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INTRODUCTION

- THIS PRODUCT has many features for making the use of this product more pleasant and enjoyable. Safety, performance, and dependability have been given top priority in the design of this product making it easy to maintain and operate.

▲ WARNING: Do not attempt to use this product until you thoroughly read and completely understand the operator's manual. Pay close attention to the safety rules, including Dangers, Warnings, and Cautions. If you use your product properly and only as intended, you will enjoy years of safe, reliable service.

- ▲ !** Look for this symbol to point out important safety precautions. It means attention!!! Your safety is involved.



▲ WARNING: The operation of any tool can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Before beginning operation, always wear safety goggles or safety glasses with side shields and a full face shield when needed. We recommend Wide Vision Safety Mask for use over eyeglasses or standard safety glasses with side shields. Always wear eye protection which is marked to comply with ANSI Z87.1.

GENERAL SAFETY RULES

▲ WARNING: When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment. Read all instructions before using the tool!

- **Work area conditions.** Cluttered areas invite injuries.
- **Additional work area conditions.** Do not use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted.
- **Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools or extension cords.
- **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
- **Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. There are certain applications for which this tool was designed. It will do the job better and more safely at the rate for which it was intended. Do not modify this tool and do not use this tool for a purpose for which it was not intended.
- **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
- **Use eye protection.** Always wear ANSI approved impact safety glasses underneath a full face shield during use. Also, wear heavy duty work gloves.
- **Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines.
- **Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. The handles must be kept clean, dry, and free from oil and grease at all times.
- **Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before starting work.
- **Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
- **Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Any part that is damaged should be replaced.
- **Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from Cummins Industrial Tools.
- **Do not operate tools if under the influence of alcohol or drugs.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

▲ WARNING: The warnings, cautions, and instructions discussed in this instruction 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 can not be built into this product, but must be supplied by the operator.

