

AT2552BE


Bandsaw



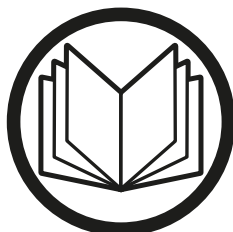
Index of Contents

EU Declaration of Conformity	02
What's Included	03-04-05
General Instructions for 230V Machines	06
Specification	07
Main Assembly	07-08-09-10-11-12-13-14
Machine Footprint	14
Illustration and Parts Description	15-16-17-18-19-20
Setting Up the Saw	21-22-23-24-25
Electro-magnetic Motor Brake Switch	26
Operating Instructions	27
Changing the Saw Blade	28-29
Maintenance	29-30
Exploded Diagrams/Lists	31-32-33-34-35-36-37-38-39-40-41
Wiring Diagram	42
Notes	43

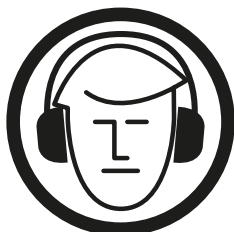
EU Declaration of Conformity

Cert No: SBW-3501BS Axminster Tools & Machinery Ltd Axminster Devon EX13 5PH UK axminster.co.uk declares that the machinery described:- <table><tr><td>Type</td><td>Bandsaw</td></tr><tr><td>Model</td><td>AT2552BE</td></tr></table> Signed  Andrew Parkhouse Operations Director Date: 27/04/2015	Type	Bandsaw	Model	AT2552BE	EU Declaration of Conformity This machine complies with the following directives: 2006/42/EC 2006/95/EC 06/42/EC - Annex I/05.2006 EN 1807-1:2013 conforms to the machinery example for which the EC Type-Examination Certificate No BM50309398 has been issued by OAV Equipment & Tools, Inc. at: No.96, Wucuo 1st st., 43641 Qingshui Dist., Taichung City, Taiwan, R.O.C. and complies with the relevant essential health and safety requirements.
Type	Bandsaw				
Model	AT2552BE				

The symbols below advise the correct safety procedures when using this machine.



Fully read manual
and safety instructions
before use



Ear protection
should be worn



Eye protection
should be worn



Dust mask
should be worn



HAZARD

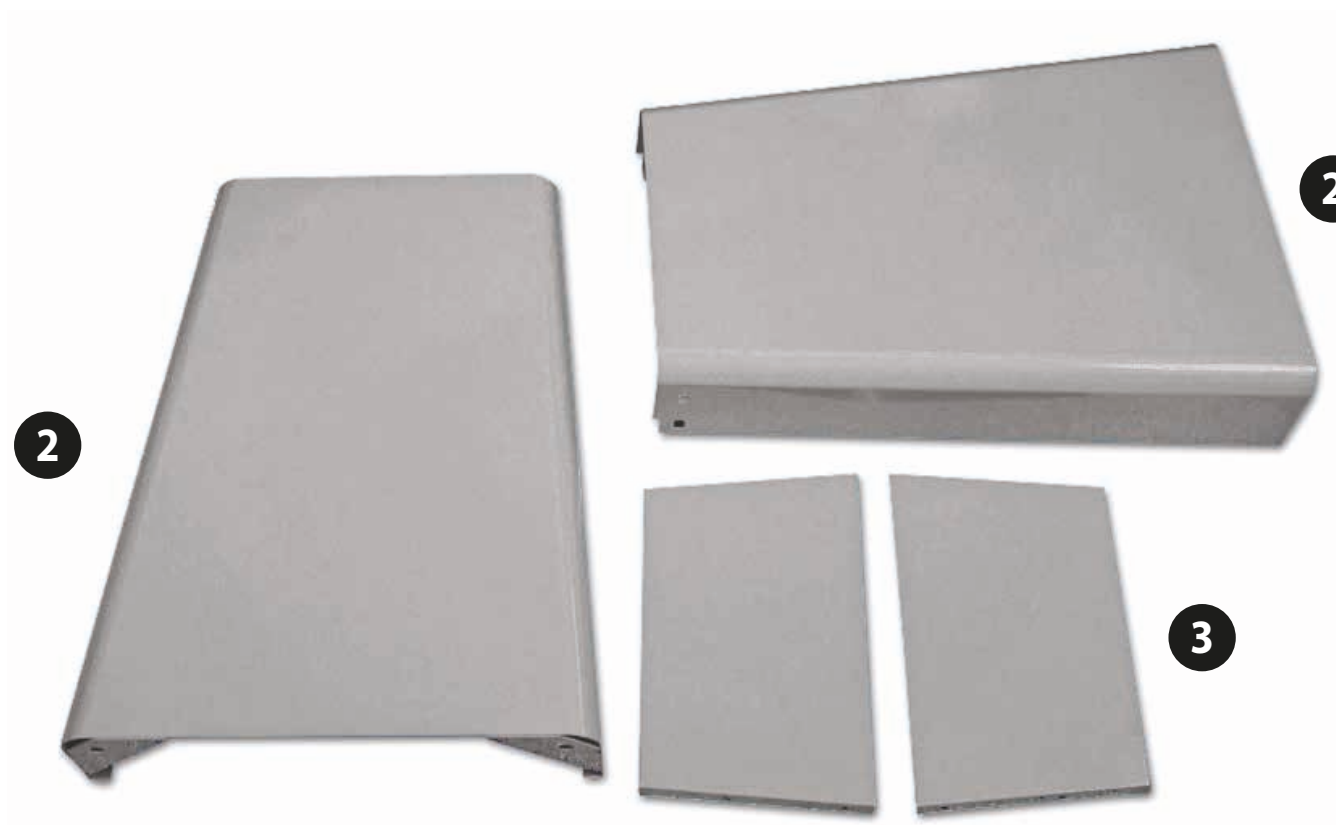
Quantity	Item	Model Number AT2552BE			
1	Industrial Bandsaw				
	Bandsaw Blade 2,552mm (100.1/2") long, mounted on saw but not tensioned.				
1	Cast Iron Table	1			
Stand Assembly:					
2	Stand Supports	2			
2	Stand Support Brackets	3			
Fence Assembly:		Bags Comprising:			
1	Front Fence Rail with Scale	4	1	Mitre Fence	17
1	Rear Fence Guide Rail	5	2	Clamping knobs with	
1	Fence	6		M8 threads	18
1	Fence Clamp Assembly with		1	M8 x 80mm Bolt & M8 Nut	19
	Magnifying Glass	7	8	M6 Flat Washers	20
1	M8 Lift and Shift Handle	8	2	M4 Nuts	21
1	M8 Threaded Lever	9	8	M6 Shoulder Nuts	22
1	Threaded 'T' Slot Insert	10	8	M8 Shoulder Nuts	23
2	M6 x 20mm Threaded Bolts	11	2	Domed Head Phillips Screws	24
2	M6 x 16mm Caphead Bolts	12	8	M6 x 16mm Bolts	25
1	M8 Large Washer	13	8	M8 Coach Bolts	26
2	M6 Small Washers	14			
2	Spring Washers	15			
1	M8 Nut	16			
1	User Manual				



Please read the Instruction Manual prior to using your new machine; as well as the operating procedures for your new machine, there are numerous hints and tips to help you to use the machine safely and to maintain its efficiency and prolong its life. Keep this Instruction Manual readily accessible for any others who may also be required to use the machine.



What's Included





General Instructions for 230V Machines

The following will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.



WARNING!! KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN



KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.

Mains Powered Tools

- Tools are supplied with an attached 16 Amp plug.
- Inspect the cable and plug to ensure that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.
- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.

- Carry out a final check e.g. check the cutting tool is securely tightened in the machine and the correct speed and function set.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check cutters are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

Specification

Code	700356
Model	AT2552BE
Rating	Trade
Power	750W 230V 1ph
Blade Speed	800m/min
Blade Length	2,552mm(100.1/2")
Blade Width Min/Max	3mm(1/8")/19mm(3/4")
Max Width of Cut	340mm
Max Depth of Cut	200mm
Table Size	495 x 360mm
Table Height on Stand	1,060mm
Table Tilt	-10° to +45°
Table Height	490mm
Dust Extraction Outlet	100mm
Overall L x W x H	445 x 610 x 1,753mm
Weight	85kg

Main Assembly

Your bandsaw is 90% assembled in order to reduce the footprint of the machine for packaging, several items are dismantled from the machine and need to be re-affixed.



HAVING UNPACKED YOUR ACCESSORIES PLEASE DISPOSE OF ANY UNWANTED PACKAGING PROPERLY. THE POLYTHENE AND CARD IS RECYCLABLE.



WARNING! THE BANDSAW IS A HEAVY PIECE OF MACHINERY, WE STRONGLY ADVISE YOU GET THE ASSISTANCE OF ANOTHER PERSON OR USE SOME SORT OF LIFTING DEVICE, (HOIST, ENGINE CRANE), BEFORE YOU ATTEMPT TO LIFT OR MOVE THIS MACHINE!

Stand Assembly

You will require the stand supports (02), stand support brackets (03), M6 bolts (25), M6 shoulder nuts (22) and M6 flat washers (20), see fig 01.

Step 1 Line up the first two pre-drilled holes in the support bracket (03) with the holes to one side of the support stand (02) and secure using the M6 bolts, washers and nuts (20-22-25), see fig 2. Repeat for the remaining stand and bracket.

NOTE: Make sure the support brackets (03) are the correct way round, otherwise the remaining holes in the stand assembly will not line up.

Fig 01

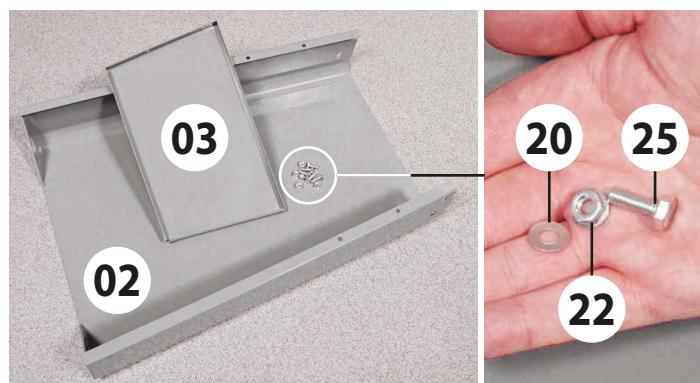


Fig 02



Main Assembly

Step 2 Line up the remaining holes in the two parts of the assembly and secure using the remaining M6 bolts, washers and nuts (20-22-25), securely tighten all fixing, see figs 03-04.

Fig 03



Fig 04



Fig 05



Mounting the Bandsaw



WARNING!! WHEN MOUNTING THE UNIT, WE STRONGLY ADVISE YOU GET THE ASSISTANCE OF ANOTHER PERSON BECAUSE THE BANDSAW IS HEAVY .

Lift the saw on to the stand and line up the pre-drilled holes, see fig 05, secure using the eight M8 coach bolts (26) and M8 shoulder nuts (23), see fig 06.

Fig 06



Mounting the Emergency Stop Assembly

Step 1 Locate the two domed head Phillips screws (24) and M4 nuts (21), see fig 07. loosen the four Phillips screws from the front of the emergency stop housing and very carefully open the outer cover, see fig 08.

Fig 07



Fig 08



Step 2 Line up the two elongated holes in the rear of the emergency stop housing with the two pre-drilled holes to the front of stand, insert one of the domed Phillips screw through the housing and while holding it in place screw on the M4 nut (21) and finger tighten. Repeat for the opposite side then fully tighten the fixings, see figs 09-10-11.

Step 3 Carefully replace the outer housing and tighten the four Phillips screws, see fig 12.

Fig 09-10-11-12

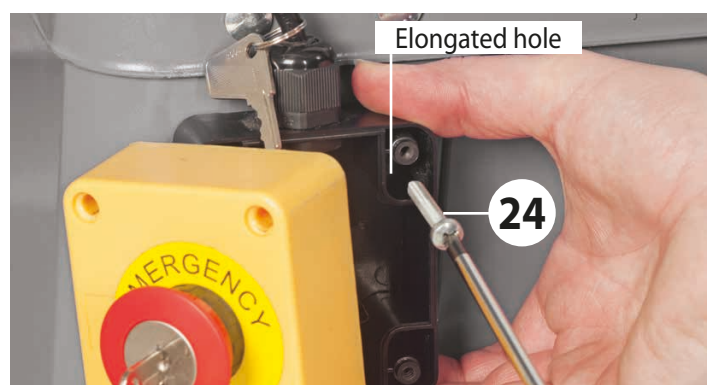
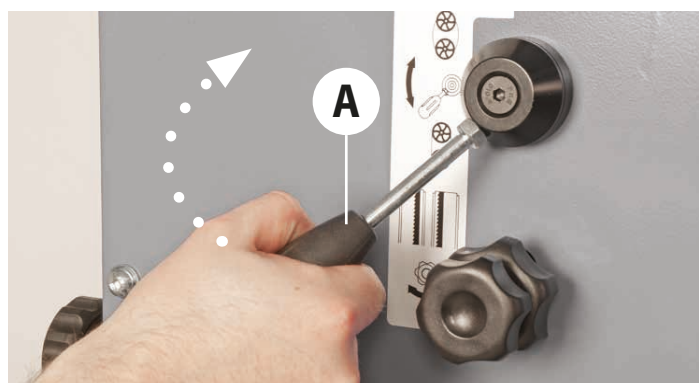


Fig 13-14



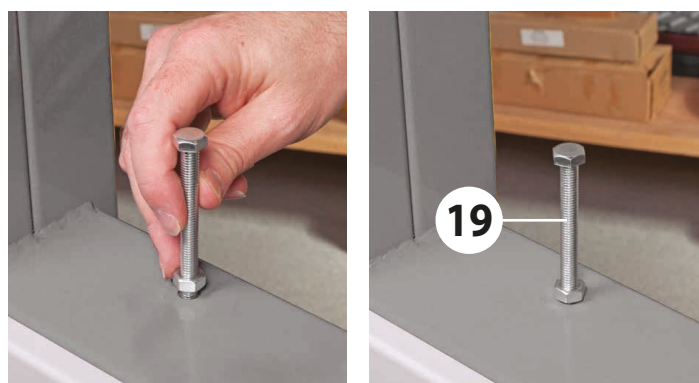
Mounting the Table

The saw table can be fitted without removing the blade. However, if you would feel more comfortable not having to manoeuvre the table around the blade (the table is quite heavy), remove the blade by opening the top and bottom covers, release the tension on the blade by releasing the Quick release tensioning lever (A), see fig 13-14.

Locate the cast iron table (1) the two M8, clamping knobs (18) and M8 x 80mm Bolt and Nut (19).

Step 1 Locate the threaded bolt/nut (19), screw the nut onto the thread then screw the bolt into the pre-drilled hole in the bandsaw frame, behind the tilt quadrant, see fig 15.

Fig 15



Main Assembly

Step 2 Remove the table insert and table alignment pin and place safely aside, see figs 16-17. Lift the table (1), slide the blade through the table slot, see fig 18, line up the two threaded bolts to the underside of the table and lower them through the holes in the tilt quadrant assembly, see fig 19.

Make sure the table is seated correctly on the tilt quadrant then screw on the two clamping knobs (18) to clamp the table (1) in position, see fig 20.

Fig 16-17

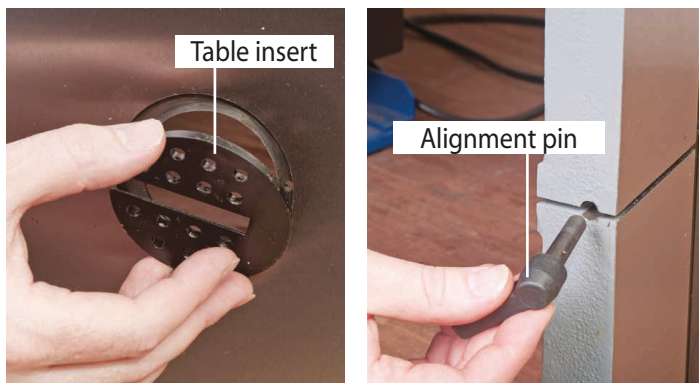


Fig 18

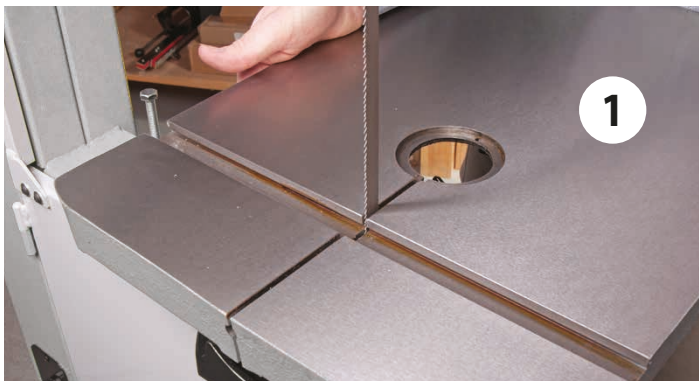


Fig 19

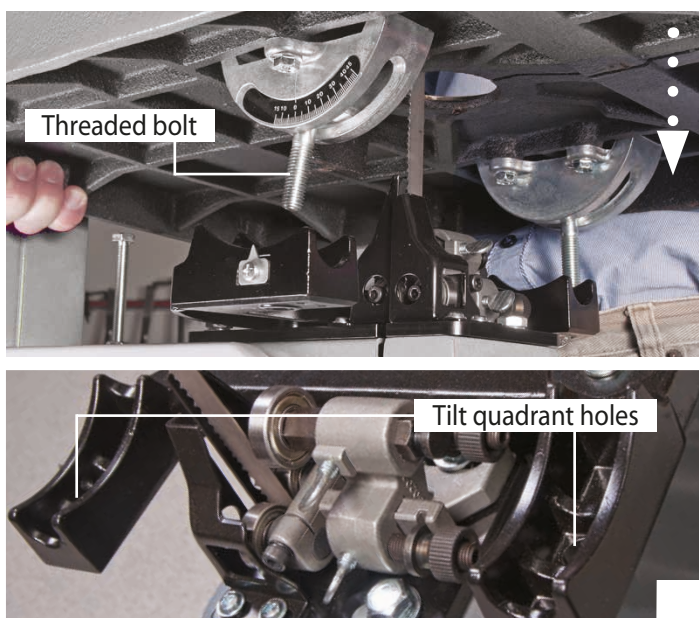
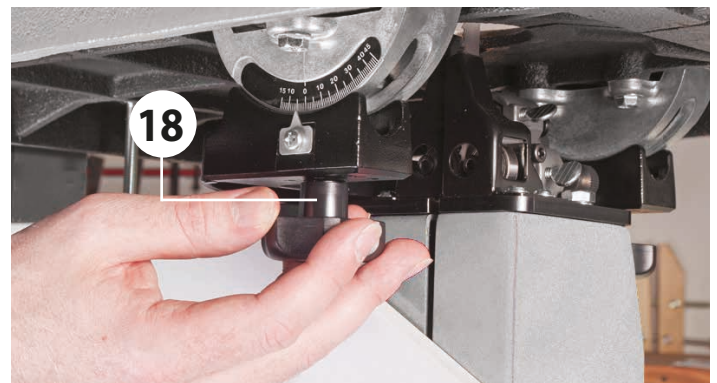
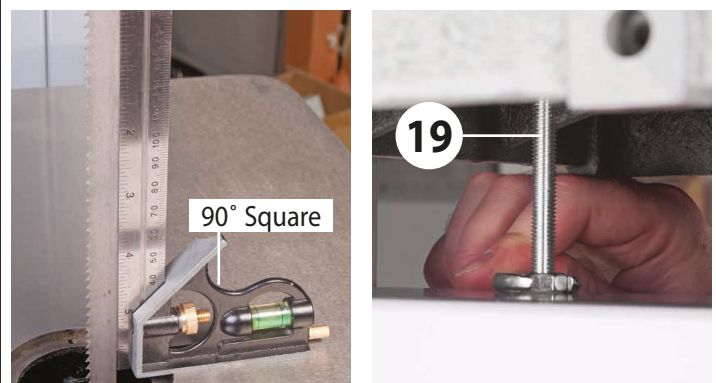


Fig 20



Step 3 Place a 90° square up against the blade, loosen the tilt quadrant clamping handles (18) and adjust the table levelling stop bolt (19) beneath the table until the table is perpendicular to the blade. Nip tighten the nut on the stop to lock the setting, see figs 21-22. Retighten the clamping knobs (18).

