

Instruction Manual

Sliding Panel Saw

Model No.: CPS1600(MJ12-1600II); CPS2800(/2800 II)



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SPECIFICATIONS

Model	CPS1600 (MJ12-1600II)			CPS2800 MJ12-2800 II	
Motor power	220V~,60HZ,3000W			220V~,60HZ,3000W	
Major table size	385×800mm			385×800mm	
Extension table (Cast iron)	440×800mm			440×800mm	
Extension table (Steel plate)	440×800mm			440×800mm	
Rear extension table	310×500mm			310×500mm	
Sliding panel size	1600×270mm			2800×270mm	
Cross cut table size	680×580mm			680×580mm	
Cross cut fence	1200-2200mm			1200-2200mm	
Main blade size	315×30×3mm			315×30×3mm	
Main blade speed	5500rpm			5500rpm	
Scoring blade size	90x20x3 mm			90x20x3mm	
Scoring blade speed	9900rpm			9900rpm	
Max cut depth	100 mm @ 90° (315) 75 mm @ 90° (254) 80 mm @ 45° (315) 60 mm @ 45° (254)				
Max distance-blade to rip fence	1220mm			1220mm	
Max cross cut length	1600mm			2800mm	
Max cross cut width	1350mm			1350mm	
Packing size	936×756×1040mm 1640×240×310mm			1580×756×1009mm 2850×246×325mm	
Weight(N.W./G.W.)	265/305kg			305/345kg	
Noise level (Unload)	85 dB(A)			85 dB(A)	

SAFETY



For Your Own Safety, Read Instruction Manual Before Operating this Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

This symbol is used to alert the user to useful information about proper operation of the equipment.

Safety Instructions for Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.**
Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT. DO NOT** use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL. DO NOT** force tool or attachment to do a job for which it was not designed.
9. **USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size

should be in accordance with amperage rating. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire. Always repair or replace extension cords if they become damaged.

10. **WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are **NOT** safety glasses.
12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
13. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **USE RECOMMENDED ACCESSORIES.** Consult the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.
17. **MANY WOODWORKING TOOLS CAN "KICKBACK" THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create "kickback" and know how to avoid them. Read the manual accompanying the machine thoroughly.
18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. DO NOT** leave tool until it comes to a complete stop.
20. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.
21. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

Additional Safety Instructions for Panel Saws

1. **SAFETY ACCESSORIES.** Always use the blade guard and riving knife on all "through-sawing" operations. Through-sawing operations are those when the blade cuts completely through the work-piece.
2. **KICKBACK.** Be familiar with kickback. Kickback happens when the work-piece is thrown towards the operator at a high rate of speed. Until you have a clear understanding of kickback and how it occurs, DO NOT operate this table saw!
3. **WORKPIECE CONTROL.** Make sure the work-piece is placed in a stable position on the table and is either supported by the rip fence or the crosscut table during cutting operations.
4. **PUSH STICK.** Always use a push stick when ripping narrow stock.
5. **OPERATOR POSITION.** Never stand or have any part of your body directly in-line with the cutting path of the saw blade.
6. **REACHING OVER SAW BLADE.** Never reach behind or over the blade with either hand while the saw is running. If kickback occurs while reaching over the blade, hands or arms could be pulled into the spinning saw blade.
7. **USING THE RIP FENCE AND THE CROSSCUT FENCE TOGETHER DURING A CUTTING OPERATION.** When using the crosscut fence, the work-piece should never be contacting the rip fence while the saw blade is cutting.
8. **STALLED BLADE.** Turn the saw off before attempting to "free" a stalled saw blade.
9. **COMFORTABLE CUTTING OPERATIONS.** Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the spinning saw blade.
10. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact your agent.
11. **BLADE HEIGHT.** Always adjust the blade to the proper height above the work-piece.
12. **DAMAGED SAW BLADES.** Never use blades that have been dropped or otherwise damaged.
13. **RIVING KNIFE ALIGNMENT.** Only operate the saw if the riving knife is aligned with the main blade.

Like all machines there is danger associated with this Sliding Panel Saw. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



Statistics prove that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward its operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Preventing Kickback

Never attempt freehand cuts. If the work-piece is not fed perfectly parallel with the blade, a kickback will likely occur. Always use the rip fence or crosscut fence to support the work-piece.

Make sure the riving knife is always aligned with the blade. A misaligned riving knife can cause the work-piece to bind or stop the flow of the cut, resulting in an increased chance of kickback. If you think that your riving knife is not aligned with the blade, check it immediately!

Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table.

Use the riving knife during every cut. The riving knife helps maintain the kerf in the work-piece after it is cut, therefore, reducing the chance of kickback.

Feed cuts through to completion. Anytime you stop feeding a work-piece that is in the middle of a cut, the chance of binding, resulting in kickback, is greatly increased.

Protecting Yourself from Kickback

Even if you know how to prevent kickback, it may still happen. Here are some tips to reduce the likelihood of injury if kickback DOES occur:

Stand to the side of the blade during every cut. If a kickback does occur, the thrown Work-piece usually travels directly in front of the blade.

Always wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.

Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade.

Use a push stick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.

SITE CONSIDERATIONS

General Condition:

- 1 .Electrical connection: Steady state voltage: 0.9-1.1 of nominal voltage.
Frequency: 0.99-1.01 of nominal frequency continuously; 0.98-1.02 short time

The mains connection must have maximum 16A fuse.

Electrical supply which has protection devices of under-voltage, over-voltage, over-current as well as a residual current device (RCD) which maximum residual current rated at 0.03A.

- 2 . Altitude are not exceeding 1000m,

Maximum ambient air temperature is +40 °C,

minimum ambient air temperature is not less than
storage and transportation temperature
+5 °C,
range is -25 °C~+55 °C.

The relative humidity does not exceed 50% at a maximum temperature of +40 °C, higher relative humidity may be permitted at lower temperature

(e. g. 90% @ 20 °C).

Floor Load

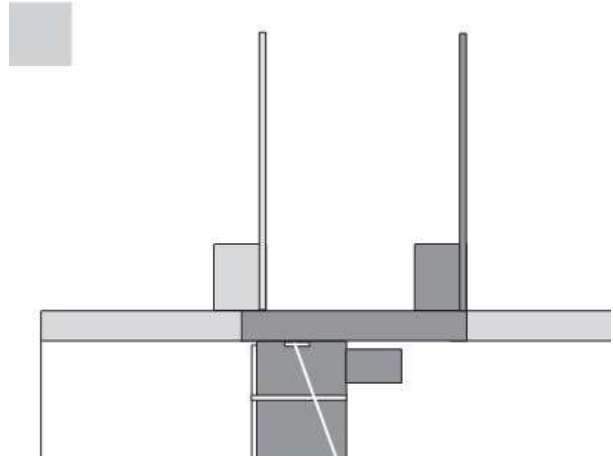
This machine represents a moderately large weight load in a small footprint. Most commercial shop floors will be adequate for the weight of the machine. Some floors may require additional support. Contact an architect or structural engineer if you have any question about the ability of your floor to handle the weight.

To ensure sufficient upright stability of the machine it should be bolted to floor. For this purpose 4 holes are provided in the machine's bracket of workstand.

Working Clearances

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See above figure for the maximum working clearances of the Sliding Panel Saw.



Lighting and Outlets

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets, or circuits.

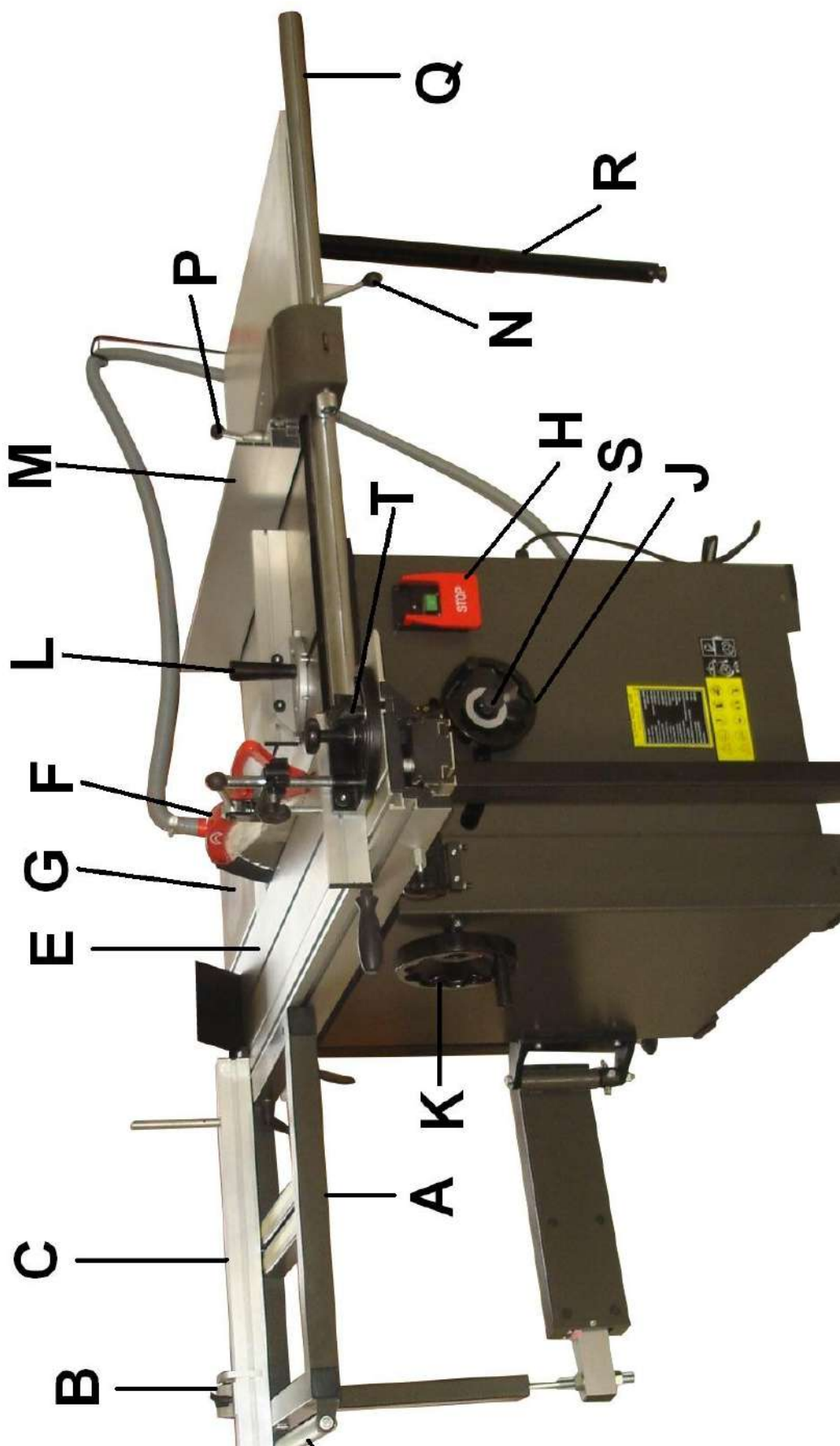
Dust Collector

As a rule, this machine must be vacuumed during use. A time relayed socket is available as an accessory. In addition, the vacuum performance must be sufficient to achieve the required negative pressures and a maximum air speed of 20m/sec at the connector.



Read the manual before assembly and operation.

Become familiar with the machine and it's operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.



