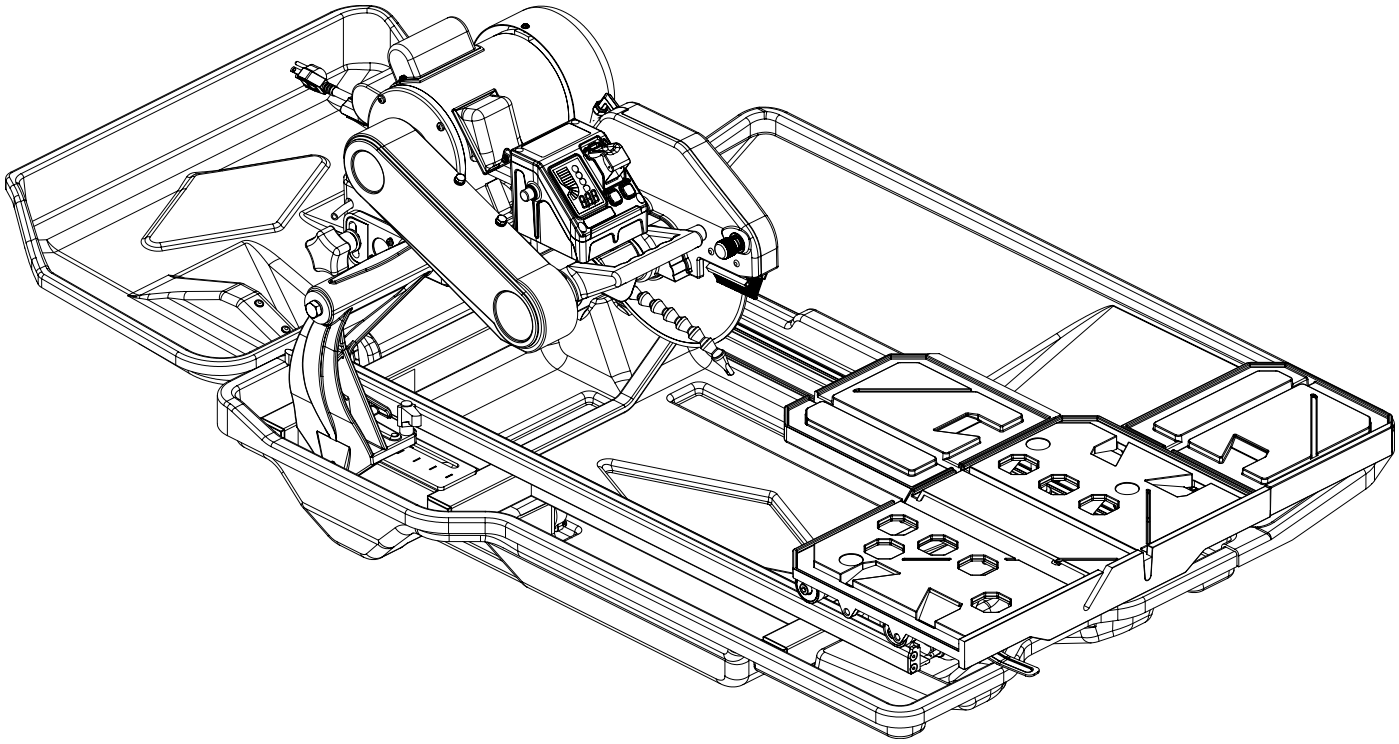
SDT-1030M2 / SDT-1030

Wet Tile Saw

SAWMASTER Diamond Tools, Inc.

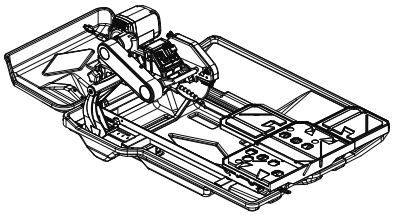
Owner's Manual

Keep for your records



ATTENTION!

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



SDT-1030 Model

Contents

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.

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 reproductive 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 container and carefully lift the saw by the foam packaging and place it on a flat, level working area. Be sure that you have the following items before you discard the container:

- Saw
- Plastic water tray
- Rear drip tray
- Rear extension table
- Side drip tray (SDT-1030M2 model only)
- Side extension table (SDT-1030M2 model only)
- Saw blade
- Universal wrench
- Water pump
- Rip guide
- Drain plug
- Owner's manual

See also page 26 for additional optional accessories.

Set Up

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

1. Position water pump within the frame before dropping into the water tray.

2. Slide cutting head onto post. Attach cutting head to shaft by using the washer and bolt. Then attach cutting depth control knob and washer to the slot located underneath cutting head, which is aligned with the post shaft. (The cutting head is already mounted on the frame's post for saws built in 2010 and later.)

3. Attach both side extension tables to the main cutting table with the provided bolts and washers.

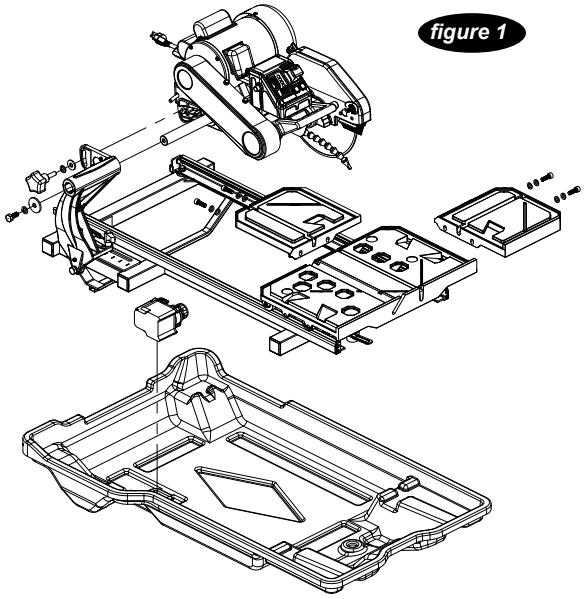


figure 1

4. Attach side then rear drip trays to the water tray.

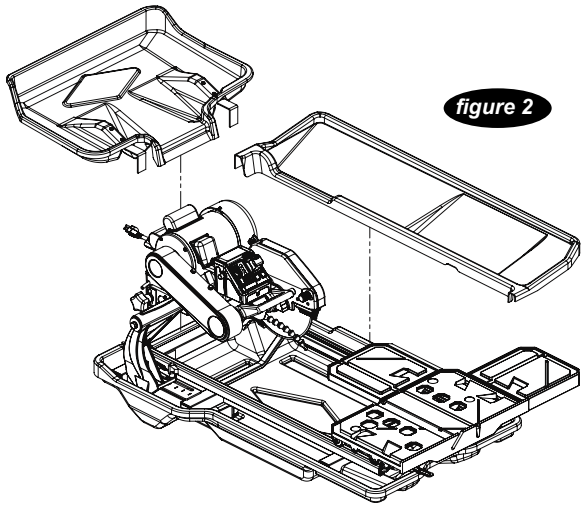
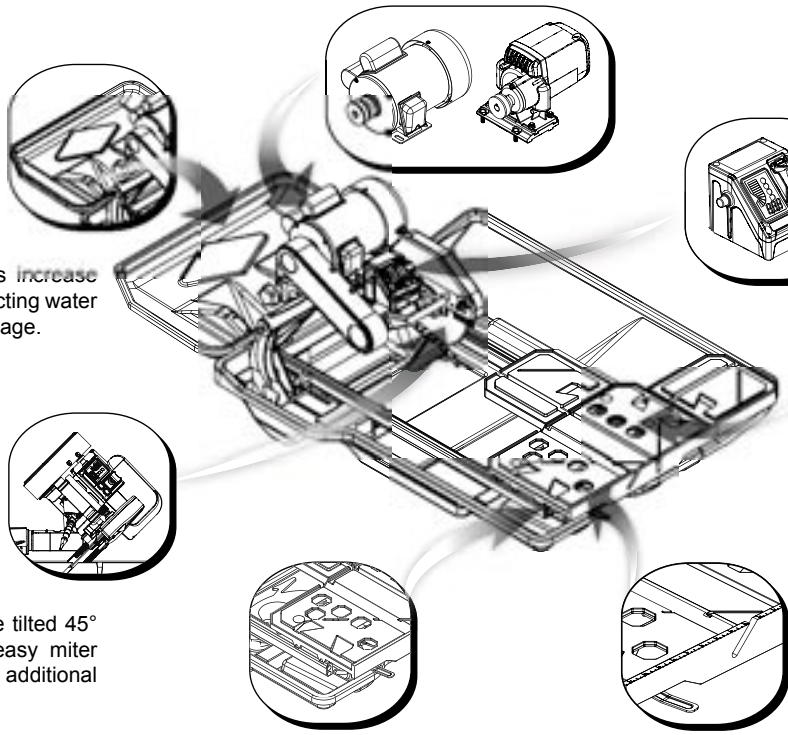


figure 2

Features

Induction Motor (SDT-1030M2)
Reliable, high performance motor with superb service life and low operating noise levels.

Carbon Brush Motor (SDT-1030)
Generates more torque and is physically smaller and lighter than similarly rated induction motors.



Pro E.D.I. System
The E.D.I. System is capable of monitoring the machine's performance and health and then providing feedback that will allow the user to work more efficiently and to quickly identify problems.

Drip Trays
Rear and side drip trays increase the surface area for collecting water and slurry to prevent spillage.

Cutting Table
Features an injection mold rubber mat that provides a firm, durable work surface while the ball bearing wheels and rollers ensure smooth effortless movement.

Miter Cutting Capacity
The cutting head can be tilted 45° to perform quick and easy miter cuts without the aid of additional tools.

Table Retention Device
The device secures the cutting table when transporting the saw.

Ruler Guide
The guide allows convenient measurements and promotes precision cuts.

Specifications

SDT-1030M2 / SDT-1030 TILE SAW					
Motor	**Max. Blade Capacity**	**Cutting Length**	**Cutting Depth**	**Weight**	**Dimensions**
1½ HP / 2 HP, 115 V/60 Hz, 3200 RPM	10-in blade for ⅝-in arbors	25½-in, Diagonally cut 18-in tile	3½-in	87 lbs / 72 lbs	Length: 40.8-in Width: 25-in Height: 19.9-in

* Dimensions do not include extension tables and drip trays.

