



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.

*FOR HELP OR ADVICE ON THIS PRODUCT PLEASE CONTACT YOUR DISTRIBUTOR,
OR SIP DIRECTLY ON:*

TEL: 01509500400

*EMAIL: sales@sip-group.com or technical@sip-group.com
www.sip-group.com*

Ref: 061216

sip
SIP INDUSTRIAL

machinery specialists since 1968

14" Abrasive Cut Off Saw



01308 / 01315

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

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

14" Abrasive Cut Off Saw - SIP Part No. 01308
14" Abrasive Cut Off Saw (110v) - SIP part No. 01315

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

2006/42/EC	Machinery Directive
2014/30/EU	EMC Directive
2011/65/EU	RoHS Directive

And the relevant harmonised standard(s), including

EN61029-1:2009+A11:2010
EN61029-2-10:2010+A11:2013
EN55014-1:2006+A1:2009+A2:2011
EN55014-2:2015
EN61000-3-2:2014
EN61000-3-11:2000

Signed: 

Mr P. Ippaso - Managing Director - SIP (Industrial Products) Ltd
Date: 06/12/2016.



Page No.	Description
4.	Safety Symbols Used Throughout This Manual
4.	Safety Instructions
9.	Electrical Connection
10.	Guarantee
10.	Contents and Accessories
11.	Technical Specification
12.	Getting to Know Your Abrasive Cut Off Saw
13.	Operating Instructions
14.	Maintenance
15.	Wiring Diagram
16.	Exploded Drawing
17.	Parts List - 01308
19.	Parts List - 01315
23.	Declaration of Conformity

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 abrasive cut off saw.*

When using your abrasive cut off saw, basic safety precautions should always be followed to reduce the risk of personal injury and / or damage to the abrasive cut off saw.

Read all of these instructions before operating the abrasive cut off saw and save this user manual for future reference.

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

This abrasive cut off saw is designed to cut all types of ferrous metals.

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

Before each use of the abrasive cut off saw always check no parts are broken and that no parts are missing.

Always check that the disc bolt is tight before, during and after operation.

Always operate the abrasive cut off saw safely and correctly.

KNOW YOUR ABRASIVE CUT OFF SAW: Read and understand the owner's manual and labels affixed to the abrasive 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 ABRASIVE CUT OFF SAW IN DANGEROUS ENVIRONMENTS: Do not use the abrasive cut off saw in damp or wet locations, or expose it to rain. Provide ade-

NOTES

PARTS LIST - 01315....cont

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
61.	Gear Case Cover	WK08-00061	78.	Rubber Pole	WK08-00078
62.	Screw	WK08-00062	79.	Cap	WK08-00079
63.	Check Ring	WK08-00063	80.	Lower Handle	WK08-00080
64.	6204 Bearing	WK08-00064	81.	Capacitor	WK08-00081
65.	Spindle	WK08-00065	82.	Switch	WK08-00082
66.	Key	WK08-00066	83.	Trigger	WK08-00083
67.	Fixed Guard	WK08-00067	84.	Soft Start	WK08-00084
68.	Spring Washer	WK08-00068	85.	Upper Handle	WK08-00085
69.	Screw	WK08-00069	86.	Screw	WK08-00086
70.	Inner Flange	WK08-00070	87.	Carry Handle	WK08-00087
71.	Outer Flange	WK08-00071	88.	Screw	WK08-00088
72.	Washer	WK08-00072	89.	Screw	WK08-00089
73.	Screw	WK08-00073	90.	Screw	WK08-00090
74.	Lock Nut	WK08-00074	91.	Mains Lead Gland	WK08-00091
75.	Moving Guard	WK08-00075	92.	Mains Lead	WK08-00092
76.	Special Screw	WK08-00076	93.	Cable Clamp	WK08-00093
77.	Special Screw	WK08-00077			

SAFETY INSTRUCTIONS....cont

quate space surrounding the work area. Do not use in environments with a potentially explosive atmosphere.

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 ABRASIVE CUT OFF SAW SAFELY WHEN NOT IN USE: The abrasive cut off 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 abrasive 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 abrasive cut off saw when you are tired or under the influence of alcohol or drugs.

