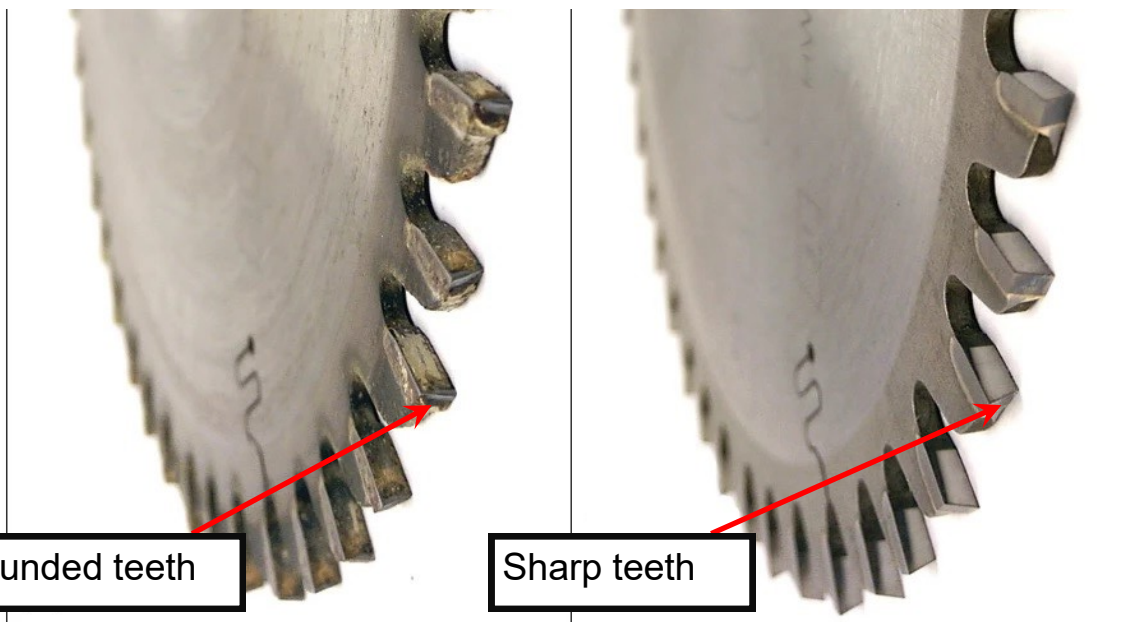


Check for signs of blade wear:

- A. Rounded or chipped teeth
- B. Increased tear out and chipping when cutting.
- C. Burn marks that were not happening before on similar cuts.
- D. Saw motor is becoming louder when making cuts.



Blade quality makes a big difference in cut quality. We sell high quality carbide-tipped blades that are built to last.
Call 515-232-3188 or email support@razorgage.com for pricing.

REPLACEMENT BLADES

18" Wood blade RGX00472
(Pocket Hole Saw)

24" Wood blade RGX00473
(Cyclone 600)

24" Aluminum blade RGX00474
(Cyclone 600)

20" Wood blade RGX01124
(Cyclone 500 & 600)

20" Aluminum blade RGX01220
(Cyclone 500 & 600)

Do not exceed the rated RPM of the blade. Motor speed is adjustable only on saws equipped with a VFD.

Do not cycle through your material faster than your blade can handle. Harder materials require a slower cycle.

Adjust the flow controls located on the back of the saw to slow down the cycle speed.



