

# Highland Park Lapidary Co.

Model HT14 Slab Saw

Operator's Manual



**Caution:** Read all safety and operating instructions before using this Equipment.

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# Table of Contents

<b>HT14 Slab Saw Overview .....</b>	<b>1</b>
<b>HT14 Slab Saw Specifications .....</b>	<b>1 - 2</b>
<b>What to do when HT14 Slab Saw arrives .....</b>	<b>2</b>
<b>Motor Installation .....</b>	<b>3</b>
<b>Belt Guard Installation .....</b>	<b>3</b>
<b>Secure Mounting of the HT14 Slab Saw .....</b>	<b>4</b>
<b>Coolant Required for Proper Operation .....</b>	<b>4 - 6</b>
<b>Diamond Blade Operation and Maintenance .....</b>	<b>6</b>
<b>Blade Removal and Replacement .....</b>	<b>7</b>
<b>Operation of the HT14 .....</b>	<b>7 -10</b>
<b>Warranty .....</b>	<b>11</b>
<b>Part and Support Contacts .....</b>	<b>12</b>

# HT14 SLAB SAW

The Highland Park HT14 Slab saw is a precision lapidary machine that is used to produce slabs of lapidary gemstone material. When properly used it is capable of producing slabs that are very consistent in thickness and surface condition. When used with the proper blade and cutting fluid your saw will produce uniformly flat smooth cut.

Today, with higher prices of fine lapidary material it is especially important that all cuts be uniform and high quality. One advantage of a 14" slab saw over a much larger machine is that the width of the blade is much less. This means that less of your material will be lost due to the width of the blade.

This Owner's Manual will give you all the instructions required to begin using your new slab saw safely and efficiently to professionally cut any smaller lapidary rough material.

## Features and Specifications

<b>WORKPIECE SIZE</b>	5-1/2 x 7 inch Cross Section
<b>ARBOR SHAFT</b>	Tool steel machined to 3/4 inch bearing diameter. 5/8 inch diameter for blade arbor
<b>BLADE FLANGES</b>	Steel 3 inch outside diameter
<b>BLADE</b>	Greenline Agate Eater sintered diamond blade
<b>SAFE START SYSTEM</b>	Contactors interlock control system reduces the risk of accidental startup
<b>AUTOMATIC CUT-OFF SWITCH</b>	The trip chain can be adjusted for different lengths of cut and will shut off the saw
<b>POWERFEED</b>	Approximate workpiece infeed rates 11-1/4 inches per hour, 3/16 inches per minute
<b>SPLIT NUT DRIVE</b>	Engages carriage with powerfeed screw. Released by a flip of the handle for quick carriage return
<b>PRECISION CARRIAGE</b>	Carriage rides on precision-ground hardened 3/4" steel rails retained by adjustable
<b>CROSSFEED WAYS</b>	1/2 inch precision ground steel
<b>SAW BOX</b>	Welded 16 gauge steel. Inside dimensions 20 inches wide x 11-3/4 inches deep x 25-1/2 inches long. Overall height with the hood closed – 20-1/4 inches
<b>WISE</b>	<ul style="list-style-type: none"><li>• Steel vise jaws</li><li>• Maximum workable jaw opening 5-1/2 x 7 inches</li><li>• Lateral travel of vise assembly 4-1/4 inches</li></ul>
<b>V-BELT</b>	Connects motor to saw blade
<b>MOTOR</b>	110 volt NEMA 56 frame 1/2 Horsepower motor with thermal protection and start capacitor and run capacitors (220/230 volt 50/60 Hz available)
<b>WEIGHT</b>	145 lbs

## Common Slab Thicknesses (With Greenline Blade)

SLAB THICKNESS	14" SAW
1/2 inch	14 turns of crossfeed handle
3/8 inch	11 turns of crossfeed handle
1/4 inch	8 turns of crossfeed handle
3/16 inch	6.5 turns of crossfeed handle
1/8 inch	5 turns of crossfeed handle

## WHEN YOUR NEW HT14 SLAB SAW ARRIVES

Your new slab saw will arrive assembled, however the motor ships separately and will be installed once you set up your machine.