Fig 21-22



Step 4 Locate the table alignment pin you removed earlier, place a straight edge or 90° square across the table's slot and introduce the tapered alignment pin into the tapered hole to the front of the table, this will align both sides of the table, see figs 23-24.

Fig 23

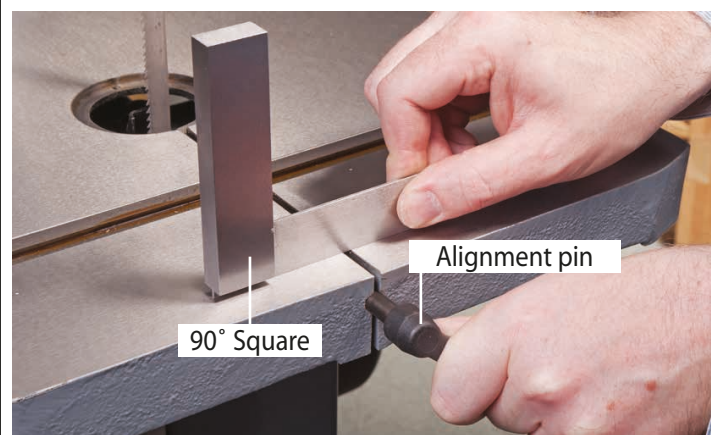


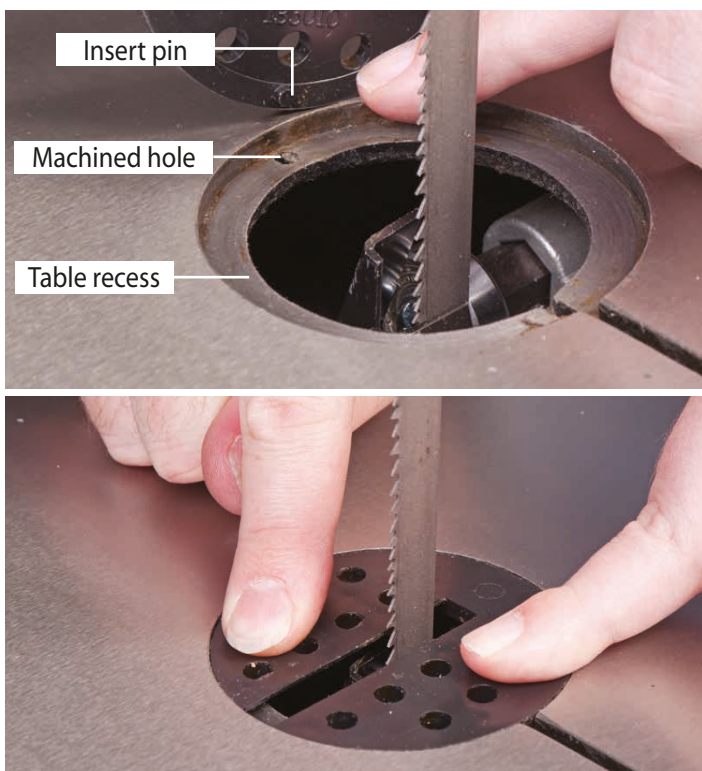
Fig 24



Checking both sides of the table are level

Step 5 Replace the table insert by lining up the two pins in the insert with the machined holes in the recess to the centre of the cast iron table. Push firmly down, see figs 25-26.

Fig 25-26



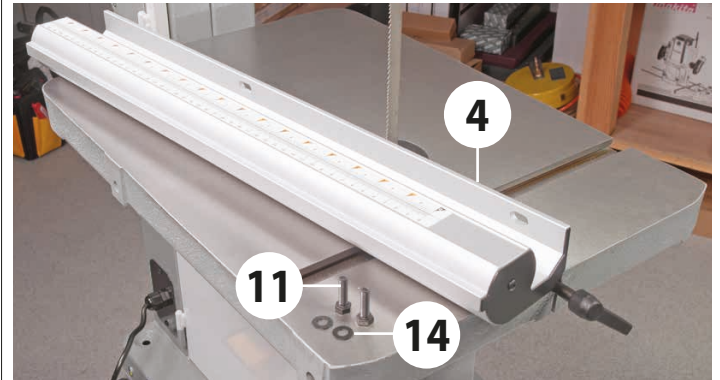
Fence Assembly

Locate the front fence rail with scale (4), rear fence guide rail (5), fence (6), fence clamp assembly (7), M8 lift & shift handle (8), M8 threaded lever (9), threaded 'T' slot insert (10), M6x20mm bolts (11), M6x16mm bolts (12), M8 large washer (13), M6 small washers (14), spring washers (15) and M8 nut (16).

Step 1 Place a washer (14) over each M6x20mm bolt (12), line

up the elongated holes in the front fence rail (4) with the pre-drilled holes to the front of the cast iron table (1), introduce the two M6x20mm bolts (12) through the fence rail and lightly tighten using the supplied spanner (22), see figs 27-28-29-30.

Fig27-28-29-30



Step 2 Place a spring washer (15) over each M6 caphead screw (12), line up the holes in the rear fence guide rail (5) with the threaded holes to the opposite side of the cast iron table and secure in place with the two M6 caphead screws (12) and using a 5mm Hex key tighten the guide rail, see figs 31-32-33-34.

Fig 31

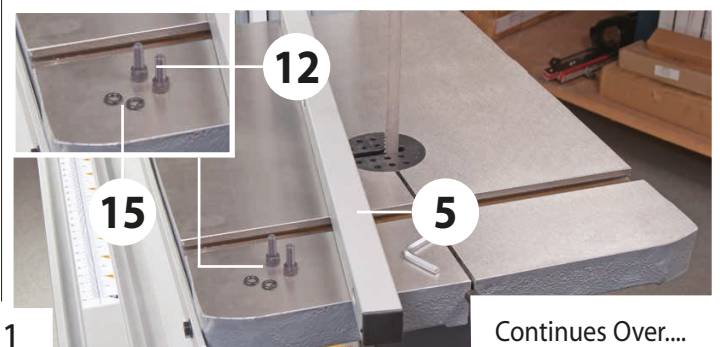


Fig 32-33-34



Step 3 Fit the fence clamp assembly (7) over the front fence rail (4) and lower the rear of the clamp assembly so the adjustable guide rests on top of the rear guide rail (5), see fig 35-36.

Fig 35

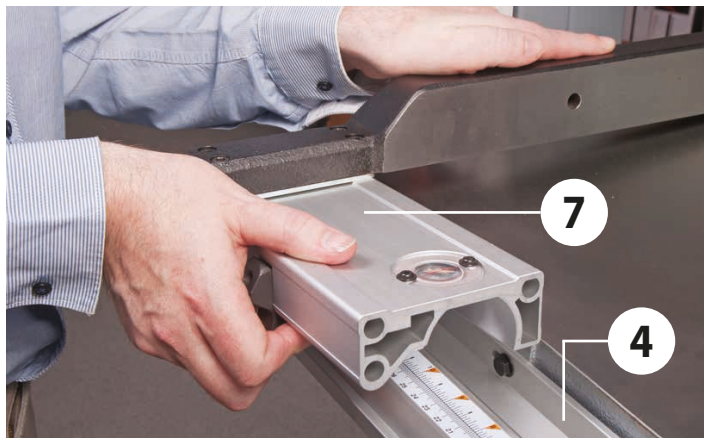


Fig 36



Step 4 Locate the M8 nut (16), and screw it onto the thread of the M8 threaded lever (9) then screw the threaded lever (9) into the threaded hole in the clamp assembly (7) mechanism and tighten the nut with a spanner, see figs 37-38.

Fig 37-38



Step 5 Slide the fence assembly (7) until it's up against the blade and press down the locking lever (9), see fig 39. Look at the 'RED' line on the magnifying glass to check it's set to '0' on the scale, see fig 40. If it's out of alignment, loosen the front fence rail (4) and tap the side of the fence until the scale reads '0' then re-secure the fence rail, see figs 41-42.

Fig 39

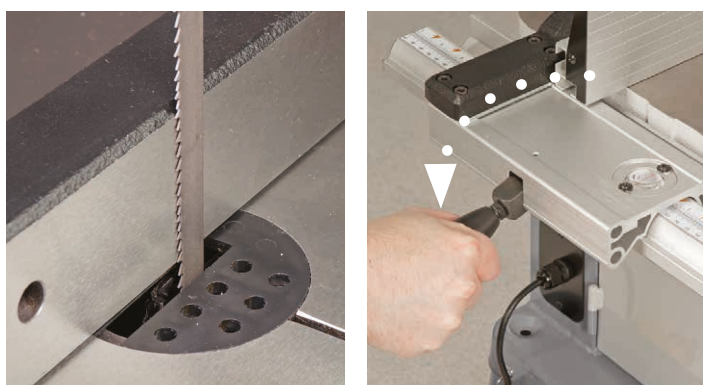


Fig 43



Fig 40-41-42



Magnifying scale

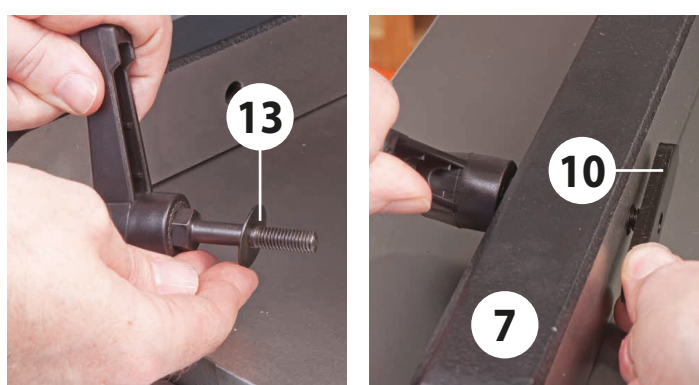
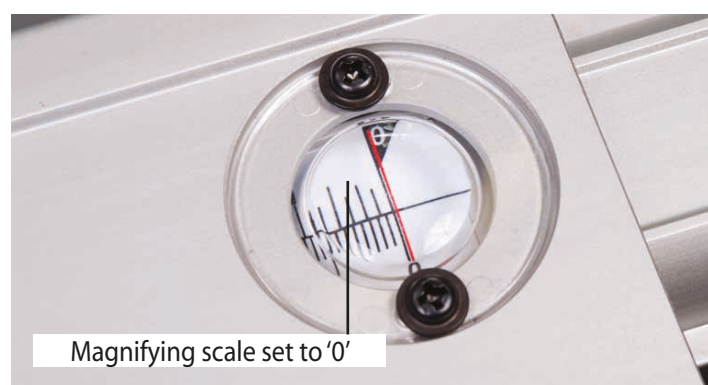
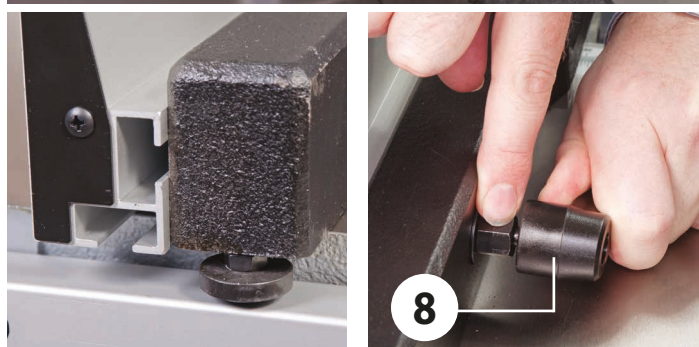
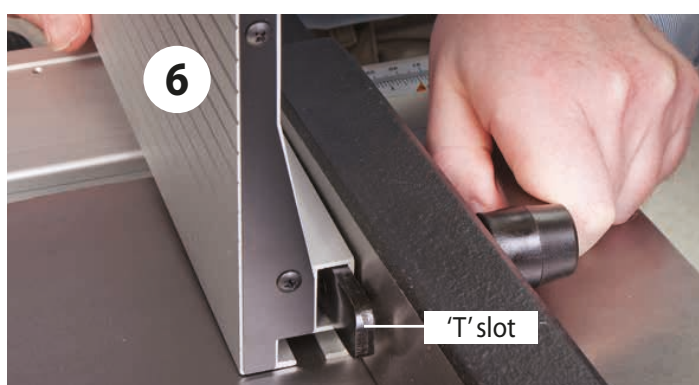


Fig 44-45

Step 7 Introduce the 'T' slot to the side of the fence (6) over the threaded 'T' slot insert (10) and slide on the fence until the fence (6) is flush with the end of the cast iron fence (7). Tighten the lift and shift handle (8), see figs 46-47-48.



Fig 46-47-48



Magnifying scale set to '0'

Step 6 Locate the fence (6), M8 lift and shift handle (8), M8 large washer (13) and threaded 'T' slot insert (10), see fig 43. Place the large washer over the thread of the lift and shift handle (8), see fig 44, introduce the handle through the machined hole to the side of the cast iron fence (7) and lightly screw on the threaded 'T' slot insert (10), see fig 45.

Main Assembly/Machine Footprint

NOTE: The fence (6) has two positions, vertical and horizontal for cutting narrow pieces, see fig 49-50-51.

Fig 49-50-51



Mitre Fence Assembly

Locate the mitre fence (19) and slide the mitre fence into the table (1) 'T' slot, see fig 52.

