

# JET

**JCOM-400T**

**CHOP-OFF SAW**

**GB**

**Operating Instructions**



## **JPW (Tool) AG**

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**CE-Conformity Declaration**  
**CE-Konformitätserklärung**  
**Déclaration de Conformité CE**

**Product / Produkt / Produit:**

Chop-off saw

**JCOM-400T**

**Brand / Marke / Marque:**

**JET**

**Manufacturer / Hersteller / Fabricant:**

JPW (Tool) AG, Tämperlistrasse 5, CH-8117 Fällanden  
Schweiz / Suisse / Switzerland

We hereby declare that this product complies with the regulations  
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht  
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

**2006/42/EC**

Machinery Directive  
Maschinenrichtlinie  
Directive Machines

**2014/30/EU**

electromagnetic compatibility  
elektromagnetische Verträglichkeit  
compatibilité électromagnétique

designed in consideration of the standards  
und entsprechend folgender zusätzlicher Normen entwickelt wurde  
et été développé dans le respect des normes complémentaires suivantes

**EN ISO 12100:2010**

**EN 60204-1:2006+A1:2009+AC:2010,**

**EN 61000-6-4:2007+A1:2011, EN 61000-6-2:2005,**

**EN 60204-1:2006/AC:2010,**

**EN 13898:2003+A1:2009/AC:2010,**

**EN 61000-3-2:2014, EN 61000-3-3:2013**

Responsible for the Documentation / Dokumentations-Verantwortung / Responsabilité de Documentation:

Head Product-Mgmt. / Leiter Produkt-Mgmt. / Resp. Gestion des Produits

JPW (Tool) AG



2018-02-26 Jan Dätwyler, General Manager

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## 1. the scope of application of profile cutting machine

1.Profile cutting machine is applicable to round steel pipe, special-shaped steel, cast iron pipe and round steel in architectures,decoration,machine manufacturing and other industries.Angle sheet,channel sheet,flat steel and other profiles should be cut off a piece for sampling. Due to the adoption of fiber-reinforced grinding wheel, this type of cutting machine is prominent in cutting materials with high toughness and hardened steel.

## 2. technique data

Project	unit	type
power	kW	3
voltage	V	400
frequency	Hz	50
motor speed	r/min	2810
spindle speed	r/min	3380
size of grinding wheel	mm	PB400X3.2X32
safety line speed of grinding wheel	m/s	70/S
grinding wheel static balance	g	10
cutting adjustment angle	°	0 ~ 45
N.W.	kg	58
cutting ability	mm	●40 ◎125 L120X10

### 3. safety precautions

1. Check carefully the power cable, switch, fastener and other spare parts before usage. Safety risks are forbidden, for example, no damage and loose of spare parts should happen due to improper transportation.
2. Check whether the ground wire is reliable first before usage. Ground device must not be loose and ground cable must not be broken or damaged. Using more than 500V megger to test the insulation resistance, no less than 2 megohm.
3. The cable insulation must not be broken. Choose plug according to motor data when connection. Yellow-green cable is grounding cable.
4. Do not change connection line in motor switch without permission.
5. This machine must use fiber-reinforced resin thin grinding wheel and must not use grinding wheel whose safety line speed is lower than 60m/s.
6. Do not use deformed or broken grinding wheel. When knock lightly by wooden hammer, there must not be cracked sound.
7. It's forbidden to operate when the protection mask is moved.
8. Goggles is a must while working. Operators must stand beside the grinding rotation direction.
9. Grinding rotation direction must be the same as shown in the shield logo .
10. During cutting work, work piece must be clamped tightly. If it's longer than the workbench, the rest must be supported by the block to make sure the work piece is level.
11. Wait until the spindle stops working completely. After cutting off the power, the working of dis-assemble work piece and grinding wheel, cutting angle adjustment and maintenance can start.
12. Do not touch the section of work piece that has just been cut to avoid being scalded.
13. Do not use cutting machine in sites where there are flammable and explosive products.
14. Do not touch switch by wet hands
15. When operating, do not force it too much in order to avoid motor over-heating due to overload and grinding wheel explosion.
16. The maintenance of electrical parts must be operated by professional personnel.
17. Choose the power same as the motor nameplate requires. Voltage fluctuation must not exceed 10% voltage the nameplate requires.

#### 4 . the usage of cutting machine

- 1.Do use this product after reading clearly the safety notes.
- 2.Before usage, please make sure that this product is under great condition and meets the technical demand of safety notes.
- 3.Put the long handle bar into the hole, fastening it with bolts and check whether the switch and cables are in good condition.
- 4.Turn on the power, test it with no loading to check whether the cutting machine is working well. There must not be abnormal vibration and noise and the operation direction must be the same as the cutting machine requires.
- 5.After non-loading test run,put on the grinding wheel, clamping the grinding wheel and test run again to check whether there is improper installation or vibration caused by improper static balance.
- 6.Work piece must be clamped tightly. Non-looseness is required.
- 7.During operation, if there is any abnormal noise or vibration, stop working immediately. Check and eliminate problems and then to continue using.
- 8.After using the product, cut off the power supply immediately.

