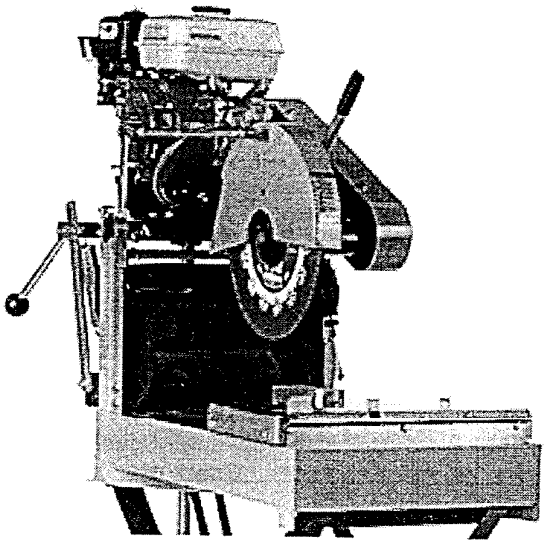
OPERATING INSTRUCTIONS AND PARTS LIST
INSTRUCCIONES DE OPERACION Y LISTA DE PIEZAS



MASON MITE II Masonry / Refractory Saw
Model SPS-55
(5.5hp Honda Gasoline Engine)

FELKER®

17400 West 119th Street
Olathe, KS 66061
Customer Service 800-288-5040
Corp. Office 913-928-1000
Cust. Service FAX 800-825-0028
Corp. Office FAX 913-438-7951
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Internet ..... http://www.targetdbi.com

DIAMANT BOART INC.

0AF04067

Printed in U.S.A.

SAFETY WARNINGS FOR OPERATION OF THIS MACHINE

DO Read this entire operator's manual before operating this machine. Understand all warnings, instructions, and controls.
DO keep all guards in place and in good condition.
DO wear safety approved hearing, eye, head and respiratory protection.
DO read and understand all warnings and instructions on the machine.
DO read and understand the symbol definitions contained in this manual.
DO keep all parts of your body away from the blade and all other moving parts.
DO know how to stop the machine quickly in case of emergency.
DO shut off the engine and allow it to cool before refueling.
DO inspect the blade, flanges and shafts for damage before installing the blade.
DO use only reinforced abrasive blades or steel center diamond blades manufactured for use on masonry saws.
DO use only blades marked with a maximum operating speed greater than the blade shaft speed. Verify speed by checking blade shaft rpm and pulley diameters and blade flange diameters.
DO verify saw drive configuration by checking blade shaft RPM, pulley diameters, and blade flange diameter.
DO read all safety materials and instructions that accompany any blade used with this machine.
DO inspect each blade carefully before using it. If there are any signs of damage or unusual wear, **DO NOT USE THE BLADE.**
DO mount the blade solidly and firmly, Wrench tighten the arbor nut.
DO make sure the blade and flanges are clean and free of dirt and debris before mounting the blade on the saw.
DO use dry cutting diamond blades with a 5/8" diameter arbor only. Never use damaged or worn blade flanges.
DO use the correct blade for the type of work being done. Check with blade manufacturer if you do not know if blade is correct.
DO operate this machine only in well ventilated areas.
DO instruct bystanders on where to stand while the machine is in operation.
DO establish a training program for all operators of this machine.
DO clear the work area of unnecessary people. Never allow anyone to stand in front of or behind the blade while the engine is running.
DO make sure the blade is not contacting anything before starting the engine.
DO always tie down the machine when transporting.
DO use caution and follow instructions when setting up or transporting the machine.
DO have all service performed by competent service personnel
DO verify the blade arbor hole matches the machine spindle before mounting the blade.
DO always check for buried electrical cables before sawing. If unsure, contact the local utilities.
DO Move the machine at least 10 feet (3 meters) from the fueling point before starting the engine and make sure the gas cap on the machine and the fuel can is properly tightened.
DO clean the machine after each day's use.
DO remove adjusting keys and wrenches from tool before turning it on.
DO keep the handles dry, clean and free of oil and dirt.
DO carefully maintain and clean for better and safer performance. Follow instructions for changing accessories. Inspect tool cords periodically and, if damaged, have repaired by authorized service facility.
DO use the proper blade flange size for each blade size. Never use damaged or worn blade flanges.
DO use caution when handling fuel.
DO only cut in a straight line.
DO only saw as deep as the job specifications require.
DO always give a copy of this manual to the equipment user. If you need extra copies, call TOLL FREE 1-800-288-5040.

DO NOT operate this machine unless you have read and understood this operator's manual.
DO NOT operate this machine without the blade guard, or other protective guards in place.
DO NOT stand behind or in front of the blade path while the engine is running.
DO NOT leave this machine unattended while the engine is running.
DO NOT work on this machine while the engine is running.
DO NOT operate this machine when you are tired or fatigued.
DO NOT use this saw in a wet cutting operation.
DO NOT use a wet blade without adequate water supply to the blade.
DO NOT exceed maximum blade speed shown for each blade size. Excessive speed could result in blade breakage.
DO NOT operate the machine if you are uncertain of how to run the machine.
DO NOT use damaged equipment or blades.
DO NOT touch or try to stop a moving blade with your hand.
DO NOT cock, jam, wedge or twist the blade in a cut.
DO NOT transport a cutting machine with the blade mounted on the machine.
DO NOT use a blade that has been dropped or damaged
DO NOT use carbide tipped blades.
DO NOT use conventional abrasive blades with water.
DO NOT use segmented diamond blades without water unless specifically designed for dry cutting.
DO NOT touch a dry cutting diamond blade immediately after use. These blades require several minutes to cool after each cut.
DO NOT use damaged or worn blade flanges.
DO NOT allow other persons to be near the machine when starting, refueling, or when the machine is in operation.
DO NOT operate this machine in an enclosed area unless it is properly vented.
DO NOT operate this machine in the vicinity of anything that is flammable. Sparks could cause a fire or an explosion.
DO NOT allow blade exposure from the guard to be more than 180 degrees.
DO NOT operate this machine while using drugs or alcohol.
DO NOT operate this machine with the belt guard or blade guard removed.
DO NOT operate this machine unless you are specifically trained to do so.
DO NOT use a blade that has been over heated (Core has a bluish color).
DO NOT jam material into the blade.
DO NOT grind on the side of the blade.
DO NOT start cutting with a saw until you have a clear work area and secure footing.

****

This saw was designed for certain applications only. DO NOT modify this saw or use for any application other than for which is it was designed. If you have any questions relative to its application, DO NOT use the saw until you have written Diamant Boart, Inc. and we have advised you.

DIAMANT BOART INC.®
17400 West 119th St.
Olathe, KS 66061

MANDATORY

INDICATION
INFORMATION

WARNING

PROHIBITION

These signs will give advice for your safety

Before leaving our factory every machine is thoroughly tested.

Follow our instructions strictly and your machine will give you long service in normal operating conditions.

1. Features (SPS-55 - Honda Gas Model)

Use: Wet or Dry sawing of masonry and refractory.