DISCONNECT THE ABRASIVE CUT OFF SAW FROM THE MAINS SUPPLY: When not in use, before servicing and when changing accessories such as the abrasive disc, etc.

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

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

DO NOT ABUSE THE MAINS LEAD: Never attempt to move the abrasive cut off 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 abrasive cut off saw, the guards or any 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. Guards or any other part that are 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 authorised service agent. Do not use the abrasive cut off saw if the switch does not turn the saw on and off.

SAFETY INSTRUCTIONS....cont

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

MAINTAIN THE ABRASIVE CUT OFF SAW WITH CARE: Keep discs clean for the best and safest performance.

All extension cables must be checked at regular intervals and replaced if damaged.

ALWAYS: Keep the vice handle knob on the abrasive cut off 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 abrasive cut off saw before every use.

SECURE THE WORKPIECE: Always use the vice to hold the workpiece. This frees up both hands to operate the abrasive saw.

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

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

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

DO NOT OPERATE THE ABRASIVE CUT OFF SAW IN EXPLOSIVE ATMOSPHERES: Do not use the abrasive cut off saw in the presence of flammable liquids, gases, dust or other combustible sources. Abrasive sawing operations may create sparks which can ignite the dust or fumes.

DO NOT EXPOSE THE ABRASIVE CUT OFF SAW TO RAIN OR USE IT IN WET CONDITIONS: Water entering the abrasive cut off saw will greatly increase the risk of electric shock.

HAVE YOUR ABRASIVE CUT OFF 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 abrasive cut off saw without all guards fitted as this may be dangerous and will invalidate the warranty.

- Keep hands out of the path of the abrasive disc, never reach around the abrasive disc.
- Make sure the abrasive disc is clear of the workpiece before the trigger switch is pressed in.
- Stop operation immediately if you notice anything abnormal.
- Wait for the abrasive disc to stop completely and remove the plug from the mains supply before servicing or adjusting the abrasive cut off saw or changing the abrasive disc.
- Be alert at all times, especially during repetitive, monotonous operations. Don't be lulled into a false sense of security. Abrasive discs can be extremely unforgiving.

PARTS LIST - 01315

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
1.	Lock Bolt	WK08-00001	31.	Clamp Nut	WK08-00031
2.	Screw	WK08-00002	32.	Screw	WK08-00032
3.	Washer	WK08-00003	33.	Spring Washer	WK08-00033
4.	Locking Handle	WK08-00004	34.	Roll Pin	WK08-00034
5.	Rubber Foot	WK08-00005	35.	Split Pin	WK08-00035
6.	Base	WK08-00006	36.	Washer	WK08-00036
7.	Fixed Clamp Jaw	WK08-00007	37.	Screw	WK08-00037
8.	Washer	WK08-00008	38.	Motor Cover	WK08-00038
9.	Lock Washer	WK08-00009	39.	Brush Spring	WK08-00039
10.	Bolt	WK08-00010	40.	Brush Set	WK08-00040
11.	Spark Deflector	WK08-00011	41.	Screw	WK08-00041
12.	Bolt	WK08-00012	42.	Brush Holder	WK08-00042
13.	Pivot Shaft	WK08-00013	43.	Screw	WK08-00043
14.	Lock Pin	WK08-00014	44.	Housing	WK08-00044
15.	Ring	WK08-00015	45.	Rubber Cover	WK08-00045
16.	Lock Pin Cap	WK08-00016	46.	608 Bearing	WK08-00046
17.	Screw	WK08-00017	47.	Stator	WK08-00047
19.	Nut	WK08-00019	48.	Fan Baffle	WK08-00048
20.	Washer	WK08-00020	49.	Screw	WK08-00049
21.	Lock Nut	WK08-00021	50.	Armature	WK08-00050
22.	Torsion Spring	WK08-00022	51.	Screw	WK08-00051
23.	Nut	WK08-00023	52.	Spring Washer	WK08-00052
24.	Small Lead Screw	WK08-00024	53.	Bearing Cap	WK08-00053
25.	Thread Pin	WK08-00025	54.	Flange Lock Pin	WK08-00054
26.	Clamp Jaw	WK08-00026	55.	Bearing	WK08-00055
27.	Washer	WK08-00027	56.	Spring	WK08-00056
28.	Spring Washer	WK08-00028	58.	Arm	WK08-00058
29.	Nut	WK08-00029	59.	Bearing	WK08-00059
30.	Clamp Base	WK08-00030	60.	Gear	WK08-00060

