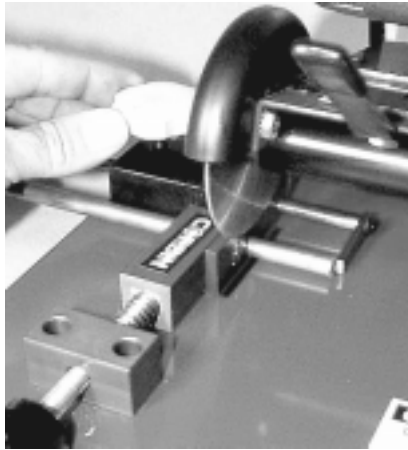


**Unplug the saw before making any adjustments!**



Set the length of tube to be cut off by positioning the stop. Lock the stop with the large grey knob. Do not over-tighten. If you wish to use the vise as a guide only, adjust it so that you can just slide the tubing between the jaw and the back stop with no side play.

Loosen the vise clamp, and insert a length of tubing to the stop. Set the vise clamp so the tubing is held snugly by spring pressure but can be moved forward without loosening the clamp.



Plug in and turn on the saw. Gently lower the saw blade so it cuts through the tube. Let the saw do the work (forcing it only clogs the teeth and breaks the belt).

The cut piece is usually flicked out by the passing saw teeth, so you can set up a box to act as a catcher.



Never reach in to clear a cut piece without first turning off the saw! The back legs of the saw are longer than the front legs, so that the saw sits at an angle to allow cut pieces to roll forward. The motor and arbors are set at a slight cant to compensate for belt torque. Do not "straighten out" the relation of the upper and lower mounting plates, as this will cause excess belt wear and breakage.

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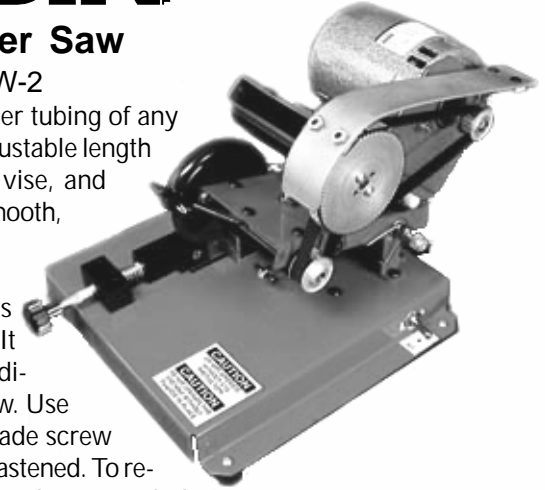
**CORBIN**

## **Tubing Cutter Saw**

**Cat.No. SAW-2**

Cut precise lengths of copper tubing of any length. The saw features adjustable length stop, spring-loaded clamp vise, and gear/belt-drive system for smooth, clean cuts.

**Important:** The saw blade is held on by a left-hand screw. It is removed in the opposite direction from a normal screw. Use only a hardened, aircraft grade screw and make sure it is securely fastened. To remove the blade easily, unplug the saw, unbolt the pivot screw and remove the motor assembly from the base.



**Never touch the blade or put your hands near the drive pulleys when the unit is plugged into power!** Always wear eye protection when using this tool.

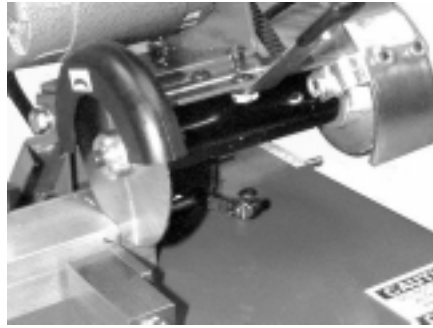
The saw blade is made for cutting non-ferrous metals like copper and aluminum. Do not attempt to cut steel rod or tubing. The blade will have longer life if you use a mist coolant to spray the sides or the contact against the work piece. Appropriate mist coolant systems are available from most machine tool supply companies.

