 MANUAL INSTRUCTION
 and
 PARTS LIST

Write in the serial n° of your machine here
Thank-you for purchasing a Masonry 500 from an Imer U.S.A. dealer. Your decision is an intelligent one.

There is no other sawing machine in the world which delivers the benefits and features of the Masonry 350F:

- Extremely rigid, mig welded bar steel frame.
- 9.0 H.P. Honda engine.
- Single arm for larger working space.
- Extremely rigid worktable for a precise cutting.

At IMER U.S.A. we continually search for ways to better serve our customers. Should you have an idea or thought to share with us regarding this product we would appreciate hearing from you. Our motto is "Tools and Services for the 21st Century". We look forward to delivering the goods.

Thank you again for your purchase.

Mace T. Coleman, Jr.
President, Imer U.S.A, Inc.

IMER WEST
207 Lawrence Avenue
So. San Francisco, CA 94080
Tel 650 - 872 - 2200
Fax 650 - 873 - 6482

IMER EAST
221 Westhampton Place
Capitol Heights, MD 20743
Tel 301 - 336 - 3700
Fax 301 - 336 - 6681

1. Carriage locking lever.
2. Spray guard
3. Engine
4. Blade support
5. Water pump
6. Guide
7. Emergency switch
8. Worktable
9. Water tank
10. Blade cover
11. Adjustment crank.
12. Work piece
13. Blade
14. Frame
15. Earth screw
17. Head stop bolt.
19. Accelerator lever.
Dear Customer,

Congratulations on your choice of purchase: this IMER saw, the result of years of experience, is a fully reliable machine and is equipped with the latest technical innovations.

- **WORKING IN SAFETY**

  To work in complete safety, read the following instructions carefully.
  - This OPERATION AND MAINTENANCE manual must be kept on site by the person in charge, e.g. the SITE FOREMAN, and must always be available for consultation. - This manual is to be considered an integral part of the machine, and it must be preserved for future reference (EN292/2) throughout the machine’s normal working life. If the manual is damaged or lost, a replacement may be requested from the saw manufacturer.
  - The manual contains important information regarding site preparation, installation, machine use, maintenance procedures and requests for spare parts. Nevertheless, the installer and the operator must both have adequate experience and knowledge of the machine prior to use.

  - To guarantee complete safety of the operator, safe operation and long life of equipment, follow the instructions in this manual carefully, and observe all safety standards currently in force for the prevention of accidents at work. Use personal protection (safety footwear, suitable clothing, gloves, goggles, etc.).

  - Safety glasses or a protective visor must be worn at all times.

  - Ear protection must be worn at all times.

  - MAKE SURE THAT WARNING SIGNS ARE ALWAYS LEGIBLE.

  - It is strictly forbidden to carry out any form of modification to the steel structure or working parts of the machine.

  - IMER INTERNATIONAL declines all responsibility for non-compliance with laws and standards governing the use of this equipment, in particular; improper use, defective power supply, lack of maintenance, unauthorised modifications, and partial or total failure to observe the instructions contained in this manual. IMER INTERNATIONAL is entitled to modify the characteristics of the sawing machine and/or the contents of this manual without necessarily updating previous machines and/or manuals.

1. **TECHNICAL DATA**

   Table 1 shows the saw’s technical data, referring to figure 1.

   | TABLE 1 - TECHNICAL DATA (1188808) |
   |-----------------|-----------------|
   | Blade rpm       | 2,150            |
   | Blade diameter  | 20" (508 mm)    |
   | Blade mounting hole | 4"          |
   | Engine type     | Honda GX 270    |
   | Power engine    | 9.0 / 3,600 rpm |
   | Motor rpm       | 3,400            |
   | Cutting table dimension | 20"x17" |
   | Overall dimensions (width x length x height) | 28"x62"x62" |
   | Overall dimensions for transport (width x length x height) | 28"x62"x67" |
   | Weight          | 465              |
   | Weight for transport | 515             |
   | Blade rotation direction (seen from blade clamping flange) | CLOCK WISE |

2. **DESIGN STANDARDS**

   MASONRY 500 saws are designed and manufactured according to the following standards: EN 292-1-2; EN 12418; 89/336/CEE; 2000/14/CE.

