

# Scotchman<sup>®</sup>

## Metal Fabricating Solutions

**IMPORTANT: Read Before Operating Your Cold Saw**



### **Faster is not always better**

Cold sawing is similar to a milling process. In many cases using the slower speed of the saw will produce the best results in the quality of the cut and the life of the blade, especially in heavier materials.

### **Bigger is not always better**

The smaller the diameter of the blade, the slower the surface feet per minute. Also, the smaller the diameter, the more rigid the blade -- plus, smaller diameter blades are less expensive to purchase and re-sharpen!

### **Use the right blade for the job**

There is not a universal blade for a circular cold saw that will cut through everything. Different types of material require different saw blades. Each machine is shipped with a Pitch Calculator that can be used to determine the proper blade for your needs.

### **Correctly install the blade**

When installing a new saw blade, remove the backlash by drawing the blade up against the drive pins before locking it securely in place. It is important to make sure your blade flange and spindle are clean and free of nicks.

### **Properly clamp material**

Any slippage of material within the saw vise will result in, at minimum, a damaged blade. Make sure the material is properly seated and secure in the vise; and that long pieces are properly supported.

### **Break in new blades**

New cold saw blades, like any other saw blade, come with an extremely sharp edge. To extend the life of your blade's hard sharp edge, new blades must be fed very slowly through the first 3-4 cuts.

### ***Read the Operators Manual!***

It's impossible to cover everything you need know about these machines on one page. That's why we created an operator's manual. Please make sure all operators of this machine have read the manual prior to operation. The operator's manual lays out important machine safety tips and maintenance information, in addition to a more detailed version of these cold sawing tips.