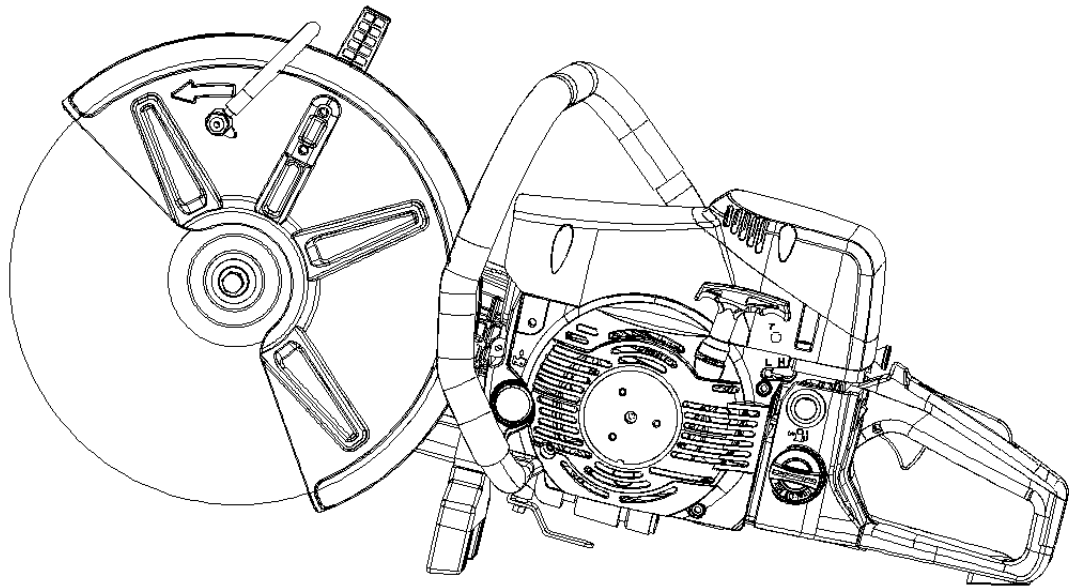


CUT OFF SAW














FOREWORD

Cutting-off machines have proven to be extremely useful and versatile. In almost any settings these powerful yet simple tools get the job done. In industrial settings, they make hard to operate areas, possible to work on. In emergency/rescue, they can even save lives. However, any tool used improperly can cause serious or even fatal injuries. Read carefully the following manual before using this product.

Since safety regulations and rules may vary between different countries and states, please contact local authorities and carefully follow their instructions pertaining to the guidelines for use of these tools.

Under no circumstances may a cutting-off machine be modified from its original design without the written permission of the manufacturer. Modifications without permission of authorities can lead to serious injury and even death to operators.

SYMBOL EXPLANATION

	<p>Read the operator's manual carefully and understand the content before using the cutting-off machine.</p>
	<p>Always wear a protective mask.</p>
	<p>Always wear protective shoes.</p>
	<p>Always wear protective gloves.</p>
	<p>Always wear: Approved protective helmet Approved ear protection Approved protective glasses</p>
	<p>WARNING! Sparks generating from the cutting blade can cause fire in combustible materials.</p>
	<p>WARNING! Cutting creates a lot of dust, which can cause inhalation damages. Use appropriate dust mask or respirator mask to avoid breathing dust and exhaust gases.</p>
	<p>WARNING! Be careful to be hit by a cutting-off machine.</p>
	<p>WARNING! Pay attention to the spectators in the work area.</p>
	<p>WARNING! Care for rotating parts.</p>
	<p>WARNING! Use the cutting-off machines in a well ventilated environment. Always make sure that the work area has enough ventilation for air to circulate properly. Otherwise, it will lead to serious injury and even death to operators. Carbon monoxide in the exhaust gas can cause suffocation.</p>

NECESSARY STEPS BEFORE USING CUTTING-OFF MACHINE

Preparatory steps:

1. Read the Operator's Instruction Book carefully.
2. Check the assembly and adjustment of the cutting blade. See chapter "Assembly".
3. Let the dealer check the cutting-off machine and make essential adjustments and repairs.

 **WARNING!**

Under no circumstances should you modify the original design of the cutting-off machine without the approval from the manufacturer. Unauthorized modifications and spare parts from other companies will lead to serious injury or death.

 **WARNING!**

Cutting material can generate dust and vapors, which may contain harmful chemicals. Know the nature of the material being cut before using the power cutter. During work, please wear appropriate dust mask or protective respirator.

 **WARNING!**

The engine exhaust from the power saw contains chemicals, which may cause cancer, birth defects or other reproductive harm.

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SAFETY PRECAUTION

WARNING!

