CUTTER

DLY-18F1

Usual safety rules

Caution:

Reading instructions: Failure to use or operate in accordance with the instructions listed below will result in electric shock, fire and / or serious injury. The warning term "power tool" listed below refers to a mains driven (wired) power tool or a battery driven (wireless) power tool.

SAVE THE MAUNAL

Working place:

1. Keep the operating place clean and bright, chaotic and dark place will cause accident.
2. Do not operate electronic tools in explosive environment. If it were operated under the environment that has explosive fluid/gas/powder, the sparks it creates will lights the powder/gas.
3. Keep others away from the operating environment, distraction might cause mistake in your operation.

Electronic safety

4. The plug of the electronics must match with the socket, the tools grounded must not use any conversion plug, unmodified plug will reduce the risk of electric shock.
5. Avoid touch metal material grounded, such as tubes or refrigerator, heat-dissipating net. If touched, it can increase the risk of electric shock.
6. Do not put it in rain or humid environment, it can increase the risk of electric shock if water got in the machine.
7. Wires shall not be abused: Never carry or pull things with the wires, do not unplug electric tools. Keep electric tools away from heat, oil, sharp edges or moving parts. Damaged or twisted wires can increase the risk of electric shock.
8. When using electric tools outdoors, use external wires suitable for outdoor use. Wires suitable for outdoor use will reduce the risk of electric shock.

Life safety

9. Keep alert, pay attention to the operation and keep awake when operating electric tools. Never operate electric tools under fatigue, drugs, alcohol or treatment reactions. Distraction during operation of electric tools can cause serious personal injury.
10. Use safety devices. Always wear goggles. Safety devices such as dust masks, anti-skid safety shoes, hard hats, hearing protection and other devices under appropriate conditions, can reduce personal injury.
11. Avoid sudden start. Make sure that the switch is in the off position when the plug is inserted. It may cause danger if you put your finger on the switch that has been turned on or inserting the plug when the switch is turned on.
12. Remove all adjustment keys or wrenches before turning on the electric tools. Keys or wrenches left on rotating parts of electric tools may cause personal injury.
13. Dress appropriately. Do not wear loose clothes or accessories. Keep your hair, clothes and sleeves away from moving parts. Loose clothing, accessories, or long hair may become entangled in moving parts.
14. If the chip removal device and dust collection equipment are provided, ensure that they are well connected and properly used. The use of these devices reduces the risk of debris.

Use and precautions of electric tools

15. Do not misuse electric tools, use appropriate electric tools according to the purpose. Selecting the appropriate rated electric tools will make your work more effective and safe.
16. If the switch cannot turn on or off the power of the tool, the power tool cannot be used. Electric tools that cannot be controlled by switches are dangerous and must be repaired.

17. Before any adjustment, replacement of accessories or storage of electric tools, the plug must be removed from the power supply and /Or disconnect the battery box from the power supply. This protective measure will reduce the risk of sudden start of electric tools.
18. Store the idle electric tools away from children. Do not let people who are not familiar with the electric tools or do not understand these instructions operate the electric tools. Electric tools are dangerous in the hands of untrained users.
19. Maintain electric tools. Check the installation deviation or jamming of moving parts, damage of parts and other conditions affecting the operation of electric tools. In case of damage, the electric tools must be repaired before use. Many accidents are caused by poorly maintained electric tools.
20. Keep cutting tools sharp and clean. Well maintained tools with sharp cutting edges are not easy to jam and easy to control.
21. Use the electric tools, accessories, tool tips, etc. according to the operation instructions and the special type requirements of the electric tools to be used, taking into account the operating conditions and the operations to be carried out. Using electric tools for operations that do not meet the requirements may lead to dangerous situations.

Maintenance

22. Send your electric tools to professional maintenance personnel and replace them with the same equipment. This will ensure the safety of the power tool being serviced.
23. Please follow the instructions of this manual when applying lubricating oil and replacing accessories.
24. The handle must be kept dry, clean and free of oil (grease).

Specific safety rules

Do not strictly observe the safety rules for convenience or because you are familiar with the operation of the portable band saw (after multiple use). Using this tool in an unsafe or incorrect manner may cause serious personal injury.