Installation and Operation

SAW STAND SETUP

1. Remove the folding stand from its box.

2. While holding the stand upright, spread both sets of legs apart and swing the workbench over and on top of the legs.

3. Insert lock pins through the legs and into the workbench. Seat the saw securely onto the stand. ***(see figure 3)***

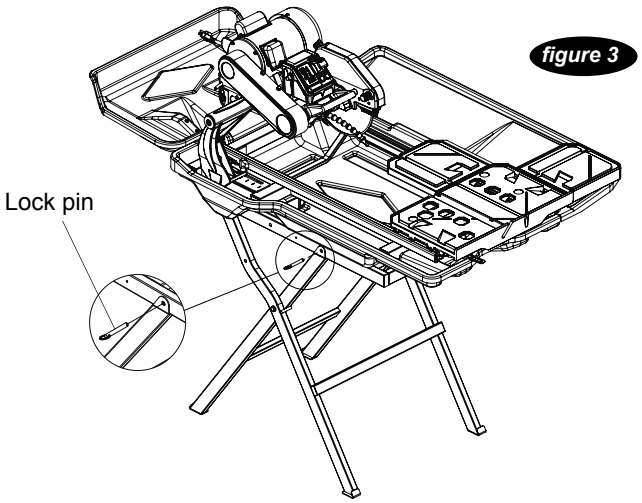


figure 3

BLADE INSTALLATION

1. Turn the silver knob on the inner blade guard counterclockwise until it pops out to unlock the outer blade guard. ***(see figure 4)***

2. Slide the outer blade guard horizontally across the inner blade guard, away from the motor. The tab at the rear of the blade guard must clear the enclosing slot.

3. Remove the outer blade guard by pulling it away from the inner blade guard. Do not force!

4. Remove the blade shaft nut and outer flange. If a blade has been mounted, hold the blade with one hand and use the other hand to loosen the nut with the universal wrench. Remove existing blade.

5. Mount new blade, but make certain the arrow on the blade coincides with the rotation direction of the shaft.

6. Perform steps 1 through 4 in reverse to complete installation. Make certain the flanges are pressed flush against the blade and that the nut is firmly tightened, but do not over tighten.

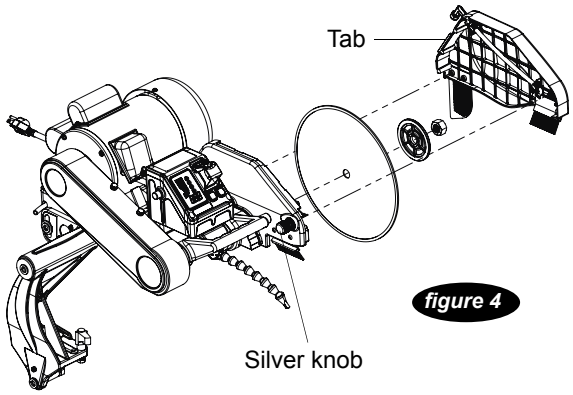


figure 4

WATER PUMP INSTALLATION

1. Remove the water pump from the box and check that it is not damaged.

2. Place the pump within the water tray such that the water outlet is horizontal. ***(see figure 5)***

3. Connect the water hose from the blade guard to the pump and plug the pump's power cord into the receptacle on the switch box.

4. Fill the water tray so that the water intake is fully immersed. Proper water level must be maintained at all times during saw operation.

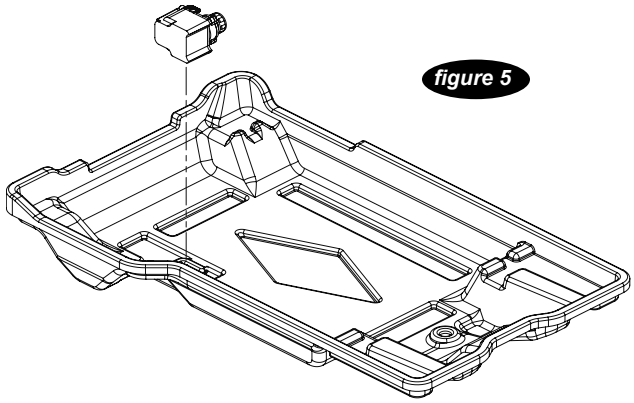


figure 5

⚠ WARNING:

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

USING THE CUTTING TABLE

- The ruler guide has inches marked along the top to allow convenient measurements and to promote precision cuts. ***(see figure 6)***

- With the standard equipped rear and side extension tables, the cast aluminum cutting table spans an area of 28-in x 20½-in, which allows it to provide greater support for handling larger materials.

- Cutting table is covered by a rubber mat that provides a firm, durable work surface.

- A rip guide should be used together with the cutting table to ensure precision while making cuts.

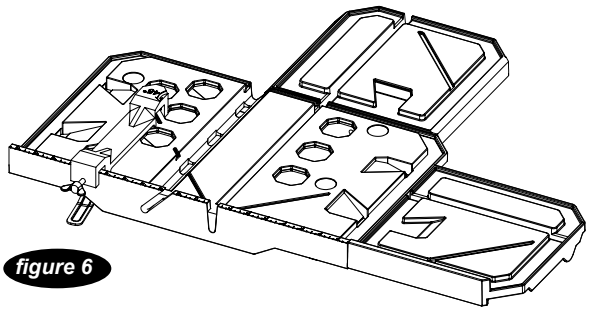


figure 6

USING THE RIP GUIDE

1. Set the rip guide at the desired location on the ruler guide and tighten the threaded knob. Make sure that the rip guide is firmly tightened to avoid slippage. The rip guide can be used for 45˚ and 90˚ cuts.

2. After the rip guide is positioned for the desired cut, place material flat against the rip guide and the ruler guide.

3. Now you are ready to make your cut.

PERFORMING DIAGONAL CUTS

1. Remove threaded knob from the end of the rip guide with the horizontal groove and insert it into the other end with the diagonal groove.

2. Set the rip guide onto the ruler guide, such that the top edge of the rip guide is aligned with the diagonal groove to the left of the vertical channel in the cutting table. Tighten threaded knob once in place.

3. Place one corner of the material being cut in the vertical slot of the ruler guide and rest the adjoining edge flat against the rip guide.

4. Now you are ready to make your cut.

PERFORMING MITER CUTS

1. The cutting head must be parallel with the table before it can be rolled to the miter position. To accomplish this, locate the viewfinder on the support post next to the cutting depth control knob. ***(see figure 7)***

2. Loosen knob and pitch the cutting head up or down until the red marker is centered within the viewfinder. This indicates the head is now parallel with the table. Tighten knob when done.

3. Secure the table to the front of the saw using the table retention device. This will prevent the blade from hitting the table when rolling the cutting head.

4. Loosen the lever and socket head screw located at the rear of the cutting head. ***(see figure 7)*** Turn socket head screw with provided hex key. Roll the head 45˚ and secure in place by tightening the lever and socket head screw.

5. Now you are ready to make your cut.

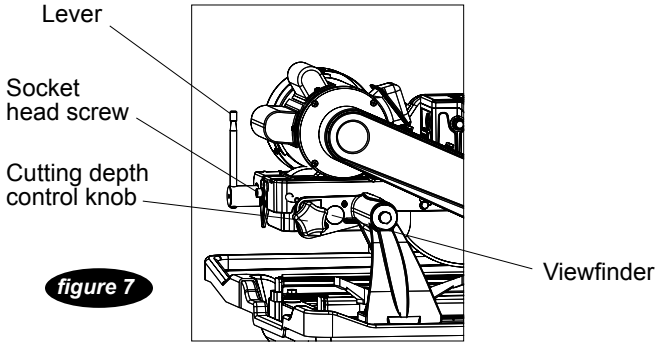


figure 7

SETTING THE CUTTING DEPTH

The recommended cutting depth is ¼-in below the cutting table surface. To adjust the cutting depth, loosen the cutting depth control knob and set the cutting head such that the lowest point of the blade is ¼-in below the table surface.

Blade Diameter	Cutting Depth
10-in	3½-in

⚠ WARNING:

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

SETTING MAXIMUM CUTTING LENGTH

When cutting smaller tiles, the post and cutting head may be positioned closer to the operator to conveniently allow smaller cutting motions to minimize strain. Conversely, when positioned further away from the operator, the saw is capable of cutting larger tiles.

1. Loosen the two acorn nuts and the bolt fastened near the base of the post using the provided universal wrench. Note that older version of the saw will have adjustable knobs with handles, instead of acorn nuts as shown below. ***(see figure 8)***

2. While lifting the cutting head, slide the post to the desired position.

3. Tighten both black adjustable handles and the bolt to secure the post and cutting head in place.

4. Check the saw's alignment after moving the cutting head.

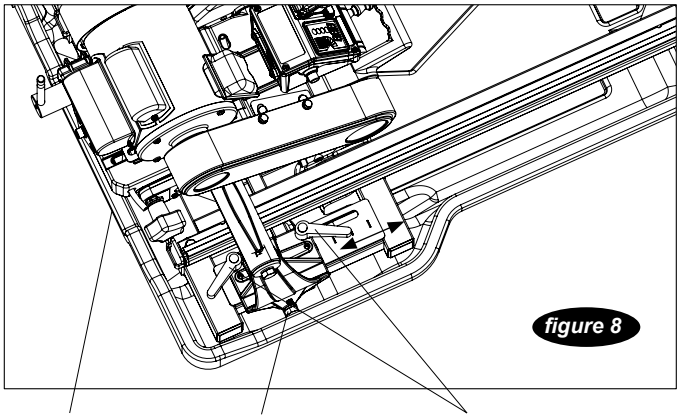


figure 8

CLEANING THE WATER TRAY

1. Remove the rear drip tray followed by the side drip tray.

2. Lift the saw up from inside the water tray.

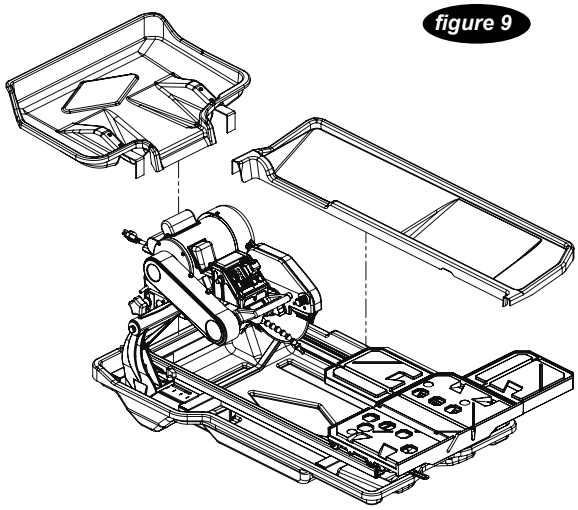
3. Remove the drain plug and drain any water left inside the water tray.

