

## **SAFETY TIPS**

**Always unplug the Revolution XT from its power source before removing it from the water bath or when performing any maintenance.**

**Always wear safety glasses when the saw is in operation.**

**NEVER RUN THE SAW DRY!**

**Always empty the water bath before attempting to carry the saw.**

**Always use a grounded power source to plug the saw into.**

**Never run the saw without the covers mounted.**

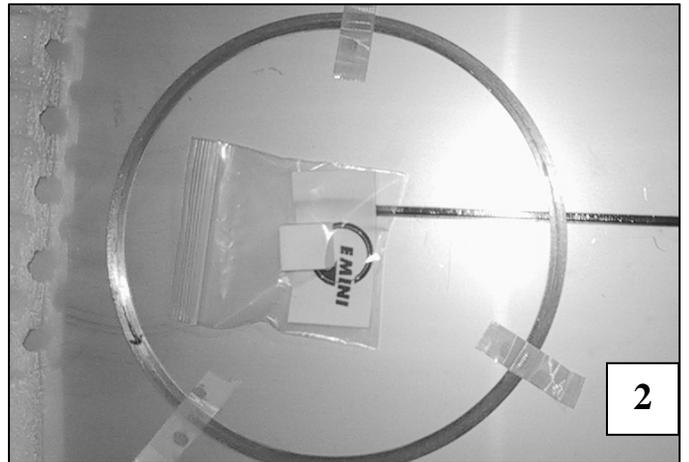
**Keep towels, rags or loose clothing away from the blade.**

# ASSEMBLY/CONTENTS



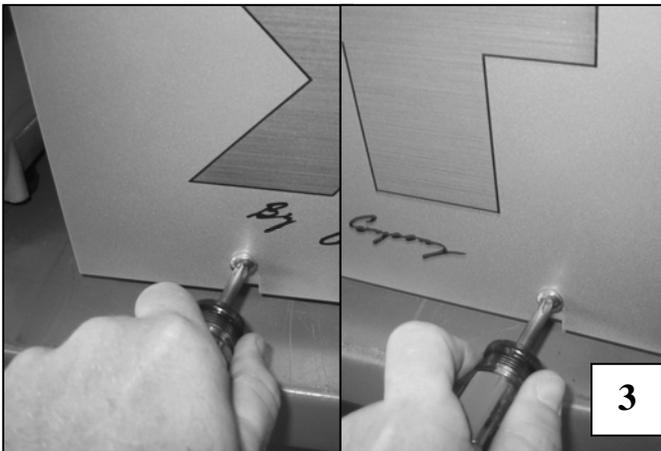
1

Remove saw from carton and place it on your work area.



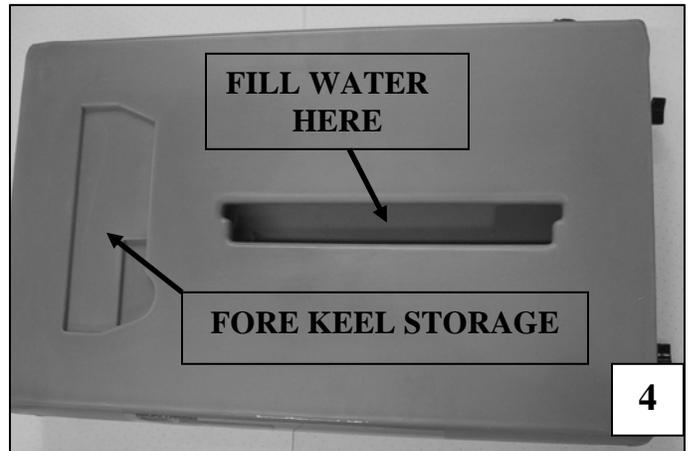
2

Remove Blade from work surface. Next remove work surface. Note: A dressing stone has been provided with the blade.



3

Remove all four machine screws that attach the saw to the water bath and lift off the Saw Assembly and replace with the Thumb Screws (4) found in your parts box.



