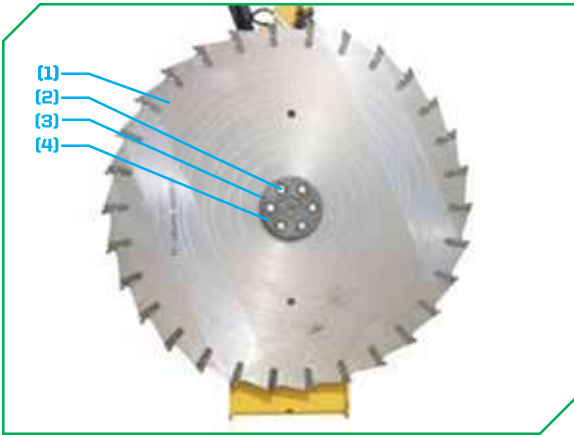


MAINTENANCE



BLADE

- The blade (1) and its hardware (2)(3)(4) should be inspected every 10 hours or daily.
- Inspect the blade (1) for any cracks or damage.
- If blade bolts (2) are loose, remove them, apply loctite 262 to the threads, and replace them.
 - Torque the blade bolts (2) to 240ft-lbs (325Nm).
- A blade (1) that is dull or significantly worn should be replaced, have its carbide teeth replaced, or have its teeth inserts replaced.

To replace the blade:

- Remove the blade bolts (2), bolt protector (4), and spacer (3) (under bolt protector (4)).
- Replace the blade (1).
- Replace the spacer (3), bolt protector (4), and blade bolts (2).

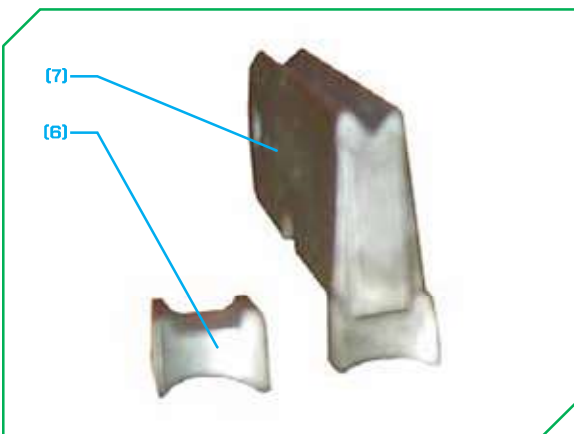
⚠ WARNING

Never attempt to weld or repair a blade. Severe damage may occur if this instruction is not followed.

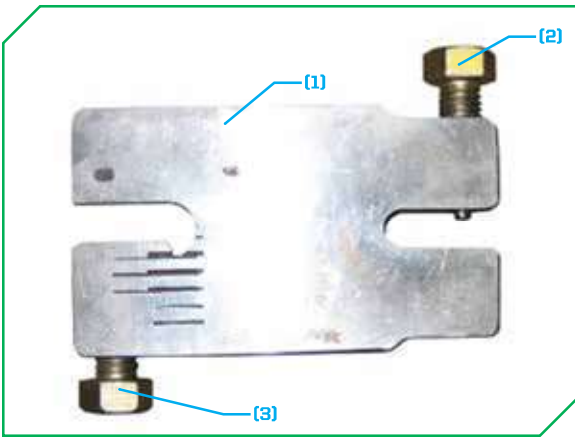


To replace a carbide tip:

- Carbide tips come with solder (5) pre-applied to the inside of the dovetail on the carbide tip.
- Using a torch, heat the old carbide tip on the blade insert (7) until the solder releases, and the carbide tip can be removed.
 - **NOTE:** The blade insert (7) does not have to be removed from the blade to replace a carbide tip.
Diamond Mowers recommends the services of an experienced solderer.
- Clean the blade insert (7) where the old carbide tooth was located of any debris.
- Heat the new carbide tip (6) up until the solder becomes molten, and slip the new carbide tip (6) onto the dovetail of the blade insert (7) in the same position the old carbide tooth was previously.
- Heat the new carbide tip (6) up until the solder flows correctly for a good weld, and allow the new carbide tip (6) to cool.

