



Husqvarna®



Operator's manual TS 250 XS

Please read the operator's manual carefully and make sure you understand the instructions before using the machine.



GB



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Olathe, Kansas 66061 U.S.A.

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DUST WARNING

Cutting, especially when DRY cutting, generates dust that comes from the material being cut, which frequently contains silica. Silica is a basic component of sand, quartz, brick clay, granite and numerous other minerals and rocks. Exposure to excessive amount of such dust can cause:




- Respiratory diseases (affecting your ability to breath), including chronic bronchitis, silicosis and pulmonary fibrosis from exposure to silica. These diseases may be fatal;
- Skin irritation and rash; and
- Cancer according to NTP* and IARC*
* National Toxicology Program, International Agency for Research on Cancer

Take precautionary steps

- Avoid inhalation of and skin contact with dust, mist and fumes;
- Wet cut when feasible, to minimize dust;
- Wear and ensure that all bystanders wear appropriate respiratory protection such as dust masks designed to filter out microscopic particles. (See OSHA 29 CFR Part 1910.1200)

California Prop 65 Warning:

Use of this product can cause exposure to materials known to the State of California to cause cancer and/or birth defects or other reproductive harm.

 WARNING!	
 	<p>Before starting up machine make sure you completely read these instructions. Be familiar with operation of the machine before operation!</p>



EVERY MACHINE IS THOROUGHLY TESTED BEFORE LEAVING THE FACTORY. EACH MACHINE IS SUPPLIED WITH A COPY OF THIS MANUAL. OPERATORS OF THIS EQUIPMENT MUST READ AND BE FAMILIAR WITH THE SAFETY WARNINGS. FAILURE TO OBEY WARNINGS MAY RESULT IN INJURY OR DEATH. FOLLOW INSTRUCTIONS STRICTLY TO ENSURE LONG SERVICE IN NORMAL OPERATION.

CONTENTS

Symbol Definitions 4 - 6

Decal Descriptions and Locations 7

Dimensions 8

Specifications 9

Safety Warnings - DOs & DO NOTs 10 - 11

Reference Figure 12

Preoperation Checklist / Scheduled Maintenance 13

Instructions:

 1. Features 14

 2. Assembly 14 - 15

 3. Operating Procedures 15 - 16

 4. Manual Thermal Overload 16

 5. Extension Cords 16

 6. Alignment Procedures 16

 7. Maintenance 17

 8. Water Pump, Trouble Shooting Procedure 17

 9. Repairs 17

 10. Spare Parts 17

Wiring Diagrams 18 - 19

Symbol Definitions

Definición De Los Simbolos



- Please read the instructions for use prior to operating the machine for the first time.
- Antes de la puesta en marcha, lea detenidamente las instrucciones y familiarícese con la máquina.



- Mandatory
- Obligatorio



- Indication
- Indicación



- Prohibition
- Prohibición



- Warning Triangle
- Triángwulo De Advertencia



- Wear Eye Protection
- Usar Gafas De Protección



- Wear Head Protection
- Usar Casco De Protección



- Wear Breathing Protection
- Usar Máscara De Protección



- The Use Of Ear Protection Is Mandatory
- Es Obligatorio El Uso De Protección Auditiva



- Wear a Hard Hat
- Usar Casco Duro



- Wear Safety Shoes
- Usar Zapatos De Seguridad



- Wear Appropriate Clothing
- Usar Ropa Adecuada



- Remove The Blade Prior To Hoisting, Loading, Unloading And Transporting The Machine On Jobsite.
- Desmontar El Disco Antes De Desplazar, Cargar, Descargar O Transportar La Máquina En La Obra.



- Motor Off
- Parar El Motor



- Use In Well Ventilated Area
- Usar En Una Área Bien Ventilada



- Do Not Use In Flammable Areas
- No Usar In Áreas Inflamables



- Machinery Hazard, Keep Hands And Feet Clear.
- Máquina Peligrosa - Mantenga Manos Y Pies Alejados De La Máquina



- No Non-working Personnel In Area
- Prohibido Para Personas Ajenas A La Obra



- No Smoking
- No Fumar



- Do Not Operate Without All Guards In Place
- No Operar Sin Todas Las Protecciones In Su Sitio



- Always Keep the Blade Guards In Place
- Mantenga Siempre Las Protecciones De La Hoja En Su Sitio



- Keep Work Area Clean/Well Lit, Remove All Safety Hazards
- Mantenga Limpio El Sitio De Trabajo/Bien Iluminado, Elimine Todos Los Riesgos De Seguridad



- Dangerously High Noise Level
- Nivel De Ruido Elevadamente Peligroso



- Pay Extreme Attention To The Care And Protection Of The Machine Before Starting Up
- Ponga Extrema Atención Al Cuidado Y Preparación De La Máquina Antes De Ponerla En Marcha



- Remove Tools From Area and Machine
- Elimine Las Herramientas Del Área Y De La Máquina



- Electrical Switch - OFF
- Conmutador De Apagado Eléctrico



- Electrical Switch - ON
- Conmutador De Encendido Eléctrico



- Electrical Switch - Start
- Conmutador De Arranque Eléctrico



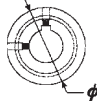
- Repairs Are To Be Done By An Authorized Dealer Only
- Las Reparaciones Deben Ser Efectuadas Únicamente Por Un Distribuidor Autorizado



- Diamond Blade
- Sierra Diamantada



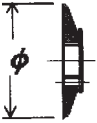
- Blade Diameter
- Diámetro De La Hoja



- Pulley Diameter
- Diámetro De La Correa



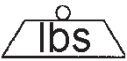
- Number of Revolutions Per Minute, Rotational Speed
- N° De Revoluciones Por Minuto, Velocidad De Rotación