A cutting-off machine is a very dangerous tool. If used carelessly or incorrectly, it can cause serious and even fatal injuries. It is extremely important that you read and understand this manual.

PERSONAL PROTECTIVE EQUIPMENT

WARNING!

You must wear protective equipment approved by the authorities whenever you use a power cutter. Personal protective equipment does not eliminate the risk of accidents, however, it can reduce the effects of an injury in the event of an accident. Ask your dealer for help when choosing protective equipment.

1. Protective Helmet, Ear Protection, Protective Glasses, Full Face



Protection

2. Breathing Mask



3. Heavy-duty, Firm Grip Protective Gloves



4. Snug-fitting, Heavy-duty, Comfortable Clothing and Leg Protection

That Allows Full Freedom of Movement



5. Anti-slip Boots with Steel Toe Caps



6. First Aid Kit



CUTTING-OFF MACHINES'S SAFETY EQUIPMENT

This section explains the various safety features of the power cutter, How they work, and basic inspection and maintenance that you should carry out to ensure safety operation. (See the chapter “Part List of the Power Saw”)

WARNING!

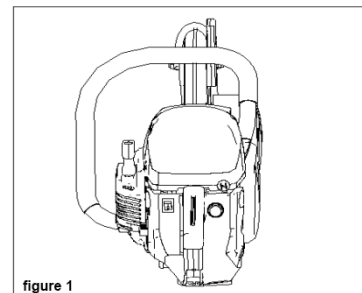
Never use a cutting-off machine with defective safety components. Follow the control, maintenance and service instruction described in this manual.

WARNING!

All service and repair work on the cutting-off machine demands special training. This is especially true for power cutter's safety equipment. If your cutting-off machine fails any of the checks described below, you should immediately take it to your service workshop before using it again. When you buy any of our products, we guarantee the availability of professional repairs and service. If the dealer is not a servicing dealer, please contact the nearest service workshop.

1. Stop switch

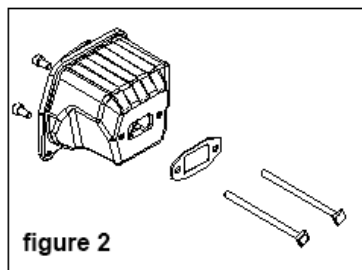
The stop switch should be used to stop the engine. Start the engine and make sure that engine stops when the stop switch is moved to its primary stopped position (See figure 1)



2. Mufflers

WARNING!

The muffler gets very hot during use and remains so for a short time thereafter. Do not touch a hot muffler. The muffler is designed to give the lowest possible noise level and to direct the exhaust fumes from engine away from the user. The engine's exhaust fumes are hot and can contain sparks, which can lead to the outbreak of fire. Never use a cutting-off machine that has a faulty muffler. Check mufflers regularly. (The connection structure of muffler see figure 2)



IMPORTANT INFORMATION!

Check, service and maintain the muffler according to the instructions. (See chapter “Maintenance”).

3. Blade guards

WARNING!

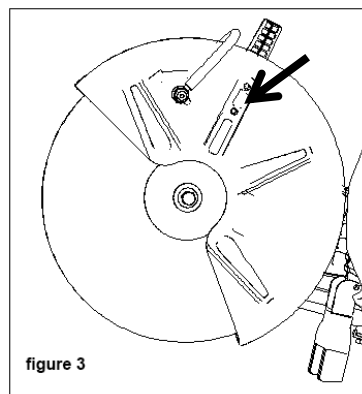
Always check the blade guard is correctly fitted before starting the machine. The blade guard is fitted above the cutting blade and is designed to prevent parts of the blade or cutting fragments from being thrown towards the user. (See figure 3)

WARNING!

Check the cutting blade is fitted correctly and does not show signs of damage before cutting every time. A damaged blade can cause personal injury during cutting, the operator must grip the saw by both hands. Never operate the saw with one hand. When the saw is put on the ground, the cutting-off machine must be stopped at once to avoid danger.

WARNING!


Never use a cutting-off machine with defective safety components. The safety equipment must be checked and maintained as described in this manual. If the cutting-off machine fails any of these checks, please contact service workshop to get it repaired.





GENERAL SAFETY INSTRUCTION

IMPORTANT INFORMATION!


The cutting-off machine is designed to cut hard materials such as concrete, masonry, steel. Observe the increased risk of kickback when cutting soft material.


 Never use the cutting-off machine when you are tired or under the influence of medicines/drug or any alcohol.

 Never use a cutting-off machine in doors. Be aware of the dangers of inhaling the engine's exhaust fumes.

 Do not lend out the cutting-off machine without including this manual. Ensure that the person who intends to use the cutting-off machine understands the information in this manual. The same person can't work for two successive hours.

