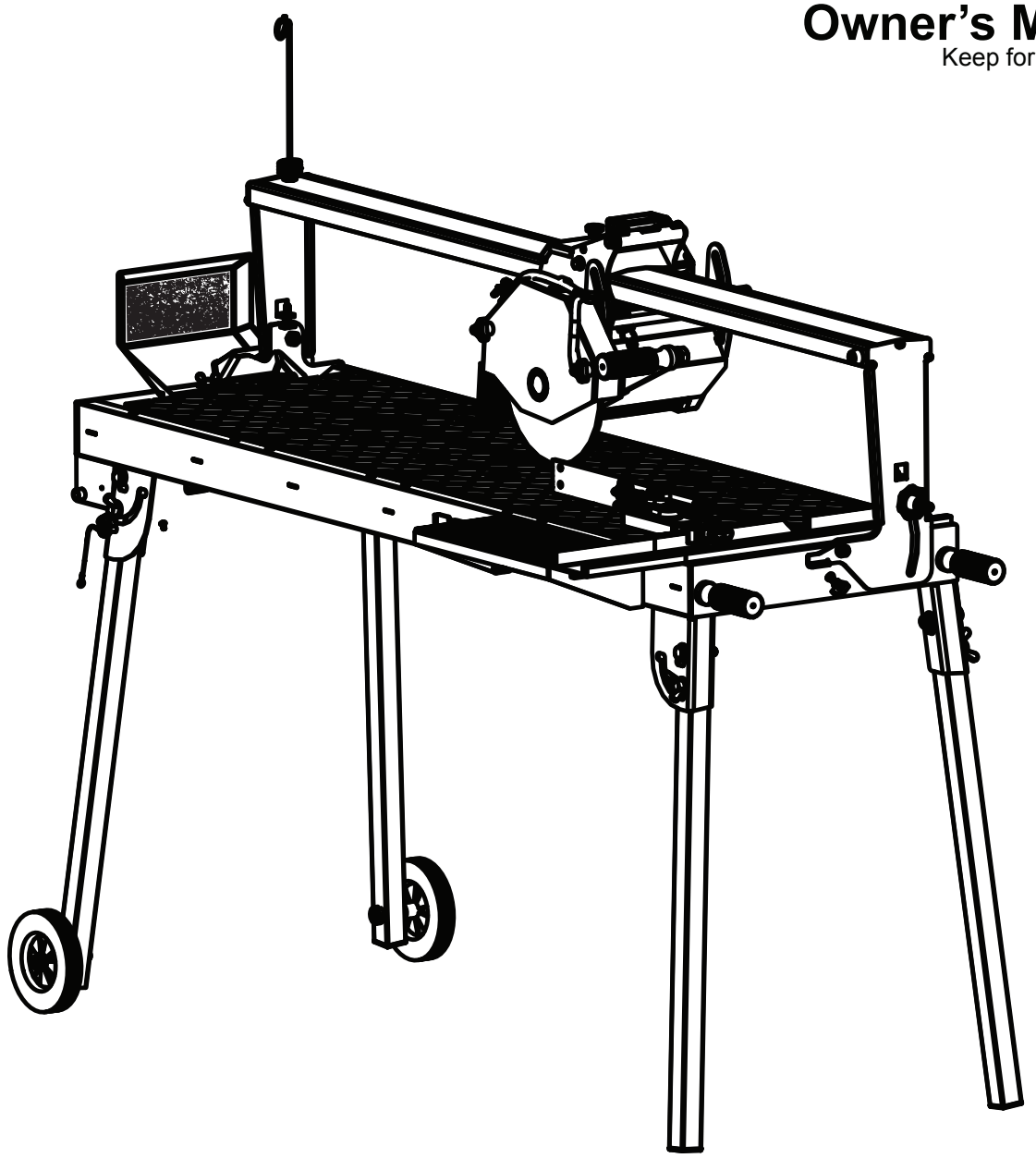
R1048

WET TILE SAW

SAWMASTER

Owner's Manual

Keep for your records



ATTENTION!

Read safety and operating instructions carefully before operating the saw for the first time. Retain manual for future reference.

2018.04.26

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Safety Precautions

⚠ WARNING

A. Saw blade should be inspected daily for excessive wear, core cracks and arbor damage. Replace any blade that shows signs of damage.

B. To mount the blade, clean the arbor and outer flanges, and tighten the nut securely.

C. DO NOT place any portion of your body in line with the blade while it is rotating.

D. Wet cutting blades MUST be used with water.

E. To reduce the risk of electrical shock, we recommend the use of GFCI and to refer servicing to a qualified professional.

F. When operating the saw, be sure to wear proper safety gear, such as safety glasses, dust mask, and hearing protection. A hard hat is also recommended.

G. Never use the machine improperly or work in an unsafe manner.

H. Maintain alertness while operating the machine. Failure to maintain attention, by the operator, may lead to serious injury.

I. Keep work area clean.

J. Before you start working, familiarize yourself with the work site and its surroundings. Take notice of circumstances which may impede work or traffic, observe soil conditions (good bearing or not) and take measures to ensure safety (e.g. the shielding of roadworks from public traffic).

K. Take measures to ensure that the machine is in a safe and trouble-free condition prior to usage. Use the machine only when all protective devices (i.e. guards, noise absorbers, emergency-off devices) are in place and in working order.

L. A visual check of the machine must be made at least once a shift to ensure that visible damages or faults are recognized. Any changes (including changes in the performance or behavior of the machine) must be reported to the supervisor. If necessary, stop the machine at once and secure it.

M. In the case of a malfunction, stop the machine immediately and secure it. Fix the problem as soon as possible.

N. To stop and start the machine follow the operating instructions and observe any indicator lights.

O. Keep out of reach of children. Before operating machine, be sure the activated machine will be of no danger to anyone.

P. Be sure to connect the plug to a properly grounded receptacle to reduce the risk of electric shock.

Q. Wear proper apparel. Do not wear loose clothing or accessories. Keep hair and body parts away from openings and moving parts.

R. If cord/plug is damaged do not operate.

S. Make sure power switch is in "off" position before plugging in power cord to prevent any accidental activation.

T. When machine is plugged in do not leave it unattended. Unplug prior to servicing, when changing accessories, and when not in use.

U. Never carry machine by cord. Do not pull cord to unplug. Keep cord away from heat, sharp edges and oil.

V. Do not operate the machine when you are tired or while under the influence of drugs, alcohol or any medication.

W. Never operate this unit when flammable materials or vapors are present. Electrical devices produce sparks or arcs which can cause a fire or explosion.

X. When using an extension cord, make sure it is in good condition and heavy enough to carry the current drawn by the machine. Refer to the extension cord table in the "Electrical Specifications" section for the correct gauge depending on the desired cord length and the machine's horse power and voltage.

