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Milwaukee 6177-20 14" Abrasive Cut-Off Machine

Risk Rating	Low	Med	<input checked="" type="checkbox"/>	High
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Potential Injuries and Hazards



<input checked="" type="checkbox"/>	Amputation
<input checked="" type="checkbox"/>	Burns
<input type="checkbox"/>	Concussion / Head Injury
<input checked="" type="checkbox"/>	Cuts / Lacerations
<input checked="" type="checkbox"/>	Electric Shock
<input checked="" type="checkbox"/>	Eye Injury
<input type="checkbox"/>	Fatality
<input type="checkbox"/>	Fire / Combustible Material
<input checked="" type="checkbox"/>	Moving Machinery / Parts
<input checked="" type="checkbox"/>	Pinch Points / Sharp Points
<input checked="" type="checkbox"/>	Respiratory Damage
<input type="checkbox"/>	Slips, Trips, or Falls
<input type="checkbox"/>	Other:



KEY NOTES:

1. This task may expose workers to risk of musculoskeletal injury (MSI). Signs and symptoms include pain, burning, numbness, tingling, swelling, stiffness, and/or loss of movement or strength in a body part. Report these to your supervisor immediately.
2. This task may only be performed by trained and authorized personnel. Supervisors must ensure workers are trained and following the SOP.

Personal Protective Equipment (PPE) Requirements

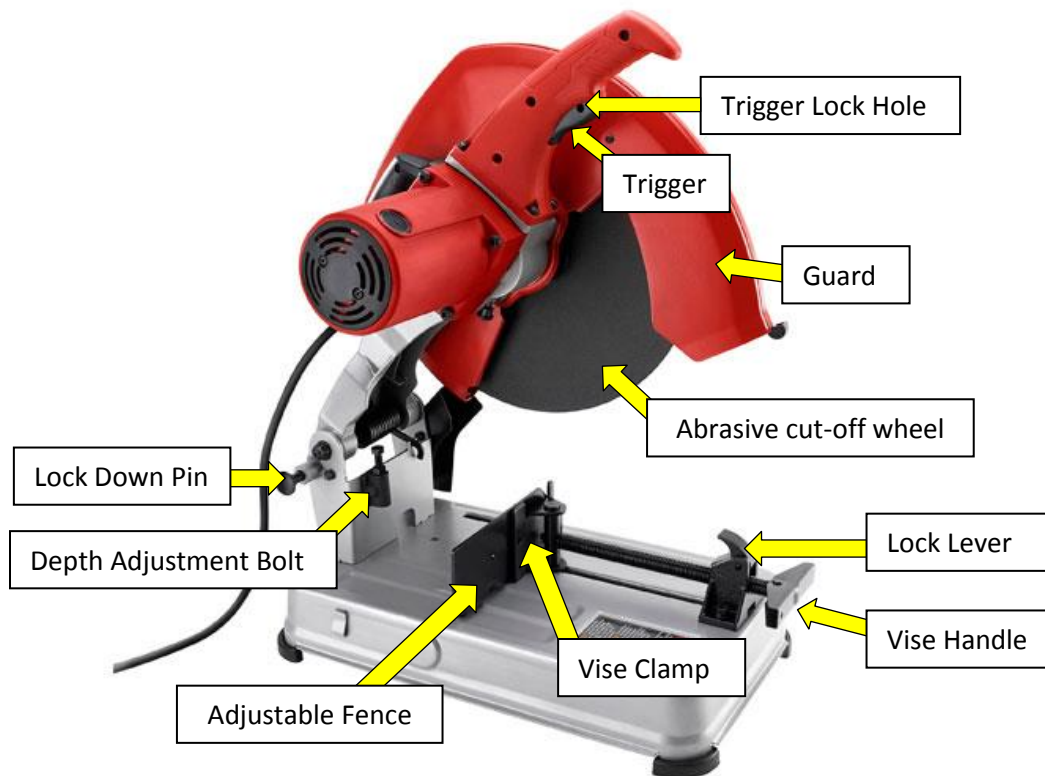
Safety Glasses	Safety Footwear	Hearing Protection	Face Shield	Respirator	Cut Resistant Gloves	Nitrile Gloves	Electrical Gloves	Hard Hat	Fall Protection	Hot Work PPE
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> *						

- Inspect all PPE prior to use. Report any worn or damaged equipment to your supervisor immediately.
- Ensure all PPE is properly cleaned, maintained, and stored.
- All relevant PPE must be CSA approved as per Personal Protective Equipment (PPE) Doc 10210.
- *Wear approved NIOSH or OSHA respirators if you are not working in a well ventilated area or using it for extended period of time.

