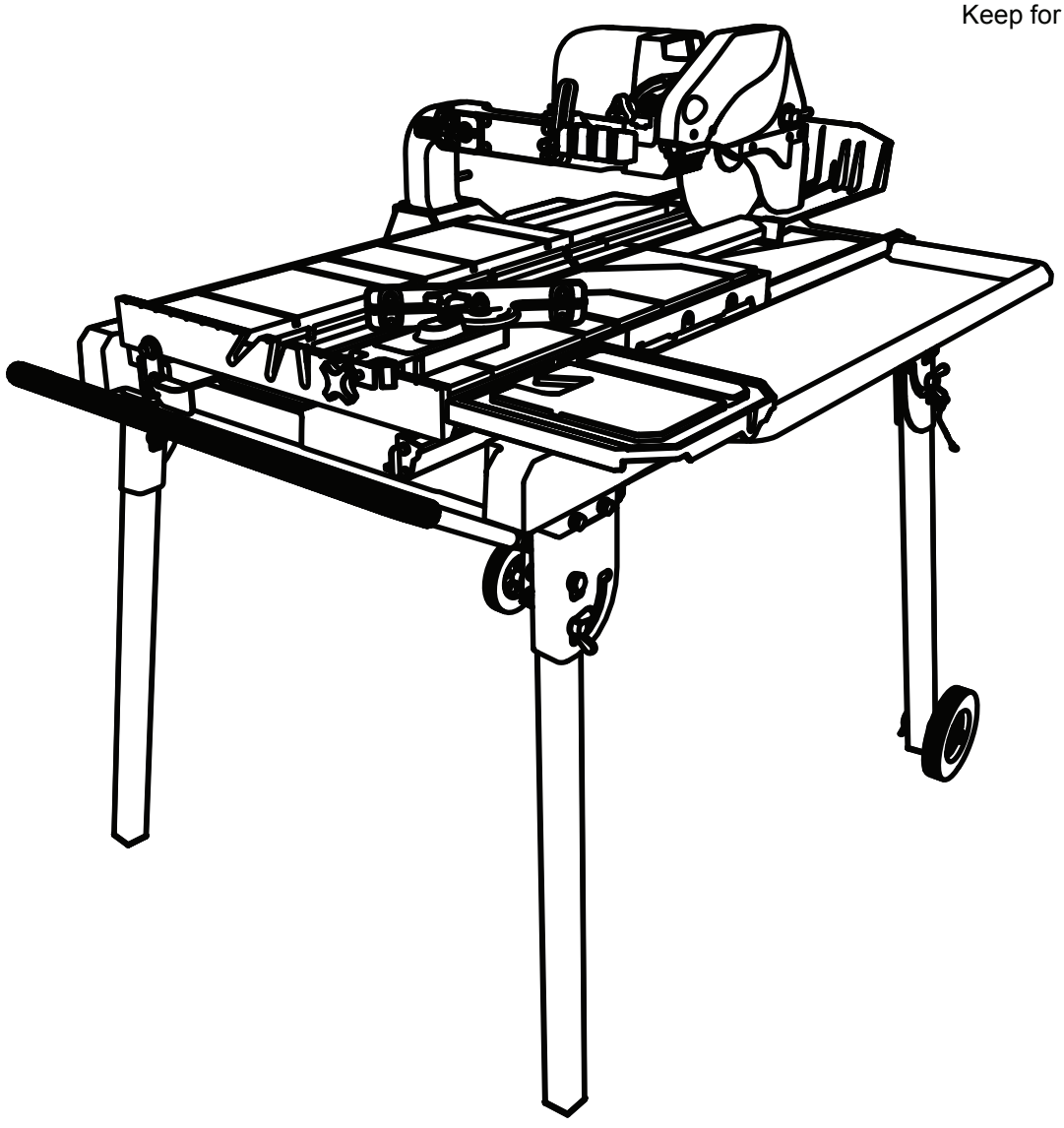
M1030/M1036

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.

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.

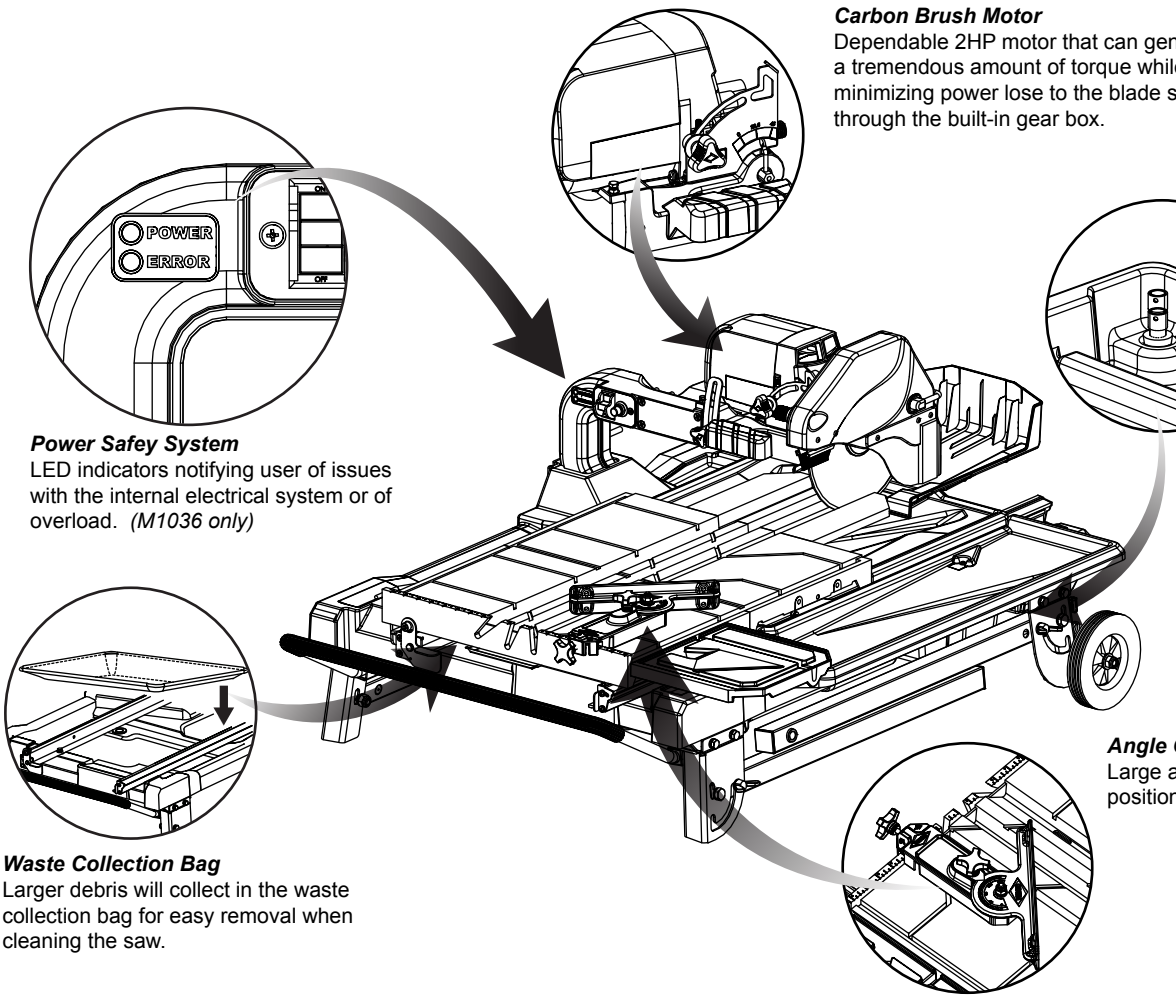
U. Never carry machine by cord. Do not pull cord to unplug. Keep cord away from heat, sharp edges and oil.

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.

Features



Carbon Brush Motor
Dependable 2HP motor that can generate a tremendous amount of torque while minimizing power lose to the blade shaft through the built-in gear box.

Overflow Plug
Use of fluid overflow plug features traditional plug to stop water from draining as well as becoming a overflow tube so excess water can escape the lower water tank enabling placement of water bucket to accumulate cleaner water to be pumped back into the glade guard.

Power Safey System
LED indicators notifying user of issues with the internal electrical system or of overload. *(M1036 only)*

Angle Guide
Large adjustable guide allows for easy positioning of tile for cutting at any angle.

Waste Collection Bag
Larger debris will collect in the waste collection bag for easy removal when cleaning the saw.

Specifications

	Motor	Max. Blade Capacity	Cutting Length	Cutting Depth	Weight	Dimensions
M1036	2 HP 115 V/ 60 Hz, 3200 RPM	10-in blade for 5/8-in arbors	36-in, Diagonally cut 24-in tile	2.4-in	132 lbs	Length: 45-in Width: 34.5-in Height: 23-in
M1030	2 HP 115 V/ 60 Hz, 3200 RPM	10-in blade for 5/8-in arbors	30-in, Diagonally cut 20-in tile	2.4-in	128 lbs	Length: 45-in Width: 34.5-in Height: 23-in

* Dimensions do not include extension tables and drip trays.

