Instructions for Stone Cutting Machine

For your own safety, read all instructions carefully
Before using this machine

Technical data

		RPM	IP	Φ mm	mm	B L mm	β		H B L mm	Kg.
SJ23060	3HP	2800rpm	IP55	(300x25.4) 350x25.4	L=600 B=85(165)	500x510	0°or 45°	600lt/h	L=1145 B=695 H=500	77/97
SJ23080	3HP	2800rpm	IP55	(300x25.4) 350x25.4	L=800 B=85(175)	1050x580	0°-45°	600lt/h	L=1270 B=786 H=735	112/142
SJ23100	3HP	2800rpm	IP55	350x25.4 (300x25.4)	L=1000 B=115(230)	1250x580	0°-45°	600lt/h	L=1470 B=786 H=735	127/157
SJ23120	3HP	2800rpm	IP55	350x25.4 (300x25.4)	L=1200 B=115(230)	1450x580	0°-45°	600lt/h	L=1670 B=786 H=735	137/172

Please Read First

⚠ **WARNING!**
When using electric tools basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury including the following.

- Read these instructions before attempting to operate this product and save these instructions.
- If you notice transport damage while unpacking, notify your supplier immediately. Do not operate the saw!
- Dispose of the packing in an environmentally friendly manner. Take to a proper collecting point.
- Keep these instructions for reference on any issues you may be uncertain about.

General safety instructions

1. Keep work area clear
   - Cluttered areas invite injuries.

2. Consider work area environment
   - Do not expose tools rain.
   - Do not use tools in damp or wet locations.
   - Keep work area well lit.
   - Do not use tools in the presence of flammable liquids of gases.

3. Guard against electric shock
   - Avoid body contact with earthed or grounded surfaces. (e.g. pipes, radiators, ranges, refrigerators).

4. Keep other persons away,
   - Do not let persons, especially children, not involved in the work touch the tool or the extension cord and keep them away from the work area.

5. Store idle tools
   - When not in use, tools should be stored in a dry locked up place. Out of reach of children.

6. Do not force the tool
- It will do the job better and safer at the rate for when it was intended.

7. Use the right tool
   - Do not force small tools to do the job of a heavy duty tool.
   - Do not use tools for purposes not intended.

8. Dress properly
   - Do not wear loose clothing or jewellery, they can be caught in moving parts.
   - Non-skid footwear is recommended.
   - Wear protective hair covering to contain long hair.

9. Use protective equipment
   - Use safety glasses.
   - Use face or dust mask if working operations create dust.

10. Do not abuse the cord
   - Never yank the cord to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.

11. Do not overreach
   - Keep proper footing and balance at all times.

12. Maintain tools with care
   - Keep cutting tools sharp and clean for better and safer performance.
   - Follow instructions for lubricating and changing accessories.
   - Inspect tool cords periodically and if damaged have them repaired by an authorized service facility.

   - Inspect extension cords periodically and replace if damaged.
   - Keep handles dry, clean and free from oil and grease.

13. Disconnect tools
   - When not in use, before servicing and when changing

accessories such as blades, bits and cutters, disconnect tools from the power supply.

14. Remove adjusting keys and wrenches
- Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.

15. Avoid unintentional starting
- Ensure switch is in "off" position when plugging in.

16. Use outdoor extension leads
- When the tool is used outdoors, use only extension cords intended for outdoor use and so marked.

17. Stay alert
- Watch what you are doing use common sense and do not operate the tool when you are tired.

18. Check damaged parts
- Before further use of tool, it should be carefully checked to determine that it will operate properly and perform its intended function.
- Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation.
- A guard or other part that is damaged should be properly repaired or placed by an authorized service center unless otherwise indicated in this instruction manual.
- Have defectives switches replaced by an authorized service center.
- Do not use the tool if the switch does no turn it on and off.

19. ⚠ **Warning**
- The use of any accessory or attachment other than one recommended in this instruction manual may present a risk of personal injury.
- Use only saw blades for which the maximum possible speed is not less than the maximum spindle speed of the tool and the tool and the material to be cut.
- When transporting the machine use only transportation devices and do never use guards for handling or transportation.
- Do not use saw blades which are damaged or deformed.
- Wear respiratory protection to reduce the risk of inhalation of harmful dust.

20. Have your tool repaired by a qualified person. This electric tool complies with the relevant safety rules. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user.