Fig 52

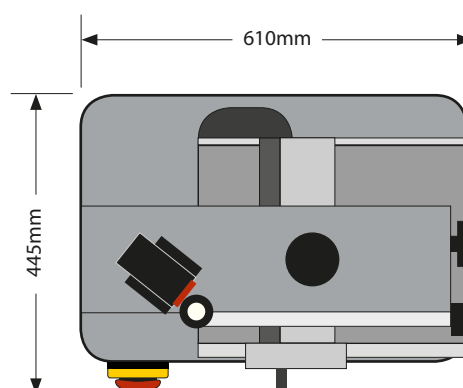
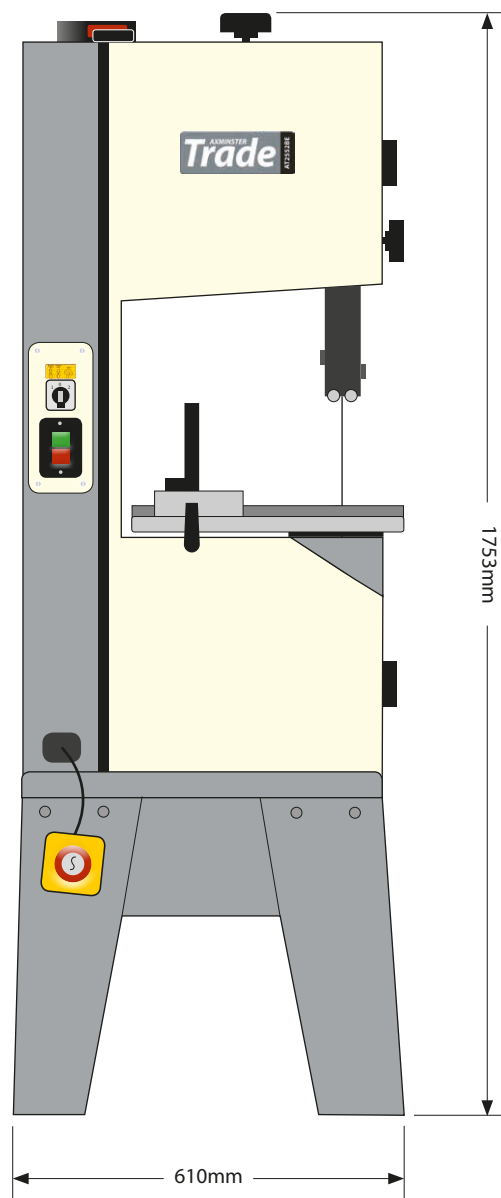


Illustration and Parts Description

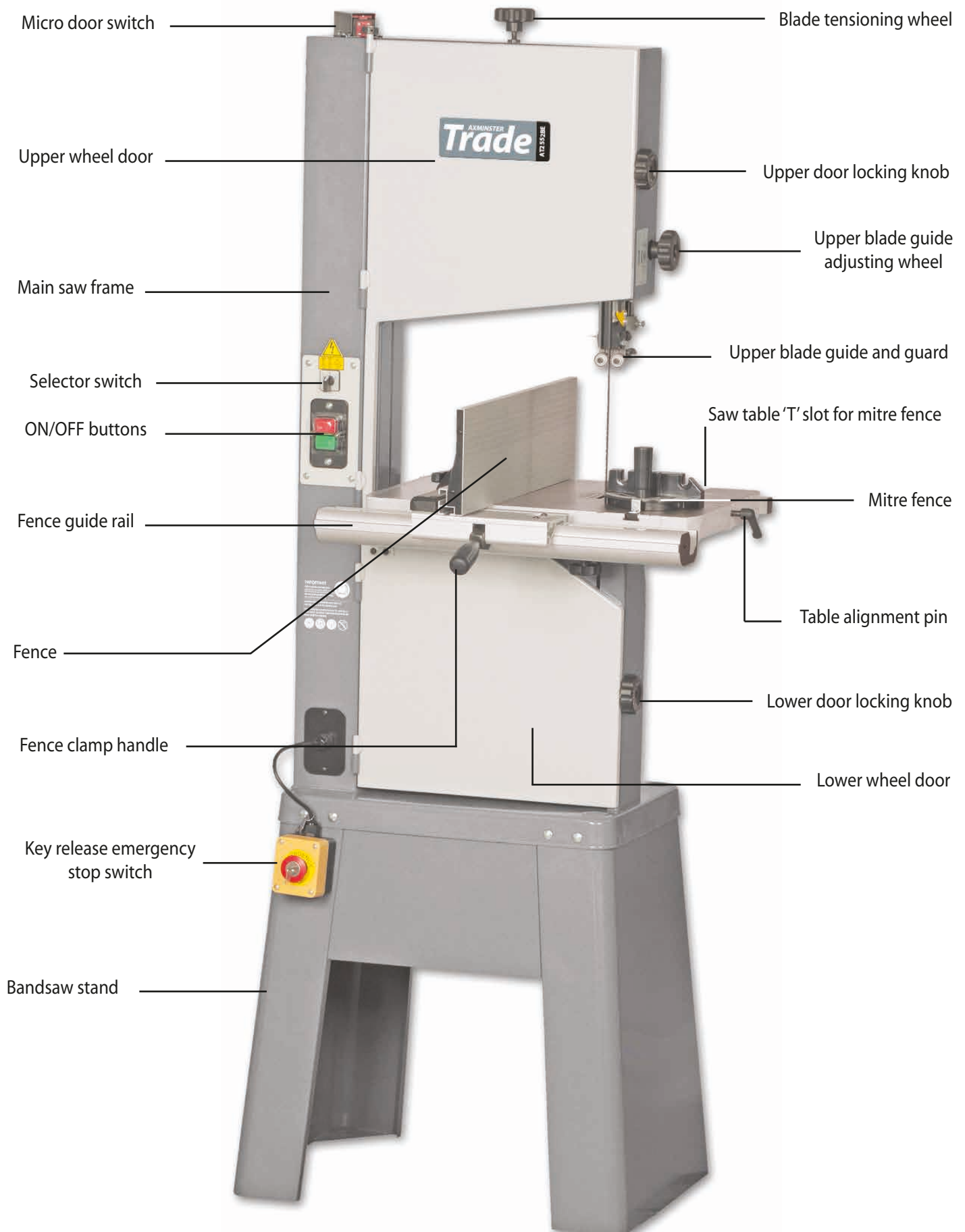


Illustration and Parts Description



Key release emergency stop, press the button to stop the bandsaw and turn the key to release it



NVR switch On/Off buttons



Upper door micro switch assembly



Electro-magnetic motor brake switch
Brake OFF (1), Brake ON (0), Run (2)



Scale magnifying glass Upper blade
guide height scale and pointer



Upper blade guide height
scale and pointer



Table levelling stop bolt



Table insert

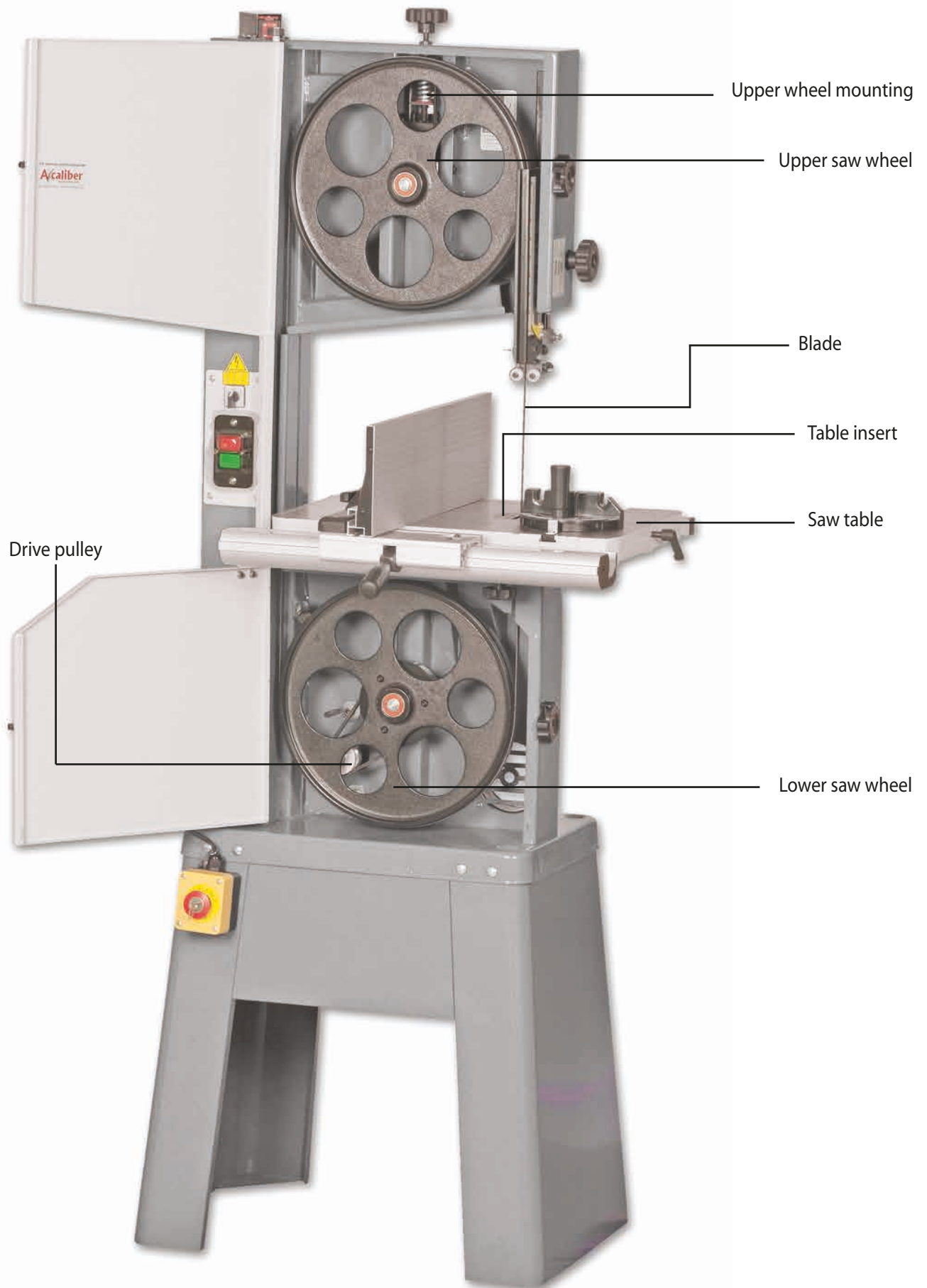
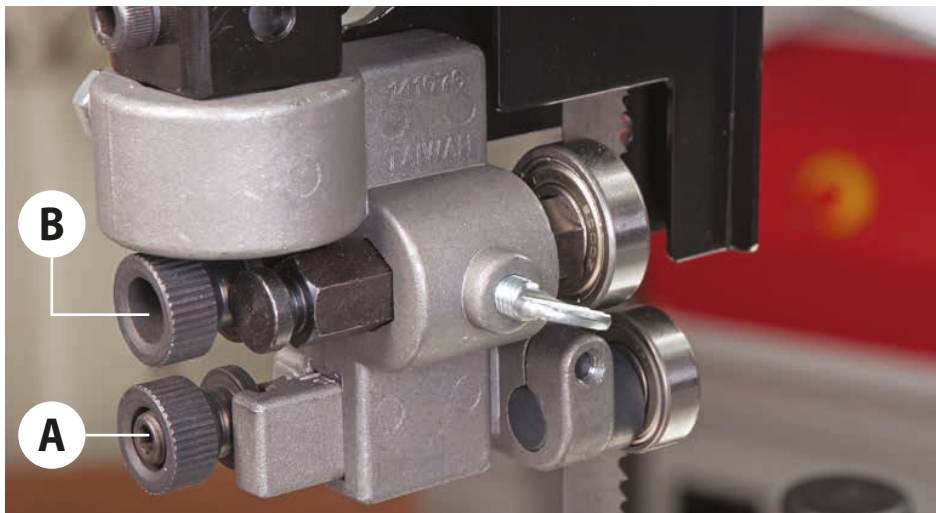
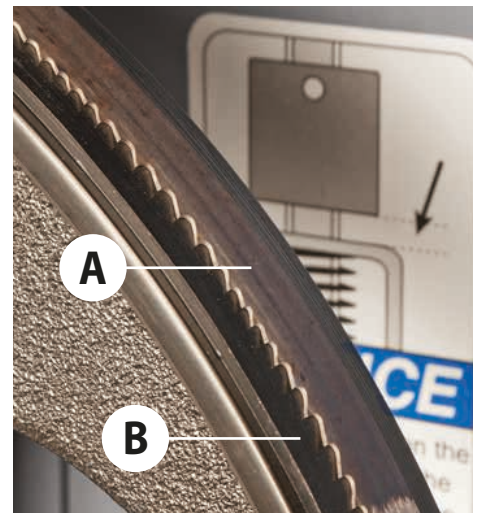


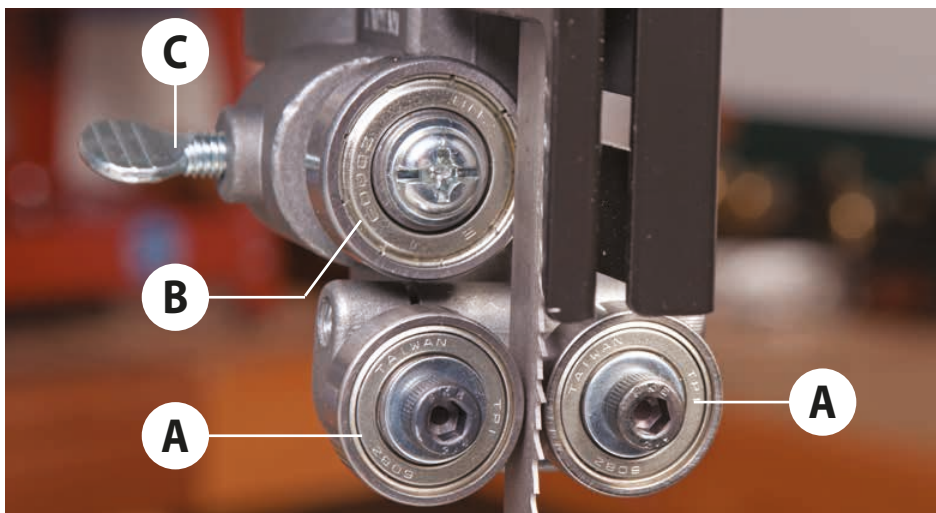
Illustration and Parts Description



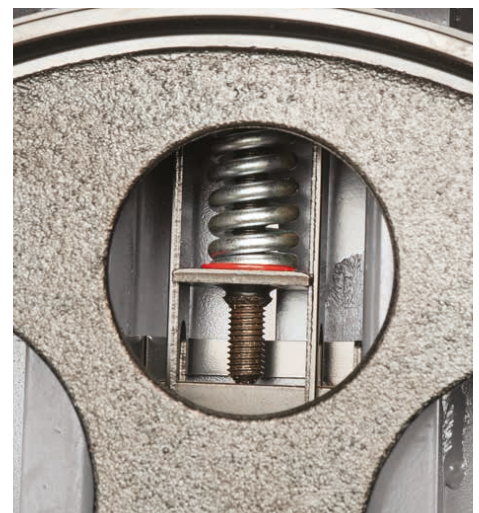
Blade guide fore and aft adjusting knob (A), Rear thrust bearing adjusting knob (B)



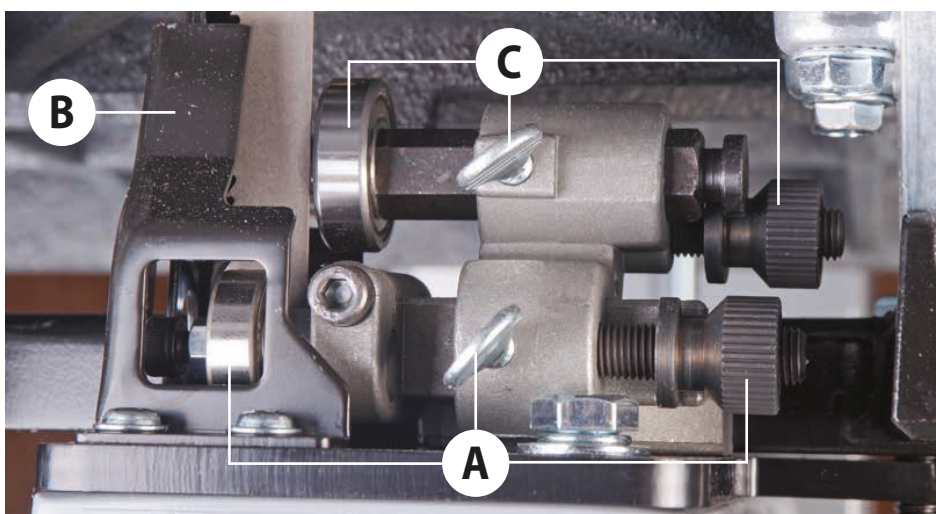
Blade (A), Tyre (B)



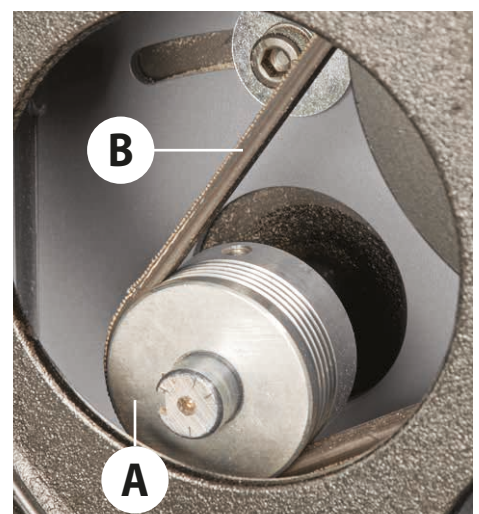
Upper bearing blade guides (A), Rear thrust bearing (B) and rear thrust bearing butterfly clamping screw (C)



Blade tensioning mechanism



Lower bearing blade guide, butterfly clamp and adjusting knob (A), lower bearings guide guard (B) Rear thrust bearing, butterfly clamp and adjusting knob (C)



Drive pulley (A), Pulley belt (B)

