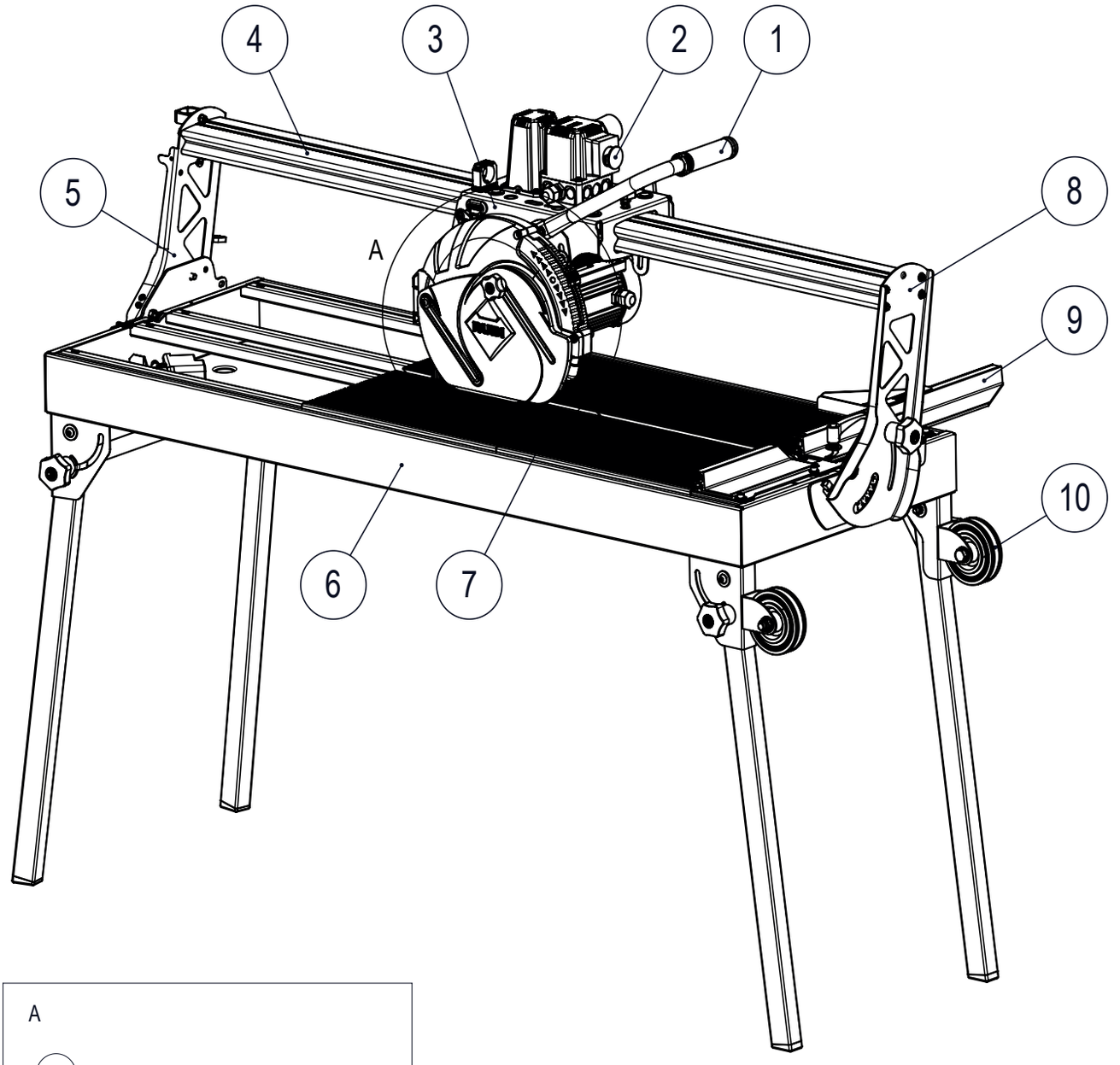
RUBI

DC-250 PYTHON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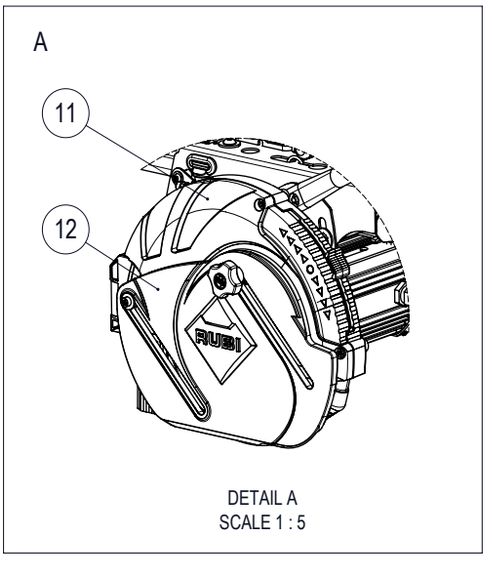
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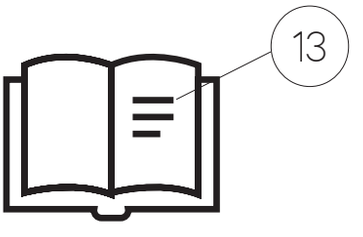
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CONTENTS

1. USING THE MACHINE

RUBI electric cutters are professional precision machines, suitable for cutting tiles, ceramics and other materials, either straight cuts or mitre cuts, by means of a bearing guide system.

These cuts are made with water-cooled diamond blades.

COMPONENTS / ELEMENTS OF THE MACHINE

1) Hand grip
2) On/off switch
3) Motor bracket
4) Motor guide
5) Rear arm
6) Chassis/water tank
7) Aluminium table
8) Rear arm
9) Rotating stop
10) Wheels
11) Front blade cover
12) Rear blade cover
13) Instruction manual

2. SAFETY WARNINGS

2.1 SYMBOLS

	READ THE INSTRUCTION MANUAL
	CAUTION
	BLADE DIRECTION OF ROTATION
	ALWAYS WEAR SAFETY GLOVES
	WEAR SAFETY GLASSES
	ALWAYS WEAR HEARING AND EYE PROTECTION
	WARNING: SAW CUTTING. RISK OF HARM IF NOT USED CORRECTLY
	CE MARK
	CONFORMS TO WEEE

2.2 PRECAUTIONS

General safety warnings for tools

⚠ **WARNING! Read all of the safety warnings and all of the instructions.** Failure to observe all of the warnings and instructions indicated below could result in electric shock, fire and/or serious injury.

Save all of the warnings and instructions for future reference.

SAFETY IN THE WORK AREA

a. **Keep the work area clean and well lit.** Dark and disorderly areas lead to accidents.

b. **Do not handle electrical tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Electric tools generate sparks that can ignite dust and fumes.

c. **Keep children and bystanders away when handling an electric tool.** Distractions can result in a loss of control.

ELECTRICAL SAFETY

a. **The plug of the electric tool must match the base of the electrical outlet. Never modify the plug in any way. Do not use plug adapters with grounded electric tools.** Unmodified plugs and matching outlets will reduce the risk of electric shock.

b. **Avoid contact between the body and grounded surfaces such as pipes, radiators, electric ranges and refrigerators.** There is an increased risk of electric shock if your body is grounded.

c. **Do not expose electric tools to rain or damp conditions.** Any water that enters the tool will increase the risk of electric shock.

d. **Treat the power cord with care. Do not use the power cord to carry, lift or unplug the electric tool. Keep the power cord away from heat, oil, sharp edges and moving parts.** Damaged or tangled power cords increase the risk of electric shock.

e. **When handling an electric tool outdoors, use extension cords suitable for outdoor use.** Using extension cords that are suitable for outdoor use reduces the risk of electric shock.

f. **If using the tool in a damp area is unavoidable, use a power supply that is protected by a residual current device (RCD).** The use of an RCD reduces the risk of electric shock.

