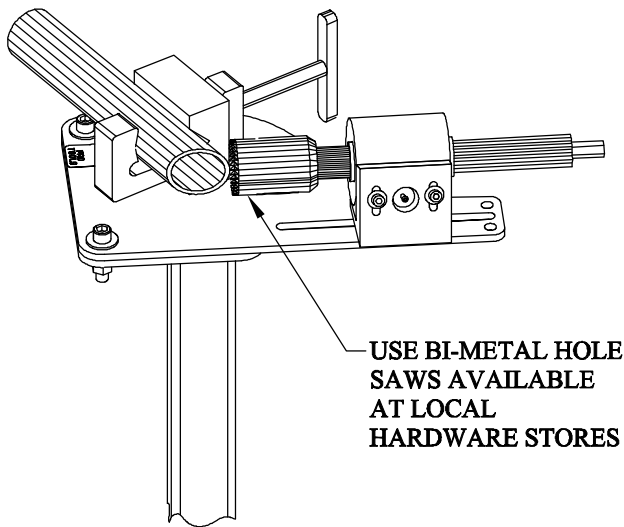
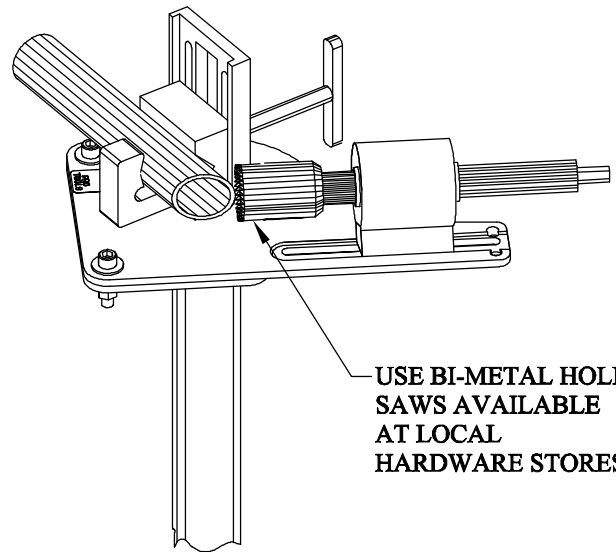

***OPERATING INSTRUCTIONS FOR
MODELS***

HSN-500



USE BI-METAL HOLE
SAWS AVAILABLE
AT LOCAL
HARDWARE STORES

HSN-501i



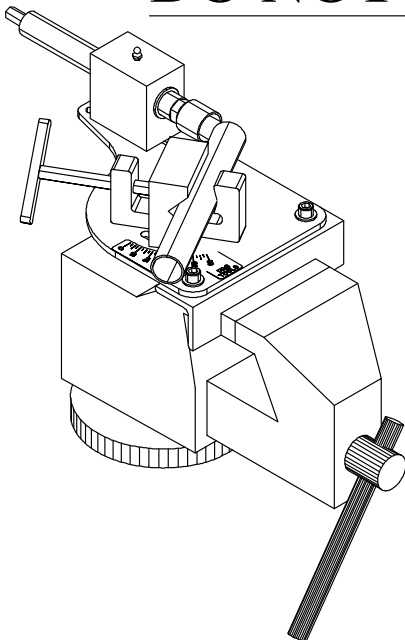
USE BI-METAL HOLE
SAWS AVAILABLE
AT LOCAL
HARDWARE STORES

HOLE SAW NOTCHER

OPERATING INSTRUCTIONS FOR MODELS HSN-500 & HSN-501i

- 1. SAFETY GLASSES MUST BE WORN WHEN OPERATING ANY CUTTING TOOL!**
- LOWER RPM'S ARE REQUIRED FOR CUTTING STEEL TUBING TO PREVENT OVERHEATING. **IMPORTANT:** RECOMMENDED OPERATING SPEED FOR HOLE SAWS IS **200 RPM'S OR LESS!**
- USING CUTTING OIL WILL PROLONG THE LIFE OF THE HOLE SAW AND WILL ENABLE YOU TO CUT FASTER.
- WHEN NOTCHING LARGER DIAMETER TUBES AT SHARP ANGLES, IT WILL HELP TO FIRST MITER CUT THE TUBE WITH A CUT-OFF SAW. THIS WILL KEEP THE SCRAP PIECE AS SMALL AS POSSIBLE (A LARGE SCRAP PIECE CAN GET JAMMED IN THE HOLE SAW AND PREVENT COMPLETION OF THE CUT).