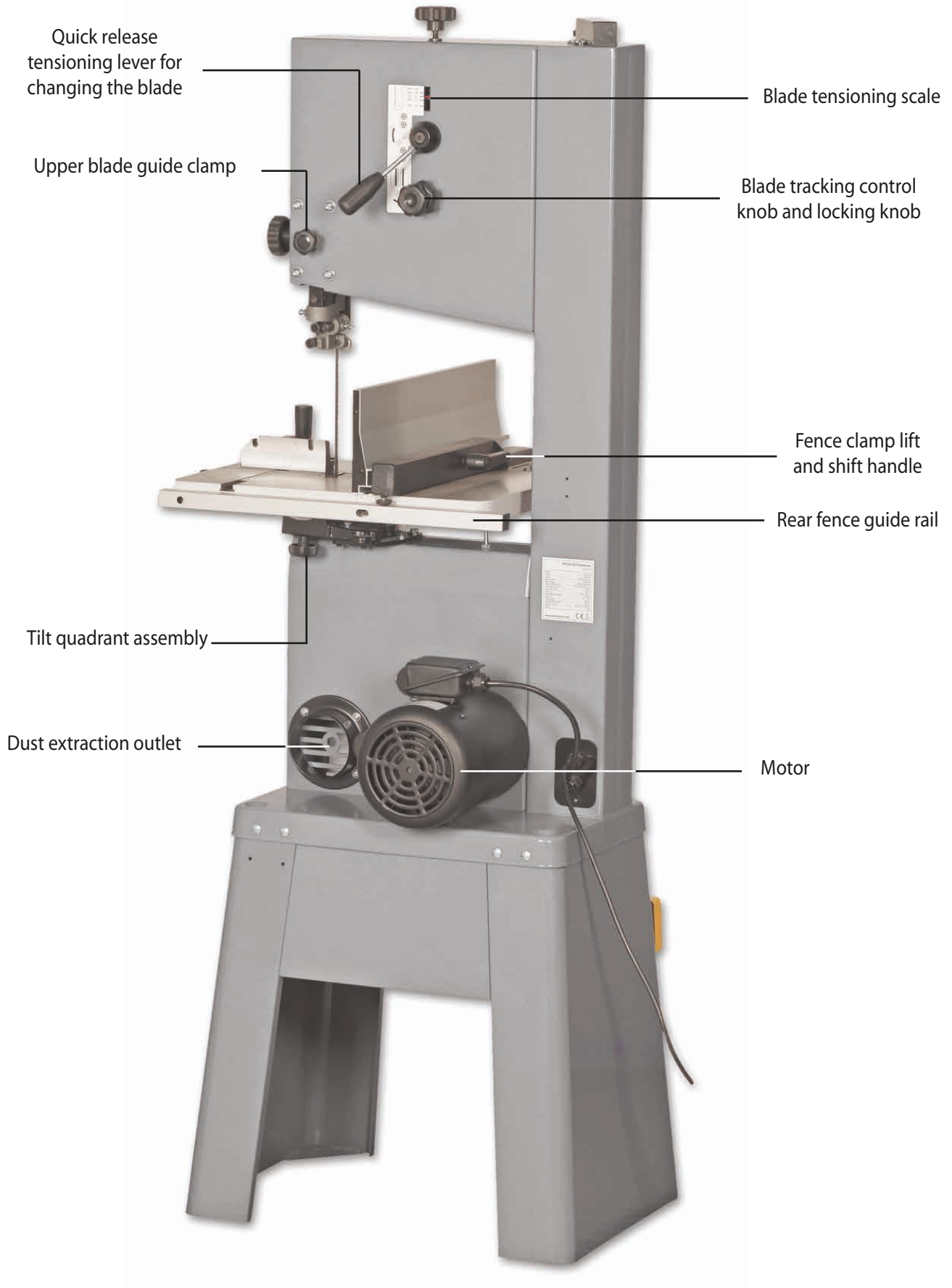
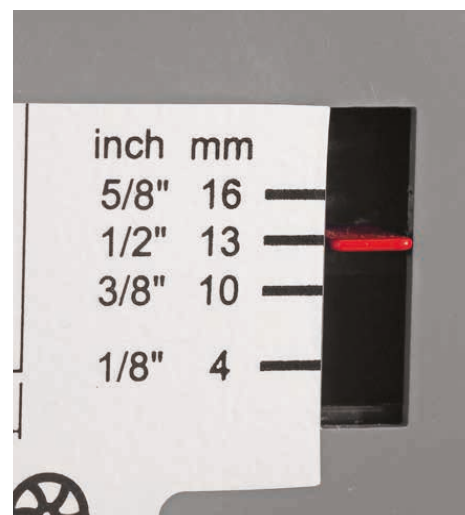


Illustration and Parts Description



Quick release tensioning blade lever (A), Tracking control knob (B) and locking knob (C)



Blade tensioning scale



Upper blade guide clamp

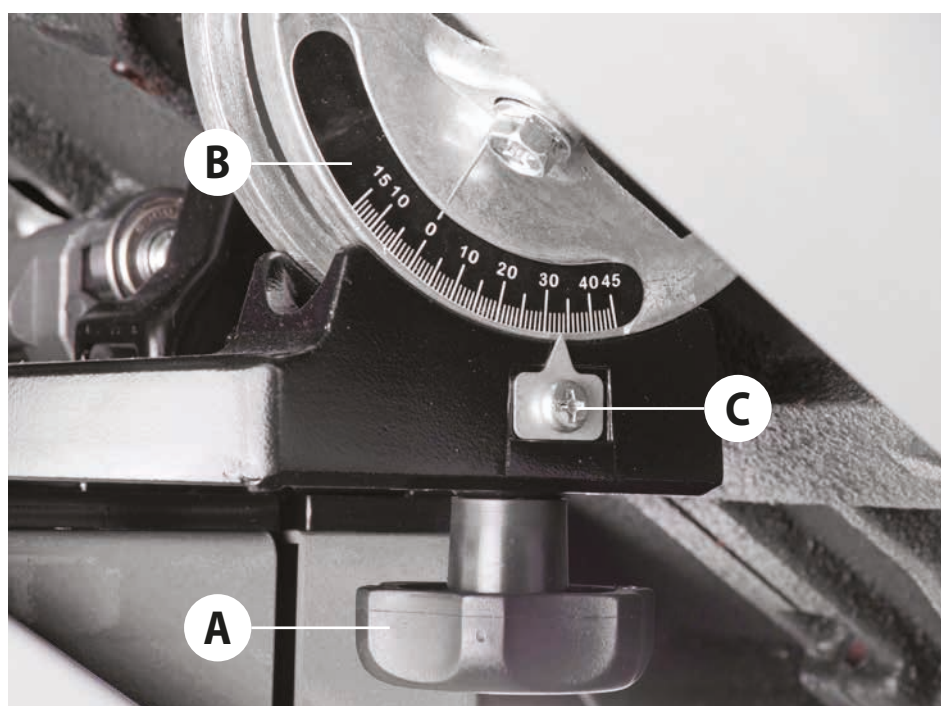


Table tilt clamping knob (A), Table tilt scale (B) and pointer with adjustment screw (C)



Dust extraction outlet



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Tensioning and tracking the blade

Make sure both top and bottom blade guides are well clear of the blade

Open the front covers fully, giving good access to the top compartment of the saw and good visibility into the bottom compartment (see page 17). For tracking the blade, first adjust all bearing guides so that they're well clear of the blade. Check that the blade is sitting approximately in the middle of the wheels, see fig 53. Apply some tension to the blade by turning the tensioning wheel clockwise, see fig 54 spin the top wheel by hand and check that the blade remains centrally on the tyre, see fig 55. If it does not, adjust the tracking by turning the tracking control at the rear of the head box, see fig 56. Viewed directly onto the tracking control wheel, turning clockwise should cause the blade to track to the rear of the tyre; anti-clockwise to the front, DO NOT make large adjustments).

Spin the top wheel again, check again. Continue until the blade tracks in the centre of the tyres with no appreciable to and fro movement. Push the tracking control lock up to lock the setting. Tension the blade fully. A sideways push of about 7-8 lbs (3+kgs) in the middle of the blade should allow a 1/4" (6.5mm) distension. Check the tracking again, adjust if necessary. Check that the drive belt is tensioned correctly. If it is slack, apply 'take up' pressure to the belt by loosening the motor locking Hex bolt (A) and pushing down the motor assembly until the belt is under tension. Then re-tighten the Hex bolt to lock the motor in position, see fig 57-58.

Connect the power to the machine. Stand clear and start the saw. Check that the saw is running smoothly, (no thumps, bumps, knocking or excessive vibration) and the blade appears to be tracking correctly (in one place). You can check this by holding a marker, e.g. a pencil, close to the back of the blade (approach from the back of the blade only) and check that the gap remains constant.

If it doesn't, adjust the tracking until it does. Make very small adjustments and wait for the saw to react before you adjust again, sometimes the reaction is not instantaneous. Once you are satisfied that the tracking is correct, switch the machine off and allow it to run to a complete stop.

Fig 53



Fig 54



Fig 55

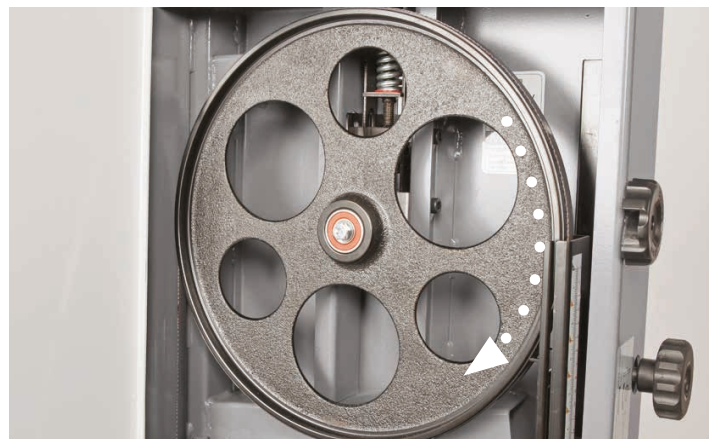
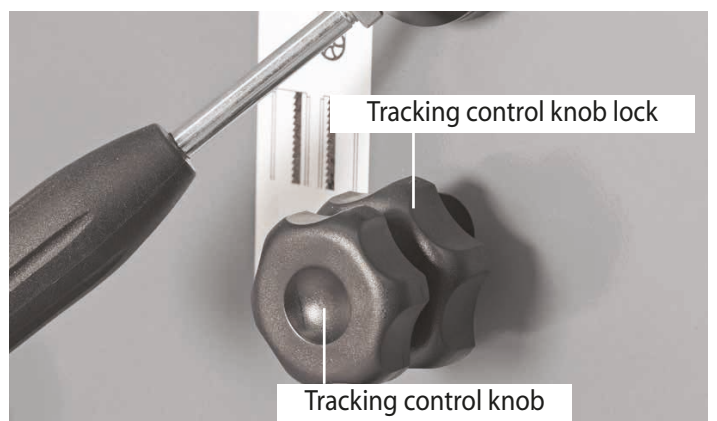


Fig56



Setting Up the Saw

Fig 57-58



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Checking the table is square

Loosen the two clamping knobs beneath the table, clamping the tilt mechanism. Lower the table until its against the stop (19). This is a bolt with a lock nut screwed into the underside of the table, see fig 59. The head of the bolt acts as a stop when it strikes the machine frame. Tighten the clamping knobs.

Fig 59



Make sure the upper blade guide is raised as high as possible. Place a square on the table and move it up against the blade (behind the teeth), see fig 60.

Check that the blade is perpendicular to the table. If it is not, try resetting the table. If it is still not correct, loosen the table locking knobs, see figs 61 and adjust the table stop bolt nut until perpendicularity is achieved, see fig 62

Fig 60

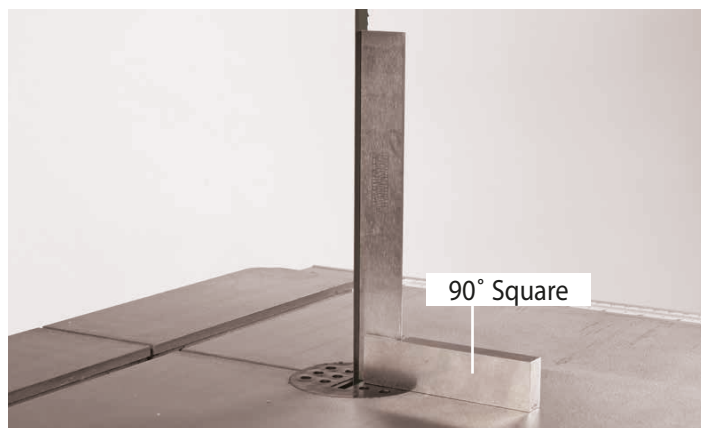
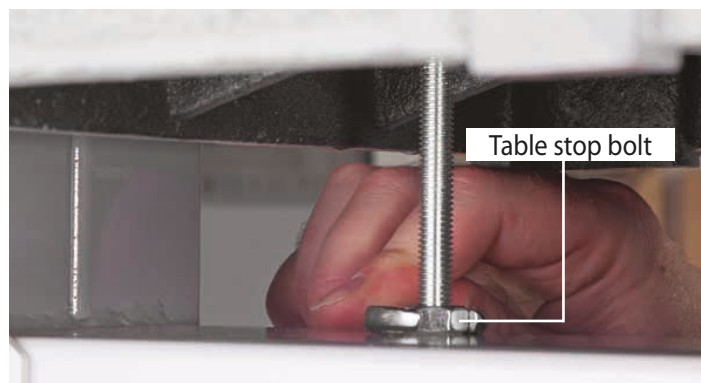


Fig 61

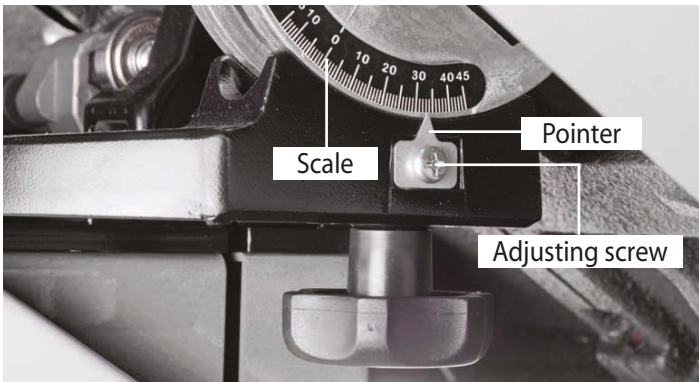


Fig 62



Tighten the lock nut and then re-check. When you are satisfied that the table is set correctly, check that the pointer of the tilt scale reads zero, if not, adjust it, see fig 63. Retighten the table clamping knobs.

Fig 63



Setting the Fence

To make sure the guide fence is at 90° to the table, line up the guide fence with the edge of the table's 'T' slot, see fig 64. If you find that the fence is out of alignment follow the steps below:

- 1** Clamp down the fence by pushing the locking lever down, see fig 65.
- 2** Loosen the 4 Hex bolts that secures the fence and adjust until the fence is in alignment with the 'T' slot in the table, then re-tighten the bolts, see fig 66.
- 3** Replace the fence assembly to its original position.

Fig 64

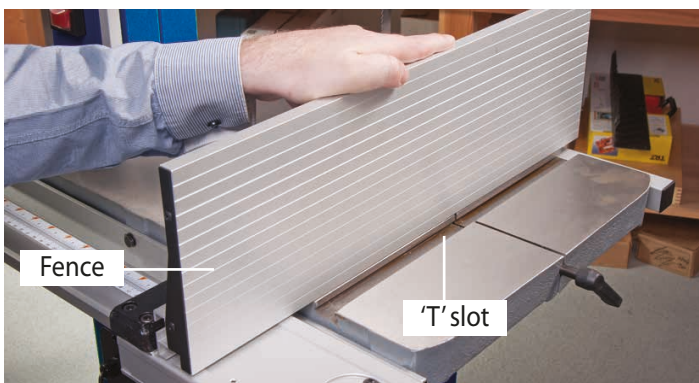
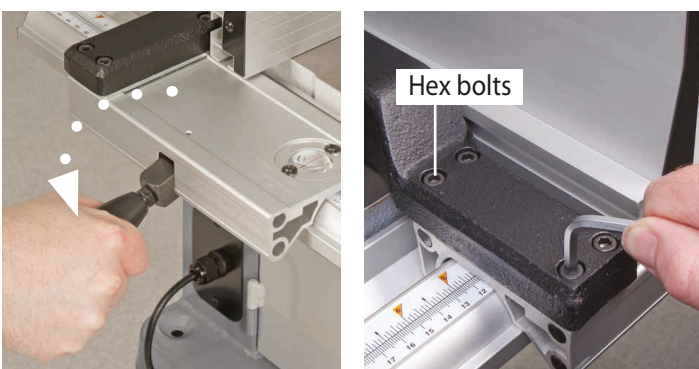


Fig 65-66



Setting the Blade Guides (above table)



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Lower the upper blade guide to approximately 1 1/2" (38mm) above the table. Clamp in place. Loosen the butterfly screw (A), holding the guide assembly in place and adjust the fore and aft position by turning the adjustment knob (B) so that the leading edges of the side guide bearings are approximately 2 mm behind the gullets of the saw blade. Re-tighten the butterfly screw, see fig 67-68. Loosen the butterfly screw (C) that clamps the rear thrust bearing in position and turning the adjustment knob (D) until the thrust bearing is approximately 2mm behind the blade, re-tighten the butterfly screw, see fig 69-70-71.

Fig 67-68

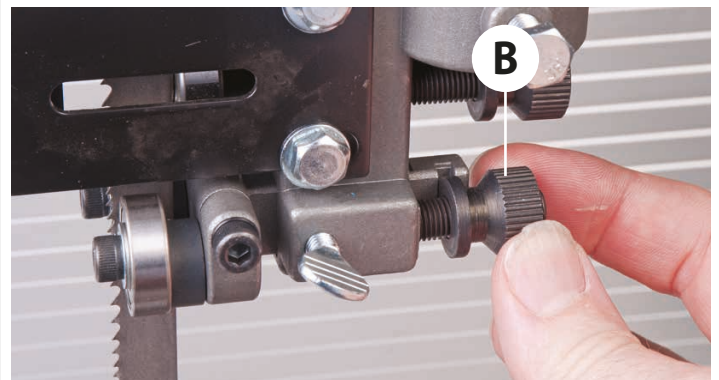
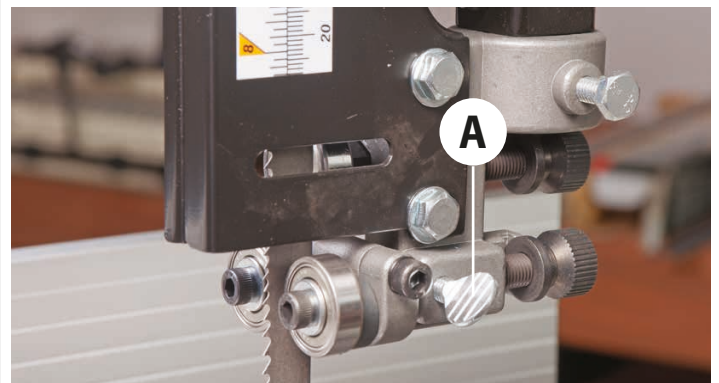
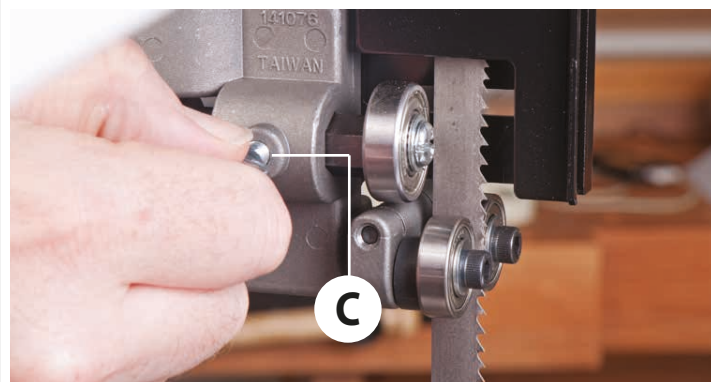
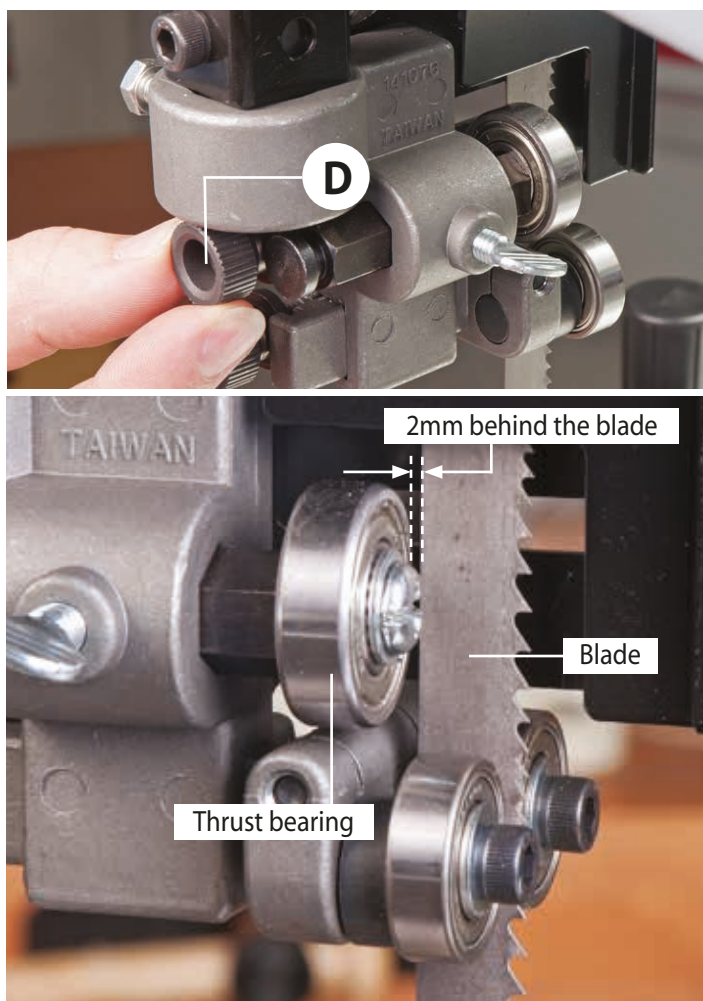


Fig 69



Setting Up the Saw

Fig 70-71



Loosen the Hex screw (A) holding the guide bearings and move to approximately 0.5mm from each side of the blade. **NOTE: A sheet of A4 of photocopier paper is approximately 0.5mm thick.** Adjust the guide bearings by turning the adjusting Hex screw (B), until the bearings are set to the correct thickness. Re-tighten the Hex screw (A), see fig 72-73-74.