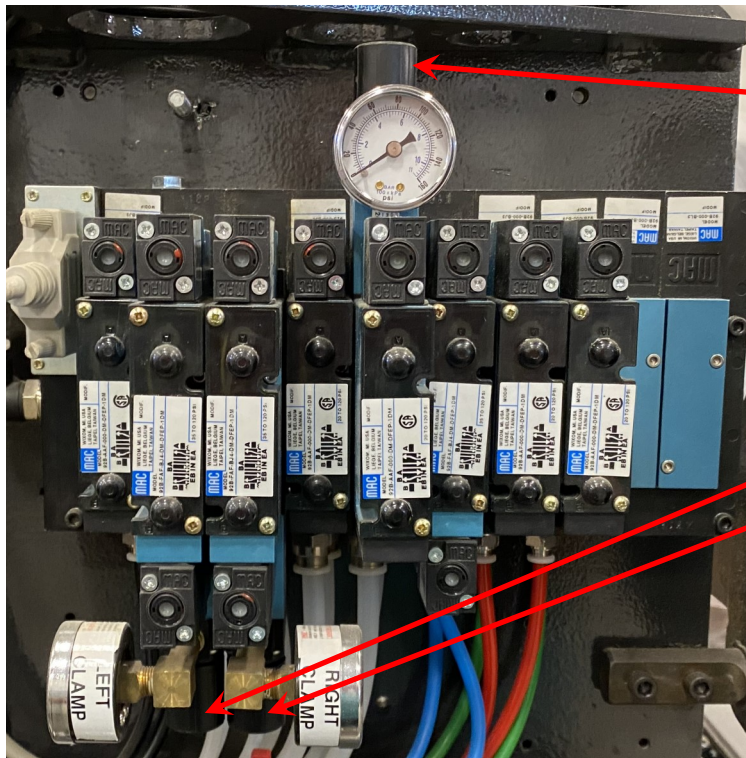
POCKET HOLE SAW



CYCLONE 600 SAW

Make sure the clamp pressure is set high enough to firmly hold the part while cutting. A minimum pressure of 40 psi is recommended.

The clamp regulators are located either on the valve or on a separate in-line regulator.



VERTICAL CLAMP

LEFT CLAMP

RIGHT CLAMP

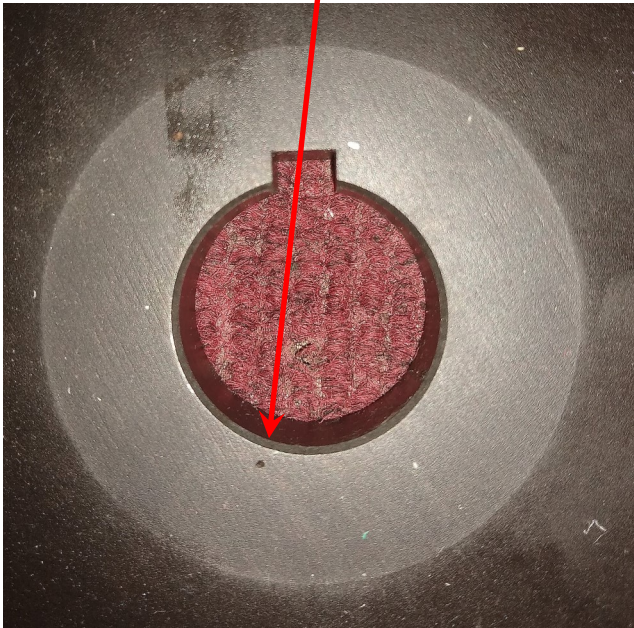


Cut Quality Troubleshooting (Vibration Issues)

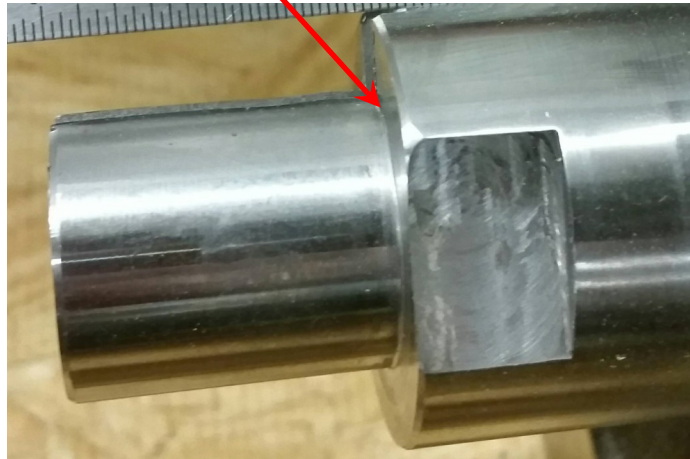
Bad vibration can also reduce cut quality.
Check the following items to reduce vibration.

Make sure there is no shim behind the inner arbor plate. Also make sure the inner arbor has a chamfer big enough to accommodate the spindle shoulder radius.

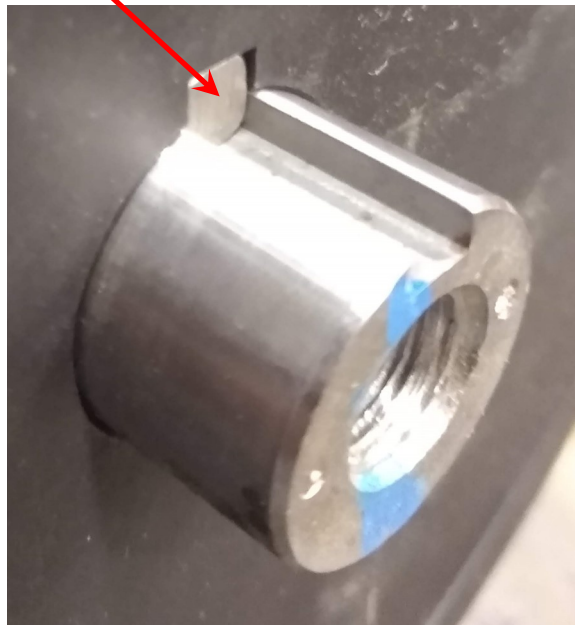
ARBOR PLATE
CHAMFER



SPINDLE SHOULDER
RADIUS



Make sure the arbor key is not longer than the arbor plate thickness.