TRANSPORT AND STORAGE


 Store the cutting-off machine in a lockable area so that it is out of reach of children and unauthorized persons.


 The blade must be removed when storing the cutting-off machine.


Never start the cutting-off machine under following conditions:

1. If the fuel is spilled on the power cutter, please wipe up all spillage.
2. If you have spilled fuel on your clothes, please change your clothes.

Make regular checks for leakage from the fuel cap and the fuel supply pipes.

 Always store the cutting-off machine and fuel in safety place to ensure any leakage or vapors will not come into contact with sparks and naked flames.

 When storing fuel, approved container intended for this purpose must be used.

 The fuel tank should be emptied and cleaned when storing the cutting-off for a long time. Contact your local fuel station to find out how to dispose of excess fuel.

WARNING!

Use fuel tank for the special purpose of anti-slip. Fuel and fuel fumes are highly flammable. Stop the engine before refueling. Do not overfill. Mop up any spills on the ground or the machine. If you spill the fuel on your clothes, change your clothes. Move the machine at least three meters from the refueling site before starting.

GENERAL WORKING INSTRUCTIONS


This section explains basic rules for using a power cutter. Follow these general working instructions, but do not use a cutting-off machine in a situation where you cannot call for help in case of accident.


BASIC SAFETY PRECAUTIONS


IMPORTANT INFORMATION!


Never use the cutting-off machine that is damaged or has been fit wrongly or has parts missing. Check the cutting blade stops rotating when the throttle is released. If you encounter a situation where you are uncertain how to proceed, you should ask an expert. Avoid all usage beyond your capacity.


 Ensure there is no one in the immediate vicinity when using the machine.


 Avoid usage in unfavorable weather conditions.


 Before using cutting-off machine, clean the obstacles in working area. Ensure no material can become loose and fall, causing injury when cutting. Take great care when working on sloping ground.


 Make sure clothing and parts of the body do not come into contact with the rotating blade when the engine is started.


 Maintain a safe distance from the rotating blade when the engine is running.


 The blade guard should always be fitted in place when the engine is running.

 Ensure that the working area is sufficiently illuminated to create a safe working environment.

 Do not move the cutting-off machine with the blade rotating when the engine is started. Do not leave the engine running whilst unattended.

 Unfavorable working environment may create great stress on the operator.

 Make sure that no pipes, electrical cables or highly flammable and explosive goods are routed in the area to be cut.

 Do not start cutting until the engine is at full speed. Always hold the cutting machine with both hands.

 **WARNING!**

Use the cutting-off machine in areas with good ventilation; otherwise it can cause serious injury or even death. Carbon monoxide in exhaust fumes can cause suffocation.

 **WARNING!**

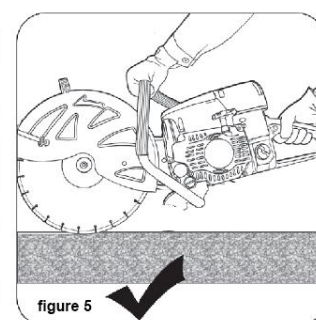
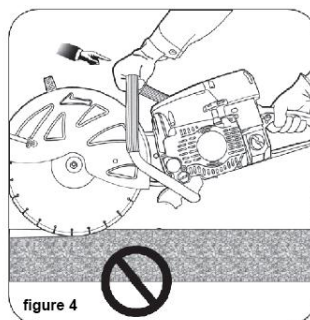
The safety distance for the cutting-off machine is fifteen meters. You are responsible that onlookers and animals are not in the working area. Do not start to work with the cutting-off machine before the working area is clear and you have a firm foothold.

 **WARNING!**

Over exposure to vibration can result in blood vessel or nerve injury. Examples of such symptoms are numbness, lack of feeling, pain lack or a reduction in normal strength, changes in the color of the skin. If you experience such physical experience, you should consult the doctor. These symptoms normally appear in the fingers, hands or wrists.

CUTTING TECHNIQUE

1. Put the cutting materials according to the illustration.
2. Always cut at full throttle.
3. Start cutting gently, do not force or squeeze the blade in (See figure 4、 5)
4. Use high speed.
5. Move the blade slowly backwards and forwards.
6. Use a small part of cutting edge of the blade.
7. Only use cutting edge when cutting.
8. Cut with the blade at the right angles.



WARNING!

Under all circumstances avoid cutting using the side of the blade. It will certainly be damaged and broken and cause immense damage. Only use the cutting section.

WARNING!

Do not pull the cutting-off machine to one side; this can cause the blade to jam or break resulting in injury to people.

WARNING!