General Safety Rules

- Never use the machine improperly or work in an unsafe manner.
- Always wear safety goggles, dust mask, and ear protection while operating saw (to comply with ANSI-Z87.1)
- Always remain alert when the saw is in use. Failure to pay attention on the operator's part may lead to serious injury.
- Before you start working, familiarize yourself with the work site and its surroundings. Take notice of circumstances which may impede working or traffic, observe soil conditions (good footing or not), and take measures to ensure safety (i.e. the shielding of roadworks from public traffic).
- Take measures to ensure that the machine is in safe and trouble-free condition prior to usage. Use the machine only when all protective devices (i.e. guards, noise absorbers, emergency-off devices) are operating in the intended locations.
- A visual check of the machine must be made at least once a shift to ensure that visible damages or faults are recognized. Any changes (including performance or behavior of the machine) must be reported to the supervisor. If necessary, stop the machine at once and secure it.
- In the case of a malfunction stop the machine immediately and secure it. Fix the problem as soon as possible
- For starting and stopping the machine follow the operating instruction steps and observe any indicator lights, if applicable.
- Before switching the machine on, make sure that the to be activated machine will be of no danger to anyone.
- Be sure to connect the plug to a properly grounded receptacle to reduce the risk of electric shock.

Health Warning

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

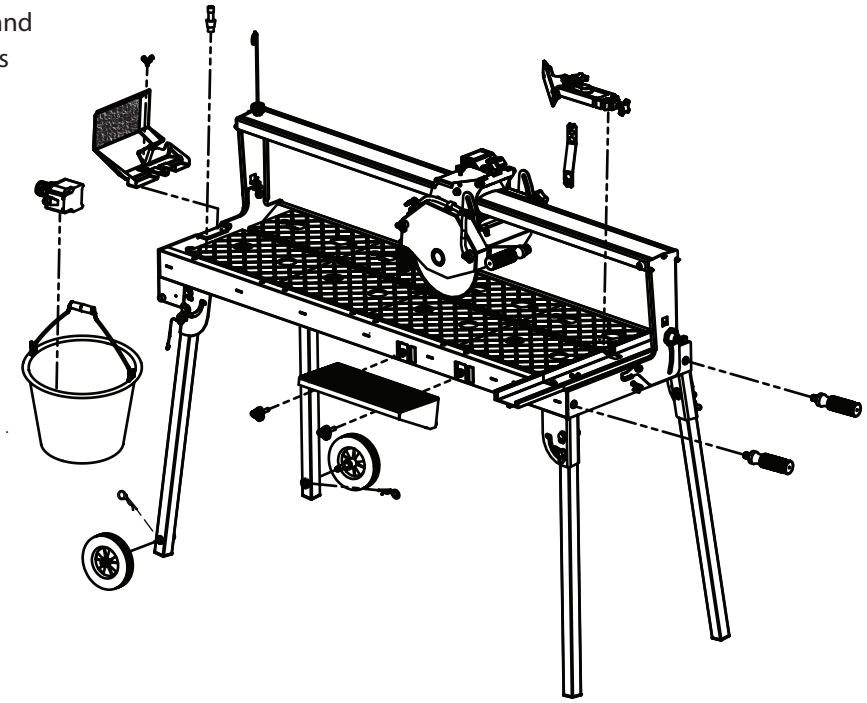
- Lead from lead-based paints,
- Crystalline silica from bricks, cement and other masonry products, and
- Arsenic and chromium from chemically-treated lumber.

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.

Unpacking

Open the carton box cover by lifting the top portion. Locate the accessory box and check its content for the following items before discarding any packaging:

- Saw
- Pin (2)
- Universal Wrench
- Water Pump
- Wheel Assemblies (2)
- Owner's Manual
- Drain Plug
- Rear Splash Guard
- Wing Screw
- Extension Table
- Knobs (2)
- Lifting handles (2)
- Masonry guide
- Bucket



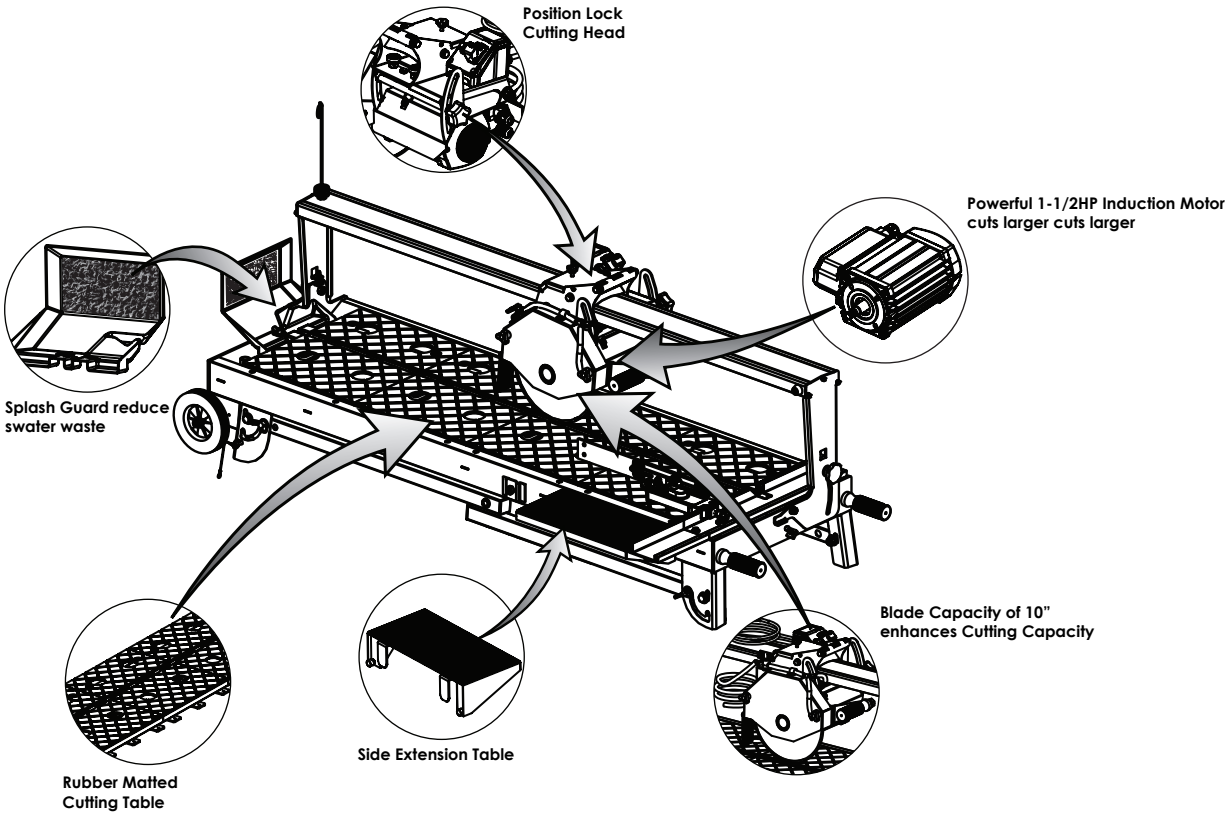
Proceed to the following section to complete assembly of the saw.

