

# OPERATING INSTRUCTIONS

## Sumitomo Universal Central Tube Slitter (UCTS)

### SLITTING PROCEDURE

**CAUTION:** Avoid placing fingers in stripping channels. Blades protruding from both sides can cause injury.

1. Rotate Round Jaws, as necessary, to appropriate Slitting Channel per table below.
2. For easier setting of proper Blade depth, turn the Thumb Knobs clockwise to the fully retracted position, so that the Dial reads 0. Set the Blades according to the table below.  
NOTE: For 10.5 Tube OD (to reach 2.25 on the dial), Thumb Knob must be rotated almost two full revolutions from 0, and will read 2.25/1.0. One full revolution of the Thumb Knob will move the Blade 1.25mm.
3. Open the tool and place over the Tube. See Figure 1. Firmly grasp the handles and pull in the direction shown.

TUBE OUTSIDE DIAMETER	DIAL SETTING	SLITTING CHANNEL
18.5	1.25	LARGE
16.8	.80	
14.6	.25	
12.5	0	
10.5	2.25	SMALL
8.7	2.25	
8.0	2.05	
7.1	1.87	
6.0	1.75	
5.6	1.65	
4.75	1.50	

**NOTE:** Applying too much squeezing force on the tool will distort the tube, thereby affecting, tool performance. Only apply enough force to keep the tool from opening.

Make a short slit to confirm proper blade setting. Due to some tube size variation, you might need to further adjust the blades in or out. See Figure 2.

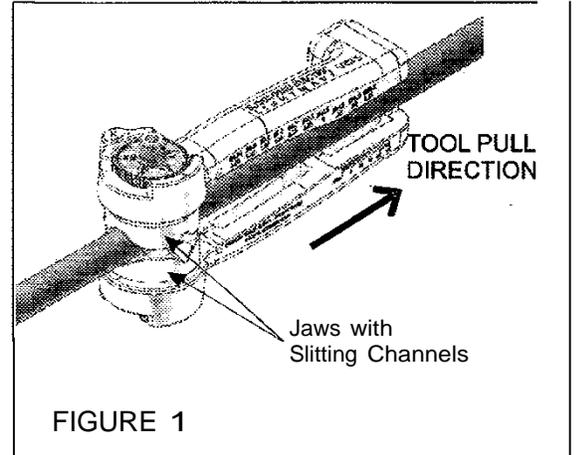


FIGURE 1

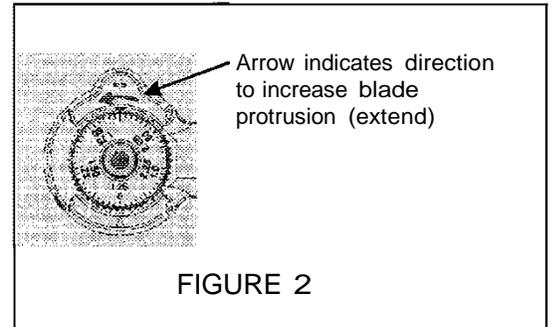


FIGURE 2

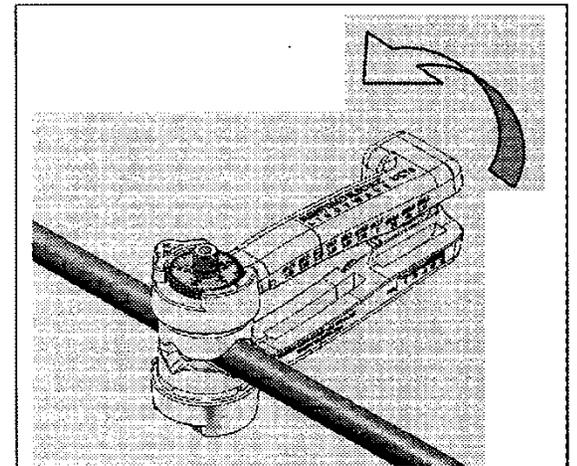


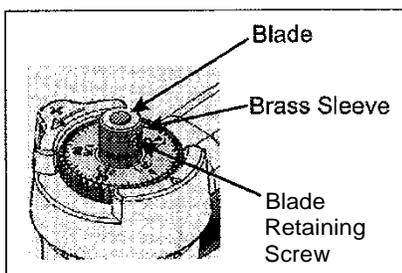
FIGURE 3

### RING CUT (for scoring)

1. Follow steps 1 to 3 above, then rotate both Round Jaws 90°. Retract the blades slightly by turning the Thumb Knobs approximately half a revolution clockwise.  
NOTE: Ensure you are using the appropriate Channel.
2. Open the tool and place over the tube. See Figure 3. Rotate the tool fully around the tube, grasping it to prevent it from opening.

### BLADE REPLACEMENT (Two per pack)

Contact Sumitomo to order replacement blades.



1. Turn thumb knob clockwise to the fully retracted position, so that the dial reads 0.
2. Loosen blade retaining screw. Remove blade through the top. Ensure the brass sleeve does not rotate before inserting the new blade.
3. Insert new blade assembly, blade end first, aligning top of blade assembly flush with top of brass sleeve. Tighten blade retaining screw.