1. Only 1745mm long, 13mm wide and 0.65mm thick saw blades can be used.
2. 2. Please carefully check whether the saw blade is cracked or damaged before operation, and replace it immediately if found.
3. Work pieces shall be firmly fixed. When cutting into bundles, all work pieces must be firmly fixed together before operation.
4. Cutting the work piece with oil may cause the saw blade to slip off accidentally. Wipe off the excess oil on the work piece before operation.
5. Do not use cutting oil as cutting lubricant.
6. Do not wear gloves during operation.
7. During operation, press the steel pipe tightly to avoid cutting the saw belt during operation.
8. Keep hands away from rotating parts.
9. When cutting metal, pay attention to splashing high-temperature metal chips.
10. The running tools cannot be left unattended.
11. Do not touch the saw blade immediately after operation to avoid hand injury.
12. During operation, if the cutting tool may touch the hidden wiring or its own wire,

please hold the insulated handle surface of the tool. Contact with the "live wire" will cause the exposed metal parts of the tool to be "electrified", thus causing the operator to get an electric shock.

Please keep this instruction

Caution:

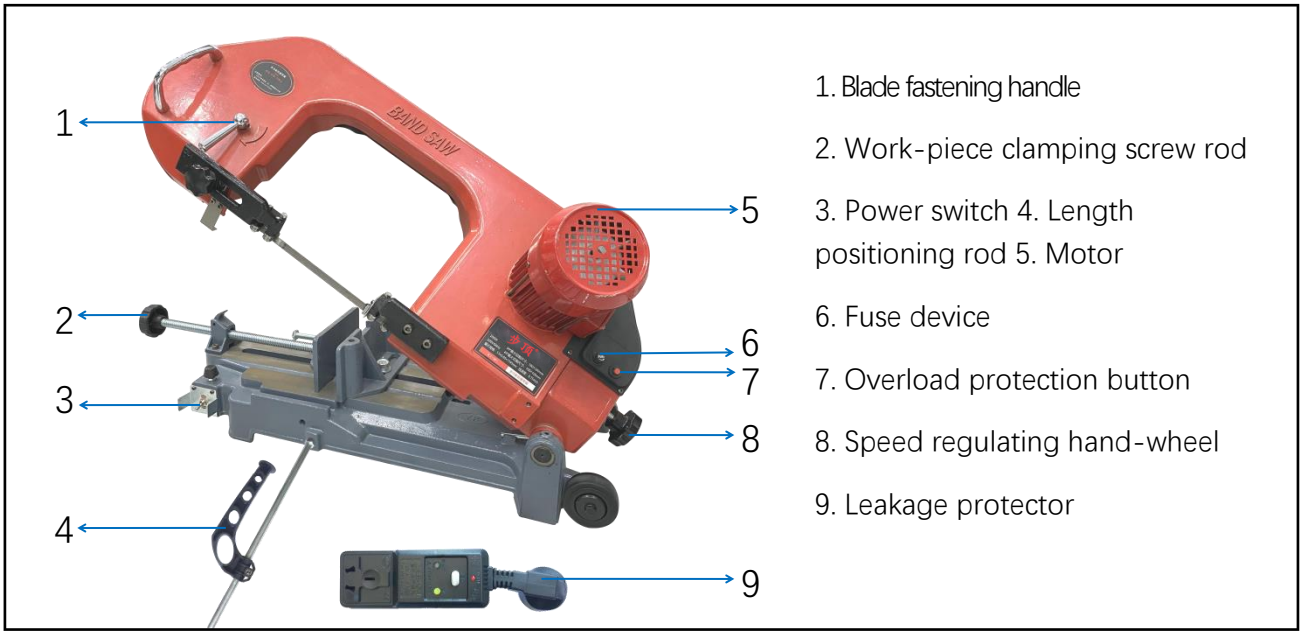
Misuse of tools or failure to observe the safety rules listed in this manual may cause serious personal injury.

