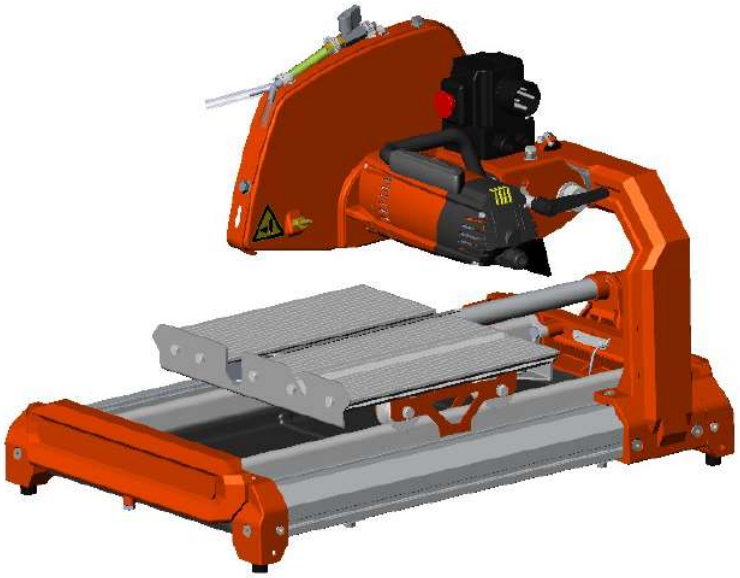
D-CUT 350A

Drying&Wet Cutting

User's Manual



Read operating manual before starting any work!
Keep the operating manual for future use!

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1. GENERAL

1.1 Operating Manual

This operating manual provides guidance on safe and efficient operation and should form a basis of any actions involving the machine. It is an integral part of the machine, which should be kept in the immediate vicinity accessible for its operating personnel. Prerequisite of safe operation is adherence to all safety and handling instructions.

Therefore, before starting any work, the personnel must read carefully and understand the operating manual.

Moreover, the accident prevention regulations applicable at the site of the machine operation and general safety regulations must be complied with.

1.2 Explanation of symbols

Warnings and safety instructions

Warnings and safety instructions in the manual are indicated with the pictograms and provided in blocks highlighted in grey and yellow.

DANGER:
... draws attention to an immediate danger that, if not avoided, may result in heavy or even fatal injuries.

ATTENTION!
... draws attention to potentially dangerous situations that, if not avoided, may result in material damage.

.

...marks danger due to electric current.
Failure to observe the safety instructions leads to danger of heavy or fatal injuries.

...marks danger of crushing.
Failure to observe the safety instructions leads to danger of heavy injuries from moving parts.

.

...marks danger due to hot surface.
Failure to observe the safety instructions leads to danger of burns and heavy skin injuries caused by heat.

...marks danger from moving diamond blades.
Failure to observe the safety instructions leads to danger of cuts and heavy skin injuries caused by rotating diamond blades.

1.3 Liability limitation

All data and instructions provided in this manual were compiled with consideration of applicable standards and regulations, state of the art in this field and our long-standing insights and experience.

The manufacturer accepts no liability for damages caused by:

- Non-observance of the Operating manual.
- Unintended use.
- Employment of unskilled and uninstructed personnel.
- Unauthorized conversions.
- Technical changes.
- Use of non-approved spare parts.

The responsibilities agreed in the delivery contract, the General Terms and Conditions as well as the delivery conditions of the manufacturer and the statutory regulations valid at the time of the conclusion of the contract shall apply.

Warranty

The manufacturer guarantees the functional capability of the applied process technology and performance parameters identified. The warranty period commences with the defect-free delivery.

Warranty conditions

12 months after delivery of mechanical and electrical components for one-shift operation, except for the wear parts and tools.

The warranty claim expires, if the system was not installed and started up by our experts.

The warranty extends to the replacement parts. Consequential damages are excluded.

Damage caused by natural wear, deficient of improper maintenance, failure to comply with the operating regulations, excessive loads and use of inappropriate equipment shall be excluded from the warranty.

2. SAFETY

2.1 Intended use

This D-CUT 350A machine is designed exclusively for the following purposes in the commercial sector: Dry and wet cutting of the solid construction materials such as: Clinker, bricks, concrete block products, refractory, natural and artificial stone products as well as tiles and ceramics.

- Any claims for damages resulting from unintended use are excluded.
- The operator alone is responsible for all damages due to unintended use.

2.2 Rationally foreseeable misuse

Any use of the machine going beyond the intended one, shall be deemed unintended and thus prohibited.

This also applies to:

- Cutting any materials other than presented.
- Cutting without or with open diamond blade guard.
- Cutting without water.
- Removal of clippings in pendulum cutting procedure (vertical plunging into clippings from above).

2.3 Responsibilities of Operator

Operator

An operator is every natural or legal person, who uses the machine or delegates its use to others and is responsible for the safety of the user, personnel or third parties in the course of such use.