4. Flush water into the tray while holding it upright to remove any sludge buildup.

5. Replace the saw back into the water tray.

6. Attach the side drip tray followed by the rear drip tray. ***(see figure 9)***

figure 9



TRANSPORTING THE SAW

1. Ensure that the water tray is empty and dry.

2. Unplug the power cord and store it in the water tray.

3. Secure the cutting table to the front of the saw using the table retention device.

4. Tighten all adjustment handles, in particular the handles that set the cutting depth and maximum cutting length.

5. Optionally the rear and side drip trays may be removed and set in the water tray for better handling. It is recommended that the side extension table be removed.

Proper Blade Use

	Dos	Don'ts
Wet Cut Blades	• 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 bore shaft size. • Ensure that blade is mounted in the correct direction. • Use proper safety equipment when operating the saw. • Always have a continuous flow of water on both sides of blade. • Secure the blade to the arbor with a wrench.	• Do not operate the saw without safety guards in position. • Do not operate the saw with blades larger than 10-in. • Do not cut dry with blades marked "Use Wet". • Do not exceed manufacturer's recommended maximum RPM. • Do not force blade into material. Let blade cut at its own speed.
Dry Cut Blades	• 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 blades. • Use 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.

Care and 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 performing any maintenance/repair.
- Before performing any cleaning/maintenance/repair, the machine must be switched off with the main power switch.

Steps to Follow When Cleaning:

- 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 86ºF! Use a fluff-free cloth only.
- Use a cloth which may be lightly moistened only for removing dust and dirt. Hard packed dirt can be removed with a soft brush.
- For the sake of safety, no water/cleaning liquid/vapor may penetrate into the electric motor, connectors/plugs, switches, etc. Therefore cover all apertures, holes in the housing, connectors or plugs, etc. or seal them with adhesive tape!
- 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 (e.g. switch, motor). Clean the motor and switches only by wiping with a moist cloth.
- Do not “rinse” the bearings of the drive elements to prevent them from running dry. The ball bearings of the machine are permanently lubricated.
- After cleaning, remove all covers and adhesive tape! All screws/nuts which you may have loosened must be tightened again!
- After wet cleaning, try the machine on a power outlet which is equipped with a power breaker (i.e. fault current circuit breaker). If the fault current circuit breaker cuts the power supply, the machine must be inspected by an authorized dealer prior to use!

CLEANING

After every use of the machine:

- Remove dirty water from container.
- Remove dirt and mud from the bottom of the container.
- Rinse the immersion pump with fresh water to prevent the water pump from clogging with residual dirt.

After wet cleaning and before using the machine again:

- Connect the machine to an electric power outlet equipped with a “GFCI” safety power breaker. If the safety power breaker cuts off the electrical power supply, do not try to operate the machine but have it checked by an authorized dealer first.

PROLONGED PERIOD OF NONUSE

Before not using the machine for a prolonged period of time:

- Clean and lubricate all movable parts. However, do not grease the guide rails.

After not using the machine for a prolonged period of time:

- Check that the stand is safely fixed.
- Check that all screw joints and nuts are fixed.
- Check that the cutting table is seated properly on the guide rails and that it moves easily along the entire length of the rails.
- 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 cooling water tap 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 if necessary.

EXTREME TEMPERATURE

Ambient temperature below 32° 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 and water hose!

WATER PUMP MAINTENANCE

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

1. Remove the immersion pump from the water container.
2. Clean the immersion pump.
3. Loosen the fixing screws of the pump lid.
4. Take the lid off the pump. Be careful not to damage or lose the gasket underneath.
5. Clean the pump lid.
6. Remove all dirt and incrustations from the pump wheel.
7. Check whether the pump wheel can be easily turned.
8. Then reassemble the immersion pump correctly and check whether it works properly.

BELT REPLACEMENT

1. Unplug the saw before proceeding any further.
2. Secure the cutting table to the front of the saw using the table retention device.
3. Slightly loosen the lever and wing bolt located at the rear of the cutting head. Roll the cutting head to 45° angle. Tighten the lever and wing bolt to secure the cutting head in place.
4. Loosen and remove the three screws located above and below the belt guard and then remove the belt guard. ***(see figure 10)***

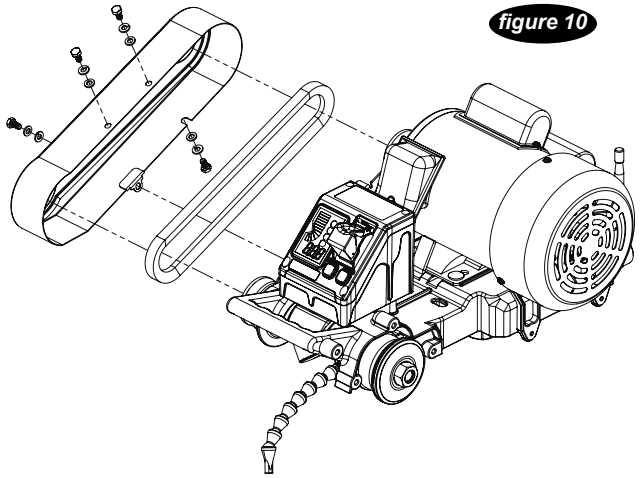


figure 10

5. Loosen the four sets of fasteners located at the base of the motor.
6. Use a hex wrench to access the socket hex bolt located at the rear of the cutting head. Turn wrench to move the motor forward, thus providing some slack in the belt.
7. Remove existing belt and replace with a new belt.
8. Perform steps 1 through 6 in reverse to tension the belt and reinstall the belt guard. Make sure the belt is at the proper tension before tightening the four bolts at the base of the motor.

CARBON BRUSH REPLACEMENT

1. Unplug the saw before proceeding any further.
2. Remove the fan cover by removing the four sets of screws located at the rear of the cover.
3. Locate the carbon brush caps found on the left and right side of the motor housing. Remove the caps (turn counter-clockwise to unscrew) to allow the carbon brushes to spring out. If they do not come out after the caps are removed, use a flat screw driver to gently nudge them out.
4. When installing the new brushes, make sure they fit snugly into the slots. Do not modify the replacement brushes (i.e. file them down) or use non OEM brushes, as it may damage the armature and in doing so voids the manufacturer warranty.
5. Perform steps 1 through 3 in reverse to reinstall the fan cover.

REALIGNMENT

Method 1:

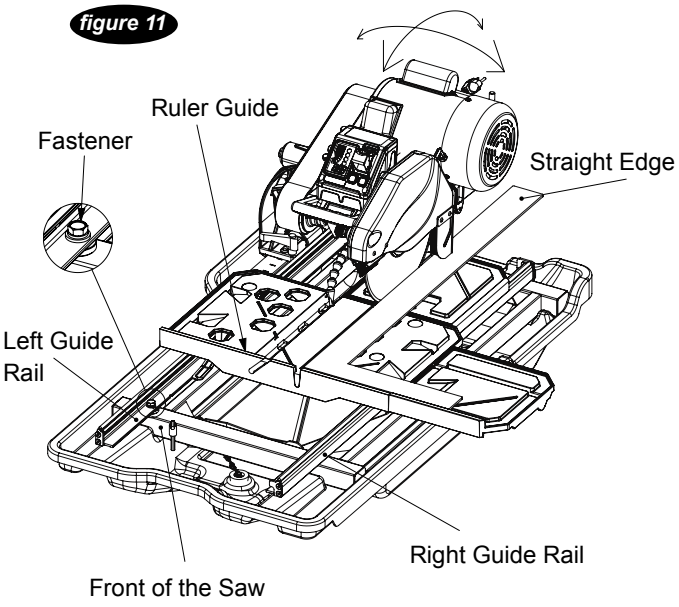
This procedure deals with the most common source of misalignment that occurs when the guide rails are not parallel with the blade.

1. Set the cutting depth such that the blade passes through the table, not over.

2. Place a straight edge (i.e. carpenter's square) on the cutting table as shown in ***figure 11.***

3. Loosen the left and right guide rails by loosening the fasteners found at the ends of the rail. ***(see figure 11)*** The left rail should be slightly loose, so there is not too much play during adjustments, but the right rail should move freely as it will be adjusted last.

figure 11



4. Make sure the short portion of the straight edge is placed flush against the ruler guide. Adjust the left guide rail so that the front and rear edges of the blade touch the straight edge, although a tolerance of 0.1mm between the front and rear edges is allowed. Perform this adjustment along the entire length of the straight edge.

5. Position the table as close to the user as possible. Place the straight edge flush against the ruler guide and blade. Without holding onto the straight edge, gently move the table towards the rear of the saw and then back. Observe any gaps that may appear between the straight edge and blade or between the straight edge and ruler guide. A gap exceeding the allowed tolerance means that the table is not moving parallel to the blade; hence, further adjustments as outlined in step 4 will be required. However, if scenario A or B described below occurs, other adjustments may be required instead.

   A. If the straight edge only touches the blade when the table is positioned midway along the rail or at the ends of the rail, then the rail may be deformed (i.e. bowed). ***(see figure 12)*** Perform test cuts to determine if the rail should be replaced. Typically a bowing displacement of about 0.2mm will not affect cutting accuracy.

figure 12

   B. If the straight edge touches both edges of the blade initially, but shifts apart as the table travels along the rail, proceed to method 2 below.

6. Tighten the fasteners at both ends of the left rail.

7. Adjust the right guide rail so that the horizontal rollers underneath the table engage the rail as shown in ***figure 13***. In most cases the rollers will not have to be vertically adjusted. Spacing between rails must be equidistant at all points to ensure that they are parallel. Once adjustments are made, lightly tighten the fasteners on the right rail and move the table back and forth. If the table binds against the rail at any point, adjust spacing accordingly until the table moves smoothly.

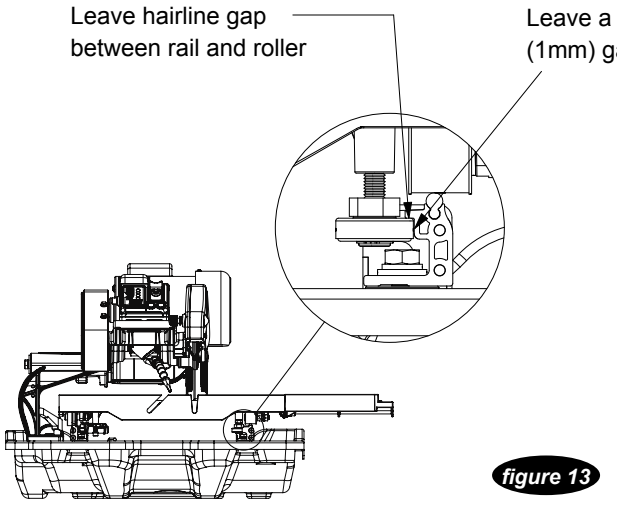


figure 13

8. Tighten the fasteners at both ends of the right rail.

If alignment has been achieved do not proceed to method 2.