Tools: Diamond blades -- dry or water cooled, Ø: 14" (350 mm), with Arbor Ø 1" (25.4 mm). *(For information contact your Dealer)*

Depth of Cut (Maximum):

5.00" (127 mm) with Ø 14" (350 mm) blade

Maximum material Size:

8 x 8 x 16" (20,3 x 20,3 x 40,6 cm) block

Block must be rotated 180 degrees to complete cutting through 8" (20,3 cm) depth.

Nominal Weight (SPS-55): 198 Lb. (91,4 kg)

Operating Weight (SPS-55): 259 Lb. (117,7 kg) [With 3" (76 mm) of Water In Pan]

Dimensions (L x W x H) (SPS-55):

SPS-55: 43.1" x 22.8 x 34.8"
(109.5 x 57.9 x 88.4 cm)
H = 63.0" (160.0 cm) With Optional Stand and Optional Skid Kit.

Blade Guard Capacity (SPS-55): 14" (350 mm) Only Smaller Blade Diameter not recommended because blade will not cut through material. Larger Blade Diameter not available because Blade Guard maximum is 14" (350 mm).

Blade Shaft RPM (SPS-55): 2950 (14" Blade)

Before starting up machine make sure you read these instructions and are familiar with the operation of this machine.

The working area must be completely clear, well lit and all safety hazards removed (no water or dangerous objects in the vicinity)

The operator must wear protective clothing appropriate to the work he is doing. We recommend hearing, respiratory and eye protection.

Any persons not involved in the work, should leave the area.

Use only blades marked with a maximum operating speed greater than the blade shaft speed.

2. Assembly

- When unpacked, this unit consists of three (3) major parts: ***1. Pan Weldment (A), 2. Head Platform Assembly (B), 3. Cart Assembly (C)*** (See Figure 1).
- If this unit is to use the optional ***Folding Stand (D)*** and ***Skid Kit (E)*** assemble these units first using the instructions provided with these options (See Figure 1).
- Set the ***Pan Weldment (A)*** on a table or on the optional ***Folding Stand / Skid Kit (D / E)*** as shown in Figure 1. It is very important that the ***Pan Weldment (A)*** be assembled on the ***Folding Stand (D)*** as shown in Figure 1, or the optional ***Foot Pedal Kit (F)*** CAN NOT be assembled onto the unit.
- Remove the ***Cart Assembly (C)*** from its shipping carton. Set the **Cart Assembly (C)** onto the ***Pan Weldment (A)*** so that the wheels of the **Cart Assembly (C)** roll along the sides of the ***Pan Weldment (A)*** (See Figure 1).
- Make sure that the left and right ***Bearing Clamps (G)*** on the ***Pan Weldment (A)*** are pivoted into their lowered position (See Figure 2). Carefully pick up the **Head Platform Assembly (B)** mount it to the ***Pan Weldment (A)*** such that the ***Bearings (H)*** (on Head Platform) are resting in the ***Pivot Blocks (J)*** (on Pan Weldment) and that the blade shaft end of the ***Head Platform (B)*** is resting on the ***Cart Assembly (C)*** (See Figure 2).
- Pivot the left and right ***Bearing Clamps (G)*** into their upper position, and tighten the ***Knobs (K)*** (or Capscrews depending on date of manufacture) until the ***Head Platform Assembly (B)*** is secured to the ***Pan Weldment (A)*** (See Figure 3).
- Assemble the ***Upper Spring Support (FF)*** using the two (2) 3/8-16UNC x 1.00" Long Capscrews and 3/8-16UNC Locknuts provided (See Figure 4).
- Install the ***Counterbalance Arm (L)*** (See Figure 4). Loosely assemble the 3/8-16UNC x 1.00" Long ***Capscrew (M)*** and 3/8-16UNC ***Locknut*** through

the ***Lower Bracket (N)*** and the lower end (13/32" diameter hole) of the ***Counterbalance Arm (L).***

- Raise the ***Head Platform Assembly (B)*** until the slot in the ***Counterbalance Arm (L)*** can be put onto the 1/2" Stud on the ***Upper Spring Support (FF)***--be sure to install the 1/2" flat Washers (Supplied) on both sides of this Arm,
- Mount and secure the ***Lock Handle (P)*** onto the 1/2" Stud of the ***Upper Spring Support (FF).***
- Install the upper end of the ***Spring (Q)*** (See Figure 4) in the hole in the rear of the ***Upper Spring Support (FF).*** Loosen the ***Lock Handle (P)*** and pivot the ***Head Platform Assembly (B)*** so that the blade shaft is in the upper position, then tighten the ***Lock Handle (P)*** securely. Using a tool (such as a screwdriver or pliers) stretch the lower end of the ***Spring (Q)*** so that it is secured into the ***Eyebolt (R)*** on the ***Lower Bracket (N).***
- Install the hoses to the water pump. They must be connected together as shown in the parts list section of this document. Place the ***Strainer (S)*** in the bottom of the ***Pan Weldment (A)*** after connecting the hose (See Fig 4). Hook the top of the Splash Curtain over the head pivot bar, & place the bottom of the curtain in the pan (Not Shown).
- When the unit is fully assembled, but before starting the engine, verify that the engine does NOT exceed 20 degrees angle of inclination in any position of the ***Head Platform (B)*** [Use an angle measuring gauge (Customer supplied) held flat against the ***Engine Platform (AA)***].

CAUTION: *Any engine inclination angle greater than 20 degrees could cause severe engine damage and void your engine warranty!*

3. Operating Instructions

Wet Cutting (Gasoline Model Only):

- Assemble the machine per section "2. Assembly" of these instructions.
- Fill the water reservoir pan [***Pan Weldment (A)***] with water to within 1 inch (25 mm) of the top. Be sure that the water pump intake ***Strainer (S)*** is fully immersed in water at all times. Keep the intake ***Strainer (S)*** clean and free of accumulated sludge, slurry, or other foreign material (See Figure 5).
- Partially open the ***Water Valve (T)*** and prime the ***Water Pump (U)*** using the ***Primer Bulb (V).*** Squeeze the ***Primer Bulb (V)*** until water reaches the ***Water Pump (U).*** Close the ***Water Valve (T)*** when water passes through the blade guard onto the ***Cart Assembly (C)*** (See Figure 5).
- *Mount* the ***"Wet" Diamond Blade (DD)*** (See Figure 5):

WARNING: *Conventional "Wet" diamond blades MUST be used with water.* ***DO NOT*** *use conventional "Wet" diamond blades without water. Using conventional "wet" diamond blades without water can result in injury or death of the operator or persons in the work area!*

1) Using the Wrench provided (or one of your own) loosen the ***Capscrew (BB)*** by turning it ***clockwise (Gasoline Model Only).***

CAUTION: *Note that on Gasoline Models the capscrew (BB) has* ***LEFT HAND THREADS.*** *Installation of the wrong capscrew could result in damage to the blade shaft!*

2) Remove the outer ***Flange (CC)*** and make sure the outer Flange (CC), and Inner Flange (Not Shown), and arbor shaft (Not Shown) are clean and not damaged.

3) Mount the ***"Wet" Diamond Blade (DD)*** to the arbor and install the outer ***Flange (CC).*** Install and tighten the ***Capscrew (BB)*** by turning it in a Counter-Clockwise direction ***(Left Hand Thread).*** Use the Wrench to firmly tighten the capscrew to the arbor shaft.