Operator's duties

The machine is used in the commercial sector. Therefore, the operator of the machine is subject to statutory obligations regarding occupational safety. The operator, in particular, must:

- Be informed about current occupational safety regulations.
- Determine, through hazard evaluation, any potential additional dangers resulting from specific usage conditions at the site of the machine operation.
- Check regularly throughout the service life of the machine, whether the operating instructions drawn up by the operator are in line with the current status of rules and regulations.
- Exercise control of the competence for installation, operation, maintenance and cleaning of the machine in a clear and unambiguous manner. Make sure that all personnel involved with the machine have read and understood the operating instructions. Moreover, the personnel must undergo training in handling the machine at regular intervals and be informed about potential dangers.
- Provide the persons appointed for operating the machine with the prescribed and recommended protective.
- Moreover, the operator is responsible for ensuring that the machine is always in a technically perfect condition.
- Is maintained according to the specified maintenance intervals, and that all safety mechanisms of the machine are regularly controlled for completeness and functionality.

2.4 Personnel requirements

Fundamentals

Any operation with the machine may only be carried out by the persons, capable of performing their work properly and reliably and meet every requirement mentioned.

- No works can be carried out by the persons, whose response capability is affected, e.g., by drugs, alcohol or medicines.
- When deploying personnel at the site of operation, always adhere to the applicable occupational and age-specific regulations.

WARNING:
Risk of injury for unqualified personnel!

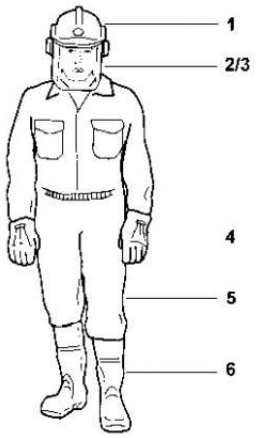
Improper operation can result in significant personal and material damage.

Any operations must be only carried out by the persons having required training, knowledge and experience.

Qualified electricians
As a matter of principle, all works on the electrical installations must be carried out by qualified electricians.

2.5 Personal protective equipment

Wearing personal protective equipment is required during the work.



1. Helmet with ear protectors.
2. Visor or protective goggles.
3. Dust mask / respirator.
4. Safety gloves.
5. Suitable protective clothing.
6. Protective footwear.

NOTE!
It is prohibited to wear protective gloves near rotating parts, which pose the danger of pinching. Here, danger created by wearing protective definitely surpasses the intended protection.

2.6 Dangers

The machine has undergone a risk review. Wherever possible, the identified dangers were eliminated and risks reduced.

Nevertheless, the machine poses residual risks described in the following section.

- Strictly observe warnings and safety instructions specified here and in the chapters about handling to avoid potential damage to health and dangerous situations.

2.7 Residual Risks

CATIONS!
Risks of cut injuries!

Reaching into rotating tools may lead to heavy injuries.

- Do not touch rotating diamond blades in any circumstances.
- Never work without diamond blade guard.
- Only work with diamond blade guard closed.
- Only remove clippings with diamond blade stopped.

CAUTION!
Risk of injury by flying clippings or tool parts!

- Failure to wear appropriate protective equipment, working with open diamond blade guard or with inappropriate diamond blades may lead to heavy injuries.
- Wear protective goggles.
- Only work with diamond blade guard closed.
- Only work with diamond blades, specifically designed for the material to be cut.

CAUTION!
Risk of injury by pinching in movable parts!

Failure to wear appropriate protective equipment may lead to heavy injuries.

- Wear protective gloves.
- Lock the cutter head.
- Lock the guiding bridge.

DANGER!
Danger to life from electric current!

Touching live parts leads to death. Damaged insulation or individual components can be life-threatening.

Disconnect the machine from the power supply before any work on the electric system. Verify that the system is disconnected from power supply.

- Switch off power supply before maintenance, cleaning and repair operations and secure the machine against being restarted.
- If the power supply insulation is damaged, switch off immediately and arrange for repairs.
- Never bypass or disable fuses.
- Always use fuses with correct amperage when replacing defective fuses.
- Keep moisture away from live parts.
- Any works on the electrical installations must be carried out by qualified electricians.

CAUTION!
Risk of burns on hot surfaces.

- Contact with hot parts may cause burns.
- Do not touch the surface.
- Before every work, make sure that the parts have cooled down to the ambient temperature.

CAUTION!
Danger of injuries caused by special physical effects.

Failure to wear appropriate protective equipment may lead to heavy injuries. Wear ear protectors. Wear protective gloves. Take adequate breaks. Have regular medical examinations ‘G20‘.

CAUTION!
Risk of injury by hazardous substances, such as dust and cutting water or slurry!

Failure to wear appropriate protective equipment may lead to damage to health. Use personal protective equipment. Renew the cutting water regularly. Use the dust mask. Connect water supply.

CAUTION:
Risk of injury due to inadequate lighting.

Work in inadequate lighting conditions may lead to heavy injuries. Provide for adequate lighting at the workplace.

WARNING:
Danger to life due to defective or bypassed safety devices!

Inoperable, bypassed or disabled safety devices do not protect from hazards and may lead to heavy or fatal injuries.

Before commencement of works, always make sure that all safety devices are properly installed and functional.

Never disable safety devices.

Ensure that the safety devices are always freely accessible.

