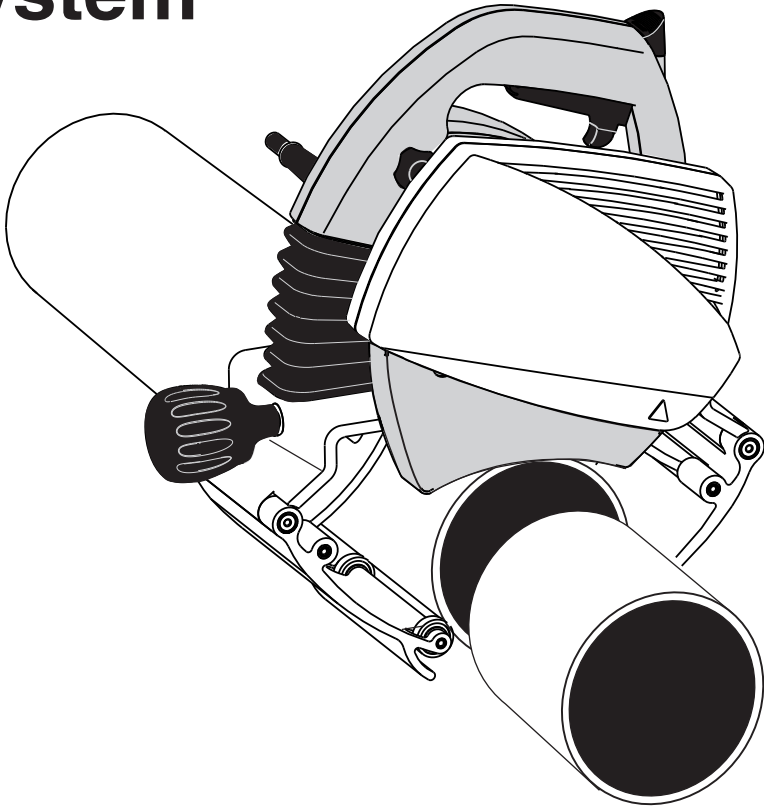


# exact

## PipeCut 200 System



EN

Operating Instructions

5-16

# Exact PipeCut 200 System

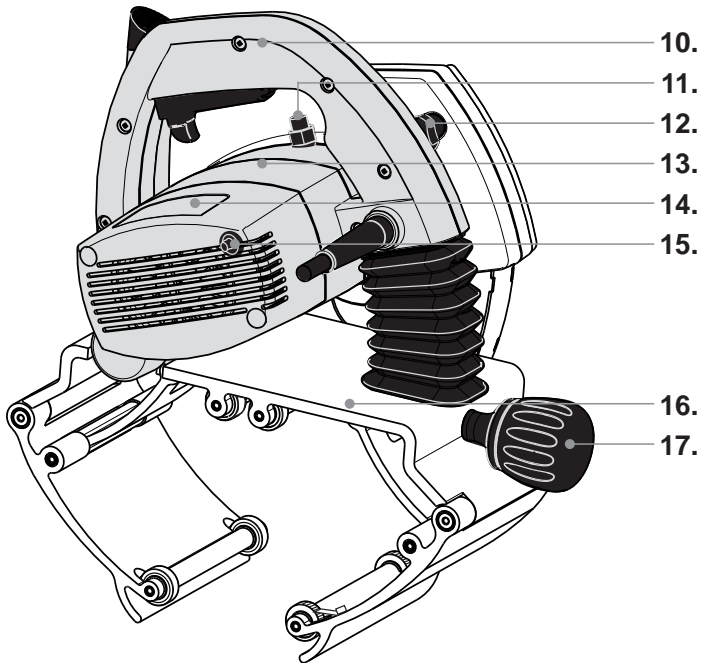
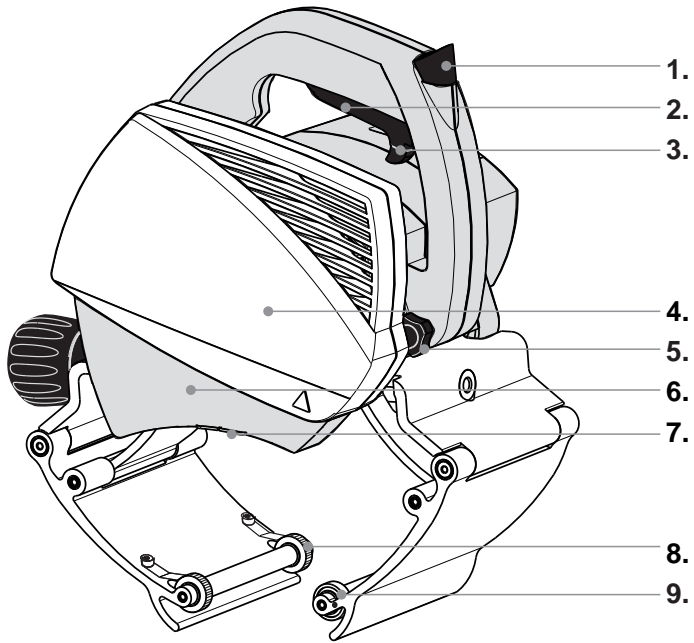
## Blade information for Exact PipeCut saws

