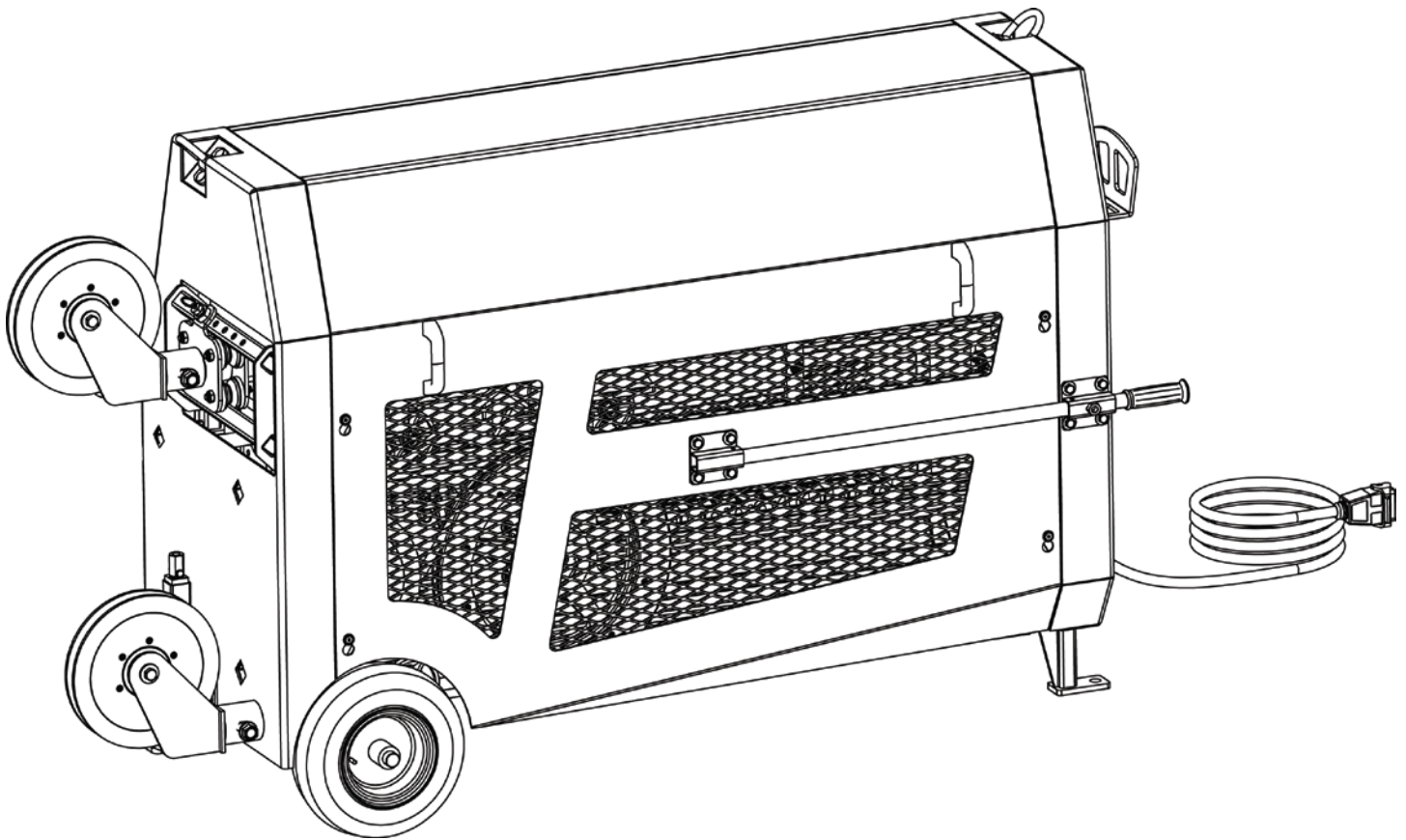


**DIAMOND
PRODUCTS**
WS30-LE

25HP High-Cycle Pneumatic Diamond Wire Saw



Parts Manual
December 2017
Part Number 1803059
www.diamondproducts.com

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Unpacking

This machine was inspected and operated before shipment and should not require any additional adjustment prior to its initial use. However, in the unlikely event of damage during shipment, the operator is advised to check out the machine by following the instructions of this manual in operating each of the equipment subsystems.

Uncrate the equipment carefully to prevent damage. Follow the instructions contained in this manual for the assembly and installation of any component parts which may have been removed for shipping purposes.

Check each item making certain that all items are accounted for and in good visual condition before discarding any packing materials. If there is any damaged or missing parts call customer services on our toll free number: 1-800-321-5336.

Contents of Carton

1. Diamond Products WS-30-XLE Wire Saw
2. WS-30-XLE Control Station
3. Owners Manual
4. Operators Manual

Before Starting

This instruction manual describes the operating procedures, care, maintenance, adjustments and safety precautions for proper use of this machine. This equipment is intended for industrial applications by experience operators. It is to be operated in conformance with applicable federal, state and local codes or regulations pertaining to safety, air pollution, noise, etc.

IMPROPER USE OF THIS EQUIPMENT OR IMPROPER MACHINE ALTERATIONS MAY BE EXTREMELY DANGEROUS!

The operator is cautioned against using this machine before having read and fully understood the instructions presented in this manual and in the original manufacturer's instructions provided separately.

USER RESPONSIBILITIES

It is the operator's responsibility to use this machine under safe working conditions and to be fully aware of requirements for operator safety and safety of co-workers, observers and public at large. The operator must be aware of the machine's capabilities and limitations and follow the safety precautions in each section of this manual. Periodic maintenance is required, in accordance with instructions herein, to promote safe and reliable operation.

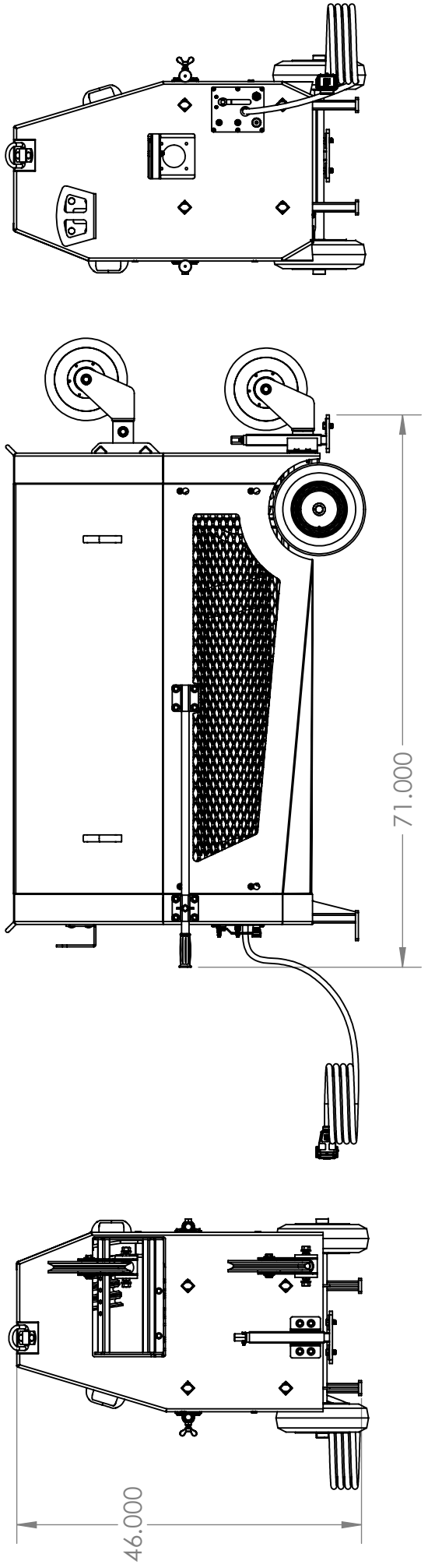
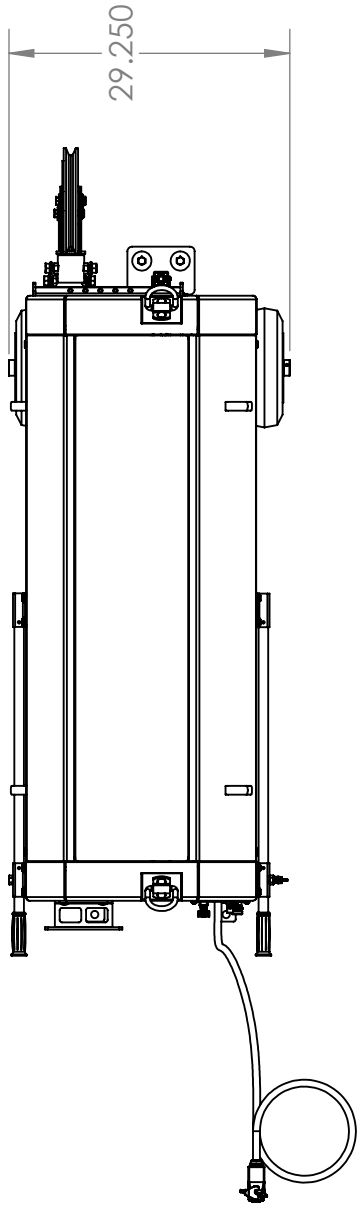
Care is to be taken by the operator to see that all of the safety features furnished with the machine are properly maintained and operational.

It is the responsibility of the operator to provide a safe working environment and to follow proper safety procedures when operating this equipment. Operators must use approved ear protection, safety hat, eye protectors, gloves, safety shoes and any other personal protective equipment required for compliance with standard safety practices or federal, state and local codes and regulations.

WS30-LE

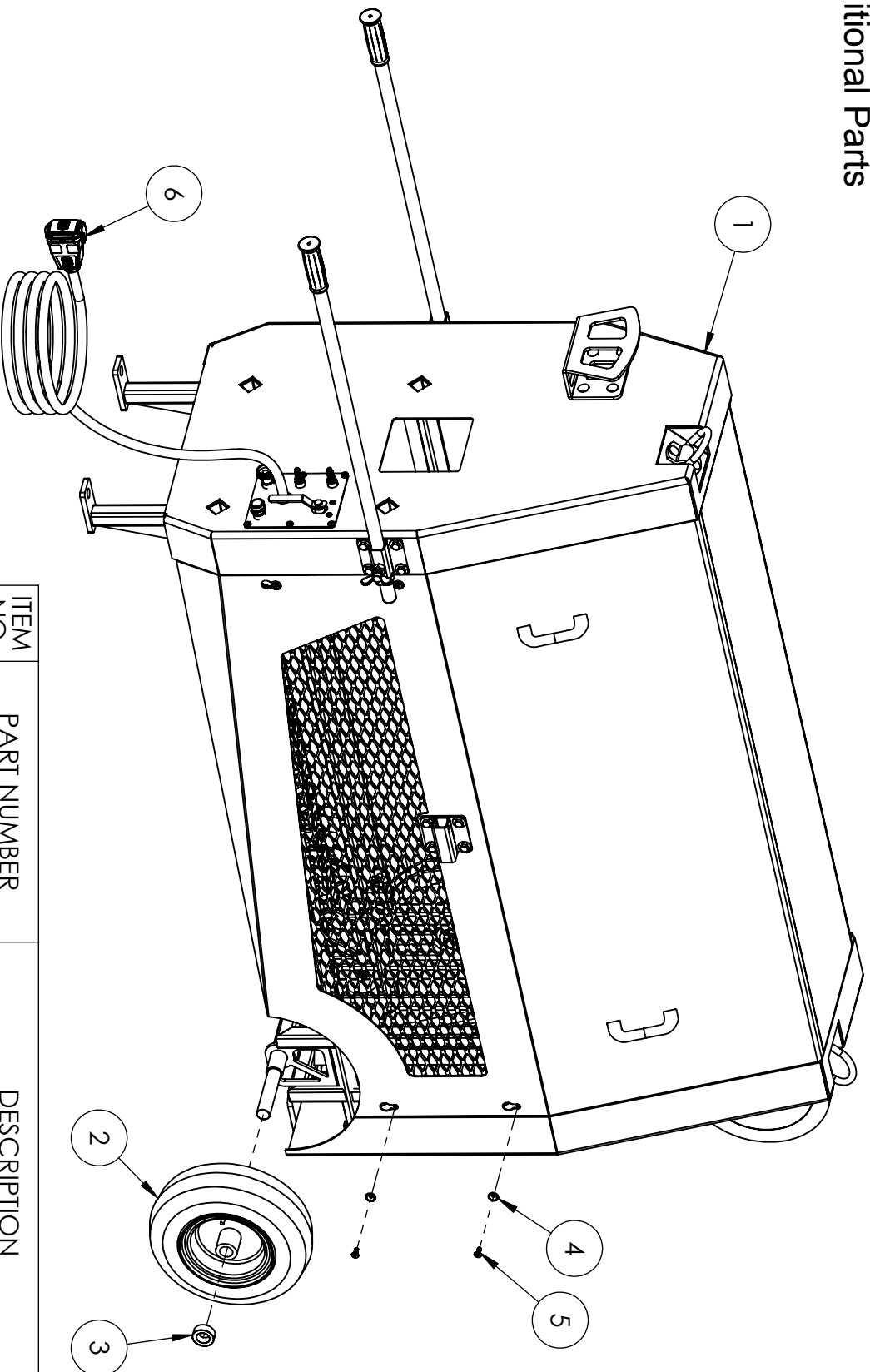
25 HP High-Cycle Pneumatic Diamond Wire Saw

