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### Sheet Metal and Plate Cutting Machine

Kavax is a highly versatile and extremely useful sheet metal and plate-cutting machine. Its compact size and low weight enable it to move around easily on the workshop floor or to be taken along by the operator on mobile worksites. If the machine is not intentionally treated carelessly and unnecessarily overloaded, it will serve you faithfully for many years. Simply follow these directions carefully and the Kavax will prove to be a dependable and useful aid for everyone working with sheet metal and plate.



#### Instruction Manual:

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- **General Precautions**
  - **Maintenance**
  - **Setting the cutter wheels**
  - **Grinding the cutter wheels**
  - **Regrinding the cutting wheels**
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# KAVAX

# General Precautions

## Before using the machine:

- Fit the motor attachment (58 - fig. 1) and secure the motor so the direct coupling fits onto the drive shaft.
- Remove the plug (23 - fig 1) on the gear housing and fill up with the oil provided.
- Check the setting of the cutter wheels (see “Maintenance”).
- Only motors with spring-action switches may be used in combination with Kavax.

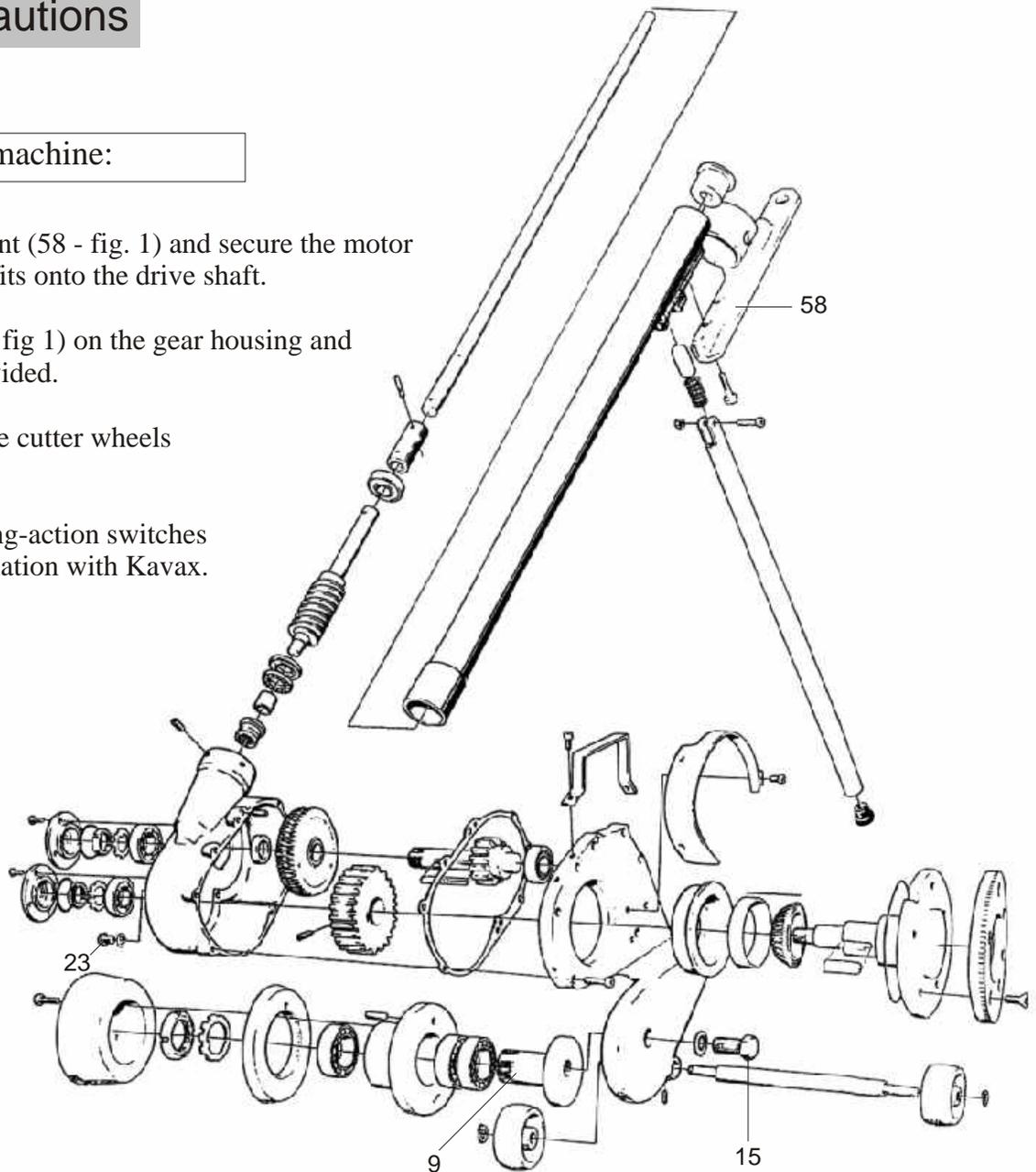


fig. 1

## This is how to use your Kavax

The sheet metal or plate to be cut must be at the same height as the cutting table (150 mm). A standard pallet may be used to advantage for this purpose.

Mark out the cutting line and move the machine along the marking.

One of the advantages of the Kavax is that it can also be used to make bent cuts.

## CAUTION!

The guards over the chuck and cutter wheels must always be fitted!

## Maintenance

The oil should be changed for the first time when the machine has been in use for 20 hours and then at intervals of 400 hours. The oil must nevertheless be changed at least once per year.

