

# PROMAC®

10-2016

**Metal Cold Saw**  
**Metallkreissäge**  
**Fraise-scie**

## SY-250A



# CE

France  
**TOOL France**  
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1. SAFETY INSTRUCTIONS AND GUIDELINES
2. DIMENSIONS, TRANSPORT, INSTALLATION & DISMANTLING OF THE MACHINE
3. FUNCTIONAL ELEMENTS OF THE MACHINE
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This machine has been designed in accordance with the national and European accident prevention regulations. The manufacturer shall not be held liable in case of Improper use of and/or improper changes/works carried out on safety devices.

## 1.1 User guidelines

- Make sure that the voltage indicated on the motor is the same as the mains voltage.
- Check the correct operation of the power supply and earth connection; plug the machine's mains plug into the mains socket and connect the earth conductor (yellow/green) to the grounding system.
- Only the section of the saw blade used for sawing should remain uncovered.
- The machine must not be used without the guards of protective devices.
- Always disconnect the mains plug before replacing the saw blade or carrying out any maintenance work; this also applies in the event of faults.
- Always wear suitable eye protection.
- Never put your hands or arms into the cutting area while the machine is in operation.
- Do not move the machine during sawing.
- Do not wear loose clothes such as shirts with excessively long sleeves, excessively large gloves, bracelets, chains or other jewellery that may get caught while sawing. Long hair must be tied up.
- Keep the area around the machine clear of devices, tools, or any other objects.
- Always perform only one task at a time. Never hold several objects in your hands at the same time. Keep your hands as clean as possible.
- All works, maintenance works or repairs to be carried out inside the machine must be done in a well-lit place or in a place sufficiently illuminated by additional light sources to avoid the risk of even minor accidents.

## 1.2 Electrical machines according to the European standard CENELEC EN 60 204-1, which incorporates the publication IEC 204-1 with some amendments necessary for its incorporation.

- The electrical machine provides protection against electric shocks due to direct or indirect contact. The moving parts of this machine are located in a housing that can only be unscrewed with a special tool; the parts are operated with low current (24 V alternating current). The machine is splash-proof and dust-proof.
- The machine is protected against short circuits by quick-acting fuses and earthing; the motor is protected against overload by a thermal relay.
- In the event of a power failure, the special start button must be unlocked.
- The unit has been tested in accordance with Point 20 of EN 60204.

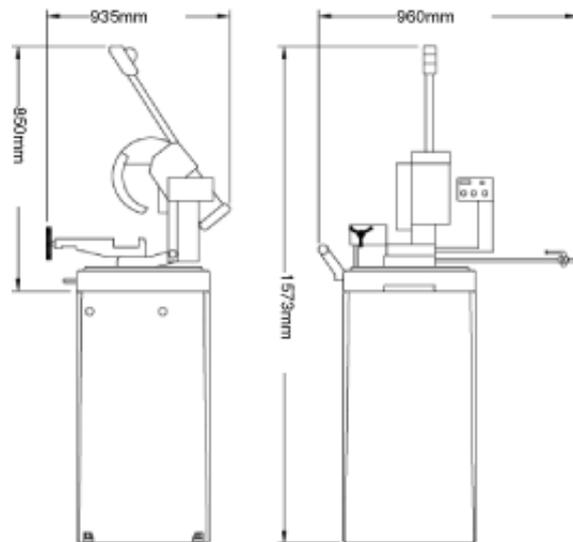
## 1.3 Emergencies according to the European standard CENELEC EN 60 204-1

- In the event of faulty operation or danger, the machine can be stopped immediately by pressing the red mushroom button.

NOTE: After an emergency stop, the machine must be restarted by pressing a special switch.

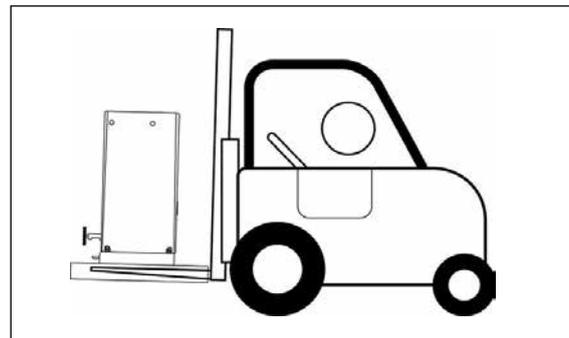
## 2 DIMENSIONS, TRANSPORT, INSTALLATION AND DISMANTLING OF THE MACHINE

### 2.1 Machine dimensions



### 2.2 Transporting the machine

If you need to move the machine in its original packaging, use a forklift truck or straps.



### 2.3 Minimum requirements for the machine environment

- Mains voltage and frequency must be suitable for the machine's motor.
- The ambient temperature should be between -10°C and +50°C.
- The relative humidity must not exceed 90%.

### 2.4 Installation instructions for loose parts and accessories

- Install the supplied parts
- Fit the stop
- Install the roller support in alignment with the vice table

### 2.5 Storage of the machine for an extended period

If the machine is not to be used for an extended period of time, we recommend to proceed as follows:

- 1) Lock up the main switch
- 2) Loosen the blade
- 3) Release the bow return spring
- 4) Empty the coolant tank
- 5) Carefully clean and lubricate the machine
- 6) If necessary, cover the machine.

## 2.6 Dismantling (due to a defect and/or obsolescence)

### General rules

If the machine is to be dismantled on a long-term basis and/or scrapped, then the components to be disposed of must be separated as follows, depending on their type and composition:

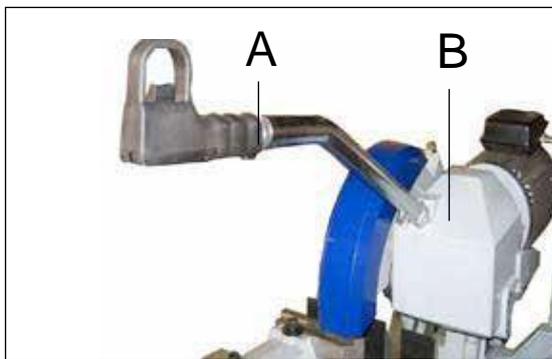
- 1) Cast iron or ferrous parts, consisting only of metal, are secondary raw materials and can therefore be taken to an iron foundry to be remelted after removal of the other components (classification under Point 3).
- 2) Electrical parts including cables and electronic parts (magnetic cards, etc.) fall under the category of domestic waste according to the local, regional or national laws of your country, so that they can be disposed of via the public waste collection service.
- 3) Waste oils (mineral and synthetic and/or mixed oils), oil emulsions and greases are considered toxic or special waste and must be collected for disposal and transported to a hazardous waste landfill.