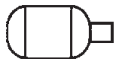
- Blade Flange Diameter
- Diámetro De La Brida De La Hoja



- Blade Cutting Depth
- Profundidad De Corte De La Hoja



- Machine Mass (lbs)
- Masa De La Máquina (lbs)



- Electric Motor
- Motor eléctrico



WARNING
HEARING HAZARD

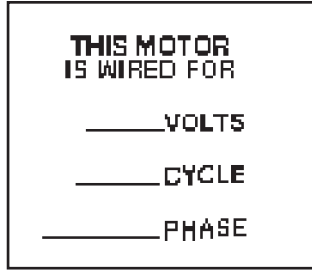
DURING NORMAL USE OF THIS MACHINE, OPERATOR MAY BE EXPOSED TO A NOISE LEVEL EQUAL OR SUPERIOR TO **85 dB (A)**



ATENCION
RIESGO DE DAÑO AUDITIVO

EN CONDICIONES NORMALES DE UTILIZACIÓN, EL OPERADOR DE ESTA MÁQUINA PUEDE ESTAR EXPUESTO A UN NIVEL DE RUIDO IGUAL O SUPERIOR A **85 dB (A)**

DECAL DESCRIPTIONS & LOCATION DESCRIPCIÓN DE CALCAMONIAS Y UBICACIONES



P/N 542 00 08-45
Location: Motor Assembly



P/N 542 04 63-26
Location: Motor Assembly



P/N 542 19 37-94
Location: Water Pan



P/N 542 17 75-88
Location: Top of Belt Guard

GOOD MOTOR PERFORMANCE DEPENDS ON PROPER VOLTAGE. EXTENSION CORDS THAT ARE TOO LONG AND/OR SMALL REDUCE VOLTAGE TO MOTOR UNDER LOAD. USE EXTENSION CORDS NO SMALLER THAN INDICATED BELOW.

MOTOR HP	50' CORD		75' CORD		100' CORD	
	115V	230V	115V	230V	115V	230V
1	#12	#14	#10	#14	# 8	#14
1 1/2	#10	#14	#10	#14	# 8	#14
2	#10	#12	# 8	#12	# 8	#12
3	# 8	#10	# 8	#10	# 8	#10
5	# 8		# 8		# 8	

046327

P/N 046327
Location: Motor Assy



TARGET STONEMATIC TS250XS

HUSQVARNA-TARGET STONEMATIC TS 250 XS LOGO
SIDES OF WATER PAN (X2)
P/N 542 19 07-30

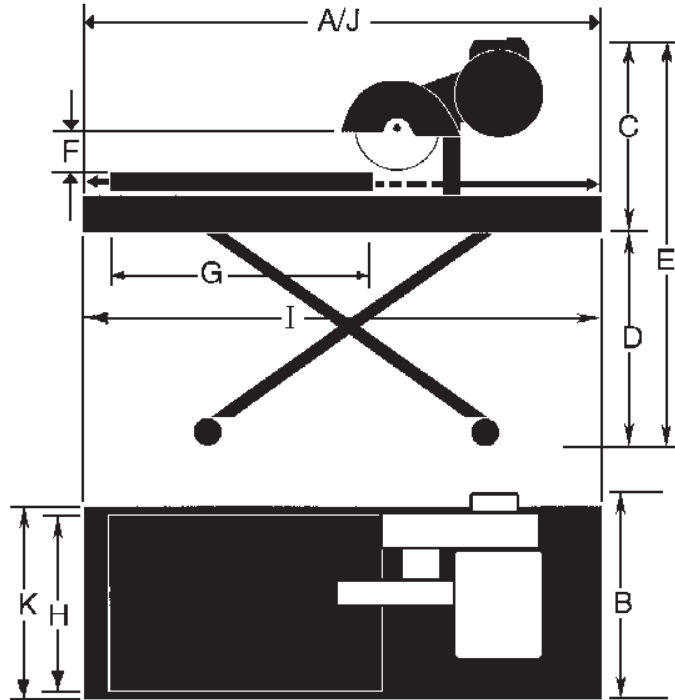


HUSQVARNA LOGO, 35mm
FRONT OF EACH BLADE GUARD SIDE
P/N 504 04 02-01



HUSQVARNA LOGO, 250mm Long
REAR OF COWL
542 19 08-45

Saw Dimensions



ITEM	DESCRIPTION	inch	mm
A	Saw Length	67-3/4	1721
B	Saw Width	33-5/8	854
C	Saw Height	22-3/4	578
D	Stand Height	30-1/4	768
E	Total Height	53	1346
F	Arbor to Top of Cart	6-9/16	167
G	Cart Length	36	914
H	Cart Width	24	610
I	Cart Travel	45-3/8	1153
J	Tray Length	67-3/4	1721
K	Tray Width	26-1/8	664
L	Extension Length	24	610
M	Extension Width	12	305
Crated Dimensions: (L x H x W)		67-3/4 x 33-5/8 x 53	(1721 x 854 x 1346)