PARTS LIST - 01308....cont

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
61.	Gear Case Cover	WK08-00061	78.	Rubber Pole	WK08-00078
62.	Screw	WK08-00062	79.	Cap	WK08-00079
63.	Check Ring	WK08-00063	80.	Lower Handle	WK08-00080
64.	6204 Bearing	WK08-00064	81.	Capacitor	WK08-00081
65.	Spindle	WK08-00065	82.	Switch	WK03-00305
66.	Key	WK08-00066	83.	Trigger	WK08-00083
67.	Fixed Guard	WK08-00067	84.	Soft Start	WK03-00307
68.	Spring Washer	WK08-00068	85.	Upper Handle	WK08-00085
69.	Screw	WK08-00069	86.	Screw	WK08-00086
70.	Inner Flange	WK08-00070	87.	Carry Handle	WK08-00087
71.	Outer Flange	WK08-00071	88.	Screw	WK08-00088
72.	Washer	WK08-00072	89.	Screw	WK08-00089
73.	Screw	WK08-00073	90.	Screw	WK08-00090
74.	Lock Nut	WK08-00074	91.	Mains Lead Gland	WK08-00091
75.	Moving Guard	WK08-00075	92.	Mains Lead	WK03-00315
76.	Special Screw	WK08-00076	93.	Cable Clamp	WK08-00093
77.	Special Screw	WK08-00077			

SAFETY INSTRUCTIONS....cont

- Use of improper accessories may cause damage to the abrasive cut off saw and surrounding area as well as increasing the risk of injury.
- Do not modify the abrasive cut off 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.
- Remove all tools from the machine base after adjustments are 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 abrasive disc. Allow the abrasive disc to operate at its optimum speed for maximum efficiency.
- Always ensure that the accessories such as abrasive discs are rated / designed for use with this abrasive cut off saw as well as the required application, and are correctly and securely fastened before connecting the abrasive cut off 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 abrasive disc or machine.
- Keep hands away from the abrasive disc.
- Never use this abrasive cut off saw with the disc guards or rear motor cover removed.
- Round tubing can have a tendency to roll whilst being cut and can cause the abrasive disc to slip, **DO NOT** cut such items without clamping the material with the vice.
- Do not start the abrasive cut off saw until the material is secure and the abrasive disc has been lowered to just above the material.
- Never use damaged, expired or lower rpm rated abrasive discs, this is extremely dangerous and could split or even shatter, and could injury you or any one in the vicinity.



Note: If the abrasive cut off 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



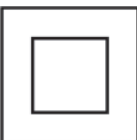
When using the saw always ensure the operator as well as those in the area wear ear protection.



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



Some metals and metal composites have the potential to be highly toxic; always wear a face mask when operating saw.



This abrasive cut off saw is double insulated; This means the operator is separated from the tool's electrical system by two complete sets of electrical insulation. This extra layer of insulation is intended to protect the user from electrical shock due to a break in the wiring insulation. All exposed metal parts are isolated from the internal metal motor components with protecting insulation. Double insulated tools do not need to be grounded (earthed). Servicing of a tool with double insulation requires extreme care and knowledge of the system and should be performed only by a suitably qualified person.



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.