DO NOT CLAMP IN VISE!

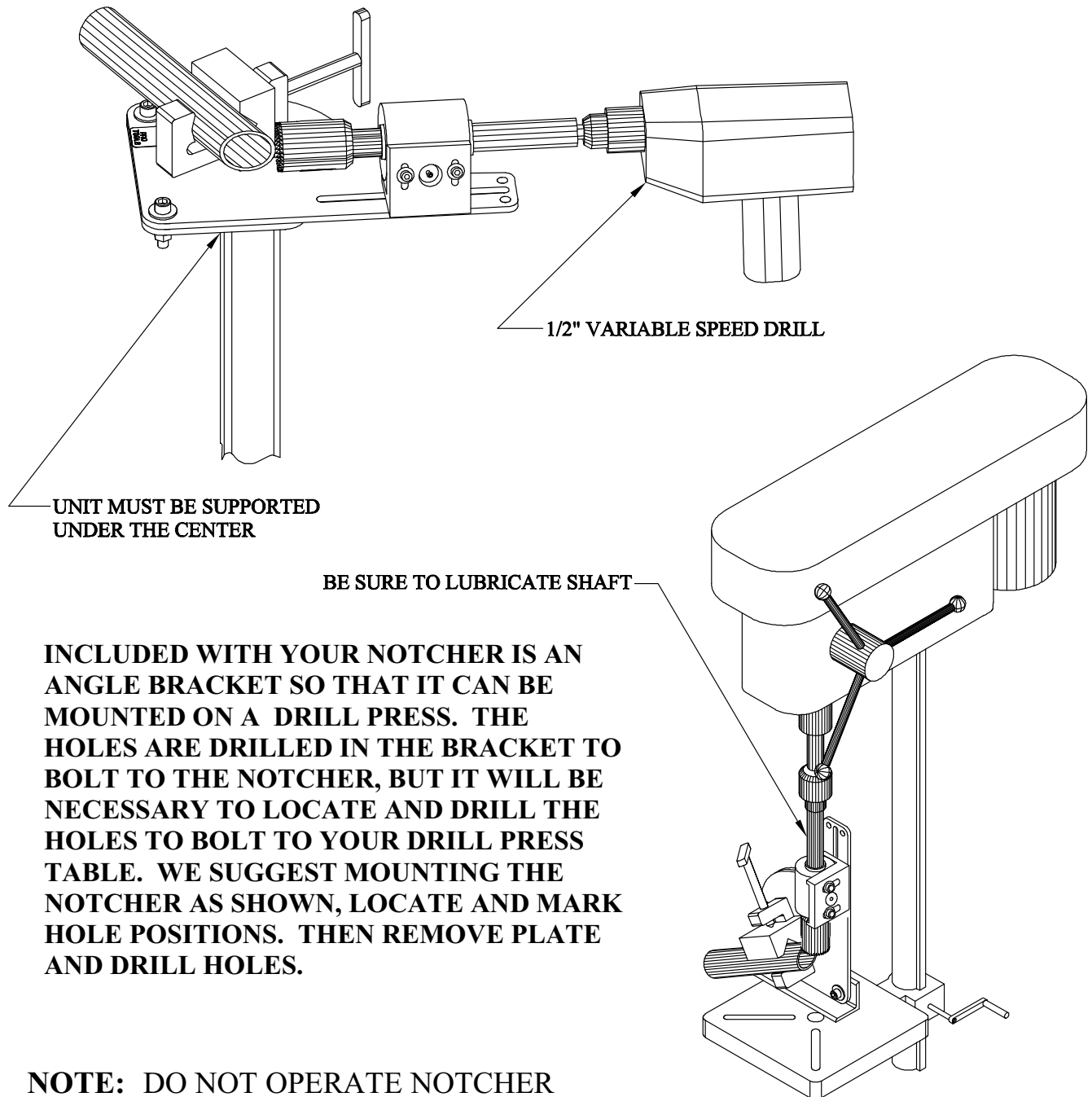


IF YOU ARE GOING TO USE THE NOTCHER IN A HORIZONTAL POSITION, IT WILL BE NECESSARY TO FABRICATE A STAND THAT WILL SUPPORT THE UNIT PROPERLY. CLAMPING THE UNIT IN A VISE, WITHOUT PROPER SUPPORT, WILL CAUSE THE NOTCHER TO FLEX AND CUT OFF CENTER.



