TOOLS FOR CUTTING SLABS

USE AND MAINTENANCE MANUAL

RAIMONDI
DALL'1974 INNOVAZIONI PER I PROFESSIONISTI DELLA POSA
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# TABLE OF CONTENTS

**FREE-CUT**

## CHAPTER 1  INTRODUCTION

1.1 TESTING, WARRANTY AND RESPONSIBILITY .......................................................... 4/32-1
1.2 ENVIRONMENTAL CONDITIONS ............................................................................ 4/32-1
1.3 INTERVENTION REQUEST – TECHNICAL SERVICE ............................................. 5/32-1
1.4 SPARE PARTS ORDER ......................................................................................... 5/32-1

## CHAPTER 2  SAFETY RULES

2.1 GENERAL SAFETY NOTES .................................................................................. 6/32-2
2.2 DEFINITION OF SAFETY TERMS ....................................................................... 7/32-2
2.3 DEMOLITION AND DISPOSAL ............................................................................. 7/32-2
2.4 “FREE-CUT” – SYSTEM FOR CUTTING SLABS .................................................. 8/32-2
   2.4.1 Correct use ..................................................................................................... 8/32-2
   2.4.2 Description of units ........................................................................................ 8/32-2
   2.4.3 Operator’s position ........................................................................................ 8/32-2

## CHAPTER 3  HANDLING, INSTALLATION, ADJUSTMENTS

3.1 PACKING TRANSPORT ....................................................................................... 9/32-3
3.2 ASSEMBLY ......................................................................................................... 9/32-3

## CHAPTER 4  USE

4.1 USE .................................................................................................................. 11/32-4

## CHAPTER 5  MAINTENANCE INTERVENTIONS

5.1 MAINTENANCE .................................................................................................. 13/32-5
   5.1.1 Replacement of cutting wheel with spindle .................................................. 13/32-5
   5.1.2 Pulley adjustment ......................................................................................... 14/32-5
   5.1.3 Suction cups ............................................................................................... 14/32-5

## CHAPTER 6  SPARE PARTS

6.1 SPARE PARTS ................................................................................................... 15/32-6

## CHAPTER 7  ACCESSORIES

7.1 ACCESSORIES .................................................................................................. 17/32-7
   7.1.1 Kit for fixing to the bench (169DTR) ............................................................... 18/32-7
      7.1.1.a Assembly ............................................................................................... 18/32-7
      7.1.1.b Use with kit for fixing to the bench ......................................................... 20/32-7
   7.1.2 Pliers for high thicknesses ............................................................................ 21/32-7
      7.1.2.a Employment ........................................................................................... 21/32-7
7.1.3 “FREE-FLEX” device
    7.1.3.a Use
    7.1.3.b Blade replacement
    7.1.3.c Pulley adjustment
    7.1.3.d Wheel adjustment
    7.1.3.e Spare parts

7.1.4 “FREE-FLEX 45°” device
    7.1.4.a Use
    7.1.4.b Blade replacement
    7.1.4.c Reference adjustment
    7.1.4.d Pulley adjustment
    7.1.4.e Wheel adjustment
    7.1.4.f Spare parts
1.1 Testing, warranty and responsibility

Testing
The equipment is shipped to the customer already prearranged for being installed after having passed tests and testings envisaged by the manufacturer in compliance with the regulations in force.

Warranty
During the 12-month warranty, RAIMONDI S.p.A. undertakes to supply, free of charge, those parts of its production found to be defective, in terms of material or processing. Such parts will have to be returned to RAIMONDI S.p.A., shipped carriage free.
By warranty, we mean supply of defective parts, if any.

The warranty does not cover all the expenses as to travel, board, lodging, transport and manpower concerning the replacement of parts by the RAIMONDI S.p.A. technicians, which will be charged entirely on the Customer.
The warranty does not cover all the parts subject to wear.

As to purchased components, the supplier warranty will apply.
No compensation will be granted for expenses, damages or loss of profits incurred by customer.

