



Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local amenity tip and place into the appropriate recycling bin.



Never dispose of electrical equipment or batteries in with your domestic waste. If your supplier offers a disposal facility please use it or alternatively use a recognised re-cycling agent. This will allow the recycling of raw materials and help protect the environment.

**Sip**  
SIP INDUSTRIAL

**machinery specialists since 1968**

## 10" Industrial Circular Saw



**01554**

**FOR HELP OR ADVISE ON THIS PRODUCT PLEASE CONTACT YOUR DISTRIBUTOR,  
OR SIP DIRECTLY ON:  
TEL: 01509500400  
EMAIL: [sales@sip-group.com](mailto:sales@sip-group.com) or [technical@sip-group.com](mailto:technical@sip-group.com)  
[www.sip-group.com](http://www.sip-group.com)**

**Please read and fully understand the instructions in this manual before operation. Keep this manual safe for future reference.**

# DECLARATION OF CONFORMITY

## Declaration of Conformity

We

SIP (Industrial Products) Ltd  
Gelders Hall Road  
Shepshed  
Loughborough  
Leicestershire  
LE12 9NH  
England

As the manufacturer's authorised representative within the EC  
declare that the

10" Industrial Circular Saw - SIP Part. No. 01554

**Conforms to the requirements of the following directive(s), as indicated.**

2006/95/EC	Low Voltage Directive
2006/42/EC	Machinery Directive
2004/108/EC	EMC Directive
2002/95/EC	RoHS Directive

**And the relevant harmonised standard(s), including**

EN 55014-1:2006+A1+A2  
EN 55014-2:1997+A1+A2  
EN 61000-3-2:2006+A1+A2  
EN 61000-3-3:2008

Signed:  .....

Mr P. Ippaso - Managing Director - SIP (Industrial Products) Ltd  
Date: 30/08/2013.



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## SAFETY SYMBOLS USED THROUGHOUT THIS MANUAL



**Danger / Caution:** Indicates risk of personal injury and/or the possibility of damage.



**Warning:** Risk of electrical injury or damage!



**Note:** Supplementary information.

## SAFETY INSTRUCTIONS



**IMPORTANT:** Please read the following instructions carefully, **failure to do so could lead to serious personal injury and / or damage to the circular saw.**

When using the circular saw, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury.

Read all these instructions before operating the circular saw and save this user manual for future reference.

The circular saw should **not** be modified or used for any application other than that for which it was designed.

It was designed for metal cutting work in engineering workshops, garages, metal fabricators, etc.

If you are unsure of its relative applications do not hesitate to contact us and we will be more than happy to advise you.

**KNOW YOUR CIRCULAR SAW:** Read and understand the owner's manual and labels affixed to the circular saw. Learn its applications and limitations, as well as the potential hazards specific to it.

**KEEP WORK AREA CLEAN AND WELL LIT:** Cluttered work benches and dark areas invite accidents. Floors must not be slippery due to oil, water or sawdust etc.

**DO NOT USE THE CIRCULAR SAW IN DANGEROUS ENVIRONMENTS:** Do not use the circular saw in damp or wet locations, or expose it to rain. Provide adequate space surrounding the work area. Do not use in environments with a potentially explosive atmos-

## PARTS LIST...cont

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
79.	Washer M5	WK03-00076	92.	18mf Capacitor	WK03-00086
80.	Coolant tray	WK03-00077	93.	50mf Capacitor	WK03-00087
81.	Base	WK03-00078	94.	Terminal strip	WK03-00088
82.	Sleeve	WK03-00079	95.	QF1,2 & 3 Breaker	WK04-00149
83.	Hex screw M8x35	WK03-00080	96.	Transformer	WK04-00153
84.	Bench lever	WK03-00081	97.	Emergency stop button	WK03-00089
85.	Bolt M8x30	WK03-00082	N/A	Electrical box	WK03-00097
86.	Washer M8	WK03-00056	N/A	Electrical box cover	WK03-00098
87.	Fixing bracket	WK03-00083	N/A	Electrical box gasket	WK03-00099
88.	Switch	WK03-00084	N/A	Oil sight glass	WK03-00093
89.	Relay	WK04-00151	N/A	Coolant pump housing	WK03-00094
90.	Contactora	WK04-00150	N/A	Inline filter	WK03-00095
91.	Mains filter	WK03-00085	N/A	Machine base filter	WK03-00096

## PARTS LIST....cont

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
21.	Crown wheel	WK03-00021	50.	Lock sleeve	WK03-00049
22.	Hex screw M4x16	WK03-00022	51.	Lock screw M8x10	WK03-00050
23.	Washer M4	WK03-00023	52.	Quick vice lever	WK03-00051
24.	Coolant pump	WK03-00024	53.	Thrust bearing	WK03-00052
25.	Spring ring	WK03-00025	54.	Sleeve	WK03-00053
26.	Bearing	WK03-00026	55.	Handle for vice	WK03-00054
27.	Motor	WK03-00027	56.	Handle boss	WK03-00055
28.	Lock screw M8	WK03-00028	57.	Washer M8	WK03-00056
29.	Stud bolt	WK03-00029	58.	Hex screw M8x30	WK03-00057
30.	Gasket	WK03-00030	59.	Lower vice	WK03-00058
31.	Worm gear	WK03-00031	60.	Hex screw M6x25	WK03-00012
32.	Bolt M16	WK03-00032	61.	Cut off stop rod	WK03-00059
33.	Bearing	WK03-00033	62.	Cut off stop	WK03-00060
34.	Gear box	WK03-00034	63.	Bolt M6	WK03-00061
35.	Handle lever	WK03-00035	64.	Bolt M8x16	WK03-00062
36.	Bolt M5x10	WK03-00036	65.	Eccentric sleeve	WK03-00063
37.	Handle switch	WK03-00037	66.	Eccentric shaft	WK03-00064
38.	Hex screw M12x25	WK03-00038	67.	Lock screw M6x12	WK03-00065
39.	Washer M12	WK03-00039	68.	Bolt M10	WK03-00066
40.	Vice jaw	WK03-00040	69.	Bolt M10x55	WK03-00067
41.	Bolt M20x1.5	WK03-00041	70.	Spring	WK03-00068
42.	Vice bracket	WK03-00042	71.	Washer M12	WK03-00039
43.	Upper vice	WK03-00043	72.	Bolt M10x35	WK03-00069
44.	Lock screw M8x20	WK03-00044	73.	Washer M10	WK03-00070
45.	Lock screw M8	WK03-00028	74.	Bolt M10x30	WK03-00071
46.	Vice screw	WK03-00045	75.	Swivel base	WK03-00072
47.	Spring	WK03-00046	76.	Spring pin	WK03-00073
48.	Bushing	WK03-00047	77.	Screw	WK03-00074
49.	Oil cup	WK03-00048	78.	Hex screw M5x10	WK03-00075

## SAFETY INSTRUCTIONS....cont

phere.

