OWNERS MANUAL

Multiple Application Concrete Saw

MODEL:

GC55

FORM <<GC55 rev B 5/2009

Discount Equipment

NORTON Clipper

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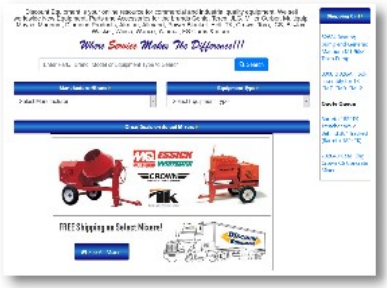

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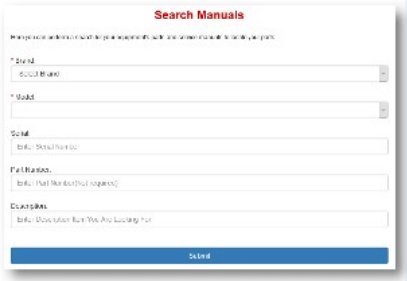

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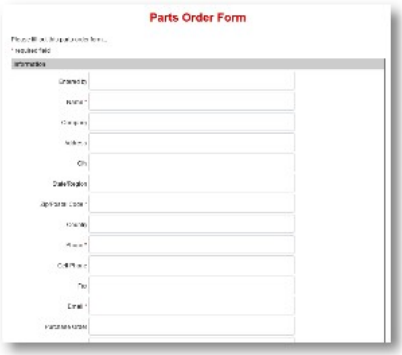

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WARRANTY

Norton warrants all products manufactured by it against defects in workmanship or materials for a period of one (1) year from the date of shipment to the customer.

The responsibility of Norton under this warranty is limited to replacement or repair of defective parts at Norton's Stephenville, Texas factory, or at a point designated by it, of such part as shall appear to us upon inspection at such point, to have been defective in material or workmanship, with expense for transportation borne by the customer.

In no event shall Norton be liable for consequential or incidental damages arising out of the failure of any product to operate properly.

Integral units such as **gasoline engines**, **electric motors**, **batteries**, **tires**, **transmissions**, **etc**., are excluded from this warranty and are subject to the prime manufacturer's warranty.

This warranty is in lieu of all other warranties, expressed or implied, and all such other warranties are hereby disclaimed.

Important: Before placing equipment in operation, record the following information.

MODEL:_____ SERIAL NO._____

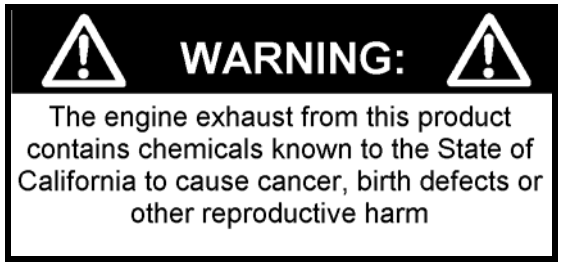
PURCHASE FROM: _____

ADDRESS: _____

CITY_____ STATE _____ ZIP _____

TELEPHONE NO. _____

Before using this equipment, make sure that person using it read and understand the instructions in this owner's manual.



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Read Owners Manual Before Use

Safety Alert Symbol: Information Following This Symbol Is Very Important.

Use Only Clipper Diamond Blades

I. PREPARATION

A. Safety Precautions

Important! The following safety precautions must always be observed.

Hazard Symbols

Fuel (gasoline) is extremely flammable and its vapors can explode if ignited. Store gasoline only in approved containers, in well-ventilated, unoccupied approved areas, and away from sparks or flames. Do not fill the fuel tank while the engine is hot or running. Do not start the engine near spilled fuel.

Never use the fuel as a cleaning agent

Engine components can get extremely hot from operation. To prevent burns, do not touch the engine or related parts while the engine is running or immediately after it is turned off. Never operate the engine with any heat shields or guards removed.

Keep all guards in place when operating any piece of equipment

Keep hands, feet, hair, and clothing away from all rotating parts

Lethal Exhaust Gas use only in well ventilated areas. Engine exhaust gases contain poisonous carbon monoxide, which is orderless, colorless, and can cause death if inhaled. Avoid inhaling exhaust fumes, and never run the engine in a closed building or confined area

Never tamper with the governor components of settings to increase the maximum speed. Severe personal injury and damage to the engine or equipment can result if operated at speed above maximum. Always obey the maximum speed rating of blade.

DO NOT LIFT THE SAW BY THE HANDLE BARS

⚠ WARNING

Dust and Silica Warning

Grinding/cutting/drilling of masonry, concrete, metal and other materials can generate dust, mists and fumes containing chemicals known to cause serious or fatal injury or illness, such as respiratory disease, cancer, birth defects or other reproductive harm. If you are unfamiliar with the risks associated with the particular process and/or material being cut or the composition of the tool being used, review the material safety data sheet and/or consult your employer, the material manufacturer/supplier, governmental agencies such as OSHA and NIOSH and other sources on hazardous materials and make certain to comply with all product warnings and instructions for the safe and effective use of the material being cut. California and some other authorities, for instance, have published lists of substances known to cause cancer, reproductive toxicity, or other harmful effects.

Control dust, mist and fumes at the source where possible. In this regard use good work practices and follow the recommendations of the manufacturer/supplier, OSHA/NIOSH, and occupational and trade associations. Water should be used for dust suppression when wet cutting is feasible. When the hazards from inhalation of dust, mists and fumes cannot be eliminated through engineering controls such as either vacuum and/or water mist, the operator and any bystanders should always wear a respirator approved by NIOSH/MSHA for the material being cut.

Use Approved:

Eye Protection

Hearing Protection

Respiratory Protection

Head Protection

1. **Before mounting any blade on the saw, the blade should be inspected for any damage which might have occurred during shipment, handling or previous use.**
2. **The blade collars and arbors should be cleaned and examined for damage before mounting the blade.**
3. **The blade must be properly fitted over the arbor with the drive pin on the outside collar projecting through the drive pin hole on the blade and inside collar.**
4. **The blade shaft nut, which is a left-hand thread nut, must be tightened securely against the outside blade shaft collar.**
5. **The blade must be operated within the specified maximum operating speed listed on the blade.**
6. **The blade guard must be in place with the nose guard down and locked when the saw is running.**
7. **The operator should wear safety glasses and any other appropriate safety equipment.**
8. **When starting the saw, the operator should stand away and to the side of the blade.**
9. **If for any reason the saw should stall in the cut, raise the blade out of the cut. Check the outside blade shaft collar and nut for tightness. Inspect the blade for damage before restarting the saw. Use caution when resuming a cut. Be certain that the blade is in alignment with the previous cut.**
10. **During cutting operations, do not exert excess side pressure on the handles as a method of steering. Do not force the blade into the cut by lowering the blade too fast or by pushing the saw too fast.**

You Are Responsible For Your Safety!!!

I. PREPARATION

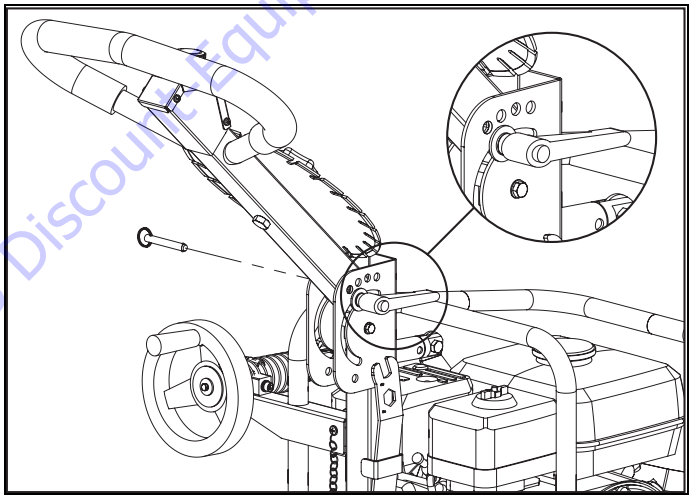
B. Assembly

The GC55 compact concrete saws are shipped completely assembled and ready for use except for diamond blade, gasoline, oil and Handle Bar position. Inspect the saw for shipping damage. If any damage is found, contact the shipper immediately and file a freight claim. The Norton Company is not responsible for any freight-related damages.

Adjust the Handle Bars Position:

1. Remove the GC55 from the box.
2. Remove the Quick Release Pin P/N: 241055 out of it's retaining hole
3. Loose the Black Knob P/N: 241054.
4. Rotate the Handle Bar from the lowered storage position to the desired position.
5. Align the hole in the Handle Bar with the holes in the frame.
6. Attach the Quick Release Pin P/N: 241055 by pushing it through the hole in the Frame and then the hole in the Handle Bar. Make sure that the Quick Release Pin passes all the way through both sides of the Frame.
7. Tighten the Black Knob P/N: 241054.