Length	71.00" / 1803mm
Width	29.25" / 743mm
Height	46.00" / 1168mm
Weight	780lbs / 354.0 kg
Wire Storage	49' / 15m
Power	25hp / 18.65 kw



WS30-LE

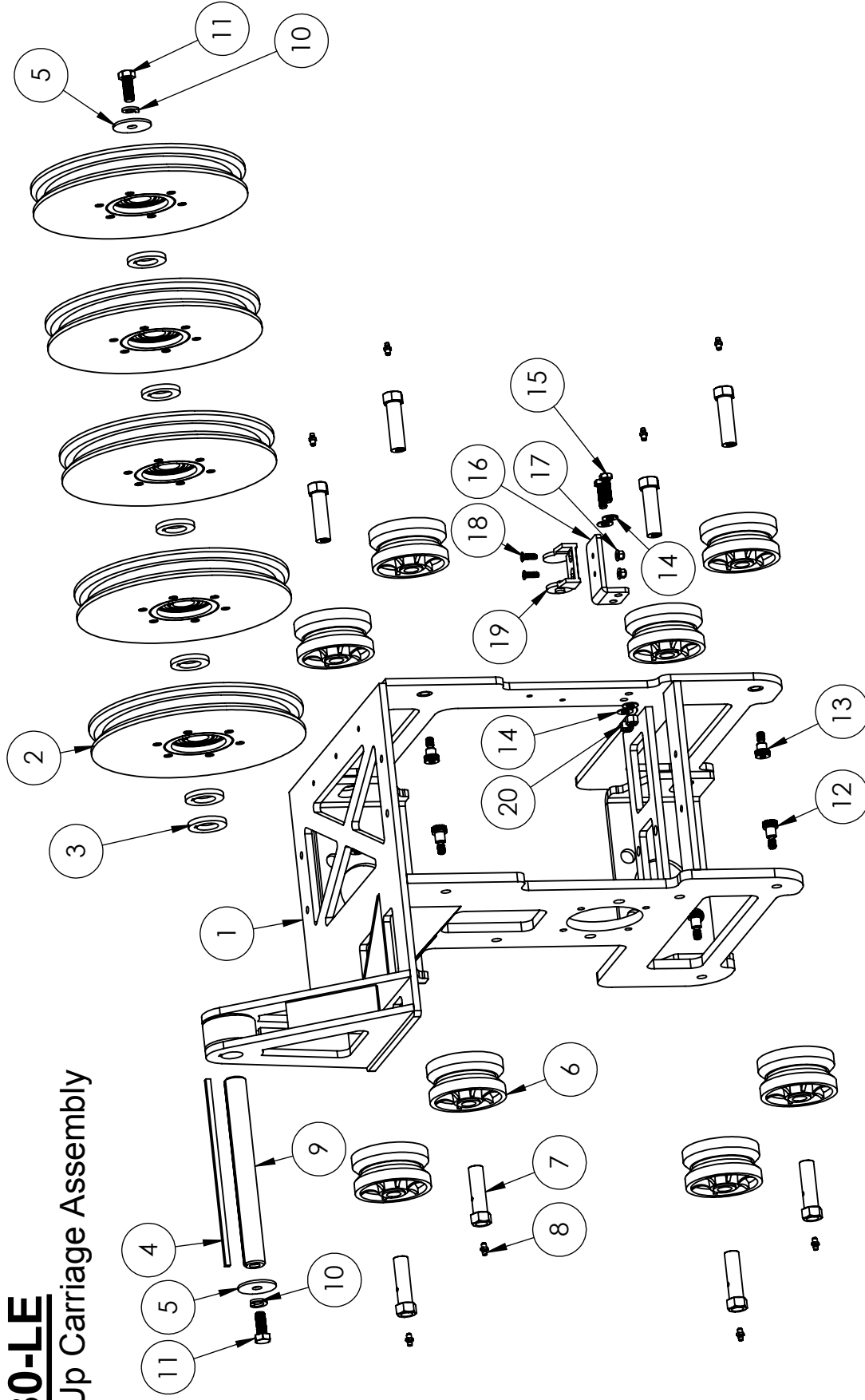
Additional Parts



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070725	WS30-LE Frame Weldment	1
2	2506908	WHEEL, 12.4"x3.6"x 1" BEARING	2
3	2500009	Set Collar, 1" ID	2
4	6071005	Panel Standoff, 3/4"	8
5	2902984	1/4-20 x 1.00 FHCS	8
6	4647134	50' Power Cord, 700hz Complete	1
7	1803075	Decal Kit, WS-30-XLE	1

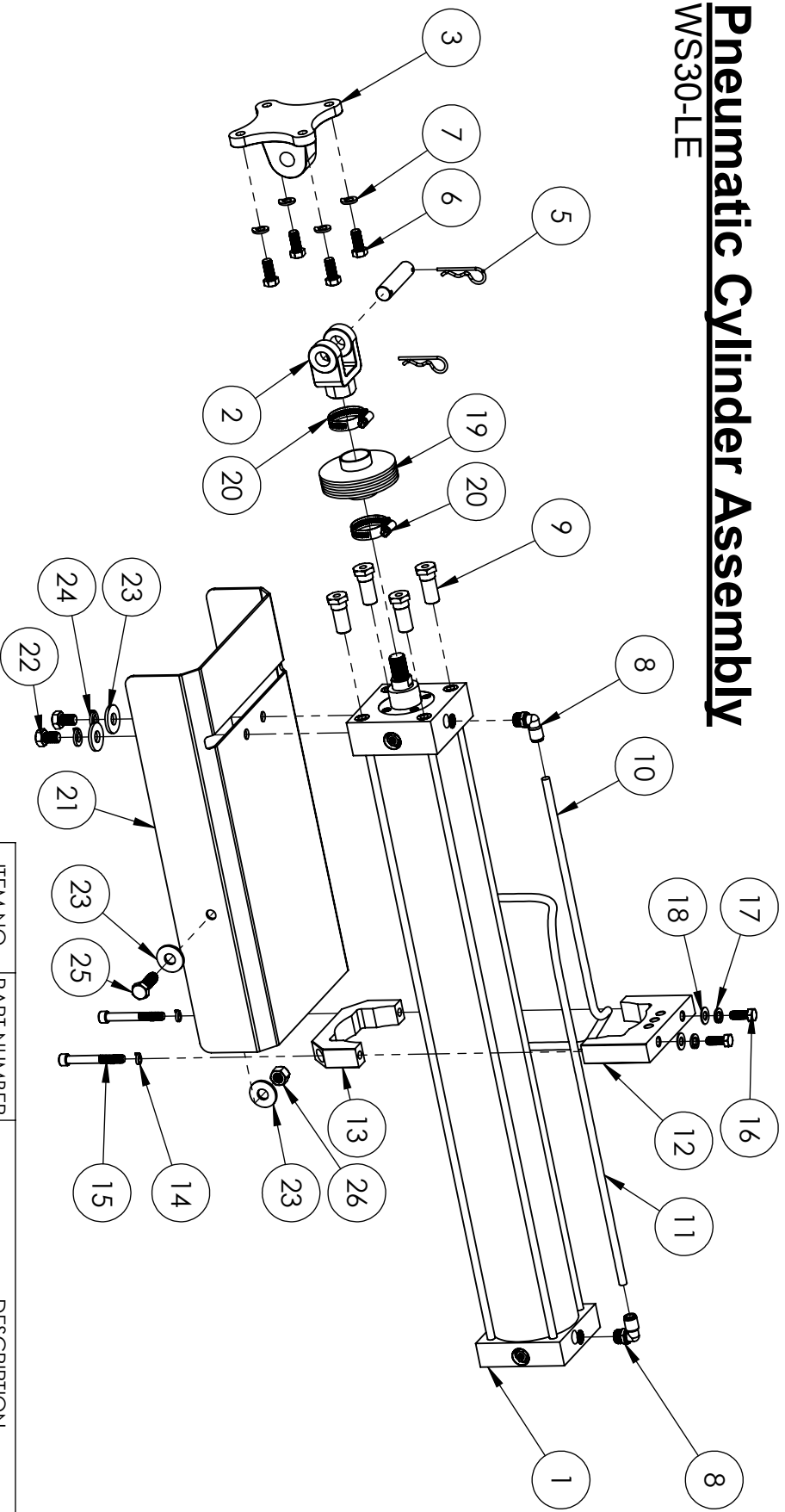
WS30-LE

Take-Up Carriage Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070695	Track Carriage, WS30-XLE	1	11	2900025	1/2-13 x 1.25 HHCS	2
2	2505895	Idler Wheel Assembly	5	12	2902047	1/2 DIA. SHOULDER SCREW 1/2" LONG	4
3	6070272	Keyed Washer	6	13	2902048	1/2 DIA. SHOULDER SCREW 3/8" LONG	4
4	6071009	Key, .250" Square x 10.25"	1	14	2900014	3/8" SAE Flat Washer	6
5	2900854	Flat Washer, 1/2" x 2" x 1/8"	2	15	2900013	3/8-16 X 1.25" HHCS	2
6	8741T61	V-Groove Wheel, Poly 2" x 4"	8	16	6071006	Cable Carrier Bracket	1
7	6072509	Eccentric Bolt	8	17	2902053	M6-1 Nylon Insert Hex Nut (Flanged)	2
8	2900706	1/4-28 Grease Fitting	8	18	2902054	M6-1 x 20mm FHSCS	2
9	6071008	Keyed Shaft, 1.125" x 10.25"	1	19	2505549	Cable Carrier Mount, (Male)	1
10	2900084	1/2 SPLIT LOCK WASHER	4	20	2900018	3/8-16 Nylon Lock Nut	2

