



HOBAS

HOBAS PIPE USA

Technical Advice Sheet

Cutting HOBAS PIPE

General:

HOBAS centrifugally cast fiberglass pipes have a smooth and uniform exterior surface. This allows the pipe to be cut anywhere along its length and joined using the FWC or closure coupling. Chamfering of the pipe ends is the only preparation needed

Safety:

Cutting of HOBAS fiberglass pipes creates silica sand and fiberglass dust. It is advisable to wear a dust mask or respirator, eye protection, and gloves when cutting or grinding, as a minimum.

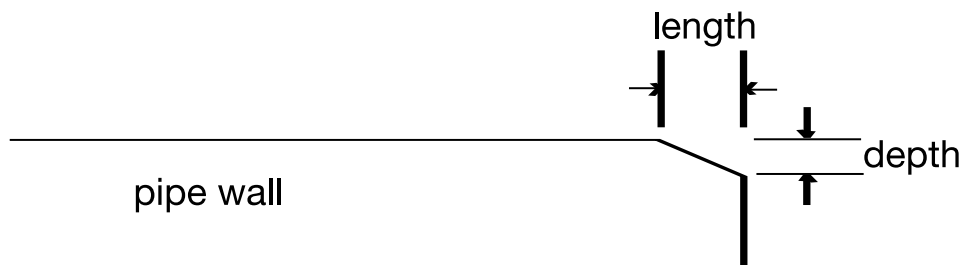
Equipment:

HOBAS pipes may be cut using a gasoline, air or electric powered disc cutter. A masonry (aluminum oxide typical), diamond tipped or other suitable abrasive cut-off saw blade could be used.

If in doubt, seek advice from:
HOBAS PIPE USA
800-856-7473

1. Mark the pipe circumferentially. Measure from a square end making sure that the cutting mark is at a right angle to the main pipe axis.
2. Provide support to either side of the cut and the pipe as a whole, so that no part will drop during cutting. If the pipe has to be rolled during the cutting process, ensure that at least one-quarter of the circumference is intact; otherwise damage may occur when moving pipes.
3. If cutting insitu, it may be necessary to cut a hatchbox out of the top of the pipe and complete the cut from the inside, if full circumferential access is not possible.
4. Carefully cut along the marked line. Before completing the cut, check again the cut piece will not drop as the cut is completed. If the pipe does drop, delamination of the pipe wall may occur. In that case, a re-cut or repair may be necessary.
5. Check the following:
 - a. The cut ends of the pipe are in good condition.
 - b. There is no damage to the pipe.
 - c. There is no delamination of the pipe wall.
6. Add the homing mark to the freshly cut pipe ends. (optional)
7. Mark all cut pieces of pipe with the pipe stiffness and pressure rating.
8. If a standard FWC coupling is to be used, then a slight chamfer (see chart below) should be made to the outside edge of the pipe. This is best done with an abrasive disc grinder.

Diameter Range	Depth (in.) Min. - Max.	Length (in.) Min. - Max.
18" - 24"	0.080 - 0.150	0.165 - 0.330
30" - 36"	0.100 - 0.200	0.220 - 0.450
42" - 54"	0.150 - 0.250	0.450 - 0.750
60" - 110"	0.200 - 0.300	0.600 - 0.900



NOTE: This general cutting procedure is also appropriate for non-square cuts such as for miters, fittings, repairs, etc. Mark the pipe for the cut required and follow steps 2-5.