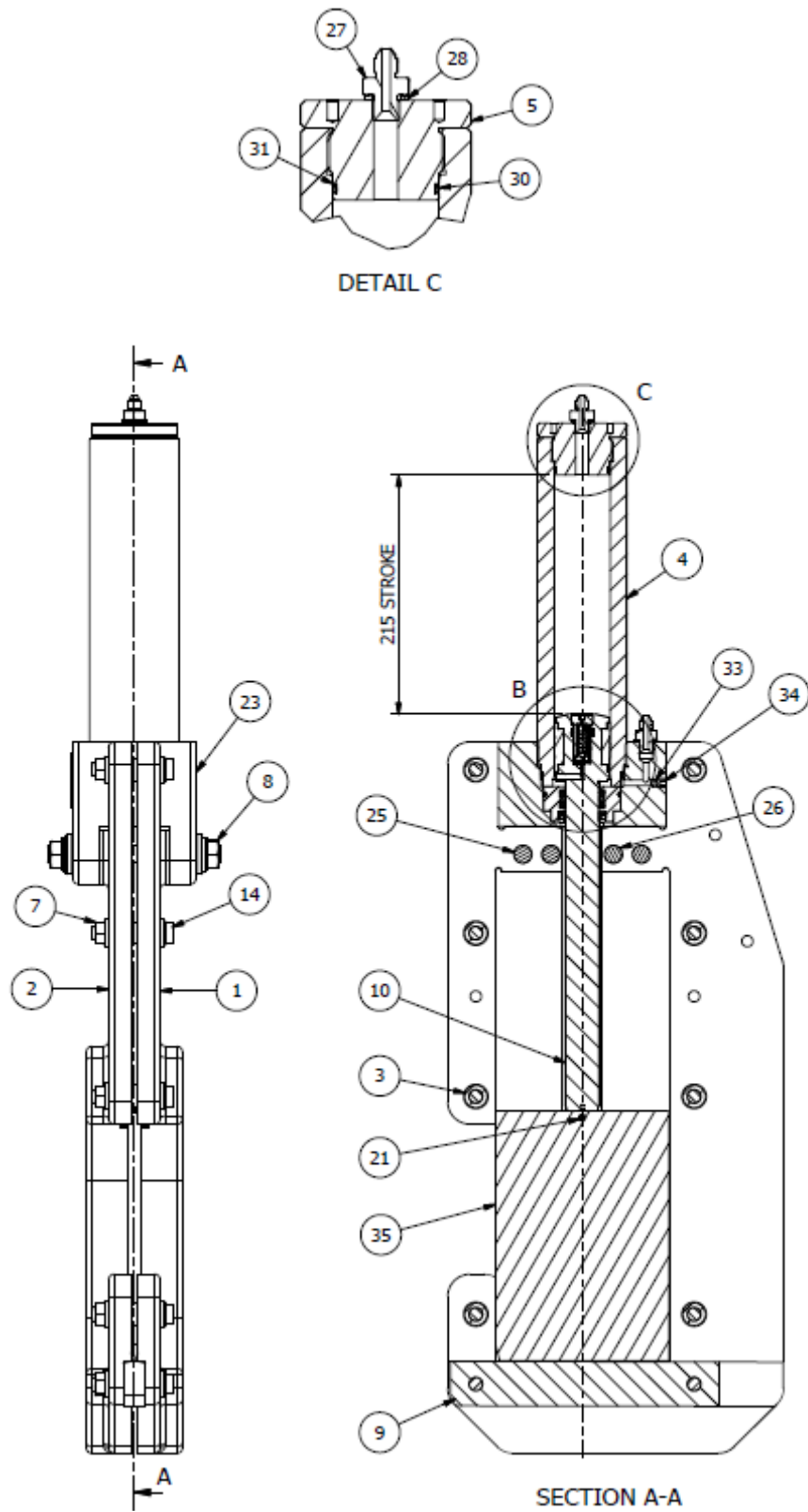


Figure 12 – Parts List Identifier 1

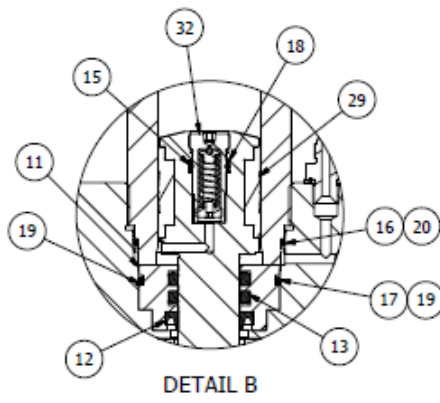


Figure 13 – Parts List Identifier 2

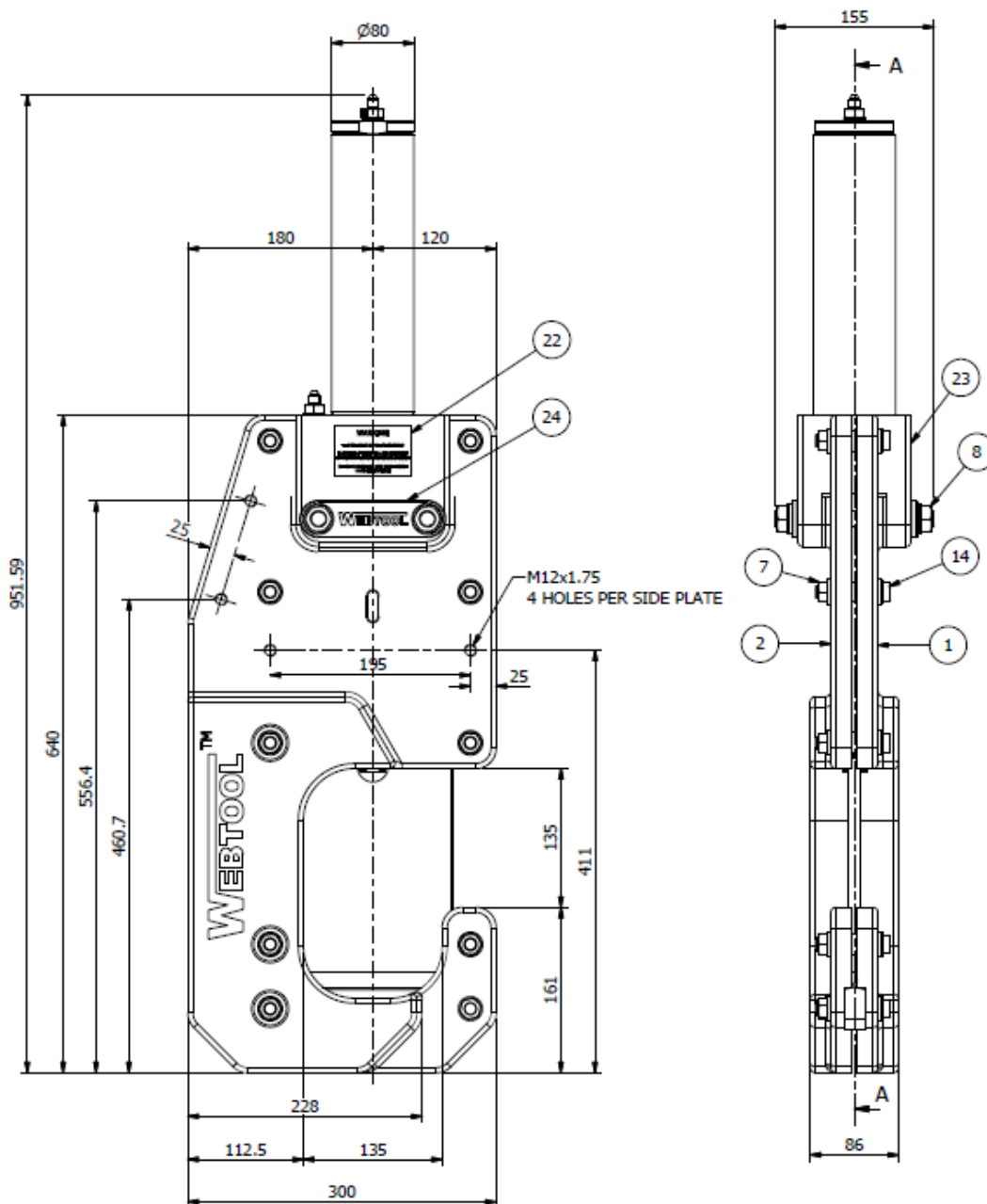


Figure 14 – Overall Dimensions



PARTS LIST				
ITEM	QTY	PART NUMBER	DESCRIPTION	
1	1	710332A	SIDE PLATE RIGHT HAND	
2	1	710332B	SIDE PLATE LEFT HAND	
3	8	715377	SPACER	
4	1	728112	CYLINDER	
5	1	728113	CYLINDER CAP	
6	1	749052	HOUSING	
7	10	758078	NUT, COLLAR SPECIAL M12	
8	4	758080	NUT, COLLAR SPECIAL M16	
9	1	761299	ANVIL	
10	1	764153	PISTON	
11	1	774039	BEARING RING	
12	1	025933	WYCLIP WIPER SEAL - 30mm	
#	13	2	025935	ROD SEAL
#	14	10	035146	SCREW, FLANGED SPECIAL M12
15	1	32-60-2413	RELIEF VALVE O-RING	
#	16	1	32-60-2437	O RING
#	17	1	32-60-2435	O RING
#	18	2	32-61-2413	A/E RING
#	19	1	32-61-2435	A/E RING
#	20	1	32-61-2437	A/E RING
#	21	1	029528	BLADE RETAINING PIN
22	1	752569	PRESSURE WARNING LABEL	
23	1	752342	NAME PLATE	
24	2	765347	RETAINING PLATE	
25	2	035160	M16 TIE BAR	
26	2	027956	RETAINING PIN	
27	2	791157	JIC ADAPTOR	
28	2	32-07-0035	1/4" BSPP DOWTY WASHER	