Installing commercial parts not complying with RAIMONDI S.p.A. specifications – if marketed – or not supplied by RAIMONDI S.p.A. – if manufactured by it – shall make the warranty void as well as using the equipment improperly.

Responsibility
RAIMONDI S.p.A. shall not be held liable for any anomalies in the operation or generic failures deriving from the unauthorized use of the equipment or interventions and/or modifications carried out by external people not authorized by RAIMONDI S.p.A.

1.2 Environmental conditions

The environmental operation conditions of equipment must be the following:

Temperature  
+10°C ÷ +55°C (50°F ÷ 131°F)
Humidity  
10% ÷ 90% (not condensed)

THE EQUIPMENT MUST BE SHELTERED FROM RAIN.

Environmental conditions different than the ones specified herein may cause serious damage to the equipment.

PLACING THE EQUIPMENT IN ENVIRONMENTS NOT CORRESPONDING TO THE SPECIFICATIONS WRITTEN HEREIN SHALL MAKE WARRANTY NULL AND VOID.

Storage of the equipment not working allows for a temperature variation ranging between +10°C (50°F) and +70°C (158°F), without prejudice to the other precautions.

USE IN ENVIRONMENTS WITH EXPLOSIVE ATMOSPHERE OR FIRE RISK IS STRICTLY FORBIDDEN.
1.3 Intervention request - Technical Service

Each intervention request to the Technical Service shall be sent, by fax, to:

RAIMONDI S.p.A.
Technical Service
Telefax (39) 059 282 808
E.mail: raiutens@raimondiutensili.it

Specifying:
1. type of equipment, registration number, serial number and year of manufacture;
2. detected defects;
3. dealer where the equipment was purchased;
4. receipt for item purchased certifying the date of purchase by the user.

1.4 Spare parts orders

Each request of spare parts shall be sent, by fax, to:

RAIMONDI S.p.A.
Technical Service
Telefax (39) 059 282 808
E.mail: raiutens@raimondiutensili.it

Specifying:
1. Equipment model;
2. Registration number (see manual title page);
3. Code of the part to be ordered (see spare parts manual enclosed);
4. Requested quantity;
5. Shipping modality.
2.1 Safety general rules

1. Never try to use the equipment until its operation has been clearly understood.
2. In case of doubts, despite having carefully and entirely read this manual, please contact the RAIMONDI S.p.A. Technical Service.
3. Make sure that all provisions relating to safety are known by the whole personnel involved in the use of the equipment.
4. Before using the equipment, the operator must check any presence of visible defects on the safety devices and equipment.
   In that case immediately notify any apparent damage RAIMONDI S.p.A. or the nearest Technical Service Center.
5. Never use the equipment before having notified and moved away all personnel in the vicinity of it.
6. Daily check the correct operation of all the safety devices and switches.
7. Safety devices shall never be removed nor made ineffective.
8. During maintenance, adjustment or repair interventions, it might be necessary to disable some of the safety devices.
   This operation shall be carried out by authorized personnel only.
9. The operator shall be familiar with the function and position of the STOP and START buttons.
10. Replace parts deemed to be broken with original spare parts, warranted by the manufacturing company.
11. Never try reckless solutions!
12. Do not wear clothes, ornaments or accessories that might get entangled in the moving members.
13. Always wear protective glasses, hearing protectors, particulate respirator suitable for the product to be worked and any other personal protection equipment in the areas where such equipment is required.
14. Pay the utmost attention to all the signs of precaution, warning and danger placed on the equipment.
15. Always comply with and ensure compliance with the safety rules; in case of doubts, please consult this manual again before taking any action.
16. The equipment must be solely used for its intended uses and according to what was established with RAIMONDI S.p.A. by contract.

DO NOT USE THE EQUIPMENT FOR DIFFERENT USES THAN THE ONES SPECIFIED IN THIS MANUAL.
DO NOT WORK PRODUCTS DIFFERENT THAN THE ONES WRITTEN IN THIS MANUAL.