3. **NOISE EMISSION LEVEL**

   Table 2 indicates the environmental noise levels measured for the panel saw (lwa) in accordance with EN ISO 3744 and the acoustic pressure level measured at the operator’s ear with the machine empty (Lpa).

<table>
<thead>
<tr>
<th>TABLE 2 - [dB(A)]</th>
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<td>SAWING MACHINE</td>
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<td>Masonry 500 ENG</td>
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</table>

4. **CUTTING SPECIFICATIONS**

   This saw model has been specially designed for cutting stone, ceramics, marble, granite, concrete and similar materials. Only water-cooled diamond blades with continuous or segmented edges (see paragraph 13) must be used. Under no circumstances must dry cutting blades be used or materials other than those specified above. IMER INTERNATIONAL declines all responsibility for damage caused by improper use of the above machine.

5. **CUTTING CAPACITY**

   - max. cutting capacity with vertical blade = 8” in one single pass.
   - max. height of workpiece: 16½” in.
   - min. width of workpiece: 2”.
   - max. cutting length: 17” (with blade lowered), 27” (vertical movement of the disk).
   - Blade at 45°: with support at 45° on the work surface.

6. **WARNING**

   - Do not load the saw with workpieces that exceed the specified weight (max. 90 lb.).
   - Ensure stability of machine: it must be installed on a solid base with a maximum slope of 5° (fig. 2).
   - Ensure the workpiece is stable before, during and after cutting: in any case, workpieces must not overhang the worktable.
   - Respect the environment; use suitable receptacles for collection of cooling water contaminated with cutting dust.

7. **SAFETY PRECAUTIONS**

   - IMER saws are designed for work on construction sites and under conditions of natural light, hence the workplace must be adequately lit.
   - The machine must never be used in environments subject to risks of explosion and/or underground sites.

8. **TRANSPORTATION (fig.4)**

   - Warning. Before removing the panel saw, lock the carriage using the stop (ref. 4, fig. 4). When transporting the machine, use a four-arm tie rod (ref.1, fig.4) engaging the hooks in the connectors provided (ref.3, fig. 4). When transporting the machine with a fork lift, insert the left fork in the slot provided (ref.2, fig.4).

9. **INSTALLATION (fig.4)**

   - Lift the machine out of its package using slinging equipment with 4 rope legs. Fix the hooks to the relative attachments.
   - Install the machine on a completely even and stable surface.
   - Release the carriage from the lever that secures it to the frame.
   - Fill the pump with water, unscrewing the connector (fig.10).
   - Warning. Before removing the panel saw, lock the carriage using the stop (ref. 4, fig. 4). When transporting the machine, use a four-arm tie rod (ref.1, fig.4) engaging the hooks in the connectors provided (ref.3, fig. 4). When transporting the machine with a fork lift, insert the left fork in the slot provided (ref.2, fig.4).

10. **STARTING THE MACHINE**

    The endothermic motor is equipped with a centrifugal clutch which engages automatically, transmitting drive to the cutting wheel as the engine revs up.

    The hazard warnings and the instructions for use and maintenance contained in the manual enclosed with the endothermic engine must be read and understood before the engine is started.

    1-Check the engine (see enclosed engine manual).
    2-Check the oil level in the motor; horizontal motor position (see enclosed engine manual).
    3-Fill the fuel tank (enclosed engine manual).
    4-Set the accelerator lever to minimum, so as to start the motor without turning the cutting wheel (clutch not engaged).
    5-Warm the engine by letting it run at low speed.

    - Emergency-stop: press the engine stop button (ref. 7, fig. 1), (turn to switch on again).