Read and understand the remaining sections of this Owner's Manual. NOTE: Do not install the blade until it is time to use the saw. ANSI regulations prohibit the transportation of any concrete saw with the blade installed.



Part #	Description	QTY
241054	SCR 5/16-18 UNC X 2-1/2" CARRIAGE BOLT	1
241055	PIN QUICKRELEASE 5/16" X 2" GRIP LENGTH	1
241054	KNOB M8 X 1.25 ADJUSTABLE	1
232110	WASHER M8 DIN125 FLAT	1
241055	WASHER 3/8 WAVE	1

C. GC55 Series Concrete Saw Specifications

Dimensions/Weight	
Length (Working)	54.00" (1369mm)
Length (Transport)	32.75" (827mm)
Width	18.25" (463mm)
Height	37.25" (945mm)
Weight	118lbs
Engine	
Engine Mfg.	Honda
Spec No.	GX160K1QXC
Engine Type	Single Cylinder 4 Cycle
Horse Power	4.5 hp @ 3,600 rpm Net Horsepower Rating provided by engine the manufacturer measured in accordance to SAE j1349 @ 3,600 RPM. The engine may vary from this value. Actual horsepower on the machine will vary due to operating speed of engine, belt tension, environmental conditions, machine maintenance, and other variables.
Max Torque	7.6 lb-ft (10.3 Nm, 1.05 kg-m) @ 2500 rpm
Model	GX160K1QXC
Model	GX160
Cooling System	Air
Oil Capacity	0.6 liter (0.63 US qt)
Fuel Capacity	3.1 liter (3.28 US qt)
Fuel Type	Unleaded Gasoline (86 pump octane)
Low Oil Sensor	Yes
Air Filtration	Four Stage Cyclone
Characteristics	
Max Blade	Ø10" (254mm)
Depth of Cut 10" (254 mm)	3.5" (88mm)
8" (203 mm)	2.5" (63mm)
Arbor Bore	5/8"
Blade Shaft Speed	2905 rpm
Depth Control	Hand Wheel With Screw Feed
Depth Lock	Standard
Depth Gauge	Standard
Number Of V-Belts	1
Blade Guard Type	Screwed On, All Steel Construction
Cutting Side	Center
Lifting Bale	Built In
Handle Bars	Adjustable, Stays Level At All Times
Wheels	Non-marking
Sound pressure[1]	88 db (A)
Sound power[1]	105 db (A)

1) The sound measures have been made following pr EN 12638, Annex A; 2) "Floor sawing, grooving and milling machines – Safety "

The GC55 was designed from the ground up to be a High Performance Multiple Application saw. The GC55 is capable of cutting Green Concrete (Early Entry), Cured Concrete, Asphalt, and Decorative Concrete. Being able to cut more than just green gives the GC55 many advantages over the competitor's machines such as a lower investment for our customer.

Use For Cutting Multiple Applications:

Green Concrete (Early On)
Decorative Concrete
Cured Concrete
Asphalt

Features that make the GC55 a High Performance Multiple Applications Saw:

- Blade in center line of saw helps to reduce tearing of concrete when cutting green concrete. The center line blade also helps the GC55 to roll straight while cutting due to the blade being parallel to the blade.
- Reinforced all steel frame reduces bending, flexing, and vibrations which can damaged the concrete. The reinforced all steel frame is also stronger than the competitive models
- Soft Silicone Rubber wheels that are based off of a Norton Patient to absorb vibrations that can create spalling and machine movement. The wheels also feature a concave profile that helps the machine to roll over small objects with out upsetting the blade.
- 10" maximum blade capacity with standard 5/8" arbor. The GC55 can use with 7" to 10" diameter Norton blades.
- Hand Wheel with Depth Adjustment Screw & Depth. Allows precise depth adjustments up to 3-1/2" deep when used with a 10" blade.
- Fully adjustable non-scratching Dust removal system helps stabilize the GC55 by pushing debris way from wheels and undercarriage of the machine.
- Front and rear pointers for precise alignment.
- Handle Bar and Pointer folds up for compact easy transport.
- Light in weight, weights only 115 lbs.
- The GC55 is a very simple machine to operate.
- The GC55 is designed for cutting Multiple applications: Green Concrete (Early Entry), Cured Concrete, Asphalt, and Decorative Concrete.
- Includes a free 10" GMAX blade. The GMAX blade is specifically designed with the following features for improved Green Concrete cutting:
    - Anchor Slot Core Technology Reduces Chip Causing Vibrations.
    - Thicker Core Resist Flexing and Bending For Improved Cut Quailty.
    - Optimize Bond And Diamond For Fast Green Concrete And Aggregate Cutting.

D. Engine

Prior to attempting to operate the engine, read the information contained in the engine owner's manual. An engine owner's manual is supplied with every gasoline powered concrete saw.

1. **Check Oil:** Add oil if low. Refer to the engine owner's manual for the recommended SAE viscosity grades. Capacity of oil is 0.6 liter (0.63 US qt.)

2. **Check Fuel:** Fill if low. Use only unleaded gasoline with a pump sticker octane rating of 86 or higher is recommended. **Never use an oil and gasoline mixture!**

3. **Air Cleaner:** Never run the engine without the air cleaner! Rapid engine wear will result from contaminants being drawn through the carburetor and into the engine.

4. **Engine Starting:** Refer to the engine owner's manual for proper engine starting procedure.

E. Pointer Alignment

1. Use a straight edge, and carefully mark a line 12 feet long on a smooth level surface.

2. Place the saw blade on the marked line, move the saw to the center of the marked line and then lower the blade until it is about 1/16" above the marked line.

3. Measure from each end of the saw frame to insure that the frame is parallel to the marked line. Adjust the saw as needed.

4. With the blade centered on the marked line and the saw frame parallel to the marked line, lower the front pointer.

5. Adjust the nylon nuts until the pointer is aligned with the marked line.

II. OPERATION

A. Installing the Blade

1. Disconnect the spark plug.

2. Raise Blade Guard its highest position.

3. Open the blade nut access door. Remove the blade shaft nut (Turn clockwise) and remove the outside collar and raise the Blade Guard.

4. Clean off any foreign particles on the clamping surfaces of both collars and on the mounting surface of the blade.

4. Position the blade beneath the cutting head and slide the blade into the blade guard (slide the blade under the blade guard at an angle will simplify the installation process). Be careful not to hit the blade shaft with the blade.

5. Locate the blade shaft then slide the blade bore hole onto the blade shaft.

Use only Norton Diamond Blades. This machine was not designed for the use with abrasive blades. For the best performance when cutting green concrete use the Norton GMAX series blade.

6. Slide the outside blade shaft collar onto the blade shaft.

7. Tighten the blade shaft nut (Turn counter-clockwise) securely against the outside collar. Close the blade nut access door.

8. Reconnect the spark plug.

Use Only Norton Diamond Blades

B. Starting the Engine

1. Refer to the engine owner's manual for the proper starting procedures.

2. Always cut with engine rpm in the full throttle setting.

C. Operating the Saw

1. For blade installation instructions see section II. Operation sub heading A. Installing the Blade. For the engine starting instructions, see the Engine manual and follow the instructions located in section II. Operation sub heading B. Starting the Engine.

2. Check the Engine Oil level.

3. Raise the saw to the full upright position. Do not let the blade come in contact with the ground.

4. Maneuver the saw to the desired starting point.

5. Follow the instructions for starting the engine found in the Engine manual.

6. Be sure the engine is running at full throttle!!!

7. Slowly lower the blade by rotating the hand wheel clockwise until the desired depth of cut is reached. Use a reasonable rate of feed. Do not force the blade into the cut!! If the engine starts to die slow down the rate of feed! If the machine tries to climb out of the cut, slow down the rate of feed!

8. When the end of the cut is reached, slowly raise the blade out of the cut by rotating the Hand Wheel counter-clockwise until the blade is at least one (1) inch above the ground.

9. Only move the saw in reverse with the blade in the raised position.

10. When moving the saw to a new location, be sure the blade is not touching the ground. Always pay close attention to where you are moving and where the blade is at all times.

D. Cutting Technique

Lower the blade into the concrete to the required depth by turning the hand wheel clockwise.

Push the saw steadily forward using the front pointer as a guide. Exert enough forward pressure so that the engine begins to labor, but does not slow down. If the saw begins to stall, reduce the forward movement until full rpm is restored to the blade. If the saw stalls, raise the blade out of the cut before restarting. Avoid excessive side pressure or twisting of the blade in the cut.

Additional Guide Lines For Sawing:

- Understand and follow all of the instructions in this owner's manual.

- In critically hard aggregate, be careful not to feed too quickly as it may stall the saw or ruin the cut.

- If the saw stalls in the cut, immediately stop the forward speed and raise the blade out of the cut. If this is not done the belts can fail or the blade may be damaged.

- Go slowly with a new blade until it opens up, that is, until the diamonds can be seen and felt.