**IMPORTANT NOTE: Lapidary saws MUST have coolant added prior to operation. Your saw is not shipped with cutting oil installed in the saw box. You must add this according to these instructions prior to operation.**

Prior to operation please do a quick check to confirm all the necessary items are included. This will also serve to begin to familiarize you with the various operating parts of the saw:

- Check for any shipping damage to the shipping box or saw itself. If none is found proceed with verification checks. If physical damage is found to the saw please contact us immediately and note it if signing for the receipt of shipment.
- Visually inspect your saw for any loose fasteners or damage. Your saw was carefully assembled and quality checked prior to shipment, however, during shipment and handling sometimes rough treatment can cause loosening of fastener. It is a good practice to visually inspect your machine as you are using it periodically to notice any potential issues.
- Please read this operating manual thoroughly prior to operation of the saw. It is very important that you understand the operation of your new saw, safeguards, and proper operation before proceeding to actual use of the machine. Failure to read and understand the operating instructions could result in unsafe operation and damage to the machine and may result in voiding
- Your new saw arrives assembled, but you will need to install the motor and blade as you set it up on your workbench.
- After unpacking the saw, you will need to connect the motor power cord to the right side of the switch box. With the saw unplugged, insert the motor power cord plug into the outlet on the right side of the switch box which is mounted on the front of the saw.

## MOTOR INSTALLATION

This saw has a 1/2 HP, 1750 RPM motor with a size NEMA 56 frame.

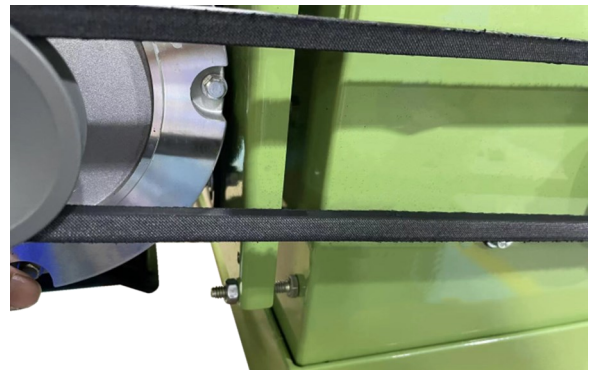
1. Unbox the motor and then remove the two screws on the back of the saw motor mount bracket
2. Place each end of the belt over the arbor pulley and the arbor pulley, then align the top edge of the motor plate to the motor mount bracket and put the screws thru the slots on the motor plate back into the motor mount bracket.



3. Use a straight edge to align the pulleys by sliding the motor to the left or right and then tighten the two screws into the motor mount bracket.



4. Adjust the two belt tension bolts on the lower part of the motor plate to obtain the correct belt tension.
5. Do not overtighten the belt as this can cause unnecessary bearing wear.



## BELT GUARD INSTALLATION

1. Place belt guard over the belt, motor pulley, and frame
2. Install the two mounting screws and tighten securely.



## SECURE MOUNTING OF THE HT14 SLAB SAW

The HT14 slab saw, for safety and proper operation must set on a strong and secure table or workbench. The work surface should be flat and level. A level work top is important so that coolant fluid in the saw box is uniform depth.

The physical strength of the work table or bench is important since the saw weighs approximately 140 pounds without oil or rock included. A powerful 1/2 H.P. motor powers the saw. While the machine is very well balanced for smooth operation, some vibration will be present during operation. For these reasons please be certain that the mounting surface is strong enough to support your machine.

## COOLANT REQUIRED FOR PROPER OPERATION

A low viscosity (5 to 7cst) mineral oil cutting fluid is required to properly cut any stone on your automatic feed slabbing saw.

Your HT14 Slab Saw does not include oil. It's a good idea to order 5 gallons of oil with your saw initially.

We recommend Highland Park HPCool Cut™ which is a high-performance odorless, high purity mineral oil cutting fluid. Developed originally for our own commercial production cutting operation, HPCool Cut™ reduces cutting force and runs cooler for precise cutting performance with longer machine and blade life. Ideal for glass and stone cutting and grinding, this oil is also non-toxic. Food grade or veterinary grade mineral oils are generally not idea for lapidary use because they have a much thicker viscosity of about 15 to 18cst which will cause higher motor load and increase cutting force because the thicker oil does not flush the cut as well.