Improper use of the equipment may result in dangers for the personnel in charge of operating it and may damage the equipment as well.

For any problem that may arise during the operating life of equipment and that is not covered by the following technical documentation, it shall be necessary to contact our Technical Customer Service in order to resolve the problem as soon as possible.
2.2 Definition of safety-related terms

The following safety-related terms are used in this manual:

**Dangerous area**

every zone inside and/or in proximity of the equipment where the presence of an exposed person poses a risk for the safety and health of this personnel.

**Exposed person**

whoever is – both completely and partially – inside a dangerous area.

**Operator**

person responsible for installing, operating, adjusting, servicing, cleaning, repairing, transporting parts of the equipment and all the other activities required to operate it.

**Safety component**

component expressly designed by the manufacturer and marketed separately from the equipment in order to fulfill the safety functions. Therefore the safety component is defined as that mechanism whose failure to operate jeopardizes the safety of the exposed people.

2.3 Demolition and disposal

The manufacturer estimates a life of 15,000 hours of operation under normal conditions of use.

When the life cycle is over, the company using the tool must dispose of it by fully complying with the regulations in force. It must first empty it of the lubricating fluids and thoroughly clean the various elements, then disassemble the different pieces making up the equipment.

After having disassembled the equipment according to the previous disassembly procedure, the various materials must be separated pursuant to what it is provided for by the regulations of the Country where the equipment must be disposed of. The equipment does not contain any hazardous components or substances requiring special procedures of disposal.

**WARNING**

DURING THE DISPOSAL PROCESS, COMPLIANCE WITH THE LAWS IN FORCE IN THE COUNTRY IS REQUIRED. POLLUTANTS, SUCH AS OILS AND SOLVENTS, SHALL BE STORED EXCLUSIVELY IN METAL DRUMS.
2.4 “Free-Cut” – System for cutting slabs/tiles

2.4.1 Correct use

Employment
“Free-Cut” cutting bar is used to cut and cut off big slabs/tiles such as: ceramic, porcelain, etc…

THE EQUIPMENT CANNOT BE USED FOR OTHER TYPES OF PRODUCTS WITHOUT THE EXPLICIT AUTHORIZATION BY RAIMONDI S.P.A. WHICH SHALL NOT BE HELD LIABLE FOR ANY DIRECT OR INDIRECT DAMAGES DERIVING FROM AN IMPROPER USE OF THE EQUIPMENT.

2.4.2 Description of units

“FREE-CUT” equipment is made up of a series of units which interact so that they always work effectively. The identifiable units are the following:

1 Complete guide
2 Patch cord
3 Cutting-off pliers
4 Cutter unit

2.4.3 Operator’s position

“FREE-CUT” must be used by at least two operators: one for the incision phase and the other one to support the cut part in order to prevent the slab from falling and breaking.

The operator shall position himself next to the equipment. By grabbing the knob of the cutter unit the operator can perform the incision of slabs. Once the incision phase is over, he can complete the cutting-off with the aid of a second operator and by means of the cutting-off pliers.
### 3.1 Packing transport

Before using the equipment make sure there are no broken, worn-out or damaged parts. Should that be the case, promptly replace them. In order to replace those parts, carefully follow the instructions contained in this manual.

### 3.2 Assembly

**WEAR PROTECTIVE GLOVES AND ACCIDENT-PREVENTION SHOES TO PERFORM THESE OPERATIONS.**

**THE TOOLS MUST BE POSITIONED ON A STURDY, FLAT SURFACE.**

**Clip module assembly**

Extract the guide from the container tube (A) and insert the cutting trolley (B). Later insert the left-hand (C) and right-hand (D) reference squares.