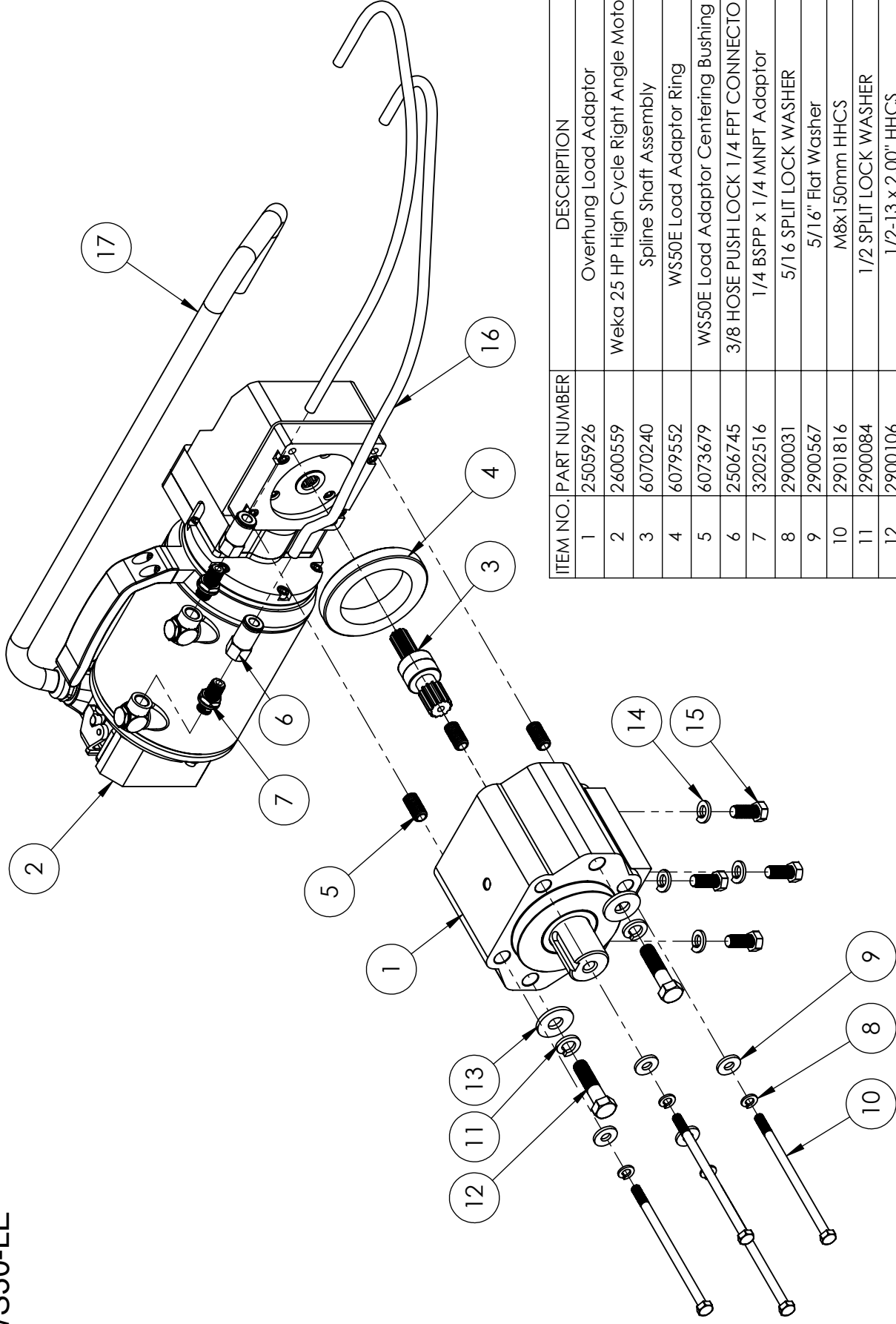
Pneumatic Cylinder Assembly WS30-LE



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2506902	Pneumatic Cylinder, 4" x 30"	1	14	2903041	3/8 Machine Screw Split Lock Washer	2
2	2505695	Rod Clevis	1	15	2900120	3/8-16 x 3.00 SHCS	2
3	2505696	Pivot Bracket	1	16	2900005	3/8-16x1.00 HHCS	2
4	2505697A	Cylinder Pin (Included w/ #2505697)	1	17	2900006	3/8 SPLIT LOCK WASHER	2
5	2900829	Hairpin Cotter, 1/8" x 5/8" to 7/8"	2	18	2900014	3/8" SAE Flt Washer	2
6	2900407	7/16-14x1.00 HHCS	4	19	2506907	BELLOWS, 1-1/4 ID X 3-3/4	1
7	2900238	7/16 SPLIT LOCK WASHER	4	20	2503266	#20 Hose Clamp	2
8	2506743	3/8 HOSE PUSHLOCK 90 SWIVEL	2	21	6070780	Cylinder Shield, WS30-XLE	1
9	6071010	Internally Threaded Shoulder Bolt, 3/8-24	4	22	2900495	1/2-13 x .750" Hex Head Cap Screw	2
10	2506746	3/8 O.D. Green Tubing (Per Foot)	1	23	2900127	1/2" USS Flt Washer	4
11	2506747	3/8 O.D. Red Tubing (Per Foot)	1	24	2900084	1/2 SPLIT LOCK WASHER	2
12	6070702	Cylinder Supprt	1	25	2900499	1/2-13x1.50 HHCS	1
13	6071024	Carrier Block, Lower	1	26	2900026	1/2-13 Nylon-Insert Hex Locknut	1
				27	3203051	Cylinder Rebuild Kit	1
				28	2505909	Limit Switch, Reed Style	1

Motor Assembly

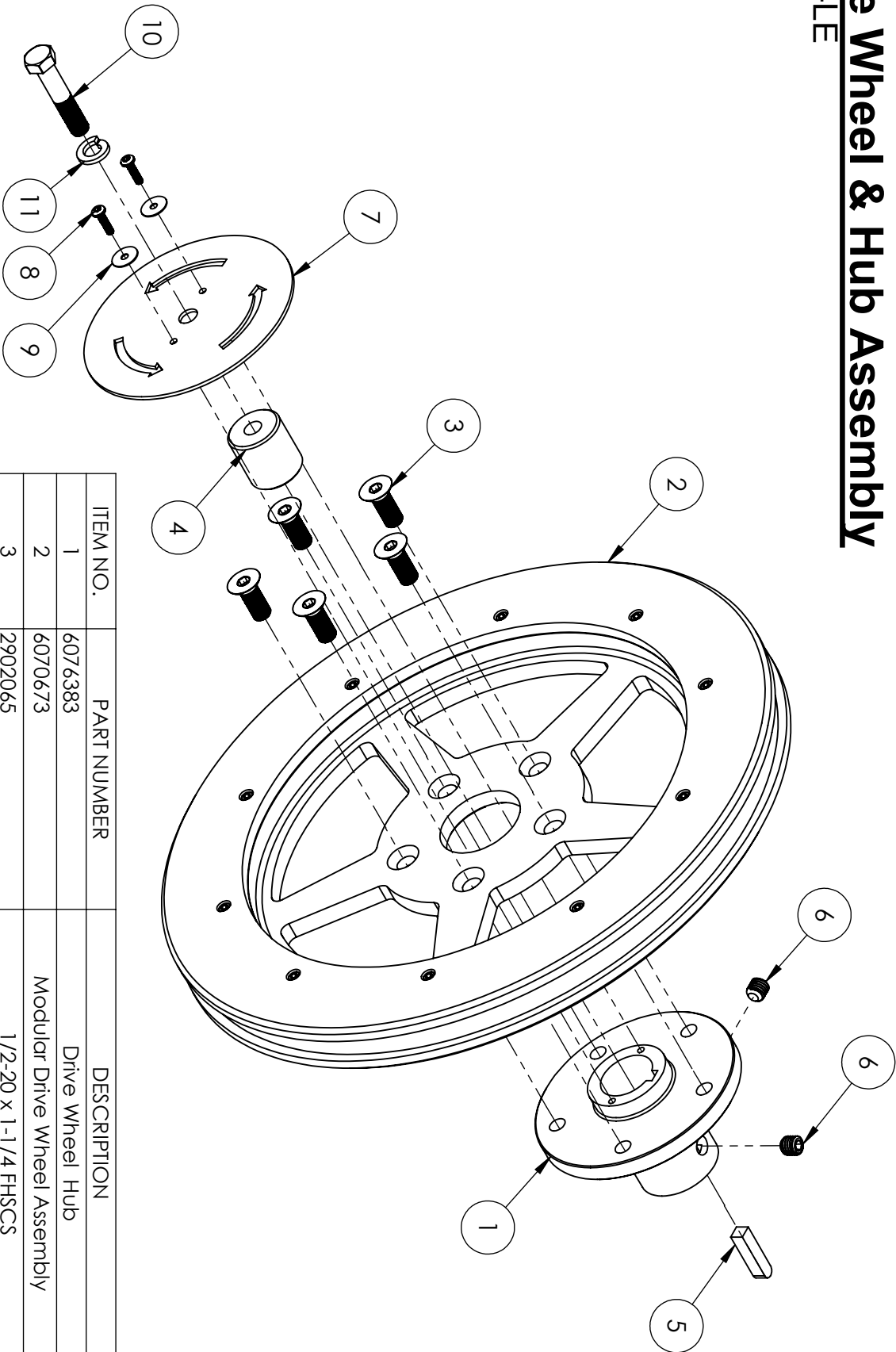
WS30-LE



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2505926	Overhung Load Adaptor	1
2	2600559	Weka 25 HP High Cycle Right Angle Motor	1
3	6070240	Spline Shaft Assembly	1
4	6079552	WS50E Load Adaptor Ring	1
5	6073679	WS50E Load Adaptor Centering Bushing	4
6	2506745	3/8 HOSE PUSH LOCK 1/4 FPT CONNECTOR	2
7	3202516	1/4 BSPP x 1/4 MNPT Adaptor	2
8	2900031	5/16 SPLIT LOCK WASHER	4
9	2900567	5/16" Flat Washer	4
10	2901816	M8x150mm HHCS	4
11	2900084	1/2 SPLIT LOCK WASHER	2
12	2900106	1/2-13 x 2.00" HHCS	2
13	2900127	1/2" USS Flat Washer	2
14	2900238	7/16 SPLIT LOCK WASHER	4
15	2900407	7/16-14x1.00 HHCS	4
16	2506744	3/8" O.D. Tubing (Sold Per Foot)	1
17	4647138	CORD, 700HZ WS30-XLE	1

Drive Wheel & Hub Assembly

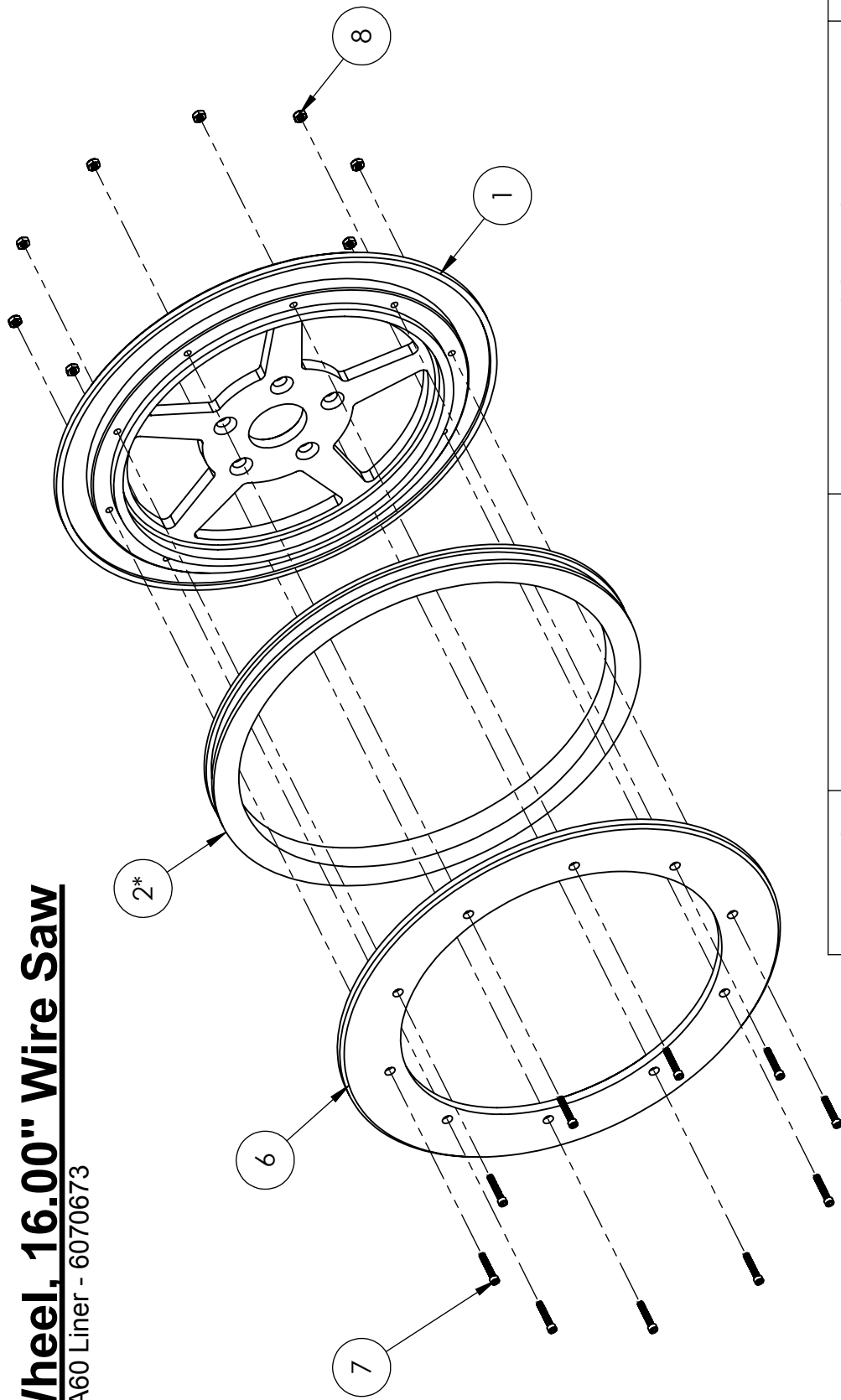
WS30-LE



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6076383	Drive Wheel Hub	1
2	6070673	Modular Drive Wheel Assembly	1
3	2902065	1/2-20 x 1-1/4 FHSCS	5
4	6070432	Drive Wheel Slug	1
5	6073681	WSS0E Hub Key	1
6	2900859	1/2-13 x .500" Cup Point Set Screw	2
7	6070411	Rotational Sftet Washer, WS50-XLE	1
8	2902027	10-32 X 3/4 PAN HEAD TORX SS	2
9	2902028	#10 TYBE B PLAT WASHER SS	2
10	2900811	1/2-13 x 2.50 Hex Cap Screw	1
11	2900084	1/2 SPLIT LOCK WASHER	1