<p><b>Your saw will require approximately 1 1/3 gallons of cutting oil for the initial fill</b></p>	<p>As you operate the saw some oil will be lost in normal operation as some of it will cling to the stones as they are removed from the saw after cutting. For this reason it is important that you periodically check the level of oil on the saw blade to confirm proper oil depth is present.</p>
<p><b>Oil is added by simply pouring it into the saw box. (Make sure that the drain plug is in place before adding oil)</b></p>	<p>You can add one gallon before beginning to check the oil level on the blade. After one gallon has been added continue to add oil while monitoring the level on the blade. Your target is to have the bottom of the blade immersed 1/2" into the oil initially and to <b>MAINTAIN THIS LEVEL</b> during the use of the saw. If you do not have sufficient oil, it can cause the blade and the stone to get overheated and damage one or both. Additionally, it is not good to overfill the saw too much as this can cause oil to leak out onto the floor.</p>





<p><b>You may find it helpful to carefully turn the blade a bit by hand to confirm the oil level</b></p>	<p>Even with the Highland Park <b>SAFE START SYSTEM</b> (description later in this manual) guarding against accidental start-up of the saw, we recommend that you unplug the unit prior to adding oil or in any way manipulating the blade by hand.</p>
<p><b>Your oil can be reused</b></p>	<p>To reuse your oil it first must be removed from the saw box. To do this remove the drain cap on the front pan of the machine. Be sure to have a large enough bucket or other container under the plug when it is opened. Allow all oil to drain from the machine. Then use a spatula or putty knife to move sediments from the saw box via the drain. Remove all possible material from the saw box. You may wish to use a small squeegee to get all material. Also wipe down interior parts of the saw such as vise and carriage that may have a coating of sediment.</p>
<p><b>Your oil in the saw should be changed periodically to insure proper lubrication</b></p>	<p>More frequent oil changes will result in longer blade life, cooler cutting, less need for blade dressing, and less messiness in operation of the saw. Oil should be changed when it is significantly discolored and has begun to get a thicker consistency. Oil should never be allowed to have the consistency of pudding.</p>
<p><b>Used HPCut™ oil may be set aside so that solids can settle out with clear oil on the top</b></p>	<p>Putting the oil in a 5 gallon pail is good for allowing the sediment to settle out. After several days of settling the clear oil can be poured off back into the saw. Be sure to add additional new or settled oil to insure proper oil level on the blade. If this method is used you may want to consider having twice the amount of oil needed for operation on hand at all times....half in the saw and half on standby for when the oil is changed.</p> <p>Used HPCut™ oil may be set aside so that solids can settle out with clear oil on the top. Return of the oil to original one gallon shipping jugs works well for this. After several days of settling the clear oil can be poured off back into the saw. Be sure to add additional new or settled oil to insure proper oil level on the blade.</p> <p>Keep in mind that eventually some oil will have to be discarded that cannot be separated from sediments produced by rock cutting. This will require making up the lost quantity of oil so having extra on hand is a good practice so that your cutting will not be interrupted.</p> <p>You may also filter the oil instead of allowing it to settle. Various materials can be used as filters including paper grocery bags or even large coffee filters. Filtering is usually faster than allowing sediments in the oil to settle. However, it can also be more messy.</p>
<p><b>When oil/sediment can no longer be settled or filtered to produce usable clean oil it must be discarded.</b></p>	<p>The oil can be discarded according to state guidelines for disposal of mineral oil.</p>



## SAFETY WARNING!

*You must use only HPCut™ saw coolant or equivalent mineral oil from another source. Never use kerosene or any other flammable petroleum based coolant such as diesel fuel or home heating oil. Using such liquids can result in fire, skin irritation, or other health problems. Highland Park Lapidary is not responsible for adverse consequences that may arise as a result of using unapproved materials as saw coolant.*

*Additionally, do not use Automotive Antifreeze, CNC machining fluids or Automatic Transmission fluid as coolant in your saw. These liquids are not suitable for lapidary work and may cause damage to your machine.*

*When using any mineral oil coolant, you should avoid breathing the fine oil mist present when the saw is opened after a cut is completed.*