Specifications

Model		DLY-18F1
0° Cutting size	Round	Φ180mm
	Square	180×180mm
45° Cutting size	Round	Φ100mm
	Square	100×100mm
Net.W/Gross.W		61/68kg
Blade size		13×0.65×1745mm
Power		250W
Voltage		220V/50Hz

Remarks: the attached accessories include a length positioning rod, a leakage protection plug, a set of clamping device, a switch, a fuse, a hex wrench and two brushes.

Function description



1. Blade fastening handle
2. Work-piece clamping screw rod
3. Power switch 4. Length positioning rod 5. Motor
6. Fuse device
7. Overload protection button
8. Speed regulating hand-wheel
9. Leakage protector

FIGURE. 180-1

Caution:

- **Before adjusting or checking the function of the tool, be sure to turn off the power switch of the tool and unplug the power plug.**

1. When confirming that the switch is closed, first insert the leakage protector into the 220V single-phase power socket, and then insert the tool power plug into the leakage protector.

2. When cutting the work-piece, turn the power switch to start the machine, wait for a moment until the saw blade reaches full speed, and gently lower the saw blade for cutting. If the saw blade falls too fast,

it is easy to hit the teeth. The machine will stop automatically after cutting.

3. The tool adopts imported bimetal saw blade. Can cut carbon steel, stainless steel, steel plastic pipe, etc. During the initial use of the saw blade, it is necessary to run in to make the saw blade adapt to the wear at the initial stage of cutting, and effectively avoid the premature collapse and rolling of the saw blade.

4. Firmly fix the work-piece to be cut, and the work-piece shall not be loose during cutting.

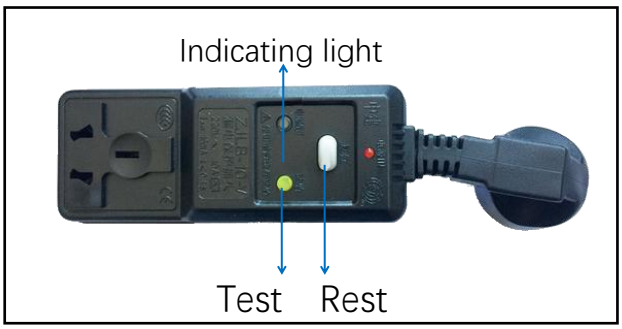


FIGURE. 180-2

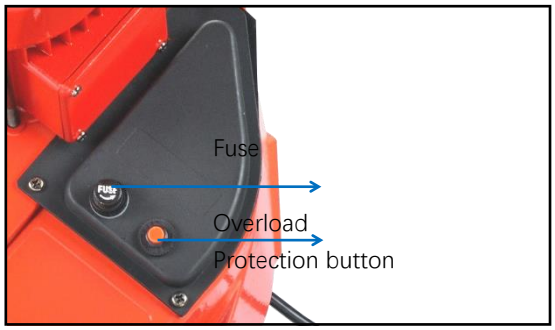


FIGURE. 180-3

5. As shown in figure 180-2, when the leakage protector is connected to the power supply and the machine, press the reset key to turn on the power supply, and the indicator light will be on. Then, turn the machine power switch to start the machine, and the machine will operate normally. If the machine is shut down suddenly, press the test key to check whether the machine circuit is abnormal. If the power is cut off instantaneously, please pay attention to whether the motor and other power lines are abnormal. The machine can be used normally after the fault is cleared.

6. As shown in figure 180-3, when the fuse is burnt out and needs to be replaced, directly unscrew the fuse device for replacement. When the motor is suddenly stuck or the circuit is abnormal, please press the overload protection button immediately and restart the machine for cutting operation after troubleshooting.