Unpacking

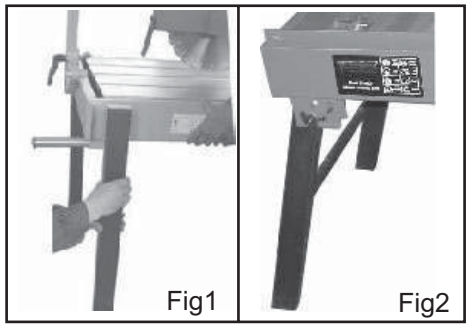
Note:
Make sure all items are accounted for before discarding any packaging material.

Warning:
To avoid injury, if any parts are missing, do not attempt to assemble the machine, do not plug in the power cord, do not turn the switch on until missing parts are obtained and installed correctly.

Installation

Warning:
Do not lift the saw without help.
The saw is too heavy to lift without help, customers should seek assistance from staff to lift this machine.

After unpacking, install all the loosen parts on the main body in according to the explosion drawing on the manual. Make sure all the loosen parts correctly installed.



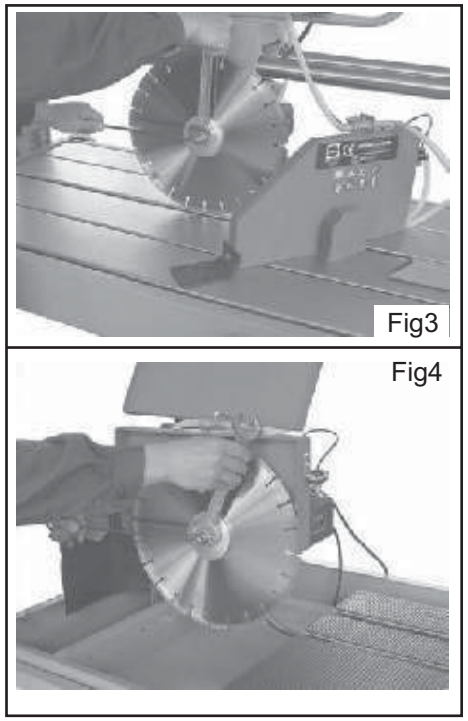
Installing support legs

Note:
To portably turn the head assembly for bevel cutting, in stead of two hex screws on two support brackets (model 800,1000,1200) or on up-down frame (model 600) by two ratchet levers M14x50 in "bag of loosen parts".

Replacing the Saw Blade (Disc)

Warning:
Make sure the switch is off, and your saw is unplugged in power supply. Failure to do so could result in serious personal injury.

- Loosen screws on blade guard, and remove the blade guard.
- Insert a steel bar or a screw driver into the hole on shaft, and loose the 30mm blade nut with 30mm spanner, remove the blade nut and blade flange. Carefully remove the worn blade disc.
- Place new blade disc onto the saw arbor shaft, and sure the disc rotation direction must be clockwise. Place the blade flange and blade nut onto saw arbor shaft. Then insert a screw driver into the shaft hole and tighten the blade nut with 30mm spanner.
- Re-install the blade guard.
- Check the spacer between the blade guard and blade. Keep the blade free from blade guard. And keep the water tube free from blade disc.
- Tighten the screws on blade guard, and always have blade guard installed during operation.