A. Crosscut Table-Provides a wide, stable platform for supporting full-size panels during crosscutting operations.

B. Flip Stops-Used for quick measurements for crosscutting.

C. Crosscut Fence-Used during crosscutting operations. Features a scale and multiple flip-style stopblocks for precise, repeatable crosscutting operations.

D. Roller-Used for supporting full-size panels during crosscutting operations.

E. Sliding Panel-Conveniently glides the work-piece through the blade with effortless precision and ease.

F. Blade Guard-Fully-adjustable blade guard allows high visibility of the cutting operation while maintaining maximum protection around the saw blade.

G. Rear extension table

H. Power Switch-Start/stops the machine and has emergency stop function.

J. Blade Elevation Hand-wheel-Adjust the height of the main saw blade.

K. Blade Angle Hand-wheel-Adjust the angle of the saw blades.

L. Mitre Gauge-This gauge aligns the wood for a cross-cut.

M. Rip Fence-Fully adjustable with fine adjustments. Fence face can be positioned for standard cutting operations, or in the lower position for blade guard clearance during narrow ripping operations.

N. Fence Assembly Lock Down lever-Secures the fence assembly into position along the fence rail.

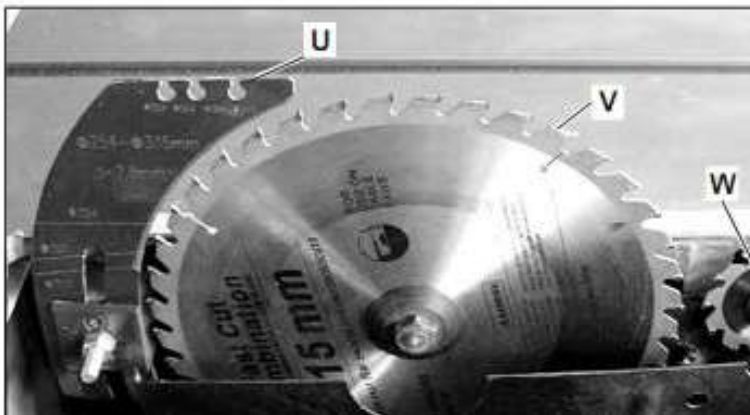
P. Fine-Adjust Knob-Precisely adjusts the fence.

Q. Rip Fence Rail-Provides the support for rip fence.

R. Support Leg-Provides the support for the extension table.

S. Main Blade Angle Lock Knob-Secures the angle of main blade.

T. Hold Down w/Mitre Gauge-Holds the work-piece for sliding or mitre cutting.



U. Riving Knife-Maintains kerf during cutting operations. This function is crucial to preventing kickback caused by the kerf closing behind the blade.

V. Main Blade-Performs the cutting operations.

W. Scoring Blade-Small cutting blade that rotates opposite the main saw blade. The blade scores the workpiece before the actual cutting operation is performed; thus, preventing tear-out in laminate materials. The scoring blade is adjustable forward and backward, up and down, and in thickness of kerf.

1. Scoring Blade Alignment Screw-Adjusts the lateral movement of the scoring blade.

2. Scoring Blade Lock Screw-Locks the scoring blade after adjusted.

3. Scoring Blade Elevation Screw-Adjusts the height of the scoring blade.

UNPACKING

The Sliding Panel Saw is shipped from the manufacturer in a carefully packed crate. If you discover the machine is damaged after you have signed for delivery, please call Customer Service immediately for advice. When you are completely satisfied with the condition of your shipment, you should inventory its parts.



The Sliding Panel Saw is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine you will need assistance and power equipment. Serious personal injury may occur if safe moving methods are not followed.

Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

Piece Inventory

After all the parts have been removed from the carton, you should have:

Main crate

- Main saw unit
- Cast iron extension table
- Steel plate extension table w/support leg
- Rear extension table w/support
- Swing arm assembly (inside main saw unit)
- Cross cut table
- Roller, cross cut
- Blade guard
- 2-1/2" dust hose
- Dust port
- Mitre gauge
- Hand wheels (2)
- Hardwares
- Tools
 - 13-15 mm open head wrench
 - Arbor wrench
 - Arbor pin
 - 3, 4, 5, 6 mm "L" wrench
- Push stick
- (Some parts are inside the main saw unit)
- Edge shoe

Rail crate

- Rip fence
- Rip fence rail
- Rear support rail
- Sliding table
- Sliding table carrier
- Support leg, sliding carrier
- Cross cut fence
- Hold down w/fence
- Flip stop

Clean Up

The unpainted surfaces are coated with a light oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser. To clean thoroughly, some parts may need to be removed. For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.



Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used.



Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

ASSEMBLY

Moving & Placing Saw Base Unit



Warni

The Sliding Panel Saw is a heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.



Warni

Use lifting straps with a minimum of 500 kgs lifting capacity. If the lifting strap breaks, serious personal injury may occur.

1. Remove the top of crate and position the forklift forks together and directly above the saw.
2. Place four lift rings onto Saw Base Unit and place two lifting straps over the forks and attach the lifting rings.
3. Insert a wood block for protecting the main switch.
4. Lift the saw base unit and move it to your predetermined location.
5. Before lowering the saw into position, place four rubber blocks under the frame.
6. Lower the saw on the floor.

Install the extension table

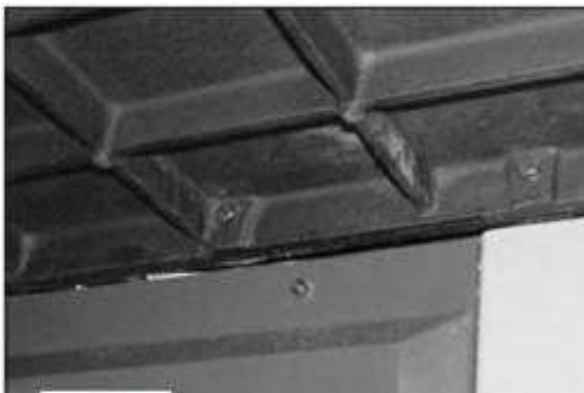
Take out the cast iron extension table, steel plate extension table and rear extension table from the Saw Base Unite crate.



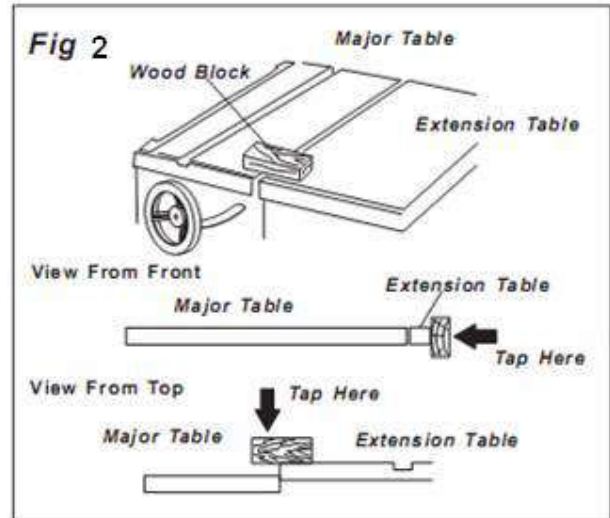
Warni

The cast iron extension table is heavy part that weighs over 35 kgs. To be safer, you will need assistance.

1. Attach the Cast iron extension table to major table with 4-M8x20 hex head screws/ washers.



2. Center the extension table over the edges and tap it. Check the surface alignment.



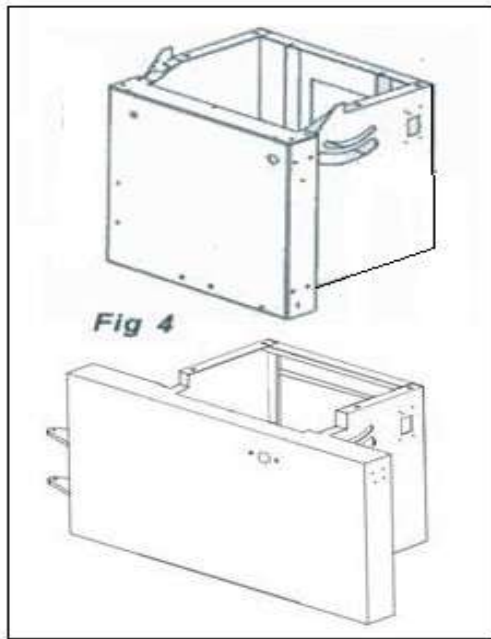
3. Tighten 4-screws with 13 mm open head wrench.

Attach the steel plate extension table to cast iron extension table, Aligned and tighten them as "install the cast iron extension table".



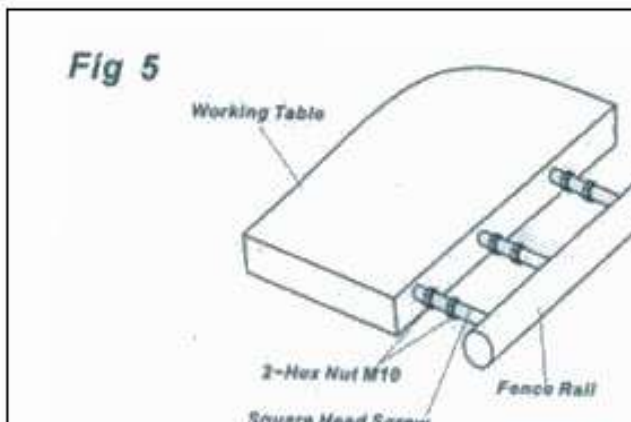
Install the sub-support (model MJ2600-MJ3200)

1. Attach the front sub-support to saw base unit and Tight it with 4-M 10x25 allen screws w/spring washers.
2. Attach the front sub-support to main saw base on Same way.
3. Align the front sub-support. Rear sub-support and the Main saw base on the same level.



Install the rip fence rail

1. insert 4-M10x80 hex head bolts into major table and extension tables. Loosely attach 2-M10 hex nuts to each bolt.
2. Screw the four bolts into rip fence rail, just 4-5 circles.
3. First tighten two bolts to align the rail parallel With the table.
4. Then tighten another two bolts.



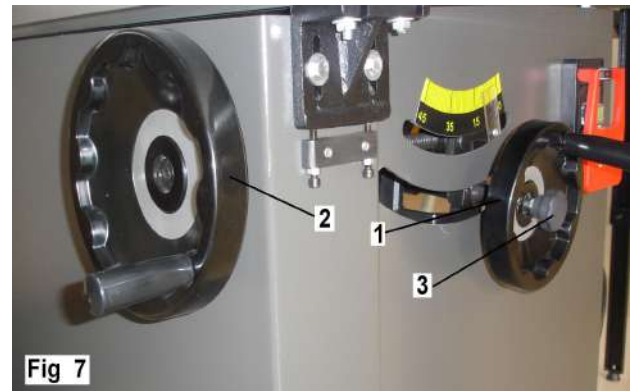
Install the rear extension table

1. Attach the rear extension table to the rear portion of major table with 2-M8x16 hex head screws washers, hex nuts.
2. Place the bracket onto rear panel of saw base unit with a M8x16 hex head screw, another end of bracket mounted to rear extension table with a M8x16 hex head screw.
3. Align the rear extension 0.5mm lower than the major table.



