



***ATC-075***  
***AIR CUT-OFF TOOL***

**INSTRUCTION MANUAL**

Order Code: A087

## *Safety Air Tool Warnings*

1. Read and understand this entire manual before attempting assembly or operation.
2. Read and understand all warnings posted on the tool and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. Do not use this tool for other than its intended use. If used for other purposes, Toolmaster disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
5. Always wear approved safety glasses or face shield while using this tool. (Everyday eye glasses only have impact resistant lenses; they are not safety glasses.)
6. Wear ear protectors (plugs or muffs) if the noise exceeds safe levels.
7. Wear gloves and protective clothing if operation produces sparks or flying particles. Gloves should be tight-fitting, without frayed fingers or hanging threads. Keep hands and body away from the working area of tool.
8. Do not operate an air tool continually at full throttle without a work load on the tool.
9. The air tool must be properly lubricated before operating.
10. Never start a percussion type air tool (chipper, breaker, buster, etc.) without securing the tooling in the retainer and placing the tip against the work surface.
11. Do not operate air tool without its guards in place. Do not modify the tool.
12. Do not operate this tool while tired or under the influence of drugs, alcohol, or any medication.
13. Adopt a comfortable posture with proper balance, and maintain secure footing at all times. Non-slip footwear or anti-skid floor strips are recommended.
14. Do not wear loose clothing or jewellery. Confine long hair.
15. Excessive air pressure and too much free rotation may decrease life of the tool and may cause a hazardous situation.
16. Check air hoses for wear, and keep them away from heat and sharp edges. Repair or replace damaged air hose immediately. Do not carry tool by the air hose.
17. Air hose may cause tripping hazards; keep hose away from traffic areas.
18. Do not use this tool near flammable objects, or in potentially explosive environments. Do not use near live electrical wires.
19. Do not use power tools in damp or wet location, or expose them to rain. Keep work area well lighted.
20. Do not leave a connected tool unattended. When not in use, disconnect tool from air source.
21. Shut off air supply and discharge any residual pressure from tool before removing hose, making adjustments, changing accessories, or storing tool.
22. Make sure tool is switched off, and your finger off the trigger, before connecting to air supply. Remove adjusting keys before operating
23. Keep visitors a safe distance from the work area. Keep children away.



### Safety Specific For Air Cut-Off Tools

1. The Toolmaster Air Cut-Off Tool is designed for cutting and removing bolts, nuts, metal components on vehicles or machinery in the workshop, work site or garage. Built with precision bearings for low vibrations and increased lifespan.
2. Speed rating of tool attachment must equal or exceed the rated free speed of Cut-Off Tool.
3. Make sure attachment is securely attached to the shaft and the nut tight.
4. Make sure work piece is secure and will not shift while operating the Cut-Off tool. Do not hold the work piece with your hand.
5. Use only attachments designed for the Cut-Off tool. Do not modify an attachment or use bushings, wheel flanges, etc. to mount an attachment of incorrect size.

**Warning:** Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals that may cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated timber

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as dust masks that are specifically designed to filter out microscopic particles.

### Technical Specifications

Disc Size	75mm
Length	183mm
Free Speed:	20,000rpm
Air Consumption	3.5 CFM (186 L/min)
Maximum Air Pressure	90 PSI
Speed Setting	Variable
Noise level	90dB
Recommended Air Hose	10mm
Inlet	1/4" BSPT
Weight	0.35kg

## Setup

Any missing parts or damage should be reported immediately to your **Toolmaster** distributor. Do not use a damaged tool. Read this instruction manual thoroughly for operation, maintenance and safety instructions.

The diagram below is the ideal setup position. The lubricator is optional and if not used, then a few drops of Pneumatic Tool Oil needs to be added to the airline connection before operation. Add a few more drops after each hour of continual use.