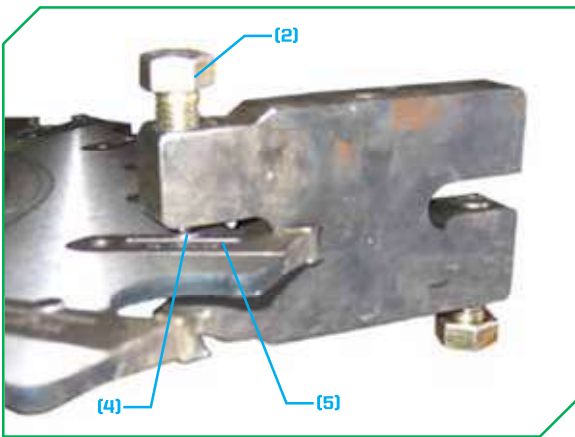


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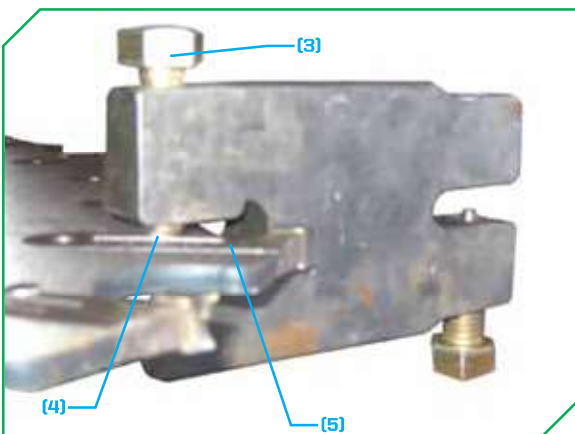
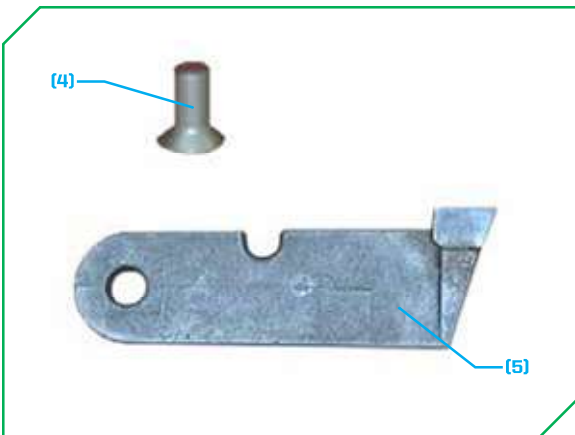


To replace a blade insert:

- Diamond Mowers offers a specialized press (1) (part #22-3006) for the removal and replacement of saw blade inserts.
- Prior to using the press, grind away the top side end cap of the rivot until flush with the saw blade.
 - **NOTE:** This step is necessary for the rivot to be pushed out and to prevent damage to the press.



- Place the press (1) onto the rivet (4) securing the blade insert (5) onto the saw blade.
 - **NOTE:** The press (1) has (2) bolts, with one of them having a larger flat tip (3), and the other with a narrow punch-type tip (2). The punch-type tip (2) is for removing old rivets, and the flat tip (3) is for pressing new rivets in.
- Using a breaker bar, air-powered impact wrench, or other suitable tool, thread the narrow punch-type tip (2) bolt down until it forces the old rivet (4) out and it drops free.
- Back the narrow punch-type tip (2) out to free the press (1).
- Remove the press (1) and old blade insert (5).
 - If needed, insert a rod approximately the same diameter as the blade insert (5) base hole, and tap the rod evenly on both sides of the blade insert (5) to assist removal.



- Place a new blade insert (5) into the slot on the saw blade.
- Press a new rivet (4) into place with the press (1).
 - Use the larger flat tip (3) to press the rivet (4) into place.
- Using a breaker bar, air-powered impact wrench, or other suitable tool, thread the larger flat tip (3) down until the new rivet (4) is forced flush with the saw blade.