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| Abrassive cut off saw (chop saw) | 2 |
| Metals |

**Estimated time**: 50 Min

Equipment

* Milwaukee 14” Chop Saw

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**Procedure**

**Removing and Installing Cut-Off Wheels**

Use only *MILWAUKEE* 14" Abrasive Cut-Off Wheels, 3/32” thick with this tool. Before operating the tool, make sure the wheel is in good condition as described in the “Specific Safety Rules”.

To change wheels:

1. Unplug the tool.

2. Raise the head.

3. Push up the lower guard to expose the hex bolt. Press in the spindle lock button and use the wrench provided to loosen the hex bolt (counterclockwise).

4. Remove the hex bolt, washer, outer flange and cut-off wheel. Do not remove the inner flange.

5. Check the inner and outer flanges to be sure they are in good condition. Remove any nicks, burrs, and debris from the mounting hardware, which could cause uneven cutting pressure and result in wheel damage.

6. Install the cut-off wheel, outer flange, washer, and hex bolt onto the spindle, as shown.



7. Press in the spindle lock button while using the wrench provided to tighten the hex bolt (clockwise).

8. Release the lower guard.

9. Before starting a cut, step back from the tool and make a trial run to confirm that the wheel is in good condition. Before using a new cut-off wheel, run the tool for at least 3 minutes. Before starting work, run the tool for at least 1 minute.

**Adjusting the Depth of Cut**

The depth adjustment bolt can be adjusted to change the depth of cut. When adjusted properly, the depth adjustment bolt prevents the cut-off wheel from contacting the surface under the base during cutting. Cut-off wheels wear down as they are used and the depth of cut may need to be increased.

To adjust the depth of cut:

1. Unplug the tool.

2. Use the wrench provided to loosen the hex nut.

3. Adjust the depth adjustment bolt to the desired height.

4. Tighten the hex nut.

**Vise and Fence System**

The adjustable vise and fence system holds the workpiece in the desired position. The vise plate and fence can be moved backward or forward and can be adjusted to any angle between 90° and 45°. When adjusting the system, the vise and fence should be positioned so the centerline of the wheel hub is in line with or behind the centerline of the workpiece, toward the rear of the tool. The workpiece should be resting flush with the base of the cut-off machine.

To **adjust the fence:**

1. Use the wrench provided to loosen (counterclockwise) the two fence bolts.

2. Adjust the position and angle of the fence as desired.

3. Securely tighten (clockwise) the two fence bolts.

To **adjust the vise**:

1. Pull the lock lever back.

2. Pull the vise handle out.

3. Place the workpiece fl at on the base and against the fence.

4. Push down the lock lever.

5. Slide in the vise handle to press the vise plate against the workpiece.

6. Turn the vise handle clockwise to tighten the vise plate against the workpiece.

**Starting and Stopping the Tool**

1. Plug in the tool.

2. To **start** the tool, pull the trigger.

3. To **stop** the tool, release the trigger

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**Making a Cut**

1. Unplug the tool.

2. Select a cutting angle and position the fence and vise to support the workpiece (see “Supporting the Workpiece and Adjusting the Vise and Fence System”).

3. Plug in the tool.

4. Before starting a cut, step back from the tool and make a trial run to confi rm that the wheel is in good condition. Before using a new cut-off wheel, run the tool for at least 3 minutes. Before starting work, run the tool for at least 1 minute.

5. Allow the motor to reach full speed. Slowly lower the wheel into the workpiece.

**NOTE:** Always start the cut gently; do not bang or bump a wheel when starting the cut. For the safest and most efficient cutting, make sure that the cut-off wheel contacts the center of the workpiece.

6. When the cut is complete, raise the wheel completely from the workpiece before releasing the trigger and allowing the motor to stop.

**Trigger Hole Lock-Off**

The trigger hole allows the user to insert a padlock. This prevents the tool from being started unintentionally

**Wheel Instructions**

**•** Use only the edge (not the sides) of the wheel for cutting. Do not allow the wheel to twist or bind.

**•** Keep hands and body away from the rotating wheel. Do not wear loose clothing when using this tool.

**•** Store cut-off wheels with care. Do not drop them or subject them to excessive heat, cold or humidity.

**•** Make sure that all wheel flanges and other mounting hardware are in good condition and are always used properly. Defective or missing parts may cause damage to the wheel. Always use mounting flanges supplied with the tool.

**•** Cutting with a damaged wheel is very hazardous. After installing a new wheel, leave the tool unplugged and rotate the wheel by hand to see if it is uneven, warped, or cracked. If so, discard the wheel and replace it with a new one. Do not use a wheel that has been dropped; impact may result in breakage.

**•** Before starting a cut, step back from the tool and make a trial run to confirm that the wheel is in good condition. Trial run periods are: When replacing a cut-off wheel — over 3 minutes. When starting routine work — over 1 minute.

**•** Never try to remove or clamp the workpiece to the tool while the cut-off wheel is rotating.

**•** Before installing a cut-off wheel, always inspect it for cracks. Visually check resinous and rubber bonded wheels for cracks. Replace cracked wheel immediately.

**•** Always check maximum operating speed established for wheel against machine speed. Do not exceed the maximum operating speed that is marked on the wheel.

**•** Do not force a wheel onto the machine or alter the size of the arbor hole. Don’t use a wheel that fits the arbor too loosely. If the wheel doesn’t fit the machine, get one that does.

**•** Do not attempt to install saw blades on this tool because it is not designed for this type of blade.

**•** Do not overtighten wheel nut.

**Machine Instructions**

**•** Start cutting only after the motor has reached full speed.

**•** Release switch immediately if the cut-off wheel stops rotating or if the motor sounds like it is straining.

**•** Keep flammable and fragile objects away from this tool. Do not allow cut-off sparks to contact the operator’s hands, face or feet.

**•** Place the tool securely on a flat, level surface.

**•** Always use the tool with the proper voltage specified on the tool’s nameplate.

**•** Never touch a short cut-off piece until it cools.

**•** Never attempt to cut material larger than the rated capacity listed in “Specifications”.

**•** Never stand in line with the wheel while cutting. Always stand to the side.

**•** Always keep guards in place.

**•** Always start the cut gently. Do not bump or bang a wheel to start a cut.

**•** Never make any freehand cuts. Always place the workpiece between the vise and fence when making cuts.