Specifications		
MODEL NO.	TS 250 XS	
TYPE	1-1/2 HP, 115/208-230/	2 HP, 115/230V-60Hz
Blade Guard Capacity	10" (250 mm)	
Blade Shaft RPM:	3880	3880
Max. Depth of Cut:	3-3/4" (95 mm)	
Maximum Material Size:	Up to 24" wide x 36" long (610 x 914 mm)	
Blade Arbor Size:	5/8" (15.9 mm)	
Blade Shaft:	Sealed Ball Bearings	
Blade Shaft Drive:	3VX V-Belt (2 Band)	
Blade Coolant:	Water	
Water Pan:	Powder coat finish to resist chipping. Sliding tray accommodates materials from 4" to 24" (102 to 610mm); with spring tensioned latches.	
Water Pan Capacity:	27-1/2 gallons (105 liters)	
Cutting Table:	Formed steel, powder coated, high density polyethylene top, extended rails for longer cuts and two intermediate supports for stability and consistent tracking. Small cutting cart for smaller tiles features "Sure-grip" bonded surface and rides on separate rails: 24" x 36" (610 x 914mm). Table extension: 12" x 24" (305 x 620mm)	
Water Pump:	115V, 60 Hz., 1-phase, 0.5 amps, 300 gal/hr. (1144 l /hr.) Output, Totally Epoxy Sealed, Thermal Over Load Protected, lifetime lubricant	
Cutting Head:	Cast aluminum pivoting head, can be preset, locked or fully adjusted to varying heights.	
Weight Pounds (kg):		
Saw Crated:	410 (186)	452 (205)
Saw Uncrated:	360 (164)	383 (174)

Power Source		
TYPE:	Electric	
Engine / Motor:	Baldor	
Horsepower (kw):	1-1/2 (1.1)	2 (1.5)
RPM:	3450	
Specifications:	T.E.F.C.	
Voltage:	115 / 208-230	115 / 208-230
Cycle (Hz) / Current / Phase:	60 * / A.C. / 1	
Starter:	Capacitor	
Full Load Amperage:	17.2 / 9-8.6	16.8 / 7.6-8.4
Coolant:	Air	

SAFETY FIRST!



WARNINGS DO's AND DO NOT's

! WARNING: FAILURE TO COMPLY WITH THESE WARNINGS AND OPERATING INSTRUCTIONS COULD RESULT IN DEATH OR SERIOUS BODILY INJURY.

DO

- 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 turn the "ON/OFF" switch to the "OFF" position prior to connecting the machine to the power source.
- DO inspect the blade, flanges and shafts for damage before installing the blade.
- DO use the blade flange size shown for each blade size.
- DO use only the blade flanges supplied with the saw. Never use damaged or worn blade flanges.
- 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 the correct blade for the type of work being done. Check with blade manufacturer if you do not know if blade is correct.
- DO use caution and follow the instructions when loading and unloading the machine.
- 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 motor is running.
- DO make sure the blade is not contacting anything before starting the motor.
- DO use caution when lifting and transporting this machine.
- 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 make sure electric powered machines are plugged into a properly grounded circuit.
- DO make sure power cords are the proper size and in good condition.
- DO maintain a secure grip on the material being cut.
- DO clean the water tray frequently.
- DO verify the blade arbor hole matches the machine spindle before mounting the blade.
- DO clean the machine after each day's use.
- DO follow all electrical codes in your area.
- DO consider work area environment. Don't expose power tools to rain. Don't use power tools in wet locations.
- DO use caution to guard against electric shock. Prevent body contact with grounded surfaces (i.e., pipes, radiators, ranges, refrigerators).
- DO use correct voltage and proper extension cords. Never carry tool by cord or yank it to disconnect it from receptacle. Keep cord away from heat, oil and sharp edges.
- DO always carry the machine with the motor stopped.
- DO disconnect tools from power source when not in use, before servicing and when changing accessories.
- 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 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.

SAFETY FIRST!

WARNINGS **DO's AND DO NOT's**

 **WARNING: FAILURE TO COMPLY WITH THESE WARNINGS AND OPERATING INSTRUCTIONS COULD RESULT IN DEATH OR SERIOUS BODILY INJURY.**