PARTS LIST - 01308

Ref. No.	Description	SIP Part No.	Ref. No.	Description	SIP Part No.
1.	Lock Bolt	WK08-00001	31.	Clamp Nut	WK08-00031
2.	Screw	WK08-00002	32.	Screw	WK08-00032
3.	Washer	WK08-00003	33.	Spring Washer	WK08-00033
4.	Locking Handle	WK08-00004	34.	Roll Pin	WK08-00034
5.	Rubber Foot	WK08-00005	35.	Split Pin	WK08-00035
6.	Base	WK08-00006	36.	Washer	WK08-00036
7.	Fixed Clamp Jaw	WK08-00007	37.	Screw	WK08-00037
8.	Washer	WK08-00008	38.	Motor Cover	WK08-00038
9.	Lock Washer	WK08-00009	39.	Brush Spring	WK08-00039
10.	Bolt	WK08-00010	40.	Brush Set	WK03-00267
11.	Spark Deflector	WK08-00011	41.	Screw	WK08-00041
12.	Bolt	WK08-00012	42.	Brush Holder	WK08-00042
13.	Pivot Shaft	WK08-00013	43.	Screw	WK08-00043
14.	Lock Pin	WK08-00014	44.	Housing	WK08-00044
15.	Ring	WK08-00015	45.	Rubber Cover	WK08-00045
16.	Lock Pin Cap	WK08-00016	46.	608 Bearing	WK08-00046
17.	Screw	WK08-00017	47.	Stator	WK03-00274
19.	Nut	WK08-00019	48.	Fan Baffle	WK08-00048
20.	Washer	WK08-00020	49.	Screw	WK08-00049
21.	Lock Nut	WK08-00021	50.	Armature	WK03-00277
22.	Torsion Spring	WK08-00022	51.	Screw	WK08-00051
23.	Nut	WK08-00023	52.	Spring Washer	WK08-00052
24.	Small Lead Screw	WK08-00024	53.	Bearing Cap	WK08-00053
25.	Thread Pin	WK08-00025	54.	Flange Lock Pin	WK08-00054
26.	Clamp Jaw	WK08-00026	55.	Bearing	WK08-00055
27.	Washer	WK08-00027	56.	Spring	WK08-00056
28.	Spring Washer	WK08-00028	58.	Arm	WK08-00058
29.	Nut	WK08-00029	59.	Bearing	WK08-00059
30.	Clamp Base	WK08-00030	60.	Gear	WK08-00060



This abrasive cut off saw is double insulated. This means the operator is separated from the tool's electrical system by two complete sets of electrical insulation.

This abrasive cut off saw (01308) is fitted with a standard UK type 230v ~ plug. Before using the tool inspect the cable and plug to ensure that neither are damaged. If any damage is visible have the tool 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 abrasive cut off saw (01315) is supplied with no plug fitted.

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

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



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



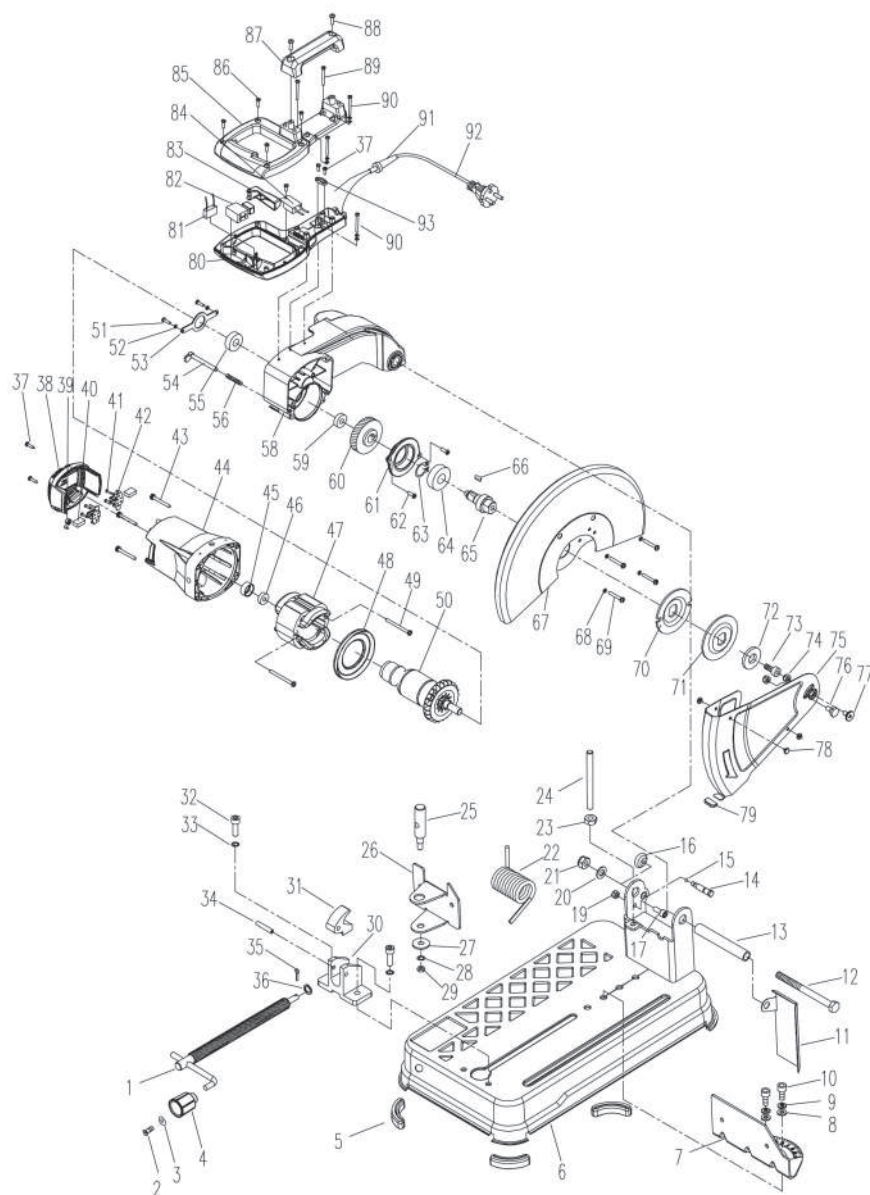
Note: Always make sure the mains supply is of the correct voltage and the correct fuse protection is used. In the event of replacing the fuse always replace the fuse with the same value as the original (where applicable).