Method 2:

This procedure corrects another source of misalignment that occurs when the table's orientation is not parallel with the guide rails.

1. Remove the top screw from the table stop plate on the right guide rail and rotate the plate 180º. ***(see figure 14)*** Extract the table from the opened end of the guide rails.

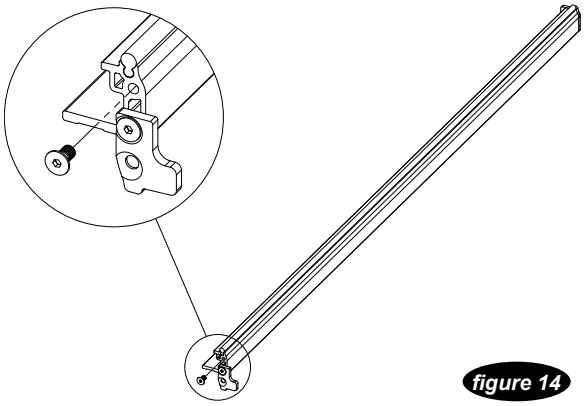


figure 14

2. If the table shifts to the right as it travels away from the user, a shim needs to be added to the guide roller furthest from the ruler guide. On the other hand, if the table shifts to the left, a shim needs to be added to the guide roller closest to the ruler guide. Remove the appropriate guide roller to insert a shim between the roller and table, then reattach. ***(see figure 15)*** Depending on the severity of the shift, more than one shim may be required.

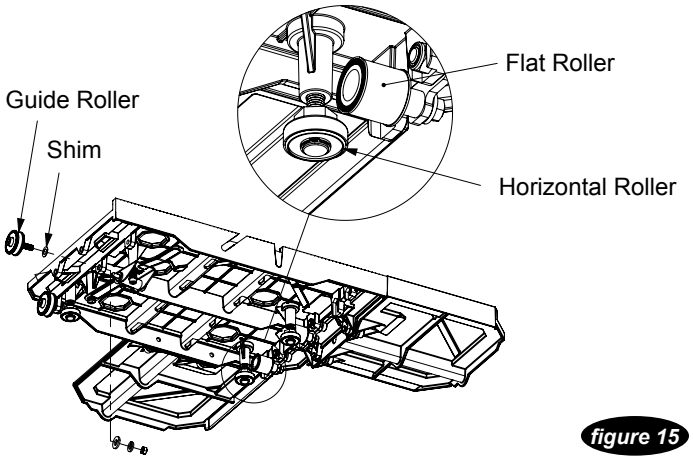


figure 15

3. After adding shim(s), mount the table onto the guide rails and realign the table to the blade using method 1. Check to see if any shifting persists. A shift tolerance of 0.2mm is allowed. A shift in excess of that will require further adjustment—repeat step 2.

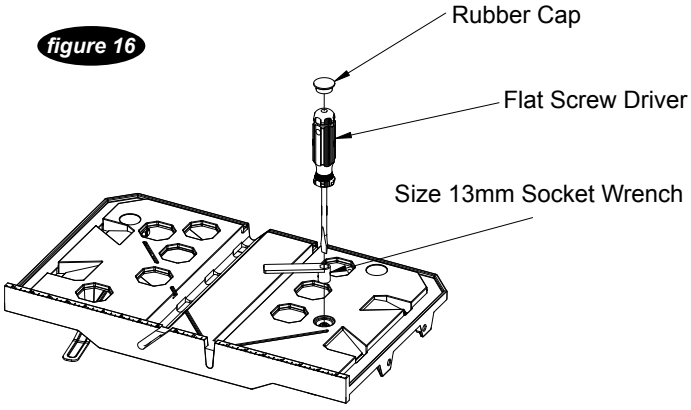
4. Once alignment is successful, restore the table stop plate on the right guide rail to its original position and secure it in place with the provided screw.

LEVELING ADJUSTMENT

This procedure levels the table so that it is perpendicular to the blade and flush against the rails.

1. Remove the two rubber caps on the right side of the table. Loosen the lock nut fastened above the right horizontal rollers underneath the table. Note that older versions of the saw have the lock nuts fastened under the cap, as shown below. ***(see figure 16)*** This will lower the horizontal roller to allow room for adjusting the flat rollers.

figure 16



2. Loosen the socket bolts on the flat roller plate so that the roller can swing freely about one bolt. ***(see figure 17)*** Do this for both flat roller plates.

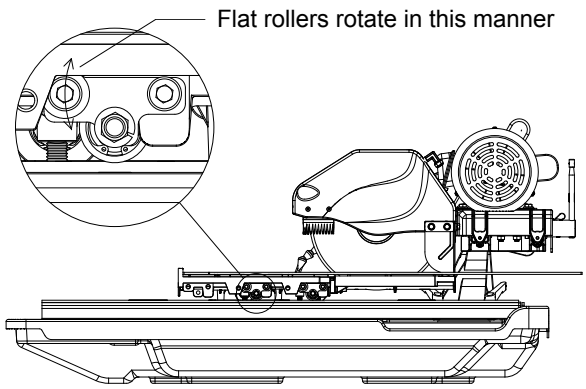


figure 17

3. Hold the table against the guide rails. The flat rollers should reposition themselves to maintain contact with the guide rails. If the table is not perpendicular to the blade, lift the right side of the table instead to obtain the proper angle. A square tool will be required to confirm the angle. Tighten the socket bolts. Check the table for play. Repeat step 2 if some play is still present.

4. Restore the horizontal rollers to their original position as shown in ***figure 13*** by reversing the instructions in step 1. Be sure to tighten the lock nuts and replace the rubber caps.

MITER ADJUSTMENT

The saw should be properly aligned before performing miter adjustments.

1. Remove the outer blade guard. ***(see figure 18)***

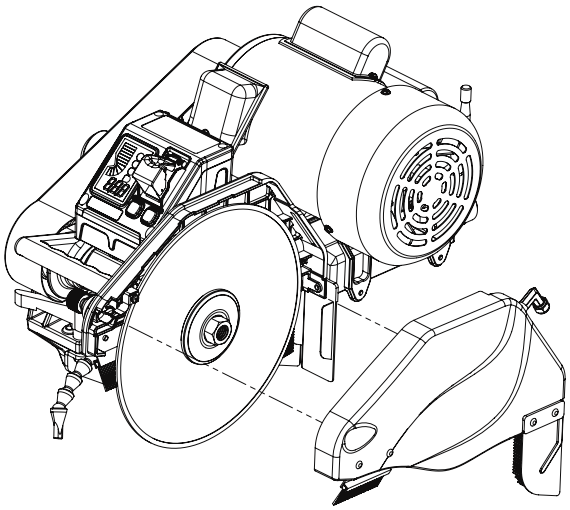


figure 18

2. Move the table to the front of the saw to prevent damage to the blade resulting from rolling the cutting head to the miter cut position.

3. Locate the viewfinder next to the post. Loosen the depth control knob and pitch the cutting head up or down until the marker is centered within the reticle. Lock the cutting head by tightening the depth control knob. ***(see figure 19)***

4. Loosen the miter lever by hand and the socket head screw with the provided hex key. ***(see figure 19)*** Roll the head so that it rests at the miter position. Tighten the miter lever and socket head screw.

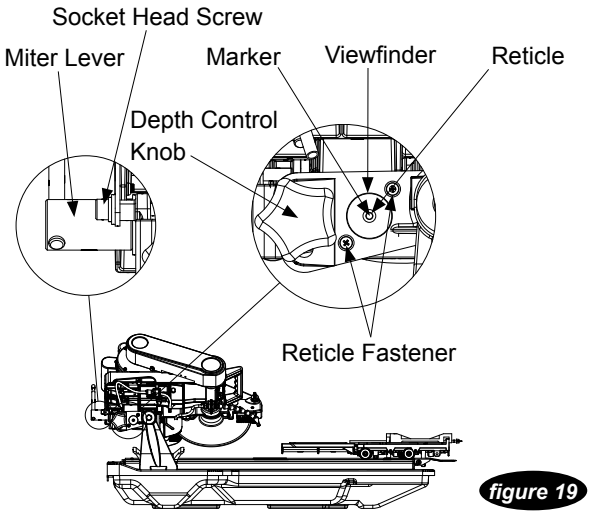


figure 19

5. Confirm that the cutting head is parallel with the table by placing a straight edge (i.e. carpenter's square) on the table as shown in ***figure 20***. The straight edge should touch the front and rear edges of the blade. If not, adjust the pitch of the cutting head until that condition is met. Confirm that the marker is still centered within the reticle. If not, loosen the two reticle fasteners next to the viewfinder and center the reticle onto the marker, then tighten the fasteners to secure the reticle in place.

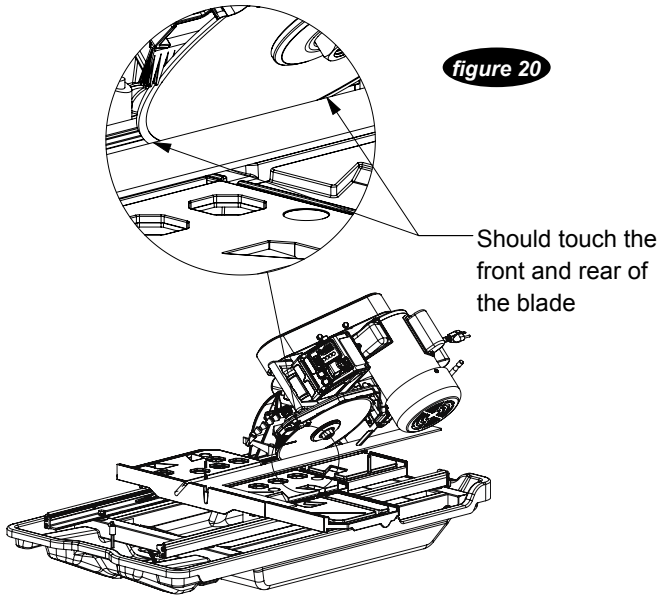


figure 20

6. Use a rafter angle square as shown in ***figure 21*** to confirm that the miter angle is properly set to 45º. The square should touch the top and bottom edges of the blade. If it does not, roll the cutting head back to the upright position. Locate the set screws underneath the

cutting head. ***(see figure 22)*** Extend the set screws to decrease the amount the head will roll and retract to increase it. After each adjustment, the jam nuts should be tightened to prevent the set screws from moving. Check the miter angle and make further adjustments as required.

