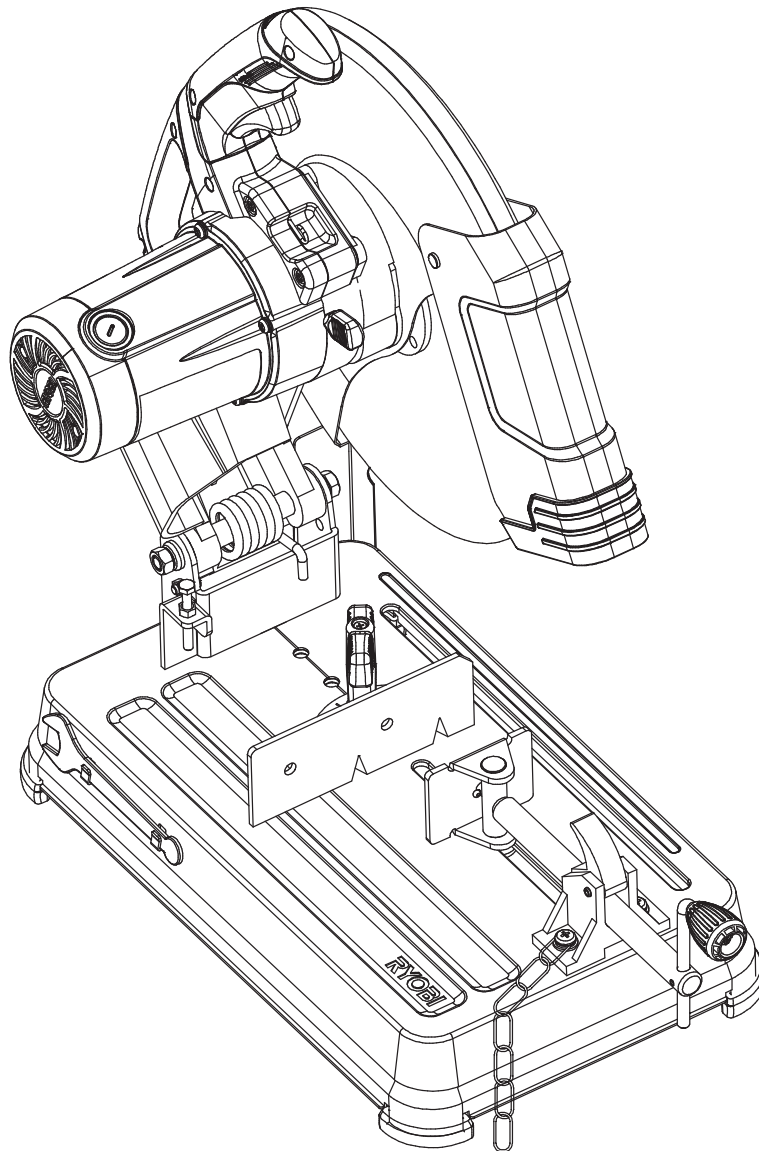




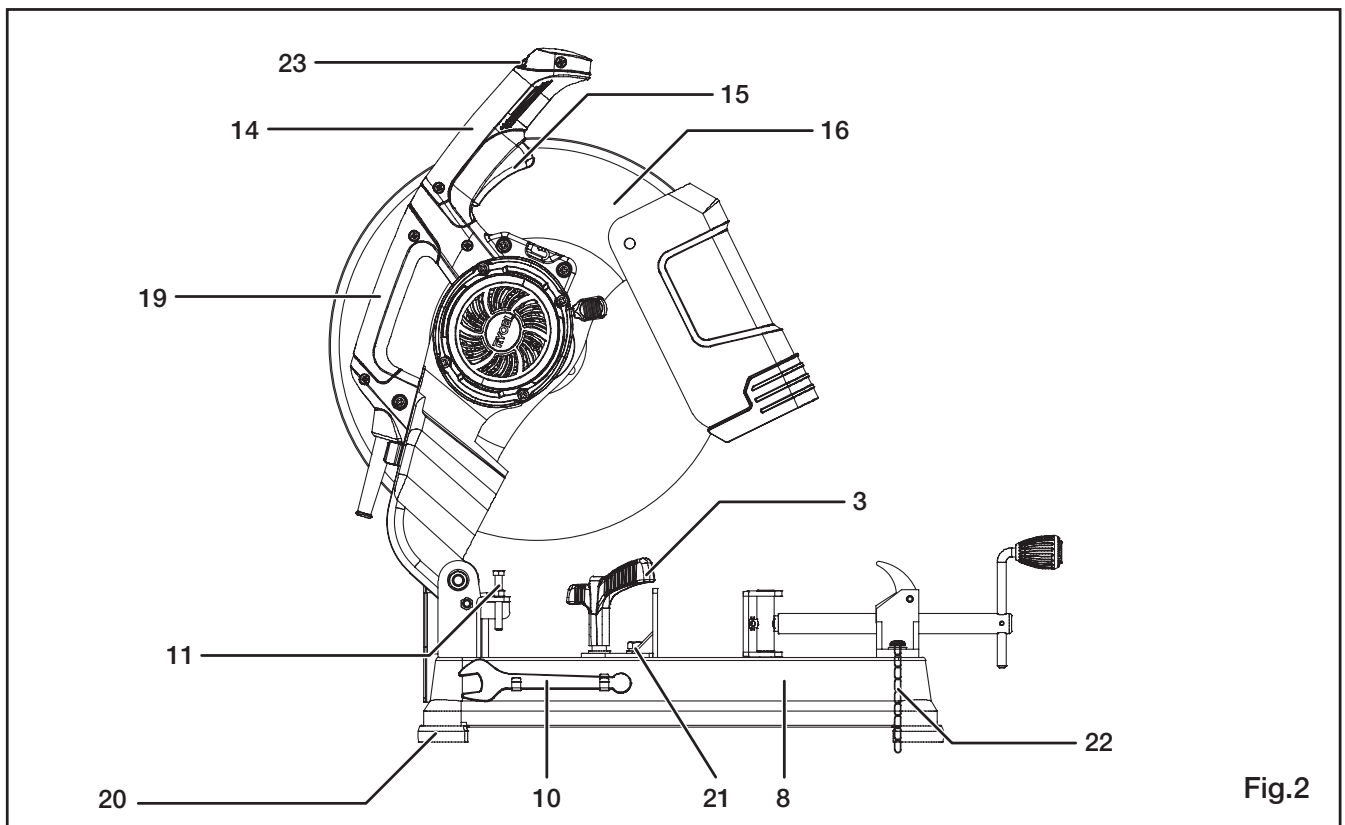
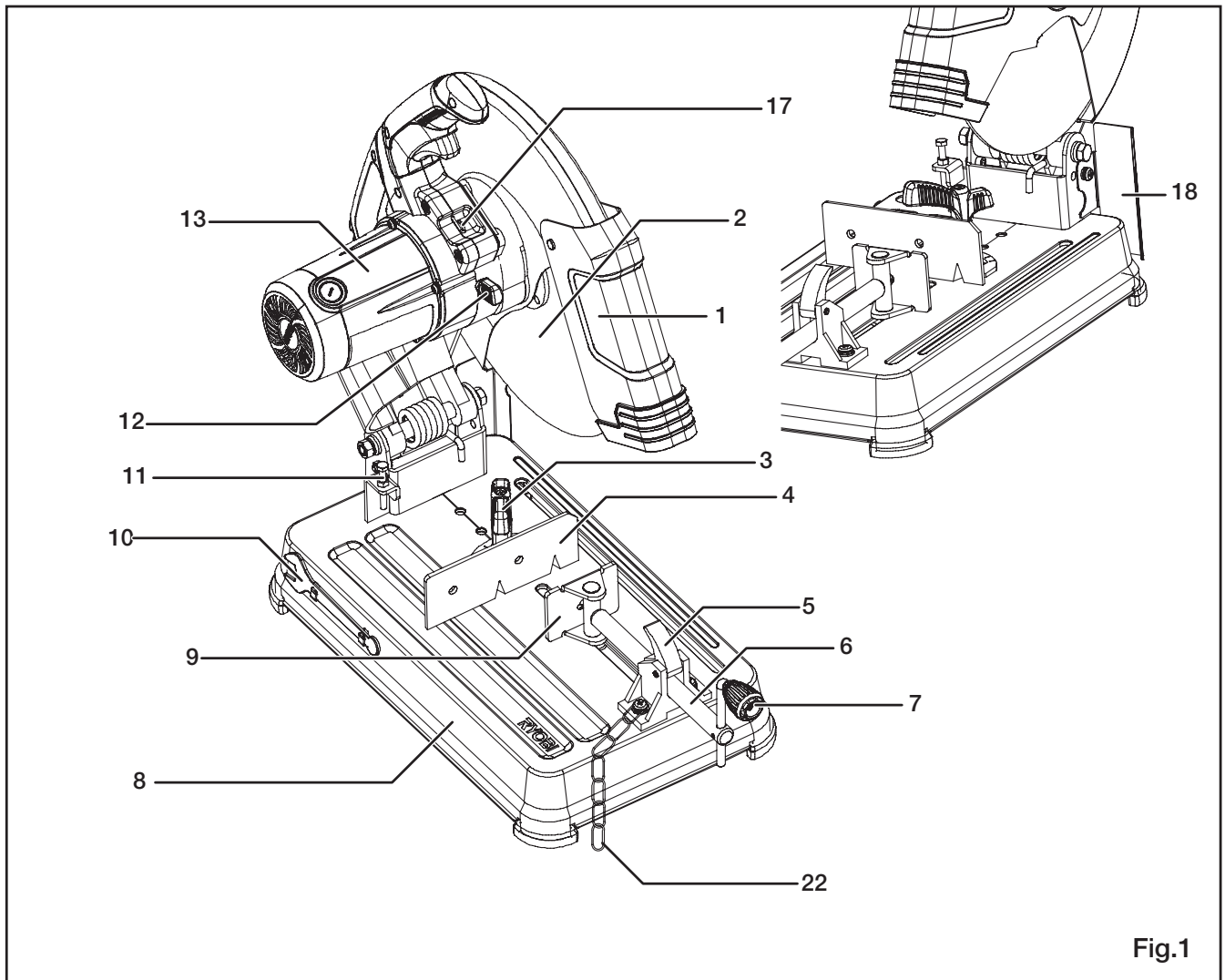
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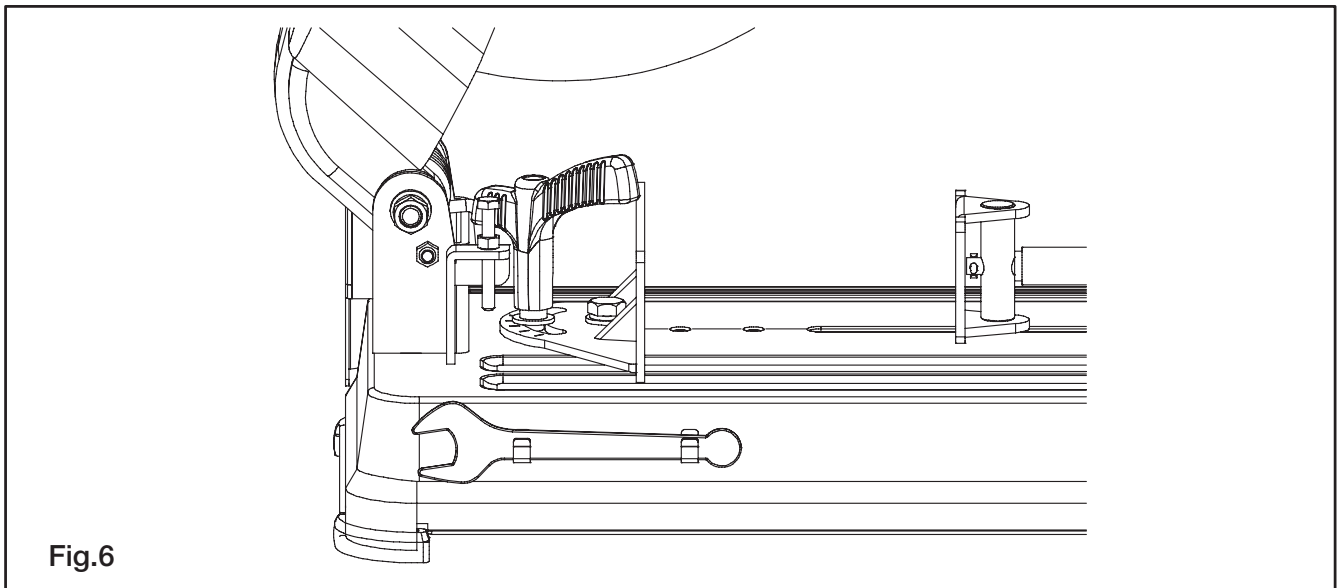