#### 5 . commom faults and elimination methods of cutoff machines.

faults	reasons	elimination methods
the motors don't turn after turning on the power	1.there's no voltage in power supply 2.poor connection of plugs and sockets 3.switch failure 4.the power cord is disconnected 5.the stator is damaged	1.check and mend the power line 2.check plugs and sockets 3.change the switch 4.change and mend the power cable 5.change and mend the stator
motor insulation is poor and there is leakage	1.the cutting machine is damped or motor is wet 2. the grounding cable is disconnected 3.the power line of motor is damaged 4.the nut is loose in the Junction Box or the copper wire touches the shell 5.stator damaged	1.dry the whole machine and motor 2. connect the grounding wire 3.change and mend the power cable 4.open the motor Junction Box to check all connections and mend 5.change and mend the stator

faults	reasons	elimination methods
low speed of the cutting machine	1.voltage drop in power supply 2.put too much force during operation 3.three-phase motor works without three-phase 4.capacitance damaged or fuk bag group damaged due to single-phase motor operation, 5.V-belt is wore and sliding 6.the gap between motor shaft and rotor is small leading to sliding	1.stop using immediately, wait until the voltage is normal 2.lift grinding wheel at once and use with proper force. 3.check power supply,cables and motor lines 4.mend the motor 5.change V-belt or adjust pulley center distance to increase the tension 6.change and mend the rotor
loud noise and abnormal vibration	1.grinding wheel's big and unbalanced and improperly installed. 2.the shaft is wore and there's something in it 3.the fastening is loose 4.the pulley and V-belt protection mask is deformed 5.the abnormal noise of motor. The wind cover is deformed. There's something inside the shaft and the shaft and rotor work without three-phase motor	1.change grinding wheel or re-install properly 2.clean and change shaft 3.tighten the fasteners 4.check the motor
the cutting machine runs in the wrong direction	1three-phase cutting machine 2.the start winding or start capacitor of single-phase cutting machine is damaged	1.change arbitrary two cables in three power cables. 2.mend the motor

## 6 . the transportation and storage of profile cutting machine

1.During the transportation, the cutting machine must be carried strictly according to the icons on the package. Do not roll and collide.

2.Profile cutting machine must be stored in warehouse where is dry and ventilated and clean. There must no be acid-base chlorine and other corrosive substances. Also it's forbidden to put it with insulating materials that have a corrosive effect on chemicals.

3.In the warehouse,the cutting machine must not be damped or frozen in order to avoid insulation materials crapping so that the motor can't be used.

## 7 . random packing list

name	type	quantity
profile cutting machine		1
products instruction book		1

## 8. the maintenance of profile cutting machine

The warranty period of cutting machine is, under the correct usage,maintenance,storage and transportation as per the usage and maintenance instruction book, within 6 months from purchasing(base on the invoice date), if damages appear because of the quality problem so that it can't work, the company will mend or change spare parts or the whole product for our clients for free charge.



