



OPERATOR'S MANUAL

Wood Working



SLIDING TABLE SAW MODEL: STS-14120

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THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without a RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without a RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 30 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (e) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing, and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator's manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorneys' fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy.

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at sales@baileighindustrial.com



INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



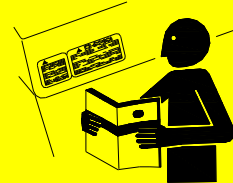
Note: *This symbol refers to useful information throughout the manual.*



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

DANGER: Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING: Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION: Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE: Indicates a situation which, if not avoided, could result in property damage.

 **DANGER**

 **WARNING**

 **CAUTION**

NOTICE

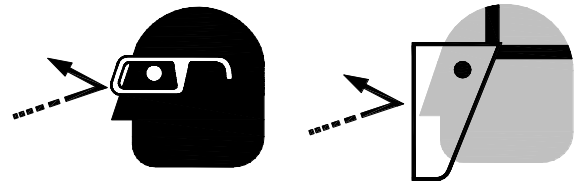


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



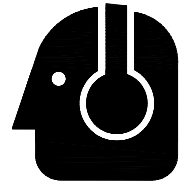
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



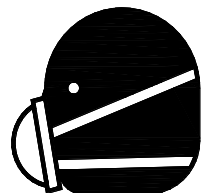
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



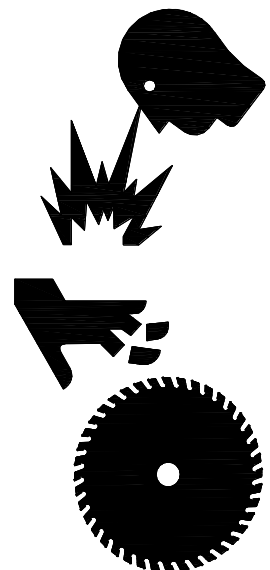
DUST HAZARD

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long term respiratory damage. Be aware of the dust hazards associated with all types of materials.



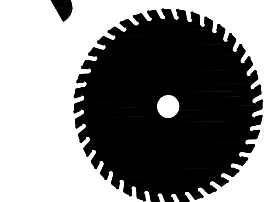
DUST PARTICLES AND IGNITION SOURCES

DO NOT operate the table saw in areas where explosion risks are high. Such areas include locations near pilot lights, open flames, or other ignition sources.



ROTATING BLADE HAZARD

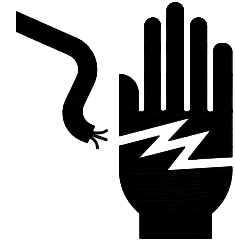
Moving saw blade may result in loss of fingers or limb. **DO NOT** operate with guard removed. Follow lockout/tagout procedures before servicing.





HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off.
(FOLLOW PROPER LOCKOUT PROCEDURES)



EMERGENCY STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset.

Note: Resetting the E-Stop will not start the machine.



SAFETY PRECAUTIONS



Wood working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, push sticks, hold-downs, feather boards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN
SERIOUS PERSONAL INJURY**

Dear Valued Customer:

- All Baileigh woodworking machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.



Please enjoy your Baileigh machine!Please enjoy it SAFELY!

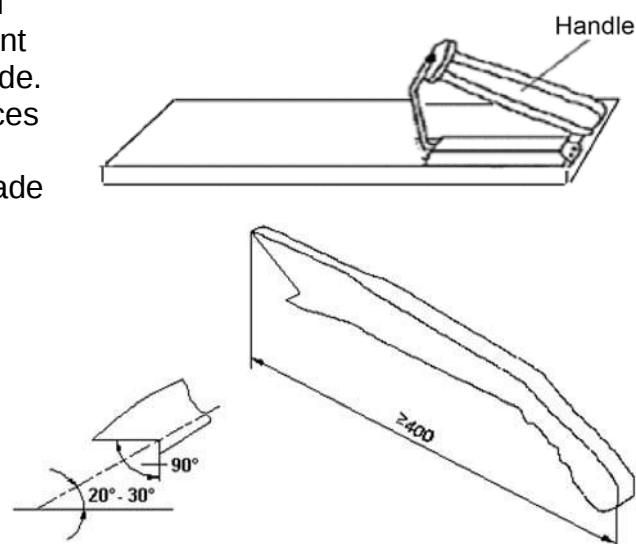
1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel should operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Kickback.** Kickback happens when the piece part is thrown back toward the operator at a high rate of speed. Before operating this saw, understand how kickback occurs, and how to prevent it.
5. **Reaching Over Saw Blade. NEVER** reach behind or over the blade with either hand while the saw is operating. If kickback of a piece part were to occur, you could amputate your hands, arms, or fingers.
6. **Blade Height.** Adjust the blade to the correct height above the piece part so it does not kickback toward the operator causing injury.
7. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
8. **Blade Guard / Riving Knife.** To reduce the risk of kickback, always use the riving knife and blade guard. Make sure they are properly installed during cutting operations.
9. **Dado and Rabbet Operations.** Dado and Rabbeting operations require that the blade guard be removed. Be aware of your personal safety while the guard is off, and replace the blade guard after these operations are completed.
10. **Keep work area clean.** Cluttered areas invite injuries.
11. **Push Sticks and Push Blocks.** When ripping narrow stock, there is a risk of your hands and fingers contacting the rotating blade, resulting in **serious personal injury.**
12. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
13. **Crosscutting Operations.** Remove the rip fence whenever using the miter gauge to crosscut a piece part.
14. **Operator Position.** If kickback occurs, the blade will eject the piece part into the path of the operator. **NEVER** stand in- line with the cutting path of the blade during operation.
15. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
16. **Awkward Positions.** Avoid awkward hand and body positions where a sudden slip could cause your hands or body to contact the spinning blade.
17. **Use eye and ear protection.** Always wear ISO approved impact safety goggles



18. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
19. **Damaged Saw Blades.** A damaged saw blade can cause kickback. If in doubt as to the condition of the blade, **DO NOT** use it.
20. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
21. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for binding of moving parts that may affect proper machine operation.
22. **Observe work area conditions.** **DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
23. **DO NOT** bypass or defeat any safety interlock systems.
24. Know the location of the **ON - OFF** switch and the **"E"- STOP** button.
25. **Removing Piece Parts.** Before removing cut-offs, always turn the saw **OFF**, and wait for the blade to stop turning, to avoid contact with a moving blade.
26. **Control of the Piece Part.** If the piece part should unexpectedly move or bind the blade, kickback could occur. Make sure the piece part is supported by either the rip fence or the crosscut fence. **NEVER** back a piece part out of a cut.
27. **Supporting Piece Part.** Provide adequate support to the sides and rear of the saw table for material that is extra wide and long.
28. Keep visitors a safe distance from the work area.
29. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
30. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
31. **DO NOT** touch live electrical components or parts.
32. **Be Sure** all equipment is properly installed and grounded according to national, state, and local codes. If machine is equipped with a three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.
33. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
34. **Maintain machine in top condition.** Keep clean for best and safest performance. Follow instructions for lubricating and changing accessories.



35. **Reduce the risk of unintentional starting.** Make sure switch is in “**OFF**” position before plugging in power cord.
36. **Never leave machine running unattended. TURN POWER OFF.** Don’t leave machine until it comes to a complete stop.
37. **Make sure machine is disconnected from power supply** while motor is being mounted, connected or reconnected.
38. **Saw Appropriate Material.** Only use this saw for natural wood stock and wood stock products such as particle board, plastics, laminates, and medium-density fiber board (MDF). DO NOT try and cut metal, glass, ceramics, or products containing asbestos or lead paint. Some of these materials contain hazardous dust and can cause severe respiratory problems.
39. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use a wood dust collection system whenever possible.
40. A push block and/or a push stick must be used if the workpieces is less than 5” (127mm) to prevent your hands from getting too close to the saw blade. Push block must be used to cut narrow workpieces and, when necessary, to push the workpiece against the fence, a push block can be easily made by the operator.





MACHINE NOISE

DECLARED NOISE EMISSION VALUES in accordance with ISO 7960.		
	Idling	Operating
Declared A-weighted Sound Power Level L _w , in dB re 1 pW.	73	75
Declared A-weighted Emission Sound Pressure Level, L _{pAd} , in dB re 20 µPa, at the operator's position.	60	62
Values determined according to specific test code ISO 3746.		

Noise Range

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include characteristics of the work room, the other sources of noise, etc. i.e. the number of machines and other adjacent processes.

Also the permissible exposure level can vary from country to country, this information; however, will enable the user of the machine to make a better evaluation of the hazard and risk.

If the environmental noise level exceeds the permissible value, the customer is requested to adopt addition noise control measures.

Noise Level

According to EN848-1/ISO3746 (The uncertainty K = 4 dB)

Sound pressure level: 83dB(A)

From the above measured results, this sliding table sawing machine present a little hearing or noise hazard to operator, the operator is required to wear ear protection whenever possible during operation and conform to the local safety regulations.

Noise Level

From the above measured results, this sawing machine present no sever hearing or noise hazard to operator, However, the operator is recommended to wear hearing protection whenever possible during operation and conform to the local safety regulations.



SPECIFICATIONS

Cast Iron Fixed Table Dimension	22.4" x 39.3" (570 x 1000mm)
Sliding Table Dimension	15" x 102.3" (380 x 2600mm)
Main Saw Blade Ø	12" (305mm)
Main Saw Blade Ø Maximum	14" (355mm) optional
Main Saw Bore	1" (25.4mm)
Max. Cutting Height With Bade At 90	4.1" (105mm)
Max. Cutting Height With Bade At 45	2.875" (73mm)
Supply Power	220V / 3ph / 60hz
Main Motor Power	7.5hp (5.5kw) 220V / 3ph / 60hz / 23A
Main Blade Speed	3000 / 4000 / 5000 RPM
Scoring Saw Blade Ø	4.75" (120mm)
Scoring Saw Blade Bore Ø	.875" (22mm)
Scoring Motor Power	1hp (0.75kw) 220V / 3ph / 60hz / 5A
Scoring Blade Speed	8000 rpm
Cutting Width	39.3" (1000mm)
Cutting Width Adjustment	Manual
Saw Table Extension	14.5" (370mm)
Blade Titing Adjustment	Manual (0° ~ 45°)
Main Saw Height Adjustment	Manual
Scoring Saw Height Adjustment	Manual
Scoring Saw +/- Direction Adjustment	Manual
Blade Titing Angle Show	Digital display
Main Blade Speed Show	LED exhibit
Overhead Saw Guard	Delux
Crosscut Fence Digital Display	DRO Model Yes
Rip Fence Digital Display	DRO Model Yes
Rapid Clamp	optional
Tool Frame	optional
Noise Level	78dB
Dust Collection System	Main channel 4", Simple guard Ø 60, Delux 3"



Cutting Depths

Saw Blade Diameter	10" (225mm)	12" (305mm)	14" (355mm)
Cutting Depths At 90°	0 ~ 2.16" (0 ~ 55mm)	0 ~ 3.15" (0 ~ 80mm)	0 ~ 4.13" (0 ~ 105mm)
Cutting Depths At 45°	0 ~ 1.5" (0 ~ 38mm)	0 ~ 2.2" (0 ~ 56mm)	0 ~ 2.87" (0 ~ 73mm)

Cutting Lengths

Sliding Table Cutting Lengths	With or Without Scoring Saw Blade
102.36" (2600mm)	98.53" (2500mm)

Machine Weight

Cutting Width	39.3" (1000mm)
Main Crate N/W	1675/1785lbs. (760/810kg)
Sliding Table Length	74.75" (1900mm)
N/W	227/337lbs. (103/153kg)

TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990, and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileighindustrial.com, Phone: 920.684.4990, or Fax: 920.684.3944.



Note: The photos illustrations using in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



Note: The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.

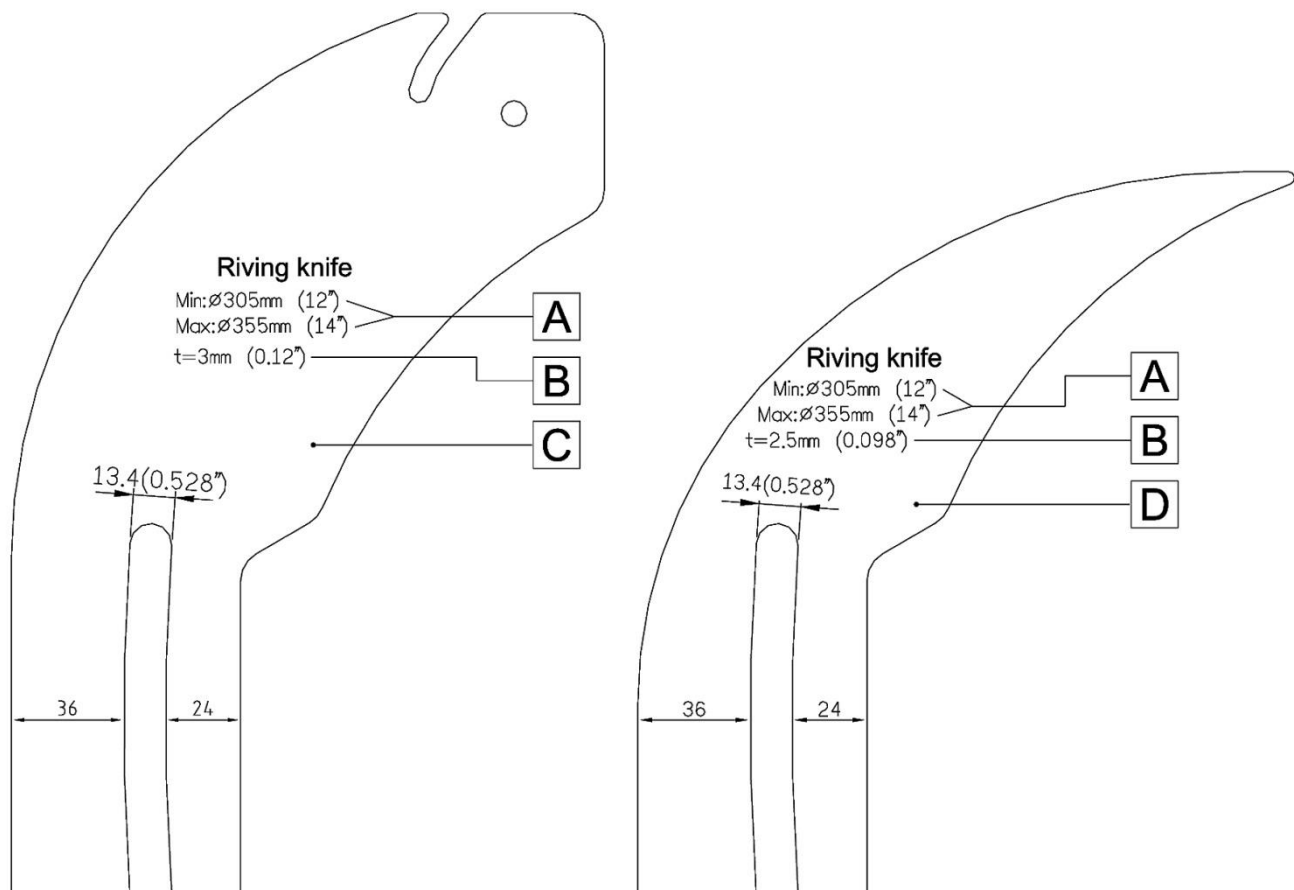


RIVING KNIFE SPECIFICATION



WARNING: Before setting the riving knife, verify that it matches the saw blade diameter and body thickness.

Always disconnect power at the mainpower switch prior to setting the riving knife to prevent unintended machine start up.



- A: Main Saw Diameter Range.
- B: Riving Knife Depth.
- C: Simple Riving Knife.
- D: Delux Riving Knife.

The machine is delivered as standard with the following riving knives.

305 ~ 355/2.5 specification:

Saw blade diameter 305~355mm.

Saw blade basic body thickness up to maximum:

2.5mm.

Diameter range and thickness are both engraved at the bottom end of the riving knife.

The thickness of the riving knife was selected so that they match the commercially available saw blade thickness in the respective diameter range. Use correct riving knife only and always.



TRANSPORTING AND LIFTING



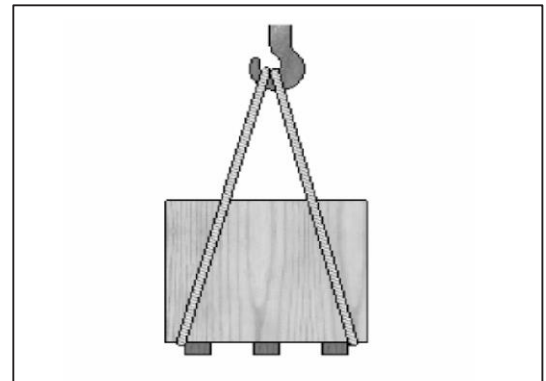
CAUTION: Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced. Choose a location that will keep the machine free from vibration and dust from other machinery. Keep in mind that having a large clearance area around the machine is important for safe and efficient working conditions.

Follow these guidelines when lifting:

- Always lift and carry the machine with straps on each end (fig. 1) for balance.
- Use a straps capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, and lower slowly until it touches the floor.

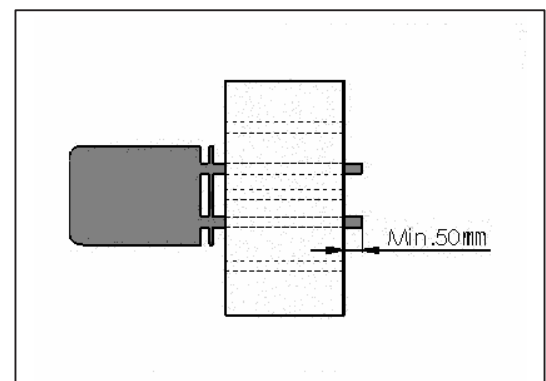
Use Crane To Move Wooden Crate

The crane's rope must be in good condition with no visible damage and be able to support the machine's full gross weight to prevent breakage.



Use Lift Truck To Move Woden Crate

Place the wooden crate in the middle of the forks and keep at least 2" (50.8mm) distance between the front of the forks and the wooden crate to avoid the case collapsing and secure safe transport.





Use Lift Truck To Transport Machine

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain at least 6 ft. (2m) safe clearance zone around the transport area.
- The machine is equipped with the slots that are specially designed for transport of lift truck and manual (electric) trolley.



Use Gantry Or Crane To Move Machine



Fig. 1

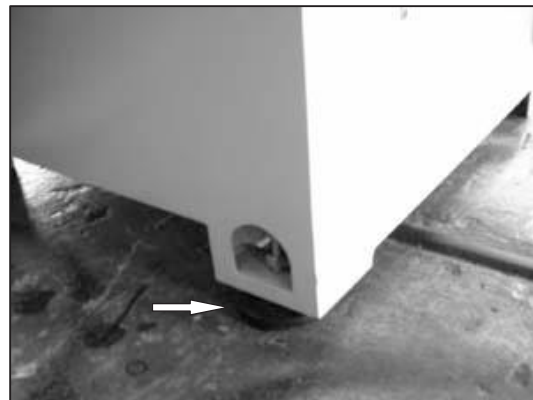


Fig. 2

- Before the machine is put on the floor, install level adjusting bases (as shown in Fig. 2 arrow marked) and adjust the level of the machine's working table to insure the sliding table's smooth movement and the machine's balanced operation.



INSTALLATION

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.

It is important to maintain free area around the machine, which is required for the working place. If any long material is machined, it is necessary to have a sufficient room in front of the machine as well behind it in the places of material input and output.

Before beginning assembly, take note of the following precautions and suggestions.

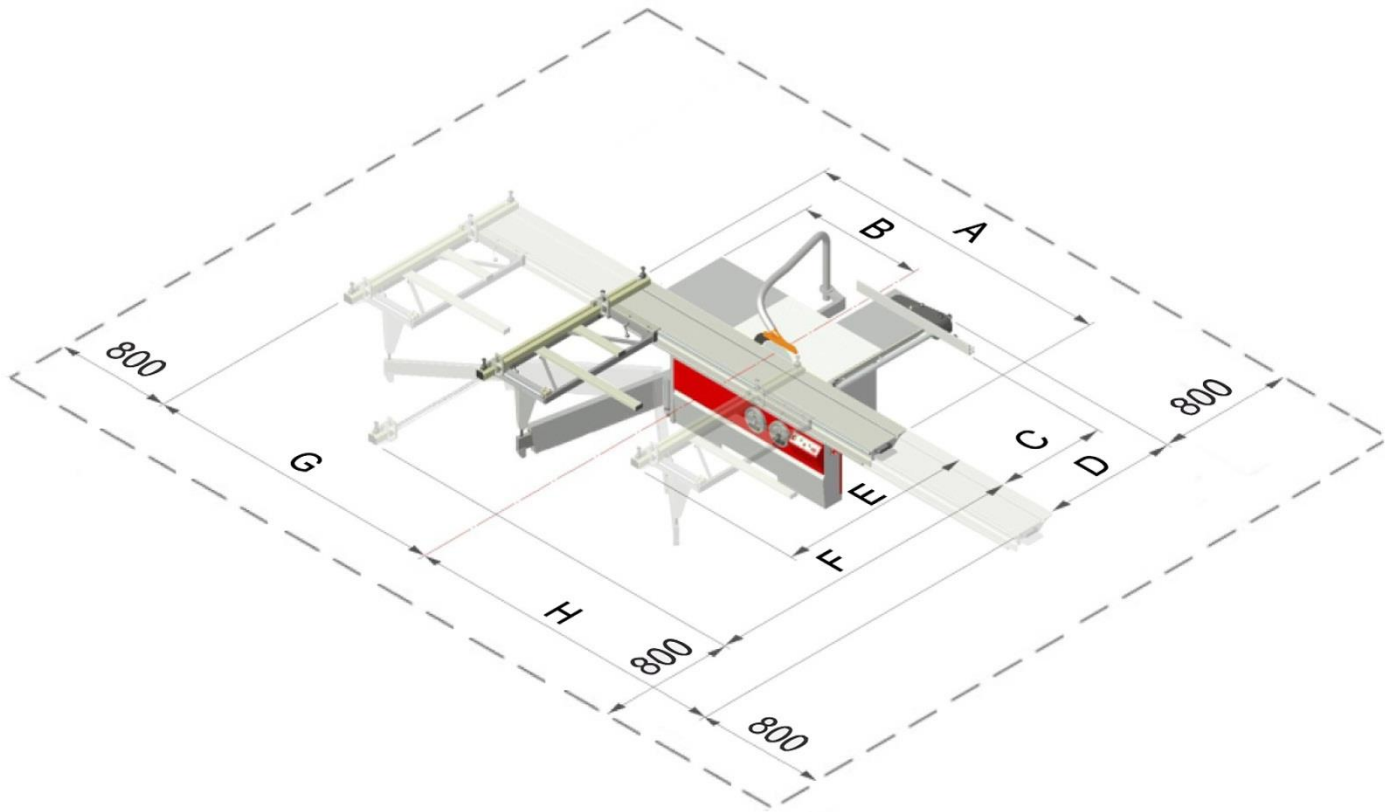
- The machine is bolted to the pallet. Before attempting any of the assembly procedures remove all of the loose parts and hardware from the inside of the machine and unbolt the machine from the pallet.
- FLOOR: This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting both the weight of the machine and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- WORKING CLEARANCES: Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- OUTLET PLACEMENT: Outlets should be located close enough to the machine so that the power cord or extension cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.



WARNING: Before operating; make sure it is positioned firmly on a solid work surface. If it tips over on you, it could cause severe injury or death.