PERSONAL SAFETY

a. **Be alert and pay attention to what you are doing, and use common sense when handling an electric tool. Do not use electric tools when you are tired or under the influence of alcohol, drugs or medication.** A moment of distraction while handling electric tools can result in serious personal injury.

b. **Use personal safety equipment. Always wear eye protection.** Using safety equipment that is suited to the conditions, such as a dust mask, non-slip footwear, helmet or hearing protection will reduce personal harm.

c. **Avoid accidental startup. Make sure that the switch is in the "open" position before plugging the machine in and/or connecting the battery, picking up or carrying the tool.** Carrying electric tools with your finger on the switch or plugging in electric tools that have the switch in the "on" position leads to accidents.

d. **Remove any spanners or adjustment tools before starting the electric tool.** A spanner or tool connected to a rotating part of an electric tool can result in personal injury.

e. **Do not overextend. Keep your feet firmly on the floor and keep your balance at all times.** This gives you better control over the electric tool in unexpected situations.

f. **Wear suitable clothing. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothing, jewellery and long hair can become snagged in moving parts.

g. **If there are devices for connecting suction and dust collection equipment, make sure they are connected and used correctly.** Using these devices can reduce the risks related to dust.

h. **The confidence gained from the frequent use of tools should not allow general safety principles to be ignored.** A careless action could cause a serious injury in a fraction of a second.

USE AND CARE OF ELECTRIC TOOLS

a. **Do not force electric tools. Use electric tools correctly for their proper application.** The proper electric tool will work better and safer at the speed for which it was designed.

b. **Do not use electric tools if the switch does not turn to "on" and "off".** Electric tools that cannot be controlled with switches are dangerous and should be repaired.

c. **Unplug the electric tool from the power supply and/or battery before making any adjustments, changing accessories or storing the tools.** These preventive safety measures reduce the risk of accidentally starting the tool.

d. **Store electric tools out of reach of children when not in use and do not allow people who are not familiarised with the tools or with these instructions to handle the electric tool.** Electric tools are dangerous in the hands of untrained users.

e. **Perform maintenance on electrical tools and accessories. Check that the moving parts are not misaligned or locked, that there are no broken parts or other factors that could affect the operation of the electric tools. Electrical tools must be repaired before use when they are damaged.** Many accidents are caused by poorly maintained electric tools.

f. **Keep tools sharp and clean.** The Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.

g. **Use the electric tool, accessories and tool tips, etc..** in accordance with these instructions, taking into account the working conditions and the work to develop. Use of the electric tool for applications other than those intended could result in a hazardous situation.

h. **Keep the handles and gripping surfaces dry, clean and free of oil and grease.** Slippery handles and gripping surfaces do not allow for a secure grip and control of the tool in unforeseen circumstances.

TECHNICAL SERVICE

a. **Have your electric tool checked by a qualified repair service using only identical spare parts.** This guarantees that the safety of the electric tool will be maintained.

Additional safety warnings from the manufacturer

1) **WARNING!** Do not use the machine for uses other than those for which it was designed.

2) Adequate artificial lighting is required in work areas when ambient light is insufficient.

3) Recommended operating temperature between 0 and 40°C and between 0.8 and 1.1 bar (maximum humidity 95%).

4) Before starting operations, wear protective gloves, hearing protectors and protective glasses.

5) When unpacking the machine, and also after each use, check for dents or deformations and broken parts and cords. If any of these are found, do not use the electric tool and contact the manufacturer immediately.

6) Keep hands away from the cutting area and blade at all times. Keep the hand that is not being used on the secondary handle. Your hands cannot be cut by the blade if they are both holding the cutter.

7) Do not place your hand under the piece that is being cut.

8) Always use blades with interior diameters that correspond to the machine's shaft. A larger interior diameter would cause the cutter to rotate eccentrically, leading to a loss of control.

9) Never use plates or anchor screws from damaged or incorrect blades. These parts were designed specifically for this cutter, to provide better functioning and safety during operation.