When cutting concrete, the cutting-off machine using gas or petroleum operates with a water cooling system to help reduce dust as well as to increase its service life. However, its disadvantage is that when operating on a very low temperature there is a risk of damaging the floor and can cause slippages.

BLADE VIBRATION

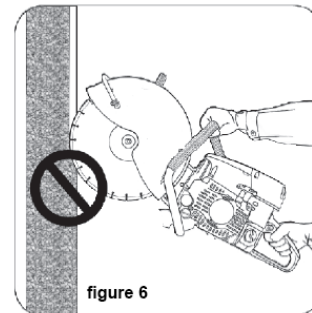
The blade can become out of shape (not round) and vibrate if too high feeding pressure is used or if the blade is pressed into the work piece.

WARNING!

Kickback can occur very suddenly and with great force. If the following directives are not followed, it can result in serious or even fatal injury.

 If the sector of the blade illustrated below is used for cutting, the blade can start to climb causing the cutting-off machine to kickback upwards and backwards. How to avoid kickback

1. Never cut with the segment illustrated in the diagram.
2. Keep good balance and a firm foothold.
3. Use both hands and take a firm grip with the thumb and fingers around the handle.
4. Stand at a reasonable distance with the work piece.
5. Run the cutting-off machine with full throttle.
6. Take care when cutting.
7. Never cut above the shoulder height.
8. Be alert to the slow movement of the power cutter, or it will cause the work piece or anything else pinch the blade.



PULL IN

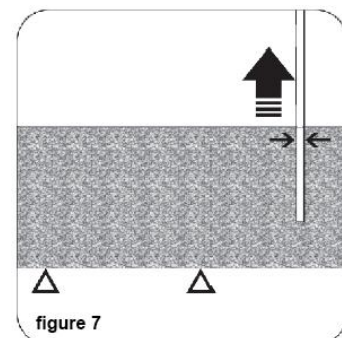
Pull in occurs when the lower part of the blade is suddenly stopped or when the cut closes. (To avoid this see the section “How to avoid kickback” and “How to avoid pinching”)

PINCHING

Pinch occurs when the cut closes. Pinching will result in clamp of blade. The cutting-off machine can be pulled down with a very powerful movement.

Avoid pinching

As shown in the figure, support the work piece in such way to avoid closing of cut (See figure 7)



CARE AND STORAGE

GENERAL

If your cutting-off machine is used at a high processing rate, all service procedures must be carried out at all the times and in the manner described, so that the machine always works efficiently and safely.

Read this manual to determine which service routines you should carry out and ensure all other service work is carried out by an authorized service workshop.

STORAGE OF CUTTING-OFF MACHINE

1. Always handle the cutting-off machine carefully and store it with the blade removed.

2. Care and storage of blades
3. All blades should be removed from the cutting-off machine after use and before storage.
4. Store blades in dry, frost free conditions.
5. Inspect new blades for transport or storage damage.

CUTTING BLADES

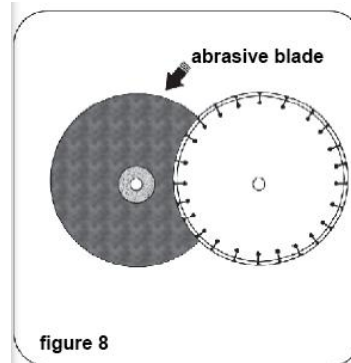
Cutting blades are available in two standard designs: abrasive discs and diamond blades.

⚠ WARNING!

A cutting blade may burst and cause injury to the operator.

⚠ WARNING!

Never use a cutting blade at lower speed rating than that of the power cutter,



SPECIAL BALDES

Some cutting blades are designed for stationary equipment and for use with attachments. Such cutting blades must not be used on portable power cutters (See figure 8)

⚠ WARNING!

Never use cutting blades for any other purpose than that they are intended for.

ABRASIVE DISC

1. The material on abrasive discs consists of grit bonded using an organic binder. Reinforced blades are made up of fabric or fiber base that prevents total breakage at maximum working speed if the blade should be cracked or damaged.
2. The type and size of abrasive corn, and the type and hardness of the bonding agent determine a cutting blade's performance.
3. Characteristics that given the blade a shorter service life and great cutting capacity are said to make the blade "softer". A blade with a longer service life and slower cutting capacity is blade with "harder" effect.
4. High quality cutting blades are normally more economical. Lower quality cutting blades usually have an inferior cutting capacity and shorter service life, which results cost per processed material.

TYPE OF CUTTING BLADES

1. Check that the blade is approved for the same or higher speed according to the approval plate of the engine. Never use a cutting blade with lower speed rating than that of the power cutter.
2. Ensure the abrasive disc is not cracked or damaged in any other way.
3. Test the abrasive disc by hitting it lightly with piece of wood. If the blade does not give a full-sounding ring then it is damaged.
4. Never use a blade that has fallen on the floor.

