

AT254PS16

Panel Saw



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General Information

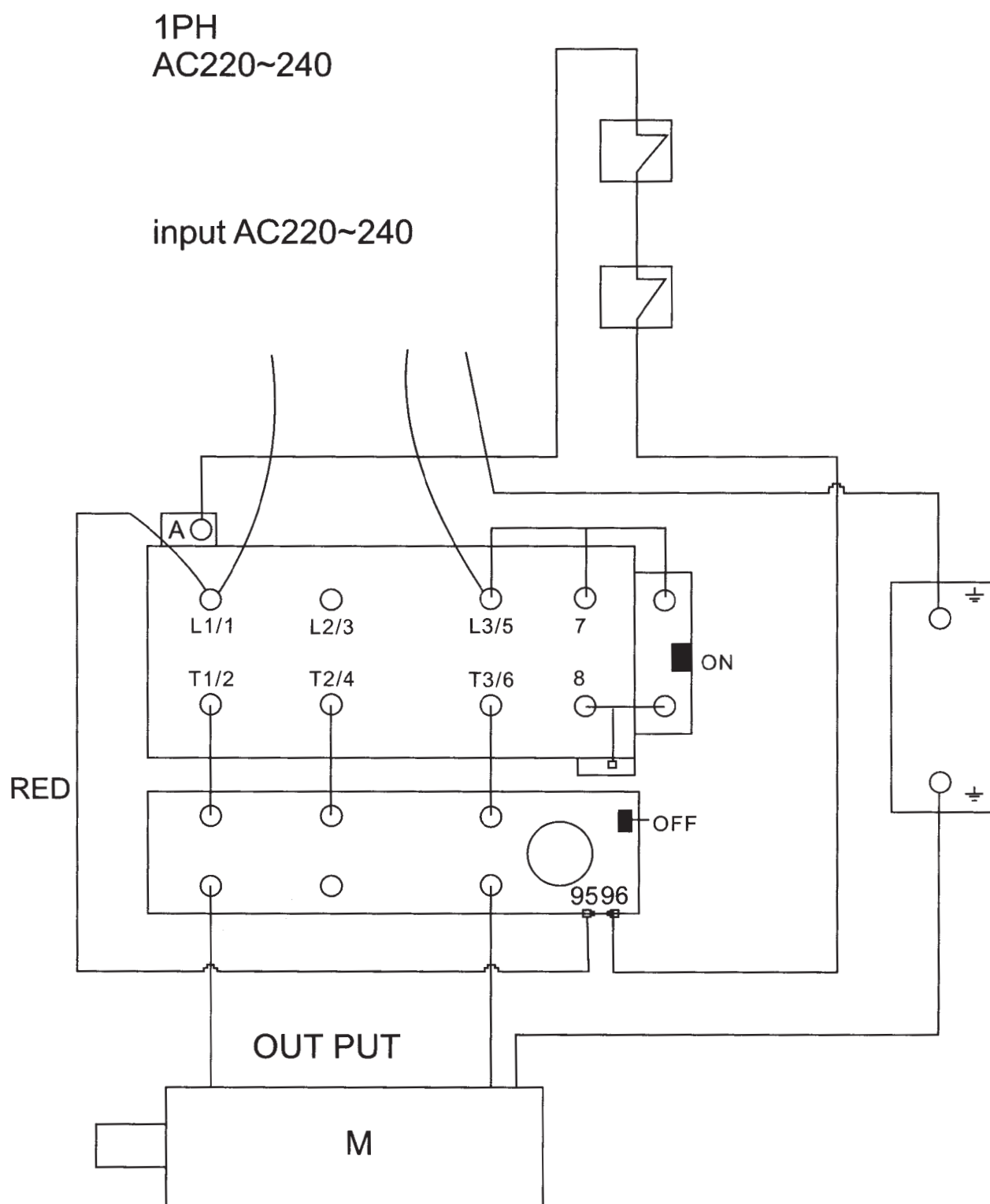
OAV equipment & tools, inc. is specialized to supply full series of panel saw from 1600, 2300, 2500 to 3200mm. The outlook design of this machine is unique, complete cast iron trunnion bracket instead of sheet metal, enlarged outtigger and carriage, direct dust collection outlet. term its overall condition. The table saw is also an important products after our band saw series, please enjoy your operation on this machine and If you have any comment to improve this saw, please don't hesitate to contact us through your agent.

Safety Rules

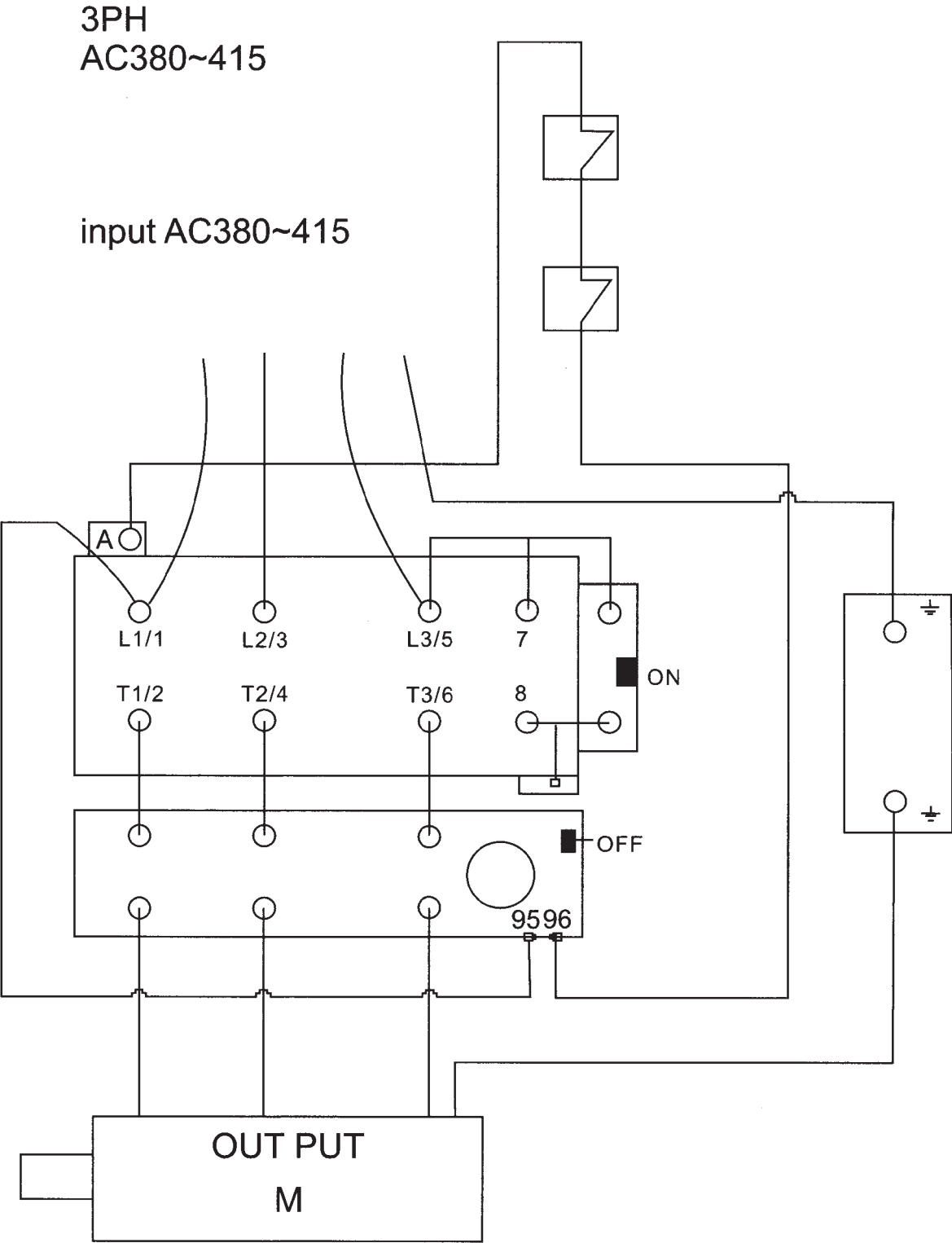
For your own safety read instruction manual before operating

1. To avoid dangerous working environments, do not use stationary machine tools in wet or damp locations, keep work area as clean and well-lit.
2. Wear proper apparel, no loose clothing or jewelry which can get caught in moving parts.
3. Never leave when machine is running.
4. Disconnect electrical power before tools are serviced.
5. Remove adjusting keys and wrenches before turning machine on.
6. Be sure that the keys and adjusting wrenches have been removed and all the nuts and bolts are secured.
7. Keep guards in place and in working order.
8. Keep children and visitors away, they should be kept at a safe distance from the work area. Never leave the machine with power on.
9. Keep hands well away from blades and all moving parts. Do not clear chips and sawdust away with hands.

Wiring diagram



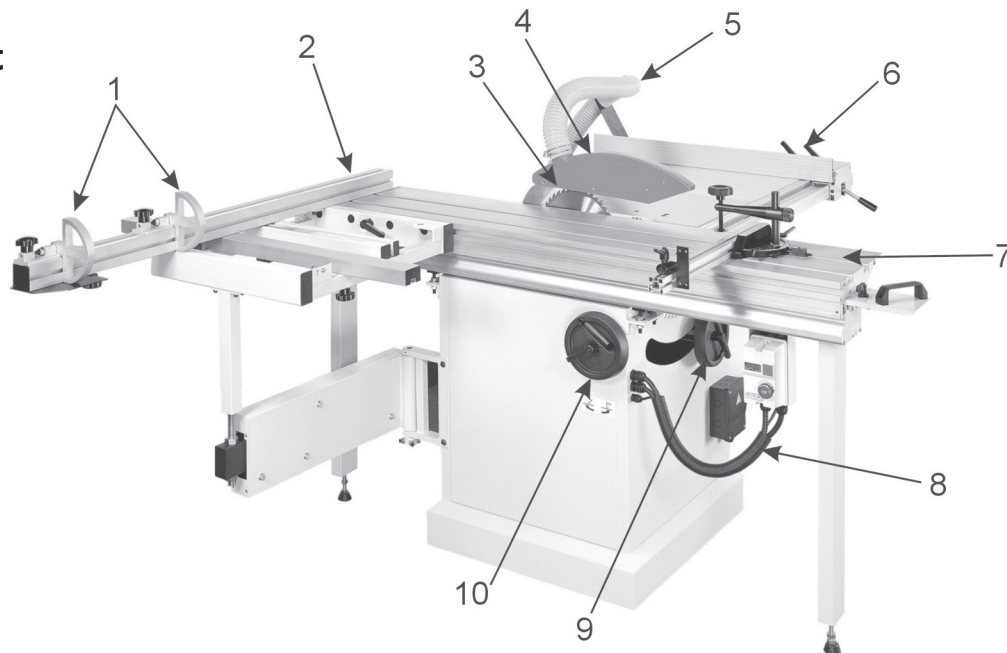
Wiring diagram



SPECIFICATION

Model		10" PANEL SAW	10" PANEL SAW (CE)
Sliding Table Dimension		63x12-7/16"	1600X316mm
Max. Sliding Stroke w/crosscut Fence		63"	1600mm
Max. Sliding Stroke w/o crosscut Fence		74-7/8"	1900mm
Table Height		35-7/8"	912mm
Table Size w/ext. Wing		14-7/8"X27"(40-1/8"X47")	W:377mm X D:688mm(1020mmX1193mm)
Main saw	Max Saw Blade Diameter	10"	254mm
	Saw Blade Arbor Diameter	5/8" (CSA)	30mm (CE)
	Cutting Height at 90, 45°	3-1/8"/2-1/8"	80/57mm
	Motor Power	3HP/3PH	2.25KW/3PH
		(Optional:3HP/1PH, 5PH/3PH)	(Optional :2.25KW/1PH/3.75KW/3PH)
	Spindle RPM	4,000 (Motor RPM 3600)	4,000 (Motor RPM 2875)
Scoring saw	Saw Blade Diameter	3-1/8"	80 mm
	Saw Blade Arbor Diameter	7/8"	20 mm
	Cutting Height at 90, 45°	3/16",3/32"	5mm/3mm
	Motor Power		
	Spindle RPM	8,000	8,000
Ripping Width		33"	838mm
Crosscut Width		54"/92-1/2"	1,380mm/2,350mm
Blade Height Adjustment		Manual	
Blade Tilting Adjustment		Manual, 0-45°	
Electric Control System		Magnetic switch	Magnetic switch
Dust Collection System		Main Channel 4" (100 mm), Saw Blade Guard Extract 2-1/2" (60 mm)	
Standard Accessories		Extruded Profile Rip Fence	
		Sheet Metal Extension Table X 2 PCS	
		Standard Saw Blade Guard	
		Standard Miter fence, Scoring Saw Blade	
Optional Accessories		Main Saw Blade, Edge Shoe	
		Saw Blade Hose Support Plate and Hose	
Remark: Due to needs of continuous improvement, specifications are subject to change without prior notice.			

Main Feat



1. Flip Stopper-Large stopper for accurate measurements
2. Crosscut Fence-90° and 45° quick position design for a precise crosscutting operation
3. Riving Knife : It is prevent kickback caused by the knife closing behind the blade
4. Saw blade guard : Fully adjustable blade maintains maximum protection around the saw blade.
5. Hose Support Plate and Hose : To collect the dust chip efficiency
6. Rip Fence : For smooth and precise cutting
7. Sliding table : For smooth cutting, precise sliding table glides the workpiece through the blade.
8. Control Panel : Simple push button controls for operation
9. Main Saw Blade height adjusting handwheel :Manual adjusts the height of saw blade
10. Main Saw Blade angle adjusting handwheel : Manual adjusts the angle of saw blade

(1) Control panel

1. Main Switch : Power on and power off the panel saw.
2. Emergency stop button disconnects power to motor.
3. Blade on button : Starts the main saw blade and scoring saw blade.
4. Blade off button : Stops the main saw blade and scoring saw blade.

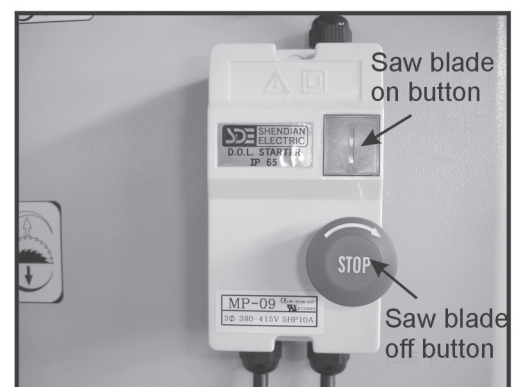


Fig. 1

(2) Rip fence

- A. One single lock down lever: Simple and precise to lock the fence assembly into fence rail
- B. Forward and backward slide lock handle : To firm the high/low profile alum. Fence on its forward/backward slide track
- C. Rip fence scale: Allows precise measurement of rip cutting operations.

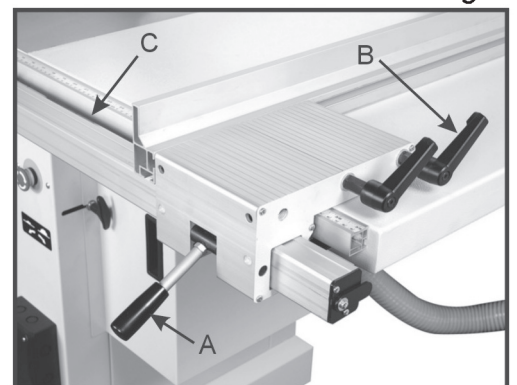


Fig. 2

(3) Miter Fence

- A. Fine adjustment handle. (Fig. 3)
- B. To hold the wood firmly.

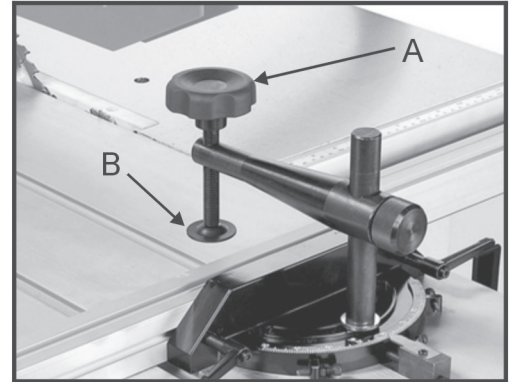


Fig. 3

(4) Riving knife and saw blade

1. Riving knife : Maintains kerf opening during cutting operations. The Purpose is crucial to preventing kickback caused by the kerf closing behind the blade.
2. Main saw blade : The maximum is 254 mm.
(Optional accessories)
3. Scoring saw blade : It rotates opposite the main saw blade, the blade cores the workpiece before the actual cutting operation is performed preventing tear-out in laminate materials. The scoring is adjustable forward and backward, upper and down. (Fig. 4)

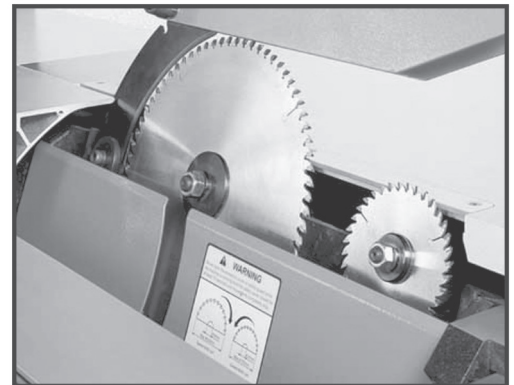


Fig. 4

Assembly and set up

(1) Sliding Table

Sliding table content

T-Bolt M12-1.75 x 2

Flat washer 12mm x 2

Sliding table locate plate handle x 1

Sliding table lock plate x 1

Lock washer M12 x 2

Hex nut M12 x 1.75 x 2

Lock washer M6 x 2

Hex nut M6 x 2

Switch

Stand

Button head bolt M6X16

Cap screw M8 x 20

Locate plate

1. Lift the sliding table up to the cabinet, with another person's help insert the T-bolts into the track along the bottom of the sliding table (Fig. 5.1) and space them apart the same distance and the mounting bolts to the cabinet. (fig. 5.2) Lift up the sliding table again and fit the T-bolts into the mounting holes on the cabinet. Secure the sliding table to the cabinet with two M12x 1.75 Hex. Nut. Insert the locate plate into the track use two M5x12 Hex socket bolt to mount the main switch.

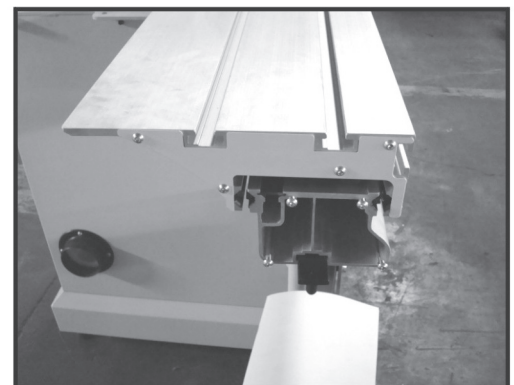


Fig. 5.1



Fig. 5.2

- Inset the another lock plate to install the two side stand and fasten the stand use 2pcs M8x20 Cap screw at the both left and right hand side. (Fig. 5.3 & Fig .5.4)
2. Install the end handle of the sliding table with M6x16L Button head screw 2pcs, the sliding is located when the table lock is in the right position, (Fig. 5.5) rotate the table lock 180 degree to unlock the sliding table.
 3. Install the locate plate use 4pcs of M6 x 12 button head screw at the two side of sliding table.

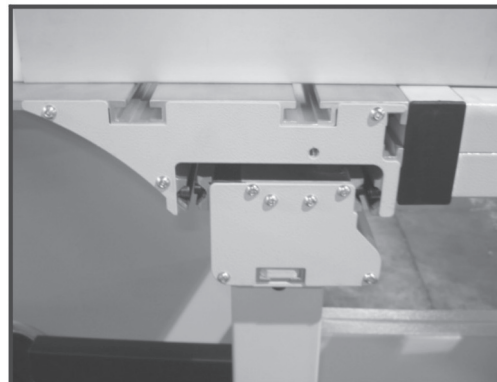


Fig. 5.3

(2) Extension Tables content

1. Large extension table x 1pc
2. Small extension table x 1pc
3. Hose support plate x 1pc
4. Cap screws M10-1.5 x 25 x 6pcs, Set screw M8-1.25x25x6pcs
5. Hex nuts M8-1.25 x 6pcs
6. Lock washers 10mm x 6pcs
7. Flat washers 10mm x 6pcs
8. Hex nut M10-1.5 x 1pc

How to install the extension tables.

