Portable Bearing Cutting Tool
Swaged Bearing Removal Process
Disassembled Portable Bearing Cutting Tool showing separate components

Cutter Head Assy  Draw Rod  Locating Ring  Nut
Assembled Portable Bearing Cutting Tool
To cut the swaged bearing:

Disassemble the portable cutting tool
Place the draw rod into the bearing bore with the flanged side facing up
Place the locating ring onto the bottom of the draw rod with the angled side facing the bearing.
Finger tighten the nut onto the draw rod below the locating ring.
Use the flats on the draw rod for counter rotation while tightening the nut.
Place the cutter head onto the installed draw rod
While holding the cutter turn the tensioner nut clockwise until the cutting teeth are touching the bearing.
Place the crank onto the cutter head

The locating pin on the crank fits into a locating hole on the outside dimension of the cutter head.
Start cutting the swaged bearing by giving a little tension with the tensioner nut and turning the crank clockwise.

The tensioner nut lowers the cutter’s teeth down onto the swaged bearing.
For every two turns of the crank add about one fifth of a turn on the tensioner nut.

- Clockwise turns with the crank.
- Approximately 70 degrees on the tensioner nut.
Turning the crank and adding tension can be done simultaneously

The teeth will begin to cut the bearing free from the housing

Crank

Tensioner nut
Chips will form as the bearing is cut away from the housing
Cut until there is no more cutting action or when the cutter head hits the limiting stop.

The limiting stop is adjusted by the limit setting screw inside of the tensioner nut.
To disengage the cutting tool:

While holding the cutter’s head, turn the tensioner counterclockwise

Remove the cutter’s head from the draw rod

Remove any residual bearing material that has been cut from the bearing
Clean the cut chips away from the bearing and housing
Use the flats and the nut to disassemble the draw rod

Nub

Flats on the draw rod

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Remove the nut, the locating ring, and the draw rod
Clean the chips off of the cutter head
Re-assemble the cutting tool, oil, and store
Thank you!

Any questions or comments?