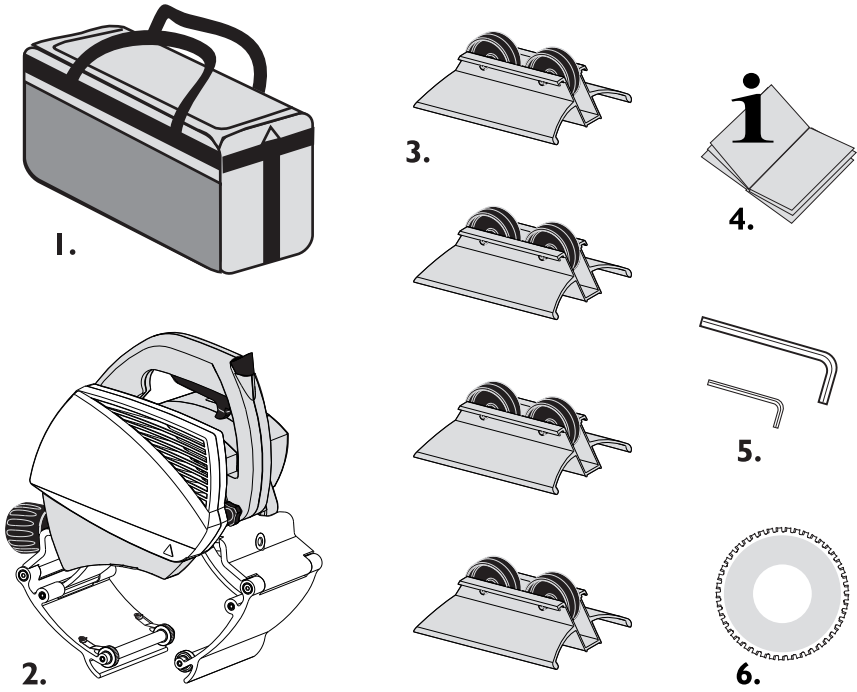
**TCT** (tungsten carbide tip) saw blades are for cutting steel, copper, aluminium and all kind of plastics. TCT blades can be sharpened.

**Cermet** (ceramic alloy tip) saw blades are for cutting stainless steel, acid proof materials, steel, copper, aluminium and all kind of plastics. Cermet blades can be sharpened.

**Diamond** blades are for cutting cast iron only. Diamond blades can not be sharpened.

**A**





**Extension chord sets minimum gauge**  
**Calibre (gauge) minimal pour les cordons de rallonges**  
**Calibre (gauge) mínimo para juegos de cables**

		Total length of chord Longueur totale de la rallonge Longitud total del cable			
		120 V	25 ft 7,6 m	50 ft 15,2 m	100 ft 30,5 m
Ampere rating Courant Amperios	240 V	<b>50 ft</b> 15,2 m	<b>100 ft</b> 30,5 m	<b>200 ft</b> 61,0 m	<b>300 ft</b> 91,4 m
		AWG	AWG	AWG	AWG
0-6	A	18	16	16	14
6-10	A	18	16	14	12
10-12	A	16	16	14	12
12-16	A	14	12	Not recommended Non recommandé No recomendado	

## Contents

- 6. Technical data
- 6. Package contents

### Safety

- 7. Safety instructions

### Operation

- 10. Functional description
- 10. Product features
- 11. Before operating the tool
- 11. Connection to the mains power supply
- 11. Precise setting of the cutting point
- 11. Setting the pipe on supports
- 12. Attaching the pipe saw to the pipe
- 12. Piercing the pipe wall
- 12. Sawing around a pipe
- 13. Overload protection
- 13. Straightness of cut and adjusting wheel

- 14. **Installing and changing the saw blade**

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- 16. **Environment /Disposal**


- 16. **Guarantee/Guarantee conditions**


- 16. **Tips for users**


**Exploded view** (separate attachment)


## Definitions: Safety guidelines

The definitions below describe the level of severity for each signal word. Please read the manual and pay attention to these symbols.

 **DANGER:** Indicates an imminently hazardous situation which, if not avoided, **will** result in **death or serious injury**.

 **WARNING:** Indicates a potentially hazardous situation which, if not avoided, **could** result in **death or serious injury**.

 **CAUTION:** Indicates a potentially hazardous situation which, if not avoided, **may** result in **minor or moderate injury**.

 **NOTICE:** Indicates a practice **not related to personal injury** which, if not avoided, **may** result in **property damage**.

 Denotes risk of electric shock.

**The label on your tool or this manual may include symbols. The symbols and their definitions are listed on page 41.**

## Operating, safety, and servicing instructions

Please read this operating, safety, and servicing instructions carefully before using the pipe saw. Also store this instruction book somewhere accessible to everyone using the pipe saw. In addition to these instructions, always follow the official work, health and safety regulations. The Exact PipeCut 200 is meant for professional use only.