Assembly & Set-up

1. Remove the carton box cover by lifting the upper cover.
2. Locate the accessory box and open it. Obtain the two lifting handles and install one on each end of the saw. Install it in the side furthest from the post.
3. Loosen the lock knob on top of the cutting head.
4. Deploy the stand legs by following the "folded leg assembly" section.
5. Install the side extension table, side splash guard and back splash guard.
6. Install the spring holder on top of the sliding rail to hold the power cable and the water hose.
7. Fill the tray with water before operating the saw.

Features

These saws are professional saws for cutting floor tiles, paving stones, stairs, large-sized natural stones, and similar materials.

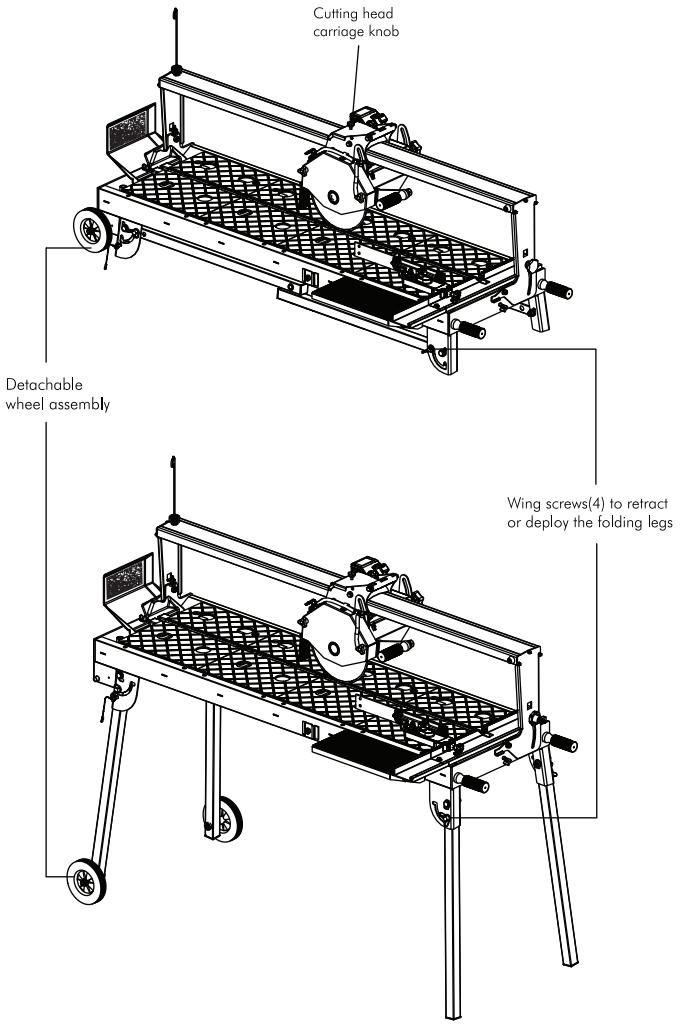


Specifications

R1048					
Motor	**Max Blade Capacity**	**Cutting Length**	**Cutting Depth**	**Weight**	**Dimensions**
1-1/2 HP 115 V/60 Hz 3200 RPM	10-in blade for 5/8-in arbors	48-in, Diagonal cut 34-in tile	2.4-in	182 lbs	Length: 56.4-in Width: 22-in Height: 23-in

* Dimensions do not include extension tables and drip trays.

Saw Stand Assembly



FOLDING STAND

1. It is recommended that adjusting the folding leg be done by at least two people.
2. Remove the detachable wheel assembly and stow it on the frame.
3. Shift the cutting head away from the end of the frame where the leg is being adjusted. Tighten the cutting head carriage knob to hold the head in place.
4. Loosen the knob that is locking the leg in place.
5. Lift the saw slightly to give the leg room to rotate into stow/deployed postion.
6. Slide the leg in place and tighten the knob.
7. Repeat steps 2-4 as required to the remaining legs.

EASY TRANSPORT

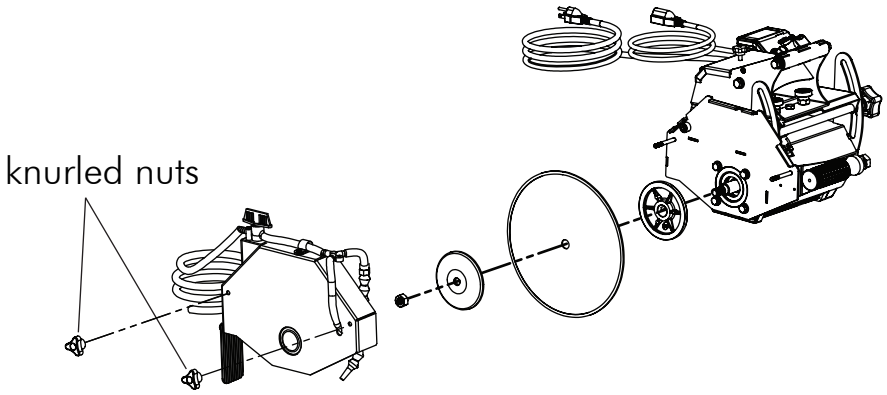
1. It is recommended that adjusting the folding leg be done by at least two people.
2. Remove the detachable wheel assembly and stow it on the frame.
3. Shift the cutting head away from the end of the frame where the leg is being adjusted. Tighten the cutting head carriage knob to hold the head in place.
4. Loosen the knob that is locking the leg in place.
5. Lift the saw slightly to give the leg room to rotate into stow/deployed postion.
6. Slide the leg in place and tighten the knob.
7. Insert the detachable wheel assembly in either the frame/leg position depending on need.
8. Make sure the head is on the side closest to the wheels before transporting the saw.

Blade Installation

⚠ WARNING:

Disconnect the power plug before installing the blade onto the blade shaft.

1. Loosen the knobs securing the blade guard and remove the guard.
2. Loosen the cutting shaft nut (left-hand thread); while loosening the nut, block the cutting shaft from turning.
3. Remove the blade clamping flange. Check that the contact area between the blade holder assembly and the diamond saw blade is clean.
4. Install the saw blade on the supporting flange. Ensure the blade rotation arrow matches the clockwise rotation of the saw blade shaft.
5. Install the blade clamping flange.
6. Re-tighten the cutting shaft nut. Block the cutting shaft from turning while tightening the nut.



7. Lightly turn the installed saw blade by hand and check the blade for true running.
8. Mount the blade guard.

⚠ WARNING:

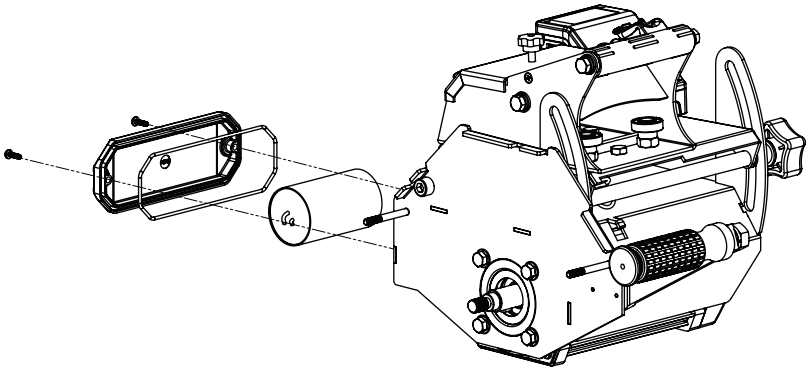
Setting the blade too low may damage the cutting table and if set too high, the blade may grab the material being cut, causing damage and possibly injury.