HOLE SAW NOTCHER

OPERATING INSTRUCTIONS



UNIT MUST BE SUPPORTED
UNDER THE CENTER

1/2" VARIABLE SPEED DRILL

BE SURE TO LUBRICATE SHAFT

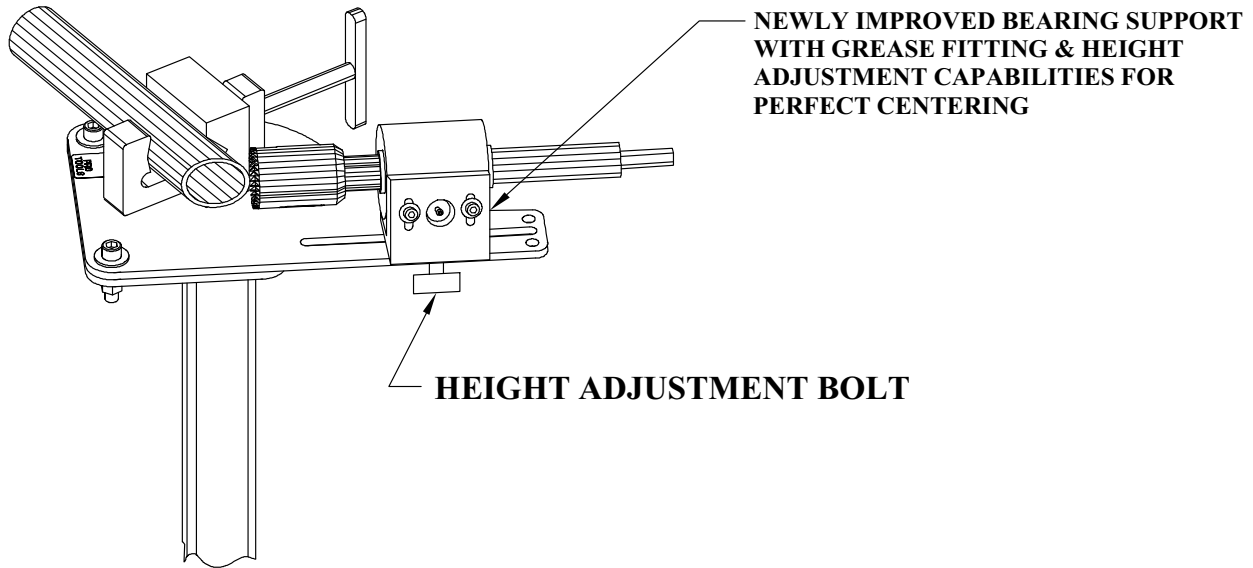
INCLUDED WITH YOUR NOTCHER IS AN ANGLE BRACKET SO THAT IT CAN BE MOUNTED ON A DRILL PRESS. THE HOLES ARE DRILLED IN THE BRACKET TO BOLT TO THE NOTCHER, BUT IT WILL BE NECESSARY TO LOCATE AND DRILL THE HOLES TO BOLT TO YOUR DRILL PRESS TABLE. WE SUGGEST MOUNTING THE NOTCHER AS SHOWN, LOCATE AND MARK HOLE POSITIONS. THEN REMOVE PLATE AND DRILL HOLES.