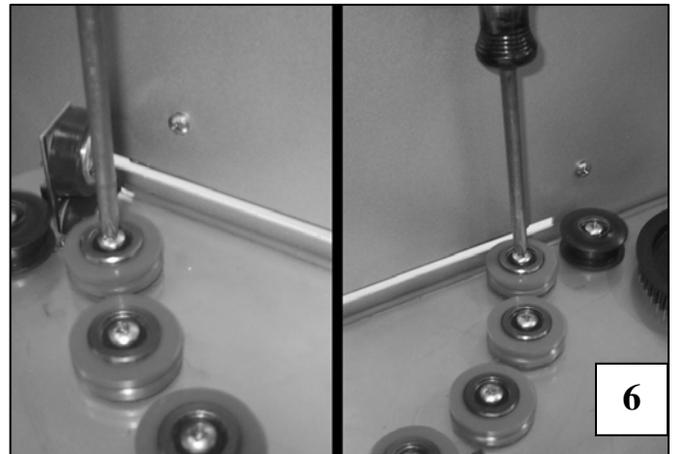
4

Fill water bath until completely full. The bath holds 11 liters or approx. 2.9 gallons of water.



5

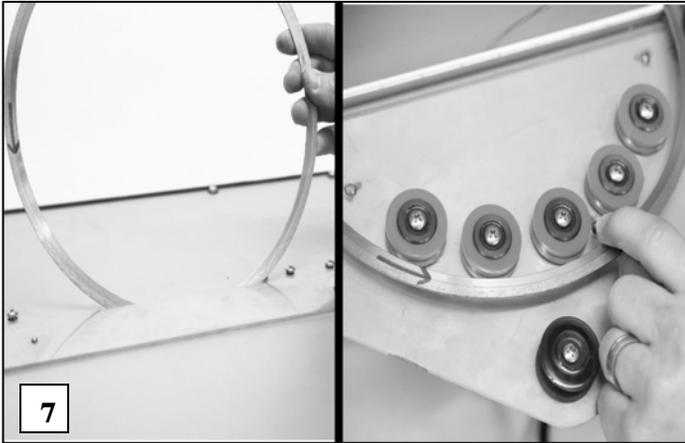
Set Saw Assy. On it's side and remove transparent Side Cover.



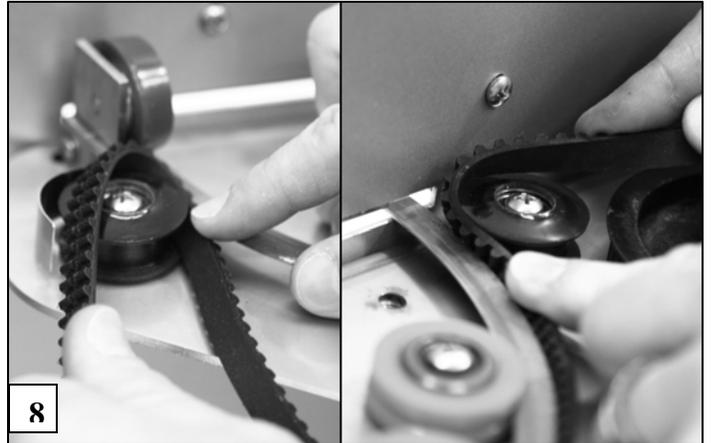
6

Unscrew the first and last Orange Groove Grommets.

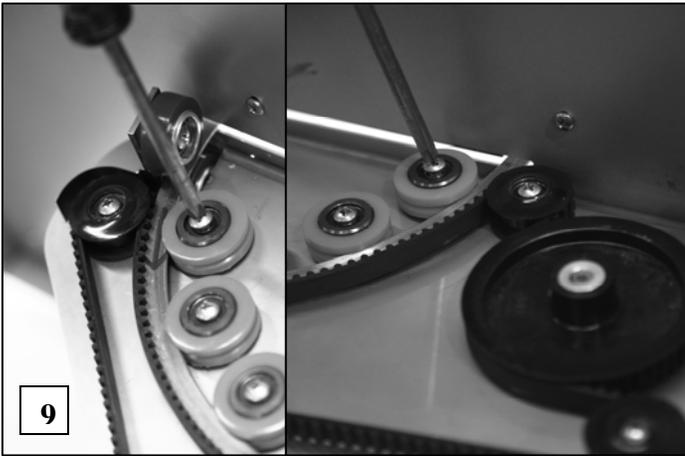
# BLADE INSTALLATION / SAW ASSEMBLY



To install blade, bring the Blade down from the top, pull it down and slip it into the Groove Grommets so that its inner edge makes contact with the groove in each grommet.