Motor Capacitor Installation

⚠ WARNING:

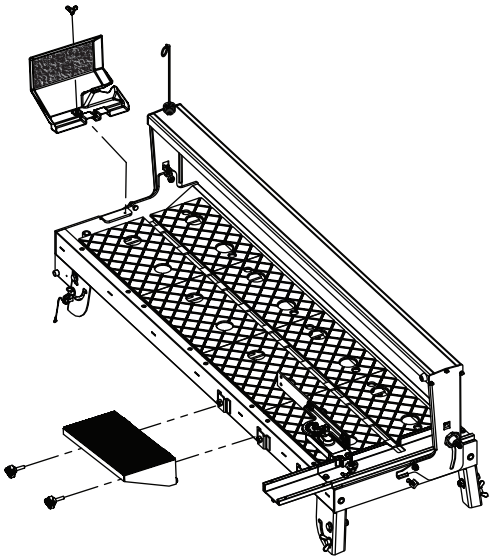
Disconnect the power plug before servicing the motor

1. Locate the aluminum housing on the side of the motor body.
2. Using a phillip/cross screw driver to remove the two screws to open the capacitor housing cover.
3. Pull the capacitor out and remove the two wire caps to disconnect the wires.
4. Replace the old capacitor with the new capacitor and reattach the wires using the same wire caps.
5. Close the capacitor cover and make sure the rubber gasket is properly in place so no water can seep into the housing.



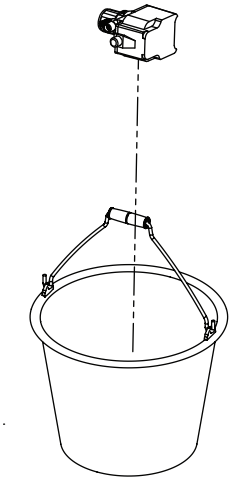
Side Table & Splash Guard Installation

Install the side table and splash guard as shown in the illustration to the side. Fasten the knobs/screws respectively to the saw frame.



Water Pump Installation

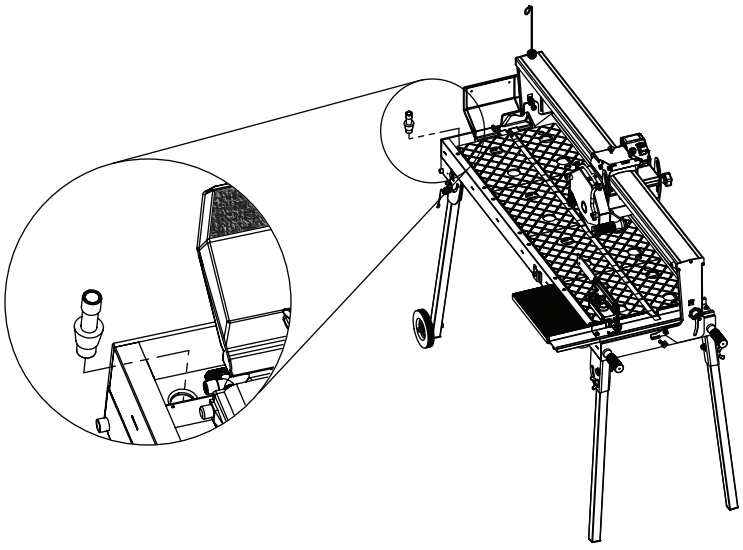
1. Remove the water pump from the box and check that it is not damaged.
2. Place the water pump into the bucket and place the bucket underneath the water drain hole on the water tray.
3. Position the water outlet of the pump so that it lays horizontally. Connect the water hose from the blade guard to the water pump.
4. Plug the power cord into the 3-prong receptacle coming from the power switch housing.



Overflow Plug Installation

A tube at the rear end of the saw filters the debris from the water produced during the cutting operation. Debris settles in the water tray while the water is allowed to pass through the tube and into the water bucket, where fresh and filtered water reside.

1. Remove the water level tube from the plastic bag.
2. Insert the thin end of the tube into the rear hole next to the water pump, as shown in the illustration.
3. Fill the water tray with water.

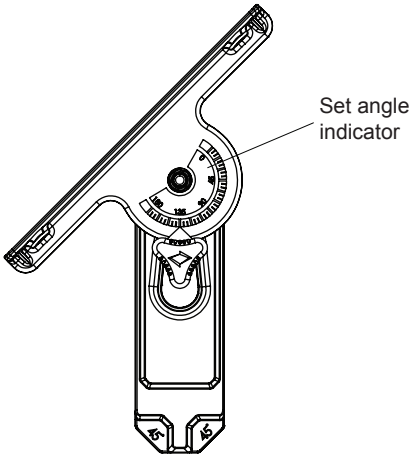


⚠ WARNING:

Disconnect the water pump before attempting to handle it. Never operate the pump without water in the tray.

The Adjustable Angle Guide

The Adjustable Angle Guide is a two-piece assembly consisting of a base and an attachment that rotates. This guide will support cutting angles between 0°, 22.5°, 30°, 45° and many more. The attachment has a casted angle indicator that show what angle the Angle Guide is currently set to support.



⚠ WARNING:

Always lock the Adjustable Angle Guide prior to transporting the saw.

Operating The Saw

1. After you have made yourself familiar with the components of your saw, the machine has been properly set up, the bucket or water tray is filled with water, and the electrical connection is established in accordance with the relevant safety regulations, you may now begin with the cutting operation.
2. Before you start operation open the water shut-off valve.
3. During the operation, the user must stand in front side of the saw pulling on one of the two handles of the cutting head when cutting. The workpiece must rest on the work table and should be pressed tightly against the cutting fence on the table.
4. Always turn off the saw before you leave the machine unattended.

Operating The Saw :continued

5. Prevent accidental restarting of the saw by unplugging the power cable.

CUTTING AT CONSTANT DEPTH

When cutting at constant depth the cutting head must be pulled against the work piece. The motor should be turned off when adjusting the cutting depth.

1. Before starting the cut, hold the current depth by firmly grasping the plunge handle extending from the blade guard. Set the cutting head at the desired cutting depth by first loosening the depth control knob on the side of the cutting head where the switch box is located.

2. Adjust the head to the blade depth/clearance desired. Tighten the depth control knob.

3. Put the workpiece securely on the cutting table. Have it positioned to achieve the desired cut.

4. Turn on the saw and slowly and uniformly pull the head along the guide rail and across the workpiece.

5. Slowly return the cutting head to the original starting position and turn off the motor.

PLUNGE CUTS

The handling of long or partial cuts can be made using the plunge cutting method. In this case, the cutting head will not be set to a fixed cutting depth/clearance while performing a cut. The cutting head is freely movable during seesaw cutting operations.

