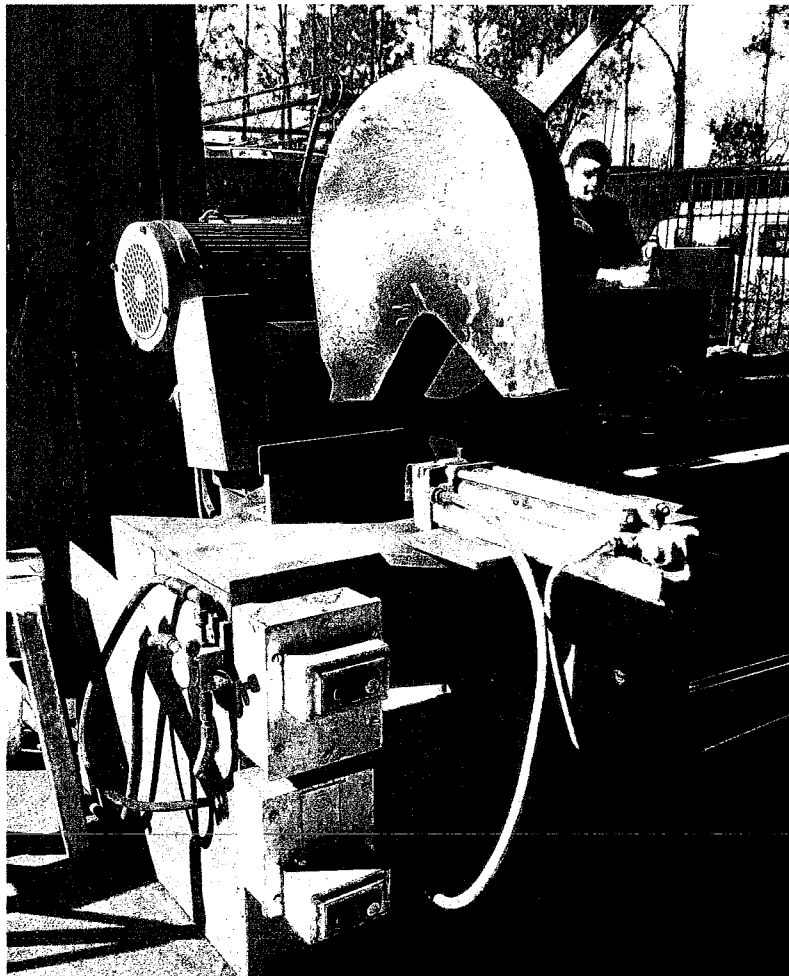


Choppalator 1000

Model 24RP

26" Dry Radial Metal Cutting Saw
with Pneumatic Vice

OPERATOR'S MANUAL



Model 26RP 230V
Serial # C100024RP0001

26" Dry Radial Metal Cutting Saw with Pneumatic Vise

TABLE OF CONTENTENCE

General Safety Rules and Specific Instructions...	2-3
Specific Rules and Symbols.....	4-6
Functional Drawing.....	7
Operation.....	8-9

HAWTHORNE MACHINERY CO. RESERVES THE RIGHT TO MAKE
IMPROVEMENTS AND CHANGES WITHOUT PRIOR NOTICE.

HAWHTORNE MACINERY CO.
16945 CAMINO SAN BERNARDO, SAN DIEGO, CA 92127

GENERAL SAFETY RULES

WARNING! Read and Understand all Instructions.

Failure to follow all instructions listed below, may result in electric shock, fire and/or serious personal injury.

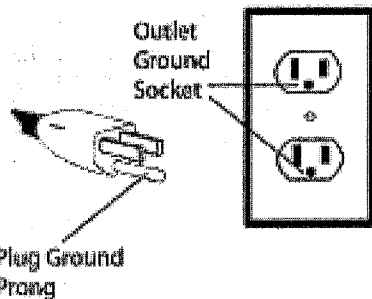
SAVE THESE INSTRUCTIONS

Work Area

- Keep Your Work Area Clean and Well Lit.
- Cluttered benches and dark areas invite accidents.
- Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust. Power tools create sparks which may ignite the dust or fumes.
- Keep bystanders, children, and visitors away while operating a power tool. Distractions can cause you to lose control.

