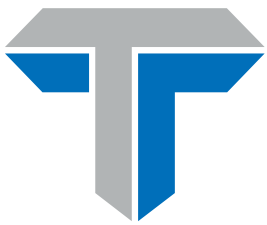


Operation Manual

92-1865 Orig. 181003
18V Cordless Motor Assembly, Japan



TRI TOOL
BUILDING PERFORMANCE

ABOUT TRI TOOL INC.



Tri Tool's extensive experience in the design, development and manufacture of portable machine tools and welding equipment has resulted in machinery that is designed to meet the highest standards of quality, safety, and performance. Our products are backed by a company totally committed to service, integrity, and customer satisfaction.

Tri Tool Services has developed a solid reputation as a trusted provider of dependable and cost-effective on-site service solutions including turnkey project management, machining services, and mechanized and manual code welding services using experienced and well-trained machinists and welders.

In addition to developing industry leading machining and welding equipment, Tri Tool's engineering team provides custom equipment design and manufacturing solutions to suit the most rigorous requirements of our customers' special applications.

Please contact us for more information on any of our products or services. Company representatives are available for demonstrations of most of our products at your facility.

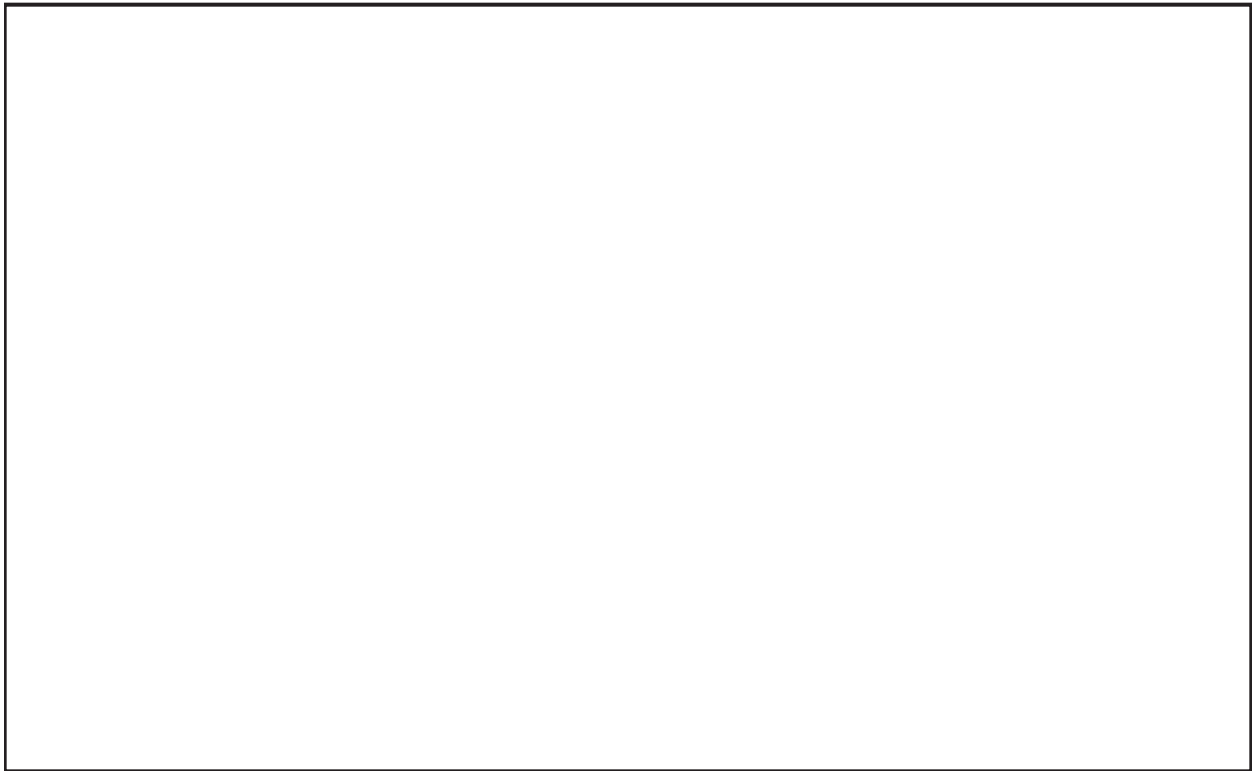


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TRI TOOL INC. Warranty

All products manufactured by Tri Tool Inc., except for tool bits and for other consumable items, are warranted to the original purchaser to be free from defects in materials and workmanship under normal use for a period of one year from the date of purchase.

The purchaser shall bear all shipping, packing and insurance costs and all other costs to and from a designated repair service center. The product will be returned to the purchaser freight prepaid and billed to the purchaser.

The warranty will not apply to those products that have been misused, abused, or altered without the express permission in writing by Tri Tool Inc.

Neither this warranty nor any other warranty, expressed or implied, including implied warranties of mechanical ability, fitness for a particular use, or merchantability, shall extend beyond the warranty period. No responsibility is assumed for any incidental or consequential damages.

Some states do not allow limitations on how long an implied warranty lasts and some states do not allow the exclusion or limitations incidental or consequential damages, so the above limitation of exclusion does not apply to all purchasers. This warranty gives the purchaser specific legal rights. Other rights vary from state to state.

Tool Bit Resharpener Policy

Tri Tool Inc. can not resharpen badly gouged, chipped, or broken tool bits. Check the tool bits before you send them and package them well. Within two working days of receipt, the tool bits are evaluated and the customer is contacted for authorization.