NOTE: Waste-related standards and legislation are constantly changing and are therefore subject to modifications. The user should find out what regulations are in force at the time of disposal as they may differ from those described above.

## 3 FUNCTIONAL ELEMENTS OF THE MACHINE

### 3.1 Machine head

- The machine head consists of a 2-speed electric motor, the reducing gear, and the electric control panel.
- *A. Lever.* This lever is equipped with a handle including a built-in start switch (trigger switch). Pulling or lifting the operating handle lowers or raises the machine head.
- *B. Reducing gear.* Reduces the engine speed to match the cutting speed.



### 3.2 Machine base

- The machine base supports the saw head and clamping vice, and collects the coolant.



### 3.3 Clamping vice

The vice is used to clamp and secure the workpiece. It consists of an adjustable slide with quick-clamping system and of an "anti-burr" system.



### 3.4 Roller support

Enables to secure the clamping of longer workpieces.



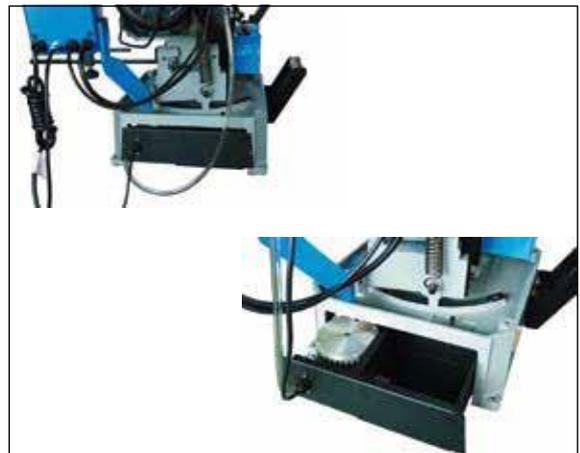
### 3.5 Machine stand

The machine stand carries the machine base and the machine head.



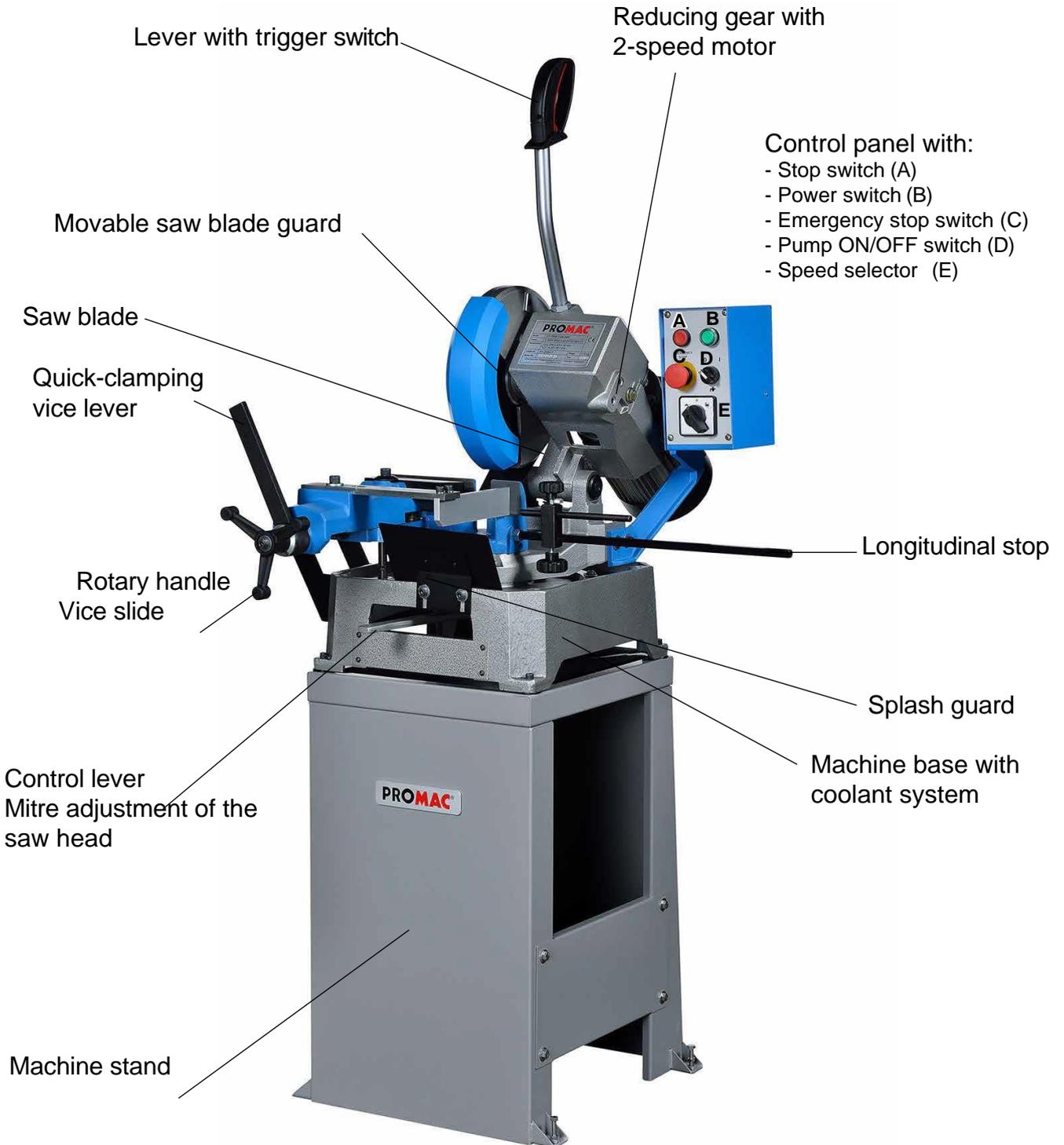
### 3.6. Coolant system

The complete coolant system is located in the machine base.



## 4. MACHINE CONTROLS

### 4.1 Operator's controls for using the machine



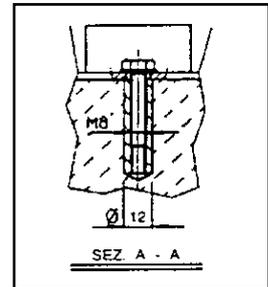
## 5. MACHINE INSTALLATION & OPERATION

### 5.1 Transport

Using a forklift, move the machine to the installation location. A forklift or crane is required to install the machine base with saw head on the stand.

### 5.2 Anchoring the machine

Place the machine on a stable concrete floor, and observe a minimum distance of 800mm between the rear side of the machine and the wall. Anchor the machine to the floor using screws and expansion elements or tie rods embedded in the concrete floor (see Fig.) and make sure that the machine is installed horizontally.