Clearance Dimensions



A	126" (3200mm)
B	33.5" (850mm)
C	59" (1500mm)
D	68" (1725mm)
E	71.75" (1820mm)
F	127" (3230mm) maximum
G	138.75" (3525mm)
H	136.5" (3470mm)



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.



WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

Cleaning



WARNING: **DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.



CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



Important: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.





INTENDED USE

Table saw and the workpiece guide equipment supplied with it are intended to be used exclusively for the following purposes:

- Laminated and unlaminated board materials (e.g. chipboard, coreboard, MDF board, ...)
- Solid wood
- Gypsum plasterboard, Cardboard, Veneer with a suitable clamping device.
- Dimensionally stable plastics (thermoset plastics, thermoplastics). Sawing these materials does not normally involve any risks in respect of dust, chips, and thermal degradation products.

OPERATIONAL INDICATION

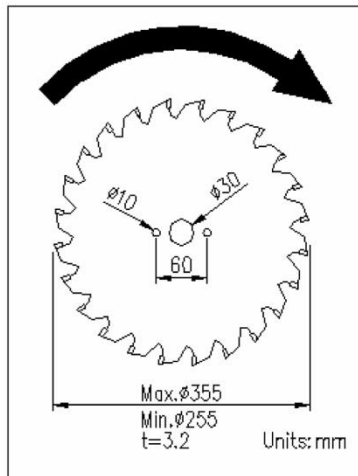


Fig.1

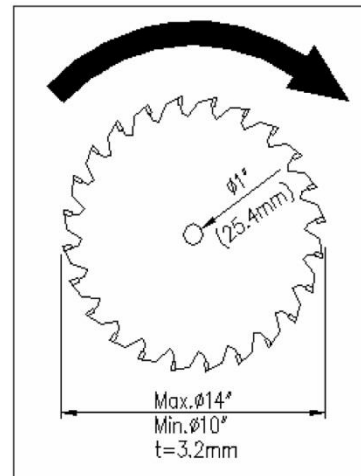


Fig.2

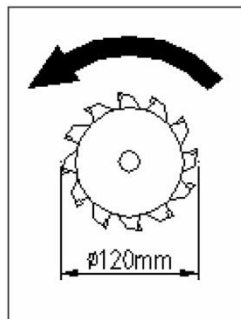


Fig.3

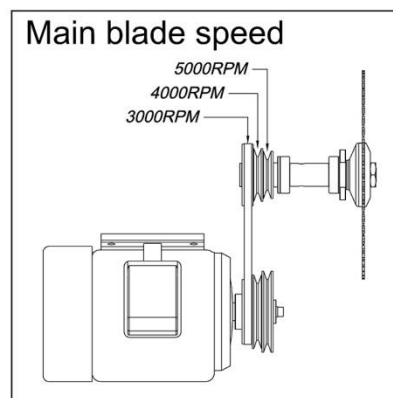
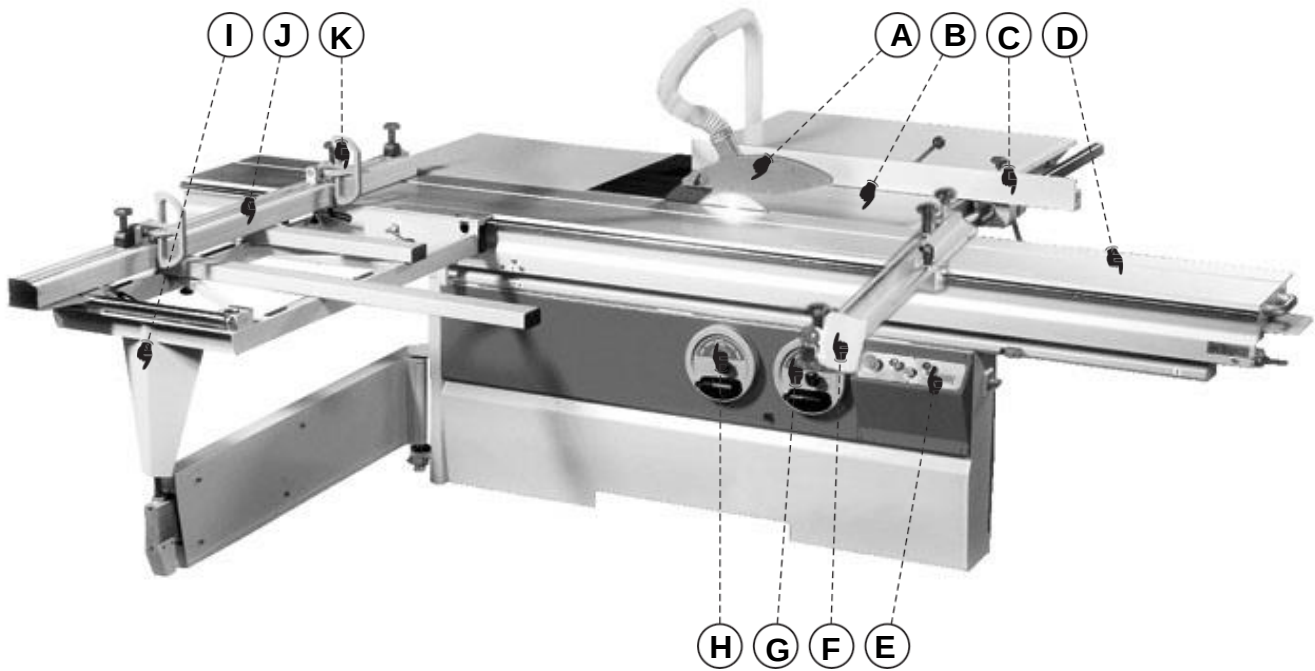


Fig.4

- Fig. 1: the main saw's size and running direction.
 Fig. 2: the main saw's size and running direction.
 Fig. 3: the scoring saw's size and running direction.
 Fig. 4: Belt speed diagram.



GETTING TO KNOW YOUR MACHINE



A:	Dust Guard	Not only reduce dust produced by chips while cutting, but also warning the operator where the saw-blade position.
B:	Main Table	Main working table.
C:	Rip Fence	Reference positioning while ripping.
D:	Sliding Table	Table for main feeding while cutting.
E:	Controlling Panel	Control the machine's running, indication, stop etc.
F:	Miter Fence	Reference positioning while 0~45°cutting.
G:	Main Saw Tilting Adjusting Hand Wheel	Hand wheel for adjusting main saw tilting 0~45°.
H:	Main Saw Lifting Adjusting Hand Wheel	Hand wheel for adjusting main saw up/down.
I:	Cross Cut Table	Used to put the workpiece while cross cutting.
J:	Cross Cut Fence	To position the size of the movable positioning board.
K:	Movable Positioning Stops	To position while cross cutting.



ASSEMBLY



WARNING: For your own safety, DO NOT connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.



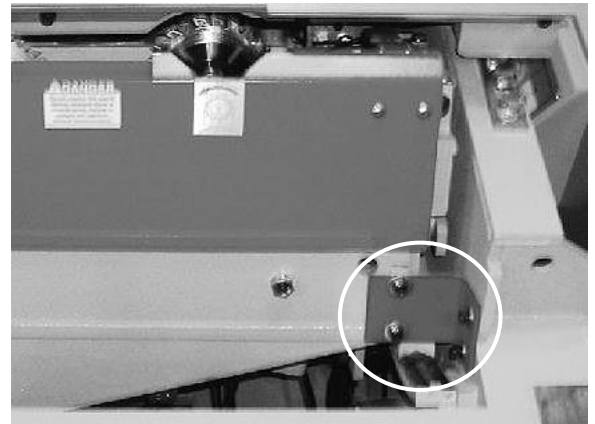
Note Due to the size and weight of many of the saws components, the assembly of the complete saw will require the use of from 4 – 6 assistants.



Note The saw was fully assembled, adjusted, and tested at the factory. Many of the fasteners have been installed into there mounting holes for shipping.

INITIAL INSTALLATION ASSEMBLY

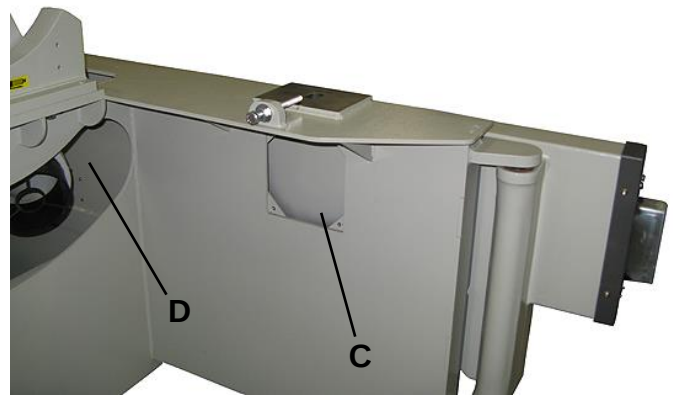
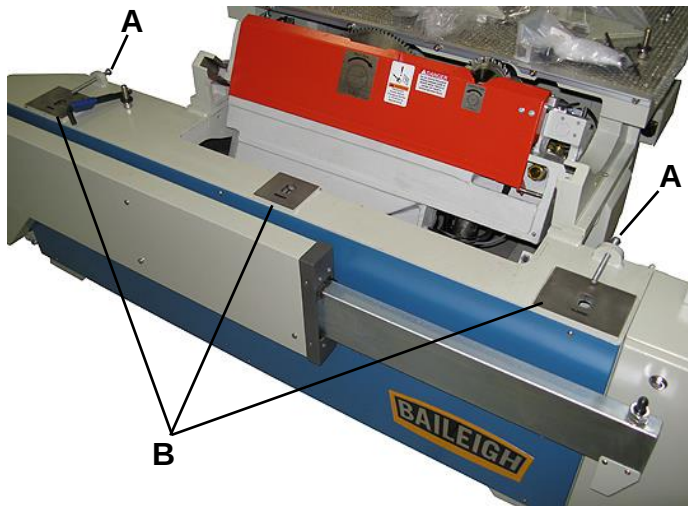
1. Verify that the saw is positioned in the desired location.
2. Verify that the leveling feet are properly positioned under the leveling bolts and that the table is level.
3. Remove the 2 retaining brackets securing the saw blade assembly to the cabinet and the electrical enclosure to the cabinet.





SLIDING TABLE INSTALLATION

1. The sliding table was installed and adjusted for parallelism at the factory. DO NOT change or damage the the adjusting bolts (A) during installation of the sliding table.
2. Clean the rust preventative off of the contact surfaces (B) for the main cabinet and the sliding table (Total 3 contact surfaces).



3. Remove the access covers (C) from behind the 2 outer mounting points. The center mount is accessed through the clearance slot (D) for tilting the blade.



Note Use care when placing the sliding table on the contact surfaces so as not to damage the surfaces. The sliding table may require from 4~ 6 workers to lift safely.

4. Using the assistants, lift the sliding table onto the machine taking care not to damage the contact spots. Looking closely at the edge of the sliding table base, you should be able to see the spots where the adjusting bolts have contacted the sliding table. Use these marks to help align the bolt holes.
5. Install the 3 mounting bolts hand tight.
6. Verify that the sliding table base is tight against the adjusting bolts and slightly tighten the 3 mounting bolts.

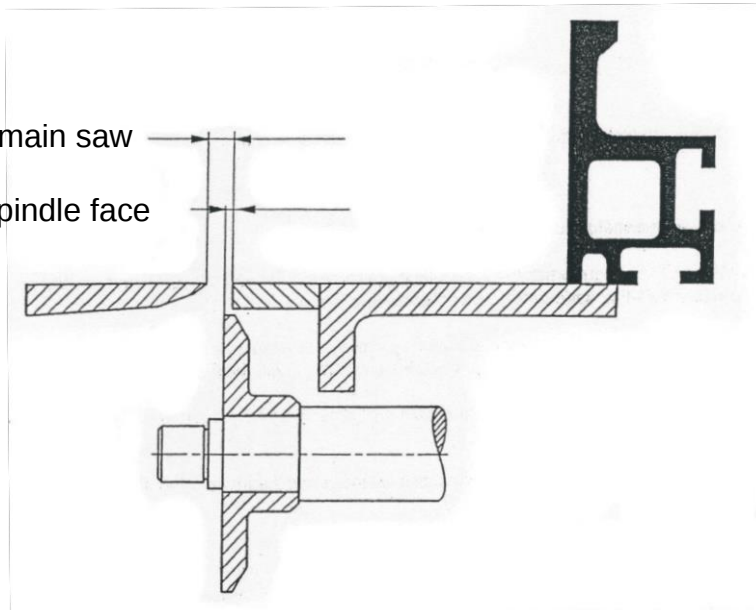


7. Check the parallelism of the sliding table to the main table.

If the sliding table is parallel to the main table and has a maximum gap of 12mm between the tables and 3mm to the spindle face, final tighten the 3 mounting bolts verifying that the table does not move.

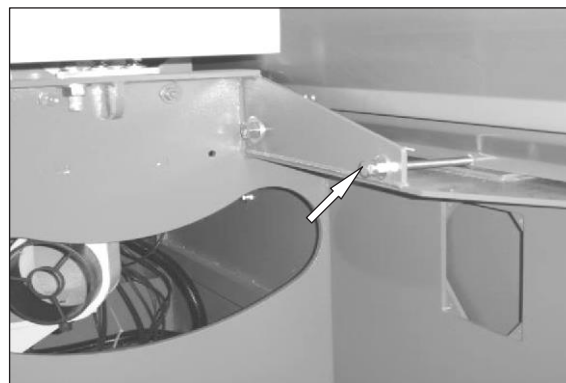
Maximum 12mm to main saw

Maximum 3mm to spindle face



If the sliding table is either not parallel, or within the clearance limits:

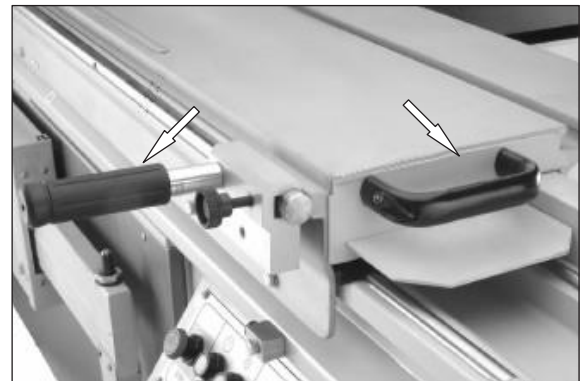
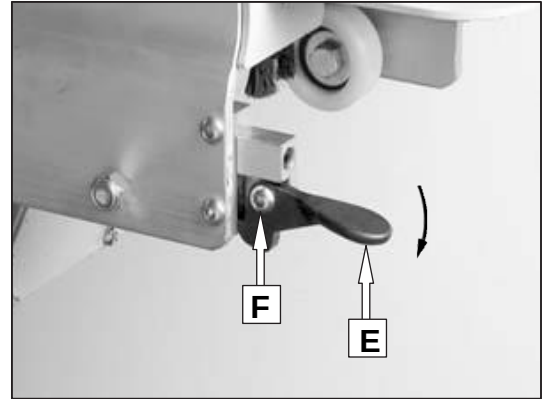
8. Loosen the 3 screws holding the sliding table to the machine just enough to allow movement for adjustment.
9. Use the 2 adjusting screws at the ends of the main cabinet to make the sliding table parallel to the saw blade and keep the gap within its limits.
10. Hold in position and fully tighten the 3 mounting bolts.



Note The sliding table must be 0.3mm higher than the working table (The height has been set at the factory. Do not adjust this height without verified measurement and approval from the factory. This is considered an unauthorized change and will void the warranty.

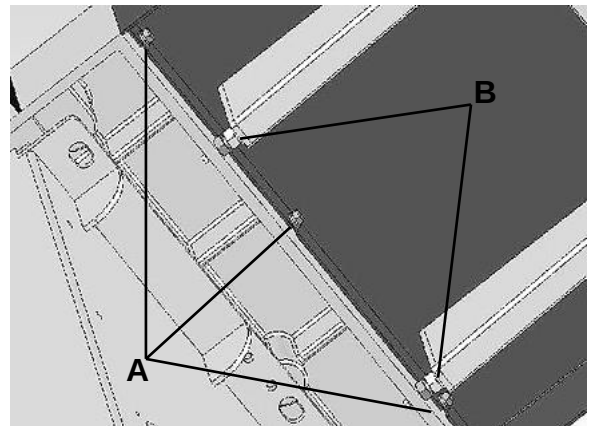


11. Install the table lock (E) onto the right end of the sliding table using the M6 x 20 screw, washer, and M6 nut (F).
12. The lock can fasten the sliding table in the middle and the end positions.
13. Before the sliding table is moved, make sure the safety lock is unlocked.
14. Lifting the handle will lock the table.
15. Pressing down on the handle will unlock the table.
16. The front handle is moveable on the front rail of the slide table. Install the front handle over the rail and position near the end. Tighten the hand screw to hold in position. This handle may be position along the rail as desired or removed as needed.
17. Install the end caps on the ends of the slide table. Remove the bolts from the slide table and insert the bolts through the end cap brackets and tighten. The end cap with the handle go on the right end of the sliding table.



LENGTH EXTENSION TABLE INSTALLATION

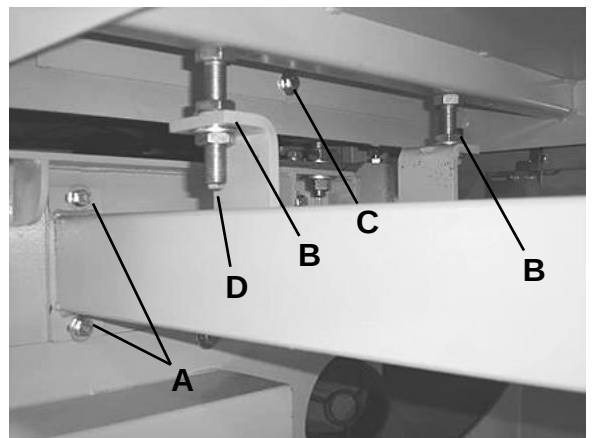
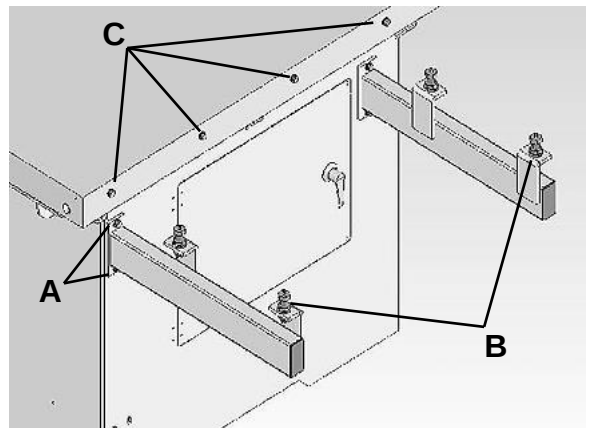
1. Loosen the 3 extension table mounting bolts (A) on the main table just enough to slide the extension table onto them.
2. Slide the extension table onto the mounting bolts so that the extension is tight to the main table and the washers and bolt heads (A) are to the inside of the extension table.
3. Place a level across the extension table and the main table.
4. Adjust the leveling bolts (B) to level the extension table to the main table.
5. When the extension table is level to the main table, tighten the mounting bolts (A) keeping the extension table level and flush to the main table.





WIDTH CUTTING EXTENSION TABLE INSTALLATION

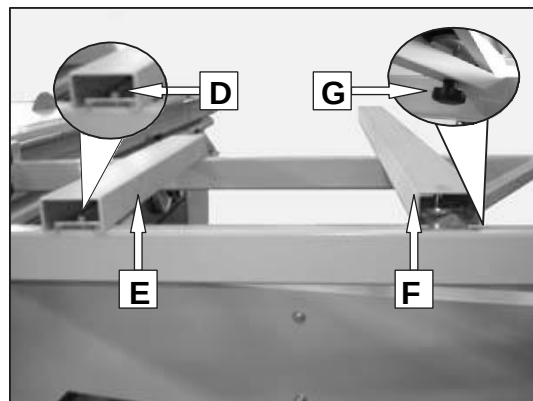
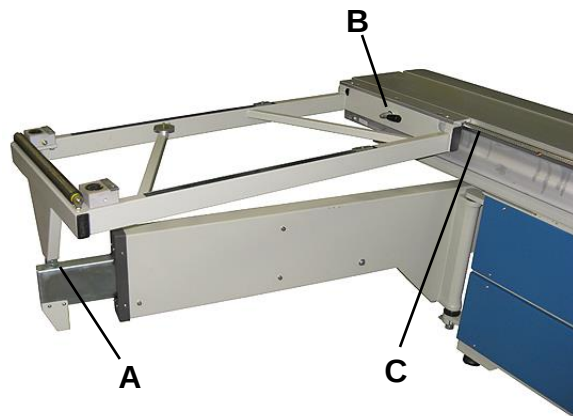
1. Locate the two extension table supports.
2. Remove the 4 cabinet mounting bolts (A) from the back of the main cabinet and install the supports with the leveling bolt (B) up and the adjustment opening toward the outside.
3. Tighten the cabinet mounting bolts (A) enough to hold the supports stable but allow a little movement for alignment of the leveling bolt locating bolts (D) to the extension table.
4. Loosen the 4 extension table mounting bolts (C) on the back of the main table just enough to slide the extension table onto them.
5. Slide the extension table onto the mounting bolts so that the extension is tight to the main table and the washers and bolt heads (C) are to the inside of the extension table.
6. Install the leveling bolt locating bolts (D) into the extension table 3 – 4 turns.
7. Align the extension table supports and final tighten the mounting bolts (A).
8. Place a level across the extension table and the main table.
9. Adjust the leveling bolts (B) on the supports to level the extension table to the main table.
10. When the extension table is level to the main table, secure the table starting with the 4 bolts (C) securing the extension to the main table keeping the table level and flush to the main table.
11. Fine tune the extension table level as needed and then tighten the upper and lower leveling bolt (B) jam nuts.
12. Tighten the leveling bolt locating bolts (D).





CROSSCUT TABLE ASSEMBLY

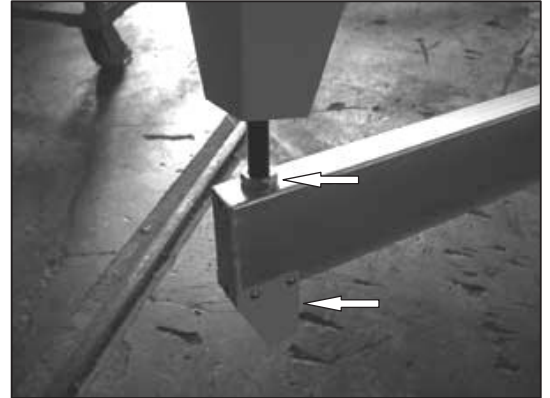
1. Lubricate the pivot pin (A) with light grease and place the stand end of the crosscut table onto the pivot pin.
2. Lift and hold the lock handle (B) so that it is pointing straight up.
3. Place the slide end of the crosscut table on the on the slide rod (C) of the sliding table. Verify that the locking bar of the crosscut table is positioned under the slide rod.
4. Tighten the handle (B) to fasten the crosscut table.
5. Place the two C-shaped aluminum channels across the crosscut table.
6. Loosen the bolts on the 2 bar clamps (D) and center the shorter aluminum channel (E) on the crosscut table with the bar clamp positioned to clamp the channel in place.
7. Tighten the bar clamp bolts (D) to secure the channel.
8. The longer channel (F) is a movable channel. Loosen the hand bolt enough to allow the channel to slide over the plate clamp (G).
9. Slide the channel over the plate clamp at least 1" and hand tighten the bolt to secure the channel in place. This channel may be repositioned as needed to support the work material as needed.
10. Using a soft mallet, install the end caps into the channels.
11. Place a straight edge across the crosscut table channels and onto the sliding table to check if the surface is flat.
12. Adjust the pivot pin (A) nuts as needed to level the crosscut table to the sliding table.