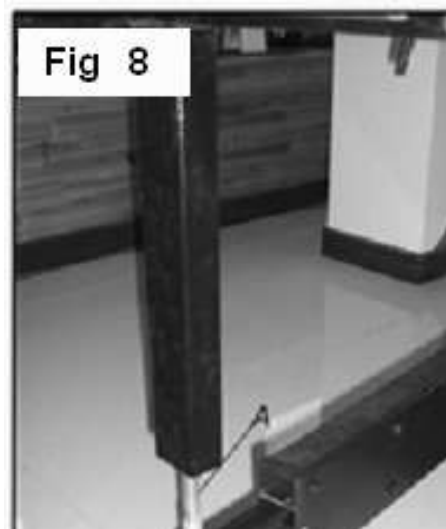
Install the main blade elevation & angle handwheel

1. Fitting the elevation handwheel(1) and angle handwheel (2) onto the elevation and angle shaft.
2. Screw the blade lock knob(3) onto the elevation Handwheel.



Install the swing arm assembly

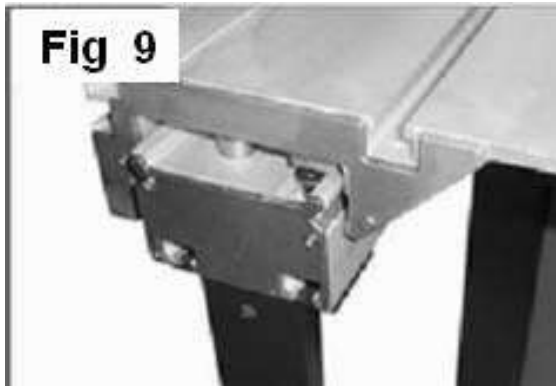
1. Place 4 M8x30 hex head screws to mount the swing arm assembly to the saw base unit, and keep the arm on horizontal level.



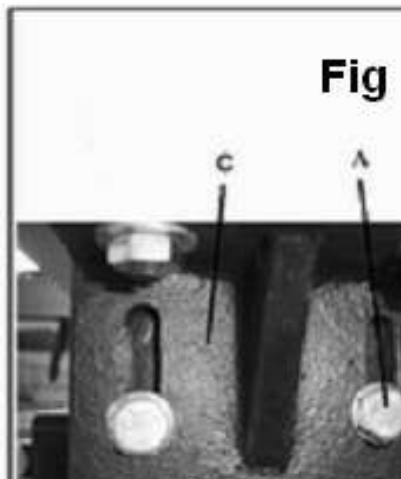
- 2 .Place the cross-cut table support (A) onto the swing arm assembly, and hand tighten the lock nuts. The support needs further adjustment.

Install the Sliding panel assembly

- 1 .Place 2 sets of star-type screws (include 8mm washer, insert, screw guide) into the lower slot of sliding panel carrier (see above 14).



- 2.Put the sliding panel assembly onto the sliding panel supports, and lay two star-type screws as fig 15 show.



- 3.Tighten two star-type screws.



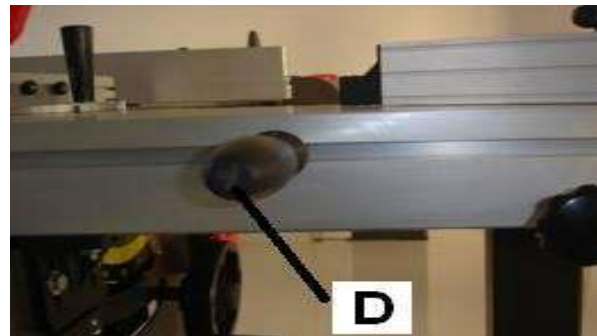
4. Install the support leg to the sliding carrier.

Adjust the sliding panel level:

- 1 .Place a level rule (cross cut fence) on to major table and sliding panel.
- 2.Loosen 4-M8x25 hex screws(A) , adjust the M8x40 hex screw(B) to adjust the sliding panel level(fig 13).
- 3.Then re-tighten 4-M8x25 hex screws (A).
- 4.To fine adjust, using 3 mm "L" wrench to adjust 4-M8x12 set screws(C).

Install the push handle and lock pin

- 1 . Sliding the M12x1.75 T-nut into the sliding panel and thread in push handle(D) with a 17 mm open end wrench.
2. Insert the star-type lock pin (E) into sliding panel, and lock the M10 hex nut on the opposite side.



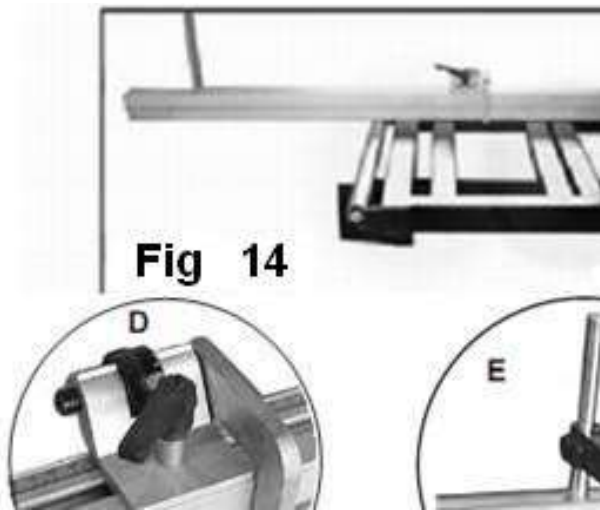
Install the cross cut table

- 1.Slide two M8x70 carriage bolts with T-lblocks into the side slot of sliding panel. Attached the crosscut table to sliding panel.
- 2.Use 2 wing nuts mounted the cross cut table to sliding panel.
- 3 .Use 2 M6x30 Hex head screws mounted the cross cut table to support (B).
- 4 .Adjust 4-M12 thin hex nut (C) to adjust the cross cut table on the line with sliding panel.
- 5.Then tighten 4-M12 thin nut (C).



Install the cross cut fence

- 1.Drop the cross cut fence into the forward or rear guide pin hole.
- 2.Tighten the knurled nut.
- 3.Turn the "Z" lock plate to quick aligning the fence to table.
- 4.Turn the star type screw and clamped the fence in position.
- 5.Slide the flip stop(D) into the fence.
- 6.Place a T-nut into the top slot of fence, thread the stud of hold-down on fence.
- 7.If need, put the hold down arm onto the stud (E).



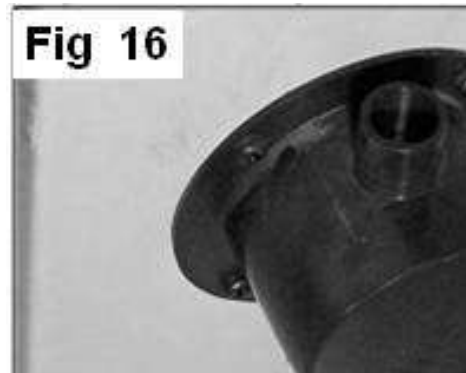
Install the hold down/Mitre Gauge

1. Slide the hold down/Mitre Gauge onto the sliding table and push it as far as possible. And lock the hold down/mitre gauge on table with the star-type lock handle (A) locked.
2. Aligned the Mitre Gauge fence on it.



Install the dust port

Place the dust port onto the bottom of rear panel, tighten it with 4 M6x12 pan head screws washers and nuts (nuts inside stand).

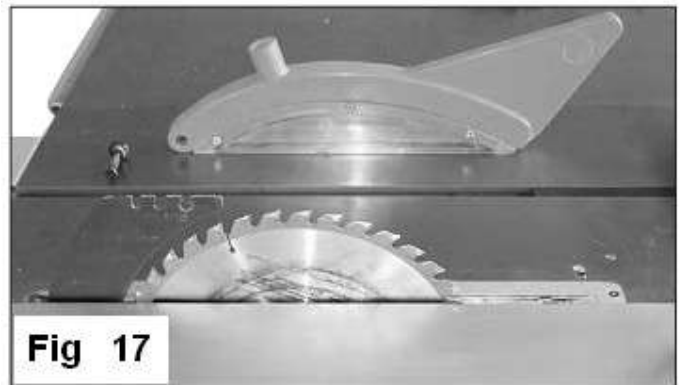


Install the blade guard

The riving knife cuts 3 slot for different blade size.

For PS10 the blade guard mounts to the 254 slot.

For PS12, if using the 254 mm blade place the blade guard onto 254 slot; if using the 305 or 315 mm place the blade onto 315 slot.



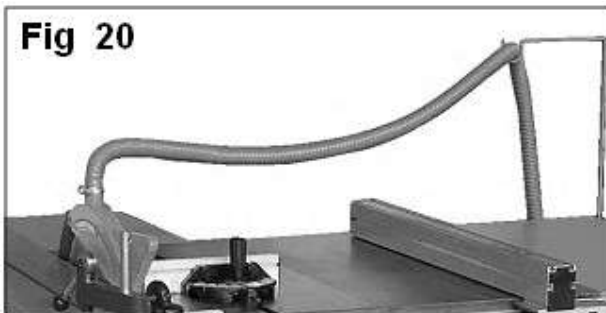
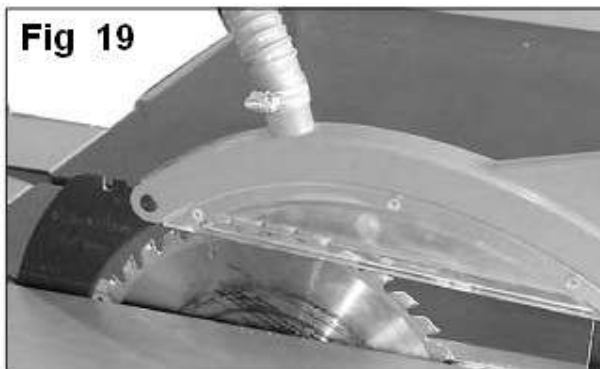
Install the dust hose support

To install the dust hose support onto the rear portion of steel plate extension table with 2 M6x20 hex head screws washers and nuts(nuts under the table).



Install dust hoses

1. Install the 2" dust hose onto the blade guard with 2" hose clamp.
2. Put the 2" dust hose onto dust hose support keep free with the working table.
3. Another end of 2" dust hose clamps to the main dust port on the bottom of rear panel.
4. Install 4" dust hose to main dust port with 4" hose clamp



REPLACEMENT & ADJUSTMENT



Attention!

Replace the main blade



Caution!

Disconnect the saw from the power source!

The main blade dimension suitable for **MJ12B** machine is 254x30x3(outer diameter, core diameter, thickness), 305x30x3, 315x30x3mm.



Attention!

But any time you change blade thickness, the appropriate sized riving knife and scoring blade must also be changed to match the size of main blade you install.

To change main blade:

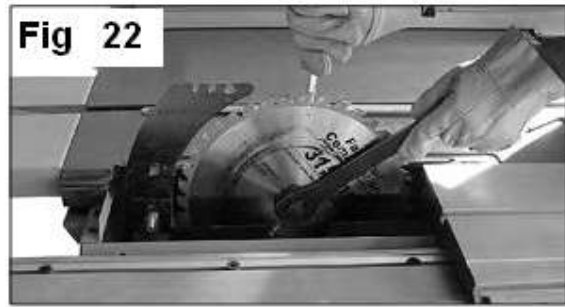
- 1 . Move the blade tilt to 0° (Blade 90° to table) on the control panel and raise the blade as far as it will go.
- 2 . Move the sliding panel all the way to the right and remove two M6x12 pan head screws to expose the internal blade guard that covers the blades and riving knife.
- 3 . Remove the blade guard from the riving knife to expose the mounting assembly.
- 4 . Remove the table insert.
- 5 . Insert the arbor pin into the hole on blade inner flange and locks the blade.
- 6 . Using the arbor wrench, remove the arbor nut that secures the main blade (turn clockwise to loosen).
- 7 . Remove the arbor flange and the old main blade.
- 8 . Install the new main blade, replace the arbor flange and nut, and tighten the arbor nut to secure the main blade.