FIGURE 180-4

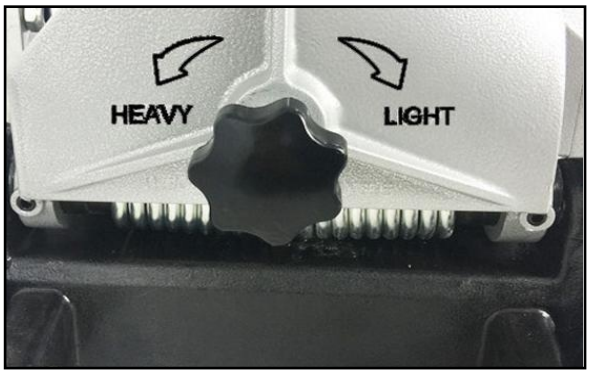
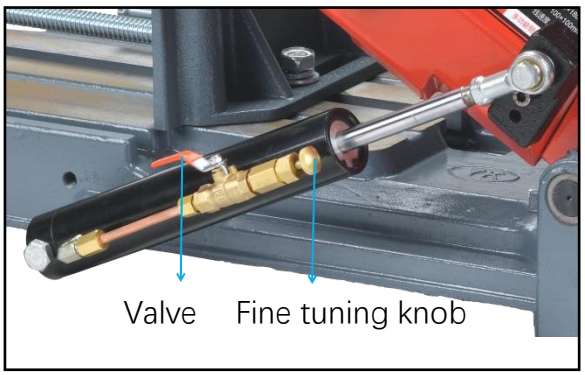


FIGURE 180-5



7. As shown in figure 180-4, if it is necessary to slow down the lowering speed of the saw blade, please rotate the hand wheel clockwise to reduce the lowering pressure of the frame itself, and the direction is marked as "light". If it is necessary to speed up the lowering speed of the saw blade, please rotate the hand wheel counterclockwise to increase the lowering pressure of the frame itself, and the pointing sign is "heavy".

8. As shown in Fig. 180-5, the oil cylinder is an optional accessory. If it is necessary to cut the pipe with relatively thin wall thickness (wall thickness ⩽ 4mm), it is recommended to purchase an additional oil cylinder. The oil cylinder is mainly used to reduce the lowering pressure of the frame to slow down the lowering speed of the saw blade. During cutting operation, the lowering speed of the saw blade can be controlled by adjusting the cylinder valve and the fine adjustment knob.

Removal and installation of saw blade

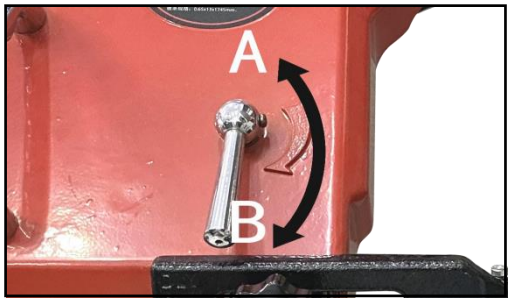


FIGURE 180-6

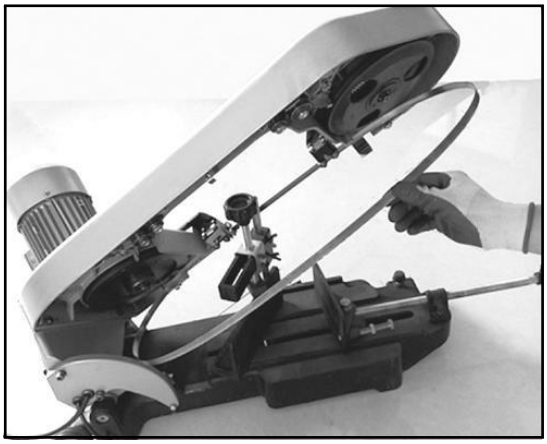


FIGURE 180-7

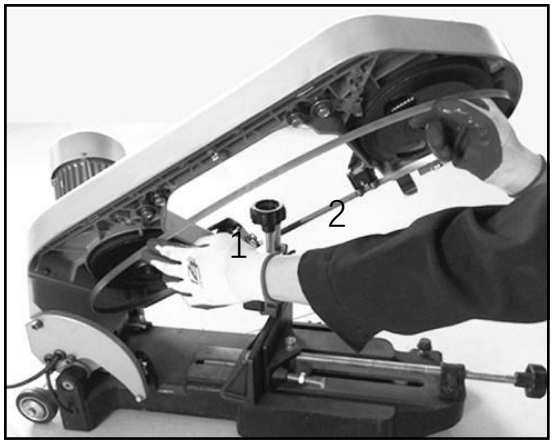


FIGURE 180-8

1. When removing the worn and scrapped saw blade, rotate the saw blade fastening handle counterclockwise (a) as shown in figure 180-6 to loosen the saw blade. Then slowly take out the worn and scrapped saw blade as shown in figure 180-7.