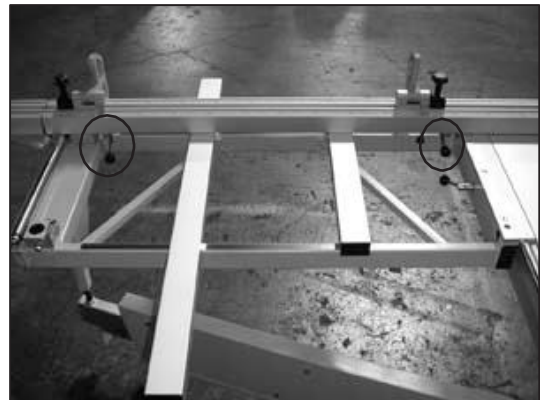
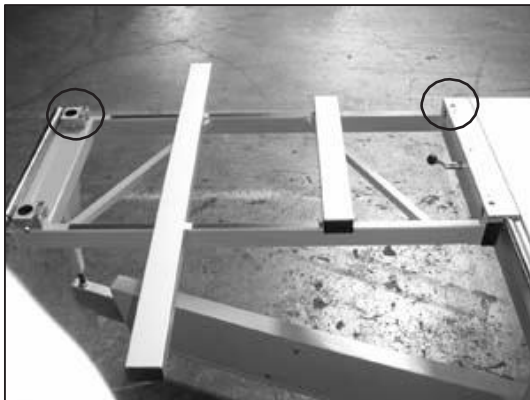


Crosscut Table Adjustment

If the crosscut table is not parallel to the working table, adjust the nut of the crosscut table and the expansion pipe and also adjust the nut in the cover plate.



CROSSCUT FENCE ASSEMBLY



1. Place the crosscut fence into the positioning point of the crosscut table.
2. Press down the handle to secure the crosscut fence.



Note If the crosscut fence is moved, first adjust the perpendicularity of fence and saw blade before use.



Crosscut Fence Adjustment

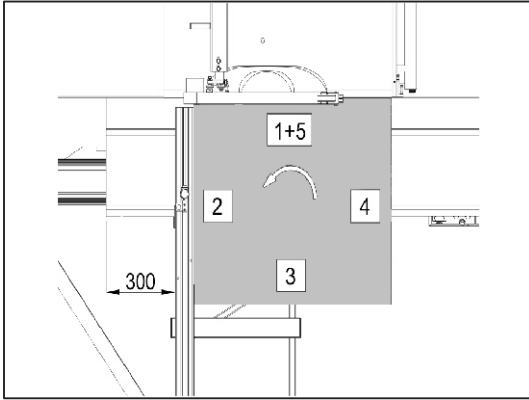


Fig. 1



Fig. 2



Fig. 3

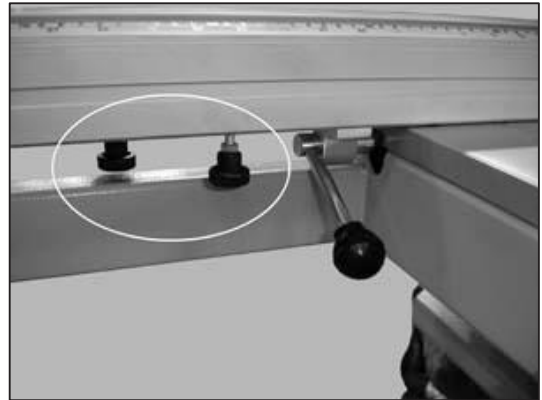
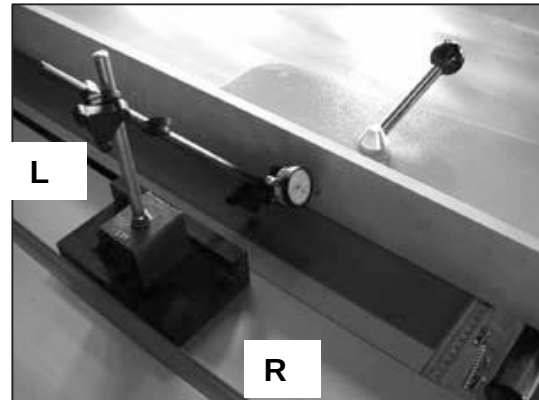
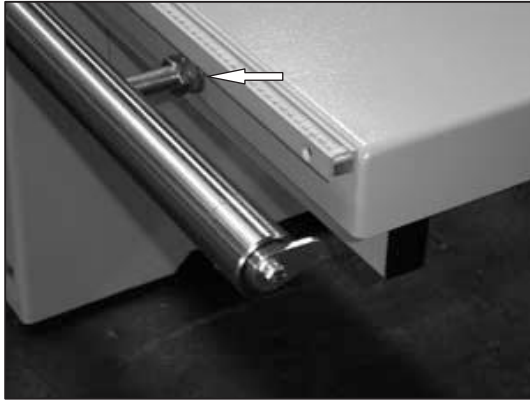


Fig. 4

1. Maintain 11-7/8" (300mm) distance between the fence and the sliding table. Use a 14" x 0.125" x 100T (355mm/3.2t/100T) blade at 5000 rpm speed and wood board 40" x 40" x 3/4" (1016 x 1016 x 19mm) for trial cut.
2. Make 5 cuts on the board in the sequentially shown in Fig. 1, cutting from NO.1 ~ 5.
3. Measure diagonally to check the board for square's error of the wood board to precede adjustment Fig. 2 parts, lock the nut Fig. 3 after adjustment.
4. The two knobs in the Fig. 4 are to fasten the scale on the crosscut fence.



RIP FENCE ASSEMBLY



1. Install the screw on the round rod into the right side of the working table, put into the rip fence base, adjust three nuts on the round rod to make rip fence parallel to the saw blade.
2. Use the gauge to measure the parallelism of the rip fence and the main saw blade.
Measuring: The rip fence is stationary and the sliding table is pushed to the left. Measured tolerance is 0 ~ 0.003" (0 ~ 0.1mm) from the left to the right as the direction shown in the above drawing. Parallelism of the sliding table and the main saw blade must be adjusted within tolerance before proceeding.



3. Adjust the eccentric wheel on the front end of the fence base to make the fence base parallel to the working table.
4. Adjust two eccentric wheels at the side of the fence base to make the aluminum fence parallel to the working table.
5. Tighten the rip scale. Adjust the limit screw on the stop block. The safe gap between the fence and the saw blade is at 0.5mm.
6. The screw at the left side is the limit for cutting 90°.
7. The screw at the right side is the limit for cutting angle.





Rip Fence Adjustment

After the rip fence is moved, if the moving size and the target size have slight difference, the following is the operating way of the micro-knob:

1. Pull the handle (A) upwards and move the rip fence to near the target size.

2. Loosen knob (B).

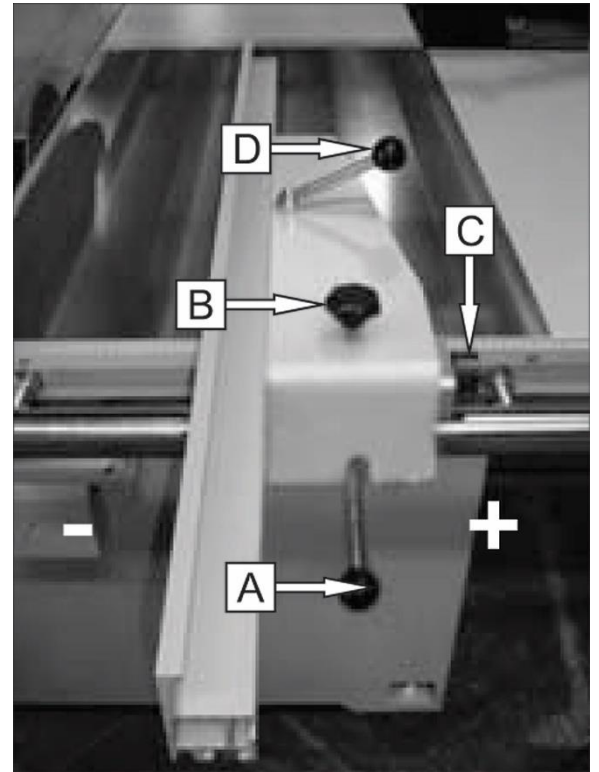
3. Turn the micro-knob (C) to the target size.

Turn the micro-knob clockwise: - direction movement.

Turn the micro-knob counter-clockwise: + direction movement.

4. To fasten the rip fence, do above steps in reverse order.

5. To change the aluminum fence, loosen the handle (D).



- Above left drawing is the position of aluminum fence at 90 degree cutting.
- Above right drawing is the position of aluminum fence at cutting angle.



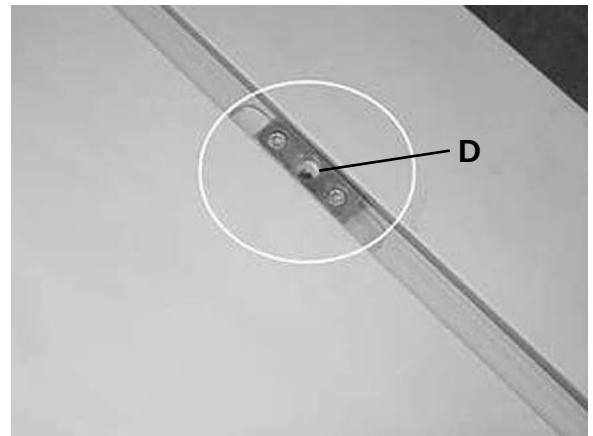
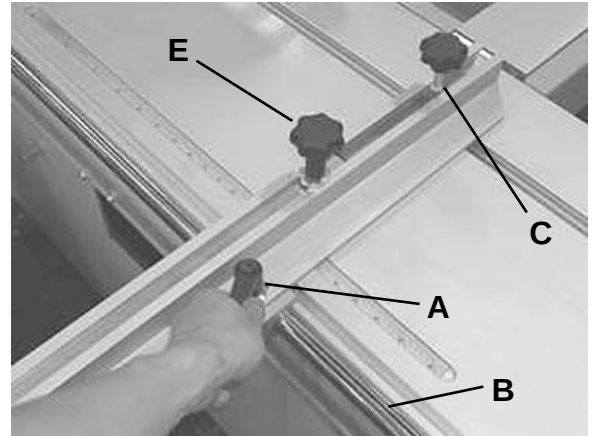
MITER FENCE ASSEMBLE

1. Loosen the miter fence slide block clamp handle (A) a few turns.
2. From the right end of the slide table, place the miter fence slide block over the round slide rod (B) on the front of the sliding table and slide it onto the table until it is over the angle scale.
3. Install the pivot bolt (C) into the pivot block (D) in the sliding table slot and tighten until the miter fence is snug but will rotate on the pivot bolt.
4. Swing the miter fence to the desired angle and tighten the clamp handle (A).

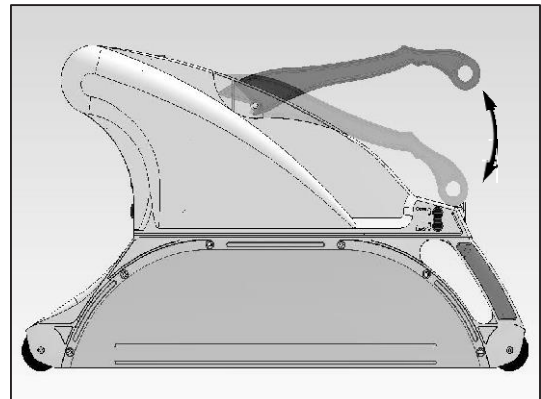
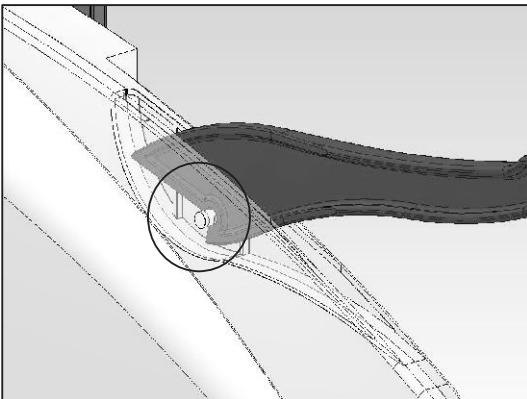


Note Swing the miter fence slowly and smoothly as the slide block may bind slightly when the fence is moved, especially at the extreme angles.

5. Loosen knob (E) and push outwards to extend the miter fence stops.



PUSH STICK INSTALLATION



1. Install the pushing stick on the holder at degree 45.
2. Lightly press down on the push stick until the push stick is latched in place.



DUST GUARD AND SUPPORT ASSEMBLY

Before the machine is used to cut workpiece, make sure the dust collector work normally.

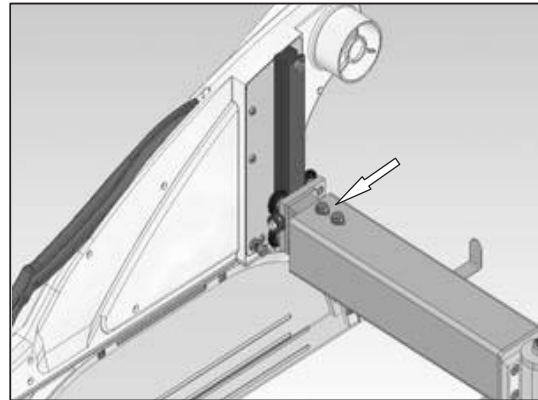
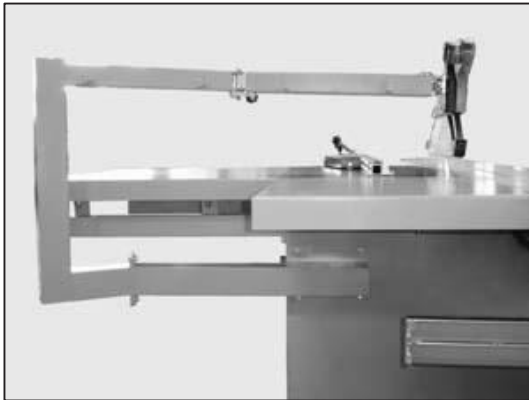


Note: The required air speed at the end of flexible tube is 30 ~ 34m/sec. The required air volume of the machine is 1220 ~ 1390 m³/hr. (43,000~49,000 cu. ft./hr.).

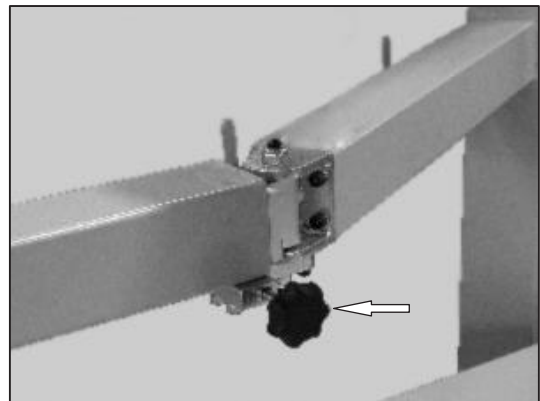
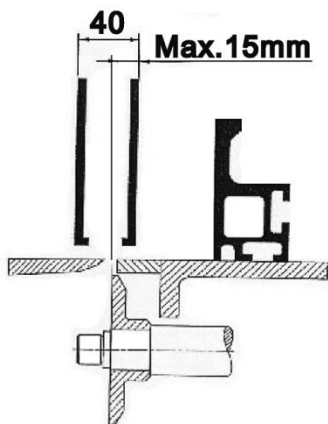


Note: Use antistatic and electrically conductive hoses only.

Delux Saw Guard



1. Install the dust collection support rack onto the left side of the machine as shown in above drawing.
2. Before installing the safety guard, lower the saw under the table.
3. Adjust the guard parallel with the saw and tighten the screw as shown in above drawing.



4. Keep safe distance between the safety guard and the saw as shown in above drawing.
5. Tighten the knob to secure the guard. Loosen the knob, the guard can be moved as shown in above drawing.



ADJUST SAFETY GUARD

1. Move the saw guard up or down slightly by hand.
2. Adjust how tight the up/down movement of the saw guard is by adjusting the bolt shown.
3. This adjustment will loosen over time and must be adjusted at least tight enough to prevent the saw guard from moving when unintended.



DUST-COLLECTING CONNECTIONS

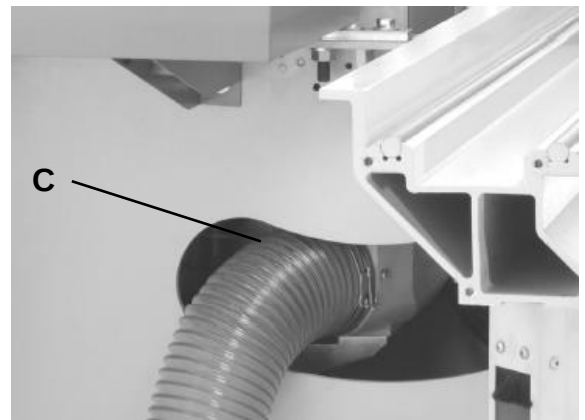
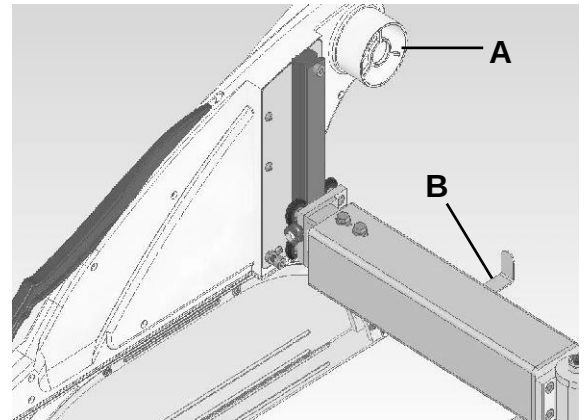
Before the machine is used to cut workpiece, make sure the dust collector work as designed.



Note: The required air speed at the end of flexible tube is 30 ~ 34m/sec. The required air volume of the machine is 1220 ~ 1390 m³/hr. (43,000~49,000 cu. ft./hr.). Use antistatic and electrically conductive hoses only.

Two dust-collecting outlets are available on the machine to assist with dust removal. The saw guard has a 3" diameter connection port and the saw blade has a 5" diameter connection port on the left side of the machine. They can be connected to the dust collector by one flexible hose in proper diameter.

1. Install the dust collection hose into the dust collection hole (A) at the back of the guard. Diameter of hose at the back of guard is 3".
2. Route and secure the hose onto the support brackets (B).
3. Install the dust collection hose into the dust collection hole (C) on the left side of the saw blade housing. Diameter of hose is 5".





CHANGE SAFETY GUARD

1. Disconnect and lockout power to the saw!
2. Lower the saw blade fully under the saw table.
3. Push up on the saw guard lock button to loosen the saw blade shield and move backward to remove.

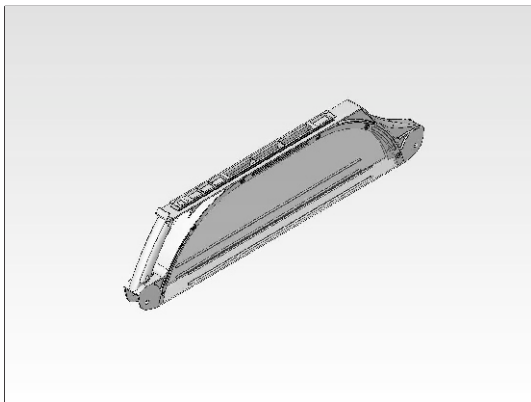
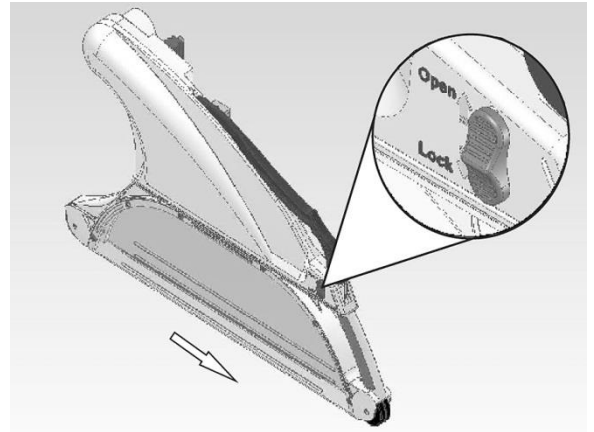


Fig. 1

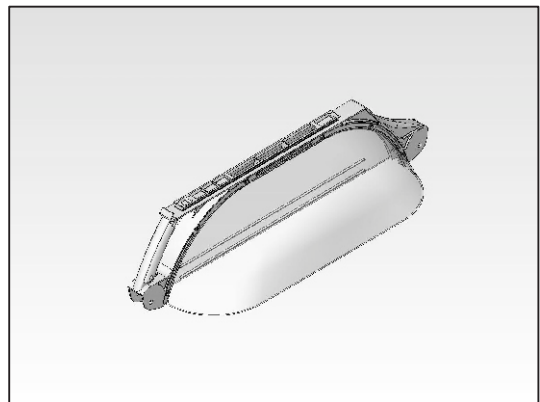


Fig.2



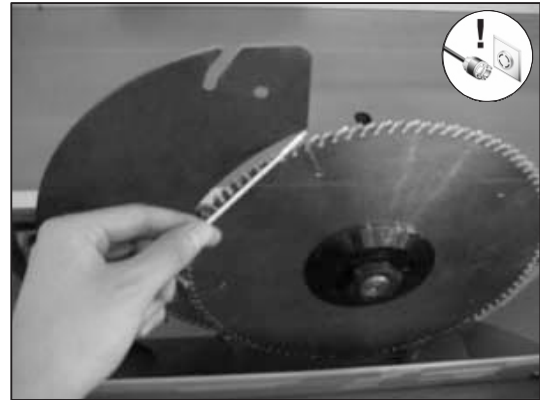
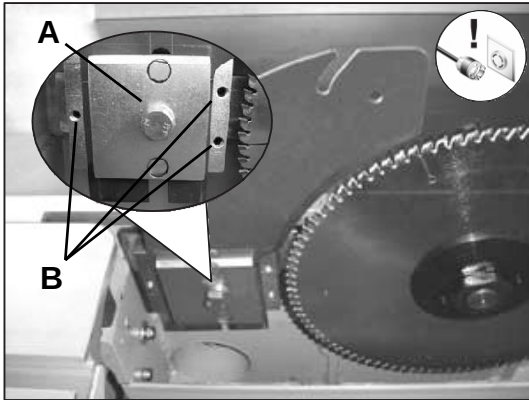
Note: While cutting workpiece:

At 90° cutting, 90° special safety guard must be used as Fig. 1.

At angular cutting, special angular safety guard must be used as Fig. 2.