The customer will receive a price and a scheduled return shipment date. The price structure is available from your Tri Tool Inc. sales representative.

Tool bits that are not suitable for resharpening are returned with the tool bits that were resharpened, unless Tri Tool Inc. is instructed otherwise.

The customer is responsible for shipping charges to and from Tri Tool Inc.

This policy only covers tool bits manufactured by Tri Tool Inc.



1. ABOUT THE MANUAL

1.1 Copyright

©Copyright Tri Tool Inc. Proprietary property of Tri Tool Inc. No reproduction, use, or duplication of the information shown hereon is permitted without the express written consent of Tri Tool Inc.

1.2 Disclaimer


The instructions and descriptions in this manual were accurate when the manual was written. However, the information in the manual is subject to change without notice. Check for updated information before you start any job. The Tri Tool Inc. web site has the most current information.


Do not operate or work on this equipment unless you have read and understood the instructions in this Manual. Failure to follow the instructions or follow the safety instructions could result in serious injury or death. This manual describes conditions and hazards that are common and anticipated during equipment operation. No manual can address all conditions which may occur.

1.3 Safety Symbols

The manual may contain one or more safety symbols. These symbols and the associated text warn you of potentially hazardous conditions. Examples of the safety symbols and the associated text follow:

 DANGER	DANGER: Indicates a hazardous situation that, if not avoided, will result in serious injury or death.
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 WARNING	WARNING: Indicates a hazardous situation that, if not avoided, could result in serious injury or death.
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 CAUTION	CAUTION: Indicates a hazardous situation that, if not avoided, could result in minor or moderate injury, or cause property damage.
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2. SAFETY PRECAUTIONS

2.1 In General

Use standard safety equipment such as: hard hats, safety shoes, safety harnesses, protective clothes, and other safety devices when appropriate.

Operate this tool only in accordance with specific operating instructions.



WARNING: Do not override the dead-man switch on the power unit. Locking down, obstructing, or in any way defeating the dead-man switch on the power drive unit may result in serious injury.

2.2 Personal Protective Equipment

Use standard safety equipment such as: hard hats, safety shoes, safety harnesses, protective clothes, and other safety devices when appropriate.

Wear safety glasses.

Do not wear loose clothing or jewelry.

Wear nonskid footwear.

Put long hair in a cap or a net to make sure hair does not get tangled in equipment.