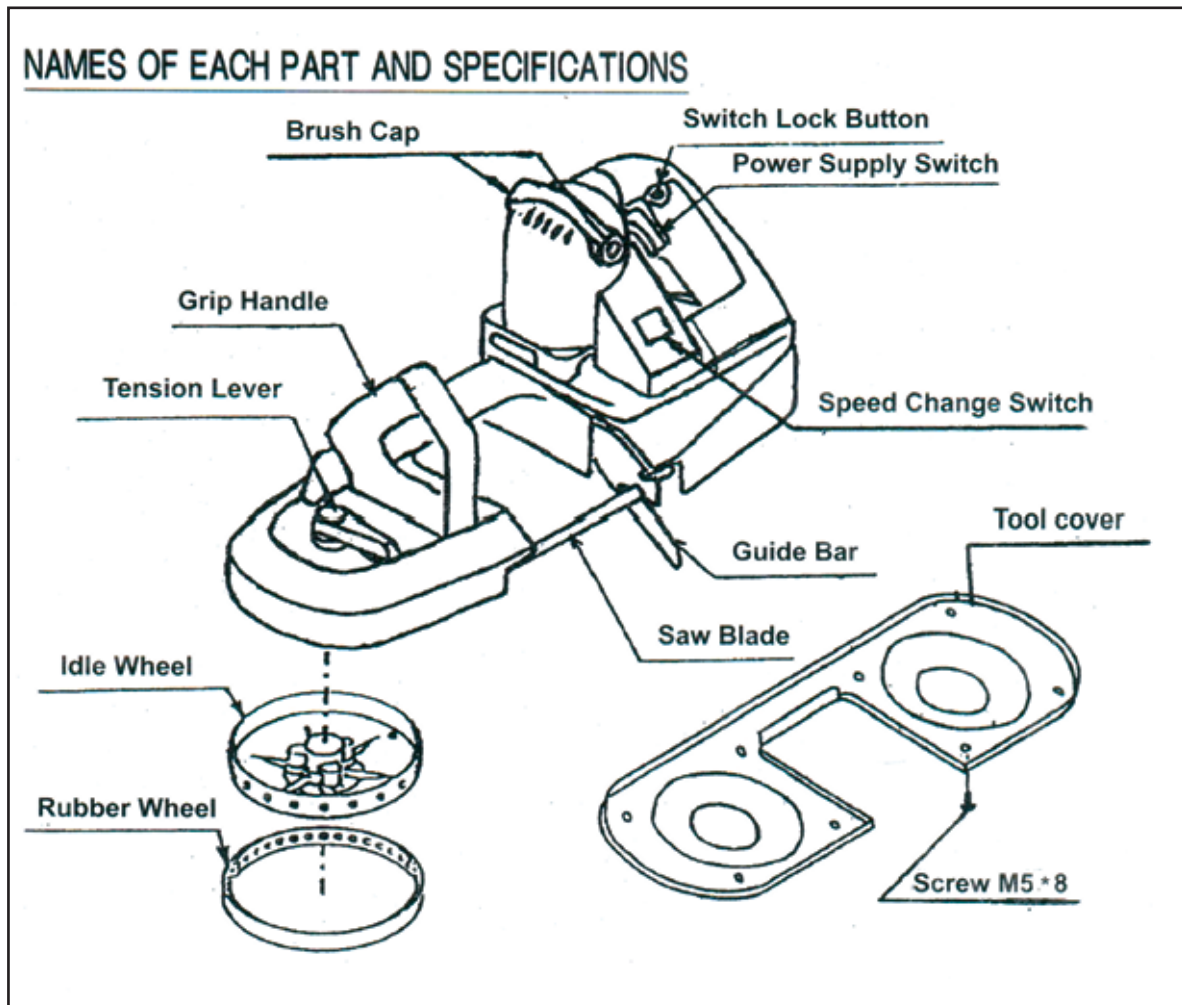
SPECIFIC SAFETY RULES

- Prevent body contact with grounded surfaces such as pipes or radiators.
- Be sure the switch is OFF before plugging in.
- Do not use the tool if any switch does not turn off and on properly.
- Always unplug the cord by the plug. Never yank the cord out of the wall.
- Always turn off the machine before unplugging.
- Make sure the tool has been cleaned and properly lubricated.
- With normal use, the motor housing may get hot.
- Make all adjustments to the machine with the power OFF.
- Never leave the band saw unattended while it is running..
- When turning off the machine, never leave the band saw until it has come to a complete stop.
- Make every effort to prevent snagging by exercising special care when working corners, sharp edges, ragged welds, etc.
- Never carry the tool by the cord.
- Do not pour water or coolant on blade when cutting.
- Make sure to secure cutting material so it does not move during operation.
- Cutting material can get extremely hot during operation.
- When cutting metals, be cautious of hot flying chips.
- Cutting workpiece covered with oil can cause the blade to come off unexpectedly. Wipe off all excess oil from workpiece before cutting.
- Do not use a blade that is not in accordance with specified sizes.
- Select blade according to cutting material:
 - For soft material (aluminum, lead, rubber-like material) – 14-teeth blade.
 - For hard material (cast iron, soft steel, hard steel) – 24-teeth blade.
 - For either soft or hard material – 18-teeth blade.
- Select blade according to diameter of work piece:
 - For thick material – 14-teeth blade.
 - For thin material – 24-teeth blade.
 - For either thick or thin material – 18-teeth blade.

Blade Tooth and Blade Speed Chart

MATERIAL		Steel Pipe		Conduit		Steel (Rod, Shaped Steel)					Stainless Steel Pipe			Aluminum/ Brass			
		0 to .5	2 to 3	Thick	Thin	0 to 3	3.1 to 6	6.1 to 7.9	8 to 9.9	10	0 to 1.2	1.3 to 4.0	4.1	0 to 5	5.1 to 7.9	8 to 9.9	10
Material Thickness (mm) >	Blade Type TPI																
Alloy	24																
Alloy	18																
Alloy	14																
Alloy	10																
Alloy	8																
Alloy	6																
High Speed	18																
High Speed	14																
High Speed	10																
High Speed	8																