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 out of the packaging and place it on a flat, level working area. Be sure that you have the following items before you discard the container:

1. Saw
2. Side extension table w/hardware
3. Saw blade
4. Wrenches (universal and hex wrench)
5. Side drip tray
6. Rear drip tray
7. 180 Degree adjustable angle guide
8. Front lift handle w/hardware
9. Debris bag
10. Over flow plug (M1036 only)
11. Owner's manual
12. Bottom water tray (M1036 only)
13. Wheels (2)
14. Elastic strap (M1036 only)

See included SUPPLEMENTARY UNPACKING AND ASSEMBLY INSTRUCTIONAL BOOKLET for more details.

Set Up

See included SUPPLEMENTARY UNPACKING AND ASSEMBLY INSTRUCTIONAL BOOKLET for more details.

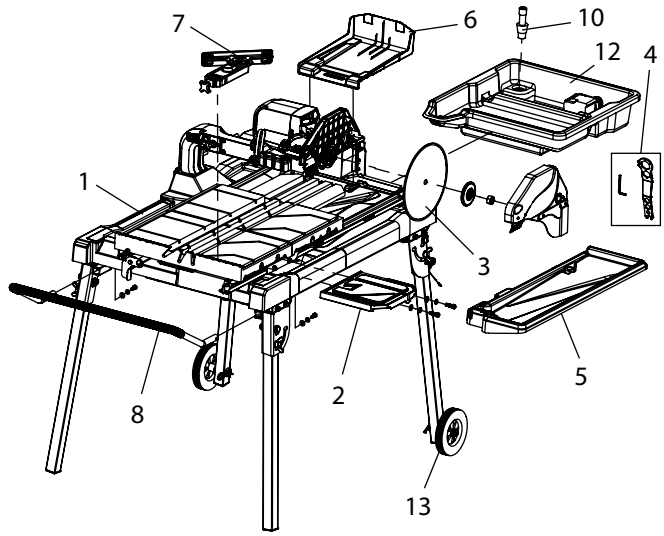


figure 1

Saw Stand Use

⚠ *WARNING: The following steps should be done on a stable dry flat surface.*

⚠ *WARNING: Lock the table before proceeding to prevent damage or bodily harm from sudden movement of the table.*

FOLDING BUILT-IN LEGS

1a. It is recommended that adjusting the folding leg be done by at least two people.

2a. Remove the detachable wheel assembly from the legs and stow it on the frame. ***(see figure 2)***

3a. Starting from the rear, the end where the motor is on, lift the saw up.

4a. Working on one leg at a time, have another person remove the safety pin and loosen the wing screw. If the wing screw is stuck, shake the leg to un-stick the wing screw. With the leg loose, slide the leg from "setup 2" to "setup 1" position as shown in ***figure 2***. Retighten the wing screw.

5a. Perform step 4a on the other leg on the same end.

6a. Place the rear of the saw on the ground. The wheel's should be touching the ground.

7a. Perform steps 4a-5a again but on the front of the saw. No safety pin is involved for the front.

DEPLOYING BUILT-IN LEGS

1b. It is recommended that adjusting the folding leg be done by at least two people.

2b. Starting from the front, the end opposite from where the motor is on, lift the saw up using the front lift handle.

3b. Working on one leg at a time, have another person loosen the wing screw. If the wing screw is stuck, shake the leg to un-stick the wing screw. With the leg loose, slide the leg from "setup 1" to "setup 2" position as shown in *figure 2*. Retighten the wing screw.

4b. Perform step 3b on the other leg on the same end.

5b. Place the front of the saw on the ground. The frame should be touching the ground.

6b. Perform steps 3b-4b again but on the rear of the saw.

7b. Remove the wheel assembly from the frame and install it on the leg, in the state it was in step 3a.

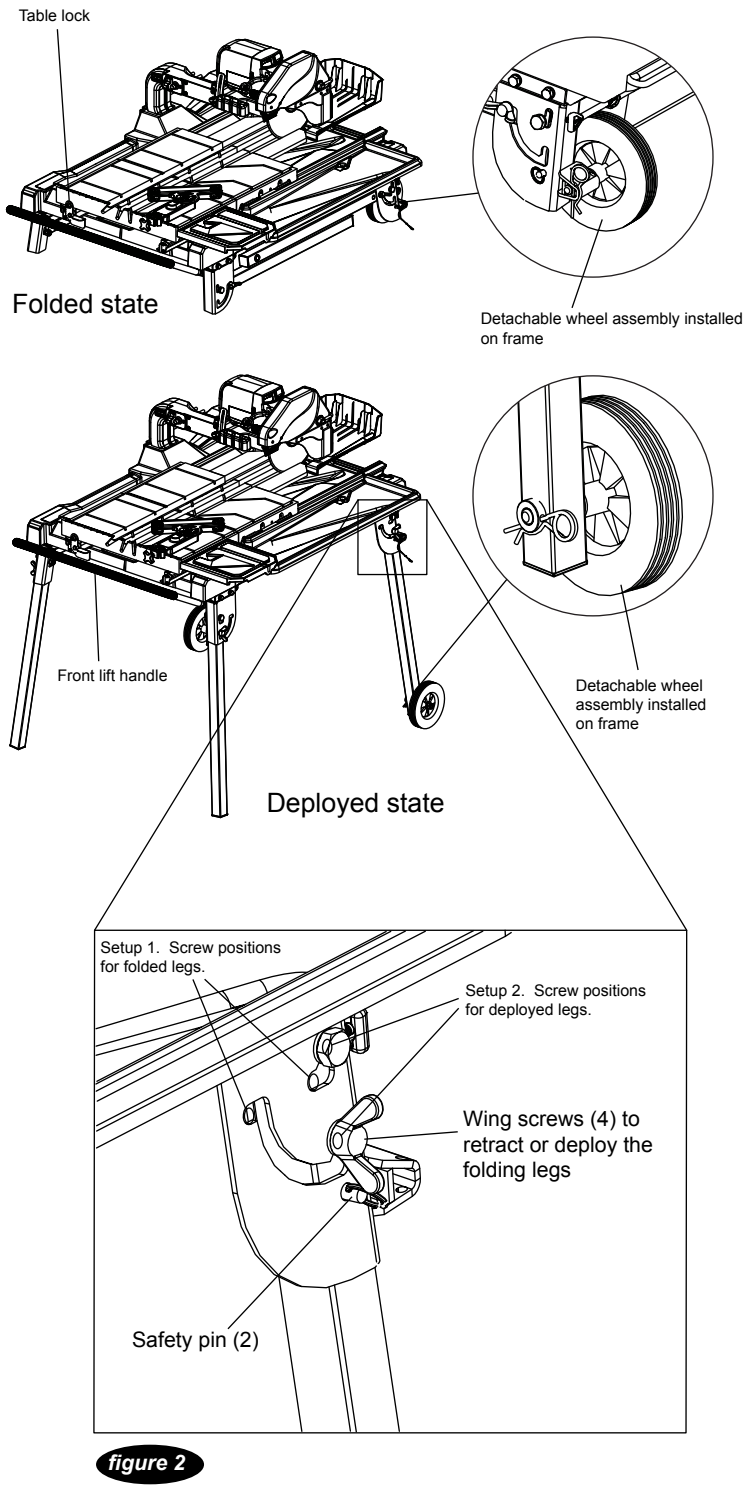


figure 2

NOTE: Refer to SUPPLEMENTARY UNPACKING AND ASSEMBLY INSTRUCTION for more details.

Preparation for Use

BLADE INSTALLATION

1. Turn the silver knob on the inner blade guard counterclockwise until it pops out to unlock the blade guard. ***(see figure 3)***

2. Slide the outer blade guard horizontally across the inner blade guard towards the plunge handle. The tab at the rear of the blade guard must clear the enclosing slot.

3. Rotate the blade guard away so that it lays open. Do not separate the outer guard from the inner guard!

4. Remove the blade shaft nut and outer flange. If a blade has been mounted, hold the blade with one hand or use the provided hex wrench to insert into the slot on the blade shaft 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.

