1. For 16 facet polishing please enter in to ‘MODE’ and select ’16 F/Pvln’. For 8 facet polishing on pavilion side select ’08 F/Pvln’ and for 8 facet polishing on crown side select ’08 F/Crwn’.
2. For lock particular facet please enter in to ‘FLK’ and press left and right arrow button for lock and change facet using ‘facet’ switch and last press ‘Enter’ button for save lock facet.
3. Use normal coating on saren for diamond polishing. Recoating saren every 5-7 days if machine is use 20 -22 hours in day. If machine is use 10-12 hours then recoating on saren every 12-14 days.
4. Always use Mittutoyo dial gauge(0.01mm) for levelling of machine. Variation must be as per given below
   1. fighter level – 0 to 10 micron
   2. horizontal level- 0 to 5 micron
   3. vertical level – 0 to 5 micron
5. After change saren and proper levelling of all four machine if facet repairing is higher after polishing 2 diamond in each machine then again take level of machine and then start polishing diamond. After this process if again repairing is high then contact customer care of DRC.
6. For good polishing(ghutan) and symmetry of diamond use zeut mode in last 5 microns in 16 facet polishing and use upper polishing area of saren. zeut weight must be equal or below 300 in zeut mode.
7. In case if machine running in air repeatedly then first remove dust from load sensor and also check load sensor connector and belt connected properly. After this process still machine running in air then contact customer care of DRC.
8. In case of improper or overlap faceting(dacha) first remove dust from 7pin connector shaft. After this process still same problem found then contact customer care of DRC.
9. Please ensure that wass cover properly fitted with moderate pressure in culet so that brass pin is touch with die otherwise there is chance of damage in diamond during 8 facet(bhala) polishing.
10. During 16 facet polishing, if facet complete without touch of wass cover with saren then please remove burst between wass cover and die using pressurize air. If same problem, found again then please change die.
11. List of Errors and its troubleshooting.

**ERROR 1** - This error is displayed if grain motor is not working properly.

* First check if all cables are attached properly.
* Check the grain motor assembly.
* Check 7 pin connector is properly fit or not.

**ERROR 2** - This error is displayed if pressure motor is not working properly.

* First check if 10 pin FRC belt is attached properly.
* Check the magnet drive on the shaft of pressure motor is properly fit or not.
* Check pressure sensor PCB is properly fit or not.

**ERROR 3** - This error is displayed if carbon cable or carbon is not fit properly.

**ERROR 4** - This error is displayed when facet sensor does not sense wass cover.

* Check if ceramic-clamp pressure is proper or not.
* Check 7 pin connector is properly fit or not.

**ERROR 5** - This is error is displayed if the lifting motor is not working properly.

* First check if all cables are attached properly.
* Check the lifting motor in the gear box.
* Check motor and encoder power connection.

4)