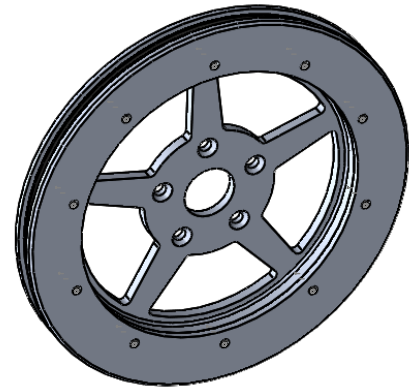
Drive Wheel, 16.00" Wire Saw

Assembly W/ A60 Liner - 6070673

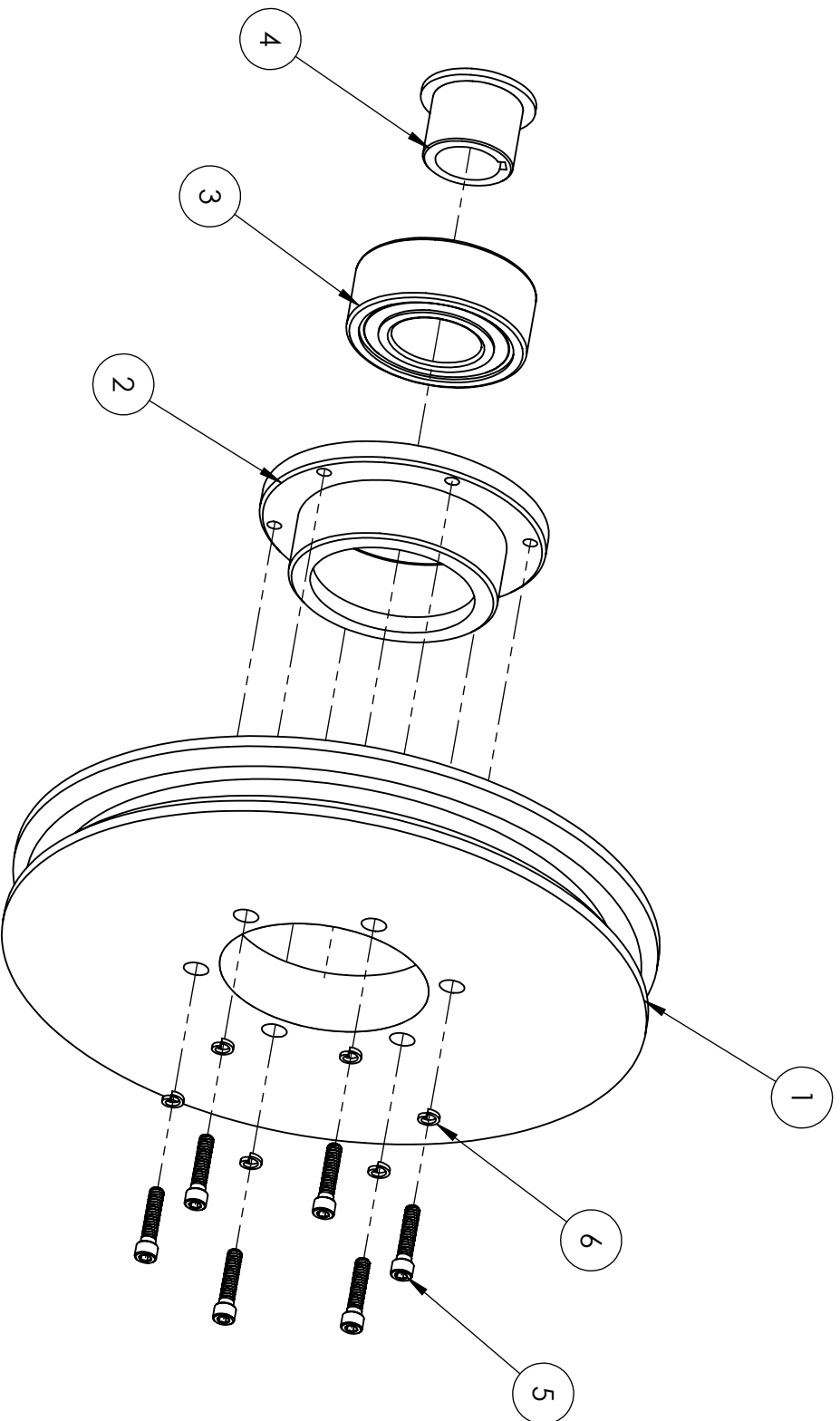


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070671	Drive Wheel Half, Inner	1
2*	6070670	Wheel Liner, 17" x 1", Black 60A	1
3	6070713	Wheel Liner, 17" x 1", Orange, 40A	
4	6070714	Wheel Liner, 17" x 1", Blue, 50A	
5	6070715	Wheel Liner, 17" x 1", Green, 80A	
6	6070672	Drive Wheel Half, Outer	1
7	2900519	1/4-20 x 1.25" SHCS	10
8	2902069	1/4-20 Thin Nylon Insert Hex Nut	10

NOTE: DUROMETER IS A MEASURE OF MATERIAL HARDNESS, SMALLER NUMBER IS SOFTER
*INCLUDED IN WHEEL ASSEMBLY 6070673



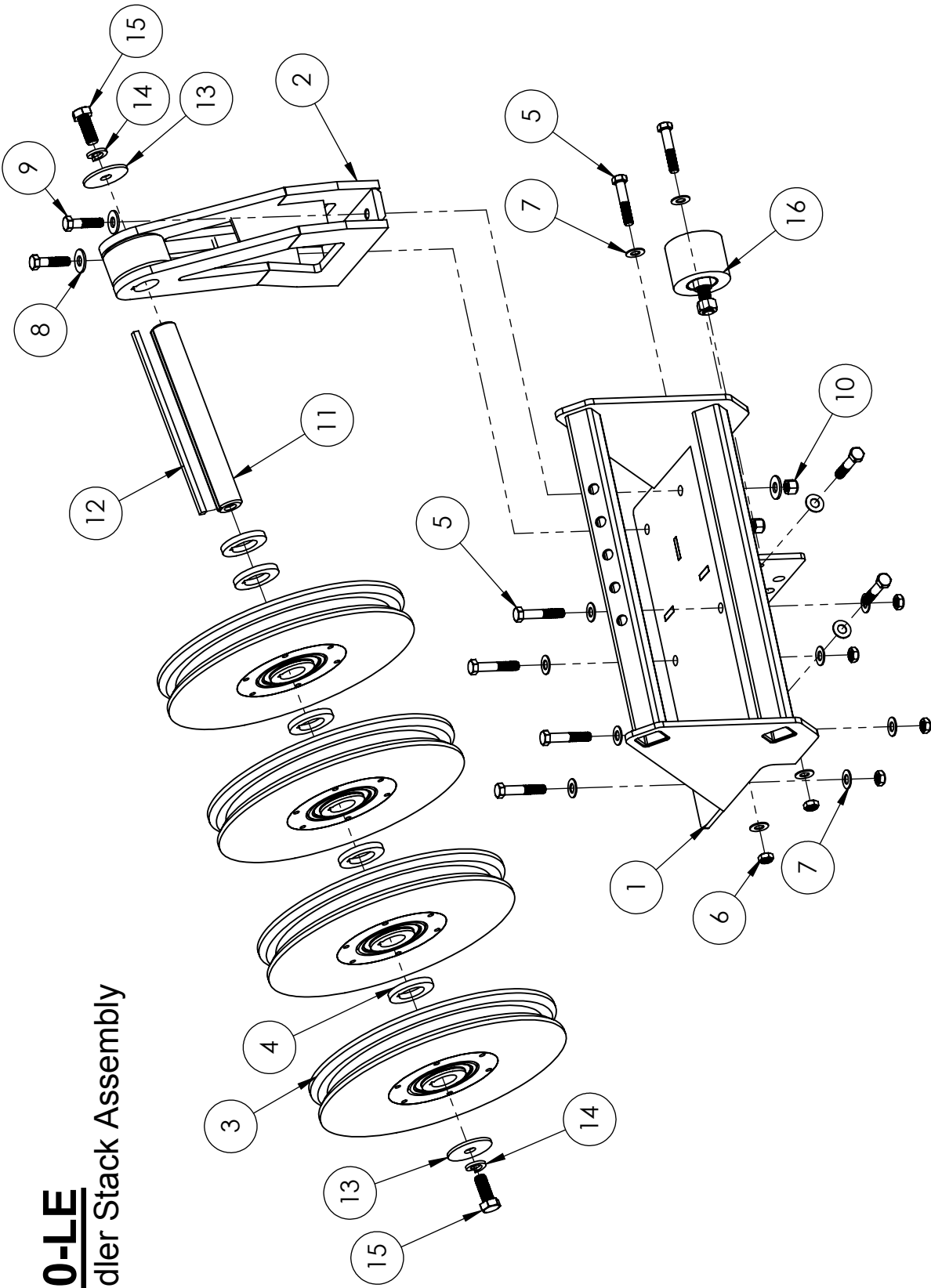
WS30-LE IDLER WHEEL ASSEMBLY - 2505895



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6072508	WS50-LE Delrin Wheel (Cut)	1
2	6070269	80mm Bearing Flange	1
3	2503953	Bearing, 40 X 80 X 1.1875" (5208-2RS)	1
4	6070268	Keyed Bushing	1
5	2902026	1/4-20 X 1.125 SHCS Zinc Plated	6
6	2900404	1/4 SHCS Lock Washer	6

WS30-LE

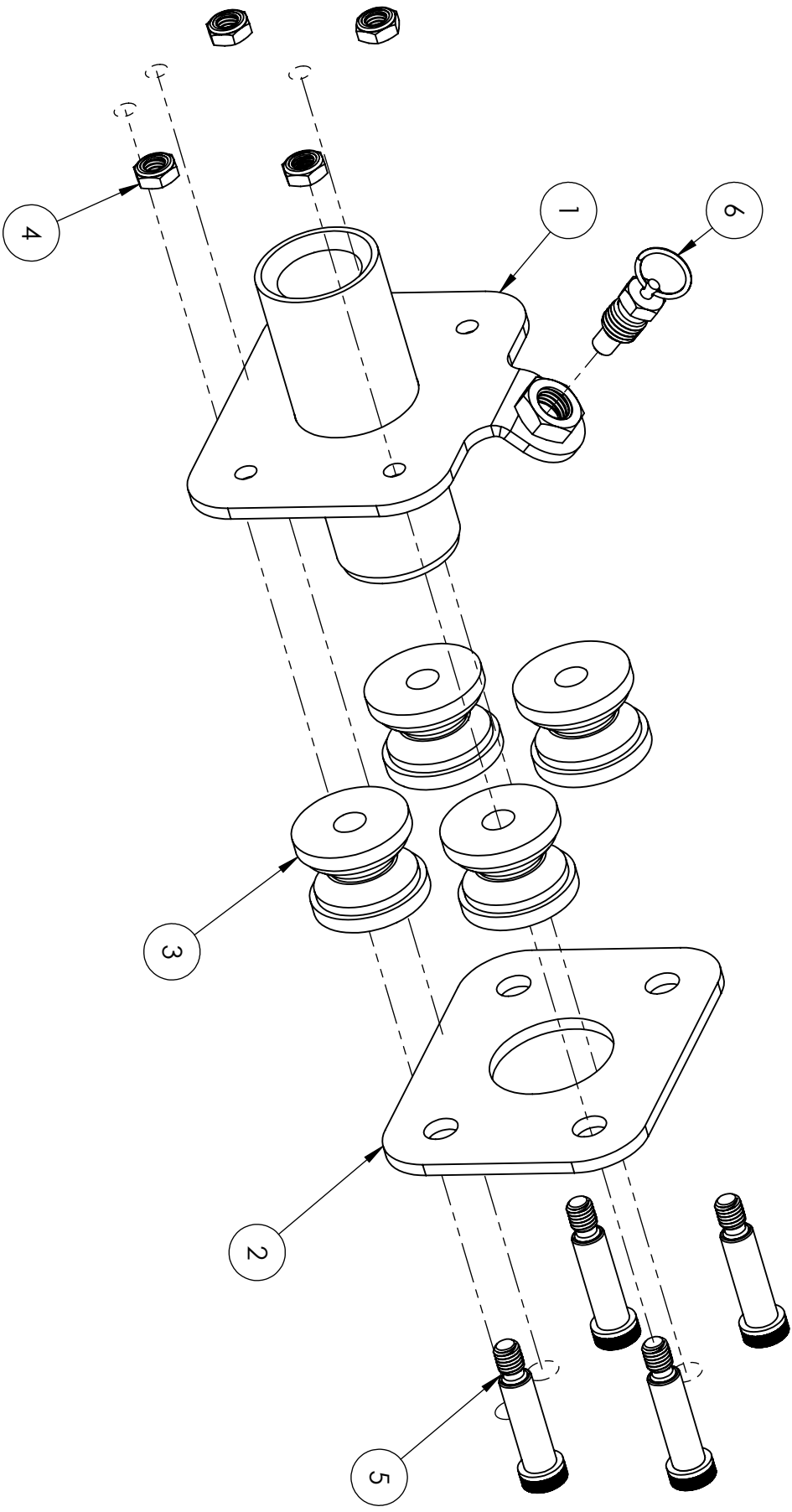
Fixed Idler Stack Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070699	Fixed Guide Weldment	1	9	2900029	3/8-16 x 1.50 HEX HEAD CAP SCREW	2
2	6070701	Fixed Idler Support Weldment	1	10	2900018	3/8-16 Nylon Lock Nut	2
3	2505895	Idler Wheel Assembly	4	11	6071012	Keyed Shaft, 1.125" x 8.75"	1
4	6070272	Keyed Washer	5	12	6071013	Key, .250" Square x 8.75"	1
5	2900060	3/8-16 x 2.00 HHCS (Grade 5)	8	13	2900854	Flat Washer, 1/2" x 2" x 1/8"	2
6	2901988	3/8-16 Nylon Insert Thin Nut	8	14	2900084	1/2 SPLIT LOCK WASHER	2
7	2900014	3/8" SAE Flat Washer	16	15	2900025	1/2-13 x 1.25 HHCS	2
8	2903018	USS 3/8" Flat Washer	4	16	2506915	Idler Roller	1