E. Green Concrete Cutting

The new Norton Clipper GC55 is much more than a green concrete saw or as it is some times called an early entry saw. The GC55 was designed from the ground up to be a High Performance Multiple Application saw. The GC55 is capable of cutting Green Concrete (Early Entry), Cured Concrete, Asphalt, and Decorative Concrete. Being able to cut more than just green gives the GC55 many advantages over the competitor's machines such as a lower investment for our customer.

Green Concrete Cutting Important Considerations

Green concrete is concrete that is still in a plastic state that is the concrete still has a lot of moisture in it, in other words it is not fully cured or dry. As the concrete starts to hydrate (dry or cure), the concrete will change slightly in volume. Concrete normally shrinks about 1/16" for each 10 feet during the hydration process. This change in size creates internal stress in the concrete which will develop into cracks. Joints also known as Crack Control Joints and or Expansion Joints are normally cut into the concrete in order to relieve the internal stress and to create an area where a controlled crack will occur. With the joint in place the concrete will normally crack in a straight line underneath the joint. The idea behind cutting the green concrete is that the sooner the stress relieving joints are made the better control over the random cracking will be obtained. For most green cutting the depth of cut is made at 25% of the overall thickness of the concrete, for example if the concrete is 6" thick, the cutting depth would be set to 1-1/2" deep. One important fact to remember is that Green Concrete is any concrete that has set up but not hardened. For concrete to become fully hardened it may take 5 to 7 days.

There are a few factors that affect green concrete cutting quality, and time that the cutting can begin. The following list is extremely important to follow and to understand in order to create a good quality cut with no spalling or chipping of the cut line.

1. The concrete must set up long enough to hold the aggregate in place. If not the aggregate will tumble and move when the Diamond Blade contacts it, causing internal damage to the concrete and possible tearing or spalling of the concrete surface. The aggregate along with the concrete must be cut for proper crack control. With out proper set up the aggregate will roll or move within the concrete creating voids and spalling or chipping of the

cut line will occur. Concrete set up is the MOST important issue to obtaining a quality cut line when green concrete cutting. Factors that affect the concrete set up are:

a) Concrete Mixture – PSI, concrete type, sand type and amount, and other materials.
b) Water to Cement Ratio – more water the longer the set up
c) Aggregate Size and Type
d) Concrete Additives – some speed up while others slow down the set up time.
e) Environmental Factors – Sun, Wind, Rain, Temperature
f) Concrete Temperature – cooler the concrete the longer the set up time.

2. Flat surface. Flat surfaces help to insure that the blade is perpendicular to the concrete which reduces the chances of damaging the concrete surface. When the blade meets the concrete surface at a 90° angle (perpendicular) less side drag is created on the blade. When the blade is not perpendicular side drag is create that will cause the concrete to chip or spall.

3. Blade that is designed for green concrete cutting. The GMAX blade has some unique features that make it an outstanding blade for green concrete cutting such as:

a) Anchor Slot Core Technology that reduces vibrations in the blade. Excessive vibrations will cause the blade to flutter or bend from side to side which will damage the concrete surface and cause the blade to wear out prematurely.
b) Thicker core that resist flexing and bending. Thin core blades bend due to excessive pressure during cutting and from over heating. When blade bends and flexes the concrete and blade will be damaged.
c) Optimized bond and diamond for fast green concrete cutting. The improper bond will not cut green concrete properly.

When to Start Green Concrete Cutting

Timing is the most important aspect of cutting green concrete. The time that the operator can start cutting will vary depending on the key factors listed above. For example if the concrete has a high water to cement ratio or the day is cooler then more time is required for the concrete to properly set up and hold the aggregate in place. Typically we are finding that starting around 5 to 6 hours after finishing good results can be obtain. We find in our testing that at 16 hours in gives the best results. These times to start are assuming that the concrete has set up long enough to hold the aggregate in place.

Green Concrete Cutting Trouble Shooting

Spalling or Chipping On Both Sides of Cut:

1. **Wait** at least 1 to 2 more hours before cutting. The very good cut appearance is achieved at 5 to 6 hours after finishing complete. The best cut appearance occurs when the concrete has set up enough for the aggregate to be held in place which may take up to 16 hours. The actual time to begin cutting will depend on many factors such as: concrete mixture (PSI, concrete type, sand type and amount, and other materials, water to cement ratio – more water the longer the set up), aggregate size and type, concrete additives – some speed up while others slow down the set up time, environmental factors (sun, wind, rain, temperature), concrete temperature (cooler the concrete the longer the set up time).

2. **Check** blade specification. The improper blade specification will create additional spalling or chipping of the concrete. For best results use a Norton GMAX series Blade. The Norton GMAX series have unique features to improve the green concrete cut quality and the overall efficiency of the blade while cutting green concrete. The GMAX blade provided with the GC55 was designed exclusively for use on this product to provide maximum performance and a precision cut appearance!

3. **Check** blade for wear. As the blade loses width the cut appearance will get worse. Blades with segments that look like a knife blade need to be replaced immediately as a blade in this condition will create a poor quality cut line.

4. **Check** concrete surface for flatness.

5. **Replace** the blade with a new blade of the same specification.

6. **Replace** blade with the correct specification.

Cut Appearance Previously Fine But Now Constantly Spalling or Chipping On One Side Of The Cut:

1. **Check** for warped blade. A warped our out of tension blade will create a cut that has spalling and chipping. Replace blade if necessary.

2. **Check** the tracking on saw.

3. **Check** that the machine is being pushed in a straight line.

Thin Shell Chipping of Concrete:

1. **Wait** 1 to 2 hours for the concrete cure depth to increase. Shell chipping is caused when the top layer of concrete is curing at a faster rate than the concrete below. The concrete needs to cure to a deeper depth in order to prevent the shell chipping.

Features of the GC55 That Help to Improve the Cut Quality:

- Blade in center line of saw helps to reduce tearing of concrete when cutting green concrete. The center line blade also helps the GC55 to roll straight while cutting due to the blade being parallel to the blade.

- Reinforced all steel frame reduces bending, flexing, and vibrations which can damaged the concrete. The reinforced all steel frame is also stronger than the competitive models

- Soft Silicone Rubber wheels that are based off of a Norton Patient to absorb vibrations that can create spalling and machine movement. The wheels also feature a concave profile that helps the machine to roll over small objects with out upsetting the blade.

- 10” maximum blade capacity with standard 5/8” arbor. The GC55 can use with 7” to 10” diameter Norton blades.

- Hand Wheel with Depth Adjustment Screw & Depth. Allows precise depth adjustments up to 3-1/2” deep when used with a 10” blade.

- Fully adjustable non-scratching Dust removal system helps stabilize the GC55 by pushing debris way from wheels and undercarriage of the machine.

- Front and rear pointers for precise alignment.

- Light in weight, weights only 115 lbs.

- The GC55 is a very simple machine to operate.

III. MAINTENANCE

A. Engine

Follow the below schedule for engine maintenance. NOTE: Check the Honda Engine manual that came with the engine for any changes to the maintenance schedule. If the charts have any differences, follow the chart in the Honda Engine Manual. The Norton Company does not warranty the engine. If any

engine. If any warranty or service of the engine is required contact your nearest Honda service center, or from the Internet: http://www.honda-engines.com/home.htm

Honda engine (refer to owner's manual for complete maintenance.)

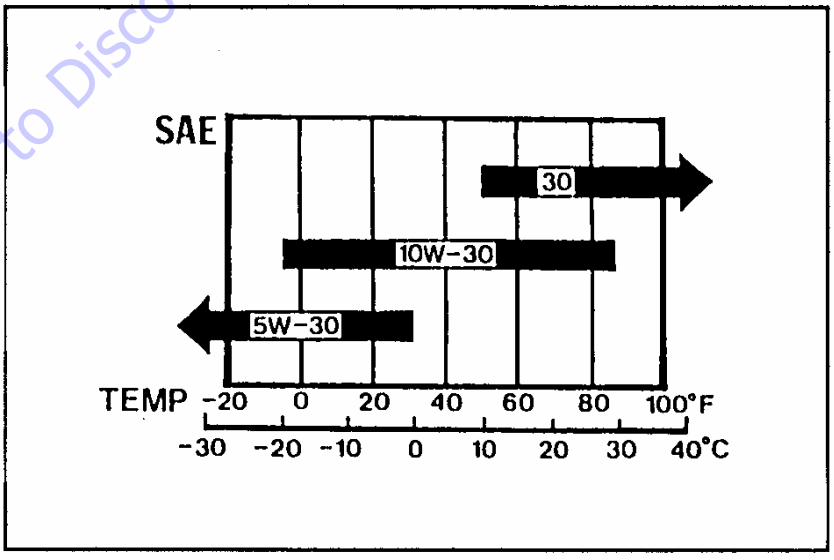
MAINTENANCE SCHEDULE

ITEM / REGULAR SERVICE PERIOD (Perform at every indicated operating hour interval.)		EACH USE	FIRST 20HRS	EVERY 50HRS	EVERY 100HRS	EVERY 300HRS	Refer to page
Engine oil	Check level	O					3-2
	Change		O		O		
Reduction gear oil	Check level	O					3-2
	Change		O			O	
Air cleaner	Check	O					3-3
	Clean			O (1)			
Fuel strainer cup	Clean				O		3-7
Spark plug	Check-Clean				O		3-6
Valve clearance	Check-Adjust					O	3-5
Combustion chamber and valves	Clean-Lap					O	9-3,4
Fuel line	Check (Replace if necessary)	Every 2 years					3-8

NOTE: (1) Service more frequently when used in dusty areas.