If you changed blade diameter sizes during this procedure, now is the time to adjust the riving knife. (Just for **MJ12B**)

If the kerf thickness is different from your old blade, the scoring blade kerf and riving knife thickness must match the new main blade kerf.

- 9 . Make sure the correct size riving knife is installed and aligned with the blade.
10. Move the internal blade guard back into its original position, next to the blades, and center the sliding panel.
11. Align the scoring blade to the main blade .

Fig 22



Replace and adjusting the scoring blade



Warning!

Disconnect the saw from the power source!



Caution!

Suitable for machine is 90x20x3(outer diameter, core diameter, thickness) mm **Tapered Scoring Blade**.

To replace scoring blade:

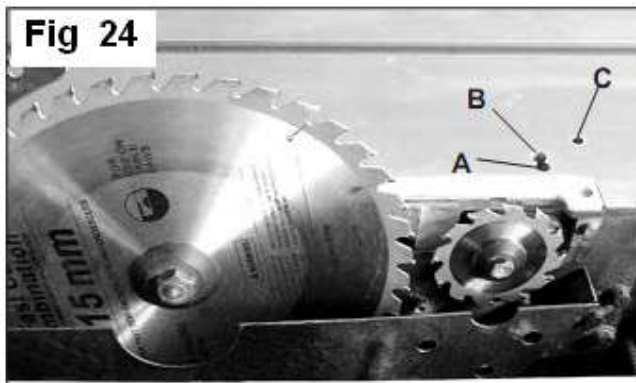
- 1 . Move the blade tilt to 0° (Blade 90° to table) on the control panel and raise the blade as far as it will go.
- 2 . Move the sliding panel all the way to the left and remove two M6x12 pan head screws to expose the internal blade guard that covers the blades and riving knife.
- 3 . Remove the blade guard from the riving knife to expose the mounting assembly.
- 4 . Remove the table insert.
- 5 . Insert the arbor pin into the hole on blade inner flange and locks the blade.
- 6 . Using the arbor wrench, remove the arbor nut that secures the main blade (turn anti-clockwise to loosen).
- 7 . Remove the arbor flange and the old scoring blade.
- 8 . Install the new scoring blade, replace the arbor flange and nut, and tighten the arbor nut to secure the scoring blade.

Fig 23



To align scoring blade:

Loosen the clamping screw (A). Lateral adjustment is made via adjusting screw (B). the height setting is made via setting screw (C). retighten the clamping screw (A). Adjust the scoring blade laterally so it is in line with the main saw-blade.



Replace and adjust the riving knives



Warning!

Disconnect the saw from the power source!

1. Move the blade tilt to 0° (Blade 90° to table) on the control panel and raise the blade as far as it will go.
2. Move the sliding panel all the way to the right and remove two M6x12 pan head screws to expose the internal blade guard that covers the blades and riving knife.
3. Remove the blade guard from the riving knife to expose the mounting assembly.
4. Remove the center bolt in the mounting assembly to remove the mounting plate.
5. Remove the currently installed riving knife and install the correct riving knife.
6. Replace the mounting plate and thread in the center bolt without completely tightening it.



Caution!

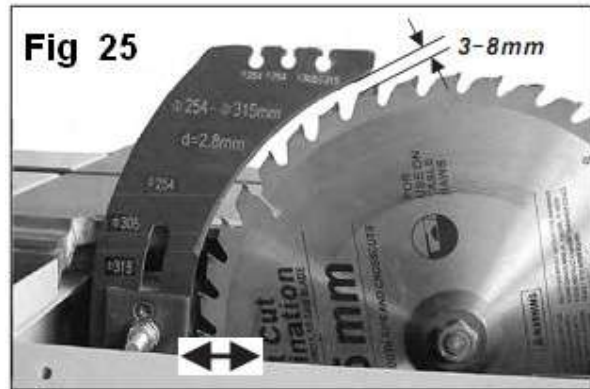
The riving knife is carved with different blade size, just put the carved line under table.

The center carriage bolt is mounted in a horizontal slot, so the riving knife can move far or near the main blade.

7. Position the riving knife about 3mm to 8mm away from the nearest carbide tooth on the main blade.

Note For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife.

8. Tighten the center bolt to secure the riving knife in position.
9. Move the internal blade guard (from step 4) back to its original position, and move the sliding panel back to center.

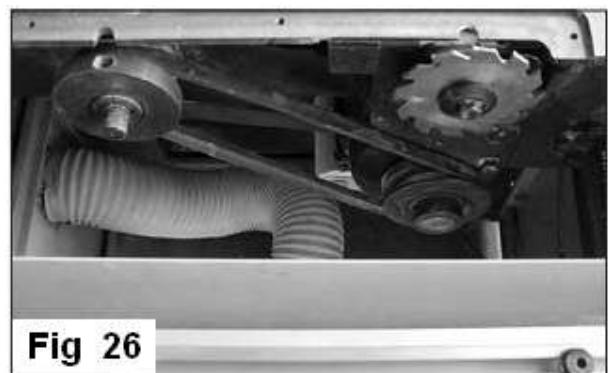


Replace the main belt

Disconnect the saw from the power source!

1. Move the blade tilt to 0° (Blade 90° to table) on the control panel and raise the blade as far as it will go.
2. Move the sliding panel all the way to the left and remove two M6x12 pan head screws to expose the internal blade guard that covers the blades and riving knife.
3. Remove the blade guard from the riving knife to expose the mounting assembly.
4. Remove the main blade.
5. Remove 3 M8x18 Allen screw and remove the chip house.
6. Remove the 4 Allen screws on the top and bottom of left panel, and remove the left panel.
7. Loosen motor amount 4-M8x40 hex head screws(A) and loosen the tension bolt (B).
8. Remove the V-belt.

9. Replace new V-belt, tighten motor bolts and the tension bolt, close the left panel, and re-mount blade inner guard, blade, blade guard.



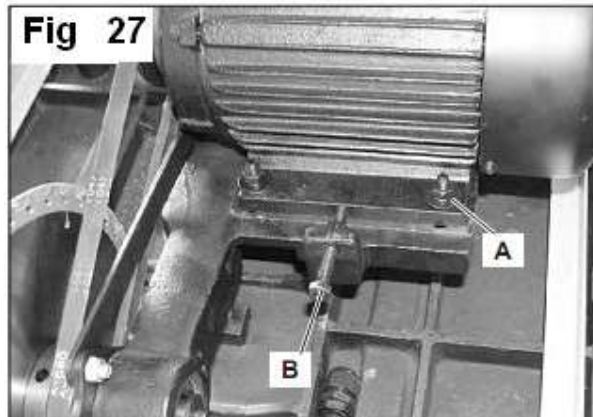


Fig 27

Replace the scoring belt



Warning!

Disconnect the saw from the power source!

1. Move the blade tilt to 0° (Blade 90° to table) on the control panel and lower the blade as far as it will go.
2. Remove the 4 Allen screws on the top and bottom of right panel, and remove the left panel.
3. Push the tension pulley as far as it will go as arrow show.
4. Remove the old belt and replace new belt.
5. Re-mount the right panel.

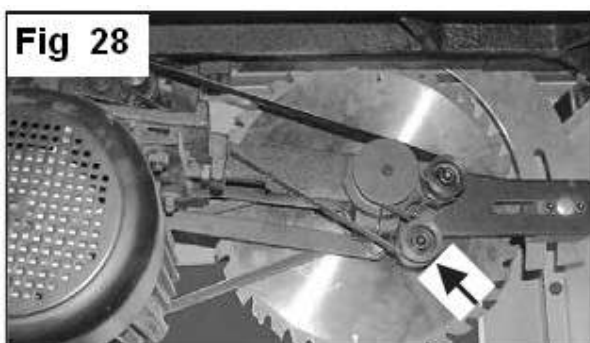


Fig 28

Sliding Panel Parallel Adjustment



Warning!

Disconnect the saw from the power source!

Now is the point in the assembly process to make the sliding panel parallel with the main saw blade and secure the sliding panel to the saw base.

Besides the tools included with the saw, this procedure requires you to have a precision ruler, a felt tip pen, and the assistance of another person.

To adjust the sliding panel parallel with the main blade:

1. Set the blade to 0° on the control panel (90° with the cast iron table).

2. Raise the main blade up as far as it will go.

3. Mark the center of the blade with a felt tip pen. This will allow you to take your measurements from the exact same place on the blade.

4. Move the sliding panel all the way to one end, and using a precision ruler, measure the gap between the edge of the panel and your mark on the blade as shown in Fig 29.

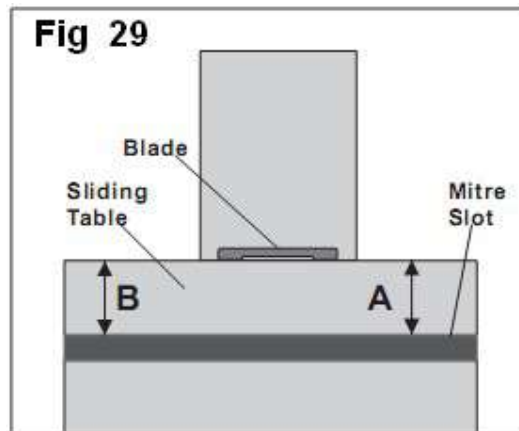


Fig 29

5. Move the other end of the sliding panel in front of the blade and measure the gap.

If the gap is the same on both sides, then the sliding panel is already parallel with the main blade.

If the gap on one side is different than the other, then continue with **step6**.

6. Move the end of the sliding panel that needs to be adjusted in front of the blade.

7. Loosen the two hex head screws (C) and light tap the sliding carrier support to adjust the gap.

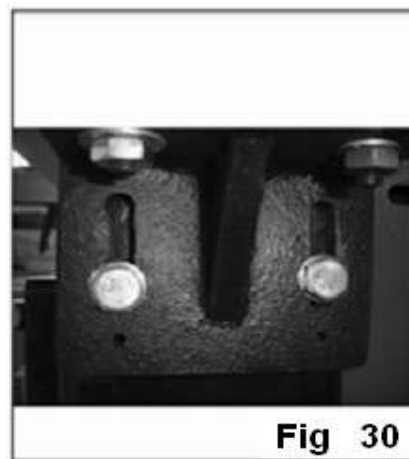


Fig 30

8. Repeat **steps 7** until the gap between your mark on the blade and the edge of the sliding panel is even at both ends.

9. Tighten the four hex head screws (C) and secure supports in place

10. Now tighten the two star-type screws that secure the sliding panel to the base.

OPERATIONS



Your safety is important. To preventing work-piece kick-back, slide the edge shoe into sliding panel when needed.
The edge shoe can slide into the front or rear portion of sliding panel.

Rip Cutting

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



This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw. Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.



Determine which cutting operation will be best suited for the workpiece to be ripped.

To use the sliding table, read the instructions titled "Rip cutting with the sliding panel."

To use the machine as a traditional table saw, skip ahead to "Rip cutting using the traditional table saw technique."

Rip cutting with the sliding panel:

1. Mount the crosscut table to the sliding panel.
2. Slide and secure the crosscut table to the end of the sliding table opposite the sliding table handle.