**Extension module assembly**

**THE GUIDE OBTAINED BY CONNECTING THE TWO MODULES MUST BE HANDLED WITHOUT STRESSING THE CONNECTING POINT.**

Position the guide on a wooden bench, remove plugs (E) by removing the fixing screws (F); remove the right-hand square (D) by unscrewing knobs (G).
Pull out the left-hand reference square (C) and the cutting trolley (B). Couple the two modules (H) and (I), fitting pins (L) into the holes (M).

Fasten the two modules using the snap hook (N) and tighten the wing nut (O); check the correct fastening between the two modules and insert the cutting trolley (B) into the guide (A). Insert the reference left-hand (C) and right-hand (D) squares again.
4.1 Use

**Wear Protective Gloves and Accident-Prevention Shoes to Perform These Operations.**

**Set Up a Stable, Flat Work Bench for Cutting Operations.**

Guide positioning

Position the slab to be cut on the bench and mark out the portion to be removed to the end. Position the cutting guide (A) so that the references of squares (B) and (C) coincide with the marked lines.

Lock the guide position (A) by means of suction cups (D). Then visually check that the cutting wheel is beside the size marked on the slab; if need be, perfection the guide positioning.

**Incision**

*In order to ensure a correct incision, both the pressure and feeding of cutting trolley must be constant.*

Cut into an end of the slab by approximately 10 cm (3" 15/16") by pushing the cutting trolley toward the edge; resume from where the incision was started and complete it up to the opposite edge of the slab.
Cutting off slabs with thickness ranging from 3 mm (1/8”) to 6 mm (15/64”)

**WARNING**

TWO PEOPLE ARE REQUIRED IN ORDER TO PREVENT THE SLAB FROM FALLING OR BREAKING.

By means of the cutting guide move the slab until the incision line juts out 5 cm (1” 31/32”) or 10 cm (3” 15/16”) from the work bench; release the cutting guide from suction cups and shift it toward the middle of the slab. Position the cutting-off pliers (G) beside the line cut into the slab and exert a progressive pression until the beginning of the cutting off is noticed; repeat the operation in the opposite area of the slab. If need be, complete the cutting off manually or by means of the cutting-off pliers.

**WARNING**

AT LEAST TWO OPERATORS MUST GRIP THE PORTION TO BE REMOVED AND EXERT A PROGRESSIVE PRESSION DOWNWARD.

Cut edges can be refined by means of diamond pads (H).
5.1 Maintenance

5.1.1 Replacement of cutting wheel with spindle

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

Remove trolley (A) from guide. Unscrew the screw (B) and remove the wheel (C), the 2 washers (D) and bearing (G). If need be, replace the sponge (E) inside the stem (F).

Insert screw (B), first washer (D1), wheel (C) and second washer (D2).

Reposition the bearing (G) and tighten the nut (H). Make sure the wheel rotate freely. Make sure the screw turns together with the wheel.
5.1.2 Pulley adjustment

In order to adjust the top pulley (A) the screw (B) must be loosened; once it has been adjusted, fully tighten it.

5.1.3 Suction cups

Suction cup rubbers (A) must be clean for a correct grip. Should they be worn out or damaged, replace them.
# 6.1 Spare parts

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7.1 Accessories

WEAR PROTECTIVE GLOVES AND ACCIDENT-PREVENTION SHOES TO ASSEMBLE ACCESSORIES.

TABLE OF CONTENTS

7.1.1 KIT FOR FIXING TO THE BENCH (169DTR)
   7.1.1.a Assembly .................................................. 18/32-7
   7.1.1.b Use with kit for fixing to the bench .................. 20/32-7

7.1.2 PLIERS FOR HIGH THICKNESSES
   7.1.2.a Use of the pliers for big sizes and high thicknesses .................. 21/32-7

7.1.3 “FREE-FLEX” DEVICE
   7.1.3.a Employment .............................................. 23/32-7
   7.1.3.b Blade replacement ....................................... 25/32-7
   7.1.3.c Pulley adjustment ....................................... 25/32-7
   7.1.3.d Wheel adjustment ....................................... 26/32-7
   7.1.3.e Spare parts ............................................. 27/32-7