PRODUCT SPECIFICATIONS



Technical Data

Voltage (by area)*	120 V/60 Hz	
Power Input	750 W (High)	420 W (Low)
Blade Speed	80 m/min (262 fpm) (High)	58 m/min (190 fpm) (Low)
Max. Cutting Capacity	Round Pipe $\varnothing 4\text{-}3/4\text{'}$ ($\varnothing 120\text{ mm}$) Round Bar $\varnothing 1\text{'}$ ($\varnothing 25\text{ mm}$) Square Pipe $4\text{-}3/4\text{'}$ x $4\text{-}1/2\text{'}$	
Saw Blade Size	45" in. (length) x 0.5 in. (width) x 0.024 in. (thickness)	

UNPACKING

INSTRUCTIONS

When unpacking the tool:

- Carefully remove the tool and accessories from the box.
- Make sure that all items listed in the packing list are included.
- Inspect the tool carefully to make sure no breakage or damage occurred during shipping.
- Do not discard the packing material until you have carefully inspected and satisfactorily operated the tool.

⚠ WARNING: If any part are missing do not operate the tool until the missing parts are replaced. Failure to do so could result in possible serious personal injury.

PACKING LIST

Standard Accessory

- Carbon Steel Blade (1 piece)

Optional Accessories

- Bi-metal Blade
- Carrying Case

OPERATION

How To Cut (See Figures A and B)

- Apply saw blade to workpiece at a right angle.
- Apply guide bar (#58) to workpiece before switching on.
- When start cutting, tilt the unit so the blade is vertical.
- When the switch (#76) is turned on, the blade will begin to turn counterclockwise and cutting begins.
- While cutting, it is not necessary to force the cut or lean on the band saw. Cut the material with the weight of the unit only (forcing the tool or twisting the blade during cutting could result in damage to the blade or the tool).
- When the cutting operation is close to ending, finish the cutting by slightly raising the unit.

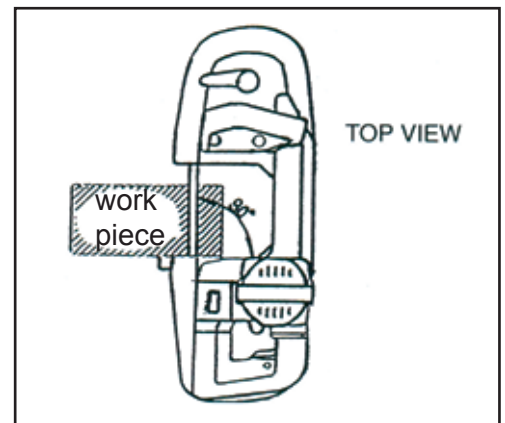


Figure A

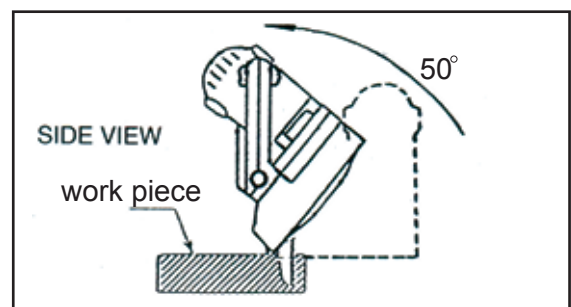


Figure B

OPERATION

Switch Operation (See Figures C)

- Before plugging the tool in, press the lock button and turn the trigger to the “ON” position to confirm that the switch returns to its original position when released.
- When the trigger is pulled, the switch is on. When the trigger is released, the switch is off.
- To start the machine running, press the lock button and pull the trigger. The machine will stop working when both of them are released.

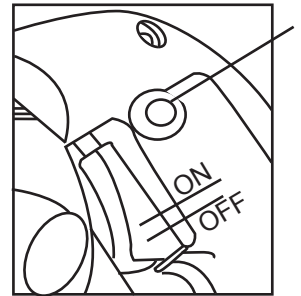


Figure C

Speed Change Switch

⚠ CAUTION: NEVER switch speeds when motor is turning.