BLADE GUARDS

Check the blade guard to see if there are no cracks or not showing any signs of damage. Clean the inside of the guard before fitting a new blade. Check the blade guard if it can be adjusted easily

DIAMOND BLADES

Diamond blades consist of a steel body with segments that contain industrial diamond.

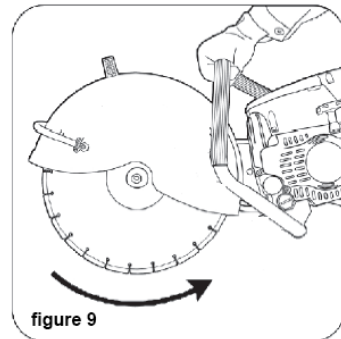


WARNING!

Cool diamond blades continuously with water to prevent overheating that can cause the blade to break and pieces being thrown off resulting in injury and damage.

USING DIAMOND BLADES

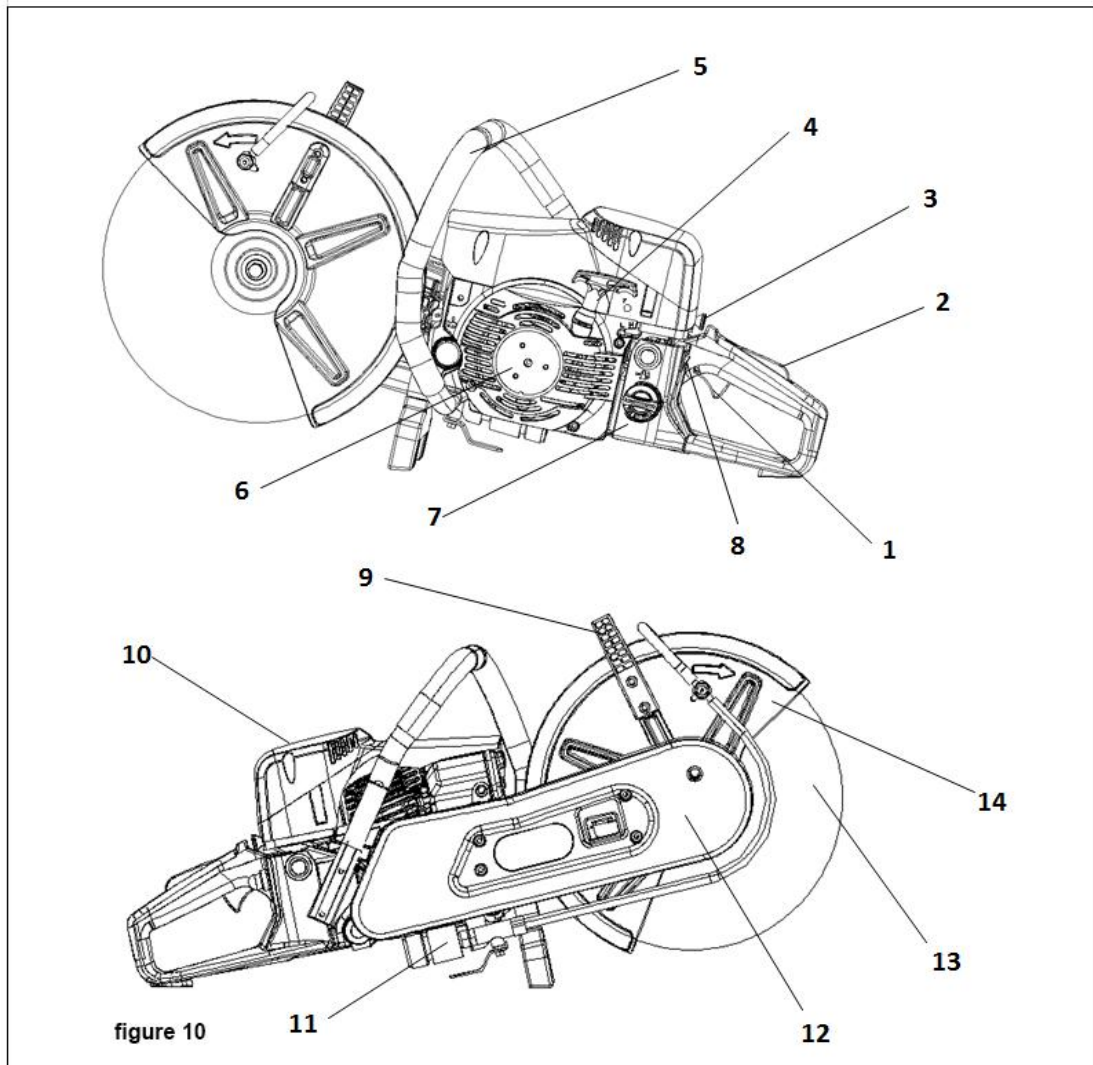
1. Let the cutting blade rotate in same direction as the arrow markings indicate.(See figure 9)
2. Cool continuously with water.
3. Keep the cutting blade sharp.
4. Remove the cutting blade when the machine is transported.
5. Avoid running the blade in wrong direction.
6. Avoid forcing a dull blade or wedging the blade into a cut.
7. Avoid letting the blade fall on the work piece heavily.



