

Y6S20 KRIMPMATIC WORKSHOP SERIES

Hose Cut Off Saw
Operation Manual



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General

General Information

Before unpacking or operating the cutting machine, read this manual completely. Every operator is required to read and understand it. The manual contains the critical guidance needed to use the machine safely.

The content is intended solely for suitably competent personnel capable of operating the machine without creating risk to themselves, other people, property, the machine, or the environment.

Operators must be demonstrably competent in:

- Troubleshooting methods
- Conducting machine inspections
- Performing basic mechanical maintenance tasks
- Safe hose-making practices and procedures

This machine has been designed:

- For safe, clean, efficient cutting of textile or wire braided, suction, and multi spiral hydraulic hoses
- To use only on hydraulic hoses within the maximum size and construction limits specified
- For use in workshops

Disassembly and full maintenance procedures are not included in this manual and must only be performed by an authorised service technician.

Keep this manual accessible and in good condition for future reference. For a replacement copy, contact your nearest Motion branch.

Motion assumes no responsibility for injury or damage to persons, the machine, or property arising from improper use, prohibited modifications, or any misinterpretation of the safety instructions contained in this manual.

Pre-Use Inspection

- Ensure the saw is securely mounted and in serviceable condition.
- Verify all fasteners, including the arbor/blade nut, are tight.
- Inspect the steel cut off saw blade for nicks, cracks, distortion, missing segments, or other damage; replace if any defect is found.
- Confirm the blade is centered with no axial/radial runout and spins freely.
- Check rotation direction: viewed from the operator side, the blade turns from top toward bottom.

Safety

Safety Guidelines

All operation and safety procedures are to be read and understood and only trained staff are to operate the equipment. Personal Protective Equipment is to be always worn whilst operating the cut off saw and safety requirements are to be adhered to. Isolate power with the supply disconnecting device before service or blade changes.

- Read all instructions before use. Establish a clean, dry, well lit, well ventilated workspace.
- Use caution to prevent injury, blade damage, or machine damage.

Critical Safety Requirements

- Disconnect power before inspection, maintenance, or service.
- Do not operate with safety guards removed.
- Wear PPE: safety glasses/face shield, hearing protection, and cut resistant gloves.
- Keep hands and body clear of moving parts and the cutting zone.
- Do not exceed the machine's rated hose size/construction.
- Do not cut materials other than hose.
- Avoid loose clothing and jewellery. Tie back long hair.
- No smoking during cutting.
- Be aware of fire/explosion risks: cutting used hose may release toxic fumes; some fluids and electrical sparks can ignite.

Safe Operation

- Power ON only immediately before cutting; power OFF immediately after the cut.
- Allow the blade to reach full speed before contacting the workpiece.
- Expect hot hose ends and possible hot fragments; avoid burns and shield the area as needed.
- Use respiratory protection when cutting hose that may contain residual fluids or produce fumes.

Safe Power Supply

- Mains powered unit: avoid extension cords; low voltage can damage the motor.
- Portable power sources: ensure stable voltage and sufficient capacity; low voltage can damage the motor.

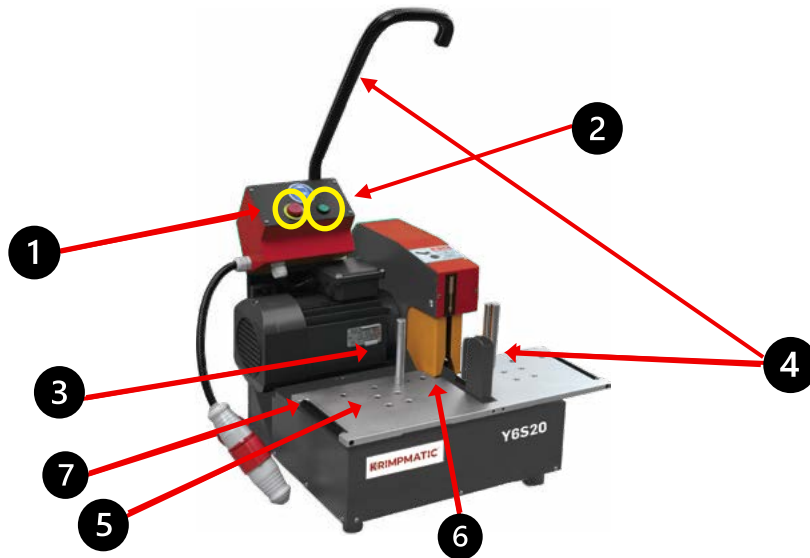
Machine Identification

The CE label on the rear of the machine includes:

- Manufacturer
- Serial number
- Year of manufacture
- Weight

Do not remove, cover, or damage the identification plate. This is strictly prohibited.