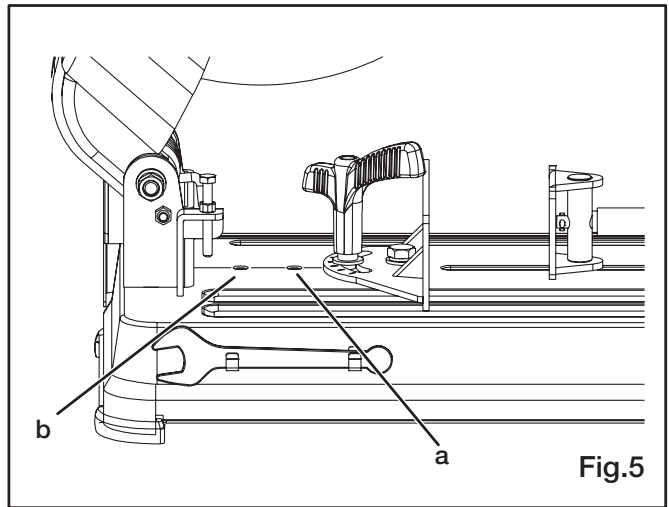
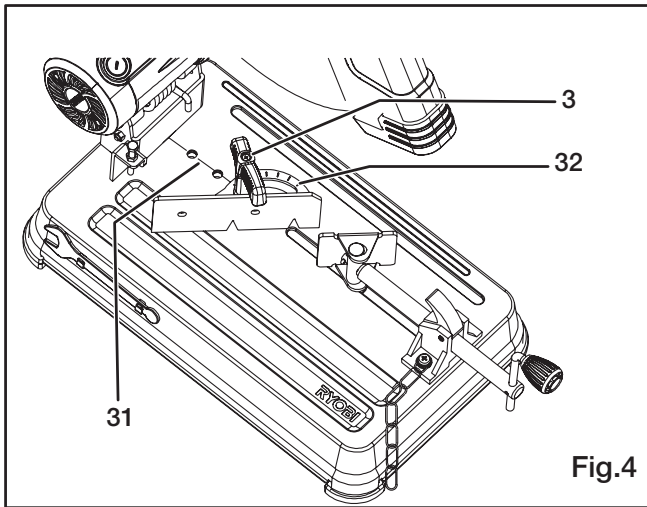
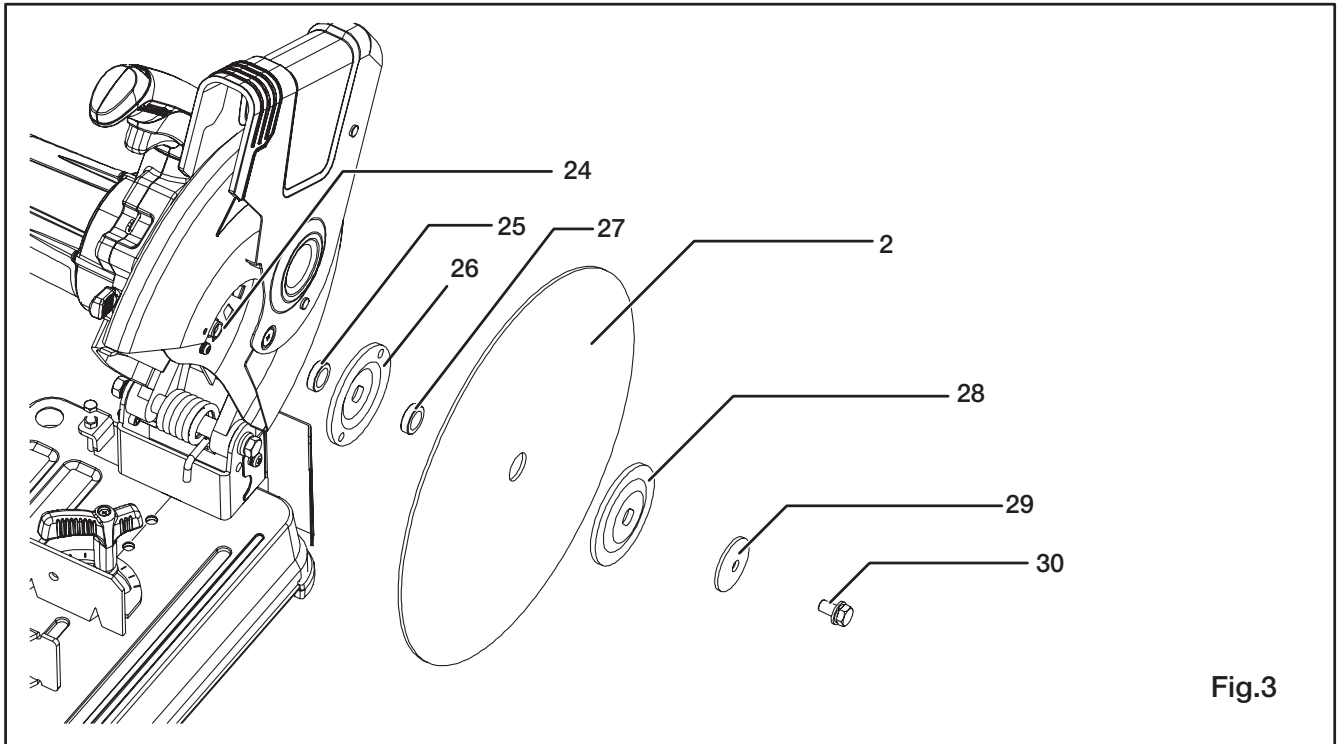
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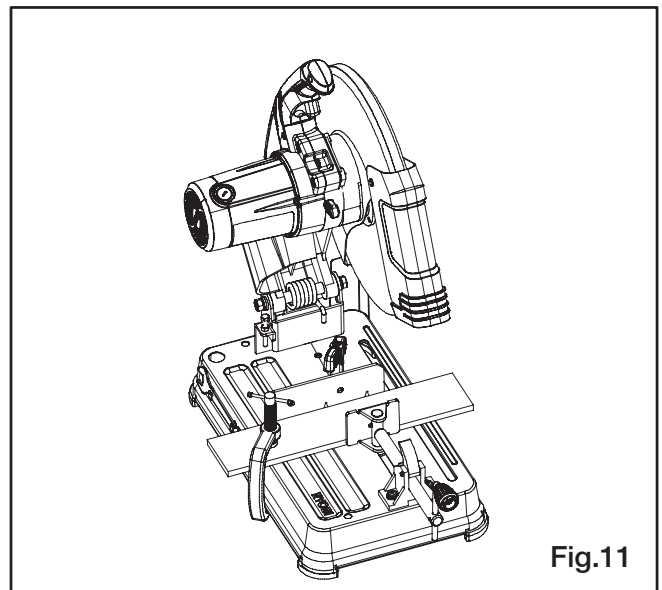
