

# COLD SAW

VERSION 3.1



AUTODESK  
PIER 9

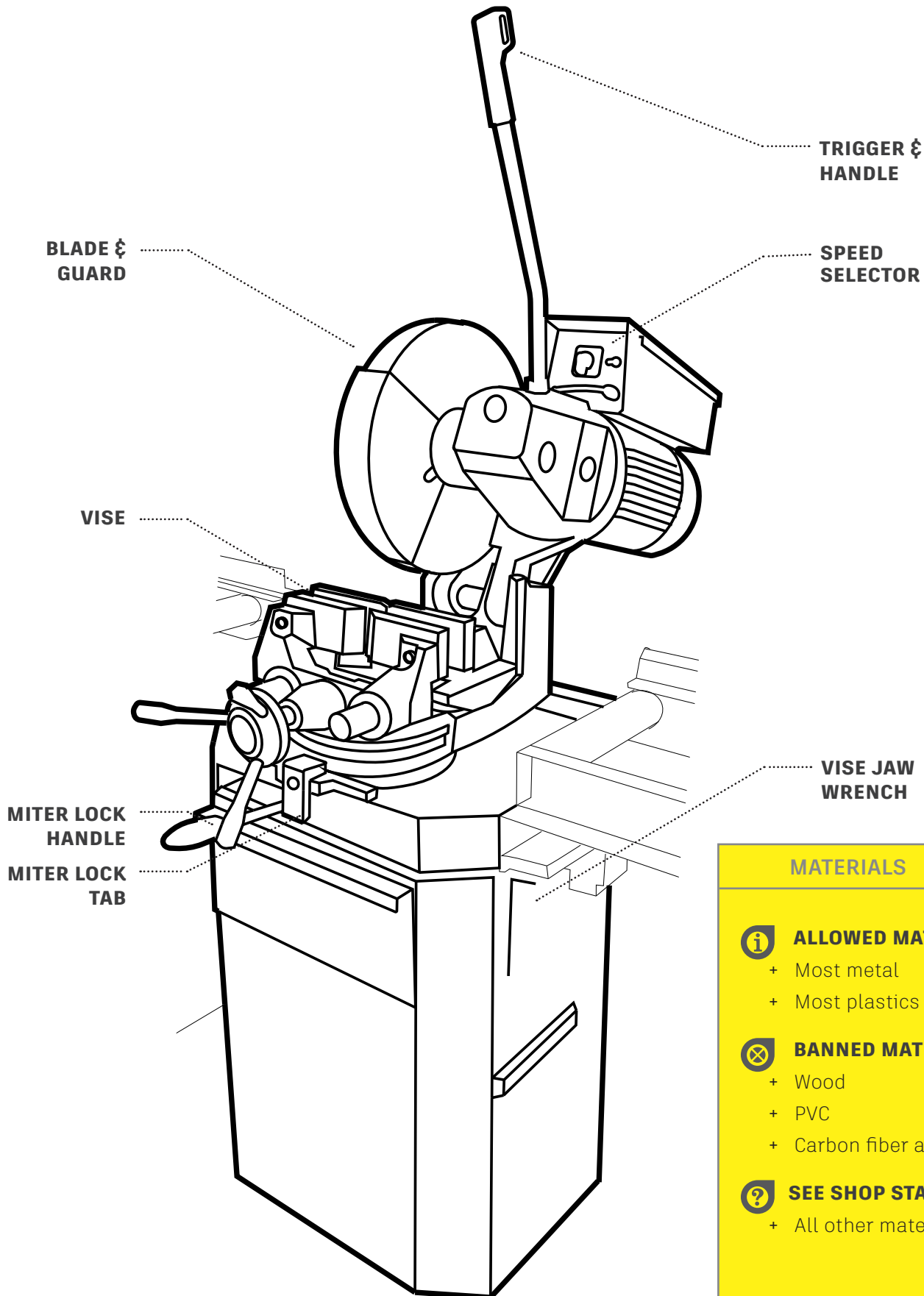
# COLD SAW

MACHINE  
CONTROLS

VERSION 3.1

THE COLD SAW MAKES ACCURATE STRAIGHT & MITERED CUTS IN METAL.

P. 2



## MATERIALS



### ALLOWED MATERIALS

- + Most metal
- + Most plastics



### BANNED MATERIALS

- + Wood
- + PVC
- + Carbon fiber and composites

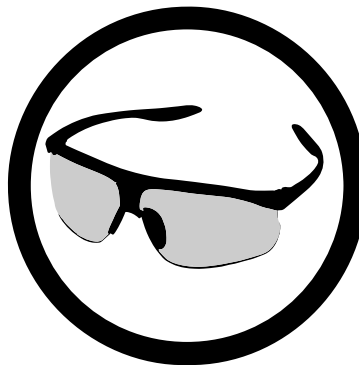


### SEE SHOP STAFF FIRST

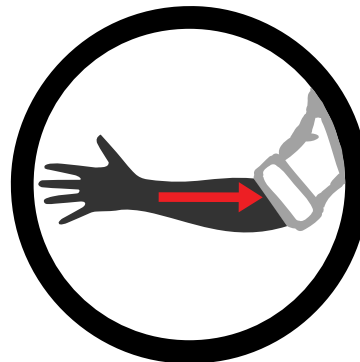
- + All other materials

USE PERSONAL PROTECTIVE EQUIPMENT WHEN OPERATING THE COLD SAW.

