

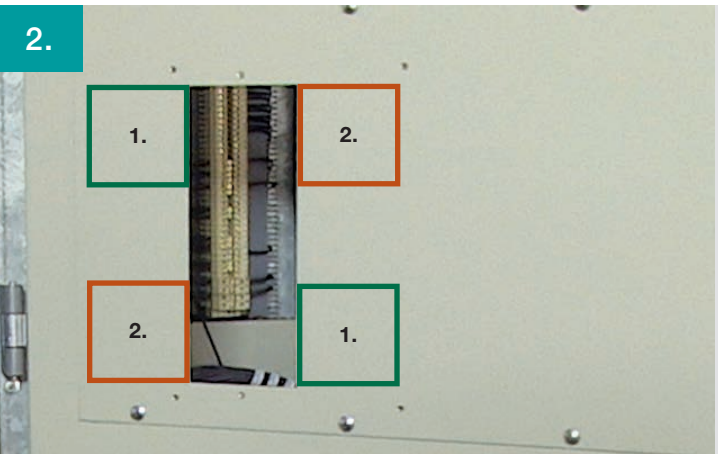
Relay Retrofit Program Cutting Tool Operating Guide BBC Std. casing size 1

Preparations



Remove the existing relay.

Ensure that there is enough space to operate the cutting tool in all intended directions. Check the space required by the replacement IED and its wiring.



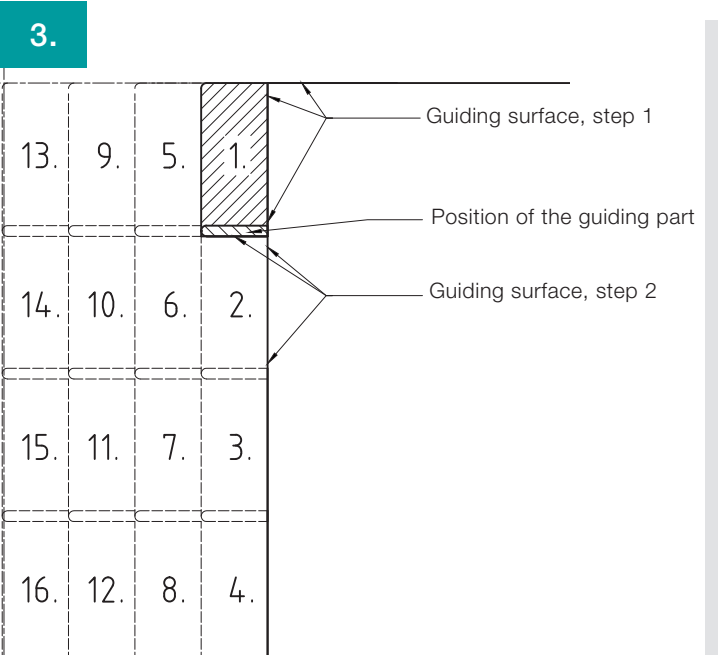
There are four optional extension directions. Cutting can be done from the front or from the back, and from any of the directions shown in the picture.

Note the additional space required for the cover plate!

1. From the front, when the door is closed.

2. From the back, when the door is open.

Cutting cycle



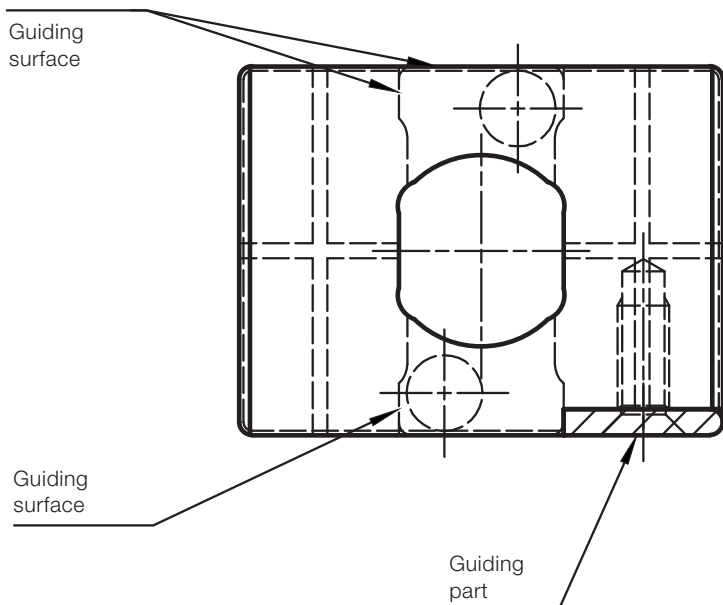
The picture shows the cutting order (1-16) for the upper left corner.