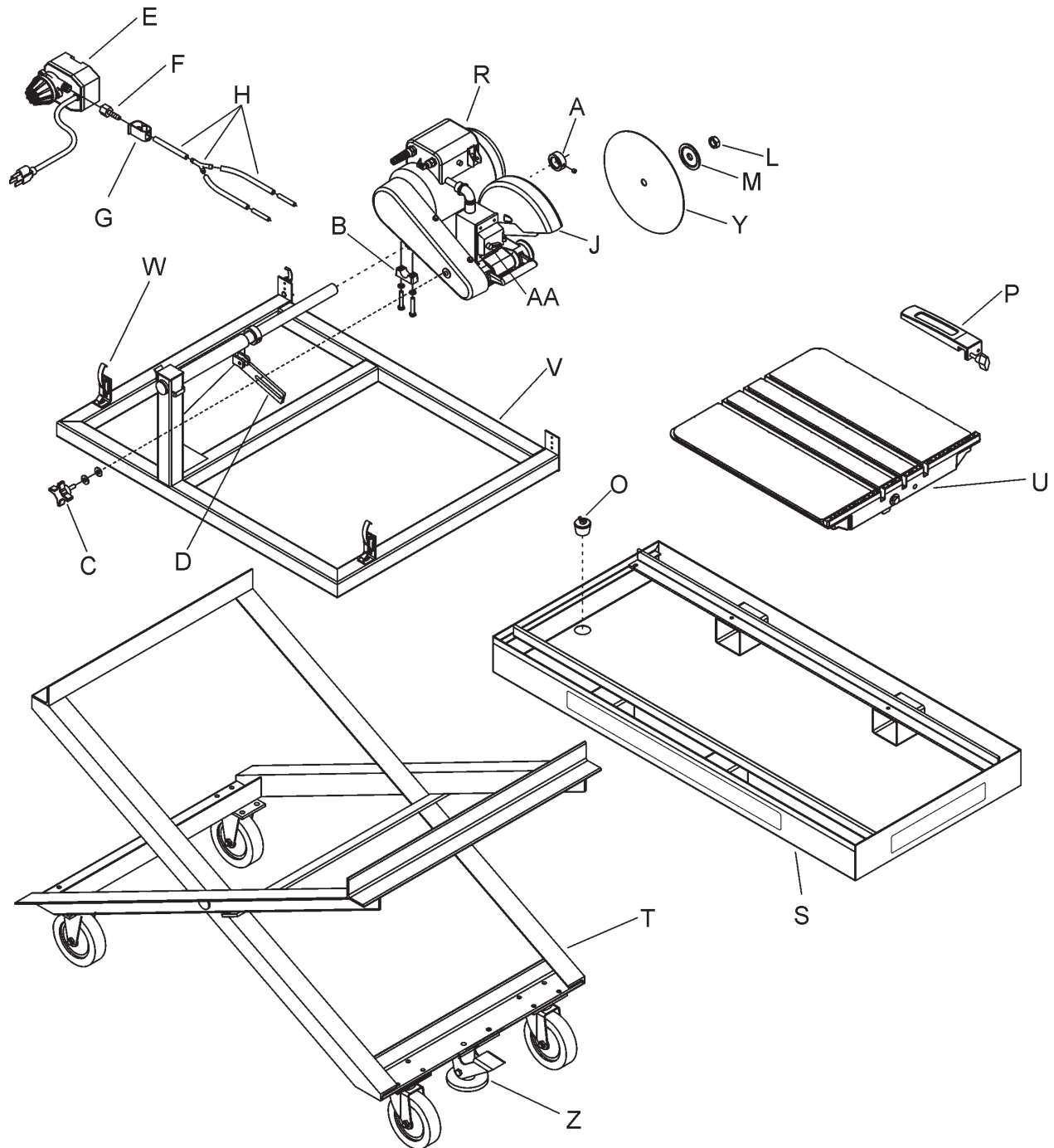
DO NOT

- 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 motor is running.
- DO NOT** leave this machine unattended while the motor is running.
- DO NOT** operate this machine when you are tired or fatigued.
- 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 abrasive blades.
- DO NOT** use conventional abrasive blades with water.
- 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 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 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** lay power cords in or near the water.
- DO NOT** replace the motor with any motor that does not have a special grounding connection.
- DO NOT** cut deeper than 1" per pass with a dry blade. Step out to achieve deeper cuts.
- DO NOT** start cutting with a saw until you have a clear work area and secure footing.
- DO NOT** operate this machine while using drugs or alcohol.

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.

**Husqvarna Construction Products, North America
17400 West 119th Street
Olathe, Kansas 66061
In USA: 1-800-288-5040**

What-Is-What (Parts Identification)



- | | | |
|------------------------|------------------------------|----------------------------------|
| A. Set Collar | J. Blade Guard | S. Water Pan Assembly |
| B. Bearing Caps | K. Electrical Receptacle | T. Rolling Stand |
| C. Locking Knob | L. Blade Shaft Nut | U. Conveyor Cart Assembly |
| D. Lockbar | M. Outer Blade Flange | V. Frame Assembly |
| E. Water Pump | N. Wrench | W. Pan Latches (4) |
| F. Hose Barb | O. Drain Plug | Y. Diamond Blade (Not Included). |
| G. Water Control Valve | P. Rip Guide | Z. Parking Brake. |
| H. Water Tube Assembly | Q. Water Pan Assembly Guides | AA. Start / Stop Switch |
| I. Water Tube Ports | R. Cutting Head Assembly | BB. -- |

PRE OPERATION CHECKLIST



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.



Before starting up the machine, make sure you read this entire Operation's Manual and are familiar with the operation of the machine.

WITH MACHINE SETTING A FIRM LEVEL SURFACE:

1. Check that the saw is mounted correctly on the stand.
2. Fill with water and check that the water level covers the water pump inlet.
3. Check that the Cart is set on the rails and traverses freely.
4. Check that the Blade is installed correctly and the blade shaft nut is tightened firmly.
5. Check that the Blade rotates Counter-ClockWise (CCW).
6. Insure that the power cord is plugged into a properly grounded circuit and for the correct power requirements.

1/2 - 1 HOUR OPERATION CHECK LIST:



ALWAYS set the saw on a level surface with the switch "OFF" and the power cord unplugged from the outlet!!

1. Check the blade shaft nut.
2. Check the V-belt tension if any slippage is noticed. DO NOT over tension!!
3. Keep the cart top clean and free of cuttings.
4. Drain, clean and refill pan frequently. Flush the coolant system with plenty of water, then drain and refill the pan.

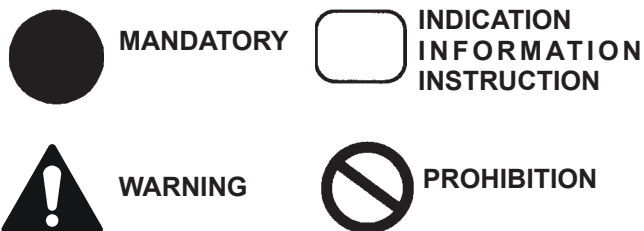
SCHEDULED MAINTENANCE QUICK REFERENCE:



Before performing any maintenance, **ALWAYS** turn "OFF" and unplug the saw.

SERVICE DAILY:

1. It is always good practice to clean your tile saw after each day's use.
2. Drain the water and clean out the pan.
3. Inspect water pump strainer and clean if necessary.
4. For protection, remove blade before transporting the saw.
5. Wipe off excess water.
6. Store saw in a dry safe place.



MANDATORY



INDICATION
INFORMATION
INSTRUCTION

WARNING



PROHIBITION

These signs will give
advice for your safety.

NOTICE

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

Use: Cutting of stone slabs, tiles, bricks or paving stones up to 24"W x 36"L (601 x 914mm)

Tools: Rip Guide and stand comes standard on all tile saws. Diamond blades — water cooled, Ø: up to 10" with Arbor Ø- 5/8" (22.1mm)

(For information, contact your supplier)

Blade Capacity: Rim Ø 10" (254mm) - bore 5/8" (15.9mm)

Profile Wheel: Rim Ø 7" (180mm) - bore 5/8" (15.9mm)

Blade Rotation: Counter-Clockwise (CCW)

Depth of Cut: 3-3/4" (95mm) with 10" (254mm) blade.