2. When installing a new saw blade, as shown in figure 180-8, put the saw blade around the runner and insert the other side of the saw blade into the guide arm

(1 and 2) until the back of the saw blade contacts the bottom of the guide arm. Keep the saw blade stationary, as shown in Fig. 180-6, rotate the fastening handle of the saw blade clockwise (b) (do not pull it too much). At this time, the saw blade has proper tension, and confirm that the saw blade is correctly located between the saw frame and the runner.

2. Switch on and off the machine for two to three times to confirm that the saw blade can operate normally.

⚠Caution:

1. When rotating the fastening handle of the saw blade anticlockwise to loosen the saw blade, do not face the falling direction of the saw blade to prevent personal injury caused by accidental sliding of the saw blade.
2. When confirming whether the saw blade operates normally, keep your body away from the saw blade.

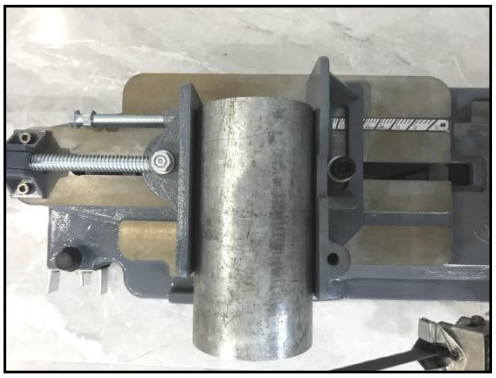


Figure 180-9

Figure 180-10

Figure 180-11

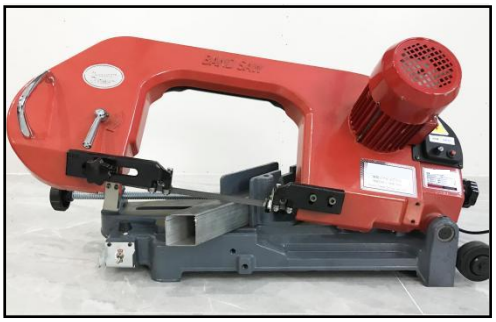


Figure 180-12

1. When 0 °cutting operation is required, fasten the cutting work-piece as shown in figure 180-9. Then start the tool as shown in Fig. 180-11, wait for a moment until the saw blade reaches full speed, and then gently lower the saw blade to the cutting position. It is recommended to use the self-weight of the machine body to lower, and do not apply pressure. In special cases, slightly apply pressure to it, and do not apply too much pressure. At the end of cutting, gently lift the rack and fix it on the rack clamp to ensure that it will not fall. If it is necessary to cut fixed length work-pieces in batches, set the length to be cut by using the length positioning rod to perform the cutting operation.

2. When 45 ° cutting operation is required, as shown in figure 180-10, loosen the clamp bolt first, move the clamp to the 45o scale position, then fix the bolt and fasten the cutting work-piece. Then the cutting operation is performed as shown in Figure 180-12.

NOTE:

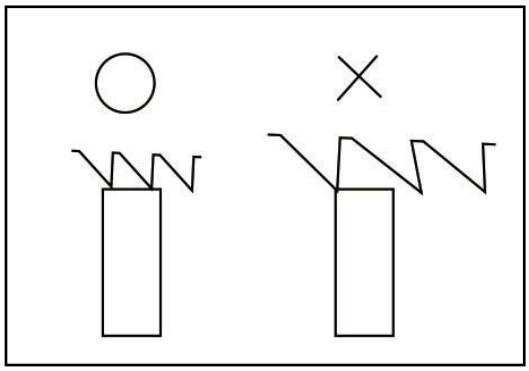


Figure 180-13

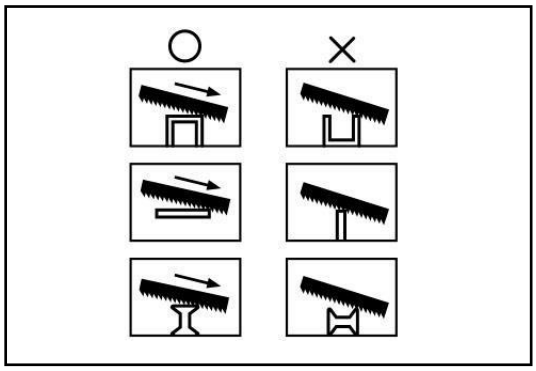


Figure 180-14

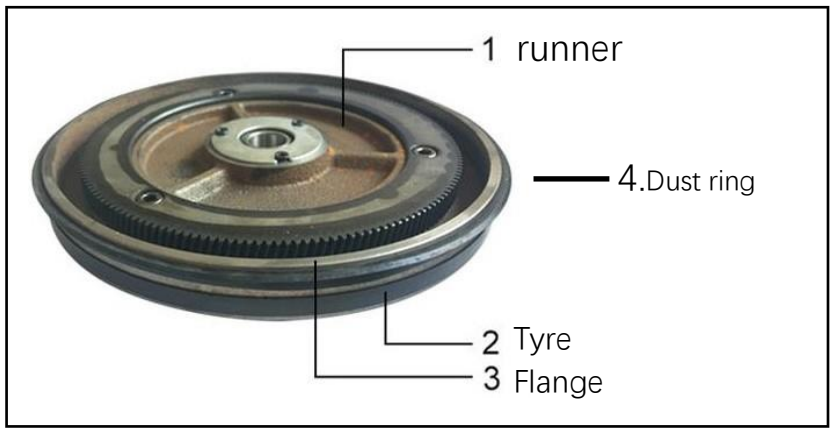


Figure 180-15

1. As shown in figures 180-13 and 180-14, at least two serrations shall enter the cutting seam during cutting, which is very important Yes. As shown in figure 180-13, select the correct cutting position for the work-piece.
3. After use, as shown in figure 180-15, clean the cutting wax, saw dust and dust on the tool and its runner, tire, flange and saw blade. If the saw blade slips off or the cutting position is poor due to severe tire wear, or the flange of the runner is damaged, replace the tire.

⚠CAUTION:

- before checking or maintaining tools, please turn off the power switch of tools and unplug the power plug.
- do not use gasoline, benzene, diluent, alcohol or similar items to clean tools. Otherwise, the tool may be discolored, deformed

or cracked.

- do not use turpentine, gasoline, varnish and other solvents to clean plastic parts.
- the wax and saw dust on the runner tire may cause the saw blade to slip off accidentally. Please use dry cloth to remove.