*You must not use water as coolant for this saw even with additives. Water does not provide sufficient lubrication of the blade as it cuts. Use of water also does not provide adequate lubrication for carriage movement or the feed mechanism. Use of water may cause excessive heat and damage to blade and/or material and will also result in rusting of key components regardless of claims of the additives. The warranty on this saw will be voided if water or water soluble oils are used as a cutting coolant.*

## DIAMOND BLADE OPERATION AND MAINTENANCE

Periodically you should sharpen your blade. When cutting hard materials sometimes the diamonds on the edge of the blade will get rounded over and polished. Sharpening the blade with our recommended technique will revitalize the cutting edge of the blade without diminishing blade life. A periodic schedule of blade sharpening will insure that you do not have adverse performance or damage to your blade during operation.

We recommend that you sharpen your blade every **ten to twenty hours** of actual cutting time depending upon sizes of rocks being cut and their hardness. Larger rocks that present more contact area to the blade will result in needing more frequent blade sharpening. Harder rocks also result in the necessity to sharpen the blade more frequently than softer stones.

Performance also can give you indications of the need to sharpen the blade. The cutting efficiency of blades that need to be sharpened will diminish. This often results in the saw sounding different when cutting: indication may be slowing of the blade rpm, lapping of the saw, or unusual or changed sound from the saw. Failure to sharpen the blade may result in failure to cut or that the stone may be dislodged from the vise. This can also cause dishing or warpage of the blade, damage to the feed mechanism, or other outcomes that can damage the machine.

To sharpen your blade, see our video on YouTube for our method of sharpening: <https://www.youtube.com/watch?v=yaZUVBxVWdA>



# BLADE REMOVAL AND REPLACEMENT



## SAFETY WARNING!

*Be sure to unplug machine prior to removing and replacing blade.*

Eventually even properly used diamond blades will wear out and need to be replaced. Replacing a worn out or damaged blade is accomplished by removal of the saw arbor nut. This nut is a right and thread and loosens by turning it counterclockwise looking at the shaft from the right hand side. Be sure to use a good wrench that will provide secure contact with the nut, this will prevent damage to the arbor nut.

The blade may be held by hand as the arbor nut is loosened. You must be careful to not put side force on the blade, only holding it to prevent rotation. If this method does not allow removal of the arbor nut then remove the arbor belt guard. Once the belt guard is removed you can hold the belt or arbor pulley as you apply force to the arbor nut. Do not get any saw oil on either the arbor belt or pulley.

When you replace the blade make certain that the blade surfaces that will contact the flanges are clean and that the flanges are clean and undamaged as you install the blade. Put the blade bushing into the blade, laying it on a flat surface and tapping the bushing into place with a rubber mallet then carefully put the blade onto the arbor. If you have trouble keeping the bushing in the blade, then you can put the bushing onto the arbor shaft and then carefully position the blade onto the arbor shaft aligning it with the bushing. Put the outer flange onto the arbor shaft next and then reinstall the arbor nut making certain that the threads are clean and oiled on the shaft and inside the nut. Any clean new oil will suffice for this and insure ease of removal of the nut in the future. When the nut is up against the flange, then rotate the snug it lightly at first and rotate the arbor shaft to be sure that the blade is seated with the bushing in the center before fully tightening the arbor nut. When you are sure that the blade is seated properly, then you can tighten the arbor nut. You can hold the blade to tighten the arbor nut, however if the nut does not fully tighten, then you will need to hold the pulley or shaft to insure that the arbor nut is properly tightened.

# OPERATION OF THE HT14

## Checklist prior to saw operation:

- Be certain the saw is secure on work table or bench.
- Install motor belt and belt guard
- Install diamond blade.
- Confirm proper oil level in the saw box.
- Close hood.
- Confirm power switch in off position.
- Plug in electrical cable.