DIAMOND BLADES FOR DRY CUTTING

Diamond blades for dry cutting are a new generation of blades that do not require water-cooling. However, the blades are still damaged by excessive heat. It is good economics to let the blade cool by simply lifting the blade from the cut every 30 to 60 seconds and let it rotate in the air for 10 seconds to cool.

PART LIST OF THE CUTTING-OFF MACHINE

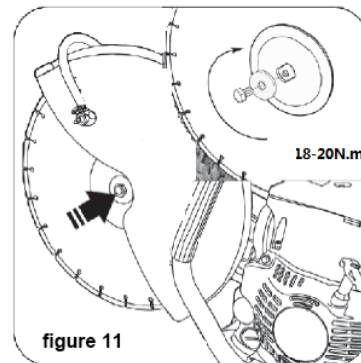


1. Throttle trigger
2. Throttle trigger lockout
3. Choke
4. Starter handle
5. Front handle
6. Starter cover
7. Fuel tank
8. Stop switch
9. Adjustment handle for blade guard
10. Air filter cover
11. Valve
12. Belt guard
13. Blade
14. Blade guard

BLADE SET-UP

CHECK THE DRIVE SHAFT AND FLANGES

1. Check if the threads on the drive shaft are undamaged.
2. Check the contact surfaces of the cutting blade and flanges are flat, running correctly on the spindle and free from foreign objects.
3. Do not use flanges that are twisted, dirty, and with damaged edges.
4. Do not use different size of flanges.



FITTING THE BLADE

The blade is placed between the right flange and the left flange. Tightening torque for the bolt holding the blade is 18-20N.m (See figure 11)

FUEL HANDLING

NOTE! The cutting-off machine is equipped with a two-stroke engine and must use a mixture of petrol and two-stroke engine oil. It is very important to accurately measure the amount of oil to be mixed to ensure that the correct mixture is obtained. When mixing fuel, even small inaccuracies can drastically affect the ratio of the mixture.



WARNING!

Always provide for good ventilation when handling fuel.

PETROL

1. Use good quality petrol.
2. The lowest octane recommended is 90. If you run the engine on a lower octane grade than 90, knocking can occur. This gives a rise to a high engine temperature, which can result in serious engine damage.

TWO-STROKE OIL

1. Use two-stroke oil. Mixing ratio is 1:40.
2. Contact the dealer when selecting oil. Follow the manufacturer's recommended mixing ratio.
3. Never use two-stroke oil intended for water cooled outboard engines, so called outboard oil.
4. Never use oil intended for four-stroke engine.

MIXING

1. Always mix the petrol and oil in a clean container intended for fuel.
2. Always start by filling half the amount of the petrol to be used. Then add the

entire amount of oil. Shake the fuel mixture. Add the remaining amount of petrol.

3. Shake the mixture thoroughly before filling the fuel tank.
4. Do not mix more than maximum one-month's supply of fuel.
5. If the cutting-off machine is not used for some time, the fuel tank should be emptied and cleaned.

FUELING

⚠ WARNING! The following precautions reduce the risk of fire

1. Do not smoke or place any sources of heat in the vicinity of the fuel.
2. Never refuel when the engine is running.
3. Open the fuel cap slowly so that any over pressure is released slowly.
4. Tightened the fuel cap carefully after refueling.

Always move the cutting-off machine from the fueling area before starting.

1. Keep the handle dry, clean and free fuel.
2. Clean around the fuel cap. Clean the fuel tank regularly. The fuel filter should be changed at least once per year. Contamination in the tank can disrupt operation. Ensure the fuel is well mixed by shake the container before filling the tank.
3. Always exercise great care when filling the fuel. Move the cutting-off machine at least three meters from the fueling area before it is started. Make sure the fuel cap is tightened.