- Start the engine by using the procedure in the engine operation manual.
- Open the engine throttle full open. All sawing is done at full throttle. Do Not change the engine governor setting -- it is factory set for the correct speed.

Model	*Engine RPM*	*Blade Shaft RPM*
SPS-55	3500 RPM	2950 RPM

- Open the Water Valve fully, and check the water flow before cutting.

Dry Cutting (Gasoline Model Only):

WARNING: *Conventional "Wet" diamond blades MUST be used with water.* ***DO NOT*** *use conventional "Wet" diamond blades without water. Using conventional "wet" diamond blades without water can result in injury or death of the operator or persons in the work area!*

WARNING: *When cutting without water use only diamond blades that are intended to be used dry (without water). Conventional "Wet" diamond blades MUST be used with water.*

- Assemble this unit per section "2. Assembly" of these instructions. *Hint:* To reduce vibration of the saw , the water reservoir pan [Pan Weldment (A)] can be filled with sand. Be sure to remove the water pump intake ***Strainer (S)*** to avoid contaminating it with dirt or sand.
- Remove the water pump drive ***V-Belt (EE)*** (See Figure 6):

1) Remove the two shields covering the Water Pump belt drive, and the belt guard.
2) Loosen the two (2) bolts that hold the Water Pump in position. Loosen the drawbolt that tensions the water pump belt.

3) Slide the water pump forward and remove the belt from the water pump pulley.
4) The water pump belt can now be disassembled:

a) Turn the belt inside out and with one hand squeeze the two strands of the belt together.

b) Twist one tab 90 degrees so that it is parallel with the slot in the adjacent link.

c) Pull the end of that link over the tab.

d) Pull belt end through the other two links.

5) Re-install the Belt Guard and water pump shields. **Save the water pump belt so that it can be re-installed if the unit needs to be used for wet cutting.**

⚠ ***CAUTION: DO NOT** run the **Water Pump (U)** for extended periods of time without water! The **Water Pump (U)** could be damaged!*

- Start the engine by using the procedure in the engine operation manual.
- Open the engine throttle full open. All sawing is done at full throttle. Do Not change the engine governor setting -- it is factory set for the correct speed.

Model	*Engine RPM*	*Blade Shaft RPM*
SPS-55	3500 RPM	2950 RPM

4. Maintenance

Check Daily:

- Clean the reservoir pan [***Pan Weldment (A)***] to remove sludge and slurry. This concrete slurry is an abrasive cutting compound and will shorten the life of the ***Water Pump (U)*** and the ***Diamond Blade (DD).*** Clean the reservoir pan [***Pan Weldment (A)***] twice a day in heavy cutting. Then refill the water reservoir pan [***Pan Weldment (A)***] with clean water.
- At the end of each day clean the water reservoir pan [***Pan Weldment (A)***] to remove sludge from the saw. Flush clean water through the Water Pump (U) and hoses.
- Check engine air cleaner daily! If cutting dry check engine air cleaner every four hours! Clean or replace air cleaner element as recommended by the engine manufacturer.
- Check engine oil daily. See engine operation manual for proper care and maintenance.

Check Weekly:

- **V-Belt** tension **(See Figure 4, 6):** Check V-Belt tension when unit is new and never set belt tension beyond this point. ***Blade Shaft Drive V-Belt:*** Excessive belt tension will cause engine misalignment because the engine is mounted on four (4) rubber vibration ***Isolators (W).*** Stop tensioning the blade shaft drive v-belt when the center section of the ***front right hand Isolator (W)*** begins to separate from its mounting plate. Tensioning the Blade Shaft drive V-Belt beyond this point is not recommended because the ***Isolator (W)*** will not function properly. The water pump ***V-Belt (EE)*** may need to be tightened after a few hours of operation. Over time this V-Belt may stretch beyond the length of the adjustment slot. If this happens simply remove the V-Belt and take out one or more links (as required) from its length.

When Required:

- **"Stay-Level" Blade Guard (See Figure 7):** If the blade guard becomes loose and pivots too freely the blade guard rotation can be tightened. Adjust the TOP ***Wheel (X)*** of the three (3) wheels behind the blade guard:

  1) Loosen the nut holding the TOP ***Wheel (X).***

  2) Adjust the ***Setscrew (Y)*** to force the Top ***Wheel (X)*** down against the ***Track Bar (Z).***

  3) Re-tighten the nut holding the TOP ***Wheel (X)*** in position.

- **Blade Alignment (See Figures 8 & 9):** The blade shaft arbor on this machine is aligned at the factory so that a new blade will cut "square" with the material placed on the ***Cart Assembly (C).*** If the saw or ***Head Platform Assembly (B)*** is dropped or damaged the blade could become mis-aligned so that it no longer cuts "squarely" through the material. If this occurs the blade shaft should be re-aligned so that the saw will produce "square" cuts. If the Blade is severely out of alignment [1/16" (1.5 mm) or more] the ***Head Platform Assembly (B)*** may need to be "bent" so that the blade is closer to being aligned. In cases of severe damage the Head Platform Weldment should be replaced. Precise alignment can be achieved by using ***Shims (HH)*** of various thickness. See the parts list for part number and thickness information about the shims.

⇒ ***Note: Before starting to align the head platform make sure the blade is flat and is NOT bent or damaged!***

⇒ ***Note: When aligning the blade against the square be sure to allow for the difference in thickness between the diamond segment and the center core of the blade!***

1) Make sure the ***Conveyor Cart (C)*** rolls freely along the pan. If the pan is damaged it must be repaired or replaced before the blade can be aligned. Lock the ***Head Platform Assembly (B)*** securely in the horizontal position.

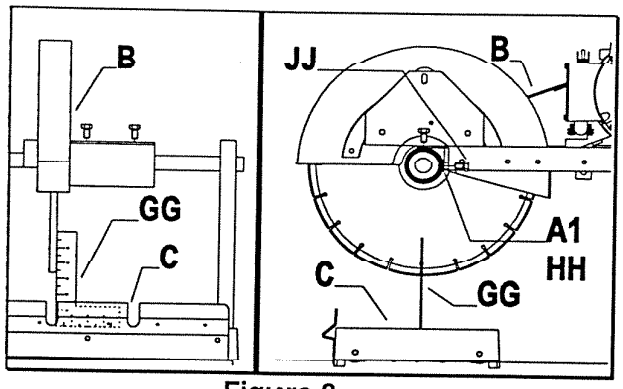

Figure 8

2) Supply a ***Square (GG)*** and place it on the ***Conveyor Cart (C)*** and roll the cart while the Square rests against the blade. Adjust the Blade Shaft Front-To-Rear (if required) by putting ***Shims (HH)*** between the blade shaft housing and the head platform weldment (Location ***"A1"*** in Figure 8). Loosen, but do not remove, the ***Capscrews (JJ)*** holding the blade shaft in position. Slide a shim, of the proper thickness, into position at one of the capscrews (around the thread) so that the blade shaft is aligned Front-To-Rear. Tighten the hardware and check the blade alignment. Add more shims if required until the blade shaft is aligned Front-To-Rear.