WARNING:
Risk of injuries due to wrong spare parts.

Wrong spare parts can seriously compromise safety and cause damage and malfunction up to total failure.

As a matter of principle, only original spare parts must be used. Original spare parts can be obtained via an authorized dealer or directly from the manufacturer.

2.8 Signage on machine

Danger from electric current!

DANGER!
Danger to life from electric current! Touching live parts leads to death.

- Damaged insulation or individual parts can be life-threatening. Disconnect the machine from the power supply before any work on the electric system.
- Check that no voltage is present! Switch off power supply before maintenance, cleaning and repair operations and secure the machine against being restarted.
- If the power supply insulation is damaged, switch off immediately and arrange for repairs.
- Never bypass or disable fuses.
- Always use fuses with correct amperage when replacing defective fuses.
- Keep moisture away from live parts.

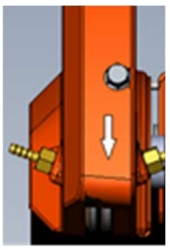
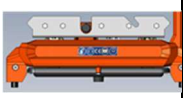
- Any works on the electrical installations must be carried out by qualified electricians.
- Annual check of the electric system according to VDE0701.

CAUTION!
Risk of cut injuries!

Reaching into moving tools may lead to heavy injuries.

- Do not touch rotating diamond blades in any circumstances.
- Switch off the machine and disconnect power supply before replacing the diamond blade.

There are the following symbols and information signs on the machine that refer to potential dangers:

	Warning of rotating tool!	
	Running direction of the saw blade.	
	Wear gloves Wear ear protectors Observe the operating manual Wear protective goggles The machine meets EU guideline	

2.9 Actions in emergency and in case of accidents

Necessary actions

- Always be prepared for accidents or fire.
- First aid facilities (first aid box, cloth, etc.) and fire extinguisher must be close at hand.
- Personnel must familiarize themselves with accident signaling equipment, first aid and rescue facilities.
- Access roads for rescue vehicles must be always kept free.

If the need arises, act properly

- Initiate first aid measures
- Remove persons affected from the danger area.
- Inform persons responsible at the operation site.
- Alert doctor and/or fire brigade in case of heavy injuries.
- Keep access roads for rescue vehicles free.

3. MACHINE DATA

3.1 Diamond blades

DANGER!
Risk of injury by defective or incorrectly mounted diamond blades!

Wrong rotation direction and damaged diamond blades may cause injuries of personnel!

Check diamond blades for broken of segments and segment pieces, segment foot cracks, diamond blade deformations or signs of wear before starting work.

Pay attention to the rotation direction arrows on the diamond blades and guard!

DANGER!
Risk of injury by unchecked or unapproved tool!

Diamond blades or buzz saw blades that have not been checked or approved may cause injuries of personnel!

Before starting work, check whether a proper diamond blade is mounted.

Pay attention to the rotation direction arrows on the diamond blade and guard!

NOTE!
All diamond blades used must be designed in terms of their permissible max. cutting speed to match the max. drive speed and intended application of the machine tool.

Diamond blade	Diameter	Material
Concrete diamond blade	Ø 350 mm	Concrete, washed concrete, bricks
Universal diamond blade		Concrete, washed concrete, bricks, clinker, hard stone, granite
Tiles and natural stone diamond blade		Hard stone, granite, natural and artificial stone, hard clinker

3.2 Type plate

The type plate is located on the vertical supporting column for cutting head.

3.3 Installation site requirements

The floor surface must:

- Have sufficient load bearing capacity.
- Be slip proof.
- Be level.

3.4 Storage requirements

Storage conditions

As a matter of principle, the machine, its components, assemblies or parts must be only stored in the following conditions:

- Do not store outdoors.
- Store in dry and dust-free place.
- Do not expose to aggressive media.
- Protect from solar radiation.
- Avoid mechanical vibrations. Storage temperature range 5 to 45°C relative air humidity, max. 60%.

In case of storage for over 3 months, check general condition of all parts and packaging on a regular basis. If necessary, renew or replace conservation materials.

4. TRANSPORT

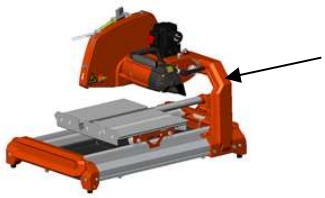
NOTE!
Damage through improper transportation!

Improper transportation can result in considerable damage of the machine and objects in the vicinity.

Before every transport:

- The cutter head must be locked.
- The cutter head must be lowered and locked.
- The machine must be disconnected from power supply.

The machine can be carried by one person on the vertical column.



NOTE!
The machine is not designed for crane transport. There are no appropriate load suspension points on the machine.

5. INSTALLATION

5.1 Connection

Before connecting the machine to the power source, make sure that:

- Voltage / phase of the power supply, match the data on the type plate of the motor and machine.
- The power supply line is grounded according to the safety provisions.
- The wire size of the extension cord is sufficient, H07RNF 3x2.5 mm² up to 50m for 230V.