1. Thread the set screws into the 6mm holes from the inside of both extension tables.
2. Before the tables are leveled please don't completely tighten the bolts in follow steps.
3. Attach the large extension table with three M10-1.5 x 25 cap screws, lock washers and flat washers (Fig.6)



Fig. 5.4

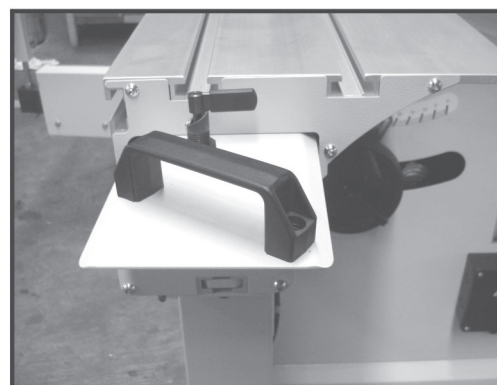


Fig. 5.5

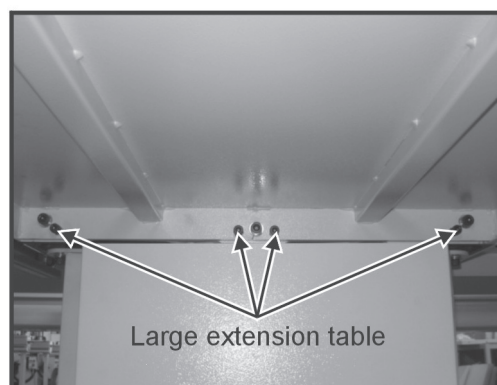


Fig. 6

4. Attach the small extension table with two M10-1.5 x 25 cap screws, lock washers and flat washers (Fig. 7)
5. Place the hose support plate to the extension table and thread M10-1.5x25 screws, lock washers and hex nut (Fig. 8)
6. Check the surfaces 0° the table with a straightedge (Fig. 9)

(3) Scale adjustment

1. Loosely thread 2pcs M6 x 16 hex screw and 1 pc M6 x 25 hex screw with lock and flat washers through the scale and into table. (FIG 10)
2. Tight the cap screws to the extension table with M6 hex nuts.
3. Line the scale up with the top of the table and tighten the hex nuts

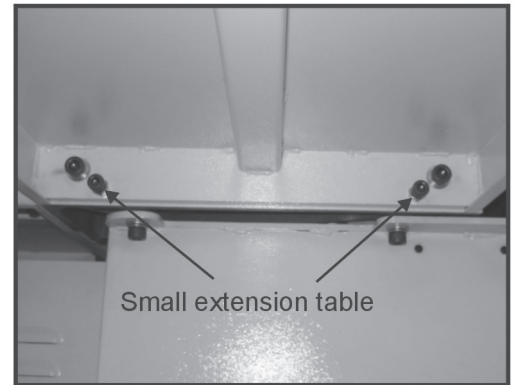


Fig. 7



Fig. 8



Fig. 9



Fig. 10

(4) Rip fence

Rip fence content

Rip fence x 1

Bracket x 1

Rip fence body x 1

Screw M12-1.75X90X3

Hex Nut M12-1.75 x 9

Flat washer 12mm x 9

Lock washer 12mm x 3

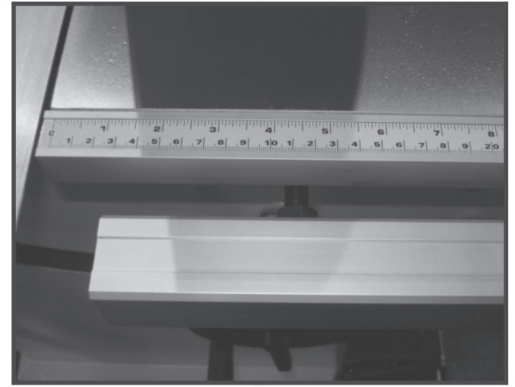


Fig. 11

How to adjust the rip fence

1. Thread 4pcs studs into bracket.
2. Thread an M12-1.75 hex nut onto each stud and tighten the nut against the bracket.
3. Thread an m12-1.75 hex nut and a flat washer half way onto each studs
4. Insert the studs into the table (Fig. 11) Tighten with an M12-1.75 hex nut, lock washer and a flat washer on each stud.
5. Slide the rip fence body onto the bracket.
6. Thread the lock handles into the rip fence body.
7. Lock the rip fence with the handle on the right hand side the rip fence body. (Fig.12)
8. Check the height of the rip fence rail by sliding the rip fence along the rail and comparing the gap between the fence body and the table.
9. Adjust the height of the rip fence rail, then tighten all of the nuts against the table showed. (Fig. 13)

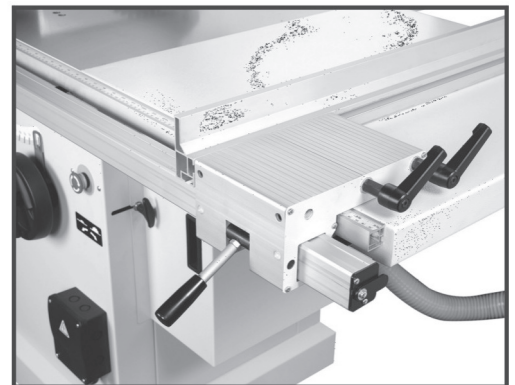


Fig. 12

(5) Cross table

Crosscut content

Crosscut table x 1

Crosscut table brace x 1

T-nut M8-1.25 x 2

T-nut M12-1.75 x 1

Flat washer 12mm x1

Adjustment handle M12-1.75 x 55 x 1

Knob M8-1.25 x 50 x 2

Flat washer 8mm x 2

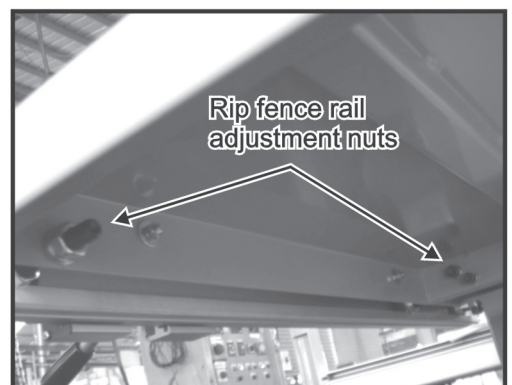


Fig. 13

1. Thread the M12-1.75x55 adjustable handle with a 12mm flat washer through the crosscut table and into a M12-1.75 T-nut. (Fig. 14)

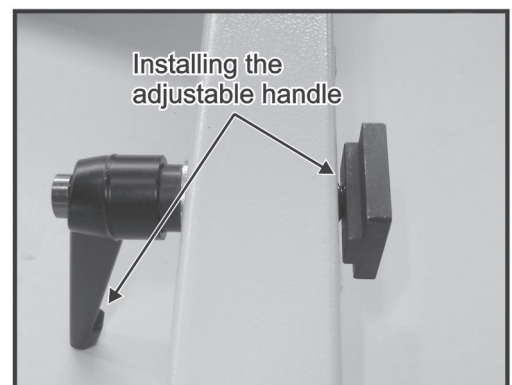


Fig. 14

2. Secure the pivot pin to the crosscut table first, Place the extension table set on the swing arm and slide the T-nut into the T-slot in the sliding table. (Fig. 15, 16)
3. Slide two M8-1.25 T-nuts into the crosscut table brace.
4. Align the T-nuts in the crosscut table supporter with the holes in the crosscut table and thread the M8-1.25x50 knobs, with 8mm flat washers, into the T-nuts (Fig. 17)

(6) Crosscut fence

Crosscut fence content

Crosscut fence x 1

Crosscut fence support plate x 1

Center stud M8-1.25 x10 x 1

Flat washer 8 x ϕ 20 x1

T-nut M8-1.25 x 5

Knob M8-1.25 x 25 x 1

Knob M8-1.25 x 1

T-bolt M8-1.25 x 60 x 1

Flat washer 8mm x 1

Lock washer 8mm x 3

Button head screw M8-1.25 x 16 x 2

Fence support plate

1. Thread the center stud and the flat washer 8 x ϕ 20 into the remaining M8-1.25 T-nut.
2. Sliding the center stud, an M8-1.25 x 60 T-bolt and screw M8-1.25 x 25 knob into the crosscut fence (Fig. 18)
3. Slide the center stud to the end with the plastic cap and tighten it in place.

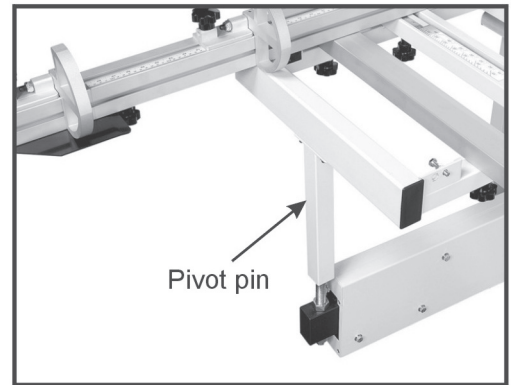


Fig. 15

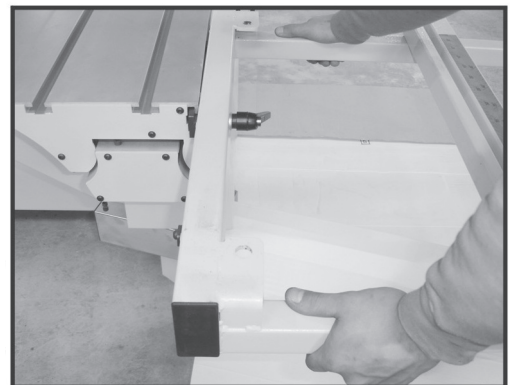


Fig. 16

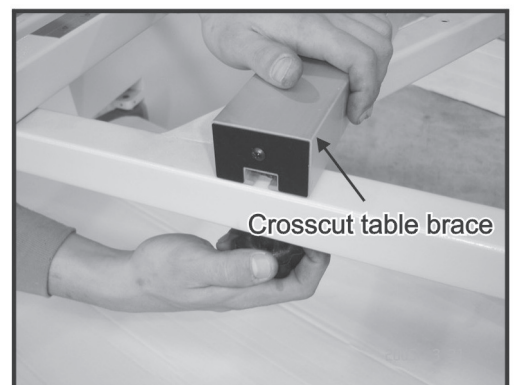


Fig. 17

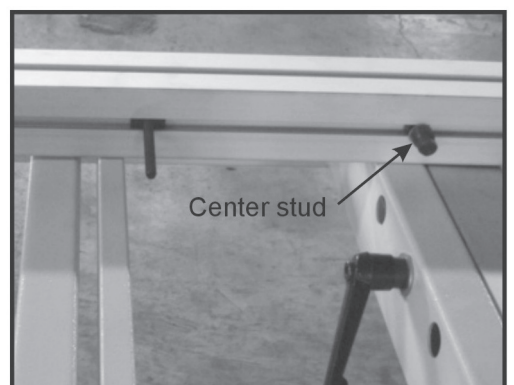


Fig. 18

4. Insert the center stud and the T-bolt in the places indicated (Fig. 19)
5. Secure the crosscut fence with the M8-1.25 knob with an 8mm flat washer threaded onto the T-bolt.
6. Unlock the crosscut fence extension and slide the flip stops into the fence.
7. Slide two M8-1.25 T-nuts into the crosscut fence extension and attach the crosscut fence support plate to the fence extension with two M8-1.25 button head screws and lock washers.

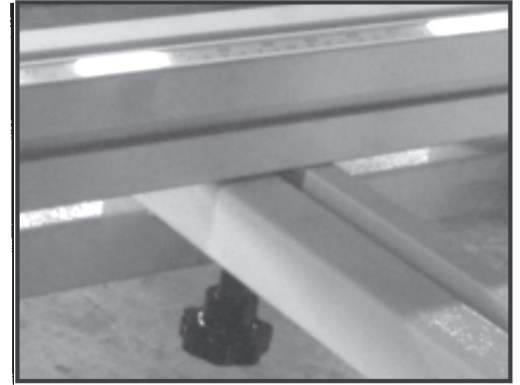


Fig. 19

(7) Main Blade

Main blade content

Blade 10" (as option) x 1

Flat belt 15 x 1,080 mm x 1

Riving knife x 1

This saw is designed with 10" main saw blade, before you change blade sizes, the riving knife must be adjusted to match the size of blade you install.

1. Before adjusted the blade, open the motor compartment and remove the foam shipping block and the red shipping brackets from the motors.
2. Place the flat belt on the scoring blade arbor (Fig. 21), lift the scoring motor and slide the flat belt over the scoring motor pulley.(Option)

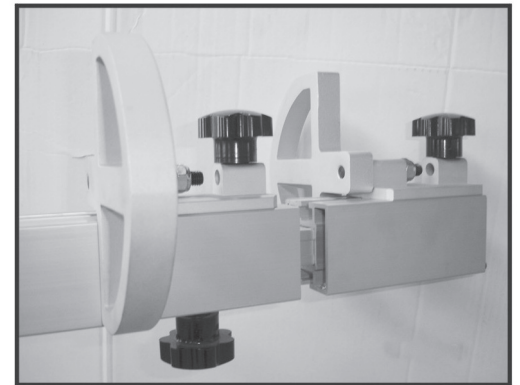


Fig. 19.1

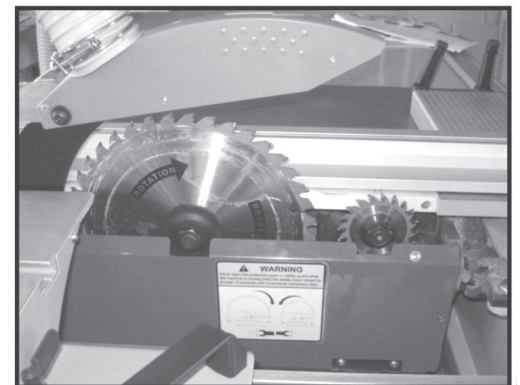


Fig. 20

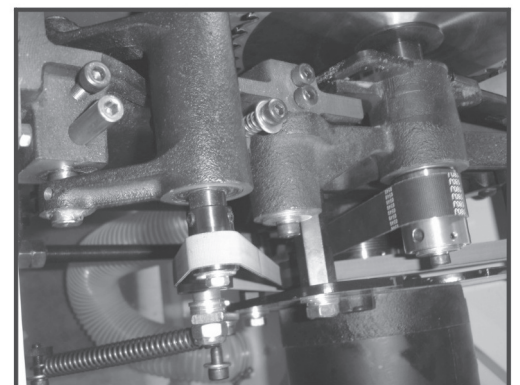


Fig. 21

3. Move the blade tilt to 0° and raise the main blade as far as it will go.
4. Slide the table all the way forward to access the blade arbor and pull open the blade guard. (Fig. 22)
5. Use the arbor wrench to remove the arbor nut and arbor flange, the arbor nut has left hand threads and loosens by turning clockwise. (Fig. 23.1 & Fig. 23.2)
6. Slide the blade over the arbor with the teeth facing the front of the saw.
7. Re-install the arbor flange and the arbor nut and tighten them against the blade.
8. Loosen the riving knife center bolt, slide the riving knife over the bolt (Fig. 24) and slightly tighten.

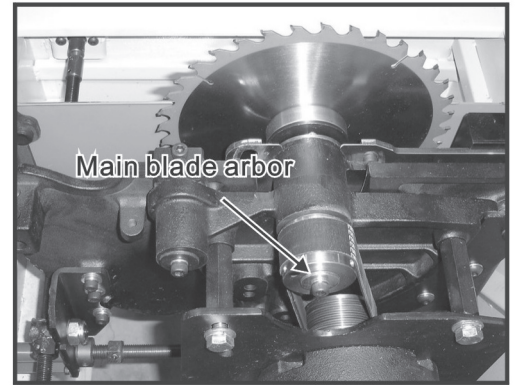


Fig. 22



Fig. 23.1



Fig. 23.2

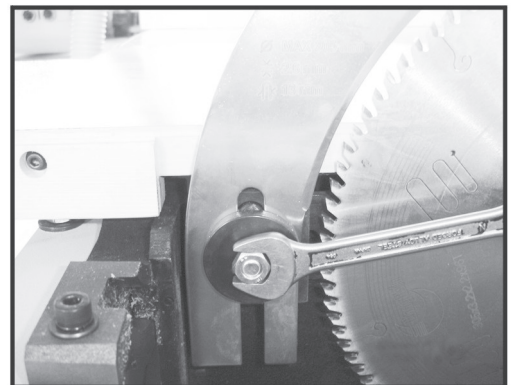


Fig. 24

9. Position the riving knife about 3mm or 1/8" away from the nearest carbide tooth on the main blade. For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife. (Fig. 25)
10. Tighten the center bolt to secure the riving knife in position.
11. Move the blade guard back to its original position, and move the sliding table back to center.



Fig. 25

(8) Scoring Blade

Aligning Scoring Blade Set

The scoring blade must be aligned with the main blade to ensure satisfactory cutting results.

1. Move the blade tilt to 0° (blade 90° to table) and raise the main blade all the way up.
2. Release the screw in Hole A before adjust the scoring blade and tighten the screw each time after adjustment. (Fig. 26, Hole A)
Hole B to adjust the scoring blade up and down.
Hole C to adjust the scoring forward and backward.
Important notice: tighten the Hole A when finish adjustment.
3. Move the rip fence against the main blade (or scoring blade) (Fig. 27)
4. Use the adjustment controls to move the scoring blade so that the rip fence can touch both the scoring blade and the main blade.
5. Lower the scoring blade to the correct height (2mm or 5/64"), perform a test cut, then make any final adjustment.

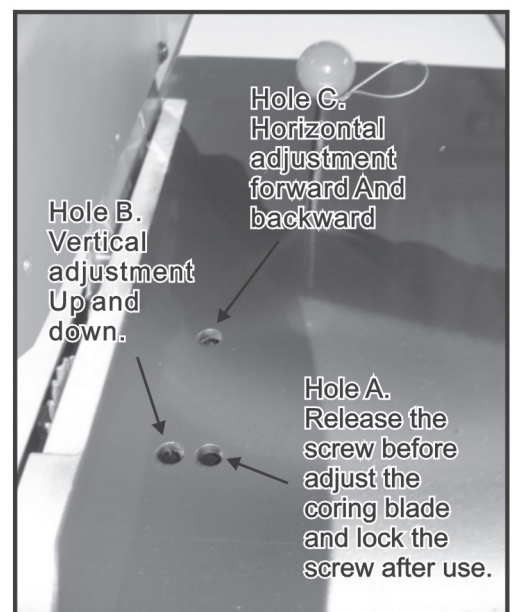


Fig. 26

(9) Fence Scale Alignment

Before operation, the 0" mark on the rip fence scale must be aligned with the right side of the blade to ensure that the rip fence measurements will be accurate.

1. Move the blade tilt to 0° (blade 90° to table), and raise the main blade all the way up.
2. Move the rip fence against the main blade (Fig. 27)
3. Loosen the cap screws securing the fence scale.
4. Slide the fence scale to line up the first mark on the scale with the left edge of the rip fence and tighten the cap screws.

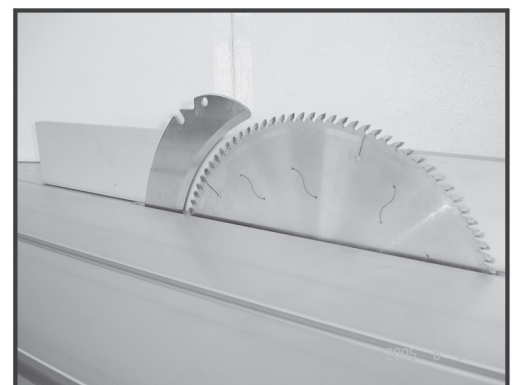


Fig. 27

(10) Dust Collection

There are dust ports are designed on this machine, please connect the dust collection system before operations.

1. Secure a 4" dust hose to the dust port. (Fig. 28)
2. Run the 4" hose to your dust collection system. Slide the blade guard/dust hood over the riving knife and attach it with a M8-1.25 x 40 button head cap screw and a flat washer (Fig. 29)
3. Secure a 2-1/2" dust hose to the dust port on the top of the blade guard (Fig. 29)
4. Run the 2-1/2" hose over the hose support (Fig. 30) and connect it to the dust collection system.
5. Run a ground wire along the dust hose and attach the wire to the machine to protect against static electricity. Notice: Hose is optional accessories.

(11) Power Cord

1. Open the terminal box (fig .31)
2. Feed the power cord through the strain relief on the bottom of the control panel and connect the cord to the terminals. If finish, close the terminal box.
3. Shut off the main power at the power source circuit breaker and install the cord to the disconnect switch.