**KEEP CHILDREN AND UNTRAINED PERSONNEL AWAY FROM THE WORK AREA:** All visitors should be kept at a safe distance from the work area.

**STORE THE CIRCULAR SAW SAFELY WHEN NOT IN USE:** The circular saw should be stored in a dry location and disconnected from the mains supply, and out of the reach of children.

**WEAR THE CORRECT CLOTHING:** Do not wear loose clothing, neckties, rings, bracelets, or other jewellery, which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Roll long sleeves up above the elbow.

**USE SAFETY CLOTHING / EQUIPMENT:** Wear CE approved safety goggles at all times, normal spectacles only have impact resistant lenses, they are **NOT** safety glasses. A face or dust mask should be worn if the operation is dusty and ear protectors (plugs or muffs) should be worn, particularly during extended periods of operation.

**PROTECT YOURSELF FROM ELECTRIC SHOCK:** When working with the circular saw, avoid contact with any earthed items (e.g. pipes, radiators, hobs and refrigerators, etc.). It is advisable wherever possible to use an RCD (residual current device) at the mains socket.

**STAY ALERT:** Always watch what you are doing and use common sense. Do not operate the circular saw when you are tired or under the influence of alcohol or drugs.

**DISCONNECT THE CIRCULAR SAW FROM THE MAINS SUPPLY:** When not in use, before servicing and when changing accessories such as circular saw blade, etc.

**AVOID UNINTENTIONAL STARTING:** Make sure the switch is in the **OFF** position before connecting the circular saw to the mains supply.

**NEVER LEAVE THE CIRCULAR SAW RUNNING / CONNECTED WHILST UNATTENDED:** Turn the circular saw off and disconnect it from the mains supply between jobs. Do not leave the circular saw until it comes to a complete stop.

**DO NOT ABUSE THE MAINS LEAD:** Never attempt to move the circular saw by the mains lead or pull it to remove the plug from the mains socket. Keep the mains lead away from heat, oil and sharp edges. If the mains lead is damaged, it must be replaced by the manufacturer or its service agent or a similarly qualified person in order to avoid unwanted hazards.

**CHECK FOR DAMAGED PARTS:** Before every use of the circular saw, a guard or other part that is damaged should be carefully checked to determine that it will operate correctly and perform its intended function. Check for alignment of moving parts, free running of moving parts, breakage of parts, and any other conditions that may affect its operation. A guard or other part that is damaged should be correctly repaired or replaced by an authorised service centre unless otherwise indicated in this instruction manual. Have defective switches replaced by an authorized service agent. Do not use the circular saw if the switch does not turn the saw on and off.

**KEEP ALL GUARDS IN PLACE:** And in full working order.

**MAINTAIN THE CIRCULAR SAW WITH CARE:** Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.

## SAFETY INSTRUCTIONS....cont

All extension cables must be checked at regular intervals and replaced if damaged. Always keep the vice hand-wheel grip/s on the circular saw clean, dry and free of oil and grease.

**USE ONLY RECOMMENDED ACCESSORIES:** Consult this user manual, your distributor or SIP directly for recommended accessories. Follow the instructions that accompany the accessories. The use of improper accessories may cause hazards and will invalidate any warranty you may have.

**REMOVE ADJUSTING KEYS AND WRENCHES:** Form a habit of checking to see that keys and adjusting wrenches are removed from the circular saw before every use.

**SECURE THE WORK-PIECE:** Always use the vice to hold the work-piece. This frees up both hands to operate the circular saw.

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

**USE THE RIGHT TOOL:** Do not use the circular saw to do a job for which it was not designed.

**DO NOT FORCE THE CIRCULAR SAW:** It will do the job better and more safely at the rate which it was designed.

**DO NOT OPERATE THE CIRCULAR SAW IN EXPLOSIVE ATMOSPHERES:** Do not use the circular saw in the presence of flammable liquids, gases, dust or other combustible sources. Circular sawing operations may create sparks which can ignite the dust or fumes.

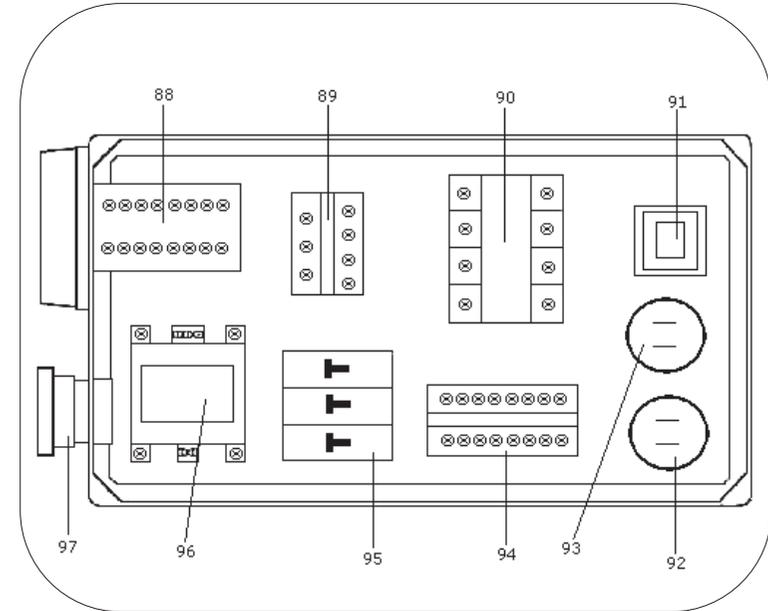
**DO NOT EXPOSE THE CIRCULAR SAW TO RAIN OR USE IT IN WET CONDITIONS:** Water entering the circular saw will greatly increase the risk of electric shock.

**HAVE YOUR CIRCULAR SAW REPAIRED BY A QUALIFIED PERSON:** The tool is in accordance with the relevant safety requirements. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user.

**DO NOT** dismantle, tamper with or use the circular saw without all guards fitted as this may be dangerous and will invalidate the warranty.

- Keep hands out of the path of the circular saw blade, never reach around the circular saw blade.
- Make sure the circular saw blade is clear of the work-piece before the handle trigger is pressed in.
- Stop operation immediately if you notice anything abnormal.
- Wait for the circular saw blade to stop completely and remove the plug from mains supply before servicing or adjusting the circular saw or changing the blade.
- Be alert at all times, especially during repetitive, monotonous operations. Don't be lulled into a false sense of security. Circular saw blades can be extremely unforgiving.
- Use of improper accessories may cause damage to the circular saw and surrounding area as well as increasing the risk of injury.