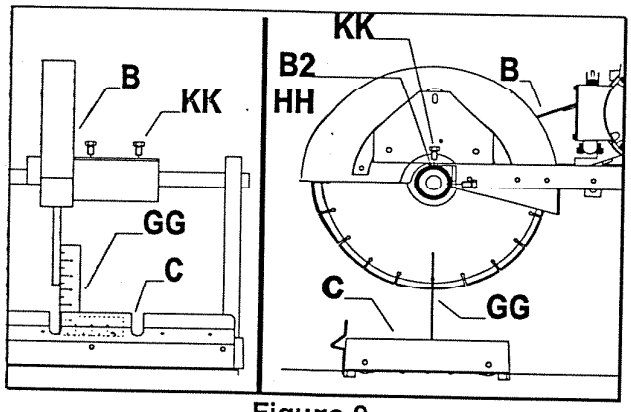

Figure 9

3) Place the ***Square (GG)*** on the ***Conveyor Cart (C)*** so that it is against the saw blade and is below the center of the blade shaft (Figure 9). If the Square does NOT contact the saw blade along the entire length (height) of the square, the blade shaft must be aligned Top-To-Bottom (Horizontally). Adjust the blade shaft by putting ***Shims (HH)*** between the blade shaft housing and the head platform weldment (Location ***"B2"*** in Figure 9). Loosen the **Capscrews (KK)** that hold the blade shaft in position. Slide a shim, of the proper thickness, into position at one of the capscrews (around the thread) so that the blade shaft is aligned Top-To-Bottom (Horizontally). Tighten the hardware and check the blade alignment. Add more shims if required until the blade shaft is aligned Top-To-Bottom (Horizontally).

5. Important Advise

- Never transport a masonry saw with the cutting head in position on the frame. The pounding and bouncing can knock the head out of alignment.
- When storing for an extended length of time, use a wire brush to remove hard, caked sludge. Clean and thoroughly lubricate moving parts - so when the saw is taken to the next job it is ready to operate.
- Drive belts must be tight. When the belts are loose, power is lost. Replace worn belts without delay!
- The blade must fit the arbor snugly - especially diamond blades. Otherwise, pounding will occur and will seriously damage the blades. If the arbor shoulder is grooved where the diamond blade has bound in the cut as the shaft has continued to turn, the arbor must be replaced, or the blade life will be severely shortened.
- Blade flanges must be full diameter - minimum of 4" (100 mm). Replace worn flanges at once because undersized flanges shorten blade life and cause breakage.
- Check the conveyor cart condition on a regular basis. Replace the wheels and the wooden insert frequently.
- Be certain the cutting head is correctly aligned. Blade misalignment because of handling damage, or transporting the saw with the cutting head on the frame can seriously affect blade life.
- Replace noisy bearings immediately! Worn bearings will quickly destroy the blade.
- Flush clean water through the pump and spray the assembly after every job to prolong the pump and blade life.
- Diamond blades may need to be "sharpened". Blades may be efficiently "dressed" with dressing sticks.

⚠ ***WARNING:*** *Never use fire bricks to "sharpen" or dress diamond blades!*

- Abrasive blade must be a reinforced type. Never use an abrasive blade with water. These products can be damaged by operator abuse such as jamming the material into the blade. *This can also be hazardous!*

6. Spare Parts

For a quick supply of spare parts it is essential to quote the data shown on the ***Serial Number Plate (GG)*** (See Figure 7) fixed to the machine. Make note of this information below for quick reference:

Model: _____

Serial Number _____

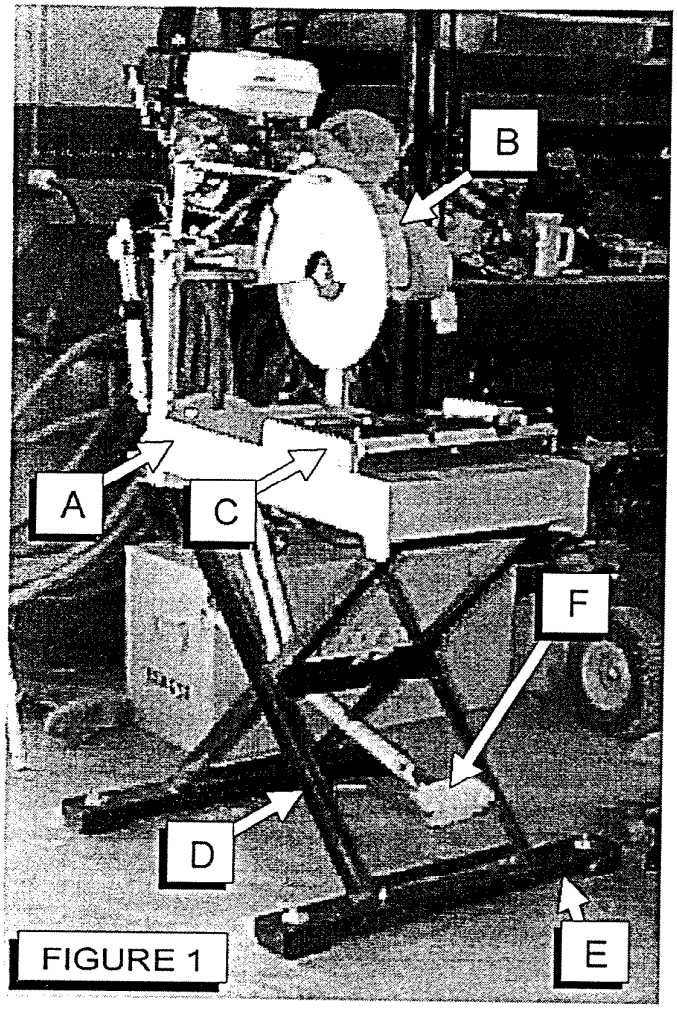

FIGURE 1

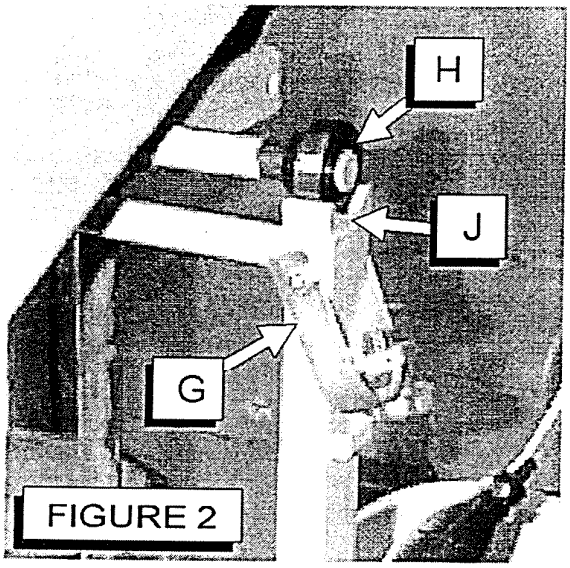

FIGURE 2

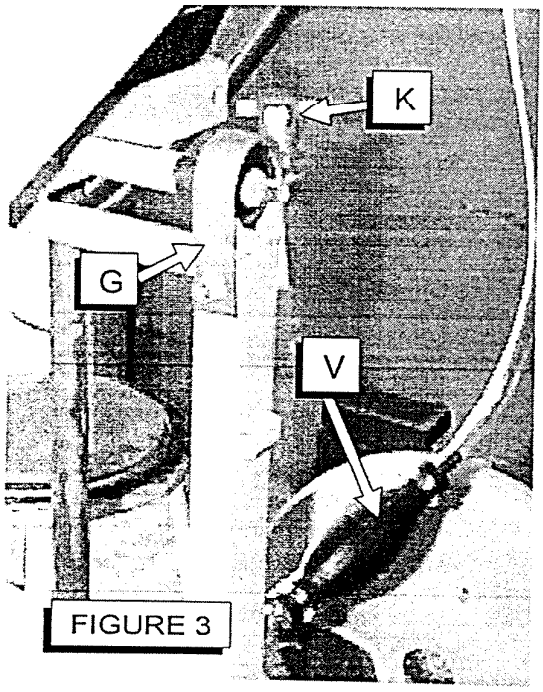

FIGURE 3

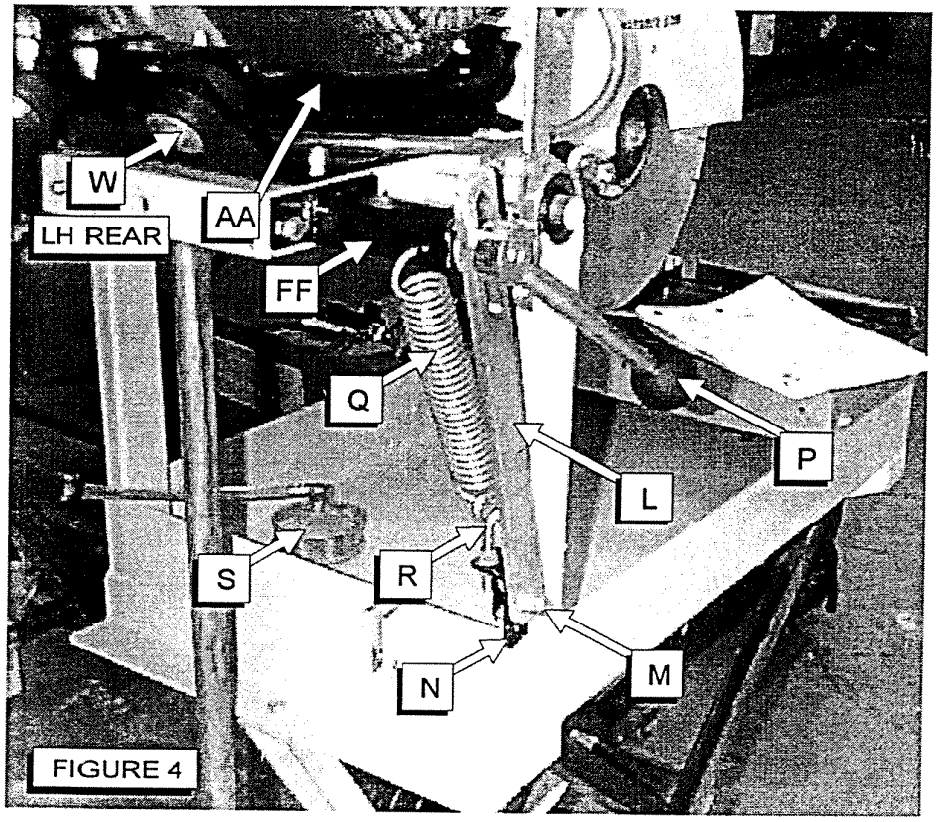

FIGURE 4

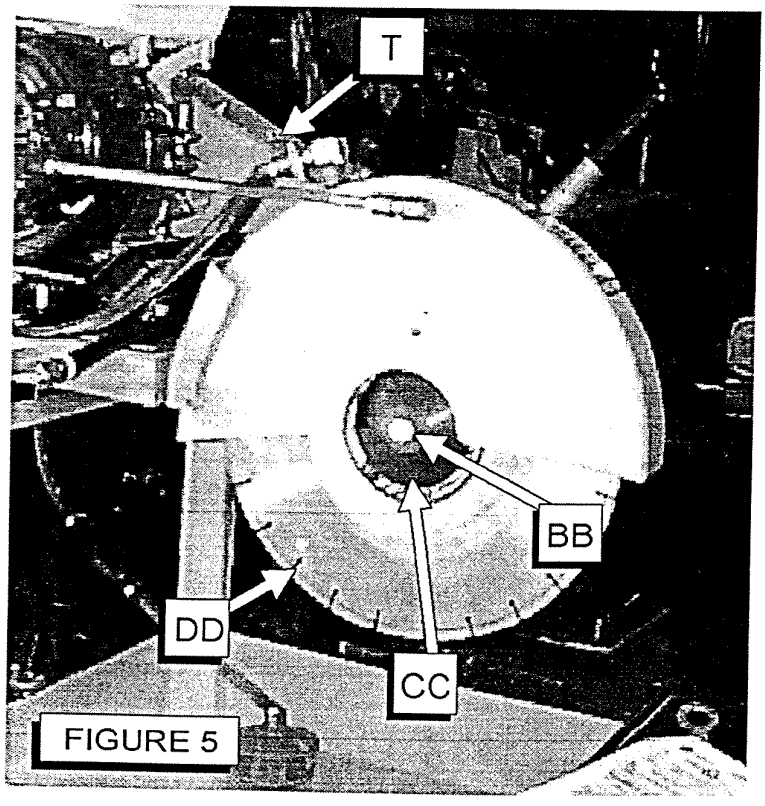

FIGURE 5

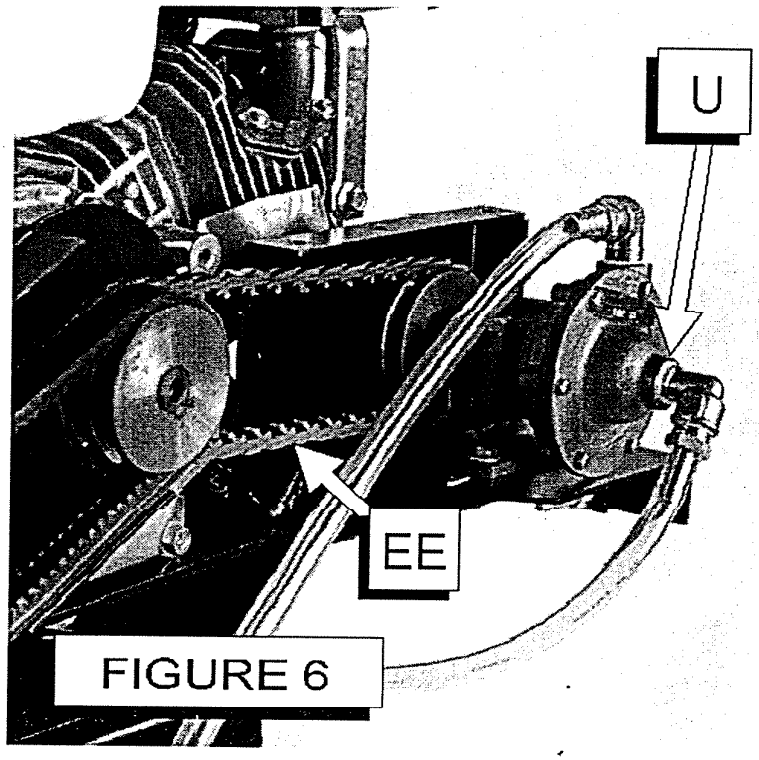

FIGURE 6

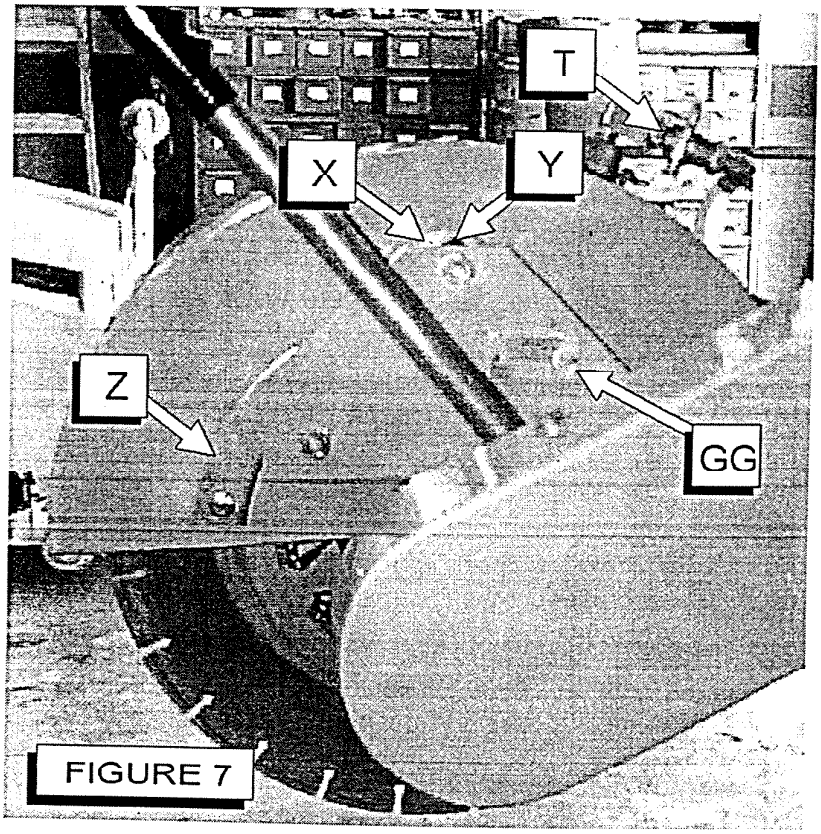

FIGURE 7

PARTS LIST
LISTA DE PIEZAS

FIGURE 3 - UPPER SAW ASSEMBLY, GASOLINE MODEL

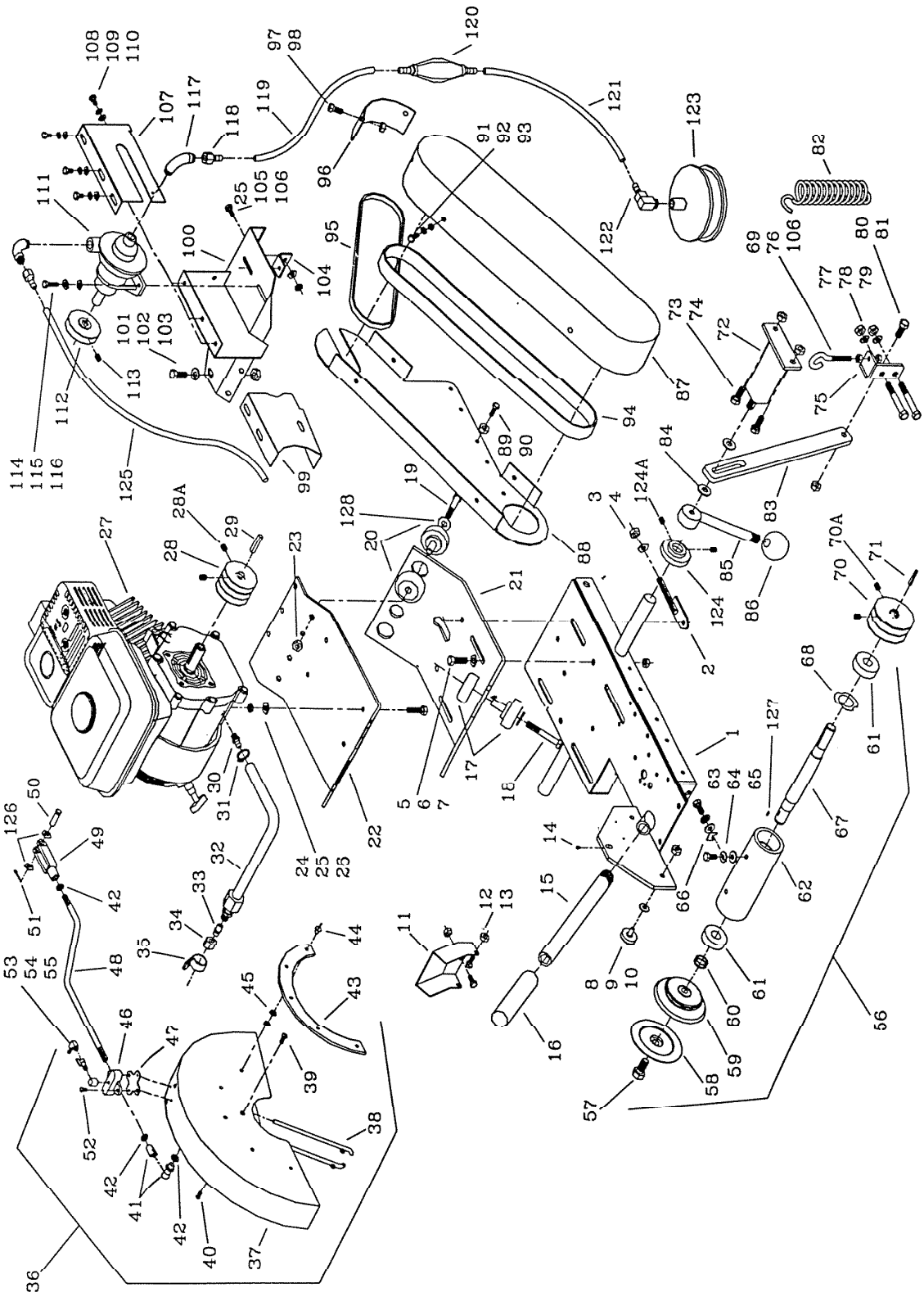

FIGURE 3 - PARTS LIST

DIAG. LOC.	PART NO.	QTY. REQ.	DESCRIPTION
1	177299	1	Platform Weldment
2	060411	1	Drawbolt Weldment, 3/8-16UNC
3	020764	1	Washer, Flat 3/8" SAE
4	020199	1	Locknut, Fiber 3/8-16
5	048740	4	Capscrew, Hex Hd., 3/8-16 x 1-1/4"
6	020743	4	Washer, Flat 3/8"
7	020199	4	Locknut, Fiber 3/8-16
8	030822	3	Wheel
9	020763	3	Washer, Flat 5/16" SAE
10	032366	3	Nut, Keps 5/16-18UNC
11	177300	1	Shield, Water
12	020301	2	Capscrew, Hex Hd.. 1/4-20 x 5/8"
13	020195	2	Locknut, Fiber 1/4-20
14	020572	1	Setscrew, Socket Hd., #10-24 x 1/2"
15	020263	1	Handle, 1/2" x 12" Long
16	043935	1	Grip, Handle
17	161197	1	Isolator, Engine 40-45 Durometer
18	020329	1	Capscrew, Hex Hd., 3/8-16 x 2-3/4"
19	020329	3	Capscrew, Hex Hd., 3/8-16 x 2-3/4"
20	161196	3	Isolator, Engine 30-35 Duro
21	177348	1	Plate, Engine Base
22	177307	1	Plate, Engine
23	020199	4	Locknut, Fiber 3/8-16
24	020373	4	Capscrew, Hex Hd.,5/16-18 x 1-1/2"
25	020742	5	Washer, Flat 5/16"
26	020197	4	Locknut, Fiber 5/16-18
27	173098	1	Engine, 5.5HP Honda
28	177356	1	Pulley, 3G3V2.65 - .75 w/Setscrews
28A	020550	2	Setscrew, Socket .Hd., 5/16-18 x 3/8"
29	020063	1	Key, 3/16" Sq. x 1-1/2"
30	177382	1	Fitting, Oil Drain M10 x 1.25 x .38 Barb
31	020049	1	Clamp, Hose
32	167304	1	Hose Assembly, Oil Drain
33	167307	1	Cap, Blanking