Fig. 28

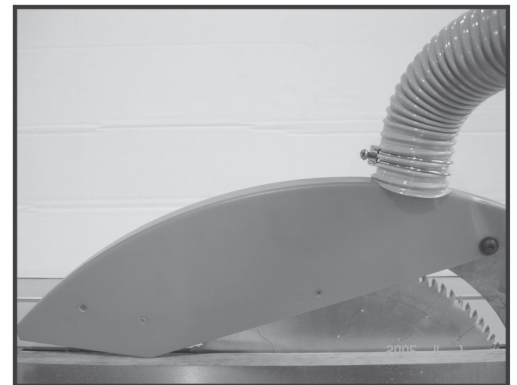


Fig. 29

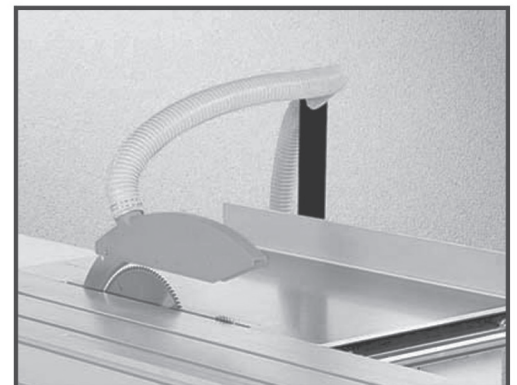


Fig. 30

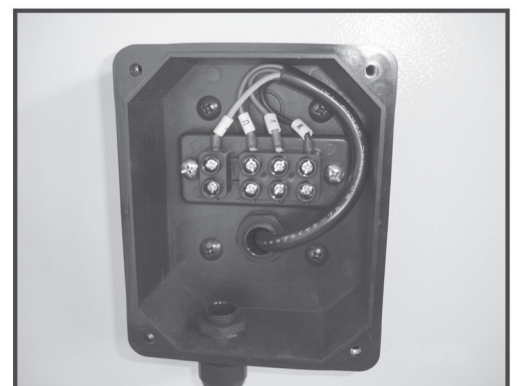


Fig. 31

(12) Test Run

Before operation, it must be testing this machine to make sure all the controls are working properly.

WARNING

Before starting the saw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury or even death!

1. Connect the machine to the power source.
2. To check the machine light is turning on.
3. Press the main blade button, if the main blade is rotating in a counter-clockwise, then press the scoring blade button, if the main blade is rotating in a clockwise direction, disconnect the saw from power and exchange wires in the terminal box.

Operation

You must follow these instructions EVERY time you use your saw.

1. Stand to the left of the blade line-of-cut when performing a cutting operation.
2. Turn off the saw and allow the blade to come to a complete stop before removing the cut-off piece.
3. Make sure the riving knife is always aligned with the main blade before cutting.
4. Always position the blade guard to the correct height above the workpiece.
5. Carefully plan each cutting operation to avoid injuries.
6. When you release the sliding table lock, make sure that the knob is positioned so that it will not lock the table during a cut.

(1) Changing Main Blade

The main blade size for this machine 10", it is as option. Any time you change the blade size, adjust the riving knife to 3mm away from the blade you install.

1. Disconnect the power source.
2. Move the blade tilt to 0° (blade 90° to blade) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife. (Fig. 32)
4. Pull the blade guard away from the blades to expose the mounting assembly.
5. To remove the main blade, use the stopper rod to fix blade, use the arbor wrench to remove the arbor nut and arbor flange. (the arbor nut has left hand threads and loosens by turning closewise.)

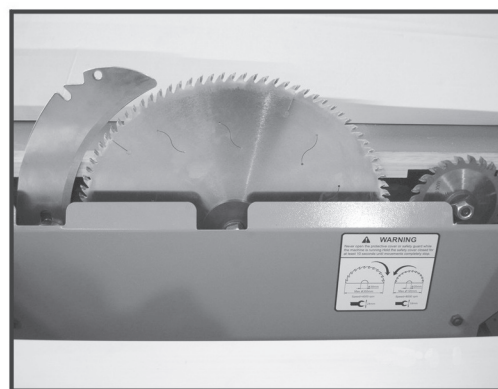


Fig.32

6. Install the new blade, re-install the arbor flange and the arbor nut and tighten them against the blade. (Fig. 33)

WARNING

Wear gloves to protect your hands when installing or removing blades.

7. Move the orange blade guard back into its original position, next to the blades and center the sliding table.

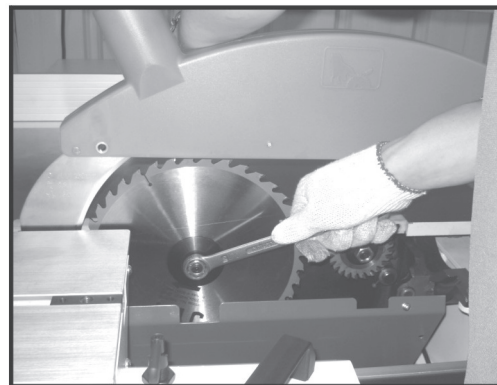


Fig.33

(2) Riving Knife Adjustment

Whenever the blade size is changed (maximum 10"), then riving knife must be adjusted to 3mm away from the blade you install.

1. Disconnect the saw from power source
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife.
4. Pull the blade guard away from the riving knife to expose the mounting assembly.
5. Loose the riving knife center bolt, slide the riving knife away from the blade and slightly tighten. (Fig. 34)
6. Position the riving knife about 3mm or 1/8" away from the nearest carbide tooth on the main blade. (Fig. 35)
7. Tighten the center bolt to secure the riving knife in position.
8. Move the blade guard back to its original position, and move the sliding table to center.



Fig. 34

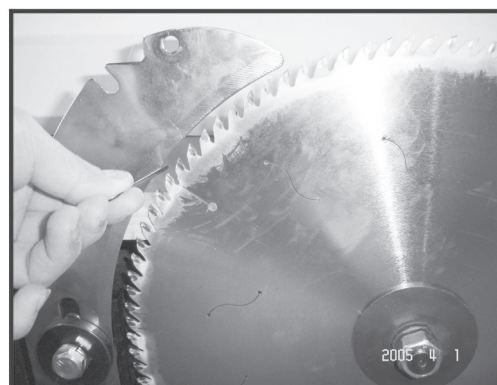


Fig. 35

(3) Changing Scoring Blade

1. Discount the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table), and raise the scoring blade all the way up.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blade and riving knife.
4. To remove the scoring blade set, use the stopper rod to fix the blade, use the arbor wrench to remove the arbor nut and arbor flange. (the arbor nut has right hand threads and loosens by turning counterclockwise.
5. Measure the main blade, and use the shims to stack the scoring blade set so the thickness matches the thickness of the main blade.
6. Install the blade set, re-install the arbor flange and the arbor nut, and tighten them against the blade set.
7. Move the orange blade guard back into its original position, next to the blades, and center the sliding table.
8. Align the scoring blade set to the main blade.

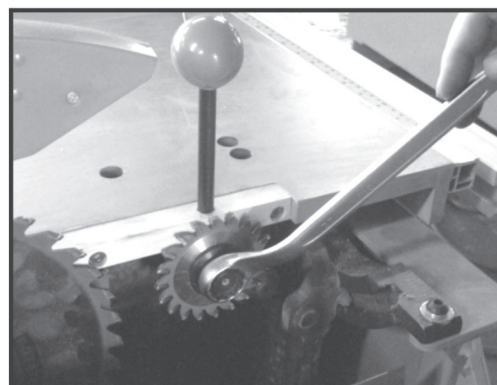


Fig. 36

(4) Rip Cutting.

The panel saw has the capability of rip cutting full size panel panels, the sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

The saw also with the capability of rip cutting smaller boards which is using the machine as a traditional table saw. (Fig. 37)

Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.

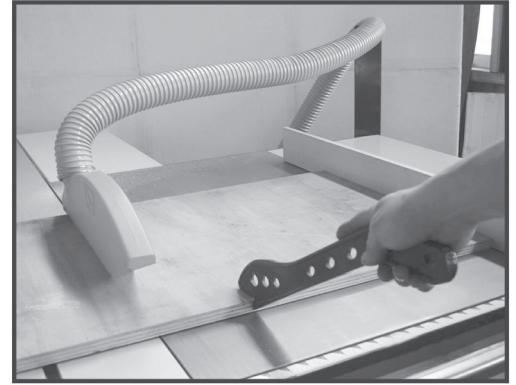


Fig. 37

Rip Cutting With The Sliding Table:

1. Install the crosscut fence in the center stud hole.
(Fig. 38)
Note: Drop the crosscut fence into the center stud hole and rotate it to the 90° stop.
Check to make sure the fence is at 90° and adjust it.
(Fig. 38)
2. Slide the protection block against the blade teeth to calibrate the scale, then tighten the lock knob, and make sure the scale will not be accurate if the protection block is cut.
3. Set a flip stop to the desired width-of-cut.
4. Position the blade guard to the correct height for your workpiece.
5. Load the workpiece onto the table saw.
6. Take all the necessary safety precautions, then perform the cutting operation.

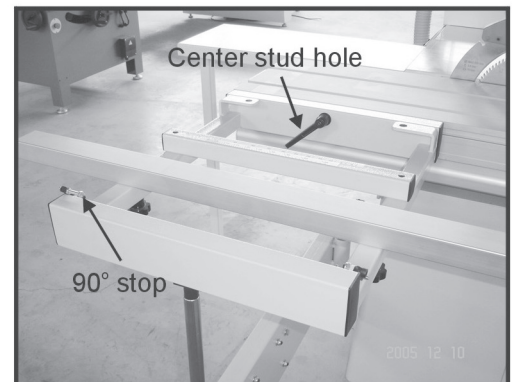


Fig. 38

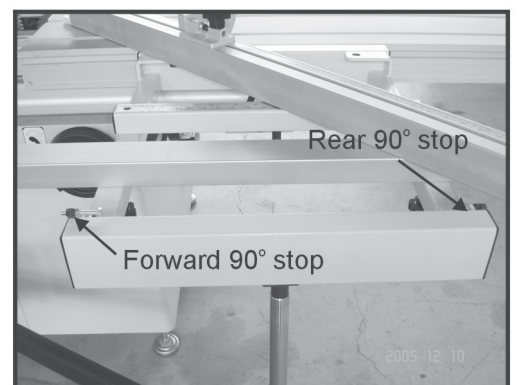


Fig. 39

Trading Table Saw Cutting

1. Place the fence in the vertical position (Fig. 40) for larger workpiece, or in the horizontal position (Fig. 41) for angled cuts and for small workpiece.

2. Slide the leading end of the rip fence so it is even with the center of the main saw blade.

Note: This technique allows the finished cut-off piece to "fall" away from the blade when the cutting operation is complete, reducing the possibility of kickback.

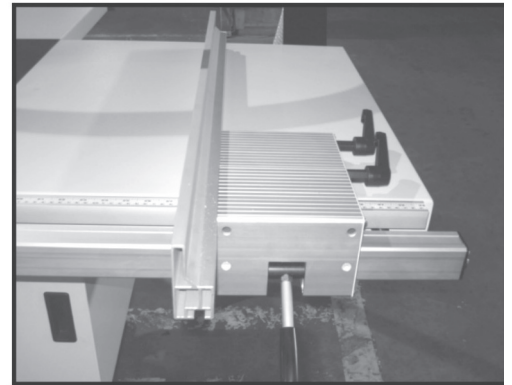


Fig. 40

(5) Crosscutting

This saw can crosscut full size panels with the fence in the forward or rear position, although it is easier to load full size panels with the crosscut fence mounted in the forward position.

Mounting the crosscut fence in the rear position gives greater stability for crosscutting smaller panels. (Fig. 42)

Lastly, this machine has capability of crosscutting workpiece while using the rip fence as a cut-off gauge. (Fig. 43)

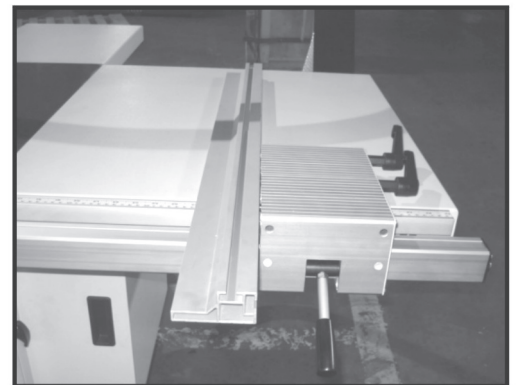


Fig. 41

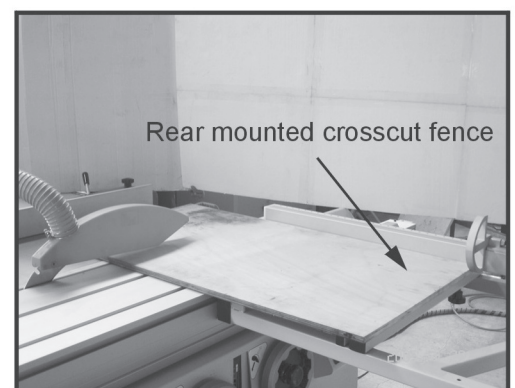


Fig. 42

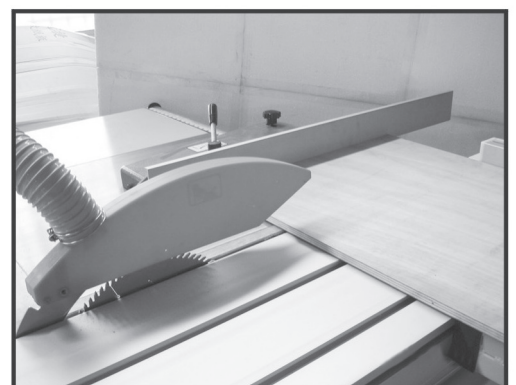


Fig. 43

Crosscutting full size panels

1. Install the crosscut fence to the forward 90° stop (Fig. 44) and lock it in place.
Note : Drop the crosscut fence in the center stud hole and rotate it to the 90° stop. Check to make sure the fence is at 90° and adjust it. (Fig. 44)
2. Set either flip stop to the desired width-of-cut, if the workpiece is more than 120mm, you must extend the crosscut fence slide.
3. Load the workpiece onto the table saw.
4. Once all the necessary safety precautions have been taken, perform the cutting operation.

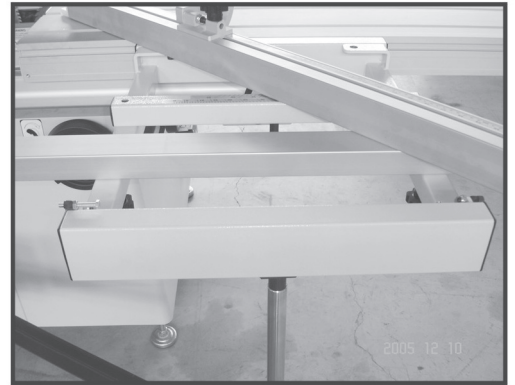


Fig. 44

Crosscutting small panels

1. Install the crosscut fence to the rear 90° stop and lock it in place. Note: Drop the crosscut fence in the center stud hole and rotate it to the 90° stop.
2. Check to make sure the fence is at 90° and adjust it.
3. Set either flip stop to the desired width-of-cut, if the workpiece is more than 120mm, you must extend the crosscut fence slide.
4. Load the workpiece onto the table saw.
5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting using rip fence as a cut-off gauge:

1. Install the crosscut fence in the rear mounting points (Fig.45) and lock it in place.
2. Position the rip fence for the desired width.
3. Load the workpiece onto the table saw.
4. Slide the leading end of the rip fence behind the back edge of the blade. (Fig.45)
5. Take all the necessary safety precautions, then perform the cutting operation.

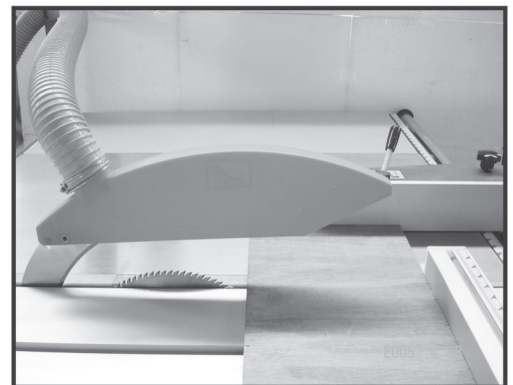


Fig. 45

(6) Miter Cutting.

The miter fence allows miter cuts from 0° through 135°. The table mounted miter scale has a resolution of 1°.

1. Slide the crosscut table to the front edge of the sliding table and lock it in place.
2. Place the crosscut fence center stud in the center stud hole of the crosscut table. The fence can be installed for 90° to 135° cuts (Fig. 46) , or 0° to 90° cut.



Fig. 46

3. Rotate the fence to the desired angle and use lock knob to lock the fence in place.
4. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.
5. Load the workpiece onto the table saw.
6. Once all the necessary safety precautions have been taken, perform the cutting operation.

(7) Lubrication

Lubrication the areas indicated below every 6-12 months, depending on frequency of use.

1. Blade angling trunnion.
2. Sliding table track.
3. Scoring blade worm gear
4. Blade height linkage.
5. Blade height bearing
6. Blade tilt worm gear
7. Blade height slide

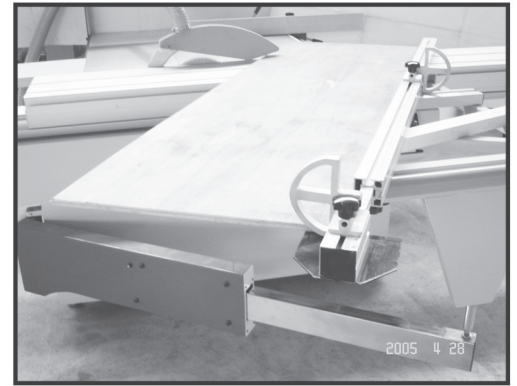


Fig. 47

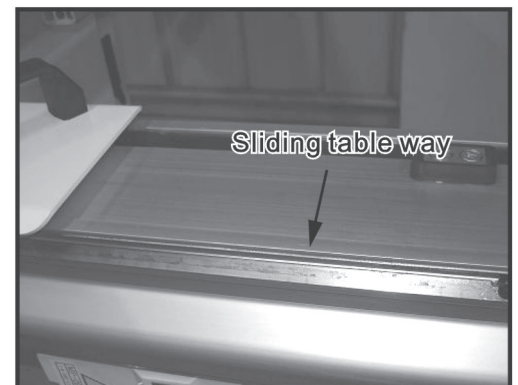


Fig. 48



Fig. 49

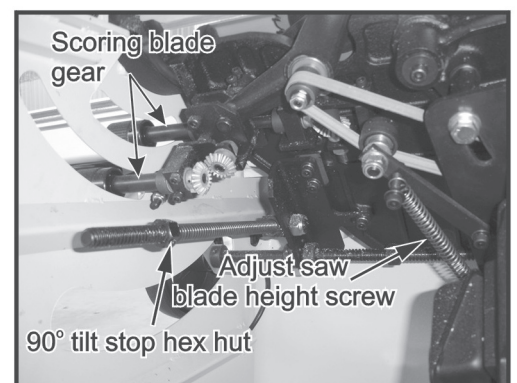


Fig. 50

(8) Replace Belts

To change V-belt for the main motor

1. Disconnect the saw from the power source.
2. Move the blade tilt to 45° (blade 45° to table) and raise the main blade and scoring blade set up.
3. Open the motor cabinet door.
4. Loosen the three M12 bolt (Fig.51)
5. Slowly upper the motor and then tighten the bolt. Pull off the old v-belts and replace them with new ones.
6. Ensure the motor pulley and arbor pulley are lined up.
7. Loosen the M12 bolt, and pivot the motor down.
8. Tighten the M12 bolt after adjusting suitable tension.
9. Close and secure the motor cabinet door.

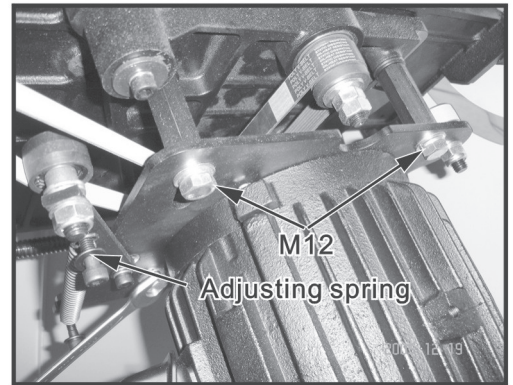


Fig. 51

To change flat belt for the scoring motor (Option)

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade and scoring blade set up.
3. Open the motor cabinet door.
4. Push the scoring blade motor and remove the flat belt.
5. Place the flat belt on the scoring blade arbor, lift the scoring motor and slide the flat over the scoring motor pulley.
6. Close and secure the motor cabinet door.