- For high speed revolution (wood, resin, non-ferrous materials): push switch to “Hi” side.
- For low speed revolution (soft steel, hard steel, stainless steel): push switch to “Lo” side.

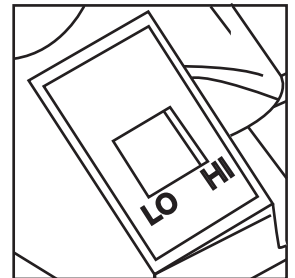


Figure D

MAINTENANCE

Change Saw Blade

▲ CAUTION: Before removing or installing a blade, switch off and unplug the tool.

To Install the Blade

- Wipe off any oil and debris on saw blade with a clean cloth.
- Turn tension handle (#9) to “loose” position.
- Turn over the unit and install the blade from the “1” position shown in Figure E.
- Insert the blade into one blade guide over one end of the frame.
- Insert the blade into the other blade guide until it reaches the bearing that supports the back of the blade.
- While holding the blade so that it does not fall off the guides put the blades on as shown in 2 + 3 in Figure E.
- Turn tension lever completely to “TIGHT” position until the blade is taut.
- Plug the tool back in. Clear fingers from blade and run the machine for a few seconds to ensure that the blade steadily runs around the wheels. Eye protection should be worn at all times.

To Remove the Blade

- Wipe off any oil and debris on saw blade with a clean cloth.
- Turn tension handle (#9) to “loose” position.
- Turn over the unit and remove the blade from the position shown in Figure E.
- Remove the blade by completing steps 4-7 above in reverse order.

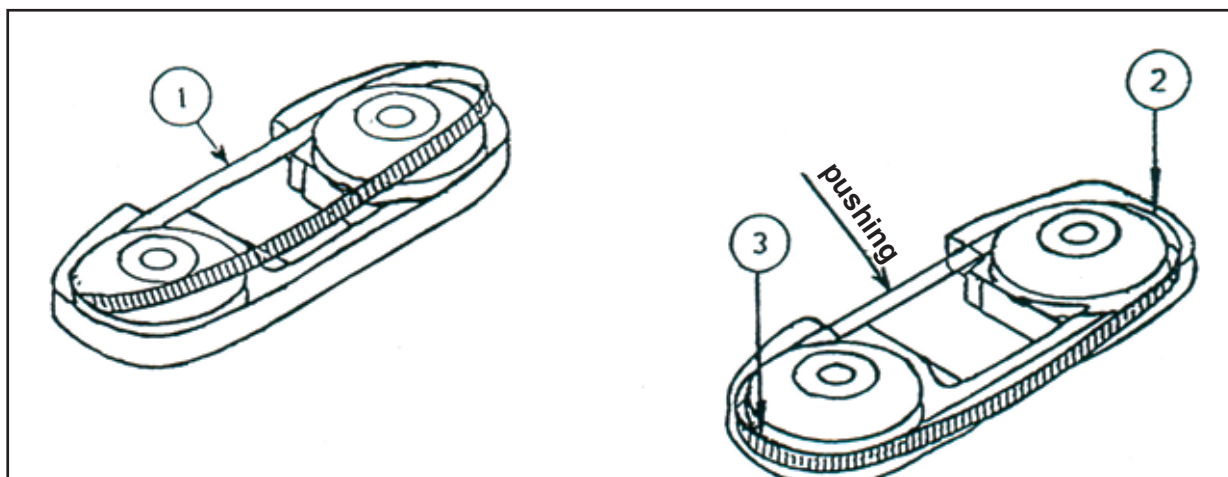


Figure E

Cleaning

- Regularly clean the work surface with dry brush or clean cloth. Wipe any oil or debris off saw blade. Always keep the motor area clean of debris.

MAINTENANCE

Motor Lubrication

- No lubrication is required. All of the bearings in this tool are lubricated with a sufficient amount of high grade lubricant for the life of the machine under normal operating conditions.