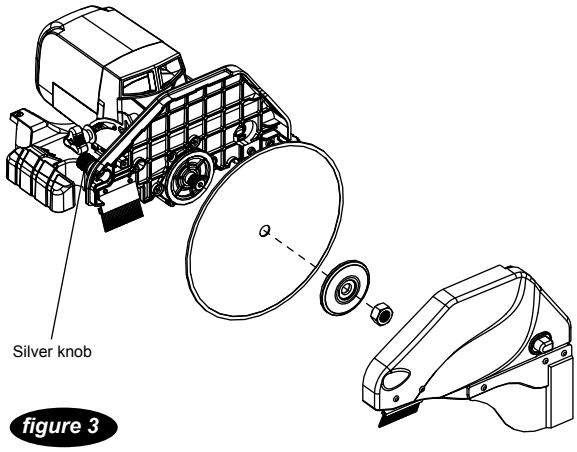


figure 3

OPERATING THE WATER SPRAY SYSTEM

1. Open outer blade guard.

2. Locate the adjustable water nozzle on the outer and inner blade guard. ***(see figure 4)***

3. Using ***figure 4*** on right as reference set the water nozzle to desired effect (minimal mist/max water).

4. Note that the blade has to be removed in order to adjust nozzle on the inner blade guard.

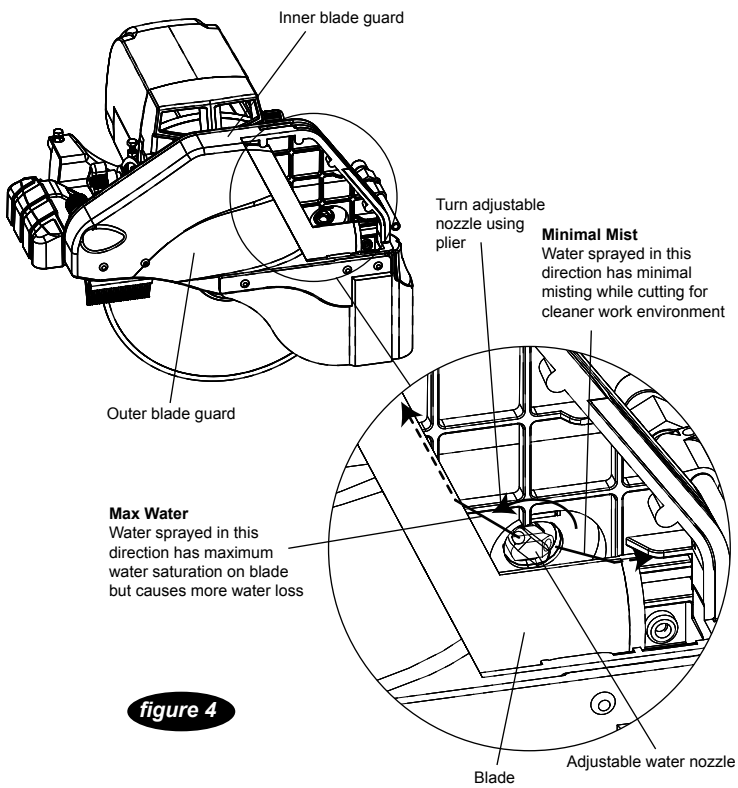


figure 4

WATER PUMP USAGE OPTIONS

Option 1. Water pump can be placed in the top water tray (A). ***(see figure 5)*** Only the top water tray would need water, but care must be taken to not over fill the tray or water will spill out from the over flow hole on the tray.

Option 2. Water pump can be placed in the bottom water tray (B). ***(see figure 5)*** Fill the bottom water tray with water until water almost reaches the opening on the over flow plug. Next fill the top water as instructed above in “option 1”.

Option 3. Water pump can be placed in a bucket (C) placed directly below the over flow plug in the bottom water tray. ***(see figure 5)*** Fill the bucket halfway with water. Next fill the bottom water as instructed above in “option 2”.

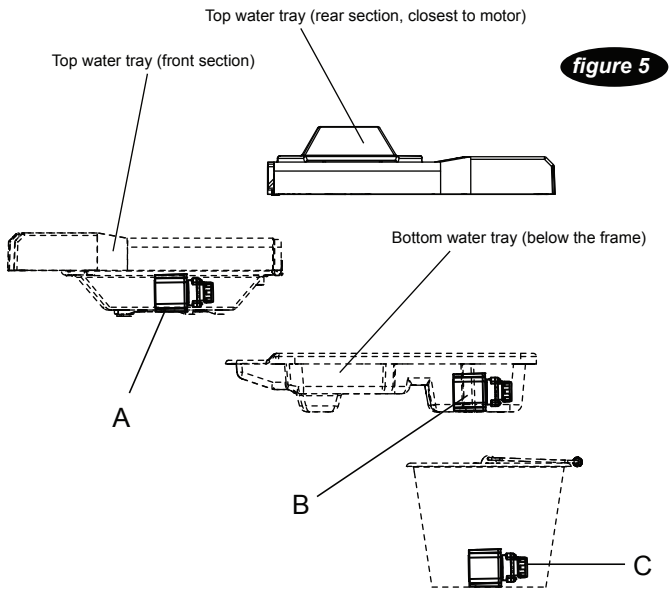


figure 5

⚠ WARNING:

Disconnecting the water pump should be done by a certified electrician.

OVERFLOW PLUG USAGE

Pull the bottom water tray partially out from under the saw. Insert the over flow plug into the hole in the tray. ***(see figure 6)*** Make sure tube is no further than 1-inch from top of tube.

See included SUPPLEMENTARY UNPACKING AND ASSEMBLY INSTRUCTIONAL BOOKLET for more details.

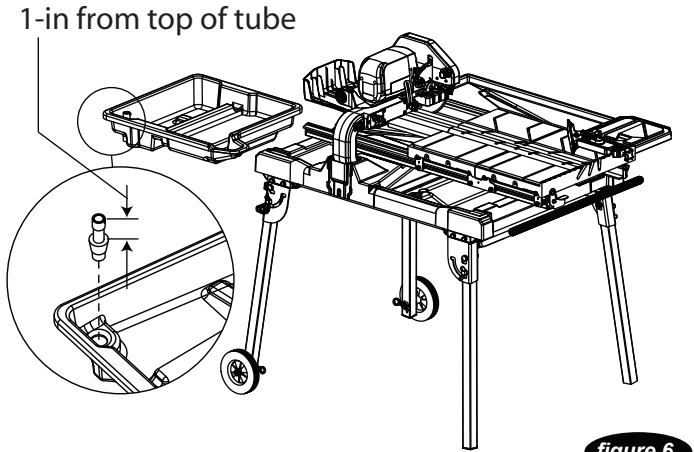


figure 6

CHOOSING THE RIGHT BLADE

1. The blade shaft speed of this saw is exclusively 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. Choose the correct type of saw blade for the material to be cut and the required cutting depth.

Note to dress/sharpen the blade when cutting speed is reduced as it may lead to poor cutting accuracy. Always let the blade cut, do not force.

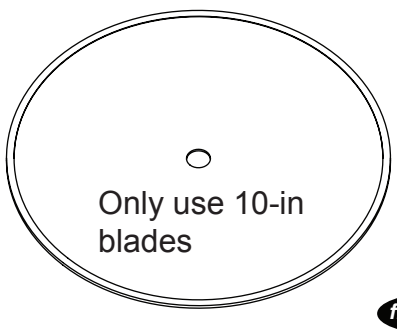


figure 7

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 on the water pump.

3. Place the tile on the table and position the tile such that the flat face of the tile sits flush against the ruller on the table.

4. Line up the tile such that the desired cut lines up with the blade.

5. Deploy the rear scoop and attach the rear drip tray, side extension table and side drip tray as necessary.

6. Level the saw so water runs slightly towards the post.

7. During the cut operation, the user must use both hands to hold the tile in place while also apply even force to push the table forward. Do not force feed the blade for best cut results.

8. Dress the blade occasionaly so the diamonds on the blade do not glaze over.

9. Always turn off the saw before you leave the machine unattended. Unplug the power cable at the end of job.

NOTE: Refer to SUPPLEMENTARY UNPACKING AND ASSEMBLY INSTRUCTION for more setup details.

CUTTING AT CONSTANT DEPTH

The motor should be turned off when adjusting the cutting depth.

1. Before starting the cut, adjust the cutting depth. Loosen the "angle adjustment knob" to adjust the blade cutting depth. ***(see figure 8)*** Be sure to grasp the plunge handle as the head will rise suddenly.

2. Adjust the depth such that the rim of the blade goes past the top of the table by about 1/8". Then retighten the "angle adjustment knob".

3. Turn on the saw.

4. During the cut operation, the user must use both hands to hold the tile in place while also apply even force to push the table forward. Do not force feed the blade for best cut results.

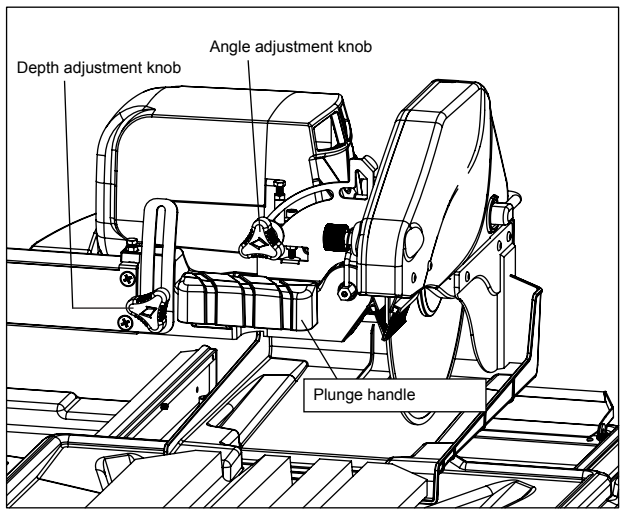


figure 8

PLUNGE CUTS

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

1. Before starting the cut, the cutting head must be fully raised. Loose the "angle adjustment knob" to adjust the blade cutting depth. ***(see figure 8)*** Be sure to grasp the plunge handle as the head will rise suddenly.