Optional accessories

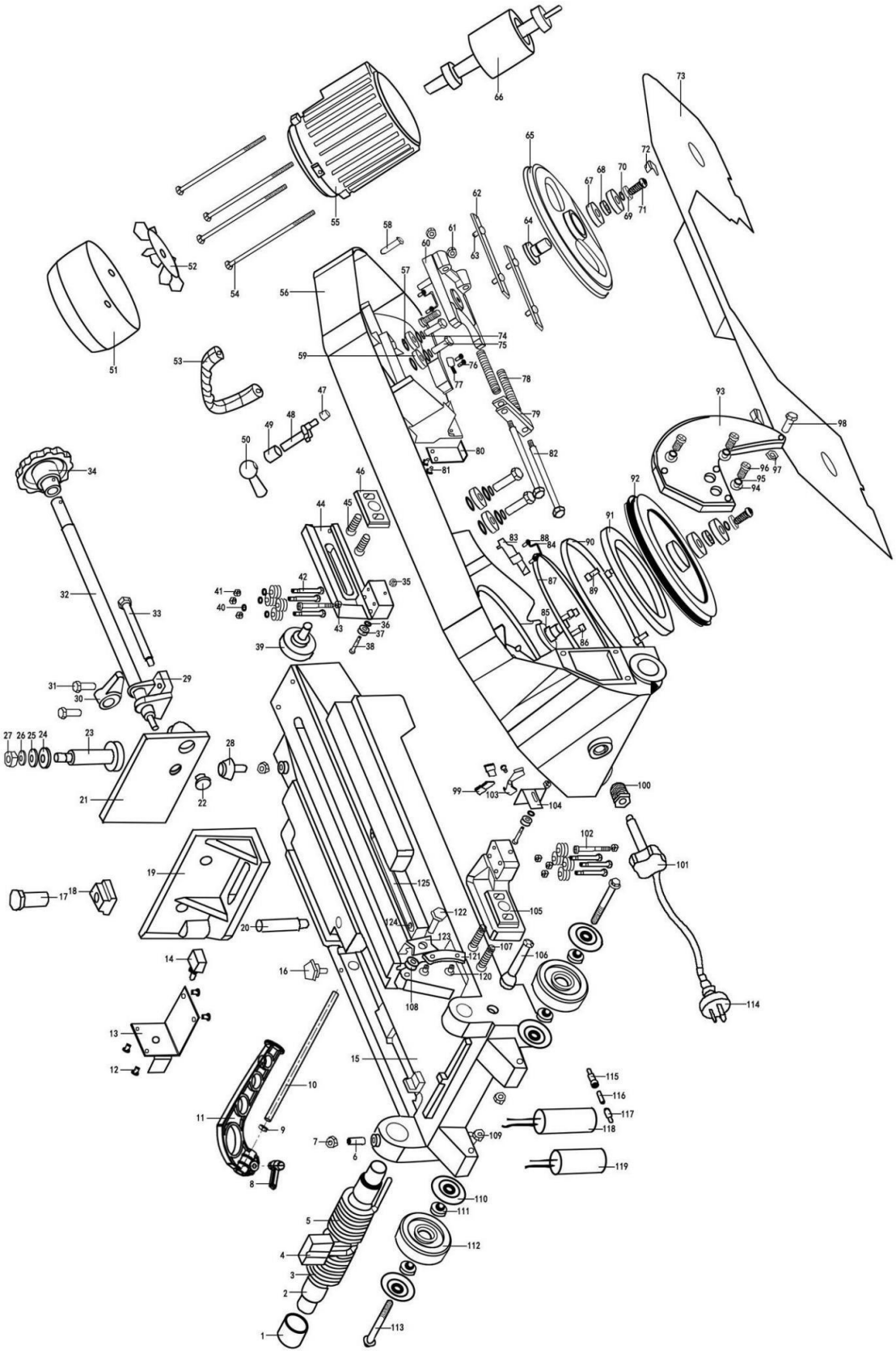
Blade size：13×0.65×1745mm

Tyre (Special rubber wear ring)

fault analysis

Common faults	Cause analysis	Resolution
Blade falling off	The saw blade is incorrectly installed and does not fit the guide bearing	Install the saw blade correctly according to the manufacturer's instruction video
	Guide arm bearing is incorrectly installed or worn	Correctly install or adjust the guide arm bearing
	Wheel rubber is worn or stained with oil	Check the rubber ring of the wheel to prevent oil
	The saw blade is stained with oil or water	Do not add oil or water during cutting
Abnormal fracture of saw blade	Incorrect tooth selection or saw blade material	Select the correct saw blade according to the cutting material and size
	The work-piece is not fixed properly and there is movement	Clamping work-piece
	Too fast vertical cutting speed	Adjust the lowering pressure of the saw frame
Loud noise	Friction between driven shaft and tension spring	Adjust the tension spring
	The driving gear teeth are worn or the meshing clearance is improper	Adjust the gear clearance or replace the gear
	Bearing wear of driving wheel and driven wheel	Pay attention to timely replacement of bearings

Motor smoke shutdown	Inaccurate voltage	Use the correct voltage according to the instructions
	Motor short circuit	Check the circuit of the motor or replace the stator of the motor
The cutting surface is rough and uneven	Serration wear leads to passivation and tip damage	Replace the saw blade
	Too fast vertical cutting speed	Adjust the lowering pressure of the saw frame
	The position of the guide arm and the work-piece is incorrect	Readjust the position of the guide arm and work-piece
	Incorrect tooth selection or saw blade material	Select the correct saw blade according to the cutting material and size
Cutting vibration	Incorrect tooth selection or saw blade material	Select the correct saw blade according to the cutting material and size
	The work-piece is not fixed properly and there is movement	Clamping work-piece
	Too fast vertical cutting speed	Adjust the lowering pressure of the saw frame
Premature passivation of serrations	Not running in at the beginning of use	The new saw blade shall be properly run in at the initial stage of use
	The work-piece surface is defective and the cutting hand is uneven	Check the work-piece and select the appropriate saw blade for correct cutting
	Work-piece inclusion hard guide block	Check the work-piece and select the appropriate saw blade for correct cutting
	Incorrect tooth selection or saw blade material	Select the correct saw blade according to the cutting material and size
	The saw blade is installed reversely	Properly install the saw blade
	The new saw blade cuts the old cut	Avoid cutting old cuts with new saw blades
	Too fast vertical cutting speed	Adjust the lowering pressure of the saw frame