To change oil, remove the plug (23 - fig 1) and place the machine on its side so that all the oil flows out. Refill with 0.25 dm<sup>3</sup> (litres) of Kavax Oil X 1001-3, which can be obtained from your retailer.

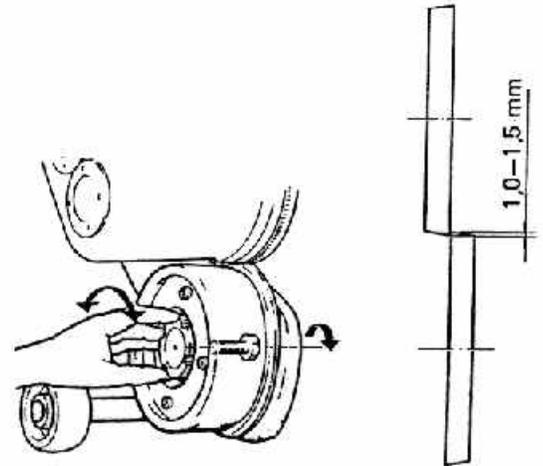
Brush a little lubricating oil on the upper cutter wheel every now and then. By this means, the cutter wheel will retain its sharpness longer and its service life be significantly increased.

## Setting the cutter wheels

The setting of the cutter wheels should be checked at regular intervals and, needless to say, always adjusted after regrinding. The correct overlap is 1.0-1.5 mm. To adjust, turn the lower cutter wheel shaft (9 - fig. 1) having first slackened the screw (15 - fig. 1). The play between the cutter wheels is approx. 0.15mm.

## Grinding the cutter wheels

The cutter wheels need to be resharpener when they have been in use for some time - see "Grinding Instructions". If you do not have grinding resources of your own, you can opt to use the replacement Service offered by the dealer.



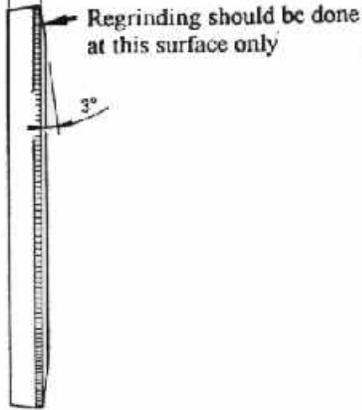
The technical drawing shows the machine from a side perspective. In the upper left corner, there is a graph with 'Capacity in steel' on the y-axis and 'Speed' on the x-axis. The graph shows a curve that starts high and decreases as speed increases. Below the graph, there are several lines of text, likely representing a table of data, but they are too small to read. To the right of the machine drawing, there is a section titled 'Technical data' with the following information:

Capacity in steel:	0.19-0.1875 inch
Speed:	5-16 ft/min depending on thickness and drive motor.
Weight:	78 lbs
Drill motor rating:	700 W
Recommended drill speed:	300-1200 r/min
Oil volume in gear housing:	½ pint
Gear oil:	Kavax Oil X 1001-3

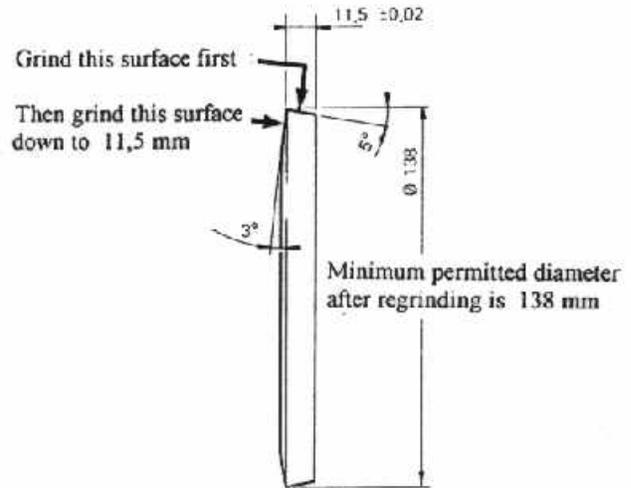
# Regrinding the cutting wheels

## Regrinding of upper cutter wheel

New cutter wheel	11,5 ±0,02
Regrinding 1	11,3 ±0,02
Regrinding 2	11,1 ±0,02
Regrinding 3	10,9 ±0,02

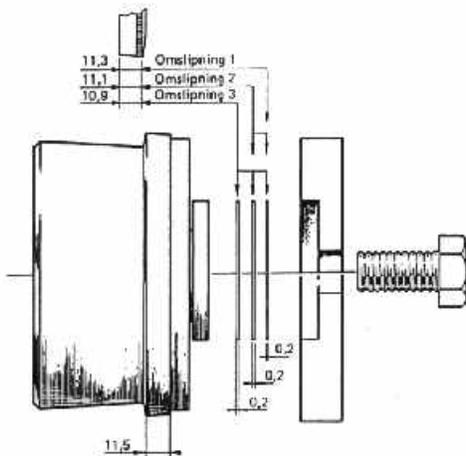


## Regrinding of lower cutter wheel



## Using Shims

By assembly the shear wheels, the reduced width of the upper wheel shall be compensated by adding shims between the lower wheel shaft and the stand.



## Adjusting

The pass between the wheels shall 0.15mm.

Measuring the overlap has to be done as the figure shows.

“B” has to be one millimeter (0.04”) shorter then “A”.