Y6S20



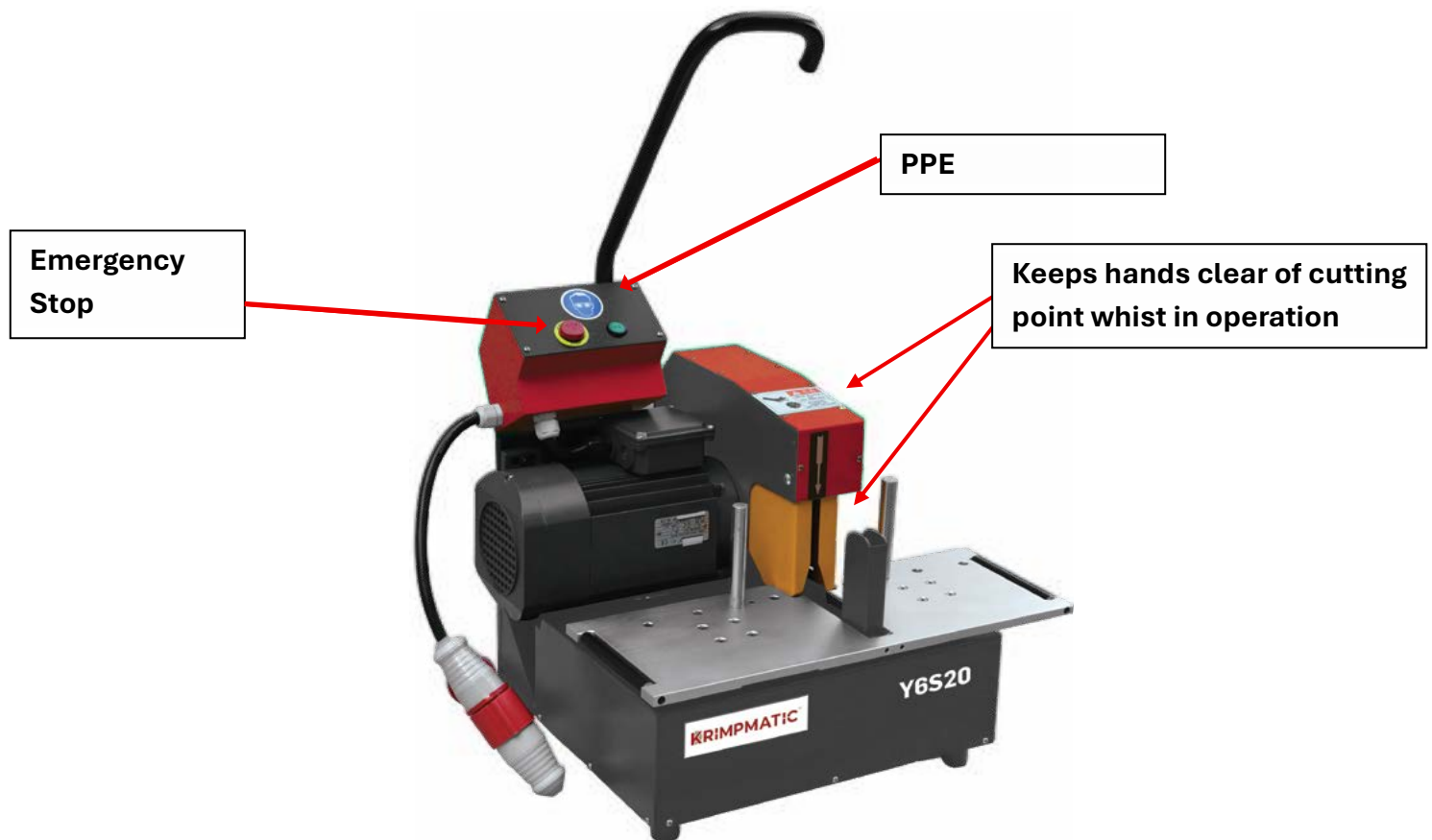
1. Emergency stop and stop switch: Press to cut power to the motor.

Note: The blade may continue spinning due to inertia. Wait for a complete stop before any adjustment or service.

2. Start switch: Press to start the motor and bring the blade up to cutting speed.
3. Hose lever: Bows the hose to present it correctly to the blade for efficient cutting.
4. Hose pusher: Linkage mechanism that advances the hose into the cutting zone when actuated.
5. Hose lever dividing holes and supports: Adjusts the spacing between hose supports to set the required bow radius. Adjust supports based on hose size being cut.
6. Blade guard: Protective shield that contains fragments and debris in the event of blade failure.

Note: Never operate with the guard removed or damaged.
7. Hose slide: Rotating slider that reduces friction during hose feed.