    Keep far enough away from the saw when it is running to avoid inhaling exhaust gases from the endothermic engine.
- Turn off the engine before topping up the tank with petrol.
Saws with endothermic engines must be used in the open air. If they have to be used in closed environments, the openings must be provided to conduct gases from the engine’s exhaust pipe to the outside using appropriate non-flammable flexible tubes. These must be checked for leaks and breakages at the beginning of every shift.

- Do not start the machine with the blade in the workpiece.
When the saw is not being used, turn the petrol cock to the OFF position.

10.1 STARTING ROTATION OF THE CUTTING WHEEL
Gradually move the lever (ref.19; fig.1) so as to bring the motor revs up to normal working speed and start the wheel turning at the cutting speed foreseen.

11. STARTING THE MACHINE
Before cutting:
1 - Check that there is enough cooling water in the tank.
2 - Adjust the flow of cooling water by turning the cock next to the blade guard (do not perform cutting without water).
3 - Ensure that blade rotation corresponds to the indications on the blade guard.
4 - If everything is in order, work can begin.

12. EMERGENCY - STOP
- In an emergency, stop the machine by pressing the stop control switch (ref. 7, fig.1).

13. BLADE INSTALLATION (Fig.5)
By means of a hex wrench no.10, unscrew the 5 screws that lock the moving blade guard (ref.3). Loosen the locknut (ref.1) by rotating clockwise (left thread). Remove the mobile flange (ref.2) and check that the flanges, disc shaft and blade are not damaged.

- Never use worn blades or blades with missing segments.
- Only use blades that are designed for the number of revolutions indicated on the machine rating plate.

- Check that blade rotation corresponds to that indicated on the blade guard.
Centre the blade against the fixed flange, position the mobile flange and tighten the blade locknut fully down by rotating anticlockwise (left thread). Refit the mobile blade guard, tightening the 5 screws (ref.3).

- Ensure that the blade guard (ref.3) is locked securely into position.

- WARNING! An incorrectly installed blade, or a screw insufficiently tightened can provoke damage to the machine or injury to persons.

- Note that the blade must have an external diameter of 20"in., a central hole diameter of 1"in. and max. thickness of 1/8"in.

- Check that the blade to be used is suitable for the material to be cut.

- Do not use blades for wood! (fig. 6).

14. USE
- Leave a space of at least 5ft. around the machine to operate in full safety.
- Do not allow other persons to approach the machine during cutting.
- Never use the machine in fire-risk areas. Sparks can cause fire or explosions.
- Make sure that the machine is switched off before positioning or handling.
- Always ensure that the blade is free of any contact before start-up.

- Ensure correct installation of all protective devices.
- Before starting work, fill the water tank. Top up during operation whenever necessary. N.B. the pump suction hose must always remain immersed in water.

- WARNING! For safety purposes the removal of protective guards from the machine is strictly prohibited.
- WARNING! Always switch off the machine before carrying out blade adjustment.
Loading and unloading pieces on the machine cutting table. To avoid the risk of accidental contact with the cutting wheel, the pieces must be positioned and removed from the carriage with the cutting wheel stopped. This is done by adjusting the lever (ref.19; fig.1) so as to reduce the revs to minimum, thus disengaging the clutch.

14.1 VERTICAL MOVEMENT OF THE DISK
To raise or lower the cutting wheel, turn the crank (ref.11, fig.1) until the wheel is at the required height above the cutting table. The wheel can also be lowered by pressing the pedal (ref.16, fig.1); when the pedal is released the cutting wheel will return to the position originally set using the crank.

- Ensure that the locking handle is tightened fully before starting work.

14.2 POSITIONING FOR 45° CUTS
To machine a 45° cut, it is necessary to use the 45° support. Place the 45° support on the cutting table in the position required, fix the support to the carriage by locking the flywheel provided, then position the piece to be cut, after which it is possible to start the motor and commence cutting operations.

14.3 CUTTING
For safe use of the machine when cutting, push the carriage forwards as the cut advances, placing your hands to the two sides of the carriage. Never push directly on the piece to be cut.