**JCOM-400T**

**CHOP-OFF SAW**

**50006101T 400V/50Hz**

## **PARTS LIST**

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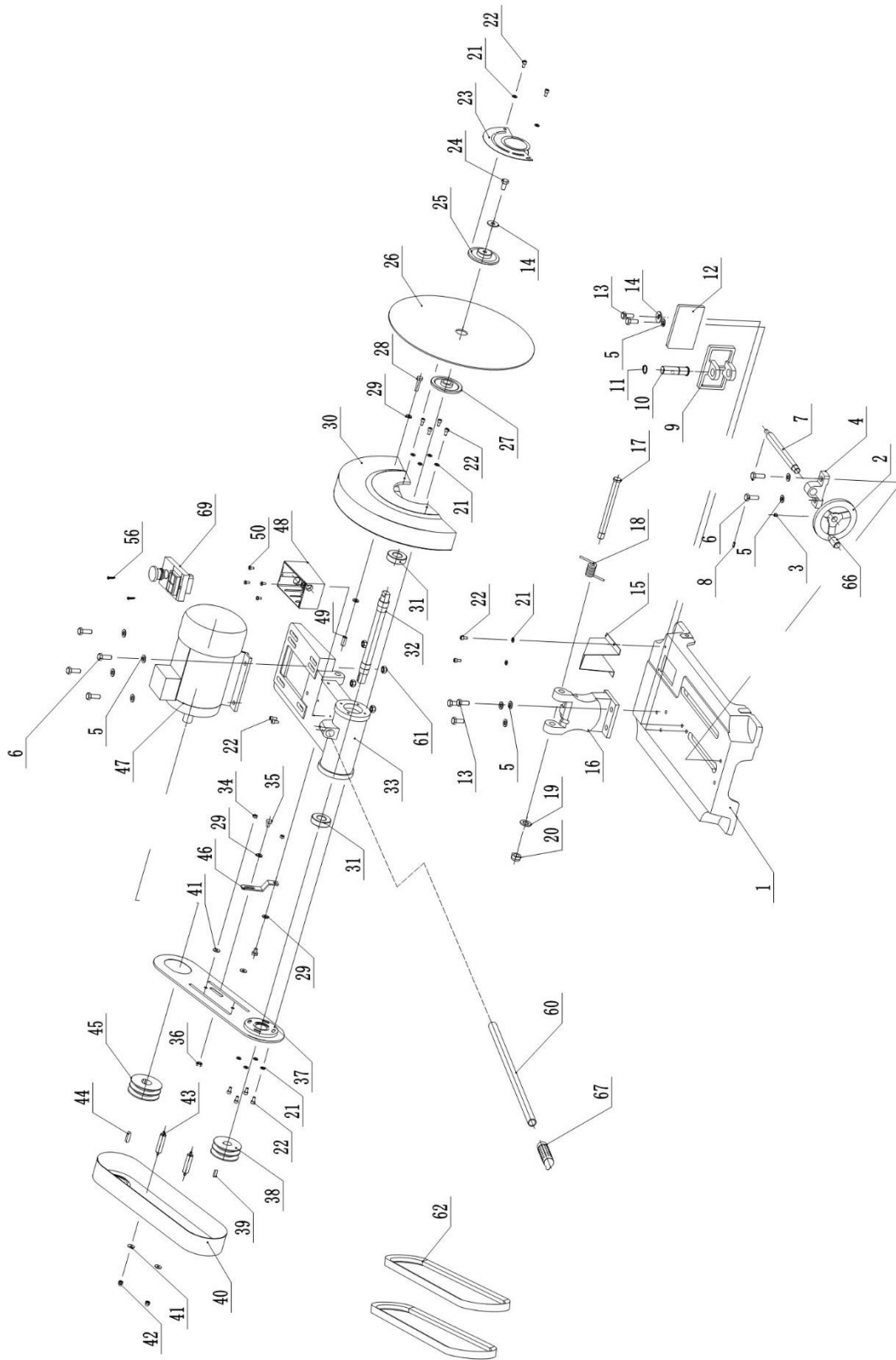
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## . Assembly Breakdown