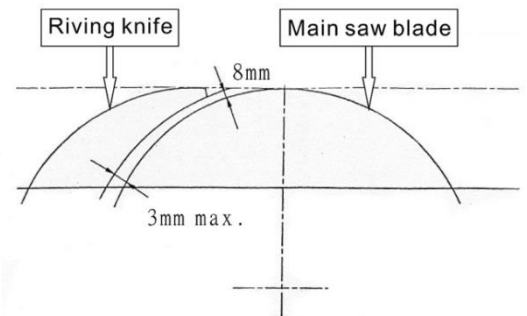
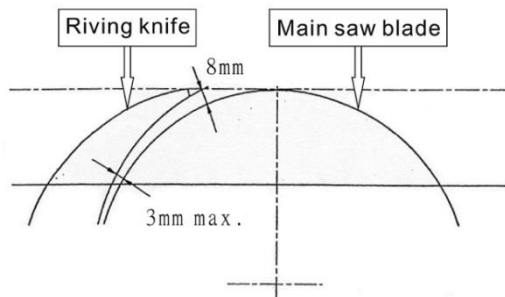


RIVING KNIFE ADJUSTMENT

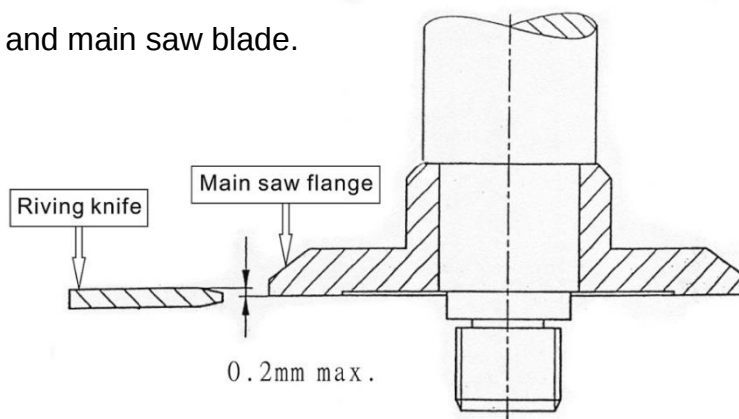


1. Disconnect and lockout power to the saw!
2. Open the saw blade guard.
3. Loosen the retaining screw (A) on the riving knife base just enough to allow the riving knife to move.
4. Adjust the 3 set screws (B) at the sides of the retaining screws as the projected place shown in the above drawing.
5. Measure the relative size of the riving knife and saw blade.

After adjustment of the riving knife is completed, please make sure to tighten the fixing screw on the riving knife base.



Relative size of the riving knife and main saw blade.





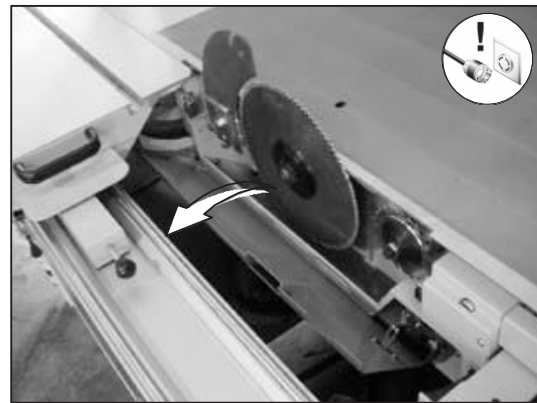
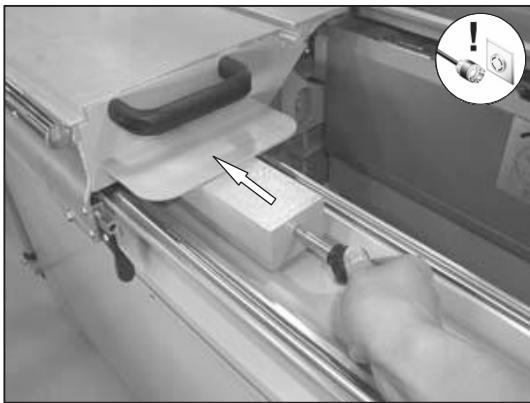
CHANGE MAIN SAW BLADE

⚠ WARNING: Blades are dangerously sharp. Use extreme caution when working with or around the blade. Wear proper safety protection such as heavy gloves.

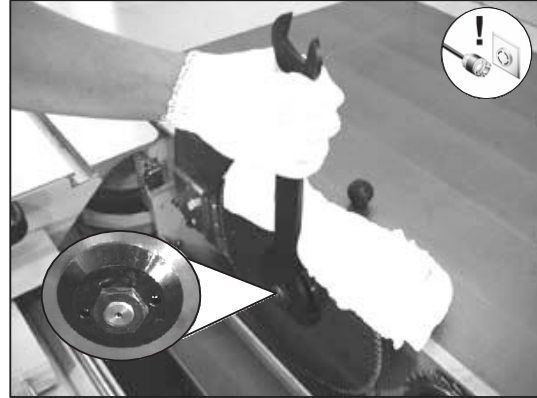
⚠ WARNING: Turn the power switch "OFF" and unplug the power cord from its power source when changing the saw blade.

When replacing blades, check the thickness stamped onto the riving knife. You must select a blade with a kerf width larger than the thickness of the riving knife. Thinner blades may cause the workpiece to bind during cutting.

1. Disconnect and lockout power to the saw!



2. Push the sliding table towards the left.
3. When the pusher rod is seen, push the ball on the pusher rod inwards to push the sliding table fully to the left.
4. Open the saw blade guard.



5. Raise the main saw blade to the highest position.
6. Turn the saw blade until the fixing pin is inserted into the spindle fixing hole.
7. Loosen the nut (clockwise), clean the flange and new saw blade and then install them onto the spindle.



Important: The main saw blade flange nut must be torqued to 21.7 lb/ft (300kg/cm).

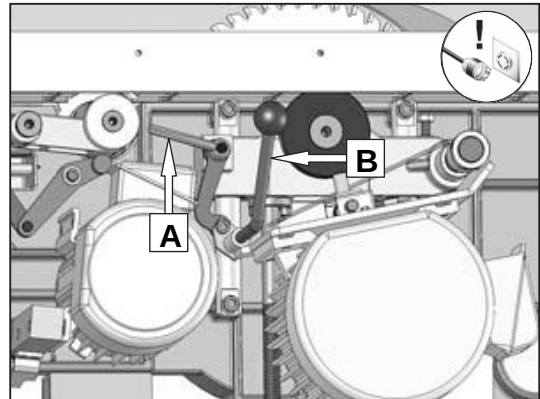


CAUTION: After changing a saw blade, always check that the Riving knife and Blade Guard is correctly set!

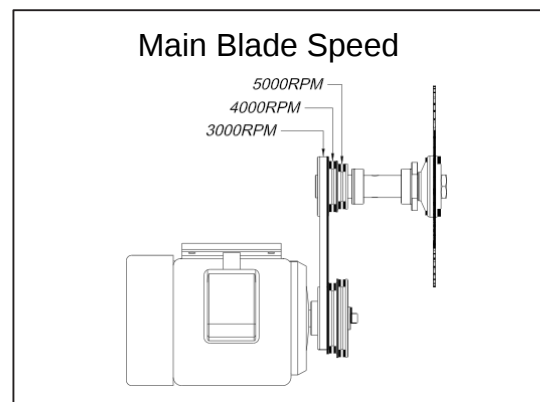
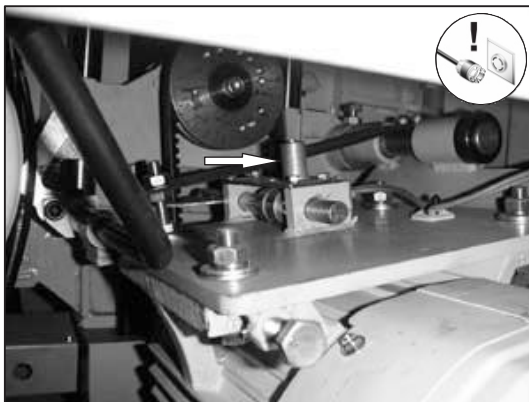


CHANGE SPINDLE ROTATING SPEED

1. Disconnect and lockout power to the saw!



2. Lower the main saw blade to the bottom position.
3. Open the service door at the back of the machine, loosen the adjusting handle (A), press down on handle (B) to raise the motor.



4. Lift the rotating speed knob upwards.
5. Change the rotating speed knob and belt as per the motor's rotating speed list. Then push the handle upwards to make belt produce tension.
6. Tighten adjust handle. The change of rotating speed is completed.
7. Above drawing is motor's rotating speed list.

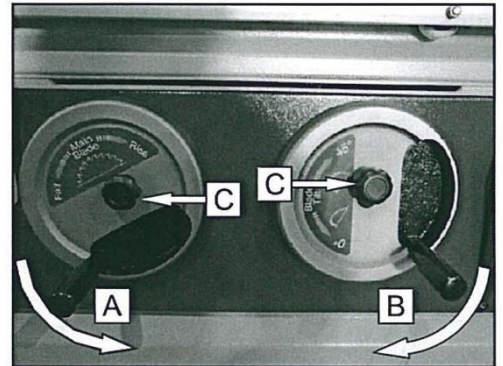
Main blade speed is 5000rpm, 4000rpm, or 3000rpm.



MAIN SAW HEIGHT AND TILTING ADJUSTMENT

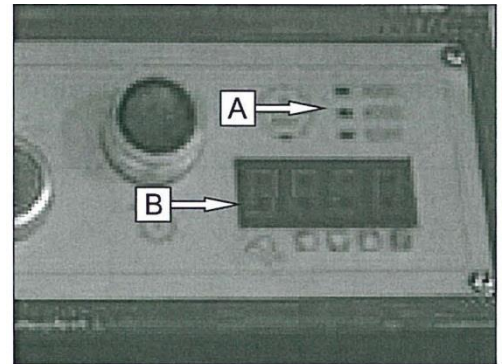
Hand wheel operation

- A. Hand wheel for main saw blade height adjustment. The arrow direction (Counterclockwise) is down. Clockwise is up.
- B. Hand wheel for main saw blade tilting adjustment. The arrow direction (Clockwise) increases the tilt angle. Counterclockwise decreases the tilting angle.
- C. Hand wheel lock knobs. After adjusting the hand wheel, lock up the knob to secure the blade in position for accuracy and safety.



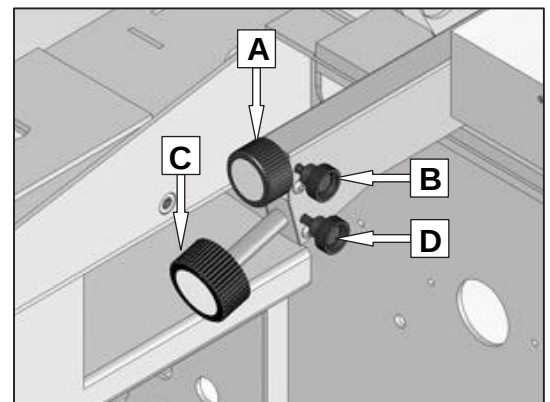
Digital display

- A. Speed display for main shaft.
- B. Tilting angle display for main saw blade.



SCORING SAW OPERATION

- A. Forward/backward adjusting knob.
- B. Forward/backward fixing knob.
- C. Lifting displacement knob.
- D. Lifting fixing knob.





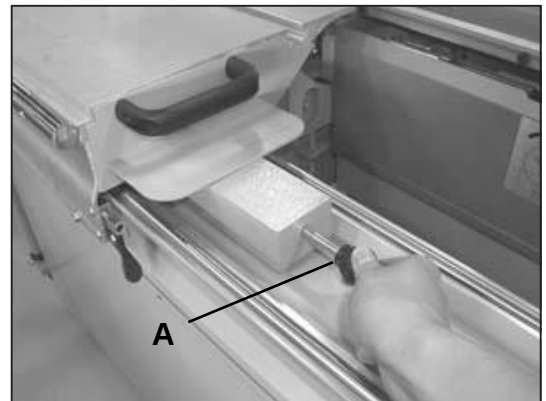
CHANGE SCORING SAW BLADE



WARNING: Blades are dangerously sharp. Use extreme caution when working with or around the blade. Wear proper safety protection such as heavy gloves.

Turn the power switch “OFF” and unplug the power cord from its power source when changing the saw blade.

1. Disconnect and lockout power to the saw!
2. Push the sliding table to the left until the travel release rod (A) is exposed.
3. Push the ball on the rod inwards to release the sliding table to allow it to over travel the bed and expose the blade housing.
4. Pull forward on the saw blade guard to open it.
5. Use the wrench provided to hold the arbor and remove the flange nut.
6. Make sure the new saw and flange are clean.
7. Install the new saw blade and torque the nut to 20 lb/ft (250kg/cm) to tighten the arbor nut.
8. Close the saw cover.
9. Move the slide table back to the right to engage the travel limit rod.

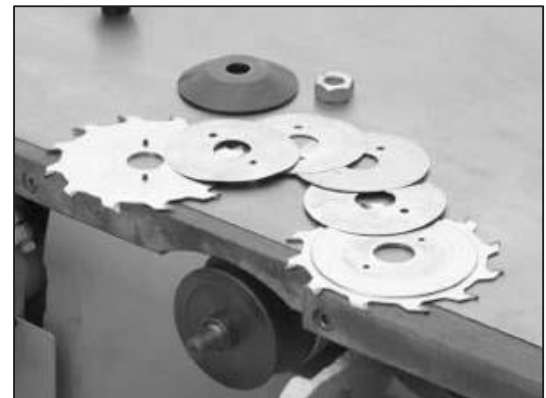


Important: The scoring saw blade flange nut must be torqued to 20 lb/ft (250kg/cm).

The shims are used to adjust the cutting width of the scoring saw to allow it to be wider than the cutting width of the main saw blade to make the cutting workpiece look nicer.

- Thickness of the scoring saw is 2.8mm. Adding shims in combination will increase the thickness of the scoring saw blade up to 4.3mm.
- Shim size & quantity:

0.1mm	1pcs.
0.2mm	1pcs.
0.3mm	4pcs.





ELECTRICAL



WARNING: Baileigh Industrial is not responsible for any damage caused by wiring up to an alternative 3-phase power source other than direct 3-phase. If you are using an alternate power source, consult a certified electrician or contact Baileigh Industrial prior to energizing the machine.



CAUTION: HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!
Check if the available power supply is the same as listed on the machine nameplate.



WARNING: Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

Power Specifications

Your machine is wired for 220 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machine. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.



WARNING: In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

Electrical Enclosure

1. Disconnect and lockout power to the saw!
2. Use the specific triangle socket key tools enclosed to unlock the electrical enclosure door.

Notes for wiring:

1. Power input: AC5V and AC12V / 50~60HZ.
2. Signal input: Standard proximity sensor or encoder A, B phase signal (DC12V).
3. Unit of measurement: Degrees.
4. Don't connect the shielded cable of the induction unit to circuit 0V or GND.
5. Sensor shielded cables please direct connection to the controller.
6. For reducing controller interference. Use separate signal wire and power wire.
7. The programmable controller is intended of use in Zone B typical industrial environment.



Important:

- *The fuse in the signal circuit cannot exceed 3A. Customer supplied.*
- *Electrical technician and operator must obey above-mentioned items. Changing internal wiring or circuit protection may cause controller burnt out other mechanical damage, this will void the warranty.*



Power Supply Connection

1. Verify that the voltage of the machine conforms to your company's power.
2. Use the specific tool to open the power controlling box to connect power.
3. Connect three power wires to terminal L1(R), L2(S), L3(T) as shown in the Fig. 1 and Fig. 3. Connect the earth wire (green-yellow) to PE terminal.
4. Start motor to check if the rotating direction of the main saw blade and the scoring saw is as shown in "Operational Indications" on page 19.
5. If the saw blade rotates in reverse direction, stop rotating and shut power off, exchange terminal L1 position for L2 position and check again.

Power Distribution



Fig. 1



Fig. 2

Power Distribution (CE Type)



Fig. 3

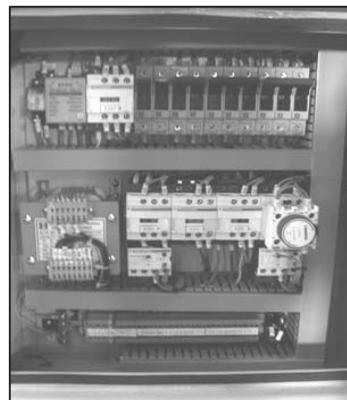


Fig. 4



OPERATION OVERVIEW

Safety Precautions Before Operations

The operation of power tools involves a certain amount of hazard for the operator. Before attempting regular work we recommend you get the feel of operations using scrap lumber to check settings. Read entire instructions before you start to cut workpiece.

Always pay attention to safety precautions to avoid personal injury.

 **WARNING:** Never operate the saw with any guards or covers removed missing or damaged. It could cause severe injury or death.

 **CAUTION:** Always wear proper eye protection with side shields or a face shield, safety footwear, dust mask, and possibly heavy gloves to protect from, chips, dust, burrs, and splinters.

 **WARNING:** Check that saw blade clamping system is tight before operating the machine.

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls and components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is not intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

To complete a typical operation, the operator will:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the blade tilt, if necessary, to the correct angle of the desired cut.
3. Adjusts the blade height to no more than 1/4" higher than the thickness of the workpiece.
4. Adjusts the fence to the desired width of cut then lock it in place.
5. Checks the outfeed side of the machine for proper support and to make sure the workpiece can safely pass all the way through the blade without interference.
6. Puts on safety glasses and a respirator.
7. Locates push sticks/blocks if needed.
8. Starts the saw.



9. Feed the workpiece all the way through the blade while maintaining firm pressure on the workpiece against the table and fence, and keeping hands and fingers out of the blade path and away from the blade.
10. Stops the saw immediately after the cut is complete.

OPERATIONAL SAFETY CHECK



IMPORTANT: Perform these safety checks at least twice every week to ensure proper and secure emergency and interlock switch function.

Emergency Stop Switch Check

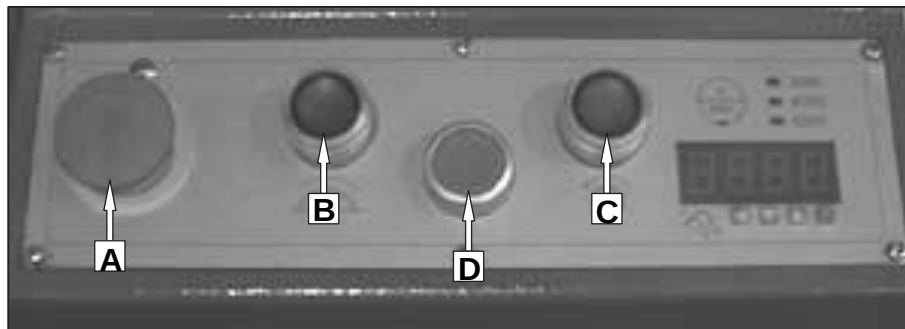
1. Connect to power, start the main saw blade and the scoring saw to make the machine run.
2. Push each emergency stop of machine and check if the saw blade and the scoring saw completely stop within 7 seconds.
3. With the emergency stop switch depressed, operate the machine to see if it starts.
 - If the machine does not start the system is operating normally.
 - If the machine starts, the emergency stop is not operating properly, immediately stop operation. Have someone trained in electrical circuits inspect and test the system and possibly replace the emergency stop switch.

Safety Connection Switch Check

1. Connect to power to the saw. Open the safety door (i.e. saw blade's guard and service door) at the back of the machine.
2. Operate the machine. The machine should not operate.
3. Close the safety door and operate the machine again. The machine should operate.
 - If machine works as described, the safety connection switch is normal.
 - If machine does not work as described, the safety connection switch or wiring has failed and need immediate repair or replacement.



CONTROL PANEL OPERATION

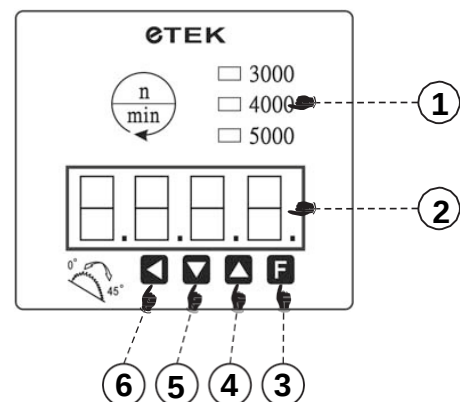


Explanation Of Main Keys

Item	Name	Description
A.	Emergency stop button	Urgently shut down the machine's power.
B.	Main saw start button	Start main saw.
C.	Scoring saw start button	Start scoring saw.
D.	Saw blade stop button	Stop the main saw and scoring saw.

Explanation of Angle Machine's Keys

Item	Function
1.	R.P.M display - 3000, 4000, 5000.
2.	4 Digits display - one decimal point.
3.	Set button.
4.	Set button.
5.	Set button.
6.	Set button.



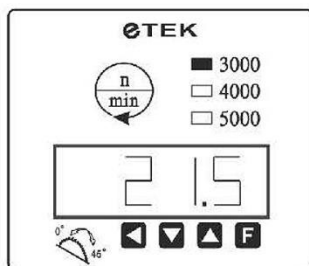
Notes:

- The angle screen of the machine adopts micro-computer single chip controller, so it is stable and safe under long-term use.
- When power is off, the angle screen does not have any display. After power is started, the angle that the angle screen shows is the angle when power was closed last time. After power is closed, please don't adjust the angle and tighten the fixing knob on the hand wheel.
- If the angle is adjusted accidentally while power is off, the angle must be returned to zero to avoid the cutting angle and the actual angle not being the same after power is started.

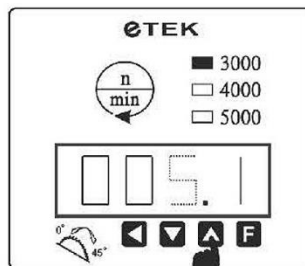


CORRECTING CURRENT DIMENSION

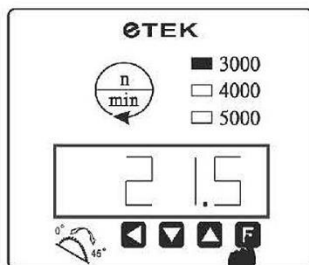
- The figure shows 21.5 on the display. If for example, the correct position is 35.1. The following steps will change and set the correct position.



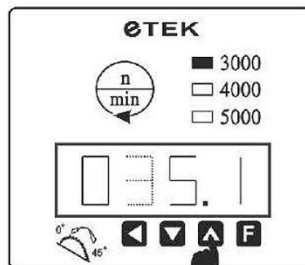
The display shows 21.5



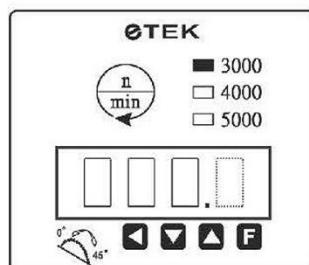
Step 4:
Press button once and press button 5 times. The display shows 005.1 and 3th digital (5) flash.



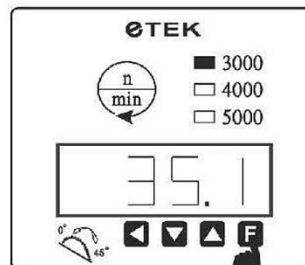
Step 1:
Press button 5 seconds, unrelease button.



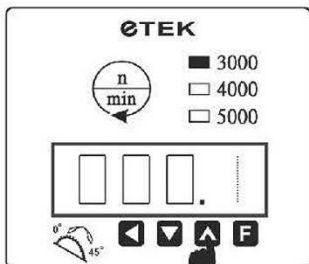
Step 5:
Press button once and press button 3 times. The display shows 035.1 and 2th digital (3) flash.



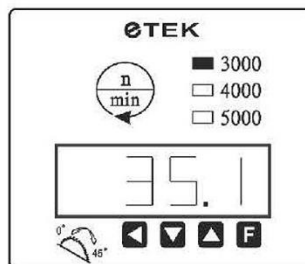
Step 2:
Release button the display shows 000.0 and 4th digital flash.