Cut Quality Troubleshooting (Vibration Issues)

Make sure the assembly is thick enough that the bolt can tighten down properly. The bolt tightens in the opposite direction of blade rotation.



The arbor bolt for the Cyclone saw has left-hand threads.



The arbor lock nut for the Pocket Hole saw has right-hand threads.

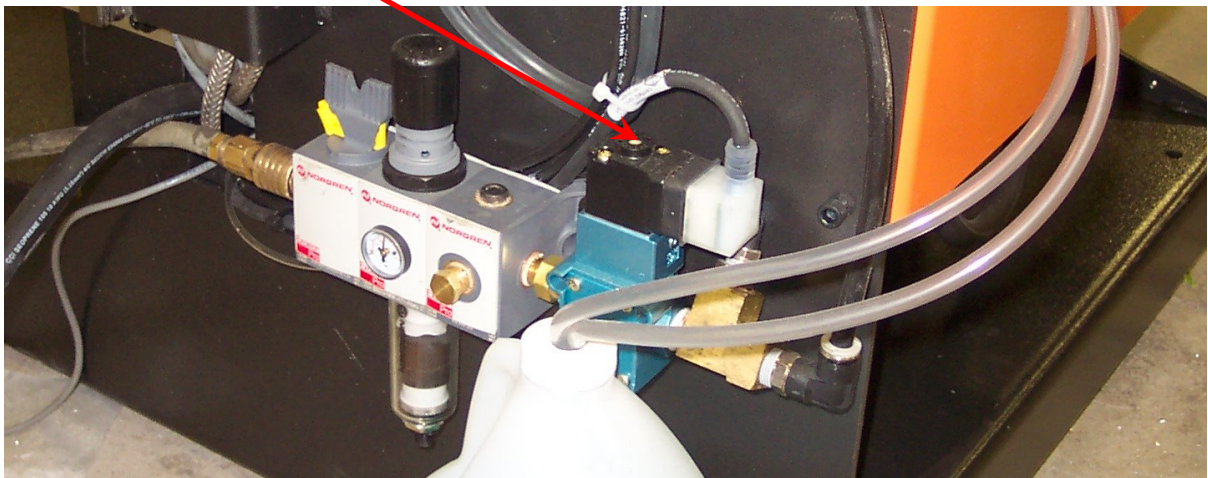
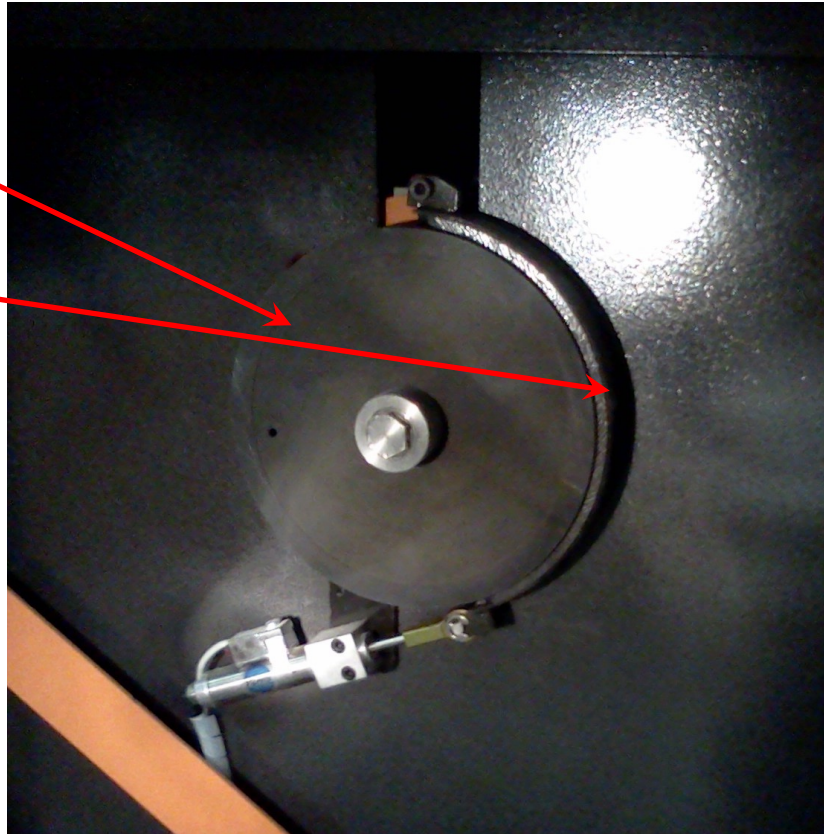
Cut Quality Troubleshooting (Vibration Issues)

If your saw is equipped with a mechanical brake make sure the brake is fully releasing when the saw starts. This can be tested without starting the saw by manually triggering the dump valve.

