

## Short manual for Pentrunder HF-wall saws

It is essential that all personnel working with, or in close proximity to, the saw have read and understood the contents of the operator's manual before commencing operations.



**This short manual does not replace the operator's manual.**

### 1 Mounting track feet and track

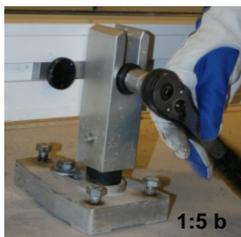
- 1:1 Drill expander hole and fit expander in the concrete
- 1:2 Place both track feet over expander holes and put in the bolts. Don't tighten.
- 1:3 Position track feet no. 1 relative to where the cut should be (217 +/- 25 mm) and put it in a straight angle. Tighten the bolt in the expander.



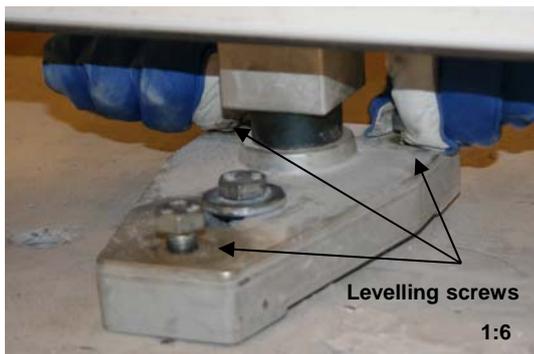
- 1:4 When the fork is completely turned in, turn the fork about 5 times counter-clockwise, to make sure the saw arm doesn't touch the concrete at the last cut if the concrete is uneven.



- 1:5 a) Slide in the t-slot piece in the t-slots .
- b) Fasten the clamp screw on track foot no. 1.



- 1:6 a) Adjust the levelling screws on track foot no. 2, so that the track isn't warped due to unevenness of the concrete.



- 1:6 b) Wrongly mounted track foot.
- c) The track should be tight against the track fork.



- 1:7 Tighten the bolt in the expander (1:3) and then fasten the clamp screw on track foot no. 2 (1:5b).

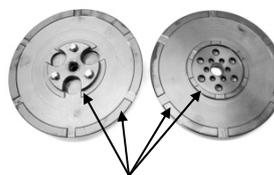
### 2 Mounting the saw head on the track

- 2:1 Press the locking pins and fold out the handles to "open" the eccentric rollers.
- 2:2 Fold the saw onto the track, the lower "eccentric" rollers engaged first. Move the saw head slightly along the track to engage the travel gear with the rack, then fold the saw completely on to the track, press the locking pins and turn the handles until the locking buttons pops up again.

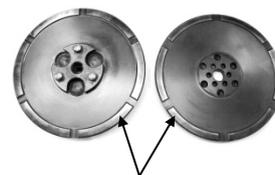


### 3 Mounting the blade on the saw head

- 3:1 Make sure the blade and blade flange are clean. Fit the blade on the inner flange and clamp it by the outer collar with the special centre bolt. The centre screw should be tightened to 60-70 Nm for the version with two friction surfaces and 40 Nm for the version with one friction surface. see picture below for difference.



Two friction surfaces:  
Tighten with torque wrench to **60-70 Nm**  
Must be kept clean and dry!

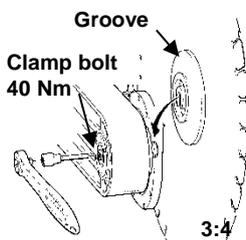


One friction surface:  
Tighten with torque wrench to **40 Nm**  
Must be kept clean!

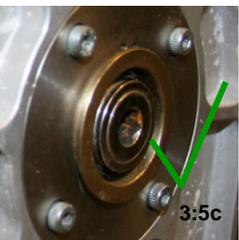
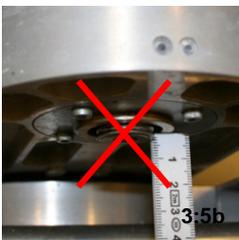
- 3:2 Make sure the quick disconnect coupling for the blade is clean.
- 3:3 Make sure the blade flange is clean. Remove all dirt!



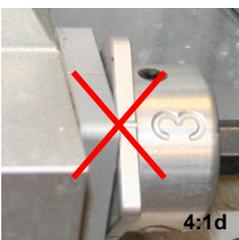
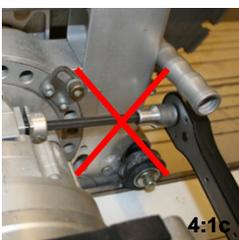
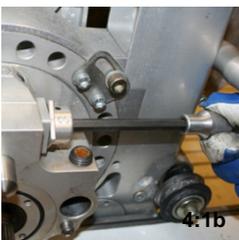
- 3:4 With the groove upwards, mount the blade flange on the saw head spindle.
- 3:5 a) Turn the blade a little until the dogs on the blade flange and saw head spindle are in mesh, "click". Use a ½" torque wrench to tighten the clamp bolt on the rear side of the spindle.  
**Tighten to 40 Nm.** Do not over tighten the coupling clamp screw!



- 3:6 b) If the dogs are not in mesh the screw will stick out from the coupling when tightened.
- c) The screw should be flush with the bronze water seal bushing when the coupling is tightened.



- 4 Choose the correct gear (if applicable)
- 4:1 a) To shift gear, push in the gear shift knob, turn the blade slightly while turning the knob to position. Use hand only.
- b) An 8 mm key can also be used.
- c) Don't use a ratchet to change gears as the "feeling" is lost.
- d) Do not leave the gear shift knob between positions.