34	167622	1	Nut, Tube M16
35	166676	1	Clamp, Insulated
36	177419	1	Blade Guard Assy (Incl. 37-47 & 53-55)
37	177292	1	Blade Guard Weldment, 14"
38	030865	2	Water Tube 14"
39	020426	1	Screw, Machine Flat #10-32 x 3/8"
40	020424	1	Screw, Machine Round #10-32 x 3/8"
41	031045	1	Joint, Ball
42	020171	3	Nut, Thin Jam 3/8-24
43	060435	1	Track, Blade Guard
44	020701	5	Rivet. Pop
45	020762	10	Washer, Flat ¼" SAE
46	030870	1	Manifold
47	030875	1	Gasket, Water Manifold
48	060455	1	Rod Link
49	060460	1	Yoke
50	060465	1	Pin, Clevis
51	020611	1	Pin, Cotter
52	020425	2	Screw, Machine #10-32 x 1/2"
53	161176	1	Fitting, 90° Elbow 1/4" - 18, 3/8" Barb
54	090578	1	Valve, 1/4-18NPT
55	020813	1	Fitting, 90° Street Elbow 1/4-18 NPT
56	177305	1	Blade Shaft Assy (Incl. 57-62 & 67-68)
57	177290	1	Capscrew, Hex Hd.,1/2-20UNF-LH x 1.0"
58	030951	1	Collar, Outer
59	030945	1	Collar, Inner
60	139274	1	Spacer
61	139273	2	Bearing
62	177416	1	Housing, Blade Shaft
63	020314	4	Capscrew, Hex Hd.,5/16-24 x 3/4"
64	020763	4	Washer, Flat 5/16"SAE
65	020785	4	Lockwasher, Split, 5/16"
66	032501	(as req.)	Shim, .005" Thick
--	032502	(as req.)	Shim, .015" Thick
--	032503	(as req.)	Shim, .020" Thick
67	177289	1	Shaft, Blade, LH Thread
68	030004	1	Washer, Spring
69	020169	1	Nut, Hex Jam Thin 5/16-18
70	060106	1	Pulley, 2G3V3.15 - .75 w/ Setscrew
70A	020550	2	Setscrew, Socket Hd., 5/16-18 x 3/8"
71	020062	1	Key, 3/16" Sq. x 1-1/4"
72	177385	1	Support Weldment, Spring Top
73	020323	2	Capscrew, Hex Hd., 3/8-16 x 1"
74	020199	2	Locknut, Fiber 3/8-16
75	177387	1	Support, Spring Bottom
76	030251	1	Eye Bolt, 5/16-18 x 2"
77	020329	2	Capscrew, Hex Hd., 3/8-16 x 2-3/4"
78	020743	2	Washer, Flat 3/8"
79	020199	2	Locknut, Fiber 3/8"
80	020323	1	Capscrew, Hex Hd., 3/8-16 x 1"
81	020199	1	Locknut, Fiber 3/8-16
82	060395	1	Spring
83	177389	1	Arm, Counterbalance