Electrical Safety

- Grounded tools must be plugged into an outlet properly installed and grounded in accordance with all codes and ordinances. Never remove the grounding prong or modify the plug in any way. Do not use any adapter plugs. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. If the tools should electrically malfunction or break down, grounding provides a low resistance path to carry electricity away from the user.
- Avoid body contact with grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is grounded.
- Don't expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.



- Do not abuse the cord. Never use the cord to carry the tools or pull the plug from an outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords increase the risk of electric shock.

- When operating a power tool outside, use an outdoor extension cord marked "W-A" or "W." These cords are rated for outdoor use and reduce the risk of electric shock.

(Note) When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

GENERAL SAFETY RULES (continued)

Personal Safety

- Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.
- Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts.
- Avoid accidental starting. Be sure switch is off before plugging in. Carrying tools with your finger on the switch or plugging in tools that have the switch on invites accidents.
- Remove adjusting keys or switches before turning the tool on or plugging it in. A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.
- Do not overreach. Keep proper footing and balance at all times. Proper footing and balance enables better control of the tool in unexpected situations.
- Use safety equipment. Always wear eye protection. Always wear hearing protection. Dust mask, non-skid safety shoes, hard hat, or hearing protection must be used for appropriate conditions.

Tool Use and Care

- Use machine vise to secure and support the workpiece. Drop piece or long material profiles must be supported. Holding the work by hand is unstable and may lead to loss of control. Always use machine vise.
- Do not force tool. Use the correct tool for your application. The correct tool will do the job better and safer at the rate for which it is designed.
- Do not use tool if switch does not turn it on or off. Any tool that cannot be controlled with the switch is dangerous and must be repaired.
- Disconnect the plug from the power source before making any adjustments, changing accessories, or storing the tool. Such preventive safety measures reduce the risk of starting the tool accidentally.
- Store idle tools out of reach of children and other untrained persons. Tools are dangerous in the hands of untrained users.
- Maintain tools with care. Keep cutting tools sharp and clean. Properly maintained tools, with sharp cutting edges are less likely to bind and are easier to control.
- Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tools operation. If damaged, have the tool serviced before using. Many accidents are caused by poorly maintained tools.
- Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one tool, may become hazardous when used on another tool.

SERVICE

- Tool service must be performed only by qualified repair personnel. Service or maintenance performed by unqualified personnel could result in a risk of injury.
- When servicing a tool, use only identical replacement parts. Follow instructions in the Maintenance section of this manual. Use of unauthorized parts or failure to follow Maintenance Instructions may create a risk of electric shock or injury.

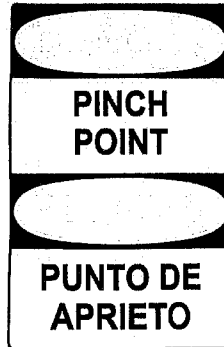
SPECIFIC SAFETY RULES AND SYMBOLS



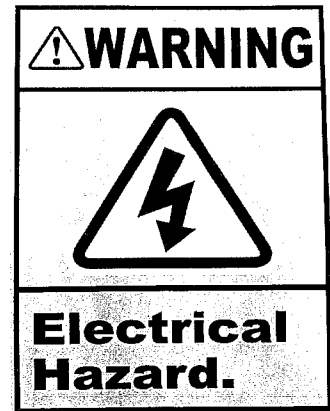
DO NOT OPERATE MACHINE IF WARNING AND/OR INSTRUCTION LABELS ARE MISSING OR DAMAGED.

NOTICE
PROPER PPE
REQUIRED

AVISO
SE REQUIRE PPE
APROPRIADO



CAUTION
KEEP HANDS
CLEAR



LEQM780VSP

SAFELY MADE IN THE USA*

- Keep saw blades securely fastened. Check blade flanges for debris before installing any new blade.
- Do not use dull or broken blades. Check blades often for condition and wear.
- Check blade cover for proper fit to minimize the risk of flying debris.
- Beware of ejecting chips. They become HOT both during and after cutting.
- Always make provisions for safe handling of excess material.
- Keep saw base free from dirt and other debris.
- Beware of ejecting drop piece. Thinner slices pose a significant ejection hazard.

