

Item	Part No	Description	Item	Part No	Description
1	SA25T/01	HOUSING	19	SA25T/19	ROTOR BLADE
2	SA25T/02	VALVE BUSHING	20	SA25T/20	CYLINDER
3	SA25T/03	TRIGGER ASSEMBLY	21	SA25T/21	WASHER
4	SA25T/04	PIN	23	SA25T/23	FRONT PLATE
5	SA25T/05	O-RING	24	SA25T/24	PIN
6	SA25T/06	O-RING	25	SA25T/25	BEARING
7	SA25T/07	VALVE STEM	26	SA25T/26	COLLET HOLDER
8	SA25T/08	SPRING	27	SA25T/27	RETAINER
9	SA25T/09	AIR REGULATOR	28	SA25T/28	METAL DISC GUARD
10	SA25T/10	O-RING	29	SA25T/29	NUT
11	SA25T/11	O-RING	30	PTC/3C	CUTTING WHEEL( NOT INCLUDED )
12	SA25T/12	VALVE PLUG	31	SA25T/31	WASHER
13	SA25T/13	MUFFLE COVER	32	SA25T/32	BOLT
14	SA25T/14	AIR INLET	33	SA25T/33	WASHER
15	SA25T/15	BEARING	34	SA25T/34	WRENCH
16	SA25T/16	END PLATE	35	SA25T/35	HEX WRENCH ( NOT SHOWN )
17	SA25T/17	BALL			
18	SA25T/18	ROTOR			

**NOTE:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice. **IMPORTANT:** No liability is accepted for incorrect use of this equipment. **WARRANTY:** Guarantee is 12 months from purchase date, proof of which will be required for any claim. **INFORMATION:** Call us for a copy of our latest catalogue and promotions on 01284 757525 and leave your full name and address including your postcode.

Thank you for purchasing a Sealey Product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.



**IMPORTANT:** PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS AND CAUTIONS. USE THIS PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.

**1. SAFETY INSTRUCTIONS**

- ✓ Follow all workshop health & safety rules, regulations, and conditions when using tool.
- ❑ **WARNING!** Disconnect from air supply before changing cutting disc or servicing.
- ✓ Maintain tool in good condition and replace any damaged or worn parts. Use genuine parts only. Non-authorized parts may be dangerous and will invalidate the warranty.
- ❑ **WARNING!** Check correct air pressure is maintained and not exceeded. We recommended 90psi.
- ✓ Keep air hose away from heat, oil and sharp edges. Check air hose for wear before each use and ensure that all connections are secure.
- ❑ **WARNING!** Before each use check cutting disc is secure, and the disc is not worn or damaged, if damaged replace immediately.
- ✓ Ensure replacement discs are not damaged in any way such as cracks, deformations or splinters etc. Also check the mounting washer to ensure it is not deformed, burred or notched. Damaged washer must not be used as it may cause irregular pressure on the disc which may cause the disc to break. DO NOT over tighten a disc and never tamper with a disc in order to adapt it to a different size holder.
- ✓ Always use the correct disc suitable for the material being cut. Ensure the maximum speed specification of the cutting disc is higher than that indicated on the machine data plate.
- ❑ **WARNING!** Keep disc guard in place, tight and in good working order. The safety guard is a mandatory fitting where tool is used in premises covered by the Health & Safety at Work Act.
- ❑ **WARNING!** Always wear approved eye and face protection when operating the tool.
- ✓ Use breathing protection in accordance with COSHH regulations if fumes or dust pose a hazard.
- ✓ Wear ear defenders and gloves if necessary.
- ✓ Keep hands and body clear of the workpiece when operating the tool.
- ✓ Maintain correct balance and footing. Ensure the floor is not slippery and wear non-slip shoes.
- ✓ Secure non stable work piece with a clamp, vice or other adequate holding device.
- ✓ Keep children and non essential persons away from the working area.
- ✓ Avoid subjecting disc to excessive strain, always ease disc down against workpiece (a harsh impact may break the disc). Do not over press in order to cut workpiece. Maintain a controlled adequate progression, which will emit a minimum of sparks.
- ✗ DO NOT get the tool wet or use in damp or wet locations.
- ✗ DO NOT hold the workpiece by hand. Use clamps or a vice to secure the workpiece.
- ✗ DO NOT use the tool for a task it is not designed to perform.
- ❑ **WARNING!** DO NOT use tool if damaged or faulty. Contact your local service agent.
- ✗ DO NOT use tool unless you have been instructed in its use by a qualified person.
- ✗ DO NOT position your body in line with the disc whilst cutting, and DO NOT remove the safety guard whilst in use.
- ✗ DO NOT carry the tool by the air hose, or yank the hose from the air supply.
- ✗ DO NOT direct air from the air hose at yourself or others.
- ❑ **WARNING!** DO NOT cut any materials containing asbestos.

- x DO NOT switch the tool on whilst the disc is in contact with the work piece.
- x DO NOT allow workpiece to over heat. Periodically cool by immersing the work piece in water.
- x DO NOT use tool where there are flammable liquids, solids or gases such as paint solvents, including waste wiping or cleaning rags etc as any sparks generated may be dangerous.
- x DO NOT touch the workpiece close to the surface which has been ground as it will be very hot. Allow to cool. The workpiece may also be very sharp.
- x DO NOT operate tool if you are tired, under the influence of alcohol, drugs or intoxicating medication.
- ✓ When not in use disconnect from air supply and store in a safe, dry, childproof location.

## 2. INTRODUCTION & SPECIFICATIONS

Versatile tool, with lightweight aluminium alloy housing, suitable for cutting car panel thickness material. Ideal also for cutting exhaust brackets. Fitted with metal safety guard and throttle safety device to prevent accidental operation. Quality air motor bearings for smooth and powerful operation. Integral sintered brass baffle with rear exhaust gives quiet operation.