Danger Zones and Warning Labels



 EYE PROTECTION MUST BE WORN IN THIS AREA HEARING PROTECTION MUST BE WORN IN THIS AREA GLOVES MUST BE WORN IN THIS AREA	Always wear appropriate Personal Protective Equipment
 WARNING	Keeps hands clear of cutting zone whilst cut off saw is in operation
 EMERGENCY STOP	If the cut off saw is making any abnormal sounds or movements press the emergency stop immediately

Commissioning and Installation

Delivery and Setup

- The cut off saw is shipped fully assembled and wired.
- After unpacking, mount it to a suitable work surface and connect the plug to the correct mains power supply.
- Intended for use in workshop environments when securely bench mounted.

Preinstallation-

- Verify all fasteners are tight, including the arbor/blade nut.
- Inspect for any shipping damage.
- Confirm the steel cut off saw blade is centered with no axial or radial runout and rotates freely.
- Check rotation: viewed from the operator/handle side, the blade turns from top to bottom.
- Read the entire operation manual before use.
- Verify all power cords are new, undamaged, and rated for the intended power supply.
- Confirm required safety and information labels are present and legible:
 - Identification/CE plate
 - Emergency Stop label
 - Warning label
 - Personal Protective Equipment labels
 - Caution labels

Mounting requirements

Place the machine on a firm, stable, and level surface with adequate clearance for safe operation.

Secure the base to the work surface using suitable bolts with washers and nuts through the mounting holes in the base.

Ensure clear, easy access around the machine for operation, cleaning, and maintenance.

Installation Safety

- Disconnect power before installation or adjustment.
- Do not operate unless all safety guards and labels are installed and legible.
- Verify the installation is secure and stable before powering on.

Operating Procedure

1. Position the hose supports on the cutting plate in the dividing holes. Widen the supports relative to the size of the hose being cut.

Note: The supports must be equal distance on either side to the cutting blade.



2. Ensure the operating lever is in the most upright position (allowing hose pusher to be in its most open state)



3. Mark the hose cut location on the hose and position the hose to be cut so that:
 - i. it is lying flat on the hose cutting plate
 - ii. it is in contact with both hose supports
 - iii. the hose cut position that is marked on the hose is aligned with the cutting blade guard slot

Note: Do not cut or trim very short hose lengths. The hose must remain in contact with both hose supports for the entire cutting cycle.

4. Press the green Power ON switch located at the top of the cut off saw to power on the crimper and start the saw rotation.
5. Pull down on the cut off saw operating lever ensuring the hose is located against the supports
6. Pulling down on the lever will engage the pusher to present the hose to the cutting blade. The hose pusher will safely guide the hose through the guard and onto the cutting blade to commence cutting
7. Continue to pull down the lever until the hose is cut through maintaining a slow and even force.

Note:

Do not apply excessive force. Signs include the motor labouring, RPM drop, or stalling. Overloading can damage the steel cut off saw blade and distort or burn the hose. If overheating occurs, pause for several seconds to allow the blade to cool before resuming the cut.

8. When cutting is complete slowly release the lever back to its starting position and turn off the cut off saw
9. Carefully remove the hose from the cutting plate area
10. Inspect the hose to ensure a clean 90° cut has been achieved at the axis of the hose.

Never leave the cut off saw powered on or running unattended. To prevent unintentional activation, isolate the machine at the power source and depress the EMERGENCY STOP button.

Emergency Stop Button

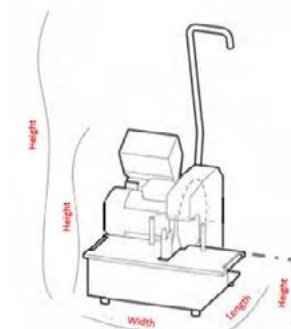
In any dangerous or emergency, immediately press the Emergency Stop button to cut power to the motor.

Examples include, but are not limited to, overheating of the workpiece or saw components; the hose, clothing, body parts, or jewellery becoming jammed or caught in the blade; or any other unsafe condition identified by the operator.

The Emergency Stop is located on the top of the cut off saw and is easily identifiable. It is the red button with a bright yellow border.

After pressing the Emergency Stop, disconnect all power by unplugging the machine from the power source.

Specifications



Krimpmatic™ Y6S20 220 Volt (single phase) & 400 Volt (3 Phase) cut off saw

The Krimpmatic™ Y6S20 is a compact and efficient cut off saw which optimises your hose cutting requirements by providing fast operation and clean cutting of textile, wire braided and multi spiral hydraulic hoses. Suitable for cutting hose up to 51mm (2") 4 spiral hoses.