Power Cord

- Inspect the power cord periodically and, if damaged, have it repaired by an authorized technician.

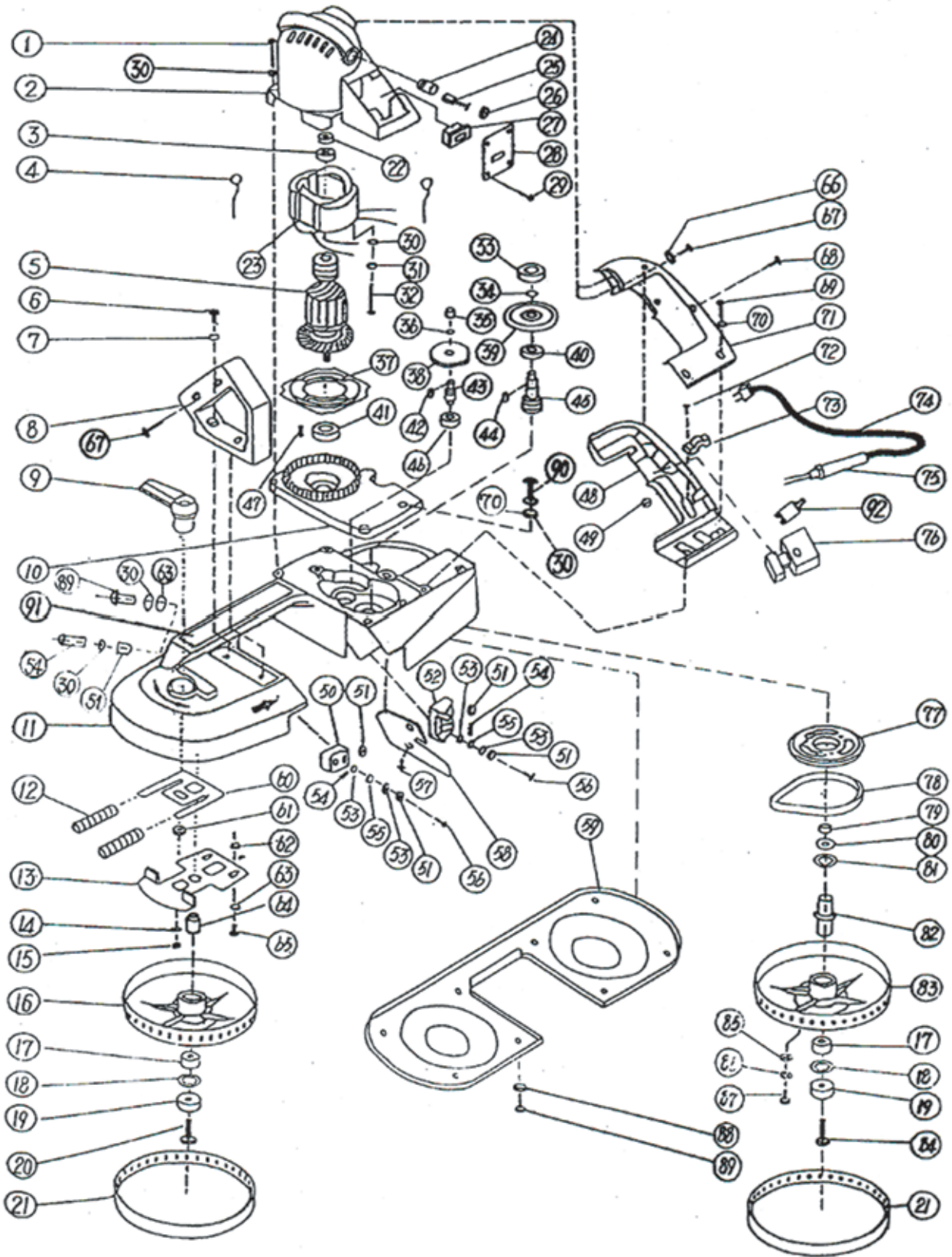
Replacement Parts

- Replace saw blades at the first sign of slippage or dulling. When servicing, use only identical replacement parts. Use of any other parts will void the warranty.