10) Hold the cutter firmly and position your body and arms in such a way that you can resist the forces of KICKBACK. KICKBACK forces can be controlled by the operator if the proper precautions are taken.

11) Do not use damaged or dull blades.

12) Use only the recommended blades, suitable for RPMs that are greater than or equal to the maximum RPM of the machine and with holes for the proper shaft.

13) Position the blade plates correctly and tighten the screw properly before starting up the machine.

14) Check the interior surfaces of the blade anchor plates, as well as the sides of the blade, in order to avoid any problems.

15) Verify that the blade has no cracks or other damage before operation. Immediately replace damaged blades. Do a functional test with no load for at least 30 seconds before using the cutter.

16) Never start the machine with the piece being cut in contact with the blade.

17) Allow the motor to reach its maximum speed before cutting.

18) Important: after completing the cut, release the switch and wait for the blade to stop completely before setting the cutter down.

19) Do not use the machine in areas with flammable solids, liquids or gases. The sparks produced in the brushes could cause a fire or explosion.

20) This machine was designed for specific applications. The manufacturer certifiably recommends that it not be modified and/or used for applications other than the ones for which it was designed. If you have any questions regarding the use of the machine, do not use it until you have consulted the manufacturer and received the corresponding information.

21) Keep the power cord away from the machine's cutting zone. Always keep the power cord away from the machine behind you.

22) Turn off the machine immediately if you notice any unusual vibration or any other malfunction. Check the machine to determine the cause.

23) Use only the diamond blades recommended by the manufacturer.

24) Pay attention to the dimension of the blades. The centre hole in the blade must fit on the shaft with no free play. If not, a reducer washer (provided with the blade) will be needed to ensure proper fit.

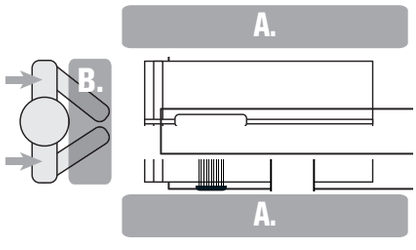
25) The dust that is produced when working with this tool may be harmful to your health. Use an absorption system and wear a suitable dust mask. When the cutting operation has been completed, clean any deposited dust with a vacuum cleaner.

2.3 WORK AREA

Work position

A. Working area designed for tiles **over 60 cm.**

B. Working area designed for tiles **up to 60 cm.**



3. OPERATING INSTRUCTIONS

3.1 ASSEMBLY INSTRUCTIONS

INSTALLATION

After unpacking the machine, carefully check for damaged or broken parts. If you find any damaged or malfunctioning parts, replace them with original spare parts from the manufacturer and contact RUBI's after-sales service.

Although the wheels allow one person to transport the machine, it is recommended that this be done by two people.

The DC–250 PYTHON machines come packaged with the support feet properly positioned for the transport position and with the wheels mounted.

BEFORE STARTING THE MACHINE:

1) Machine assembly and set up (fig. 1, 2).

2) It is advisable to use the machine on flat and level surfaces. Check that it is properly stabilised on the ground before starting work, so that safe working conditions are achieved (fig. 3, 4).

3) The moving head of the machine comes fixed to the guide to avoid possible movements during transport. Loosen knob B to release the position (fig. 5).

INSTALLING AND REPLACING THE BLADE:

4) The machine comes with a blade as standard. To install or replace the blade, the front guard must be removed. The motor shaft will be visible (fig. 6).

5) To release the blade, loosen the fastening nut in a clockwise direction or in the direction of rotation of the blade (fig. 7).

6) Mount the blade between the plates, matching the direction of rotation indicated on the machine.

7) Tighten the fastening nut firmly in an anti-clockwise direction (fig. 8). The tools to perform this operation are included.

WATER FEED SYSTEM:

8) It is essential to fill the tank with water until the water pump is completely submerged (fig. 9).

9) It is important to replace the water regularly, since using the machine with clean water prolongs the life of the blade and improves its performance.