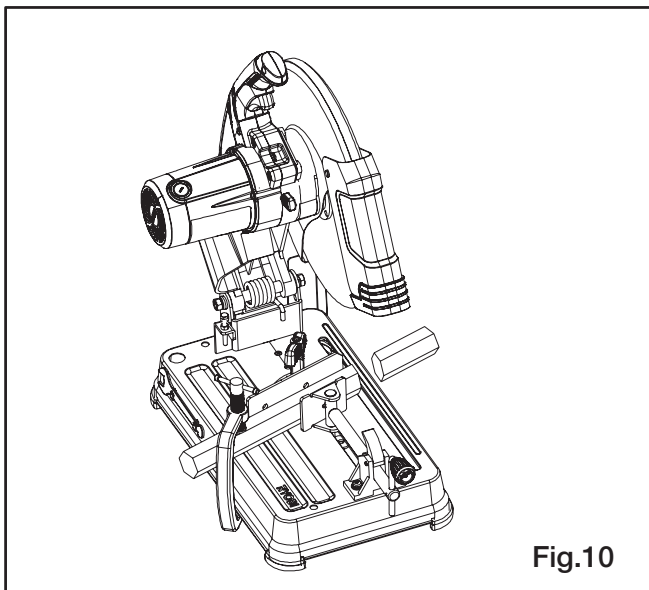
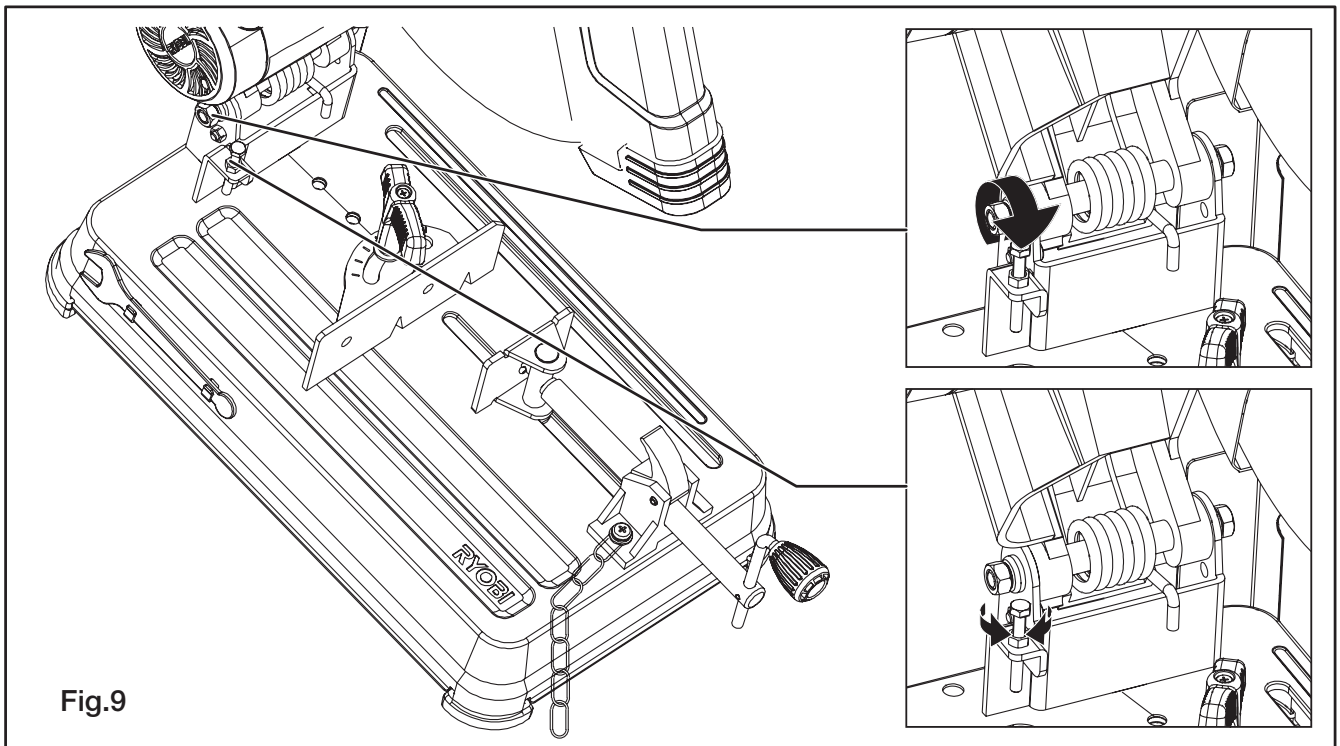
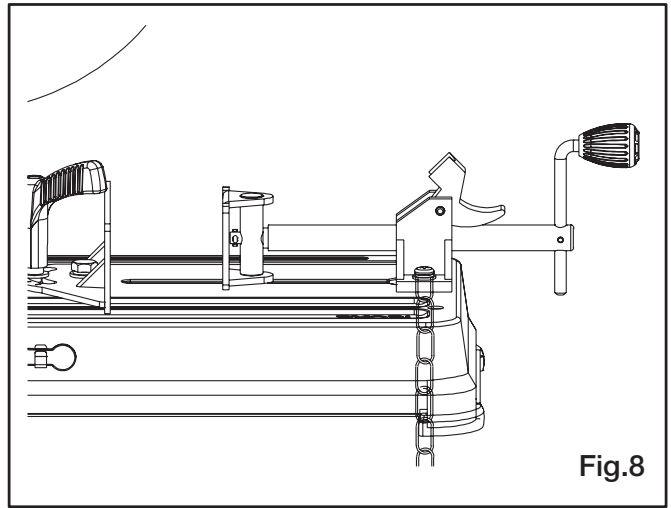
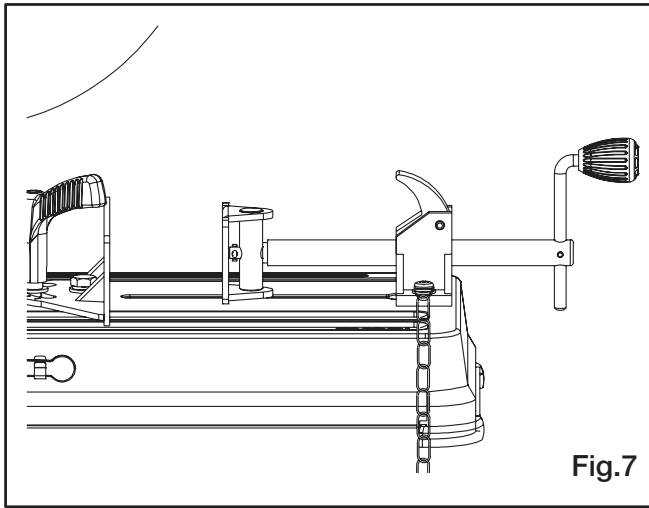
OWNER'S OPERATION MANUAL