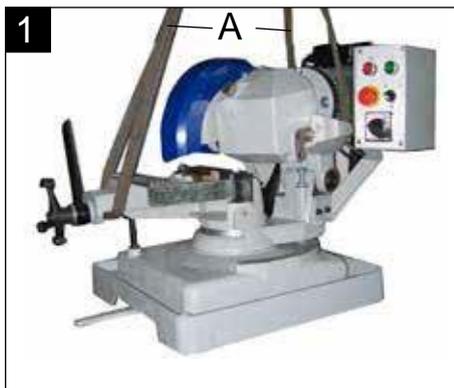


### 5.3 Unpacking

- Remove the packaging. Remove all accessories from the pallets.

### 5.4 Install the machine on the stand or work station

- The installation requires a crane or forklift with lift straps.
- Carefully place the lift strap (A) around the machine as shown in the picture, and carefully place the machine on the stand or work station.



Install the machine on the stand.

- Lift the machine using a crane as described in Point 5.4.
- Align the holes of the machine base (B) with the holes of the machine stand.
- Place the 4 rubber rings (spacers) on the holes of the stand.
- Screw the machine base to the stand; use M8x35 screws.

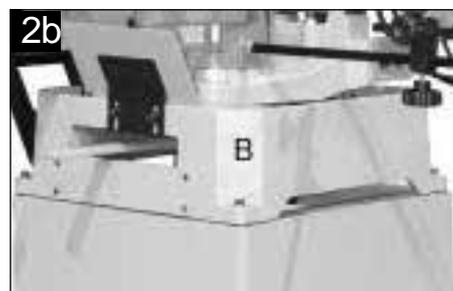
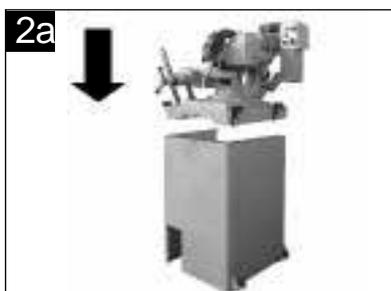


Fig.3

Remove the screw (E) (only needed for transport) from the reducing gear head.

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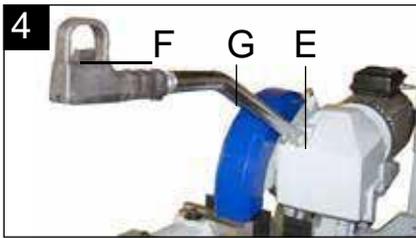


Fig.4

Screw the lever (G) with starter handle (F) into the threaded hole (E), and tighten it with the nut to secure it in correct position.

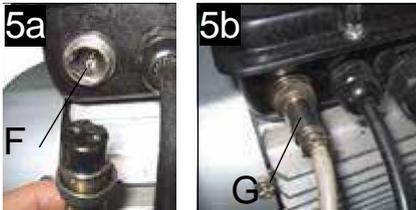


Fig. 5a +b

Attach the control cable to the socket (F) on the motor.  
Tighten the screw connection (G).

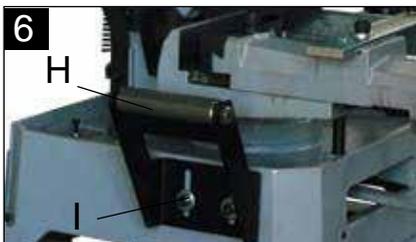


Fig. 6

Mount the workpiece support (H) on the left side of the machine stand.

- Lightly fasten the workpiece support to the machine stand using two M10x25 screws (I), as shown.
- Align the workpiece support (roller) precisely with the height of the vice bottom.
- Tighten both screws.

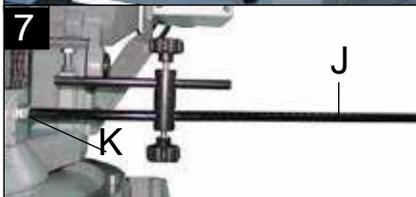


Fig. 7

Fasten the longitudinal stop (J) on the right side of the machine base.

- Turn the long stop rod into the threaded hole of the machine base and secure it with the nut (K).
- Adjust the stop on the saw blade so that the stop moves to the "0" mark.



Fig. 8

The coolant system is located in the rear part of the machine base. The coolant hose and the electric cable to the pump are fitted. Fill in the coolant:

- Remove the 4 screws from the coolant unit.
- Pull out the coolant unit halfway, as shown in Figure 9.
- Fill the tank with coolant.
- Fully push the coolant system into the machine base and secure it using the 4 screws.
- Turn the speed selector and press the power switch.
- Press the start switch on the handle to switch on the machine.
- When the saw motor starts, the pump motor starts as well and coolant sprinkles the saw blade.

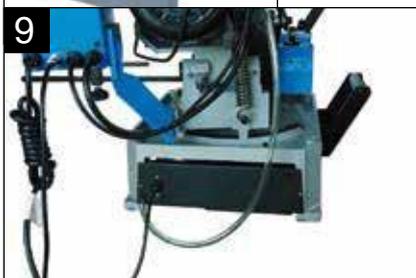


Fig. 9 + 10

To clean the coolant system:

- Remove the coolant system as described above, and also remove the hose and cable.
- Clean the coolant tank, replace the filter if necessary.

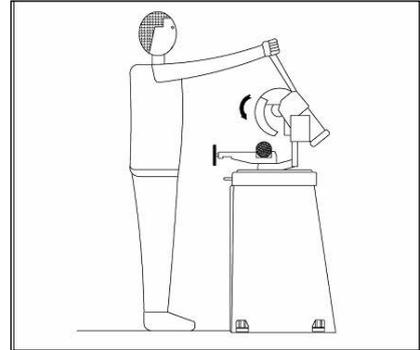


## 5.5 Operation

- The PROMAC Metal Cold Saw is intended to be used in mechanical workshops, locksmith's workshops, metal construction and smithery workshops.
- The SY-250A Model (45/90m min-1) is suitable for lighter workpieces.
- The machine requires an operator.
- When using the machine for the first time, do not overload it so that the reducing gear can run in.
- Always make sure that workpieces are clamped correctly and firmly.
- Do not use saw blades larger than 250mm.
- Always start the machine with the head raised and the lower guard closed.
- Only use a well-sharpened saw blade, with the right tothing for the workpiece to be machined.

