

Operating Instructions

FOR EVERETT 8" & 10" ABRASIVE CUTOFF MACHINES

FORWARD

Operating techniques outlined in the guide are basic. Skill and techniques develop as the operator gains knowledge of the cutoff machine.

Your safety and the safety of others depends upon care and judgment in the operation of this machine. A careful operator is good insurance against an accident.

Most accidents, no matter where they occur, are caused by someone's failure to observe and follow simple and fundamental rules or precautions. For this reason most accidents can be avoided by recognizing hazards and taking steps to avoid them before an accident occurs.

Regardless of the care used in the design and construction of any type of equipment, there are conditions that cannot be completely safeguarded against without interfering with reasonable accessibility and efficient operation.

This information is not intended to cover all possible operating conditions. The user should contact Everett Industries in the event operating conditions or situations are encountered which are not dealt with in these operating instructions.

SAFETY INSTRUCTIONS

American National Standards Institute, ANSI, Safety Code Number B7.1 is the approved safety code for the use, care and protection of abrasive wheels according to the Occupational Safety and Health Administration, (O.S.H.A.), U.S. Department of Labor. Everyone using abrasive wheels and machinery must be familiar with this code and fully comply with it to insure against unsafe working conditions.

1. READ MACHINE OPERATING INSTRUCTIONS. NEVER START MACHINE WITHOUT COMPLETE UNDERSTANDING OF ITS OPERATION.
2. USE REINFORCED WHEELS ONLY.
3. RING TEST AND INSPECT EACH WHEEL BEFORE INSTALLING. DO NOT USE WHEEL IF CRACKED OR FRACTURED.
4. WEAR FULL FACE SHIELD WHEN OPERATING MACHINE.
5. MAKE SURE ALL SAFETY GUARDS ARE IN PLACE BEFORE STARTING MACHINE.
6. MAKE SURE WORK PIECE IS HELD FIRMLY IN VISE BEFORE STARTING MACHINE.
7. OPERATE WITHIN RATED MACHINE CAPACITY.
8. DO NOT OVER FEED CUTOFF WHEELS.
9. NEVER USE CUTOFF WHEELS FOR GRINDING.
10. ALWAYS KEEP WHEEL GUARD IN DOWN POSITION EXCEPT WHEN CHANGING WHEEL.
11. KEEP HANDS CLEAR OF CUTTING AREA.
12. OBSERVE ALL COMMON SENSE SAFETY PRACTICES.
13. SET UP MAINTENANCE PROCEDURES FOR CARE AND CLEANING OF MACHINE.
14. COMPLY WITH ANSI SAFETY CODE B7.1.

Applications for copies should be addressed to:

American National Standards Inst. Inc.
25 West 43rd Street 4th Floor
New York, New York 10036

COMPLY WITH OCCUPATIONAL SAFETY AND HEALTH ADMINISTRATION (OSHA), U.S. DEPT. OF LABOR,
(Standards are printed in the Federal Register) Applications for copies should be addressed to:
U.S. Government Printing Office
732 N. Capitol Street NW
Washington, DC 20401

**FAILURE TO COMPLY WITH ANY OF THESE INSTRUCTIONS
CAN RESULT IN SERIOUS BODILY INJURY.**

"WARRANTY: All Everett products are warranted against defective materials and workmanship, conditioned as follows. If a product is returned to Everett by the original purchaser prepaid within 1 year after delivery to the original purchaser and is judged by Everett to be defective, the product will be repaired, replaced or credited. This warranty is exclusive and in lieu of all other warranties of quality, whether written, oral, or implied (including any warranty of merchantability or fitness for purpose). Everett will not be liable for any consequential damages and **no claims will be allowed for repairs to Everett products by the purchaser or any third party.**"



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SETTING UP MACHINES

All machines should be leveled and secured to work stand or table.

ELECTRICAL CONNECTIONS

All electrical connections should be made by an experienced electrician in accordance with all applicable local and national electrical codes.

GROUNDING INSTRUCTIONS

1. All grounded, cord connected tools:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided – if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only extension cords that have grounding plugs and receptacles that accept the tools plug.

Repair or replace damaged or worn cord immediately.

SINGLE PHASE

If your new unit is wired for operation on **110 volt single phase**, you must install adequate fuses in your electrical system to avoid blowing a fuse when the machine is first started. We recommend delayed action, "Fusetron" type, rated for 40 amps.

If your unit is wired for 220 volt, single phase, use delayed action fuses rated for 20 amps.

Voltage changes can be made as diagramed on the motor nameplate.

If your machine slows down or stalls, check your voltage and make certain your wire is heavy enough. A long extension cord or wires that are too small will reduce the motor power. Wires should be at least #10 or larger.

Remove wheel nut and flange before testing for rotation. After connecting power line, check the direction of spindle rotation. It should be counter-clockwise standing on the right side of the machine. If it is rotating clockwise, interchange any two sets of leads. (SEE MOTOR NAMEPLATE IF SINGLE PHASE).

OPERATION

1. Secure workpiece in vise.
2. After slowly making contact between wheel and material, apply steady even pressure until the cut is complete.