Before starting up the machine, make sure you read this entire manual and are familiar with the operation of this machine.



The working area must be completely clear, well lit and all safety hazards removed.



The operator must wear protective clothing appropriate to the work he is doing.



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



WARNING!

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

2 ASSEMBLY

- Remove all items from the shipping carton and identify:
 - Cutting Head Assembly (R) {includes Water Tube Assembly}
 - Rolling Stand Assembly
 - Frame Assembly
 - Water Pan Assembly
 - Converyor Cart Assembly (U) Carton {Cart Assembly and Rip Guide}
 - Water Pump and Accessory Carton: Includes Water Pump, Hose Barb, Water Valve, 15/16" Blade Shaft Wrench, Drain Plug, two Bearing Caps and fasteners: [four each of 5/16" flatwashers and fiber locknuts], Locking Knob and a 5/16" flatwasher.
 - Miter Guide Assembly
 - Literature Assembly Envelope

NOTE: Check the carton and all packing filler for loose parts and optional accessories (if ordered).

- Set the Frame Assembly on a flat surface or on a the rolling stand.
- Set the Water Pan Assembly between the Guides on the Frame Assembly. The Pan is orientated with the Stop tabs on the bottom over the rear leg of the Frame and the drain plug opposite the operator end. The Pan Assembly should slide freely back and forth on the guides with little lateral movement; adjust if needed.
- Install the Converyor Cart Assembly (U) with the Back Stop at the operating end. Check that all four wheels are on the rails and that it travels freely back and forth.

Install the Cutting Head Assembly (R):

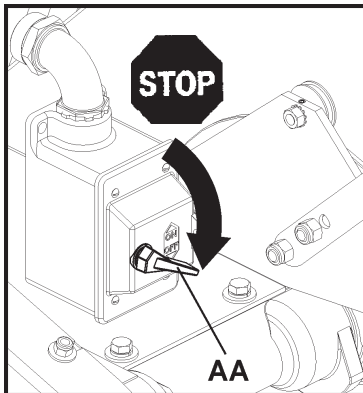
- Set the Cutting Head Assembly (R) on the pivot bar up against the Set Collar. The set collar has been pre-set at the factory to align the blade with the slot in the center of the cart; it can be adjusted if needed
- Insert the Locking Knob (C) with 5/16" flatwasher through the slotted Lockbar into the tapped hole in the belt guard. This will temporarily hold the Cutting Head Assembly (R) in position. The knob is used to set the cutting depth of the blade once the saw is assembled.
- Install the two Bearing CapS (B) and four Cap-screws & Washers below the pivot bar. Tighten this hardware so that the Cutting Head Assembly (R) is held securely on the pivot bar, but can be adjusted up or down.

Water Pump Assembly (E) Set-up:

- Remove the Water Pump (E), Hose Barb (F), the Water Control Valve (G) and Water Tube Assembly (H) from their carton. Thread the Hose Barb on the water pump outlet, hand tighten.
- Slide the Control Valve onto the flexible plastic tubing and push the open end onto the Hose Barb.
- Set the Water Pump Assembly in the pan beneath the belt guard. **Note: The water pump inlet screen must be submerged in order to properly**

- pick up water.**
- Place the Water Tube Assembly to the back of the Blade Guard and insert the two 1/4" plastic nozzles into the Ports on the side of the Blade Guard. To prevent interference with the full movement of the cart, it is recommended that the tubing and electrical cord exit out the back between the rail and pan, near the vertical post of the Frame.
 - Insert the male plug into the Receptacle on the motor. The Water Pump will start when the motor is turned on. For dry cutting, the Water Pump should be unplugged or removed to prevent damage to the pump. **NOTE:** If a motor is changed from 230V power supply to 115V, the voltage change switch will still allow the water pump outlet to provide the same 115V to the water pump.

Install the Blade:



! WARNING!
Always set the Motor Switch (AA) to "OFF" (STOP) position prior to mounting the blade.

- Be sure you are using the correct blade for the material being cut. For example, blades are available for cutting materials such as wall tile, quarry tile, marble, slate and similarly hard materials. For the best results, always use genuine **Husqvarna**® diamond blades. Contact your nearest dealer to select the correct blade for your specific cutting needs.
- Rotate the Blade Guard fully up, tightening the wing nut if needed to hold it in the fully raised position.
- Remove the Blade Shaft Nut and the Outer Blade Flange.
- Check the blade for Counter Clockwise (CCW) rotation and install on the spindle shaft.

NOTICE

Rotation direction is indicated by an arrow on one side of the blade. Make sure the blade contact surfaces are clean.

- Install the outer flange with the large diameter against the blade. Tighten the Blade Shaft Nut with the 15/16" Blade Shaft Wrench provided.
 - Lower the Blade Guard and retighten the wing nut to securely hold the guard in place.
- Install the Drain Plug into the back end of the pan and fill with clean water up to the bottom of the rails or, at a minimum, until inlet filter of water pump is covered. [27-1/2 gallons (105 litres)]

3 OPERATING PROCEDURE

! WARNING!



Before starting up machine make sure you completely read these instructions. Be familiar with operation of the machine before operation!



! WARNING!

Take into account the working conditions from the health and safety point of view.



Always pay extreme care and attention to the preparation of the machine before starting.



Remove all wrenches and tools from the machine.



Always keeps blade guard in place.

- Fill the Pan with clean water to fully submerge the water pump screen. [27-1/2 gallons (105 litres)]
- Before connecting the power cord:
 - * Check the spindle nut to be sure it is tight and that the blade rotates freely.