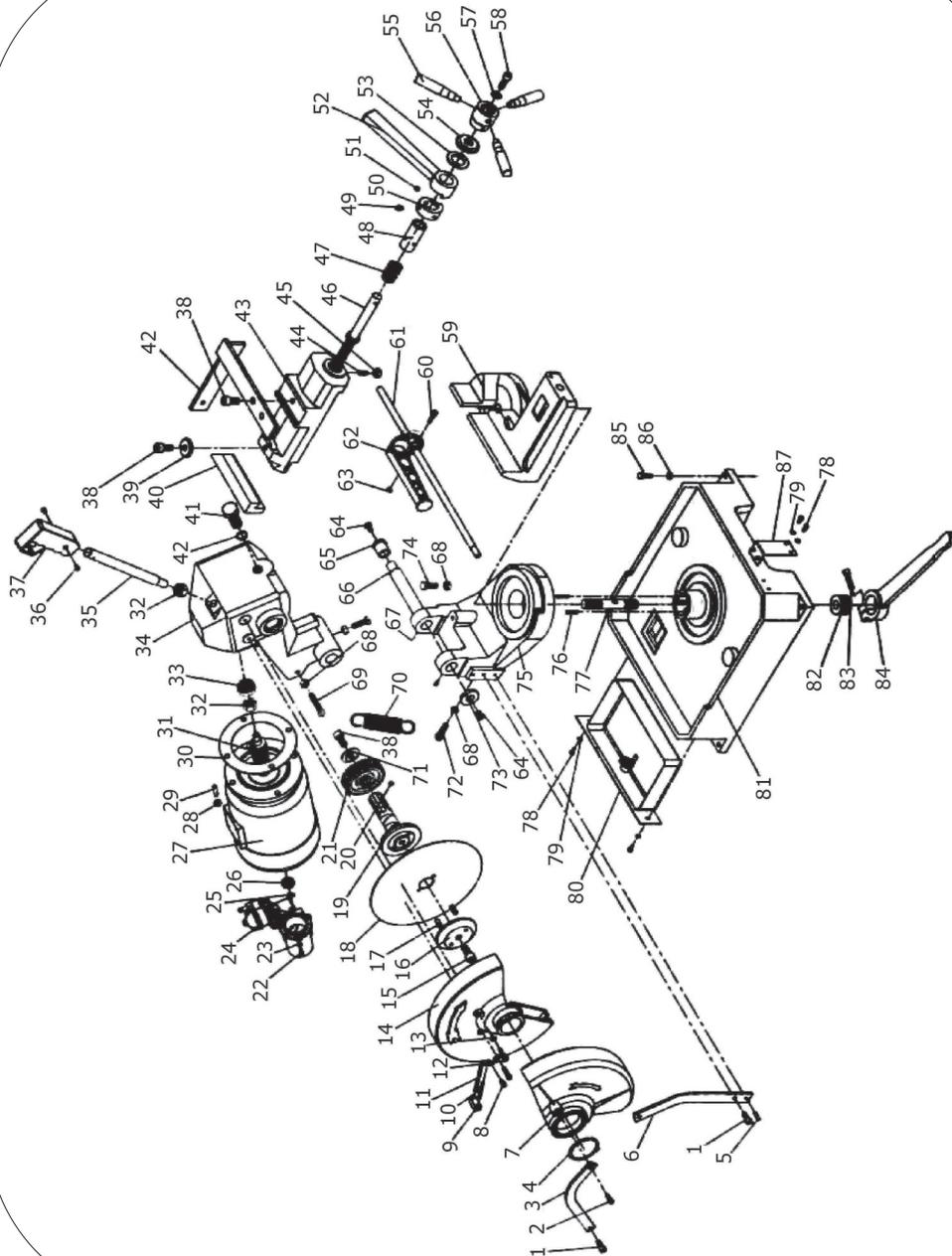
## EXPLODED DRAWING....cont



## PARTS LIST

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
1.	Cap head bolt M8x20	WK03-00001	13.	Washer M6	WK03-00013
2.	Cap head bolt M6x16	WK03-00002	14.	Fixed blade guard	WK03-00014
3.	Moving guard arm	WK03-00003	15.	Blade bolt M12x25	WK03-00015
4.	Guard circlip	WK03-00004	16.	Blade flange	WK03-00016
5.	Hex screw M6x20	WK03-00005	17.	Blade flange pin	WK03-00017
6.	Fixed guard arm	WK03-00006	18.	Blade 250 x 2.0 x 32mm Z100 T8	05206
7.	Moving blade guard	WK03-00007	18.	Blade 250 x 2.0 x 32mm Z128 T6	05208
8.	Hex screw M6x10	WK03-00008	18.	Blade 250 x 2.0 x 32mm Z160 T5	05210
9.	Fixed block	WK03-00009	18.	Blade 250 x 2.0 x 32mm Z200 T4	05212
10.	Coolant pipe	WK03-00010	18.	Blade 250 x 2.0 x 32mm Z250 T3	05214
11.	Coolant pipe	WK03-00011	19.	Blade shaft	WK03-00019
12.	Hex screw M6x25	WK03-00012	20.	Bolt M8x8	WK03-00020

## EXPLODED DRAWING



## SAFETY INSTRUCTIONS...cont

- Do not modify the circular saw to do tasks other than those intended.
- When sawing always use the vice to hold the material; To avoid injury, the work piece should never be held with the bare hands.
- Secure the stand to the circular saw before using the circular saw. If the work is heavy or large and likely to cause the circular saw to tip over, use additional supports as appropriate under and around the material.
- Remove all tools from the machine base after adjustment is made.
- Appropriate personal protective equipment **MUST** be worn and **MUST** be designed to protect against all hazards created. Severe permanent injury can result from using inappropriate or insufficient protective equipment - Eyes in particular are at risk.
- Do not overload the blade. Allow the blade to operate at its optimum speed for maximum efficiency.
- Always ensure that the accessories such as blades are rated / designed for use with this circular saw as well as the required application, and are correctly and securely fastened before connecting the circular saw to the mains supply.
- The work must be clamped firmly whilst sawing, If its loose it could result in personal injury or damage to the blade/machine.
- Using the correct tpi blade for cutting the material will make your job easier, and the blade last longer, using the wrong tpi blade will make a rough cut and will decrease the life of the blade.
- Keep hands away from the blade.
- Never use this circular saw with the blade guard or electrical box cover removed.
- Round bar and tubing can have a tendency to roll whilst being cut and can cause the blade to slip, **DO NOT** cut such items without clamping the material with the vice.
- Never have the blade touching the material before you press the handle trigger, this is dangerous and will make the blade bounce or even shatter, any damage will not be covered by warranty.
- Do not start the circular saw until the material is secure and the blade has been lowered to just above the material.
- Never use damaged or deformed circular saw blades, this is extremely dangerous and if the blade shatters pieces will fly out, and could injury you or any one in the vicinity.