Gently push the blade back against the thrust bearing, use a scrap of wood and check that the side bearings are still behind the teeth of the blade.

Fig 72

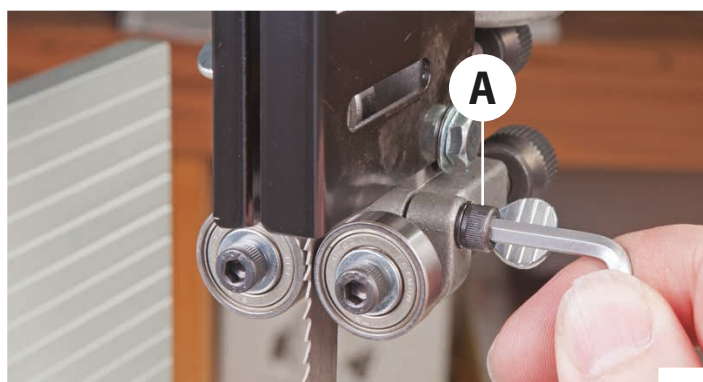
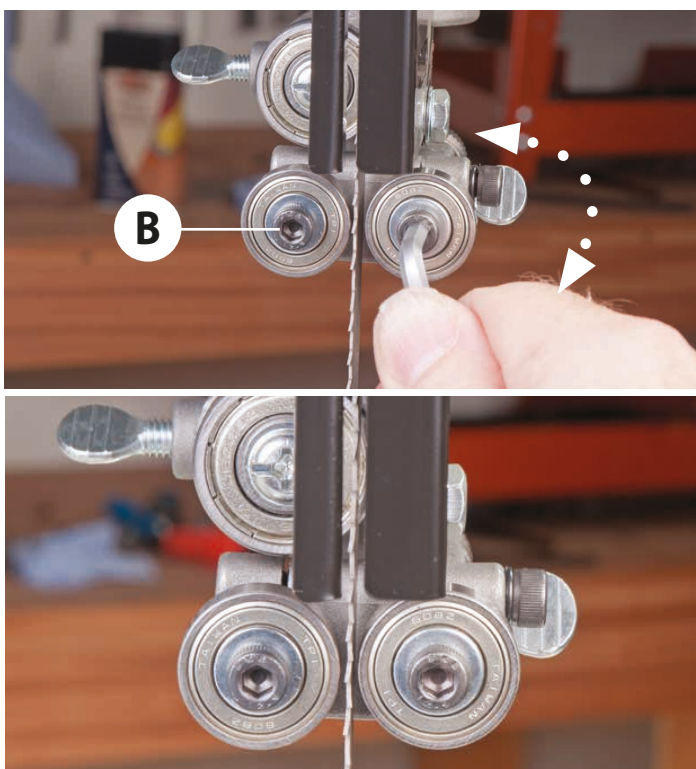


Fig 73-74



Guide bearings set to 0.5 thickness to the blade

Setting the Blade Guides (below table)



IT MAY BE EASIER TO SET THE GUIDE BEARINGS IF THE CAST IRON TABLE (1) IS REMOVED, REFER TO MAIN ASSEMBLY INSTRUCTIONS.

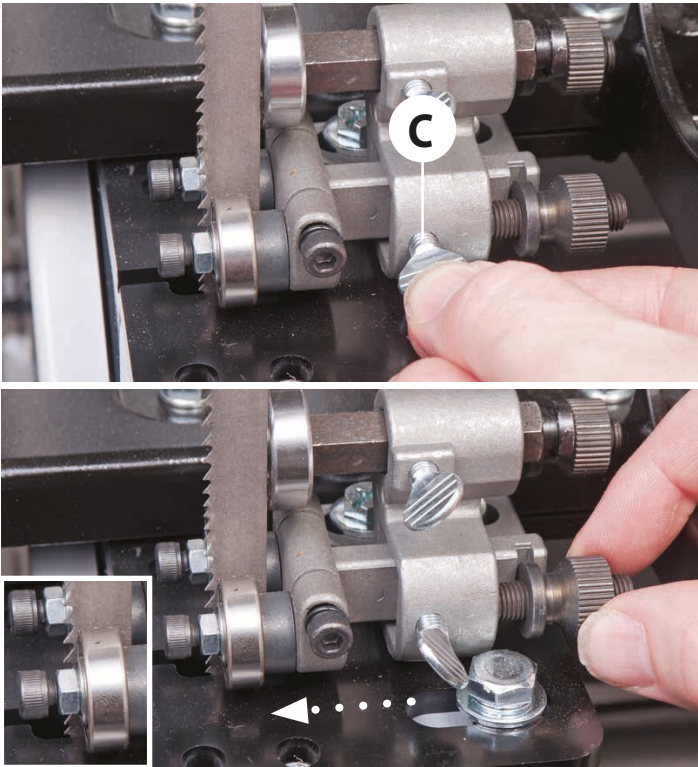
Remove the guide bearing guards and place safely aside, see fig 75. Beneath the table loosen the butterfly screw (C) holding the lower blade guide assembly in place and position so that the leading edges of the side guide bearings are approximately 2mm behind the gullets of the saw blade. Re-tighten the butterfly screw (C), see fig 76-77.

Note: The guide bearing should always be set behind the teeth of the saw.

Fig 75

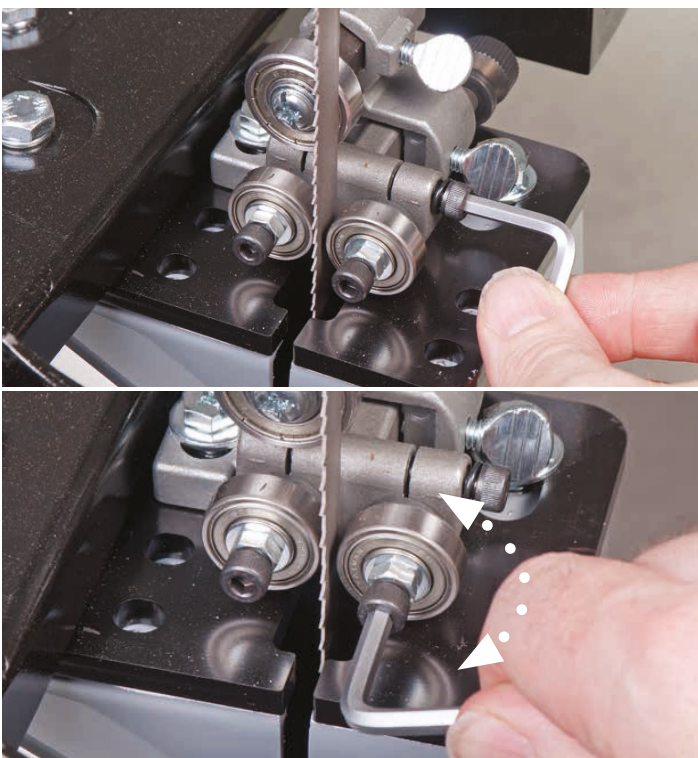


Fig 76-77



Rotate the top wheel by hand, at this point. None of the bearings should come into contact with the blade, only when in use. Adjust the lower blade guides, and set them similarly to the upper guides, using a Hex key to release and tighten the Hex screws, see figs 78-79.

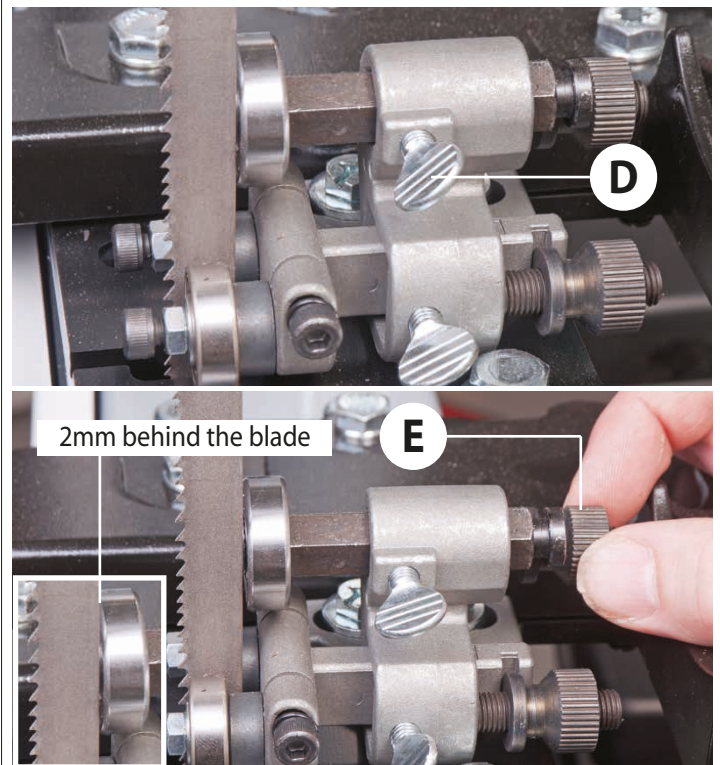
Fig 78-79



To adjust the lower thrust bearing, loosen the butterfly screw (**D**), see fig 80, turn the adjusting knob (**E**) to move the thrust bearing approximately 2mm behind the blade, see fig 82. Re-tighten the butterfly screw (**D**).

When all adjustments have been made, recheck that when the blade is pressed back against the thrust bearing, both the upper and lower side guides are still behind the teeth of the saw. Replace the guide bearing guards you removed earlier, see fig 75 and replace the cast iron table.

Fig 81-82



When all adjustments are complete re-connect the power, switch the saw on and allow to run for several minutes. Check that the blade is still tracking correctly, there is no excessive vibration, etc. Switch off. **The saw is ready to be used.**

Electro-magnetic Motor Brake Switch

The electro-magnetic brake switch is located above the NVR switch assembly and has three positions, see fig 83.

- Position **(0)** engages the motor brake to prevent the bandsaw blade from moving and to isolate the bandsaw to prevent it from being started accidentally, see fig 84.
- Position **(1)** releases the motor brake allowing the blade to turn freely for changing and for tracking purposes, see fig 85.
- Position **(2)** is for running the machine. Move the selector switch to this position then press the 'Green' button on the NVR switch to start the bandsaw, see fig 86.

Fig 83

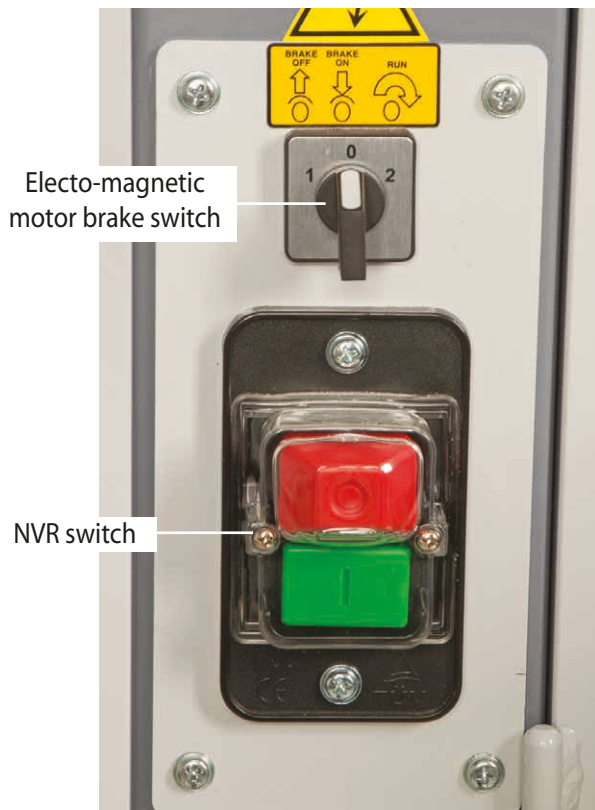


Fig 84



Fig 85



Fig 86



1. Make sure you have read and fully understood the general instructions and safety precautions that are printed in the preceding pages of this manual.

2. Before connecting the machine to the supply; check the machine for obvious signs of damage, paying particular attention to the plug and the power cable. Rectify or have rectified any damage you discover. Check that the blade you are using is the correct one for the job

1. Make sure you have read and fully understood the general instructions and safety precautions that are printed in the preceding pages of this manual.

2. Before connecting the machine to the supply; check the machine for obvious signs of damage, paying particular attention to the plug and the power cable. Rectify or have rectified any damage you discover. Check that the blade you are using is the correct one for the job in hand. Change the blade if necessary. Check the blade is not damaged; is clean, sharp, tracks properly and is correctly tensioned.

3. Set the upper blade guide to approximately 12mm (1/2") above the height of the work piece.

4. Check, especially on site, that there are no foreign objects e.g. old nails, screws, small stones etc embedded in the material you are about to cut.

5. Check that all accessories, tools etc., that have been used to set the machine up, are removed and set carefully aside or stowed away correctly.

6. Ensure the machine is switched off. Plug the power cable into a correctly rated switched socket outlet. If extension leads are being used, check these for damage, do not use if damaged. If you are working outside, check that any extension cables in use are rated for outside work. Switch on. Allow the saw to run up to speed.

7. Make sure that the material you are about to cut is within the machine's capacity, and the cut you are about to make is within the blades' capabilities, e.g. do not try to cut a 1" radius curve using a 5/8" blade.

8. Make sure the blade is not in contact with the material when you start the saw. Start the cutting operation. Do not try to cut too quickly; the correct cutting speed, if one could be so precise, would never see the blade pushed back against the thrust bearing, the saw would cut and clear the saw line at the rate the work piece was fed into it. If you notice that you require more and more pressure to effect the cut, and the blade is in continual contact with the thrust bearing, the chances are the blade is becoming blunt. Check and change if necessary.

Do not let go of the work piece, if you have to change your grip, make sure one hand is holding the material at all times.

9. If you are cutting long pieces of material think about sawing cutouts (i.e. a saw cut from the edge of the material to the saw line) along the saw line so that you can discard the off cuts as you progress down the saw line.

10. Observe the old woodworkers' adage of never allowing your hand/fingers within one handbreadth of the blade.

11. If you have to cut very small pieces of material, arrange or manufacture some form of 'shoe' to carry the timber. If the work piece is exceptionally small, find something to use as a sacrificial carrier and mount the work piece on it with double sided tape, or similar.

12. Remember to check the blade tension after a new blade has been 'working' for 30-60 mins. The blade will 'stretch' slightly when new.

13. Do not release the tension on the saw blade when work is complete. The blades and the main saw frame do not respond kindly to constant changes in stress and tension. Only release the tension to change the blade or once work has finished for the day. The blade in tension over a long period of non-use will cause the tyres to develop 'flat' spot. Open the saw cut, either by pulling apart or driving a wedge in close to the back of the blade. Try to wriggle the blade free of the saw. If this is not possible; check that the saw is free in the cut, start the saw, allow it to run up to speed and 'cut out' as quickly as possible. The removal of the 'off cut' may well prevent the saw jamming again if you resume the original cut.



**WARNING! IF THE SAW JAMS!
SWITCH OFF IMMEDIATELY.**

Changing the Saw Blade

Put the table back to the level position if it has been tilted. Move the motor brake selector switch to position (1), see fig 85 and set the upper blade guide assembly approximately midway in the throat. Open the top and bottom covering doors and remove the table insert.