Disc size . . . . .	.75x2x10mm	Operating pressure . . . . .	.90psi
Free speed . . . . .	22,000rpm	Air inlet size . . . . .	1/4" BSP
Air consumption . . . . .	4cfm	Weight . . . . .	0.8kg

Cutting wheel part no: PTC/3C

## 3. PREPARING TOOL FOR USE

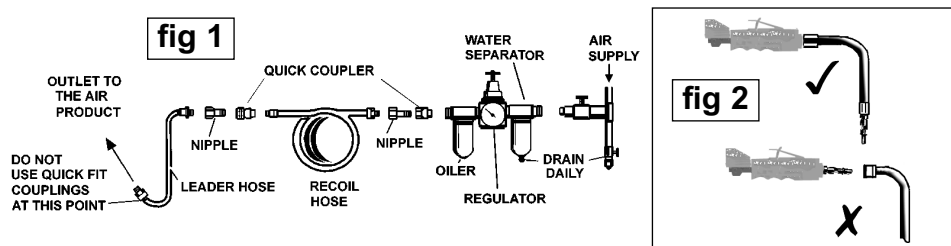
**3.0 NOTE.** This machine is capable of operating at speeds up to 22,000 rpm without a disc fitted and around 21,000rpm with a disc fitted. We recommend that the air inlet pressure of this machine be regulated to 90psi and be fitted with 1/4" bore hose and couplings. This will limit the machine's free speed to 20,000rpm

**3.1. AIR SUPPLY** ( Recommended hook-up procedure is shown in fig 1.)

- 3.1.1. Ensure tool air valve (or trigger) is in "off" position before connecting to the air supply.
- 3.1.2. You will require an air pressure of 90psi, and an air flow according to specification.
- 3.1.3.  **WARNING!** Ensure the air supply is clean and does not exceed 90 psi while operating the tool. Too high an air pressure and unclean air will shorten the product life due to excessive wear, and may be dangerous causing damage and/or personal injury.
- 3.1.4. Drain the air tank daily. Water in the air line will damage the tool.
- 3.1.5. Clean air inlet filter weekly.
- 3.1.6. Line pressure should be increased to compensate for unusually long air hoses (over 8 metres). The minimum hose diameter should be 1/4" I.D. and fittings must have the same inside dimensions.
- 3.1.7. Keep hose away from heat, oil and sharp edges. Check hose for wear, and make certain that all connections are secure.

**3.2. COUPLINGS**

Vibration may cause failure if a quick change coupling is connected directly to the tool. To overcome this, connect a leader hose to the tool. A quick change coupling may then be used to connect the leader hose to the air line recoil hose. See fig 1 & 2.



## 4. OPERATING INSTRUCTIONS

**4.1 FITTING CUTTING DISC**

- WARNING!** Disconnect from the air supply before changing disc.
- 4.1.1. Use hex key to remove hex screw (item 32 on the parts list) and washer (31).
- 4.1.2. Place the cutting disc onto the spindle.
- 4.1.3. Replace the washer and secure with hex screw, but do not over tighten. Check that replacement disc is not damaged, (cracks, deformations or splinters etc). Also check the mounting washer to ensure it is not deformed, burred or notched . A damaged washer must not be used as it may cause irregular pressure on the disc which may cause it to break. DO NOT tamper with a disc in order to adapt it to a different size holder.

**4.2. OPERATING**

- WARNING!** Ensure you have read, understood and apply safety instructions.
- 4.2.1. Connect the tool to the air supply.
- 4.2.2. To start the tool, hold firmly and push the trigger locking lever forward whilst depressing trigger.
- 4.2.3. The disc must be running at its maximum speed before attempting to cut the workpiece.
- 4.2.4. Slowly and smoothly bring the cutting disc toward the workpiece (avoid jerky movements).
- 4.2.5. Exert adequate pressure on the tool to allow cutting according to the type and size of the material you are working with. Avoid subjecting disc to excessive strain, always hold tool firmly and ease disc against workpiece (a harsh impact may break the disc). Maintain a controlled adequate progression.

DO NOT allow tool to free run for an extended period of time as this will shorten its life.

## 5. MAINTENANCE

- WARNING!** Disconnect tool from air supply before changing accessories, servicing or performing maintenance. Replace or repair damaged parts. *Use genuine parts only. Non-authorized parts may be dangerous and will invalidate the warranty.*
- 5.1. Lubricate the air tool daily with a few drops of Sealey air tool oil dripped into the air inlet to prolong its life.
- 5.2. Clean the tool after use.
- 5.3. Loss of power or erratic action may be due to the following:
  - a) Excessive drain on the air line. Moisture or restriction in the air pipe. Incorrect size or type of hose connectors. To remedy check the air supply and follow instructions in chapter 3.
  - b) Grit or gum deposits in the tool may also reduce performance. If your model has an air strainer (located in the area of the air inlet), remove the strainer and clean it. Flush the tool out with gum solvent oil or an equal mixture of SAE No 10 oil and paraffin. Allow to dry before use.
- 5.4. For a full service contact your local Sealey service agent.
- 5.5. When not in use, disconnect from air supply, clean tool and store in a safe, dry, childproof location.

**Declaration of Conformity** We, the sole importer into the UK, declare that the product listed here is in conformity with the following EEC standards and directives. The construction file for this product is held by the Manufacturer and may be inspected, by a national authority, upon request to Jack Sealey Ltd

**Air Cut-off Tool Model: SA25T**  
98/37/EC Machinery Directive  
93/68/EEC Marking Directive



Signed by Mark Sweetman

25th June 2001

For Jack Sealey Ltd. Sole importer into the UK of Sealey Power Tools.