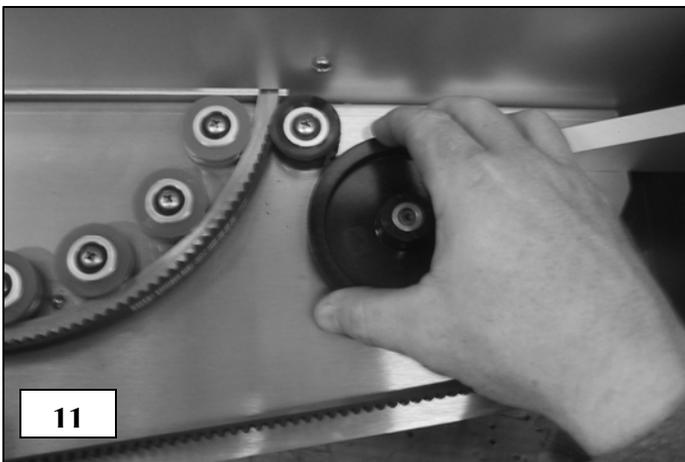
Loosen or unscrew the Blue Pulleys push the Belt between them and the Blade. For the front pulley counter clockwise, for the back clockwise.



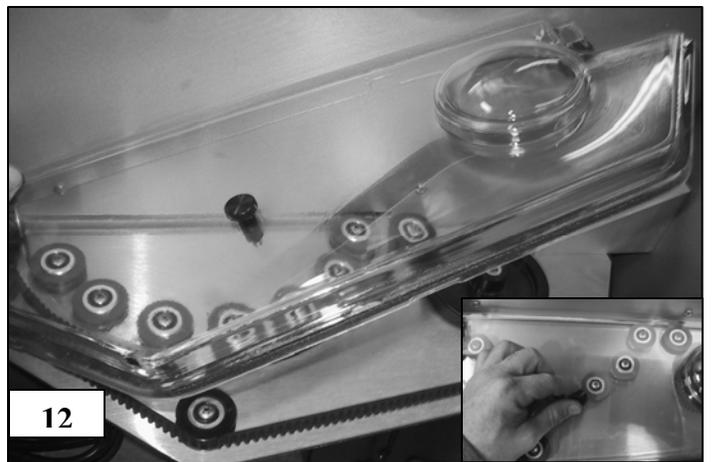
Screw Orange Groove Grommets back on saw assembly. Make sure the belt is wrapped around the Blue Pulleys as shown on the cover page.



At this point the Belt will be somewhat loose. Loosen the Blue Pulley on the lower right with the Allen wrench found in the parts box, push it HARD to the right as far as it will go, and tighten the screw. This will put proper tension on the Belt.



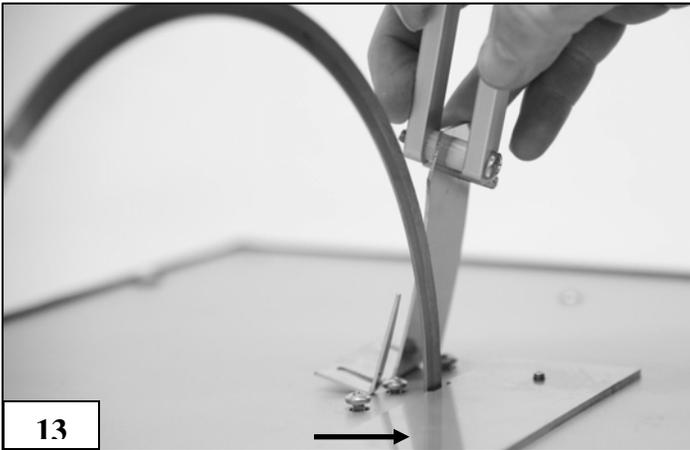
Rotate the Drive Gear counter clockwise to ensure all parts are moving freely.