**If the circular saw is used in a place of work all rules and laws etc. relating to the use of portable electrical appliances should be followed.**

## SAFETY INSTRUCTIONS....cont



When using the circular saw for certain operations, particularly during extended periods; ensure the operator as well as those in the area wear ear protection.



When using the circular saw always ensure the operator as well as those in the area wear eye protection.

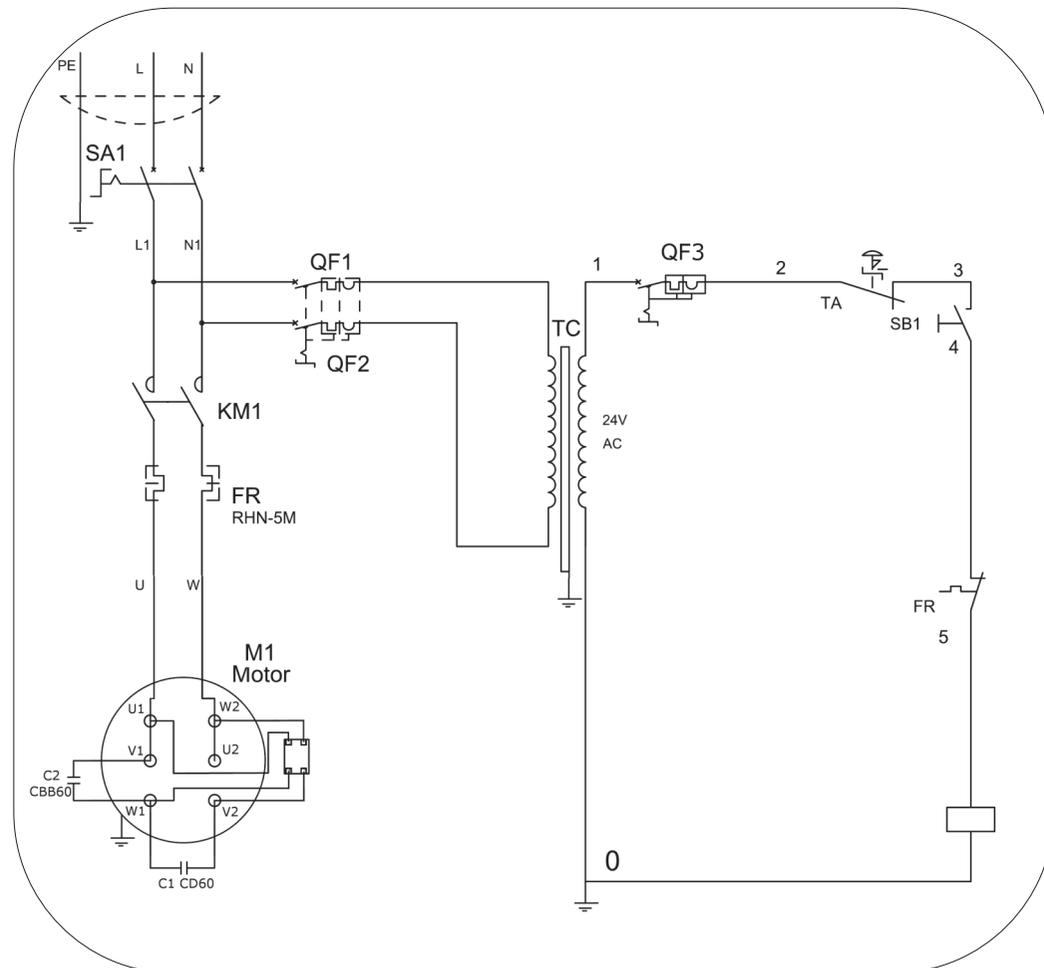


Some materials have the potential to be highly toxic; always wear a face mask when operating circular saw.



**CAUTION:** The warnings and cautions mentioned in this user manual can not cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be applied.

## WIRING DIAGRAM



Ref.	Description	Ref.	Description
TA	Emergency stop	TC	Transformer
SB1	Trigger switch	C1	Capacitor 50mf
FR	Overload relay	C2	Capacitor 18mf
KM1	Contactor	QF1,2,3	Breaker

## TROUBLESHOOTING

Symptom	Possible problem	Solution
Excessive bouncing or blade breaking.	<ol style="list-style-type: none"> <li>Teeth blunt on blade.</li> <li>Wrong coolant.</li> <li>Worm and worm wheel defective.</li> </ol>	<ol style="list-style-type: none"> <li>Replace blade.</li> <li>Use correct coolant.</li> <li>Replace or contact distributor for repair.</li> </ol>
Motor doesn't turn.	<ol style="list-style-type: none"> <li>Switch is in the 'OFF' position.</li> <li>Breaker popped out.</li> <li>Emergency stop button activated.</li> </ol>	<ol style="list-style-type: none"> <li>Turn the switch to the 'ON' position.</li> <li>Reset the breaker in the electrical box or mains board.</li> <li>Reset emergency stop button.</li> </ol>
Coolant system not working.	<ol style="list-style-type: none"> <li>Coolant tap in the 'CLOSED' position.</li> <li>Coolant pump faulty.</li> <li>Coolant tank empty.</li> <li>Coolant pipe obstructed.</li> <li>Coolant filter blocked.</li> </ol>	<ol style="list-style-type: none"> <li>Put to the 'OPEN' position.</li> <li>Replace coolant pump.</li> <li>Fill coolant tank.</li> <li>Check and clear/replace pipe if necessary.</li> <li>Clean/replace coolant filter.</li> </ol>



**Note:** If none of the above solutions work then contact your local distributor for repair, or contact SIP technical for more advise.



01 509 500400



technical@sip-group.com

## ELECTRICAL CONNECTION

**WARNING!** It is the responsibility of the owner and the operator to read, understand and comply with the following:

You must check all electrical products, before use, to ensure that they are safe. You must inspect power cables, plugs, sockets and any other connectors for wear or damage.

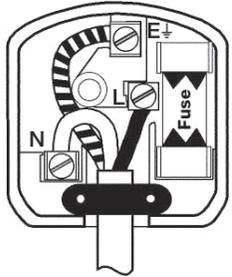
You must ensure that the risk of electric shock is minimised by the installation of appropriate safety devices; A residual current circuit Breaker (RCCB) should be incorporated in the main distribution board. We also recommend that a residual current device (RCD) is used. It is particularly important to use an RCD with portable products that are plugged into a supply which is not protected by an RCCB. If in any doubt consult a qualified electrician.

