

## LS18 INSTRUCTIONS AND PARTS LIST



A rugged, accurate and economical 18" slab saw. Its design has been proven by years of trouble free service in commercial operations. An adjustable rate screw-feed and a large capacity vise allow the LS18 to cut material up to 7" thick. Oil coolant required.

- Durable 18" Blade
- Adjustable Rate Screw-Feed
- Sturdy Welded Steel Frame
- Hinged Hood with Tempered Glass Window

## SETUP

- Check to make sure you have received the following parts:
  - (1) LS18 Saw with Motor and Blade
  - (1) Accessory Package Containing:
    - (4) Leveling Feet with Nuts and Washers
    - (1) Gear Box Oil
    - (1) Blade Dressing Stick
    - (1) Operators Manual and Warranty Card
- Remove the saw from its packing and check for damage. Immediately contact the shipping agent if damage is discovered.
- Place the saw on a sturdy, flat, level surface.

**IMPORTANT**  
Read the following instructions before assembly or use. Failure to follow instructions can result in damage to the machine or injury to the operator.

## LEVELING SAW

- Install leveling bolts in each saw leg.
- Adjust bolts in or out as necessary until saw is level.

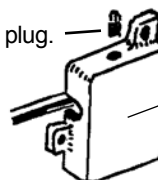


Install leveling bolts in each saw leg.  
Adjust as necessary.

## FILLING GEAR BOX

- Remove top plug on gear box.
- Add entire contents of oil container to gear box.
- Replace plug on gear box.

Remove plug.



Add Oil to Gear Box.

## ELECTRICAL CONNECTION

- Make sure all Switches on the Control Box are in the OFF position and the hood is closed.
- Plug the Saw Power Cord into a grounded outlet

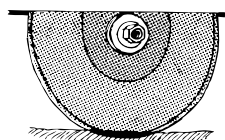
## COOLANT

We recommend LORTONE Cutting Oil #086-010 for optimal results.

- Use a neutral petroleum base oil with a high flash point and no additives.
- Add approximately 3 gallons of coolant until the bottom 1/2"-3/4" of the blade is covered.

## BLADE CARE & DRESSING

- YOU MUST DRESS THE BLADE PRIOR TO INITIAL USE.
- Clamp a Blade Dressing Stick in the vise. With the hood closed and the saw running, make several cuts through the stick. Repeat as needed.
- Dress the blade frequently. Dull or glazed blades will quickly dish or warp.  
*Note:* Dished or warped blades are not covered under warranty.



Coolant 1/2"-3/4" on Blade

## CAUTION

**DO NOT** run saw without proper coolant.  
**DO NOT** use Kerosene or other flammable solvents.  
**DO NOT** use water or water soluble oils.  
Failure to follow these instructions can result in damage to machine or serious injury to operator.  
Use of these coolants will void the warranty.

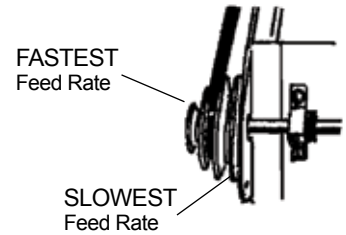
## OPERATION

### Setting Feed Rate:

Select the feed rate appropriate for the material, coolant and blade.  
Select slow feed rate for hard materials or thick cross sections.

**CAUTION:** Too fast a feed rate can result in damage to the blade or saw and is not covered under warranty.

- SLOWEST feed rate - Move the feed belt to the LARGEST pulley.
- MEDIUM feed rate - Move the feed belt to the MIDDLE pulley.
- FASTEST feed rate - Move the feed belt to the SMALLEST pulley.



### Clamping Material:

- Make sure the switch on Control Box is in the "OFF" position (toward saw) before opening the hood.
- Clamp material securely in vise. Check for looseness of material and re-tighten if necessary.
- Adjust cross feed and hand tighten the carriage lock screw. Check to be sure that material will clear the arbor shaft cover and the blade flanges.
- To release carriage, pull half nut lever toward control box. Slide the carriage to desired position and release the half nut lever. Make sure the lever is fully engaged.
- Adjust shutoff chain for desired length of cut.