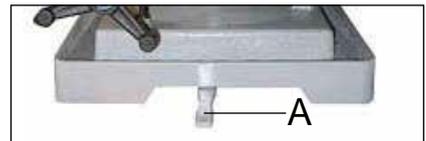
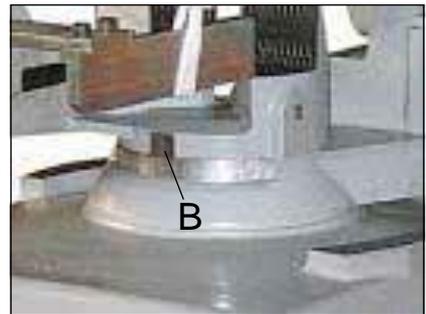
## 5.6 Operator's position

The operator stands in front of the machine and can thus operate all controls.



## 5.7 Mitre adjustment of the saw head

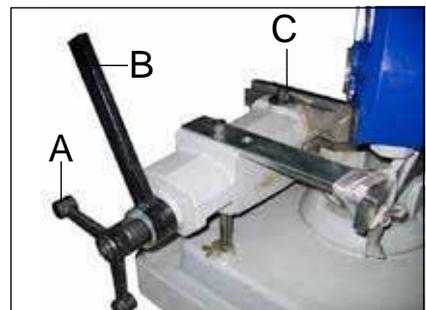
- Loosen the adjustment lever (A) for mitre adjustment.
- Move the saw head to the correct mitre position (B).
- Tighten the adjustment lever.



## 5.8 Using the vice

The machine is equipped with a quick-clamping system.

- To adjust, use the rotary handle (A) to guide the vice slide towards the workpiece (C), leaving 2 - 5mm clearance between workpiece and clamping jaw.
- The workpiece can now be clamped and released quickly and safely with the quick-acting vice lever (B).



## 5.9 Clamping the workpiece

- Open the vice slide sufficiently.
- Measure the workpiece and mark the interface.
- Place the workpiece between the open clamping jaws.
- Align the workpiece with the saw blade and make sure that the workpiece is fully touching the rear clamping jaws.
- Clamp the workpiece as described in Point 5.8.

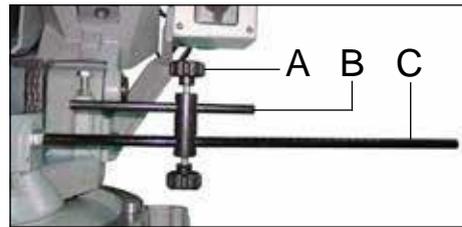
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### 5.10 Setting the workpiece length

The length of the workpiece can be set using the longitudinal stop.

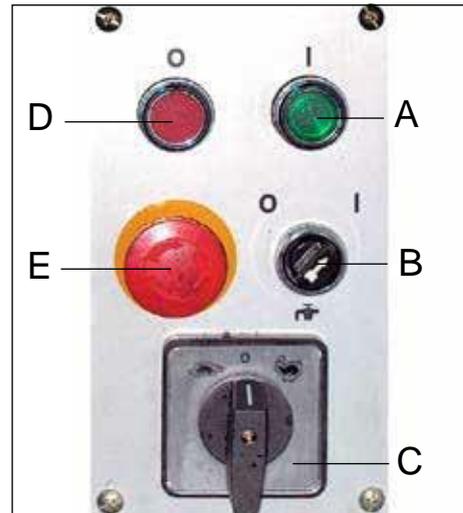
- Set the desired workpiece length according to the scale on the stop bar (C).
- Place the workpiece in the vice so that the end of the workpiece touches the stop (B), then tighten the adjusting screws (A).
- Clamp the workpiece with the quick-clamping vice lever.
- Check the length of the workpiece.



### 5.11 Operational process

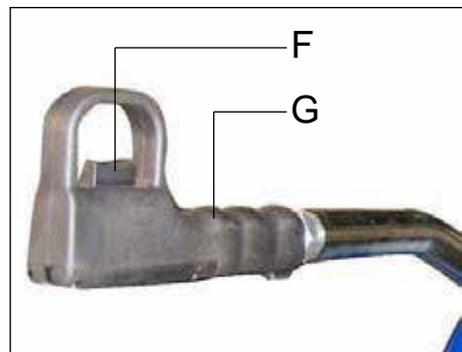
#### START

- Set the saw head to the desired mitre angle.
- Open the vice sufficiently.
- Adjust the stop.
- Place the workpiece.
- Clamp the workpiece.
- Set the desired speed on the speed selector switch (C).
- Switch on the coolant pump (B), if necessary.
- Press the start switch (A).
- Grasp the lever (G) and start the machine by pressing the start/stop switch (trigger switch) (F).
- Carefully pull the saw head towards the workpiece and cut with a constant and suitable contact pressure.



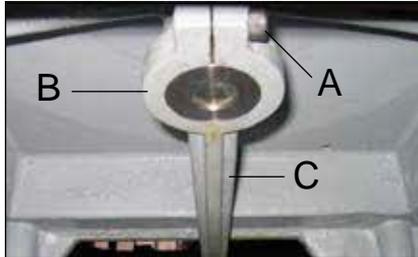
#### STOP

- When the cut is completed, carefully move the saw head back to the start position.
- Release the start/stop switch (F), the machine stops.
- Press the stop switch (D).
- Release the quick-release lever.
- Reposition or remove the workpiece.



## 6. ADJUSTMENTS

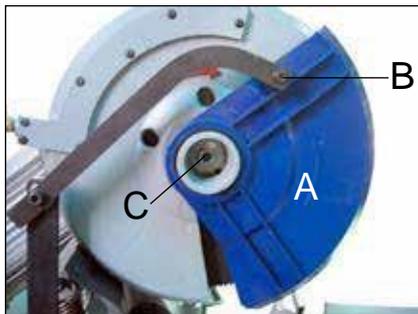
**CAUTION:** Before attempting any work (e.g., maintenance, adjustment or repair work), the machine must be disconnected from the mains.



### 6.1 Adjusting the mitre adjustment lever

If the adjustment lever for mitre adjustment of the saw head cannot be correctly released or tensioned, then the position of the lever must be readjusted.

- Loosen the screw (A), guide the bush with screw bolt (B) to the correct position of the mitre adjustment lever (C) and tighten the screw (A).



### 6.2 Replacing the saw blade

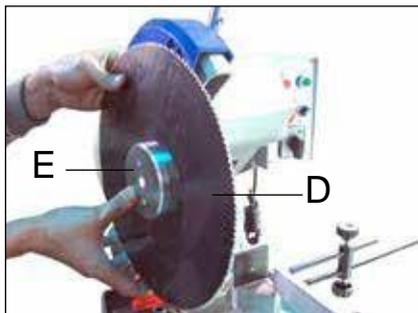
- Release the linkage (B) of the movable chip guard (A) so that it can move freely.

- Place a piece of wood in the vice and put the saw blade on it.
- Loosen the screw (C) using the spanner supplied.

