

No. 502

Sawing electric cable ducts (steel)



A

Description

This application example describes the exact sawing of a steel cable duct with dimensions 130 x 68 mm and a portable circular saw TS 75.

Electrical lines for telephone, electricity, computers, etc. are installed nowadays by industrial and crafts enterprises in electrical installation duct systems, which are often made of steel.

Installation is often associated with problems of cutting cable ducts to size or making exact mitre cuts.



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502/02

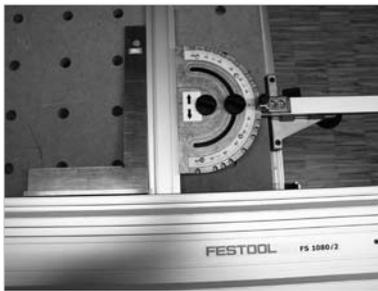
B

Tools/accessories

For a cable duct cut, you will require the following machines and auxiliary equipment:

Denomination	Order no.
Plunge-cut saw TS 75 EBQ Plus GB 240V	561190
guide rail FS 1400	491498
4x one-hand lever clamp FS-HZ 160	491594
4x MFT-SP quick-action clamp	488030
Mobile dust extractor CTM 26 E GB 240V	584003
Multifunction table MFT 3	495315
Spark trap D 50 FL	484733
Flat top saw blade 210x2.2x30 F36	493351

The spark trap is installed at the mobile dust extractor between the hose and the hose connection. It prevents sparks produced during sawing from entering the dust extractor, Fig. 502/02.



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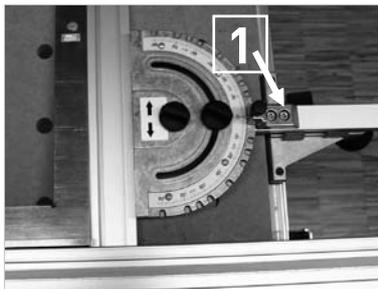
C

Preparation/set-up

Preparation at the multifunction table

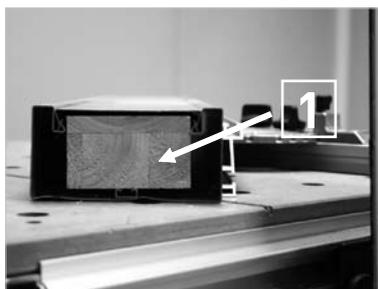
To check the angularity of the stop the guide rail is lowered until it bears on the stop.

Use a set square to check the 90° angle from the stop ruler to the guide rail and readjust if necessary.



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To do this, release screw 1, set the 90° angle exactly and retighten the screw.



502/05

To improve stability when working on the steel cable duct, you can prepare a wooden inlay "1". It fills the entire interior of the cable duct and thus reinforces it during sawing.



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Saw blade changing

- Disconnect the machine from the mains
- Push the FastFix lever down to the detent
- Push switch lock up and push sawing unit down until it locks into place



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- Open screw with Allen screw
- Remove saw blade
- Clean flange
- Insert steel/sandwich saw blade (493351). The direction of rotation of saw blade and machines must match
- Mount outer flange and tighten screw



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- Push FastFix lever back.



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Guide play

- First adjust the green eccentric jaws in the base plate of the portable circular saw to the guide rail, ensuring there is no backlash.

It should be possible to move the machine on the guide rail without any significant resistance.

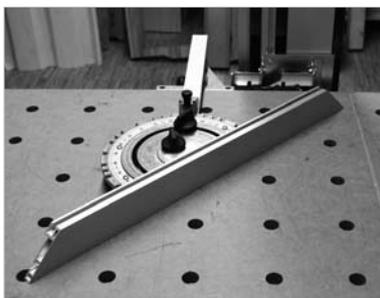
Cutting into the splinterguard at the guide rail

- Prior to the work step, a cut is made into the splinterguard of the guide rail.
- To do this, the cutting depth display must be set to 15 mm.
- The cutting depth indicator on the scale is pressed in and, at the same time, set to the desired depth.

Cut into the splinterguard along the entire length.

This sets the cutting edge of the splinterguard exactly to the circular saw including saw blade and can therefore be used as a guide edge and scribe mark.

E Procedure



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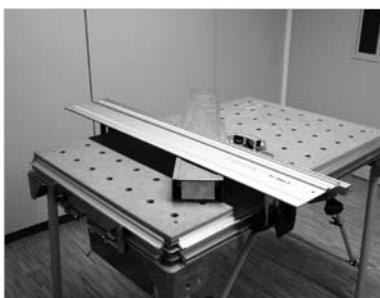
Mitre cut 45 °

- 1. MFT - adjust the preset profile setting rail to 45°, Fig. 502/10.



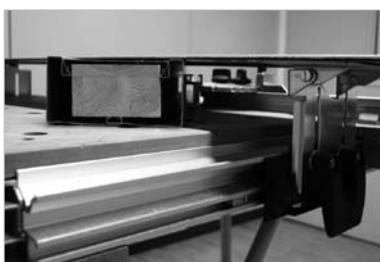
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- 2. Align steel cable duct to angle stop, Fig. 502/11.



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- 3. Fold over guide rail, Fig. 502/12.



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- 4. Adjust guide rail to height of cable duct, Fig. 502/13



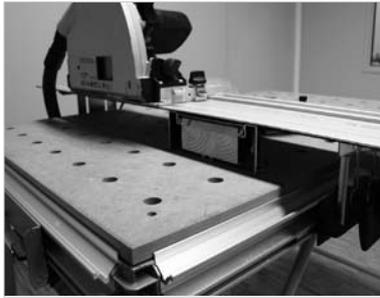
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- 5. Connect mobile dust extractor to plunge-cut saw, Fig. 502/14.



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- 6. Set speed level 4-5, switch on machine and cut off cable duct at low advance speed, Fig. 502/15.



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Note:

1. 90° cuts are executed using an appropriate procedure.
2. Notes on safety and use are enclosed with the saw blade and must be observed in all circumstances!
3. Clamping the cable duct is even safer with the use of the clamping elements MFT-SP (accessories).

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