START AND STOP

⚠ WARNING! Before starting the machine, read the following:

1. Do not use start the cutting-off machine without the cutting arm, belt fitted. Otherwise the clutch can come loose and cause personal injuries.
2. Always move the cutting-off machine from the fueling area before starting.
3. Ensure you and the machine stand firmly and the cutting blade rotates freely.
4. Make sure no unauthorized persons are within the working area.

START

⚠ WARNING!

The cutting blade can rotate when engine starts. Make sure it can rotate freely.

1. Put the cutting-off machine on the ground. Take hold the front handle by your left hand. Put your right foot on the lower part of the rear handle.
2. Pull out the choke A, Slide stop switch B to "I" position.
3. Pull starter handle C by hand until hearing combustion sound of "pop".
4. Trigger the throttle trigger D while pressing the

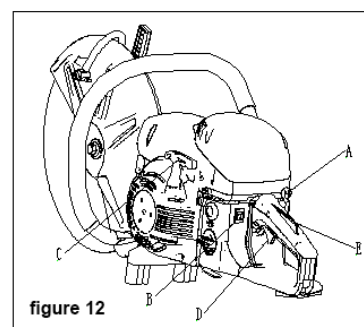


figure 12

trigger control arm E, let choke lever return to its original position.

5. Pull the starter handle again until the cutting-off machine starts.

Note! Do not pull out the starter cord completely and do not release the starter from the fully extended position. This can damage the power cutter.

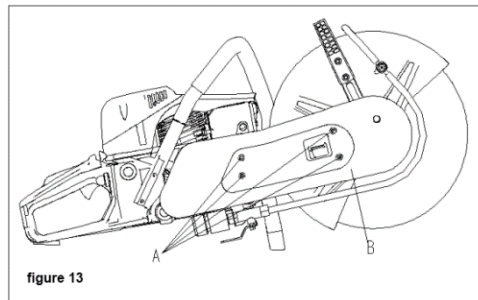
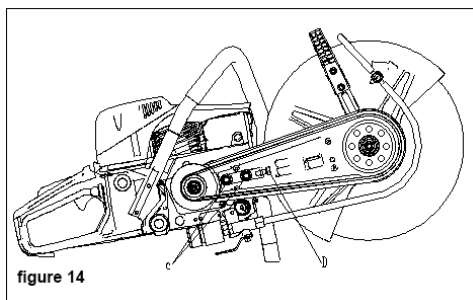
STOP

The engine is stopped by sliding stop switch B to "0" position (See figure 12)

ADJUSTING THE DRIVE BELT

TIGHTEN THE DRIVE BELT

1. Remove four screws A, remove the right belt B, loosen two screws C, adjust the pulley with spanner to tighten the screw D and the belt. (See figure 13、figure 14)
2. Tighten two screws C and fit the right belt guard B. Tighten four screws A.



IMPORTANT INFORMATION!

A drive belt should be tensioned after using one or two tanks of fuel.

CHANGING THE DRIVE BELT

1. Remove the right belt guard A, loosen two screws and adjust the pulley with spanner to tighten the screw, release the belt.
2. To assemble reserve the procedures for dismantling.
3. Check the blade guard for signs of cracking or other damage. Replace it if damaged.

WARNING!

Never use the cutting-off machine without blade guard fitted.

BELT PULLEY AND CLUTCH

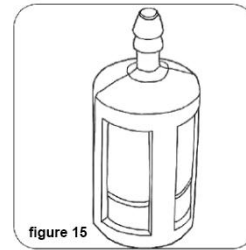
Never start the engine when the belt pulley and clutch are removed for maintenance.

WARNING!

Do not start the cutting-off machine without the cutting arm, belt or cutting head fitted. Otherwise the clutch will come loose and cause personal injuries.

FUEL FILTER

1. The fuel filter sits inside the fuel tank.
2. The fuel filter must be protected from contamination when filling. This reduces the risk of operation disturbances caused by blockage of the fuel filter.
3. The filter cannot be cleaned but must be replaced when it is blocked. The filter should be changed at least once per year. (See figure 15)

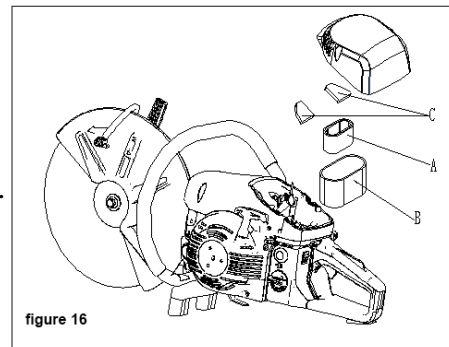


AIR FILTER

The air filter must be cleaned regularly. Remove dust and dirt to avoid:

1. Carburetor malfunction
2. Starting problems
3. Reducing engine power
4. Unnecessary wear to engine parts

The air filter includes: an air filter element (A), an air filter sponge (B), two intake sponge (C). (See figure 16)