### Technical data

Model	Pipecut 200
Voltage	120 V / 60 Hz
Current	9,2 A
Power	1100 W
No-Load speed	5000 /min
Intermittent operation	2,5 min ON / 7,5 min OFF (S3 25%)
Blade diameter	5.51" (140 mm)
Mounting bore	2,44" (62 mm)
Weight	20 lbs (8,9 kg)
Range of use Ø	0,60"- 8" (15 mm –200 mm)
Max. pipe wall steel	0,31" (8 mm)
Max. pipe wall plastics	0,45" (12 mm)
Protection class	□ / II
Spindle lock	YES
Speed preselection	NO
Constant electronic control	NO
Overload Protection	YES
Reduced starting current	NO

### Exact PipeCut 200 pipecutting system, Package contents:

Please check the package contains the following items (page 4):

1. Pipecutting System case
2. Exact PipeCut 200 pipe saw
3. Cutting supports 4x
4. Operating instructions
5. Hex socket key 5 mm and 2 mm
6. Hard-metal blade 140 x 62 fitted on the machine

## General power tool safety warnings



**WARNING: Read all safety warnings and all instructions.** Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

### 1. Work area safety

- a) **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- b) **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.
- c) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

### 2. Electrical safety

- a) **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- c) **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- d) **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges and moving parts.** Damaged or entangled cords increase the risk of electric shock.
- e) **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- f) **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.

### 3. Personal safety

- a) **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.

- b) **Use personal protective equipment. Always wear eye protection.** Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- c) **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- d) **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- e) **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- f) **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- g) **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related hazards.

### 4. Power tool use and care

- a) **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- b) **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- c) **Disconnect the plug from the power source from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- d) **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- e) **Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- f) **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- g) **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.

## 5. Service

Have your power tool serviced by a qualified repair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.

## Safety warnings for circular saws

- a) **DANGER: Keep hands away from cutting area and the blade. Keep your second hand on motor housing.** If both hands are holding the saw, they cannot be cut by the blade.



- b) **Do not reach underneath the workpiece.** The guard cannot protect you from the blade below the workpiece.
- c) **Never hold the workpiece being cut in your hands or across your leg. Secure the workpiece to a stable platform.** It is important to support the work properly to minimize body exposure, blade binding, or loss of control.
- d) **Hold the power tool only by the insulated gripping surfaces when performing an operation where the cutting tool may contact hidden wiring or its own cord.** Contact with a "live" wire will also make exposed metal parts of the power tool "live" and shock the operator.
- e) **Always use blades with correct size and shape (diamond versus round) of arbour holes.** Blades that do not match the mounting hardware of the saw will run eccentrically, causing loss of control.
- f) **Never use damaged or incorrect blade washers or bolt.** The blade washers and bolt were specially designed for your saw, for optimum performance and safety of operation.
- g) **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 saw from the work or pull the saw backward while the blade is in motion.** Investigate and take corrective actions to eliminate the cause of blade binding.
- h) **When restarting a saw in the workpiece, centre 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 from the workpiece as the saw is restarted.
- i) **Do not use dull or damaged blades.** Unsharpened or improperly set blades produce narrow kerf causing excessive friction and blade binding.
- j) **Use extra caution when making a "plunge cut" into existing walls or other blind areas.** The protruding blade may cut objects that can cause kickback.
- k) **Check lower guard for proper closing before each use. Do not operate the 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 with the retracting handle and make sure it moves freely and does not touch the blade or any other part, in all angles and depths of cut.
- l) **Check the operation of the lower guard. 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 build-up of debris.
- m) **Do not reach into the saw dust ejector with your hands.** They could be injured by rotating parts.
- n) **Do not work overhead with the saw.** In this manner you do not have sufficient control over the power tool.
- o) **Do not operate the power tool stationary.** It is not designed for operation with a saw table.
- p) **Do not use high speed steel (HSS) saw blades.** Such saw blades can easily break.
- q) **When working with the machine, always hold it firmly with both hands and provide for a secure stance.** The power tool is guided more secure with both hands.
- r) **Secure the workpiece.** A workpiece supported by pipe holders is held more secure than by hand.
- s) **Always wait until the machine has come to a complete stop before placing it down.** The tool insert can jam and lead to loss of control over the power tool.
- t) **Never use the machine with a damaged cable. Do not touch the damaged cable and pull the mains plug when the cable is damaged while working.** Damaged cables increase the risk of an electric shock.

## Safety instructions for plunge type saws

- a) **Check guard for proper closing before each use.** Do not operate the saw if guard does not move freely and enclose the blade instantly. Never clamp or tie the guard with the blade exposed. If saw is accidentally dropped, guard may be bent. Check to make sure that guard moves freely and does not touch the blade or any other part, in all angles and depths of cut.
- b) **Check the operation and condition of the guard return spring.** If the guard and the spring are not operating properly, they must be serviced before use. Guard may operate sluggishly due to damaged parts, gummy deposits, or a build-up of debris.



- c) **Assure that the guide plate of the saw will not shift while performing the “plunge cut” when the blade bevel setting is not at 90°.** Blade shifting sideways will cause binding and likely kick back.
- d) **Always observe that the guard is covering the blade before placing saw down on bench or floor.** An unprotected, coasting blade will cause the saw to walk backwards, cutting whatever is in.

## Additional specific safety rules

The pipe saw must never be used in the following cases, if:

- There is water or another liquid, explosive gases or poisonous chemicals inside the pipe to be cut.
- The power switch is faulty.
- The power cable is faulty,
- The blade is bent.
- The blade is blunt or in poor condition.
- The plastic components are cracked or have parts missing.
- The gripper unit is not properly tightened around the pipe or if it is warped.
- The blade guard cover or moving blade guard has been damaged or removed from the machine.
- The locking mechanisms do not work properly (UNLOCK-button).
- The pipe saw has become wet.