BRAKE DRUM

BRAKE SHOE

DUMP VALVE
MANUAL TRIGGER



Cut Quality Troubleshooting (Wood Cutting)

If you are cutting wood pitch buildup can significantly reduce cut quality.



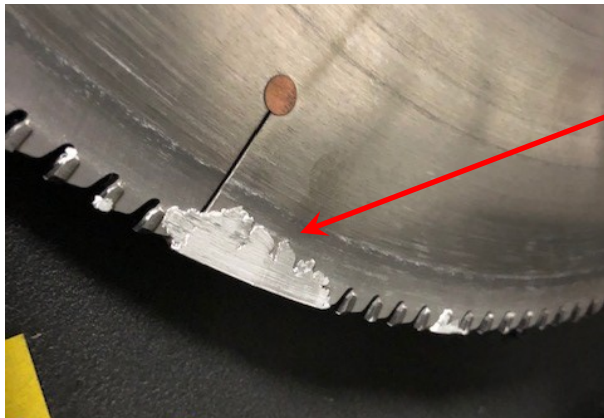
The blade should be cleaned with a solution made for cleaning blades. Soak the blade in the solution for a few minutes. Use a brass or plastic bristle brush to scrub the pitch off the blade teeth. Dry the blade thoroughly when finished.

Cut Quality Troubleshooting (Aluminum Cutting)

If cutting aluminum make sure the mister is working properly.
If the mister is not working properly you will likely be getting a very bad cut such as the one below.



Without a functioning mister the blade is very likely to get material stuck in the teeth.

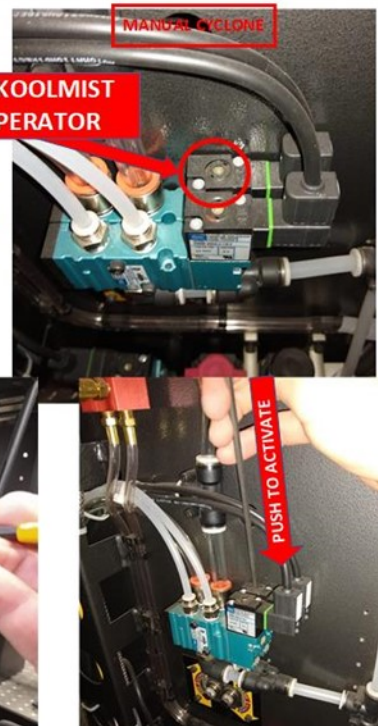
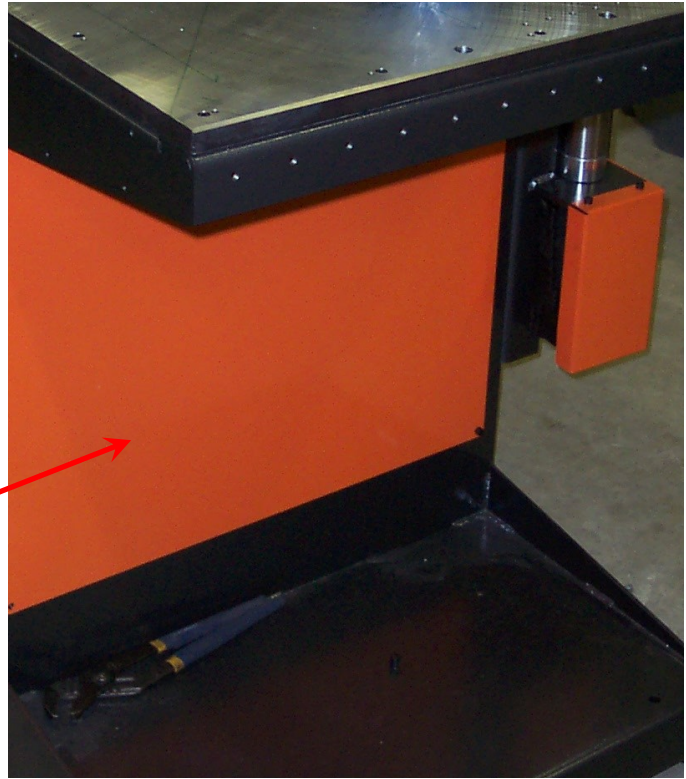


Teeth loaded with debris

Cut Quality Troubleshooting (Aluminum Cutting)

To make sure the mister is working properly first remove the blade access door guard. Hold the dump valve manual operator and the blade advance operator. This will extend the blade without requiring the motor to be on. Have someone else feel for coolant at the coolant nozzles.

