



TO INFORM YOU

PRODUCT
SUPPORT
BULLETIN # 410

TO: AUTHORIZED *portable electric tool* SERVICE STATIONS
factory SERVICE / SALES SUPPORT BRANCH
SALES COMPANIES - Customer Centers

DATE: November 2003

TOOL(S) \ PRODUCT(S) AFFECTED: 6370-20 8" 13.0 Amp Metal Cutting Circular Saw

SUBJECT: 45-14-0020 Lower Guard Sleeve / Shim

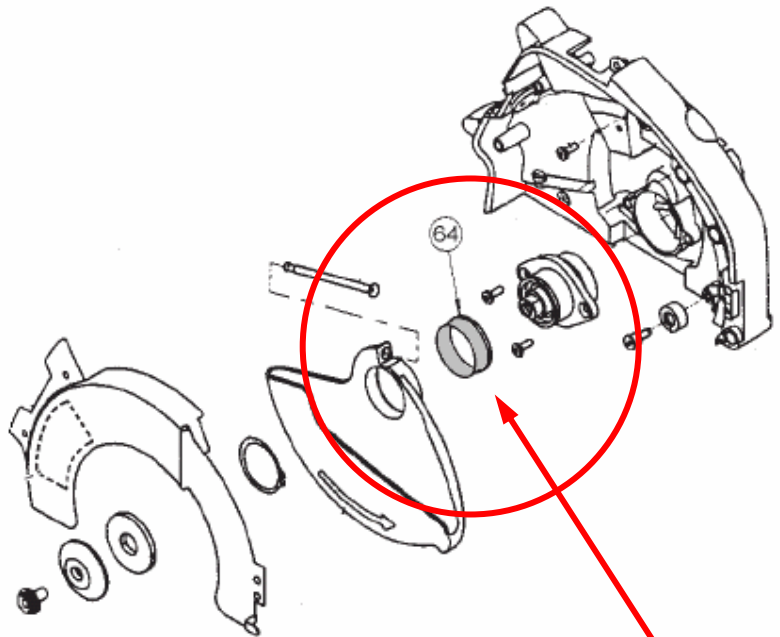
Operator of a Metal Cutting Saw should be informed to check lower guard for proper closing before each use. Never operate a saw if the lower guard does not move freely and close instantaneously.

Checking the Operation of the Lower Guard.

Lower Guard may operate slowly due to being damaged, to deposits or a build up of debris.

If lower guard does not immediately spring back to a fully closed position, clean the spindle hub & the lower guard to remove all chips and debris and replace lower guard sleeve / shim.

A close look at the Lower Guard checking ease of operation / return of the guard to its fully closed position and for a sleeve / shim with little or no embedded metal chips should be done at the time a metal saw is repaired.



Replacement of the **Lower Guard Sleeve / Shim – 45-14-0020** [fig. 64] should be considered **best practice** and done whenever a 6370-20 Metal Cutting Circular Saw is serviced.

SUBJECT: cutting material thicker than 1/4" [7mm] to a maximum of 3/4" [19mm]

Guidelines shown in the attached bulletin must be followed, when cutting material over 1/4" [0.2500" - 7mm] thick, to avoid damage to the tool or blade.

The 6370-20 8" Metal Cutting Saw has been designed to normally cut **26 to 10** gauge steel, used in steel framing and metal roofing & decking.
[26 ga - 0.0179" - 0.3mm] [10 ga - 0.1345" - 3.0mm]

- 6370 Metal Cutting Saw can make short cuts in metal up to 3/4" [0.7500" - 19mm], if guidelines are followed.
- Note! Understanding and following the **maximum cutting time, maximum length of cut, feed rate and cool down between cuts** in metal greater than 1/4" reduces the potential for motor 'burnt out' and damage to the Dry-Cut Cermet-tipped Metal Cutting blade [a lost of tooth / teeth].
 - It is very important that cuts with the metal cutting saw are straight, with the work piece being securely clamped in place. If, part way through a cut, a user finds that the cut is not straight, stop feeding the tool and release the trigger. Allow the blade to completely stop spinning. THEN remove the saw from the cut and start over. Blade life will suffer significantly, if work piece is not held securely or cut is not straight, allowing for side load and damage of the cermet-tips of the blade.

This bulletin is for informational purposes. PLEASE NOTE ON SERVICE PARTS LIST: 54-40-1625



CUTTING THICKER MATERIALS

Cutting Materials Thicker than 1/4" (3/4" Maximum Thickness)



CAUTION!

To reduce the risk of damage to the tool or blade, do not exceed the Feed Rate and Maximum Cut Time for materials thicker than 1/4", as charted below.

Between Maximum Cut Times, allow the tool to cool down for 60 minutes in still air or 6 minutes of running with no load.

Cutting too fast or too long in heavy material will damage the tool if the tool is not allowed to cool.

Cutting too slow will cause excessive wear on the blade.

When cutting materials over 1/4", certain guidelines must be followed to avoid serious damage to the tool and/or blade. The correct combination of the following factors will allow for a successful cut through thicker materials:

- Material Thickness** (do not cut materials thicker than 3/4")
NOTE: If the material thickness is not shown in the chart below, round up to the nearest thickness listed in the chart and follow those guidelines.
- Maximum Length of Cut** (the length of material in inches through which the saw moves between cool down periods)
- Feed Rate** (the speed at which the saw moves through the material in seconds per inch)
- Maximum Cutting Time** (the total amount of time that the saw can be under load between cool down periods)
- Cool Down Period** (60 minutes at rest or 6 minutes running with no load)

Material Thickness	Maximum Cutting Time (seconds)	Max Length of Cut	Feed Rate (sec./inch)(sec./cm)	Cool Down Period
3/8" (10 mm)	30 - 45	15" (38 cm)	2 - 3 (0,8 - 1,2)	60 min. at rest or 6 min. running with no load
1/2" (13 mm)	18 - 36	9" (23 cm)	2 - 4 (0,8 - 1,6)	
5/8" (16 mm)	18 - 30	6" (15 cm)	3 - 5 (1,2 - 2)	
3/4" (19 mm)	20 - 25	5" (13 cm)	4 - 5 (1,6 - 2)	