



General information and directions for operation.

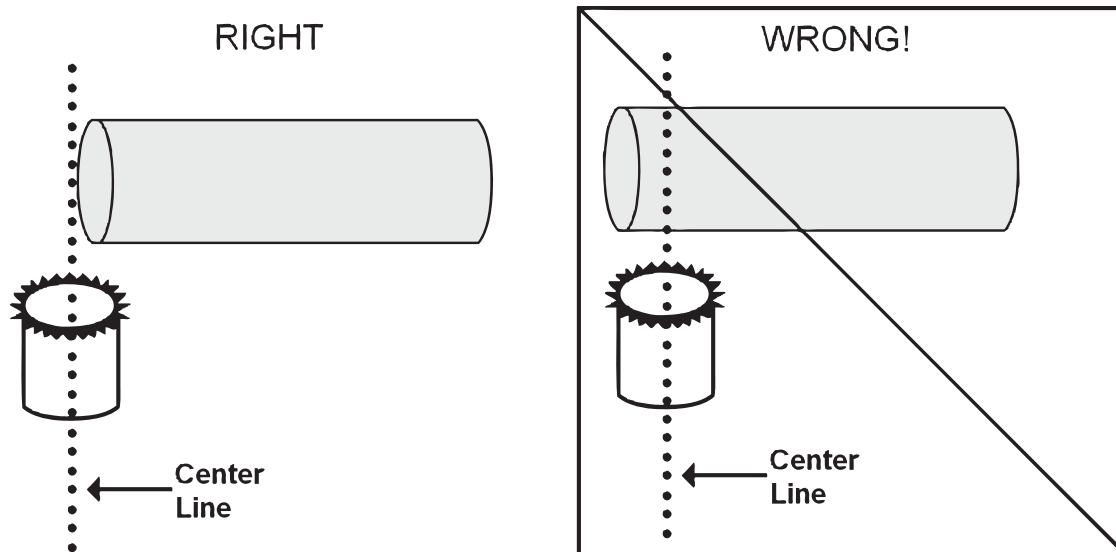
Please read these directions to ensure long saw life and accurate joints.

The simplest method of operation is to clamp the flange into a bench vise that swivels on a workbench, or use the universal mounting holes and bolt it directly to a work bench or welding table. Power the arbor with a variable speed hand drill equipped with a 1/2" chuck.

For drill press operation, set up and dedicate a small drill press for tube notching. Models that include a base can be adjusted to fit out-of-square tables. This makes it easy to lay the notcher over horizontally, while still bolted to the table and is especially helpful when working with long or cumbersome tubing that can't be notched in a vertical position. **Optional base (ALL10406) – fits ALL10411.**

The arbor is in the fixture upside down for shipping purposes. Reverse before use. The arbor has 1/2"-20 threads and includes a 5/8"-18 thread adapter needed for the larger saws. Note: if most of your work is with 1-1/8" or larger tubing, we offer an optional arbor with large 5/8"-18 threads (**ALL10405**) to eliminate the need for the adapter. The four flats on the chuck end of the arbor are designed to use a 5/8" open-end wrench to assist changing saws.

The amount of tubing under the saw is very critical and should never be inserted over halfway. Never cut a piece of tubing in half with the notcher.



On deep angles and large diameter tubing you will need to pull the tube out so it barely starts on the end of the tube. To accomplish deep angles on larger tubing, it's also necessary to adjust the bushing block back and make the cut as far as you can before the tube bottoms out in the saw. Next pull the saw back out and break or cut the piece off to continue notching. To keep the natural deflection of the saw to a minimum, adjust the bushing block so the saw starts as close to the tube as possible, then make sure all bolts are tight.

Saw life depends largely on the care and feed rate used by the operator. Arbor speed and feed rate should be slow and easy, normally less than 250rpm. Material, diameter, and wall thickness, all effect saw life.

Always lubricate the saw with quality cutting oil before notching, and on heavy wall or extremely tough material, a mist lubricating system is a real saw saver. Hole saws seem to have a break-in period and are most vulnerable when they are new. Select the saw diameter that matches the outside diameter of the tube/pipe that you're attaching to, regardless of the size of the tube being notched.

Some saw manufacturers use rolled threads in their saws for attaching instead of machined threads. Saws with rolled threads use a heavy 5/8" SAE washer (supplied) to back up or support the saw.

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