SPECIFIC SAFETY RULES (continued)

- **DANGER!** — Keep hands and body away from and to the side of the blade. Contact with blade will result in serious injury.

- **WARNING!** — To reduce the risk of injury, check lower guard. It must close instantly! Keep free hand away from blade at all times during operation. Support and clamp work. Wear eye and hearing protection.

Additional Specific Safety Rules:

DANGER! Keep hands away from cutting area and blade. Keep your second hand on auxiliary handle, or motor housing. If both hands are holding the saw, they cannot be cut by the blade.

·Keep your body positioned to either side of the saw blade, but not in line with the saw blade. KICKBACK could cause the material to jump backwards. (See "Causes and Operator Prevention of Kickback.")

·Do not reach underneath the work. The guard can not protect you from the blade below the work.

·Check lower guard for proper closing before each use. Do not operate saw if lower guard does not move freely and close instantly. Never clamp or tie the lower guard into the open position. If saw is accidentally dropped, lower guard may be bent. Raise the lower guard and make sure it moves freely and does not touch the blade or any other part, at all angles and depths of cut.

·Check the operation and condition of the lower guard spring. If the guard and the spring are not operating properly, they must be serviced before use. Lower guard may operate sluggishly due to damaged parts, gummy deposits, or a buildup of debris.

·An unprotected, coasting blade will cause the saw to cut whatever is in its path. Be aware of the time it takes for the blade to stop after switch is released.

·NEVER hold piece being cut in your hands. It is important to support the work properly to minimize body exposure, blade binding, or loss of control.

·Contact with a "live" wire will also make exposed metal parts of the tool "live" and shock the operator.

·Always use blades with correct size and shape arbor holes. Blades that do not match the mounting hardware of the saw will run eccentrically, causing loss of control.

·Never use damaged or incorrect blade washer or bolts. The blade washer and bolt were specially designed for your saw, for optimum performance and safety of operation.

·Always clamp workpiece in vise and check security of vise bolts and position often. Vise can loosen due to vibration.

SPECIFIC SAFETY RULES (continued)

CAUSES AND OPERATOR PREVENTION OF KICKBACK

Kickback is a sudden reaction to a pinched, bound or misaligned saw blade, causing an uncontrolled workpiece to lift up and out of the saw toward the operator. When the blade is pinched or bound tightly by the kerf (saw cut) closing down, the blade stalls and the motor reaction drives the workpiece rapidly backward. If the blade becomes twisted or misaligned in the cut, the teeth at the back edge of the blade can dig into the top surface of the material causing the material to climb out of the blade and jump back toward operator. Kickback is the result of tool misuse and/or incorrect operating procedures or conditions and can be avoided by taking proper precautions as given below:

Maintain a firm grip with both hands on the saw. KICKBACK forces can be controlled by the operator, if proper precautions are taken.

When blade is binding, or when interrupting a cut for any reason, release the trigger and hold the saw motionless in the material until the blade comes to a complete stop. Never attempt to remove the workpiece from the saw or pull the material backward while the blade is in motion or KICKBACK may occur. Investigate and take corrective actions to eliminate the cause of blade binding.

When restarting a saw in the workpiece, center the saw blade in the kerf and check that saw teeth are not engaged into the material. If saw blade is binding, it may walk up or KICKBACK from the workpiece as the saw is restarted.

