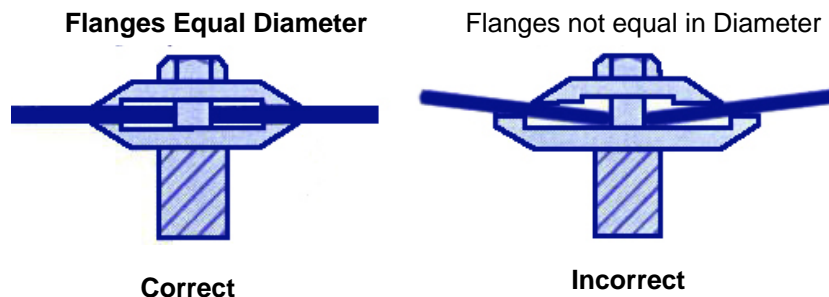


Cutting Off Wheels Safety Information

Machine Requirements:

1. **MUST** have adequate power.
It is best to have extra power to ensure efficiency
2. **MUST** be rigidly constructed, especially the arbour assembly
The machine must maintain a straight line cuts to be efficient and to avoid breakage.
3. **MUST** provide rigid support and “hold down” of piece being cut. Cutting wheels with stand a great deal of radial stress but NOT any side stress. Even reinforced wheels are not completely unbreakable. Side pressure **MUST** be avoided to ensure straight cuts and avoid possible breakage.
4. **Must** have adequate heavy duty arbour bearings to with stand operating stresses and continue to operate trouble free over long periods of time. Loose bearings can result in rough cutting and rapid wheel wear and even wheel breakage if end play develops.
5. **MUST** have adequate power transmission belting and belts must be kept tight to ensure full power transmission.



6. **MUST** have proper drive flanges. Minimum one-third of the wheel diameter.
 7. **MUST HAVE ADEQUATE GUARD OVER WHEEL.** Accidents can and do happen.
DO NOT USE A MACHINE THAT HAS IT'S GUARD REMOVED !!
 8. **MUST** be maintained in first class condition.
- All of the above machine features should be frequently checked and substandard conditions corrected.

Basic Abrasive Cutting Procedure

1. Be sure the workpiece is held securely (on both sides of the cut if practical)
2. Start the cut gently—Do not bump the wheel to start a cut
3. Feed the wheel through the work as fast as possible without slowing the wheel in the cut
Don't “baby” the wheel through the cut.

The abrasive operation generates a great deal of localised heat which causes rapid expansion of piece being cut. Wheels operated at a speed significantly below efficient speed or if fed through the cut too slowly will generate excessive heat . Result: *Rapid wheel wear, fraying around the edge of the reinforced wheels and wheel breakage.*

- **R.P.M. of the machine must never exceed R.P.M. indicated on the wheel.**
- **Do not use with out Machine Guard**
- **Always wear eye protection**
- **Always wear hearing protection and appropriate protective clothing**
- **Use in accordance with Australian / NZ Standard AS1788.2-1987**