1. The air filter element is paper filter element. To obtain a good filtering effect, the filter must be inspected regularly or cleaned.
2. Open air filter cover, remove the air filter element, blow clean with compressed air. NOTE! Paper filter element cannot be washed, and do not with a high pressure, or the air filter element will be damaged.
3. Open air filter cover, remove the air filter sponge and the intake sponge. Wash carefully in soapy water. After rinse thoroughly in clean water. NOTE! Do not compress it at a high pressure, or the filter sponge will be damaged.
4. The air filter sponge and the intake sponge that have been washed many times wears. Replace a new one if it is not elastic and seals well against the filter cover.
5. A filter used for a long period of time can never be completely cleaned. Therefore all air filters must be replaced periodically with a new one.

STARTER

WARNING!

1. The starter pulley spring is installed inside the starter housing and can with careless handling fly out and cause personal injury.
2. Always wear protective gloves when replacing the starter pulley spring or the starter cord.

REPLACING STARTER CORD

1. Pull up the starter cord wheel and place the starter cord in a relaxed position.
2. Open the starter adapter.
3. Replace the starter pulley spring. Lubricate the starter pulley spring with thin oil. Assembly the starter adapter.
4. Wind the starting cord wheel to its original state.

FITTING THE STARTER

1. Place the starter in position on the crankcase and slightly press the starter with one hand. The other hand pulls out the starter handle and releases the cord immediately so that the pawls grip in the pulley.
2. Tightened the screws that hold the starter.

MUFFLERS

The muffler is designed in order to reduce the noise level and to direct the exhaust gases away from the operator. The exhaust gases are hot and can contain sparks, which may cause fire if directed against dry and combustible material.

SPARK PLUG

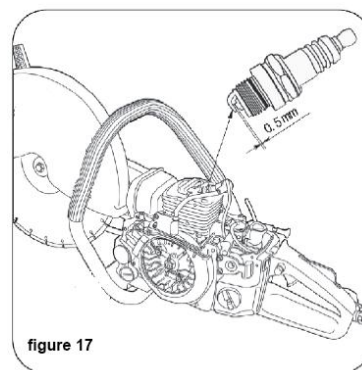
The condition of the spark plug is affected by:

1. An incorrect carburetor setting
2. An incorrect fuel mixture (too much oil)
3. A dirty air filter

These factors cause deposits on the spark plug electrode that may result in malfunction or starting difficulties.

If the machine is low on power, difficult to start or runs poorly while idling, check the spark plug first. If the spark plug is dirty, clean it and at the same time check the electrode gap is 0.5mm. The spark plug should be replaced after about one month of operation or shorter if necessary.

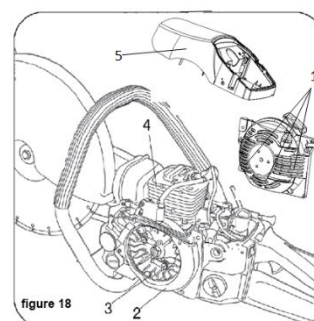
(See figure 17)



COOLING SYSTEM

The cooling system consists of:

1. An air intake (the hole is on the starter cover)
2. Air flow guide (baffle)
3. Cooling fins on the flywheel
4. Cooling fins on the cylinder



5. Cylinder cover (leads cold air onto the cylinder)

(See figure 18)

Clean the cooling system using a brush at least once a week. If necessary, clean it more often.

A dirty or blocked cooling system results in the cutting-off machine overheating, which causes damage to the piston and cylinder.

Below are some of the following general maintenance instructions. If you need further information, please contact your service workshop.

MAINTENANCE

DAILY MAINTENANCE

1. Check the throttle components work correctly from a safety viewpoint.
2. Clean the outside of the power cutter.
3. Check the tension of the drive belt.
4. Check the condition of the cutting blade.
5. Check the starter and starter cord; clean the outside of the air intake of the starter.
6. Check all the nuts and bolts are tightened correctly.
7. Check whether the choke button is normal.
8. Check the air filter sponge 、 the intake sponge.

WEEKLY MAINTENANCE

9. Check the air filter element.
10. Check the handles and the anti-vibration elements are not damaged.
11. Clean the spark plug. Check the electrode gap.
12. Clean the cooling fins on the cylinder and fly wheel.
13. Check the muffler.

MONTHLY MAINTENANCE

14. Check the clutch, drive-pulley do not wear.
15. Clean the outside of the carburetor.
16. Check the fuel filter, fuel hose. Change them if necessary.
17. Clean the inside of the fuel tank.
18. Check all the cables and connections. (See figure 19)