Step 6:
Press button 5 seconds the display shows 35.1, and stop to flash.



Step 3:
Press button once the display shows 000.1 and 4th is flash.



Step 7:
Correcting completed.

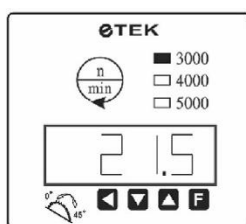


SETTING PARAMETER

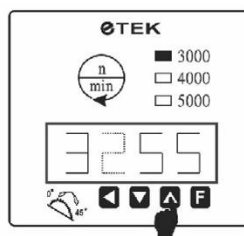
- The figure shows 3000 as the current parameter. If for example, the correct parameter is 4255. The following steps will change and set the new parameter.



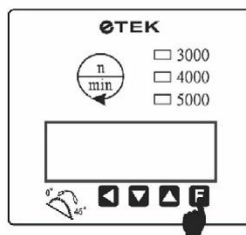
Notes: The operators must pay attention not to make any change. Otherwise, the controller operation may be unusual and damaged the machine. Unless you are and authorized technician, DO NOT alter or modify the operating conditions of the machinery, so as to avoid machinery operation in incorrect dimensions and to prevent any hazard.



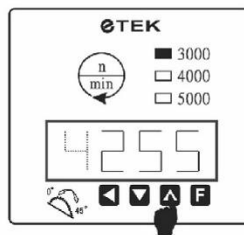
The display shows 21.5



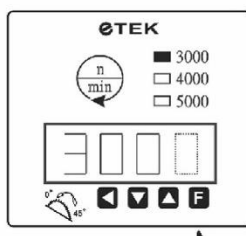
Step 5:
Press button once and press button 2 times. The display shows 3255 and 2th digital (2) flash.



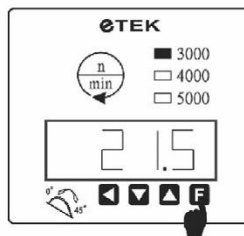
STEP 1:
Turn off the power. Press button (unrelease button) then turn on the power.



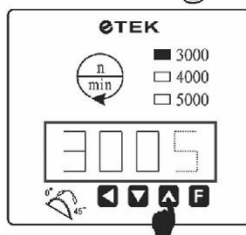
Step 6:
Press button once and press button once. The display shows 4255 and first digital flash.



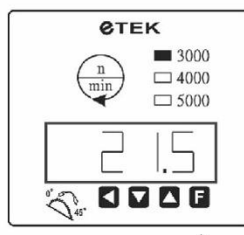
Step 2:
Release button the display shows 3000 and 4th digital is flashing.



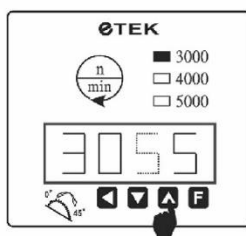
Step 7:
Press button 5 seconds the display shows 21.5, and stop to flash.



Step 3:
Press button five times the display shows 3005 and 4th digital is flashing.



Step 8:
Setting completed.



Step 4:
Press button once and press button 5 times. The display shows 3055 and 3th digital (5) flash.



MAINTENANCE



WARNING: Make sure the electrical disconnect is OFF before working on the machine. Maintenance should be performed on a regular basis following proper safety precautions.

This table saw requires very little maintenance other than minor lubrication and cleaning. The following sections detail what will need to be done in order to assure continued operation of your saw. Proper maintenance can increase the life expectancy of your machine.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Apply rust inhibitive lubricant to all non-painted surfaces.
- Inspect/test the ON/OFF switch before each use. Do not operate the saw with a damaged switch - replace a damaged switch immediately.
- Inspect the saw blade for damage or chipped teeth before each use. Replace a damaged or chipped blade immediately. Never operate the saw with a damaged or chipped blade.
- Keep the saw table clean and free of dust, pitch or glue. An occasional light coating of paste wax can be use to protect the cast-iron surface.
- Occasionally open the cabinet and brush off and vacuum out accumulated dust from inside the cabinet and on the blade tilting gears and on or around the motor.
- Periodically inspect the power cord for damage. To minimize the risk of electric shock or fire, never operate the saw with a damaged power cord. Replace a damaged power cord at the first sign of damage.
- To minimize airborne dust particles periodically inspect all dust collection fittings – re-tighten as needed.
- Check the drive belt for tightness. It should be snug but not overly tight.
- Use a mill file to remove any nicks or dings from the infeed or outfeed tables.
- Verify that the spreader/riving knife is aligned with the blade.

Cleaning

Cleaning the saw is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

After cleaning, treat all unpainted cast iron and steel with a non-staining lubricant.

Occasionally it will become necessary to clean the internal parts with more than a vacuum. To do this, remove the table top and clean the internal parts with resin/pitch dissolver or mineral spirits and a stiff wire brush or steel wool.

Make sure the internal workings are dry before using the saw again, so that wood dust will not accumulate. If any essential lubrication is removed during cleaning, re-lubricate those areas.



Lubrication

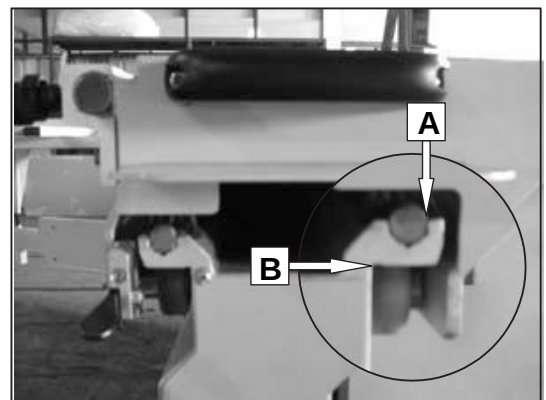
The table saw has sealed lubricated bearings in the motor housing and the arbor assembly, they will not require any additional lubrication. Use a wire brush to clean off the worm gears and trunnions and apply a white lithium grease to keep them lubricated.

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more grease to them will not yield smooth moving components.

ISO DIS-3498	Lubricating Cycle	Lubricating Way
XM2	6 months	Lubricate the machine
BRAND		
MOBIL	ESSO	SHELL
MOBILUX 2	BEACON 2	ALVANIA R2

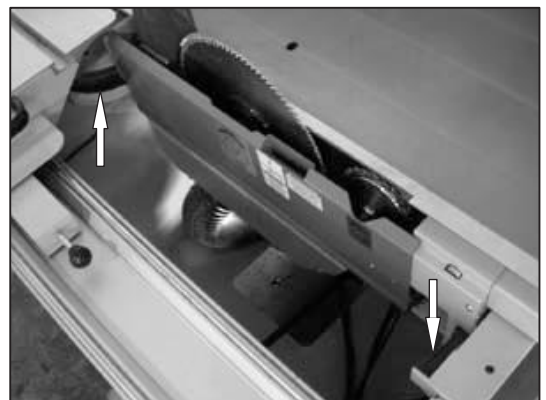
Sliding Table Maintenance

- Clean the contact surface (A) of upper slide base and lower slide base.
- Clean the contact surface (B) of lower slide base and the roller.
- Periodically clean above contact surfaces to keep long-term accuracy of machine.



Angle Slide Rail Maintenance

- Clean dust or wood chips on slide rail.
- After cleaning, apply the lubricating oil. Please refer to the following list to choose the lubricating oil.
- Periodically maintain above contact surfaces to keep long-term accuracy of machine.





TROUBLESHOOTING

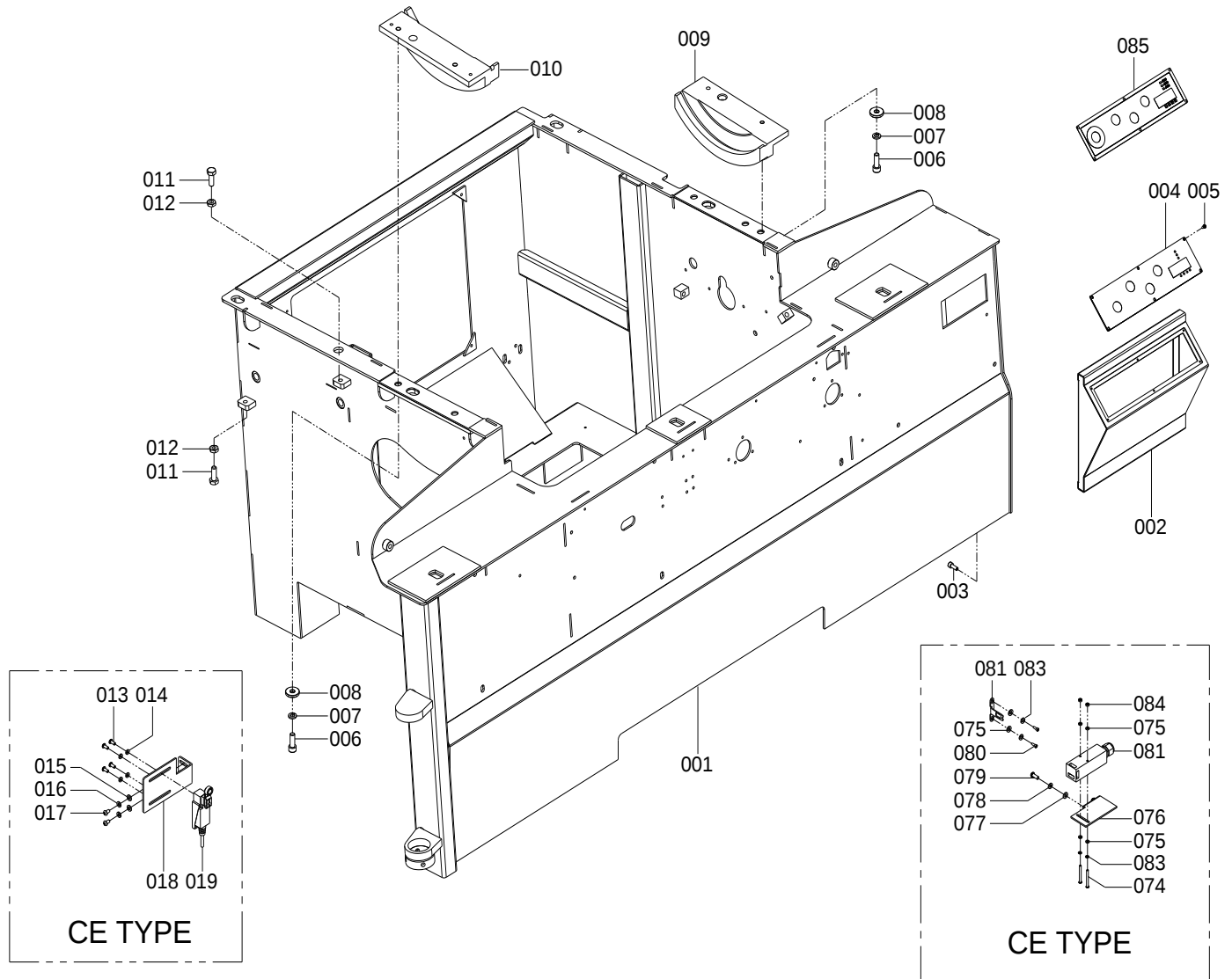


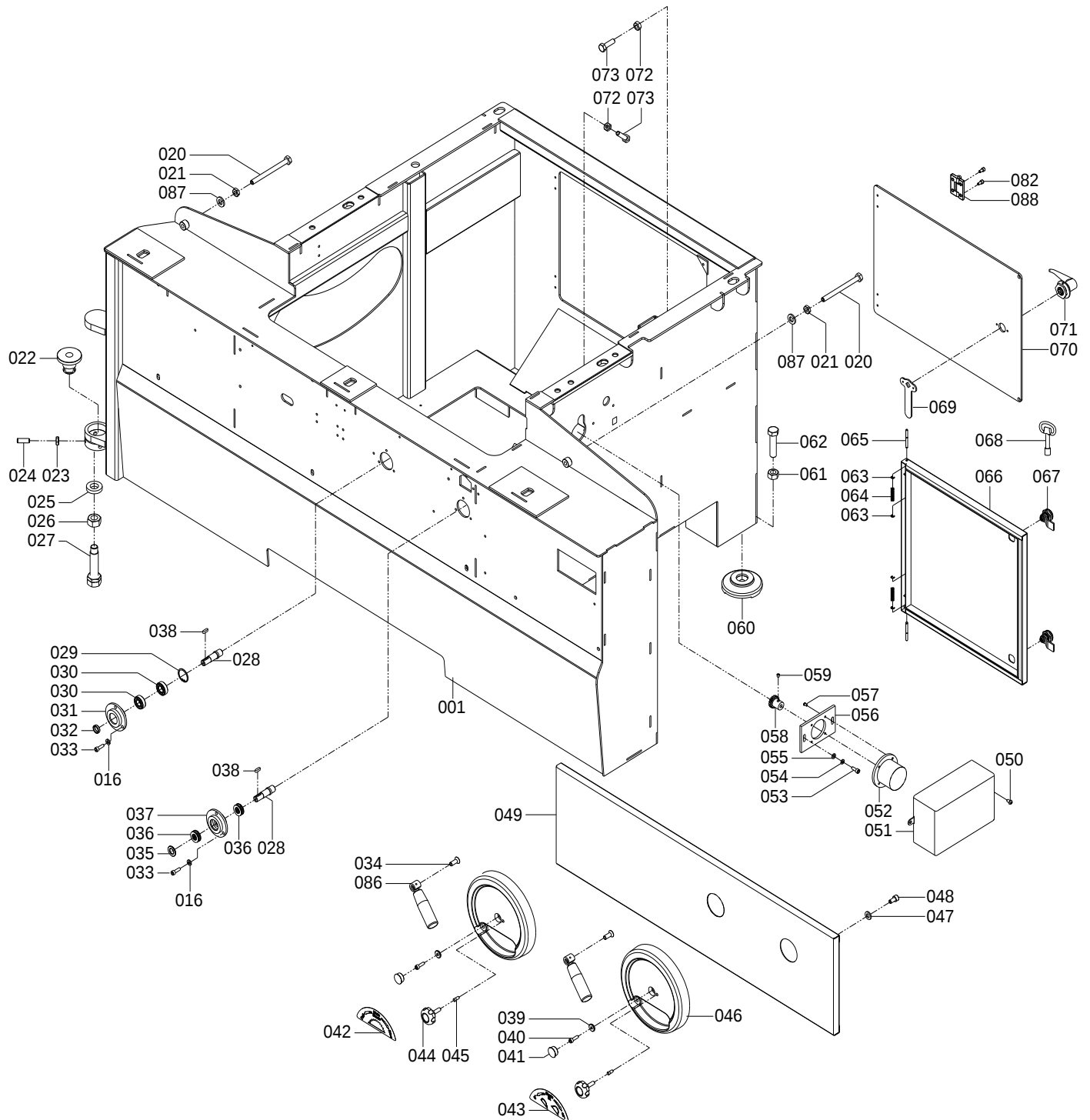
WARNING: Disconnect machine from the power source before attempting any troubleshooting.

Trouble	Check Cause	Action
LED does not display	Check if power AC 5V and AC 12V are normal.	Input correct voltage.
	If voltage is normal, that means controller is damaged.	Replace controller.
LED's value displayed is not the actual value	Check if the shown size is correct.	Correct controller's size as per actual size.
	Check if parameter is correct.	Contact the manufacturer to get correct parameter.
LED displays normally but LED value does not react when angle moves.	Check if spindle connecting device between encoder and machine has come off or is damaged.	If the spindle connecting device is damaged, please change the encoder.
	Use voltmeter to measure if A, B phase have DC 12V and OV reaction.	If A, B phase don't have any reaction, please change encoder.



MAIN CABINET PARTS DIAGRAM







Main Cabinet Parts List

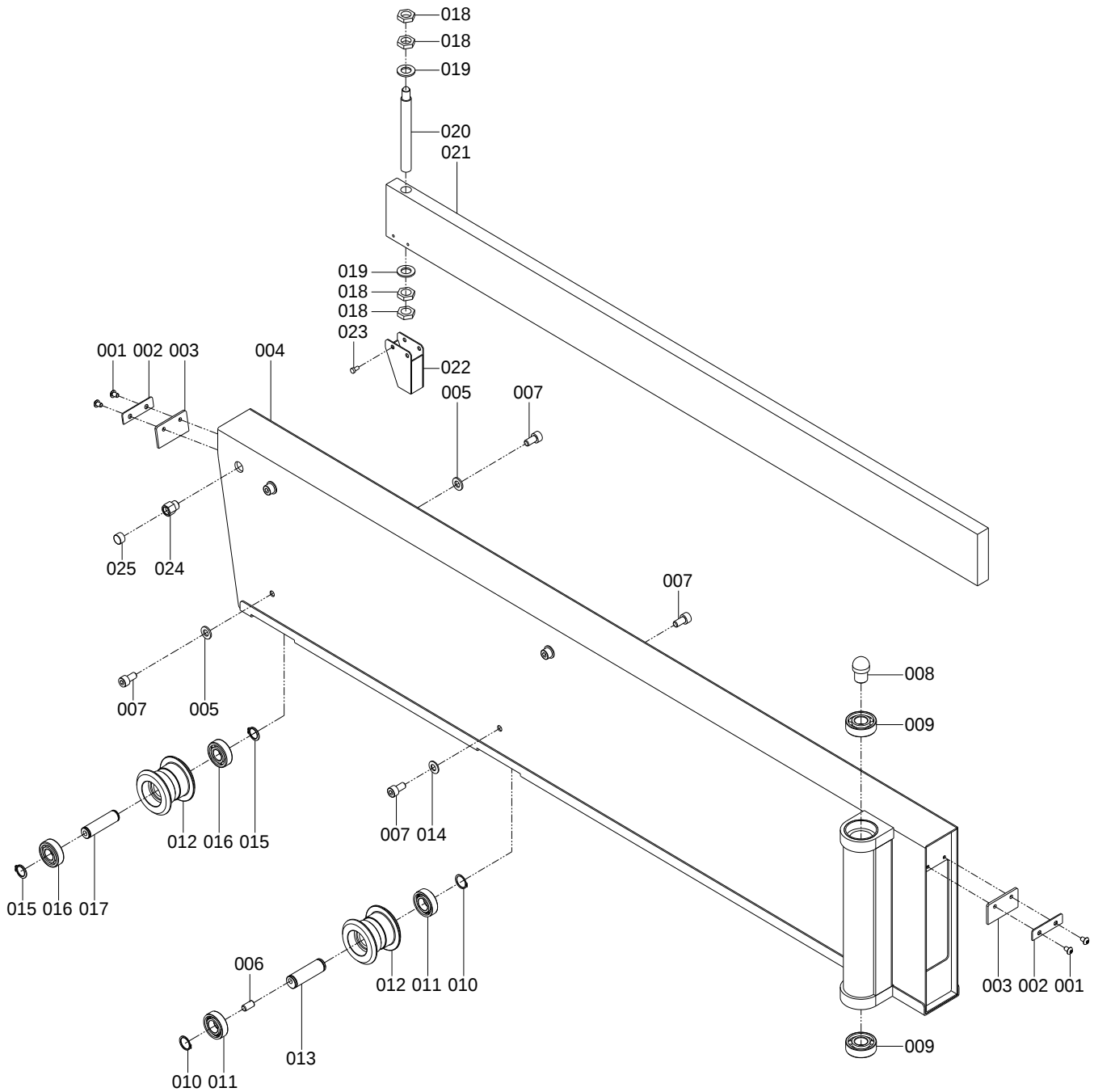
Item	Description	Specifications	Item	Description	Specifications
001	Body		045	Stop Pillar	
002	Electron Part Box		046	Handle Wheel	
003	Cap Screw	M6 x 16	047	Washer	Φ8
004	Control Faceplate		048	Cap Screw	M8 x 16
005	Button Head Screw	M4 x 8	049	Cover	
006	Cap Screw	M10 x 30	050	Button Head Screw	M6 x 10
007	Lock Washer	Φ10	051	Cover	
008	Washer		052	Encoder	HSK-200-2
009	Sliding Base		053	Cap Screw	M6 x 16
010	Sliding Base		054	Lock Washer	Φ6
011	Hex Head Bolt	M10 x 35	055	Washer	Φ6
012	Hex Nut	M10	056	Fixed Board	
013	Phillips Head Screw	M5 x 8	057	Phillips Head Screw	M4 x 8
014	Washer	Φ5	058	Gear	
015	Washer	Φ6	059	Setscrew	M6 x 6
016	Lock Washer	Φ6	060	Adjust Base	BD-100
017	Button Head Screw	M6 x 10	061	Hex Nut	M16
018	Fixed Board		062	Foundation Bolt	
019	Switch	ME-8104	063	Retain Ring	4
020	Hex Head Bolt		064	Spring	
021	Hex Nut		065	Fixed Shaft	
022	Adjust Base		066	Door	
023	Hex Nut		067	Lock	MS-705-3-25
024	Setscrew		068	Key	MS-705-3-25
025	Washer	Φ20	069	Handle	B45
026	Hex Nut	M20	070	Body	
027	Position Shaft		071	Handle	B45
028	Driving Shaft		072	Hex Nut	M10
029	Retain Ring	RTW-32	073	Hex Head Bolt	M10 x 35
030	Ball Bearing	6002 LLB	074	Phillips Head Screw	M4 x 35
031	Fixed Base		075	Washer	Φ4
032	Washer		076	Fixed Base	
033	Cap Screw	M6 x 16	077	Washer	Φ6



Item	Description	Specifications	Item	Description	Specifications
034	Countersink Head Screw	M6 x 16	078	Lock Washer	Φ6
035	Washer		079	Cap Screw	M6 x 16
036	Thrust Bearing	51102	080	Cap Screw	M4 x 10
037	Bearing Base		081	Safety Switch	EK-1-15-R
038	Key	5 x 5 x 15	082	Cap Screw	M5 x 12
039	Washer		083	Lock Washer	Φ4
040	Cap Screw	M6 x 16	084	Hex Nut	M4
041	Plug	HP-22	085	Control Faceplate(PVC)	
042	Mark		086	Handle	
043	Mark		087	Washer	Φ10
044	Knob	HS40M823	088	Hinger	CL-208



