

## Complete safety and maintenance manual 2025-2

### Manufacturer information

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*This document is an integral part of the product. We recommend keeping it for the entire duration of the tool's use. Document downloadable from [www.caul.it](http://www.caul.it) – tool care*

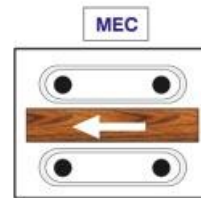
By choosing a CAUL cutter, you have prioritized quality. Tests and quality controls are scrupulously carried out on samples, prototypes, and raw materials. CAUL cutters are manufactured by highly specialized personnel with integrated computer assistance using CAD-CAM systems and new special CNC equipment.

CAUL tools have significantly lower noise levels than the phonometric parameters required by law, both during idle rotation and during machining phases. All tools are delivered ready for use; for special tools, delivery includes the relevant wood sample that proves successful testing.

### **ALL OUR TOOLS ARE IN CONFORMITY WITH THE EUROPEAN NORMATIVE - EN - 847-1 EN - 847-2**



**MANUAL FEED MOTION TOOLS**



**MECHANICAL FEED MOTION TOOLS**

The correct use of the tool guarantees high-quality work for many years. Our tools will accompany your work for years. To avoid problems and work safely, carefully observe the following basic rules.

## Fundamental safety recommendations

### A) Standards and regulations

Always strictly observe all indicated safety standards and regulations contained in the instruction manual for each machine or power tool. Comply with safety standards issued by organizations responsible for accident prevention.

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## **B) Safe working conditions**

When using rotating tool machines of any kind, there are always some risks. It is necessary to be very careful and concentrate on the work you are about to do, in efficient physical conditions and with a well-lit work environment and machine table free of obstacles.

## **C) Tool conditions**

Install only tools in perfect sharpening conditions on the machine. Never use cracked, deformed, chipped, or poorly sharpened tools.



Damaged body of tool



Collet too dirty



Broken knives



Broken shank

## **D) Manual feed**

To safely perform any machining with manual feed, always use tools equipped with chip limiters (MAN).

## **E) Direction of rotation**

Verify that the tool rotates in the correct direction.

## **F) Maximum speed**

Never exceed the maximum speed indicated on the tool (n.max).

## **G) Chip extraction**

The chip extraction system must always be operated simultaneously with the machine.

## **H) Assembly and locking**

Before mounting the tool on the machine, always ensure that all locking screws are tightened so they do not loosen during use.

## I) Assembly attention

Pay attention when mounting tools, particularly ensuring that the locking acts on the body and that the cutting edges are not in contact with other cutting edges or with locking elements.



## Extreme danger conditions

### ⚠ WARNING: MORTAL RISK

After a collision or exceeding the maximum allowed RPM, cutting parts may be thrown from the tool.

### Definition of collision

This occurs when a moving or stationary tool comes into contact with rigid parts of the machine or with the floor or other foreign objects.

### Exceeding maximum RPM

The maximum RPM is indicated on the tool and on the provided technical drawing.

## Mandatory emergency protocol

### Behavior after a collision or exceeding maximum RPM:

1. Immediately execute machine stop with "Emergency mushroom button"
2. Remove all cutting edges from the tool
3. Carefully verify all clamping elements:
  - Cracks on cutting edges
  - Damaged tool body
4. Damaged cutting edges must be replaced
5. Remount cutting edges and clamping elements

6. Replace all screws and bolts
7. If the tool body is damaged, it must not be reused under any circumstances
8. Do not perform "do-it-yourself" repairs
9. Verify eccentricity, rotation, and linearity of the tool

## **Specialized maintenance and care**

### **L) Cleaning aluminum tools**

Resin must be removed from lightweight alloy tool bodies only with solvents that do not attack aluminum. Clean aluminum tools only with appropriate water-soluble detergents. Never use alcohol-based detergents.

### **M) Clamping surfaces**

Clamping surfaces must be free from dirt, grease, oil, or water.

### **N) Screw tightening**

Locking screws must be tightened following the manufacturer's instructions. When changing cutting edges, tighten screws following the prescribed Newton torque values.

### **O) Absolute prohibitions**

Extensions for tools or tightening with hammer blows must not be permitted.

### **P) Rings and bushings**

The use of removable rings or bushings is permitted only if supplied by the manufacturer.

### **General precautions**

- Avoid hitting cutting edges against metallic surfaces
- During tool changes, thoroughly clean the attachment and clamping collet

## **Repairs and spare parts**

### **Q) Qualified personnel**

Composite tools must be repaired by competent and experienced personnel who have knowledge of design requirements and the safety level that must be achieved.

### **R) Original spare parts**

Repair must include the use of spare parts in accordance with specifications of original parts supplied by the manufacturer. Use only original CAUL spare parts.

Sharpening work must be performed only by qualified personnel.

### **S) Clamping tolerances**

Maintain tolerances that ensure correct clamping.

### **T) Sampling**

Perform sampling before proceeding to series production.

## **Quality controls**

Every tool undergoes:

- Balancing
- Dimensional control
- Tool integrity control
- Operator signature
- Control date

*For any questions about your CAUL tools, do not hesitate to contact us.  
We are at your service.*