Check the engine oil level before each use when the engine is cool and the engine is level. Add oil if the level is low. The oil level should be within the operating range (see the engine owner's manual for details).

Only use a high-detergent, premium quality motor oil certified to meet or exceed U.S. automobile manufacturer's requirements for Service Classification SG, SF/CC, CD. Motor oils will show the classification on the container. A SAE viscosity of 10W-30 is recommend by Honda for general, all temperature use. Please consult the below chart or contact your local Honda service center for the proper viscosity for your temperature range.



Always refer to the engine manual for more detailed information on checking the oil, changing oil, and oil capacity, air filter changes, and fuel type to use. Use only Honda air filters. Do not clean the air filter with gasoline or other flammable solvents. A fire or explosion could result. To clean, follow the instructions found in the Honda engine manual.

Dry Cutting Engine Maintenance

- ✓ When operating the engine in dry cutting or dusty environments the following is required:
- ✓ Engine oil changed more often.
- ✓ Every 50 hours (or more often if conditions require) clean all of the engine cooling fins.
- ✓ Every 25 hours (or more often if conditions require) clean the engine pre-cleaner.
- ✓ Every 100 hours (or more often if conditions require) replace the air filter. If the engine is equipped with a reusable air cleaner, clean and re-oil it.
- ✓ Check and clean the air filter after each use. Replace as needed.

B. Bearings

The GC55 is equipped with permanently sealed blade shaft and wheel bearings that will never need any lubrication. These types of bearings are designed for long life and minimum maintenance. If any problem occurs with the blade shaft, or wheel bearings replace the bearing.

The only the Raise Screw and Cutting Head pivot point will need periodic re-lubrication. Both of these points require just a squirt of a good quality NLGI #2, aluminum complex type grease is recommended one time a month. Check the function of the Hand Wheel and Cutting Head before each use.

C. V-Belts

Warning: Never make adjustments to belts or pulleys while engine is running!

1. The best tension for a belt drive is the lowest tension at which the belts will not slip under full load.

2. Simply take up the drive until the belts are snug in the grooves. Run the drive for about 15 minutes to "seat" the belts. Then impose the peak load. If the belts slip, tighten them until they no longer slip at peak load.

3. **Remember, too much tension shortens belt and bearing life!**

4. Check the belt tension frequently during the first day of operation. Check the belt tension periodically thereafter and make any necessary adjustments.

5. The two most common causes of misalignment are shown in the Figure 1 and Figure 2 to the right.

   a). The engine drive shaft and the blade shaft are not parallel.
   b). The pulleys are not located properly on the shafts.

6. To check alignment, all you need is a steel straight edge.

7. Line up the straight edge along the outside face of both pulleys as shown in the drawing.

8. Misalignment will show up as a gap between the pulley face and the straight edge.

9. Make sure that the width of the outside land (area between the belt and the edge of the pulley) is equal on both pulleys.

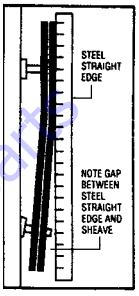


FIGURE 1

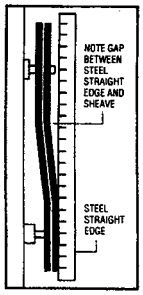


FIGURE 2

D. Depth Control

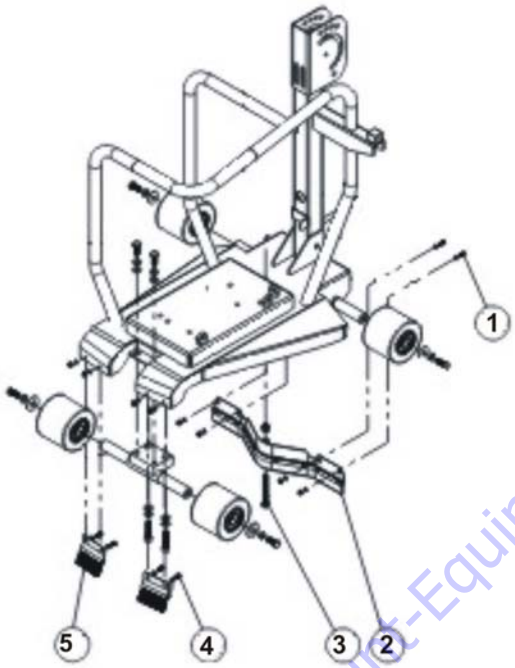
The cutting depth is controlled by a chrome turn handle. It is located next to the push handle base, easily accessible from the rear of the saw. The handle must first be unlocked before it can be turned. It is locked by a black knob located on the operator's left side of the hand wheel near the base of the handle. This knob must be turned counter-clockwise to unlock the handle. Once unlocked rotating the handle clockwise will lower the cutting blade. Rotating it counter-clockwise will raise the cutting blade. When the proper cutting depth is achieved by reading the depth gauge, relock the turn handle to ensure a constant cutting depth throughout the cut.

The depth gauge can be found further down the shaft of the turn handle. This gauge will already be preset for an Ø10" blade, but it still must be calibrated by the user since blade diameters may vary. When using an Ø8" blade, the gauge must be readjusted from an Ø10" blade to an Ø8" blade. Simply loosen the black knob found near the collar of the gauge and slide it accordingly to achieve the proper reading.

The collar used to support the turn handle's screw should be checked after each use to make sure it is lubricated and turning freely. If more lubricant must be added, NLGI #2, aluminum complex type grease is recommended.

E. Dust Removal System Adjustment

The GC55 is equipped with a fully adjustable non-scratching Dust removal system which helps stabilize the GC55 by pushing debris way from wheels and undercarriage of the machine. Depending on the surface and wear the Dust Removal System may need adjustments from time to time. The Dust removal system consist of two Brushes located in front of the Front Wheels and a large Squeegee Assembly located under the machine and in front of the rear wheels. When this system is properly adjusted the front wheel Brushes, and the Rear Wheel Squeegee System will barely touch the work surface.



Before making any adjustments turn off the machine and disconnect the spark plug.

To adjust the Rear Wheel Squeegee Assembly:

1. Loose the Squeegee Assembly mounting hardware items 1 & 3
2. Position the Squeegee Assembly to the required position
3. Tighten the Squeegee Assembly mounting hardware items 1 & 3

To adjust the Front Wheel Brush:

1. Loose the Front Wheel Brush mounting hardware
2. Position the Front Wheel Brush to the required position
3. Tighten the Front Wheel Brush mounting hardware

NOTE: The Left and Right Side Front Wheel Brushes Are Different Parts

IV. PARTS LIST SECTION

A. Ordering Information

1. List model number and serial number of machine.

2. List part number and serial number of part not the item number.

3. Wherever alternate parts are shown due to product improvement, inspect the part you have and provide additional description as necessary.