2. With the head raised, position the tile such that the blade will make the intended cut. If making long cuts, it is best to use the angle guide to help stabilize the tile.

3. Turn on the saw.

4. With one hand grab the plunge handle and make the plunge cut. During the cut use the free hand to stabilize the table. If doing a long cut push the table forward. Do not force feed the blade for best cut results.

CUTTING DEPTH

The recommended cutting depth is 1/4-in below the cutting table surface. To adjust the depth raise/lower the blade by loosening the depth adjustment knob and use the plunge handle to adjust the blade depth as necessary. ***(see figure 8)***

Blade Diameter	Cutting Depth
10-in	2.4-in

⚠ WARNING:

The blade may grab the material being cut, causing damage and possibly injury.

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° and 180°. The attachment has a casted angle indicator that show markings every 5° with numerical markings every 45°. ***(see figure 9)***

⚠ WARNING:

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

⚠ WARNING:

Always lock the cutting table prior to transporting the saw.

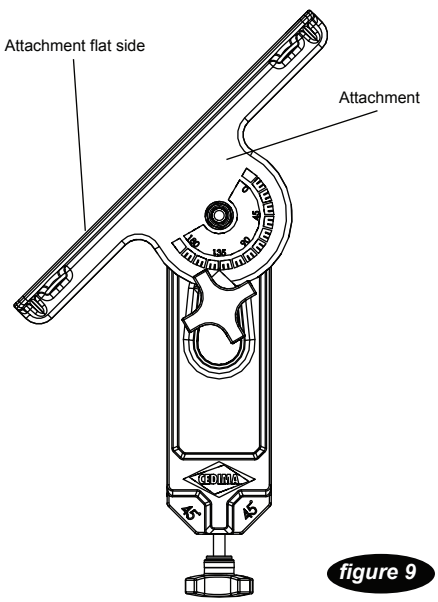


figure 9

USING THE CUTTING TABLE

The ruler guide has inches marked along the top to allow convenient measurements and to promote precision cuts. ***(see figure 10)*** With the side extension table installed, the table spans 28-in x 23.15-in. If equipped with the rear extension the table will span 28-in x 32.2-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 guide should be used together with the cutting table to ensure precision while making cuts.

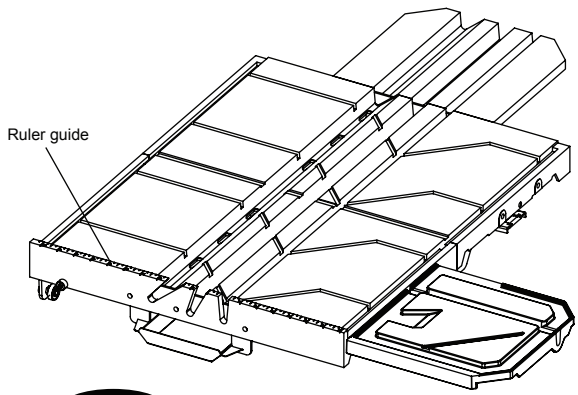


figure 10

USING THE GUIDE FOR RIP AND DIAGONAL CUTS

The motor should be turned off when adjusting the material being cut.

1 **For rip cuts**. Set the tile such that the desired cut lines up with the blade.

2. Next adjust the adjustable angle guide such that the rotating attachment is set at either the 0° or 180° position. 0° if the guide is to be placed to the left of the material, or 180° if the guide is to be placed to the right of the tile. ***(see figure 11)***

3. Position the guide so its attachment's flat side rests flush against the material to be cut. (see figure 8)

4. Tighten the threaded knob. Now you are ready to cut.

5. **For diagonal/angled cuts**. Adjust the adjustable angle guide such that the rotating attachment is set at an angle that matches the desired cut line to be made on the tile.

(continue on page 11)

6. Position the tile to be cut in the position that when the blade engages it, it will result in the desired cut. Since this time the cut is angled, place the guide's attachment's flat side such that it sits flush against the material. Tighten the threaded knob to engage the table ruler guide. Reposition the guide and the material as necessary such that the flush contact is mantained while the blade will still make the intended cut, while making sure the tile is fully inserted in the ruler slot. ***(see figure 12)***

7. Tighten the threaded knob. Now you are ready to cut.

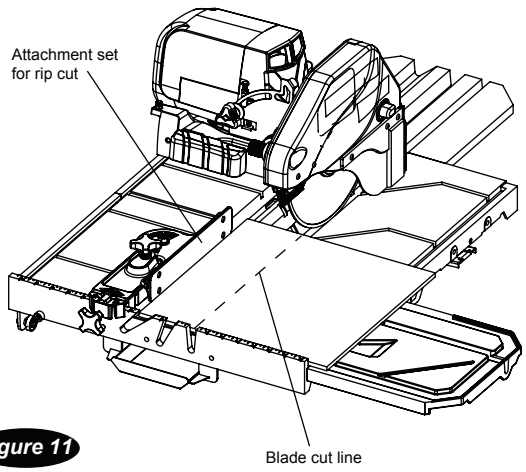


figure 11

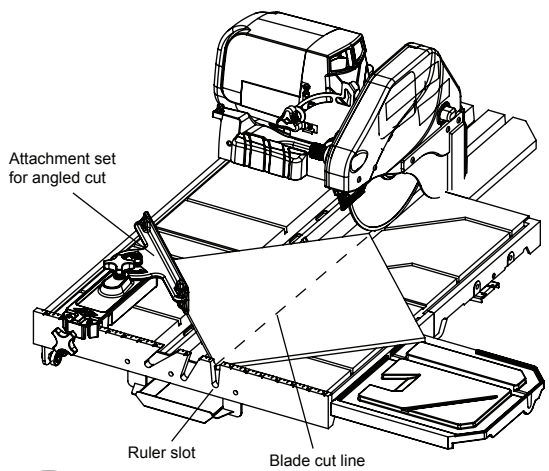


figure 12

PERFORMING MITER CUTS

The motor should be turned off when changing the cutting head's pitch or cutting depth.

1. The cutting head must be parallel with the table before it can be rolled to the miter position. To accomplish this loosen the depth adjustment knob and push the cutting head until the depth adjustment screw bottoms out. ***(see figure 13***

2. Tighten the depth adjustment knob.

3. Pull the cutting table all the way to the front of the saw past the table lock. ***(see figure 2)*** The table must clear the blade before adjusting the cutting head angle.

4. Loosen the angle adjustment knob. Roll/rotate the cutting head to the 45° position. Righten the angle adjustment knob.

5. Now you are ready to make your cut. It is advised to use the adjustable angle guide to support the tile from the right side during these kinds of cuts.

Note to dress/sharpen the blade when cutting speed is reduced as it may lead to poor cutting accuracy. This is especially important for miter cuts. Always let the blade cut, do not force.

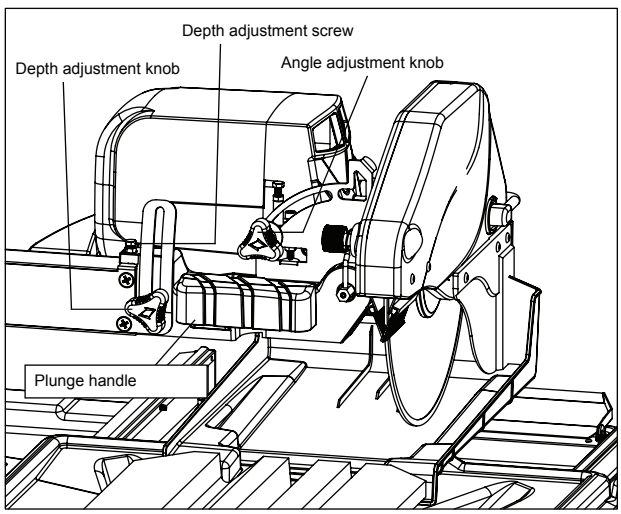


figure 13

Electrical Specifications

	M1030/M1036
Power	2 HP
Volts	115 V
Amps	15 A
Blade Shaft RPM	2800 RPM
Cycle	60 Hz
Phase	1

EXTENSION CORD CHART

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

RECOMMENDED

1. It is recommended that a 15 amp circuit be used while operating this saw. This will prevent any loss of power or interruption.

2. Always plug saw as close as possible to the power source while operating. This will allow you to receive optimum electricity.

POWER SAFETY SYSTEM
(M1036 only)

⚠ *WARNING: The saw should be unplugged before servicing.*

The saw is equipped with an internal electrical safety system. It is meant to notify the user of an electrical issue with the machine and to cut power in response to the following issues:

- When power leak/ground fault is detected between the power switch and the other electrical system, the error light on the power will flash and power will be cut. ***(see figure 14)***
- When power is abruptly cut from the saw (ie unintenional power cable pull out, power failure, etc...) sudden power recovery will not abruptly turn on the saw. The user must manually turn off the power switch and turn it back on.