1. Before starting the cut, the cutting head must be fully raised. Be sure to grasp the plunge handle extending from the blade guard. Loosen the depth control knob on the side of the cutting head where the switch box is located.

2. Set the workpiece securely on the cutting table. Have it positioned to achieve the desired cut.

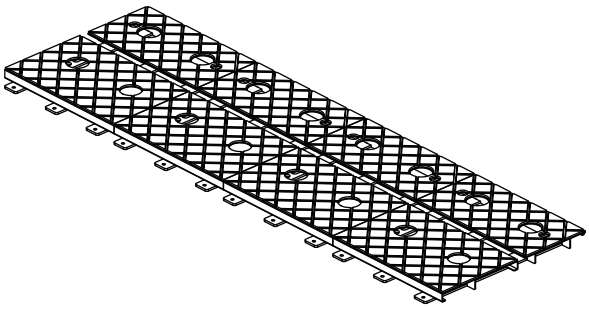
3. With the head fully raised, move to the desired start of cut along the path of the blade. Plunge the head and pull until the desired cut is complete.

4. Slowly return the cutting head to the original starting position and turn off the motor.

The Cutting Table

FEATURES

- The easily removable cutting table is covered with an anti-skid rubber coating, which allows the material being cut to sit on the table while the cutting head is pulled through it.
- Simply line up the material being cut with the appropriate pre-marked lines on the cutting table.



STEPS TO MAKE MITER CUTS:

1. The bench saw is equipped with a hinged guide rail that allows the user to make accurate miter cuts.
2. To pivot the guide rail, lightly loosen the knobs at both ends of the saw.
3. Set the rail to the desired angle by using both hands to firmly hold the rail and rotating it. While still holding the rail at the desired angle, tighten each knob.

⚠ WARNING:

Turn off the saw before pivoting the guide rail. Do not attempt to pivot the rail mid-cut. The saw blade must be clear of the material being cut and the saw must be turned off first!

Cutting Depth

The recommended cutting depth is 1/4” below the cutting table surface. The cutting clearance has been fixed from original design.

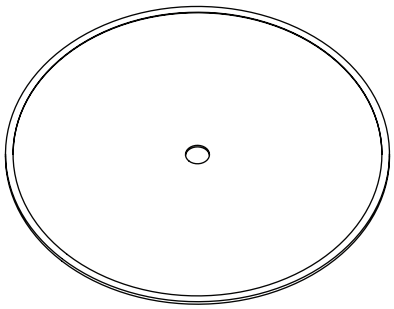
Blade Diameter	Cutting Depth
8”	1.4”
10”	2.4”

⚠ WARNING:

Setting the blade too low may damage the cutting table and if set too high, the blade may grab the material being cut, causing damage and possibly injury.

Choosing The Right Blade

1. The blade shaft speed of this saw is exclusibely designed for cutting with diamond saw blades. The saw may only be used for cutting natural and artificial stone materials, do not cut wood or metal!
2. The saw uses diamond saw blades with diameters up to 10”. Saw blades with larger diameters must NOT be installed on the saw.
3. Choose the correct type of saw blade for the material to be cut and the required cutting depth.



Electrical Specifications

	R104B
Power	1-1/2 H.P
Volts	115 V
Amps	15 Amps
Motor RPM	3450 RPM
Cycle	60 Hz
Phase	1

EXTENSION CORD CHART

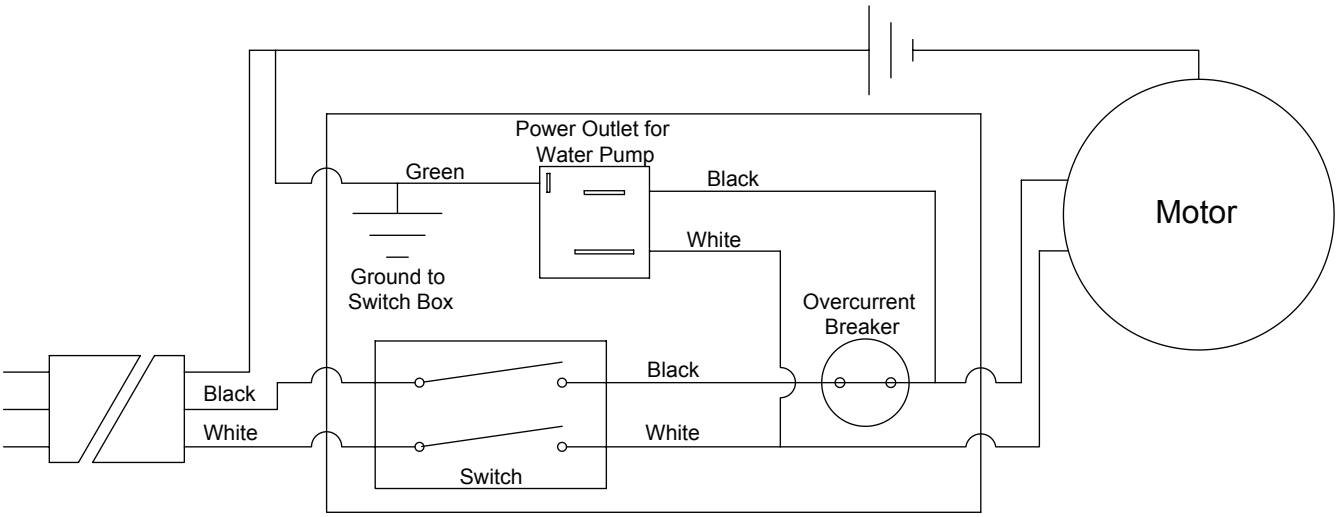
Wire Gauge	Length of Cord
No. 12	25'
No. 10	50'
No. 8	75'

⚠ WARNING:

To avoid permanent motor damage you must use the correct extension cord. Never use more than one extension at a time. Follow the chart for proper size.

RECOMMENDED

- It is recommended that a 15 amp circuit be used while operating this saw. This will prevent any loss of power or interruption.
- Always plug saw as close as possible to the power source while operating. This will allow you to receive optimum electricity.



Power Switch Box

Do’s & Don’ts For Blades

Wet Cut Blades

DO'S	DON'TS
• Inspect blades daily for cracks or uneven wear. • Always use appropriate blade for material being cut. • Inspect arbor shaft for uneven wear before mounting blade. • Always use blades with the correct arbor shaft size. • Ensure that blade is mounted in the correct direction. • Secure the blade to the arbor with a wrench. • Use proper safety equipment when operating the saw. • Periodically check the blade for cracks or bond fatigue. • Always have continuous flow of water on both sides of blade.	• Do not operate the saw without safety guards in position. • Do no operate the saw with blades larger than 10”. • Do not cut dry with blades marked “Use Wet”. • Do not exceed manufacturer’s recommeded maximum RPM. • Do not force blade into material. Let blade cut at its own speed.