4. Specify mode of shipping desired, such as, parcel post, truck, U.P.S., best way, etc.

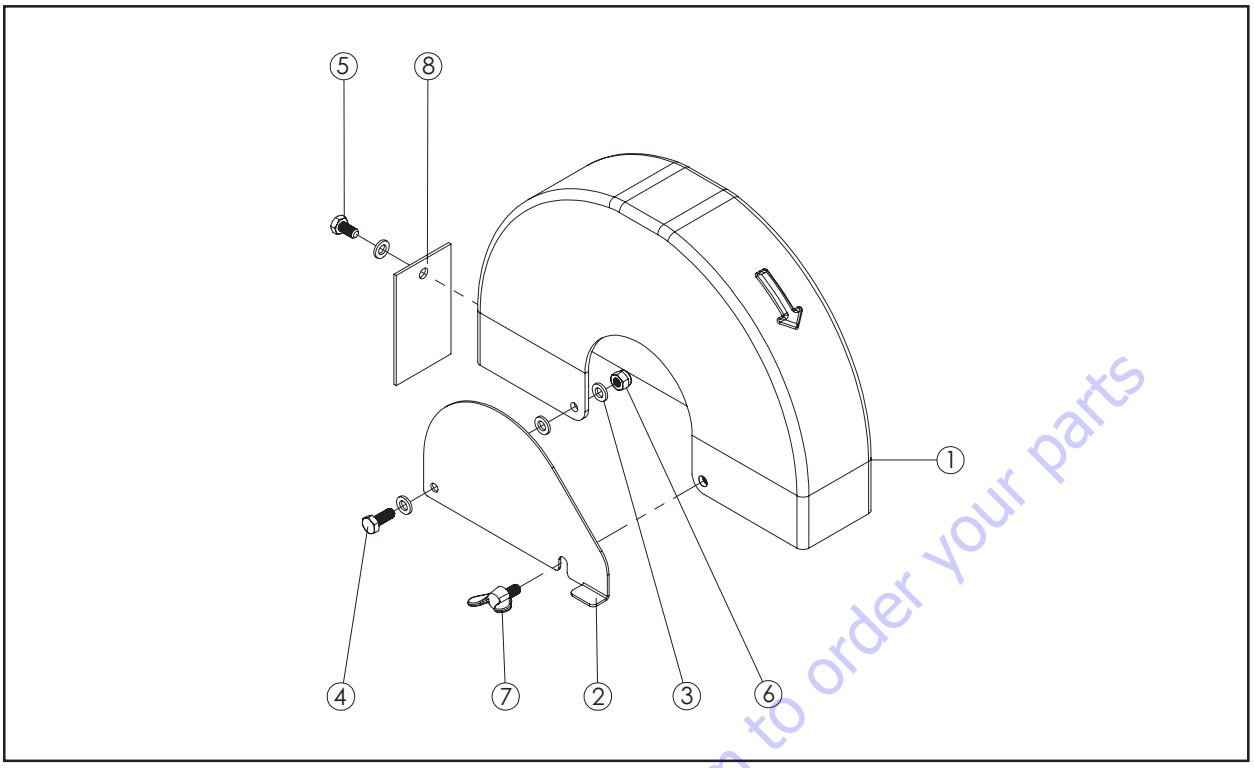
For the nearest Clipper distributor call 1-800-554-8003

Common Replacement Parts

Description	Part Number
WRENCH UNIVERSAL	233041
LOOSE COLLAR GC55	241081
TIGHT COLLAR GC55	241082
NUT 5/8-11 UNC HEX LEFT HAND THREAD	241083
GUARD BLADE GC55/GC25E	241001
BLADE SHAFT GC55	241016
BEARING RADIAL 6204-RS	212142
HAND WHEEL GC55	241023
BELLOWS GC55	241026
KNOB W/THREADED STUD M6 X 15 1.0	241029
KNOB W/THREADED HOLE M6 X 15 1.0	241032
CUTTING HEAD FLANGE GC55	241037
BRUSH WHEEL OPERATOR'S RIGHT GC55	241048
BRUSH WHEEL OPERATOR'S LEFT GC55	241049
POINTER WELDMENT GC55	241085
SWITCH EMERGENCY STOP GC55	241059
KNOB W/THREADED HOLE M10 X 1.5 X 50mm DIA	241061
WHEEL 75X28X8mm	241086
WHEEL W/BEARING GC55	241044
OIL DRAIN HOSE ASSY 5.5HP HONDA	241035

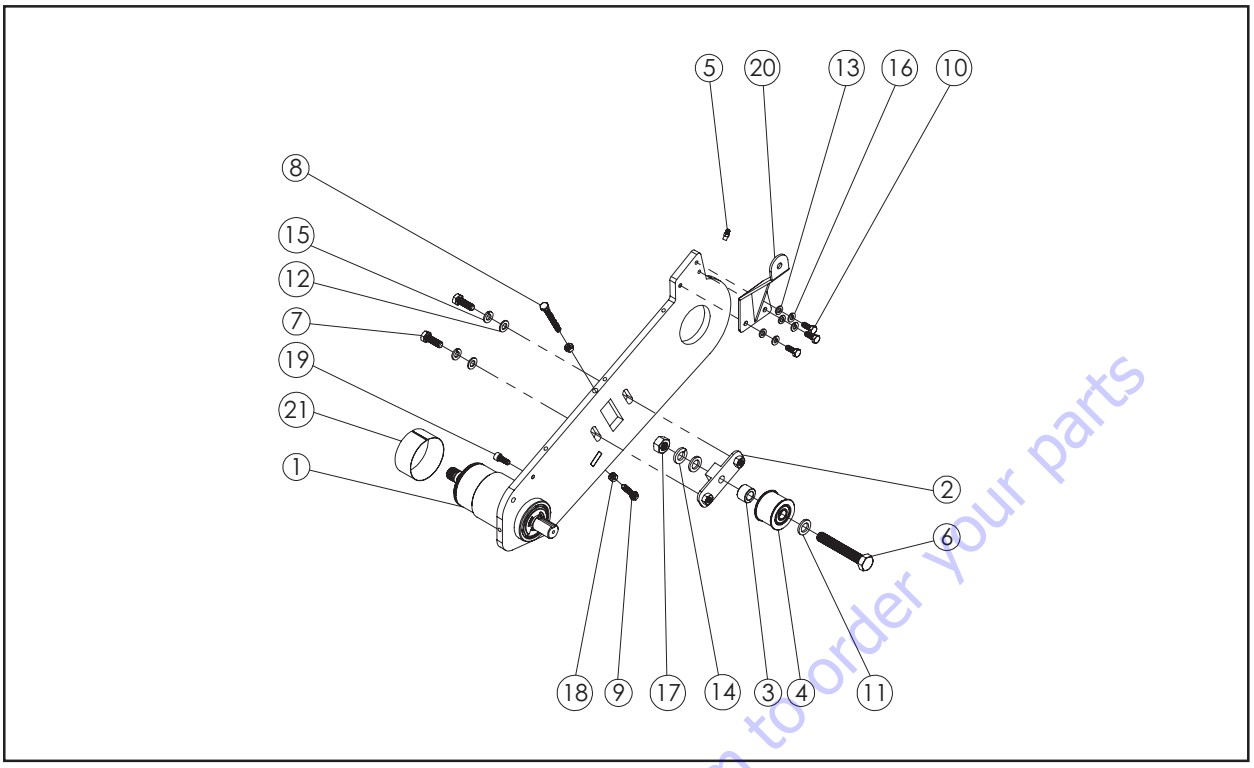
NOTE: All Parts Are Sold As Individual (each) Unless Noted Otherwise

Blades Use Only Norton Diamond Blades. Contact your local Norton Clipper Distributor or Norton Clipper at 1-800-554-8003 for the best blade for the application.



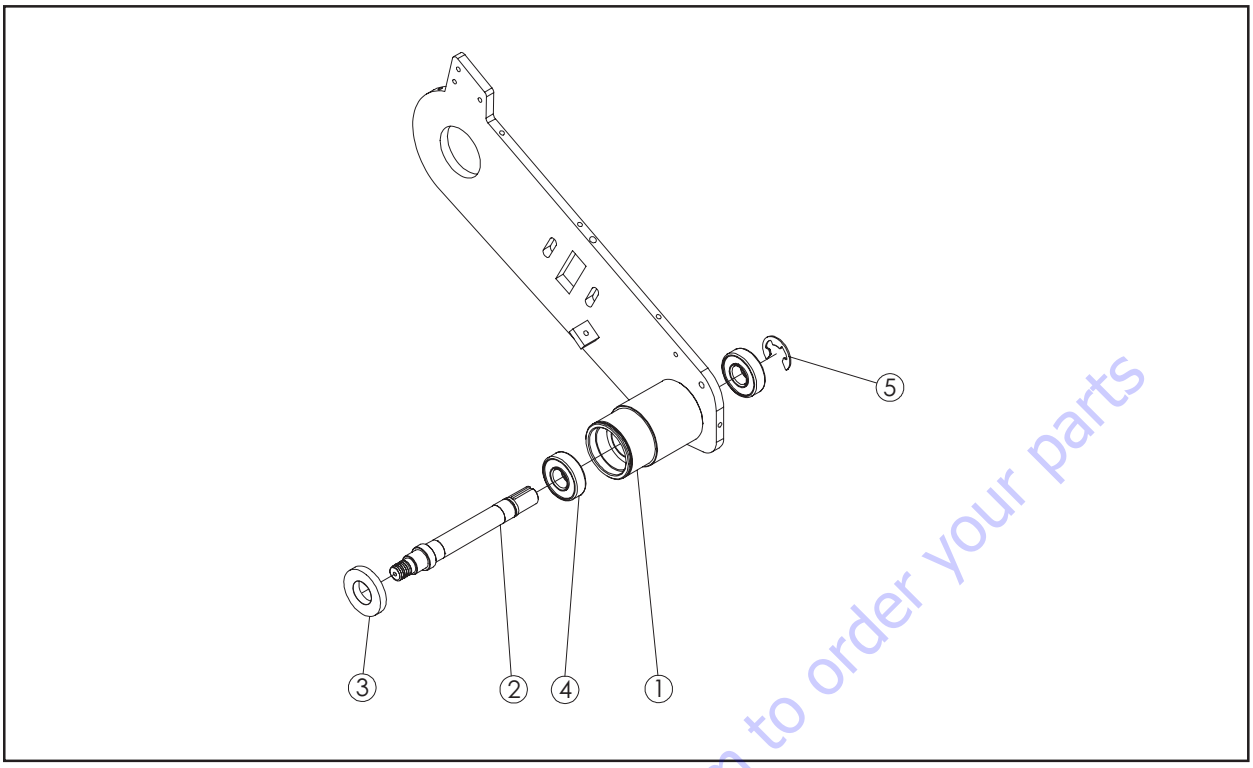
BLADE GUARD ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	GUARD BLADE GC55/GC25E	1	241001
2	BLADE SHAFT VENT COVER	1	241002
3	WASHER M6 DIN125 FLAT	4	27539
4	SCR M6 X 16 1.0 DIN933	1	235048
5	SCR M6 X 12 1.0 DIN933	1	300566
6	NUT M6 DIN985 LOCK	1	235136
7	SCR THUMB M6 X 12 1.0	1	241003
8	SPLASH GUARD GC55	1	241004