SUPPORT ARM PARTS DIAGRAM



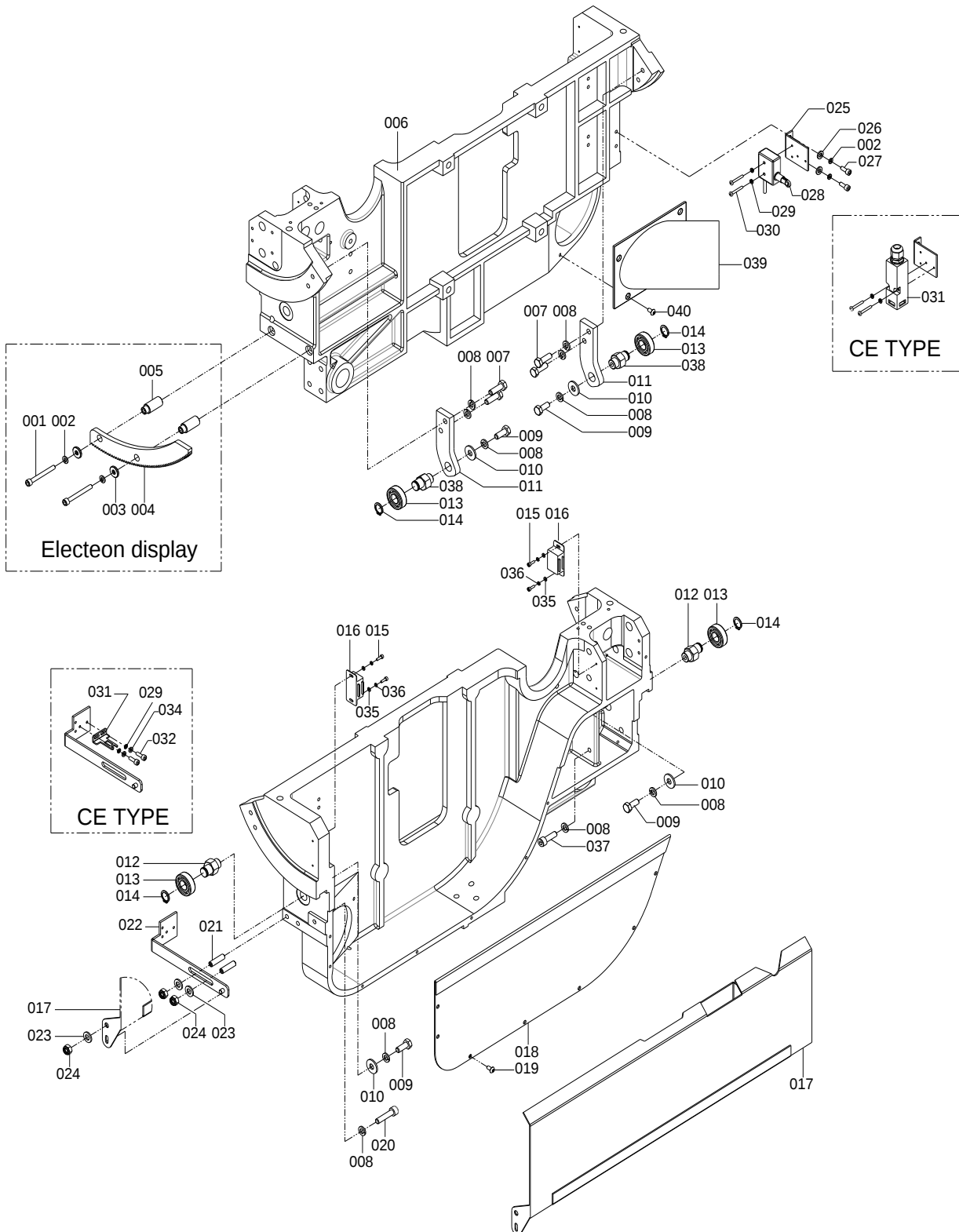


Support Arm Parts List

Item	Description	Specification
001	Button Head Screw	M5 x 8
002	Fixed Board	
003	Clean Sheet	
004	Arm	2.6m, 3.2m
	Arm	1.9m
005	Washer	M8
006	Setscrew	M8 x 10
007	Cap Screw	M8 x 16
008	Position Shaft	
009	Ball Bearing	6203 LLU
010	Retain Ring	STW-17
011	Ball Bearing	6003 ZZ
012	Sliding Wheel	
013	Adjust Shaft	
014	Washer	M8
015	Retain Ring	STW-15
016	Ball Bearing	6202 ZZ
017	Sliding Shaft	
018	Hex Nut	M20
019	Washer	Φ20
020	Screw	
021	Extending Arm	1.9m
	Extending Arm	2.6m
	Extending Arm	3.2m
022	Cover	
023	Button Head Screw	M6 x 10
024	Rocker arm suction base	
025	Intensify magnet	Φ15 x 10



ROTARY BASE PARTS DIAGRAM





Rotary Base Parts List

Item	Description	Specification	Item	Description	Specification
001	Cap Screw	M6 x 55	021	Setscrew	M8 x 25
002	Lock Washer	Φ6	022	Joint Bar	
003	Washer		023	Washer	Φ8
004	Rack		024	Lock Nut	M8
005	Fixed Pole		025	Fixed Rack	
006	Rotary Base		026	Washer	Φ6
007	Cap Screw	M8 x 30	027	Cap Screw	M6 x 16
008	Lock Washer	Φ8	028	Sensor	TZ-7311
009	Hex Head Bolt	M8 x 25	029	Washer	Φ4
010	Washer	Φ8 x Φ23	030	Phillips Head Screw	M4 x 30
011	Fixed Block		031	Safety Switch	EK-1-15-R
012	Adjust Shaft		032	Cap Screw	M4 x 12
013	Ball Bearing	6202 2NSL	034	Lock Washer	Φ4
014	Retain Ring	STW-15	035	Washer	Φ3
015	Cap Screw	M3 x 8	036	Lock Washer	Φ3
016	Magnets	H-22-C	037	Cap Screw	M8 x 25
017	Cover		038	Adjust Shaft	
018	Coover		039	Collection Hole	
019	Phillips Head Screw	M5 x 8	040	Phillips Head Screw	M6 x 12
020	Cap Screw	M8 x 35			



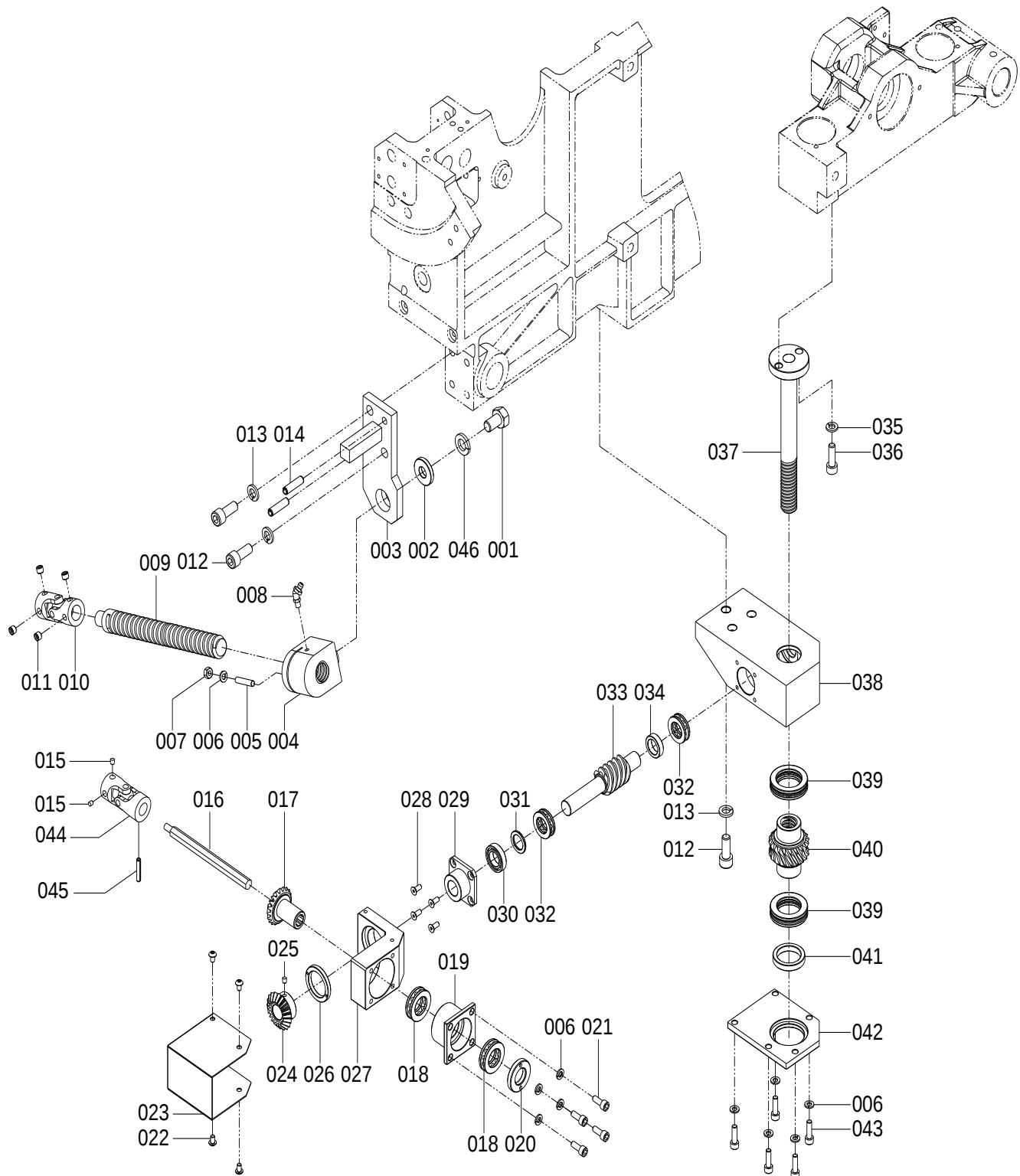


Main Saw Blade Mount Parts List

Item	Description	Specification	Item	Description	Specification
001	Hex Head Bolt	M12 x 40	025	Key	8 x 7 x 20
002	Lock Washer	Φ12	026	Spindle	
003	Fixed Block		027	Key	8 x 7 x 32
004	Riving Knife (Simple)	12", 14"	028	Button Head Screw	M6 x 10
	Riving Knife (Delux)	12", 14"	029	Cover	
005	Washer	Φ6 x Φ13	030	Hex Head Bolt	M10 x 40
006	Adjust Block		031	Hex Nut	M10
007	Pin		032	Spindle Base	
008	Cap Screw	M8 x 35	033	Button Head Screw	M6 x 12
009	Fixed Block		034	Setscrew	M10 x 16
010	Cap Screw	M5 x 16	035	Fixed Sheet	
011	Fixed Block		036	Hex Head Bolt	M6 x 12
012	Cap Screw	M6 x 20	037	Bearing Cover	
013	Lock Washer	Φ6	038	Bearing Cover	
014	Sliding Rail	237L	039	Pulley	
015	Lock Nut		040	Fixed Ring	
016	Shaft Cover		041	Lock Washer	Φ10
017	Ring		042	Cap Screw	M10 x 30
018	Flange	Φ25.4		Belt	11M-800
	Flange	Φ30	043	Belt	11M-750
019	Setscrew	M6 x 10		Belt	11M-800
020	Cap Screw	M6 x 16	044	Line Bearing	UBM-30AWW
021	Bearing Cover		045	Sliding Rail	
022	Exact Nut	M30 x P1.5-L	046	Cap Screw	M12 x 50
023	Setscrew	M6 x 6	047	Fixed Bar	
024	Ball Bearing	6206-VV-CM	048	Ball Knob	3/8"



MAIN BLADE ELEVATION AND TILT PARTS DIAGRAM



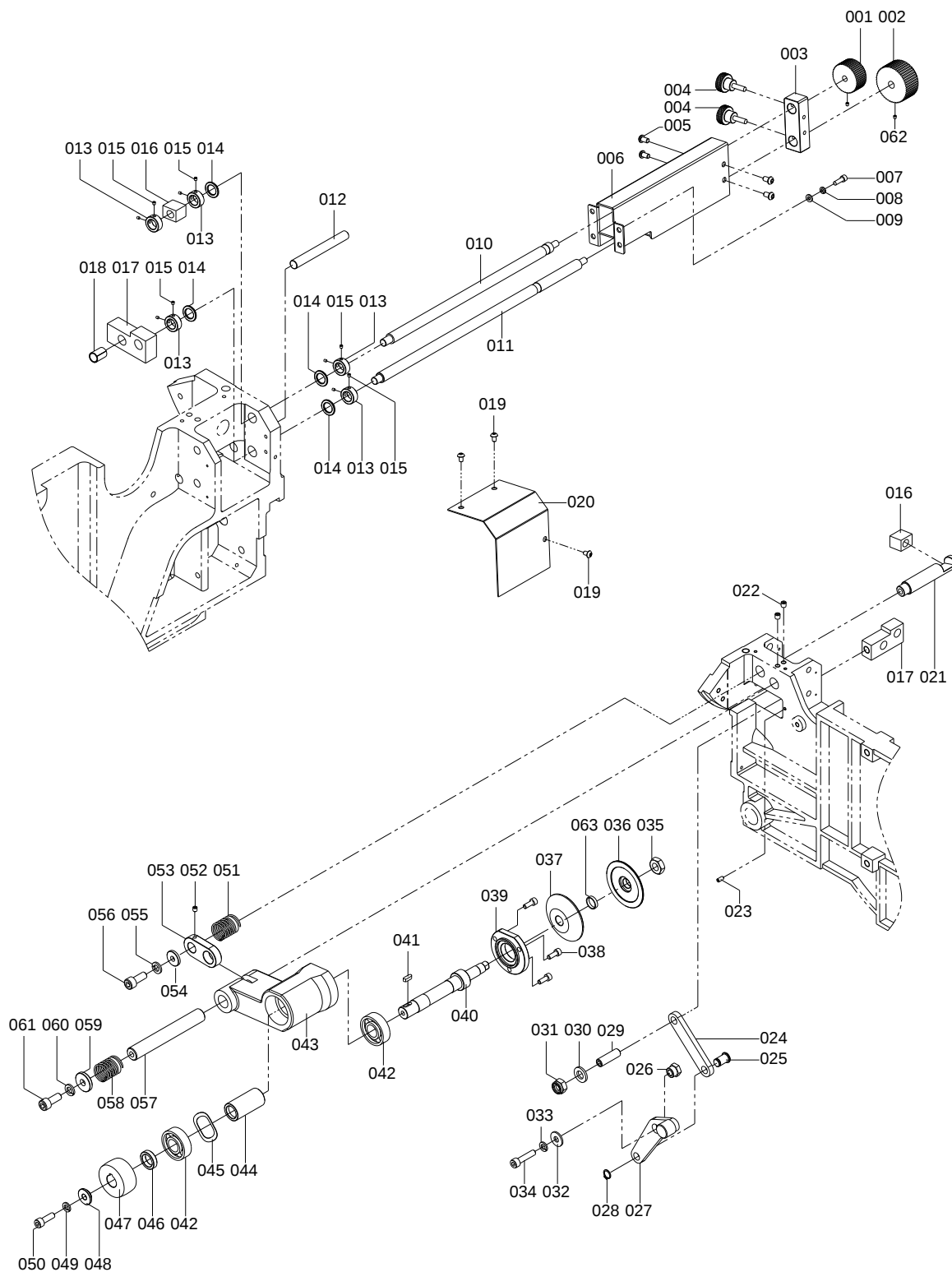


Main Blade Elevation and Tilt Parts List

Item	Description	Specification	Item	Description	Specification
001	Hex Head Bolt	M12 x 20	024	Gear	
002	Washer		025	Setscrew	M6 x 6
003	Join Block		026	Nut	
004	Driving Nut		027	Fixed Base	
005	Setscrew	M6 x 30	028	Countersink Head Screw	M5 x 12
006	Lock Washer	Φ6	029	Fixed Base	
007	Hex Nut	M6	030	Ball Bearing	6903 LLB
008	Lubricant Plug	45"-M6 x 10	031	Washer	
009	Driving Nut		032	Thrust Bearing	51103
010	Join Shaft		033	Worm	
011	Setscrew	M8 x 6	034	Spacer	
012	Cap Screw	M10 x 25	035	Lock Washer	Φ8
013	Lock Washer	Φ10	036	Cap Screw	M8 x 25
014	Spring Pin	Φ8 x 20	037	Worm	
015	Setscrew	M8 x 6	038	Gear Base	
016	Driving Join Shaft		039	Thrust Bearing	51106
017	Gear		040	Worm Wheel	
018	Thrust Bearing	51104	041	Adjust Nut	
019	Bearing Base		042	Cover	
020	Nut		043	Cap Screw	M6 x 20
021	Cap Screw	M6 x 16	044	Join Shaft	
022	Phillips Head screw	M5 x 8	045	Spring Pin	Φ6 x 32
023	Cover		046	Lock Washer	Φ12



SCORING SAW MOUNTING BLOCK PARTS DIAGRAM



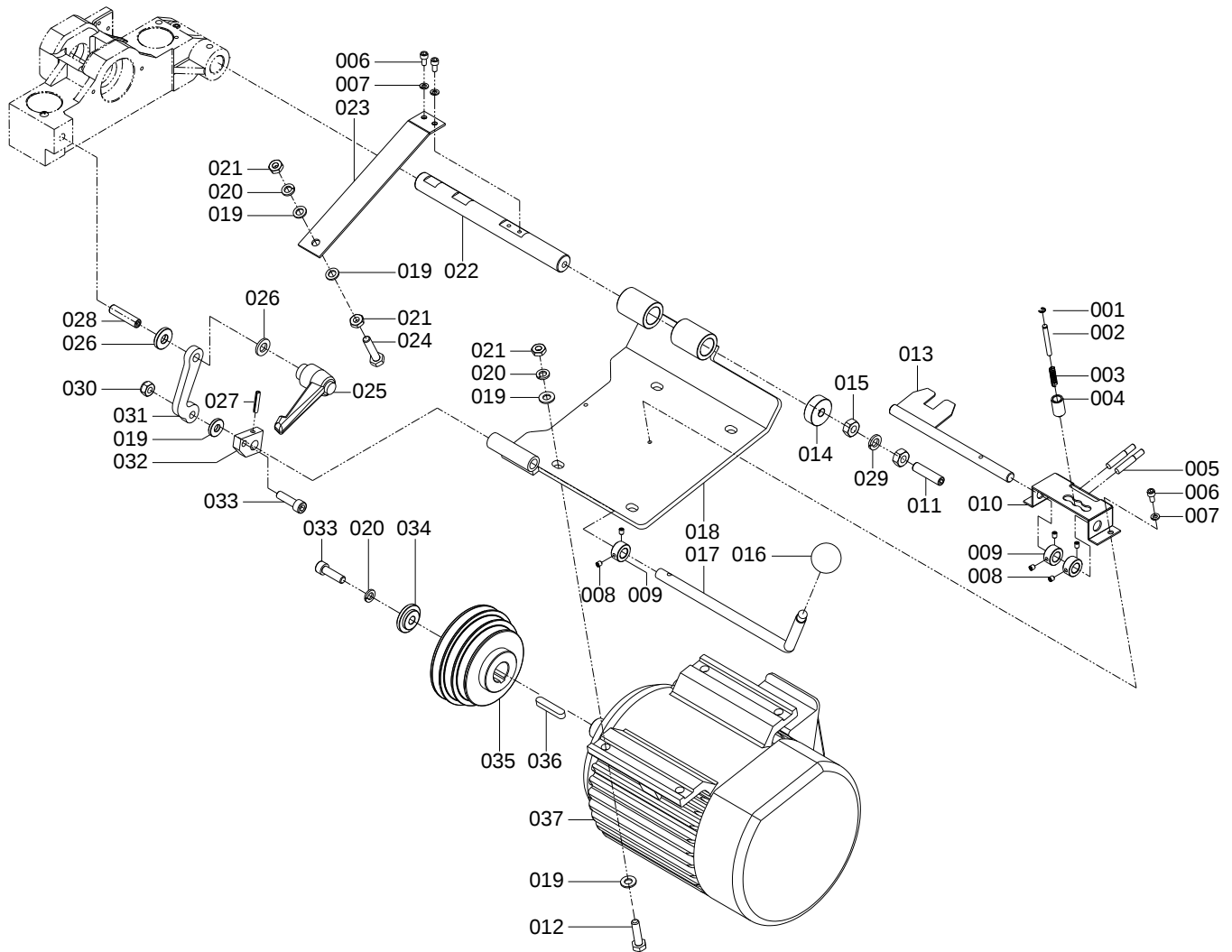


Scoring Saw Mounting Block Parts Diagram

Item	Description	Specs.	Item	Description	Specs.
1	Control Knob	7051-42-B8	34	Cap Screw	M8 x 30
2	Control Knob	7051-52-B8	35	Hex Nut	M14 x P1.5
3	Fixed Block		36	Cover	
4	Emboss Screw	8010-25-M6-20	37	Cover	Φ22 x 13t
5	Button Head Screw	M6 x 10		Cover	Φ19.5 x 13t
6	Fixed Rack			Cover	Φ20 x 15t
7	Cap Screw	M5 x 16		Cover	Φ20 x 13t
8	Lock Washer	Φ5	38	Cap Screw	M6 x 16
9	Washer	Φ5	39	Cover	
10	Adjust Shaft		40	Spindle	
11	Adjust Shaft		42	Ball Bearing	6204-LLB-CM
12	Sliding Rail		43	Spindle Base	
13	Fixed Ring		44	Spacer	
14	Washer		45	Waves Spring	
15	Setscrew	M5 x 4	46	Spacer	
16	Sliding Block		47	Pulley	
17	Sliding Block		48	Fixed Ring	
18	Bush	MB1220	49	Lock Washer	Φ8
19	Button Head Screw	M5 x 8	50	Cap Screw	
20	Cover		51	Lock Washer	
21	Driving Shaft		52	Setscrew	M6 x 6
22	Setscrew	M8 x 20	53	Driving Block	
23	Setscrew	M5 x 10	54	Washer	
24	Join Arm		55	Lock Washer	Φ10
25	Pivot Axis		56	Cap Screw	M10 x 25
26	Pivot Axis		57	Pivot Axis	
27	Elbow		58	Spring	
28	Retain Ring	STW-12	59	Washer	
29	Setscrew	M12 x 40	60	Lock Washer	Φ10
30	Washer	Φ12	61	Cap Screw	M10 x 25
31	Lock Nut	M12	62	Setscrew	M5 x 10
32	Washer	Φ8 x 23	63	Spacer	Φ19.5 x 13t
33	Lock Washer	Φ8		Spacer	Φ20 x 13t, Φ20 x 15t