WS30-LE

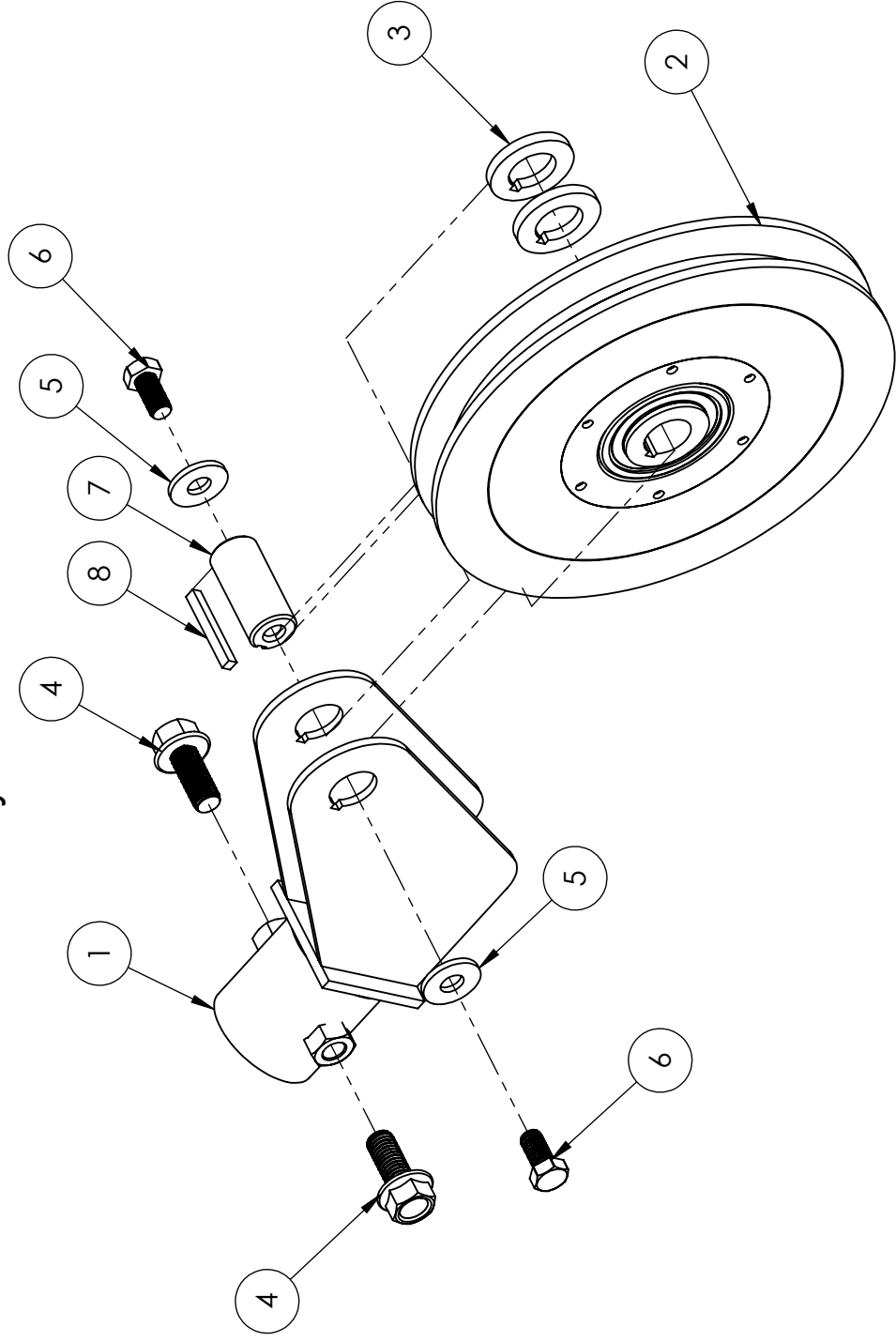
Sliding Wire Director Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070705	Slide Box, Front Weldment	1
2	6070707	Slide Box Rear Plate	1
3	6070308	2.25" V-Groove Wheel	4
4	2900543	1/2-13 Nylon Insert Hex Nut, Thin	4
5	2902061	5/8 x 2.00 Shoulder Screw, 1/2-13 Thread	4
6	2505699	Pull Ring Spring Pin, 3/4-10	1

WS30-LE

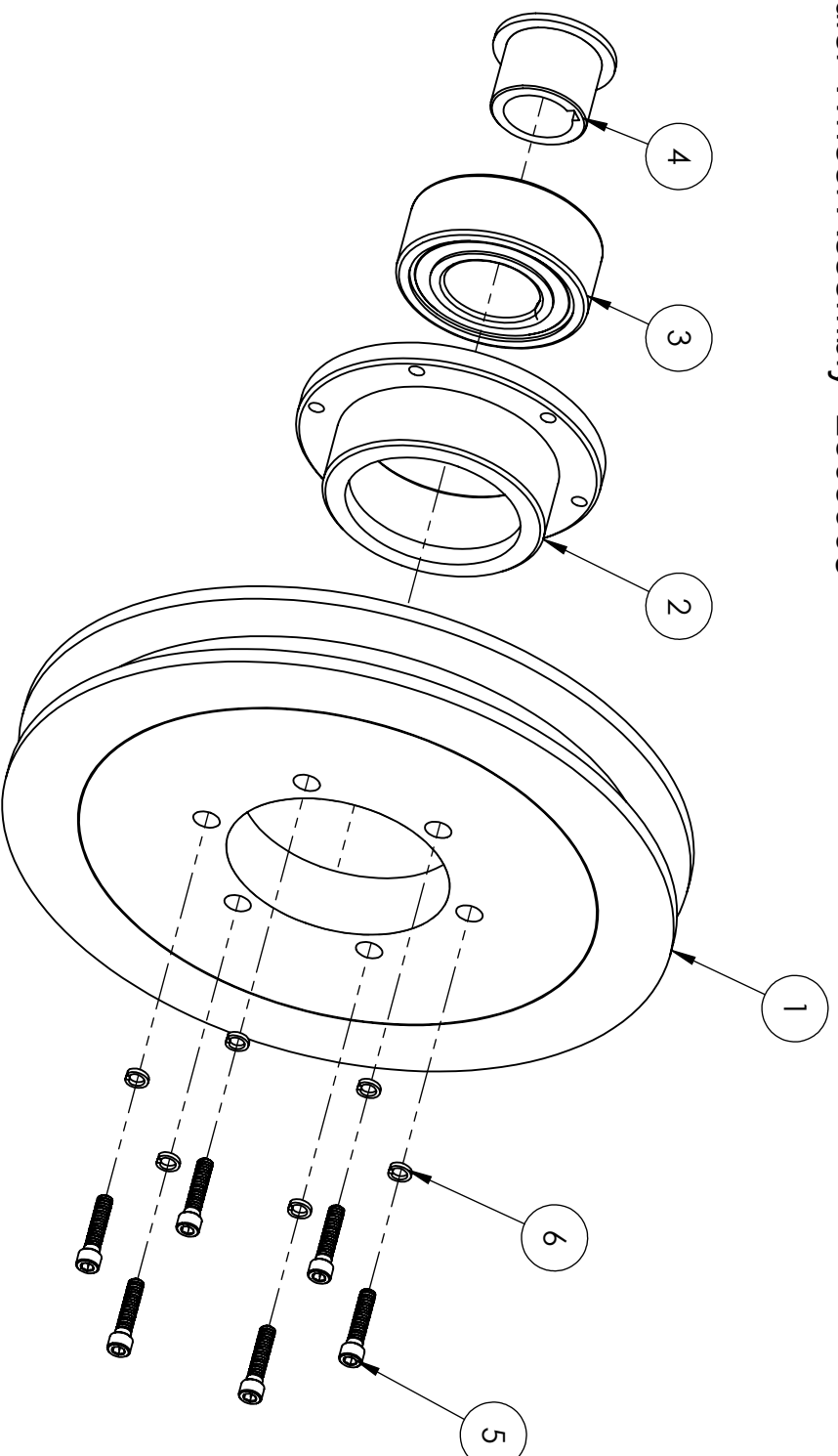
Swivel Wheel Guide Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070728	Guide Wheel Weldment	1
2	2505903	11.00 Poly Wheel Assembly	1
3	6070272	Keyed Washer	2
4	2900164	Cap Screw, Flange Hd., 5/8-11 x 1-1/2"	2
5	2900127	1/2" USS Flat Washer	2
6	2900086	1/2-13 x 1.00" HHCS	2
7	2505896	Fully Keyed	1
8	6070307	.250 " x 2.125" Square Key	1