2.3 Personnel

Only personnel who are trained or are being trained may operate the equipment.

Keep the operation manual available where the equipment is used.

The operator must read the operation manual before using the equipment.

The equipment must be operated in accordance with the manual information.

The operator must follow the safety precautions in this manual and good engineering practices to reduce the risk of injury.

Before using the equipment, the operator must ensure that all safety messages on the equipment are legible.

2.4 Work Area

Keep the work area clean.

Keep the area well lit.

Keep items such as electrical cords, cables, rags, rigging straps, away from rotating equipment.

Do not use power-cutting tools in the presence of flammable liquids and gases.

Do not let visitors or untrained personnel near tools that are in use.

Ensure all observers wear eye protection.

Keep proper footing at all times.

2.5 Area Equipment

Secure the pipe with clamps, vises, chains or straps.

Ensure that both sides of the pipe at the cut site is fully supported so that the pipe will not move after the cut is completed. Long lengths of pipe may be under load and the separation of the pipe can release pressure. This pressure can cause both sides of the pipe to move.

2.6 Tool Care

Keep tools in good operating condition. Sharp tool bits perform better and are safer than dull tool bits.

Do not use damaged tools. Always check your tools for damage especially if a tool has malfunctioned, been dropped or hit, check it for damage.

Before you start operating the equipment, do no-load tests and feed function checks.

2.7 Tool Use

Use the right tool and tool bit for the job. Contact Tri Tool to help with your application.

Keep the tool bits fully engaged in the tool bit holders. Loose bits are sharp and can cause cuts or punctures.

Disconnect power supply during setup and maintenance. Use all 'Stop' or Shut off' features available when changing or adjusting tool bits, maintaining the tool, or when the tool is not in use.

Remove adjusting keys and wrenches before applying power to the equipment. Check the tool before turning it on to make sure that all keys and wrenches have been removed.

Do not force tools. Tools and tool bits function better and safer when used at the recommended speeds.

Do not reach into rotating equipment.