Note: If an extension lead is required in order to reach the mains supply; ensure that this too is rated for the correct voltage and fuse rating.



Note: The cross section of the extension lead should be checked so that it is of sufficient size so as to reduce the chances of voltage drops.



GUARANTEE

Guarantee:

This SIP abrasive cut off 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 abrasive cut off 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.

Failure to regularly clean your abrasive cut off saw will shorten its working life and reduce performance. The warranty does not cover consumable items such as motor brushes and abrasive discs etc.



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

CONTENTS AND ACCESSORIES



Abrasive Cut Off Saw



Manual



Hex. key



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

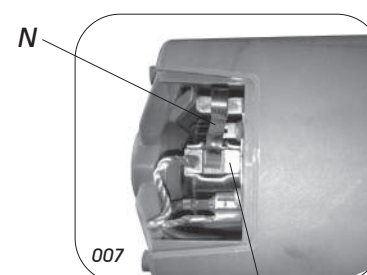
MAINTENANCE....cont

REPLACING THE BRUSHES

- Remove the rear motor cover by loosening and removing the 2 screws (M) (Photo 006).
- Pull up the brush spring (N) and pull the old brush out (O) (Photo 007).
- Pull the brush wire off the connection (P) (Photo 008).
- Fit the new brush in reverse order.
- Repeat for the other side.



M



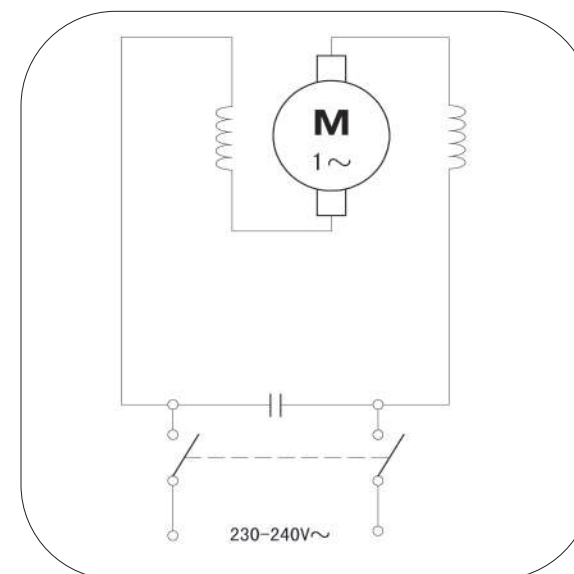
N

O



P

WIRING DIAGRAM



MAINTENANCE



Note: Disconnect the abrasive cut off saw from the mains supply before changing accessories, servicing or performing maintenance. Replace or repair damaged parts. Use genuine parts only. Non-authorised parts may be dangerous and will invalidate the warranty.