7.1.4 “FREE-FLEX 45°” DEVICE
   7.1.4.a Use .................................................... 28/32-7
   7.1.4.b Blade replacement ....................................... 29/32-7
   7.1.4.c Reference adjustment ................................... 30/32-7
   7.1.4.d Pulley adjustment ....................................... 30/32-7
   7.1.4.e Wheel adjustment ....................................... 31/32-7
   7.1.4.f Spare parts ............................................. 32/32-7
### 7.1.1 Kit for fixing to the bench (169DTR)

The kit to secure “FREE-CUT” to the bench allows repeatedly cutting slabs (ceramic, porcelain, etc...).

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**7.1.1.a Assembly**

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**A STABLE, HEAVY-DUTY, FLAT BENCH IS REQUIRED TO CARRY OUT THIS OPERATION.**

Position the guide on a wooden bench, remove plugs (A) by removing fixing screws (B); remove the right-hand and left-hand squares (C) by unscrewing knobs (D).

Position the right-hand head (E) and the left-hand one (F) on the bench and lower the respective supports (G); insert the right-hand head (E) on the guide (H).
Clamp fixing knobs (I) and repeat the same operation for the left-hand head (F); fasten the cutting-off rules onto the bench edge (L) by means of screws (M), making the bench surface coincide with the rule corner. Loosen handles (N) and adjust supports near the 5 cm (1" 31/32") indicated on guides (O) and clamp handles (N).

Position guides (O) with zero near the rule corner (L), then fasten guides to the bench (O) by means of fixing screws (P1). Loosen handles (N) and adjust supports near the 9 cm (3" 35/64") indicated on guides (O) and clamp handles (N). Fasten guides (O) to the bench by means of fixing screws (P2).

Loosen handles (N) and adjust supports near the zero shown on guides (O) and clamp handles (N); fasten guides to the bench (O) by means of fixing screws (P3). Loosen handles (N) and make sure “FREE-CUT” properly slides on guides.
7.1.1.b Use with kit for fixing to the bench

**TO BE USED FOR SLABS WITH MAXIMUM THICKNESS OF 6 MM (15/64”).**

Loosen handles (A) on both sides. Position “FREE-CUT” to the desired size to which cut is to be performed using the indicators (B) and later lock handles. Lift “FREE-CUT” until it reaches the magnets holding it in position. Insert the slab (C) to be cut under “FREE-CUT”, positioning it with its edge alongside the cutting-off corner (D).

If cutting-off rules are being used, lift references (E) to help yourself in positioning it. Lower “FREE-CUT” until it comes into contact with the material; if need be, clamp suction cups. For the incision phase, refer to what is written in the paragraph on how to use “FREE-CUT”. Then lift “FREE-CUT” and position the slab so that the cutting line is beside the cutting-off corner and carry on cutting it.
7.1.2 Pliers for high thicknesses

Cutting-off pliers are a tool conceived to cut off slabs (ceramic, porcelain, etc.) previously cut into.

7.1.2.a Employment

Choosing the breaker and position of pressing device support
- Cutting off with a width exceeding 5 cm (1 31/32") of elastic materials, use the 90° flat breaker with square (8) and pressing device support (3).
- Cutting off with a width exceeding 5 cm (1 31/32") of rigid materials, use the 90° round breaker with square (7) and pressing device support (3).
- Cutting off with a width lower than 5 cm (1 31/32") use the free flat breaker (9) by steering it 45° and pressing device support (3).
- Point-point cutting-off (diagonal), use the 90° free flat breaker and pressing device support (3).

Breaker assembly

Fully open pliers by unscrewing knob (A). Correctly position the chosen breaker and clamp breaker knob (A).
Positioning of pressing device support

Pressing device support can be positioned at 90° (a) or at 45° (b). To switch from a position to the other one fully tighten the knob (A) until pressing device support (B) can rotate freely (b). Bring it to the position and unscrew knob (A) to make it remount the guide.