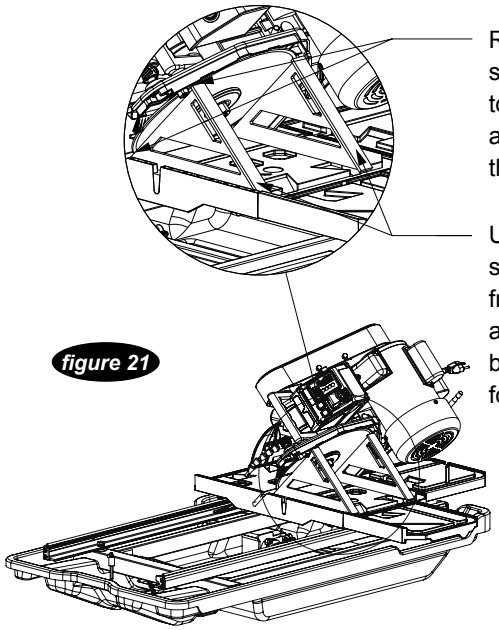


figure 21

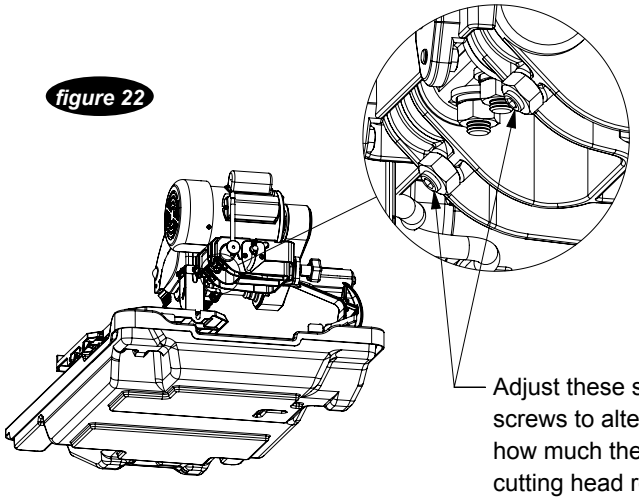


figure 22

Electrical Specifications

	SDT-1030M2 / SDT-1030
Power	1½ HP / 2 HP
Volts	115 V
Amps	15 A
Motor RPM	3200 RPM
Cycle	60 Hz
Phase	1

RECOMMENDATIONS

- 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.

⚠ 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 below for proper size.

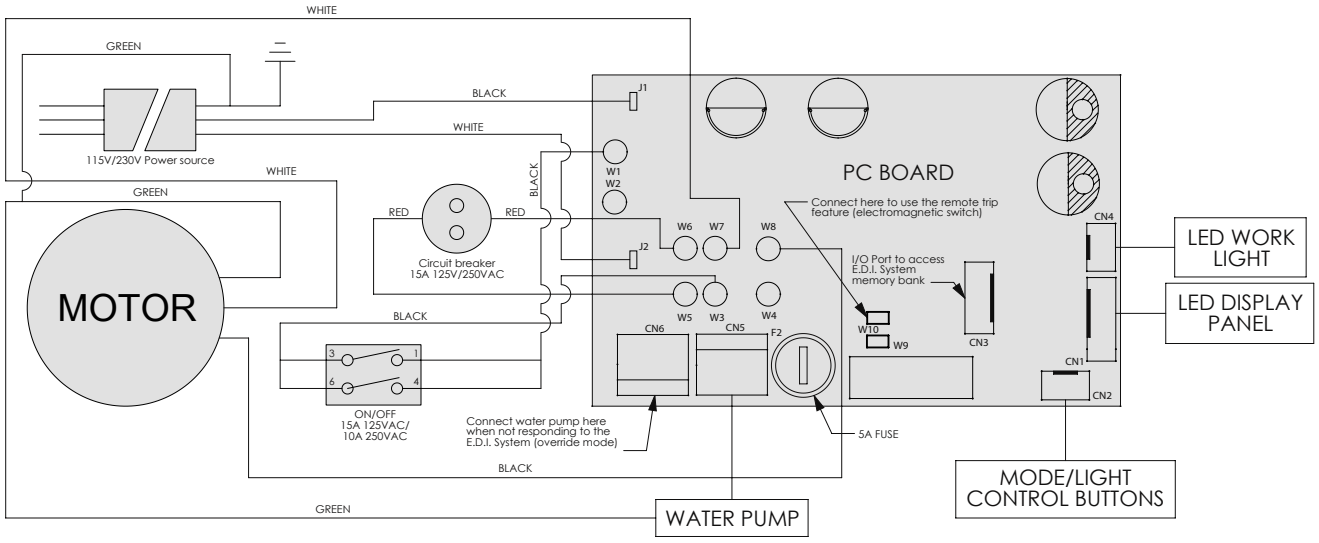
EXTENSION CORD CHART

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

WATER PUMP BYPASS

- Unplug the saw before proceeding any further. Pull out the water pump plug, found on the PC Board (view wiring diagram), and connect it to the port found next to it (CN6). To pull the plug out, locate the hook found on the head of the plug. Pull the hook back by pushing down on the back of the hook. With the hook disengaged, pull the plug head out. Plug the head into the neighboring open port, while making sure the orientation of the head has not changed.

ELECTRICAL WIRING DIAGRAM



Troubleshooting

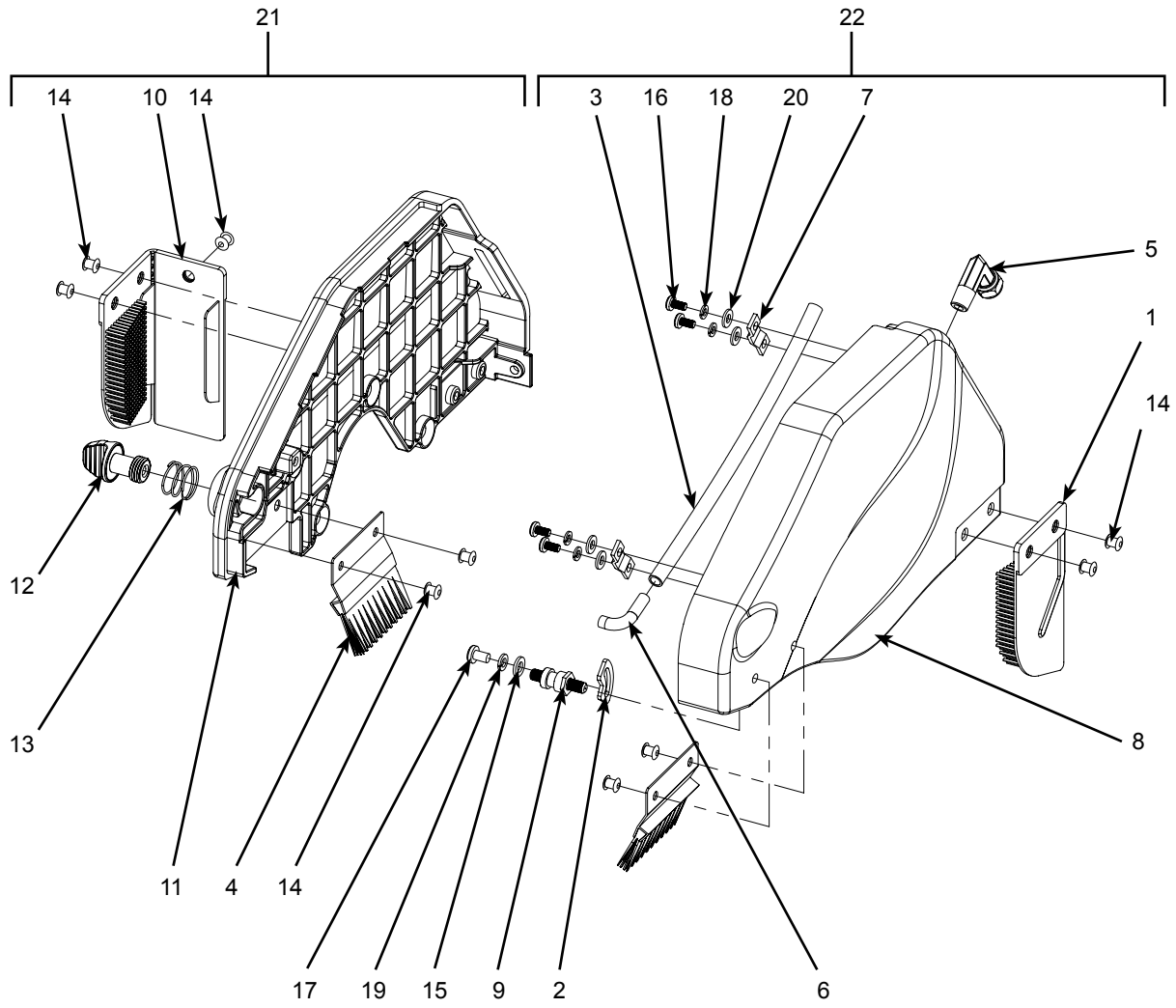
Problem	*Possible Cause*	*Solution*
Machine does not run when switched on	Power cord not properly fixed/ plugged in	Check that the machine is properly connected to the power supply
	Power cord defective	Have the power cord checked, replace if necessary
	Main power switch defective	Have the main power 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