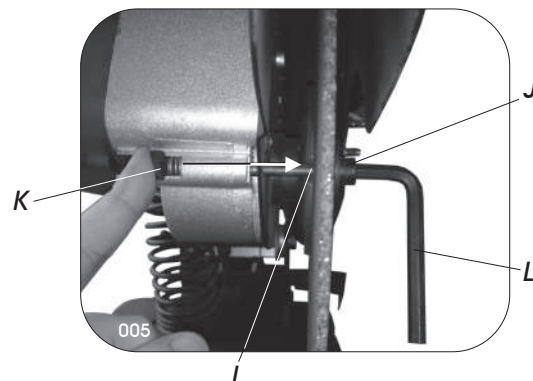
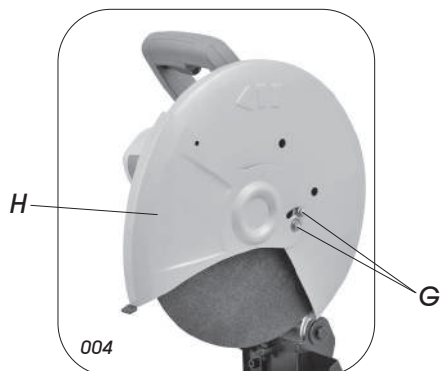
- **DO NOT** use the abrasive cut off saw if it is, or has parts that are worn, damaged or missing; remove from service and have the parts repaired / replaced using original spare parts.
- Clean the abrasive cut off saw after each use.
- Check the disc and guards for wear or damage before each use.
- The abrasive cut off saw should be stored in a clean and dry environment.

CHANGING THE DISC



Note: The abrasive disc must be rated above 3800rpm and be within the expiry date, any disc rated below this or expired could shatter and possibly cause injury to the operator or people nearby.

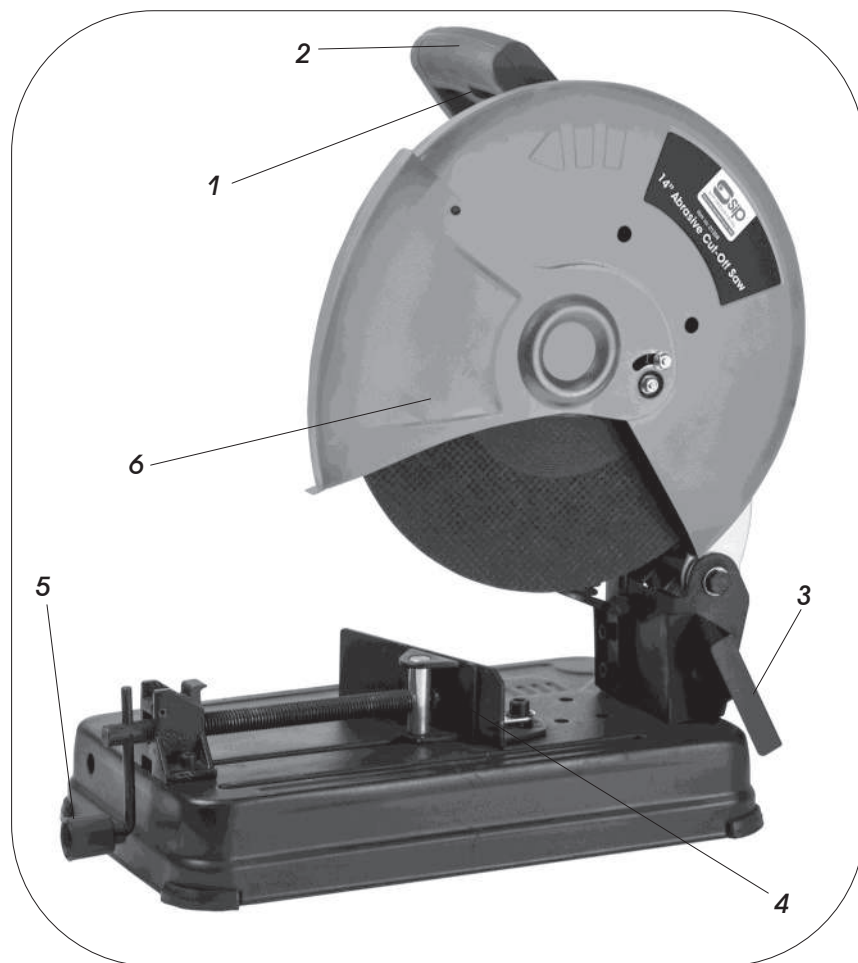
- Remove the 2 nuts (G) and remove the moving disc guard (H) (Photo 004).
- Rotate the disc until you find the inner flange cut out (I) (Photo 005).
- Place a hex. key (L) on to the disc bolt (J) (Photo 005).
- Push the disc lock pin (K) inwards so it sits inside the inner flange cut out (this will hold the abrasive disc so it won't be able to move whilst you undo the disc bolt) (Photo 005).
- Whilst the disc lock pin is still pushed inwards, turn the hex. key (L) anti-clockwise to undo the disc bolt (Photo 005).
- Remove the disc bolt, washer, outer flange and abrasive disc, place the new disc over the shaft and follow these steps in reverse to fit and secure the new disc.