## Air Supply

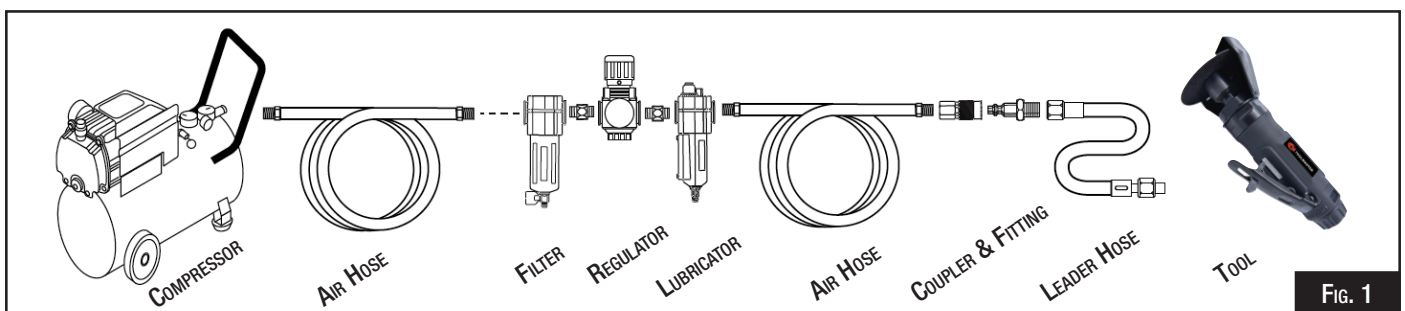
The recommended air system is shown in Fig.1.

1. Use proper air hose size (refer to tool specifications). The hose should be just long enough to serve the working area. Excessive hose length will cause pressure drop.

**⚠ WARNING!** *Ensure that the air supply is clean and does not exceed 90psi. Too high an air pressure and/or unclean air will shorten the life of the air tool due to accelerated wear and may cause damage and/or personal injury.*

2. Drain the compressor air tank daily. Water in the air line will damage the air tool.
3. Clean the compressor air inlet filter screen weekly.
4. Line pressure should be increased to compensate for unusually long air hoses (over 8 meters). The minimum hose bore should be 10mm and fittings must have the same inside dimensions.
5. Keep hoses away from heat, oil and sharp edges. Check hoses for wear, and make certain that all connections are secure.

**IMPORTANT:** *The leader hose is optional, but connecting a quick-change coupling directly to the tool is not recommended, as vibration may cause the connection to fail. For the best result, add a leader hose and install any quick-change couplings further down the line.*



**WARNING:** *Operating the tool at pressures over the rated capacity may cause severe damage and/or personal injury. Do not exceed 90 PSI while operating the tool. Do not use an accessory rated at a lower maximum pressure than the tool.*

## Operating Instructions

1. Ensure the tool is connected to an air supply with the correct pressure settings
2. To operate the Air Cut-Off Tool, release the safety lever and squeeze the trigger lever to turn on the tool. Ensure the tool is not engaged with any material when the disc starts to spin.
3. Place the cut-off disc on the work piece and keeping a light pressure allowing the tool to do the work. Do not apply heavy pressure to the Air Cut-Off Tool to avoid damage to the work piece and tool.
4. Release the trigger and allow the disc to come to a complete stop before placing the tool down.



**CAUTION! TO PREVENT INJURY FROM TOOL OR ACCESSORY FAILURE:**

*Do not exceed the tool's maximum air pressure rating. If the tool still does not have sufficient force a maximum pressure and sufficient airflow, then a larger tool may be required.*

5. To prevent accidents, turn off the tool, detach the air supply, safely discharge any residual air pressure in the tool, and release the throttle and/or turn the switch to its OFF position after use. Clean external surfaces of the tool with a clean, dry cloth, and apply a thin coat of tool oil, then store the tool indoors out of children's reach.



## Installing Cutting Disc's

1. Ensure the Air Cut-Off Tool has come to a complete stop and the tool is disconnected from the air supply.
2. Using the supplied 5mm Hex Key and Wrench, secure the spindle and screw the Hex bolt.
3. Install the new cutting disc, ensure the disc meets the correct specifications. Firmly secure the spindle with the spanner and tighten the Hex bolt with the supplied Hex Key.
4. Ensure the cutting disc is correctly mounted and tightened before use and run the tool at no-load speed for at least 1 min in a safe position; stop immediately if considerable vibration or other defects are detected and determine the cause of the defects and remedy these defects before use.