5.2 Mounting a diamond blade

To mount a new diamond blade or replace the used one, proceed as follows:

1. Switch off the machine and interrupt the power supply by pulling the mains cable from the mains outlet.
2. Loosen the screw on the back of cutting wheel guard so as to be able to turn the blade guard aside.
3. Loosen the nut of the motor shaft and remove the outer cutter flange.
4. Clean the cutter flange, nut and motor shaft.
5. Check the parts for signs of wear.
6. Mount or replace the diamond blade. While doing so, pay attention to the correct rotation direction of the diamond blade and motor shaft.
7. Replace the outer cutting flange on the motor shaft.
8. Screw the nut onto the motor shaft again and tighten it firmly.
9. Turn the cutting wheel guard back to its original location.
10. Tighten firmly the screws on the back of cutting wheel guard.

NOTE!
The arrow on the cutting wheel indicates correct rotation direction.

NOTE!
The cutting wheel, irrespective of its position or the position of the cutter head, may not touch the table!

6. OPERATION

6.1 Intended working position of the operator

The operator takes position in front of the machine.

The operator stands in front of the machine so that he can push the cutting material table forward and back and adjust the cutting head appropriately.

6.2 Start-up preparation

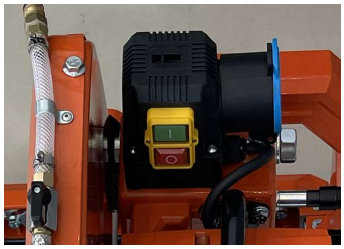
To safely use the machine as intended, the following preconditions must be met:

- The machine stands firmly.
- The water supply via a pressurized water tank or a standing pipe is guaranteed, or a suitable dust extractor of class M is connected to the dry cutting method.
- The machine has been checked for damage, loose screw connections and integrity.
- The water supply is functional.
- Rotation direction arrows on the cutting wheel and guard match.

- An appropriate cutting wheel must be installed, which meets optimum conditions.

6.3 Start-up

The machine is switched on by the main switch. For this purpose, press the green button to start.

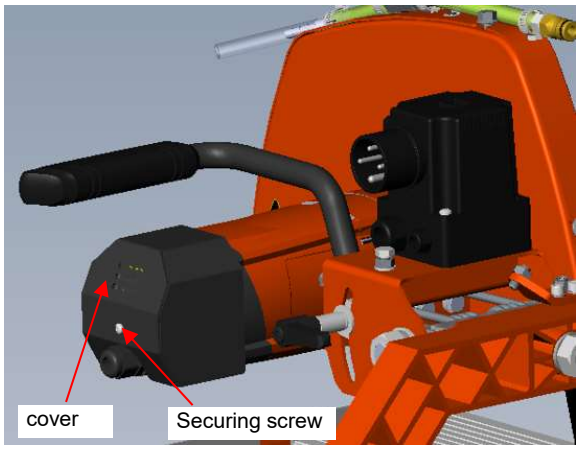


After the start, check the following:

In dry cutting process, the dust extractor must be switched on.

In wet cutting process, the cooling water must be transported in sufficient quantities to the cutting wheel and drain off on both sides.

In wet cutting process, an accessory protection cover must be attached to the rear side of motor and secured with screw.



If these are not the case, stop machine immediately!

6.4 Cutting operation

6.4.1 Normal cutting in 90° position

When cutting in 90° position, the cutter head remains at a fixed point. For adjustment, proceed as follows:

1. Switch of the machine -> the cutting wheel must stop rotating!
2. Loosen the adjusting screw.
3. Set the cutter head in the desired position.
4. Tighten the adjusting screw -> check if the cutter head is adjusted in height and make sure that it cannot move.
5. Put the material to be cut onto the table (for table saw machine position it directly at the material stop).
6. Check the position of the material using the angle stop.
7. Start the motor. If using wet cutting, open the ball valve for the water supply.
8. Grasp the handle of the cutting head with your right hand and the transport handle on the frame with your left hand.
9. Then slowly slide the cutter head through the material to be cut without pressure. The cutting wheel then cuts through the material on the table.

NOTE:
The cutting wheel, irrespective of its position or the position of the cutter head, may not touch the table!

NOTE:
In emergency, press the red stop button on the switch.

Cutting method: 45° bevel cuts

The machine offers the possibility of performing 45° bevel cuts. To perform 45° bevel cuts, proceed as follows:

1. Switch off the machine -> the cutting wheel must stop rotating!
2. Pull the cutting material table forward to have room for turning the cutting head.
3. Loosen the nut at the back of the cutting head.
4. Swivel the cutting head until it reaches the 45 °position.
5. Tighten the nut firmly at the back of the cutting head.
6. Fix the cutting head with the locking lever in the lowest position.
7. Place the material to be cut on the cut material table and position it directly at the material stop.
8. Start the motor. If using wet cutting, open the ball valve for the water supply.
9. Grasp the handle of the cutting head with your right hand and the transport handle on the frame with your left hand.
10. Slide the cutting material table slowly, without pressure, forward to the cutting disc and pull it back again after cutting through the cut material.

NOTE:
In emergency, press the red stop button on the switch by the left hand.

NOTE:
The cutting wheel, irrespective of its position or the position of the cutter head, may touch neither the table, nor the back square!

