



# MODEL H7538 CIRCLE CUTTER INSTRUCTION SHEET

## **⚠️ WARNING**

To reduce the risk of serious personal injury or property damage when using this circle cutter:

- **ALWAYS** verify that the drill press or mill is not in a high speed setting before turning the machine **ON**. **ONLY** use this tool at speeds of 250 RPM or less. Exceeding this speed can cause the tooling to be ejected.
- **ALWAYS** inspect the circle cutter to ensure that all set screws are tight before every use. A loose set screw can cause the tooling to fly apart.
- **KEEP** your body and limbs clear of cutter operation area as the tool can grab anything in its area of rotation. Tie back all loose clothing and hair before use. Remove jewelry and any other item that may become entangled with the tooling.
- **NEVER** attempt to use this circle cutter in a hand held drill. **ONLY** use this circle cutter in a fixed drill press or mill to avoid a twisting entanglement hazard.
- **ALWAYS** ensure that the workpiece is securely clamped in position. Holding a workpiece by hand during cutter use is an entanglement hazard.
- **BEFORE** use, always disconnect the machine from power and rotate the circle cutter 360° by hand to verify that it moves without obstruction.
- **ALWAYS** wear ANSI approved safety glasses and a face shield.
- **DO NOT** modify this circle cutter in any way or use it in a manner for which it was not designed.

## Introduction

The Model H7538 circle cutter cuts holes in wood, plastics and various laminates from 1<sup>3</sup>/<sub>8</sub>" to 7" in diameter. If the workpiece is cut from both sides, the maximum cutting depth is up to 1". The HSS cutter with 5% cobalt is a single flute design for easy sharpening and effective chip clearing. The 1/2" shank fits most drill press and mill chucks. An interchangeable index pin serves as an alignment point for pre-drilled workpieces.

## Inventory (Figure 1)

A.	Model H7538 Circle Cutter	1
B.	Hex Wrench 3mm	1
C.	Index Pin 1/4"	1
D.	HSS Drill Bit 1/4"	1
E.	HSS/Cobalt Cutter 1/4"	1

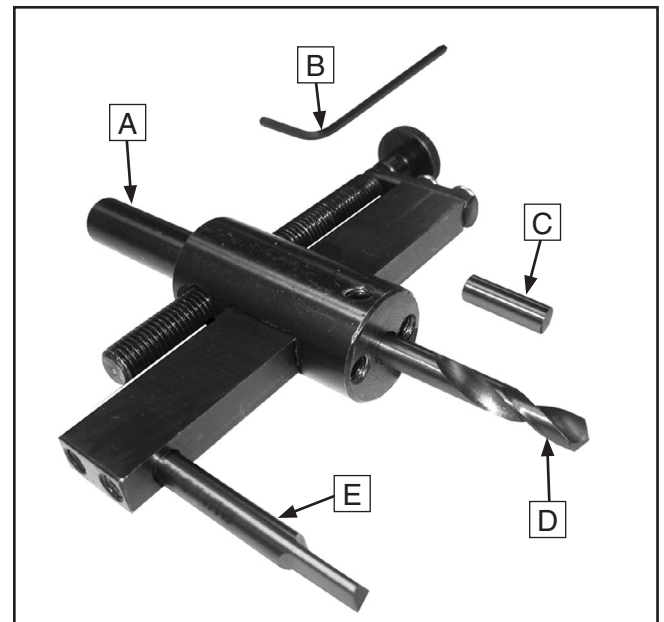


Figure 1. Model H7538.