MAIN SAW MOTOR PARTS DIAGRAM



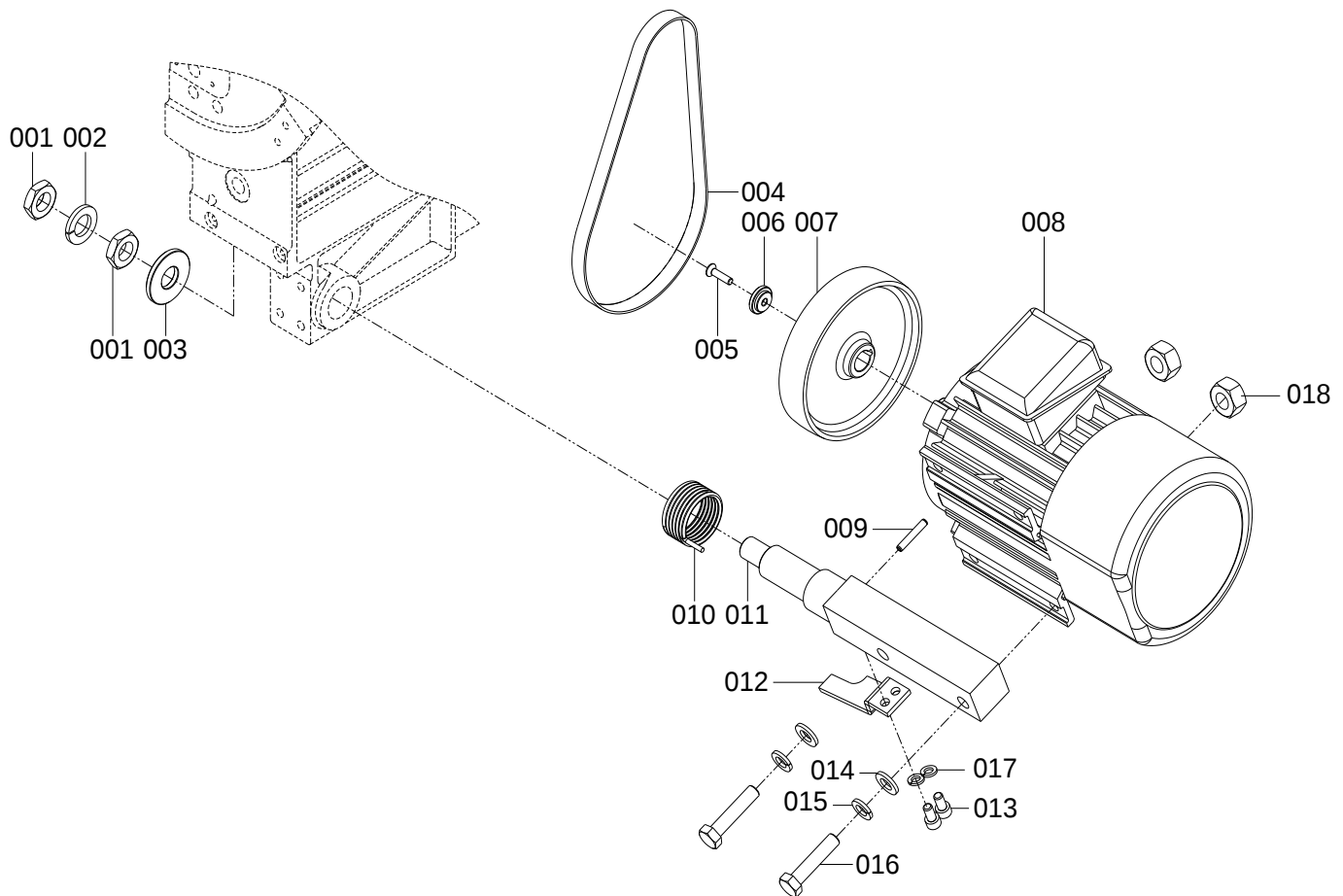


Main Saw Motor Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Retain Ring	Φ4	020	Lock Washer	Φ10
002	Position Shaft		021	Hex Nut	M10
003	Spring		022	Pivot Axis	
004	Bush		023	Spring Sheet	
005	Sensor	PM08-02N-3m	024	Hex Head Bolt	M10 x 40
006	Cap Screw	M6 x 12	025	Adjust Handle	95KA-M12-0
007	Lock Washer	Φ6	026	Washer	Φ12
008	Setscrew	M6 x 6	027	Spring Pin	Φ6 x 32
009	Position Ring		028	Setscrew	M12 x 50
010	Fixed Base		029	Lock Washer	Φ6
011	Setscrew	M12 x 50	030	Lock Nut	M10
012	Hex Head Bolt	M10 x 40	031	Elbow	
013	Cahang Shaft		032	Rotary Block	
014	Spacer		033	Cap Screw	M10 x 35
015	Hex Nut	M12	034	Fixed Ring	
016	Ball Knob	1/2"	035	Pulley	5HP,7.5HP/50HZ
017	Adjust Handle			Pulley	5HP,7.5HP/60HZ
018	Motor Board		036	Key	10 x 8 x 50
019	Washer	Φ10	037	Motor	



SCORING SAW MOTOR PARTS DIAGRAM

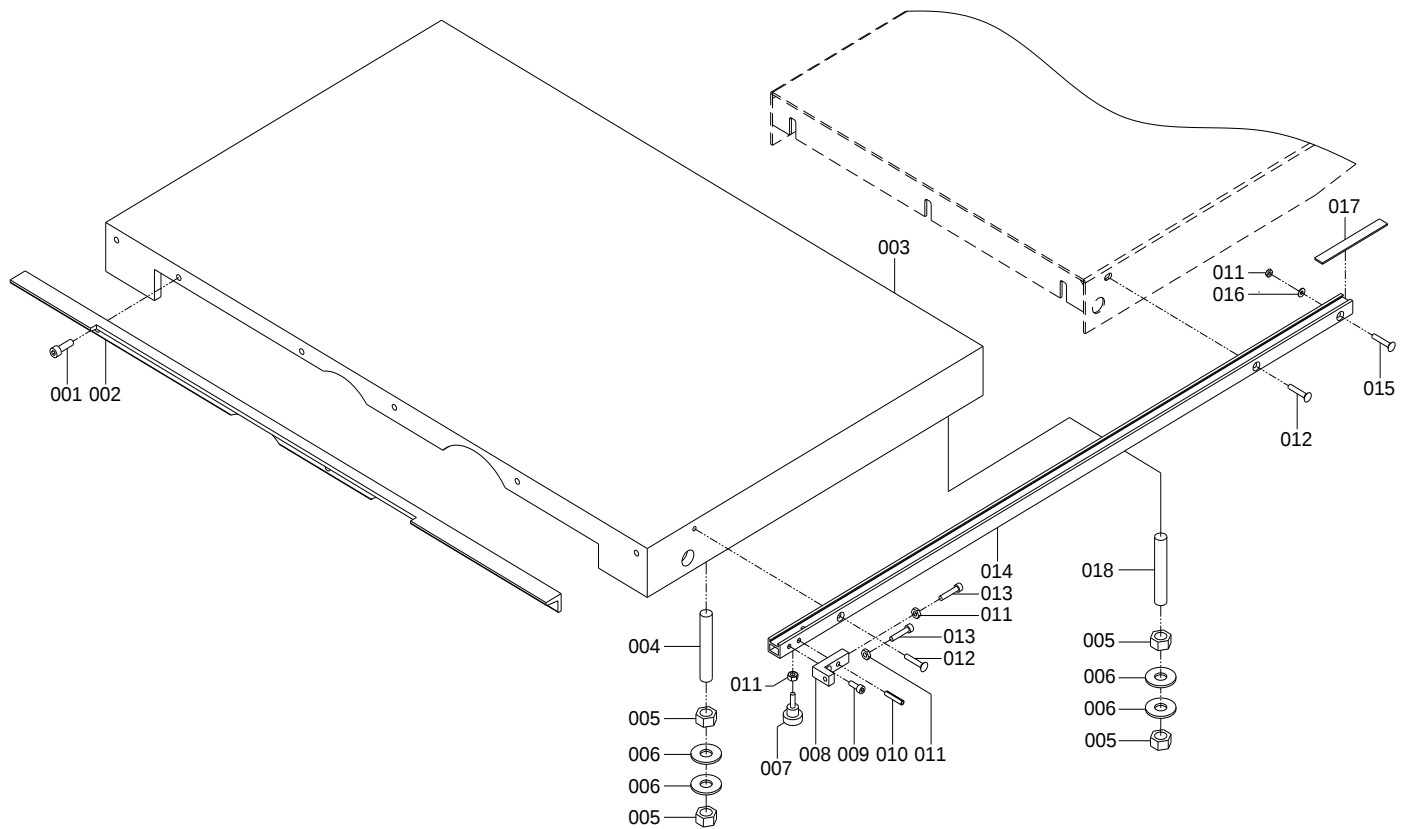


Scoring Saw Motor Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Hex Nut	M20	010	Spring	
002	Lock Washer	Φ20	011	Pivot Axis	
003	Washer		012	Stop Board	
004	Belt	15 x 690 x 1.8t	013	Cap Screw	M8 x 16
005	Countersink Head Screw	M6 x 16	014	Washer	Φ12
006	Fixed Ring		015	Lock Washer	Φ12
007	Pulley		016	Hex Head Bolt	M12 x 55
008	Motor		017	Lock Washer	Φ8
009	Spring Pin	Φ6 x 32	018	Hex Nut	M12



MAIN TABLE PARTS DIAGRAM

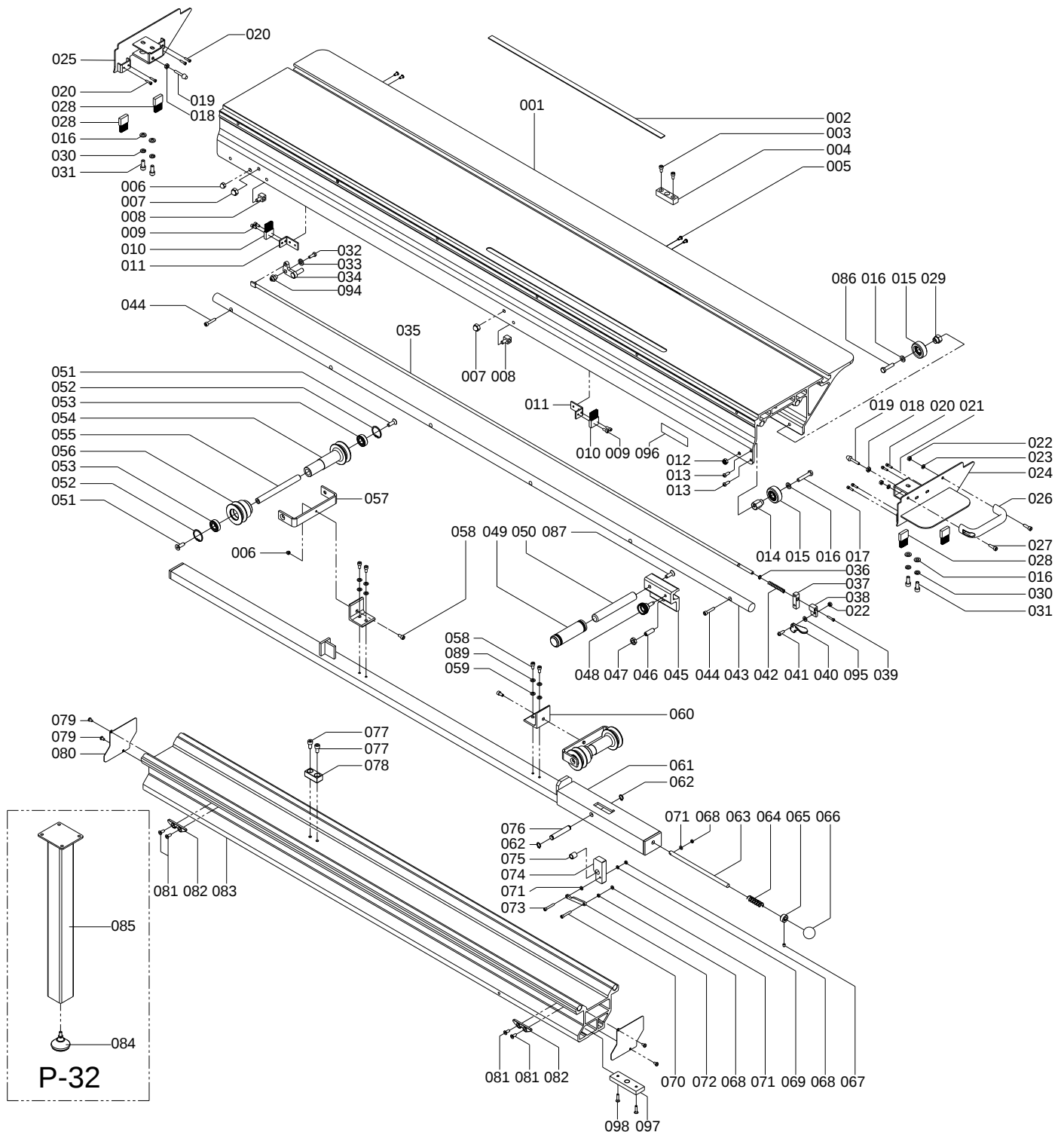


Main Table Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Cap Screw	M8 x 20	013	Cap Screw	M6 x 30
002	Protec Bar		014	Scale Base	1m
003	Main Table			Scale Base	1.3m
004	Setscrew	M16 x 120		Scale Base	1.5m
005	Hex Nut	M16	015	Countersink Head Screw	M6 x 35
006	Washer	M16	016	Washer	M6
007	Emboss Screw		017	Scale	1m
008	Fixed Block			Scale	1.3m 1.5m
009	Cap Screw	M6 x 16		Scale	1.3m 1.5m
010	Spring Pin	Φ6 x 32		Scale	1m
011	Hex Nut	M6	018	Setscrew	M16 x 150
012	Countersink Head Screw	M6 x 30			



SLIDING TABLE PARTS DIAGRAM





Sliding Table Parts List

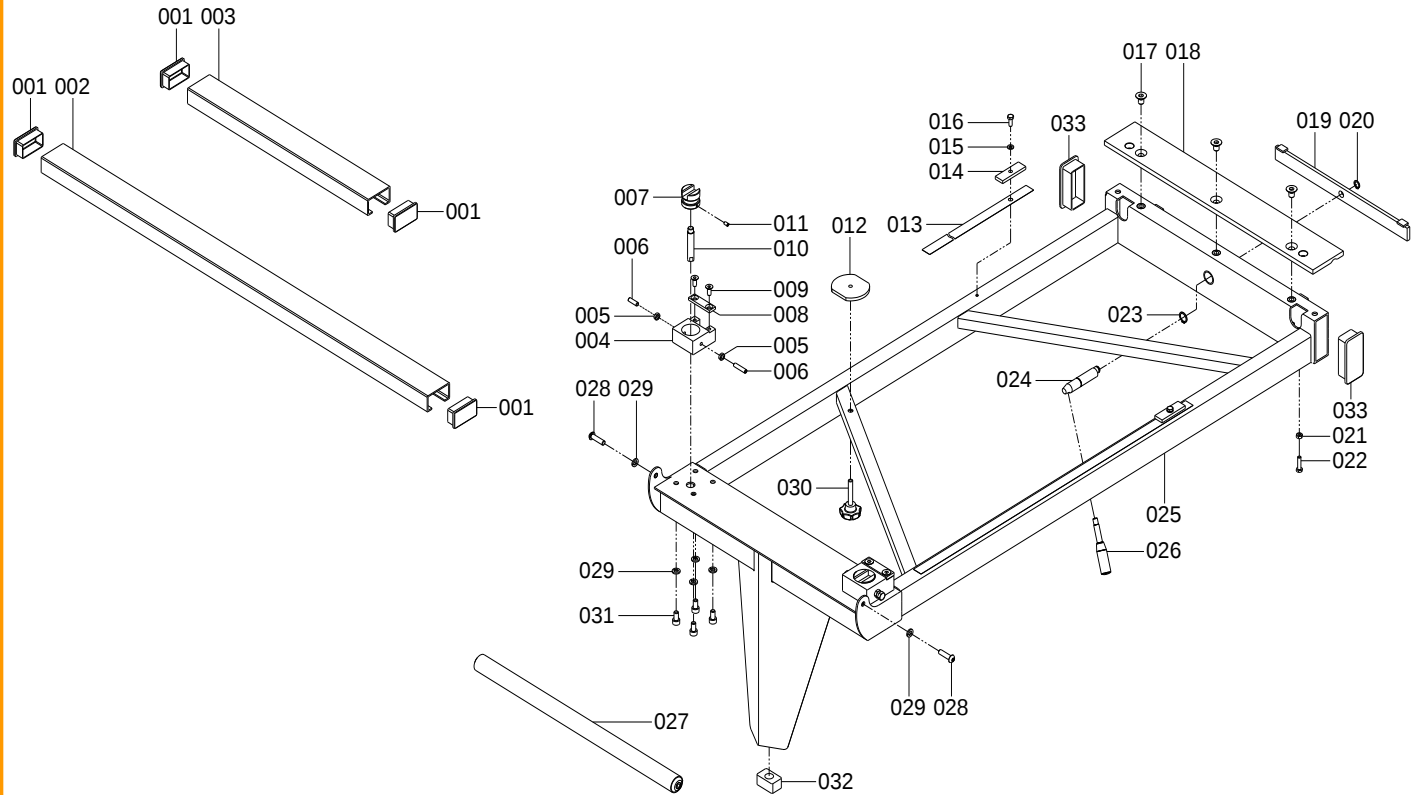
Item	Description	Specs.	Item	Description	Specs.
001	Sliding Table	1.9m	050	Handle	
	Sliding Table	2.6m	051	Counersink Head Screw	M6 x 12
	Sliding Table	3.2m	052	Retain Ring	RTW-32
002	Scale		053	Ball Bearing	6002 LLB
003	Cap Screw	M6 x 16	054	Slide Wheel	
004	Position Block		055	Slide Wheel Shaft	
005	Button Head Screw	M6 x 12	056	Slide Wheel	
006	Lock Nut	M6	057	Slide Wheel Base	
007	Cap Nut	M8	058	Hex Head Bolt	M5 x 20
008	Fixed Pillar		059	Washer	Φ6
009	Cap Screw	M5 x 12	060	Fixed Base	
010	Bristle Brush		061	Slide Bar	1.9m
011	Bristle Brush Base			Slide Bar	2.6m
012	Lock Nut	M8		Slide Bar	3.2m
013	Button Head Screw	M6 x 16	062	Retain Ring	STW-12
014	Adjust Block		063	Pull Bar	
015	Sliding Wheel		064	Spring	
016	Washer	Φ8	065	Fixed Ring	
017	Hex Head Bolt	M8 x 45	066	Knob	
018	Hex Nut	M8	067	Setscrew	M6 x 6
019	Stop Screw	SSP-FC-806312	068	Hex Nut	M5
020	Cap Screw	M4 x 10	069	Lock Washer	Φ5
022	Hex Nut	M6	070	Cap Screw	M5 x 30
023	Lock Washer	Φ6	071	Washer	Φ5
024	Cover		072	Join Sheet	
025	Cover		073	Cap Screw	M5 x 30
026	Handle		074	Stop Block	
027	Cap Screw	M6 x 20	075	Bush	MB1215
028	Bristle Brish		076	Fixed Shaft	
029	Adjust Block		077	Cap Screw	M8 x 16
030	Washer		078	Stop Block	



Item	Description	Specs.	Item	Description	Specs.
031	Cap Screw	M8 x 20	079	Phillips Head Screw	M5 x 8
032	Cap Screw	M6 x 30	080	Cover	
033	Washer	Φ6	081	Countersink Head Screw	M6 x 12
034	Connect Block		082	Position Block	
035	Connect Bar	1.9m	083	Support Base	1.9m
	Connect Bar	2.6m		Support Base	2.6m
	Connect Bar	3.2m		Support Base	3.2m
036	Retain Ring	Φ6	084	Pedestal	
037	Fixed Block		085	Support Scaffold	
038	Stop Block		086	Hex Head Bolt	M8 x 35
039	Cap Screw	M4 x 10	087	Countersink Head Screw	M8 x 25
040	Handle		088	T-Shape Block	CE
041	Button Head Screw	M6 x 20	089	Stop Board	CE
042	Spring		090	Washer	
043	Slide Rail	1.9m	091	Adjust Handle	DA7012-A10x95-B
	Slide Rail	2.6m	092	Touch Block	CE
	Slide Rail	3.2m	093	Button Head Screw	M6 x 12
044	Cap Screw	M6 x 30	094	Pivot Axis	
045	Fixed Block		095	Washer	
046	Screw		096	Mark	
047	Hex Nut	M10	097	Lock Block	
048	Emboss Screw	8010-30-M8-20	098	Countersink Head Screw	M6 x 16
049	Handle Sleeve		099	Hex Head Bolt	M6 x 16



CROSSCUT TABLE PARTS DIAGRAM



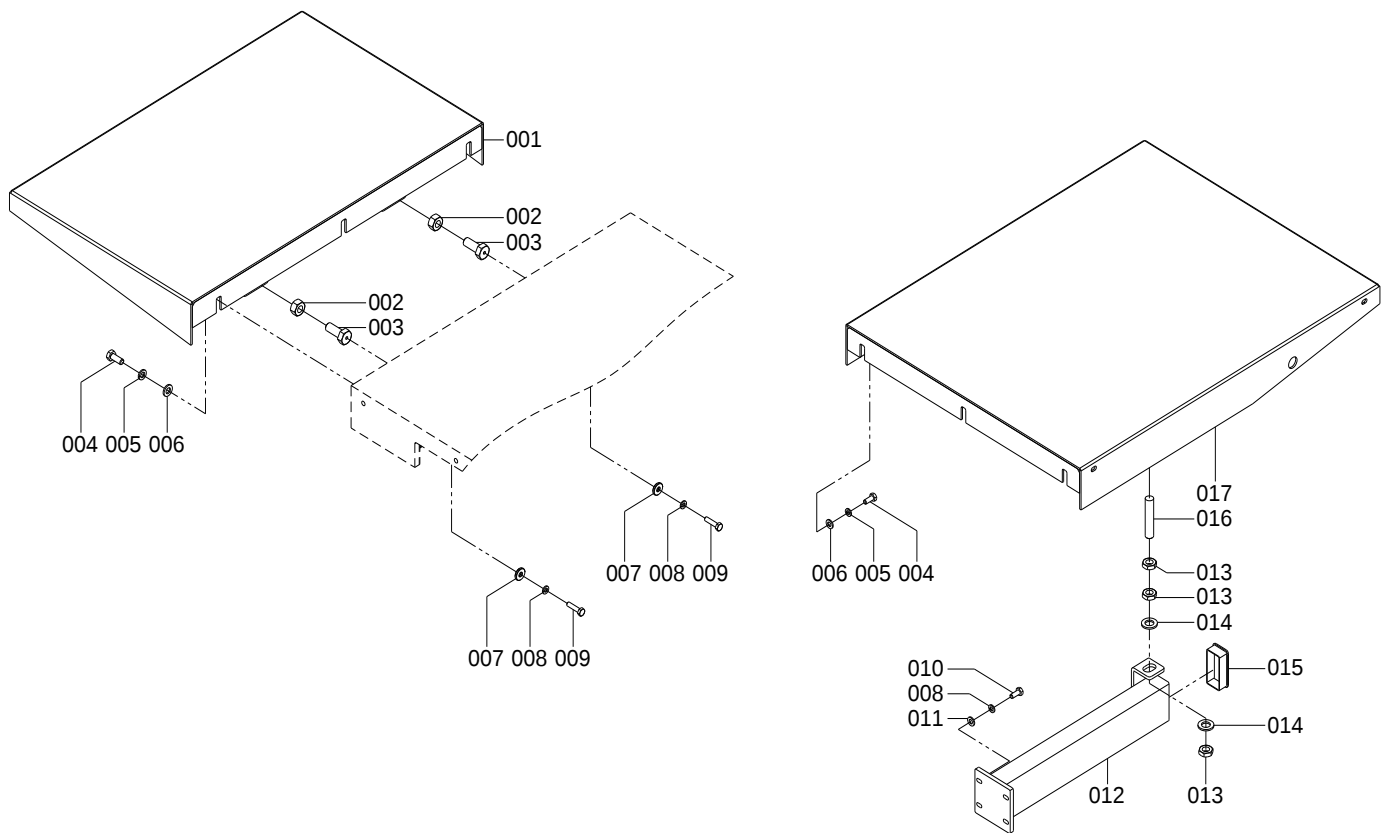


Crosscut Table Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Rectangle Insert		018	Fixed Board	
002	Short		019	Lock Bar	
003	Short		020	Retain Ring	STW-14
004	Fixed Base		021	Hex Nut	M6
005	Hex Nut	M8	022	Setscrew	M6 x 16
006	Setscrew	M8 x 35	023	Retain Ring	STW-20
007	Adjust Block		024	Fixed Shaft	
008	Clamp Element		025	Crosscut Table	2.6m, 3.2m
009	Countersink Head Screw	M8 x 12		Crosscut Table	1.9m
010	Screw		026	Handle	
011	Setscrew	M6 x 10	027	Roller	M8 x 15
012	Fixed Sheet		028	Button Head Screw	M8 x 16
013	Avert Friction Sheet	2.6m, 3.2m	029	Lock Washer	Φ8
	Avert Friction Sheet	1.9m	030	Knob Bolt	3/8" - 16
014	Fixed Board		031	Cap Screw	M8 x 16
015	Lock Washer	Φ6	032	Fixed Block	
016	Hex Head Bolt	M6 x 16	033	Retain Insert	
017	Countersink Head Screw	M10 x 25			