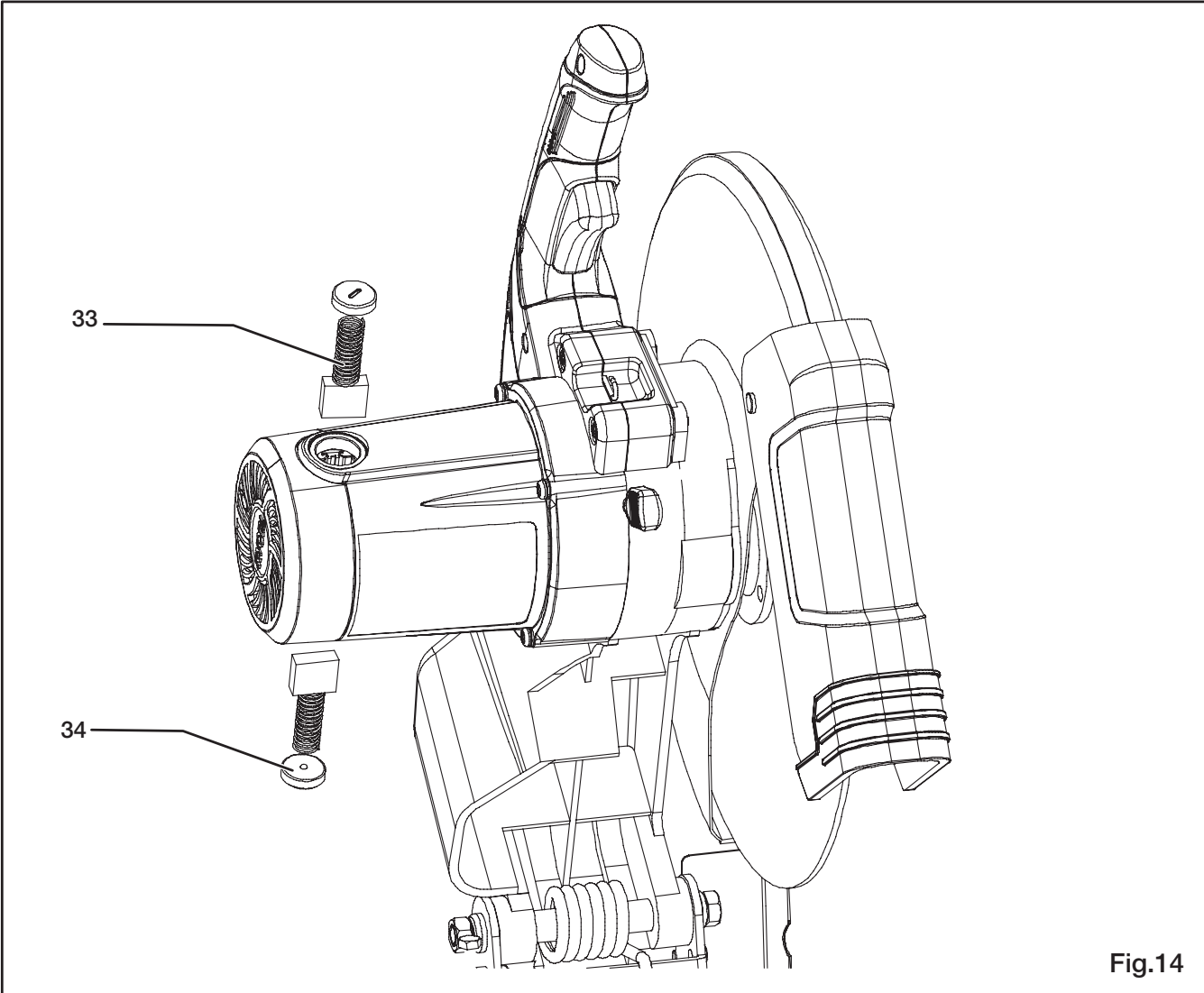
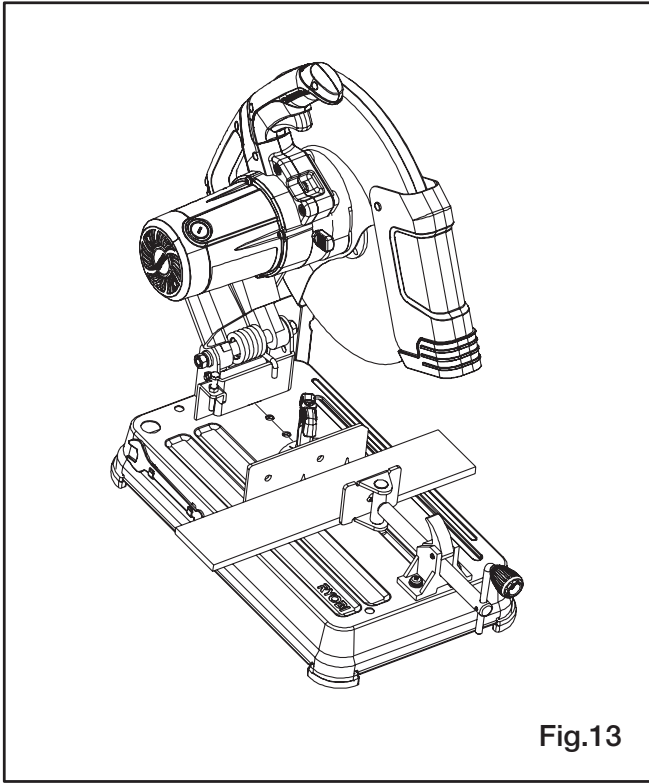
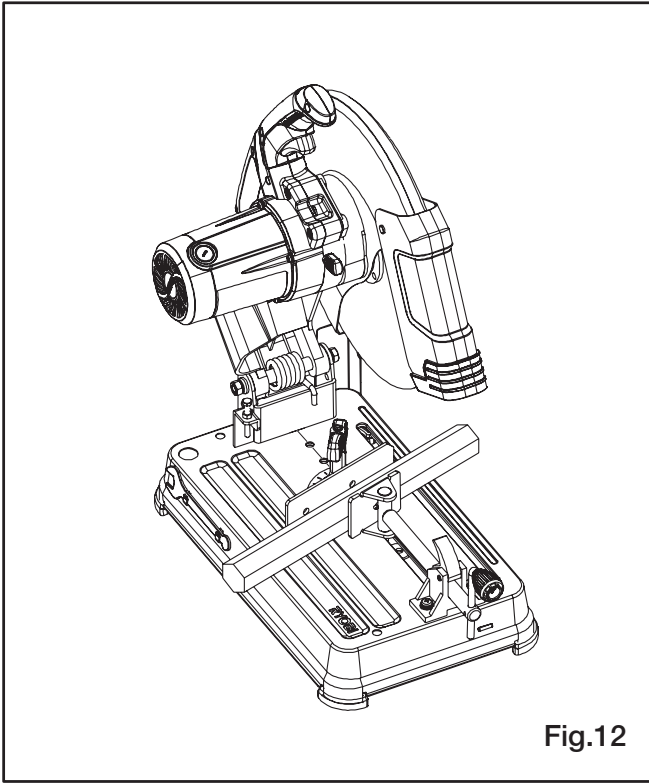