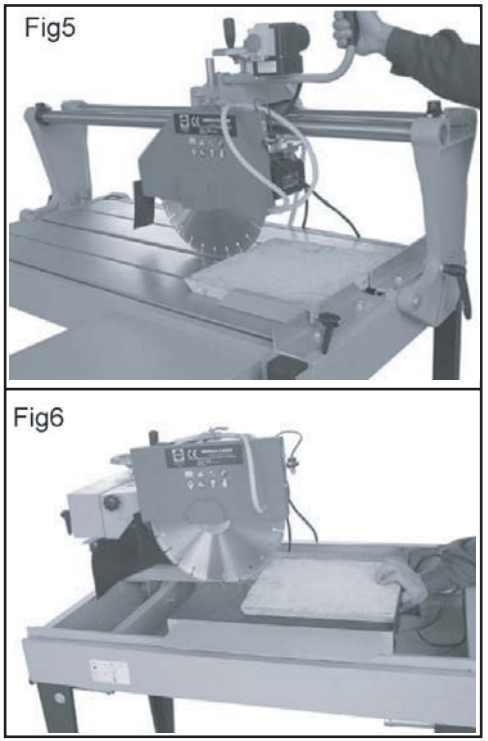


Replacing the saw blade

Operation

90° Cutting

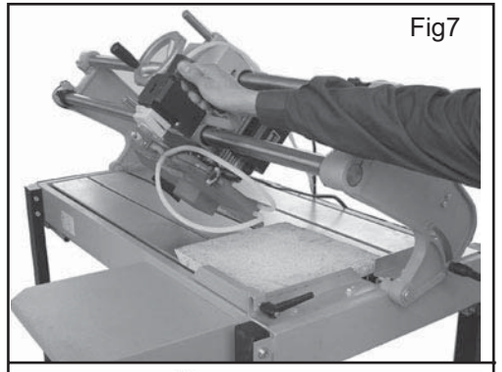
- Fill the tank with water and keep the water pump sunk into water.
- Check the angle of saw blade with the work table by a combination square, if the saw blade in not 90° with the work table, loosen the two ratchet lever on support bracket to adjust.
- Fix the workpiece on table, the end of workpiece is against the guide bracket, the side of workpiece against the guide board.
- Plug the power cables for main machine and laser guide to power supply.
- Turn the hand-wheel to set depth of cut.
- To straightly cut the workpiece, check the laser guide, make sure the laser guide with saw blade in a line.
- Turn the switch on, check the water supply, if necessary adjust the water-cock on the upper of blade guard. Make sure the water is sprayed on the two sides of saw blade.
- Pull the head handle backward to workpiece for cutting(model 800,1000,1200).
- Push the work table forward for cutting (Model 600).

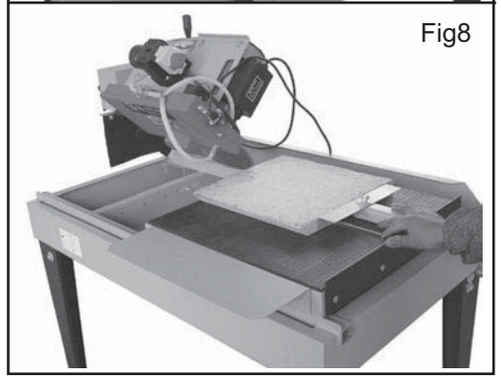


90° cutting

Bevel cutting

- The head assembly can be tilted from 0° to 45° for bevel cutting. (model 800, 1000,1200)
- Loosen two ratchet levers on support brackets, turn the head to desired angle. Then re-tighten two ratchet levers. (model 800, 1000,1200)
- The head assembly can be turned to 45° for 45° bevel cutting. (model 600)
- Loosen two ratchet levers on the up-down frame, turn the head assembly 45 degrees. Then re-tighten two ratchet levers. (model 600)
- Then performance the cutting as normal cut.





Bevel cutting

Caution:

- Do not over force the workpiece, otherwise may cause the blade disc overheat.
- When cut a long or thick workpiece, the blade disc must backward to avoid overheat more-times.
- When cutting, must keep the workpiece stably and avoid sliding.

Risk of kickback

- Do not attempt to stop the saw blade by pushing the work-piece against its side.
- Never cut several work-pieces at the same time and also no bundles containing several individual pieces.

Risk of personal injury if individual pieces are caught by the saw blade uncontrolled.

- Turn off the saw, when you finish one time of cutting.
- Make sure the saw is turned off and disconnected from power supply, when you leave the saw.

Maintenance

Before switch on

- Visual check if distance blade disc- blade guard is 1-2mm.
- Visual check of power cable and power cable plug for damage.

Daily

Warning

Don't drop the water onto the motor and switch. Make sure the saw is turned off and disconnected from power supply before clean the saw.

- Clean table, tank with brush or soft damp cloth.
- Dry the water tank with soft damp cloth or foam after dairy operation.
- Clean the water pump with sprinkler, don't dismantle the water pump.

Monthly

- Apply a light coat of oil to guide element: up-down frame, rotating frame, guide rail, up-down thread rail and swivel elements etc.

Trouble Shouting Guide

Warning

Before carrying out any fault service or maintenance work always:

- Switch machine OFF
- Unplug power cable
- Wait for saw table to come to standstill.

Motor is slow or weak:

Voltage from source is low

- Request a voltage check from local power company

Windings are burned out or open.

- Have the Motor checked / repaired.

Power Switch is defective.

- Have the Power Switch replaced.

Motor overheats:

Motor is overloaded.

- Request a voltage check from the local power company.

Dull saw blade.

- Replace the saw blade.

The machine is vibrative when cutting:

The direction of saw blade runing is anticlockwise

- Keep the direction of saw blade running clockwise

The handles for adjusting cutting depth or bevel cutting is loosen

- Tighten the handles for adjusting cutting depth or bevel cutting

Bore diameter of saw blade is unmatched with the diameter of motor axis.