COOLING POINT ADJUSTMENT:

10) The DC–250 PYTHON machine is equipped with the C3 Python cooling system, which allows the cooling nozzle to be adjusted in order to set the point of incidence on the blade (fig. 10).

11) The position of the tube must be adjusted according to the thickness of the tile to be cut. It can rotate with respect to the rotation axis of the blade.

The optimum position of the nozzle is as shown in the picture (fig. 11), which ensures a minimum space between the tile and the nozzle so that this does not rub against it.

As the C3 Python system optimises the cooling of the blade, it is considered good practice to regulate the water flow from the water feed system. Adjust the position of Tap A to approximately ¾ of the full opening (fig. 12).

ADJUSTING THE ANGLE AND DEPTH OF CUT:

12) The mitre cutting mechanism allows you to adjust the cutter angle from 0 to 45°.

13) For 45° cuts (mitre cuts), there is a mechanical locking system which allows the head to be placed in the required position.

14) Turn the cutter head to the desired cutting angle (fig. 13).

Once the cutting angle has been set, lock the system again to immobilise the cutting position.

NOTE: For a square cut, turn the cutter head to the 0° position, so that the blade is perpendicular to the piece being cut.

15) The cutting head has a plunge effect function, which allows the height adjustment of the cutting blade. The backward movement is performed by a set of springs which, in turn, compensate for the weight of the engine, improving the ergonomics for the user (fig. 14).

16) To lock the desired cutting depth, tighten lever A as shown in the picture (fig. 15).

PRELIMINARY CHECKS:

17) Before using the machine, check for any worn, damaged or broken parts and immediately repair or replace any that are found.

18) Level the machine.

19) Check that the machine stops are perpendicular to the blade. These are set at the factory (fig. 16).

20) Check that the mains voltage and frequency correspond to that indicated on the machine's technical data plate.

21) The mains outlet must be earthed and protected against current leakage (differential). When using an extension cord, make sure the cable cross section measures no less than 2.5 mm^2.

22) The blade guard protects the user from injury during cutting. When cutting, the guard should therefore be adjusted according to the thickness of the piece to be cut.

23) 230 V machines may also be connected to 210V / 240V. 110 V machines may be connected to 100V / 120V.

24) During transport, gather the power cord by winding it up. Never move the machine by pulling on the power cord.

25) If the blade is installed incorrectly and is working in the wrong direction, stop the machine and correct the blade installation.

26) Use only the blade diameters indicated in this manual.

3.2 STARTING THE MACHINE

PROPER POSITION OF THE HANDS:

SQUARE CUT

27) To make square cuts, position yourself behind the machine. Put one hand on the main handle and slide the cutter in the guide. For greater comfort, place the other hand on the machine chassis. This provides better balance and sliding of the cutter.

MITRED CUT

28) To make mitre cuts, position yourself behind the machine. Put your left hand on the main handle and slide the cutter along the guide. For greater comfort, place the other hand on the machine chassis or hold the tile. This results in better sliding of the cutter and greater precision.

PRELIMINARY CONSIDERATIONS:

29) Read these instructions carefully before using this product and do not throw them away.

30) The DC–250 PYTHON machines have a fixed support table for positioning the tiles. This system allows the user to work with great precision and comfort on all types of ceramic pieces.

31) Sliding is by means of greased and sealed ball bearings.

32) Changing the position from straight cutting to mitre cutting or vice versa, as well as adjusting the stops for repetitive cutting, must be done with the motor switched off to prevent possible accidents.

33) When the machine is used outdoors, only extension cables intended for outdoor use should be used. It should be noted that the extension cable has to be fully unwound to get maximum power.

34) Before using the machine again, it should be carefully checked to determine that it will function properly and be suitable for the function for which it is intended. Any guard or other part that is damaged should be properly repaired or replaced by the authorised technical service unless otherwise specified in this instruction manual.

35) Adequate artificial lighting is required in work areas when ambient light is insufficient.

CONNECTION:

36) Remove the adjustment spanners and tools before starting the machine.

37) Make sure the switch is in the "OFF" position when you plug in the machine.