Replacement Parts List

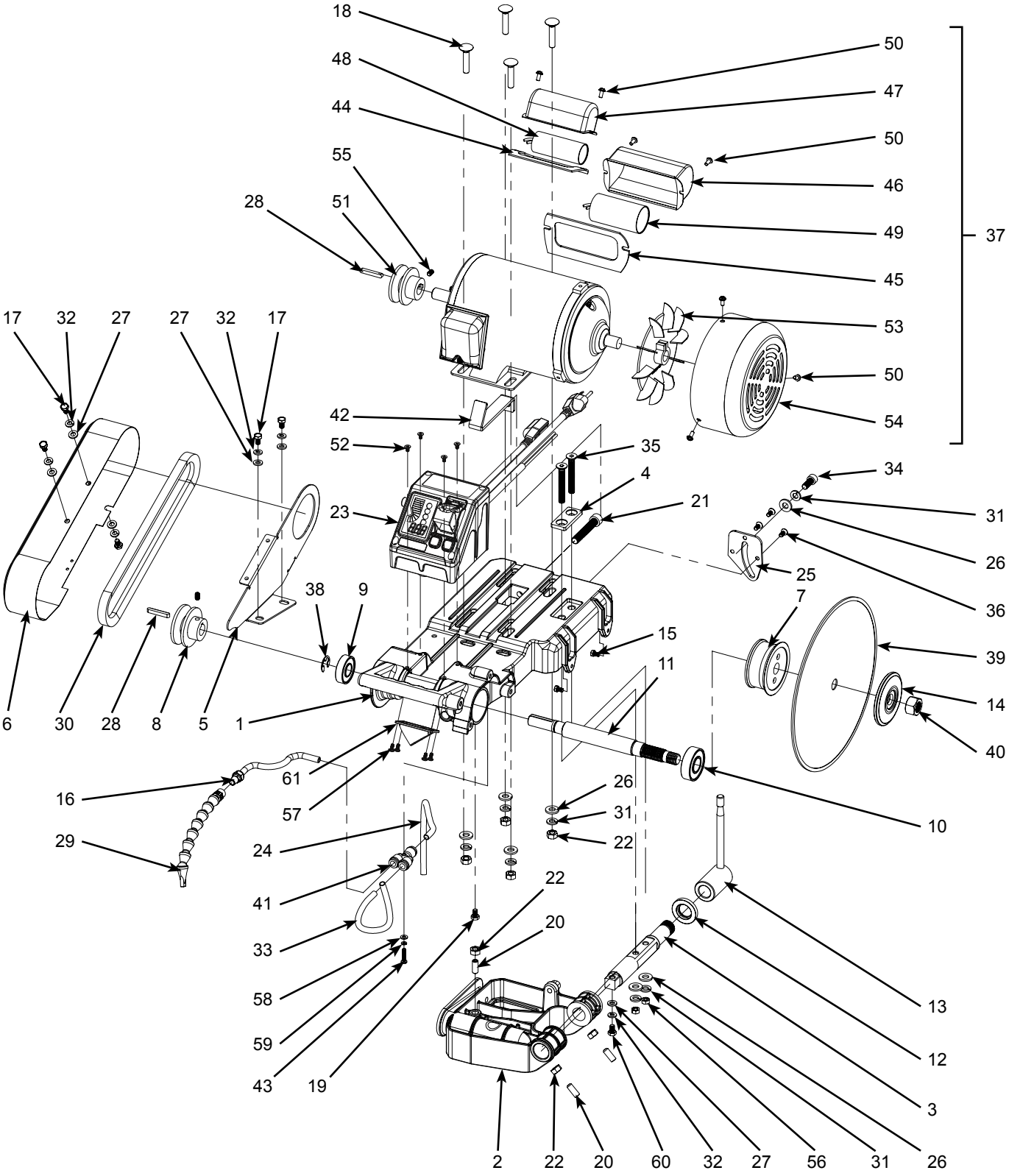
BLADE GUARD ASSEMBLY



	DESCRIPTION	PART NO
1.	Outer splash guard	420171
2.	Lock plate	420172
3.	Hose	420173
4.	Plastic brushes	420174
5.	D8 90 degree elbow hose connector	420175
6.	D6.4mm 90 degree elbow pipe	420176
7.	Hose retaining clip	420177
8.	Outer blade guard	420321
9.	Snap bar	420179
10.	Inner splash guard	420180
11.	Inner blade guard	420322
12.	Lock knob	420182

	DESCRIPTION	PART NO
13.	Spring	420183
14.	M5 Rivet	110037
15.	M5 Narrow washer	420185
16.	M4 x 0.7 x 8L Cross screw	420091
17.	M5 x 0.8 x 8L Cross screw	420186
18.	M4 Spring washer	420045
19.	M5 Spring washer	420303
20.	M4 Narrow washer	420044
21.	Inner blade guard assembly without lock knob and spring	420323
22.	Outer blade guard assembly	420324

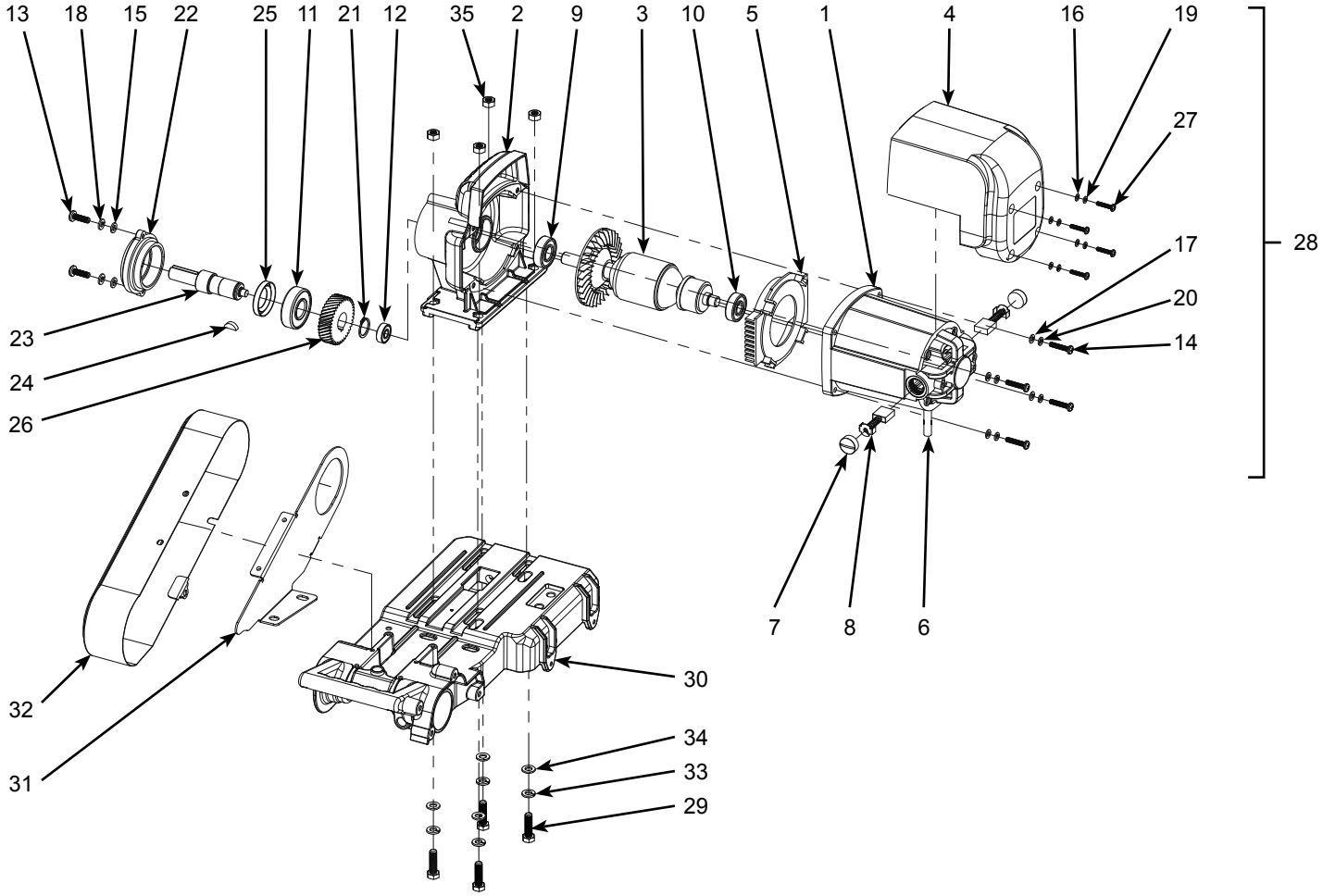
CUTTING HEAD ASSEMBLY & SDT-1030M2 MOTOR ASSEMBLY



	DESCRIPTION	PART NO
1.	Mounting plate	420325
2.	Two axis mounting block	420326
3.	Roll axis shaft	420189
4.	Rectangular washer	420190
5.	Belt guard bracket	420191
6.	Belt guard	420328
7.	Inner flange	420193
8.	Blade shaft pulley	420194
9.	D40 d17 6203LLB Radial bearing	420195
10.	D47 d20 6204LLB Radial bearing	420196
11.	Blade shaft	420197
12.	Compression plate	420198
13.	Primary lever	420199
14.	Outer flange	420200
15.	M5 x 0.8 x 8L hex bolt	420201
16.	Modular hose to Y-adapter coupled hose	420202
17.	M6 x 1.0 x 10L Hex bolt	420102
18.	M8 x 1.25 x 25L Rounded head square neck bolt	420203
19.	M8 x 1.25 x 12L Hex bolt	420304
20.	M8 x 1.25 x 20L Flat head set screw	420204
21.	M10 x 1.5 x 60L Socket hex bolt	420205
22.	M8 x 1.25 Nut	420079
23.	Pro.1 E.D.I. System	100001
24.	Water pump to Y-adapter hose	420207
25.	Roll guide plate	420208
26.	M8 Narrow washer	420209
27.	M6 x 12 x 1 Narrow washer	420097
28.	5 x 5 x 35L Square key	420210
29.	7 Link 6.3 ID Flat nose assembly	420211
30.	25-in V-Belt	420212
31.	M8 Spring washer	420051

	DESCRIPTION	PART NO
32.	M6 Spring washer	420084
33.	Y-adapter to blade guard hose	420213
34.	M8 x 1.25 x 20L Socket hex bolt	420214
35.	M8 x 1.25 x 60L Countersunk head hex screw	420215
36.	M5 x 0.8 x 10L Socket head hex bolt	420082
37.	Complete 1-1/2HP ind. motor	420216
38.	M15 External E-clip	420217
39.	10”(254mm) Cont. general purpose blade	
40.	5/8”-11 UNC Nut	S1000-17
41.	D8mm Y-Shape female connectors	420218
42.	Motor tension bracket	420219
43.	M4 x 0.7 x 20L cross screw	420046
44.	Running capacitor gasket	420220
45.	Starting capacitor gasket	420221
46.	Starting capacitor cover	420222
47.	Running capacitor cover	420223
48.	Running capacitor (40µF/250V)	420224
49.	Starting capacitor (300µF/125V)	420225
50.	3/16 x 1/4L Tapping cross screw	420226
51.	Motor pulley	420227
52.	M4 x 0.7 x 12L Cross screw	420277
53.	Fan	420229
54.	Motor fan guard	420230
55.	M6 x 1.0 x 10L Flat point set screw	420231
56.	M8 x 1.25 Nut	420079
57.	M4 x 0.7 x 8L Cross screw	420091
58.	M4 Narrow washer	420044
59.	M4 Spring washer	420045
60.	M6 x 1 x 25L Hex bolt	420319
61.	LED Work light	420329