**CAUTION!** High pressure air can cause injury  
Shut off air valve and vent all accumulated air in  
the lines and tool before servicing the Air Tool.

## Optional Accessories



PNEUMATIC TOOL OIL 500ML  
ORDER CODE A037



5 PIECE PACK - HIGH-FLOW AIR FITTINGS  
1/4" BSPT  
ORDER CODE F935



RWK-15 - INDUSTRIAL POLYMER AIR HOSE  
15 METRE x Ø9.5MM ID HOSE  
ORDER CODE H008

## Maintenance

### 1. Daily - Air Supply Maintenance:

- Every day, maintain the air supply according to the component manufacturers' instructions.
- Maintain the lubricator's oil level. Use Pneumatic Tool Oil. (Order Code A037)
- Drain the moisture filter regularly.
- Performing routine air supply maintenance will allow the tool to operate more safely and will also reduce wear on the tool.

### 2. Quarterly (every 3 months) – Tool Disassembly, Cleaning, and Inspection:

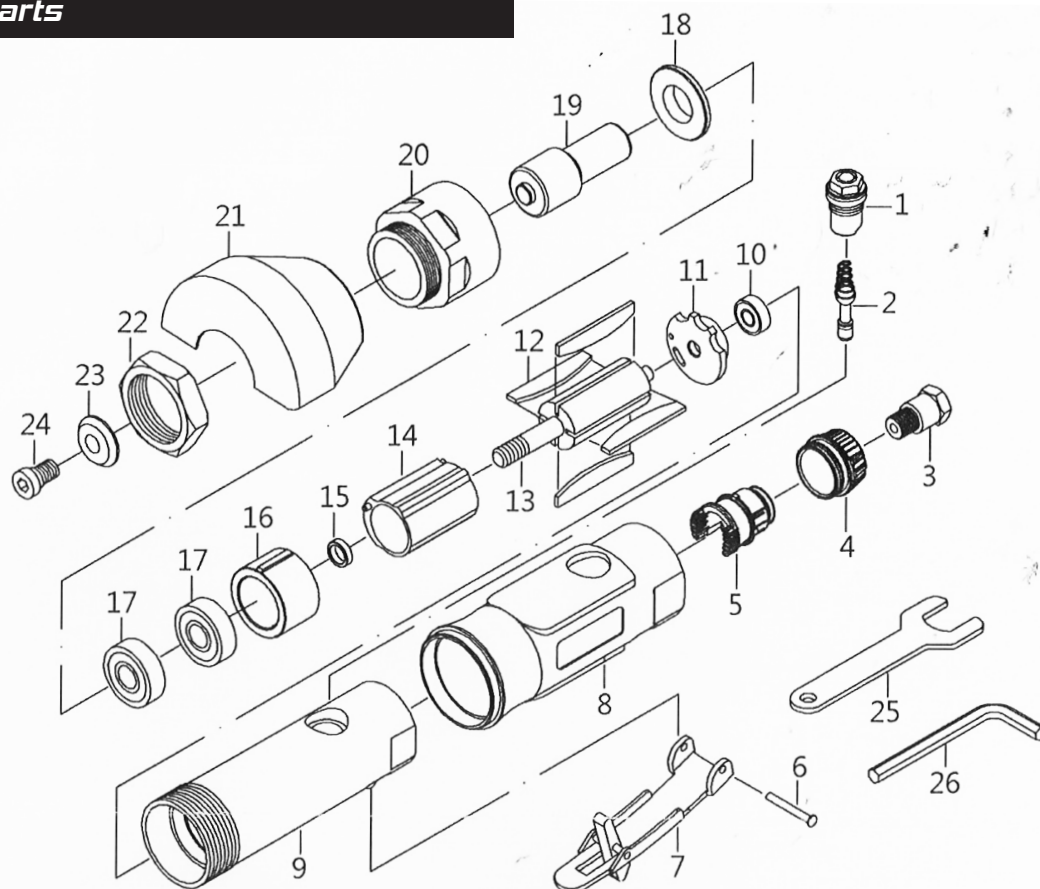
- Have the internal mechanism cleaned, inspected, and lubricated by a qualified technician.
- For a full service contact your local Toolmaster service agent.
- When not in use, disconnect from air supply, clean nibbler and store in a safe and dry place.