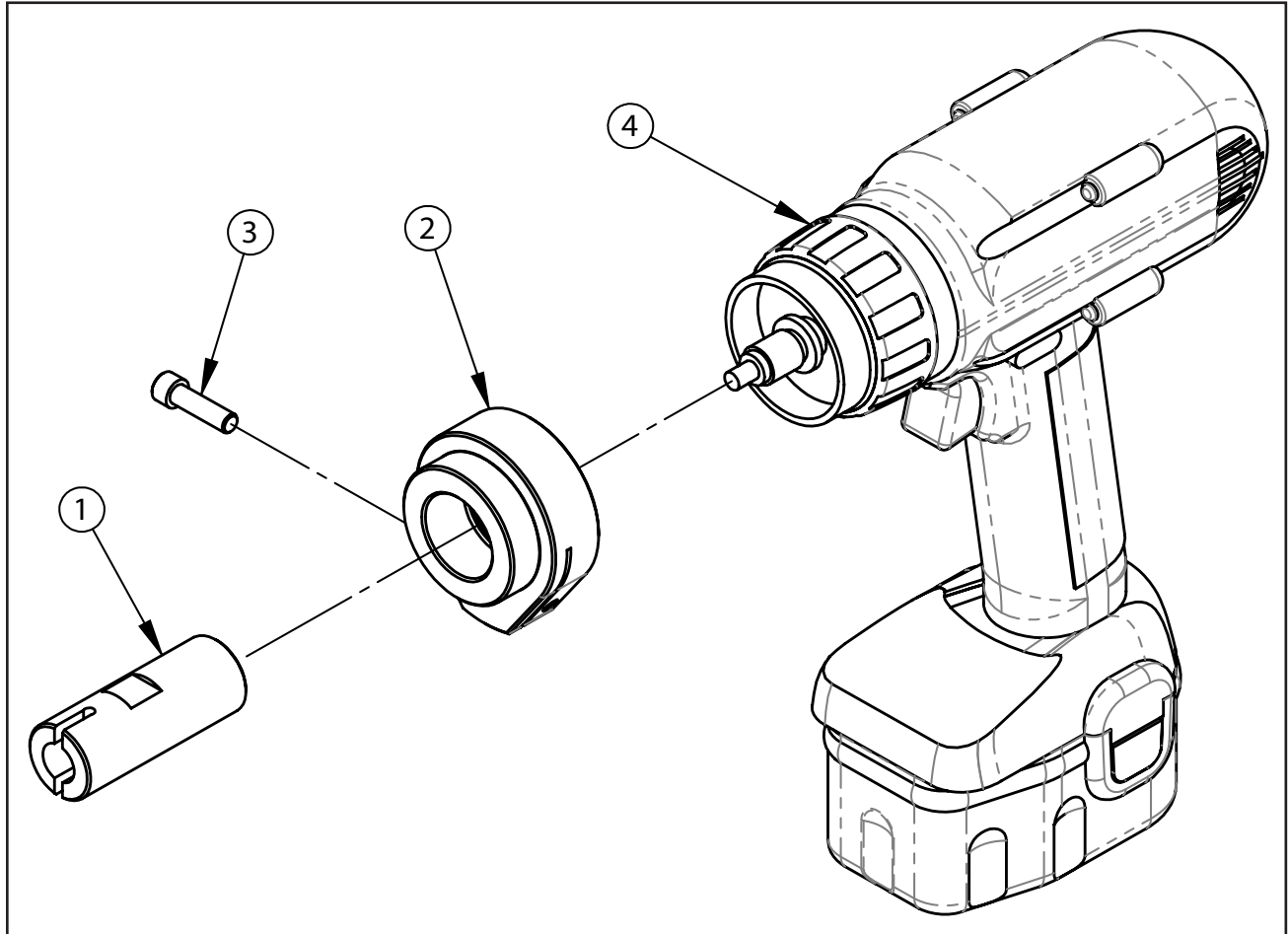
Do not reach into the rotating head stock to remove chips, to make adjustments, or to check the surface finish.

Handle chips with care. Chips have very sharp edges and are hot. Do not try to pull chips apart with bare hands.

Store tools properly. Disconnect tools from the power source, remove the tool bits, and store in a safe place.

3. ILLUSTRATED PARTS BREAKDOWN

MOTOR ASSEMBLY, CORDLESS, 18V, JAPAN (P/N 58-0354)



Parts List, Motor Assembly, Cordless, 18V, Japan (P/N 58-0354)

Item No.	Part No.	Description	Qty
1.	27-1315	ADAPTER	1
2.	27-1591	ADAPTER, MOTOR, CORDLESS, JAPAN	1
3.	33-0041	SCREW,CAP,1/4-20 X 7/8	1
4.	58-0353	MOTOR, CORDLESS, BRUSHLESS, JAPAN, MOD	1



WARNING



Read the manual and be familiar with all safety precautions before operating equipment. The following are general warnings for industrial equipment with moving parts. Refer to the manual for specific warnings applicable to your equipment.



EYE HAZARD - Always wear appropriate eye protection while operating the equipment.



PINCH HAZARD - Keep your hands and clothing away from moving parts.



CRUSH HAZARD - The machinery, pipe, or work piece can shift, separate, lurch, or fall.



CHIP HAZARD - Metal chips may be hot and sharp. Be careful when you clear the tooling path or clean up chips.



TIE DOWN HAZARD - Deliberate overriding of safety triggers can result in serious injury. Never lock or tie down any safety triggers.



SHOCK HAZARD - Ensure that the equipment is properly installed and grounded. Ensure that the equipment is not damaged and that the power cord is intact.

OTHER HAZARDS

- Tool bits are sharp and can cause serious injury.
- Do not defeat or modify safety features.
- Disconnect power sources before servicing or moving the equipment.
- Remove all loose articles of clothing and jewelry before operating the equipment.

Be Safety Conscious!



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