**NOTE:** Left-hand thread - loosen clockwise!

- Remove the blade flange (E) and saw blade (D).

Clean all parts, fit a new saw blade and blade flange and tighten the blade screw.



## 7. ROUTINE AND SPECIAL MAINTENANCE

THE MAINTENANCE TASKS LISTED BELOW ARE DIVIDED INTO DAILY, WEEKLY, MONTHLY AND HALF-YEARLY TASKS. NEGLECTING THESE TASKS WILL LEAD TO PREMATURE WEAR OF THE MACHINE AND POOR PERFORMANCE.

### 7.1 Daily Maintenance

- Clean the machine normally to remove accumulated chips.
- Clean excess lubricating oil from the lubricating oil outlet.
- Refill with lubricating oil.
- Check the saw blade for wear.
- Check protective covers and emergency stop devices for proper function.

### 7.2 Daily Maintenance

- Clean the machine thoroughly to remove chips, especially from the lubricating oil reservoir
- Clean the coolant filter, the coolant tank and coolant reservoir area

### 7.3 Monthly maintenance

- Check that all screws are tight.
- Check that the bearings of the rotating elements run perfectly.

### 7.4 Half-yearly maintenance

- Continuity test of the equipotential bonding circuit.
- See point 7.7 Gearbox

### 7.5 Lubricating oils

Considering the wide range of lubricating oils available on the market, the user can choose the oil that will meet his needs, using the SHELL LUTEM OIL ECO type as a reference. THE MINIMUM PERCENTAGE OF OIL DILUTED IN WATER IS 5-8%.

**We recommend the following PROMAC products:**

<b>9179</b>	<b>Coolant 5kg</b>
<b>100385</b>	<b>Slideway oil 1lt</b>
<b>100382</b>	<b>Gearbox oil 1lt</b>

### 7.6 Disposal of waste oil

The disposal of such products is subject to strict regulations (see Section "Dimensions, transport, installation & Dismantling", under "Dismantling").

### 7.7 Gearbox

The gearbox oil must be changed periodically. The first oil change is necessary after 6 months; the oil must then be changed once a year.

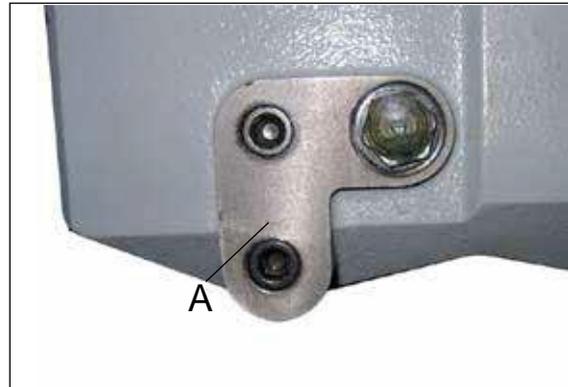
Change the oil as follows:

- Disconnect the machine from the mains.
- Move the saw arm in down position.
- Unscrew the lever from the head.
- Remove the oil drain plug (A) and drain the oil into a container.
- When all the oil has been poured out, replace the screw (A).
- Move the saw arm to the raised position.

Fill in new oil (PROMAC item no. 100381) through the filler hole (threaded hole of the lever).

Amount 0.3 litre.

- Fit and fasten the lever.



### 7.8 Special maintenance

Special maintenance work must be carried out by qualified technicians. We recommend you to contact the nearest dealer for this purpose. Special maintenance work is also required when re-adjusting protection and safety devices (reducing gear), the motor, motor pump and other electrical components,

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## 8 TECHNICAL DATA

### 8.1 Cutting performance and technical details

Type	Material					Properties		
	I UNI	D DIN	F AF NOR	GB SB	USA AISI-SAE	Hardness grade Brinell HB	Rockwell HRB	R=N/mm2
Construction steel	Fe360	St37	E24	-	-	116	67	360+480
	Fe430	St44	E28	43	-	148	80	430+560
	Fe510	St52	E36	50	-	180	88	510+660
Carbon steels	C20	CK20	XC20	060 A 20	1020	198	93	540+690
	C40	CK40	XC42H1	060 A 40	1040	198	93	700+840
	C50	CK50	-	-	1050	202	94	760+900
	C60	CK60	XC55	060 A 62	1060	202	94	830+980
Spring steel	50CrV4	50CrV4	50CV4	735 A 50	6150	207	95	1140+1330
	60SiCr8	60SiCr7	-	-	9262	224	98	1220+1400
Chrome steels	35CrMo4	34CrMo4	35CD4	708 A 37	4135	220	98	780+930
	39NiCrMO4	36CrNiMo4	39NCD4	-	9840	228	99	880+1080
	41CrAlMo7	41CrAlMo7	40CADG12	905 M 39	-	232	100	930+1130
	18NiCrMo7	-	20NCD7	En325	4320	232	100	760+1030
	20NiCrMo2	21NiCrMo2	20NCD2	805 H 20	4315	224	98	690+980
	100Cr6	100Cr6	100C6	534 A 99	52100	207	95	690+980
Tool steel	52NiCrMoKU	56NiCrMoV7C100K	-	-	-	244	102	800+1030
	C100KU	C100W1	-	BS 1	S-1	212	96	710+980
	X210Cr13KU	X210Cr12	Z200C12	BD2-BD3	D6-D3	252	103	820+1060
	58SiMo8KU	-	Y60SC7	-	S5	244	102	800+1030
Stainless steel	X12Cr13	4001	-	-	410	202	94	670+885
	X5CrNi1810	4301	Z5CN18.09	304 C 12	304	202	94	590+685
	X8CrNi1910	-	-	-	-	202	94	540+685
	X8CrNiMo1713	4401	Z6CDN17.12	316 S 16	316	202	94	490+685
Non ferrous metals	G-CuA/11Fe4Ni4 UNI 5275					220	98	620+685
	G-CuZn36Si1Pb1 UNI 5038					140	77	375+440
	SAE43-SAE430					120	69	320+410
	G-CuSn12 UNI 7013/2a					100	56.5	365+314
Cast iron	G25					212	96	245
	GS600					232	100	600
	W 40-05					222	98	420

#### Technical data

Saw motor	kW	0.75
Coolant pump	kW	0.08
Saw blade max.	mm	250
Blade speed	m/1'	45 / 90
Vice opening	mm	100
Coolant capacity	lt	2
Weight incl. stand	kg	130
Dimensions L x W x H	cm	960 x 935 x 1573
Noise level*	dB	<70

#### NOTE

\* Depending on the workpiece, the noise level may vary significantly and noise protections may become necessary.