Dry Cut Blades

DO'S	DON'TS
• In addition to the following, always follow wet recommendations. • Use appropriate blade for material being cut. • Inspect segment blades for segment cracking or loss. • Do not use damaged baldes. • User proper safety equipment when operating the saw.	• In addition to the following, always follow wet recommendations. • Do not make long cuts with dry blades--allow them to air cool. • Do not use the edge or side of blade to cut or grind. • Do not attempt to cut a radius or curve. • Do not cut too deep or too fast into the material. • Do not cut any material not recommended by blade manufacturer.

Saw Maintenance

⚠ WARNING:

For your safety, before performing any maintenance on the saw turn off the power switch and unplug the power cord.

GENERAL RULES

- Always clean the machine before maintenance/repair.
- Before cleaning/maintaining/repairing the machine, the machine must be turned off and unplugged.

Steps to Follow When Cleaning the Saw

1. Please do not use aggressive cleaners (i.e. containing solvents). Do not use high-pressure water jets, aggressive detergents or solutions and liquids with a temperature exceeding 86 F! Use fluff-free cloth only.

2. Use a cloth which may be lightly moistened only for removing dust and dirt. Hard packed dirt can be removed with a soft brush.

3. For the sake of safety, water/cleaning liquid/vapor may penetrate into the electric motor, connectors/plugs, switches, etc. therefore cover/seal all aperatures, holes in the housing, connectors, plugs, with adhesive tape.

4. Use a soft, low-pressure water jet and a brush to rinse dirt and incrustations away. Be particularly careful when near hazardous parts of the machine (i.e. switch, motor, etc...). Clean the vulnerable parts with a moist fluff-free cloth.

5. Do not “rinse” the bearings of the drive elements to prevent them from running dry. The ball bearings of the machine are permanently lubricated.

6. After cleaning, remove all areas that were covered/seal by tape! All screws/nuts which you may have loosened must be tightened again!

7. After wet cleaning, plug the machine to a power outlet which is equipped with a ground fault current interrupt. If the device cuts power, the machine must be inspected by an authorized dealer prior to use!

Maintenance Steps to Follow when Cleaning the Saw after Use

After use of the saw	- Remove dirty water from water tray/container. - Remove dirt and mud from the bottom of the container. - Rinse the water pump with fresh water to prevent clogging from residual dirt.
After wet cleaning the saw and before use	- Connect the machine to a ground fault current interrupt (i.e. GFCI) power outlet. If the device cuts off the electrical power supply, do not try to operate the machine but have it checked by an authorized dealer.

⚠ WARNING:

For your safety, before performing any maintenance on the saw turn off the power switch and unplug the power cord.

Before & After A Prolonged Time

Before not using the machine for a prolonged period of time	· Clean and lubricate all movable parts. DO NOT GREASE the GUIDE RAILS.
After not using the machine for a prolonged period of time	· Check that the legs are safely fixed. · Check that all screw and nut points are tightened correctly. · Check that the roller table is rolling on the rails and that it moves securely back and forth. With the saw blade removed, switch on the motor for an instant and switch it off again. If the motor does not run, have the machine inspected by a qualified electrician. · Check that the immersion pump works properly. Turn on the valve if applicable and switch the machine on. If the pump does not give any water or only a little, switch the machine off at once. Clean the pump, or replace it if necessary.

Temperature Changes

Ambient Temperature Below 37 F (Winter)	· To prevent the water in the pump and cooling system from freezing, remove the water after using the machine or when there will be a long break. Make sure that the cooling system is entirely drained so that there is no water left inside the pump, the bearing house and the water hose!

⚠ WARNING:

For your safety, before performing any maintenance on the saw turn off the power switch and unplug the power cord.

Water Pump Maintenance

When the machine has not been used for a long period of time, hard packed dirt may build up inside the pump and block the pump fan from rotating. If the machine is activated with the fan blocked, the electric motor inside the pump will overheat within a few minutes! Please follow the steps listed below to clean the pump before operating the saw.

1. Unscrew the pump filter.
2. Remove the water pump from the water tray/container.
3. Clean the water pump exterior.
4. Clean the interior where the fan is by removing the fan cover. If gasket is installed, be careful not to damage it.
5. The fan can be removed by using pliers to pull it off. Careful not to damage the fan or the motor shaft. With it removed, the entire volute can be cleaned easily.
6. Spin the pump shaft by hand. It should rotate almost effortlessly. Then press the cleaned fan back onto the blade. Note to align the shaft geometry with that of the blade bore before pressing it back on. Do not press the fan too far down the shaft or it may not rotate. Spin the fan blade by hand to confirmit can spin effortlessly.
7. Reassemble the fan cover.
8. Plug the water pump in briefly to check whether it works properly.

Alignment Instructions

⚠ WARNING:

For your safety, before performing any maintenance on the saw turn off the power switch and unplug the power cord.

Instructions:

Performing a Realignment of a R1048 Reminder:

- Always unplug unit before servicing.
- Adjust the cutting head such that the blade passes through the table, not over.

There are three ways to adjust the 1048's alignment:

1. Cutting fence.
2. Bridge.
3. Cutting head.

Note: Usually adjustment method 1 and 2 are the most common.

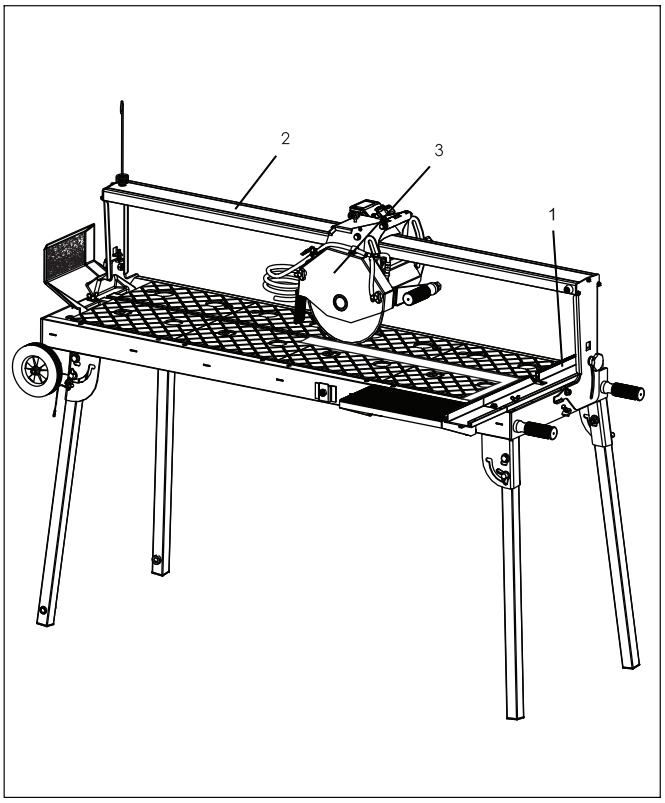


Fig. 1 3D view

Method 1:

1. Loosen the bolts that secure the cutting fence.
2. Using a steel square, as shown in Fig. 1, align the square's long arm with the blade. Both the front and the rear end of the blade's rim should have contact.
3. Adjust the cutting fence such that the fence face sits flush with the steel square's short arm.
4. Now move the cutting head back and forth, along the bridge, to check for consistent blade contact with the steel square. Make sure the short arm does not move during this process. Interference from the blade may move the steel square away from the cutting fence.