When using the pipe saw, the following factors must always be taken into consideration:

- Support tubes to minimise the risk of blade pinching.
- Ensure that the pipe to be cut is empty.
- Ensure that the blade is correctly installed.
- Ensure that the diameter and thickness of the blade are suitable for the pipe saw and that the blade is suitable for the rpm-range of the machine.
- Never use sideways force to stop the blade, always allow the blade to stop freely.
- Check the attachments of the blade guards.
- Never use excessive force when using the pipe saw.
- Never use the pipe saw to lift the pipe while it is still attached to the pipe.
- Avoid overloading the electric motor.
- Always follow the safety and operating instructions and current regulations.

**Air vents often cover moving parts and should be avoided.** Loose clothes, jewellery or long hair can be caught in moving parts.

Accessories must be rated for at least the speed recommended on the tool warning label. Accessories running over rated speed can fly apart and cause

injury. Accessory ratings must always be above tool speed as shown on tool nameplate.



**WARNING: ALWAYS wear proper personal hearing protection that conforms to ANSI S12.6 (S3.19) during use.** Under some conditions and duration of use, noise from this product may contribute to hearing loss. When working with various materials, the sound level may vary and at times exceed the 85 dB(A) limit. Always use ear protectors to protect yourself.



**WARNING: ALWAYS use safety glasses.** Everyday eyeglasses are NOT safety glasses. Always use safety goggles to prevent injury to your eyes from particles thrown up when using the pipe saw. Also use face or dust mask if cutting operation is dusty (**cast iron cutting**). ALWAYS WEAR CERTIFIED SAFETY EQUIPMENT:

- ANSI Z87.1 eye protection (CAN/CSA Z94.3),
- ANSI S12.6 (S3.19) hearing protection,
- NIOSH/OSHA/MSHA respiratory protection.



**WARNING: ALWAYS use safety gloves as the edges of cut pipes are sharp and can cause cuts.**



**WARNING: Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:**

- lead from lead-based paints,
- crystalline silica from bricks and cement and other masonry products, and
- arsenic and chromium from chemically-treated lumber (CCA).

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

**Avoid prolonged contact with dust from power sanding, sawing, grinding, drilling, and other construction activities.**

**Wear protective clothing and wash exposed areas with soap and water.** Allowing dust to get into your mouth, eyes, or lay on the skin may promote absorption of harmful chemicals.



**WARNING: Use of this tool can generate and/or disburstedust, which may cause serious and permanent respiratory or other injury. Always use NIOSH/OSHA approved respiratory protection appropriate for the dust exposure.**

**Direct particles away from face and body.**

## Extension cords

An extension cord must have adequate wire size (AWG or American Wire Gauge) for safety. The smaller the gauge number of the wire, the greater the capacity of the cable, that is 16 gauge has more capacity than 18 gauge. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. When using more than one extension to make up the total length, be sure each individual extension contains at least the minimum wire size. The following table shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord. (see page 4).

## Motor

Be sure your power supply agrees with nameplate marking. As little as 10% lower voltage can cause loss of power and can result in overheating. All Exact Tools products are factory-tested; if this tool does not operate, check the power supply.



**WARNING: Accessories must be rated for at least the speed recommended on the tool warning label. Accessories running over rated speed can fly apart and cause injury.** Accessory ratings must always be above tool speed as shown on tool nameplate.



**DANGER: Avoid contact with the blade teeth to prevent personal injury**

## Functional Description

Read all safety warnings and all instructions. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.

## Intended Use

### PipeCut 200:

The PipeCut 200 pipe saw is intended for use as a pipe fitter's tool at the installation site. The PipeCut 200 pipe saw can only be used to cut round pipes, with a diameter of 0,6-8,0" (15-200 mm) and a maximum wall thickness of 0,31" (8 mm) with steel and other ferrous and non-ferrous materials and 0,45" (12 mm) with plastics. The PipeCut 200 pipe saw can be used to cut all normal pipe materials, such as steel, stainless steel, cast iron, copper, aluminium and plastic. PipeCut 200 pipe saw is intended for short, intermittent use. The machine may be loaded for 2,5 minutes during a 10-minute period (S3 25 %). PipeCut 200 pipe saw is not intended for use in industrial production. Use pipe holders to support pipe.

## Product Features

While reading the operating instructions, unfold the graphics page for the machine and leave it open.

This page is folded under the cover of this manual (page 3). The following numbering of the product features refers to this illustration.

1. UNLOCK button
2. Power switch
3. Power-switch locking lever
4. Blade-guard cover
5. Blade-guard screw
6. Moving blade-guard
7. Edge of moving blade-guard
8. Braking wheels
9. Adjusting wheel
10. Operating handle
11. Spindle-lock button
12. Blade-guard screw
13. Motor unit
14. Rating plate
15. Overload protection
16. Gripper unit
17. Gripper adjustment handle

# Exact PipeCut 200 pipecutting system operating instructions

## Before operating the tool

Ensure that the motor unit is in the upright position. The yellow mark of the UNLOCK button is visible.

Check that the blade is correctly fitted, in good condition and suitable for the material to be cut.

Ensure the pipe saw guide wheels rotate.

Ensure the support wheels rotate.

Check the operation of the lower blade guard.

Ensure the pipe is empty.

If plastic pipes have been cut with the pipe saw (resulting in long, statically charged slivers), open the blade guard cover, and clean carefully the lower blade guard and the entire pipe saw.

