

### Chain Installation

- Loosen side cover nuts and remove side cover.
- Place bar onto studs and chain adjustment pin.
- Adjust chain tension screw until bar contacts drive sprocket.
- Mount chain on bar starting at drive sprocket continuing to bar tip. The chain is non-directional and may be installed to travel either direction.
- With all drive links in bar groove, pre-tension chain.
- If installing clamp axle on 880 saw, install axle plate on studs in place of original outerbar plate.
- Install side cover over studs and tighten nuts finger tight.
- If installing clamp axle for 633 saw place axle bracket on bar studs on outside of side cover, tighten nuts finger tight.
- Tension chain so bottom of drive link hangs even with bottom of bar and chain rotates freely.
- Tighten side cover nuts to 20 ft.lbs.

### Pre-Cut Checklist

- Attach clamp axle to saw if applicable.
- Ensure proper chain tension: Bottom of drive link hangs even with bottom of bar.
- Ensure proper water flow ( $\geq$  20 psi and 2 gpm) and hydraulic supply (8 gpm) to power unit.
- Ensure cut can be made clear of dirt.
- Determine best cutting method/strategy.
- Ensure protective clothing in place.
- Mark cut on pipe.

### Cutting Tips

- If using clamp place around pipe and adjust hand tight.
- Insert clamp axle on saw into clamp mount hole and position saw for optimum cutting position, tighten clamp with wrench to  $\geq$  40 ft. lbs.
- Ensure saw is positioned to allow handle to pivot unobstructed during cut.
- Pipe may be cut from bottom up to drain water but final cut should be made top down.
- Block, support or wedge pipe to prevent shifting during and after cut.
- Ensure water is flowing through bar and chain.
- Start saw, engage to full power and press against pipe to cut.
- Cutting force can be applied until saw motor lugs, saw cuts best at full RPM.
- If cut in 10" pipe exceeds 5 minutes, cut pulls to one side or diamond coating is worn away, chain and/or bar may need replacement.

### Maintenance

- Keep side cover clear of debris. If cutting plastic pipe, side cover may need to be flushed more frequently.