- Replace the saw blade

Track of blade cutting is deflective :

The saw blade is bent, broken, or dirt

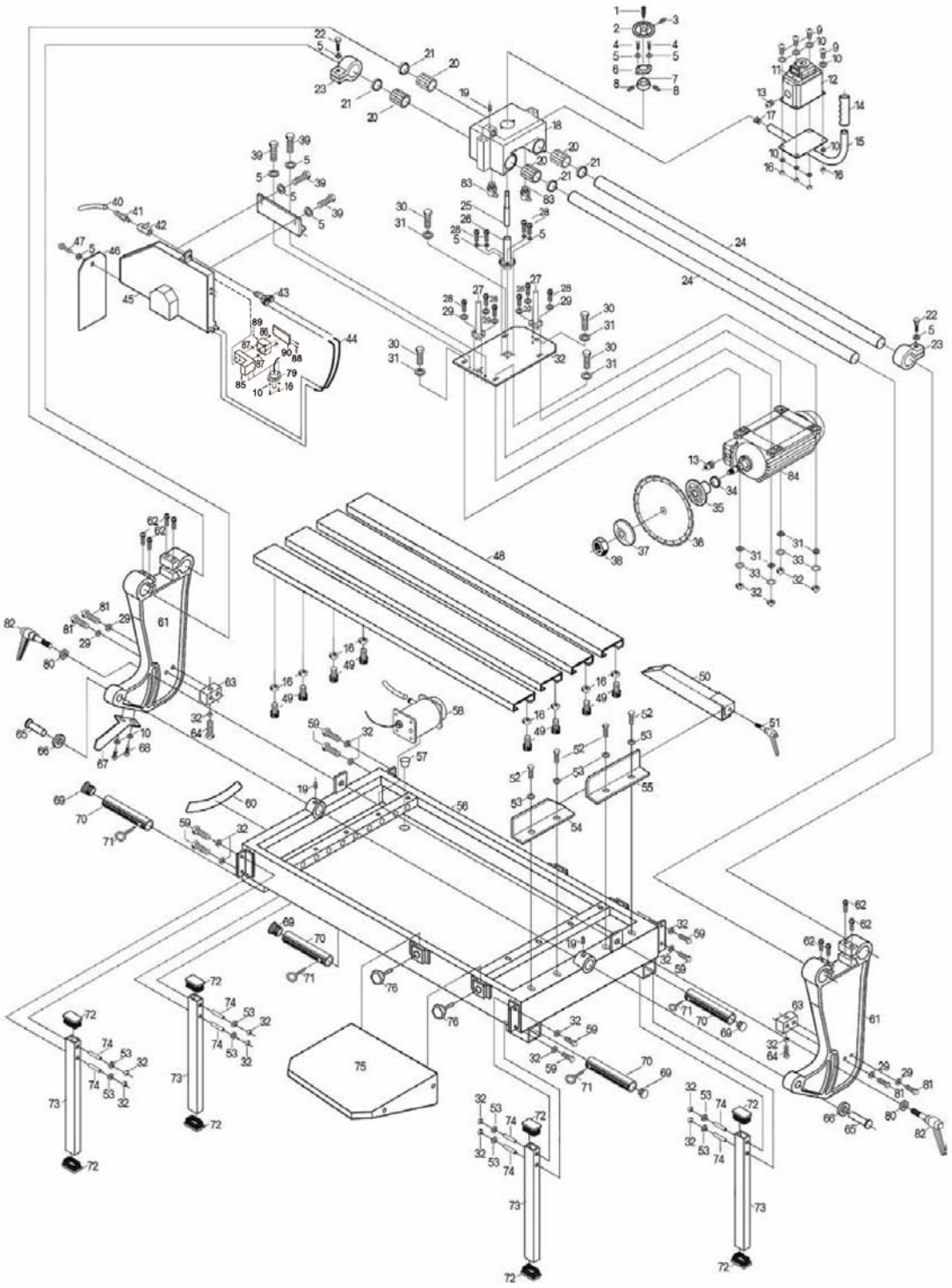
- Replace or clean the saw blade

The laser guide is deflective

- Adjust the laser guide

Partlist

1 Knob
2 Handwheel
3 Slotted set screw with flat point M6x10
4 Hexagon head bolt M6x18
5 Flat washer 6mm
6 Ball box
7 Ball bearing
8 Slotted set screw with flat point M5x16
9 Cross Recessed pan head screw M5x16
10 Flat washer 5mm
11 Switch
12 Switch box
13 Strain relief
14 Handle sleeve
15 Handle
16 Hexagon nut M5
17 Handle end cap
18 Slide case
19 Hexagon socket set screw with flat point M8x10
20 Bush
21 Oil seal
22 Flower bolt
23 Fixing device
24 Round rail
25 Up-down thread
26 Nut sleeve
27 Guide axle
28 Hexagon socket cap head screw M6x16
29 Flat washer 8mm
30 Hexagon head bolt M8x30
31 Large washer 8mm
32 Hexagon nut M8
33 Spring washer 8mm
34 Oil seal for motor
35 Flange
36 Blade
37 Flange
38 Thin hexagon nut, special
39 Hexagon head bolt M6x12
40 Hose
41 Hose connector
42 Valve
43 Tee joint
44 Hose
45 Blade guard
46 Rubber guide board
47 Cross Recessed pan head screw M6x10
48 Work table plate
49 Hexagon socket cap head screw M5x10
50 Adjusting guide board
51 Ratchet lever M8x15
52 Hexagon head bolt M10x25
53 Large washer 10mm
54 Left side guide bracket
55 Right side guide bracket
56 Water case
57 Water case plug
58 Water pump
59 Hexagon head bolt M8x75
60 Angle
61 Support bracket for round rail
62 Hexagon socket cap head screw M8x45
63 Spacing block
64 Hexagon head bolt M8x35
65 Support bracket axle
66 Flat washer 20mm
67 Pointer
68 Cross Recessed pan head screw M5x10
69 Carry handle end cap
70 Carry handle
71 Split pin
72 Leg end cap
73 Support leg
74 Lock sleeve
75 Extension table
76 Flower screw
77 Cross Recessed pan head screw M5x16
79 Laser guide & mount
80 Large washer 14mm
81 Hexagon head bolt M8x25
82 Ratchet lever M14x50
83 Sprue
84 Motor
85 Laser box
86 Cross pan head screw M5x14
87 Spring washer
88 Cross pan head screw M5x10