- Check that the blade is aligned with the cutting line.
- Place the workpiece on the worktable (ref. 8, fig. 1), resting firmly against the stop.
- Start the engine.
- Wait until the water reaches the blade.
- Begin cutting.
- Horizontal cutting movement is carried out by pulling the carriage towards the blade.

- As cutting thickness increases, the blade is subjected to greater stress. To avoid overloading the engine, the operator should continually check blade feed speed. The speed will also depend on the characteristics of the material being cut (hardness, toughness etc.).

14.3.1 CUTTING WITH CUTTING WHEEL LOWERED FROM ABOVE.
Adjust the vertical height by turning the crank (ref.11, fig.1), position the piece to be cut, start the panel saw and commence cutting operations by pressing the pedal (ref.16, fig.1) to lower the wheel from above.

14.3.2 BLADE CHANGE
To change the blade refer to section 13.

15. USING 22" in DIAMETER CUTTING WHEEL
If an optional cutting wheel diameter 22"in. is used instead of the standard wheel diameter 20"in., it is important that the stop bolt be calibrated to prevent interference between the wheel and the carriage when the head is in the lowest position.

- Warning. The panel saw is fitted with a stop bolt to stop the cutting wheel in the lowest vertical position. This stop is calibrated for a 22"in. cutting wheel. If you are using a 20"in. cutting wheel, loosen the bolt (ref. 17, fig. 1), lower the wheel to the lowest position, by turning the crank, then check, with the motor turned off, that there is no interference between the cutting wheel and the piece holder carriage when the pedal is pressed. Adjust the bolt, bring it into contact with the stop and tighten the lock nut.

- Note that the blade must have an external diameter of 22"in., a central hole diameter of 1"in. and max. thickness of 1/8"in.
16. MAINTENANCE

- **WARNING.** Servicing must always be carried out by skilled personnel and only after the endothermic engine has been turned off.

- Always keep the guards in proper working order and free from damage. Take particular care to ensure that the blade guards are kept efficient and clean, replacing them if they are damaged.

  Do not leave the machine outside: it must always be protected from the weather.

Below is a list of the cleaning operations that must be carried out at the end of every shift.

16.1 TANK CLEANING

Empty the tank by removing the drain plug. Remove cutting residue using a jet of water.

16.2 TANK REMOVAL (Ref. Fig. 7).

Empty the drum opening the drum cap from right or left side.

16.3 WORK SURFACE CLEANING

Always keep work surfaces clean. Residual dirt can impair cutting precision.

16.4 GUIDE RAIL CLEANING

It is good practice to remove all traces of dirt from the guides.

16.5 CLEANING AND MAINTENANCE OF COOLING CIRCUIT

- If water does not reach the blade stop the machine immediately to avoid blade damage.
- After switching off the machine ensure that the water level is sufficient.

  Check that there is water in the pump by unscrewing the connector, and if necessary top up until water flows out (fig. 10).

- **WARNING.** Before starting the panel saw for the first time, or when starting it after long periods of inactivity, fill the pump with water as described above.

- At the end of every shift, unscrew the suction hose filter and clean it. Then, circulate some water through it placing inside a bucket of clean water.

16.6 TENSIONING THE DRIVE BELT (fig. 8)

- Turn off the endothermic engine.
- Unscrew the 4 screws that lock the movable belt guard (ref. 1).
- Loosen the two screws (ref. 2) that clamp the water pump to the bracket and move the pulley away so that it does not touch it.
- Loosen the 4 screws (ref. 3) that clamp the endothermic engine to the blade support.
- Tension the belt using the nut (ref. 4): apply a force of about F=14lb. to the centre of the free section of the belt, the arrow should be about F=1/4"in. (fig. 9).
- Tighten the screws on the endothermic engine, checking the alignment of the engine pulley and the blade pulley.
- Lower the water pump until the pulley touches the drive belt. Tighten the two screws.
- Refit the guard and lock it using the 4 screws.