Positioning of pressing devices (4)

Pressing devices (4) must be positioned according to the cutting widths, keeping them as much apart as possible, but anyhow inside the material.

Cutting off execution

Position the pliers so that the breaker is exactly alongside the cutting line, using the indicators of the square or pressing device support. Constantly screw the knob by degrees (A) until the sound of breaking is heard.

Unscrew knob and position the pliers on the opposite side of the material and repeat the operation. Carry on screwing knob, moving the fracture forward to the opposite side.

In case of cuts with a width lower than 5 cm (1 31/32") move the fracture forward by shifting the pliers next to the material.
7.1.3 “FREE-FLEX” device

ACCESSORIES CANNOT BE USED FOR OTHER TYPES OF MATERIALS OR USES. IT IS STRICTLY FORBIDDEN TO USE IT WITH CUTTING BLADES FOR WOOD, ALUMINUM AND IRON. RAIMONDI S.p.A. SHALL NOT BE HELD LIABLE FOR ANY DIRECT OR INDIRECT DAMAGES RESULTING FROM AN IMPROPER USE OF ACCESSORIES.

MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS.

“FREE-FLEX” device is used to cut big slabs/tiles in ceramic, porcelain, natural stones with a maximum thickness of 12 mm (15/32”); it was designed to be installed onto the cutting guide of “FREE-CUT”.

7.1.3.a Employment

TO BE SOLELY USED WITH EXHAUST FAN PLUGGED IN.

MAKE SURE THAT POWER SUPPLY VOLTAGE OF MAINS CORRESPONDS TO THE DATA ON MOTOR RATING PLATE.

TO BE SOLELY USED PAIRED WITH CUTTING GUIDE.

Guide positioning

Position the slab to be cut on the bench and position the cutting guide on it (A). Fit “FREE-FLEX” (B) onto the guide (A); mark the portion to be removed at the end.
Position the blade (C) alongside the marked line and clamp the suction cup by acting on handle (D); measure the distance between the guide (A) and the slab edge and bring it back to the other end. Lock the other suction cups by acting on handles.

**Cut**

![Diagram](image)

**TWO PEOPLE ARE REQUIRED TO PREVENT THE SLAB FROM FALLING OR BREAKING.**

In order to ensure a linear cut, it is necessary to use blades in working order, to maintain a constant feeding speed proportionate to the thickness and type of material to be cut. In order to optimize the life of diamond blade, it is advisable to pause for a few seconds every 25 cm (10”) of cut.

Put the suction hose into the suction mouth (E). Start exhaust fan. Start the grinder and start cutting. Advance with constant speed, slowing down at 5 cm (2”) from the cut end. Cut edges may be refined by means of diamond pads.
7.1.3.b Blade replacement

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS TO CARRY OUT THOSE OPERATIONS.

Remove screws (A) and remove pulley support (B). Lock blade shaft by means of the suitable button found on the grinder, and unscrew the blade locking ring nut (D) by means of the supplied wrench (C). Install the new blade (E) following the rotation direction shown by the arrow etched on the blade. Reinstall pulley support. Check the correct assembly by manually rotating the blade.

7.1.3.c Pulley adjustment

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS TO CARRY OUT THOSE OPERATIONS.

Take out the pulley holder as indicated in the chapter of diamond blade replacement. Insert the pulley holder into the cutting guide. Loosen the pulley fixing screw (A) and adjust the pulley. Once it has been adjusted, lock the pulley by tightening the screw. Repeat the same operations for the pulley (B).
7.1.3.d Wheel adjustment

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS TO CARRY OUT THOSE OPERATIONS.

Cutting blade must be removed and the screw (A) of the front wheel (B) must be loosened in order to adjust wheels. Adjust the wheel (B) so that it supports the material and tighten the screw (A). Repeat the same operation on the rear wheel.