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RULES FOR SAFE OPERATION



■ USE SAFETY GLASSES

Use face or dust mask if the cutting operation is dusty. Also use ear protection to reduce the risk of induced hearing loss.

Safe operation of this power tool requires that you read and understand this operator's manual and all labels affixed to the tool. Safety is a combination of common sense, staying alert, and knowing how your cut-off machine works.

READ ALL INSTRUCTIONS

■ **KNOW YOUR POWER TOOL.** Read the operator's manual carefully. Learn the cut-off machine's applications and limitations as well as the specific potential hazards related to this tool.

■ **GUARD AGAINST ELECTRICAL SHOCK BY PREVENTING BODY CONTACT WITH GROUNDED SURFACES.** For example: pipes, radiators, ranges, refrigerator enclosures.

■ **KEEP GUARDS IN PLACE** and in good working order.

■ **REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that hex keys and adjusting wrenches are removed from tool before turning it on.

■ **KEEP THE WORK AREA CLEAN.** Cluttered work areas and work benches invite accidents.

■ **DO NOT USE IN DANGEROUS ENVIRONMENTS.** Do not use power tools in damp or wet locations or expose to rain. Keep the work area well lit.

■ **KEEP CHILDREN AND VISITORS AWAY.** Visitors should wear safety glasses and be kept a safe distance from work area. Do not let visitors touch tool or extension cord.

■ **DO NOT FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.

■ **USE THE RIGHT TOOL.** Do not force a small tool or attachment to do a job of a heavy duty tool. Don't use it for a purpose not intended.

■ **DRESS PROPERLY.** Do not wear loose clothing, or other jewellery, as they can be caught in moving parts. Rubber gloves and nonslip footwear are recommended when working outdoors. Also wear protective hair covering to contain long hair.

■ **ALWAYS WEAR SAFETY GLASSES .**Everyday eyeglasses have only impact resistant lenses, they are not safety glasses.

■ **PROTECT YOUR LUNGS.** Wear a dust mask if operation is dusty.

■ **PROTECT YOUR HEARING.** Wear hearing protection during extended periods of operation.

■ **DO NOT OVERREACH.** Keep proper footing and balance at all times.

■ **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories.

■ **DISCONNECT ALL TOOLS.** When not in use, before servicing, or when changing attachments, wheels, bits, cutters, etc., all tools should be disconnected.

■ **STORE IDLE TOOLS.** When not in use, tools should be stored in a dry or locked-up place, and kept out of reach of children.

■ **AVOID ACCIDENTAL STARTING.** Be sure switch is off when plugging in.

■ **USE RECOMMENDED ACCESSORIES.** The use of improper accessories may cause risk of injury.

■ **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the wheel is unintentionally contacted.

■ **DO NOT USE DAMAGED ABRASIVE WHEEL.**

■ **DO NOT USE THE MACHINE WITHOUT GUARD IN POSITION.**

■ **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged must be properly repaired or replaced by an authorized service center to avoid risk of personal injury.

■ **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN THE POWER OFF.** Do not leave tool until it comes to a complete stop.

■ **DO NOT REMOVE THE MACHINE'S WHEEL GUARDS.** Never operate the machine with any guard or cover removed. Make sure all guards are operating properly before each use.

■ **KEEP HANDS AWAY FROM CUTTING AREA.** Keep hands away from wheel. Do not reach underneath work or around or under the wheel while the wheel is rotating. Do not attempt to remove cut material while wheel is moving.

RULES FOR SAFE OPERATION



WARNING: Wheel coasts after turn off.

- **NEVER USE IN AN EXPLOSIVE ATMOSPHERE.** Normal sparking of the motor could ignite fumes.
- **INSPECT TOOL CORDS PERIODICALLY** and if damaged, have repaired at your nearest Ryobi Authorized Service Centre. Stay constantly aware of cord location and keep it well away from the rotating wheel.
- **USE OUTDOOR EXTENSION CORDS.** When tool is used outdoors, use only extension cords with approved ground connection that are intended for use outdoors and so marked.
- **DO NOT USE TOOL IF SWITCH DOES NOT TURN IT ON AND OFF.** Have defective switches replaced by an authorized service center.
- **KEEP TOOL DRY, CLEAN, AND FREE FROM OIL AND GREASE.** Always use a clean cloth when cleaning. Never use brake fluids, gasoline, petroleum-based products, or any solvents to clean tool.
- **ALWAYS SUPPORT LONG WORKPIECES.** To minimize risk of tipping machine, always support long workpieces.
- **BEFORE MAKING A CUT, BE SURE ALL ADJUSTMENTS ARE SECURE.**
- **ALWAYS USE THE VICE CLAMP** to secure the workpiece.
- **NEVER TOUCH WHEEL** or other moving parts during use.
- **NEVER START THE CUT-OFF MACHINE WHEN THE WHEEL IS IN CONTACT WITH THE WORKPIECE. NEVER** cut more than one workpiece at a time. **DO NOT STACK** more than one workpiece on the machine base at a time.
- **NEVER PERFORM ANY OPERATION “FREEHAND”.** Always secure the workpiece to be cut in the vice.
- **NEVER** hand hold a workpiece. Workpiece will become very hot while being cut.
- **NEVER** reach behind, under, or within three inches of the wheel and its cutting path with your hands and fingers for any reason.
- **NEVER** reach to pick up a workpiece, a piece of scrap, or anything else that is in or near the cutting path of the wheel.
- **AVOID AWKWARD OPERATIONS AND HAND POSITIONS** where a sudden slip could cause your hand to move into the wheel. **ALWAYS** make sure you have good balance.
- **NEVER** stand or have any part of your body in line with the path of the wheel.

- **ALWAYS** release the power switch and allow the wheel to stop rotating before raising it out of the workpiece.
- **DO NOT TURN THE MOTOR SWITCH ON AND OFF RAPIDLY.** This could cause the wheel to loosen and could create a hazard. Should this ever occur, stand clear and allow the wheel to come to a complete stop. Disconnect your cut-off machine from the power supply and securely retighten the wheel arbor bolt.
- **REPLACEMENT PARTS.** All repairs, whether electrical or mechanical, should be made at a Ryobi Authorized Service Centre.