Remove the table stabilising bolt, release the blade tension by pulling the quick release lever towards you, see fig 87, the blade can be easily slipped off the wheels. Remove the blade carefully, 'wiggling' it clear of the upper blade guard and through the plastic lower blade guard and out through the slot in the table. NOW is an excellent time to clean out the interior of the machine; remove the impacted 'crud' from the tyres, apply a little light oil to the screw threads of the blade and drive belt tensioners and the tracking control. The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the drive belt tensioner in its slot could likewise be lightly oiled. If you are fitting a new blade, it will have been supplied to you "folded", bound together in this configuration with tape or tie wrap.

Fig 87



WARNING! BE VERY CAUTIOUS WHEN YOU 'UNFOLD' THE BLADE; IT TENDS TO 'SPRING' OPEN, BLADE AND TEETH GOING EVERYWHERE.

Also check that the blade did not "unfold" inside out. i.e. looking at the right side front of the loop, the teeth should be on the front of the blade and pointing down. If you can't arrive at this view, turn the blade inside out from its current position and look again.



MAKE SURE THE BLADE TEETH ARE POINTING DOWN!

Open up all blade guides so that they are clear of the blade. Hold the blade approximately midway on either side of the loop and feed it into the table slot. When you get to the table insert cutout void, work the left side of the loop into the slot in the guard in the neck of the main saw frame. 'Wriggle' the right hand side of the blade through the slot in the lower bearing guide guards and through the guard on the upper blade guide assembly, see figs 88-89-90.

Fig 88

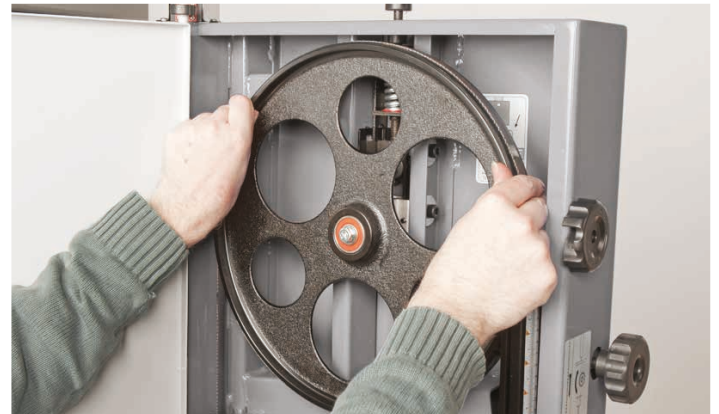
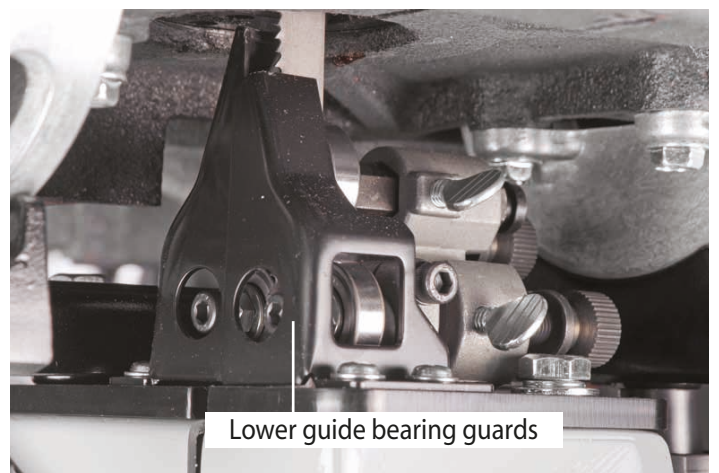


Fig 89-90



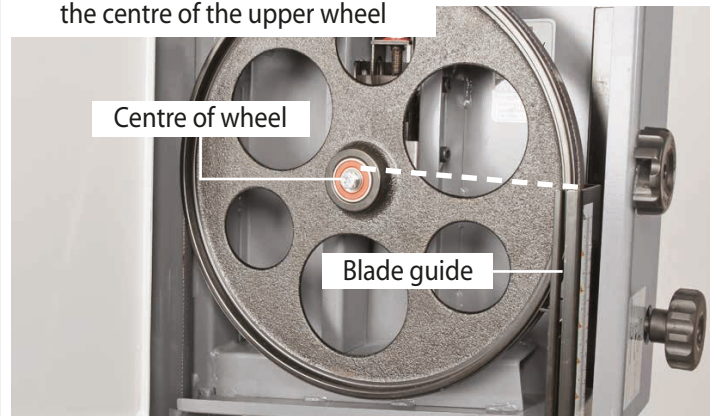
Ease the blade over the wheels and locate the blade in the blade guides. Check that the blade is sitting approximately in the middle of the wheels and re-tension the blade by pushing the quick release lever forward.

Turn the top wheel by hand to ensure the blade will not skip off the wheels and the blade is travelling in the blade guides. When you are sure that the blade is "ON" and stable, re-fit the table stabilising bolt and re-fit the table insert. Loosen the upper blade guide clamp and set the upper blade guide assembly so that the top of the blade guide is level with the centre of the top drive wheel, see fig 91. Re-tighten the clamp.

Now carry out the procedures as detailed in Setting up the Saw.

Top of blade guide lined up with the centre of the upper wheel

Fig 91



Maintenance

Daily

- Keep the machine clean.
- Check the saw blade for missing teeth and cracks, see fig 93.
- Spray oil the bare metal surfaces.

Weekly

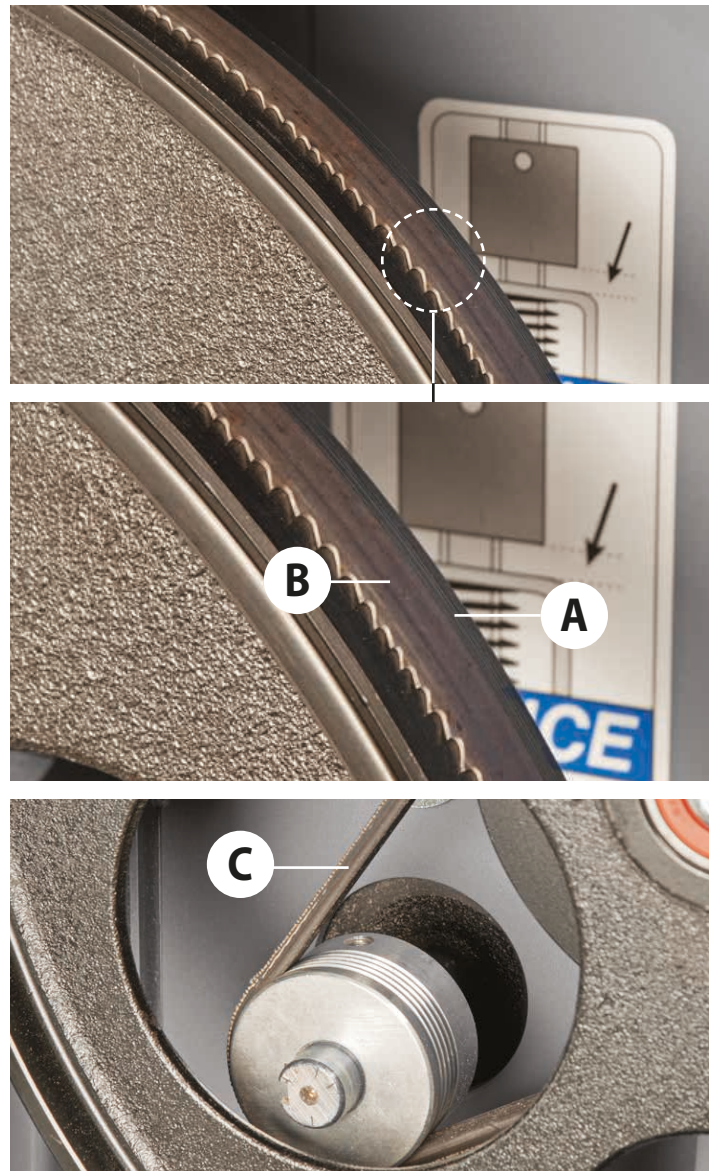
- Open the top and bottom wheel covers and clean out all saw dust.

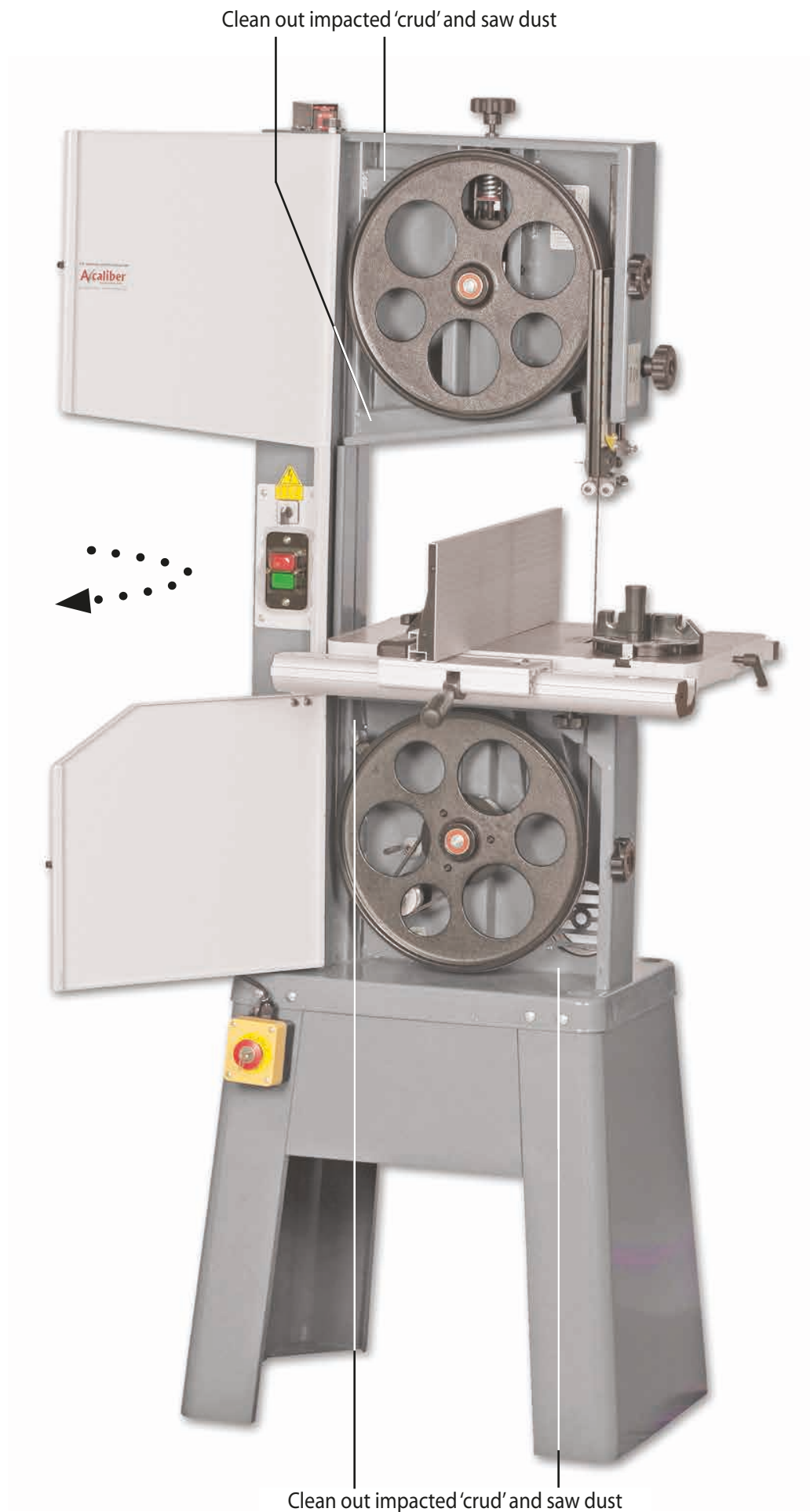
Monthly

- Open the lower and upper door and check the condition of the tyres and the drive belt, see figs 92-93-94.
- Clean impacted 'crud' from the tyres, apply a little oil to the screw threads of the blade and drive belt tensioners. **DO NOT USE OIL** near the belt.
- The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the belt tensioner in its slot could likewise be lightly oiled.
- Using an air line (**wearing goggles**) blow out the motor casing.

- Check the condition of the tyres (A)
- Check for missing teeth (B)
- Check the condition of the drive belt (C)

Fig 92-93-94





Exploded Diagrams/Lists

Item	Part No	Description	Size	Qty	Note
1	130075	BODY		1	
2	130091	UPPER DOOR ASS'Y		1	
3	130092	LOWER DOOR ASS'Y		1	
4	SR060200	SOCKET CAP BOLT	M6x10	4	
5	WS060000	SPRING WASHER	M6	4	
6	SR059300	SOCKET CAP BOLT	M5x12	1	
7	130017	BIAS SHAFT		1	
8	130018	BIAS SHAFT CLAMP SEAT		1	
9	130020	ADJUST SHOES		1	
10	SM080400	SOCKET CAP BOLT	M8x20	1	
11	NH081300	NUT	M8	1	
12	130041	HANDLE		1	
13	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	4	
14	SF040700	PAN HEAD BOLT W/FLANGE	M4x35	2	
15	136012	LIMIT SWITCH	AZD-1112	1	
16	130046	COVER		1	
17	130047	FIXED PLATE		1	
18	136009	SWITCH BUSHING		1	
19	SS050100	SET SCREW	M5x5	1	
20	IC130011	STOP SWITCH CORD		1	
21	SR060200	SOCKET CAP BOLT	M6x10	2	
22	WS080000	SPRING WASHER	M8	4	
23	SJ080400	SOCKET CAP BOLT	M8x20	4	
24	990656	LOCK KNOB	M8x25	1	
25	130011	UPPER SUPPORT BRACKET POST		1	
26	SN040100	COUNTERSUNK HEAD BOLT	M4x5	6	
27	130032	SPRING PIECE		1	
28	130012	ADJUST GEAR		1	
29	135043	BUSHING		1	
30	130016	GEAR FIXED		1	
31	WS060000	SPRING WASHER	M6	2	
32	SR060200	SOCKET CAP BOLT	M6x10	2	
33	130053	PAD		2	
34	SR060700	SOCKET CAP BOLT	M6x35	1	
35	SN040100	COUNTERSUNK HEAD BOLT	M4x5	3	
36	130010	GEAR ROW		1	
37	620029	ADJUST NUT		2	
38	130009	GUIDE SHAFT		1	
39	130025	CHANGE SHAFT		1	
40	135073	STEP SCREW		1	
41	992432	PLASTIC WASHER	6x13 t=2	1	
42	NL061000	NYLON NUT	M6	1	
43	AB150222	UPPER SUPPORT ASS'Y		1	
44	AB150213	LOWER SUPPORT ASS'Y		1	
50	130030	FREE BOARD		1	

51	130031	BLADE COVER		1	
52	SH069200	HEX HEAD BOLT	M6x8	2	
53	WF061310	FLAT WASHER	M6x 13	2	
54	SF069200	PAN HEAD BOLT W/FLANGE	M6x8	2	
55	130033	CAM		1	
56	130044	FIXED RING		1	
57	SS050100	SET SCREW	M5x5	1	
58	130036	ADJUST SCREW		1	
59	130022	SUPPORT SEAT		1	
60	130048	SPRING		1	
61	130023	INDICATOR		1	
62	130019	FREE NUT		1	
63	100152	LOCK KNOB	M8x45	1	
64	990657	KNOB NUT		1	
65	WF061310	FLAT WASHER	M6x13	2	
66	991608	PULL NUT	M8	2	
67	130015	UPPER WHEEL FIXED SEAT		1	
68	130028	FREE KEY	12x12	1	
69	SR089400	SOCKET CAP BOLT	M8x16	4	
70	WS080000	SPRING WASHER	M8	4	
71	WF082320	FLAT WASHER	M8x23	4	
72	130026	REVOLVING SPINDLE		1	
73	130006	UPPER WHEEL JUMP SEAT		1	
74	PS053500	SPRING PIN	5x35	3	
75	130007	UPPER WHEEL SHAFT		1	
76	WW152203	WAVES WASHER	15x22	2	
77	AB100247B	UPPER WHEEL		1	
79	SH089400	HEX HEAD BOLT	M8x16	2	
80	WS080000	SPRING WASHER	M8	2	
81	WF081818	FLAT WASHER	M8x18	2	
82	BB620201A	BALL BEARING	6202Z	4	
83	RR350000	RETAINING RING	R35	4	
84	135108	MULTIFINGER SWITCH		1	
85	136019	WIRE CONNECTOR	224-201	1	
86	NH182601	NUT	M18x1.5	1	
87	WS180000	SPRING WASHER	M18	1	
88	130002	LOWER WHEEL SHAFT		1	
89	130042	LEFT COVER		1	
90	NH081300	NUT	M8	4	
91	SS080400	SET SCREW	M8x20	7	
92	135013	COVER		1	
93	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	1	
94	412007	INLET		1	
95	SF060200	PAN HEAD BOLT W/FLANGE	M6x10	4	
96	ABMH130014	MOTOR	0.75KW/230V/50HZ	1	
97	KP050520	KEY	5x5x20	1	