Check the correct adjustment by moving on the material without changing the trim of the device.
## 7.1.3.e Spare parts

<table>
<thead>
<tr>
<th>ELEM.</th>
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<th>DESCRIPTION</th>
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<td>169GTS02A</td>
<td>FLEX HOLDING UNIT FOR 169GTF</td>
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<td>DIAMOND BLADE 0125MM F22,2MM TURBO</td>
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<td>299FLEX</td>
<td>GRINDER 1200W 230V 50 60HZ12</td>
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<td>GRINDER 850W 110V 50/60HZ (GB)</td>
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<td>4.2</td>
<td>299FLEX110VUSA</td>
<td>GRINDER 1050W 120V 50/60HZ SP.USA</td>
</tr>
</tbody>
</table>
7.1.4 “FREE-FLEX 45°” device

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TO BE SOLELY USED WITH EXHAUST FAN PLUGGED IN.

MAKE SURE THAT POWER SUPPLY VOLTAGE OF MAINS CORRESPONDS TO THE DATA ON MOTOR RATING PLATE.

TO BE SOLELY USED PAIRED WITH CUTTING GUIDE.

---

“FREE-FLEX 45°” device is used to bevel big slabs/tiles in ceramic, porcelain, natural stones with a minimum thickness of 5 mm (13/64”) and a maximum one of 12 mm (15/32”); it was designed to be installed on the cutting guide of “FREE-CUT”.

7.1.4.a Employment

Guide positioning

Position the slab to be cut on the bench and position the cutting guide on it (A). Correctly position the bar using the references (B).

Clamp suction cups by acting on handles (C); insert “FREE-FLEX 45°” (D) into the guide (A).
Cut

In order to ensure a linear beveling, blades in working order must be used, a constant feeding speed proportionate to the thickness and type of material to be cut must be maintained. In order to optimize the life of diamond blade, it is advisable to pause for a few seconds every 25 cm (10”) of cut.

Put the suction hose into the suction mouth (E). Start the exhaust fan. Start the grinder and start beveling. Advance with constant speed, slowing down at 5 cm (2”) from the bevel end.

7.1.4.b Blade replacement

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS TO CARRY OUT THOSE OPERATIONS.

Remove screws (A) and remove protective casing (B). Lock blade shaft by means of the suitable button found on the grinder, and unscrew the blade locking ring nut (D) by means of the supplied wrench (C). Install the new blade (E) following the rotation direction shown by the arrow etched on the blade. Reinstall protective casing (B). Check the correct assembly by manually rotating the blade.
7.1.4.c Reference adjustment

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

In order to adjust the reference, a test bevel must be performed by positioning the cutting guide onto the slab until the desired bevel has been obtained. Unscrew knob (A) and draw the reference (B) close to cutting guide. Adjust the screw (C) until it touches the beveled edge of slab. Tighten knob (A).

7.1.4.d Pulley adjustment

WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.

MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS TO CARRY OUT THOSE OPERATIONS.

In order to adjust pulleys take the pulley holder out of the device and insert the pulley holder into the cutting guide. Loosen the pulley fixing screw (A) and adjust the pulley. Once it has been adjusted, lock the pulley by tightening the screw. Repeat the same operations for the pulley (B).
7.1.4.e Wheel adjustment

**WARNING:**

**WEAR PROTECTIVE GLOVES TO CARRY OUT THIS OPERATION.**

**WARNING:**

**MAKE SURE THE ACCESSORY IS UNPLUGGED FROM MAINS TO CARRY OUT THOSE OPERATIONS.**

Cutting blade must be removed and the screw (A) of the front wheel (B) must be loosened in order to adjust wheels. Adjust the wheel (B) so that it supports the material and tighten the screw (A). Repeat the same operation on the rear wheel.

**Check the correct adjustment by moving on the material without changing the trim of the device.**
### 7.1.4.f Spare parts

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