38) Start the machine by pressing the green button or the I button (fig. 17).

39) Once the machine is running, wait until the motor and the water supply through the pump are normalised (4 or 5 seconds). Tap A can be used to regulate the cooling water flow for the blade. (fig. 18).

WARNING! To reduce the risk of serious personal injury, support the work piece correctly, as shown, and hold the cutter firmly to avoid losing control and prevent potential kickback.

OPERATING INSTRUCTIONS:

40) Keep your hands and the power cord away from the cutting zone to prevent it from being snagged or tangled on the piece being cut.

41) To make straight cuts, the blade should advance in a continuous manner, without jerking and without forcing the motor. Improper operation can break the part and seriously damage the blade.

42) DC–250 PYTHON machines allow exact parallel cuts to be made with maximum precision by means of the tile clamping accessory for repetitive cuts (fig. 19, 20).

43) For cutting at 45° (mitre) there is a mechanical locking system which allows the cutting head to be positioned precisely.

44) The square assembly is attached to the chassis and swivels between 60° and 0°. It allows users to support the pieces to be cut and to make repeated cuts (fig. 21). Side stop A is attached to the square assembly. It is factory set and allows repetitive cuts of 90° and 45° to be made accurately (fig. 22).

45) The electric machines have a safety system to prevent the motor from overheating.

46) If the motor stops for no apparent reason, you should wait a few minutes as you will most likely have overloaded it and you should then moderate the cutting speed.

47) For proper operation of the DC–250 PYTHON machines, work on level ground.

48) Do not use cracked or chipped diamond blades.

49) Do not use side pressure to slow the blades down.

DISCONNECTION:

50) To switch off the machine, press the red button or the 0 button (fig. 17).

51) The cutter will continue to rotate for a few moments after it has been turned off; wait until the machine is completely stopped before removing it from the cutting position.

52) Remember that the cutter must be unplugged from the power installation when moving from one work zone to another and when carrying out adjustment and maintenance operations.

3.3 CLEANING AND MAINTENANCE

WARNING! Unplug the machine before carrying out any adjustments, repairs or maintenance.

Proper cleaning and maintenance of the machine can extend its lifetime.

Immediately clean the machine after using, as well as during prolonged periods of inactivity.

53) Before performing cleaning, maintenance or repairs on the machine, as well as before transportation, the machine must be switched off and unplugged.

54) Do not use aggressive cleaning products to clean the machine.

55) Do not submerge the machine in water.

56) Examine the machine's cords periodically and if they are damaged, have them repaired by an authorised technical service.

57) Keep handles dry and clean and free of grease and oil.

58) In order to keep the machine in good condition, it is advisable to clean it with water and dry it after use, as well as to circulate clean water through the cooling system. It is especially important to clean the water pump. The rusting of metal parts is a direct consequence of the use of water. Proper maintenance of the cutter will minimise the appearance of rust spots.

59) We recommend cleaning the rolling tracks of the guide with a cotton cloth dampened with water. No lubrication is necessary.

60) The machine must be put out of service and scrapped in accordance with the instructions in each country, at a selective collection point for the proper classification and processing of materials.

WARNING! Continued or improper use, constant changes in location and transportation of the cutter can cause the components to become misaligned.

For proper functioning of the cutter, it is advisable to check the following adjustment points:

MOTOR ADJUSTMENT:

Check the play of the blade head regularly and adjust it if necessary (fig. 23, 24):

a) Loosen screws A and nut B as indicated.

b) Gently tighten set screw C with the help of a 3 mm Allen key.

c) Check the head play and retighten nut B to lock the system, then retighten screws A.

SQUARE ADJUSTMENT:

61) Check that the square assembly is perpendicular to the blade. To adjust it exactly to 90° (fig. 25,26):

a) Place a set square in line with the blade at 90° on the square and adjust screws A as indicated.

b) The square assembly can pivot with respect to the shaft (screw B).

c) For better positioning of the whole assembly, the DC–250 PYTHON machine has a transversal screw that allows the whole assembly to pivot (rotate) with more precision.

d) Loosen screws A and rotate the square assembly using transversal screw C until it reaches the 90° position in relation to the blade.

e) Tighten the assembly again to lock the position.