3. Install the crosscut fence in the guide pin holes and lock it in place with the knurled nut.

Note First, drop the crosscut fence into the forward guide pin hole, turn the "Z"lock plate to align the



4. Set either flip stop to the desired width-of-cut.
5. Load the workpiece onto the table saw.
6. Mount the hold down arm onto the stud and lock the work-piece in place.
7. Once all the necessary safety precautions have been taken, perform the cutting operation.

Rip cutting using the traditional table saw technique:

1. Slide the crosscut table out of the way.
2. Lock the sliding panel into a stationary position.
3. Position the rip fence to the desired width-of-cut.
4. Once all the necessary safety precautions have been taken, load the workpiece onto the table saw and perform the cutting operation.

Crosscutting

With the crosscut fence mounted in the forward position, the sliding panel saw has the capability of crosscutting full size panels.



With the crosscut fence mounted in the rear position, this machine also has the capability of crosscutting smaller panels.



This machine has the capability of crosscutting workpieces while using the hold down w/mitre gauge .



Lastly, this machine has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge.



Fig 38

Determine which cutting operation will be best suited for the workpiece to be crosscut.

If you will be crosscutting full size panels, then skip ahead to "Crosscutting full size panels."

If you will be crosscutting smaller panels, then skip ahead to "Crosscutting smaller panels."

If you will be crosscutting workpieces using the hold down, then skip ahead to "Crosscutting using the hold down w/mitre gauge."

If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to "Crosscutting using the rip fence as a cut-off gauge."

Crosscutting full size panels:

1. Mount the crosscut table to the sliding panel.
2. Install the crosscut fence in the forward guide pin holes and lock it in place.

Note *First, drop the crosscut fence into the forward guide pin hole, turn the "Z" lock plate to align the fence, then tighten the knurled nut.*

3. Set either flip stop to the desired width-of-cut.

Note *If the workpiece extends to the left of the saw blade more than 1200mm, then the crosscut fence slide needs to be extended.*

4. Load the workpiece onto the table saw.



5. Mount the hold down arm onto the stud and lock the work-piece in place.

6. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting smaller panels:

1. Mount the crosscut table to the sliding panel.
2. Install the crosscut fence in the rear guide pin holes and lock it in place.

Note *First, drop the crosscut fence into the rear guide pin hole, turn the "Z" lock plate to align the fence, then tighten the knurled nut.*

3. Set either flip stop to the desired width-of-cut.

Note *If the workpiece extends to the left of the saw blade more than 1200mm, then the crosscut fence slide needs to be extended.*

4. Load the workpiece onto the table saw.
5. Mount the hold down arm onto the stud and lock the work-piece in place.

6. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting using the hold down:

1. Mount the hold down onto the sliding panel.
2. Load the workpiece onto the table saw. Secure it using clamp.
3. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting using the rip fence as a cut-off gauge:

1. Mount the crosscut table to the sliding panel.
2. Install the crosscut fence in the rear guide pin holes and lock it in place.

Note *First, drop the crosscut fence into the rear guide pin hole, turn the "Z" lock plate to align the fence, then tighten the knurled nut.*

3. Position the rip fence to the desired width-of-cut.

4. Load the workpiece onto the table saw.
5. Mount the hold down arm onto the stud and lock the work-piece in place.
6. Once all the necessary safety precautions have been taken, perform the cutting operation.

Miter Cutting

The cross cut table built two scales for forward and rear mount fence to perform mitre cut.

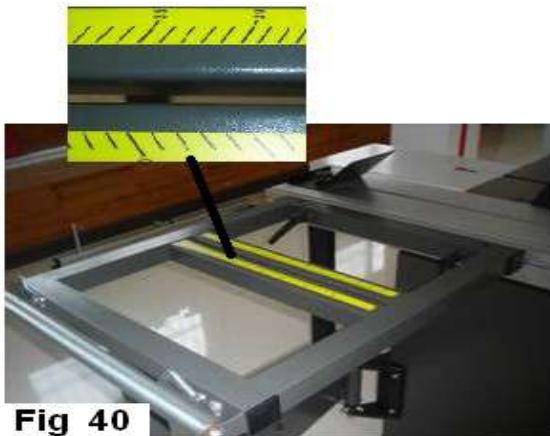


Fig 40

Also the sliding panel built a scale for hold down to perform mitre cut.



Fig 41

Lastly, this machine has the capacity of mitre cutting work-piece using the mitre gauge.

To perform a miter cut using the cross cut fence:

1. Mount the cross cut fence onto the cross cut table.
2. Position the cross cut fence at the desired angle and use the ratchet lever to lock the cross cut fence in position.



Fig 42

3. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.

Note If the workpiece extends to the left of the saw blade more than 1200mm, then the crosscut fence slide needs to be extended.

4. Load the workpiece onto the table saw.
5. Mount the hold down arm onto the stud and lock the work-piece in place.
6. Once all the necessary safety precautions have been taken, perform the cutting operation.

To perform a miter cut using the hold down w/mitre gauge:

1. Mount the hold down onto sliding panel and fit a cut fence.
2. Position the hold down w/mitre gauge at the desired angle and use the ratchet lever to lock the mitre gauge in position.
3. Load the workpiece onto the sliding panel. Secure the workpiece with clamp.
4. Once all the necessary safety precautions have been taken, perform the cutting operation.



Fig 43

MAINTENANCE



Warning!

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Cleaning

Cleaning the sliding panel 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. Treat all cast iron and unpainted steel with a non-staining lubricant after cleaning.

Once a week:

- Clean sliding panel surface and grooves.
- Clean the cast iron or steel plate saw table.
- Clean the roller guide ways for the sliding table.
- Clean the aluminum rip fence and sliding grooves.
- Clean the rip fence bracket.

Once a month:

- Vacuum inside the motor cabinet.

Miscellaneous

Always be aware of the condition of your machine. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts.
- Worn switch.
- Worn or damaged blade.
- Worn or damaged blade guard.

V-Belts

To ensure optimum power transmission from the motor to the blade and to the hydraulic pump, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension. Check the V-belts at least every 3 months; more often if the saw is used daily.

Replace the belts, if needed.

Bearings

The bearings are sealed and pre-lubricated and require no lubrication during their usable life. However, your saw components will operate at their best if the bearing surfaces are kept clean this is especially important for the trunnion bearings.

Main switch

This machine is equipped with a knee touch no-volt release main switch and a limit switch.

The main switch is equipped a large size touch panel, during performance cutting work, any part of man body touched the switch panel, it can bring the saw stop.



Fig 44

Limit switch

The limit switch is mounted under the inner guard, if your make scoring blade or main blade replacement, remove the inner guards, the limit switch keep "off" position. Reduce the risk of unintentional starting.

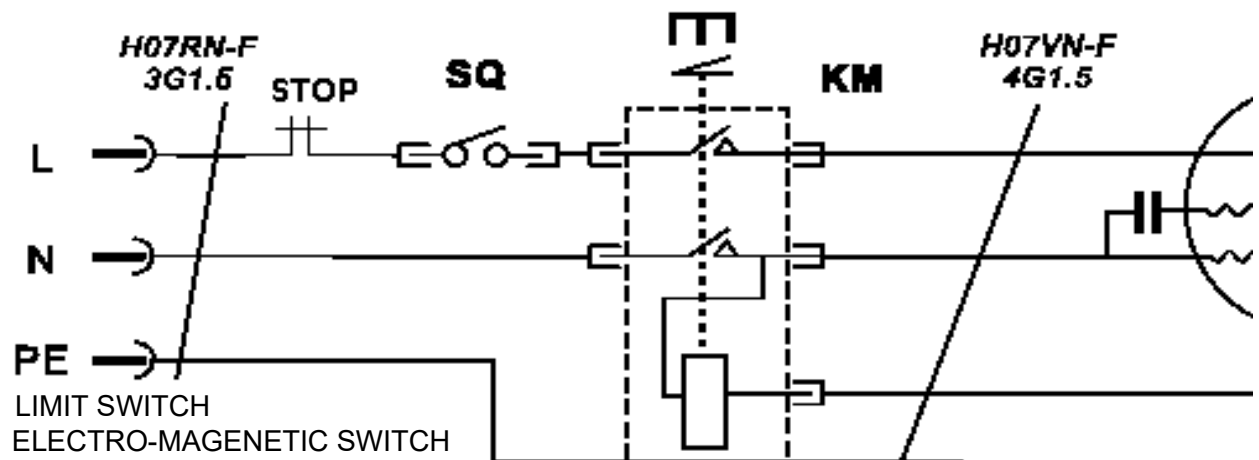


Fig 45

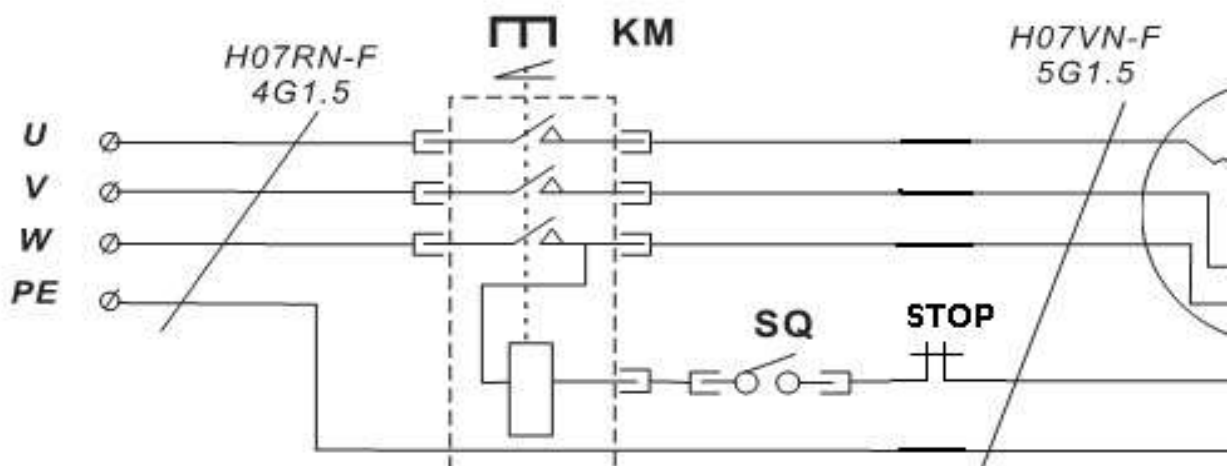
Thermo cut-out

There is thermo cut-out inside the motor, this device protect the motor from being damaged in high temperature's condition. When the motor's temperature is too high the fuse will shut off automatically, you should check the reasons to cause the high temperature or be carried out by qualified specialists at once. The thermo cut-out will return to normal automatically once the temperature low down.