#	29	1	025956	PISTON SEAL
#	30	1	32-60-2427	O RING
#	31	1	32-61-2427	A/E Ring - 44.6x50
#	32	1	1155009	10K RELIEF VALVE
33	1	704013	1/4" BALL - STAINLESS	
34	1	035167	M8x8 CUP POINT SOCKET SCREW - STAINLESS	
35	1	705071S	BLADE	

# - SEAL KIT ITEMS

Table 2 – SL135 Parts list



Webtool specialise in engineering hydraulic tools for cutting and gripping rope, cable and umbilical.

Models are designed for use in subsea environments by ROV, and surface applications in hostile environments, including:

- Wire rope cutters (WCS and WCOS) – capable of cutting steel wire rope up to 75mm diameter
- Wire Rope Cutters (RCV) – capable of cutting steel wire rope up to 190mm diameter
- Cable Cutters (HCV) – capable of cutting cable, umbilical and armoured flexible pipe lines up to 330mm diameter
- Softline Cutters (SL) – capable of cutting fibre ropes in various sizes
- Wire Rope/Cable Grippers
- Wire Rope Clamps
- Automatic Shackles

#### **Application specific solutions**

Our in house design and manufacturing capability means we can quickly and efficiently develop a solution to suit your particular application. Contact us to discuss how we can help.

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