### To Start Saw:

**Note:** The feed is engaged anytime the saw is running.

- Close hood and turn switch to "ON" position.

### IMPORTANT- DO NOT LEAVE SAW UNATTENDED

- Listen for changes in operating noise. Sudden changes can indicate damaged material or blade.
- Over-heating of the drive motor can result in tripping of the safety overload protector. To prevent blade & saw damage, IMMEDIATELY turn off the "Power" switch. Inspect the machine and blade for damage and correct any problems before continuing. When cool, press the red reset button on the drive motor to reset the protector.

### At End of Cut:

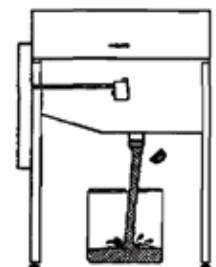
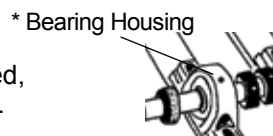
- Push power switch toward saw to "OFF" position before opening the hood.
- Remove the cut slab. Inspect the remaining material to make sure it is secure in the vise.
- Loosen carriage lock screw and advance the carriage by turning the cross-feed wheel. Each turn advances the cross-feed carriage approximately 1/16 inch (.062).

### CAUTION

Do not operate saw with hood open.  
Turn off power switch and unplug saw prior to opening hood.  
Failure to follow these instructions can result in serious injury.

## CLEANING & MAINTENANCE

- The saw should be cleaned periodically when sediment builds up to a depth of 1/4".
- Remove the drain cap from the saw case and drain the oil.
- Wipe sludge from the case and power feed screw.
- Replace the drain cap and add clean or filtered oil.
- Bearings come pre-greased from factory. If saw is heavily used, bearings can be greased through hole in the bearing housing\*.



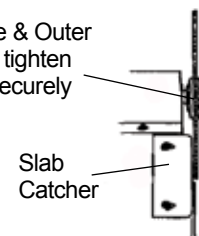
Drain used Oil & dispose of properly.

## BLADE REPLACEMENT

NOTE: This saw requires and 18" blade with a 3/4" arbor hole.

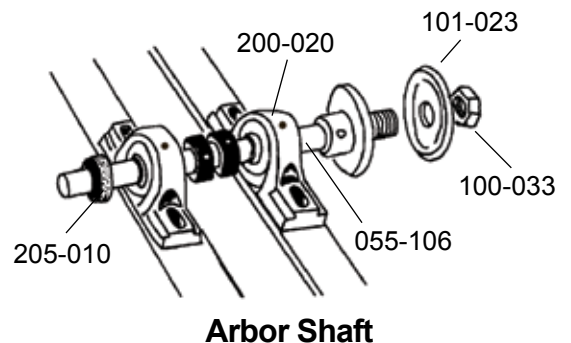
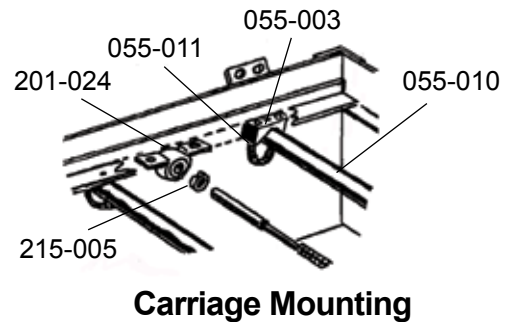
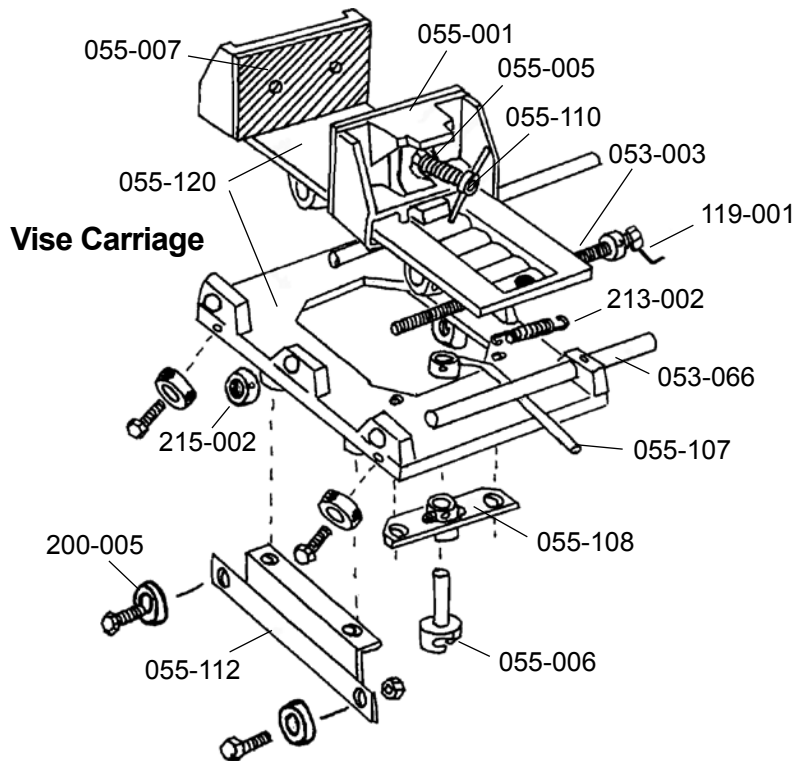
- Remove the arbor nut, outer blade flange, and blade.
- Clean the flanges.
- Install the new blade carefully.
- Replace the outer flange and arbor nut and tighten securely. Do Not Overtighten!
- Adjust slab catcher to clear blade by 1/8".