! WARNING!

Check that the ON/OFF switch is in the "OFF" position.

Only connect the power cord to a properly grounded outlet of the correct voltage. See the decal near the power cord for power requirements.

Connect the saw as close to the power supply as possible. If needed, use the correct size three (3) conductor extension cord to avoid excessive voltage drop.

Never use lamp cord type extensions.

Refer to the Recommended Extension Cords chart on page 16.

- Turn the switch to "ON". The blade should turn counter-clockwise (CCW), when looking at the blade guard side. The water pump will start automatically when the motor starts. Adjustment of the water supply may be made by means of the Control Valve.
- Follow the blade manufacturer's recommendations for dry or wet cutting.

⚠ WARNING!

Wet cutting blades can be damaged or destroyed without sufficient water. Only blades specifically designed for dry cutting can be used without coolant.

NOTICE

The water supply should be adequate, with water flowing on both sides of the blade.

Keep the water clean and make certain the WATER LEVER IS ALWAYS ABOVE THE PUMP INLET.

Do not run the water pump dry!! Unplug for dry cutting.

- For straight cuts, position the tile squarely against the back edge of the conveyor cart. Keep the cart clean and free of cuttings. The standard rip guide is used.
- Move the conveyor cart slowly and carefully until the blade is in contact with the tile. The blade needs a chance to “break-in” or “wear-in” slightly. It may take about ten cuts to open a new blade for best cutting.

This machine features an adjustable water pan assembly which is guided to maintain squareness accurately. The pan adjustment is easy; spring-tensioned latches hold the pan firmly against the frame. Flip up the four latches and slide the pan forward or back to the position best suited for the operator and the material being cut. Then re-set the latches.

4 MANUAL THERMAL OVERLOAD

The motor is equipped with a manual overload protection reset button. If the motors overheats, the red reset button will “pop out” to open the motor circuit; stopping the motor and water pump. If this occurs, the motor ON/OFF switch must be set to “OFF”. After motor the cools, push in the reset button. When it stays in, the motor can be restarted.

5 RECOMMENDED EXTENSION CORDS

NOTICE

Good motor performance depends on proper voltage. Extension cords that are too long and/or too small in wire gauge reduce the voltage to the motor under load. Use extension cords no smaller than indicated below.

Motor HP RPM	F.L. Amps		50' Cord		75' Cord		100' Cord	
	115V	230V	115V	230V	115V	230V	115V	230V
1-1/2 1725	14.6		#12		#10		#8	
1-1/2 3450	17.2	8.6	#10	#14	#10	#14	#8	#14
2 3450	16.8	8.4	#10	#14	#8	#14	#8	#12

6 ALIGNMENT PROCEDURES

Your saw is factory assembled and aligned prior to shipment to ensure accurate cuts when your saw is delivered. However, since we cannot control rough handling during shipping, it is suggested that the alignment be checked. If the saw is found in need of adjustment, refer to the appropriate section(s) following.

There are two basic alignment checks for the saw and any adjustments made must follow these procedures to ensure that the unit functions freely.

Adjustment tools required: Carpenter’s Square, two (2) 7/16” wrenches, 1/2” wrench and 5/32” hex key.

1. **Check the Blade in Slot Alignment:** The blade should be centered in the conveyor cart slot.
 - Set-up your saw as described above, move the conveyor cart back and forth from the front to the rear of the pan. If the blade contacts either side of the slot, the Cutting Head Location Adjustment must be performed.

Cutting Head Location Adjustment: The Cutting Head Assembly (R) is located between to Set Collars.

- Using a 5/32” hex key, loosen these two (2) set collars. Next, loosen the four (4) 5/16”-18 locknut nuts (1/2” wrench) that clamp the bearing caps to the pivot bar. Move the Head Assembly along the bar until the blade no longer contacts the slot. Relocate the set collars against the sides of the Cutting Head again and re-tighten the set screws. Re-tighten the capscrews on the bearing caps.

2. **Check the Parallel Alignment:** The conveyor cart should travel parallel to the plane of the blade.

- Place a square rule against the backstop, lightly in contact with the blade. The blade surface should be parallel to the square; i.e., no gap between the blade and the square at either the front or back edge of the blade. Next, holding the square firmly, traverse the cart fore and aft. The blade should remain parallel to the square, staying slightly in contact with it throughout its full travel. If the blade does not stay in contact with the square, the Parallel alignment must be performed.

Parallel Alignment

- The parallel tracking of the cart can be adjusted by moving the rails on which the cart travels. The mounting holes in the pan and the rail support are slotted to accommodate this adjustment.

Align the inside rail first. Loosen the eight (8) 1/4”-20 fasteners (7/16” wrenches) locating the two (2) rails so that both rails are free to move. Move the end(s) of rail until the square is flush with the blade as described above. Tighten the fasteners of this rail and recheck the alignment. Once alignment has been made, move the cart fore and aft to locate the second rail parallel to the first. Tighten the remaining four fasteners.

7**MAINTENANCE PROCEDURES****WARNING!**

Before performing any maintenance, ALWAYS place the machine on a level surface with the motor "OFF" and disconnect the electrical current. Let the machine cool down!

Your saw is a ruggedly constructed machine, engineered to give long, satisfactory performance. Simple daily maintenance and care will add to the life and productivity of your saw.

After each day's use: **CLEAN THE MACHINE!!**

- Turn off and unplug the saw before performing any maintenance.
- Keep the cart top clean and free for cuttings. To clean it, flush the top surface and grooves with water.
- Drain, clean and refill the pan frequently. Flush the coolant system with plenty of water, then drain and refill the pan.
- If the water flow stops, check the water pump to see if the shaft and impeller turn freely. See the **WATER PUMP TROUBLE-SHOOTING PROCEDURE** section below.
- It is always good practice to clean your tile saw after each day's use. Drain the water and clean out the pan. Clean the rails. Before storing, it is good practice to wipe or spray rails with water-soluble oil (like, WD-40 or equivalent).