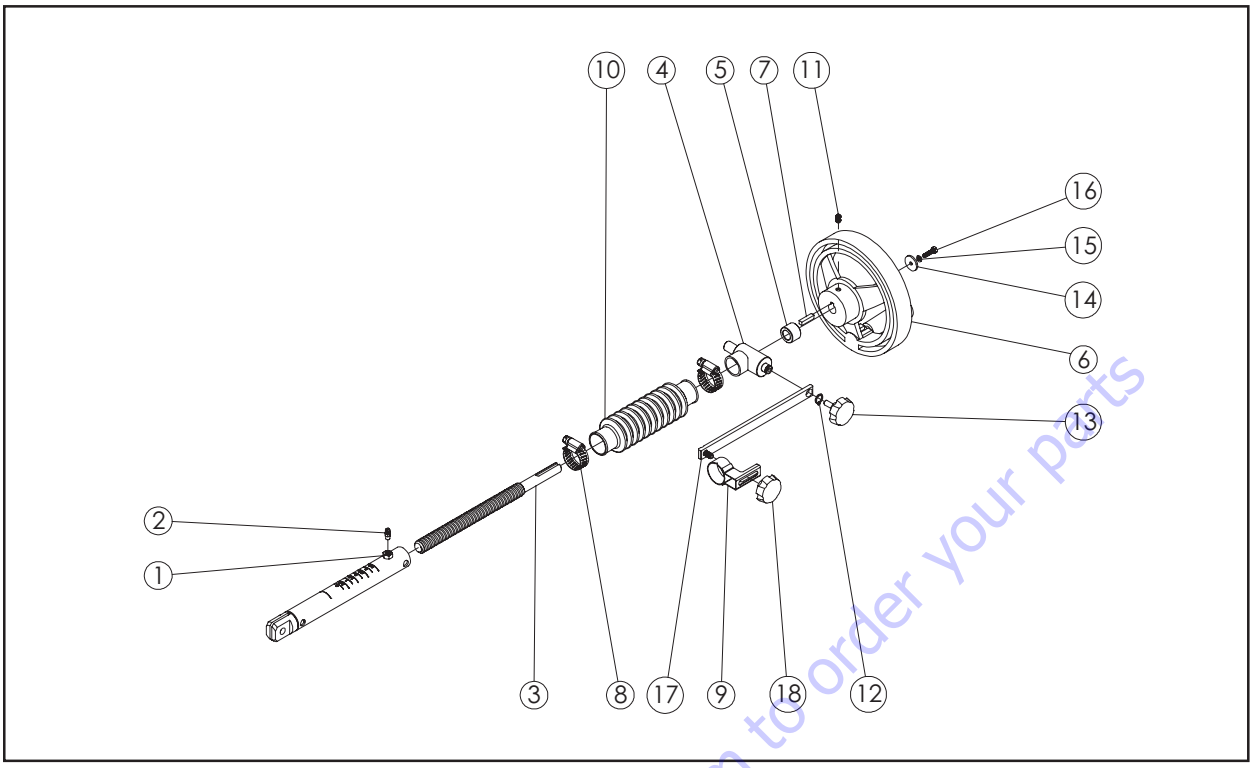
CUTTING HEAD ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	BEARING CUTTING HEAD SUB ASSY – SEE PG 23 FOR PARTS	1	241005
2	PULLEY IDLER TENSION ADJUSTER	1	241006
3	SPACER INDLER GC55	1	241007
4	PULLEY IDLER ASSEMBLY GC55	1	241008
5	ZERK FITTING M6	1	241009
6	SCR M12 X 80 1.75 DIN933	1	241010
7	SCR M8 X 25 1.25 DIN933 FULL THD	2	300323
8	SCR M6 X 55 1.0 DIN933	1	241011
9	SCR M6 X 30 1.0 DIN933	1	241012
10	SCR M6 X 16 1.0 DIN933	3	235048
11	WASHER M12 DIN125 FLAT	2	27505
12	WASHER M8 DIN125 FLAT	2	232110
13	WASHER M6 DIN125 FLAT	3	27539
14	NUT LOCK M12 1.75 DIN985	1	27017
15	WASHER LOCK M8 DIN127	2	300245
16	WASHER LOCK M6 DIN127B	3	300279
17	NUT M12 1.75 DIN934 HEX	1	27007
18	NUT M6 1.0 DIN934 HEX	2	300833
19	SCR M6 X 16 1.0 DIN912 SHCS	1	232113
20	BRACKET DEPTH CONTROL MOUNT GC55	1	241013
21	BUSHING BLADE GUARD GC55	1	241014



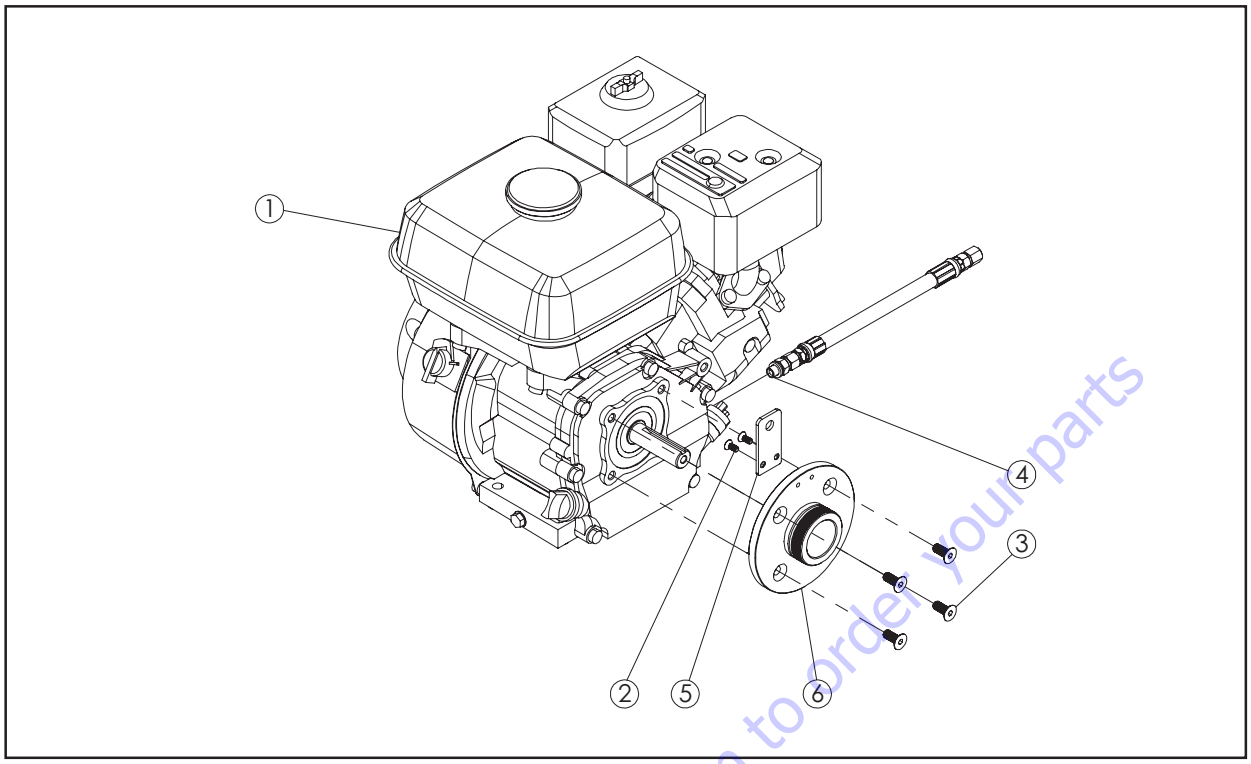
BLADE SHAFT ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	CUTTING HEAD ASSEMBLY GC55	1	241015
2	BLADE SHAFT GC55	1	241016
3	BEARING COVER BLADE SHAFT GC55	1	241017
4	BEARING RADIAL 6204-RS	2	212142
5	RETAINING RING E-STYLE 19mm X 1.8mm DIN6799	1	241018