Parts 1, 5, 9 and 13 are cut as specified in step 1 on the next page.

All other parts are cut as specified in step 2 on the next page.

Operating the cutting tool on a horizontal edge

4.



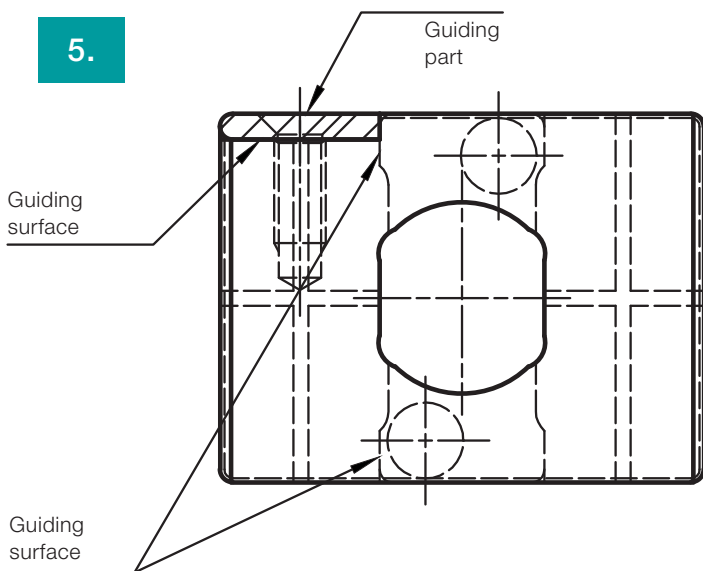
Step 1

Before cutting, ensure that the position of the cutting head is correct.

The correct positioning is shown in the image, with arrows pointing to the guiding surfaces and guiding part.

Perform the first cutting.

5.



Step 2

Turn the cutting head 180° so that the guiding part is in the position shown in the image.

Set the guiding surface as shown in the image.

Perform the second cutting.

Operating the cutting tool on a vertical edge



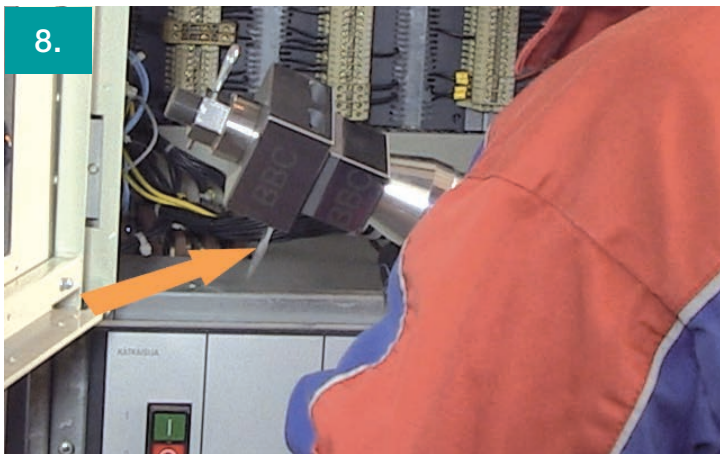
To set the cutting head for vertical guiding, push the cutting head against the edges.

Ensure that the cutting head is set in the correct position.