BLADE ADJUSTMENT (PERPENDICULARITY AND PARALLELISM):

PERPENDICULARITY

62) To set the disk at 90°, remove the blade guard, loosen knob A and the locknut, and place the set square on the table touching the blade (fig. 27)

a) Adjust the blade inclination using the screws indicated in the picture (fig. 28). Perform this operation on both sides of the machine, until the top and bottom of the blade touch the set square at the same time.

b) Replace the blade guard and then tighten the nut and knob.

PARALLELISM

63) To adjust the parallelism of the blade, it is necessary to use an alignment device as a reference.

a) Position the component so that the protrusion on the alignment device touches the outermost face of the blade at the front. To do this, rotate the blade until it comes into contact, you will notice a slight noise when the blade comes into contact with the protrusion. Mark that point as a reference (fig. 29).

b) Move the blade head, without changing the position of the alignment device (fig. 30) and turn the blade again to the indicated mark. If the blade does not make contact at the same point, it will be necessary to adjust the parallelism of the blade.

c) You can adjust the position of the motor by rotating it slightly.

d) Loosen screws A as indicated and rotate the motor using transversal screw B. Repeat the same procedure and make sure that in both positions the blade makes contact with the alignment device (fig. 31, 32).

e) Once the blade is positioned, retighten screws A.

STORAGE

Store the tool in its packaging in a cool, dry place protected against cold and direct sunlight.

The machine must be put out of service and dismantled in accordance with the instructions in each country, at a selective collection point for the proper classification and processing of the materials.

AFTER-SALES SERVICE

Use only original spare parts supplied by the manufacturer. Repairs should only be done by certified workshops or RUBI's technical service:

GERMANS BOADA SANTA OLIVA

Ronda de l'Albornar, 24–26

43710 Santa Oliva, Tarragona (Spain)

Tel: +34 977 16 90 50

For more information and the location of RUBI's official technical support centres visit: https://www.rubi.com/es/servicio-post-venta

4. EU DECLARATION OF CONFORMITY

We, GERMANS BOADA S.A.

Of Avda. Olimpíades, 89–91; 08191 Rubí (Barcelona), Spain

Declare that the DC–250 PYTHON

Model: DC–250 PYTHON 1200 (REF.: 56939), DC–250 PYTHON 1200 (REF.: 56943), DC–250 PYTHON 1200 (REF.: 56947), DC–250 PYTHON 1200 (REF.: 56914), DC–250 PYTHON 850 (REF.: 56941), DC–250 PYTHON 850 (REF.: 56937), DC–250 PYTHON 850 (REF.: 56938), DC–250 PYTHON 850 (REF.: 56911), DC–250 PYTHON 1200 (REF.: 56949)

Meets all relevant requirements of the following European directives

2006/42/EC Machinery Directive

2014/35/EU Low Voltage Directive

2014/30/EU Electromagnetic Compatibility

Using the following draft and transposed standards

EN ISO 12100:2010, EN 60204–1:2018, EN 12418:2000+A1:2009, EN 62841–1:2015, EN IEC 61000–6–4:2019, EN IEC 61000–6–2:2019, EN IEC 61000–3–2: 2019, EN 61000–3–3: 2013+A1:2019

Having been type examined to the requirements of the Electromagnetic Compatibility Directive 2014/30/EU, the Machine Directive 2006/42/EC and the Low Voltage Directive 2014/35/EU by:

Safenet Certification Services Ltd

Ducart Suite Notification number: 2805

Castletroy Park Commercial Campus

Limerick, V94 Y6FD, Ireland

Safenet Certification Services is authorised to compile the technical file in the European community.

Safenet is authorised to compile the technical file.

Carles Gamisans

Deputy Manager

2022.04.19

Seal

4.1. UK DECLARATION OF CONFORMITY

We, GERMANS BOADA S.A.