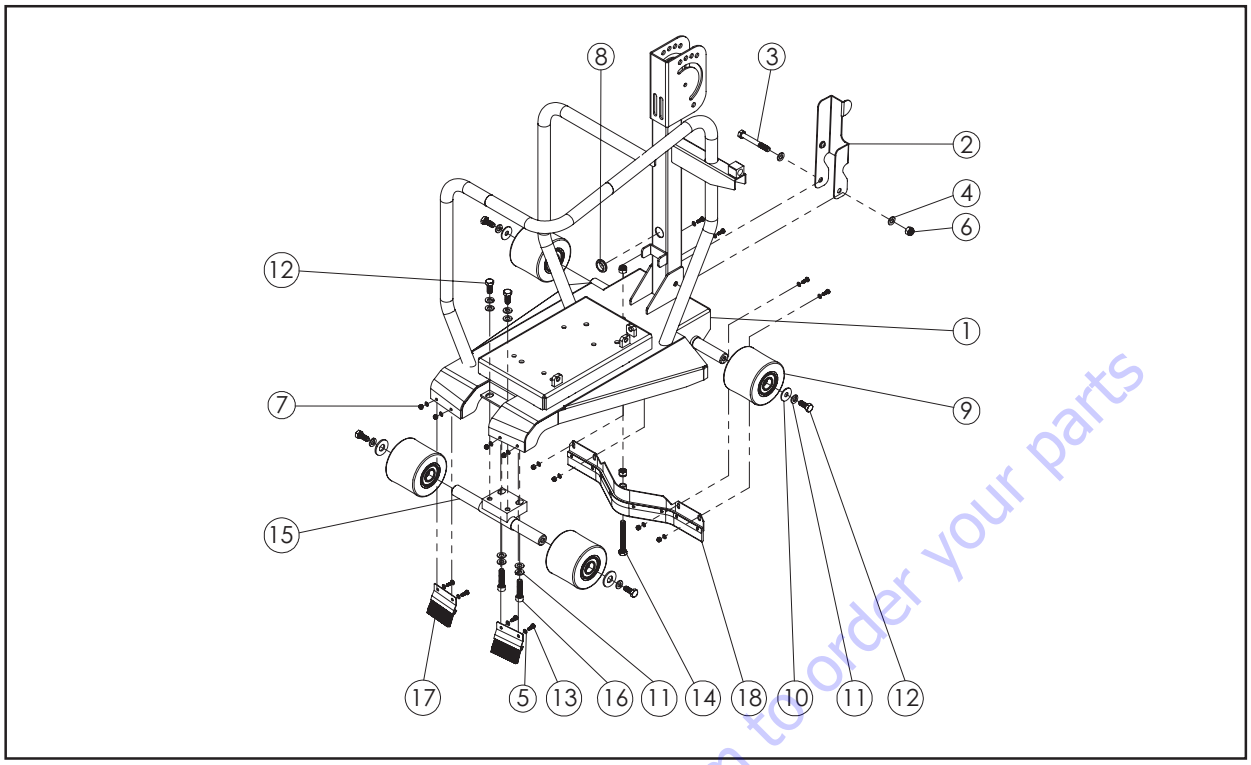
DEPTH CONTROL ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	DEPTH TUBE GC55	1	241018
2	FIT GREASE ZERK M6 X 1.0	1	241019
3	SCR DEPTH CONTROL GC55	1	241020
4	DEPTH CONTROL MOUNT GC55	1	241021
5	SPACER HAND WHEEL GC55	1	241022
6	HAND WHEEL GC55	1	241023
7	KEY 3/16X3/4	1	9201074
8	CLAMP HOSE 13/16" TO 1-3/4" X 1/2"W WORM TYPE	2	241024
9	DEPTH GAUGE POINTER GC55	1	241025
10	BELLOWS GC55	1	241026
11	SCR M5 X 10 0.8 DIN916 SET CUP POINT	1	241027
12	RETAINING RING C-STYLE 10mm X 1.0mm DIN471	1	241028
13	KNOB W/THREADED STUD M6 X 15 1.0	1	241029
14	WASHER M4 DIN125 FLAT	1	235104
15	WASHER LOCK M4 DIN127	1	241030
16	SCR M4 X 16 0.7 DIN933	1	235057
17	DEPTH CONTROL POINTER BAR GC55	1	241031
18	KNOB W/THREADED HOLE M6 X 15 1.0	1	241032



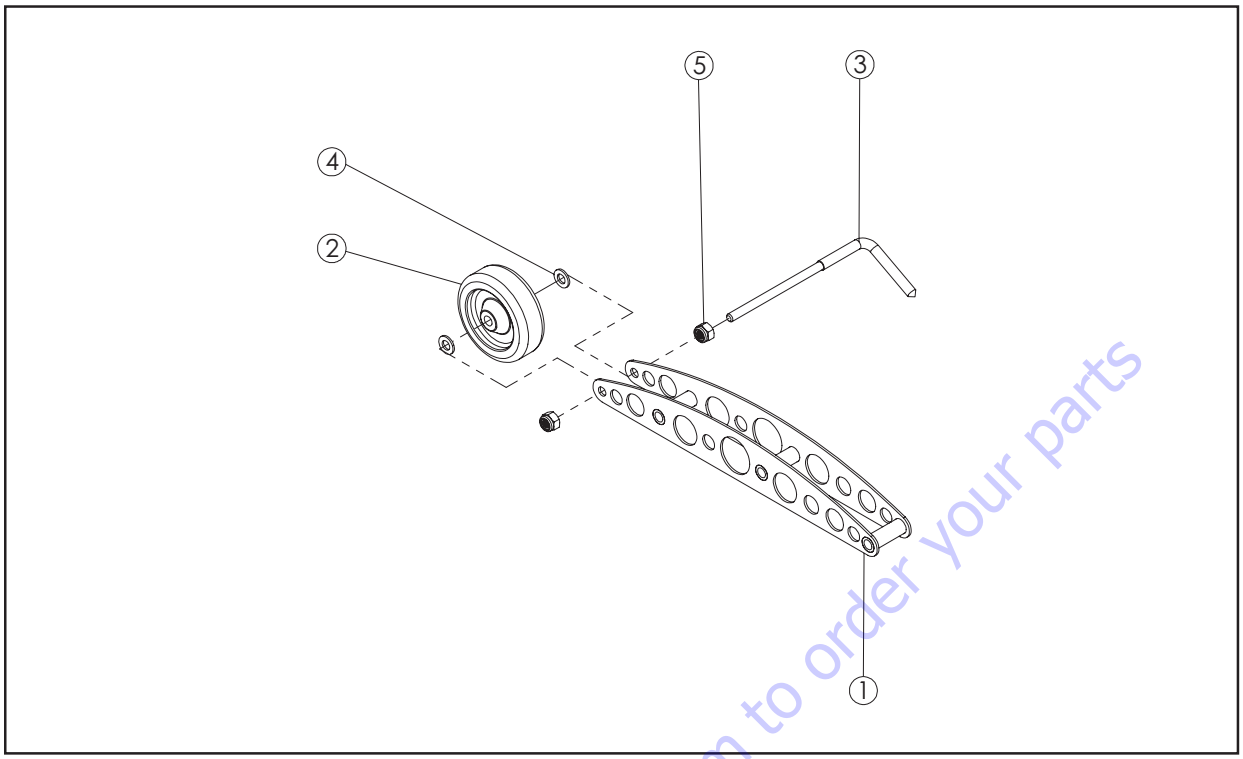
ENGINE ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	ENG 5.5HP HONDA	1	216264
2	SCR M5 X 12 0.8 FLAT HEAD SOCKET CAP	2	241033
3	SCR 5/16"-24 UNF X 3/4" C'SINK SOCKET HEAD	4	241034
4	OIL DRAIN HOSE ASSY 5.5HP HONDA	1	241035
5	BRACKET SELF LEVELING MOUNT GC55	1	241036
6	CUTTING HEAD FLANGE GC55	1	241037