1~, Motor



3~, Motor



TROUBLESHOOTING

TROUBLESHOOTING

Symptom	Possible Cause	Possible Sol
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper 2. Inspect all lead connections or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.	1. Inspect cord or plug for dam shorted wires. 2. Inspect all connections on n shorted terminals or worn in 3. Install correct fuses or circu
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide r circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Inspect connections on mot shorted terminals or worn in 2. Correct the low voltage cond 3. Install correct fuses or circu 4. Reduce load on motor.
Machine slows when operating.	1. Applying too much pressure to workpiece. 2. Belts loose	1. Feed workpiece slower. 2. Tighten belts.
Loud, repetitious noise coming from machine.	1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective	1. Inspect keys and setscrews if necessary. 2. Tighten fan or shim cover. 3. Replace V-belts.
Blade is not square w/miter slot or fence is not square to blade	1. Blade is warped. 2. Table top is not parallel to blade. 3. Fence is not parallel to blade	1. Replace blade. 2. Make table parallel to blade 3. Make fence parallel to blade
Fence hits table top when sliding on to the table.	1. Front rail is bolted too low on table. 2. Rear rail is bolted too low on the table.	1. Raise front rail. 2. Raise rear rail.
Blade does not reach 90°.	1. 90° stop bolt is out of adjustment.	1. Adjust 90° stop bolt.
Blade hits insert at 45°.	1. Hole in insert is inadequate. 2. Table out of alignment. 3. Blade position is incorrect.	1. File or mill the hole in the ins 2. Align table. 3. Adjust blade position.
Blade will not go beneath table surface.	1. Table top too low.	1. Raise table top w/washers.
Hand wheels won't turn.	1. Hand wheel key is inserted too far. 2. Roll pin or setscrew in worm gear is contacting geared trunnion.	1. Remove hand wheel and ad 2. Inspect roll pins and setscre gear. Tighten if necessary.
	1. Crested blade not fully inserted	1. Adjust the height of gear on



Warning!

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

PARTS LIST & DIAGRAMS

Parts List Diagram A

No	Description	No	Description
A-5	Pan head screw M6x12	A-28	Washer 4mm
A-6	Washer 6mm	A-29	Pan head screw M4x12
A-7	Dust port	A-30	Hold screw, push stick
A-9	Right panel, saw base	A-31	Push stick
A-15	Washer 5mm	A-32	Internal guard
A-18	Knee touch plate	A-36	Angle bracket
A-19	Taping screw ST4.2x20	A-37	Pan head screw M4x10
A-20	Saw base frame	A-38	Angle bracket
A-21	Main switch	A-39	Pan head screw M4x50
A-22	Cover, switch box	A-40	Limit switch
A-23	Plastic plate	A-41	Hex nut M4
A-24	Strain relief	A-42	Allen screw M6x12
A-25	Switch box	A-43	Hex nut M6
		A-44	Power cord
		A-45	microswitch
		A-46	flat washer 4
		A-47	cross recessed pan head screwM4
		A-48	urgent stop switch

Parts List Diagram B

No	Description	No	Description
B-1	Star-type, lock handle	B-22	Carriage bolt M6x40
B-2	Flat washer 8mm	B-23	Stud, hold down
B-3	Hex screw M8x25	B-24	Star-type knob, hold down
B-4	Hex screw M8x40	B-25	Arm, hold down
B-5	screw	B-26	Allen screw M5x16
B-6	T-base, adjust	B-27	Scale, sliding table
B-7	Bracket, sliding carrier	B-28	Disc, hold down
B-8	Stop screw	B-29	Circle ring 8mm
B-9	T-base, adjust	B-30	Pin, hold down
B-10	T-nut, sliding carrier	B-31	spring, hold down
B-11	Hex nut M8	B-32	Stud, hold down
B-12	Bracket, sliding carrier	B-33	Circle ring 12mm
B-13	Allen screw M8x32	B-34	Eccentric, hold down
B-14	Sunk head screw M8X25	B-35	Handle, hold down
B-15	Wing nut	B-36	Handle knob, hold down
B-16	Washer 6mm	B-37	End cap, fence
B-17	Mitre gauge, hold down	B-38	Fence, mitre gauge
B-18	Ratchet lever	B-39	Hex head screw M8x16
B-19	Flat washer 10mm	B-40	Upper support
B-20	Star-type lock handle	B-41	Allen screw M8x25
B-21	T-block	B-42	Disc, insert

Parts List Diagram B

cont...

No	Description	No	Description
B-43	Lower support	B-71	Hex nut M10
B-44	Adjustable disc	B-72	Lock guide
B-51	ScREW guide	B-73	T-nut, push handle
B-52	Taping screw ST4.2x12	B-74	Set screw M8x12
B-53	End cap, sliding panel	B-75	Insert, ball frame
B-54	Allen screw M5x8	B-76	Roll pin 2x8
B-55	Sliding panel set	B-77	Ball 1/2"
B-56	End cap, sliding panel	B-78	Ball frame
B-57	Stop plate	B-79	Ball frame
B-58	Stop plate	B-80	End cap, sliding rail
B-59	Sunk head screw M6x18	B-81	Sliding table rail
B-60	"Z" lock plate	B-82	End cap, sliding rail
B-61	Sunk head screw M6x20	B-83	Allen screw M6x10
B-62	Eccentric cam	B-84	Sunk head screw M8x20
B-63	Push handle	B-85	Lock nut M8
B-64	Bush, push handle	B-86	Lock nut M6
B-65	End cap, knob	B-87	Thread stud
B-66	Star-type knob, lock pin	B-88	Hex nut M8
B-67	Roll pin 3x18	B-89	T-block
B-68	Bush, lock pin	B-90	Edge shoe
B-69	Spring, lock pin	B-91	Startype screw M8x20
B-70	Lock pin	B-92	Washer 8mm

Parts List Diagram C

No	Description	No	Description
C-1	Frame-blade	C-25	Shaft
C-2	Shaft-main blade	C-26	Pulley
C-3	Main shaft	C-27	Tension shaft
C-4	Shaft housing-scoring blade	C-28	Sunken head screw M8X20
C-5	Shaft-scoring blade	C-29	Tension rod
C-6	Pulley-scoring blade	C-30	Bearing 6002
C-7	Gear house	C-31	Bearing 6205
C-8	Rotating support	C-32	Spacer
C-9	Main blade	C-33	Spacer
C-10	Pointer	C-34	Eccentric shaft
C-11	Slide piece	C-35	Circle nut
C-12	Scoring blade	C-36	Nut
C-13	Bearing house	C-37	Belt guard
C-14	Shaft	C-38	Thread
C-15	Stop, scoring blade	C-39	Shaft, spring
C-16	Thread	C-40	Insert
C-17	Main shaft	C-41	Segment
C-18	Rod	C-42	Flange, scoring blade
C-19	Shaft	C-43	Flange
C-20	Frame segment	C-44	Set screw M8X16
C-21	Pulley	C-45	Allen screw M10X25
C-22	Hex nut	C-46	Chip house
C-23	Pulley-motor	C-47	Motor A
C-24	Motor base	C-48	Flange

Parts List Diagram C

cont...

No	Description	No	Description	No	Description
C-49	Ball bearing	C-79	Hex head screw M6X20	C-134	locking wheel
C-50	Tube	C-80	Allen screw M6X20	C-135	nylon shaft
C-51	Wheel handle	C-81	Hex nut M6	C-136	sunk screw m6*25
C-52	Thread	C-82	Set screw M8X8	C-137	locking block
C-53	Spring	C-83	Flat hey 18X35	C-97	elevating handwheel
C-54	Washer	C-84	Flat washer 8mm	C-98	Lock the handle tightly
C-55	Spacer	C-85	Spring washer 8mm		
C-56	Spacer	C-86	Allen screw M8X30		
C-57	Circle ring	C-87	Carriage bolt M10X80C		
C-58	Thrust bearing	C-88	Hex nut M10		
C-59	Washer	C-89	Hex head screw M8X16		
C-60	Pin	C-90	Sunken head screw M10X25		
C-61	Circle ring 326	C-91	Hex head screw M10X25		
C-62	Roll pin 5X28	C-92	Set screw M8X16		
C-63	Set screw M6X8	C-93	Nut M35X1		
C-64	Roll pin A6X8	C-94	Multi "V" belt 660		
C-65	Set screw M8X12	C-95	Multi "V" belt 560		
C-66	Bearing 6002	C-101	Stop screw		
C-67	Lock nut M6	C-102	Set screw M8X20		
C-68	Set screw M8X12	C-103	Set screw M8X20		
C-69	Washer 8mm	C-105	Spring washer 10mm		
C-70	Hex head screw M8X12	C-107	Riving knife		
C-71	Circle ring A20	C-108	Taping screw ST4.2X10		
C-72	Circle ring	C-109	Taping screw ST4.2X26		
C-73	Hex head screw M6X12	C-110	Segement, blade guard		
C-74	Hex nut M8	C-111	Lock bolt, guard		
C-75	Pan head screw M6X12	C-112	Half, blade guard		
C-76	Flat washer 6mm	C-113	Half, blade guard		
C-77	Hex head screw M8X35	C-114	Lock washer 8mm		
C-78	Sunken head screw M8X40	C-115	Knuried nut		

Parts List Diagram D

No	Description	No	Description
D-1	L type aluminum baffle	D-14	Washer M5
D-2	Locking plate	D-15	Countersunk head screw M5X16
D-3	The positioning shaft	D-16	The locking block mandrel
D-4	Countersunk head screw M5X16	D-17	Inner six angle locking
D-5	Connecting plate	D-18	Locking block
D-6	Retaining rings for shafts ϕ 20	D-19	Side guide
D-7	L type aluminum locking shaft	D-20	Screw
D-8	Handle	D-21	Nut
D-9	Handball	D-22	Track scale
D-10	Slide block	D-23	The scale fixing plate
D-11	Retaining rings for shafts ϕ 20	D-24	Countersunk head screw M5X10
D-12	Slide block shaft	D-25	The bottom baffle
D-13	Thread bushing		

Parts List Diagram E

No	Description	No	Description
E-1	Scale, cross cut table	E-42	Hex screw M8x30
E-2	Washer 6mm	E-43	Hex screw M10x25
E-3	Scale, cross cut table	E-44	Sunk head screw M6x12
E-4	Allen screw M6x12	E-45	T-nut, extension fence
E-5	Eccentric cam	E-46	Lock plate
E-6	Washer 8mm	E-47	T-block
E-7	Sunk head screw M6x10	E-48	Scale
E-8	"Z" lock plate	E-49	End, extension fence
E-9	"Z" lock plate	E-50	Carriage bolt M6x38
E-10	Hex screw M8x20	E-51	Screw guide
E-11	Lock nut M6	E-52	Flip stop base
E-12	Hex nut M6	E-53	Knurled knob
E-13	End cap, cross cut table	E-54	Spring, flip stop
E-14	Cross cut table	E-55	Set screw
E-15	Roller	E-56	Spacer , ratchet lever
E-16	Hex screw M8x12	E-57	Ratchet lever, Flip stop
E-17	Bracket, roller	E-58	Allen screw M8x20
E-18	Bracket, roller	E-59	Stud, flip stop
E-20	Support rod, cross cut table	E-60	Flip stop
E-22	Thin hex nut M10	E-61	Scale, extension fence
E-24	Swing arm, extension	E-62	Extension fence
E-25	Pan head screw M5x12	E-63	Scale, cross cut fence
E-26	Insert, swing arm	E-64	Taping screw ST4.2 x12
E-27	Woolen sheet	E-65	End cap, cross cut fence
E-28	Block	E-66	Lock stud, cross cut fence
E-29	Roll	E-67	T-block
E-30	Bearing 6101	E-69	Flat washer M8
E-31	Spacer, roll	E-70	Spacer, lock handle
E-32	Pan head screw M5x6	E-71	Star-type lock handle
E-33	Eccentric shaft	E-72	Wing nut M8
E-34	Swing arm	E-73	Stud, cross cut table
E-35	Hex screw M6x35	E-74	T-block
E-36	Stop collar	E-75	Knurled knob, fence
E-37	Bearing 6202	E-76	End cap, swing arm
E-38	Shaft, swing arm	E-77	T-block, hold down
E-39	Hex screw M8x50	E-78	Washer 12 mm
E-40	Thin nut M16	E-79	Stud, hold down
E-41	Support, swing arm		