The belts and blade will last longer if the operator feeds the saw gently into the work, and lets the saw clear its own path rather than forcing it through the cut. The belt may be broken if the operator applies excessive force in attempting to make the saw cut faster. Use the vise as a guide or as a clamp to hold tubing from 1/8 inch OD up to a maximum of 5/8 inch OD. Up to 2.5-inch long pieces can be cut from the end of the tubing. For longer pieces, use the SAW-2 which can cut in the middle of a tube of unrestricted length.

**Motor Specifications:** 115 volt 60Hz 2.9 Amps 1/5-HP 10,000 rpm  
**Spindle:** Ball bearing, belt drive  
**Saw arbor:** 1/4-inch (.250)  
**Saw diameter:** 3-inch by .032 thick  
**Net weight:** 12 lbs  
**Tubing capacity:** 1/8 to 5/8 in.diam  
**Tubing wall:** Up to .050-in

## **Differences between SAW-1 and SAW-2 models:**

The SAW-2 is built with a dual spindle drive, which allows infinite lengths on either side of the saw blade, whereas the SAW-1 can cut up to about 3-inch lengths from one end of a piece of tubing.



When cutting long pieces of tubing in the SAW-2, it is advisable to support both ends of the tubing to prevent the cut section from acting like a lever and prying sideways on the spinning saw blade, which could break it.

***Warning: Do not attempt to cut stainless steel or other non-ferrous metals. Do not attempt to cut tubing or rod with a diameter smaller than 1/8 inch.***

## **Replacing the saw blade and belts:**

### ***Disconnect the power first!***

The SAW-1 blade is the same as the SAW-2 blade. The SAW-1 blade can be replaced more easily by removing the pivoting upper assembly from the base. The upper assembly includes the motor and spindle mounted on a mounting plate, and secured by a hinge bolt. Removing the hinge bolt allows removal of the upper assembly, which in turn makes access to the blade much easier.

Or, the spindle assembly can be unfastened from the mounting plate, allowing it to drop down and provide more access to the blade. A left-hand threaded, hardened screw is used to hold the blade on the shaft. Do not substitute any other hardware! Doing so could be dangerous. Replacement blade bolts (SAW-BB) are available from Corbin.



The SAW-2 should NOT be disassembled when replacing belts. The angle between plates is carefully adjusted to compensate for belt torque, to keep the belts running straight without rubbing on the pulley. If you see a build-up of rubber on the side of the reducer pulley on the upper spindle, it means the saw is not properly aligned and belt life may be shortened.

To remove belts, loosen the two round head hex screws that hold the upper spindle to the bottom of the middle upper mounting bracket. This allows the spindle to drop slightly, and relieves pressure on the belt so you can roll it off or on again.



The larger drive belt (primary drive from motor to large gear pulley) can be "walked" off the pulleys by applying gentle side pressure while turning the pulley by hand. The upper spindle has two gear pulleys on one end and nothing on the other end. The lower spindle has the saw blade on one end and a small pulley on the other.

The belt on the lower spindle can be removed by loosening the two round headed hex screws that secure the spindle to the lower mounting plate. This will not affect the alignment of the two plates, and is the most effective way of getting the lower belt on and off.

The belt on the lower spindle can be removed by loosening the two round headed hex screws that secure the spindle to the lower mounting plate. This will not affect the alignment of the two plates, and is the most effective way of getting the lower belt on and off.

Belts normally last a long time unless the operator stalls the saw by forcing it into the work. When the saw is forced, the belts stretch and may break prematurely. The appearance of the two plates is such that operators may view them as canted or out of square, and try to "fix" this by adjustments of their relation to each other. This is a mistake, as it destroys the slight counter-bias which keeps the belts running true without rubbing on the larger reducing gear pulley. A slight cant in the alignment of the two plates is a necessary feature.