## Connection to the mains power supply

Ensure that the mains voltage is the same as indicated on the rating plate (**Figure A/14**). Connect the pipe saw to the power outlet only after having checked this.

Fig B

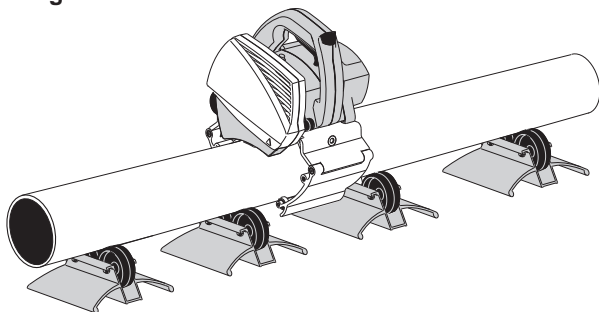
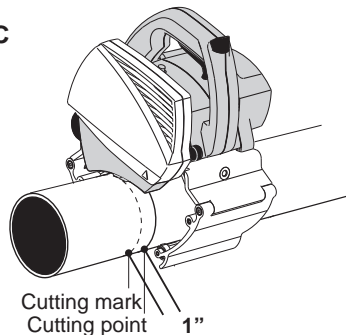


Fig C



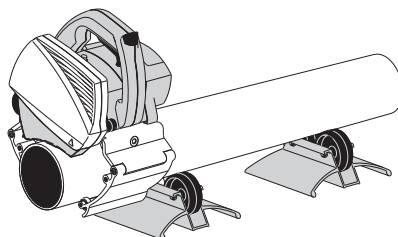
## Precise setting of the cutting point

When you mark the cutting point on the pipe to be cut, deduct 1 inch from the required dimension (Easy-to-remember rule: The cutting mark location requires a measurement of - 1").(**Figure C**)

## Setting the pipe on supports

Use the system supports when cutting pipes. This will ensure safe working and optimum result. Work on flat surface. Place the pipe on two supports so that the cutting point is between the supports. Place two more support under both ends of the pipe. Check that all support wheel contact the pipe (adjust if required e.g. with pieces of lumber) (**figure B**). When cutting short pipes (10" or less) place the supports so that the cutting point is outside supports (**figure D**). Support the pipe with your left leg, if required. Proper arrangements will prevent the blade from jamming as the pipe is cut through.

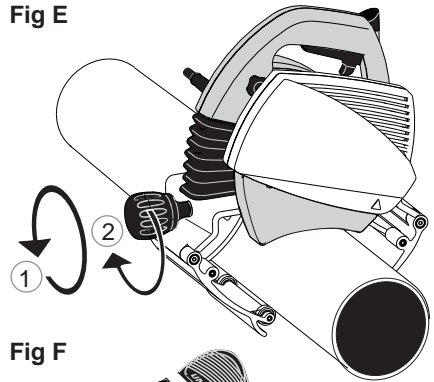
Fig D



## Attaching the pipe saw to the pipe

Open the pipe saw's gripper unit enough to suit the diameter of the pipe by rotating the adjustment handle located at the rear of the saw (**Fig. E/1**). Position the pipe saw on top of the pipe so that the edge of the lower blade guard is at the cutting mark. Fasten the pipe saw to the pipe by turning the gripper adjustment handle until the gripper grips firmly the pipe to be cut (**Figure E/2**). Hold the pipe in place and ensure that pipe saw moves freely in the direction the pipe is fed. For sake of safety ensure the pipe saw leads are to the left of the pipe saw. The pipe saw is now ready for cutting.

Fig E



## Piercing the pipe wall

Grip the gripper firmly with your right hand and place your left foot on top of the pipe approximately 20" from the pipe saw. Turn the saw until it leans slightly forward (**Figure H**). When starting the motor, first of all release the power-switch locking lever (**Fig F/1**) and push the power switch all the way down (**Fig F/2**). Before starting to saw, wait until the blade reaches full speed. Pierce the pipe wall by pressing pipe saw operating handle downwards slowly and evenly until the blade has cut through the pipe wall (at this stage the pipe must not rotate) and the motor unit is locked in the sawing position (**Fig H/1**). Look at the UNLOCK button during the piercing operation. When UNLOCK button is locked, i.e. the yellow mark disappears (**Fig G**), pipe saw is locked in the sawing position, and you can safely start sawing around the pipe.

Fig F

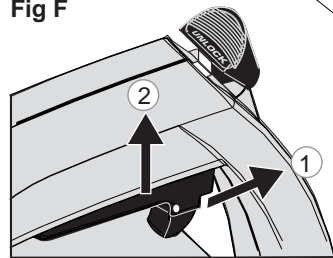
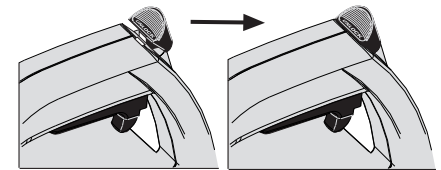


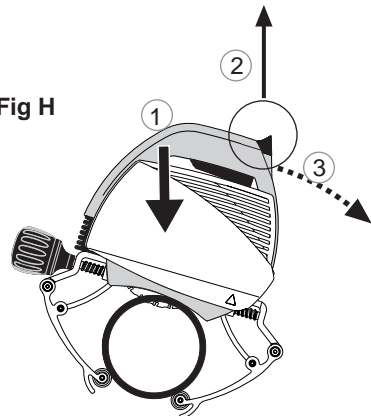
Fig G



## Sawing around the pipe

Start sawing by feeding the pipe saw forward and fix the pipe with your left foot (**Fig H/3**). After that release the pipe (remove your left foot from the pipe) and turn the pipe saw backwards, whereby the pipe will also be rotated backwards (**Fig J**). Start a new feeding movement, and feed continuously forward ca. 1/6 of the pipe's circumference. Repeat until the pipe is cut off (**Fig K**).