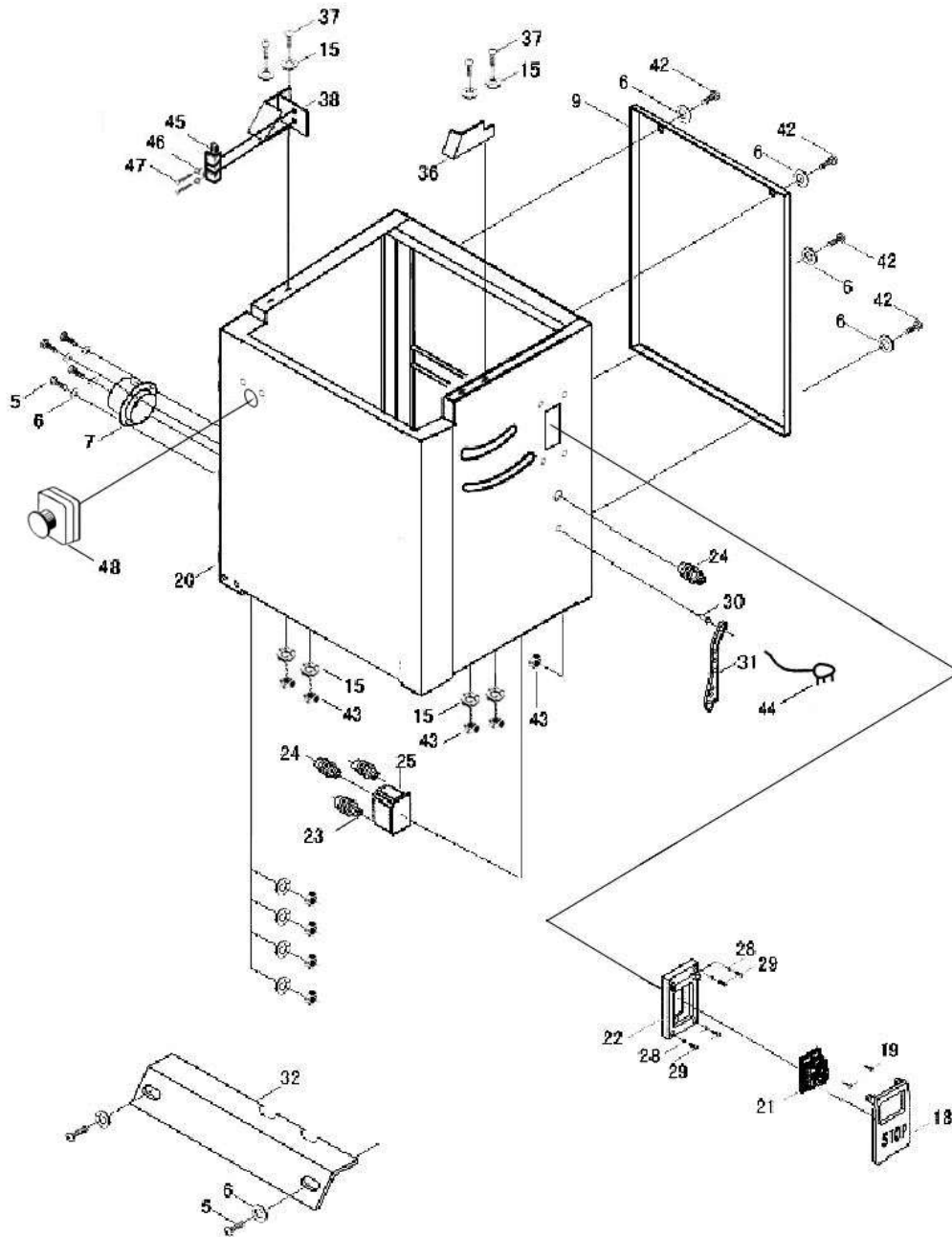
Parts List Diagram G

No	Description	No	Description
G-1	Rear extension table	G-20	Dust hose support
G-2	Washer 8mm	G-21	Washer 6mm
G-3	Hex nut M8	G-22	Hex screw M6x20
G-4	Set screw M6x12	G-23	Hex nut M6
G-5	Hex screw M8x16	G-26	Adjustable disc
G-6	Flat washer 10mm	G-27	Lower, support
G-7	Rea table support	G-28	Disc insert
G-8	Set screw M10x70	G-29	Allen screw M8x25
G-9	Hex nut M10	G-30	Upper, support
G-10	Major table	G-31	Taping screw ST4.2x12
G-11	Table insert	G-32	Washer 4mm
G-12	Sunk head screw M5x10	G-33	Right end cap, front rail
G-13	Hex screw M8x20	G-34	T-Nut M5
G-14	Front rail	G-35	Rack, fence
G-15	Square head screw M8x25	G-37	Lock washer 5mm
G-16	Extension table	G-38	Pan head screw M5x8
G-17	Steel extension table	G-39	Left end cap, front rail
G-18	Hose clamp 30mm	G-40	Scale, rail
G-19	Dust hose 30mm dia.x3240mm	G-41	Rear rail

Parts List Diagram H

No	Description	No	Description
H-1	Mitre gauge knob	H-11	Mitre gauge rod
H-2	Washer 6mm	H-12	Washer 6mm
H-3	Mitre gauge base	H-13	Knurled nut
H-4	indicator		
H-5	screw		
H-6	End cap, Gauge fence		
H-7	Gauge fence		
H-8	Sunk head screw M5x8		
H-9	Roller, guage		
H-10	Carriage bolt M6x32		