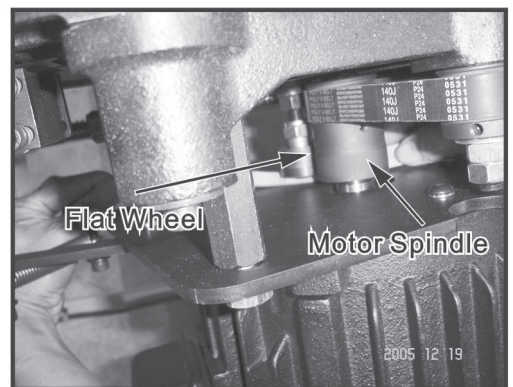


Fig. 52

(9) Blade Tilt

1. Disconnect the saw from the power source.
2. Move the blade tilt to 90° according to the gauge, and raise the main blade.
3. Place a machinist's square between the teeth on the blade and on the table surface and inspect for gaps between the blade and the square.
4. If a gap exists at either the top or bottom of the square, loosen the 90 tilt stop hex nut. (Fig.53)
5. Turn the handwheel until the blade and square are flush from top to bottom.
6. Snug the adjustment hex nut against the underside of the table and tighten the lock nut, set screw.
7. Recheck the blade with the square to ensure the screw has not been over-tightened.
8. Adjust the blade angle until you hit the 45° positive stop hex nut. Check the bevel with an adjustable square set to 45° hex nut.
9. If variations exist, adjust the 45° tilt stop hex nut until the blade and square match. (Fig. 54)
10. Tighten the lock nut set screw and recheck the bevel by adjusting the blade back to 90° then back to 45°.

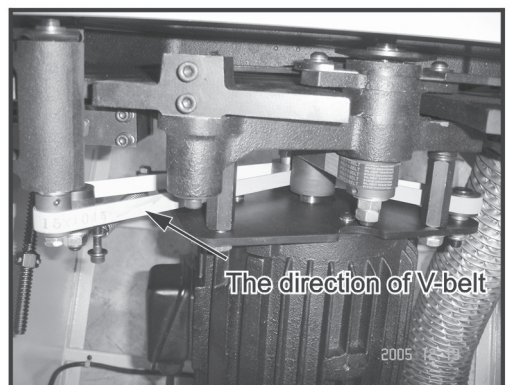


Fig. 53



Fig. 54

(10) Sliding Table Parallel Adjustment

The table is calibrated at the factory and please adjust if it changes during the transportation.

To adjust the sliding table parallel with the main blade:

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade and scoring blade set up.
3. Mark the center of the blade with a felt tip pen, this will allow you to take your measurements from the exact same place on the blade.
4. Move the sliding table all the way to one end, and using a precision ruler, measure the gap between the edge of the table and you mark on the blade. (Fig.56)
5. Move the other end of the sliding table in front of the blade and measure the gap.
6. Loosen the table mounting bolts.
7. Move the end of the sliding table that needs to be adjusted in front of the blade.
8. Using the ruler, watch the gap measurement and have your assistant slowly make the adjustment to the parallelism adjustment bolts (Fig. 58) until the gap size is equal to the other side.
9. Repeat steps 7-8 until the gap between your mark on the blade and the edge of the sliding table is even at both ends.
10. Tighten the jam nuts on the parallel adjustment bolts to secure them in place.
11. Tighten the table mounting bolts and replace the access plates.



Fig. 55

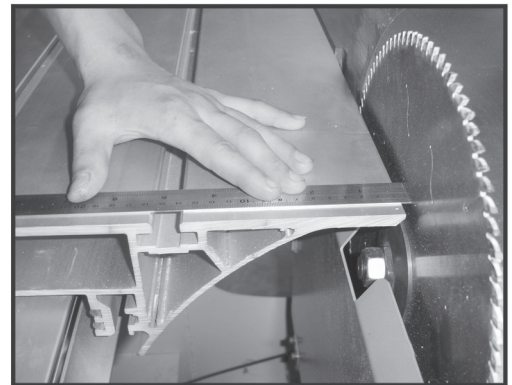


Fig. 56



Fig. 57



Fig. 58

(11) Squaring Crosscut Fence to Blade

1. Make sure the blade is parallel with the sliding table.
2. Prepare the scrap test piece by cutting it to 32" x 32" and number all four sides of the test piece.
3. Using the crosscut fence, cut 1/2" off of each side of the test piece.
4. Measure the test piece diagonally from corner to corner, at all four corners are same size.

Note : if both measurements are not within 1/16" then the crosscut fence needs to be adjusted.

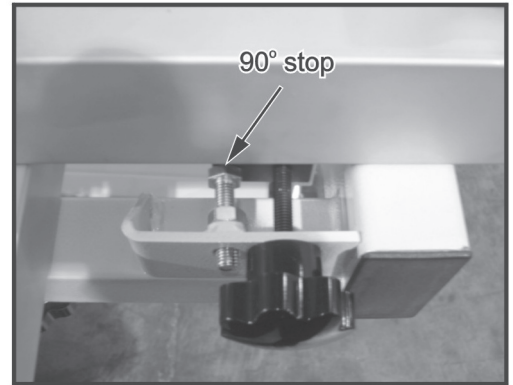


Fig. 59

5. Loosen the hex nut and adjustment screw to square the crosscut fence.
6. Tighten the hex nut and repeat 3-6.

(12) Troubleshooting

WARNING

Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury or death.

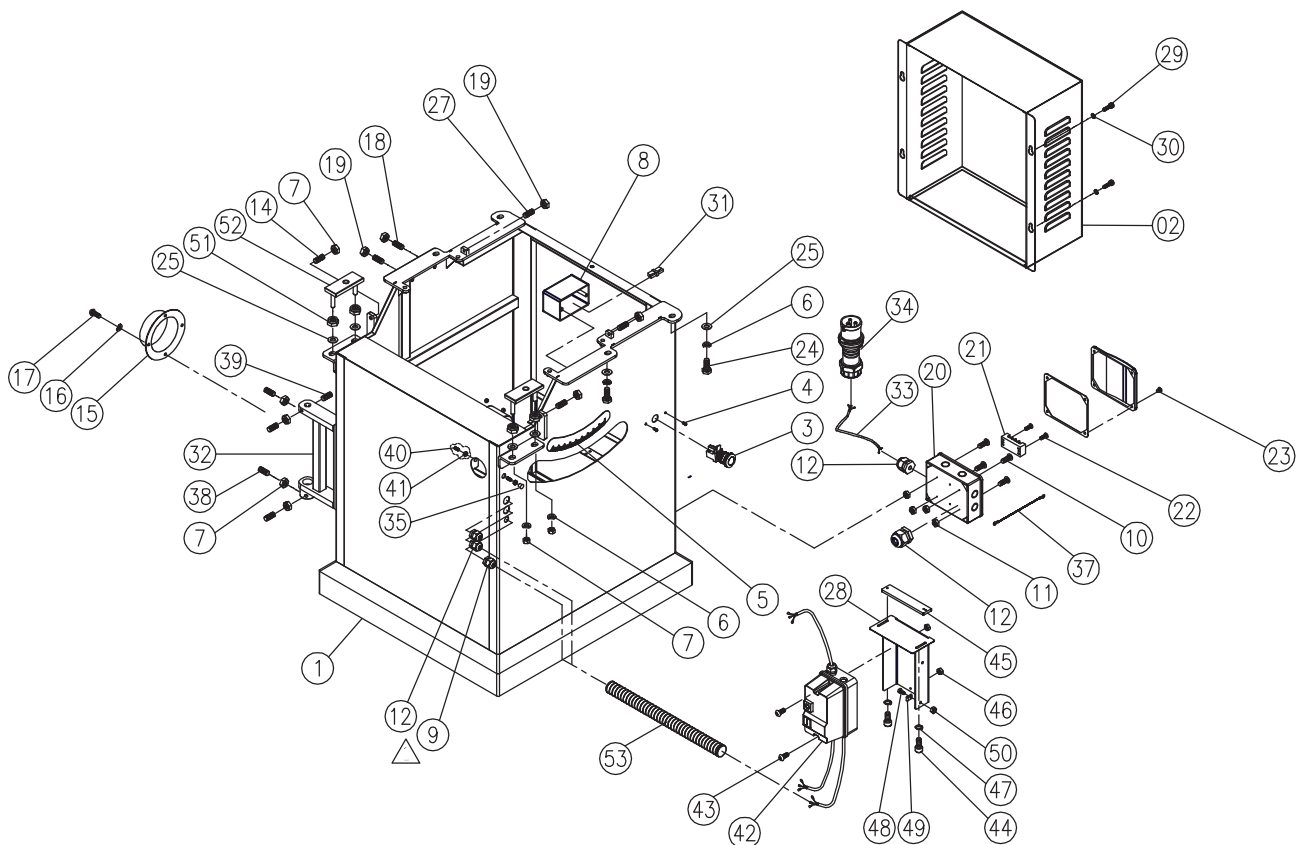
Saw will not start

1. Check the switch is being depressed fully.
2. Check the electrical power cord is plugged into the power outlet.
3. Check the electrical supply is on (reset)
4. With the power disconnected from the machine, check that the wiring in the plug is correct. Check that the rubber insulation is stripped enough and is not causing a bad connection. Check that all screws are tight.
5. With the machine power disconnected from the machine, check that the wiring to the machine is correct. Check that the rubber insulation is tripped enough and is not causing a bad connection. Check that all screws are tight.
6. Check that you have correct power.
7. Check that the ground wire is wired correctly.

Motor will not start

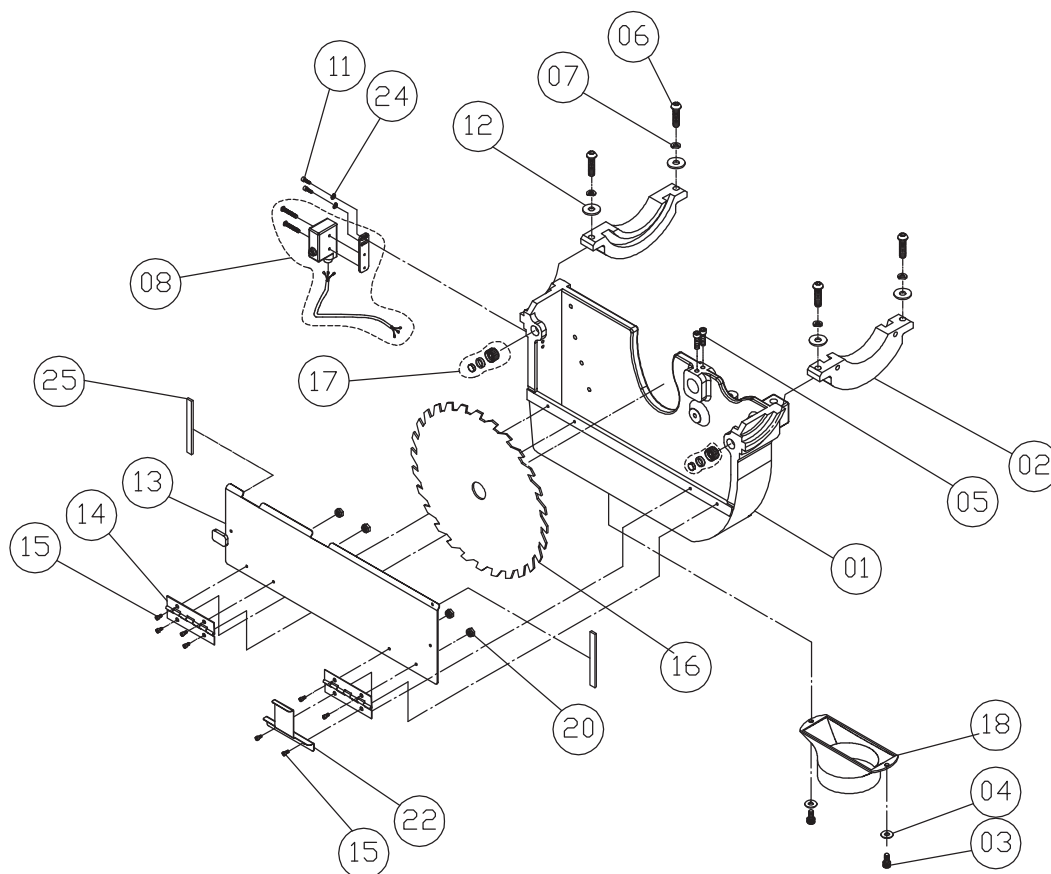
1. Emergency stop button is depressed.
2. Start capacitor is at fault.
3. Motor is at fault.
4. With the power disconnected from the machine, try to turn the blade by hand. If the blade will not turn, check the reason for the jamming, typical reason is wood jamming the blade.

If any trouble you cannot solve it from above solutions, please call your senior engineer or contact the agent which you ordered this machine.

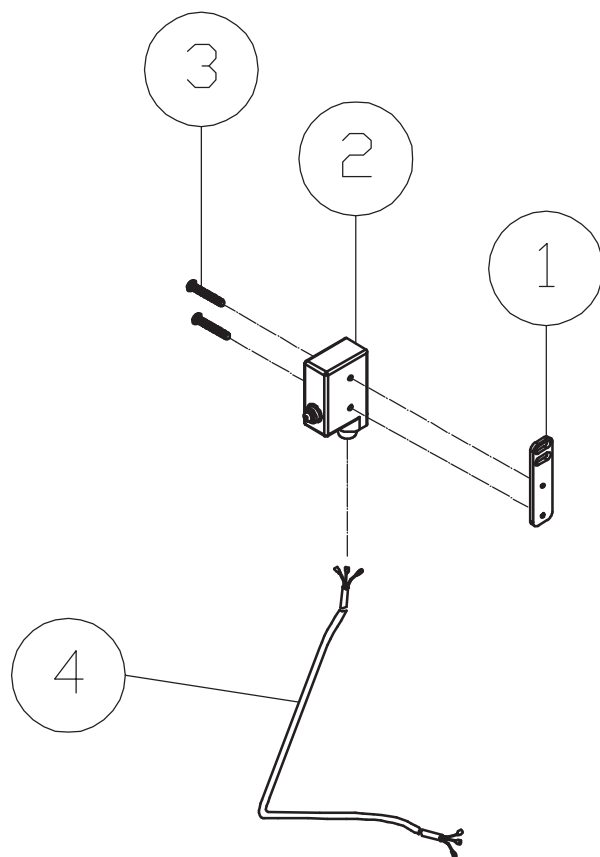


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	204048	Main Frame		1
2	204225	Cover Plate		1
3	994808	Emergency Stop Button		1
4	ST059400	Tapping Screw	M5x16L	2
5	LM204034	Scale		1
6	WS100000	Lock Washer		8
7	NH101700	Hex Nut	M10xP1.5	10
8	605408	Switch Box		1
9	709409	Strain Relie	PG-9	1
10	SP069300	Button Head Screw	M6x12	4
11	NH061000	Hex Nut	M6	4
12	136013	Strain Relief	PG-13.5	4
14	204258	Set Screw	M1x30	2
15	412007	Dust Port		1
16	WS060000	Lock Washer	M6	4
17	SP069400	Pan Head Plate	M6x16	4
18	SS080700	Set Screw	M8x35	4
19	NH081300	Hex Nut	M8	6
20	201105	Power Box		1
21	994805	Terminal		1
22	ST030400	Pan Head Plate	M3.5x20	2
23	SP050700	Button Head Screw	M5x35	4
24	SR100600	Hex Head Bolt	M10x30	4
25	WF102730	Flat Washer	M10x ϕ 27	8
27	SS080700	Set Screw	M8x35	2
28	204205	Switch Seat		1
29	SJ089400	Cap Screw	M8x16	4
30	WS080000	Lock Washer	M8	4

ITEM	PART NO	PARTS NAME	SIZE	Q'TY
31	136019	Wire Connector		1
32	204128	Sliding Table Support Bracket		1
33	IC204001	Power Cord	3PH CE 1.5mm/4C	1
	IC204002	Power Cord	1PH CE 1.5mm/3C	1
	IC204003	Power Cord	3PH CSA 1.5mm/4C	1
	IC204004	Power Cord	1PH CSA 1.5mm/3C	1
34	IC290009	Plug	CE/1 ϕ	1
	IC290006	Plug	CE/3 ϕ	1
35	201576	Plug	ϕ 10	1
37	IC135013	Short Ground Return	16AWGx100mm	1
38	SS100500	Set Screw	M10x25L	4
39	SS060200	Set Screw	M6x10L	2
40	204224	Set Screw	M12x35L	2
41	NH121900	NUT	M12	2
42	AB204005	Switch Cell	3HP/1PH/CE	1
	AB204006	Switch Cell	3HP/3PH/CE	1
	AB204007	Switch Cell	3HP/1PH/CSA	1
	AB204008	Switch Cell	3HP/3PH/CSA	1
43	SP049400	Pan Head Screw	M4X16	2
44	SR059300	Hex Socket Bolt	M5X16	2
45	204210	Locate Plate		1
46	NH040700	Hex Nut	M4	2
47	WF051210	Washer	M5x ϕ 12	2
48	SH059300	Hex Socket Bolt	M5X12	1
49	998627	Cord Clamp	3/8"	1
50	NH050800	Hex Nut	M5	1
51	NL101700	Nylon Nut	M10xP1.5	4
52	204146	Locate Block		2
53	204196	HOSE	ϕ 32x400mm	0.4

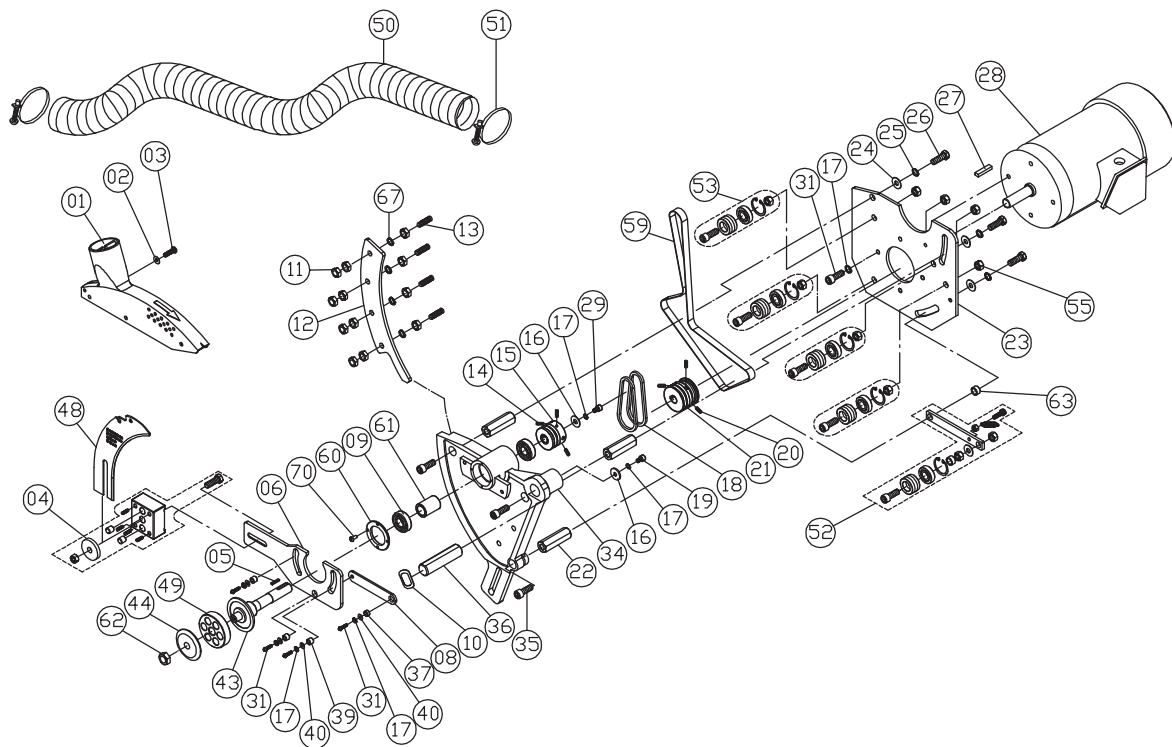


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	204060	Channel Base		1
2	204033	Trunnion Bracket		2
3	SR060200	Cap Screw	M6x10L	2
4	WF061310	Lock Washer	M6x ϕ 13	2
5	SR089400	Cap Screw	M8x16L	2
6	SJ060700	Button Head Screw	M8x35L	4
7	WS080000	Lock Washer	M8	4
8	AB204021	SWITCH (ASM.)	AZZ7100	1
11	SR050200	Cap Screw	M5x10L	2
12	WF081818	Lock Washer	M8x ϕ 18xt1.8mm	4
13	204013	Cover Plate		1
14	612030	Hinge		2
15	SF059200	Pan Head Bolt	M5x8L	8
16	204002	Saw Blade	250x2.6x5/8x40P	1
	204212	Saw Blade	250x2.6x30x40P	1
	204102	Saw Blade	250x2.6x30x60P	1
	204002A	Saw Blade	250x2.6x5/8x60P	1
17	AB203249	Magnetic Iron(assembly)		2
18	204061			1
20	NL050800	Nylon Nut	M5	4
22	204256			1
24	WF050810	Lock Washer	M5x ϕ 8xt1.0mm	2
25	150527	Pad		1



