Introduction
The Model H7538 circle cutter cuts holes in wood, plastics and various laminates from 1 3/8" 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.
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 ¼” 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 ¼” 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.

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 slide 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).

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.