## Now you are ready to clamp and cut your first rock on your new HT14 slab saw by following these steps:

1. **Open the hood.**
2. **Disengage the carriage feed lever from the carriage drive screw.** This lever is near the back right corner of the carriage, it is pulled forward to disengage the carriage feed allowing the carriage to be moved manually. It must be held forward to move the carriage, but only pull the lever far enough to disengage the feed nut, pulling it forward more than necessary will only begin to stretch the feed engagement spring. Now you can pull the carriage forward to the front of the saw. This is the proper position of the carriage for loading a new rock to be cut.
3. **Select your rough material to be cut.** Rough Lapidary material varies considerably in size and shape. This results in considerable differences rock to rock in the ease or difficulty of securing the rock in the vise for cutting. Rocks that are difficult to secure in the vise include those with very smooth rounded surfaces. It is helpful to have on hand a variety of wood shims to assist in clamping rocks in any slab saw vise. Carpenter's wood shim material works very well for this as it provides "crush" to assist in conforming rocks to the saw vise and providing more contact area between the vise surfaces and the rock. Such shim material should be cut in shorter than supplied lengths for use in shimming rocks for slabbing.  
  
The maximum size rock that can be cut on your HT14 slabs saw is 4.5" X 7". However, when cutting rocks that are near the maximum size you must check for clearance of the rock to insure that as the cut proceeds the rock does not contact the arbor nut or flange.
4. **To cut slabs from your rough material the cross feed of the vise should be moved to the maximum righthand position to the right of the blade by turning the handle counter clockwise.** The handle is on the far right of the carriage/vise assembly. The maximum cross feed on the HT14 is 4.5".

## Advancing the cross feed after each cut is finished is what will allow you to produce slabs of your material.

- Unscrew the thumb screws allowing the top bar on the vise to be raised to accommodate the rock to be cut. Position the rock so that the initial cut will remove the minimum amount from the end of the rock to produce a smooth surface. Lower the slab vise bar so that it contacts the rock and tighten the thumb screws securely. Add shim material if necessary to provide secure contact between the rock and the clamping surfaces of the vise.



- You should not be able to move the rock in the vise after tightening. If the rock moves you must tighten the thumb screws more OR reposition the rock OR insert shim material between the rock and bar to provide more secure contact. This is especially important in clamping rocks to be cut that have single points of contact with the bar. It may be necessary to use pliers or another tool to tighten the thumb screws.
- Once the rock is secure and cannot be moved by hand pressure you are almost ready to begin the cut. The next step is to position the rock nearer the blade. To do this disengage the carriage feed lever and, while holding the lever in the up position, carefully move the entire carriage toward the blade stopping when the rock is about ¼ inch from the blade. Be careful not to abruptly move the carriage toward the blade causing the rock to hit the blade. This can damage the blade if you hit the blade hard with the stone.
- Next adjust the automatic cut off chain allowing sufficient travel of the carriage to cut completely through the rock. Also, inspect the positioning of the rock carefully to insure that at the maximum cutting position it does not come in contact with the arbor nut or flange. Look underneath the carriage at the position of the rock in relation to the arbor nut and flange. Be sure to check for possible overhangs in the rock where the rock may extend below the level of the floor of the vise. Careful judgment must always be used to insure that contact does not occur between the rock and the arbor nut or flange. Such contact could severely damage the machine and can potentially void the warranty.
- You should also check the surface of the rock that will make first contact with the blade. If the blade is perpendicular to the rock surface at first contact then the cut can be started without further concerns. If, however, the rock surface curves away from the plane of the blade deflection of the blade may occur as the cut is started. This deflection can cause the cut to start into the rock significantly out of the plane of the blade. This can result in blade or machine damage.
- In cases of sloping surfaces on the rock in relation to the blade the procedure is somewhat different. In these cases the cut will be started and contact allowed to be made between rock and blade for a very short time of 10 or 15 seconds initially. After this shut off the saw, open the hood, withdraw the carriage to ¼ inch from the blade and

repeat the short contact between blade and rock as the saw runs. This procedure will cause a “notch” to be cut into the sloping surface of the rock. After 2-4 cycles this notch will be sufficient to allow you to start the saw and allow it to run without deflection of the blade.

- To start the cut confirm that the rock is positioned ¼ inch from the blade. The cut must not begin with the blade in contact with the rock. Check the oil level to confirm about 1/2 inch of immersion of the blade in the oil.