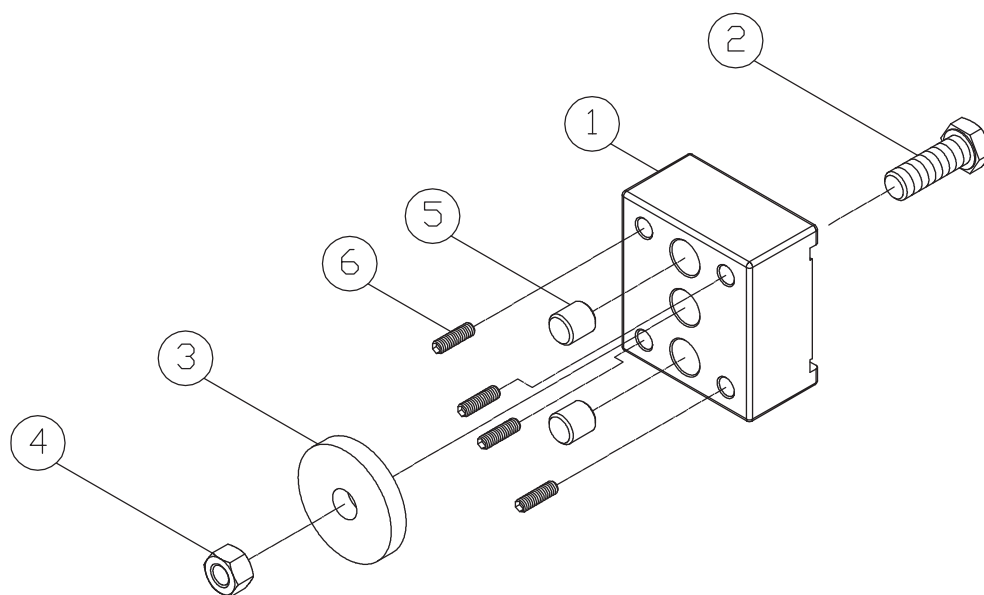
PART NO.: AB204021
SWITCH (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
01	204022	STOP BRACKET		1
02	204021	LIMIT SWITCH	AZZ7100	1
03	SP040500	PAN HEAD BOLT	M4×25L	2
04	IC204007	CONTROL CORD		1
	IC204009	CONTROL CORD		1



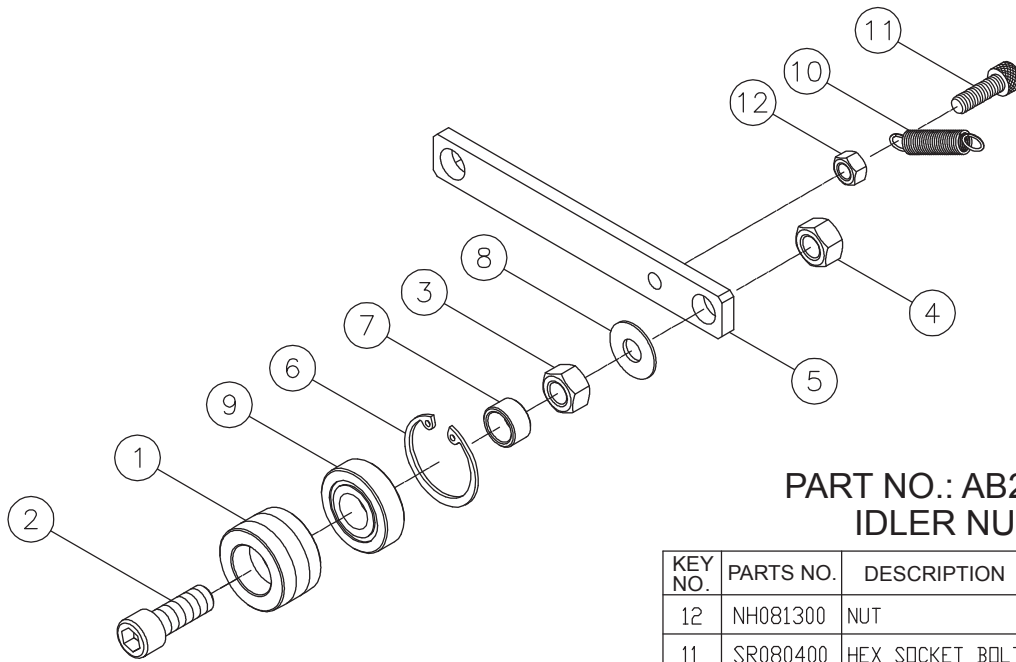
ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	200917	Blade Cover		1
2	WF083030	Washer	M8x ϕ 30xt3mm	1
3	SJ080800	Button Head Screw	M8x40L	1
4	AB204020	Splitter Seat (Asm.)		1
5	KD050540	Key	5x5x40	1
6	204166	Locate Block		1
8	204065	Linkage		1
9	BB600404	Bearing	6004LLB	2
10	WW263403	Wave Washer	ϕ 26x ϕ 34	1
11	NH101404	Hex Nut	M10xP1.5x5T	12
12	204029	Gip Plate		1
13	SS101000	Set Screw	M10x50L	4
14	SS050200	Set Screw	M5x10L	3
15	204283	Arbor Pulley	CSA(60HZ)	1
	204284	Arbor Pulley	CE(50HZ)	1
16	WF083030	Flat Washer	M8x ϕ 30xt3mm	2
17	WS080000	Spring Washer	M8	10
18	LM190000	Belt	M19	2
19	SR089400	Cap Screw	M8x16L	1
20	SS089400	Setscrew	M8x16L	3
21	204285	Belt Pulley		1
22	201333	Shaft		3
23	204008	Motor Bracket		1
24	WF122430	Flat Washer	M12x ϕ 24xt3mm	3
25	WS120000	Spring Washer	M12	3
26	SH120500	Hex Head Bolt	M12x25L	3
27	KS070730	Key	7x7x30	1
28	MH204008	Motor	5HP/3PH/400V	1
	MH204009	Motor	3HP/1PH230V	1
	MH204010	Motor	3HP/3PH/400V	1
29	SR089400	Cap Screw	M8x16L	1
31	SJ089400	Hex Socket Button Head Screw	M8x16L	8
34	204023	Rotay Block		1
35	SR120700	Cap Screw	M12x35L	3
36	204129	Shaft		1

ITEM	PART NO	PARTS NAME	SIZE	Q'TY
37	201346	Bushing		1
39	204215	Bushing		3
40	WF081818	Flat Washer	M8x ϕ 18xt1.8mm	4
43	204053	Main Arbor	CE	1
	204077	Main Arbor	CSA	1
44	204004	Arbor Flange	CE	1
	200102	Arbor Flange	CSA	1
48	204084	Splitter		1
49	204124	Washer	CSA (60Hz)	1
50	HS330009	Hose	ϕ 3"x95cm	1
51	204158	Hose Clamp	3-1/4"	2
52	AB204251	Idler Unit		1
53	AB204251-1	Idler Unit		4
55	NL120900	Nylon Nut	M12	4
59	LF410001	Flat-Belt	15x1040	1
60	204118	End Cover		2
61	204148	Bushing		1
62	991416	Hex Nut (ACME)	5/8"x12UNC(L.H)	1
	NH121902	Hex Nut	M12x1.75(L.H)	1
63	200964	Bushing		1
67	WS100000	Spring Washer	M10	4
70	SJ059300	Button Head Screw	M5x12L	4



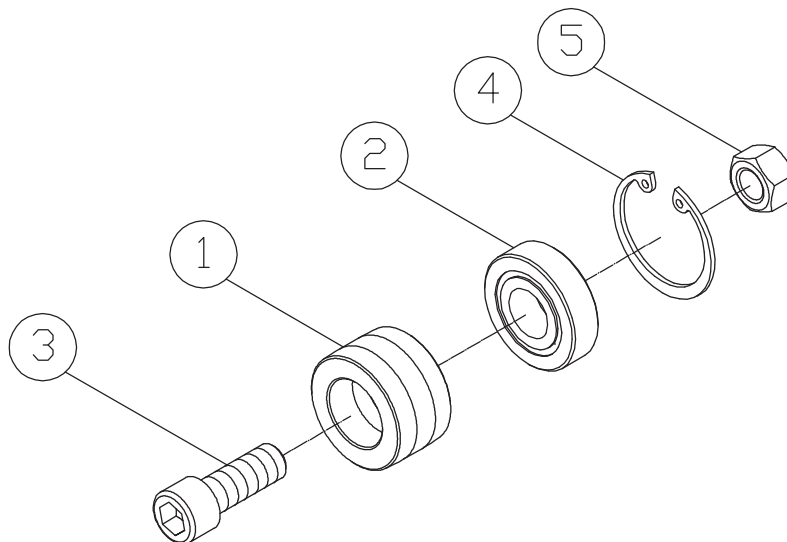
PART NO.: AB204020
SPLITTER SEAT (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
06	SS050200	SET SCREW	M5xP0.8x10L	4
05	200916	STUD		2
04	NL121900	NYLON NUT	M12	1
03	WF102825	FLAT WASHER	M10x ϕ 28xt2.5mm	1
02	SH101000	HEX HEAD BOLT	M10xP1.5x50L	1
01	204020	FIX BLOCK		1



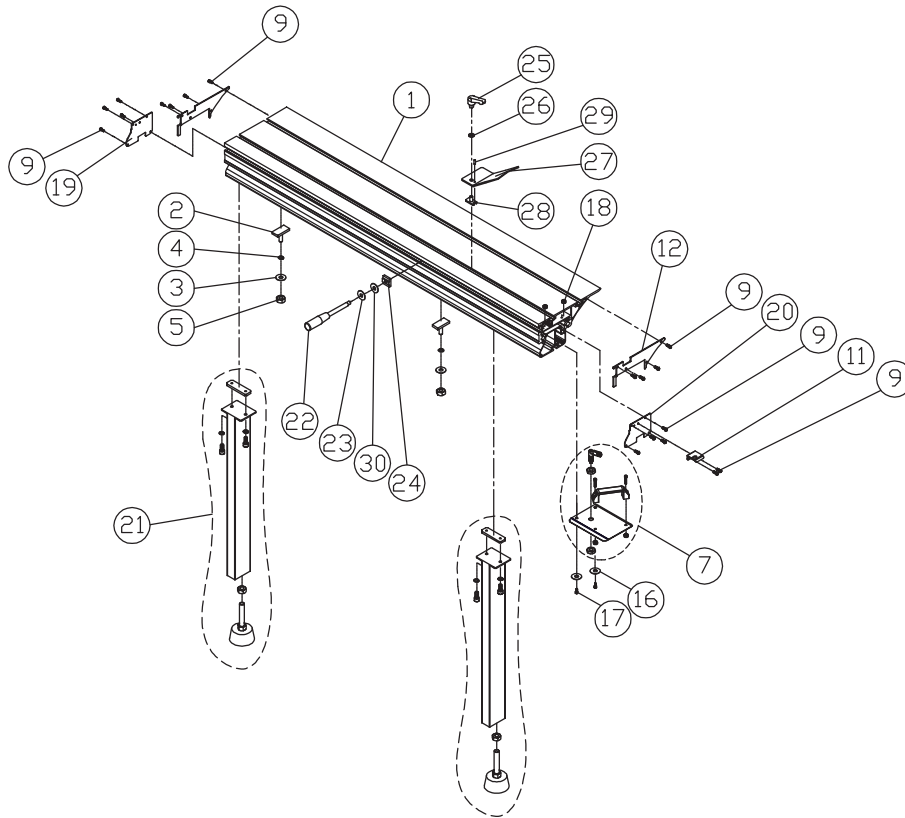
**PART NO.: AB204251
IDLER NUIT**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
12	NH081300	NUT	M8	1
11	SR080400	HEX SOCKET BOLT	M8xP1.25x20L	1
10	204247	SPRING	50L	1
09	BB600102	BALL BEARING	6001ZZ	1
08	WF122430	FLAT WASHER	M12xØ24	2
07	201547	BUSHING		1
06	RR280000	RETAINING RING	R28	1
05	201324	ROTATE PLATE		1
04	NL121900	NYLON NUT	M12xP1.75	1
03	NH121900	NUT	M12xP1.75	1
02	SR120900	HEX SOCKET BOLT	M12xP1.75x45L	1
01	204251	IDLER		1



PART NO.: AB204251-1 IDLER NUIT

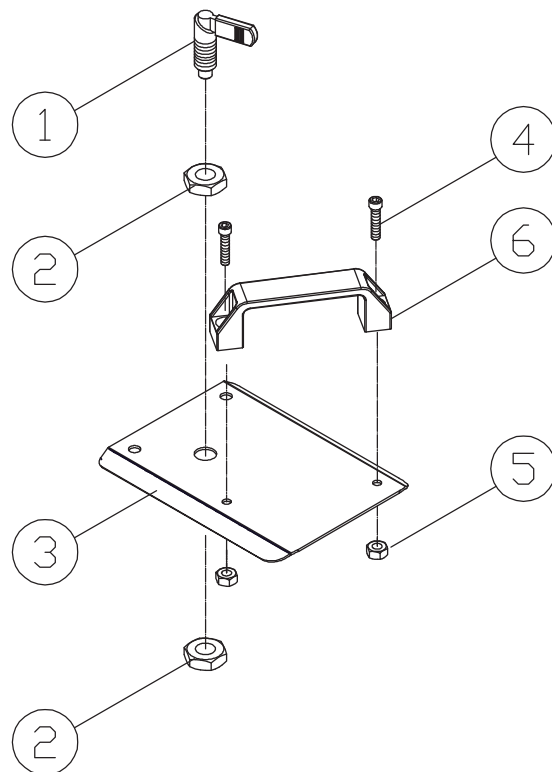
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
05	NH121900	NUT	M12xP1.75	1
04	RR280000	RETAINING RING	R28	1
03	SR120900	NUT	M12xP1.75x45L	1
02	BB600102	BALL BEARING	6001ZZ	1
01	204251	IDLER		1



ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	201469B1	Sliding Table Set	1600x316	1
2	204242	Cap Screw	M12x35	2
3	WF122430	Washer	M12x ϕ 24xt3	2
4	WS120000	Lock Washer	M12	2
5	NH121900	Hex Nut	M12xP1.75	2
7	AB204073	Push-Pull Handle ASM.		1
9	SJ069300	Button Head Screw	M6x12L	18
11	204085	Locate Block		1
12	204070	End Cover		2
16	WF061310	Washer	M6x ϕ 13xt1	2
17	SJ069400	Button Head Screw	M6x16L	2
18	NF061000	Hex Nut	M6	2
19	204071	End Cover		1
20	204096	End Cover		1
21	AB204147	Sliding Table Support (ASM.)		2
22	200939	Handle		1
23	WF123030	Washer	M12x ϕ 30xt3	1
24	201855	T-Nut	M12xP1.75	1
25	201222	Fasten Handle	M10xP1.5X20L	1
26	WF102025	Washer	M10x ϕ 25xt2.5	1
27	201830	Edge Shoe Plate		1
28	201829	T-Nut	M10xP1.5	1
29	PS051800	Spint Pin	ϕ 5x ϕ 18	1
30	992496	Plastic Washer	ϕ 13x ϕ 25xt2	1

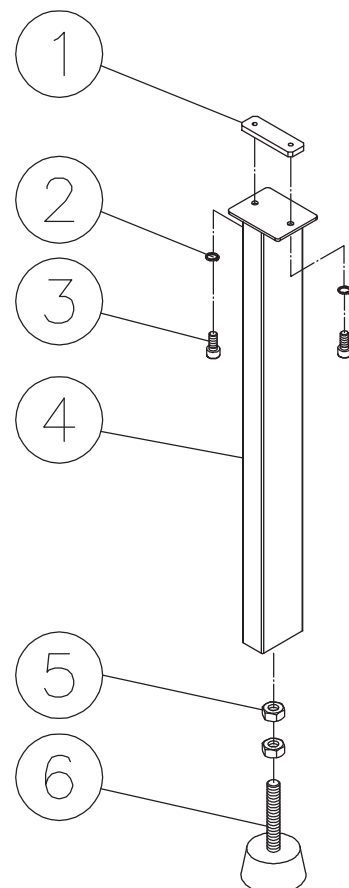
PART NO.: AB204073
PUSH-PULL HANDLE (ASM)

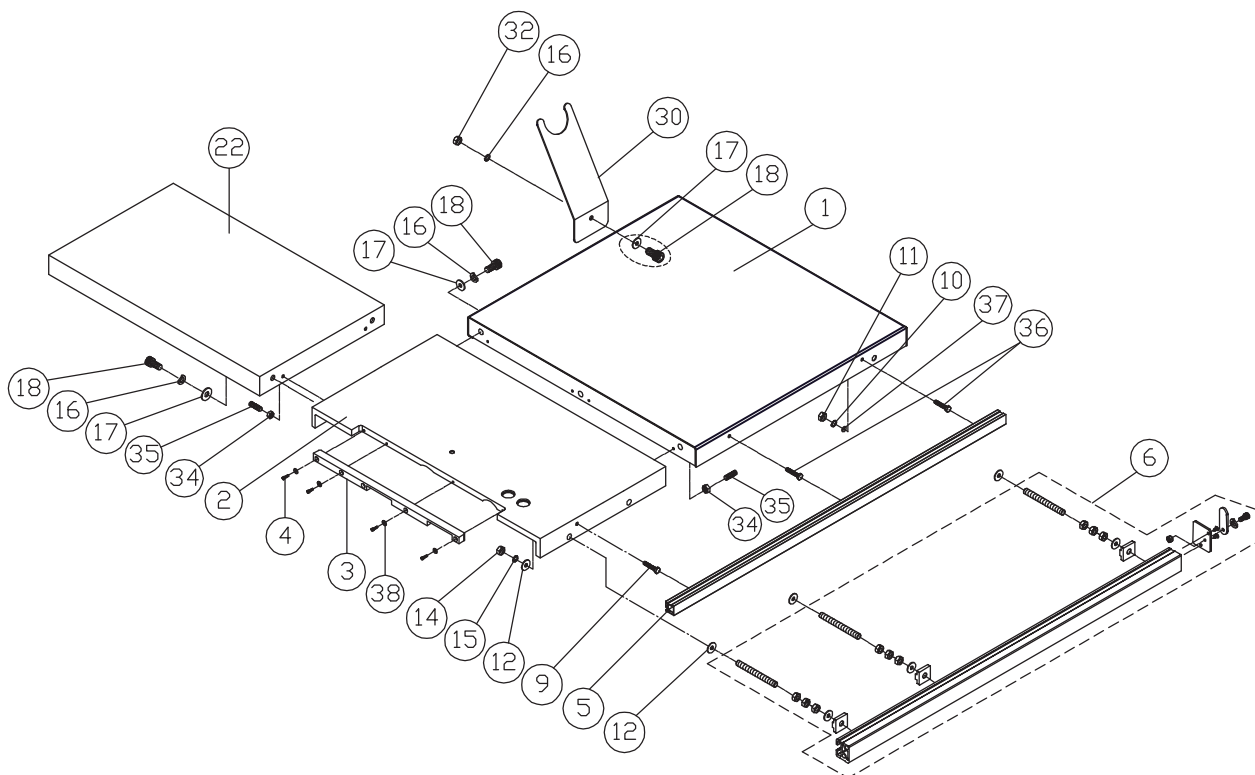
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
06	201624	HANDLE		1
05	NF061000	HEX FLANGE NUT	M6	2
04	SF069400	HEX HEAD BOLT	M6x16	2
03	204073	LOCATE PLATE		1
02	NH162400	NUT	M12	2
01	200831	PIN LOCK		1



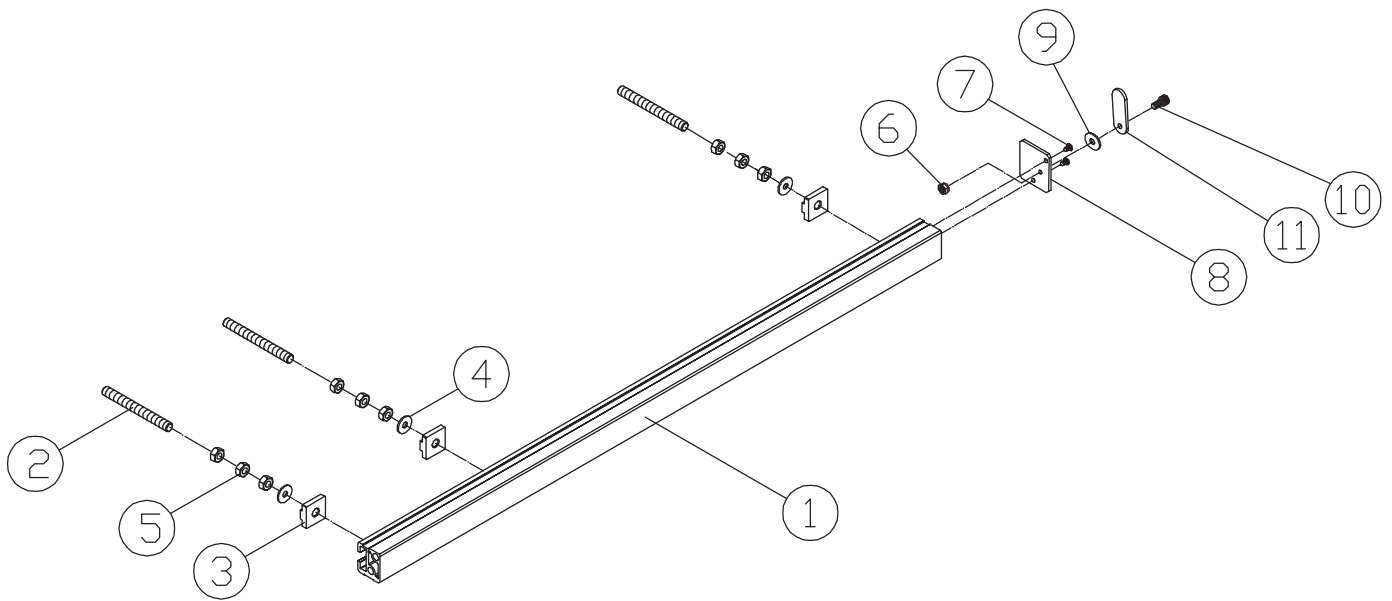
PART NO.: AB204147
SLIDING TABLE SUPPORT (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
06	201544	ADJUST FOOD	M12	1
05	NH121900	NUT	M12	2
04	204147	SUPPORT PIPE		1
03	SR080400	HEX SOCKET BOLT	M8x20L	2
02	WS080000	SPRING WASHER	M8	2
01	204052	LOCATE PLATE		1