#### *Environmental Protection.*

*Recycle unwanted materials instead of disposing of them as waste.  
All tools, accessories and packaging should be sorted, taken to a recycle centre  
and disposed of in a manner which is compatible with the environment.*

### Spare Parts



NO	PARTS NO	DESCRIPTION	Q'TY	NO	PARTS NO	DESCRIPTION	Q'TY
1	ST70004AS	REGULATOR SET	1	14	ST70021AS	CYLINDER SET	1
2	ST70007BAS	VALVE STEM SET	1	15	20022	BEARING SPACER	1
3	70009	AIR INLET	1	16	ST21023	FRONT PLATE	1
4	ST20010B-1AS	EXHAUST SLEEVE SET	1	17	21024	BEARING (608ZZ)	2
5	ST20022B	CONE MUFFLER	1	18	20025	WASHER	1
6	70432BK	SPRING PIN	1	19	25026	DISC RETAINER	1
7	ST80509	LEVER	1	20	ST25027	CLAMP NUT	1
8	70014	PROTECTING RUBBER	1	21	ST25028BK	GUARD	1
9	ST21015	HOUSING	1	22	ST25029	NUT	1
10	20312	BEARING (696ZZ)	1	23	ST25031	WASHER	1
11	ST70017	REAR PLATE	1	24	60924	SCREW (M6*12)	1
12	20019	ROTOR BLADE	4	25	BT21038-14	STOP SPANNER (14M/M)	1
13	ST288321	ROTOR	1	26	60929	HEX (5M/M)	1

WE RESERVE THE RIGHT FOR ANY DESIGNING CHANGES TO THE PARTS AND WITHOUT ANY NOTICEMENT IN ADVANCE.

## Troubleshooting

Review the troubleshooting and procedures in this section if a problem develops with your Air Tool. If you are still unable to resolve the problem, then contact your local **Toolmaster** distributor.

<i>Symptoms</i>	<i>Possible Cause</i>	<i>Possible Solution</i>
Decreased output.	<ol style="list-style-type: none"> <li>1. Not enough air pressure and/or air flow.</li> <li>2. Obstructed throttle.</li> <li>3. Incorrect lubrication or not enough lubrication.</li> <li>4. Blocked air inlet screen (if equipped).</li> <li>5. Air leaking from loose housing.</li> <li>6. Mechanism contaminated.</li> <li>7. Vane wear or damage.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for loose connections and make sure that air supply is providing enough air flow (CFM) at required pressure (PSI) to the tool's air inlet. Do not exceed maximum air pressure.</li> <li>2. Clean around throttle to ensure free movement.</li> <li>3. Lubricate using air tool oil and grease according to directions.</li> <li>4. Clean air inlet screen of buildup.</li> <li>5. Make sure housing is properly assembled and tight.</li> <li>6. Have qualified technician clean and lubricate mechanism. Install in-line filter in air supply as stated in Setup: Air Supply.</li> <li>7. Replace all vanes.</li> </ol>
Housing heats during use	<ol style="list-style-type: none"> <li>1. Incorrect lubrication or not enough lubrication.</li> <li>2. Worn parts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Lubricate using air tool oil and grease according to directions.</li> <li>2. Have qualified technician inspect internal mechanism and replace parts as needed.</li> </ol>
Severe air leakage (Slight air leakage is normal, especially on older tools.)	<ol style="list-style-type: none"> <li>1. Cross-threaded housing components.</li> <li>2. Loose housing.</li> <li>3. Damaged valve or housing.</li> <li>4. Dirty, worn or damaged valve.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for incorrect alignment and uneven gaps. If cross-threaded, disassemble and replace damaged parts before use.</li> <li>2. Tighten housing assembly. If housing cannot tighten properly, internal parts may be misaligned</li> <li>3. Replace damaged components.</li> <li>4. Clean or replace valve assembly.</li> </ol>
Excessive heat develops in tool.	<ol style="list-style-type: none"> <li>1. Improper lubrication</li> </ol>	<ol style="list-style-type: none"> <li>1. Lubricate properly according to instructions in this manual.</li> </ol>