1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28
29
30
31
32
33
34
35
36
37
38
39
40
41
42
43
44
45
46
47
48
49
50
51
52
53
54
55
56
57
58
59
60
61
62
63
64
65
66
67
68
69
70
71
72
73
74
75
76
77
78
79
80
81
82
83
84
85
86
87
88
89
90
91
92
93
94
95
96
97
98
99
100
101
102
103
104
105
106
107
108
109
110
111
112
113
114
115
116
117
118
119
120
121
122
123
124
125

1	Bearing sleeve	43	Nut	85	Driving shaft
2	axis	44	Left guide arm	86	Hexagon socket bolt with cylindrical head
3	Left torsion spring	45	Hexagon socket bolt with cylindrical head	87	Dust ring
4	Force adjusting plate	46	Backing plate	88	Cross recessed pan head screw
5	Right torsion spring	47	Rolling sleeve	89	Hexagon socket bolt with cylindrical head
6	Slotted tapered end fastening screw	48	Handle eccentric shaft	90	Wear resistant rubber ring
7	Nut	49	Guide sleeve	91	gear
8	Fastening screws	50	Wrench	92	Driven wheel
9	⌀ 12.5 nut	51	Motor protection cover	93	Swing arm
10	12.5x500 fixed length rod	52	Motor blade	94	Flat washer
11	Positioning rod	53	Handle eccentric shaft	95	Spring washer
12	Cross recessed pan head screw	54	Motor bolt	96	Hexagon socket bolt with cylindrical head
13	Switch board	55	Motor body	97	Nut
14	base	56	Saw frame	98	Bolt
15	Switch board	57	shim	99	Cover plate
16	Small hexagon pistol	58	Bolt	100	Adjusting nut
17	Hexagon bolt	59	Rolling bearing	101	Adjusting hand-wheel
18	T-nut	60	Tension plate	102	Eccentric screw of guide arm
19	Positioning clamp body	61	Nut	103	Brush rack
20	Locating pin	62	Pressing plate	104	Locating plate
21	Movable splint	63	Cross recessed pan head screw	105	Right guide arm
22	Briquette	64	Driven shaft	106	Wire holster
23	Support rod	65	Driven wheel	107	Hexagon socket flat head round screw
24	Reinforcing gasket	66	Electronic rotor	108	Spacer
25	Flat gasket	67	Rolling bearing	109	Spacer
26	Spring washer	68	Spacer	110	Protection plate
27	Nut	69	Washer	111	Protection plate
28	Ejector rod	70	Spring washer	112	Moving wheel
29	Bracket	71	Hexagon socket flat round head screw	113	screw
30	Clutch nut	72	Pull hook	114	Wire plug
31	Hexagon headed bolt	73	Rear cover plate	115	Fuse jacket
32	Screw rod	74	Spring washer	116	Fuse
33	Stabilizer bar	75	Hexagon headed bolt	117	Capacitor inner sleeve
34	Screw hand-wheel	76	Cross recessed pan head screw	118	Large capacitance

35	Nut	77	Pull hook	119	Small capacitance
36	Small washer	78	Pressure spring	120	Hexagon socket countersunk head screw
37	Rolling bearing	79	Tensioner U-plate	121	Limit plate of saw frame
38	Small hexagon bolt	80	Stop plate	122	Screw small shaft
39	Left guide arm hand-wheel	81	Cross recessed pan head screw	123	Saw frame stop plate 2
40	Spring washer	82	screw	124	Cross recessed pan head screw
41	Nut	83	Brush rack	125	a scale
42	Large hexagon bolt	84	rings		