To bring back the cutter head to the 90° position after 45° bevel cuts, proceed as follows:

1. Switch off the machine -> the cutting wheel must stop rotating!
2. Loosen the locking lever and fix the cutting head again in the top position.
3. Loosen the nut at the back of the cutting head.
4. Swivel the cutting head until it reaches the 90 °position.
5. Tighten the nut firmly at the back of the cutting head
6. Fix the cutting head again with the locking lever.

NOTE!
Hold firmly the cutter head with the hand in the 90°position. Tightening the nut can turn the square back so that the angle of the cutter head is not exactly 90°.

NOTE!
The cutting wheel, irrespective of its position or the position of the cutter head, may not touch the cutting table!

6.4.2 Water supply

Heavily polluted water decreases the service life of the water pump and cutting wheel.

For frequent use, change water several times a day, and collect, filter and dispose of the cutting mud.

6.4.2 Dust extraction

Make sure that a suitable dust extractor of class M is connected.

The suction pipe must not be clogged. If this is the case, remove the constipation before cutting!

6.5 Stop cutting operation

Use the red stop switch on the motor to stop the machine.

7. Technical Data

1) Dimensions of the machine

Specification	Value	Unit
Length	850	mm
Width	580	mm
Height	610	mm
Empty weight	28	kg
Operating weight	32,5	kg

2) Dimensions of the cut piece

Specification	Value	Unit
max. length	465	mm
max. width	400	mm
max. height	110	mm
max. weight	13	kg

3) Connection and motor values

Specification	Value	Unit
Rated voltage	230/110	V
Rated frequency	50	Hz
Capacity	2,2	kW
Rated current	10/20	A
Required fuse	16/29	A
Cutting shaft rotation speed	2800	U/min
Motor protection class	IP55	
Motor duty type	S6	

4) Other data

Specification	Value	Unit
Water tank	5	l
Cutting wheel	350	mm
Bore	25,4	mm
Flange Ø	90	mm
Vibration level	2,3	m/s^2

Measuring tolerance		
Vibration level	0,2	m/sec^2

5) Operating conditions

Working zone

Specification	Value	Unit
Temperature range	Ambient temperature 5-45	°C
Relative air humidity, maximum	60 (without condensing)	%
Conditions	Only operate the machine tool in the dust-free environment! Avoid direct impact of dampness, dust and frost. Do not operate in strong electric and magnetic fields! Do not operate the machine tool in explosive atmosphere!	

6) Noise emission

	Without load	Full load
Sound pressure level	73 dB (A)	89 dB (A)
Sound power level	75 dB (A)	91 dB (A)

Measuring tolerance	
Sound pressure level	4 dB (A)
Sound power level	2,5 dB (A)

Guaranteed sound power level	85 dB (A)

The data define the sound level of the noise exposure at the workplace of the operator and sound power level of the machine tool.

The emission values meet standards EN ISO 3744, EN 12418 and Directive 2005/88/EC.

8. Maintenance & Cleaning

Maintenance works necessary for optimum and trouble-free operation are described in the following sections.

- If an increased wear of parts is revealed by regular inspections, reduce the maintenance intervals!
- Draw up a maintenance log after every maintenance! The log assists in error analysis, enables adjusting the intervals to actual usage conditions and validating guarantee claims.
- If you have any queries on maintenance works and intervals: contact manufacturer.

8.1 Maintenance plan

Interval	Maintenance work	Personnel
Before every commissioning	Visual check - of the entire machine - of the tool holder (flange and blade holder) - of the tool (cutting wheel) - of the control elements (handles, rollers, etc.) - of the water tank and hoses connections - of the cutter head and cutting table	Operating personnel
	Visual check of the electric system of the motor	Specialist personnel
	cleaning the tool holder (flange and blade holder)	Operating personnel
	checking the tool (cutting wheel) for replacement necessity	Operating personnel
	cutter head, cutting table - lubrication /greasing / oiling - applying corrosion protection	Operating personnel
After completion of work	Cleaning of - entire machine - control elements (handles, rollers, etc.) - tools (cutting wheel) - cutter head, cutting table	Operating personnel
	Draining and cleaning water hoses and tank, remove accumulated sludge deposits on the water tank floor	Operating personnel
	Cleaning of suction pipe, remove accumulated dust residues and pieces of material	Operating personnel
	Cleaning of motor housing	Specialist personnel
	tool holder (flange and blade holder) - lubrication /greasing /oiling - applying corrosion protection	Operating personnel
weekly	Re-tightening and adjusting - control elements (handles, rollers, etc.) - cutter head and chain - threaded joints	Operating personnel
yearly	Safety inspections of - electric systems - motor	Qualified electricians
in case of an error	Visual check - of the entire machine - of the cutter head and cutting table	Operating personnel
	re-tightening and adjusting cutter head and cutting table	Operating personnel
in case of damage	change and replacement - entire machine - tool holder (flange and blade holder) - tools (cutting blade) - control elements (handles, locking rollers, etc.) - water tank and hoses - cutter head and cutting table	Operating personnel
	change and replacement - electric systems - motor	Qualified electricians