Note to test the power safety system, press the test button found on the face opposite where the Power and Error LED indicator is located. Reset from the test by toggling the power switch from off to on.

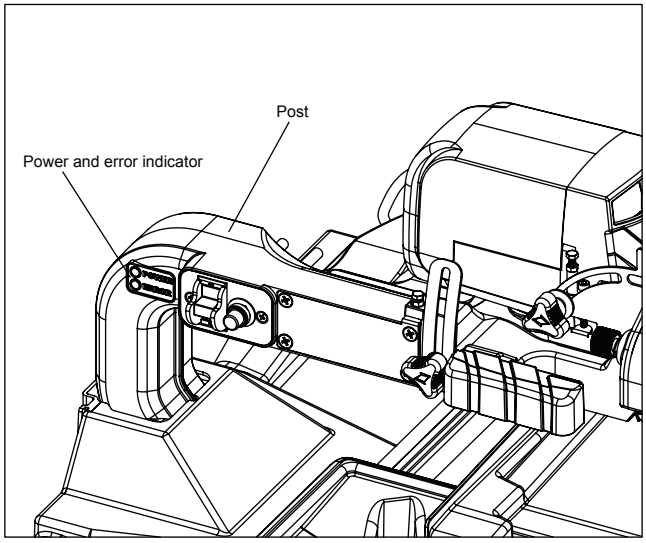
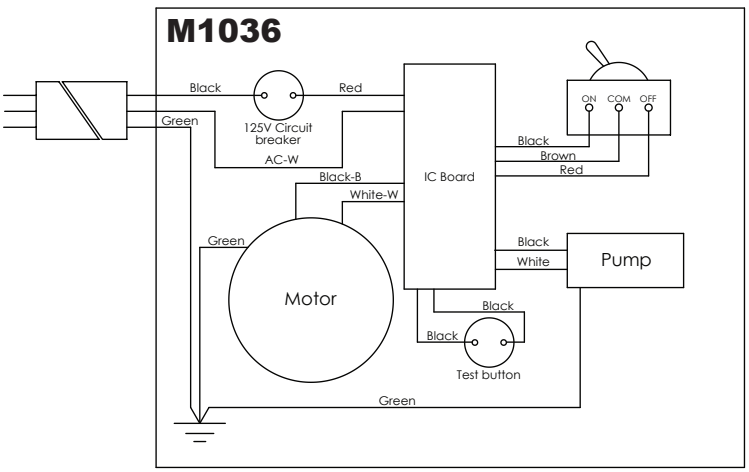
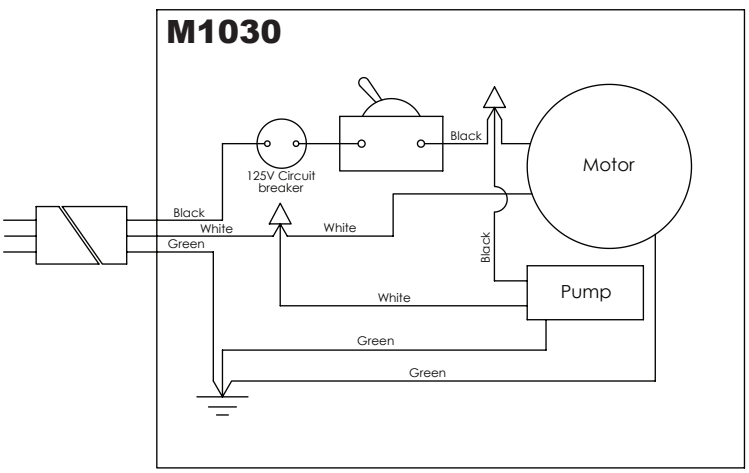


figure 14





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 other 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. Use a soft, low-pressure water jet to rinse out last two holes on the 90 and 45 degree cutting channel on cutting table.
6. Pull out the removable underside cutting table tray to clear it of debris.
7. Do not “rinse” the bearings of the drive elements to prevent them from running dry. The ball bearings of the machine are permanently lubricated.
8. After cleaning, remove all areas that were covered/seal by tape! All screws/nuts which you may have loosened must be tightened again!
9. 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. • Pour water down last two holes on the 90 and 45 degree cutting channel on cutting table to clear it of debris. • Pull out the removable underside cutting table tray to clear it of debris.
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.

See included SUPPLEMENTARY UNPACKING AND ASSEMBLY INSTRUCTIONAL BOOKLET for more details.

⚠ 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 saw as described in the ***Saw Maitenance*** section 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.

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!

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. Remove the water pump from the water tray/container.
2. Clean the water pump exterior.
3. Clean the interior where the fan is by removing the fan cover. If gasket is installed, be careful not to damage it.
4. 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.
5. 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 confirm it can spin effortlessly.
6. Reassemble the fan cover.
7. Turn the saw on briefly to check whether the pump works properly.

⚠ WARNING:

Disconnecting the water pump should be done by a certified electrician.

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
	Ground fault detected within the saw	If error light is flashing on post have the whole electric system of machine checked by a qualified electrician
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
	Ground fault detected within the saw	If error light is flashing on post have the whole electric system of machine checked by a qualified electrician
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 power network checked by a qualified electrician

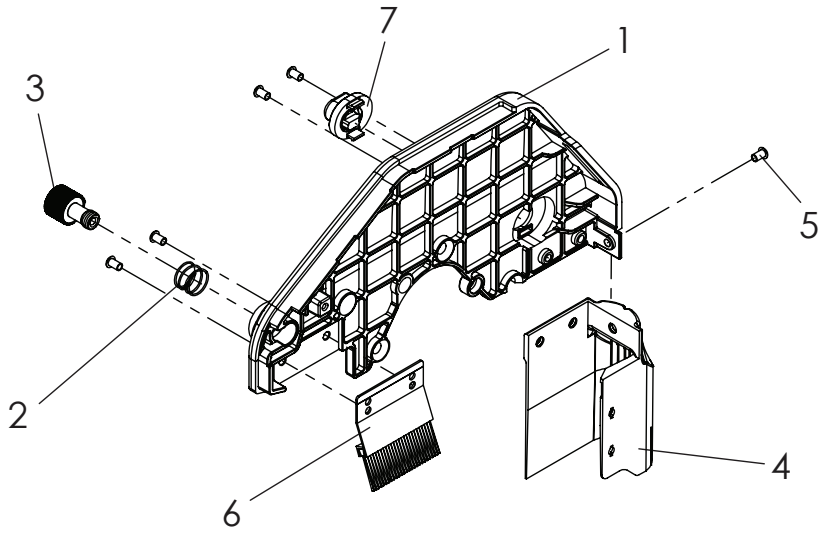
Problem	*Possible Cause*	*Solution*
Insufficient flow of cooling water or no cooling water at all	The pump draws air	Fill the container the pump sits in with water until submerged
	Filter clogged	Clean the filter of the pump
	Pump wheel of the immersion pump blocked by dirt	Disassemble the immersion 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 flanges
		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 flanges
	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
	Blade shaft bearing	Replace the bearing of the blade 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 flanges 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

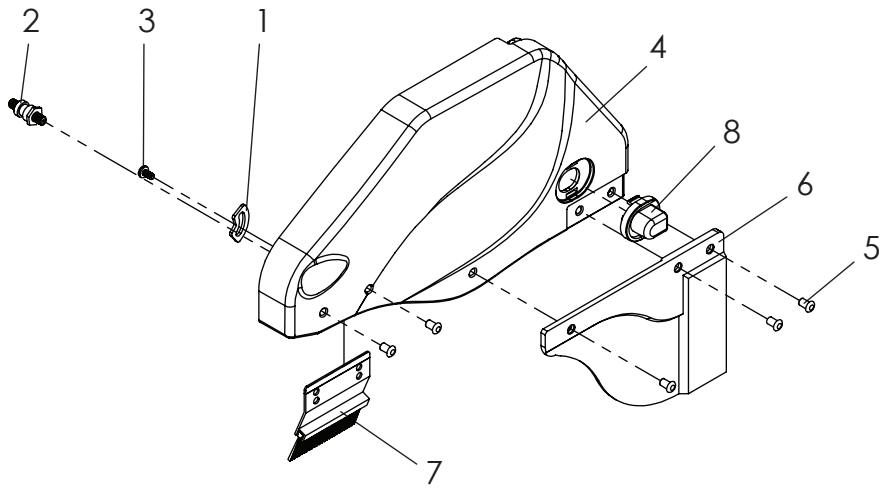
Replacement Parts List

INNER BLADE GUARD ASSEMBLY



	DESCRIPTION	PART NO
1.	Inner blade guard	
2.	Spring	
3.	Hose	
4.	Rubber splash guard A	
5.	M5 Standard rivet	
6.	Brush	
7.	Multi-directional water fitting	