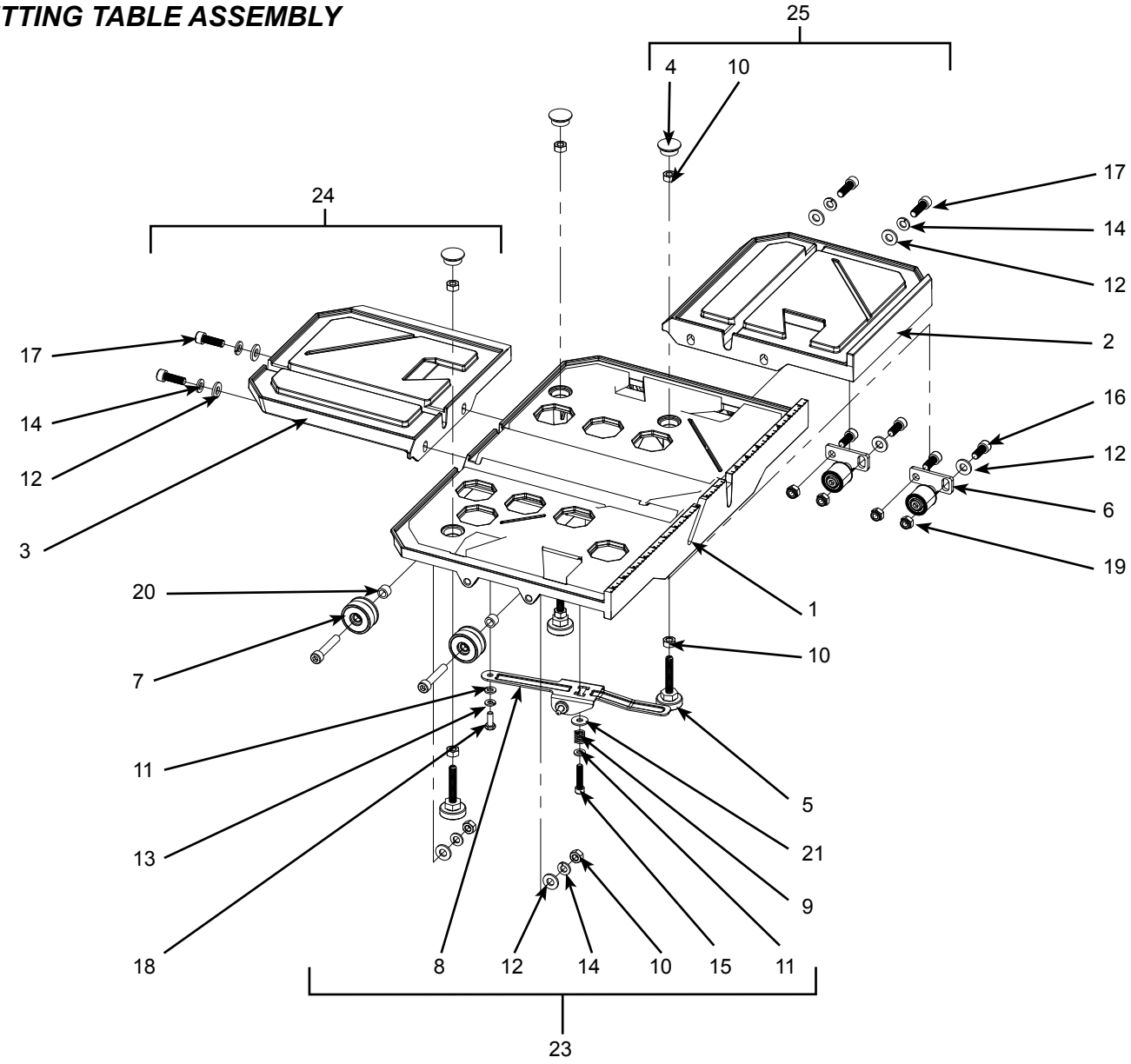
SDT-1030 MOTOR ASSEMBLY



	DESCRIPTION	PART NO
1.	Motor housing with field winding	100184
2.	Motor mounting block	100146
3.	Armature	100183
4.	Motor cover	100150
5.	Wind baffle	100153
6.	D7.4-D8.2 Snap-in cable gland (SB6N-4)	100186
7.	Carbon brush cap	100151
8.	17mm x 7mm Carbon brush (set of 2)	100152
9.	D35 d15 Radial bearing 6202 ZZ	100187
10.	D32 d12 Radial bearing 6201 ZZ	100188
11.	D47 d20 Radial bearing 6204 ZZ	420056
12.	D22 d8 Radial bearing 608 ZZ	420055
13.	M5 x 0.8 x 20L Cross screw	100189
14.	M5 x 0.8 x 25L Cross screw	100158
15.	M5 Narrow washer	100156
16.	M4 Narrow washer	100157
17.	M5 Narrow washer	100156
18.	M5 Spring lock washer	100154

	DESCRIPTION	PART NO
19.	M4 Spring lock washer	100155
20.	M5 Spring lock washer	100154
21.	M20 External C-clip	150039
22.	Gear cover	100190
23.	Motor output shaft	100191
24.	5 x 16 Woodruff key	420047
25.	D40 d24 Oil seal	420040
26.	Helical gear	100192
27.	M4 x 0.7 x 20L Cross screw	420046
28.	Complete 2HP carbon brush motor	100185
29.	M8 x 1.25 x 30L Hex bolt	42163
30.	Cutting head mounting plate	420330
31.	Belt guard bracket	420331
32.	Belt guard	420332
33.	M8 Spring lock washer	0121
34.	M8 Narrow washer	0120
35.	M8 x 1.25 Nut	100082

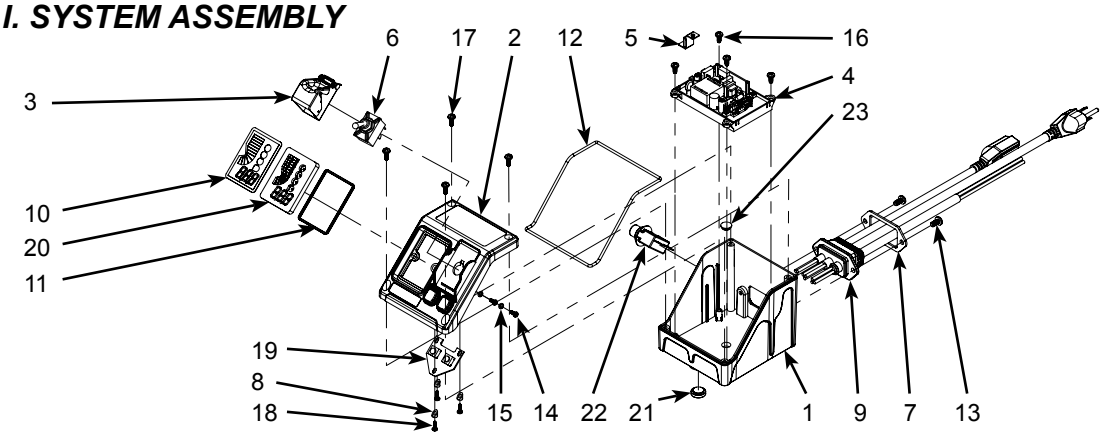
CUTTING TABLE ASSEMBLY



	DESCRIPTION	PART NO
1.	TX01 Cutting table	420234
2.	TX01A Side extension table	420235
3.	TX01B Rear extension table	420236
4.	Rubber cap	420237
5.	Concentric flat roller	420238
6.	Inner flat roller variant	420239
7.	Type 4 guide roller	420240
8.	Spring lock assembly	420241
9.	Spring	420242
10.	M8 x 1.25 Nut	420079
11.	M6 x 12 x 1 Narrow washer	420097
12.	M8 Narrow washer	420209
13.	M6 Spring washer	420084

	DESCRIPTION	PART NO
14.	M8 Spring washer	420051
15.	M6 x 1.0 x 30L Socket head hex bolt	420243
16.	M8 x 1.25 x 20L Socket head hex bolt	420214
17.	M8 x 1.25 x 25L Socket head hex bolt	420244
18.	M6 x 1.0 x 16L Hex bolt	420067
19.	M8 X 1.25 Nylon nut	420245
20.	D12.7 d8.5 x 9L Spacer	420246
21.	M6 x 19 x 1.5 Regular washer	420071
22.	M8 x 1.25 x 45L	420247
23.	TX01 Cutting table assembly w/o extension tables	420297
24.	TX01B Rear extension table w/hardware	100102
25.	TX01A Side extension table w/hardware	420299

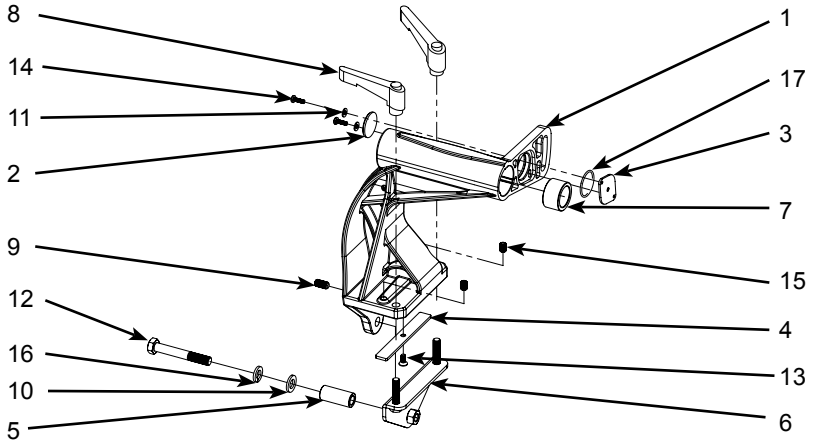
PRO.1 E.D.I. SYSTEM ASSEMBLY



	DESCRIPTION	PART NO
1.	Switch box	130026
2.	Switch box cover	130027
3.	Power switch shield	100003
4.	PC Board with plastic mount	130028
5.	Grounding plate	130044
6.	15A/125V Toggle switch	S1000-03
7.	Cable sandwich plate	130029
8.	Plastic leveling spacer	130030
9.	2 x 14AWG, 1 x 18AWG Tri-cable unibody w/gland	130031
10.	Pro.1 E.D.I. System LED panel decal	130032
11.	LED Panel gasket ring	130033