Other:

General Safety Rules

- Dress properly. Do not wear loose clothing or jewelry. Wear a protective hair covering to contain long hair. These may be caught in moving parts. Keep hands away from moving parts.
- Secure work. Use a clamp, vise or other practical means to hold your work securely, freeing both hands to control the tool. Never freehand cuts!
- Before use, examine the general condition. Inspect guards, switches, tool cord set and extension cord for damage. Check for loose screws, misalignment, binding of moving parts, improper mounting, broken parts and any other condition that may affect its safe operation. Ensure the cut-off wheel has not cracks. If abnormal noise or vibration occurs, turn the tool off immediately and have the problem corrected before further use. Do not use a damaged tool. Lock Out and Tag damaged tools "DO NOT USE" and notify your supervisor immediately.
- Start cutting only after the motor has reached full speed.
- Never stand in line with the wheel while cutting. Always stand to the side.
- Never make any freehand cuts. Always place the work-piece between the vise and fence when making cuts.



Operation

Selecting a Workpiece

The MILWAUKEE Abrasive Cut-Off Machine is designed to cut steel and concrete. It is not recommended for cutting wood. Do not attempt to install saw blade on the tool.

Starting and Stopping the Tool

1. Plug in the tool.
2. To start the tool, pull the trigger.
3. To stop the tool, release the trigger.

Making a Cut

1. Unplug the tool.
2. Select a cutting angle and position the fence and position the fence and vise to support the workpiece (see "Supporting the Workpiece and Adjusting the Vise and Fence System").
3. Plug in the tool.
4. Before starting a cut, step back from the tool and make a trial run to confirm that the wheel is in good condition. Before using a new cut-off wheel, run the tool for at least 3 minutes. Before starting work, run the tool for at least 1 minute.
5. Allow the motor to reach full speed. Slowly lower the wheel into the workpiece. NOTE: Always start the cut gently; do not bang or bump a wheel when starting the cut. For the safest and most efficient cutting, make sure that the cut-off wheel contacts the center of the workpiece.
6. When the cut is complete, raise the wheel completely from the workpiece before releasing the trigger and allowing the motor to stop. Never touch a short

Trigger Hole Lock-Off

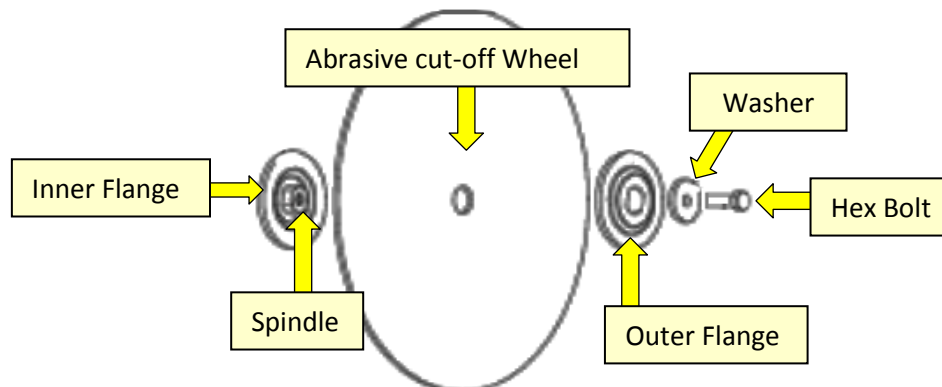
The trigger hole allows the user to insert a pad-lock. This prevents the tool from being started unintentionally.

Removing and Installing Cut-Off Wheels

Use only MILWAUKEE 14" Abrasive Cut-Off Wheels, 3/32" thick with this tool.