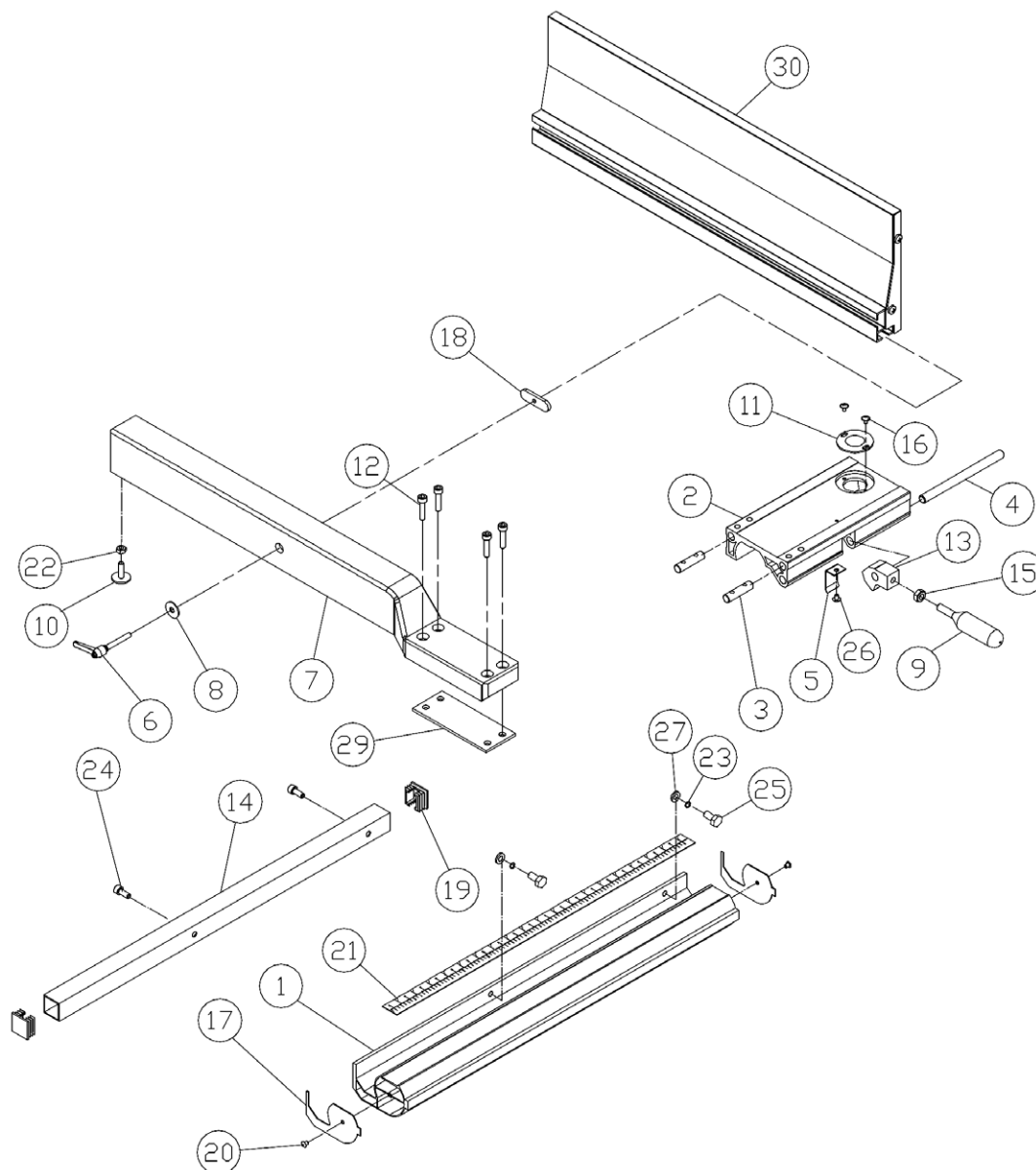
Exploded Diagrams/Lists

99	SF059300	PAN HEAD BOLT W/FLANGE	M5x12	4	
100	SR060400	SOCKET CAP BOLT	M6x20	2	
101	135041	KNOB		2	
102	NL061000	NYLON NUT	M6	4	
103	150031	PIN		2	
104	SF059100	PAN HEAD BOLT W/FLANGE	M5x6	3	
105	130043	RIGHT COVER		1	
110	995081	CLOSE-END CONNECTOR	CE-1	1	
111	130054	POINT		1	
112	SH069300	HEX HEAD BOLT	M6x12	2	
113	WF083030	FLAT WASHER	M8x30	2	
114	WS080000	SPRING WASHER	M8	2	
115	SR080400	SOCKET CAP BOLT	M8x20	2	
116	170507	BRUSH		1	
117	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	1	
118	SH080600	HEX HEAD BOLT	M8x30	3	
119	WS080000	SPRING WASHER	M8	3	
120	110045	TRUNNION SUPPORT BRACKET		1	
121	SH081600	HEX HEAD BOLT	M8x80	1	H
122	NH081300	NUT	M8	1	H
123	110049	POINTER		1	
124	SP059100	PAN HEAD BOLT	M5x6	1	
125	100030	LOCK KNOB	M10	2	H
126	135010	TABLE INSERT		1	
127	130045	TABLE PIN		1	
128	130058	TABLE		1	
129	SH101003	HEX HEAD BOLT	M10x50	2	
130	100041	TRUNNION CLAMP SHOES		2	
131	100042	TRUNNION		2	
132	100051	SCALE		1	
133	SG069300	HEX HEAD FLANGE BOLT	M6x12	6	
134	130024	SAW BLADE	101"/2562x10x0.5mm	1	6TPI
135	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	4	

136	SP040200	PAN HEAD BOLT	M4x10	2	
137	SP059300	PAN HEAD BOLT	M5x12	2	
138	WE050000	STAR WASHER (EXTERNAL)	M5	2	
139	NH050800	NUT	M5	2	
140	IC130015	POWER CORD		1	
141	IM130005	MOTOR CORD		1	
142	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	4	
143	136013	STRAIN RELIEF	PG-13.5	2	
144	136475	PLATE		2	
145	136822	SWITCH PLATE		1	
146	170245	SWITCH	KJD-11-10D(JD3)	1	230V
147	IC130011	LIMIT SWITCH CORD		1	
148	AB198101	MITER GAUGE ASS'Y		1	A.S
150	130055	FIXED BOARD		1	
151	IC135017	CONTROL CORD		1	
153	SR059300	HEX SOCKET BOLT	M5x12	2	
157	130049	FIXED PLATE		1	
158	SH080400	HEX HEAD BOLT	M8x20	3	
159	WS080000	SPRING WASHER	M8	3	
160	WF081818	FLAT WASHER	M8x18	3	
161	130108			1	
162	SS069150	SET SCREW	M6x6	2	
163	709412	STRAIN RELIEF	PG-11	3	
164	135081	RELIEF PLATE		1	
165	IC136004	CONNECTING CORD		1	
166	998628	CORD CLAMP		1	
167	SF059300	PAN HEAD BOLT W/FLANGE	M5x12	1	
168	135019	STOP SWITCH		1	
169	SJ059400	HEX SOCKET BOTTOM HEAD SCREW	M5x16	2	
170	WS050000	SPRING WASHER	M5	2	
171	WF051210	FLAT WASHER	M5x 12	2	
172	NF050800	HEX FLANGE NUT	M5	2	

Exploded Diagrams/Lists

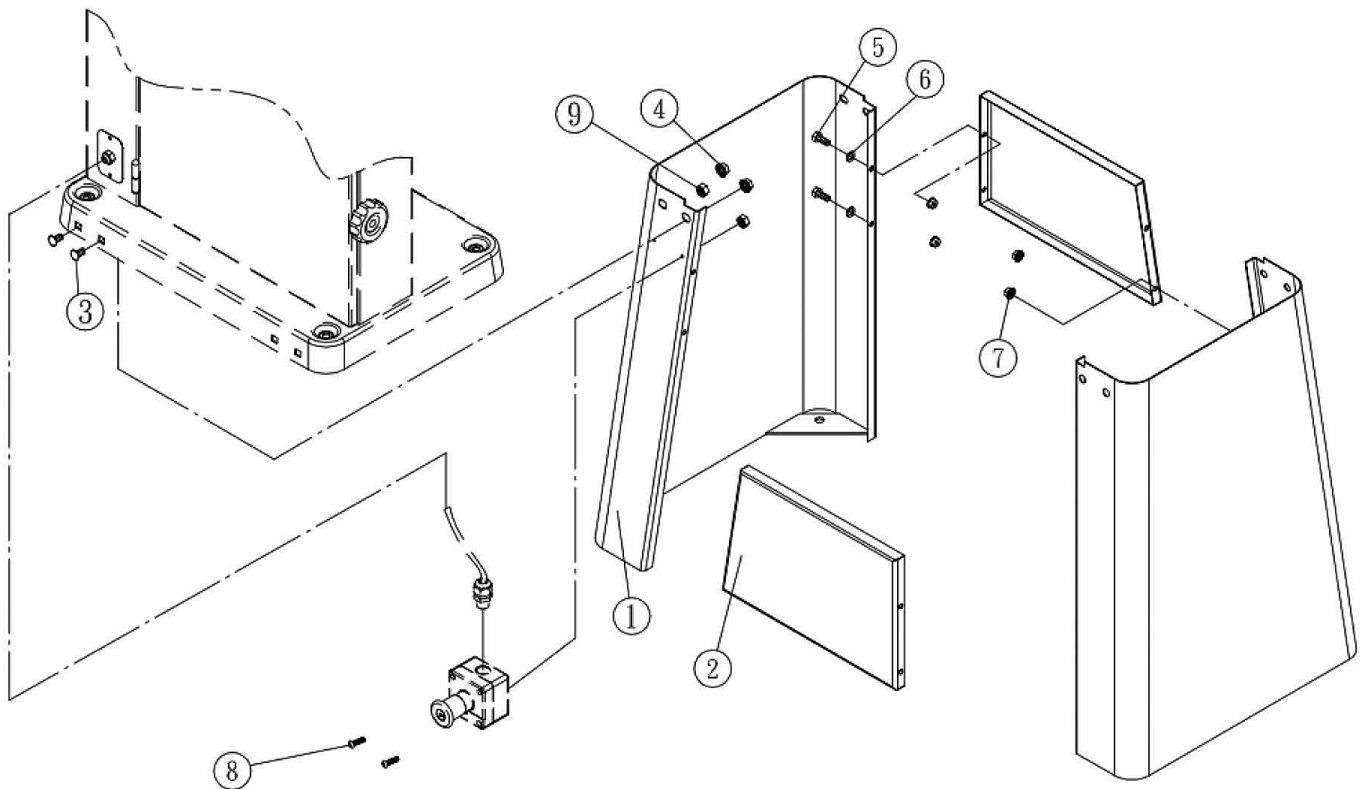
Fence Assembly



No	Part No	Description	Size	Qty
01	198018	FIXED BASE	640	1
02	198002	ADJUST BASE		1
03	198003	FIXED SHAFT		2
04	198005	SHAFT		1
05	198006	SPRING WASHER		1
06	198074	LOCK KNOB	M8x44	1
07	198077	SUPPORT TUBE	590	1
08	WE082320	FLAT WASHER	M8xΦ23	1
09	198013	HANDLE		1
10	198012	ADJUST SCREW		1
11	198007	CONVEX		1
12	SR060500	HEX SOCKET BOLT	M6x25	4
13	198004	FIXED LUMP		1
14	198020	SQUARE TUBE	640	1
15	NH081300	NUT	M8	1

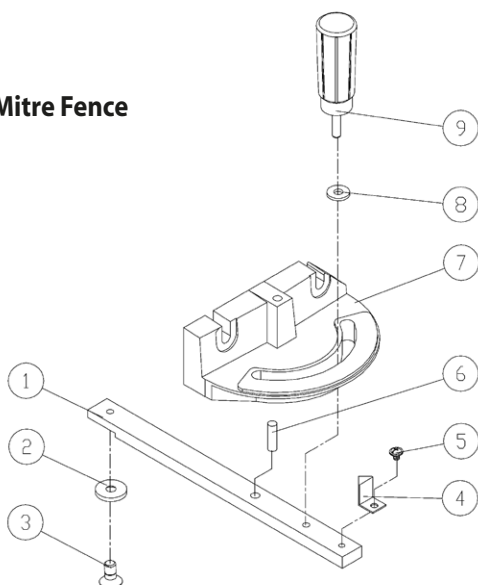
16	SE049100	PAN HEAD SCREW W/FLANGE	M4x6	2
17	198014	GUARD PIECE		2
18	200527	MOVING PLATE		1
19	198016	PLUGGED		2
20	ST039300	TAPPING SCREW	M3.5x12	2
21	LM000539	SCALE		1
22	NH061000	NUT	M6	1
23	WS060000	SPRING WASHER	M6	2
24	SR069400	HEX SOCKET BOLT	M6x16	2
25	SH060400	HEX HEAD BOLT	M6x20	2
26	SF049200	PAN HEAD SCREW W/FLANGE	M4x8	1
27	WE061310	FLAT WASHER	M6x13	2
29	198008	BRACKET	T=3	1
30	AC198082	FENCE	590	1

Stand Assembly



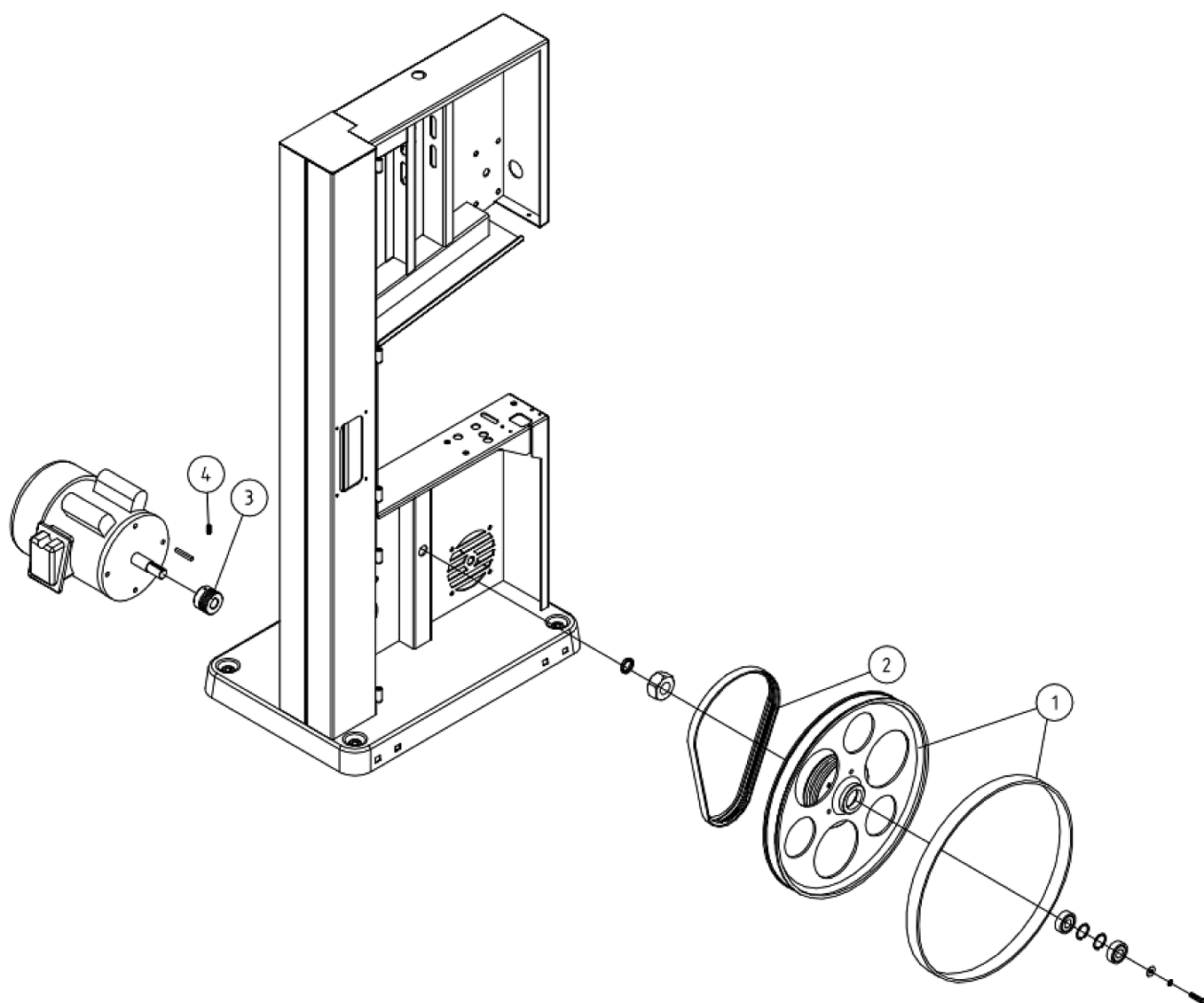
Item	Part No	Description	Size	Qty	Note
1	100144	STAND		2	
2	100164	SIDE COVER		2	
3	SC089400	CRRIAGE BOLT	M8x16	8	H
4	NF081300	NUT	M8	8	H
5	SH069400	HEX HEAD BOLT	M6x16	8	H
6	WF061310	FLAT WASHER	M6x<p13	8	H
7	NF061000	NUT	M6	8	H
8	SP049300	PAN HEAD BOLT W/FLANGE	M4x12	2	H
9	NH040700	NUT	M4	2	H

Mitre Fence



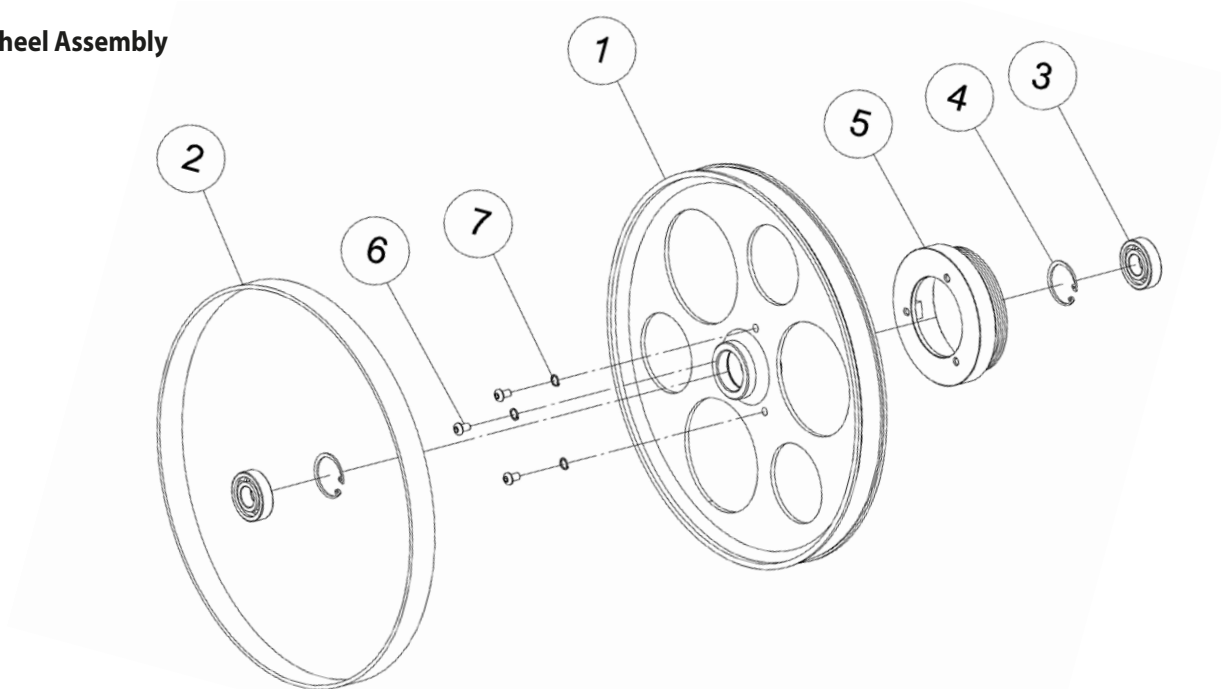
Item	Part No	Description	Size	Qty
01	198101	GUIDE BAR		1
02	198102	GUIDE PIECE		1
03	SN069200	COUNTER SUNK BOLT	M6x6	1
04	198103	POINTER		1
05	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	1
06	198107	STEEL PIN	06,5x10	1
07	198106	MITRE GAUGE BODY		1
08	198104	NYLON WASHER		1
09	198105	HANDLE		1