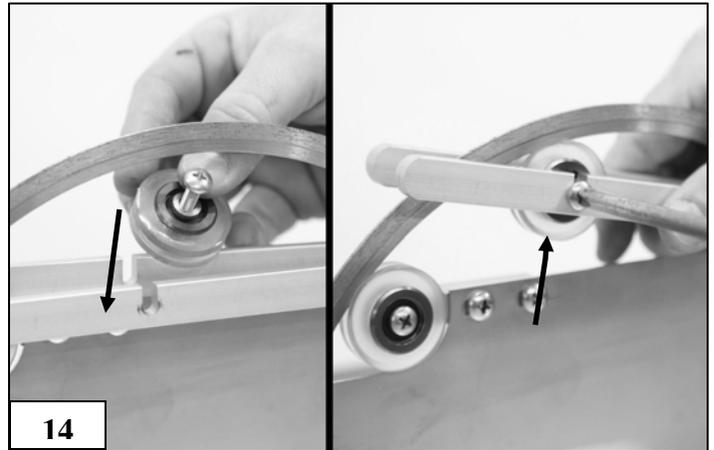
Replace clear Side Cover and SNUG down the thumb screw.

# BLADE INSTALLATION / SAW ASSEMBLY

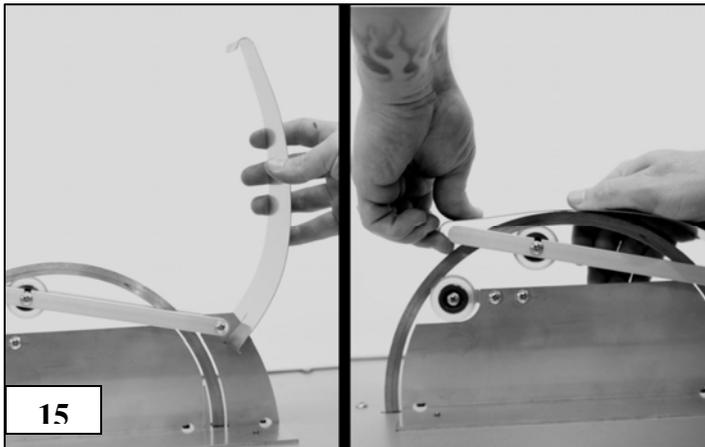
## KEEL INSTALLATION



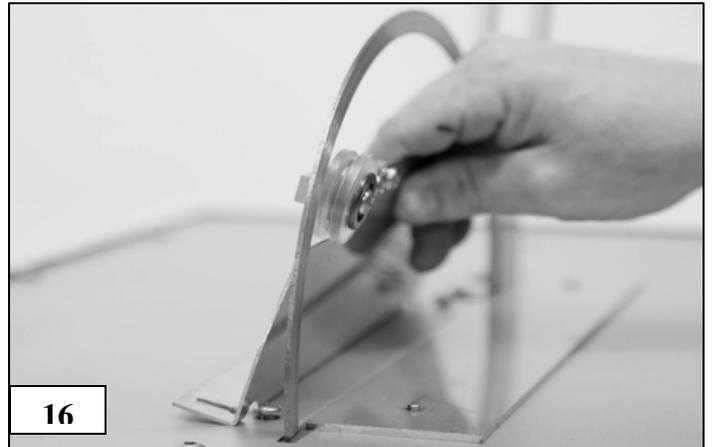
**13**  
Slip the Aft Keel slots into the keel set screws. The Aft Keel contains the splash guard which is necessary when running the saw.



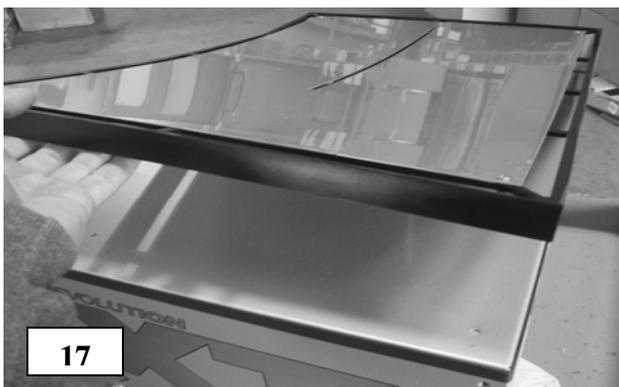
**14**  
Remove Groove Grommet and push Stabilizer Arms down past the Blade. Reinstall Groove Grommet and tighten screw. While pulling up on stabilizer arms to fully seat the screw.