Method 2:

1. Loosen the bolts that secure the bridge (Fig. 2). DO NOT REMOVE THE BOLTS AS THE BRIDGE AND CUTTING HEAD WILL FALL.
2. Repeat steps listed in method 1 to align the fence.
3. Now if the cutting fence does not move enough to align the cutting head, the bridge may be shifted as shown in the top-left illustration in the next page.

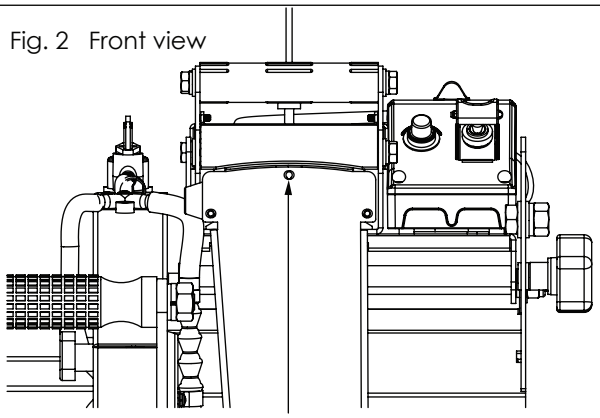


Fig. 2 Front view

The post holes allow movement of the birdge +/- 0.5mm in either the left or right direction.

Adjustment range of the bridge/rail

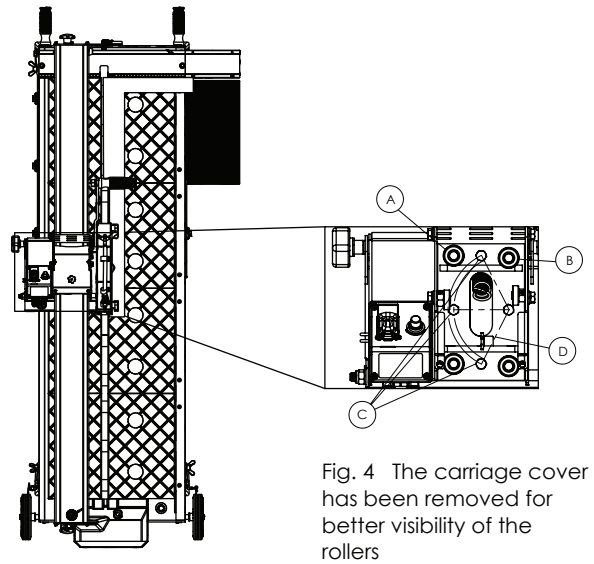


Fig. 4 The carriage cover has been removed for better visibility of the rollers

Fig. 3 Top view

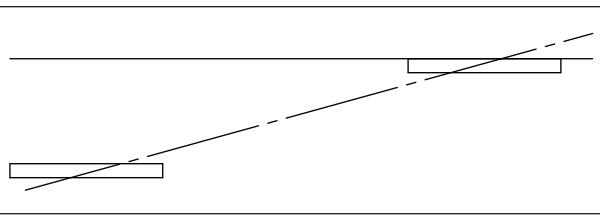


Fig. 5 Blade shifting

Method 3:

1. Underneath the carriage cover is four bolts (size 13 wrench) that hold the head's two sub-assembly together. The upper assembly is the carriage and the lower assembly is the actual cutting head. The three bolts highlighted by the balloon "C", in the mid-left illustration are the actual bolts that need to be loosened. Only loosen the bolts enough that the lower sub-assembly can move, changing the blade shaft's orientation. The fourth bolt is the pivoting bolt and does not have to be loosened.

2. If the blade is constantly shifting left, using Fig. 4 as reference, the cutting head must be rotated counter-clockwise (left).

3. If the blade is constantly shifting right, using Fig. 4 as reference, the cutting head must be rotated clockwise (right).

Note: The cutting head should glide effortlessly across the bridge. Should the head be too tight or too loose, adjust the rollers on the left (A) using a size 17 wrench to rotate it. Rollers on the right (B) are fixed so they cannot be adjusted.

Fig. 5 depicts how aligning the blade with the steel square does not always mean the head is aligned with the bridge.

1. The solid line represents the steel square.
2. The dotted line represents the bridge and ACTUAL travel direction of the cutting head.
3. The rectangular box represents the blade/cutting head orientation.

As the user pushes/pulls the cutting head if the cutting head is not properly aligned with the bridge, the blade will always moves away from the steel square.

Troubleshooting

Problem	*Possible Cause*	*Solution*
Machine does not run when switched on	Power cord not properly fixed/ plugged in	Check that the machine is properly connected to the power supply
	Power cord defective	Have the power cord checked, replace if necessary
	Main power switch defective	Have the main power switch checked and replace if necessary by a qualified electrician
	Loose electrical connection inside the electric system	Have the whole electric system of the machine checked by a qualified electrician
	Motor defective	Have the motor checked and replaced if necessary by a qualified technician
Motor stops (power cut out)	Too much pressure exerted while cutting	Exert less pressure when cutting
	Incorrect specification for saw blade	Use a saw blade which corresponds to the material being cut
	Saw has a defective electric system	Have the electric system of the saw checked by a qualified technician
Poor machine performance, little power	Power cord/extension cable too long or cable still wound up inside cable drum	Use a power cord/extension cable of the rated length, use a cable drum with cable fully extended
	Power network is insufficient	Observe the electrical ratings of the machine and connect it only to a power network which complies with these ratings
	Drive motor no longer runs at rated speed (RPM)	Have the motor checked by a qualified electrician and have it replaced if necessary

Problem	*Possible Cause*	*Solution*
Insufficient flow of cooling water or no cooling water at all	The pump draws air	Fill the container with water
	Filter clogged	Clean the filter of the pump
	Pump wheel of the immersion pump blocked by dirt	Disassemble the immersion pump and clean
Irregular run of the saw blade	Poor tension in the blade material	Return the saw blade to the manufacturer
Saw blade wobbles when running	Saw blade is damaged or bent	Have the saw blade aligned / flattened
		Clean the receiving flange
		Solder the diamond segments of the old blade onto another saw blade or use a new blade
	Flange of the saw blade is damaged	Replace the saw blade flange
	Shaft of the motor is bent	Replace the electric motor
Diamond segment becomes loose	Overheating of the saw blade; cooling water not sufficient	Have the diamond segment soldered on the blade again; ensure optimum flow of cooling water
Excessive wear	Wrong type of saw blade	Use harder saw blades
	Shaft of motor causes wobbling	Have bearings of the motor or the motor replaced
	Overheating	Ensure optimum flow of cooling water
Cracks in or near the diamond segment	Saw blade too hard	Use a softer blade
	Fixed flange is worn out	Replace the fixed flange
	Motor shaft bearing	Replace the bearing of the motor shaft