WARNING:

- When servicing use only identical Ryobi replacement parts. Use of any other parts may create a hazard or cause product damage.
- **IF ANY PART OF THIS CUT-OFF MACHINE IS MISSING** or should break, bend, or fail in any way, or should any electrical component fail to perform properly, shut off the power switch, remove the machine plug from the power source and have damaged, missing, or failed parts replaced before resuming operation.
 - **MAKE SURE THE CUT-OFF WHEEL IS SECURELY MOUNTED** as described in the operating instructions before connecting the tool to a power supply. Do not tighten wheel excessively, since this can cause cracks.
 - **CHECK THE WHEEL FOR FISSURES AND CRACKS,** and test for normal operation prior to use.
 - **ONLY USE A CUT-OFF WHEEL RATED FOR 4800min¹ OR GREATER**
Always store wheels in a dry place with little temperature variation.
 - **ALWAYS EASE THE ABRASIVE WHEEL AGAINST THE WORK PIECE** when starting to cut. A harsh impact can break the wheel.
 - **BEFORE CUTTING,** press the trigger switch and allow the cut-off wheel to reach full speed before cutting.
 - **MAKE SURE THE WORK AREA HAS AMPLE LIGHTING** to see the work and that no obstructions will interfere with safe operation **BEFORE** performing any work using your cut-off machine.
 - **DO NOT OPERATE THIS TOOL WHILE UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR ANY MEDICATION.**
 - **ALWAYS STAY ALERT!** Do not allow familiarity (gained from frequent use of your cut-off machine) to cause a careless mistake. **ALWAYS REMEMBER** that a careless fraction of a second is sufficient to inflict severe injury.

ENGLISH

RULES FOR SAFE OPERATION

- **STAY ALERT AND EXERCISE CONTROL.** Watch what you are doing and use common sense. **Do not operate tool when you are tired. Do not rush.**
- **SAVE THESE INSTRUCTIONS.** Refer to them frequently and use them to instruct other users. If you loan someone this tool, loan them these instructions also.

PRODUCT SPECIFICATIONS

Wheel Type	Reinforced Abrasive Wheels
Wheel Diameter	355 mm (14")
Bore Diameter	25.4mm(1")
No Load Speed	3900+/-10% min-1
Rating	240 V ~ 50 Hz
Input	2400 W
Net Weight	17.5 Kg
Fence Angle	
Right	45°
Left	45°
Vice Clamp-Angle	
Right or Left	45°

Maximum Cutting Capacities:

Shape Angle				
0°	115 mm (4-1/2")	119 mm (4-23/32")	115 mm x 130 mm (4-1/2" x 5-3/32") 102 mm x 194 mm (4" x 7-5/8") 70 mm x 233 mm (2-3/4" x 9-5/32")	137mm (5-3/8")
45°	115 mm (4-1/2")	106 mm (4-3/16")	115mmx103mm (4-1/2" x 4")	100mm (3-15/16")

WARNING:

This cut-off machine has been designed for cutting metals, using reinforced abrasive cut-off wheels only. Do not remove the wheel, install a steel blade, and attempt to cut other types of materials such as wood, masonry, etc. Attempting to cut these other types of materials could cause an accident resulting in possible serious personal injury.

WARNING:

Do not attempt to modify this tool or create accessories not recommended for use with this tool. Any such alteration or modification is misuse and could result in a hazardous condition leading to possible serious personal injury.

DESCRIPTION (Fig 1&2&3)

- | | |
|------------------------|------------------------|
| 1 Lower Guard | 18 Protection Guard |
| 2 Abrasive Wheel | 19 Carry Handle |
| 3 Fence Quick Lock | 20 Rubber Foot |
| 4 Adjustable Fence | 21 Fence Bolt |
| 5 Lock Lever | 22 Chain |
| 6 Vice Screw | 23 Live Tool Indicator |
| 7 Vice Crank Handle | 24 Wheel Arbor |
| 8 Machine Base | 25 Inner Washer |
| 9 Vice Clamp | 26 Inner Flange |
| 10 Wrench | 27 Spacer |
| 11 Depth Stop Bolt | 28 Outer Flange |
| 12 Spindle Lock Button | 29 Outer Washer |
| 13 Motor | 30 Wheel Bolt |
| 14 Machine Arm | 31 Scale Indicator |
| 15 Switch Trigger | 32 Fence Scale |
| 16 Upper Guard | 33 Brush Assemblies |
| 17 Lock Hook | 34 Brush Cap |

FEATURES

MOTOR

This machine has a strong motor with sufficient power to handle tough cutting jobs. It also has externally accessible brushes for ease of servicing.

POWER CORD

The power cord is H07RN-F type with length 1.8 earthing.

ABRASIVE WHEEL

A 355mm abrasive wheel is included with your cutoff machine. It may cut materials up to 115mm thick or 233mm wide, depending upon the thickness or width of the material and the angle setting at which the cut is being made.

SELF-RETRACTING LOWER WHEEL GUARD

The lower wheel guard provides protection from each side of the wheel. It retracts over the upper wheel guard as the wheel is lowered into the workpiece.

VICE CLAMP

A vice clamp has been provided with your cut-off machine. It is located on the end of the vice screw and provides greater control by clamping the workpiece to the fence. It also prevents the workpiece from creeping toward the wheel during a cutting operation.

FEATURES

ADJUSTABLE FENCE

The fence on your cut-off machine has been provided to support the workpiece and provide clamping support to the vice for holding your workpiece securely when making all cuts. It is an adjustable fence that has been provided to make your cut-off machine more versatile. It adjusts from 0° to 45°(L&R) for making angled cuts. The hole pattern allows it to be moved forward when making cuts in tall or thick stock, such as square stock or tube stock. The hole pattern allows it to be moved back when making cuts in stock that is thin or wide, such as angle stock.

QUICK LOCK-RELEASE LEVER

A lock lever has been provided on your cut-off machine. This feature allows you to open and close the vice clamp quickly without repetitive turning of the vice crank handle.

CARRYING HANDLE

For convenience when carrying or transporting your cut-off machine from one place to another, a carrying handle has been provided on top of the machine arm.

To transport, turn off and unplug your machine, then lower machine arm and lock it in the down position. Use the transport chain to lock machine arm in the down position.

SPINDLE LOCK BUTTON

A spindle lock button has been provided for locking the spindle whilst changing the abrasive wheel.

Pull the spindle lock button while installing, changing, or removing wheel only.

ADJUSTMENTS



WARNING:

To prevent accidental starting that could cause possible serious personal injury, assemble all parts to your cut-off machine before connecting it to power supply. Machine should never be connected to power supply when you are assembling parts, making adjustments, installing or removing wheels, or when not in use.

As mentioned previously your cut-off machine has been factory assembled and adjusted. After extended use and wear, the wheel will need to be replaced with a new one.



WARNING:

A 355 mm wheel is the maximum wheel capacity of your cut-off machine. Never use a wheel that is too thick to allow outer flange to engage with the flats on the spindle. Larger wheels will come in contact with the wheel guards, while thicker wheels will prevent the bolt from securing the wheel on the spindle. Either of these situations could result in a serious accident and can cause serious personal injury.

REMOVAL AND INSTALLATION OF THE WHEEL (Fig. 3)

- Unplug your cut-off machine.



WARNING:

Before performing any adjustment, make sure the tool is unplugged from the power supply. Failure to heed this warning could result in serious personal injury.

- Push down on machine arm and remove chain from hook on motor housing to release machine arm.
- Raise machine arm to its full lifted position. Be cautious when raising, machine arm is spring loaded.
- Pull lower wheel guard upward, exposing wheel bolt that secures abrasive wheel to wheel arbor.
- Pull the spindle lock button and rotate bolt until spindle locks, preventing shaft from rotating.
- Using the Wrench provided, to loosen and remove bolt. Note: Bolt has right hand threads. Turn bolt counterclockwise to loosen.
- Remove outer washer, outer flange, and wheel. Do not remove spacer, inner flange and inner washer. Removal of these three parts are not required for wheel changes.



WARNING:

If spacer, inner flange or inner washer has been removed, replace those parts before placing on wheel arbor. Failure to do so could cause an accident since wheel will not tighten properly.