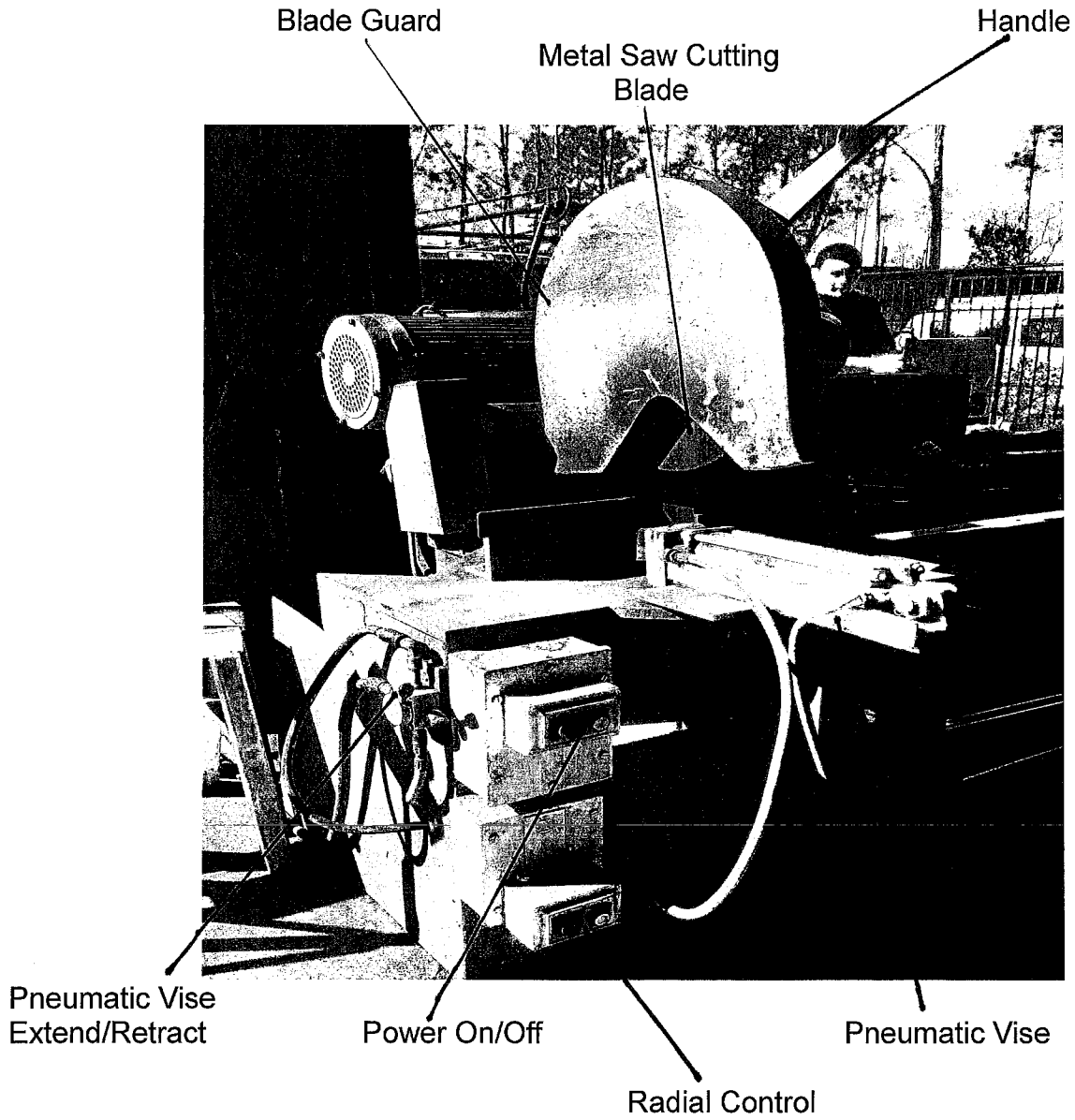
Support large panels to minimize the risk of blade pinching and KICKBACK. Large panels tend to sag under their own weight. Supports must be placed under the panel on both sides, near the line of cut and near the edge of the panel.

Do not use dull or damaged blade. Dull or improperly set blades produce narrow kerf causing excessive friction, blade binding and KICKBACK.

Blade depth and miter adjusting locking levers must be tight and secure before making a cut. If blade adjustment shifts while cutting, it may cause binding and KICKBACK.

FUNCTIONAL DRAWINGS

Caution! Always unplug saw before changing blades, servicing or adjusting saw.



OPERATION

WHAT YOU SHOULD KNOW BEFORE SAWING

WARNING!