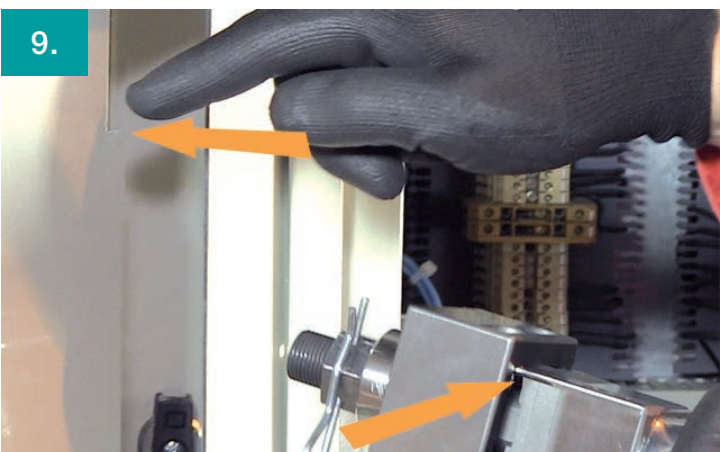


Make four punches in four columns, side by side.

Ensure that you use the correct guiding before each cutting cycle.



Remove the offcut from the cutting head after each cutting cycle.



Rotate the cutting head 180° to support the cutting tool block guide against the lower edge of the previous cut.



Push the vent lever to release the punch after each cutting cycle.

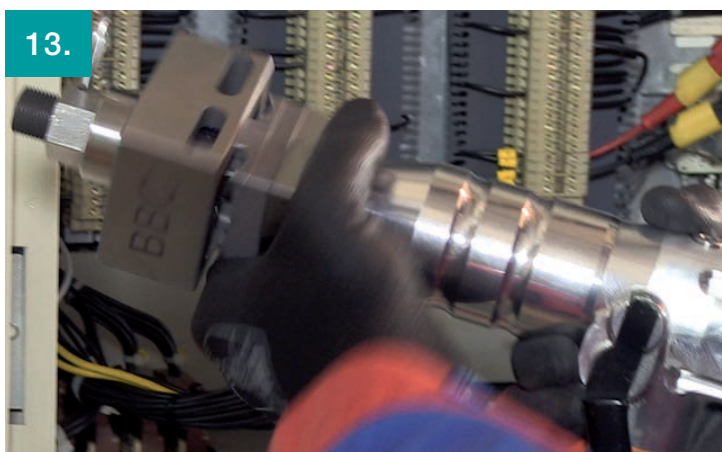


For your safety, keep your hands on the power unit, never on the cutting head.

Beware of the sharp edges!

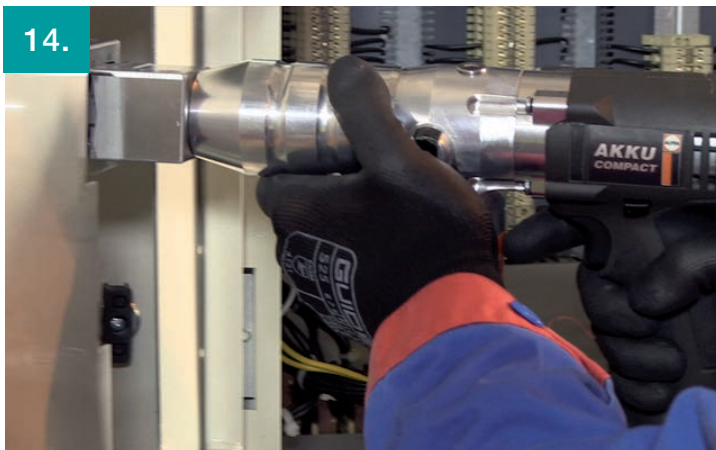


Rotate the cutting head 180° to start a new column.



Rotate the cutting head 180° to support the cutting tool block guide against the lower edge of the previous cut.

14.



Repeat the steps until you have cut three columns.

Install the cover plate

15.



Close the door and place the cover plate in its intended location.

Mark the fixing screw locations in each corner of the cover plate.

Drill the holes for fixing screws using a drill bit of 4,5 mm in diameter.

Fix the cover plate using the self-tapping screws supplied with the cover plate.

Install the new IED and finish your work

16.



Install the new IED and clean the offcuts from the floor.

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