TO INSTALL (Fig. 3)

- Unplug your cut-off machine.



WARNING:

Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.

ADJUSTMENTS

- Inspect the replacement wheel for defects such as cracks, chipping, and correct speed rating. If defects are found or the speed rating is not greater than 4800min⁻¹, stop using the wheel. Select another wheel.
- Clean debris from the inner washer and inner flange.
- Place new wheel over spacer, then place both on wheel arbor against inner flange.
- Clean outer flange, then align flats with flats on wheel arbor and slide it onto arbor until it is flushed against wheel.
- Place recessed side of outer washer against arbor, then insert wheel bolt into threaded end of wheel arbor.
- Start threads and turn bolt clockwise to snugly tighten.
- Pull the spindle lock button and rotate bolt until spindle being locked. This will prevent shaft from rotating.
- Using the wrench provided, securely tighten wheel bolt.
Note: Bolt has right hand threads. Turn bolt clockwise to tighten.



WARNING:

Do not overtighten wheel bolt. Overtightening can cause the new wheel to crack, resulting in premature failure and possible serious personal injury.

PROTECTION GUARD

- In order to avoid spark splashing, under the operational condition, loose the screw and adjust angle of the protection guard.

ADJUSTABLE FENCE (Fig. 4)

The adjustable fence is located at the rear of your cut-off machine. It is used along with the vice clamp to provide a clamp for holding your workpiece securely when making cuts. It also makes your cut-off machine more versatile.

The fence can be rotated to obtain cutting angles from 0° to 45° (L&R). It can also be moved back to allow greater cutting widths in thin stock, or moved forward to allow greater cutting depths in tall or thick stock.

CUTTING ANGLE ADJUSTMENT (Fig. 4)

- Unplug your cut-off machine.



WARNING:

Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.

- Loosen the fence quick lock, by using the wrench supplied. Then loosen the fence bolt to secure the adjustable fence.
- Rotate fence until the desired angle of cut on the scale is aligned with the indicator in machine base.
- For precise cuts, check the angle of cut for the fence against the abrasive wheel with a protractor, bevel square, or other similar device.
- Tighten the fence quick lock, by using the wrench supplied, then securely tighten fence bolt. Return wrench to its storage area in the base.

- This will secure the fence in place at desired angle.

ADJUSTING WIDTH OF CUT (Fig. 5-6)

- Unplug your cut-off machine.



WARNING:

Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.

- The default space between the vice and the fence is 0 mm min. to 170 mm max. By following the below adjustment procedures, it is possible to increase that distance so that the vice is between 35 mm and 205 mm or 70 mm and 240 mm from the fence.



WARNING:

Bevel cutting angle is not suitable for the above 2 suggested width of cuts.

- To increase the width of cut of your cut-off machine, loosen and remove the fence quick lock and washer. The use the wrench supplied to loosen and remove the fence bolt and washers to secure fence to machine base.
- Reposition the curved slot of the fence with the threaded hole (b) at the back of the machine base.
- Install a fence quick lock through a flat washer into machine base. Do not tighten fence quick lock bolt securely.
- Align remaining fence bolt hole with the middle threaded hole (a) of the machine base.
- Install fence bolt through lock washer and flat washer into machine base.
- Check and adjust fence to 0° cutting angle.
- Securely tighten fence quick lock and fence bolts.
- This position is good for cutting thin and wide pieces of stock, such as flat or angled stock.
- To increase the height of cut of your cut-off machine, follow the above procedure except place the rear fence bolt in the middle threaded hole (a) and the front fence bolt in the front threaded hole.
- Check and adjust fence to desired cutting angle.
- Using the wrench provided, securely tighten fence quick lock on fence bolts. Return hex key to its storage area in base.
- This position is good for cutting tall and thick pieces of stock, such as square or tube stock.

LOCK LEVER (Fig. 7-8)

The lock lever engages the vice clamp. It can be used along with the fence to provide a vice for securing the workpiece to be cut.

- It also allows you to open and close the vice quickly without repetitive turning the vice crank handle.

USING THE QUICK LOCK-RELEASE LEVER AND VICE CLAMP (Fig. 7-8)

To loosen:

- Unplug your cut-off machine.

ADJUSTMENTS



WARNING:

Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.

- Release tension on the vice clamp by rotating the vice crank handle 1/2 to 1 turn counterclockwise.
- Lift up the quick lock-release lever and pull back on vice crank handle to slide open the vice.

To tighten:

Unplug your cut-off machine.



WARNING:

Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.

- Push the vice crank handle forward to slide the vice clamp against the workpiece.
- Rotate the lock lever forward and push down to engage its threads with the vice screw.
- Rotate the vice crank handle clockwise to tighten the vice clamp against the workpiece.

DEPTH STOP

The depth stop limits the wheel's downward travel. It allows the wheel to go below the machine base in order to maintain full cutting capacities.

The adjustable depth stop is a bolt threaded into the bracket of the machine at the rear. To adjust the depth stop, use the wrench to raise or lower the depth stop bolt.

The depth stop has been set already to provide the maximum cutting capacity for the 355mm (14") abrasive wheel.

When the diameter of the wheel has been reduced due to wear, it may be necessary to adjust the depth stop to provide maximum cutting capacity. When a new abrasive wheel is installed, it is necessary to check the clearance of the wheel to the machine base support.

DEPTH STOP ADJUSTMENTS (Fig. 9)

- Unplug your cut-off machine.



WARNING:

- Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.
- Loosen the lock nut of the depth stop bolt that is against the machine bracket.

- The depth stop is lowered by turning the depth stop bolt clockwise and raised by turning the bolt counterclockwise.
- By pressing down on the machine arm, lower the wheel and check clearance and maximum cutting distance (distance from adjustable stationary vice where wheel enters) to front of machine base slot.
- Adjust if necessary. Re-tighten depth stop bolt lock nut securely.



CAUTION:

Do not start your abrasive cut-off machine without checking for interference between the wheel and the machine base support. Damage may result to the wheel if it strikes the machine base support during operation of the machine.

- Tighten the depth stop bolt with the wrench provided.



WARNING:

Cutting steel will cause sparks. Tighten the depth stop bolt with the hex key provided. Do not operate in the presence of combustible or flammable materials. Failure to heed this warning could result in a fire or serious personal injury.

OPERATION

APPLICATIONS

(Use only for the purposes listed below)

- Cutting all types of ferrous metals such as 50.8mm (2") x 152.4mm (6") steel framing studs.
- Cutting hard metal iron stock such as square bar stock and angle iron.
- Cutting metal tube and pipe stock.

POWER SUPPLY

Before operating your cut-off machine, check your power supply and make sure it meets the requirements listed on the tool's data plate. A substantial voltage drop will cause a loss of power and machine overheating.

Common causes of power loss and machine overheating are insufficient extension cord size and multiple tools operating from the same power source.

SWITCH

To turn your cut-off machine **ON**, depress the switch trigger located in the handle portion of the machine arm.

To turn it **OFF**, release the switch trigger.

OPERATION

CUTTING WITH YOUR CUT-OFF MACHINE (Fig. 10-11)



WARNING:

Do not attempt to cut wood or masonry with this cut-off machine. Never cut magnesium or magnesium alloy with this machine. Failure to comply could result in serious personal injury.

- To prevent machine movement or tipping during cutting procedure, secure cut-off machine in place to a workbench or work surface that is also secured.



WARNING:

Always use the vice on the cut-off machine to prevent accidents that could result in possible serious personal injury.



WARNING:

Never stand or have any part of your body in line with the path of the wheel as this may cause serious personal injury.



WARNING:

Large, circular, or irregularly shaped material may require additional means of clamping for cutting adequately. Use "C" clamps that can be mounted along the left and front side of the machine base.



WARNING:

Also use blocks to hold material securely. Failure to comply could result in serious personal injury.

To avoid accidental start up of your cut-off machine, always make sure the switch is off before connecting to power source. Failure to heed this warning could result in serious personal injury.