TECHNICAL SPECIFICATION

SIP Part No.	01308	01315
Input Voltage	230V	110V
No Load Speed	3600 rpm	3400 rpm
Input Power	2400W	2000W
Disc Size	355mm	355mm
Bore Size	25.4mm	25.4mm
Round Tube @ 0°	130mm	130mm
Round Tube @ 45°	110mm	110mm
Square Box Section @ 0°	120mm x 120mm	120mm x 120mm
Square Box Section @ 45°	90mm x 90mm	90mm x 90mm
Rectangular Box Section @ 0°	180mm x 85mm	180mm x 85mm
Rectangular Box Section @ 45°	100mm x 80mm	100mm x 80mm
Angle Iron @ 0°	140mm x 140mm	140mm x 140mm
Angle Iron @ 45°	90mm x 90mm	90mm x 90mm

GETTING TO KNOW YOUR ABRASIVE CUT OFF SAW



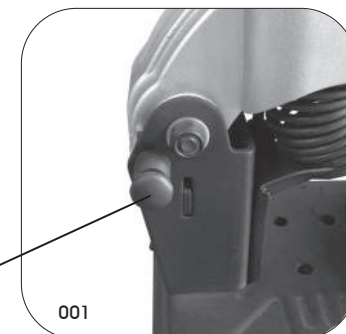
Ref. No.	Description
1.	Trigger switch
2.	Handle
3.	Spark deflector
4.	Vice
5.	Vice handle knob
6.	Moving guard

OPERATING INSTRUCTIONS

TO RAISE THE HEAD

To raise the head prior to cutting, push the head down and pull out the head lock pin (Photo 001) and the head will raise.

Head lock pin



MAKING A CUT



Danger / Caution: The abrasive disc bolt must be tight at all times, check before each use and at regular intervals during operation.

The vice jaw can be set in 3 different positions depending on the size of material to be cut, the vice can be adjusted to 45° left or right; To set the vice jaw follow the steps below.

- Remove the 2 bolts (A), if required (Photo 002).
- Move the vice jaw (B) over hole (C or D), depending on what size material is too be cut.
- Refit the 2 bolts but do not tighten yet.
- Move the vice jaw to the angle to be cut between 0° & 45° left or right.
- Retighten both bolts.
- Place the material against the vice jaw (B), lift the clamp nut (E) (Photo 003) and push the vice handle knob (F) up against the material, push the clamp nut (E) down and tighten using the Vice handle knob (F).
- Plug the machine in to the mains supply and switch on.
- Depress the trigger switch on the handle to start the machine, once the cut is made let go of the trigger switch and the machine will stop.