84	020745	2	Washer, Flat 1/2"
85	139564	1	Handle, Lock
86	163212	1	Knob
87	177422	1	Belt Guard w/ Decal
88	177296	1	Support, Belt Guard
89	020370	3	Capscrew, Hex Hd., 1/4-20 x 3/4"
90	020195	3	Locknut, Fiber 1/4-20
91	020370	4	Capscrew, Hex Hd., 1/4-20 x 3/4"
92	020784	4	Lockwasher, Split 1/4"
93	020741	4	Washer, Flat 1/4"
94	177380	1	V-Belt, 2/3VX425 (2-Band)
95	177439	1	V-Belt, 3L x 40 Links (For water pump)
96	177405	1	Cover, Rear Belt Grd (w/o H2O Pump)
97	020313	2	Capscrew, Hex Hd., 5/16-18 x 3/4"
98	020197	2	Locknut, Fiber 5/16-18
99	177346	1	Shield, Front, Water Pump
100	177342	1	Support Weldment
101	020323	4	Capscrew, Hex Hd., 3/8-16 x 1"
102	020743	4	Washer, Flat 3/8"
103	020199	4	Locknut, Fiber 3/8-16
104	177357	1	Bracket, Drawbolt
105	177378	1	Capscrew, Hex Hd., 5/16-18 x 2"
106	020197	2	Locknut, Fiber 5/16-18
107	177344	1	Shield, Rear, Water Pump
108	021423	5	Capscrew, Hex Hd., 1/4-20 x 1/2"
109	020784	5	Lockwasher, Split 1/4"
110	020762	5	Washer, Flat 1/4" SAE
111	177375	1	Pump, Water (Modified)
---	177424	1	Repair Kit, Water Pump (Not Shown)
112	177354	1	Pulley,1G3V2.65 - .625, w/ Setscrews
113	020541	2	Setscrew, Socket Hd., 1/4-20 x 3/8"
114	020306	2	Capscrew, Hex Hd., 1/4-20 x 1"
115	020762	2	Washer, Flat 1/4" SAE
116	020195	2	Locknut, Fiber 1/4-20
117	020815	2	Fitting, Street Elbow, 3/8" NPT x 90°
118	020819	2	Fitting, 3/8 NPT x 3/8" Barb
119	161225	1	Tubing, 3/8" ID x 16" Long
120	161158	1	Bulb, Primer
121	161194	1	Tubing, 3/8" ID x 12" Long
122	161181	1	Fitting, 90° Elbow 1/2NPT x 3/8" Barb
123	161159	1	Strainer, Suction
124	030580	2	Bearing, Head Pivot
124A	020553	4	Setscrew, Socket Hd., 1/4-28 x 1/4"
125	177379	1	Tubing, 3/8" ID x 32" Long
126	020764	2	Washer, Flat 3/8" SAE
127	020089	1	Key, Woodruff (ANSI #403)
128	163187	4	Washer, Flat .06 x .38ID x 1.5"OD