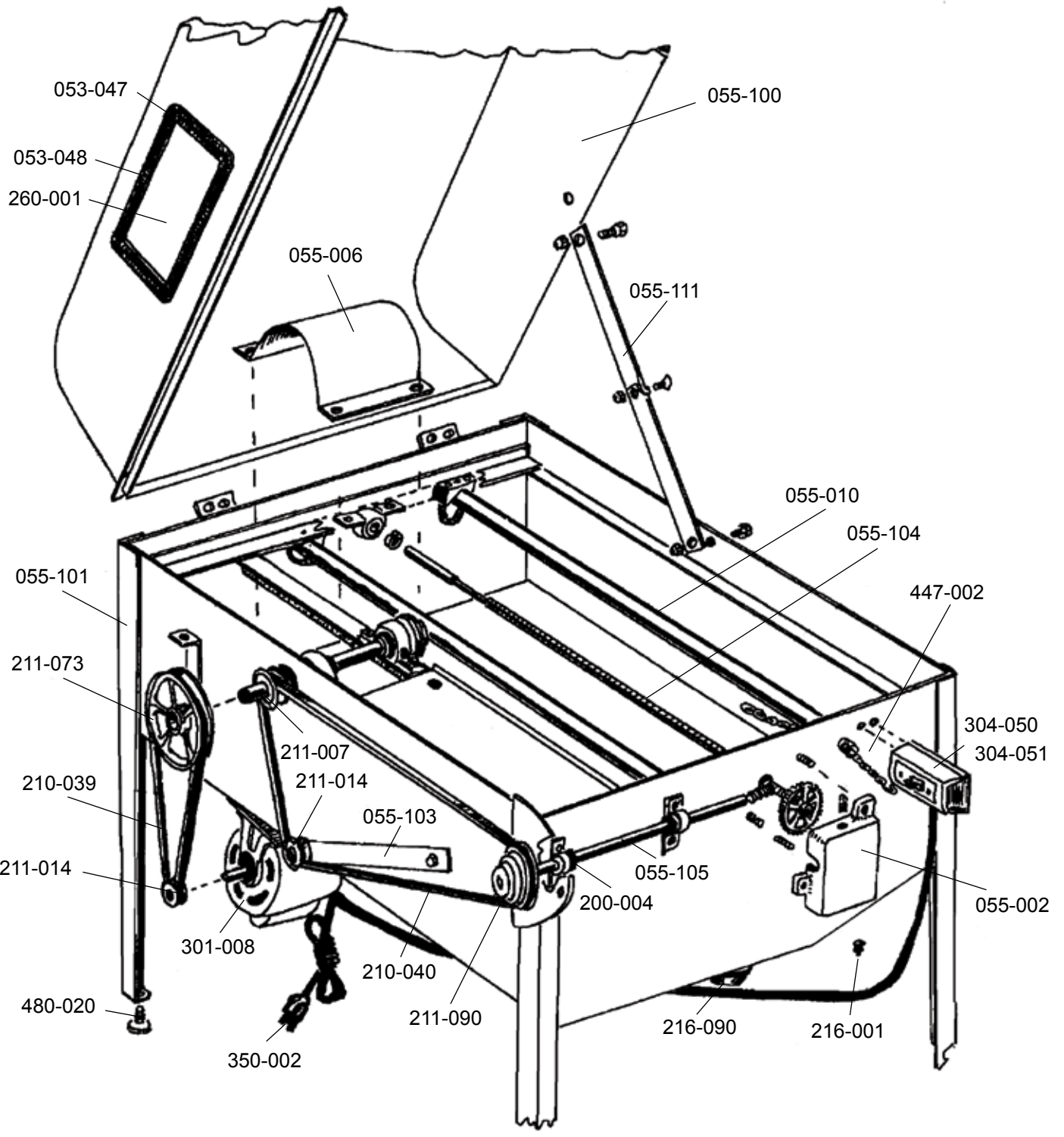
Install Blade & Outer Flange and tighten Arbor Nut securely