Interval	Maintenance work	Personnel
150 hours operation	Replace gearbox oil	Specialist personnel
250 hours operation	Replace carbon brush	Qualified electricians

ATTENTION:
Cleaning by a high-pressure cleaner will damage the machine.
Foaming and cleaning with water will damage the machine.
The diamond blade may not be cleaned by metal cleaning tools (scraper, metal sponge or similar), otherwise it will be damaged

8.2 After approx. 150 operating hours

The gear oil must be replaced after the first 150 operating hours. Gearbox oil changes bring about an essential increase of the tool's lifetime

8.3 After approx. 250 operating hours

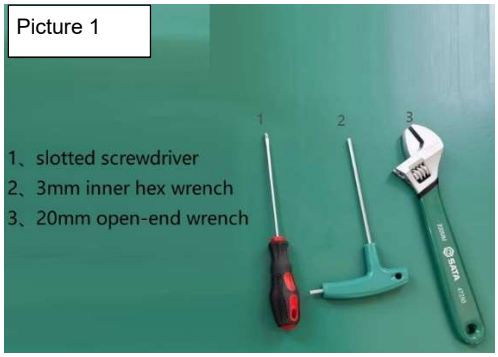
Have the carbon brushes checked by a qualified electrician and replaced if necessary:

Use only original spare parts.

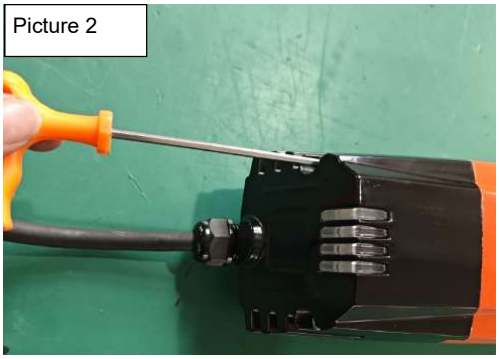
8.4 Instruction for changing carbon brushes

1) Prepare tools. (picture 1)
2) Loosen the 4 fixing screws on back ocver by using a 3mm inner hexagonal wrench. (picture 2)
3) Loosen the cable gland by using a 20mm open-end wrench. (picture 3)
4) Pull off the back cover from motor housing. (picture 4)
5) Lift the spring and take the carbon brush out from brush holder, clean carbon brush holder with brush. (picture 5)
6) Loosen the screw for fixing the cable of brush holder, remove the worn off carbon brush and replace with new carbon brush, fix the cable of carbon brush by the screw, lift the spring, assemble the carbon brush into carbon brush holder. (picture 6)
7) Check and make sure the new carbon brush moves smoothly in carbon brush holder.
8) Assemble the back cover and fix it with 4 screws.

Picture 1



Picture 2



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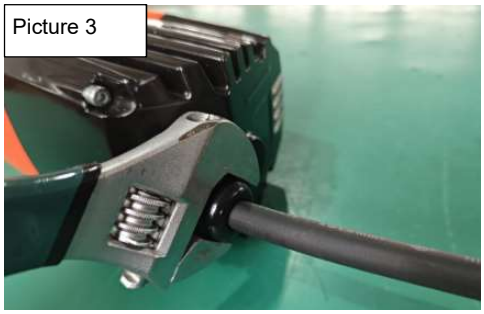

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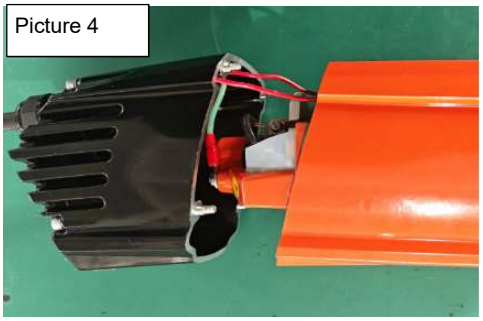

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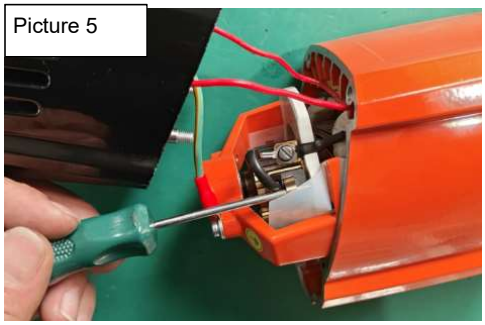
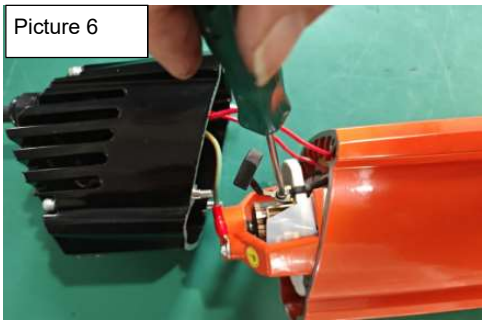


Picture 6



8.5 Steps after completing maintenance

- After completion of the maintenance works and before switching on, follow the following steps:
- Check for tightness all threaded joints previously detached.
- Check the proper installation of all previously removed protective devices and covers.
- Make sure that all tools, materials and other equipment have been removed from the working zone.
- Clean the working zone and remove any spilled substances such as liquids, processing materials or similar.
- Make sure that all safety devices of the system function properly.