Fig H



Select the feeding speed as per the material and the thickness of the wall. Too high speed can damage the blade, overload the pipe saw and give a poor sawing result.

When the pipe is cut off, push the UNLOCK button forward until the yellow mark is visible and the locking is released (**Fig L/1**). Now raise the motor unit to starting position (**Fig L/2**). Release the power switch (**Fig L/3**). When the blade is stationary, remove the pipe saw from the pipe by loosening the gripped handle (**Fig L/4**). Ensure that the moving lower blade-guard is lowered into safety position.

Should there be problems during piercing or sawing, abnormal sounds or vibrations due to which you have to interrupt sawing before the pipe is cut through, release the blade by pushing the UNLOCK button forward until the UNLOCK button is released, and lift the motor unit up. Once the problem is cleared, start sawing again.

Never start the motor, when the motor unit is locked in sawing position or teeth of the blade contact the pipe to be sawn.

## Overload protection

The pipe saw is equipped with overload protection. When the blade is dull or the speed is too high, the overload protection cuts power automatically. In case of overload: Release the power switch (**Fig L/3**). Push the UNLOCK button forward until the yellow mark is visible and the locking is released (**Fig L/1**). Now raise the motor unit to the starting position (**Fig L/2**). Restore the power by pushing the overload protection switch (**Fig A/15**).

## Straightness of cut and adjusting wheel

The cut is affected by many factors, e.g. the size of the pipe, the material, the wall thickness, the quality of the pipe's surface, the roundness, welded seams, blade condition, feed rate, operator's experience. For this reason the result may vary, and the cut may turn to left or right (misalignment of the cut's starting and ending point) (**Fig M**). The pipe saw gripper has one adjustable wheel (**Fig A/9**) which be used for improving the quality of the cut and for reducing the misalignment.

The adjustment applies only to the actual pipe size and material, and the wheel may have to be readjusted as the blade is worn.

Fig J

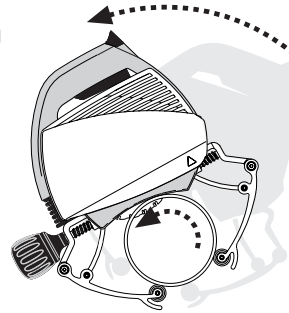


Fig K

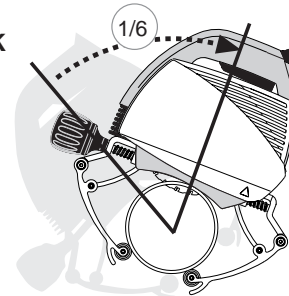


Fig L

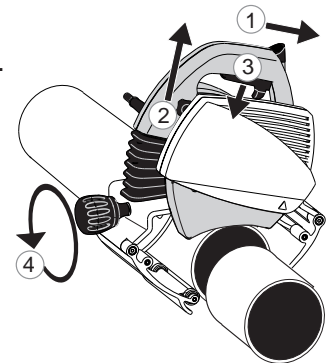


Fig M

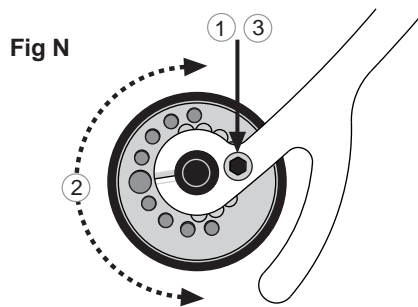


Gap to left



Gap to right

The wheel can be adjusted in 9 positions; mid position and 4 steps to left and right. To adjust the wheel, loosen the locking screw (Fig N/1) and turn the wheel center clockwise or counterclockwise to the desired position (Fig N/2), and lock the wheel again (Fig N/3). If the blade has wandered too much to the right, adjust wheel center clockwise. If the misalignment is to the left, adjust counterclockwise. The number of steps depend on the actual misalignment. Remember to lubricate the adjusting wheel at regular intervals.



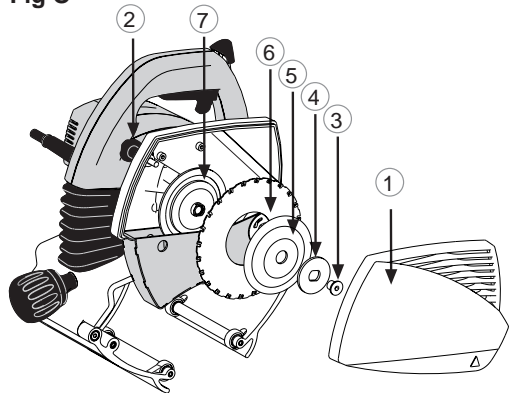
## Installing and changing the saw blade

**WARNING:** To reduce the risk of injury, turn unit off and disconnect it from power source before installing and removing accessories, before adjusting or when making repairs. An accidental start-up can cause injury.