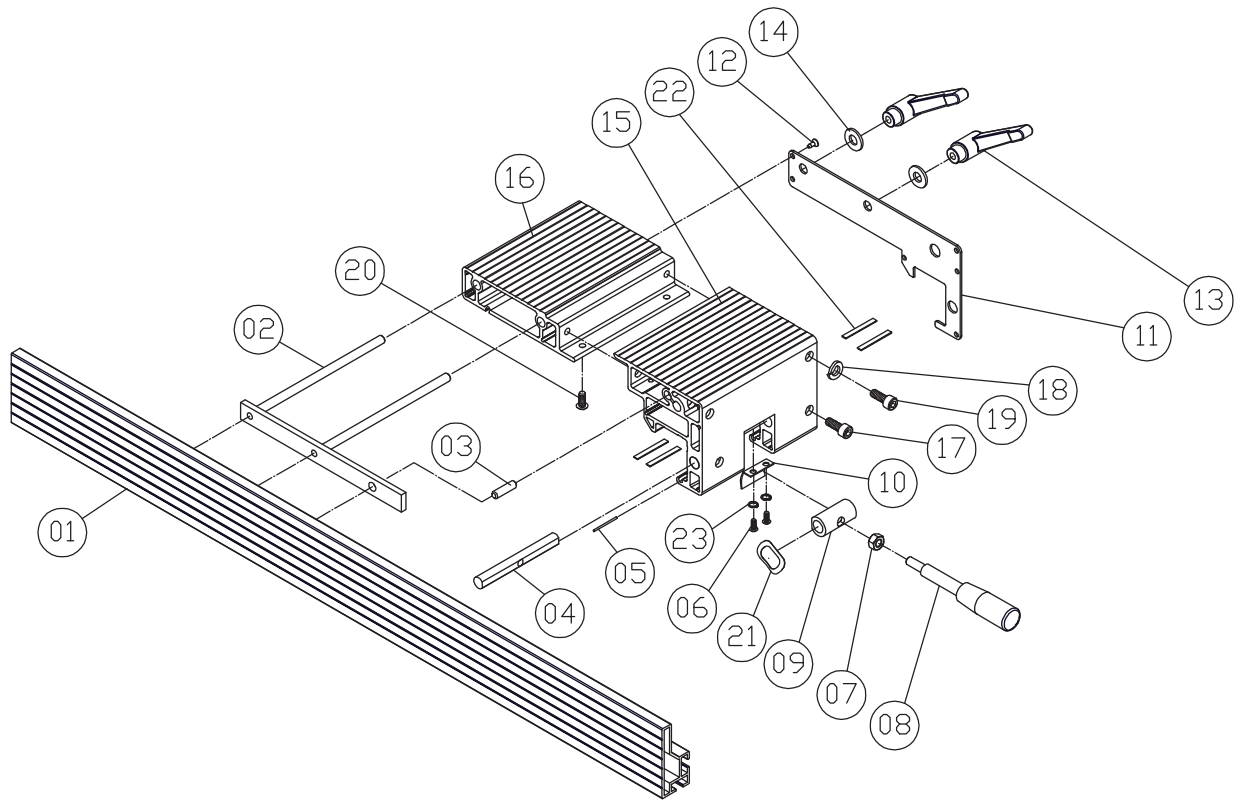


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	204028	Right Ext.Plate		1
2	204141	Table		1
3	204066	Table Insert		1
	204234	Table Insert	S(DaDo)	1
4	SR050400	Hex Socket Bolt	M5x20L	4
5	201161	Right Support Plate		1
6	AB201506	Fixed Seat (ASM.)		1
9	SH060500	Hex Head Bolt	M6x25L	1
10	WS060000	Lock Washer	M6	3
11	NH061000	Hex Nut	M6	3
12	WF122130	Flat Washer	M12x ϕ 20	6
14	WS120000	Spring Washer	M12	3
15	NH121900	Hex Nut	M12	3
16	WS100000	Spring Washer	M10	6
17	WF102025	Flat Washer	M10x ϕ 20	6
18	SR100500	Hex Socket Bolt	M10x25L	6
22	204049	Rear Ext.Plate		1
30	200522	U Supporter		1
32	NL101700	Nylon Nut	M10	1
34	NH081300	Hex Nut	M8	6
35	SS080500	Set Screw	M8x25L	6
36	SH069400	Hex Head Bolt	M6x16L	2
37	WF061310	Flat Washer	M6x ϕ 13	3
38	WF051010	Flat Washer	M5x ϕ 10	4

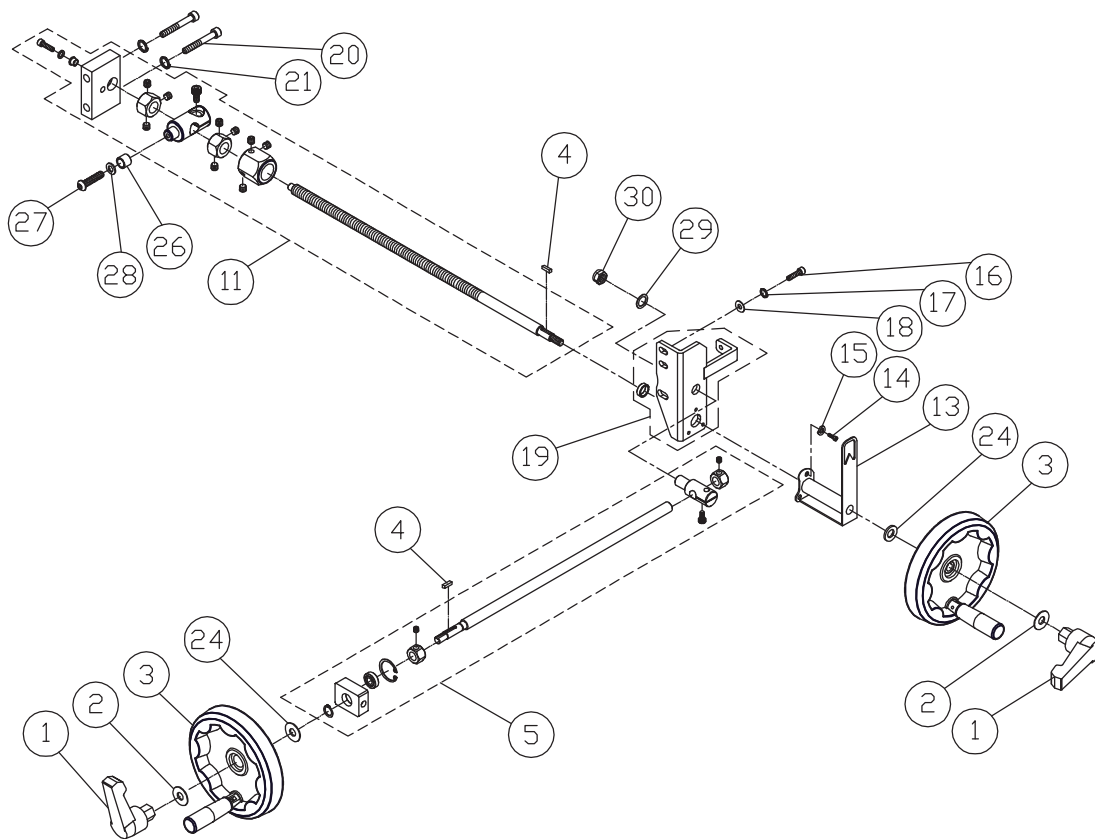


**PART NO.: AB201506
FIXED SEAT (ASM)**

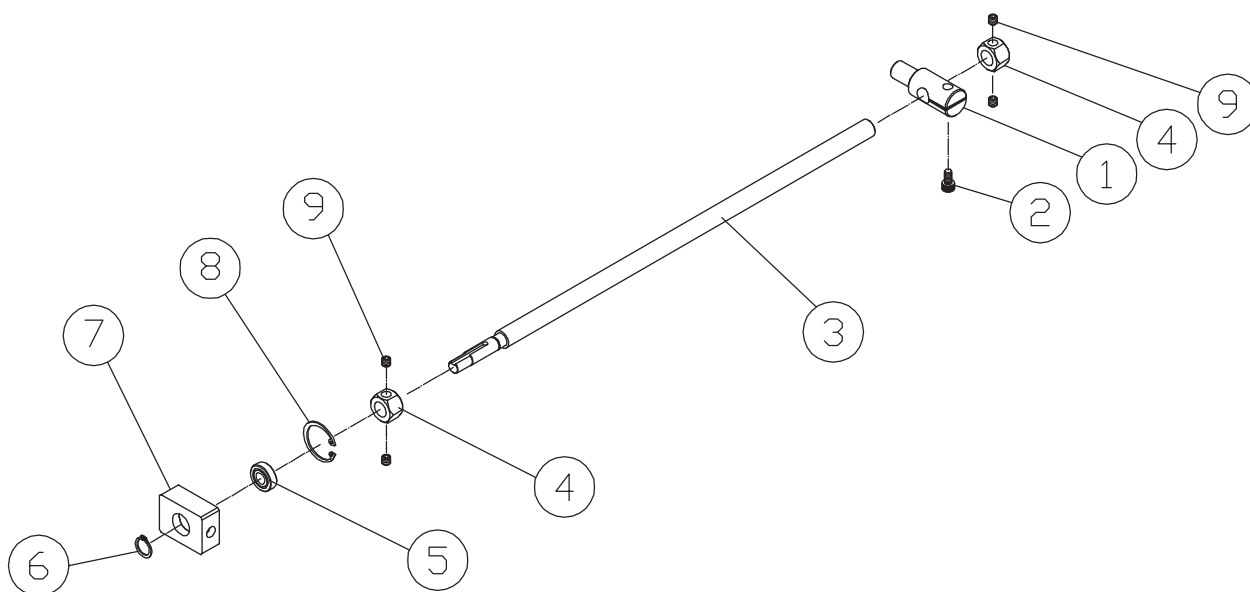
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
11	204161	PLATE		1
10	SP059400	PAN HEAD BOLT	M5xP0.8x16L	1
09	WF051010	FLAT WASHER	M5xØ10	1
08	204080	PLATE		1
07	ST040200	TAPPING BOLT	M4xP0.7x10L	2
06	NL050800	NYLON NUT	M5	1
05	NH121900	NUT	M12	9
04	WF122130	FLAT WASHER	M12X21X2T	3
03	201855	LOCATE BLOCK		3
02	204291	SCREW	M12x1.75Px90L	3
01	201506	BRACKET		1



ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	200526	Fence Plate		1
2	204288	Clamp Plate		1
3	PS083000	Spring Pin	$\phi 8 \times 30L$	1
4	204075	Rod		1
5	201479	Strip		4
6	SF050200	Pan Head Bolt W/Flange	M5x10L	2
7	NH081300	Hex Nut	M8xP1.25	1
8	204152	Handle		1
9	204076	Sleeve		1
10	204074	Spring Piece		1
11	204051	Cover Plate		1
12	ST049200	Tap Screw		6
13	204278	Quick Release	M8	2
14	WF081818	Washer	M8x $\phi 18 \times t1.8$	2
15	204016	Rip Fence Housing		1
16	204120	Rip Fence Housing		1
17	990312	Screw-Plastic	M5x16L	2
18	WS080000	Lock Washer	M8	2
19	SR080400	Cap Screw	M8x20L	2
20	SM069300	Hex Countersunk Screw	M6x12L	2
21	WW121703	Waveform Washer	$\phi 12$	1
22	204101	Strip	50x5mm	4
23	WE050000	Star Washer	M5	2

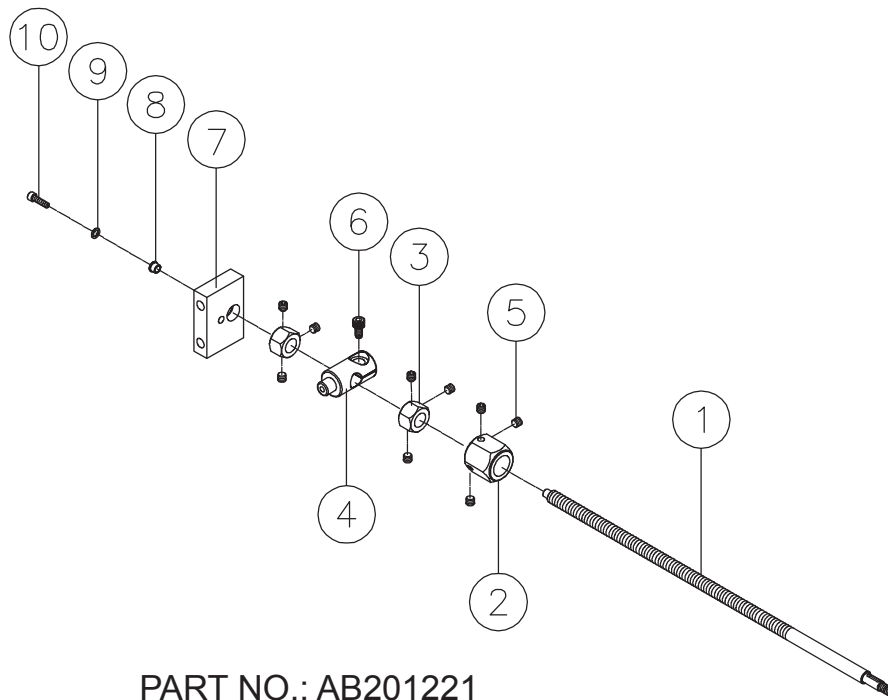


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	201222	Quick Release		2
2	WF102825	Washer	M10x ϕ 28xt2.5	2
3	204289	Handwheel	ϕ 12	2
4	KS050520	Key	5x5x20	2
5	AB204192	Tilt Adjuster ASM.		1
11	AB201221	Raising Mechanism ASM.		4
13	204030	Point		2
14	SR060200	Cap Screw	M6x10L	1
15	WS060000	Spring Washer	M6	1
16	SR080400	Cap Screw	M8x20L	1
17	WS080000	Spring Washer	M8	1
18	WF081818	Flat Washer	M8x ϕ 18xt1.8	1
19	AB204185	Supporting Bracket ASM.		6
20	SR081003	Cap Screw	M8x50L	2
21	WS080000	Lock Washer	M8	2
24	WF132625	Flat Washer	ϕ 13x ϕ 26xt2.5	1
26	204245		ϕ 13x10	1
27	SJ060200	Cap Screw	M6x10L	2
28	WF061620	Washer	M6x ϕ 16	2
29	201500	Copper Washer	ϕ 16x ϕ 24x0.2t	2
30	NL162400	Nylon Nut	M16	2



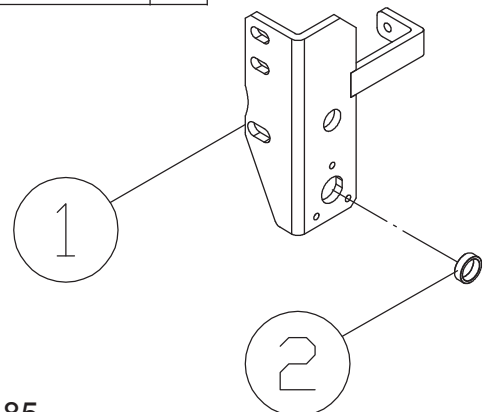
PART NO.: AB204192
TILIT ADJUSTER (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
09	SS069100	SET BOLT	M6xP1x6L	4
08	RR280000	RETAINING RING	R28	1
07	204191	ANGLE BASE		1
06	RS120000	RETAINING RING	S12	1
05	BB600102	BALL BEARING	6001	1
04	204082	HEX NUT		2
03	204192	SCREW	M16xP2x2T	1
02	SR100450	HEX SOCKET BOLT	M10xP1.0x20L	2
01	204059	ADJUST BLOCK		1



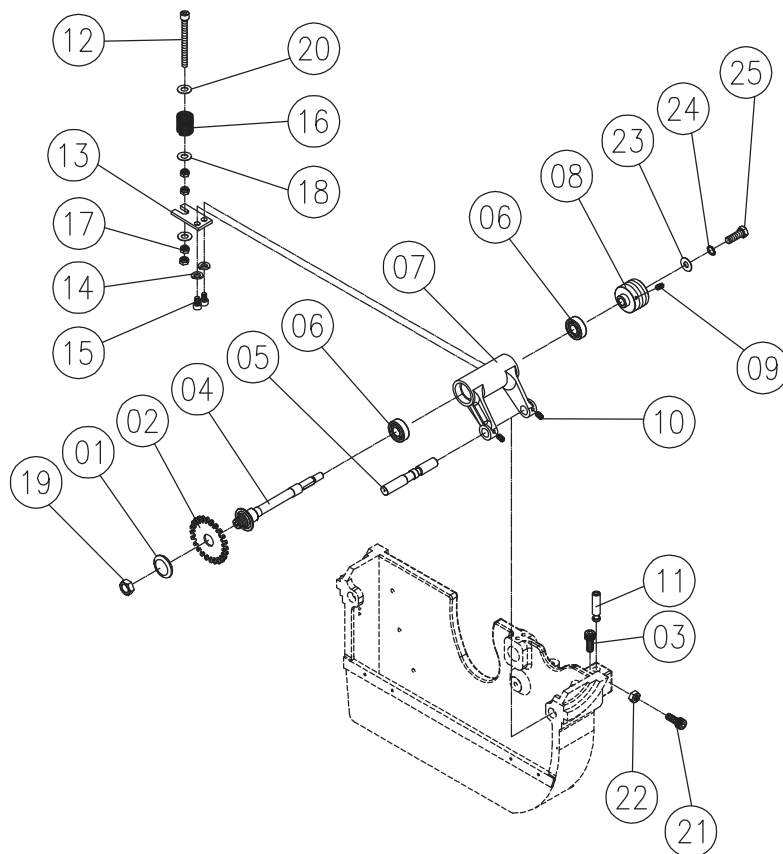
PART NO.: AB201221
RAISING MECHANISM (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
10	SJ069300	HEX SOCKET BUTTON HEAD BOLT	M5xP0.8x16L	1
09	WF061310	FLAT WASHER	M6xØ13xt1	1
08	017177	BEARING SELF LUBRICATING		1
07	201221	LOCATE BLOCK		1
06	SR100550	HEX SOCKET BOLT	M10x25L	1
05	SS069100	SET BOLT	M6X6	9
04	204026	ADJUST NUT		1
03	204250	HEX NUT		2
02	204255	LOCATE NUT		1
01	204011	SCREW		1