NOTE: DO NOT OPERATE NOTCHER
UNLESS IT IS SECURELY MOUNTED



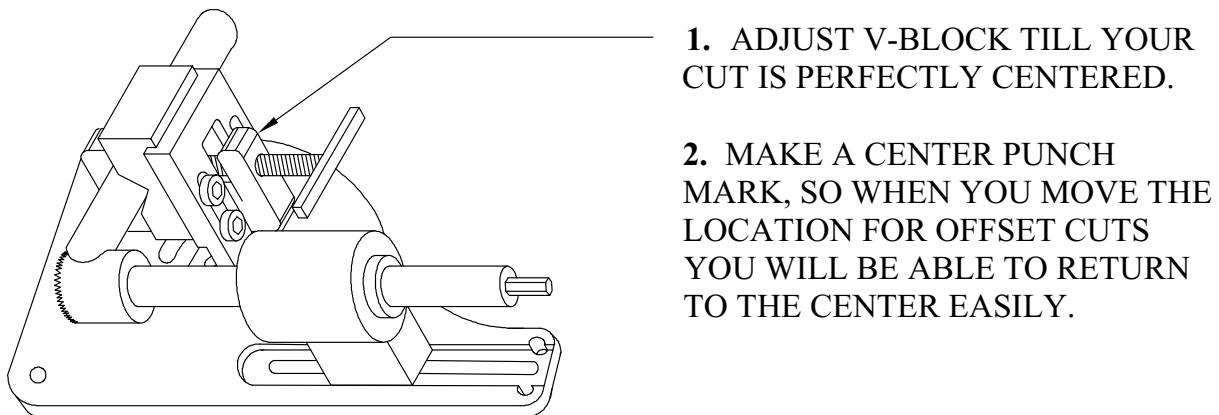
OPERATING INSTRUCTIONS

HSN-500



**NEW HEAVY DUTY MODEL WITH
ADJUSTABLE V-BLOCK**

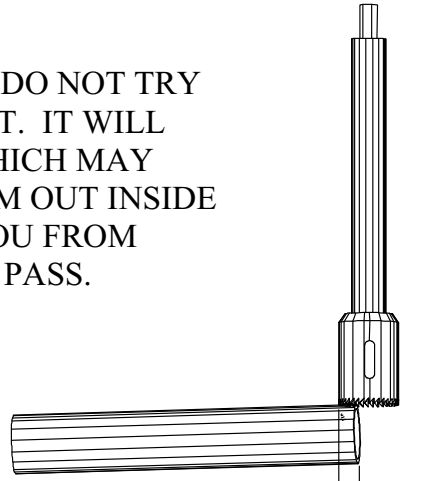
HSN-501i



OPERATING INSTRUCTIONS

WHEN MAKING YOUR NOTCH, DO NOT TRY TO MAKE TOO LARGE OF A CUT. IT WILL PRODUCE SCRAP BUILD-UP WHICH MAY HIT END OF SHAFT, OR BOTTOM OUT INSIDE THE CUTTER AND PREVENT YOU FROM COMPLETING THE CUT IN ONE PASS.

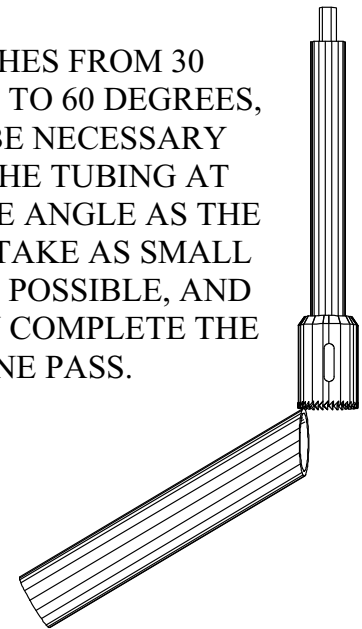
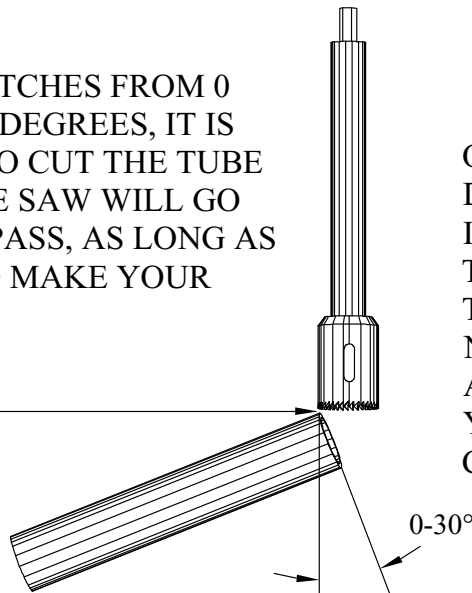
REMEMBER TO LUBRICATE SHAFT. EITHER MOTOR OIL OR WHEEL BEARING GREASE WILL WORK



KEEP SCRAP PIECE AS SMALL AS POSSIBLE

WHEN MAKING NOTCHES FROM 0 DEGREES UP TO 30 DEGREES, IT IS NOT NECESSARY TO CUT THE TUBE ON AN ANGLE. THE SAW WILL GO THROUGH IN ONE PASS, AS LONG AS YOU DON'T TRY TO MAKE YOUR NOTCH TOO DEEP.