89 Transformer & box
90 Cover, laser box



Partlist

1 Knob
2 Handwheel
3 Slotted set screw with flat point M5x12
4 Adjustable handle
5 Large washer 10mm
6 Bush
7 Cross recessed pan head screw M5x12
8 Flat washer 5mm
9 Up-down frame
10 Square-necked bolt M10x25
11 Hexagon socket set screw with flat point M6x20
12 Hexagon Nut M6
13 Flat washer M5
14 Bush
15 Hexagon head bolt M12x25
16 Square-necked bolt M10x80
17 Lower cover board
18 Corner fence
19 Rubber board
20 Press board
21 Round head rivet
22 Rotating frame
23 Square-necked bolt M10x120
24 Flat washer 10mm
25 Self-locking nut M10
26 Large washer 12mm
27 Self-locking nut M12
28 Spring seat
29 Spring
30 Slotted set screw with flat point M5x12
31 Spring adjusting cap
32 Flower bolt
33 Hexagon head bolt M10x25
34 Motor mount
35 Hexagon head bolt M8x30
36 Large washer 8mm
37 Spring washer 8mm
38 Hexagon nut M8
39 Motor
40 Strain relief
41 Sealing ring
42 Switch
43 Hose connector
44 Bush
45 Hose
46 T - joint
47 Valve
48 Hose
49 Water pump
50 Blade guide left
51 Flat washer 6mm
52 Hexagon socket set cylinder-head screw M6x10
53 Thread shaft
54 Hexagon socket set cylinder-head screw M6x12
55 Thin hexagon nut, Left M20
56 Flange Left
57 Flange Right
58 Blade guide right
59 Rubber guide board
60 Cross Recessed pan head screw M5x10
61 Nut
62 Water case
63 Side guide board
64 Extension table
65 Table
66 Sleeve
67 "V" shape wheel
68 Ball bearing 80200
69 Circlips
70 Hexagon nut M10
71 Hexagon nut M5
72 Bending plate for table
73 Support leg A
74 Support leg B
75 End cap, tube
76 Wing nut M8
77 Water case plug
78 Hexagon head bolt M8x50
79 Hexagon head bolt M10x30
80 Square-necked bolt M6x15
81 Wing shape nail M8x22
82 Blade
83 Angle
84 Guide seat
85 Wing shape nail M10x22
86 Cross Recessed pan head screw M5x14
87 Spring washer
88 Laser guide & mount
89 Spring washer
90 Cover, Laser box
91 Laser box
92 Transformer & box
93 Hex. bolt M8x50
94 Hex. bolt M8x45
95 Hex. bolt M8x25
96 Self-locking nut M8
97 Washer M8
98 Stop plate, table
99 Handle, Stop plate