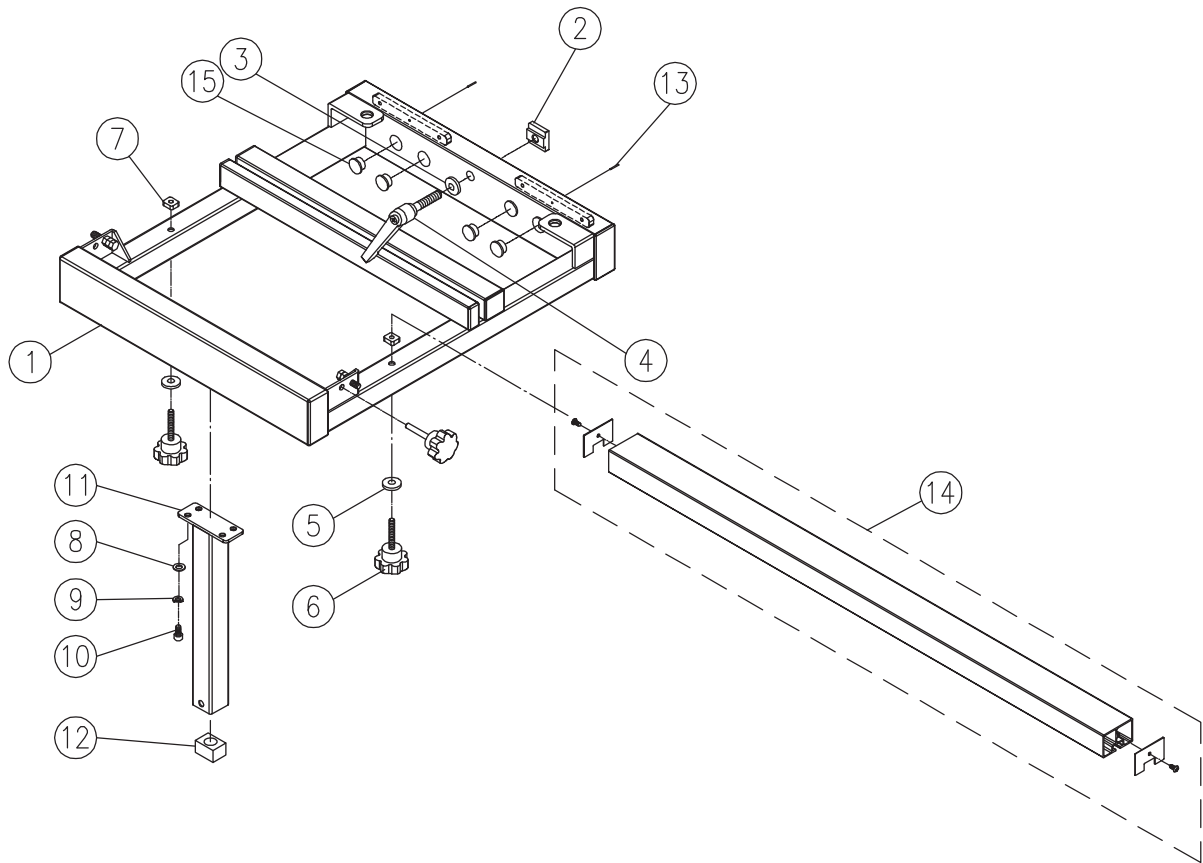


PART NO.: AB204185
SUPPORTING BRACKET (ASM)

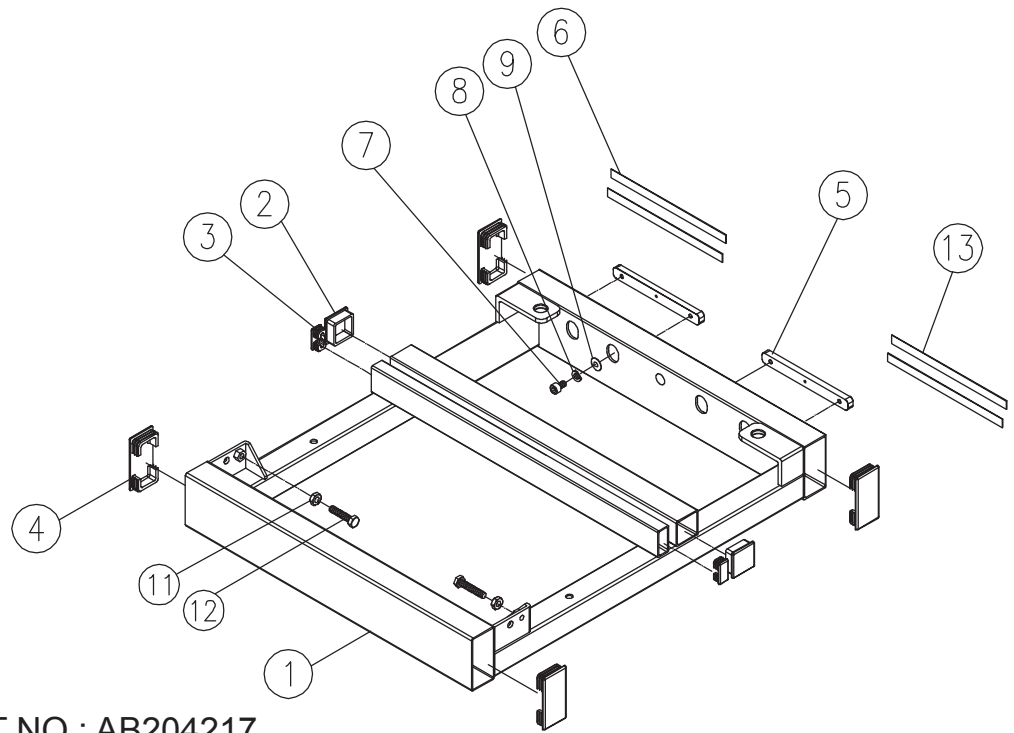
KEY NO.	PART NO.	DESCRIPTION	SIZE	Q'TY
02	204185	BUSHING		1
01	204006	SUPPORT PLATE		1



ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	204175	Arbor Flange	CSA(ϕ 22)	1
2	204058	Scoring Saw Blade		1
	204057	Scoring Saw Blade	(CE ϕ 20)	1
3	SR080400	Cap Screw	M8x20L	2
4	204056	Shaft	CSA(ϕ 22)	1
	204078	Shaft	(CE ϕ 20)	1
5	204003	Shaft		1
6	BB620204	Bearing	6202LLB	2
7	204063	Regulator		1
8	201833	Scoring Pulley	50HZ	1
	201834	Scoring Pulley	60HZ	1
9	SS069100	Setscrew	M6x6	2
10	SS069100	Setscrew	M6x6	2
11	204064	Adjust Shaft		1
12	SR082000	Adjust Screw	M8xP1.25x100L	1
13	204019	Plate	M8	1
14	WS080000	Lock Washer		2
15	SR080500	Cap Screw	M8x25L	2
16	204156	Lock		1
17	NH081300	LOCK NUT	M8xP1.25	4
18	WF082320	Washer	M10x ϕ 23xt2	2
19	NH121900	Hex Nut	M12	1
20	WF081818	Washer	M10x ϕ 18xt1.8	1
21	SR060400	Cap Screw	M6x20	1
22	NH061000	Hex Nut	M6	1
23	WF063030	Washer	M6x ϕ 30xt3	1
24	WS060000	Lock Washer	M6	1
25	SH069402	Hex Head Bolt	M6X16(L.H)	1

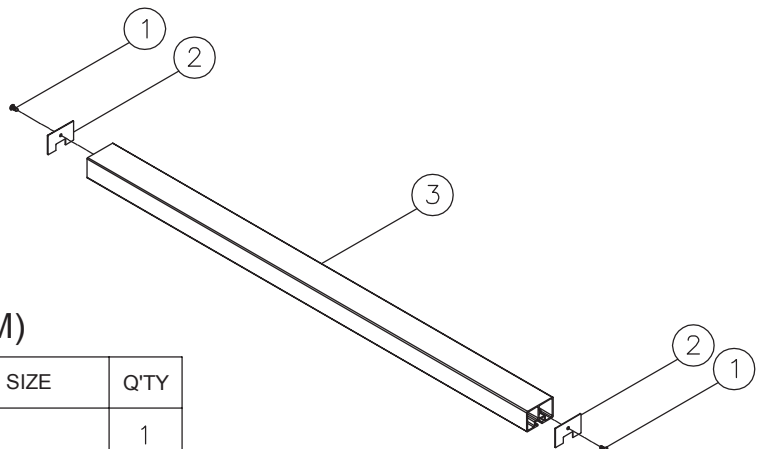


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	AB204217	Extension Frame		1
2	201855	T-Nut	M12xP1.75	1
3	WF123030	Washer	M12x ϕ 30xt3	1
4	200815	Adjust Handle	M12xP1.75x55L	1
5	WF083030	Washer	M8x ϕ 30xt3mm	2
6	200954	Knob Screw	M8x50L	3
7	201103	T-Nut	M8xP1.25	2
8	WF061620	Washer	M6	4
9	WS060000	Lock Washer	M6	4
10	SR069400	HEX SOCKET BOLT	M6x16L	4
11	204169	Supporting Strut		1
12	203094	Plug		1
13	BR000070	Rivig	§ 4.8x15	2
14	AB200833	Square Brace ASM.		1
15	201458	Plug		4



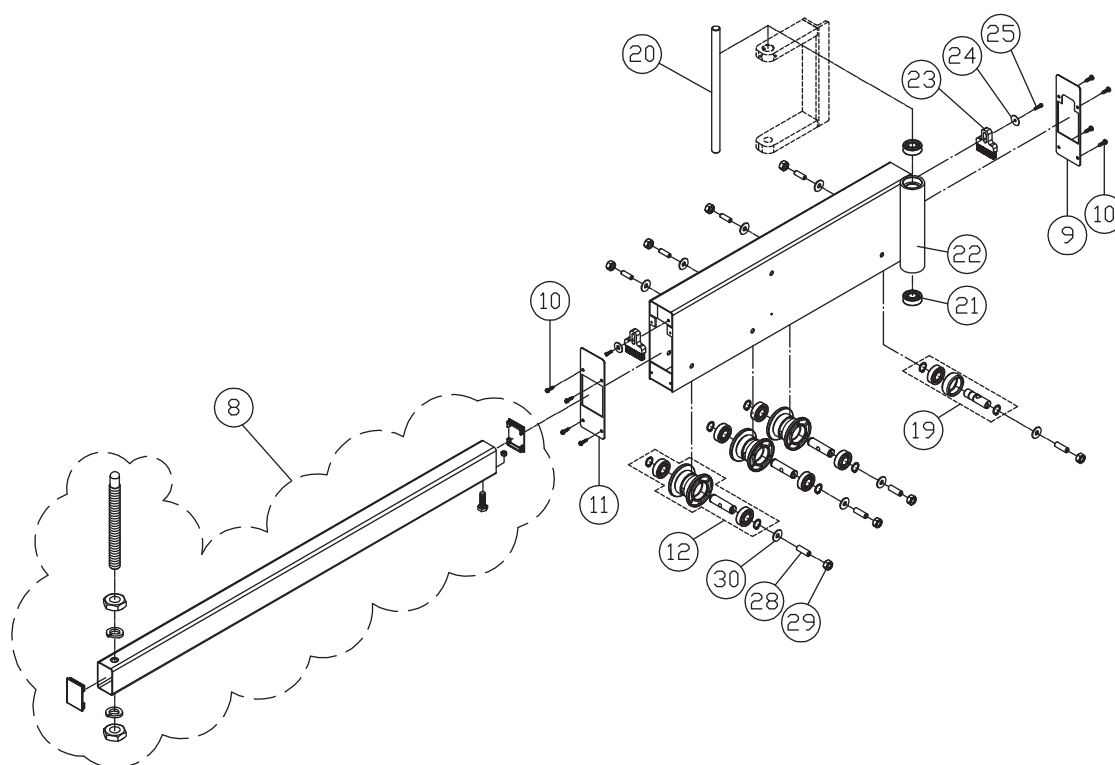
PART NO.: AB204217
EXTENSION FRAME

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
13	204276	SPONGE	2x10x500mm	2
12	SH080800	HEX HEAD BOLT	M8x40L	2
11	NH081300	NUT	M8	2
09	WF061620	FLAT WASHER	M6xø16xt2	4
08	WS060000	SPRING WASHER	M6	4
07	SJ069400	HEX SOCKET BUTTON HEAD BOLT	M6x16L	4
06	204214	PAD		2
05	204262	LOCATE PLATE		2
04	200910	PLUG	80x40	4
03	200919	PLUG	40x20	2
02	200969	PLUG	38x38	2
01	204217	EXTENSION FRAME		1

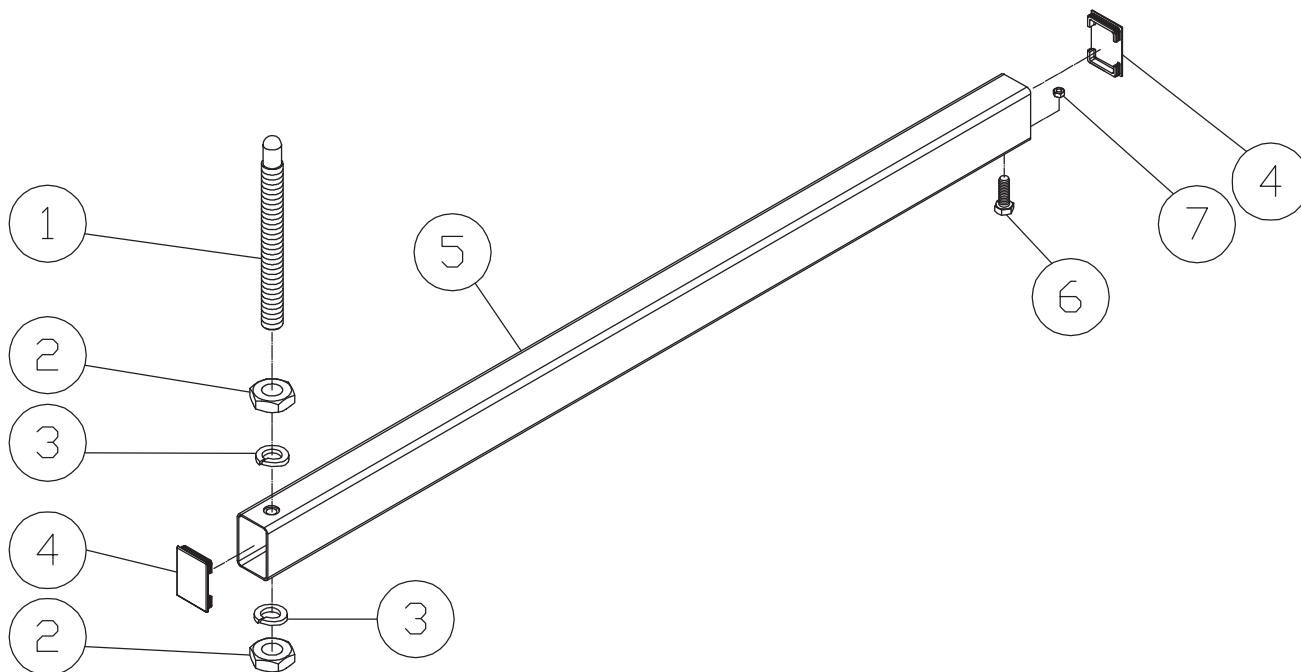


PART NO.: AB200833
SQUARE BRACE (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
03	200833	SQUARE BRACE		1
02	200955	COVER		2
01	ST040200	TAPPING BOLT	M4x3/8"	2

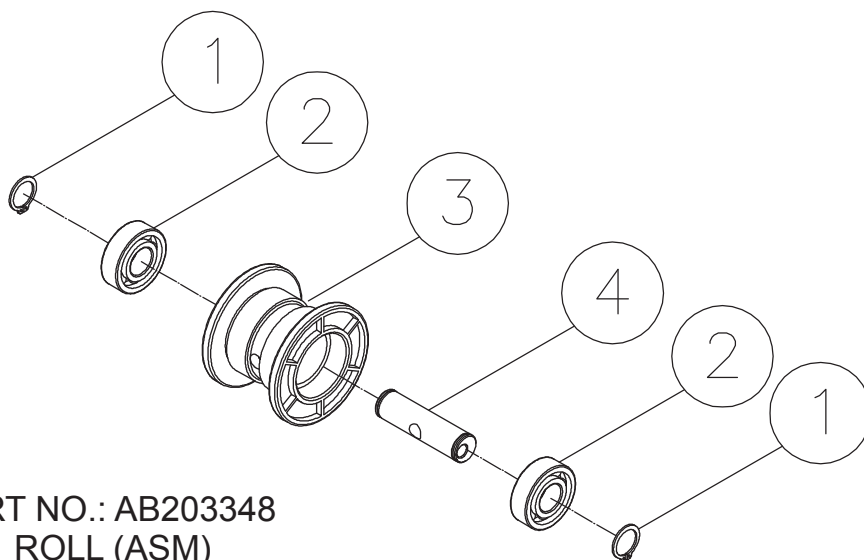


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
8	AB204241	Sliding Tube ASM.		1
9	204239	Cover		1
10	ST040200	Phillips Head Sheet Metal Screw	M4×10	8
11	204240	Cover	ROLL ASM.	1
12	AB203348	ROLL (ASM)		3
19	AB203356	ROLLING RING (ASM)		1
20	204135	Setscrew		1
21	BB620202	Bearing	6202ZZ	2
22	204038	Swing Arm		1
23	135051	Brush		2
24	WF061310	Washer	M6×13	2
25	SR060400	Cap Screw	M6×20	2
28	SS080500	Setscrew	M8X25	8
29	NH081300	Hex Nut	M8	8
30	WF081818	Washer	M8×18	8



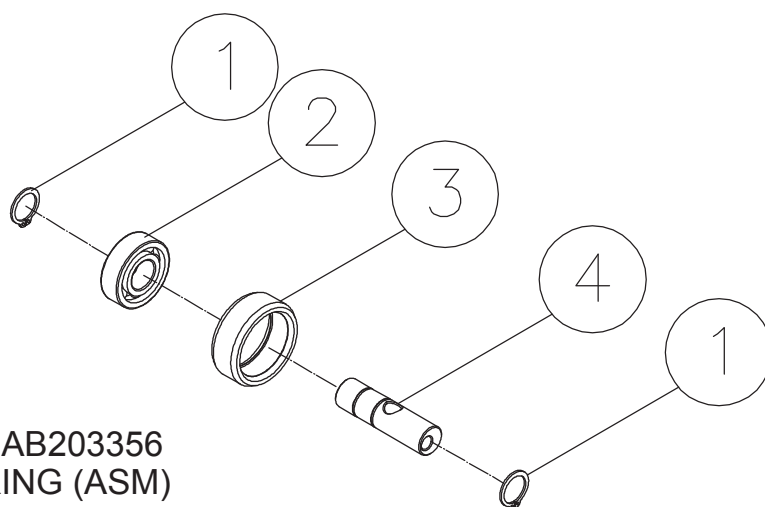
PART NO.: AB204241
SLIDING TUBE (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
07	NH081300	NUT		1
06	SJ080600	HEX SOCKET BUTTOM HEAD BOLT	M8×30L	1
05	204241	SUPPORT PIPE		1
04	200910	PLUG	40×80	2
03	WS200000	SPRING WASHER	M20	2
02	NH203000	NUT	M20	2
01	205505	ROTATE SHAFT		1



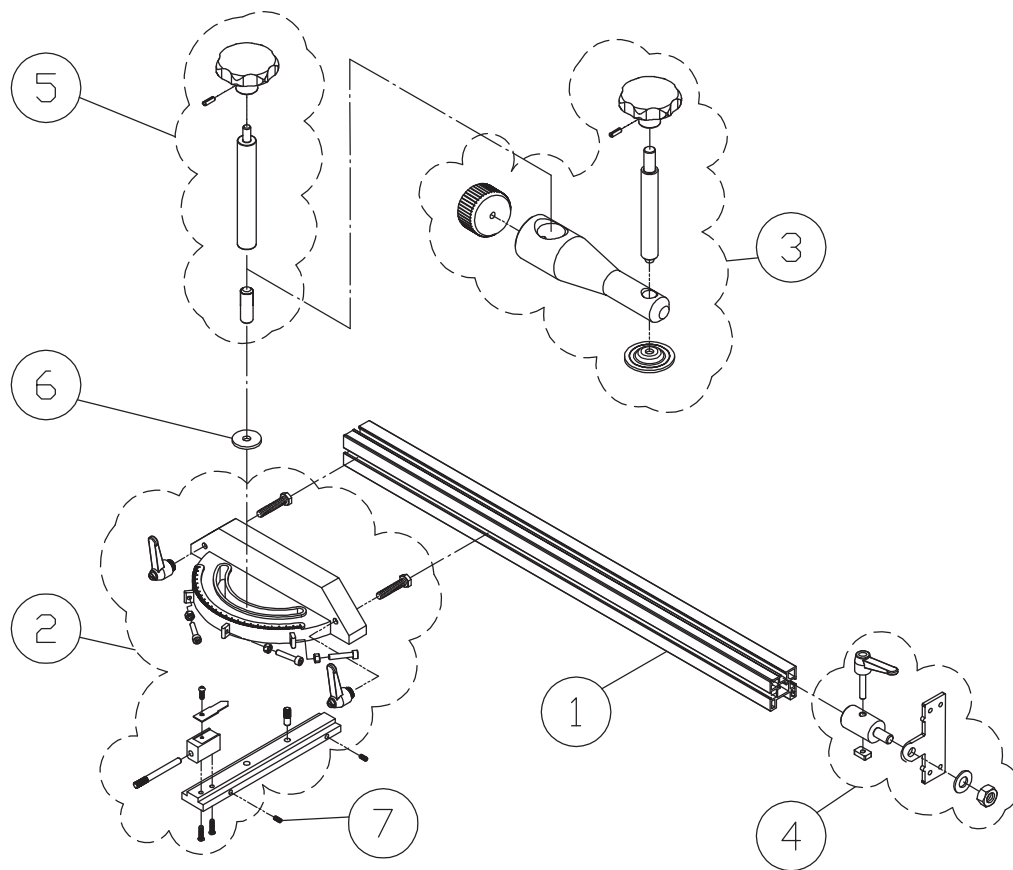
PART NO.: AB203348
ROLL (ASM)