## Model LS18 Parts List

Item	Description	Item	Description
119-001	Crank, Cross Feed	200-005	Carriage Bearing
053-003	Cross Feed Bolt	200-020	Arbor Bearing including Housing
053-006	Shaft, Cross Feed	200-006	Bearing (only)
053-047	Window Key Rubber	201-024	Feed Rod Bearing
053-048	Window Rubber Seal	202-004	Idler Arm Bushing
055-001	Vise Follower	205-010	Felt Washer
055-002	Gear Box	210-039	Belt (4L440)
055-003	V-Block	210-040	Belt (4L560)
055-004	Carriage Bearing Angle Bolt	211-007	Pulley (2" x 3/4")
055-005	Vise Push Bar	211-014	Pulley (2 1/2" x 5/8")
055-006	Half Nut	211-073	Pulley (7" x 3/4")
055-007	Vise Pad	211-090	3-Step Pulley (3 Step x 1/2")
055-010	Carriage Way	213-002	Spring
055-011	U-Bolt	215-002	Carriage Collar
055-100	Hood Assembly	215-005	Set Collar
055-102	Belt Guard Assembly	216-001	Brass Pipe Plug
055-103	Idler Arm Assembly	216-090	Pipe Cap
055-104	Feed Rod Assembly	260-001	Safety Glass
055-106	Arbor Shaft Assembly	290-002	Hood Handle (not shown)
055-107	Halfnut Handle Assembly	301-008	1/2 HP Motor
055-108	Half-nut Mounting Bracket	304-050	Toggle Switch
055-110	Push Bar Bolt Assembly	304-051	Heater Element for Switch
055-111	Hood Support Assembly	350-002	Cord Set
055-112	Carriage Bearing Strap Assy.	447-001	Shutoff Chain (21" Long)
055-120	Vise Frame & Carriage	480-020	Elevator Bolt
101-023	Plated Flange	481-058	Hex Nut 3/4-16
200-004	Jack Shaft Bearing	566-012	Blade Dressing Stick





# **CAUTION !!**

**Failure to follow these instructions  
may result in injury to the operator  
and damage to the machine.**

***FOR PROPER OPERATION USE ONLY  
5-10 wt. PETROLEUM OIL,  
NON-DETERGENT TYPE,  
WITH A HIGH FLASH POINT***

**DO NOT USE water, water-soluble oil,  
solvents, fuels, anti-freeze or vegetable oil.**

**Use of these or other materials will result in  
substandard performance and damage to  
the machine is not covered under warranty.**

**We suggest LORTONE Cutting Oil  
#086-010**

# **CAUTION !!**