- Then close the hood and insure that the power cord is plugged into the power source. This source should be equipped with a GFI ( Ground Fault Interrupter). You are ready to start the machine.
- Your saw is equipped with the “**Safe Start System**” that reduces the risk of accidental start up of the saw. Before starting the saw, always make sure that the blade turns freely and is not touching the stone. To start the saw, close the hood, set the auto shutoff toggle switch in the on position ( toward the front of the saw ) and then push and release the green start button. The saw will start and run as long as the toggle switch is in the on position. When the toggle switch is turned off manually or by the auto shut off chain the green button must be pushed again to restart the saw. This feature protects against accidental movement of the toggle switch to the on position when you are loading or unloading your cutting piece.



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- The saw cannot be started with the toggle switch alone. The green button must also be pushed. Also, if the toggle switch is in the off position and the green button is pushed the saw will not start.
- The green button is part of a safety interlock control that works when the saw is started. It is not designed and does not function as an emergency off switch. If the saw must be stopped for any reason then the toggle switch must be moved to the off position.

# Warranty

Highland Park warrants to the original purchaser for a period of one year except as noted, from the date of purchase all products covered by this Warranty to be free of defects in materials and workmanship.

This Warranty shall not apply to any parts that have been subjected to misuse or improper service, that had been damaged in transit or handling, or that have been altered or repaired by unauthorized representatives. This Warranty does not cover defects caused by or resulting from misuse, abuse, neglect, or damage caused by accident or the failure to provide reasonable maintenance. This Warranty is void if the product or any of its individual components is altered or modified by the purchaser or if the product is used in a manner or with a blade not recommended by the manufacturer.

Any claim arising under this Warranty must be submitted by the original purchaser within the warranty period specified above and shall include proof of purchase. During said warranty period Highland Park shall, at its option, either replace or repair, at no charge to the original purchaser, any parts or components that are found to be defective by Highland Park. Highland Park shall not be responsible for or obligated to pay for freight or other transportation-related costs or expenses in connection with any defective products or components that are either returned to Highland Parks facility or any authorized repair station and/or any replacement products or components that are shipped from Highland Park pursuant to this Warranty.

Parts and labor needed to maintain products and the replacement of components due to normal use are the purchaser's responsibility and are not covered by this Warranty. All products or components replaced under warranty become the property of Highland Park. All replacement parts will be considered to be part of the original product and any warranty on such parts will expire coincidentally with the original Warranty. Replacement part(s) installed by anyone else will be provided without a charge for such replacement part(s), but this Warranty will not apply to labor charges in connection therewith.

**IN NO EVENT SHALL ANY LIABILITY UNDER THIS WARRANTY EXCEED THE REPLACEMENT COST OF ANY DEFECTIVE PRODUCT OR COMPONENT THEREOF, AND HIGHLAND PARK SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES OR FOR ANY OTHER DAMAGE OR LOSS NOT EXPRESSLY ASSUMED AS SET FORTH HEREIN.**

The foregoing constitutes an expressed warranty on the terms set forth above and is the only warranty or warranties applicable to the products it covers. All other warranties, including, without limitation, the implied warranty of merchantability and/or fitness for a particular purpose or use being denied. This limited warranty is expressly in lieu of all other warranties, whether expressed or implied.

## **Diamond Blades & Core Bits**

Diamond Blades are warranted for 1 year for defects in material and work shipment.

Segment loss due to improper use or damage caused by a crash is not covered. Segment loss due to improper use or damage caused by a crash is not covered.

Blade dishing or warping due to improper lubricant, arbor alignment, or running the blade or core bit dull is not covered.

Segment wear is not covered and will vary depending upon the hardness and abrasiveness of the material being cut.

## **Polishing Tools:**

All wet grinding and polishing tools are covered by a 90-day limited warranty.

## **Motors:**

Motors purchased separately from machines are covered by a 90-day limited warranty.

## Parts and Support

As fellow cutters we want you to be successful with your Highland Park Lapidary slab saw. If you have any questions, feel free to contact us directly at [Support@HPLapidary.com](mailto:Support@HPLapidary.com) or at 512-348-8528.

We stock most replacement parts for immediate shipment. Order from [www.HPLapidary.com](http://www.HPLapidary.com), the Highland Park Lapidary Catalog or call us at 512-348-8528.

You may also visit our YouTube Channel for more information and Tutorials. <https://www.youtube.com/channel/UC5B6mXnFaUbtDcCELViPQsA>