### Connecting to the power supply:

This SIP circular saw is fitted with a standard 230v ~ 13 amp type plug. Before using the circular saw, inspect the mains lead and plug to ensure that neither are damaged. If any damage is visible have the circular saw inspected / repaired by a suitably qualified person. If it is necessary to replace the plug a heavy duty impact resistant plug would be preferable.

### The wires for the plug are coloured in the following way:

Yellow / green	Earth
Blue	Neutral
Brown	Live



As the colours of the wires may not correspond with the markings in your plug, proceed as follows: The wire which is coloured blue, must be connected to the terminal marked with N or coloured black. The wire which is coloured brown, must be connected to the terminal, which is marked L or coloured red. The wire which is coloured yellow / green should be connected to the terminal which is coloured the same or marked



Always secure the wires in the plug terminal carefully and tightly. Secure the cable in the cord grip carefully.

## ELECTRICAL CONNECTION...cont



**Warning:** Never connect live or neutral wires to the earth terminal of the plug. Only fit an approved plug with the correct rated fuse. If in doubt consult a qualified electrician.



**Note:** Always make sure the mains supply is of the correct voltage and the correct fuse protection is used. In the event of replacing the fuse always replace the fuse with the same value as the original.



**Note:** If an extension lead is necessary in order to reach the mains supply; The cross section should be checked so that it is of sufficient size so as to reduce the chances of voltage drops. Always fully unwind the lead during use.

## GUARANTEE

This SIP circular saw is covered by a 12 month parts and labour warranty covering failure due to manufacturers defects. This does not cover failure due to misuse or operating the circular saw outside the scope of this manual - any claims deemed to be outside the scope of the warranty may be subject to charges including, but not limited to parts, labour and carriage costs.

This guarantee does not cover consumables such as oil & blades etc.

In the unlikely event of warranty claims, contact your distributor as soon as possible. Proof of purchase will be required before any warranty can be honoured.



**Note:** Proof of purchase will be required before any warranty can be honoured.

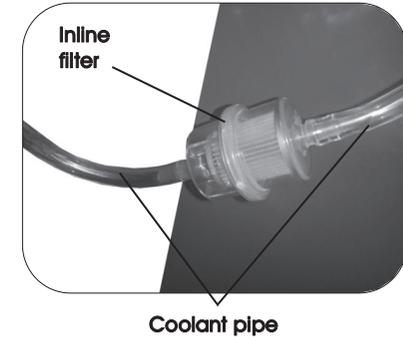
## MAINTENANCE...cont

### CHANGING THE INLINE FILTER



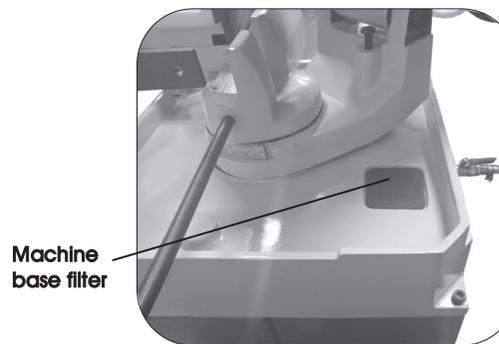
**Note:** Its best to change the filter at least once a year, or sooner if used more often in a day to day working environment.

- The filter is located on the back off the machine between the coolant pump and coolant tap.
- Pull the two coolant pipes off either side of the filter.
- Push the two coolant pipes back onto the new filter.



**Note:** Replacement filters are available through your local distributor, quote SIP Part No. WK03-00095.

### CLEANING THE MACHINE



Over the course of the day, the machine will get clogged with swarf and could possibly stop the coolant from running back into the coolant tray. It is best to get into a routine at the end of each working day, or more if its used more frequently to clean any swarf from the machine base casting, filter and vice jaws. Use a soft brush (paint brush or similar) to remove the swarf from the machine at the end of each working day, **NEVER** use compressed air to remove the swarf.



**Note:** Never run the machine without the machine base filter fitted; without it fitted swarf will get into the coolant system and clog the coolant pump, thus stopping the coolant cooling the blade. If a coolant pump is found with swarf inside of it then this will void any warranty you may have.

## MAINTENANCE...cont

### CHANGING THE GEAR BOX OIL



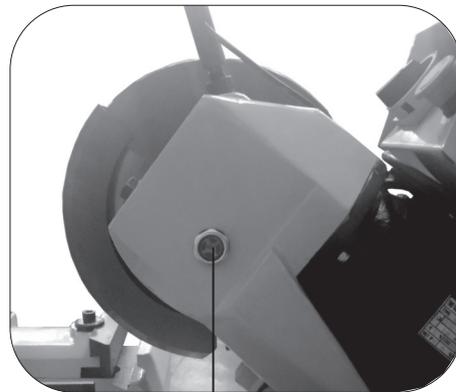
Oil drain bolt

- Turn the machine to the 'OFF' position and disconnect from the mains.
- Raise the head upwards.
- Place a container on the base of the circular saw and inline with the oil drain hole.
- Remove the oil drain bolt
- Slowly lower the head and drain all the old oil into the container.



**Note:** Contact your local authority on how / where to dispose of the waste oil.

- Once all the oil is out, raise the head upwards.
- Fill with EP90 gear oil until it reaches around the red dot on the oil sight glass.
- Refit the oil drain bolt.



Oil sight glass

## TECHNICAL SPECIFICATIONS

Name	10" Industrial Circular saw
Part number	01554
Circular 45°	55mm
Circular 90°	60mm
Rectangle 45°	55 x 45mm
Rectangle 90°	75 x 45mm
Blade size	250mm
Maximum vice width	100mm
Blade speed	42rpm
Motor	1.5HP (1.1Kw)
Net weight	143 kgs
Gross weight	171 kgs

For the sawing capacity of different shaped material and mitre angles, refer to the below diagram.