To change wheels:

1. Unplug the tool.
2. Raise the head.
3. Push up the lower guard to expose the hex bolt. Press in the spindle lock button and use the wrench provided to loosen the hex bolt (counter clockwise).
4. Remove the hex bolt, washer, and outer flange and cut-off wheel. Do not remove the inner flange.
5. Check the inner and outer flanges to be sure they are in good condition. Remove any nicks, burrs, and debris from the mounting hardware, which could cause uneven cutting pressure and result in wheel damage.
6. Install the cut-off wheel, outer flange, washer and hex bolt onto the spindle, as shown below.
7. Press in the spindle lock button while using the wrench provided to tighten the hex bolt (clockwise).
8. Release the lower guard.
9. Before starting a cut, step back from the tool and make a trial run to confirm that the wheel is in good condition. Before using a new cut-off wheel, run the tool for at least 3 minutes. Before starting work, run the tool for at least 1 minute.



Adjusting the Depth of Cut

The depth adjustment bolt can be adjusted to change the depth of cut. When adjusted properly, the depth adjustment bolt prevents the cut-off wheel from contacting the surface under the base during cutting. Cut-off wheels wear down as they are used and the depth of cut may need to be increased. To adjust the depth of cut:

1. Unplug the tool.
2. Use the wrench provided to loosen the hex nut.
3. Adjust the depth adjustment bolt to the desired height
4. Tighten the hex nut

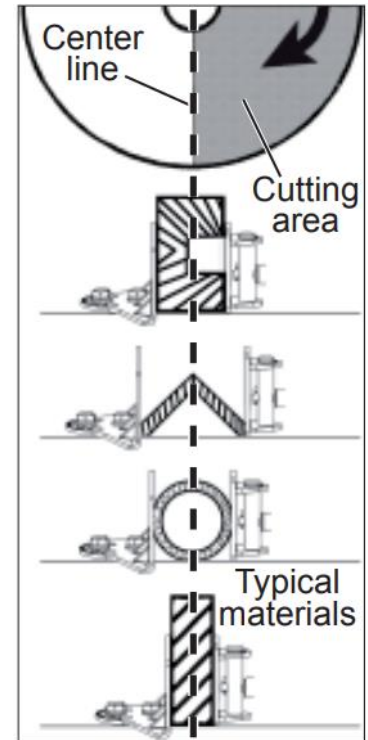
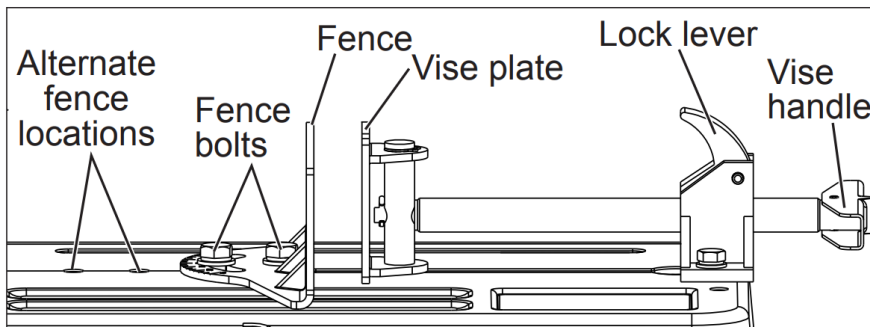
Supporting the Workpiece and Adjusting the Fence System

The adjustable vise and fence system holds the workpiece in the desired position. The vise plate and fence can be moved backward or forward and can be adjusted to any angle between 90° and 45°.

When adjusting the system, the vise and fence should be positioned so the centerline of the wheel hub is in line with or behind the centerline of the workpiece, toward the rear of the tool. The workpiece should be resting flush with the base of the cut-off machine.

To adjust the fence:

1. Use the wrench provided to loosen (counterclockwise) the two fence bolts.
2. Adjust the position and angle of the fence as desired.
3. Securely tighten (clockwise) the two fence bolts.



Training / Reference Material

Read and Understand Operators Manual Milwaukee 6177-20 14" Abrasive Cut-Off Machine. Doc#12000

Rev#	Reason for Change	Revised by:	Revision Date:
00	Initial SWP		