Remove the power plug from the socket. Check that the motor unit is locked in the upper position.

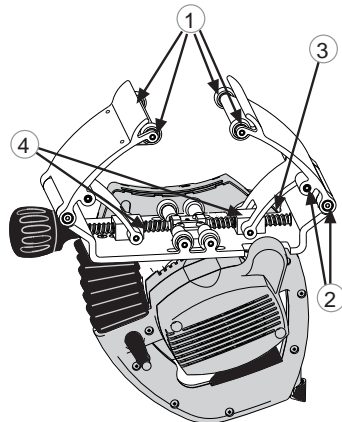
Remove the blade guard cover (Fig. O/1) by opening the two screws (Fig. O/2). Press the spindle-lock button (Fig. A/11) and simultaneously rotate the blade by hand until the spindle-lock button drops a further distance of about 0,2". Now the rotation of the blade is prevented. Use the blade key to open the blade attachment bolt (Fig. O/3). Remove the securing bolt (Fig. O/3), the washer (Fig. O/4), the blade flange disc (Fig. O/5), and the blade (Fig. O/6).

Fig O





Before installing a new blade, check that both blade flange discs are clean. Place a new or sharpened blade on the back flange disc (Fig. O/7), so that the marked side of the blade is facing outwards and the arrows on the blade are facing in the same direction as the rotation direction markings on the inside of the blade case. Ensure that the new blade goes right to the bottom in the back flange disc. Put the blade flange disc, the washer, and the securing bolt back in place. Press the spindle lock button and tighten the blade securing bolt. Put the blade guard cover back in place and tighten the bolts.


Fig P




## Maintenance and servicing instructions

 **WARNING:** To reduce the risk of injury, turn unit off and disconnect it from power source before installing and removing accessories, before adjusting or when making repairs. An accidental start-up can cause injury.

 **WARNING:** To reduce the risk of injury, DO NOT TIE, TAPE, OR OTHERWISE LOCK THE ON/OFF SWITCH ON while "running in". HOLD BY HAND ONLY.

 **Cleaning**  
**WARNING:** Periodically blowing dust and chips out of the motor housing using clean, dry compressed air is a suggested maintenance procedure. To reduce the risk of serious personal injury, ALWAYS wear ANSI Z87.1 safety glasses while using compressed air.

 **WARNING:** When cleaning, use only mild soap and a damp cloth on plastic parts. Many household cleaners contain chemicals which could seriously damage plastic. Also, do not use gasoline, turpentine, lacquer or paint thinner, dry cleaning fluids or similar products which may seriously damage plastic parts. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

### Gripper unit


Clean the gripper unit regularly with compressed air. Lubricate the gripper's wheel axles (**Fig. P/1**) and its joints (**Fig. P/2**). Also clean and lubricate the gripper's trapezoidal screw (**Fig. P/3**) and the two worm screws on it (**Fig. P/4**).

### Blade guard

When you have sawn plastic pipes and then intend to start sawing metal pipes always clean the inside of the blade guards. Hot particles derived from sawing metal will burn plastic particles, which may release toxic smoke. Make it a rule to clean the blade guard regularly, and pay special attention to keep the moving blade guard movement from becoming hampered. Lubricate the axis of the moving blade guard regularly.

### Motor


Keep the motors cooling vents clean.

 **Power cable**  
**WARNING:** Check the condition of the power cable regularly. A faulty power cable should always be replaced at an approved service agency. Correct use and regular servicing and cleaning will ensure the continued operation of the pipe saw.

 **Accessories**  
**WARNING:** Since accessories, other than those offered by Exact Tools, have not been tested with this product, use of such accessories with this tool could be hazardous. To reduce the risk of injury, only Exact Tools, recommended accessories should be used with this product.

Recommended accessories for use with your tool are available at extra cost from your local dealer or authorized service center. If you need assistance in locating any accessory, please visit our website [www.exacttools.com](http://www.exacttools.com).

 **Blades**  
**WARNING:** VISUALLY EXAMINE CARBIDE BLADES BEFORE USE. REPLACE IF DAMAGED

 **WARNING:** To minimize the risk of eye injury, always wear ANSI Z87.1 approved eye protection. Carbide is a hard but brittle material. Foreign objects in the work piece such as wire or nails can cause tips to crack or break. Only operate saw when proper saw blade guard is in place. Mount blade securely in proper rotation before using, and always use a clean, sharp blade.

A dull blade will cause inefficient cutting, overload on the saw motor.

Change blades when it is no longer easy to push the saw through the cut, when the motor is straining, or when excessive heat is built up in the blade. It is a good practice to keep extra blades on hand so that sharp blades are available for immediate use. Dull blades can be sharpened in most areas; see SAWS-SHARPENING in the yellow pages.

Your PipeCut pipe saw is designed for use with 5,51" (140 mm) diameter blades that have a 2.44" (62 mm) diameter bore. Blades must be rated for 5200 RPM operation (or higher). DO NOT use any abrasive wheels.

**See blade selection on page 2**

### Repairs

To assure product SAFETY and RELIABILITY, repairs, maintenance and adjustments should be performed by a authorized service center or other qualified service personnel. Always use identical replacement parts.