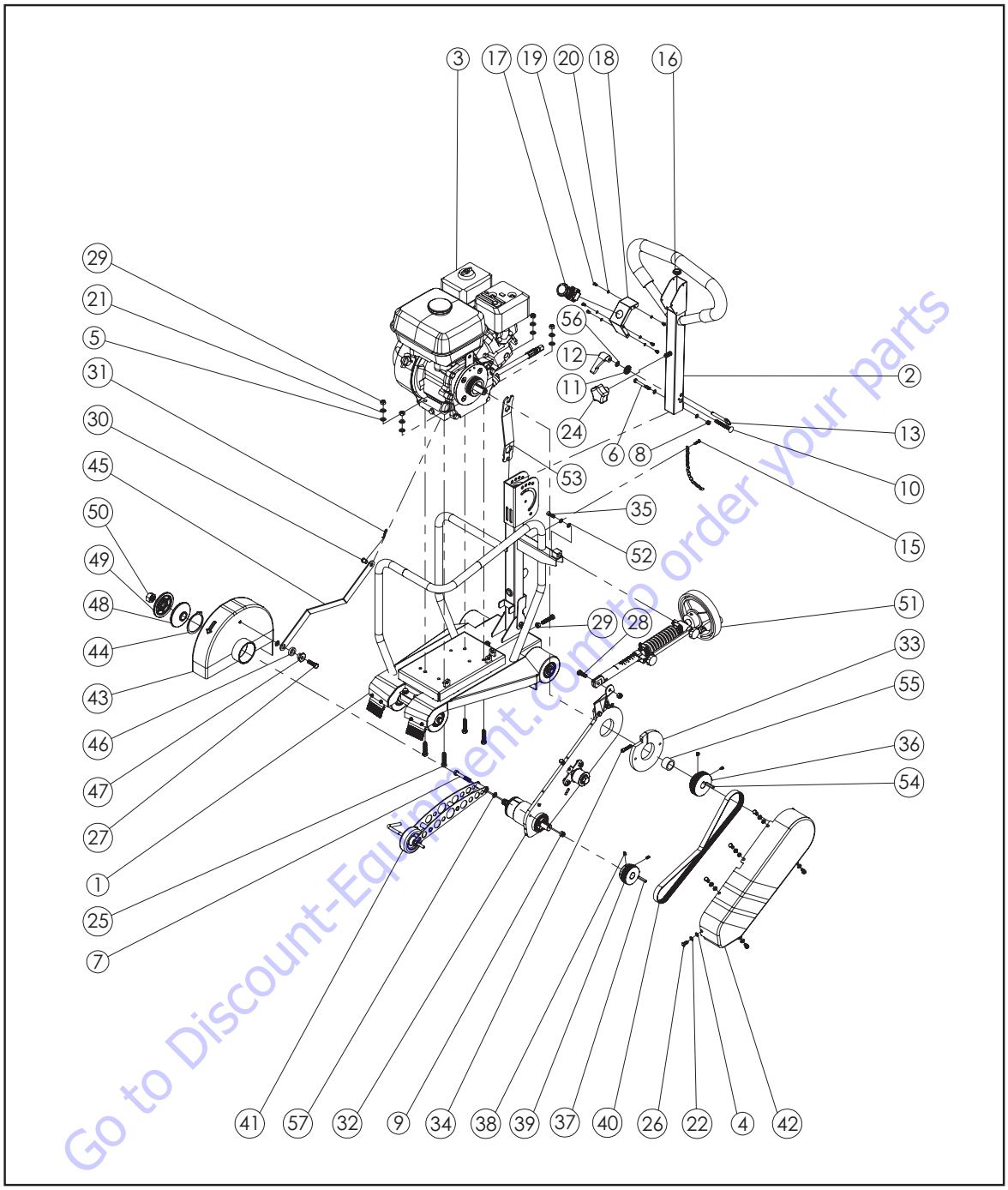
FRAME ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	FRAME GC55	1	241038
2	REAR POINTER GC55	1	241039
3	SCR M8 X 65 1.25 DIN931 HEX HEAD CAP	1	241040
4	WASHER M8 DIN125 FLAT	6	232110
5	WASHER M4 DIN125 FLAT	16	235104
6	NUT M8 1.25 LOCK DIN985	3	241041
7	NUT M4 0.7 LOCK DIN985	8	241042
8	GROMMENT GC55	1	241043
9	WHEEL W/BEARING GC55	4	241044
10	WASHER M8 X 24MM OD DIN9021B	4	241045
11	WASHER LOCK M8 DIN127	8	300245
12	SCR M8 X 20 1.25 DIN933 HEX HEAD CAP	6	235013
13	SCR M4 X 12 0.7 DIN933 HEX HEAD CAP	8	235103
14	SCR M8 X 65 1.25 DIN931 HEX HEAD CAP	1	241040
15	FRONT AXLE GC55	1	241046
16	SCR M8 X 35 1.25 SOCKET HEAD CAP DIN912	2	241047
17	BRUSH WHEEL OPERATOR'S RIGHT GC55	1	241048
18	BRUSH WHEEL OPERATOR'S LEFT GC55	1	241049
19	SQUEEGEE ASSEMBLY ONLY GC55	1	241050



FRONT POINTER ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	POINTER WELDMENT GC55	1	241085
2	WHEEL 75X28X8mm	1	241086
3	FRONT POINTER ROD GC55	1	241087
4	WASHER M8 DIN125 FLAT	2	232110
5	NUT M8 1.25 LOCK DIN985	2	241041



MAIN ASSEMBLY

MAIN ASSEMBLY

Item	DESCRIPTION	Qty	Part No
1	FRAME ASSY – SEE PG 26 FOR PARTS	1	-NA-
2	HANDLE BAR GC55	1	241052
3	ENGINE ASSEMBLY – SEE PG 25 FOR PARTS	1	-NA-
4	WASHER M6 DIN125 FLAT	8	27539
5	WASHER M8 DIN125 FLAT	6	232110
6	SCR M6 X 55 1.0 DIN933 HEX HEAD CAP	1	241011
7	SCR M8 X 60 1.25 DIN933 HHC FULL THD	1	360146
8	NUT M6 DIN985 LOCK	1	235136
9	NUT M8 1.25 LOCK DIN985	2	241041
10	SCR 5/16-18 UNC X 2-1/2" CARRIAGE BOLT	1	241054
11	WASHER 3/8 WAVE	1	241055
12	KNOB M8 X 1.25 ADJUSTABLE	1	241054
13	PIN QUICKRELEASE 5/16" X 2" GRIP LENGTH	1	241055
14	CHAIN FOR QUICKRELEASE PIN 9" LONG GC55	1	241056
15	SCR NO18-18 X 3/4" SELF DRILLING ROUND HEAD	1	241057
16	GROMMENT GC55	1	241058
17	SWITCH EMERGENCY STOP GC55	1	241059
18	SWITCH PANEL GC55	1	241060
19	SCR M4 X 8 0.7 DIN966 PHILIPS	6	235099
20	WASHER LOCK M4 DIN127	6	241030
21	WASHER LOCK M8 DIN127	4	300245
22	WASHER LOCK M6 DIN127B	7	300279
23	DIAMOND BLADE CONTACT CUSTOMER SERVICE	1	Contact Customer Service
24	KNOB W/THREADED HOLE M10 X 1.5 X 50mm DIA	1	241061
25	SCR M8 X 40 1.25 DIN933	5	235009
26	SCR M6 X 14 1.0 DIN933	6	241062
27	SCR M8 X 30 1.25 DIN933	1	241063
28	SCR M8 X 25 1.25 DIN933 HHC FULL THD	1	300323
29	NUT M8 1.25 DIN934 HEX	5	300273
30	PIN CLEVIS 9.5MM D X 11L - 6.9MM USABLE LENGTH	1	241064
31	HAIR PIN COTTER 1/4 TO 1/2 DIA X 0.062 X 1-5/16L	1	241065
32	CUTTING HEAD ASSEMBLY GC55 – SEE PG 22 FOR PARTS	1	-NA-
33	COLLAR LOCK GC55	1	241067
34	SCR M6 X 30 1.0 DIN912 SOCKET HEAD HEX	1	241068
35	SCR M6 X 20 1.0 DIN912 SOCKET HEAD HEX	1	241069
36	PULLEY 70MM D X 3/4B 6G J SECTION	1	241070
37	KEY 3/16X3/4	1	9201074

MAIN ASSEMBLY

Item	DESCRIPTION	Qty	Part No
38	SCR M5 X 10 0.8 DIN916 CUP POINT SET SCREW	4	241027
39	PULLEY 56.5MM D X 3/4B 6G J SECTION	1	241071
40	BELT 350J6 - J SECTION 6 GROOVE	1	241072
41	FRONT POINT ASSEMBLY GC55 – SEE PG 27 FOR PARTS	1	-NA-
42	BELT GUARD GC55	1	241074
43	BLADE GUARD ASSEMBLY GC55 – SEE PG 21 FOR PARTS	1	-NA-
44	RETAINING RING C-STYLE 60mm X 2.0mm DIN471	1	241076
45	ARM STAY LEVEL GC55	1	241078
46	SPACER M14	1	241079
47	CAM STAY LEVEL GC55	1	241080
48	LOOSE COLLAR GC55	1	241081
49	TIGHT COLLAR GC55	1	241082
50	NUT 5/8-11 UNC HEX LEFT HAND THREAD	1	241083
51	DEPTH CONTROL ASSEMBLY GC55 – SEE PG 24 FOR PARTS	1	-NA-
52	WASHER M6 DIN 125 FLAT	1	27539
53	WRENCH UNIVERSAL	1	233041
54	KEY 3/16X1 1/4	1	9201080
55	SPACER SHAFT GC55	1	241088
56	WASHER M8 DIN125 FLAT	1	232110
57	WASHER M8 DIN125 FLAT	1	232110

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NORTON®

Clipper

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints,
- Crystalline silica from bricks and cement and other masonry products, and
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.