

Technical Service Bulletin 04T11  
 515 Saddle Alignment

Refer to: Service Parts Guide, Model 515C Diamond Gantry Saw booklet, Carriage Assembly diagram, page 1, and photos below.

1. Check/Adjust Saddle Alignment

- a. Check clearance of two Top Rollers (Item #2 in Parts Guide) to Saddle (#7) on blade-side. It should be about  $\frac{1}{4}$ " , but it is more important for the clearance to be equal than exactly  $\frac{1}{4}$ ". If necessary, loosen the setscrews and adjust. Suggestion: Use  $\frac{1}{4}$ " key stock (square steel bar) as a gauge tool. Rollers have two holes for setscrews and each hole might contain either a back up setscrew or threadlocker compound to help keep setscrews tight. Threadlocker might require heat (heat gun or propane torch) to break the grip of the compound.
  - b. Loosen setscrews of other two Top Rollers opposite to the blade. Pry between the front and back (hidden) rollers and the inside of saddle so as to draw all four roller flanges into firm contact with tapered edges of Saw Rail.
2. Adjust bottom Guide Rollers to make snug contact with bottom of Saw Rail.
  3. Rock Saddle left-right and up-down to confirm snugness on rail in all directions. Move Carriage Assembly along Saw Rail to confirm free movement end to end.