NEVER START THE SAW WITH CUTTING EDGE OF SAW BLADE CONTACTING WORK SURFACE.
DO NOT RETRACT BLADE GUARD MANUALLY. GUARD RETRACTS AUTOMATICALLY.

ALWAYS CHECK BLADE DOWN-STOP BOLT AND LOCK NUT FOR CORRECT POSITIONING BEFORE FIRST USE AND AFTER EACH BLADE CHANGE. FAILURE TO DO SO COULD RESULT IN PERSONAL INJURY DUE TO BLADE CONTACT WITH SAW BASE OR CHIP BOX.

1. After installation of saw blade or before first use, adjust down-stop bolt so that blade does not contact chip tray bottom when blade is in the full down position.

WHAT YOU SHOULD KNOW WHILE SAWING

1. Select the correct saw blade appropriate to the material being cut. (mild steel, thin steel, stainless steel or aluminum)
2. The material surface should be clean and level, free from rust, dirt, scale, and other debris.
3. Material may become heat treated if flame cut. Always avoid cutting near these areas whenever possible.
4. Adjust the vise plate to the desired miter angle by loosening the left and right Miter Lever Lock bolts at the left of the vise plate and the right Miter Lock at the right side of vise. Refer to "Exploded View".
5. When cutting smaller profiles, vise plate may be moved forward to aid in cutting quality and to minimize pull-out from the vise. Miter can be set by observing index marks printed on vise bracket.
6. Connect machine to power source.
7. Firmly grasp guide handle and trigger handle switch
8. Position material in the saw vise and align cutting line with blade. Adjust the front and rear vise plates as necessary to firmly hold material in the desired position.
9. When ready, start saw motor by activating trigger switch
10. Slowly approach material edge and gently apply pressure until saw blade has established a cutting groove in the material.
11. Apply smooth, constant pressure without over-loading saw motor.

WARNING!

IF SAW MOTOR SHOULD STALL OR STOP BEFORE A COMPLETE CUT IS MADE ALWAYS REMOVE BLADE FROM MATERIAL BEFORE ATTEMPTING TO RESTART MOTOR. FAILURE TO DO SO COULD RESULT IN PERSONAL INJURY.

AFTER COMPLETING THE CUT

1. After the cut,
2. When saw motor completely stops, clear both drop piece and material from vise.

TROUBLESHOOTING CHECKLIST

s14 14" METAL CUTTER



ALWAYS DISCONNECT THE SAW FROM POWER SOURCE BEFORE TROUBLESHOOTING.

1. Machine will not turn on

- Inspect power cord for damage. Check continuity. Replace if needed.
- Inspect brushes for excessive wear. Replace if needed.
- Do not exceed 30 minutes run time without cool down of saw.
- Check trigger switch for continuity. Replace if needed.

2. Losing Power

- Inspect brushes and replace if needed.
- Extension cord too long. Limit cord length to 50' or less.
- Extension cord too thin. Use 12 AWG or larger.

3. Blade Guard Sticks

- Remove guard and remove any foreign material.
Guard must move freely. Use light grease on mating contact surfaces to aid in movement.
- Check guard return spring for sufficient tension. Replace if spring is weak.
- Check guard for distortion. Replace if distorted or damaged.

4. Blade Spins on Spindle

- Check for proper tightness and installation. Inspect inner blade flange and outer blade flange for wear or damage. Replace if wear is excessive.
- Check flange mating surfaces for flatness. Replace if excessive distortion exists.
- Check to ensure flat washer is present between bolt head and outer blade drive flange.

5. Low Blade Life/Teeth Chipping

- Wrong blade for the type of material.

- Aggressive contact with blade into material. The blade must be allowed to do the work.
- Too much vibration due to insufficient clamping, worn or bent blade, or worn parts (see "Saw Vibrates" below).

6. Saw Vibrates

- Check blade for tightness.
- Inspect inner blade flange and outer blade drive flange or wear or damage. Replace if needed.
- Check to ensure work is properly clamped. Both primary and cut-off piece can cause vibration.
- Check miter lock for tightness.
- Check blade teeth for missing carbide, bends or cracks.