Discoloration on dry cuts may indicate a cutting speed that is too slow or a wheel grade that is too hard. For wet cuts, discoloration may indicate cutting too fast for a wheel grade that is too hard.

CAPACITY

Do not exceed machine capacity:

8" Machine • 1" Solids, 1-1/2" Pipe • 10" Machine, 1-1/2" Solids, 2" Pipe

DRY CUTTING — USING THE PROPER WHEEL

Always use Everett fiberglass reinforced cutoff wheels. Everett wheels are designed especially for Everett abrasive cutoff machines — "Sever it with Everett" — to get longer wheel life and quality cuts. Machine warranty valid if Everett wheels are used. **EVERETT WHEELS ARE PRICED LOWER, LAST LONGER, CUT BETTER.** For cutting ferrous materials — iron, steel, etc., use the Everett #45FG internally reinforced or the Everett #45FGE externally reinforced wheel for all general purpose cutting. This wheel grade is the result of thousands of test cuts and will assure you of economical and efficient cuts on pipe, angle, channel, solids, stainless, etc.

DRY CUTTING SPEEDS

Fast cutting will insure maximum wheel life and cleaner cuts. Dry cutting time should be approximately 5 seconds per square inch of material cut.

WET CUTTING

Because most wet cutting wheels cannot be reinforced, use them with extreme caution on well guarded machines. OTHER WHEEL GRADES ARE AVAILABLE FOR PARTICULAR APPLICATIONS.

WET CUTTING SPEEDS

Because wet cutting is primarily recommended for **quality** of cut, rather than speed, slower wheel feeds **MUST** be used. Wet cutting speeds may vary depending on machine horsepower, wheel grade, material shape and hardness, and wheel feed.

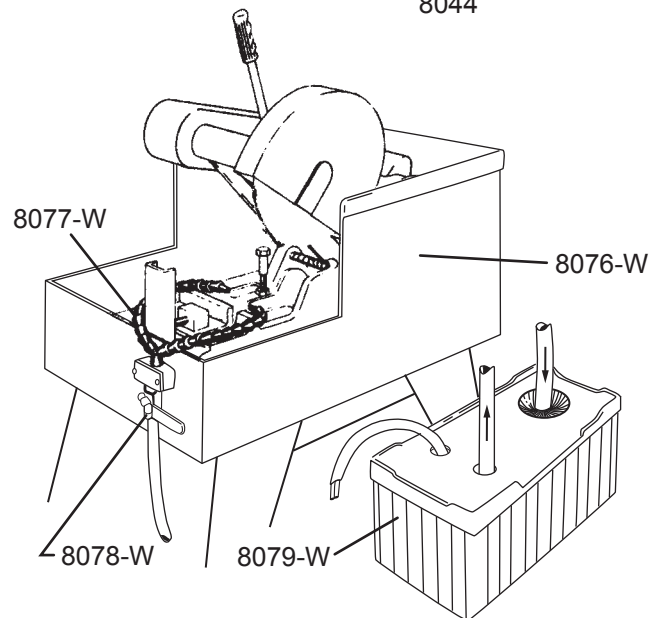
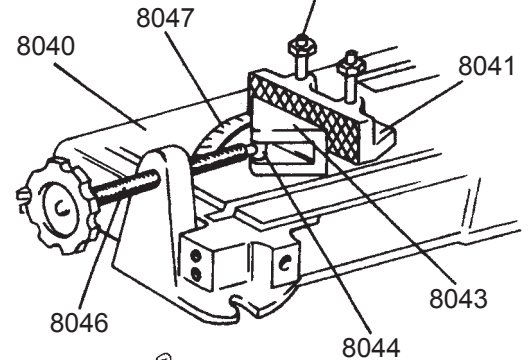
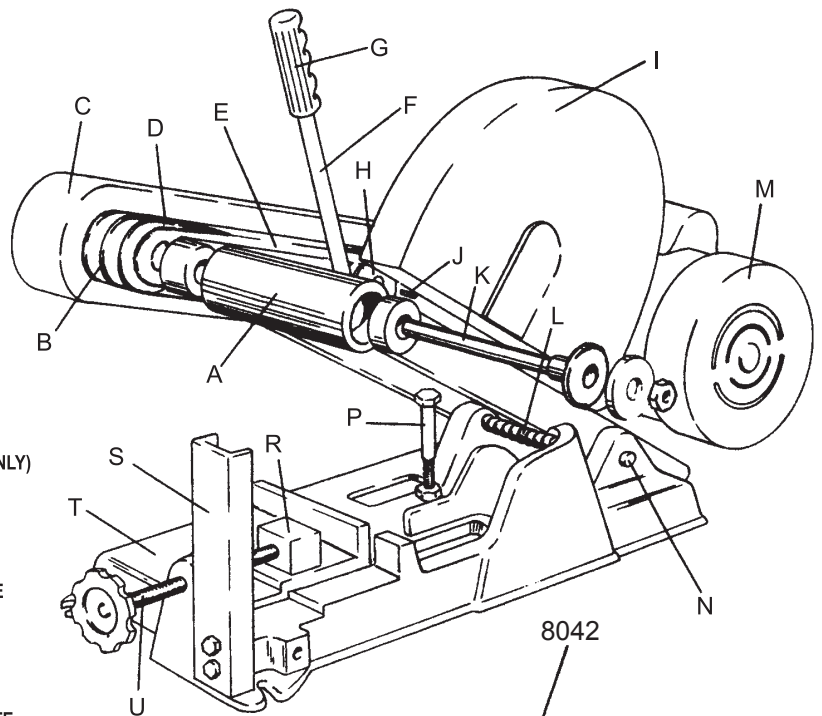
8 INCH - 10 INCH CUTOFF