WS30-LE

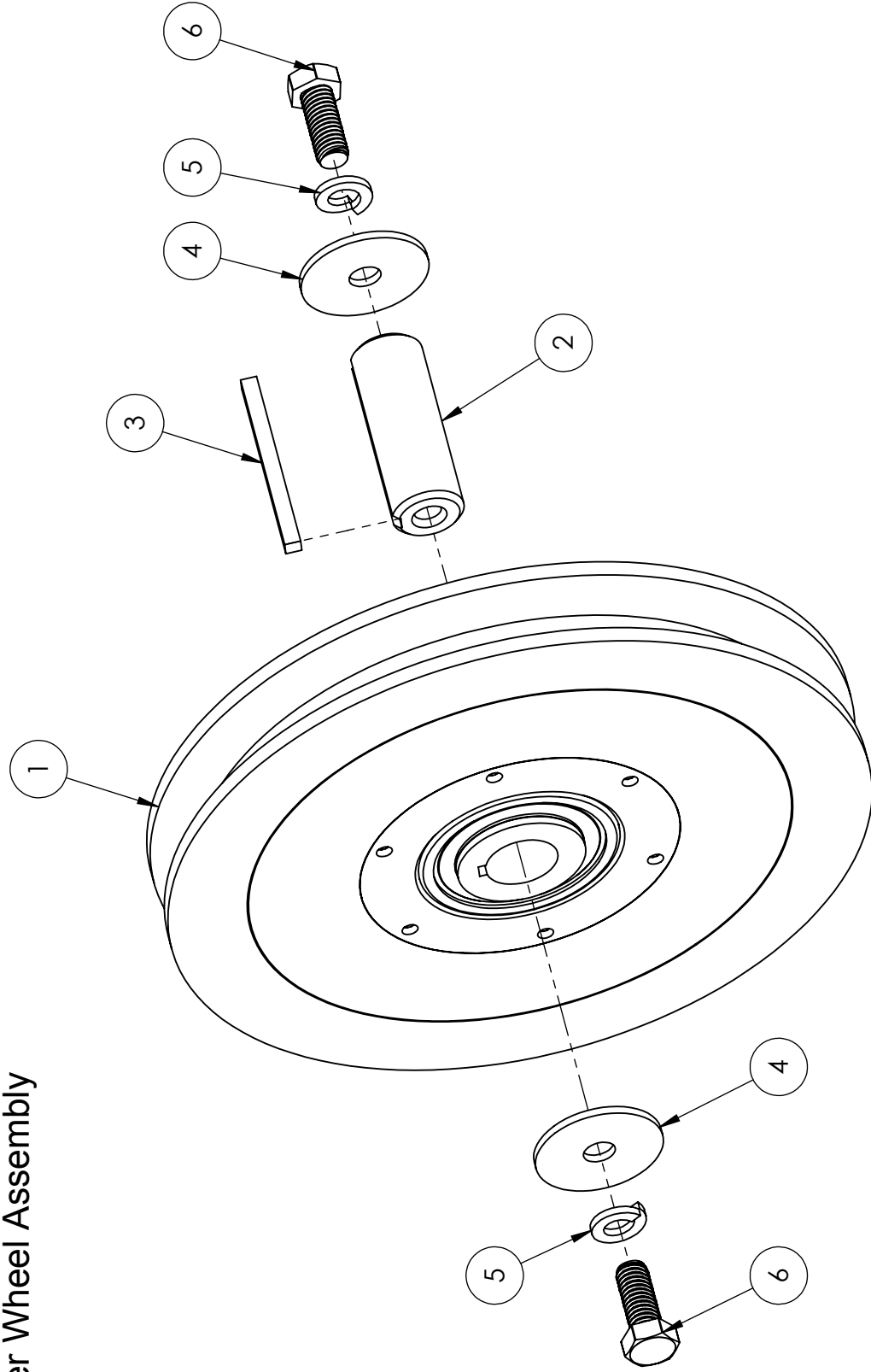
Poly Idler Wheel Assembly -2505903



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6079358	11.00" Poly Wheel, Machined	1
2	6070269	80mm Bearing Flange	1
3	2503953	Bearing, 40 X 80 X 1.1875" (5208-2RS)	1
4	6070268	Keyed Bushing	1
5	2902026	1/4-20 X 1.125 SHCS Zinc Plated	6
6	2900404	1/4 SHCS Lock Washer	6

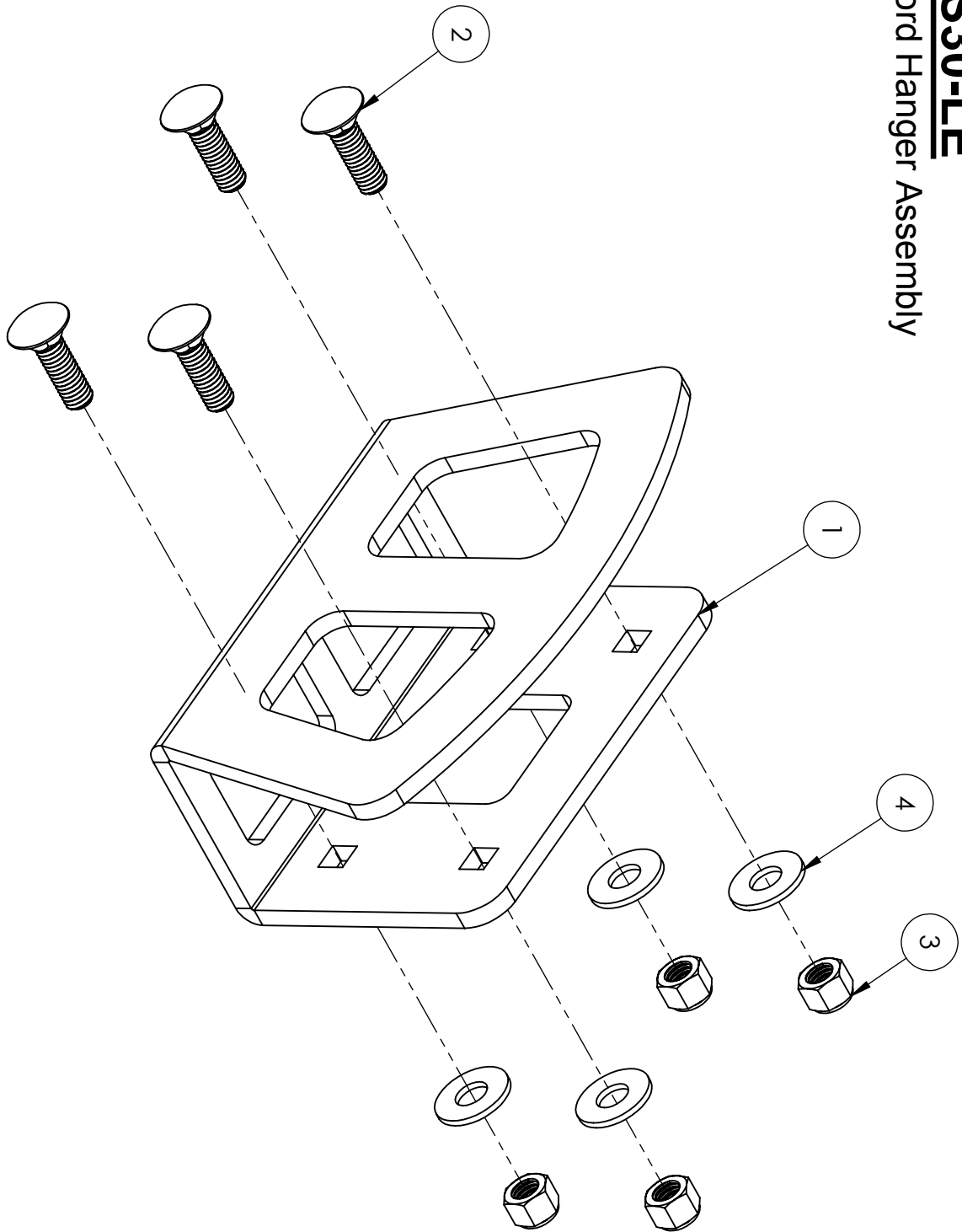
WS30-LE

Idler Wheel Assembly



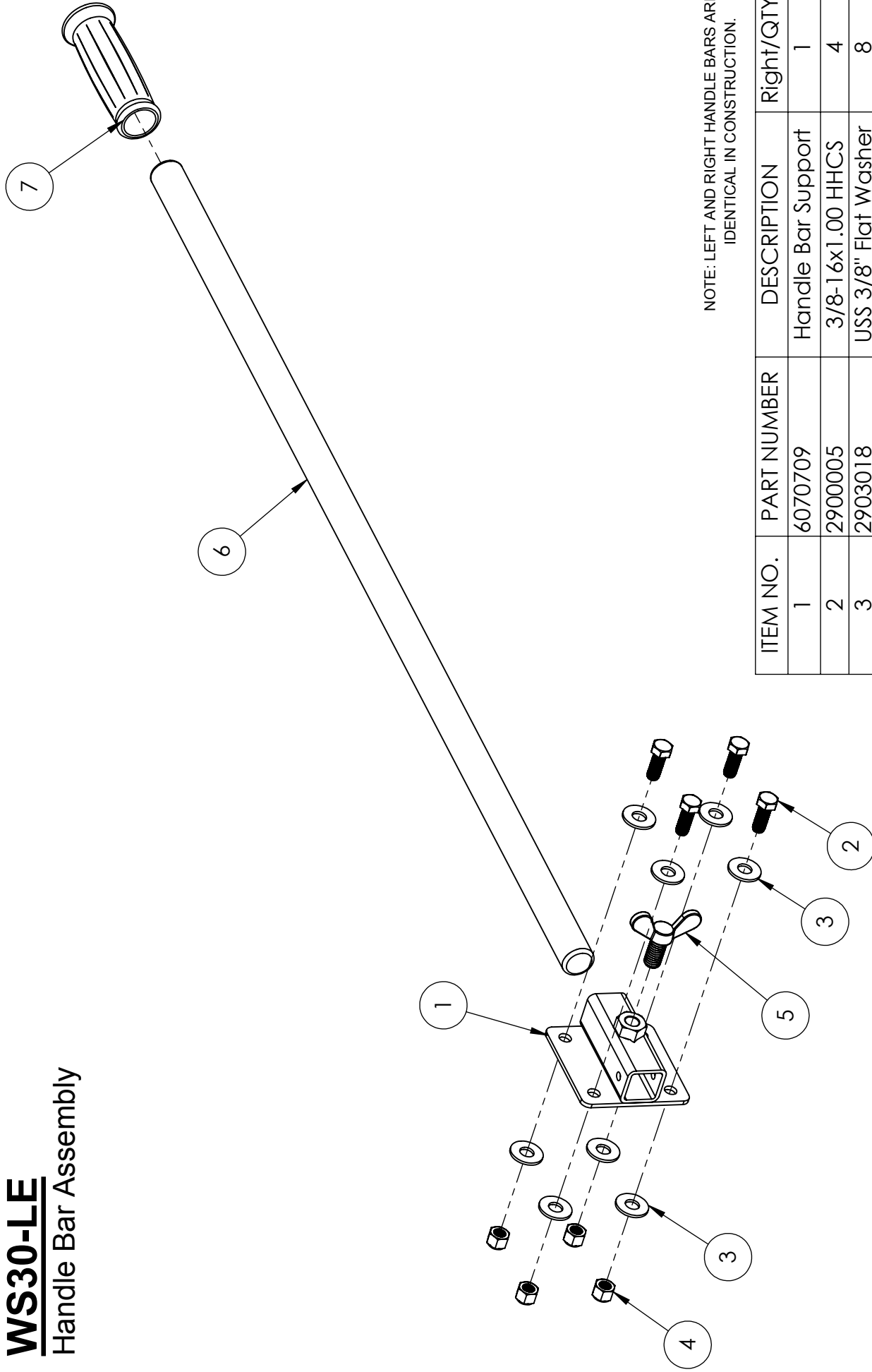
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2505903	11.00 Poly Wheel Assembly	1
2	6071015	Keyed Shaft, 1.125" x 3.125"	1
3	6071014	Key, .250" Square x 3.125"	1
4	2900854	Flat Washer, 1/2" x 2" x 1/8"	2
5	2900084	1/2 SPLIT LOCK WASHER	2
6	2900025	1/2-13 x 1.25 HHCS	2

WS30-LE Chord Hanger Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6071003	Cable & Hose Hanger	1
2	2903037	3/8-16 x 1.25 Carriage Bolt	4
3	2900018	3/8-16 Nylon Lock Nut	4
4	2903018	USS 3/8" Flat Washer	4