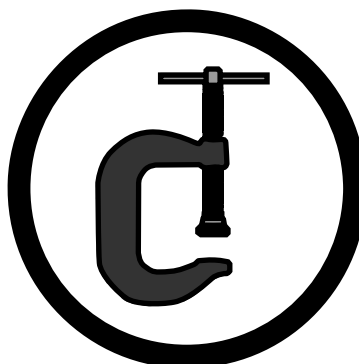
P. 3



Always wear safety glasses.



Always wear short sleeves, or rolled sleeves, pull back and tuck in long hair, remove jewelry and lanyards, etc.  
Do not wear gloves.



Using the vise is required for every cut.

USE THE VISE AND CORRECT SPEED SETTINGS WHEN OPERATING THE COLD SAW.

P. 4

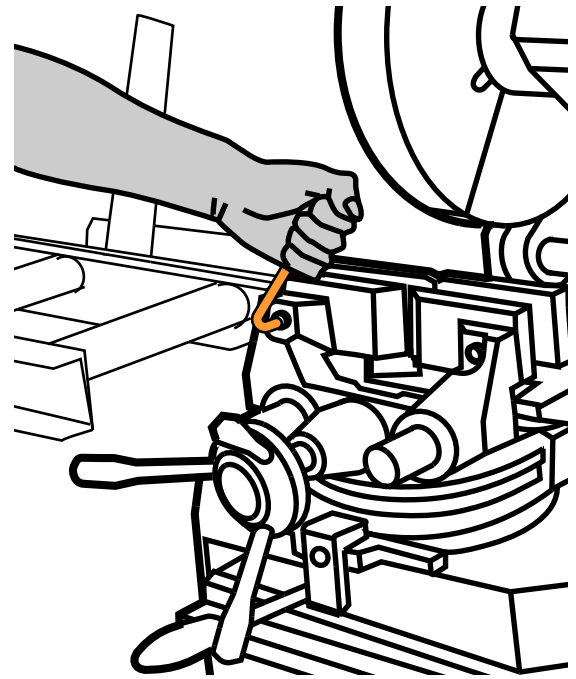
## USING THE VISE

Always use the vise; never hand hold material in the cold saw.

1. Clamp the workpiece into the vise jaws.
  - ▶ Brush out the vise before use, so your material lies flat.
  - ▶ Rotate the handle clockwise to tighten.
2. Pull down the blade, with the power off, to make sure there is no contact between the blade and vise jaws.
  - ▶ The vise jaws should be about 1/4" to 1/2" away from the blade.

If needed, the jaws can be adjusted for width.

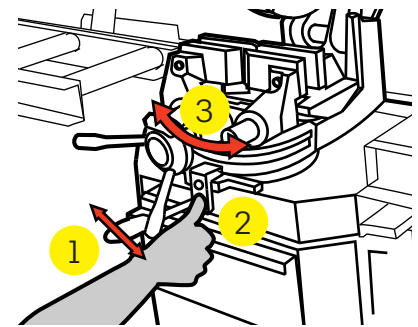
1. Use the vise jaw wrench (attached to the frame of the saw) to loosen the jaws.
2. Adjust the jaw width.
3. Check for blade clearance.
4. Tighten the jaws.



## MITER CUTS

The cold saw is capable of making miter cuts up to 45 degrees.

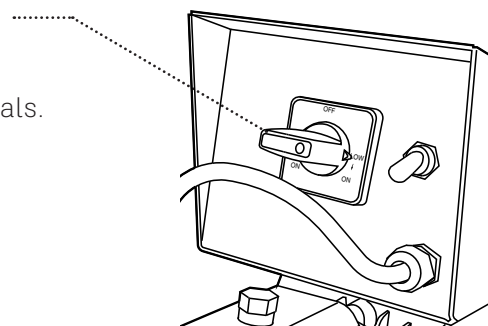
1. Move the miter lock handle to the right, to release the lock.
2. Push the miter release button.
3. Rotate the saw head to the desired angle.
  - ▶ Use the saw motor as a handle.
4. Move the miter lock handle to the left, to lock the saw.
5. Check blade and vise jaw clearance.
  - ▶ Adjust if needed.
6. When finished, return the saw to 90 degrees.



## SETTING THE BLADE SPEED

The blade has two speeds: low and high.

- + Use *low* for ferrous metals like steel.
- + Use *high* for aluminum, brass and similar metals.



# COLD SAW

HANDS ON

VERSION 3.1

OPERATING THE COLD SAW.

P. 5

## AREA AND MACHINE PREPARATION

1. Clean and clear the vise and extension tables.
2. Set the blade speed.
3. Rotate the saw for a miter cut if needed.
4. Adjust the vise jaws if needed.
  - ▶ The blade should be 1/4" to 1/2" from the jaws.
5. Tightly clamp the work in the vise.

**THE MATERIAL MUST ALWAYS BE CLAMPED IN THE VISE.**

## MAKING THE CUT

1. Pull the handle down towards the material and pull the trigger.
2. Wait for the coolant to flow.
  - ▶ Do not cut with a dry blade.
3. Gently kiss the material with the blade.
4. After the cut starts, put more pressure on the handle.
  - ▶ Be gentle. Excessive force will damage the blade, and not help cutting speed.
5. Release the trigger when the cut is complete.
6. Gently return the handle to the top.

**ALWAYS USE COOLANT WITH THE COLD SAW.**

## CLEANUP

1. Brush off the table and clean up the area.
2. Use Simple Green and shop rags on coolant spills.
  - ▶ Place the dirty rags in the red step cans for laundering.
3. Recycle scraps and put reusable pieces in the storage bin in the metal shop.

**MOP UP ANY COOLANT SPILLS; DO NOT LEAVE A WET FLOOR.**