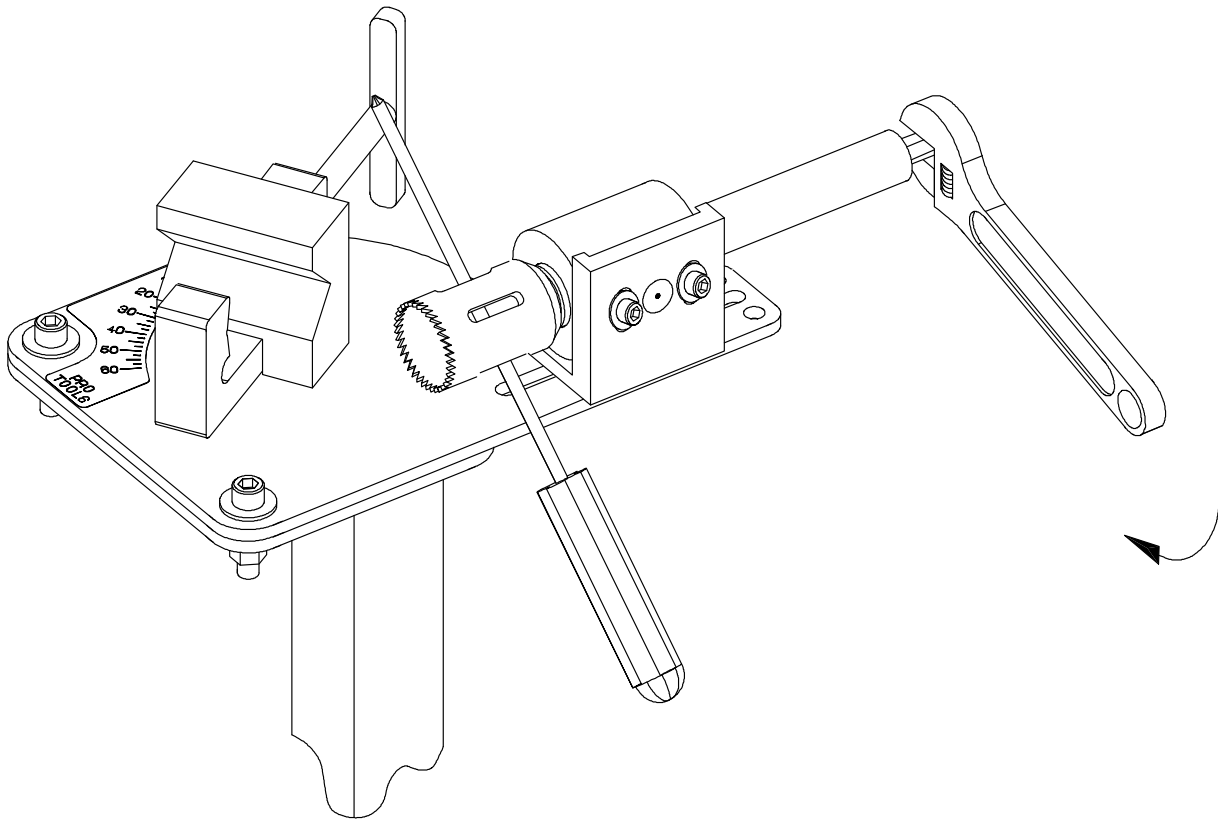
ON NOTCHES FROM 30 DEGREES TO 60 DEGREES, IT WILL BE NECESSARY TO CUT THE TUBING AT THE SAME ANGLE AS THE NOTCH. TAKE AS SMALL A CUT AS POSSIBLE, AND YOU CAN COMPLETE THE CUT IN ONE PASS.



REMEMBER TO START YOUR ANGLE CUTS WITH THE LEAST AMOUNT OF MATERIAL POSSIBLE. AS YOU CUT THROUGH, THE MATERIAL WILL BECOME THICKER AND COULD STOP THE CUTTER FROM GOING THROUGH IN ONE PASS.