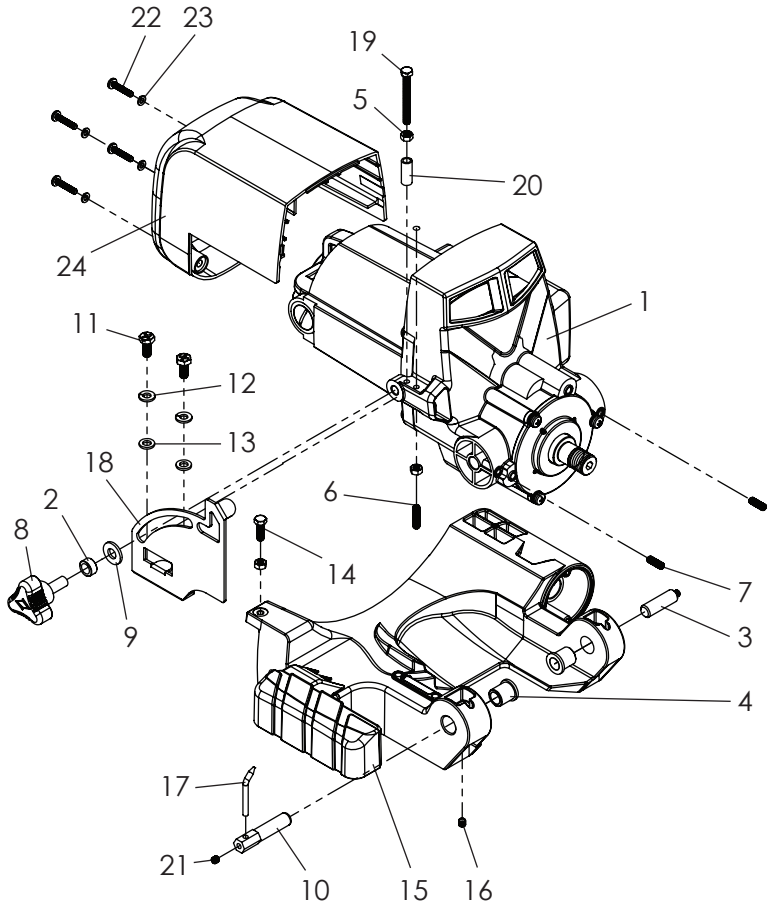
OUTER BLADE GUARD ASSEMBLY



	DESCRIPTION	PART NO
1.	Lock plate	
2.	Snap bar	
3.	M4 x 0.7 x 8L Cross Screw	
4.	Outer blade guard	

	DESCRIPTION	PART NO
5.	M5 Standard rivet	
6.	Splash guard B	
7.	Brush	
8.	Rubber splash guard A	

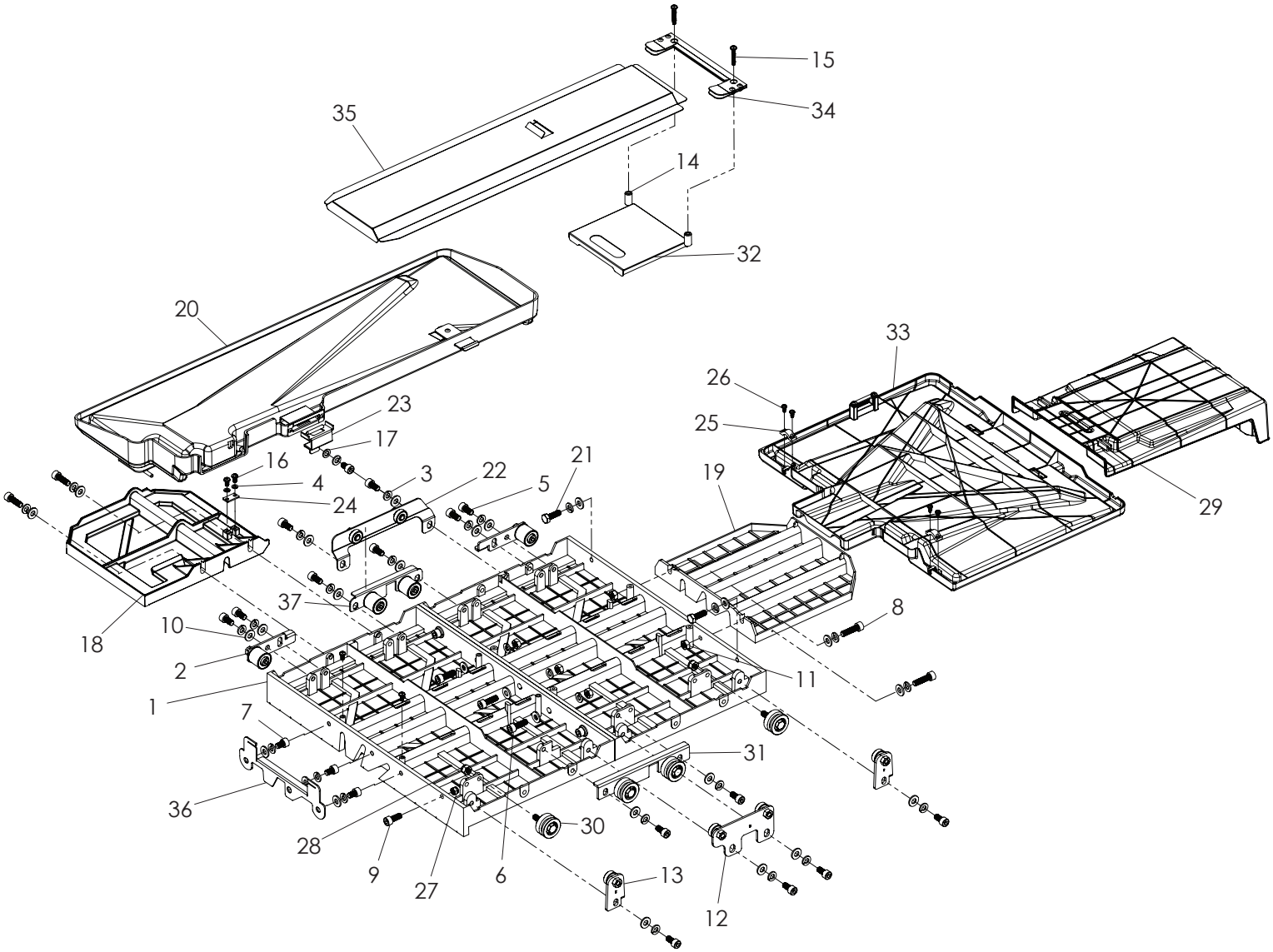
INNER BLADE GUARD ASSEMBLY



	DESCRIPTION	PART NO
1.	Cutting head	
2.	D12.7 x d8.5 x 6L Spacer	
3.	Cutting head shaft	
4.	D14 x d10 x 16L Shoulder bushing	
5.	M5 x 0.8 Nut	
6.	M5 x 0.8 x 30L Flat point set screw	
7.	M5 x 0.8 x 14L Flat point set screw	
8.	M8 x 1.25 x 20L Knob	
9.	M8 Wide washer	
10.	Cutting head angle shaft	
11.	M6 x 1.0 x 15L Cross hex bolt	
12.	M6 Spring lock washer	

	DESCRIPTION	PART NO
13.	M6 Narrow washer	
14.	M5 x 0.8 x 16L Hex bolt	
15.	Motor base	
16	M5 x 0.8 x 6L Flat point set screw	
17.	Pointer	
18.	45 Degree angle ruler	
19.	M5 x 0.8 x 45L Hex bolt	
20.	D8 x d5.5 x 20L Spacer	
21.	M5 x 0.8 x 5L Flat point set screw	
22.	M4 x 0.7 x 20L Cross screw	
23.	M4 Spring lock washer	
24.	Fan cover	

CUTTING TABLE ASSEMBLY



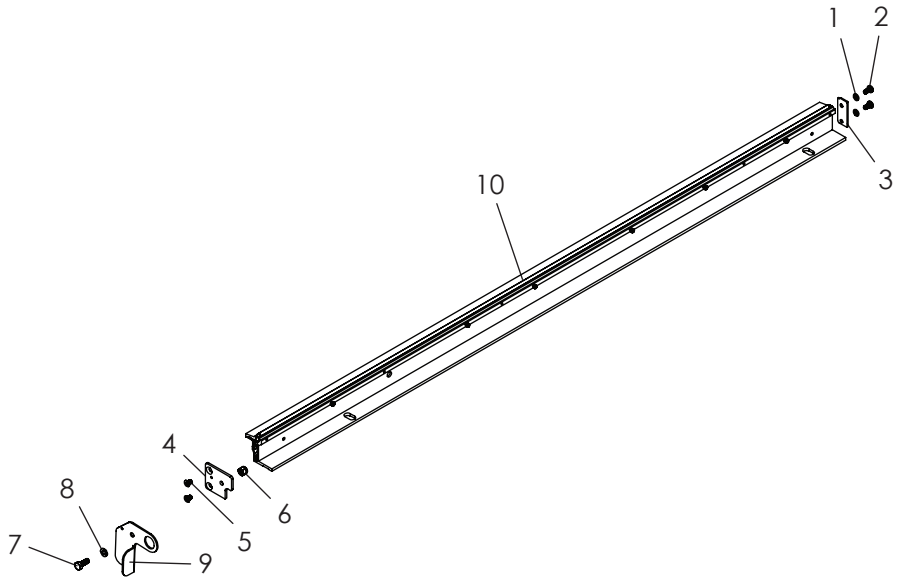
	DESCRIPTION	PART NO
1.	M1036 Table with rubber	
2.	Single flat roller assembly	
3.	M8 Spring lock washer	
4.	M5 Spring lock washer	
5.	M8 x 1.25 x 16L Socket head hex screw	
6.	M8 x 1.25 x 25L Socket head hex screw	
7.	M8 x 1.25 x 12L Socket head hex screw	
8.	M8 x 1.25 x 30L Socket head hex screw	
9.	M8 x 1.25 x 20L Socket head hex screw	
10.	M8 Wide washer	
11.	M8 x 1.25 Nut	
12.	Left opposing dual flat roller assembly	
13.	Single flat roller assembly	
14.	D11 x d5.2 x 19.8L Spacer	
15.	M5 x 0.8 x 30L Cross screw	
16	M5 x 0.8 x 10L Cross screw	
17.	M8 Narrow washer	
18.	Side extension table	
19.	Rear extension table	
20.	Side drip tray	
21.	M8 x 1.25 x 25L Hex bolt	
22.	Right opposing dual flat roller assembly	
23.	Side drip tray mounting bracket	
24.	Rectangular washer	