#### Cutting capacities, in mm

			
90° .....30 .....	75 .....	65xc65.....	90x50
45° .....30 .....	65 .....	55x55 .....	60x50

## 9 MATERIAL CLASSIFICATION AND BLADE SELECTION

Since the aim is to achieve a perfect cutting quality, various parameters must be taken into account, such as hardness of the material, shape and thickness, cross-section of the workpiece to be cut, choice of the saw blade, cutting speed and the lowering speed of the pre-tensioning frame. These specifications must therefore be combined according to practical and reasonable considerations into a single optimal operating condition that does not require countless set-up operations when the tasks to be performed are very different. Various problems, that arise from time to time, can be solved more easily if the operator knows these specifications well.

### 9.1 Materials definition

The table above lists the properties of the materials to be cut enabling to select the suitable tool.

### 9.2 Choice of the saw blade

First, the tooth pitch suitable for the material to be cut, i.e., the number of teeth per inch (25.4 mm), must be determined according to the following criteria:

- Parts with thin and/or different cross-sections such as steel sections, tubes and sheets require a narrow tooth spacing so that 3 to 6 teeth can engage simultaneously;
- Parts with large cross-sections and solid parts require a large tooth spacing to be able to take up the larger amount of chips and to ensure better penetration of the teeth;
- Parts made of soft materials or plastics (light metals, soft bronze, Teflon, wood, etc.) also require a large tooth spacing;
- Parts that are cut in bundles require a combo tooth design

### 9.3 Cutting speed and feed rate

Cutting speed (m/min.) and feed rate (cm<sup>2</sup>/Min. distance covered by the teeth when the chips are removed) are limited by the heat generated near the tooth tips.

- The cutting speed depends on the strength of the material ( $R = N/mm^2$ ), its hardness (HRC) and the dimensions of the largest cross-section.
- If the feed rate is too high (= lowering of the saw head), the blade tends to deviate from the ideal cutting path, and thus produces cuts that are not straight in both the vertical and horizontal planes.

The best combination of these two parameters can be determined easily and directly from the chips. Long chips indicate an ideal cutting. Very fine or powdered chips indicate a too low feed and/or cutting pressure. Thick and/or "blue" chips indicate too much stress on the saw blade.

### 9.4 Running-in of the saw blade

When using a saw blade for the first time, it is usual to run the blade in through a series of cuts at a low feed rate (= 30-35 cm<sup>2</sup>/min. for solid workpieces of medium size with regard to cutting ability, consisting of mild steel with  $R = 410-510 N/mm^2$ ). Spray with plenty of coolant the surface to be cut.

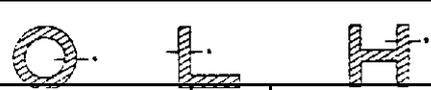
### 9.5 Blade material

Most common blades are made of HSS steel

### 9.6 Blade types

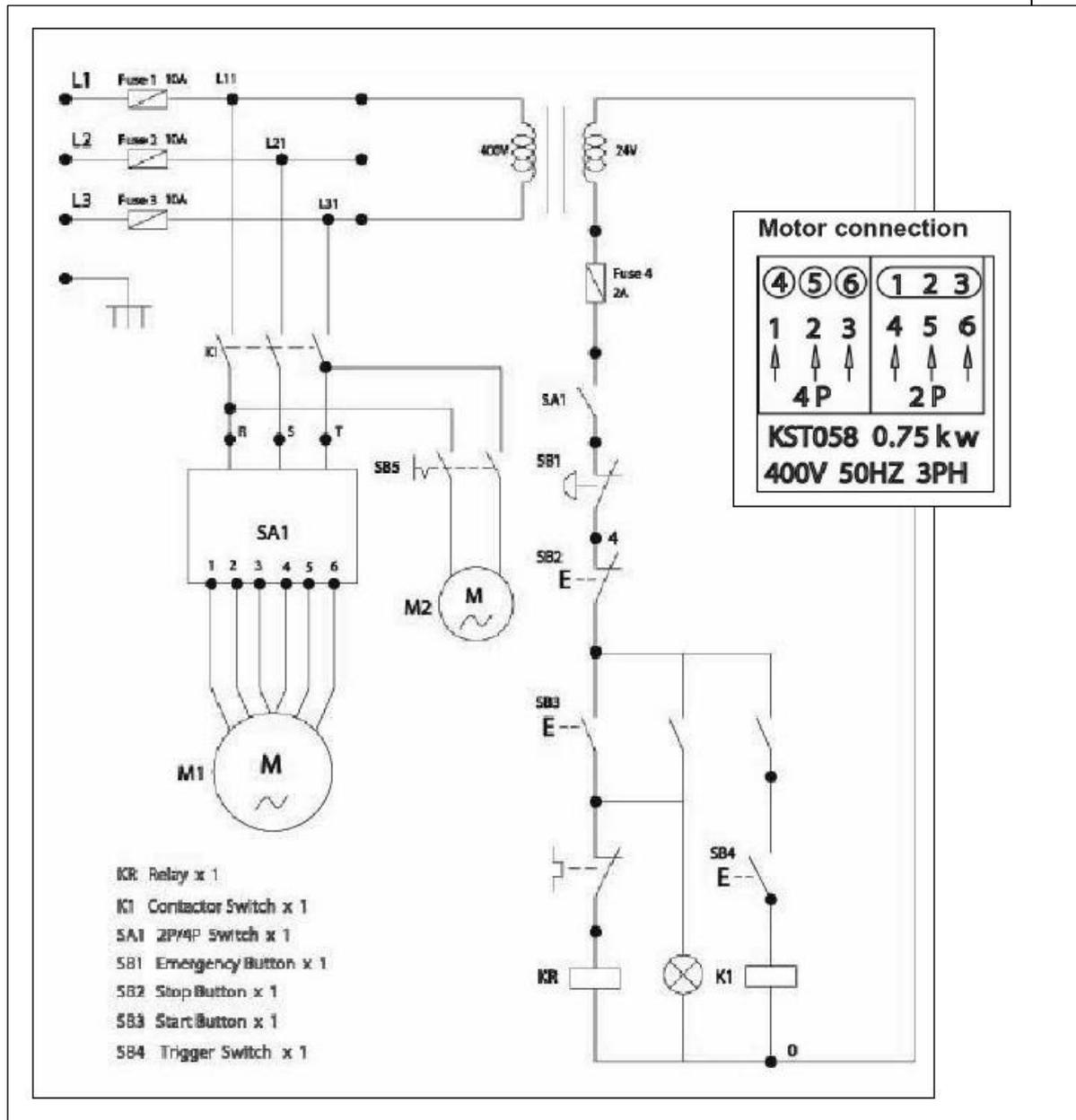
Saw blades mainly differ in the following features:

- Shape and angle of the teeth
- Tooth pitch
- Tooth set

Teeth selection table		
Material thickness mm	Teeth	PROMAC item no.
from 1.5	14	9128
from 1-2	8	9128
from 2-3	6	9127
from 3-5	6	9127
from 4-6	6	9126
above 6	4	9726
		
Solid material mm	Teeth	PROMAC item no.
up to 30	8	9126
from 30-60	6	9126
from 40-80	4	9726
		

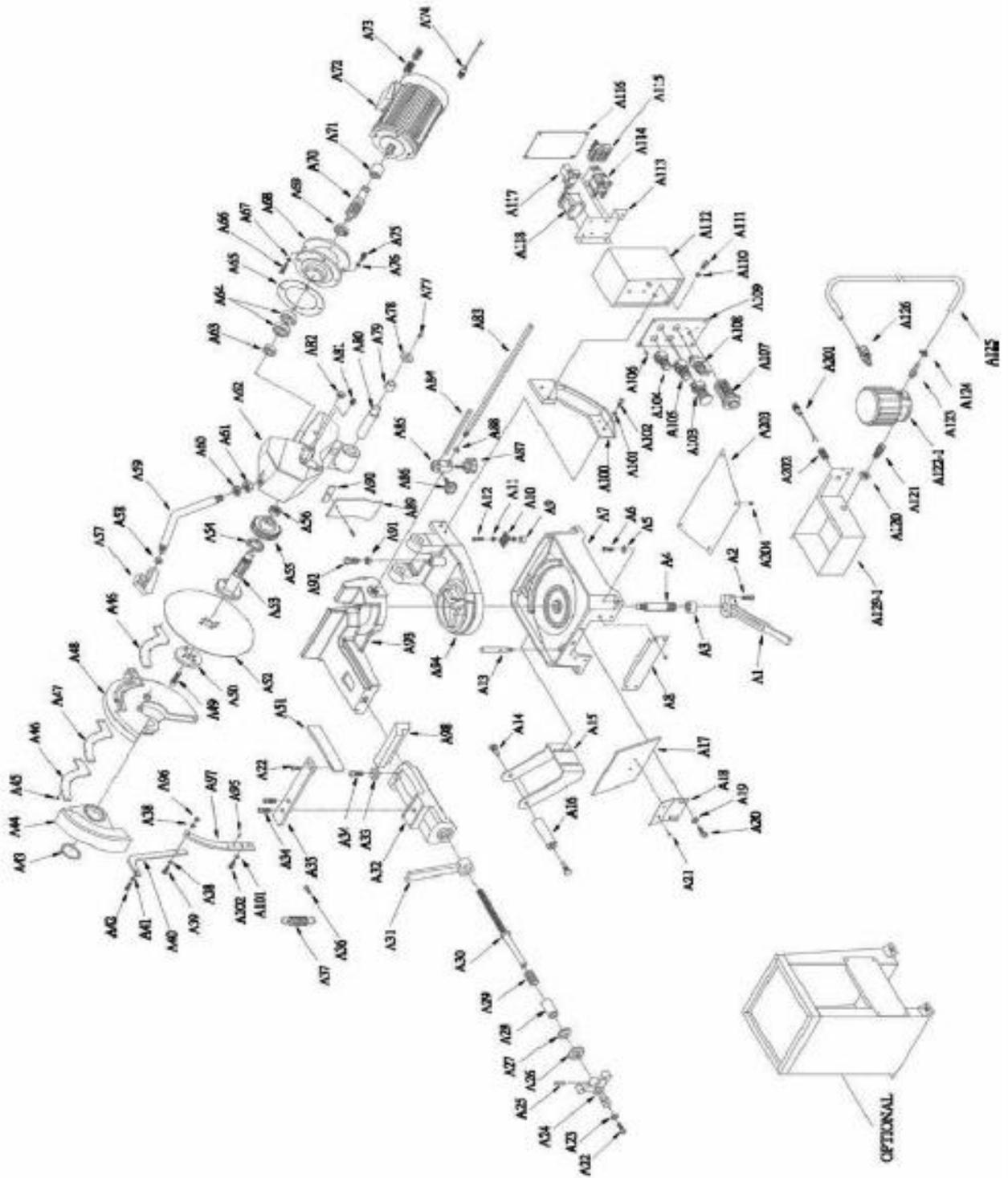
## Section 10

### 10.1 WIRING DIAGRAM



### 10.2 ELECTRICAL PARTS LIST

FU1	Fuse 10A
FU2	Fuse 10A
FU3	Fuse 10A
FU4	Fuse 24V, 2A
K1/KR	Contactor/Relay coil 24V
T1	Transformer 230V / 24V
M1	Band motor 400V
M2	Pump motor 400V
SA1	Speed selector switch
SB1	Emergency stop switch
SB2	STOP Push-button
SB3	START Push-button
SB4	Start/Stop switch (trigger switch)
SB5	Pump switch
SS	Motor circuit breaker
PE	Earthing



## Section 12

# SY-250A

A1	PM-250001	Lever
A2	PM-250002	Screw M10x30
A3	PM-250003	Nut
A4	PM-250004	Shaft
A5	PM-250005	Washer 5/16"
A6	PM-250006	Screw
A7	PM-250007	Machine base
A8	PM-250008	Cover
A9-12	PM-250009	Filter (complete)
A13	PM-250013	Pin
A14	PM-250014	Screw
A15	PM-315605	Holder
A16	PM-315607	Roller
A17	PM-315710	Plate
A18	PM-315111	Holding plate
A19	PM-315712	Washer M8
A20	PM-315713	Screw M8x16
A21	PM-315714	Screw M5
A22	PM-315609	Screw M8x20
A23	PM-315610	Washer M8
A24	PM-315611	Rotating handle
A25	PM-315612	Pin
A26	PM-315613	Thrust bearing
A27	PM-315614	Washer
A28	PM-315615	Bushing
A29	PM-315620	Spring
A30	PM-315616	Vice worm screw
A31	PM-315617	Lever
A32	PM-315618	Vice
A33	PM-315619	Washer
A34	PM-315622	Screw M12x25
A35	PM-315621	Holder
A36	PM-250036	Screw M10x30
A37	PM-250037	Return spring
A38	PM-250038	Washer M6
A39	PM-250039	Screw M6x25
A40	PM-250040	Linkage
A41	PM-250038	Washer M6
A42	PM-250042	Screw M6x12
A43	PM-250043	Circlip
A44	PM-250044	Protector
A45	PM-315636	Screw M5x10
A46	PM-250046	Plate
A47	PM-250047	Gasket
A48	PM-250048	Protector
A49	PM-315639	Blade screw M12Lx35
A50	PM-315640	Blade flange
A51	PM-315645	Plate
A52	-	Saw blade max. 250mm