Problem	*Possible Cause*	*Solution*
Saw blade is blunt	Saw blade type is unsuitable for the material being cut	Use appropriate type of saw blade
	Saw blade type is unsuitable for the machine performance	
	Saw blade too hard	
	Diamond segments are blunt	Sharpen the diamond saw blade
Appearance of cut is not optimal	Poor tension in the blade material	Return the saw blade to the manufacturer
	Too much load placed on the saw blade	Use a suitable saw blade
	Diamond segments are blunt	Sharpen the saw blade
The center hole in the saw blade has become wider due to wear	The saw blade has slipped on the motor shaft when running	The arbor of the saw blade must be fitted with an appropriate adaptor ring
		Check the receiving flange and have it replaced if necessary
Saw blade shows blooming colors	Saw blade overheating due to a lack of cooling water	Ensure an optimum flow of cooling water
	Lateral friction when cutting	The material feed is too high; proceed more slowly
Grinding marks on the saw blade	Material is not being fed parallel to the saw blade	Ensure that the direction of feed is absolutely parallel to the saw blade
		Adjust the roller table or have it adjusted
	Poor tension in the blade material	Have the saw blade tensioned
	Too much load on the saw blade	The material feed is too high, proceed more slowly

Note

Warranty

SAWS

For a period of one (1) year from the original date of purchase, if the product is determined to be defective, SawMaster will repair or replace the product, at its option, at no charge to the customer, or pay the associated repair costs to an authorized service facility. All replacement parts, new or rebuilt, supplied at SawMaster's option for repairs will be warranted for the remainder of the original warranty period of one (1) year. All defective products or components replaced under this limited warranty will become the property of SawMaster. This limited warranty excludes all components not manufactured by SawMaster, which are listed below with their corresponding independent warranty periods. Such components are warranted by their respective manufacturer, whose warranty will be the governing warranty for that particular product.

EXCLUDED COMPONENTS	MANUFACTURER'S WARRANTY
Electric Motors	1 Year
Water Pumps	Varies by model. See accompanied warranty for details.

DIAMOND BLADES AND TOOLS

If the bond between the steel core and segment or rim fails during the normal useful life of the blade, SawMaster will replace the blade at no cost to the customer.

This warranty does not cover cosmetic damages or damages due to (1) misuse, abuse, negligence, accident, or modifications of the product or any of its components; (2) improper operation or failure to provide reasonable maintenance; or (3) attempted repair by any party other than a SawMaster authorized service facility. All products are subject to wear and tear under normal use. As such, the customer is responsible for all costs associated with the maintenance of said product, including the purchase of replacement components thereof.

To obtain warranty service, you must take the product, or deliver the product freight prepaid, in either its original packaging or packaging affording an equal degree of protection, to any authorized SawMaster service facility, along with proof of purchase in the form of a bill of sale, within the warranty period specified above. Warranty may be void if additional damages are incurred during transportation due to inadequate packaging.

SawMaster shall not be responsible for or obligated to pay for freight or other transportation related costs or expenses in connection with any defective products or components that are either returned to SawMaster's facility or any authorized repair station and/or any replacement products or components that are shipped from SawMaster pursuant to this warranty.

SAWMASTER SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR BREACH OF ANY EXPRESS OR IMPLIED WARRANTY, OR NEGLIGENCE. SUCH DAMAGES INCLUDE, BUT ARE NOT LIMITED TO, LOSS OF PROFITS, LOSS OF REVENUE, LOSS OF USE OF THE PRODUCT, AND DOWN TIME. SAWMASTER'S LIABILITY SHALL NOT EXCEED THE REPLACEMENT COST OF ANY DEFECTIVE PRODUCT OR COMPONENT THEREOF. THIS LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED.

EXCLUSIONS FROM WARRANTY

SawMaster cannot assume responsibility for claims arising from abuse of the product:

- Due to abuse by the purchaser in their processing.
- Due to improper installation practices or procedures.
- Due to abuse or improper usage by the end-user.
- Due to contaminants, including, but not limited to, exposure to salt or fresh water, chemicals and any other form of contamination from a source outside of Saw's control.

How to Order

INFORMATION NEEDED FOR ORDERING PARTS

- Serial number of the saw
- Model number of the saw
- When and where the saw was purchased
- Part number and description

TO ORDER

All parts may be ordered from your local dealer. If the part is not stocked locally, call our customer service department at 888-688-6899 or you may visit us at www.sawmaster.com.

PRICES

All orders are subject to prices and terms of sale in effect on date of shipment. Prices may change to reflect market trends in the industry, so that our products remain competitive in quality and pricing. As such, prices are subject to change without notice.

Promotional prices and discounts are subject to verification after order is placed. The customer will be notified if there are any errors found in pricing that affect the invoice amount.

DELIVERY & FREIGHT

Shipments are F.O.B. for orders of $1000.00 or more. Orders may include diamond blades and tools, saws, parts and accessories. All other orders not meeting this amount are subject to freight charges, which will be included on the invoice once it is determined.

SawMaster reserves the right to select origin of shipment, routing and method of transportation.

Premium freight charges (such as air freight) will be at the purchaser's expense (shipped collect or added onto invoice).

Products not in stock when order is placed will be shipped as soon as possible thereafter.

RETURN MERCHANDISE AUTHORIZATION (RMA)

No products are to be returned without prior written authorization and then only in accordance with the company's instructions and terms. Proof of purchase (e.g. copy of original invoice) along with serial numbers for all equipment should accompany all RMA requests.

All returned products must be in sellable condition, include all components, and be packed in original packaging. The RMA number assigned by customer service must be clearly marked on the accompanying packing slip. Any returns not satisfying these conditions will be promptly returned to the customer at their expense. The customer assumes all freight charges and is liable for the purchase value of any damaged goods.

Customer Service

AFTER SALE SERVICE

All customer service (e.g. technical questions, reordering of parts, etc.) will be provided by SawMaster. All spare parts for after sales service will be stocked and shipped from our warehouse.

CLAIMS FOR LOST OR DAMAGED GOODS

If merchandise is delivered in damaged condition or carton are missing, a notation must be placed on all papers signed by the receiver.

If unreported or concealed damages are noticed after delivery, the carrier should be contacted by telephone and if carrier fails to send an inspector within five days, a request should be made in writing to the carrier, confirming the telephone request for an inspection.

All requests for credit due to transportation loss or damage should be accompanied by properly signed papers. A claim for loss or damage must be filed with the carrier within 60 days from the shipping date for UPS or other common carriers. Credit cannot be allowed for damage claims that are not properly sustained with supporting papers or received by SawMaster too late for timely filing with the carrier.

Contact Us

We at SawMaster pride ourselves on our customer service. If you have any questions regarding our products, whether it may be product inquiry or troubleshooting, please don't hesitate to contact us. We will do our best to answer your questions. In some cases we may even refer you to a local sales representative that can better service you. You can call us at the contact information listed below:

CUSTOMER SERVICE

Phone: 888-688-6899 / 951-352-8887
Fax: 951-352-2118
Email: sales@sawmaster.com
Web: www.sawmaster.com