WS30-LE Handle Bar Assembly

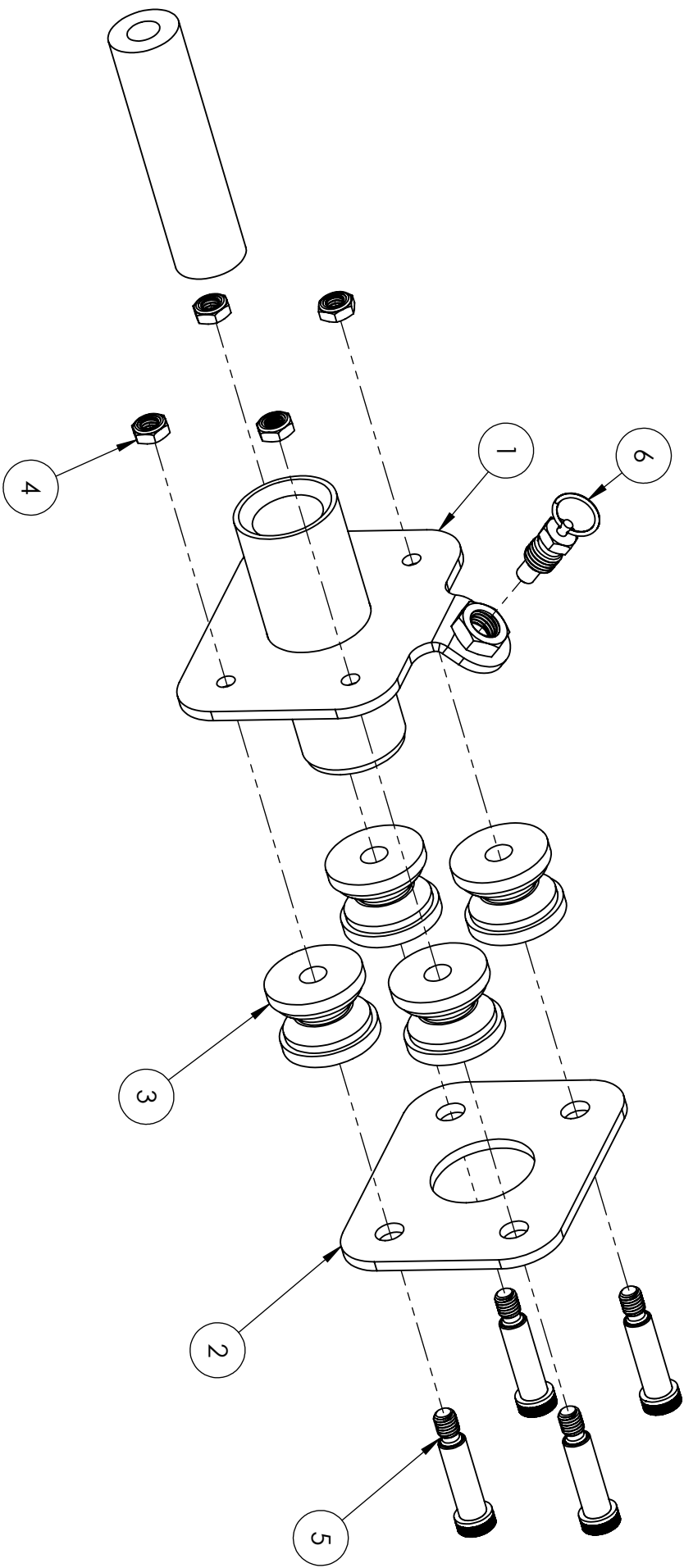


NOTE: LEFT AND RIGHT HANDLE BARS ARE IDENTICAL IN CONSTRUCTION.

ITEM NO.	PART NUMBER	DESCRIPTION	Right/QTY.
1	6070709	Handle Bar Support	1
2	2900005	3/8-16x1.00 HHCS	4
3	2903018	USS 3/8" Flat Washer	8
4	2900018	3/8-16 Nylon Lock Nut	4
5	2900430	1/2-13 Wing Bolt	1
6	6010014	Handle Bar, 36" Long	1
7	2500636	Handle Grip	1

WS30-LE

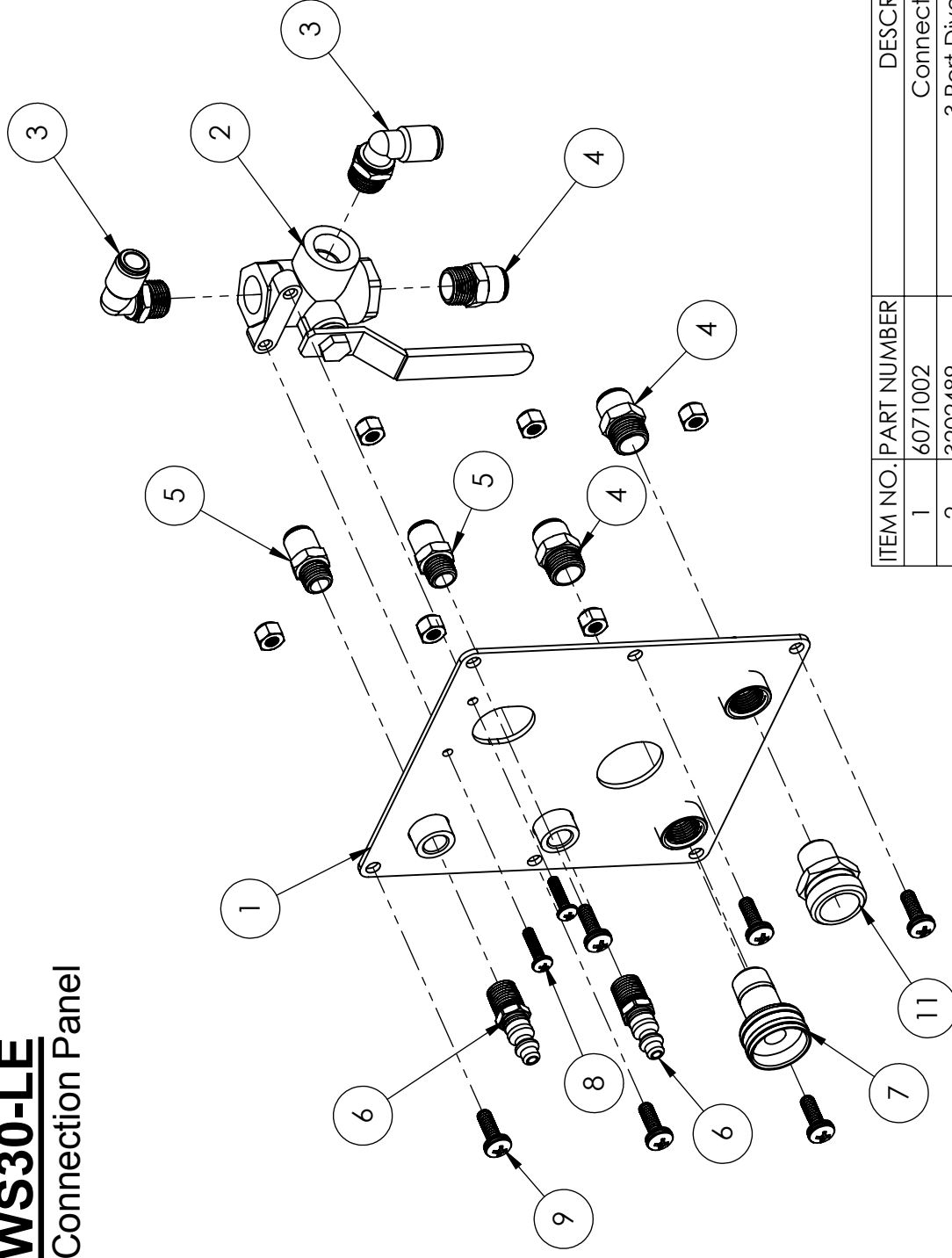
Sliding Wire Director Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070705	Slide Box, Front Weldment	1
2	6070707	Slide Box Rear Plate	1
3	6070308	2.25" V-Groove Wheel	4
4	2900543	1/2-13 Nylon Insert Hex Nut, Thin	4
5	2902061	5/8 x 2.00 Shoulder Screw, 1/2-13 Thread	4
6	2505699	Pull Ring Spring Pin, 3/4-10	1
7	6070718		1

WS30-LE

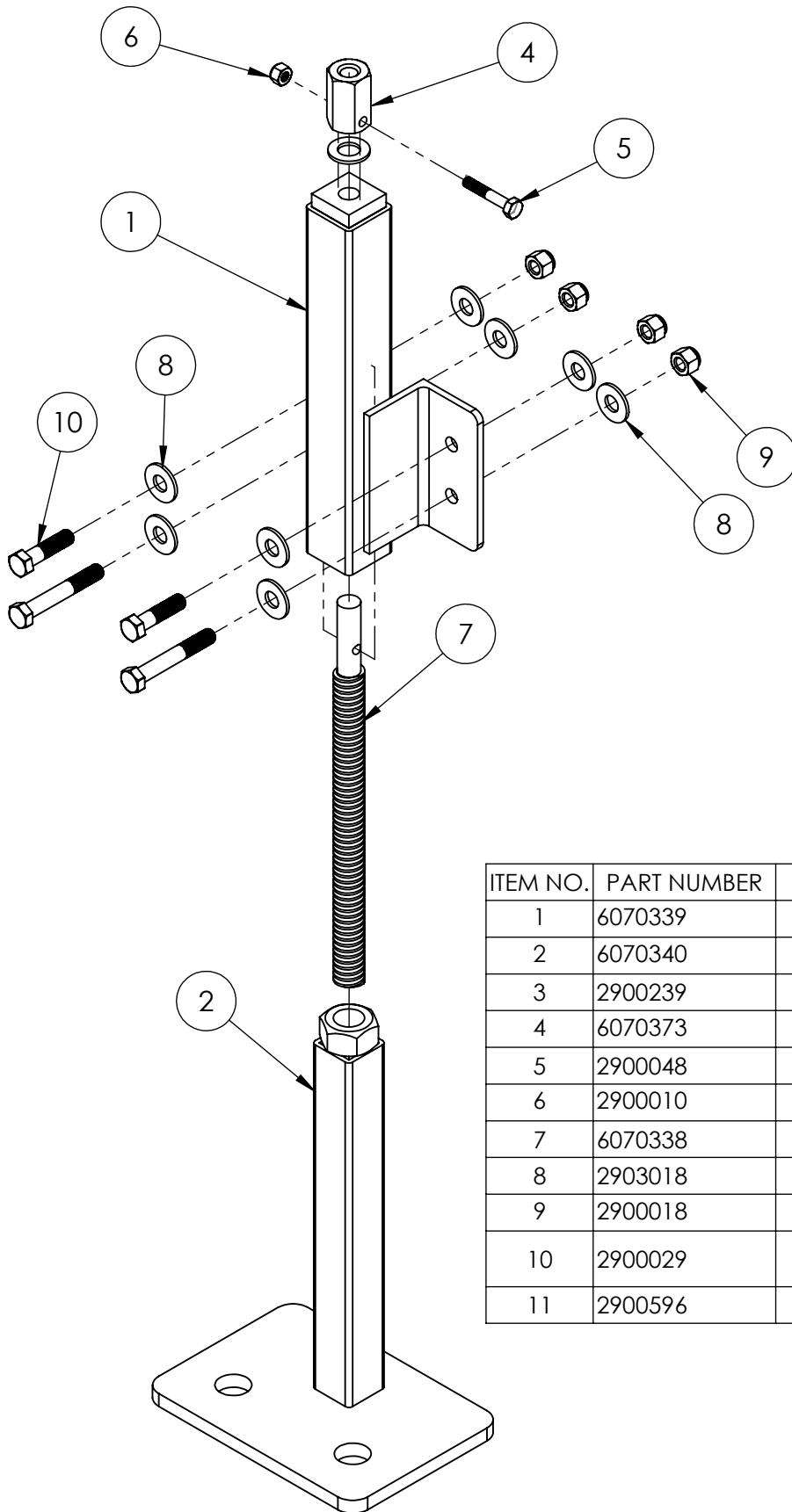
Connection Panel



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6071002	Connection Panel	1
2	3202489	3 Port Diversion Valve	1
3	2506743	3/8 HOSE PUSHLOCK 90 SWIVEL	2
4	2506748	3/8 OD PUSHLOCK FITTING	3
5	2506741	1/4 MPT X 3/8 PUSHLOCK	2
6	3202768	1/4 MPT X 1/4 INDUSTRIAL HOSE COUPLING, ZINC	2
7	3202081	Fitting, 3/4" F. Garden to 3/8" M. Pipe	1
8	2900689	#10-32X3/4" PHC	2
9	2902055	1/4-20 x 3/4 PHMS W/Washer	6
10	2900010	1/4-20 Nylon-Insert Hex Locknut	6
11	3200596	Fitting, 3/8" MPT to 3/4" F. Garden Hose	1