Entrust all repairs to your authorized dealer only.

8**WATER PUMP TROUBLE-SHOOTING PROCEDURE**

If Water Stops Flowing:

1. **Stop Sawing**, then
2. **Disconnect Electrical Plug from Outlet**, then
3. **Remove the Pump**, then
4. **Back Flush**

Back flushing is done by forcing water into the pump discharge and out through the screen. Most of the time this procedure works, and the pump can be put back into service. (See Figure)

If the back flushing does not work, remove the screen and turn the impeller manually, looking for and rinsing out the impeller cavity of any dirt or foreign matter.

9**REPAIRS**

We carry out all repairs in the shortest possible time and at the most economical prices. (See front page for address and phone numbers) Contact your authorized dealer concerning maintenance and repairs.

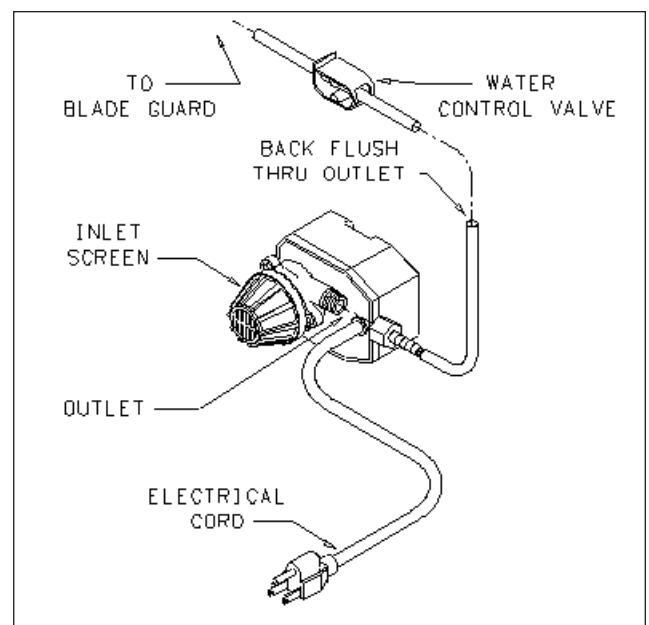
10**SPARE PARTS**

For quick supply of spare parts and to avoid any lost time, it is essential to quote the data on the manufacturer's plate fixed to the machine and the part number(s) and description to be replaced with every order.

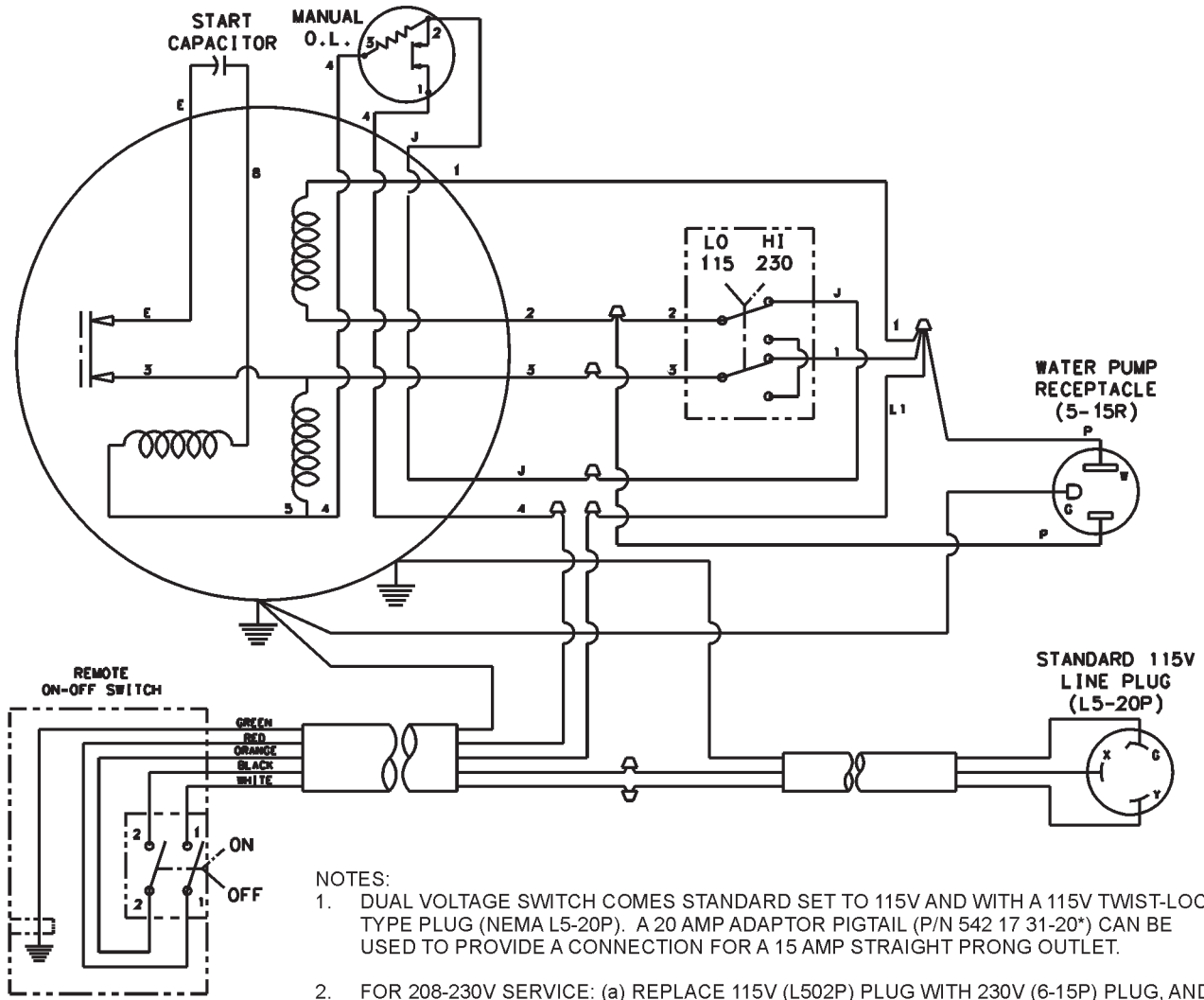
**WARNING!**

The manufacturer accepts no responsibility caused by unsuitable use or modifications.