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
04	203349	SHAFT		1
03	203348	ROLLER		1
02	BB620202	BALL BEARING	6202ZZ	2
01	RS150000	RETAINING RING	S15	2



PART NO.: AB203356
ROLLING RING (ASM)

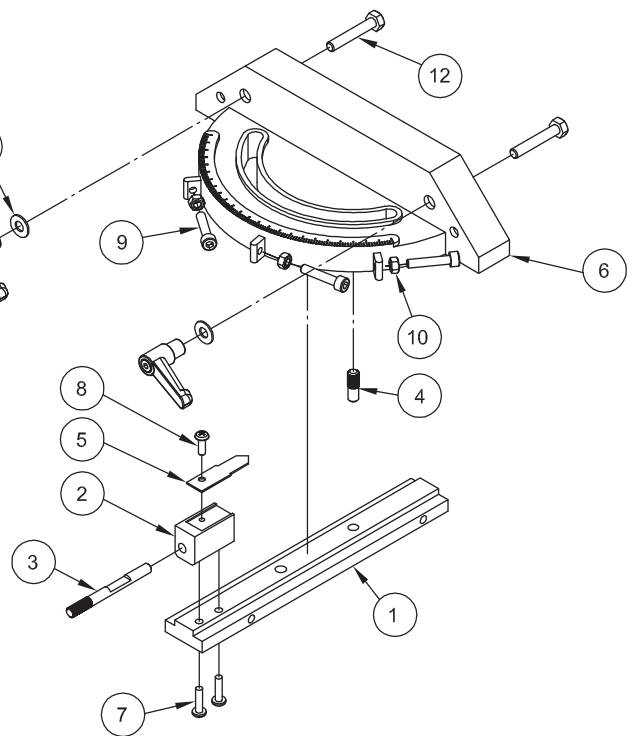
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
04	203357	SHAFT		1
03	203356	RING		1
02	BB620202	BALL BEARING	6202ZZ	1
01	RS150000	RETAINING RING	S15	2



ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	017210	Square Fence		1
2	AC204295	Miter Gauge Body		1
3	AB204201	Holding-Down Clamp		1
4	AB017219	Location Stop ASM.		1
5	AB204106A	Rotary Shaft		1
6	WF102825	Flat Washer	M10x ϕ 28xt2.5	1
7	201632	Spring plungers with ball	M4x9	2

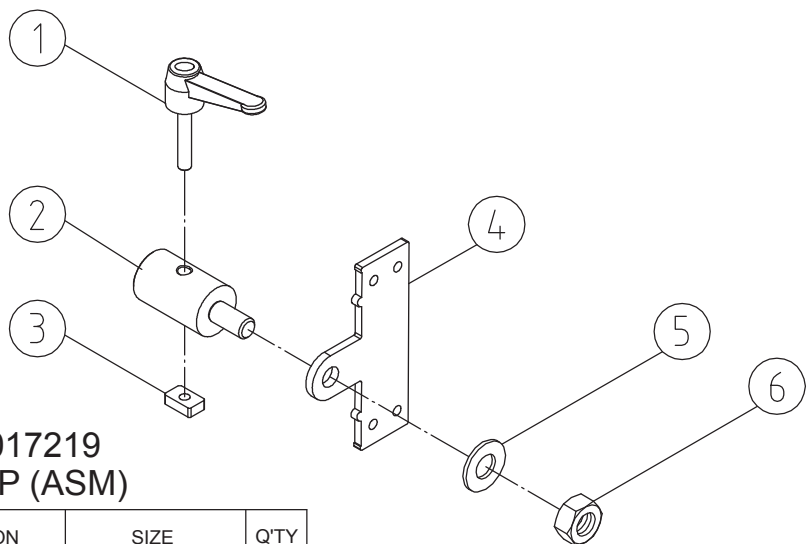
**PART NO.: AC204295
MITER GAUGE BODY**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
13	WF061620	FLAT WASHER	M6X16	2
12	SH060700	HEX BOLT	M6X35	2
11	017003	ADJUST HANDLE	M6	2
10	NH050800	HEX NUT	M5	3
9	SR050500	CAP SCREW	M5X25	3
8	SP049300	PHLP HD SCR	M4X12	1
7	SP049400	PHLP HD SCR	M4X16	2
6	198170	MITER GAUGE BODY		1
5	201366	POINTER		1
4	198174	SHAFT		1
3	201367	STOP BAR		1
2	201365	FIXED BLOCK		1
1	204295	FIXED BASE		1



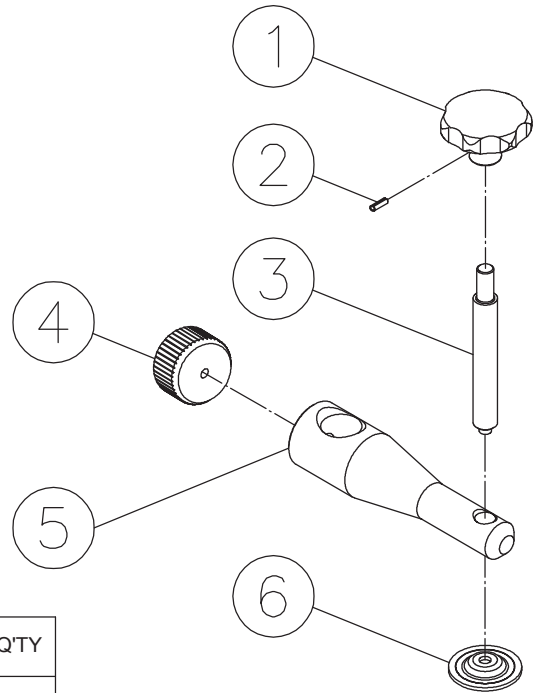
**PART NO.: AB017219
LOCATION STOP (ASM)**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
06	NL101700	NYLON NUT	M10	1
05	WF102025	FLAT WASHER	M10x20x2.5t	1
04	017219	PLATE		1
03	NS061000	NUT	M6	1
02	200343	LOCATE SHAFT		1
01	200415	ADJUST HANDLE	M6x30L	1



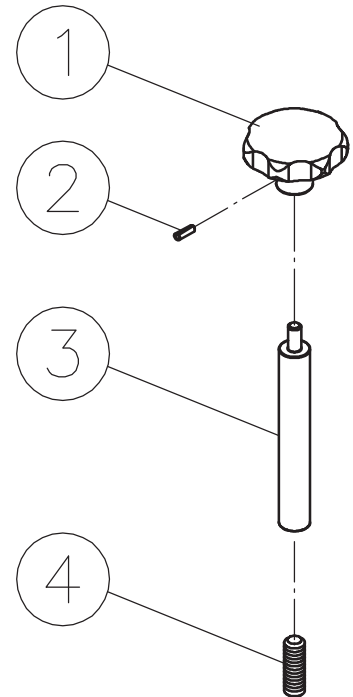
**PART NO.: AB204201
HOLDING-DOWN CLAMP**

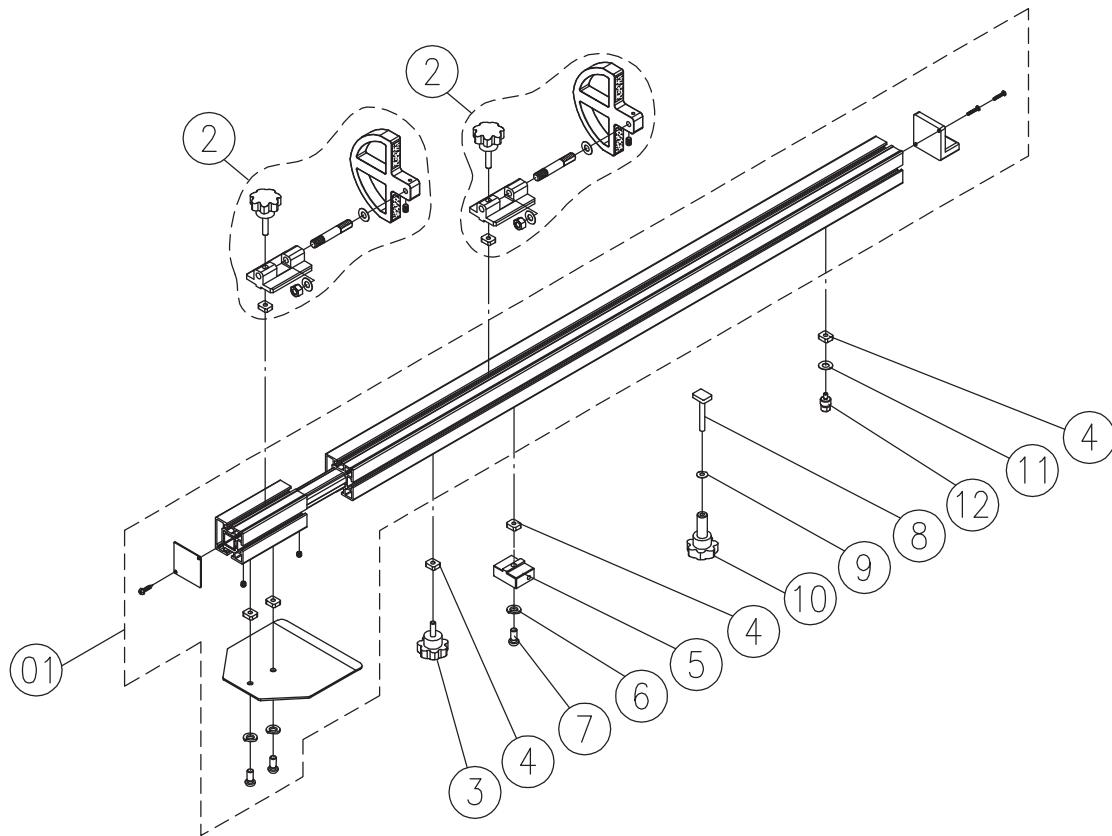
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
06	017216	PLATE		1
05	204201	BODY		1
04	017212	LOCK BOLT		1
03	204104	ADJUST SHAFT		1
02	PS032000	SPRING PIN	ø3x20L	1
01	150046	KNOB		1



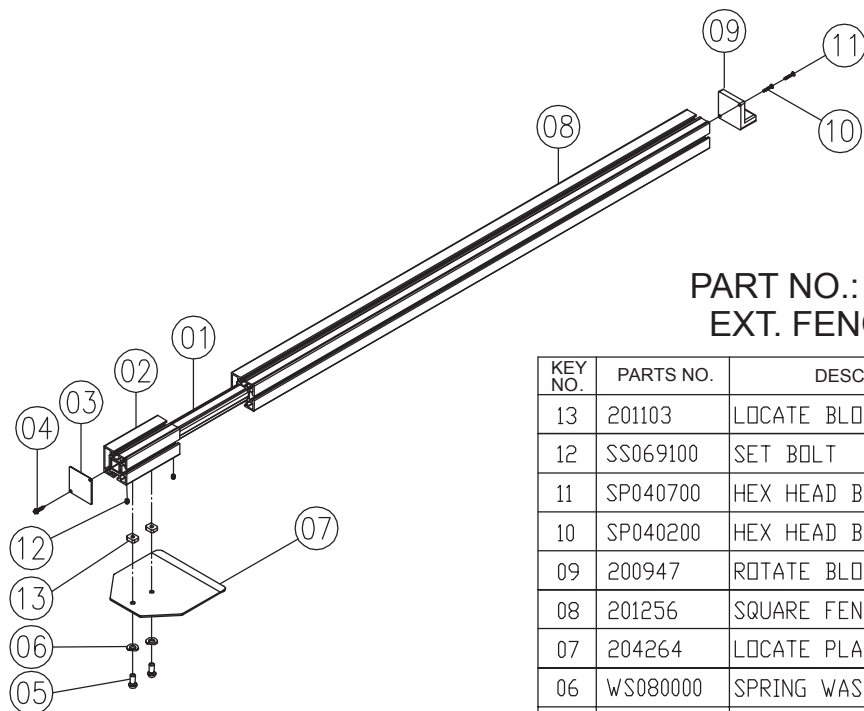
**PART NO.: AB204106A
ROTARY SHAFT**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
04	SS060900	SET BOLT	M6x45L	1
03	204106A	SHAFT		1
02	PS032000	SPRING PIN	ø3x20L	1
01	150046	KNOB		1



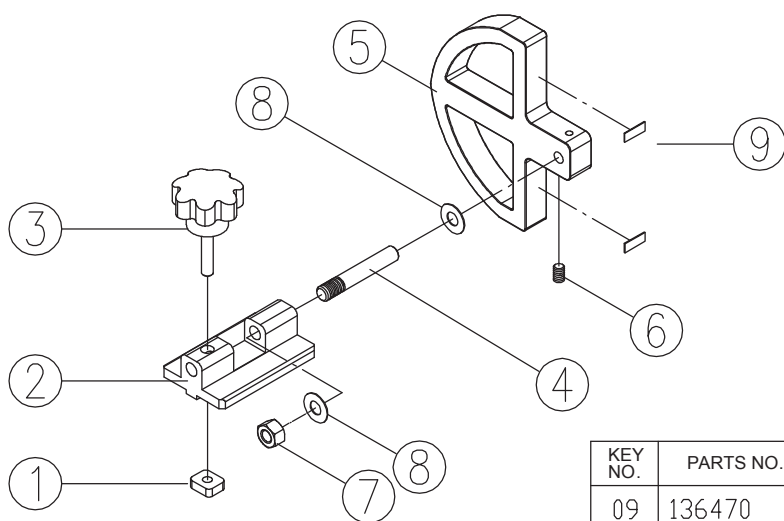


ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	AB204268	Ext. Fence ASM.		1
2	AB200823	Flip Stop		2
3	200937	Knob Screw	M8x1.25px25L	1
4	201103	T-Nut	M8x1.25p	3
5	201465	Block		1
6	WS080000	Lock Washer	M8	1
7	SR080700	Cap Screw	M8X35	1
8	200953	T-Bolt	M8x1.25px60L	1
9	WF083030	Washer	M8X30	1
10	200952	Knob Screw	M8X55	1
11	WF102015	Washer	M10X20x1.5t	1
12	200832	Rotate Shaft		1



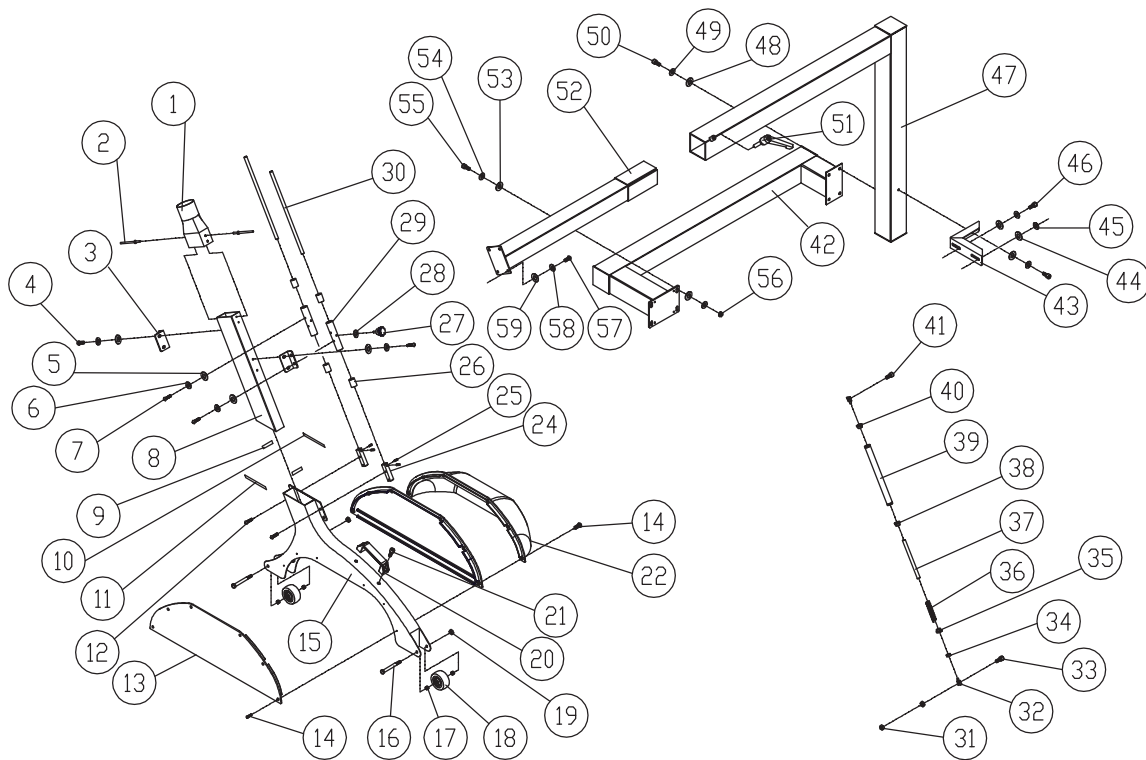
**PART NO.: AB204268
EXT. FENCE (ASM)**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
13	201103	LOCATE BLOCK		2
12	SS069100	SET BOLT	M6x6L	2
11	SP040700	HEX HEAD BOLT	M4x35L	1
10	SP040200	HEX HEAD BOLT	M4x10L	1
09	200947	ROTATE BLOCK		1
08	201256	SQUARE FENCE		1
07	204264	LOCATE PLATE		1
06	WS080000	SPRING WASHER	M8	2
05	SJ089400	HEX SOCKET BUTTON HEAD BOLT	M8x16L	2
04	ST040200	TAPPING BOLT	M4x10L	2
03	200830	PLATE		1
02	204268	EXTEND FENCE		1
01	201257	PIPE		1



**PART NO.: AB200823
FLIP STOP**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
09	136470	WEARPROOF FLAKE		2
08	992602	COPPER WASHER	ø11xø18x+t0.5	2
07	NL101700	NYLON NUT	M10xP1.5	1
06	SS080200	SET BOLT	M8xP1.25x10L	1
05	200823	BLOCK PLATE		1
04	200824	ROTATE SHAFT		1
03	200827	KNOB BOLT	M8xP1.25x40L	1
02	200826	ADJUST BLOCK		1
01	201103	LOCATE BLOCK		1



ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	201093	Dust Port		1
2	BR000041	Rivet	4-1	4
3	201098	Fixed Plate		2
4	SJ069300	Hex Socket Bootom Head Screw	M6x12	4
5	WF061310	Flat Washer	M6x ϕ 13	8
6	WS060000	Spring Washer	M6	8
7	SJ060200	Hex Socket Bootom Head Screw	M6x10	4
8	201090	Dust Bracket		1
9	201120	Seal		2
10	201119	Seal		1
11	201118	Seal		1
12	SJ060400	Hex Socket Bootom Head Screw	M6x20	4
13	205356	Protective Plate		2
14	SP049200	Pan Head Screw	M4*8	12
15	205673	Guard		1
16	SH081200	Hex Head Bolt	M8x60	2
17	201130	Bushing		4
18	201092	Roller		2
19	NL081300	Nylon Nut	M8	2
20	201624	Handle		1
21	SR089400	Hex Socket Bolt	M8x16	2
22	205355	Guard		1
24	201096	Bracket		2
25	SS069100	Set Screw	M6x6	4
26	BL190402	Bearing	LM10UU	4
27	201100	Knob	M6x15	1
28	NH061000	Nut	M6	1
29	201099	Bearing Bushing		2
30	201097	Sliding Rod		2

ITEM	PART NO	PARTS NAME	SIZE	Q'TY
31	NH081300	Nut	M8	2
32	201115	Bolt	M6x10	2
33	SR080600	Hex Socket Bolt	M8x30	1
34	201126	Pad		1
35	201111	Bottom Cover		1
36	201127	Spring		1
37	201113	Rod		1
38	201114	Screw		1
39	201110	Pipe		1
40	201112	Top Cover		1
41	SR089400	Hex Socket Bolt	M8x16	1
42	204237	Support Bracket		1
43	204235	Support Bracket		1
44	WF081818	Flat Washer	M8x φ 18	3
45	WS080000	Spring Washer	M8	3
46	SR080400	Hex Socket Bolt	M8x20	3
47	204236	Support Bracket		1
48	WF081818	Flat Washer	M8x φ 18	4
49	WS080000	Spring Washer	M8	4
50	SR080400	Hex Socket Bolt	M8x20	4
51	201109	Fasten Handle	M10x35	1
52	201392	Fixed Bracket		1
53	WF081818	Flat Washer	M8x φ 18	8
54	WS080000	Spring Washer	M8	8
55	SR080500	Hex Socket Bolt	M8x25	4
56	NH081300	Nut	M8	4
57	SJ069300	Hex Socket Bootom Head Screw	M6x12	4
58	WS060000	Spring Washer	M6	4
59	WF061310	Flat Washer	M6x φ 13	4

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