							
90°	60	55x55	55x55	55x55	75x45	35	35x35
60°	55	50x50	50x50	50x50	55x45	30	30x30
45°	55	50x50	50x50	50x50	55x45	25	25x25

## BLADE SECTION

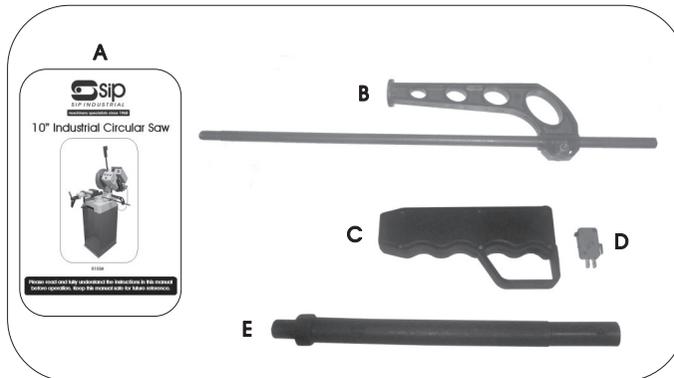
Hollow section 	Tooth Pitch	Solid Bar Size			
		10mm to 15mm	15mm to 20mm	20mm to 25mm	25mm to 35mm
		Hollow Section Wall thickness			
Solid bar 	3	x			
	4		x		
	5			x	
	6				x
	8	x			
	10		x		
	12			x	
15				x	



**Note:** The above table is a reference to what size blade should be used on different thickness materials.

## CONTENTS & ACCESSORIES

A	Manual
B	Cut off stop
C	Handle
D	Handle micro switch
E	Handle lever

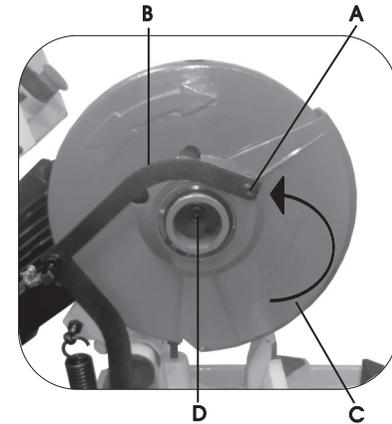


**Note:** If any of the above are missing or damaged, contact your distributor immediately.

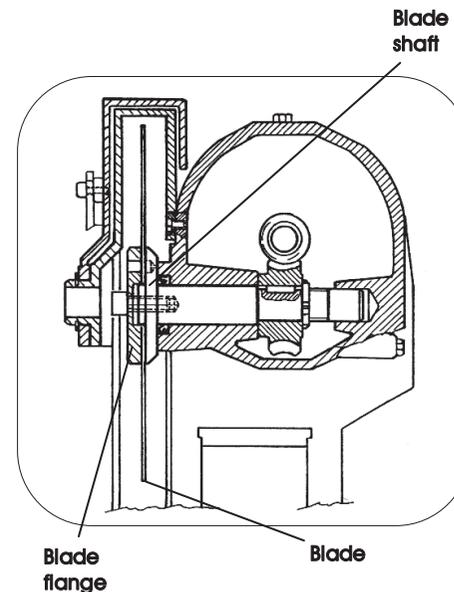
## MAINTENANCE

### CHANGING THE BLADE

- Turn the circular saw to the `OFF` position and disconnect from the mains.
- Raise the head upwards.
- Remove hex. bolt (A).
- Move arm (B) out of the way.
- Slide the movable guard (C) over the fixed guard so you can see the blade.
- Remove the blade bolt (D) by turning it clockwise to undo it, a soft mallet may be required just to loosen the bolt as it will be tight, but do not hit it too hard.



**Caution:** The blade bolt is a left handed thread, meaning to undo it you must turn the bolt clockwise, failing to do this will strip the threads on the blade shaft and possibly snap the blade bolt and will void your warranty.



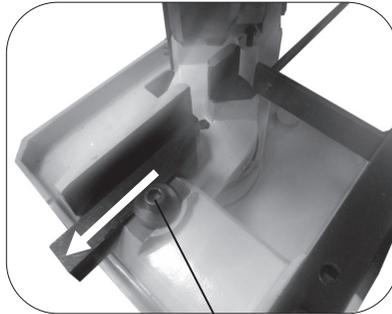
- Once the blade bolt is out, remove the blade flange and then the blade.
- Place the new blade over the blade shaft lip and align the two holes to match the blade shaft holes.
- Fit the blade flange over the blade, but make sure the two pins on the blade flange slot into the blade and blade shaft holes.
- Refit the blade bolt by turning it anti-clockwise to re-tighten.
- Slide the guard (C) back down and refit the arm (B) with bolt (A).



**Note:** If the angle to be cut is greater than 25° left or right then some adjustments will need to be made to the vice.

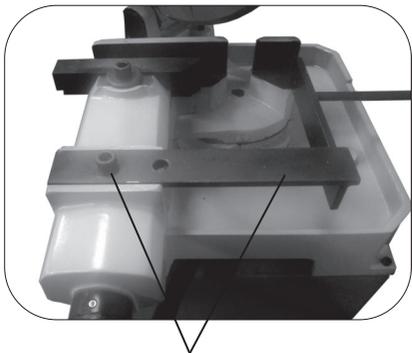
### To set an angle greater than 25° to the left.

- Loosen the hex bolt on the vice jaw and slide it to the left.
- Loosen the bench lever and set the angle you require.
- Once the angle is set, lower the blade (without the saw running) to ensure the vice jaw is sufficiently out of the way.
- Re-tighten the bench lever and vice jaw hex bolt.



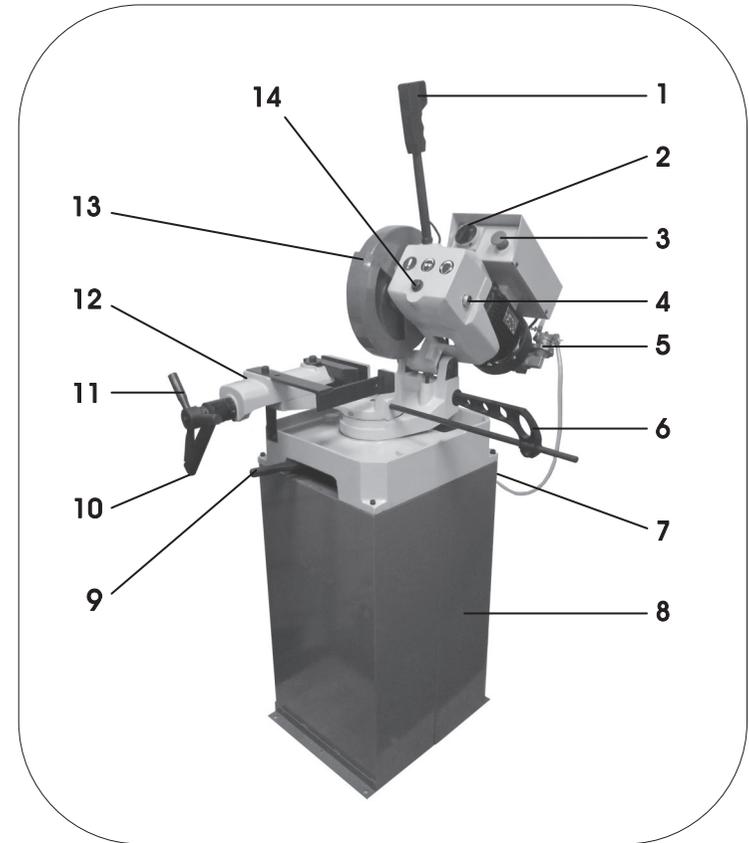
Vice jaw hex bolt

### To set an angle greater than 25° to the right.



Remove bolt & vice bracket

- Remove the hex bolt and remove the vice bracket.
- Loosen the bench lever.
- Turn the head and set the angle required.
- Re-tighten the bench lever.