FIGURE 4 - LOWER SAW ASSEMBLY, GASOLINE MODEL

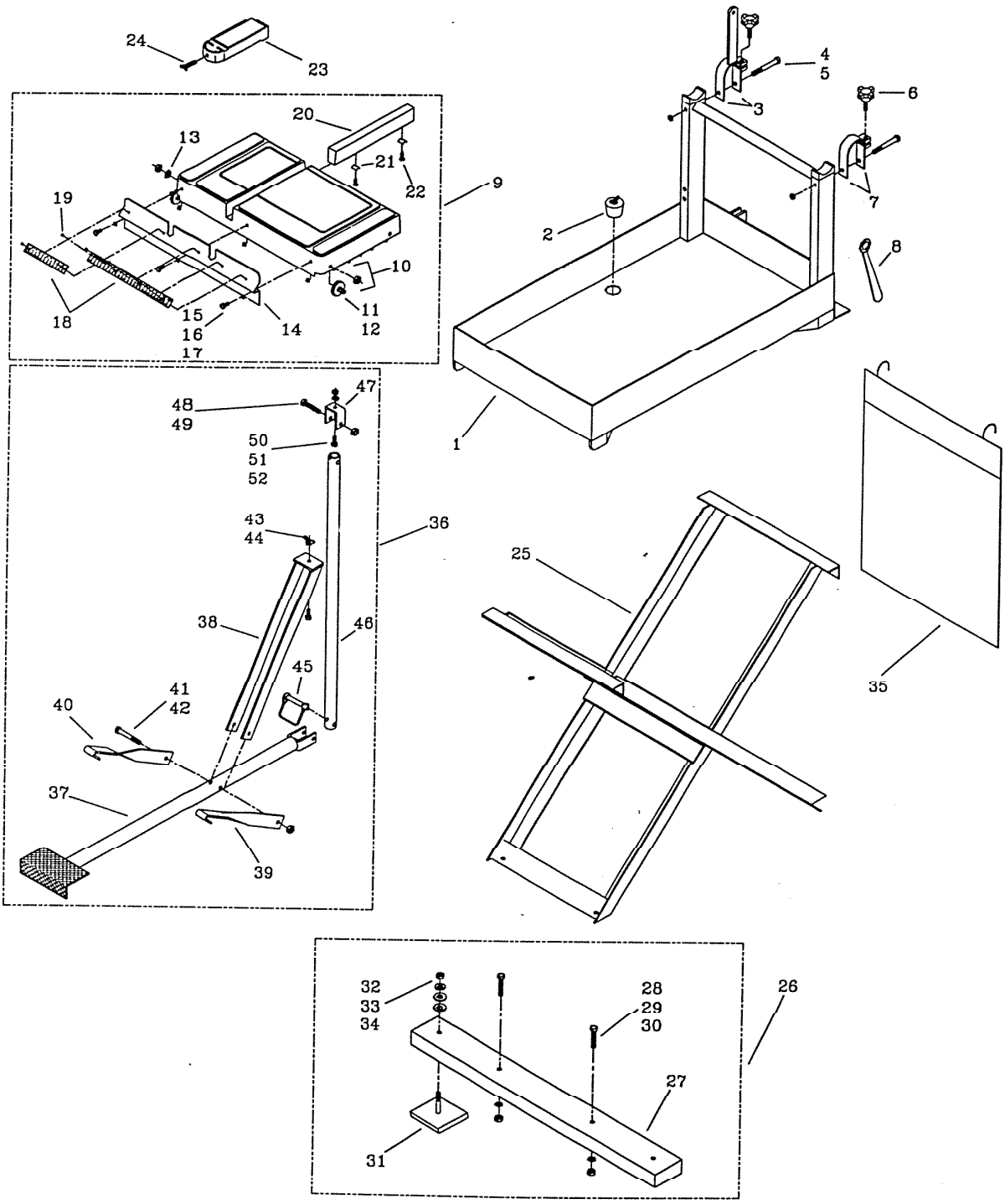

FIGURE 4 - PARTS LIST

DIAG. LOC.	PART NO.	QTY. REQ.	DESCRIPTION	DIAG. LOC.	PART NO.	QTY. REQ.	DESCRIPTION
1	177409	1	Pan Weldment	**26**	**177401**	**1**	**Skid Kit (Optional)**
2	030386	1	Drain Plug Assembly	27	177399	2	Skid, Wooden
3	030971	1	Tilt Arm Clamp	28	020509	4	Capscrew, Hex Hd., 3/8-16 x 2"
4	020330	2	Capscrew, Hex Hd., 3/8-16 x 3"	29	020743	4	Washer, Flat 3/8"
5	020199	2	Locknut, Fiber 3/8-16	30	020199	4	Locknut, Fiber, 3/8-16
6	030610	2	Knob, Hand (early models)	31	161195	4	Pad, Skid
--	048742	2	Capscrew, Hex Hd., 5/16-18 x 1-1/4"	32	020743	4	Washer, Flat 3/8"
--	020763	2	Washer, Flat, 5/16" SAE	33	020745	8	Washer, Flat 1/2"
7	030591	1	Clamp	34	020199	4	Locknut, Fiber, 3/8" - 16
8	177383	1	Wrench, Blade Shaft	35	030402	1	Curtain, Splash
9	177303	1	Conveyor Cart Kit, Complete	**36**	**034050**	**1**	**Foot Pedal Kit (Optional)**
10	030049	1	Wheel Kit, Set of 4, w/ Nuts	37	034051	1	Foot Pedal
11	030822	4	Wheel, Cart	38	034055	1	Support, Foot Pedal
12	032366	4	Nut, Keps 5/16-18UNC	39	034058	1	Support, Pedal, Right
13	020763	2	Washer, Flat 5/16" SAE	40	034059	1	Support, Pedal, Left
14	177313	1	Backstop	41	020329	1	Capscrew, Hex Hd., 3/8-16 x 2-3/4"
15	020301	3	Capscrew, Hex Hd., ¼-20 x 5/8"	42	020199	1	Locknut, Fiber 3/8-16
16	020784	3	Lockwasher. Split. 1/4"	43	020238	1	Wingnut, 3/8" 16
17	020133	3	Nut, Hex 1/4" - 20 RH	44	020323	1	Capscrew, Hex Hd., 3/8-16 x 1"
18	177404	1	Ruler Set, Conveyor Cart, Honda Eng	45	160080	1	Pin, Snapper
19	020432	5	Screw, Pan Head #10-24 x 3/8"	46	034061	1	Rod, Tilt
20	030362	1	Insert, Wood Assembly	47	034062	1	Yoke, Tilt Rod
21	170038	2	Tubing, 3/8" ID x 5/8" Cut in half (cust)	48	020509	1	Capscrew, Hex Hd., 3/8-16 x 2"
22	020699	2	Wood Screw, Round Hd., #8 x 1"	49	020199	1	Locknut, Fiber 3/8" - 16
23	030350	1	Guide, Measuring (Incl. Item 24)	50	020313	1	Capscrew, Hex Hd., 5/16-18 x 3/4"
24	020600	1	Screw, Thumb, 5/16-18 x 1" Flat Pt	51	020785	1	Lockwasher, Split, 5/16"
25	034040	1	**Stand Assembly (Optional)**	52	020134	1	Nut, Hex 5/16" - 18