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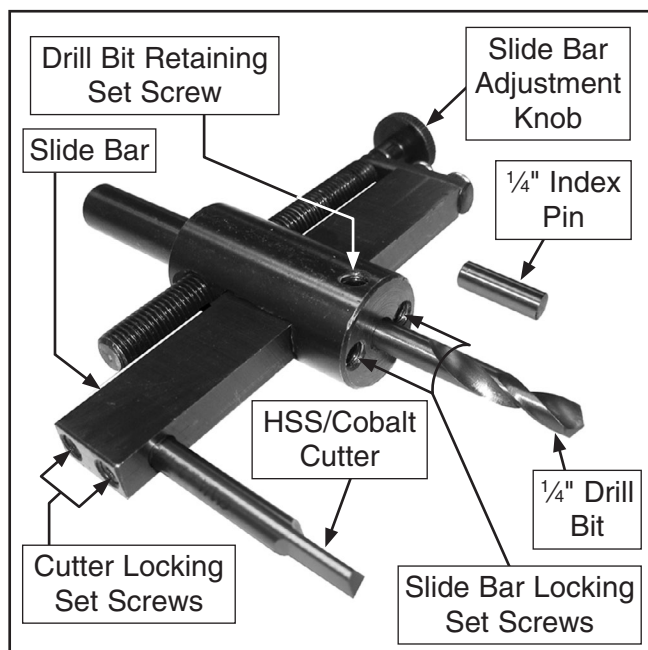
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## Operation Instructions

1. Disconnect the machine from power, read the warning list on **Page 1**, and take all required precautions.
2. Using a compass or template, draw or outline the hole or disc to be cut on the workpiece, and mark the center with a punch.

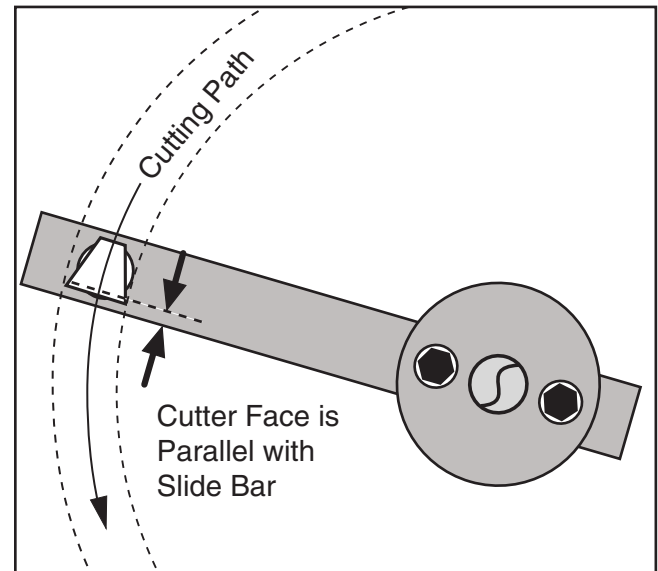
**Note:** To avoid surface splintering or cracking thin material, use a 1/4" drill bit at high speed to pre-drill the pilot hole. Do not attempt any drilling with the circle cutter at speeds greater than 250 RPM. Next, install the 1/4" index pin into circle cutter instead of the drill bit (**Figure 2**). Set the cutter depth, and use the circle cutter as normal but with the index pin supported in the pre-drilled pilot hole. The above method provides maximum support for the circle cutter, resulting in cleaner edges.



**Figure 2.** Tool components.

3. Position the drill press table so the drill bit will not bore into the table, and place a sacrificial board on top of the table to protect the table from the bit when the hole is completed.

4. Set the drill press or mill depth stop to avoid drilling into the table.
5. Clamp the workpiece and sacrificial table to the cast iron table.
6. Using the 3mm hex wrench, loosen the side bar locking set screws, and the cutter lock screws, then adjust the slide bar adjustment knob so the cutter will cut the needed hole or disc diameter (**Figure 3**).



**Figure 3.** Cutter positioning.

7. Align the workpiece pilot hole location with the circle cutter drill bit or index pin, and verify that the path of the cutter is where it is needed to be on your marked circle.
8. Rotate the circle cutter 360° by hand to verify that it moves without obstruction, and set the drill press or mill to the required speed (below 250 RPM).
9. Connect the drill or mill to power, turn **ON** the machine, and carefully lower the circle cutter to begin cutting the workpiece.