CUTTING TABLE ASSEMBLY (CONTINUED FROM PAGE 23)

DESCRIPTION	PART NO
25. Screw clamp	
26. M4 x 1.59 x 10L Cross tapping screw	
27. M6 x 1.0 Nylon nut	
28. M8 x 1.25 Nylon nut	
29. Rear splash guard	
30. Type 16 Guide roller assembly	
31. Type 16 Dual guide roller assembly	

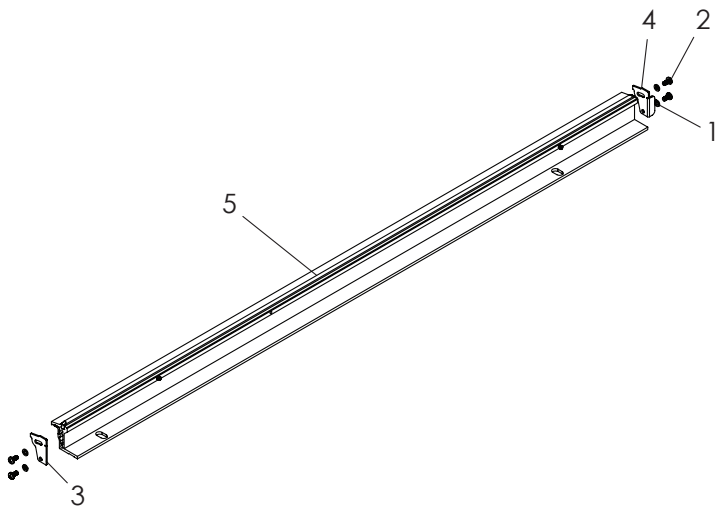
DESCRIPTION	PART NO
32 Fixed underside drip tray	
33. Rear drip tray	
34. Underside tray spring clamp	
35. Removable underside drip tray	
36. Underside tray mounting bracket	
37. Dual flat roller assembly	

LEFT RAIL ASSEMBLY



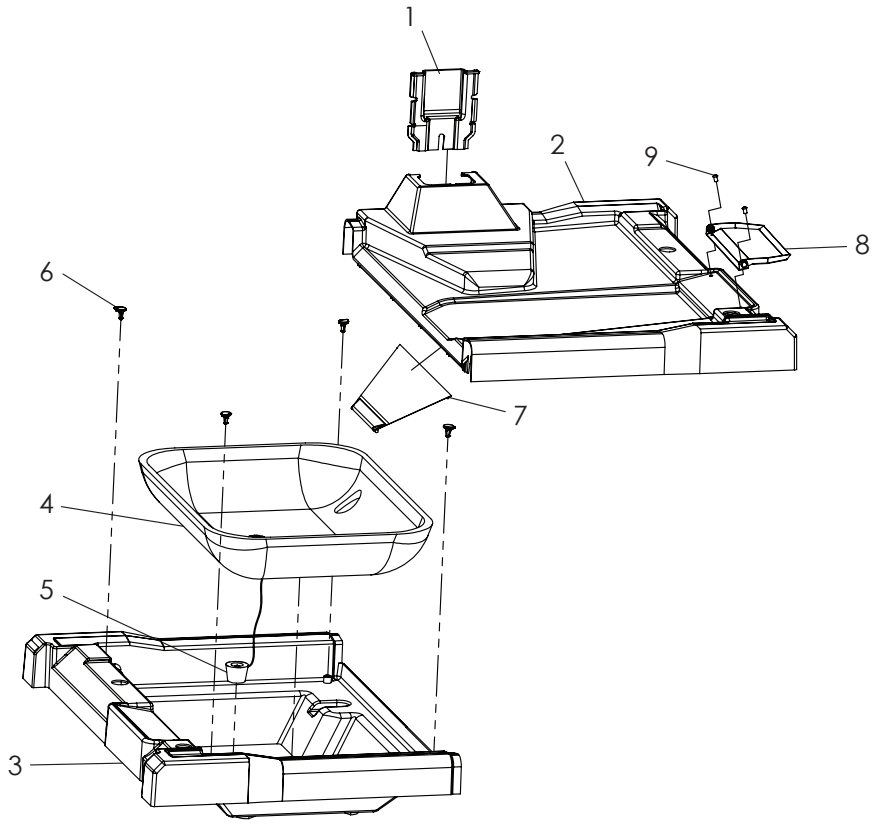
	DESCRIPTION	PART NO		DESCRIPTION	PART NO
1.	M5 Spring lock washer		6.	M6 x 1.0 Nylon nut	
2.	M5 x 0.8 x 10L cross screw		7.	M6 x 1.0 x 16L Hex bolt	
3.	Rail rectangular end cover		8.	M6 Washer, D11.5 x d6.4 x 1.6t	
4.	Table lock rail cover		9.	Table lock	
5.	M5 x 0.8 x 8L Countersunk cross screw		10.	Left rail sub-assembly	

RIGHT RAIL ASSEMBLY



	DESCRIPTION	PART NO		DESCRIPTION	PART NO
1.	M5 Spring lock washer		4.	Rail adjustable end cover w/tab	
2.	M5 x 0.8 x 10L cross screw		5.	Right rail sub-assembly	
3.	Rail adjustable end cover				

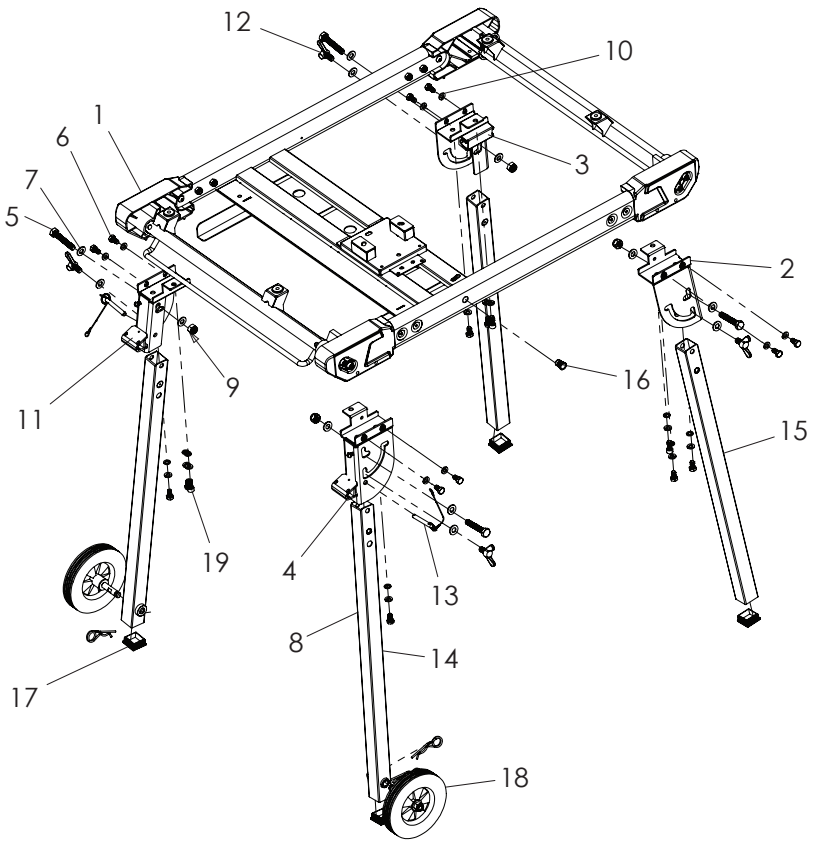
WATER TRAY ASSEMBLY



	DESCRIPTION	PART NO
1.	Water tray side panel	
2.	Rear water tray	
3.	Front water tray	
4.	Debris bag	
5.	Water tray plug assembly	