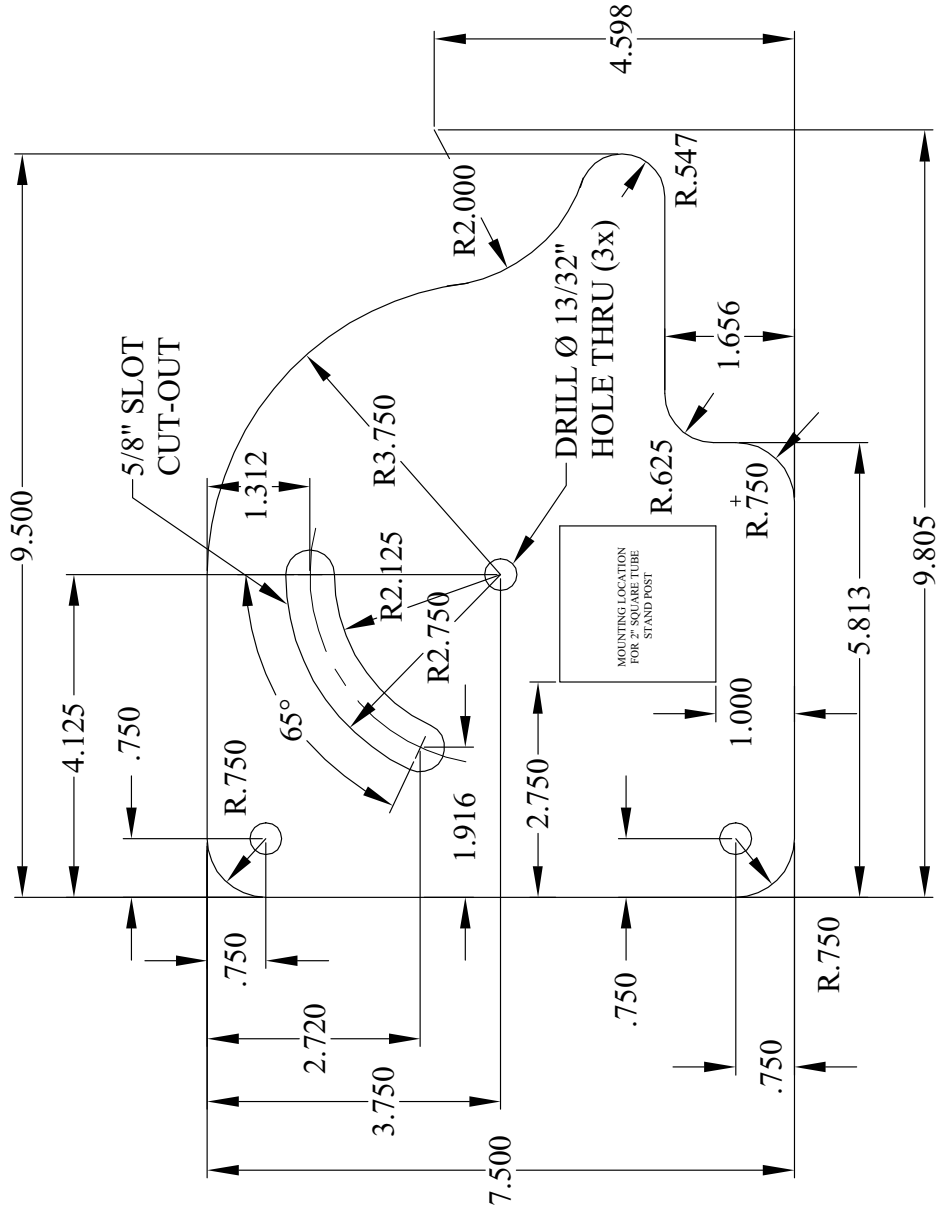
OPERATING INSTRUCTIONS



WHEN IT IS TIME TO REMOVE THE HOLE SAW, YOU WILL FIND THAT IT HAS BECOME VERY TIGHT, AND VERY DIFFICULT TO LOOSEN. SIMPLY INSERT A SCREWDRIVER OR FLAT PIECE OF METAL COMPLETELY THROUGH BOTH SIDES OF THE HOLE SAW. USE AN ADJUSTABLE WRENCH ON THE HEX END AND LET THE SCREWDRIVER BOTTOM OUT ON THE PLATE, AS YOU TURN THE SHAFT WITH THE WRENCH. **(CAUTION):** IF YOU ONLY INSERT THE SCREWDRIVER THROUGH ONE SIDE, IT WILL DEFORM AND CRACK THE HOLE SAW.