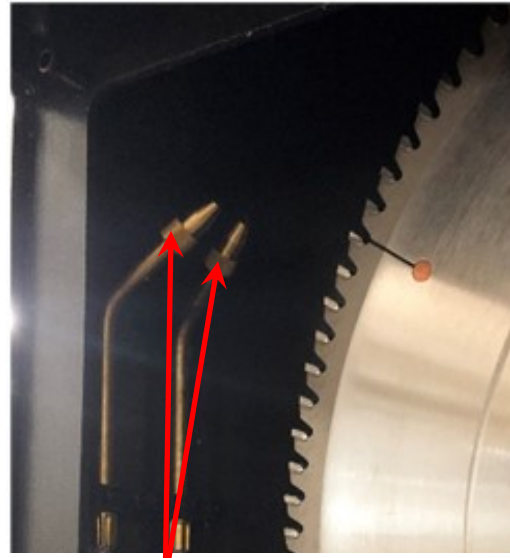
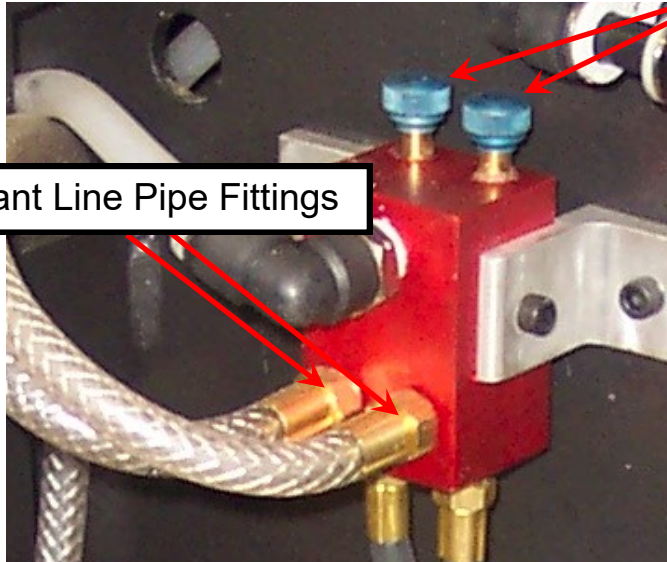
Blade Access Door



Cut Quality Troubleshooting (Aluminum Cutting)

If you feel some coolant coming out of the nozzles, but not enough, try opening the nozzle end a little more. If you can only feel air coming out of the nozzle try going through the mister setup procedure below.

1. Close both air valve stems all the way. Then open each one full turn.



2. Close both nozzle caps all the way. Then open each 1/4 turn. Trigger the mister again by holding the dump valve and saw valve. Once you feel a fine spray at the nozzle the amount can be adjusted by opening the nozzle and/or valve stem a little more.

If you still feel no mist after following these steps check the following items.

1. Are there bubbles in the coolant tank? If so either the nozzles are open too far or the coolant line fittings into the valve block need tightening. Before tightening the coolant line fittings make sure the nozzles are open at least 1/4 turn and the valve stems are open at least one turn. Do not over-tighten the coolant lines. This can damage the seals and cause the mister to not work. If you suspect the coolant line seal is damaged it will need to be replaced. After tightening the fittings try the mister again to make sure no new bubbles are forming.

Cut Quality Troubleshooting (Aluminum Cutting)

2. Make sure the syphon line connections are tight in the block and the lines aren't leaking.
3. Make sure none of the air or coolant lines are kinked.
4. Do not use more than 6 oz of coolant per gallon of water. Use filtered water.
5. The check valve may be clogged. Don't leave it submerged in the coolant jug overnight. If the check valve is clogged it will need to be replaced.

KOOL MIST REPLACEMENT PARTS Available at www.koolmist.com

| <u>PART DESCRIPTION</u> | <u>PART#</u> |
|------------------------------|--------------|
| Coolant line seal | 10CS |
| Syphon line assembly | 10SL-4 |
| Syphon line check valve only | 10BC |