Single Speed Assembly



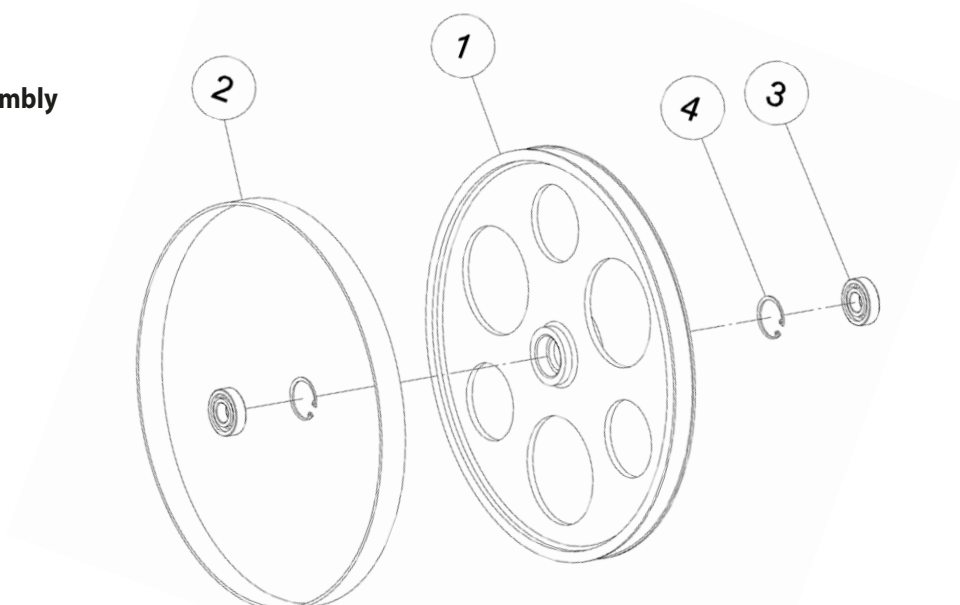
Item	Part No	Description	Size	Qty	Note
1	AB100251B	LOWER WHEEL		1	
2	LJ021050	BELT	210J5	1	
3	130027	MOTOR PULLEY		1	
4	SS060200	SET SCREW	M6x10	1	

Lower Wheel Assembly



Item	Part No	Description	Size	Qty
01	100250	LOWER WHEEL		1
02	150035	WHEEL TYRE		1
03	BB620203	BALL BEARING	6202	2
04	RR350000	RETAINING RING	R35	2
05	100274	PULLEY		1
06	SJ060500	HEX SOCKET BOTTOM HEAD SCREW	M6x25	3
07	WS060000	SPRING WASHER	M6	3

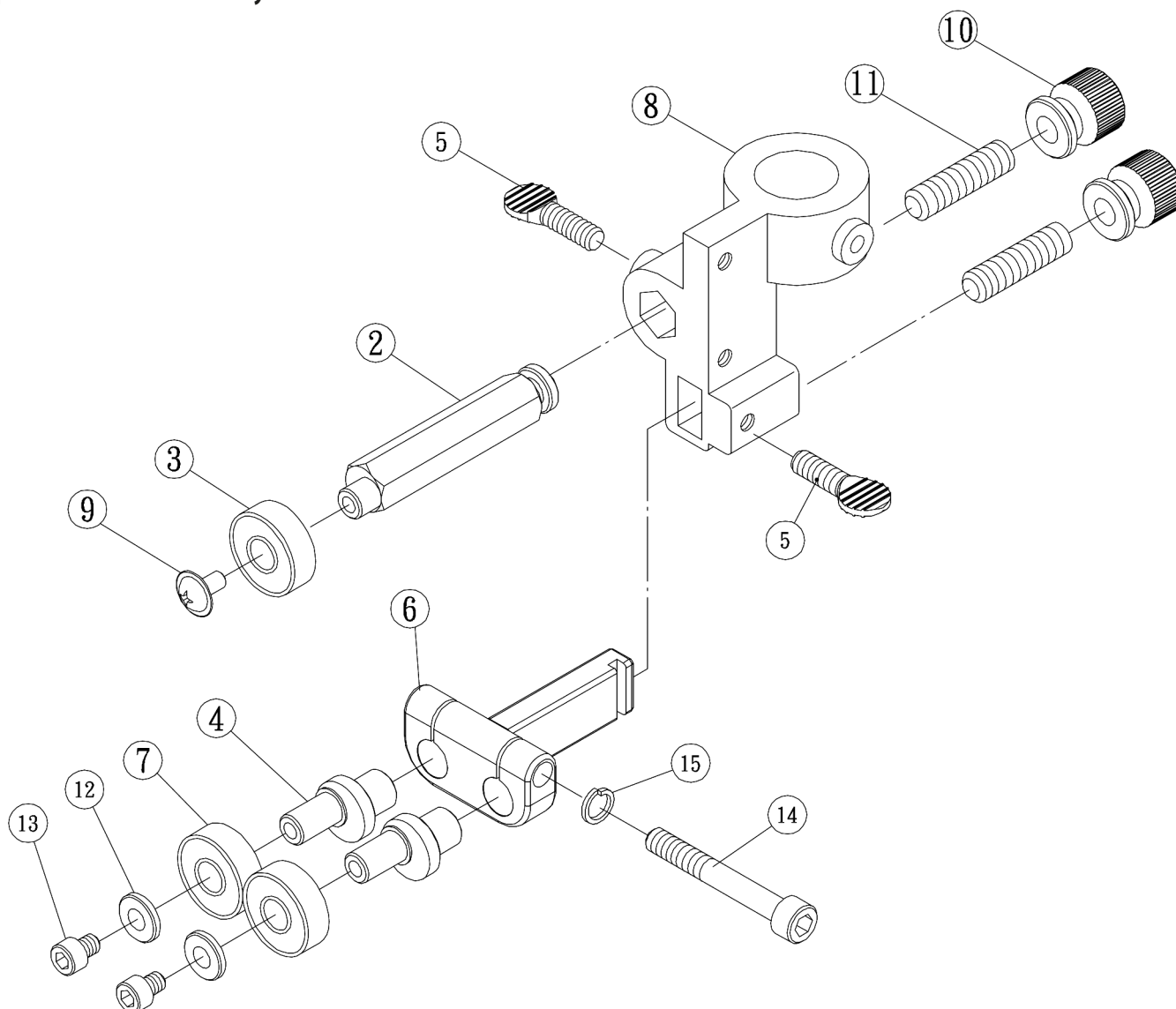
Upper Wheel Assembly



Item	Part No	Description	Size	Qty
01	100247	UPPER WHEEL		1
02	150035	WHEEL TYRE		1
03	BB620203	BALL BEARING	6202	2
04	RR350000	RETAINING RING	R35	2

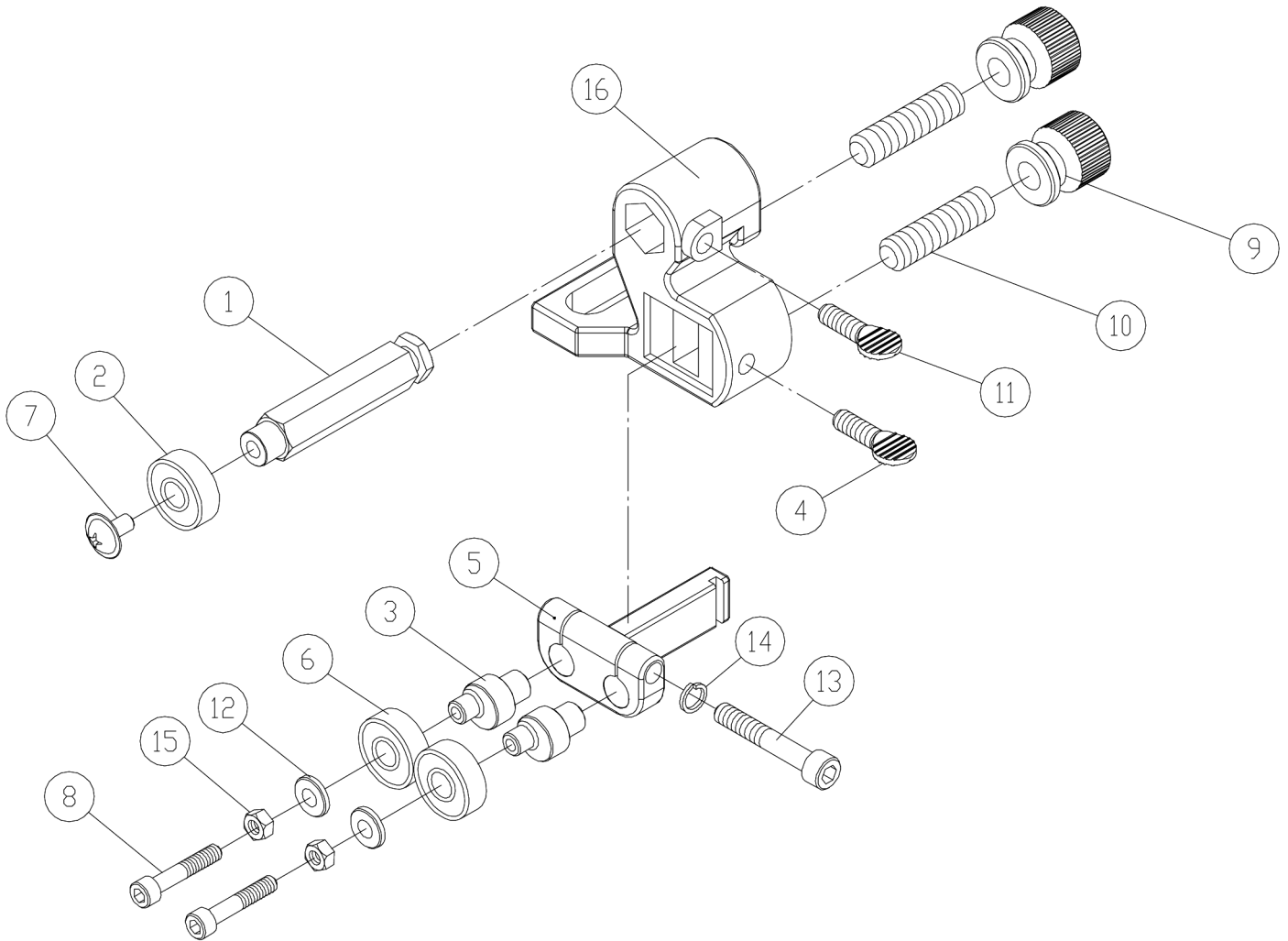
Exploded Diagrams/Lists

Upper Blade Guide Assembly



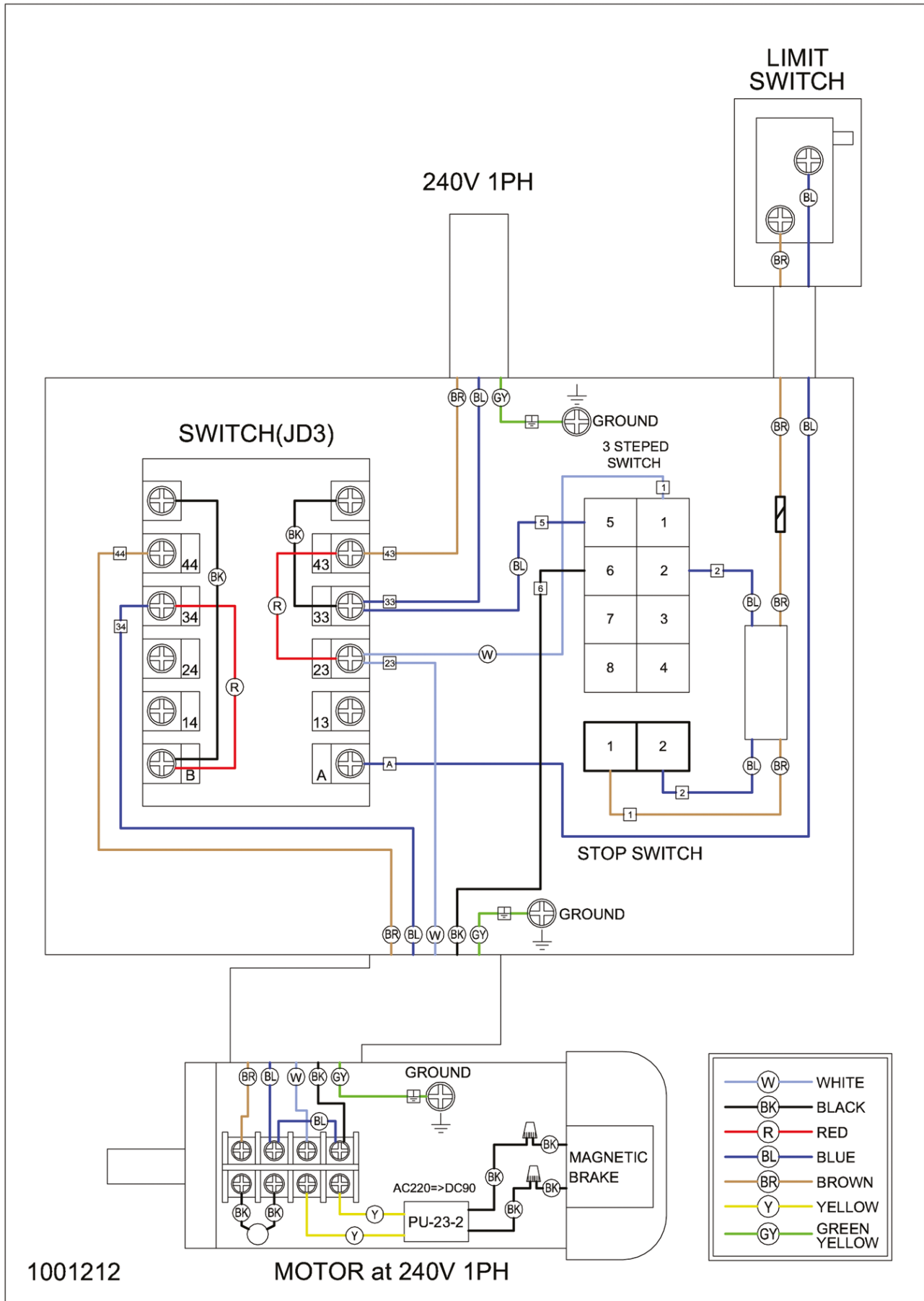
Item	Part No	Description	Size	Qty
02	150015	SPACING SLEEVE		1
03	BB600002A	BALL BEARING	6000ZZ	1
04	150213	CAM SHAFT		2
05	150013	THUMB SCREW	M6x16L	2
06	150207	SUPPORT BRACKET		1
07	BB608002A	BALL BEARING	608ZZ	2
08	141076	UPPER SUPPORT BRACKET POST		1
09	SF069200	PAN HEAD FLANGE BOLT	M6x8L	1
10	150010	ADJUST NUT	M8xI	2
11	SS080801	ADJUST SCREW	M8xI,0x40L	2
12	WF051210	FLAT WASHER	M5x012	2
13	SR059300	HEX SOCKET BOLT	M5xI2L	2
14	SR050803	HEX SOCKET BOLT	M5x40L	1
15	WS050000	SPRING WASHER	M5	1

Lower Blade Guide Assembly



Item	Part No	Description	Size	Qty
01	150015	SPACING SLEEVE		1
02	BB600002A	BALL BEARING	6000ZZ	1
03	150213	CAM SHAFT		2
04	150013	THUMB SCREW	M6xI6L	1
05	150207	SUPPORT BRACKET		1
06	BB608002	BALL BEARING	608ZZ	2
07	SE069200	PAN HEAD BOLT W/FLANGE	M6x8L	1
08	SR050400	HEX SOCKET BOLT	M5x20L	2
09	150010	ADJUST NUT	M8xI	2
10	SS080701	ADJUST SCREW	M8xI.0x35L	2
11	150014	THUMB SCREW	M6xI2L	1
12	WF051210	FLAT WASHER	M5x12	2
13	SR050803	HEX SOCKET BOLT	M5x40L	1
14	VS050000	SPRING WASHER	M5	1
15	NH050800	NUT	M5	2
16	150206	LOWER SUPPORT BRACKET POST		1

Wiring Diagram



This image shows a single sheet of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page. There is no text or other markings on the paper.

The **Axminster guarantee** is available on Craft, Trade, Engineer, Air Tools & CNC Technology Series machines

Buy with confidence from Axminster!

So sure are we of the quality, we cover all parts and labour free of charge for three years!



For more information visit axminster.co.uk/3years



The packaging is suitable for recycling.
Please dispose of it in a responsible manner.



EU Countries Only

Do not dispose of electric tools together with household waste material.
By law they must be collected and recycled separately.