CUT-OFF (Fig. 12-13)

A cut-off is made by cutting across the width of the workpiece. A straight crosscut is made with the adjustable fence set at the zero degree position. Angled cut-offs are made with the adjustable fence set at some angle other than zero.

To cut with your cut-off machine:

- Firmly secure the material to be cut by using the machine's vice (or adjustable fence and vice clamp).

- Loosen the fence quick lock and fence bolts securing the fence.
- Rotate the adjustable fence to the angle needed.
- Retighten fence quick lock and fence bolt to secure the fence.



WARNING:

To avoid serious personal injury, always tighten fence quick lock and fence bolts securely before making a cut. Failure to do so, could result in movement of the workpiece while making a cut.

- Place the workpiece flat on the machine base with one surface securely against the adjustable fence.
- Align cutting line on the workpiece with the edge of the abrasive wheel.
- Push in the vice crank handle to set the vice clamp against the workpiece. Turn the vice crank handle 1/2 to 1 turn clockwise to securely clamp the workpiece to the fence.



WARNING:

To avoid serious personal injury, keep your hands at least 76.2 mm (3") from wheel.

- When cutting long pieces, support the opposite end of the material with a roller stand or with a work surface level with the machine base.



WARNING:

Never perform any cutting operation freehand (without placing workpiece in the vice). Material will get hot during cutting operation. Keep hands off of metal being cut to avoid serious personal injury.

- Before turning on machine, perform a dry run of the cutting operation just to make sure that no problems will occur when the cut is made.
- Start the machine by grasping the handle and fully squeezing the switch trigger. Allow several seconds for the wheel to build up to full speed before letting it come into contact with the material to be cut.
- Once it reaches full speed slowly lower the handle of the machine arm until the cut-off wheel comes in contact with the material being cut. Continue to use steady and even pressure to obtain a uniform cut through the workpiece. Never force the wheel into the material being cut.

OPERATION

- Once the cut is completed, release the switch trigger and allow the wheel to stop rotating before raising the wheel out of the workpiece.



WARNING:

Do not touch the cut material until it has cooled down or you can be burned easily. Failure to heed this warning could result in serious personal injury.

MAINTENANCE



WARNING:

To ensure safety and reliability, all repairs (with the exception of the externally accessible brushes) should be performed by a Ryobi Authorized Service Centre.

BRUSH REPLACEMENT (Fig. 14)

Your cut-off machine has externally accessible brush assemblies that should be periodically checked for wear.

Proceed as follows when replacement is required:

- Unplug your cut-off machine.



WARNING:

Failure to unplug cut-off machine could result in accidental starting causing possible serious personal injury.

- Remove brush cap with a screwdriver. Brush assembly is spring loaded and will pop out when you remove brush cap.
- Remove brush assembly.
- Check for wear. Replace both brushes when it is less than 6.35mm (1/4") length of carbon remaining.
- Do not replace one side without replacing the other. Reassemble using new brush assemblies. Make sure curvature of brush matches curvature of motor and that the brush moves freely in brush tube.
- Make sure brush cap is oriented correctly (straight) and replaced.
- Tighten brush cap securely. Do not overtighten.

ENGLISH

TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
Machine does not start	<ol style="list-style-type: none">1. Power cord not plugged in.2. Power cord is damaged.3. Circuit breaker is tripped.4. Circuit fuse is blown.5. Switch is damaged or burned out.	<ol style="list-style-type: none">1. Plug in cord.2. Have the cord replaced at your nearest authorized service centre.3. Reset circuit breaker.4. Replace circuit fuse.5. Have the switch replaced at your nearest authorized service centre.
Motor does not reach full speed or power.	<ol style="list-style-type: none">1. Voltage from power source is low.2. Circuit is overloaded.3. Motor burned out.4. Fuses or circuit breakers are wrong size.5. Extension cord is too long.6. Switch is defective.	<ol style="list-style-type: none">1. Request a voltage check up.2. Test on a different circuit or without anything else on circuit.3. Have tool serviced and request a voltage check.4. Have an electrician replace with a wrong size. circuit breaker.5. Use a shorter extension cord.6. Have the switch replaced at your nearest authorized service centre.
Motor stalls, blows fuses, or trips circuit breakers.	<ol style="list-style-type: none">1. Switch is defective.2. Voltage from source is low.3. Fuses or circuit breakers are wrong size or defective.	<ol style="list-style-type: none">1. Have the switch replaced at your nearest authorized service center.2. Request a voltage check.3. Have an electrician replace with a circuit breaker.
Motor overheats.	<ol style="list-style-type: none">1. Motor is overloaded.2. Wheel is being fed into work too fast.	<ol style="list-style-type: none">1. Request a voltage check.2. Feed wheel into work slower.
Machine is noisy when running.	<ol style="list-style-type: none">1. Motor needs attention.	<ol style="list-style-type: none">1. Have the motor checked at your nearest authorized service centre
Wheel hits table.	<ol style="list-style-type: none">1. Wheel not properly installed.2. Depth stop setting incorrect.	<ol style="list-style-type: none">1. See "Removal and Installation of Wheel" section.2. Adjust the depth stop. See "Depth Stop" section.

ENGLISH

TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
Wheel does not cut through workpiece.	<ol style="list-style-type: none">1. Depth stop setting incorrect.2. Wheel worn too much.3. Incorrect cutting operation.	<ol style="list-style-type: none">1. Adjust the depth stop. See "Depth Stop" section.2. Replace with a new 355mm (14") abrasive cut off wheel.3. See "Cut-Off" section.
Machine vibrates or shakes excessively.	<ol style="list-style-type: none">1. Wheel is out-of-round.2. Wheel is chipped.3. Wheel is loosen.4. Machine is not secured.5. Work surface is uneven.	<ol style="list-style-type: none">1. Replace wheel.2. Replace wheel.3. Tighten wheel bolt on arbor.4. Check and tighten all hardware.5. Relocate and secure on a flat surface.

TECHTRONIC INDUSTRIES AUSTRALIA PTY LIMITED
GUARANTEE



Subject to the guarantee condition below, this Ryobi tool (hereinafter called "the product") is guaranteed by TECHTRONIC INDUSTRIES AUSTRALIA PTY LIMITED (hereinafter called "the Company") to be free from defects in material or workmanship for a period of 24 months from the date of original purchase covering both parts and labour. Under the terms of this guarantee, the repair or replacement of any part shall be the opinion of the Company or its authorised service centre. Should service become necessary during the warranty period, the owner should contact the customer service HELPLINE 1300 361 505 or contact the retailer from whom the product was purchased.

In order to obtain guarantee service, the owner must present the sales docket and Guarantee Certificate to confirm date of purchase. This product is sold by the dealer or service centre as principal and the dealer has no authority from the Company to give any additional guarantee on the Company's behalf except as herein contained or herein referred to.

Guarantee Conditions

This guarantee only applies provided that the Product has been used in accordance with the manufacturer's recommendations under normal use and reasonable care (in the opinion of the Company) and such

guarantee does not cover damage, malfunction or failure resulting from misuse, neglect, abuse, or used for a purpose for which it was not designed or is not suited and no repairs, alterations or modifications have been attempted by other than an authorised service centre. This guarantee will not apply if the tool is damaged by accident or if repairs arise from normal wear and tear.

The Company accepts no additional liability pursuant to this guarantee for the costs of travelling or transportation of the Product or parts to and from the service dealer or centre - such costs are not included in this guarantee.

Certain legislation, including the Trade Practices Act, 1974 (as amended) and other state and territorial laws give rights to the buyer and impose liability on the seller in certain circumstances. Nothing herein shall have the effect of excluding, restricting or modifying any condition, guarantee, right or liability imposed, to the extent only that such exclusion, restriction or modification would render any term herein void.



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Contact during normal business hours.

This Guarantee Form Should Be Retained By The Customer At All Times

For your record and to assist in establishing date of purchase (necessary for in-guarantee service) please keep your purchase docket and this form completed with the following particulars.

Purchased From _____

Address Of Dealer _____

Date _____ Model No _____ Serial No _____

Present This Form With Your Purchase Docket When Guarantee Service Is Required.