Ref.	Description	Ref.	Description
1.	Handle	8.	Stand
2.	On/Off switch	9.	Bench lever
3.	Emergency stop button	10.	Quick vice lever
4.	Oil sight glass	11.	Vice hand-wheel
5.	Coolant pump	12.	Vice
6.	Cut off stop	13.	Blade guard
7.	Coolant tap	14.	Oil bolt

## ASSEMBLY INSTRUCTIONS

### FITTING THE CIRCULAR SAW TO THE STAND



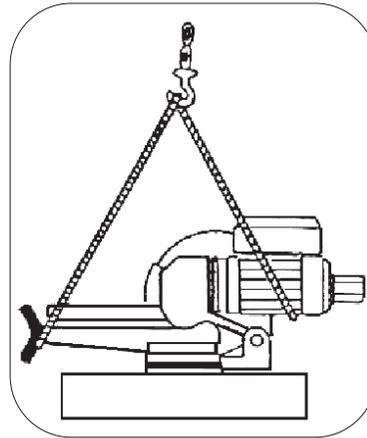
**Danger / Caution:** This is a minimum of a 2 man operation to remove this circular saw from its packaging as it is extremely heavy, failing to do this can have serious consequences and could lead to personal injury and/or the possibility of damage.



**Note:** If any items are missing or damaged, **DO NOT** use the machine and contact your distributor immediately.

- Bolt both halves of the stand together with the supplied bolts.
- Place the stand into the location where the circular saw is to be used.
- Bolt the stand to the floor (bolts not supplied).
- Remove the circular saw from its packaging.

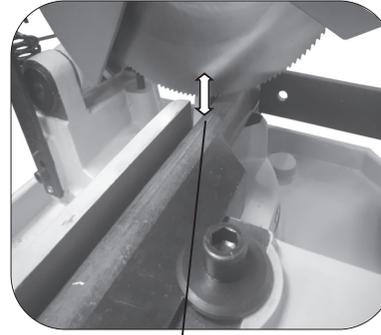
- Using proper lifting equipment and lifting straps, raise the circular saw up so its slightly higher than the stand.



**Danger / Caution:** Always using proper lifting equipment to move the circular saw onto the stand, **NEVER** attempt to lift the circular saw without lifting equipment as this is extremely dangerous.

- Slowly move the saw over the stand then slowly lower the saw onto the stand, ensuring the four holes match up on the stand and saw.
- Secure the circular saw to the stand using the four hex bolts supplied.
- Remove the straps from the circular saw.

## OPERATING INSTRUCTIONS...cont



Leave a gap of around 5mm before pressing the handle trigger

- Lower the head to just above the material, but do not make contact with the material.
- Press the handle trigger on the head lever inwards (this will activate the micro switch and start the motor and coolant pump).
- Once the material is cut, release the trigger and raise the head.
- Remove the material by undoing the quick vice lever.
- Repeat these steps if more material is to be cut.



**Danger / Caution:** Never have the blade touching the material before you press the handle trigger, this is dangerous and will make the blade bounce or even shatter, any damage will not be covered by warranty.

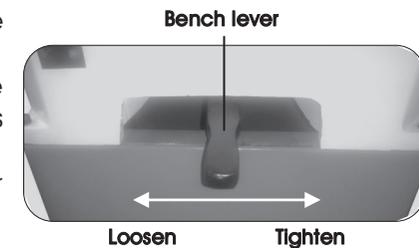


**Danger / Caution:** Never force the blade down whilst cutting, this will damage the teeth on the blade and or shatter, always let the blade do the cutting.

### SETTING UP FOR AN ANGLED CUT

The vice is fixed and the angle can only be set by rotating the head, 45° right or 0° or 45° left, to adjust to a specific angle the do the following.

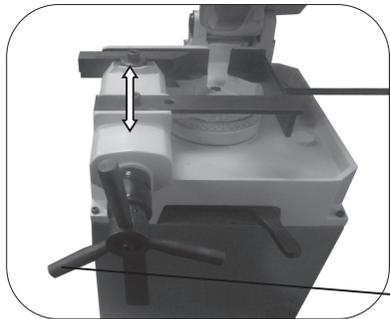
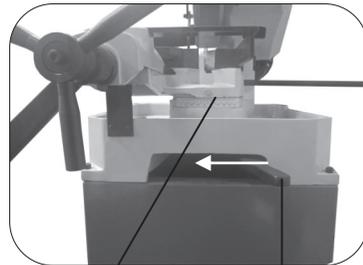
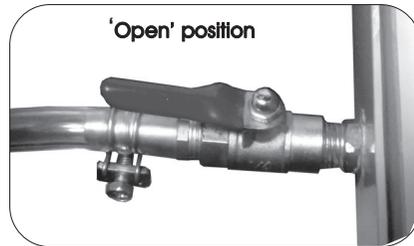
- Loosen the bench lever by moving it to the left.
- Pull the head lever down and move the head left or right, depending on what cut is to be made.
- Use the scale on the swivel base to set your angle.
- Once set re-tighten the bench lever.



## OPERATING INSTRUCTIONS...cont

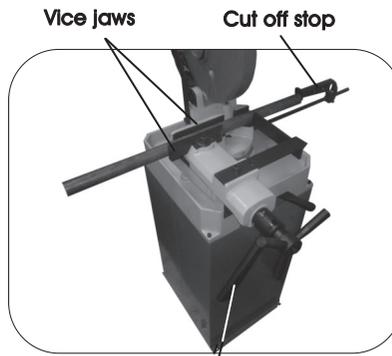
### CUTTING AT 90°

- Turn the coolant tap to the 'Open' position.
- Loosen the bench lever and turn the head so it is at 0° on the scale.
- Tighten the bench lever back up, so the head can't move as your cutting.



- Move the upper vice so you have enough clearance to fit your material; turn the vice hand-wheel on the front of the vice to move the upper vice.
- Place your material between the two vice jaws.