EXTENSION TABLE PARTS DIAGRAM

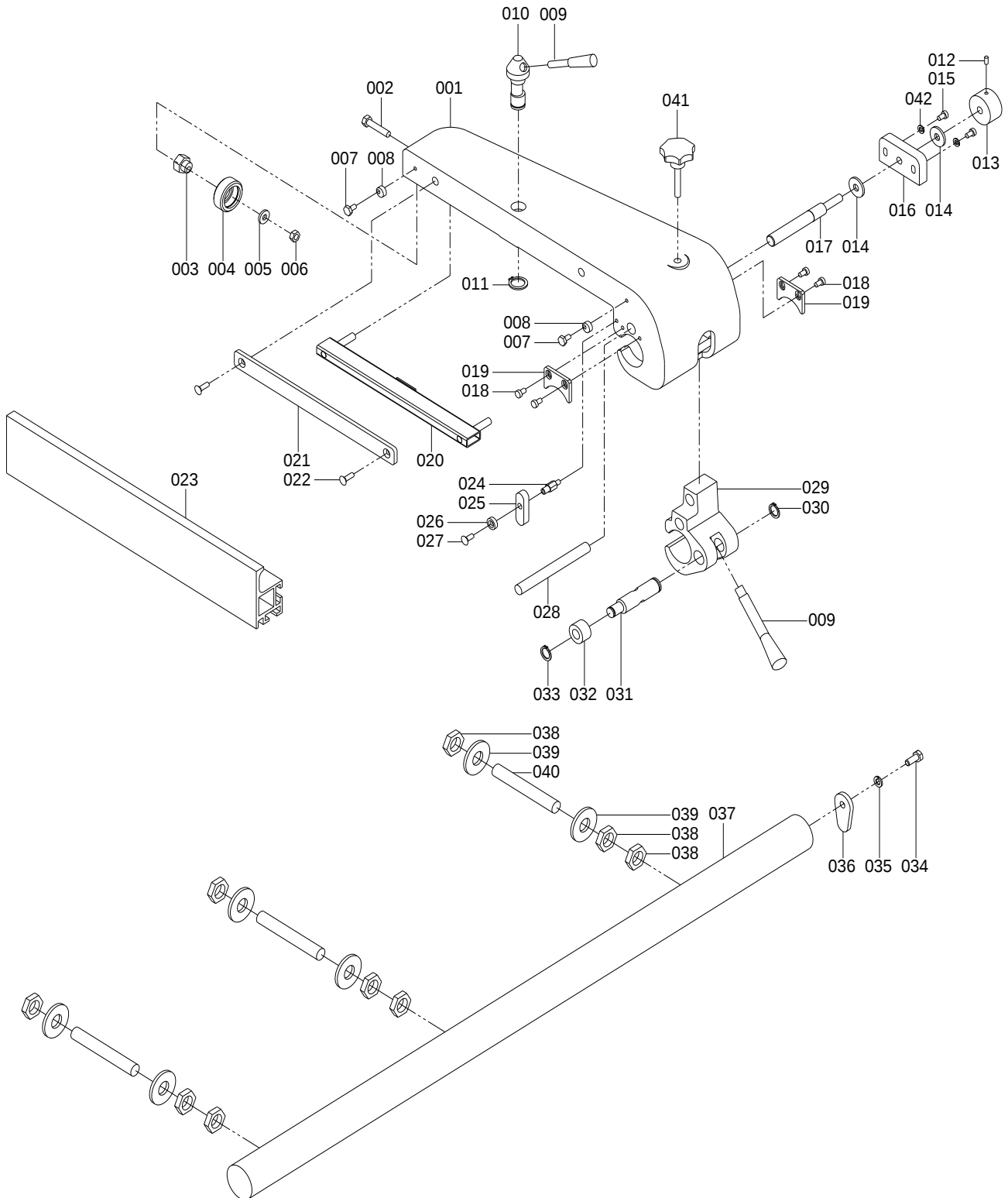


Extension Table Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Table Extension	Normal	011	Washer	Φ6
	Table Extension	CE	012	Support Rack	1m
002	Hex Nut	M12		Support Rack	1.3, 1.5m
003	Hex Head Bolt		013	Hex Nut	M16
004	Hex Head Bolt	M8 x 20	014	Washer	Φ12
005	Washer	Φ8	015	Square Pipe Plug	40 x 80 x 3t
006	Washer	Φ8	016	Setscrew	M16 x 35
007	Washer		017	Width Extension	1m
008	Lock Washer	Φ5		Width Extension	1.3m
009	Cap Screw	M5 x 25		Width Extension	1.5m
010	Hex Head Bolt	M6 x 20			



RIP FENCE PARTS DIAGRAM





Rip Fence Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Fixed Base		023	Rip Fence	
002	Hex Head Bolt	M8 x 40	024	Screw	
003	Adjust Block		025	Guide Key	
004	Slide Wheel		026	Fixed Ring	
005	Washer	Φ8	027	Countersink Head Screw	M5 x 12
006	Lock Washer	M8	028	Slide Rail	
007	Hex Head Bolt	M6 x 16	029	Slide base	
008	Guide Wheel		030	Retain Ring	STW-18
009	Handle	1162-M12-125	031	Fixed Shaft	
010	Fixed Shaft		032	Lockring	
011	Retain Ring	STW-20	033	Retain Ring	STW-14
012	Setscrew	M5 x 10	034	Hex Head Bolt	M8 x 16
013	Control Knob	7021-40-B12	035	Lock Washer	Φ8
014	Washer		036	Stop Block	
015	Cap Screw	M6 x 20	037	Slide Rail	1m
016	Fixed Base			Slide Rail	1.3m
017	Adjust Shaft			Slide Rail	1.5m
018	Button Head Screw	M6 x 16	038	Hex Nut	M16
019	Dust Scraper		039	Washer	Φ16
020	Lashing Bar		040	Setscrew	M16 x 130
021	Lashing Plate		041	Knob	HS50AM1030
022	Countersink Head Screw	M6 x 12	042	Lock Washer	Φ6



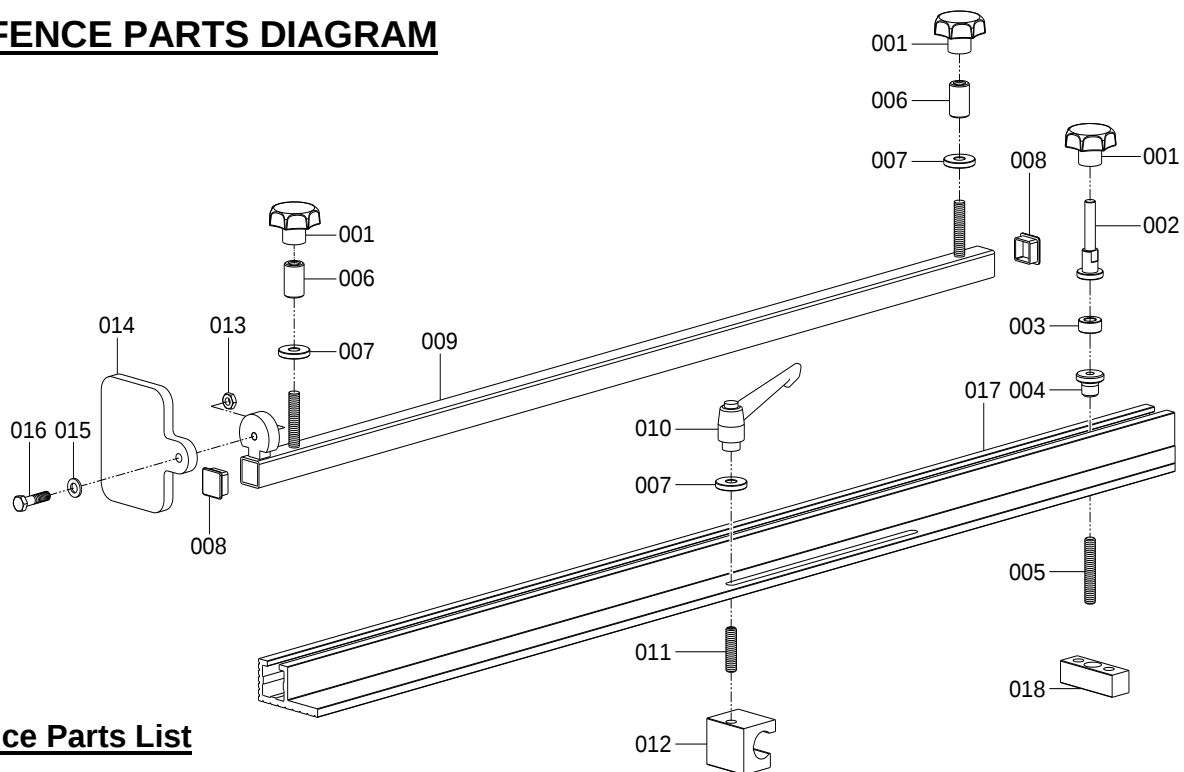


Crosscut Fence Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Spring		030	Wooden Screw	1/8" x 3/8"L
002	Locking Slide Block		031	Left Cover Plate	
003	Locking Bush		032	Scale	2.6,3.2m (inch)
004	Star-Shaped Knob	HS50AM8		Scale	2.6,3.2m (inch)
005	Positioning Pipe	2.6m, 3.2m		Scale	1.9m (inch)
	Positioning Pipe	1.9m		Scale	1.9m (inch)
006	Cap Screw	M8 x 90		Scale	2.6,3.2m (mm)
007	Locking Block			Scale	2.6,3.2m (mm)
008	Countersink Head Screw	M4 x 4		Scale	1.9m (mm)
009	Magnifier			Scale	1.9m (mm)
010	Hole Plug	HP-09	033	Positioning Pin	
011	Cap Screw	M8 x 16	034	Scale Base	
012	Setscrew		035	Fixing Sheet	
013	Fence Scale Base	2.6m, 3.2m	036	Bush	MB1625
	Fence Scale Base	1.9m	037	Adjust Block	
014	Front Positioning Pin		038	Positioning Plate	
015	Cap Screw	M6 x 16	039	Setscrew	M6 x 6
016	Retainer For Shaft	STW-8	040	Rotary Shaft	
017	Tightening Ring		041	Magnifier	
018	Tightening Base		042	Locking Base	
019	Cap Screw	M6 x 16	043	Washer	
020	Rotary Fastening Base		044	Lengthening Scale Block	
021	Handle	7108-M10-100	045	Screw	1/8" x 3/4"L
023	Embossing Screw		046	Lock Washer	Φ8
024	Packing-Up Block		047	Washer	Φ8
025	Draw Nail	4-2	048	Lock Washer	Φ6
026	Rear Positioning Pin		049	Hex Nut	M6
027	Cap Screw	M6 x 20	050	Washer	Φ4
028	Butterfly-Shaped Plate		051	Cap Screw	M8 x 20
029	Hex Head Bolt	M6 x 12	052	Hex Nut	M8



MITER FENCE PARTS DIAGRAM

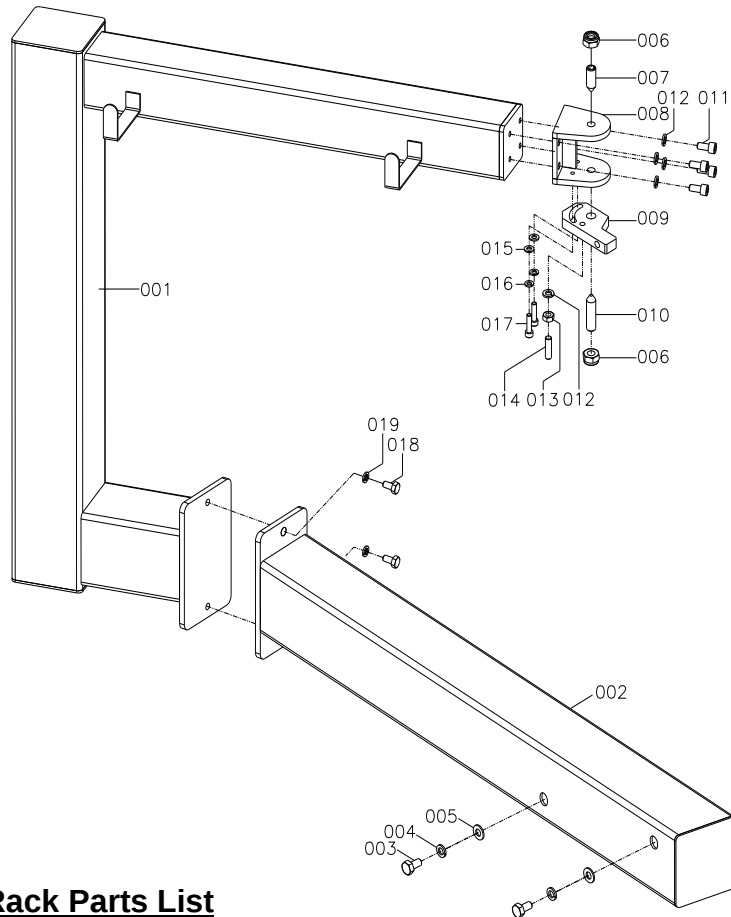


Miter Fence Parts List

Item	Description	Specification
001	Star-Shaped Knob	1083-810-M10
002	Setscrew	
003	Positioning Ring	
004	Gap Ring	
005	Setscrew	M10 x 60
006	Locking Bushing	
007	Washer	
008	Square Insert	
009	Displacement Pipe	
010	Adjust Handle	DA7012-A10
011	Setscrew	M10 x 40
012	C-Fastening Block	
013	Lock Nut	M8
014	Damper	
015	Washer	Φ8
016	Hex Head Bolt	M8 x 35
017	45° Fence	



DUST-COLLECTING FASTENING RACK PARTS DIAGRAM

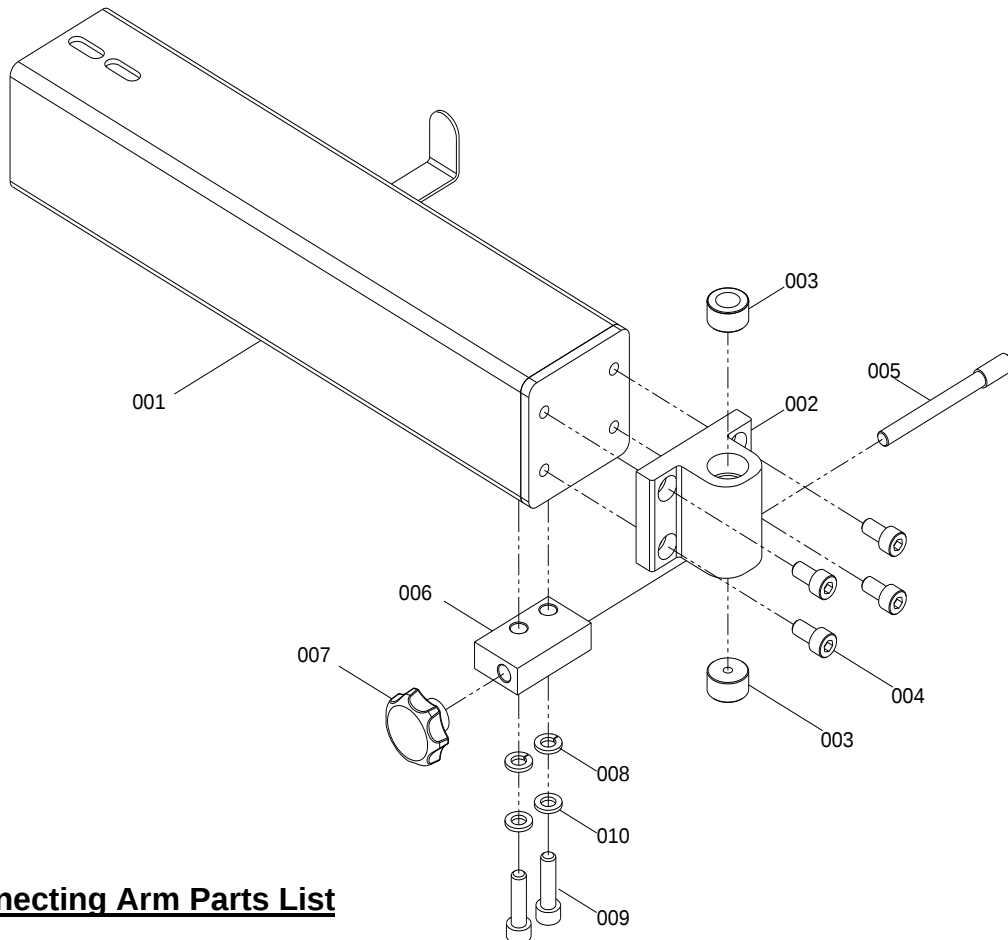


Dust-Collecting Fastening Rack Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Fixed Stand		008	Fasten Base	
	Fixed Stand(400type)		009	Adjust Block	
002	Fixed Base	1m	010	Setscrew	
	Fixed Base	1.3m	011	Cap Screw	M8 x 16
	Fixed Base	1.5m	012	Lock Washer	Φ8
	Fixed Base(400type)	1m	013	Hex Nut	M8
	Fixed Base(400type)	1.3m	014	Setscrew	M8 x 25
	Fixed Base(400type)	1.5m	015	Washer	Φ6
003	Hex Head Bolt	M16 x 130	016	Lock Washer	Φ6
004	Lock Washer	Φ16	017	Cap Screw	M6 x 25
005	Washer		018	Cap Screw	M10 x 25
006	Lock Nut	M12	019	Lock Washer	Φ10
007	Setscrew				



SAFETY GUARD CONNECTING ARM PARTS DIAGRAM

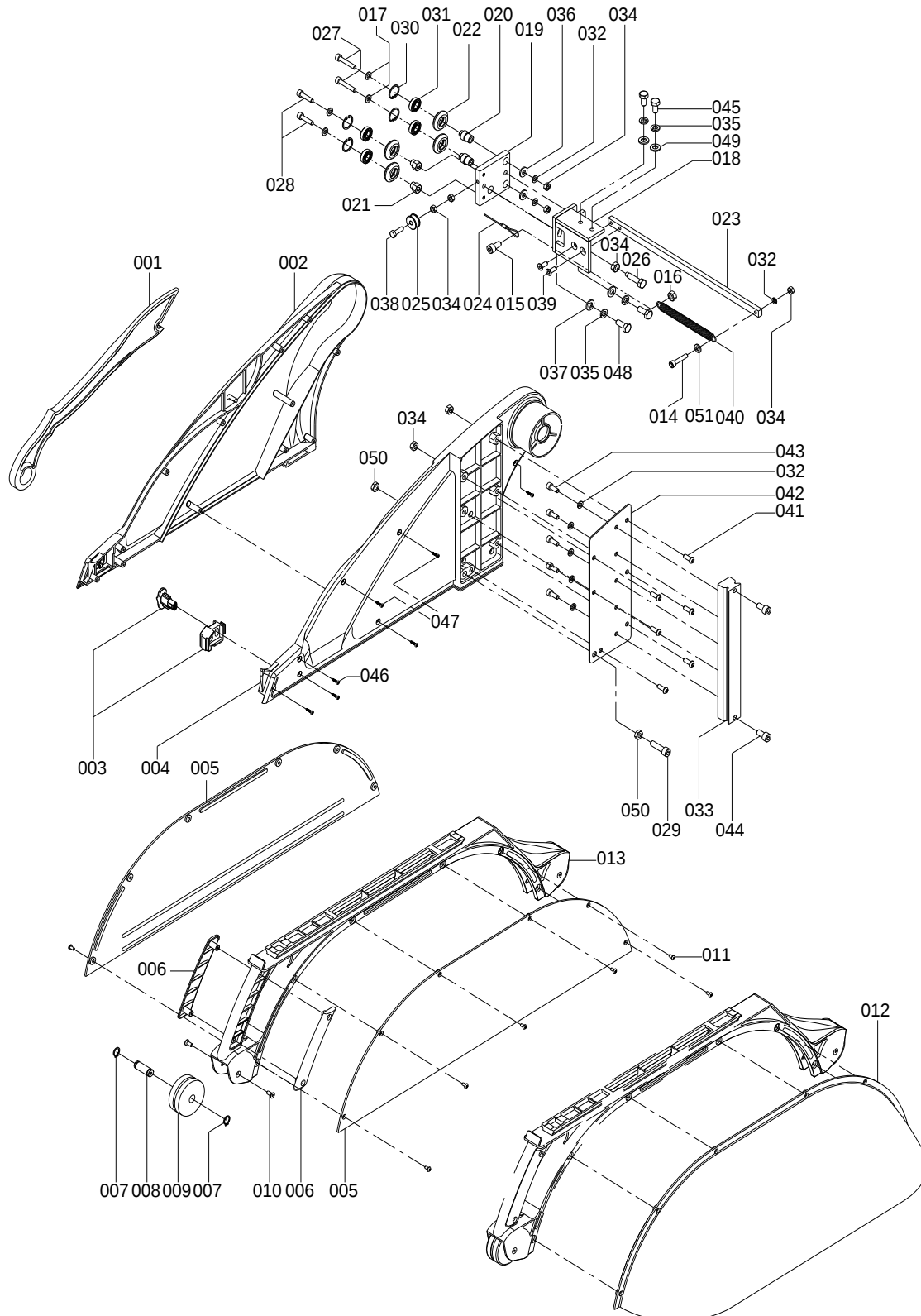


Safety Guard Connecting Arm Parts List

Item	Description	Specs.
001	Rotary Arm	1m
	Rotary Arm	1.3m
	Rotary Arm	1.5m
002	Connect Block	
003	Bush	
004	Cap Screw	M8 x 16
005	Lock Shaft	
006	Fixed Block	
007	Knob	7083.710-M8
008	Lock Washer	Φ8
009	Cap Screw	M8 x 30
010	Washer	Φ8



DELUX SAW GUARD PARTS DIAGRAM





Delux Saw Guard Parts List

Item	Description	Specs.	Item	Description	Specs.
001	Push Stick		027	Cap Screw	M6 x 35
002	Left Safety Guard		028	Cap Screw	M6 x 25
003	Open/Lock Button		029	Cap Screw	M8 x 40
004	Right Safety Guard		030	Retain Ring	Φ22
005	Chip Guard Cover		031	Ball Bearing	6900
006	Grip Cover		032	Lock Washer	Φ6
007	Retain Ring	Φ12	033	Slide Wheel	
008	Pin		034	Hex Nut	M6
009	Slide Wheel		035	Lock Washer	Φ8
010	Countersink Head Screw	M5 x 12	036	Washer	Φ6 x Φ16
011	Button Head Screw	M4 x 8	037	Washer	Φ8 x Φ23
012	Chip Guard Cover		038	Button Head Screw	M6 x 30
013	Grip Cover Base		039	Countersink Head Screw	M6 x 12
014	Cap Screw	M6 x 30	040	Spring	
015	Cap Screw	M6 x 12	041	Button Head Screw	M6 x 20
016	Lock Nut	M6	042	Join Block	
017	Washer		043	Cap Screw	M6 x 12
018	Fixed Base		044	Cap Screw	M8 x 16
019	Fixed Block		045	Hex Head Bolt	M8 x 20
020	Fixed Shaft		046	Phillips Head Screw	1/8" x 3/4"L
021	Adjust Shaft		047	Phillips Head Screw	1/8" x 5/8"L
022	Slide Wheel		048	Hex Head Bolt	M8 x 16
023	Spring Fixed Bar		049	Washer	Φ8 x Φ23 x 3t
024	Wire Rope		050	Hex Nut	M8
025	Slide Wheel		051	Washer	Φ6 x Φ13
026	Setscrew				



NOTES

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