	DESCRIPTION	PART NO
12.	Housing gasket ring	130034
13.	M5 x 0.8 x 10L Cross screw	420121
14.	M3 x 1.06 x 10L Cross tapping screw	130035
15.	M3 Narrow washer	130036
16.	M4 x 1.59 x 10L Cross tapping screw	130037
17.	M4 x 1.59 x 12L Cross tapping screw	130038
18.	M2.5 x 0.91 x 10L Cross tapping screw	130039
19.	Push button PC board	130040
20.	LED Panel backing	130041
21.	Pathway plug (large)	130042
22.	18A/125V Circuit breaker	141038
23.	Pathway plug (small)	130043

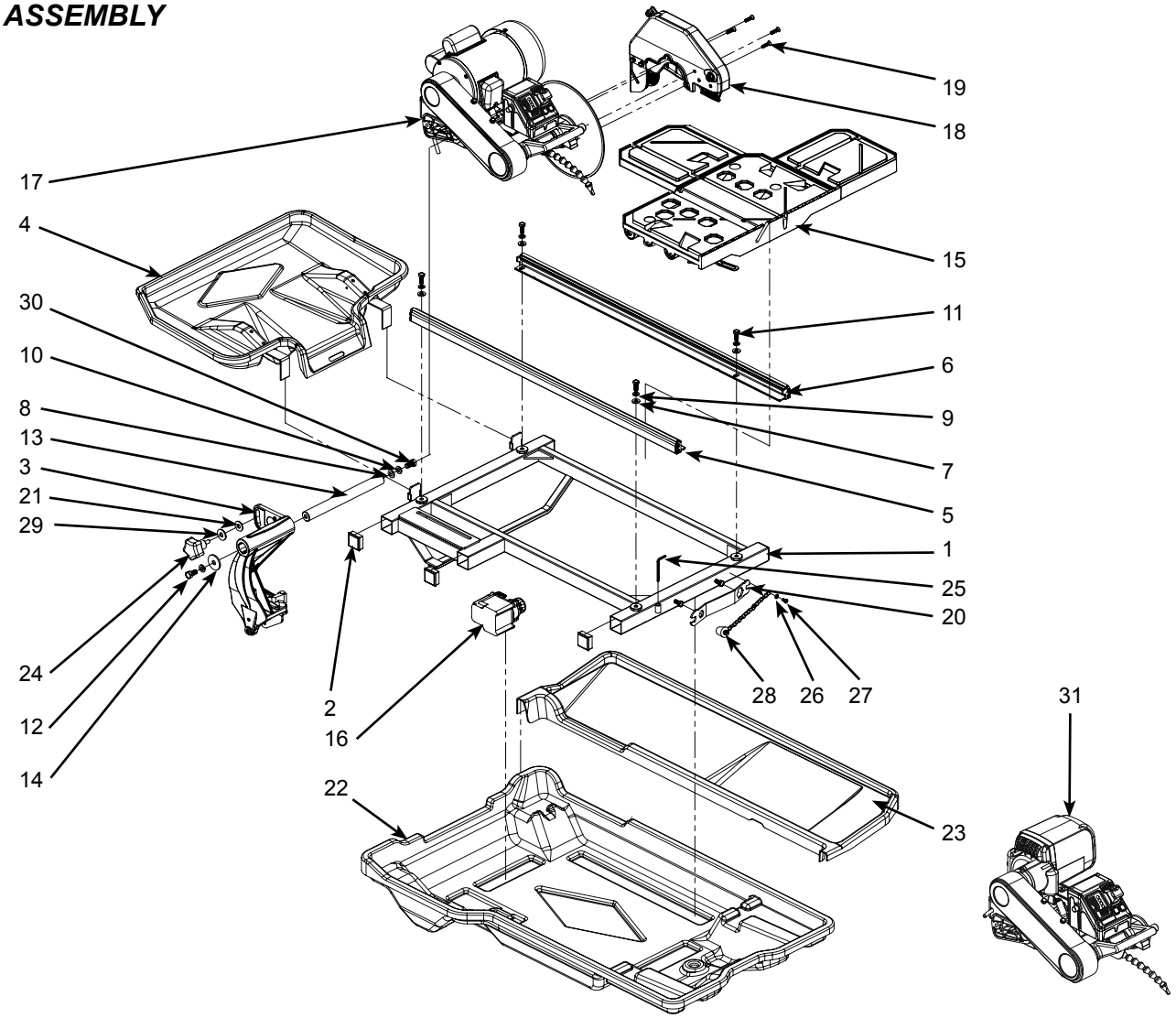
POST ASSEMBLY



	DESCRIPTION	PART NO
1.	Post	420333
2.	Magnifying lens	420267
3.	Orientation plate	420268
4.	Skid plate	420269
5.	D17 d10.5 x 38.3L Spacer	420270
6.	Post bracket	420271
7.	Shaft bushing	420272
8.	M8 x 1.25 Female adjustment knob	420273
9.	M8 x 1.25 x 15L Cup point set screw	420274

	DESCRIPTION	PART NO
10.	M10 Narrow washer	420233
11.	M4 Narrow washer	420044
12.	M10 x 1.25 x 70L x 26L Cap hex bolt	420275
13.	M5 x 0.8 x 12L Socket head hex bolt	420276
14.	M4 x 0.7 x 12L Cross screw	420277
15.	M8 x 1.25 x 10L Cup point set screw	420278
16.	M10 Spring washer	420228
17.	28.3 x 1.78 O-ring	420279

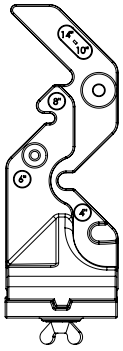
MAIN ASSEMBLY



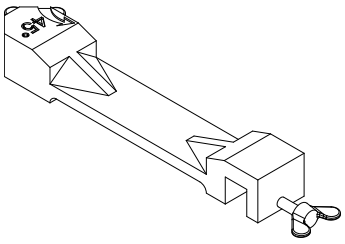
	DESCRIPTION	PART NO
1.	Frame weldment	420334
2.	35mm x 35mm Square end cap	420250
3.	Post assembly	420335
4.	Rear drip tray	420336
5.	910L Left rail	420253
6.	910L Right rail	420254
7.	M8 Narrow washer	420209
8.	M10 Narrow washer	420233
9.	M8 Spring washer	420051
10.	M10 Spring washer	420228
11.	M8 x 1.25 x 20L Hex bolt	420052
12.	M10 x 1.5 x 50L Hex bolt	420255
13.	Cutting head shaft	420256
14.	M10 Wide washer	420257
15.	TX01 Cutting table with extension tables	420258
16.	230 gal/hr Water pump (115V/60Hz)	420302

	DESCRIPTION	PART NO
17.	Cutting head assembly (SDT-1030M2)	420337
18.	Blade guard assembly	420338
19.	M6 x 1.0 x 10L Countersunk socket hex bolt	420261
20.	Universal wrench	S1000-41
21.	M10 Spring washer	420013
22.	Water tray	420327
23.	Side drip tray	420340
24.	Male 3/8”-16 x 1-1/4L knob	420265
25.	Size 4 Hex key/wrench	420266
26.	M5 Narrow washer	420317
27.	M5 x 0.8 x 10L Cross screw	420121
28.	Drain plug with chain	420300
29.	M10 Regular washer	420301
30.	M10 X 1.5 X 25L Hex bolt	420320
31.	Cutting head assembly (SDT-1030)	420341

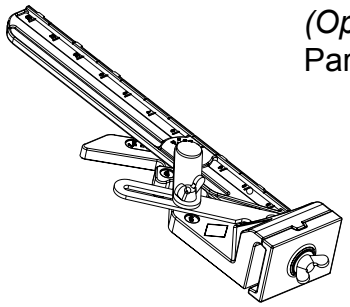
Accessories



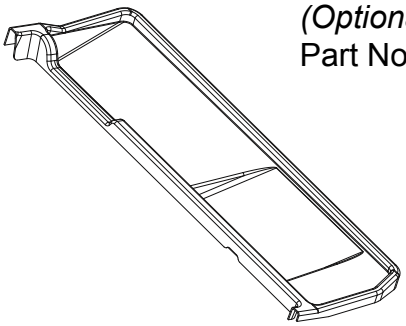
Masterguide Template Base
(Optional)
Part No. S1000-MG1



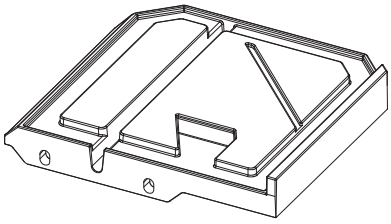
45˚/90˚ Rip Guide
Part No. S1000-35



Masterguide
(Optional)
Part No. S1000-MG

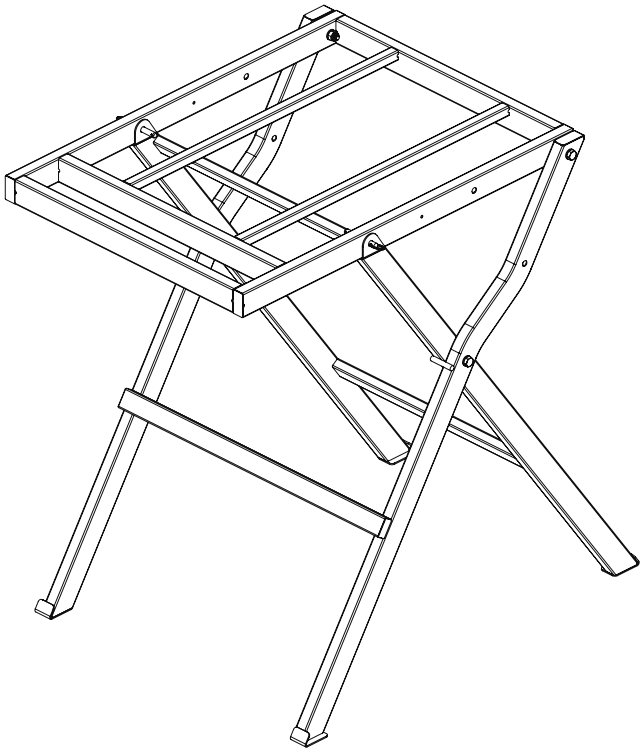


Side Drip Tray
(Optional for SDT-1030)
Part No. 420340



Side Extension Table
(Optional for SDT-1030)
Part No. 420299

Saw Stand
(Optional)
Part No. SDT-1010ST



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 1-888-688-6899 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 $800.00 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
Email: sales@sawmaster.com
Web: www.sawmaster.com

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.

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