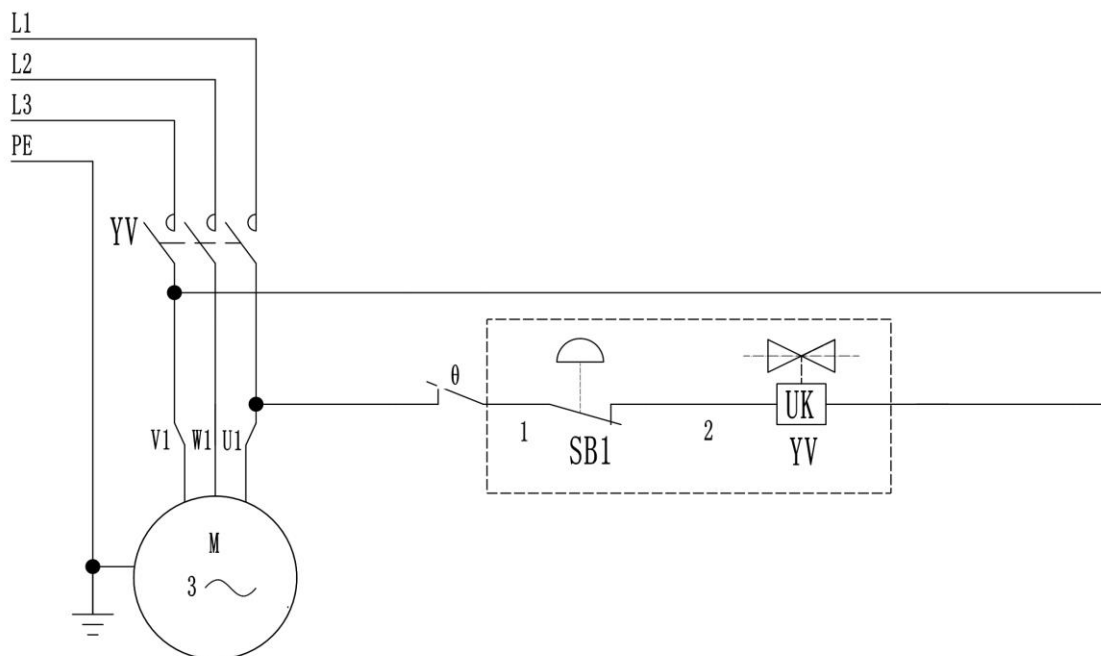


## . Parts List for Breakdown

Index No.	Part No.	Description	Size	Qty
1	JCOM400T-001	Base		1
2	JCOM400T-002	hand wheel		1
3	TS-1523031	Socket set screw	M6×10	1
4	JCOM400T-004	Screw fixing seat		1
5	JCOM400T-005	Flat washer	10	15
6	TS-1491041	Hexagon bolt	M10×30	6
7	JCOM400T-007	Screw		1
8	JCOM400T-008	Vol.	4×12	1
9	JCOM400T-009	Clamping plate		1
10	JCOM400T-010	Plate pin		1
11	JCOM400T-011	External circlip	18	1
12	JCOM400T-012	Angle device		1
13	TS-1491031	Hexagon bolt	M10×25	5
14	JCOM400T-014	Enlarged flat washer	10	2
15	JCOM400T-015	Row pin cover		1
16	JCOM400T-016	Mast base		1
17	JCOM400T-017	Lintel shaft		1
18	JCOM400T-018	Torsional spring		1
19	TS-155010	Flat washer	16	1
20	JCOM400T-020	Self-locking nut	M16	1
21	JCOM400T-021	Flat washer	6	12
22	TS-1503031	Socket head cap screw		14
23	JCOM400T-023	Cover plate		1
24	TS-1491021	Hexagon bolt	M10×20	1
25	JCOM400T-025	External clamping plate		1
26	JCOM400T-026	Cutting disk	400×32×3.2	1
27	JCOM400T-027	Internal clamping plate		1
28	TS-1490061	Hexagon bolt	M8×35	1
29	TS-1550061	Flat washer	8	4
30	JCOM400T-030	Grinding wheel cover		1
31	BB-6205	Bearing	6205	2
32	JCOM400T-032	Spindle		1
33	JCOM400T-033	Bracket		1
34	TS-1540041	Nuts	M6	2
35	TS-1490011	Hexagon bolt	M8×12	2
36	TS-1540061	Nuts	M8	1
37	JCOM400T-037	Internal belt cover		1
38	JCOM400T-038	Hexagon bolt		1
39	JCOM400T-039	Flat key	6×6×20	1
40	JCOM400T-040	Belt cover		1
41	JCOM400T-041	Enlarged flat washer	6	4
42	JCOM400T-042	Cap nut	M6	2
43	JCOM400T-043	Washer		2
44	JCOM400T-044	Flat key	8×7×30	1
45	JCOM400T-045	Motor pulley		1
46	JCOM400T-046	Shield support		1
47	JCOM400T-047	Motor	3kW,400V,50Hz	1

Index No.	Part No.	Description	Size	Qty
48 .....	JCOM400T-048 .....	Switch box .....		1
49 .....	JCOM400T-049 .....	Shield fixing sleeve .....		1
50 .....	JCOM400T-050 .....	Cross head screw .....	M5×10 .....	4
56 .....	JCOM400T-056 .....	Cross head self-tapping screw .....	M4×16 .....	3
57 .....	JCOM400T-057 .....	Trigger switch .....	HY15EC .....	1
58 .....	JCOM400T-058 .....	Handle lower cover .....		1
59 .....	JCOM400T-059 .....	Handle upper cover .....		1
60 .....	JCOM400T-060 .....	Handle lever .....		1
61 .....	TS-1540071 .....	Nuts .....	M10 .....	4
62 .....	JCOM400T-062 .....	V-Belt .....	A864 .....	2
63 .....	JCOM400T-063 .....	Cross head self-tapping screw .....	M4×9.5 .....	1
64 .....	JCOM400T-064 .....	Male line .....		1
65 .....	JCOM400T-065 .....	Bus bar .....		1
66 .....	JCOM400T-066 .....	Crank .....		1
67 .....	JCOM400T-067 .....	Handle set .....		1
68 .....	JCOM400T-068 .....	Socket set screw .....		1
69 .....	JCOM400T-069 .....	Combination switch .....	KJD18/HY57B .....	1

## . Wiring Diagrams



ITEM	Part No.	Description	TYPE	Qty
M .....	JCOM400T-047 .....	Motor (YE3-100-2) .....	3kW, 400V, 50Hz .....	1
YV/SB1 ....	JCOM400T-069 .....	Combination switch .....	KJD18/HY57B .....	1
θ .....		Overload protectors .....		1