- **To avoid shortening the life of the belt, the bearings and the blade shaft, do not overtension the belt. Finally, check the two pulleys are aligned.**

16.7 DRIVE BELT REPLACEMENT

Repeat the operations described in section 16.6, replacing the belt before tensioning it.

16.8 ENDOTHERMIC ENGINE MAINTENANCE

Refer to the specific instruction manual enclosed with the endothermic engine for its correct routine maintenance.

16.9 REPAIRS

- **WARNING.** Do not start the saw during repair work.

  Only use genuine IMER spare parts and do not modify them.

- If the guards are removed to carry out repairs, they must be refitted properly when the repair work is finished.

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17. TROUBLESHOOTING

- **WARNING.** Stop the saw and turn off the endothermic engine before carrying out any maintenance.

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<thead>
<tr>
<th>FAULT</th>
<th>CAUSE</th>
<th>REMEDY</th>
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<tr>
<td>Vertical carriage movement not smooth</td>
<td>Guide rails dirty</td>
<td>Clean the guide rails</td>
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<tr>
<td>Lack of cooling water supply to blade</td>
<td>Refer to section 16.5: “cleaning and maintenance of cooling circuit” (Chapter 16.5)</td>
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<tr>
<td>Blade does not cut</td>
<td>Blade is worn</td>
<td>Fit new blade</td>
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<tr>
<td>Blade does not cut</td>
<td>Drive belt not tensioned</td>
<td>Tension the belt</td>
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<tr>
<td>Motor starts but blade does not rotate</td>
<td>Belt is broken</td>
<td>Replace drive belt</td>
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TAV. 1 - ASSEMBLY OF MOTOR

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TAV. 2 - 45° SUPPORT

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CFTIONAL
### TAV.3 - MACHINE STRUCTURE

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**Diagram Image**: A detailed diagram of the machine structure, showing various parts and their connections. The diagram includes labels from 1 to 89, indicating different components and labels such as 'carrigh', 'strip', 'bolt', 'bearing', 'wheel', 'guide bar', 'caring label', 'strip', 'bolt', 'bearing', and so on.
ONE YEAR WARRANTY

We warrant to the original purchaser that the IMER equipment described herein (the "equipment") shall be free from defects in material and workmanship under normal use and service for which it was intended for a period of one (1) year from the date of purchase by the original purchaser.

Our obligation under this warranty is expressly limited to replacing or repairing, free of charge, F.O.B. our designated service facility, such part or parts of the equipment as our inspection shall disclose to be defective. Parts such as engines, motors, pumps, valves, electric motors, etc. furnished by us but not manufactured by us will carry only the warranty of the manufacturer. Transportation charges or duties shall be borne by the purchaser. This shall be the limit of our liability with respect to the quality of the equipment.

This warranty shall not apply to any equipment, or parts thereof, which has been damaged by reason of accident, negligence, unreasonable use, faulty repairs, or which has not been maintained and operated in accordance with our printed instructions for our equipment. Further, this warranty is void if the equipment, or any of its components, is altered or modified in any way.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE.

We make no other warranty, representation or guarantee, nor is anyone authorized to make one on our behalf. We shall not be liable for any consequential damage of any kind, including loss or damage resulting, directly or indirectly, from the use or loss of use of the machine. Without limiting the generality of the foregoing, this exclusion from liability embraces the purchase’s expenses for downtime, damages for which the purchaser may be liable to other persons, damages to property, and injury or death of any persons.

This warranty shall not be deemed to cover maintenance parts, including but not limited to blades, belts, hoses, hydraulic oil or filters, for which we shall have no responsibility or liability whatsoever.

IMER U.S.A., Inc.
207 Lawrence Avenue
South San Fancisco, California 94080
(650) 872-2200
This is a contact addendum to our manuals

Imer USA East
221 Westhampton Pl
Capitol Heights, MD  20743
Phone: 301-336-3700
Fax: 301-336-6687
Order Fax:301-336-5811

Imer USA West
3654 Enterprise Ave
Hayward, CA  94545

www.imerusa.com
800-275-5463