WS30-LE

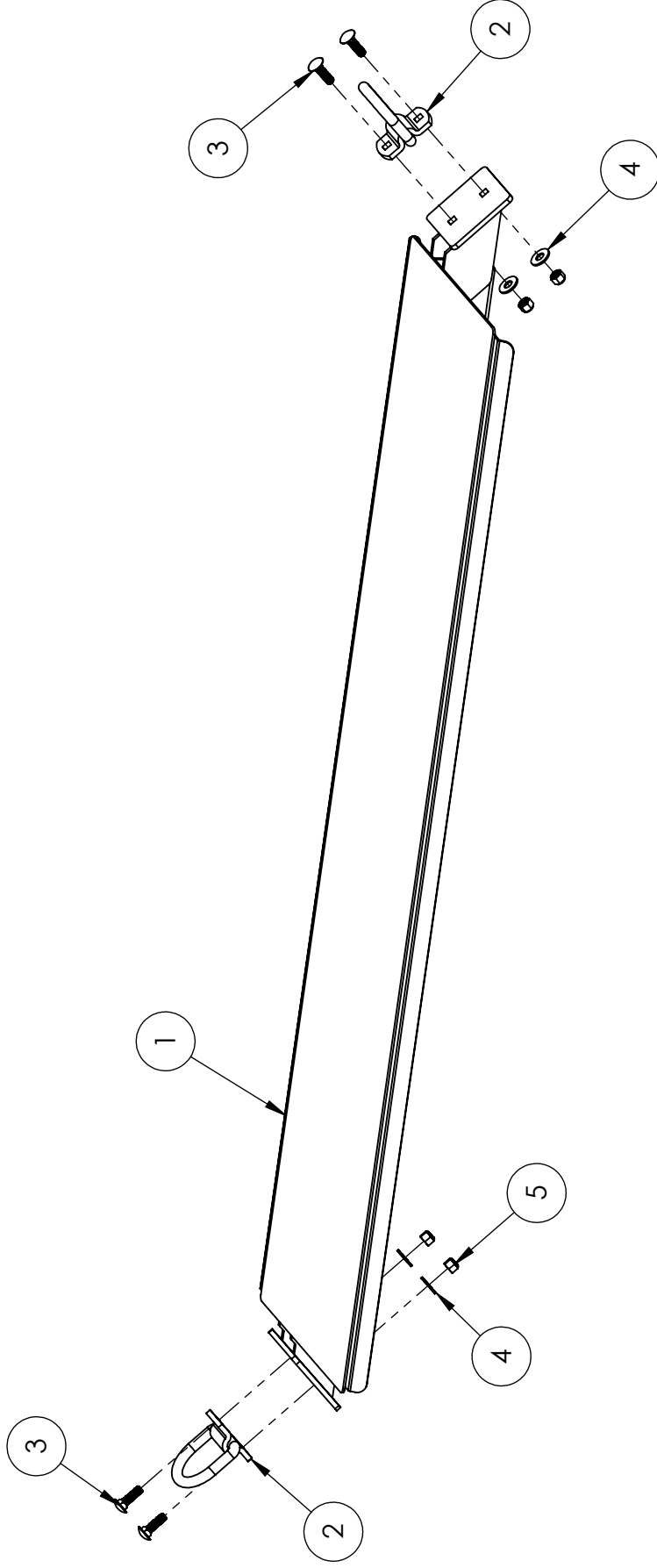
Anchoring Jack Assembly - 2505939



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6070339	Jack Assembly, Outer Cylinder	1
2	6070340	Jack Assembly, Inner Cylinder	1
3	2900239	1/2 FRICTION WASHER-NYLON	1
4	6070373	Jack Assembly Nut	1
5	2900048	1/4-20 x 1.50" HHCS (Grade 5)	1
6	2900010	1/4-20 Nylon-Insert Hex Locknut	1
7	6070338	3/4-6 ACME ROD, R.H.	1
8	2903018	USS 3/8" Flat Washer	8
9	2900018	Lock Nut, 3/8-16 Nylon	4
10	2900029	3/8-16 x 1.50 HEX HEAD CAP SCREW	2
11	2900596	3/8-16 x 2.50" HHCS (Grade 5)	2

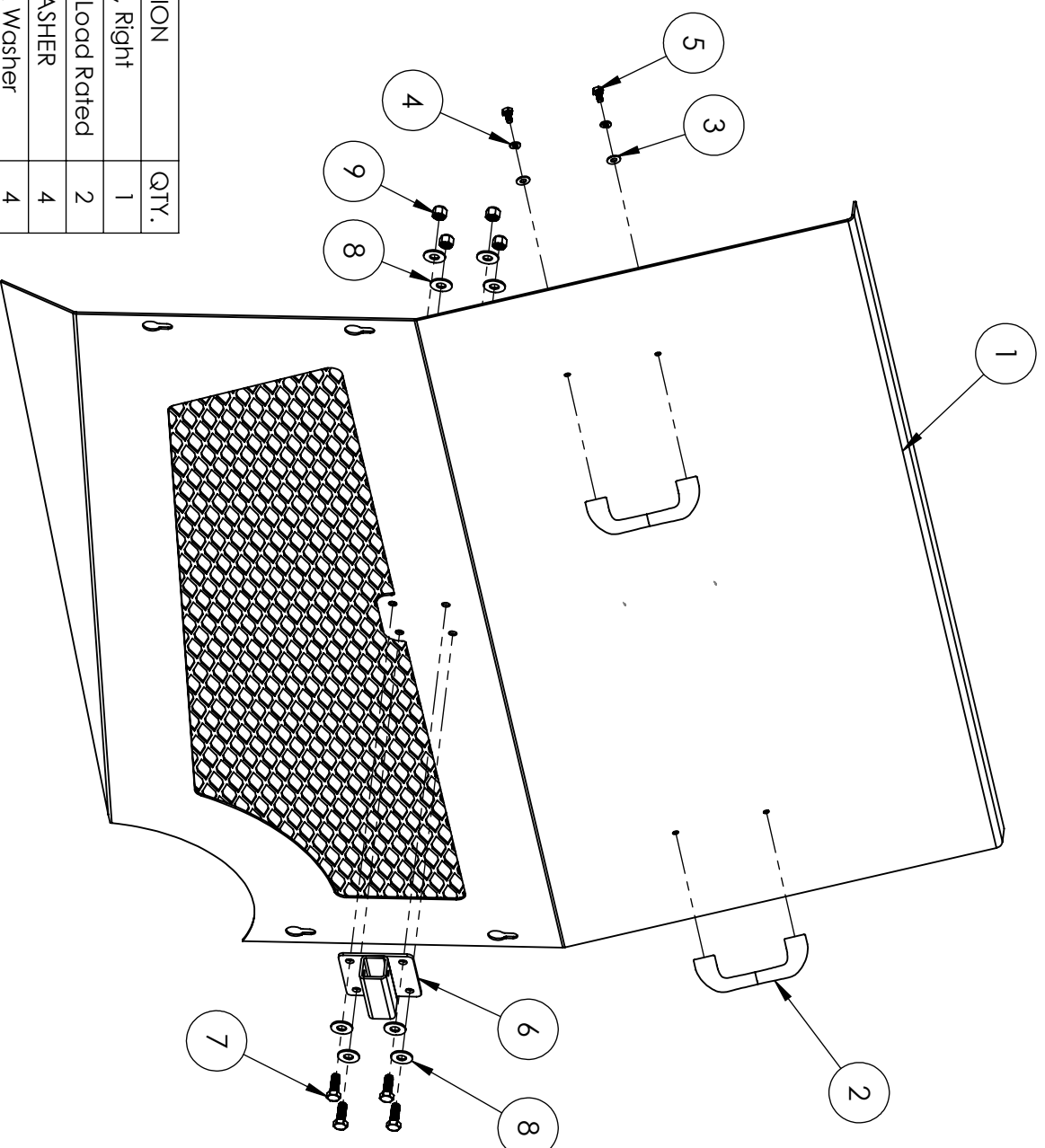
WS30-LE

Top Panel Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6071004	Spreader Beam, Weldment	1
2	2902969	1/25" D Ring	2
3	2903037	3/8-16 x 1.25 Carriage Bolt	4
4	2903018	USS 3/8" Flat Washer	4
5	2900018	3/8-16 Nylon Lock Nut	4

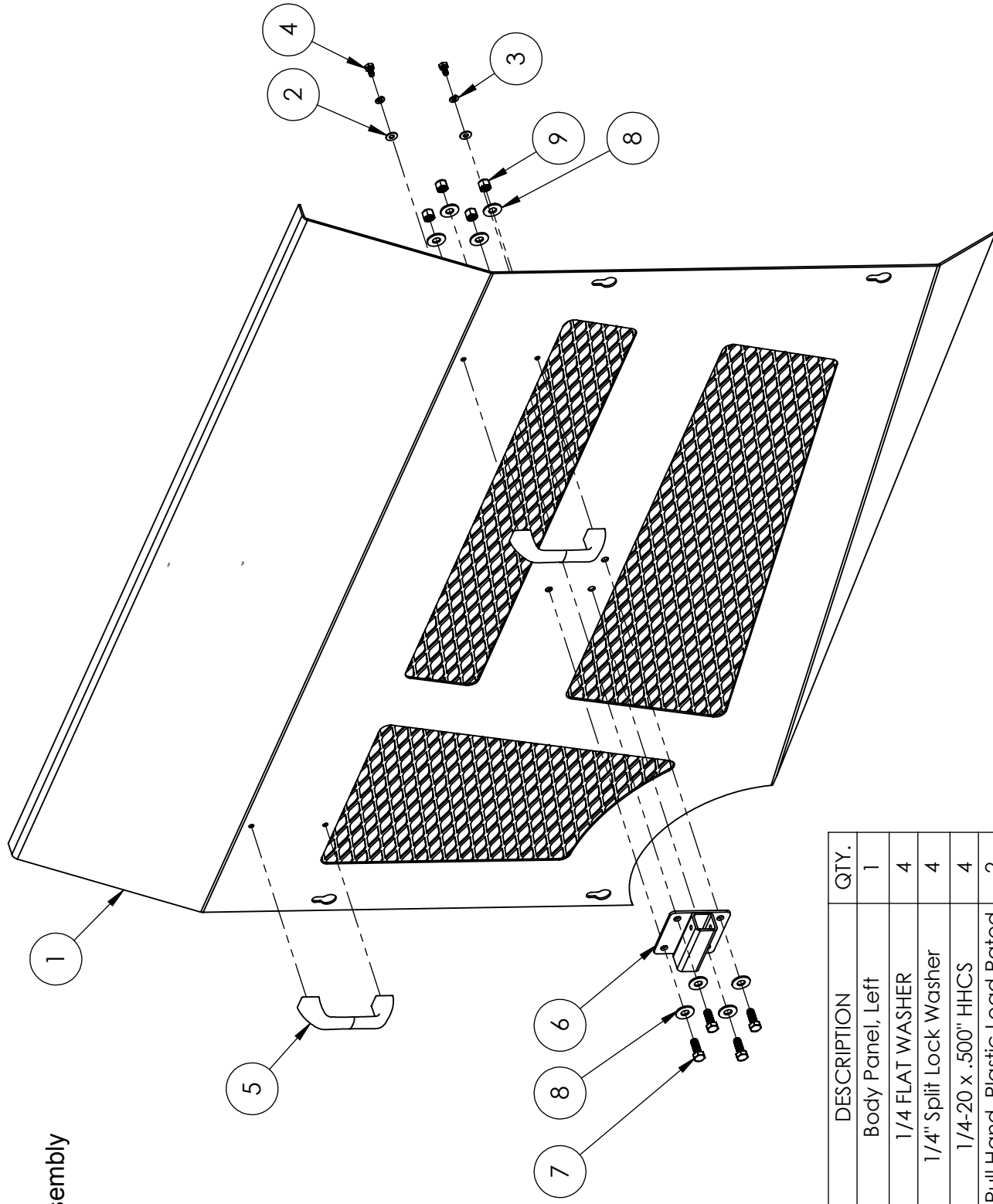
WS30-LE Right Body Panel Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6071016	Body Panel, Right	1
2	2505879	Pull Hand, Plastic Load Rated	2
3	2900126	1/4 FLAT WASHER	4
4	2900024	1/4" Split Lock Washer	4
5	2900082	1/4-20 x .500" HHCS	4
6	6070717	Handle Pocket	1
7	2900005	3/8-16x1.00 HHCS	4
8	2903018	USS 3/8" Flat Washer	8
9	2900018	3/8-16 Nylon Lock Nut	4

WS30-LE

Left Body Panel Assembly



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	6071017	Body Panel, Left	1
2	2900126	1/4 FLAT WASHER	4
3	2900024	1/4" Split Lock Washer	4
4	2900082	1/4-20 x .500" HHCS	4
5	2505879	Pull Hand, Plastic Load Rated	2
6	6070717	Handle Pocket	1
7	2900005	3/8-16x1.00 HHCS	4
8	2903018	USS 3/8" Flat Washer	8
9	2900018	3/8-16 Nylon Lock Nut	4

EQUIPMENT AND PARTS WARRANTY

Diamond Products warrants all equipment manufactured by it against defects in workmanship or materials for a period of one (1) year from the date of shipment to Customer.

The responsibility of Diamond Products under this Warranty is limited to replacement or repair of defective parts at Diamond Products' Elyria, Ohio factory, or at a point designated by it, of such parts as shall appear to us upon inspection at such parts, to have been defective in material or workmanship, with expense for transportation and labor borne by Customer.

In no event shall Diamond Products be liable for consequential or incidental damages arising out of the failure of any Product to operate properly.

Integral units such as engines, electric motors, batteries, transmissions, etc., are excluded from this Warranty and are subject to the prime manufacturer's warranty.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, AND ALL SUCH OTHER WARRANTIES ARE HEREBY DISCLAIMED.



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