- 5 Put on the blade guard
- Make sure you have the right guard guide for the saw head and the blade guard.



OR



- 43210601 Frame blade guards holder for all saw heads except Pentruder 6-8HF and 6-12Lean
- 43220101 Parallel guard guide 8-20
- 43220201 Parallel guard guide 6-12
- 43220301 Parallel guard guide CBK

- 6 Fit the HF-motor
- 6:1 Align the splined drive shaft and clamp studs with the holes in the saw head, rotate the saw blade very slowly by hand until the spline fits and motor seats properly. Then tighten the clamp screws using the 8 mm Allen T-key.



- 7 Connecting to water supply
- 7:1 a) The water supply should be minimum of 4 litres (1 gallon) of cool water per minute at full power output. The water pressure should be at least 1 bar (45 PSI) and maximum 5 bar (70 PSI).
- b) In sub zero temperatures the remaining water inside the power pack cooling circuit must be blown out with compressed air or an air pump.
- c) Check at regular intervals if the water filter needs to be cleaned.



Clean water filter.

Blow out water here.

## 8 Starting the power pack

- 8:1 Make sure all connectors are clean and dry. Do not lubricate the pins and sockets since that will attract more dirt compared to a clean and dry one.
- 8:2 a) Connect all cords, big diameter orange colour cord to HF-motor, small diameter orange colour cord to feed and travel motors, grey remote control cord to the power pack and lastly a 380 – 480V 3-phase cord to the power supply.

(When the power pack is connected to the power supply the LED's will light up in a sequence. This is used by your dealer in case trouble shooting is needed.)

b) Then press the green push button on the power pack. A green light in the button should light up.

## 9 Starting the blade

- 9:1 Make sure the emergency stop button on the remote control is out and green start button is on.
- 9:2 Turn the potentiometers to zero and put the switches and joystick in neutral.



- 9:3 a) Push the blue switch (water ON/OFF) forwards and keep it pressed.
- b) Push the red switch (blade ON/OFF) forward and then let go of both switches. Now the blade should start.



## 10 Starting to cut

- 10:1 a) Turn the left potentiometer (blade speed control) to desired cutting speed (**70-100% depending on size of blade**. See chart in Operator's manual).
- b) Turn the right potentiometer (feed and power regulation) to 100%.
- c) Move the joystick down or up to rotate the saw arm and start cutting.
- d) When the desired depth of cutting is reached, move the joystick to the side to move the saw head along the track.

Potentiometer for blade speed control

Potentiometer for feed and power regulation



## Every day maintenance



### 11 Check the water seal

If water comes out of the holes, see picture 11:1 below, while the water is switched on, this is an indication that the seals must be replaced.

Please contact your dealer for service.

The swivel should be checked every day.

If the seals are not replaced in time, water may enter the saw arm transmission and gearbox, which may cause the transmission to seize or cause irreparable damages.

Please contact your dealer for service.



**Check for water leakage every day!**

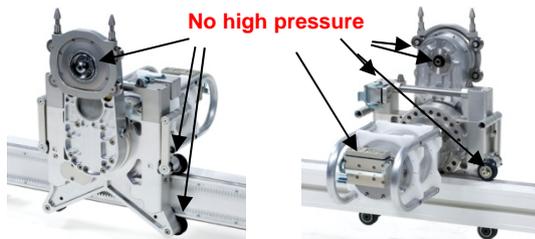
### 12 Clean the equipment and check all functions

The machine should be carefully cleaned and all functions checked and found normal before use of the machine.

If a high pressure cleaner is used, the nozzle may NOT be pointed at rotating parts on the machine.

Tractive recommends using covers on the electrical connectors.

Avoid pointing at seals and electrical connectors.



### 13 Grease and lubricate

a) Lubricate the threads on the center screw and the inner thread on the blade flange.

b) If necessary, grease the eccentric locking mechanism for the handles.

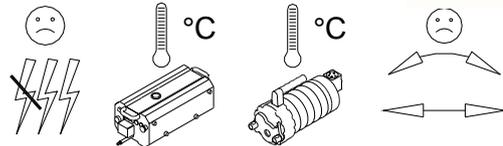
c) Check the condition of the gearbox oil (arm transmission) every week. Clean thoroughly around the plug and blow with compressed air before the plug is removed. If dirt is allowed to enter, the gearbox may seize and the warranty is not valid.

If the oil is grey it needs to be replaced. Please contact your dealer for service.

## Short trouble shooting

### A The power pack or HF-motor doesn't start / The feed and/or travel doesn't work

A:1 Check the LED's on the power pack and consult the operator's manual.



A:2 Check that the fuse is ok.

A:3 Check that the incoming voltage is not too high or low. Should be 380-480V 50-60Hz.

A:4 Check that cables and connectors are not damaged.

A:5 Reset the power pack. Disconnect the power supply and wait 1 minute, re-connect power supply. Then press the green start button to start the power pack again.

### B The saw doesn't cut straight

B:1 The track feet are not correctly mounted. See 1:6 a-c.

B:2 a) The track guide rollers are not correctly adjusted. Use a 6 mm key from one side and a ratchet from the other side to adjust the eccentric roller until it is tight. b) Now there should be a little resistance when turning the handles to lock the saw on the track.



B:3 There is too much play in the spindle bearing. The spindle bearings always has a little play, but too much play means the saw has to be sent for service to have the bearing replaced.

B:4 The saw blade is damaged and/or badly balanced. Check that it is straight. See picture below. It is important that the blade is held upright when checking that it is straight.