Storage

- When the tool is out of use for a long period of time, remove the saw blade.

EXPLODED DIAGRAM



PARTS LIST

No.	Description	Qty.	No.	Description	Qty.
1	PAN HEAD SCREW M5-40	4	47	RUBBER PIN	2
2	MOTOR HOUSING	1	48	HANDLE	1
3	BALL BEARING 80018	1	49	NUT M5	2
4	CONNECTING RING	2	50	REAR BLADE GUIDE	1
5	ARMATURE	1	51	BALL BEARING 80025	7
6	PAN HEAD SCREW M8-16	2	52	FRONT BLADE GUIDE	1
7	PLAIN WASHER 8	2	53	PLAIN WASHER 5	8
8	GRIP HANDLE	1	54	PIN 5-16	3
9	TENSION HANDLE	1	55	GUIDE ROLLER	4
10	FRONT BRACKET	1	56	HEX. HEAD SCREW M5-45	4
11	FRAME	1	57	HEX. HEAD SCREW M5-10	2
12	TENSION SPRING	2	58	GUIDE BAR	1
13	SPRING FITTING PLATE	1	59	TOOL COVER	1
14	PLAIN WASHER 6	1	60	YOKE	1
15	NUT M5	1	61	COLLAR	1
16	IDLE WHEEL	1	62	WASHER	3
17	SLEEVE BEARING	2	63	PLAIN WASHER 6	3
18	PLAIN WASHER 8	2	64	FIXING SHAFT	1
19	WASHER FOR WHEEL	2	65	SINKING HEAD SCREW	3
20	HEX. HEAD SCREW 6	1	66	PLAIN WASHER 5	4
21	RUBBER WHEEL	2	67	TAPPING SCREW ST4.8-19	4
22	BEARING WASHER	1	68	PAN HEAD SCREW M5-25	2
23	FIELD ASSEMBLY	1	69	PAN HEAD SCREW M5-25	2
24	BRUSH HOLDER	2	70	SPRING LOCK WASHER 5	2
25	CARBON BRUSH	2	71	HANDLE COVER	1
26	BRUSH CAP	2	72	PAN HEAD SCREW M4-10	2
27	SPEED CHANGE SWITCH	1	73	FIXING PLATE	1
28	SWITCH RETAINER	1	74	CORD AND PLUG	1
29	TAPPING SCREW ST2.9-9.5	4	75	CORD GUARD	1
30	PLAIN WASHER 5	8	76	POWER SUPPLY SWITCH	1
31	SPRING LOCK WASHER 5	2	77	SPROCKET WHEEL	1
32	PAN HEAD SCREW M5-45	2	78	CHAIN	1
33	BALL BEARING 80200	1	79	NUT M8	1
34	STOPPER RING 6	1	80	PLAIN WASHER 8	1
35	NEEDLE BEARING	1	81	PLAIN WASHER 10	1
36	STOPPER RING 6	1	82	DRIVING WHEEL SHAFT	1
37	BAFFLE	1	83	DRIVING WHEEL	1
38	1 ST STAGE GEAR	1	84	HEX. HEAD SCREW M8-65	1
39	2 ND STAGE GEAR	1	85	PLAIN WASHER 6	3
40	BALL BEARING 80201	1	86	SPRING LOCK WASHER 6	3
41	BALL BEARING 80200	1	87	HEX. HEAD SCREW M6-30	3
42	WOODRUFF KEY 2.5-10	1	88	PLAIN WASHER 5	8
43	2 ND STAGE PINION	1	89	PAN HEAD SCREW M5-8	8
44	WOODRUFF KEY 2.5-10	1	90	PAN HEAD SCREW M5-16	2
45	SPROCKET (SMALL)	1	91	NAME PLATE	1
46	BALL BEARING 80018	1	92	CONNECTING SHEET 6.3	5