9. Troubleshooting table

Error message / error	Possible cause	Troubleshooting	Personnel
When switched on, the machine does not start	Mains plug is loose	Check proper connection to mains	Operating personnel
	Mains plug is defective	Check the mains plug for operability, replace if necessary	Qualified electricians
	Loose connection in the electric system	Have the entire electric system of the machine checked	
	The drive motor is defective	Have the drive motor checked, replace if necessary	
	The main switch is defective	Have the main switch checked, replace if necessary.	
The machine does not provide sufficient performance	The mains plug is too long, cord reel is wound up	Observe the prescribed length of the mains plug. Unwind the cable cord	Operating personnel
	Capacity of the local mains is insufficient	Pay attention to and observe the machine connection data	
	The drive motor does not maintain the rotation speed	Have the drive motor checked, replace if necessary	Qualified electricians
	Hose are clogged	Clean the hoses	
	Hoses bent	Check hose layout	

	A hose is leaky or detached	Replace or re-attach the hose properly	
Error message / error	**Possible cause**	**Troubleshooting**	**Personnel**
Motor does not start	Mains plug is not properly plugged.	Check the mains plug for proper connection	Operating personnel
	A fuse at the construction site distribution board has tripped	Check fuses	
Cutting blade wobbles	Blade tension is poor	Return the cutting blade	Manufacturer
Segments are coming off	Overheating, cooling is poor	Check cooling water line	Operating personnel
		Segments are soldering on	Manufacturer
High segment wear!	Segment bonding is too soft	Use cutting wheels with harder segments or reduce feeding - pressure	Operating personnel
	Segments are too thin in relation to the motor capacity and feeding pressure	Reduce the feeding pressure, or use cutting wheels with thicker segments	
	Segment number is too small	Use cutting wheels with segments, or reduce the feeding pressure	
	The cutting wheel runs out	Use a new cutting wheel, have the old one straightened, check the cutting shaft, use a new one if necessary	
	The cutting wheel deviates	Check the table guides, replace if necessary	
	Abrasive aggregates	Use cutting wheels with harder segments	
	Feeding pressure is too high	Reduce the feeding pressure	
Cutting blade shows side and radial run-out	Cutting blade is bent or damaged	Have the cutting blade straightened, solder the segments to a new blade or use a new blade	Manufacturer
	Flange is polluted or damaged	Clean or replace the flange	Operating personnel
	Motor shaft is bent	Replace the electric motor	Qualified electricians
Zero performance when cutting, cutting blade is blunt	The cutting blade does not match the material	Use a proper cutting blade	Operating personnel
	The cutting blade does not match the machine capacity		
	The cutting blade is too hard		
	Diamond on the segment are blunt	sharpen	Specialist personnel
Suboptimal blade course	Blunt segments	sharpen	Specialist personnel
	Cutting blade is overloaded	Use an appropriate cutting blade	Operating personnel

	Poor tension of cutting blade	Return the cutting blade	Manufacturer
Error message / error	**Possible cause**	**Troubleshooting**	**Personnel**
Mounting bore of the cutting blade is worn out	The cutting blade rotates on the motor shaft	Check the mounting flange, replace if necessary	Manufacturer
		The mounting bore must be hollowed out and a ring fitted in	Specialist personnel
The cutting blade is oxide-coated	The cutting blade is overheating, too little cooling water	Check the cooling water	Operating personnel
	Lateral friction in the cut	Lower the feed rate, pull the - material slowly	
Cracks on steel core; eccentrical wear of the cutting blade	The cutting blade is too hard	Use a softer cutting blade	Operating personnel
	Motor shaft bearing	Replace the motor shaft bearing	

9.1 Steps after troubleshooting

After completion of the troubleshooting and before switching on, follow the following steps:

1. Check for tightness all threaded joints previously detached.
2. Check proper installation of all previously removed protective devices and covers.
3. Make sure that all tools, materials and other equipment have been removed from the working zone.
4. Clean the working zone and remove any spilled substances such as liquids, processing materials or similar.
5. Make sure that all safety devices of the machine function properly.

10. DISPOSAL

If no return or disposal agreement was made, send the dismantled components for recycling:

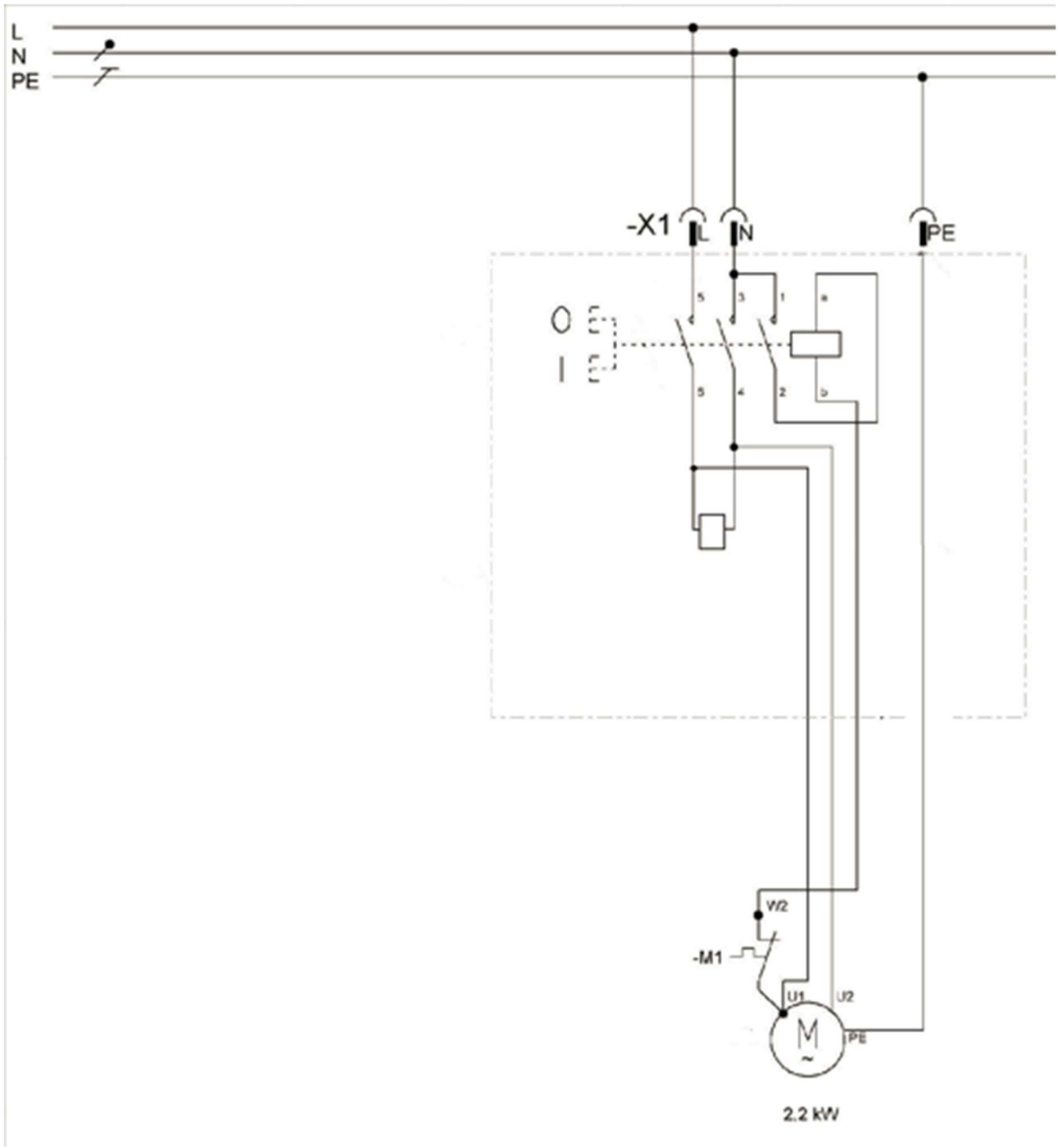
- Scrap metal parts.
- Hand over plastic parts for recycling.
- Dispose of other components assorted according to material characteristics.

EU countries only

Electric waste is recyclable and must not be disposed of in the household waste!!!

According to the European directive 2012/19/EU on electrical and electronic waste and version transposed into national law, used power tools must be collected separately and sent for recycling in an environmental-friendly manner.

11. Wiring Diagram



EU Conformity Declaration

GÖLZ (Hangzhou) Intelligent & Technology Co., Ltd
No. 99 Kenhui Eighth Rd
Hangzhou, Zhejiang Province
China

declares under sole responsibility that

Model:	**Stone cutting machine**
Make:	**GÖLZ**
Type:	**D-CUT 350A**

comply with the relevant provisions of the Directives

2006/42/EC	**Machinery directive**
2014/30/EU	**Electromagnetic compatibility**
2014/35/EU	**Low Voltage**
2012/19/EU	**Electrical and electronic waste**
2011/65/EU	**Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment**

and has been developed and fabricated in compliance with the following standards valid as at the production date::

DIN EN 12418:2022-07	**Masonry and stone cutting-off machines for job site - Safety**
DIN EN ISO 12100:2011-03	**Safety of machinery - General principles for design**
DIN EN ISO 13849-1:2023-12	**Safety of machinery - Safety-related parts of control systems**
DIN EN 61000-3-2:2019+A1 **DIN EN 61000-3-11:2019**	**Electromagnetic compatibility**
DIN EN 55014-1:2021 **DIN EN 55014-2:2021**	**Electromagnetic Compatibility**
DIN EN 60204-1; VDE 0113-1:2019-06	**Safety of machinery - Electrical equipment of machines**

Technical documentation kept by:

GÖLZ (Hangzhou) Intelligent & Technology Co., Ltd

Development and design

Year of construction and machine number are indicated on the unit.

Dunhui Zheng

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Managing Director