**15**  
Slide Splash Guard over Aft Keel. Push down on the Splash Guard and slide hook over the Stabilizer Arms. Increasing the arc of the Splash Guard will add tension to the groove grommet which will help the blade to run smooth.



**16**  
The Fore Keel is only used for straight cuts. Remove it when curve cuts are desired. Slip the Fore Keel slots into the keel set screws. Make sure the it is flush against the Adjustment Plate and tighten set screws.



**17**



**18**

Set Saw Assembly on top of the Water Bath and tighten Thumb Screws (4).

Slip from the front and place work surface on machine.

# USAGE TIPS

## **Changing the water:**

**The frequency with which you change the water in the bath will depend greatly on the type of material you cut and the amount of residue it creates, for instance cutting granite will create far less debris than cutting sandstone. Over time the water will go from clear to cloudy; this will happen rapidly and is expectable. As more cutting is done, the water will go from cloudy to milky and at that point it is time to change the water. You will want to change the water before it turns to sludge as this is very detrimental to the saws wear parts and makes cleaning it very difficult.**

## **Changing Wear parts:**

**When it comes time to replace the wheels in your saw, such as the groove grommets, pulleys and cone grommets, we recommend that you refrain from changing just one at a time. What our users have found is that when one wheel wears out, the rest are not far behind. What ends up happening is that you have more down time replacing wheels as they go and the new parts wear out quicker because they are taking up the slack for the worn out ones still inside the saw.**

**We do recommend that you keep the better of the used wheels on hand for emergencies. Signs of wear to the wheels are a rough running blade or excessive chipping of the material.**

**The sign of a worn belt is blade slippage, this happens when a blade stops rotating while the rest of the drive mechanism is spinning. If the blade continues to slip even after you have readjusted the belt tension this is an indication that the belt is worn out and needs to be replaced.**

## **Proper usage:**

**The number one rule is to let the saw do the cutting and do not force the material into the blade.**

# USAGE TIPS Cont.

## **Straight cutting:**

To cut straight it is best to always use the Fore Keel #7, as this holds the blade as well as the material, straight while cutting. The alignment plate, which is mounted to the saw base, automatically aligns the keel and blade. Push the Fore Keel up against the plate before tightening it down, (see page #4).

The Fore Keel alone works well for straight cutting but if a lot of straight cuts are to be made the optional Carriage Kit may be preferred. It is necessary for the tray to be in alignment with the blade to get a straight cut. Set up the Carriage as per instructions provided in the kit.

## **Problems/ Solutions:**

If you are having a problem cutting a straight line with the carriage in place, try making a test cut with out it first. Mark a line on a piece of material that is 90 degrees to an edge, using a square. Feed the cut through following the line by hand until both the back and the front of the blade are inside the cut. If the cut does not go well by hand either then the keel is not aligned with the blade or the blade is not cutting straight. Use a straight edge to see if the keel is lined up by placing it so that it is touching the front and the back of the blade. The keel should show a microscopic gap all the way along all the way along the straight edge that is parallel but not touching it. This should be true on both sides of the blade.

If the keel is not aligned then make sure that the mounting surface is clean and free of debris. Reattach and check again. Make sure that the Fore Keel is flat along the surface of the alignment plate.

If the keel is aligned with the blade but feeding it through by hand causes the cutting to slow down more and more then stop, use the dressing stone (provided), to dress the front of the blade while it is running to expose all the diamonds evenly. This should improve the situation but if it does not fix it completely then slow down the feed rate. In rare cases, it is possible the specific blade you are using may not work well for straight cuts.

Blades that do not cut well straight can be caused by cutting of curves and the tendency to use one side more than the other. This can usually be fixed again by dressing the blade with the stone provided. If there is to be a great deal of straight cutting with your XT it is a good idea to put aside a blade that cuts good and straight to keep it only for this purpose.

All of our blades work well on curved cuts.