Of Avda. Olimpíades, 89–91; 08191 Rubí (Barcelona), Spain

Declare that the DC–250 PYTHON

Model: DC–250 PYTHON 1200 (REF.: 56939), DC–250 PYTHON 1200 (REF.: 56943), DC–250 PYTHON 1200 (REF.: 56947), DC–250 PYTHON 1200 (REF.: 56914), DC–250 PYTHON 850 (REF.: 56941), DC–250 PYTHON 850 (REF.: 56937), DC–250 PYTHON 850 (REF.: 56938), DC–250 PYTHON 850 (REF.: 56911), DC–250 PYTHON 1200 (REF.: 56949)

Meets all relevant requirements of the following UK Statutory Instruments

Supply of Machinery (Safety) Regulations 2008 as amended

Electrical Equipment (Safety) Regulations 2016 as amended
Electromagnetic Compatibility Regulations 2016 as amended

Using the following draft and transposed standards

BS EN ISO 12100:2010, BS EN 60204–1:2018, BS EN 12418:2000+A1:2009, BS EN 62841–1:2015, BS EN IEC 61000–6–4:2019, BS EN IEC 61000–6–2:2019, BS EN IEC 61000–3–2: 2019, BS EN 61000–3–3: 2013+A1:2019

Having been type examined to the requirements of the Electromagnetic Compatibility Directive 2014/30/EU, the Machine Directive 2006/42/EC and the Low Voltage Directive 2014/35/EU by:

Safenet Limited

Denford Garage

Denford, Kettering Approved body number: 1674

Northants.

NN14 4EQ, U.K.

Safenet is authorised to compile the technical file.

Carles Gamisans

Deputy Manager

2022.04.19

Seal

FAILURE	POTENTIAL CAUSE	SOLUTION
The motor does not start	No power supplied or insufficient supply to motor.	Check installation and electric cable.
	Locked motor.	Check motor's rotation without load.
	Switch issue.	Replace switch. Contact After Sales Service.
	Motor issue.	Replace motor. Contact After Sales Service.
The motor starts but turns in reverse or does not understand the direction of rotation.	Defective capacitor.	Replace capacitor. Contact After Sales Service.
	Motor issue.	Replace motor. Contact After Sales Service.
Motor overheats or stops.	Cable extension is insufficient or defective.	"Check cable extension is suitable. Plug the machine directly to supply."
	Overloading.	Reduce working load.
	Inappropriate power supplied.	Check tension.
	Speed of cut is too fast.	Reduce speed of cut.
	Motor issue.	Replace engine. Contact After Sales Service.
Motor stops when cutting	Blade nearing end of optimum performance.	Check blade. Replace blade
	Overloading.	Reduce working load.
	Lack of power in the motor.	Check voltage input to the machine. Check engine condition.
	Motor issue.	Replace motor. Contact After Sales Service.
Misaligned cuts	Blade is nearing end of optimum performance.	Check blade. Replace blade
	Inappropriate blade for the material	Use a different recommended blade.
	Movement when cutting	Fix material properly with the relevant accessories.
	Machine is placed on an uneven surface	Using a spirit level place the machine level on the working surface.
	Machine is misaligned	Check machine's alignment. Use alignment tool to re-adjust. Contact After Sales Service.
Blade closes easily	Material to cut is too low abrasive for that particular blade	Use a softer rim blade.
	Cutting speed is too fast.	Reduce speed of cut.
	Inappropriate cooling of the blade	Check water pump, pipes and flow control system.
	Material is too thick	Use appropriate blade type for that thickness.
Blade wears easily	Material is very abrasive	Use a harder rim blade.
	Inappropriate blade for the material	Use a harder rim blade.
Blade cuts hard or very slow	Blade is nearing end of optimum performance.	Check blade. Replace blade.
	Lack of power in the motor.	Check voltage input to the machine. Check motor condition.
Machine generates vibrations	Oscilations of the blade.	Check the blade. Replace the blade.
	Defective flanges.	Check flanges. Replace flanges.