A53	PM-250053	Shaft
A54	PM-250054	Shaft seal 35x47x8
A55	PM-250055	Bronze gear
A56	PM-250056	Nut
A57	HS201402	Handle with trigger switch
A59	PM-250059N	Lever
A60	PM-315656	Nut M20
A61	PM-315656	Nut M20
A62	PM-250062	Gear box
A63	PM-370632	Ball bearing 6205
A64	939250	Ball bearing 6301
A65	PM-250065	Gasket
A66	PM-315671	Screw M8x20
A67	PM-250038	Washer M6
A68	PM-250066	Flange
A69	PM-250067	Shaft seal 25x45x10
A70	PM-250070	Shaft
A71	PM-250071	Coupling
A72	PM-250072	Motor
A73	PM-250073	Cable screw fitting
A74	-	Cable
A75	PM-315671	Screw M8x20
A76	PM-250038	Washer M6
A77	PM-250077	Screw M8
A78	PM-250078	Washer
A79	PM-250079	Bushing
A80	PM-250080	Shaft
A81	PM-315674	Screw 1/4"G
A82	PM-315673	Oil plug 1/2"G
A83	PM-315682	Stop bar
A84	PM-315681	Stop
A85	PM-315680	Flange
A86	PM-315679	Adjusting screw
A87	PM-315684	Adjusting screw
A88	PM-315683	Nut
A89	PM-315723	Cover
A90	PM-315722	Plate
A91	PM-315678	Nut M12
A92	PM-315677	Screw M12x55
A93	PM-250693A	Vice baseplate
A94	PM-250094	Swivel base
A100	PM-315691	Support
A101	PM-315692	Washer M8
A102	PM-315671	Screw M8x20
A103	PM-378104	Emergency stop switch
A104	PM-923163	Stop switch
A105	PM-923162	Start switch
A106	PM-315693	Screw M5

# SY-250A

A107	PM-315698	Speed selector switch
A108	PM-923164	Pump switch
A109	PM-315700	Front cover plate
A110	PM-315692	Washer M8
A111	PM-315671	Screw M8x20
A112	PM-315703	Housing
A113	PM-315704	Support
A114	PM-315705	Contactora
A115	PM-315706	Fuse holder
A116	PM-315707	Cover
A117	PM-315709	Relay
A118	PM-315708	Transformer
A120	PM-250120	Nut M20x1.5
A121	PM-250121	Screw
A122-1	PM-250122A	Pump
A123	PM-250123	Bolt
A124	PM-250124	Cable clamp
A125	PM-918090	Hose
A126	PM-918092	Valve
A129-1	PM-250129A	Reservoir
A201	PM-250201	Cable
A202	PM-250202	Cable screw fitting
A203	PM-250203	Plate
A204	PM-250204	Screw
SY 250-HSA		Handle with switch & lever

## Accessories

2081	Base
9126	Saw blade 250mm 120Z
9127	Saw blade 250mm 160Z
9128	Saw blade 250mm 200Z
9197	Coolant 5kg

**CE-Conformity Declaration  
CE-Konformitätserklärung  
Déclaration de Conformité CE**

**Product / Produkt / Produit:**

Metal Cold Saw / Metallkreissäge / Fraise-scie  
**SY 250A**

**Brand / Marke / Marque:**

**PROMAC**

**Manufacturer / Hersteller / Fabricant:**

TOOL FRANCE SARL, 9 Rue des Pyrénées, 91090 LISSES, France

We hereby declare that this product complies with the regulations  
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht  
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

**2006/42/EC**

Machinery Directive / Maschinenrichtlinie / Directive Machines

**2014/30/EU**

electromagnetic compatibility  
elektromagnetische Verträglichkeit  
compatibilité électromagnétique

designed in consideration of the standards  
und entsprechend folgender zusätzlicher Normen entwickelt wurde  
et a été développé dans le respect des normes complémentaires suivantes

**EN ISO 12100:2010, EN 13898 :2033+A1:2009, EN 60204-1:2006+A1:2009,  
EN 61000-6-2:2005, EN 61000-6-4:2007+A1:2011**

Responsible for the Documentation / Dokumentations-Verantwortung / Responsabilité de Documentation:  
Head Product-Mgmt. / Leiter Produkt-Mgmt. / Resp. Gestion des Produits

TOOL FRANCE SARL



2016-07-19 Christophe SAINT SULPICE, General Manager

TOOL FRANCE SARL, 9 Rue des Pyrénées, 91090 LISSES, France



## Warranty / Garantie

TOOL FRANCE SARL guarantees that the supplied product(s) is/are free from material defects and manufacturing faults. This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, damage due to accidents, repairs or inadequate maintenance or cleaning as well as normal wear and tear.

Further details on warranty (e.g. warranty period) can be found in the General Terms and Conditions (GTC) that are an integral part of the contract.

These GTC may be viewed on the website of your dealer or sent to you upon request.

TOOL FRANCE SARL reserves the right to make changes to the product and accessories at any time.

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TOOL FRANCE SARL garantiert, dass das/die von ihr gelieferte/n Produkt/e frei von Material- und Herstellungsfehlern ist. Diese Garantie deckt keinerlei Mängel, Schäden und Fehler ab, die - direkt oder indirekt - durch falsche oder nicht sachgemäße Verwendung, Fahrlässigkeit, Unfallschäden, Reparaturen oder unzureichende Wartungs- oder Reinigungsarbeiten sowie durch natürliche Abnutzung durch den Gebrauch verursacht werden.

Weitere Einzelheiten zur Garantie können den allgemeinen Geschäftsbedingungen (AGB) entnommen werden. Diese können Ihnen auf Wunsch per Post oder Mail zugesendet werden.

TOOL FRANCE SARL behält sich das Recht vor, jederzeit Änderungen am Produkt und am Zubehör vorzunehmen.

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TOOL FRANCE SARL garantit que le/les produit(s)fourni(s) est/sont exempt(s) de défauts matériels et de défauts de fabrication.

Cette garantie ne couvre pas les défauts, dommages et défaillances causés, directement ou indirectement, par l'utilisation incorrecte ou inadéquate, la négligence, les dommages accidentels, la réparation, la maintenance ou le nettoyage incorrects et l'usure normale.

Vous pouvez trouver de plus amples détails sur la garantie dans les conditions générales (CG). Les CG peuvent être envoyées sur demande par poste ou par e-mail.

TOOL FRANCE SARL se réserve le droit d'effectuer des changements sur le produit et les accessoires à tout moment.

**TOOL France SARL**  
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91090 LISSES France  
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