NOTCHER TOP PLATE DRAWING

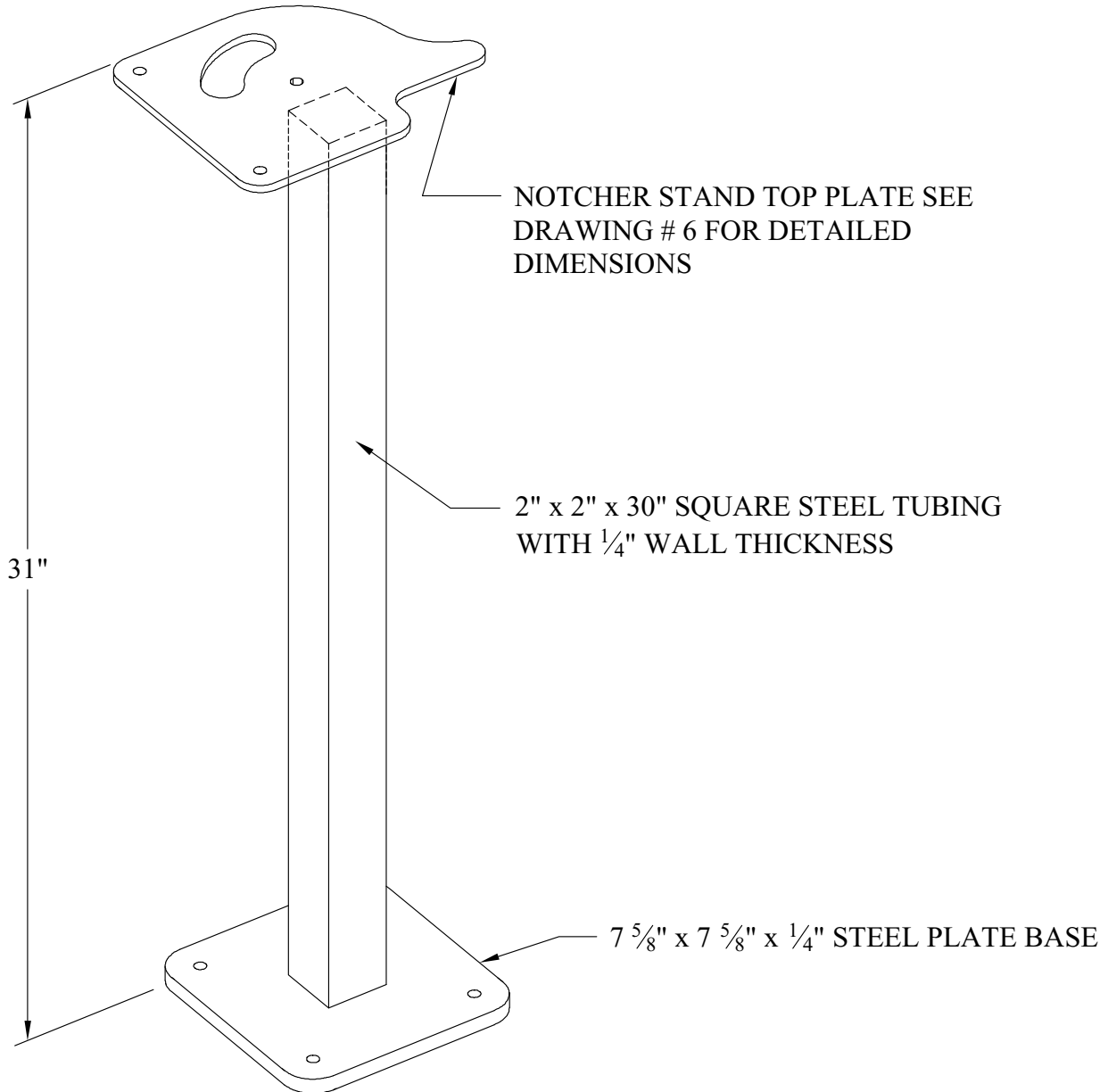


NOTE:

WHEN MOUNTING THE NOTCHER ON A STAND, IT IS NECESSARY TO SUPPORT IT PROPERLY TO PREVENT FLEXING -- ABOVE IS THE ENGINEERING DRAWING FOR MAKING A NOTCHER TOP PLATE -- OR WE HAVE TOP PLATES MACHINED & READY TO WELD.



DRAWING FOR STAND PLANS



NOTE: USE 3/8" LAG BOLTS TO SECURE TO CONCRETE FLOOR

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