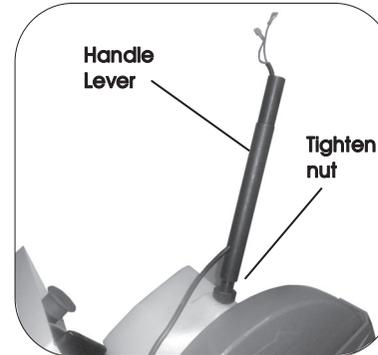
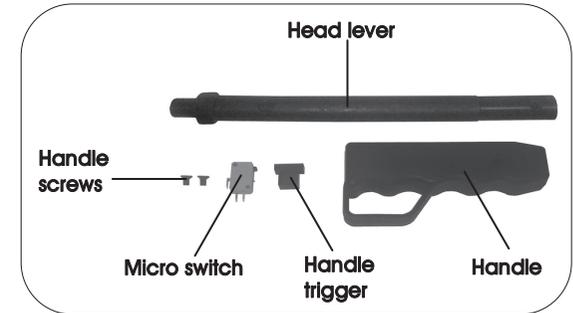
- Tighten the vice hand-wheel until it makes contact with the material.
- Use the quick vice lever to grip your material more firmly.
- Set the cut off stop only if you have multiple items to be cut at the same length, if different lengths are to be cut the cut off stop could be removed.
- Turn the on/off switch to 'ON'



## ASSEMBLY INSTRUCTIONS...cont

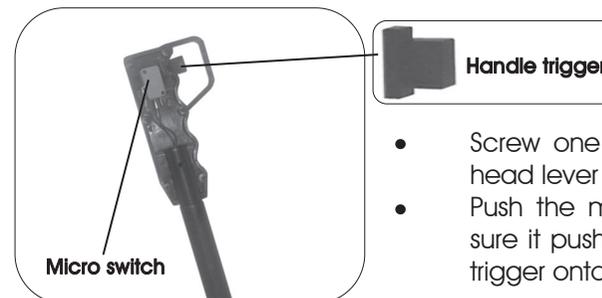
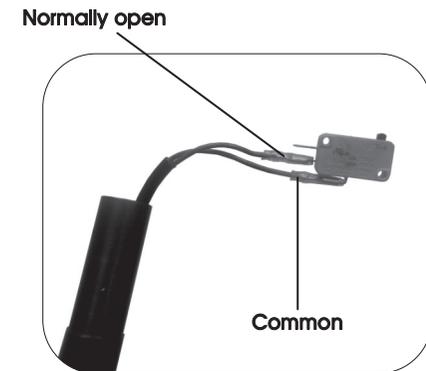
### FITTING THE HEAD LEVER

Items needed →



- Remove the transit bung from the head.
- Screw the handle lever into the head and tighten the nut (ensure the pre-drilled hole is facing the rear of the machine) so the handle lever can't move.

- Locate the micro switch wire on the back of the electrical box and slide it through the head lever.
- Connect the two wires onto the micro switch; one wire to the C (common) connection and the other to the NO (normally open) connection.



- Screw one half of the plastic handle onto the head lever using the handle screw.
- Push the micro switch into the handle making sure it pushes into both pins, then fit the handle trigger onto the handle.

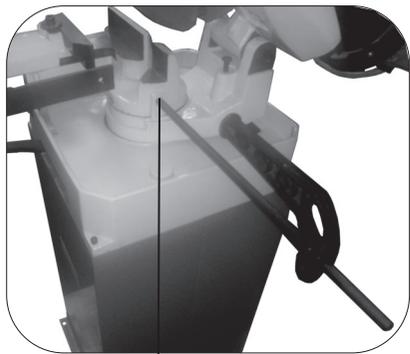
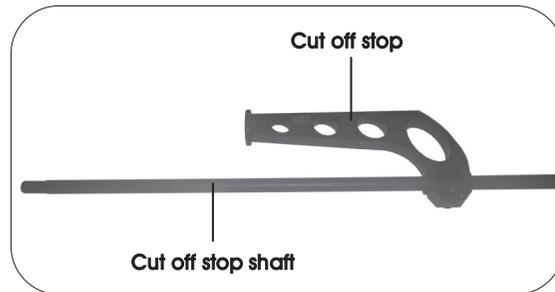
## ASSEMBLY INSTRUCTIONS...cont



- Push the other half of the handle onto the one that's already fixed to the head lever; use the remaining handle screw to secure.
- Tighten the remaining six screws to fully secure the plastic handle.
- Cable tie the wire onto the head lever.

### FITTING THE CUT OFF STOP

Items needed →

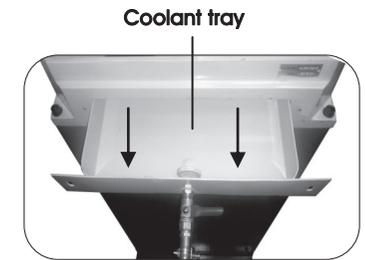
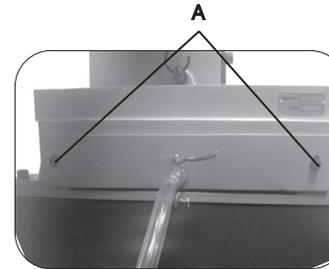


- To fit the cut off stop, simply slide the cut off stop onto the cut off stop shaft and tighten the hex bolt, then screw it into the side of the vice.

## OPERATING INSTRUCTIONS

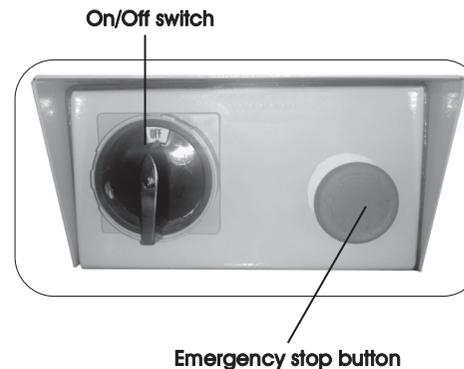
### FILLING THE COOLANT TRAY

- Remove the two hex bolts (A) and slide the coolant tray out.
- Fill the coolant tray with coolant and slide the tray back in.
- Refit the two hex bolts.



**Note:** Before any cuts are made it is best to get into a routine of turning the coolant tap to the open position, this will prolong the life of the blade

### STARTING THE CIRCULAR SAW



- To start the circular saw, turn the on/off switch clockwise to the 'ON' position (the blade will not turn until the handle trigger is pressed in).
- To stop the circular saw, turn the on/off switch anti-clockwise to the 'OFF' position, or push the emergency stop button in.
- The emergency stop button when pressed in will cut the power to the motor, to reset the emergency stop button twist it clockwise and it will pop back out.