## Environment



Separate collection. This product must not be disposed of with normal household waste. When your Exact PipeCut machine is worn out, do not dispose of it with normal household waste. This product must be recycled separately. Separate recycling of used products and packaging facilitate recycling and recovery of materials. Reusing of recycled materials helps prevent pollution of environment. According to local regulations it is possible to deliver household appliances to municipal rubbish depositories or to the dealer when buying a new product.

## Guarantee

If the Exact PipeCut pipe saw becomes unusable due to material or manufacturing faults within 24 months of the date of purchase, we will replace the damaged parts with new ones or supply an entirely new or factory-reconditioned pipe saw to replace the damaged one.

### The guarantee is only valid if:

The guarantee card or a dated purchase receipt is returned to the manufacturer or retailer.  
The pipe saw has not been misused.  
No attempt has been made by non-approved persons to repair the saw.  
The pipe saw has been used in accordance with these operating, safety, and servicing instructions.  
The guarantee does not apply to blades or the overload protection.

## Tips for using Exact PipeCut saws

Diamond blade should only be used for cutting cast iron pipe. It is not recommended to cut cast iron with TCT or Cermet blades.

Clean the inside of the blade guards after cutting plastic pipe.

Smaller pipe is easily cut by rotating the pipe by hand either on a table or on the floor. Please note: rotate pipe towards you when rotating by hand and be careful not to rotate too fast.

Check the condition of the blade regularly.

The cutting procedure is divided into two stages; first saw through the pipe wall, then complete the cut by sawing around it.

Do not overload the saw by cutting continuously. The saw will be overheated and the metal parts can become burning hot. This will also damage the motor and the blade. The rule is 2.5 minutes in use and 7.5 minutes rest.

Keep the feeding speed constant. This will extend the lifetime of the blade. For example cutting time for a steel pipe diameter of 6" (170mm), and a wall thickness of 1/5" (5mm), is 15-20 seconds, and for a cast-iron pipe diameter of 4" (110mm), with a wall thickness of 1/6" (4mm) is 20 to 25 seconds.

Always keep the motor unit in the upright position. The yellow mark of the unlock button is then visible. Never place the Pipe Cut Saw on the pipe in the locked / cutting position.

### Factors that affect the lifetime of the saw blade:

- material of the pipe
- correct blade type for material being cut
- wall thickness of the pipe
- feeding speed
- smoothness of the pipe
- user's general skills
- cleanness of the pipe
- rust on the pipe
- welded seam in the pipe
- blade speed

### Factors that affect the straightness of the cut:

- condition of the saw blade
- wall thickness of the pipe
- feeding speed
- smoothness of the feed
- user's general skills
- cleanness of the pipe
- roundness of the pipe
- gripper unit too loose or too tight
- blade assembled too tight

**Due to continuous product development, the information in this instruction book may change. We do not give separate notification of changes.**



# Definitions of symbols/ Définitions des symboles /Definicions de los símbolos

The label on your tool or this manual may include symbols. The symbols and their definitions are the following:

L'étiquette apposée sur votre outil ou de ce manuel peuvent inclure des symboles. Les symboles et leurs définitions sont les suivantes:

La etiqueta de la herramienta o en este manual pueden incluir símbolos. Los símbolos y sus definiciones son las siguientes.

	EN	FR	ES
V	volts	volts	voltios
A	amperes	ampères	amperios
Hz	herz	hertz	herzios
W	watts	watts	vatios
kW	kilowatts	kilowatts	kilovatios
F	farads	farads	faradios
µF	microfarads	microfarads	microfaradios
l	litres	litres	litros
g	grams	grammes	gramos
kg	kilograms	kilogrammes	kilogramos
bar	bars	bars	bares
Pa	pascals	pascals	pascales
h	hours	heures	horas
min	minutes	minutes	minutos
s	seconds	secondes	segundos
n <sub>0</sub>	no-load speed	vitesse de rotation à vide	velocidad sin carga
$\dots/\text{min}$ or $\dots\text{min}^{-1}$	revolutions or reciprocations per minute	révolutions ou alternances par minute	revoluciones o reciprocaciones por minuto
 or d.c.	direct current	courant continu	corriente continua
 or a.c.	altering current	courant alternatif	corriente alterna
 2	two-phase altering current	courant alternatif biphasé	corriente alterna bifásica
 2N	two-phase altering current with neutral	courant alternatif biphasé avec neutre	corriente alterna bifásica con
 3	three-phase altering current	courant alternatif triphasé	corriente alterna trifásica neutral
 3N	three-phase altering current with neutral	courant alternatif triphasé avec neutre	corriente alterna trifásica con
 A	rated current of the appropriate fuse-link in amperes	courant nominal de l'élément de remplacement approprié en ampères	corriente nominal neutral del fusible de enlace apropiado en amperios
	time-log miniature fuse-link where x is the symbol for time/current characteristic, as given in IEC 60127-3	élément de remplacement miniature avec feuille de temps, x étant le symbole de la caractéristique temps / courant, tel qu'énoncé dans la norme CEI 60127-3	un fusible de enlace en miniatura con registro de tiempo donde X es el símbolo característico para el tiempo/corriente dado en IEC 60127-3
	protective earth	terre de protection	conexión a tierra de protección
	class II tool	outil de classe II	herramienta clase II
IPXX	IP symbol	symbole IP	símbolo IP