REF. #	8" PART #	10" PART #	PART DESCRIPTION
A	8029	8009	ROCKER ARM
B	8050	8072	ARBOR PULLEY
		8073-W	ARBOR PULLEY 10" WET
C	8048	8038	OUTER BELT GUARD
D	8053	8074	DRIVE BELT(S)
		8074-W	DRIVE BELT WET
E	8049	8039	INNER BELT GUARD
F	8060	8060	HANDLE
G	8061	8061	GRIP
H	8052	8072	MOTOR PULLEY
		8072-W	MOTOR PULLEY 10" WET
I	8033	8012	WHEEL GUARD
J		8065	ARBOR PULLEY KEY
K	8031-A	8017-A	ARBOR SHAFT ASSEMBLY
L	8056	8071	TRUNNION PIN SPRING
M	8062	8062	MOTOR
N	8055	8069	TRUNNION PIN
P	8057	8067	DOWN STOP SCREW
R	8058	8022	WISE BLOCK (STR. CUTOFF ONLY)
S	—	8015	FRONT SPARK GUARD
T	8028	8008	BASE CASTING
U	8059	8018	WISE FEED SCREW
		8040	10" MITER BASE
		8041	10" MITER VISE ANGLE FENCE
		8042	10" MITER VISE BOLT
		8043	10" MITER VISE SWIVEL JAW
		8044	10" MITER VISE JAW PIN
		8046	10" MITER VISE FEED SCREW
		8047	10" MITER ANGLE INDEX PLATE
		8063	ON/OFF SWITCH (SPECIFY VOLTAGE)

ADDITIONAL 10" WET PARTS

8076-W	COOLANT TRAY
8077-W	FLEXIBLE HOSES (2 PER MACHINE)
8078-W	COOLANT VALVE
8079-W	PUMP & SETTLING TANK



A Word About Everett Abrasive Cutoff Wheels

The Everett Industries plant in Warren, Ohio houses our own cutoff wheel manufacturing facility. All the wheel grades listed below, for both dry and wet cutting, have been developed and extensively tested to produce quality cuts on a wide range of material alloys, sizes and shapes. By using only premium quality ingredients and exacting manufacturing methods, Everett cutoff wheels provide wheel grades designed for maximum performance on your new Everett cutoff machine.

Resinoid Bond Aluminum Oxide for Dry Cutting

Fiberglass Reinforced

Woven fiberglass cloth is molded in the wheel for break resistance.

45FG 45FGE	For general purpose cutting.
T32FG T32FGE	For cutting thin wall shapes and thin wall tubing.
23020FG 23020FGE	Designed for use on machines with POWERHEAD (automatic wheel feed) where free cutting ability is needed because of constant feed pressure.
GTK-7FG GTK-7FGE	Excellent for high quality dry cuts on stainless tubing and other thin wall tubing.
FG	Woven fiberglass cloth is molded in the center of the wheel for break resistance.
FGE	Woven fiberglass cloth is applied externally on both sides of wheel for break resistance.

Rubber Bonded Wheels for Wet Cutting

The following rubber bonded wheels cannot be fiberglass reinforced.

Use only on well guarded machines with extreme caution and personal protection.

#1410	For wet metallurgical sample cutting. Also excellent for high quality wet cuts on hardened material, tubing. Available in most sizes.
#1115	Calendered rubber wheel specially formulated for general purpose use on our 10" wet machine.
#1329	General purpose calendered rubber wheel, designed for wet cutting solids, heavy wall shapes and tubing. Produces fine cut, excellent for use on wet, power head machines. Available in 14", 16", 20" and 26".
#60	General purpose pressed rubber wheel, designed for wet cutting solids, heavy wall shapes and tubing. Larger grit sizes generally produce coarser cut than #1329. Available in all sizes.
#91	Designed for cutting nonferrous shapes — copper, brass, etc., rubber bond silicon carbide. Prices same as wet cutting wheels. Available in all sizes.

93FG Reinforced Wet Cutting Abrasive Cutoff Wheels

Fiberglass Internally Reinforced

Woven fiberglass cloth is molded in the center of the wheel for break resistance.

Pressed resin-rubber wheel; excellent for high quality cuts on hardened material, also metallurgical sample cutting. Available in most sizes.

We manufacture other grades of wet and dry abrasive cut-off wheels to meet specific requirements