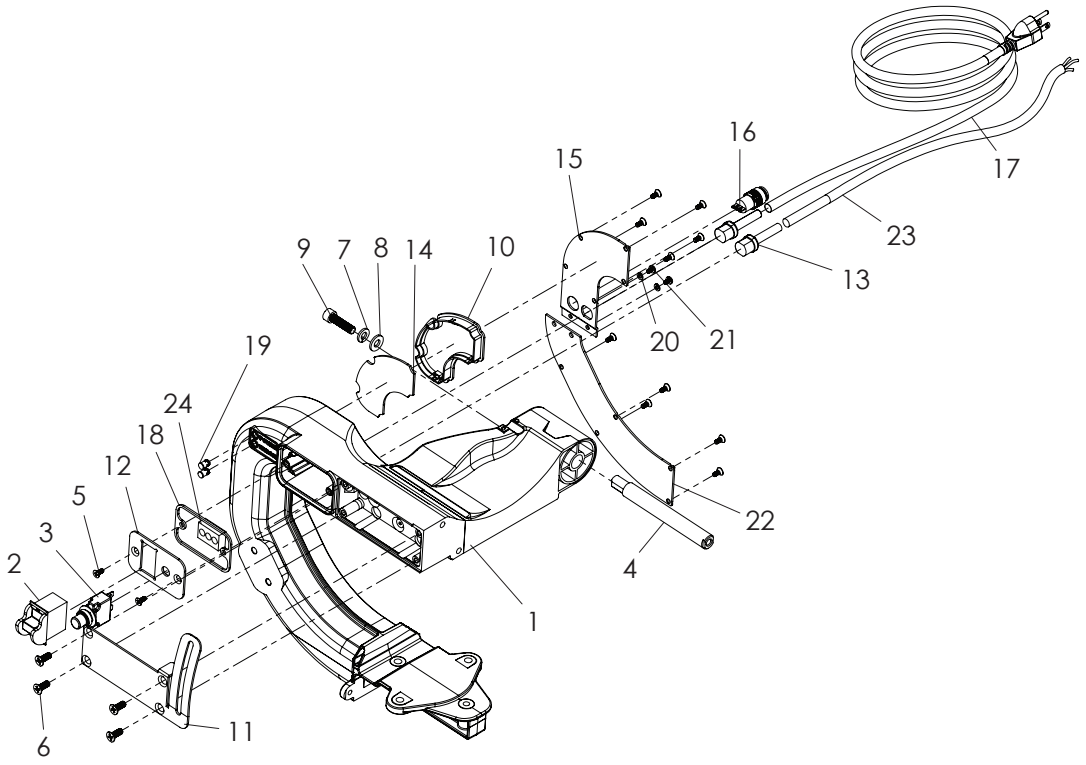
	DESCRIPTION	PART NO
6.	Debris bag hook	
7.	Rear water tray flap	
8.	Rear scoop	
9.	M5 Standard rivet	

FRAME ASSEMBLY



	DESCRIPTION	PART NO
1.	Frame assembly	
2.	Front left frame joint	
3.	Front right frame joint	
4.	Rear left frame joint	
5.	M10 x 1.5 x 60L Hex bolt	
6.	M8 x 1.25 x 16L Hex bolt	
7.	M10 Regular washer	
8.	M8 Narrow washer	
9.	M10 x 1.5 Nylon nut	
10.	M8 Spring lock washer	
11.	Rear right frame joint	
12.	M10 x 1.5 x 20L Wing screw	
13.	D8 x 50L Quick release pin assembly	
14	Rear folding leg	
15.	Front folding leg	
16.	M8 x 1.25 Blind rivet nut	
17.	35mm Square end cap	
18.	6" Wheel assembly	
19.	M8 x 1.25 x 20L Socket head hex screw	

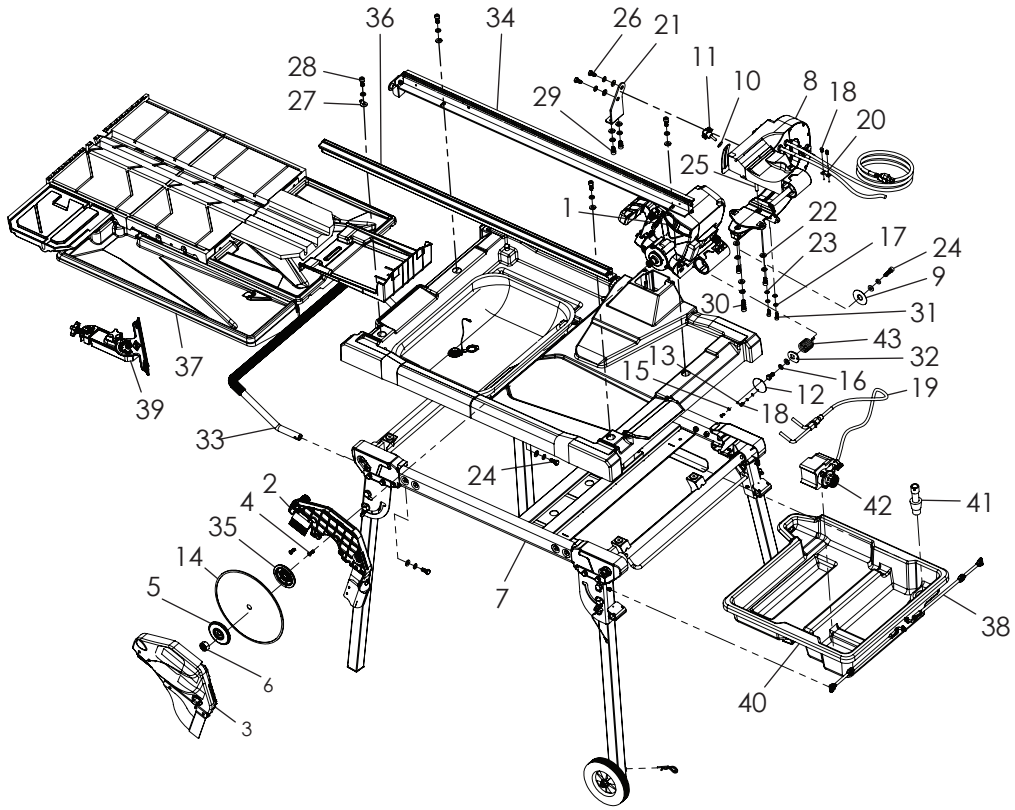
POST ASSEMBLY



	DESCRIPTION	PART NO
1.	Support arm	
2.	20A 125V/12A 250V Toggle switch	
3.	18A/125V Circuit breaker	
4.	Support shaft	
5.	M4 x 0.7 x 10L Countersunk cross screw	
6.	M6 x 1.0 x 16L Countersunk cross screw	
7.	M8 Spring lock washer	
8.	M8 Wide washer	
9.	M8 x 1.25 x 30L Socket head hex screw	
10.	M1036 IC board base	
11.	Depth adjustment plate	
12.	Toggle switch mounting plate	

	DESCRIPTION
13.	14AWG Snap-in cable gland
14.	M1036 IC board
15.	Post top back plate
16	Ground fault test button
17.	14 AWG x 3M NEMA 5-15P Power plug
18.	Toggle switch mounting plate gasket
19.	LED lens
20.	M4 Spring lock washer
21.	M4 x 0.7 x 6L Cross screw
22.	Post bottom back plate
23.	14 AWG Cable for pump
24.	Junction terminal

FRAME ASSEMBLY



1. Cutting head assembly
2. Inner blade guard assembly
3. Outer blade guard assembly
4. M6 x 1.0 x 20L Countersunk cross screw
5. Outer flange
6. 5/8 - 11 UNC Nut
7. Frame assembly
8. Post assembly
9. M8 Very wide washer
10. M6 Wide washer
11. M6 x 1.0 x 20L Knob
12. Spring cover
13. M4 Narrow washer
14. 10 inch blade
15. M4 Spring lock washer
16. M8 Spring lock washer
17. M6 Spring lock washer
18. M4 x 0.7 x 10L Cross screw
19. Water hose assembly
20. Cable clamp
21. Post-frame bracket
22. M8 Wide washer
23. M6 Regular washer
24. M8 x 1.25 x 20L Hex bolt
25. Dowel pin D8 x 35L
26 M8 x 1.25 x 16L Hex bolt
27. Chain anchor mount plate
28. M8 x 1.25 x 20L Socket head hex screw
29. M8 x 1.25 x 16L Socket head hex screw
30. M8 x 1.25 x 30L Socket head hex screw
31. M6 x 1.0 x 16L Socket head hex screw
32. Spring tension plate
33. Front lift handle
34. Left rail assembly
35. Inner flange
36. Right rail assembly
37. Cutting table assembly
38. Water tray retaining band
39. 180 Degree adjustable guide block
40. Lower water tray
41. Overflow plug
42. 253 Gal/hr water pump
43. Spring

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 pro tection, 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 au thorized 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 INCI DENTAL OR CONSEQUENTIAL DAMAGES FOR BREACH OF ANY EXPRESS OR IMPLIED WARRANTY, OR NEG LIGENCE. 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 WARRAN TY 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, ex posure 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