The instructions for use and spare parts found in this document are for information only and are not binding. As part of our product quality improvement policy, we reserve the right to make any and all technical modifications without prior notice.



WIRING DIAGRAM: 1-1/2 HP MOTOR

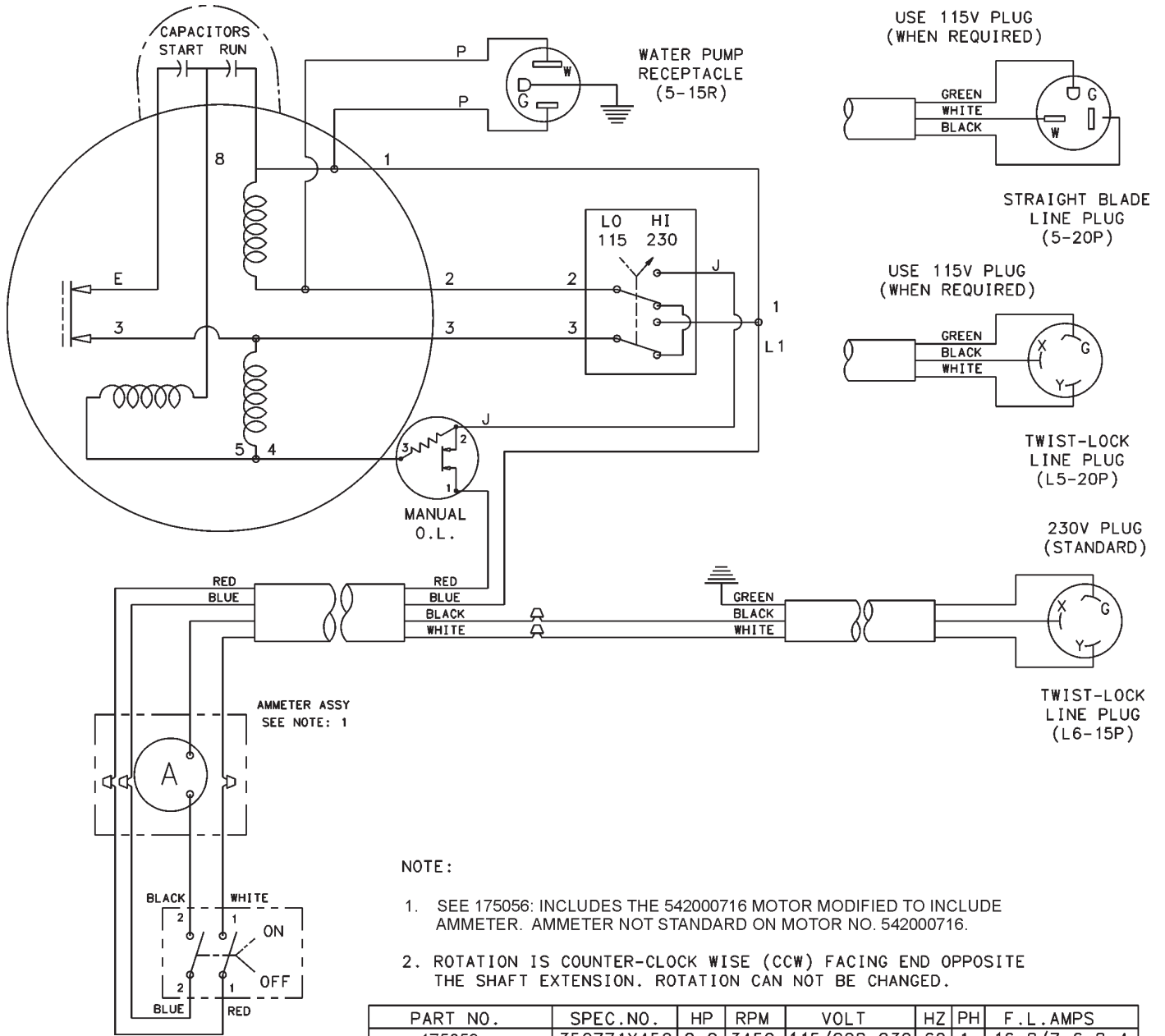


1.5 HP, 3450 RPM, T. E. F. C.
 115V/208-230, 60 Hz, 1 PHASE
 17.2/9-8.6 FULL LOAD AMPS
 INS. CLASS: F
 CODES: NEMA = -; KVA = J

PART NO.	SERVICE ITEMS
542 00 08-73*	MANUAL O. L.
542 16 15-81*	ON/OFF SWITCH
542 03 20-80*	SWITCH, BOX & WIRING
542 03 01-41*	V. C. SWITCH (INCLUDES GUARD)
542 18 91-17*	START CAPACITOR {460 Mfd/115V}
NONE	RUN CAPACITOR

PART NO.	HP	RPM	VOLT	HZ	PH	F. L. AMPS
542 00 06-05	1.5	3450	115/208-230	60	1	17.2/9-8.6

WIRING DIAGRAM: 2 HP MOTOR with AMMETER





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