Technical Parameters		87-CS-Y6S20-220V	87-CS-Y6S20-400V
Capacity	(inch)	2" (4 spiral)	2" (4 spiral)
Motor Power	(kW)	2.2	4
	(HP)	3	5
	(amps)	13	8
	(volts)	220	400
Frequency	(hz)	50	50
Velocity	(rpm)	2,850	2,850
Enclosure Class		IP54	IP54
Sound Pressure Level	(db.(A))	100	100
Electrical Requirements:			
Plug	(amps)	15	10
Circuit Breaker		C Curve	C Curve
Pneumatic Requirements:			
Air Pressure	(bar)	-	-
Cutting Blade:			
External Diameter	(mm)	300	300
Thickness	(mm)	2.5	2.5
Shaft Diameter	(mm)	32	32
Height to cutting table	(mm)	195	195
Dimensions: (L x W x H)			
Machine	(mm)	600	600
	(mm)	580	580
	(mm)	520	520
Machine (inc handle)	(mm)	930	930
Machine	(kg)	78	78
Shipping	(mm)	705	705
	(mm)	625	625
	(mm)	740	740
	(kg)	110	110

Maintenance and Inspection Guidelines

Proper maintenance and inspection are essential to maintain accuracy and performance of the cut off saw.

- Always switch off power before any maintenance. All electrical work must be performed by a qualified technician.
- Before any inspection, maintenance, or service:
 - Disconnect the power supply and press the EMERGENCY STOP button.
 - Attach a “Do Not Operate” safety tag and apply a maintenance lockout device.

General Maintenance

- Check all fasteners, including the blade retaining nut, to ensure they are tight.
- Add lubrication oil as required, using the correct type and method.
- Before use, inspect the steel cut off saw blade for nicks, cracks, distortion, missing segments, or other damage; replace immediately if defective.
- Ensure the blade is centrally mounted with no axial or radial runout; monitor for abnormal vibration during operation.
- For blade break in and conditioning, feed the blade slowly through a medium-size hose for the first five cuts.

Daily Maintenance

- Inspect the control box, electrical door, and components.
- Clean the cutting table and electrical box cover with a clean cloth.
- Verify the machine is securely mounted and in serviceable condition.
- Clean the area around the machine and remove any accumulated cutting debris.
- Add lubrication oil where required.

Weekly Maintenance

- Check for any abnormal sounds or vibration during operation.
- Inspect the external power cable for damage or deterioration.
- Ensure all safety and warning labels are clean and legible; replace any that are unclear or missing before use.
- Inspect the safety cover/guard for damage.

Cut Off Saw Blade Inspection and Maintenance

Indicators the cut off saw blade may need replacing include:

- Hose tube separating from the reinforcement
- Wire reinforcement turning blue due to overheating
- Wire reinforcement not cutting cleanly
- Excessive force required to cut
- Blade cutting edge bluing from heat or blade warpage

Blade Changing Procedure



1. Disconnect the electrical power supply from the cut off saw. Attach a “Do Not Operate” safety tag.
2. Wearing safety gloves, remove the screws from the cover that is mounted over the blade.
3. Remove the blade shroud from the saw.
4. Using the appropriately sized spanner, hold the blade shaft, loosen the nut securing the steel cut off saw blade, and remove the blade. Handle blades with extreme care to avoid injury.
5. After removing the blade, ensure the hub and shaft are clean and free of debris.
6. Install the replacement blade in the reverse order. Ensure it is straight and true, with the correct rotation direction and tooth orientation. Inspect all components for wear or damage and replace as needed. Tighten the blade nut to the correct torque.
7. Reinstall the cover that is mounted over the blade
8. Remove the “Do Not Operate” safety tag.
9. Reconnect the electrical power supply.
10. Verify the blade is centrally mounted with no axial or radial runout. Check for vibration during operation. If runout or vibration is present, immediately power off and repeat steps 1–9.

Safe Transportation, Storage and Packaging Disposal

Transportation

Move the cut off saw in its secure wooden packing box with carry slings, in compliance with all OH&S regulations. After unpacking, due to its net weight of approximately 110 kg, lift only with an approved, appropriately rated lifting sling.

Storage

For extended periods of non-use, store the cut off saw in its wooden packing box, in a clean, dry area protected from dust, direct sunlight, and moisture. Ensure all power is fully disconnected.

Packaging Disposal

Follow local environmental regulations for disposing of packing and shipping materials. Reuse or recycle where possible to minimize landfill.

Warranty

- Term: One (1) year from the purchase date, provided the product is used per the operation manual.
- Coverage: Defects in materials and workmanship only. Remedy is limited to replacement of defective parts.
- Exclusions:
 - Improper use, misuse, or normal wear and tear
 - Travel expenses, shipping costs, and any associated costs or downtime
 - Lost income or any consequential or incidental damages
- Service: Warranty repairs must be performed by the manufacturer or an authorized service technician approved by the manufacturer.
- Delivery inspection: Verify the machine is undamaged and all listed items are present upon receipt. The manufacturer is not liable for missing or incorrect parts not reported within eight (8) days of delivery.



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