DIAGRAM A



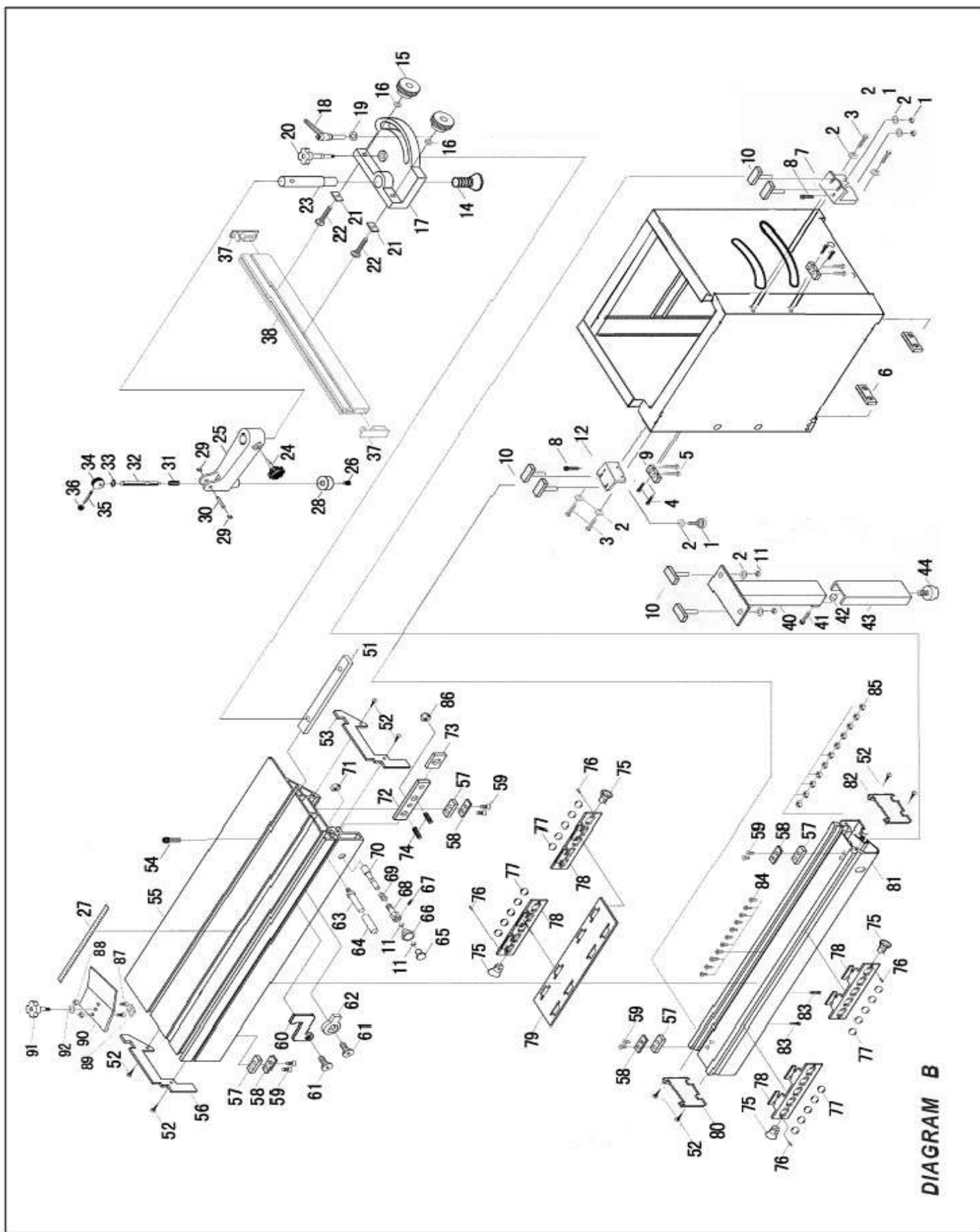
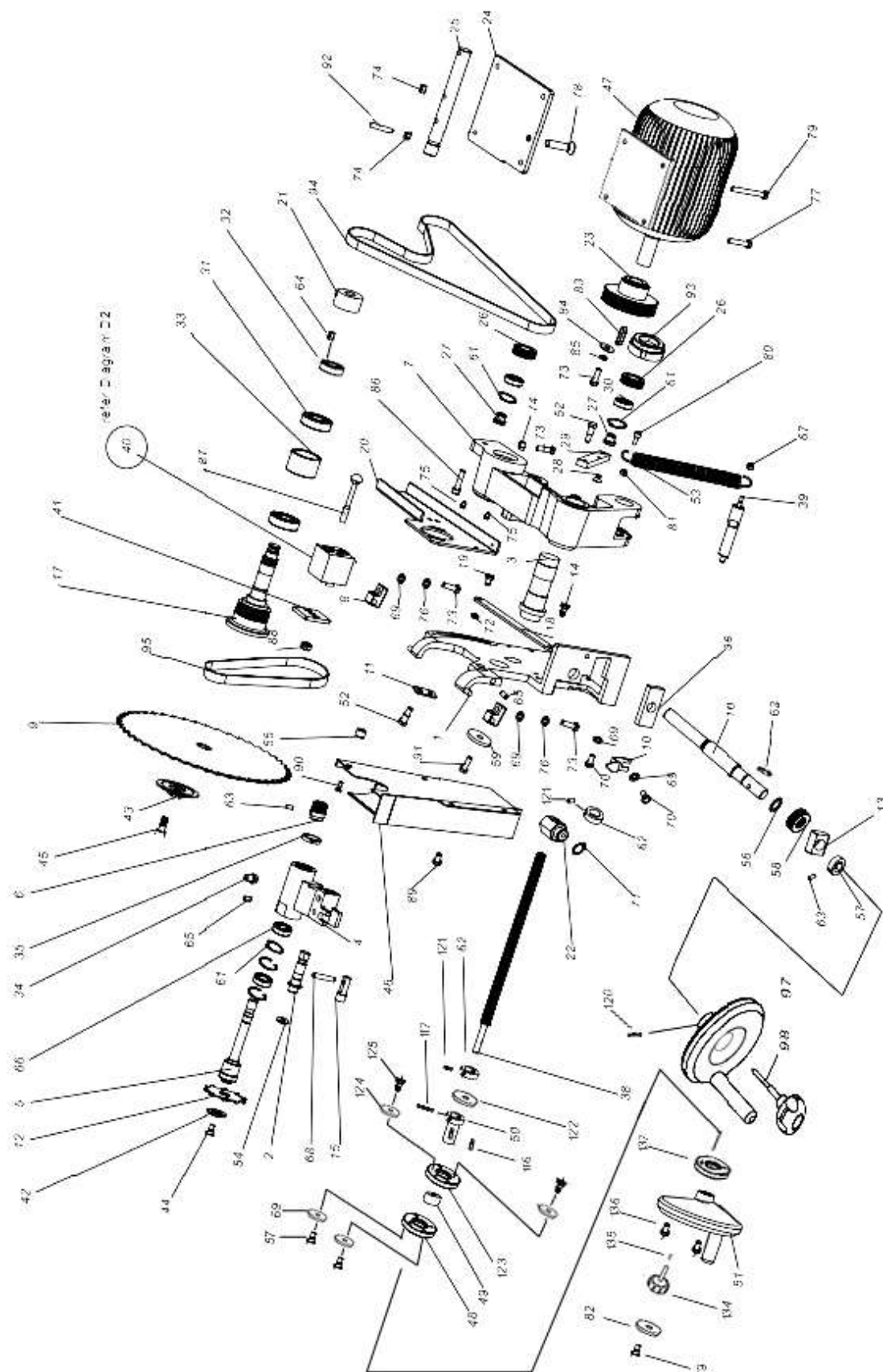
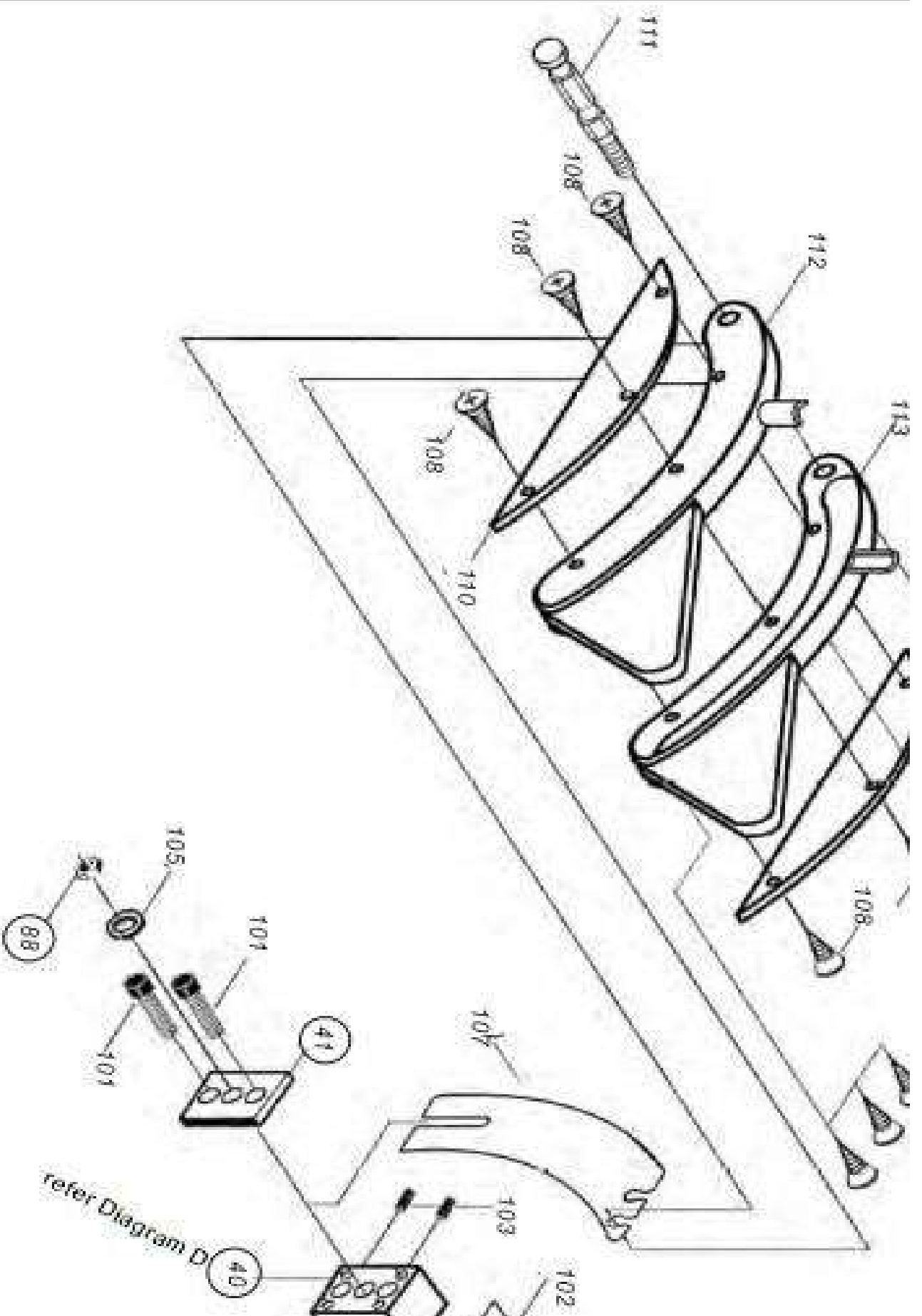


DIAGRAM C





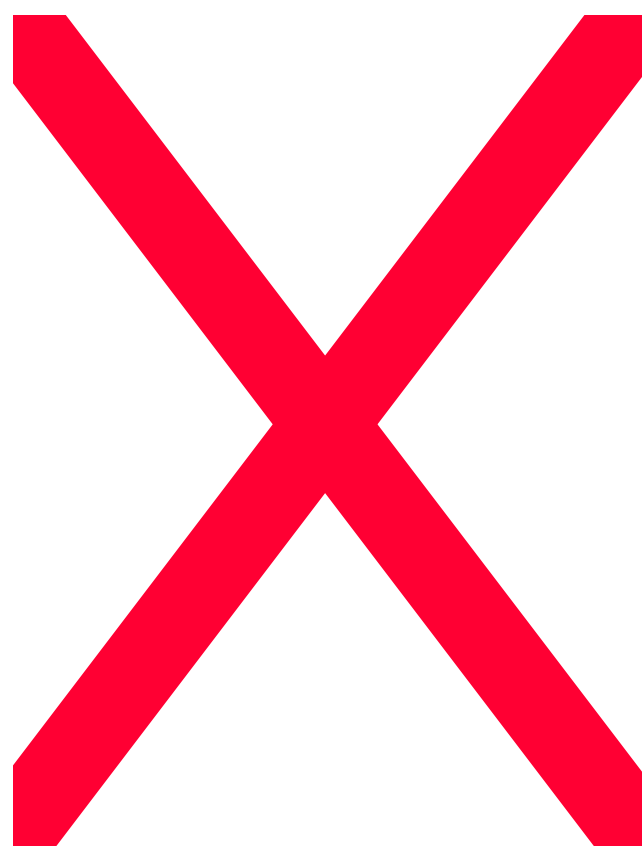
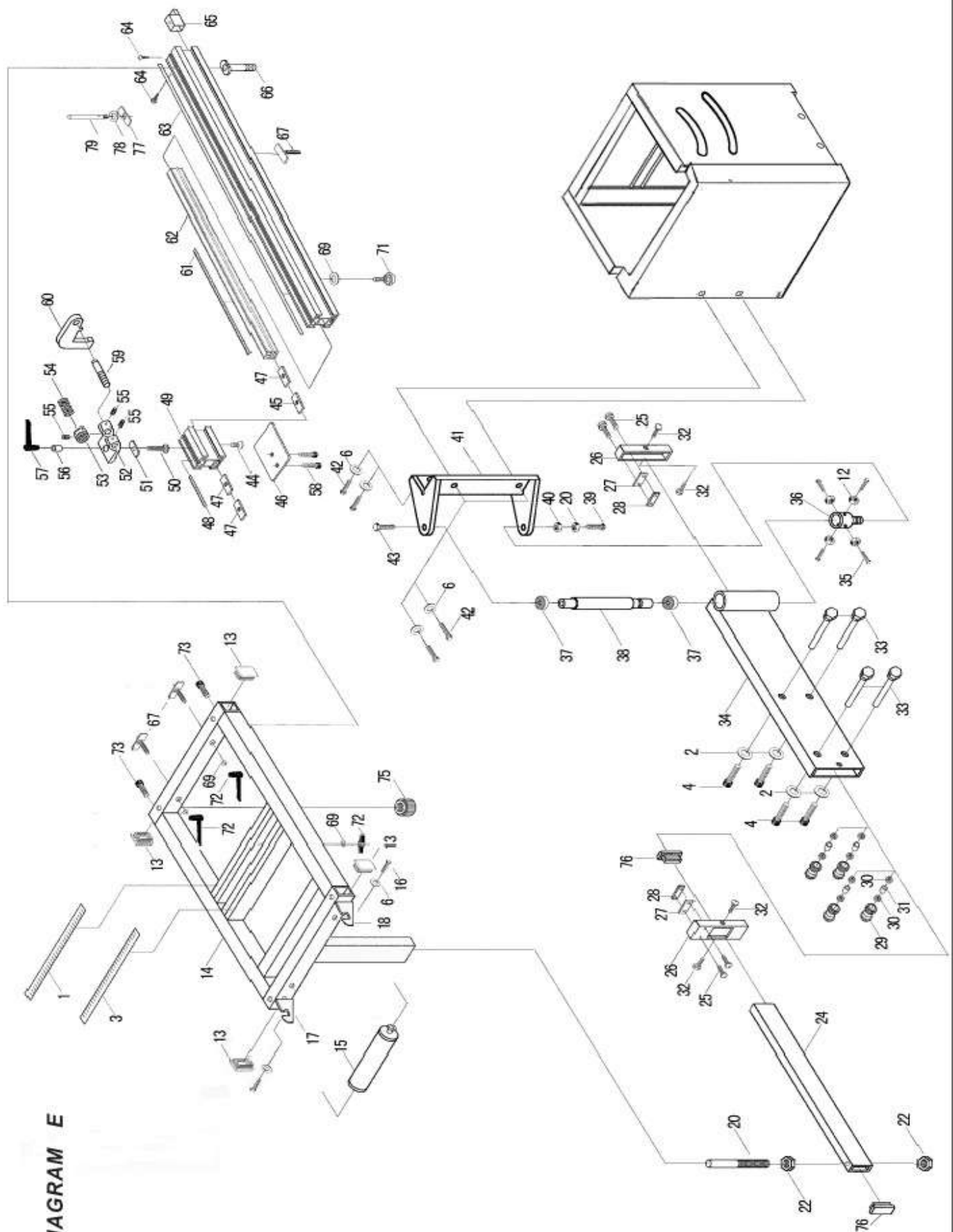


DIAGRAM E



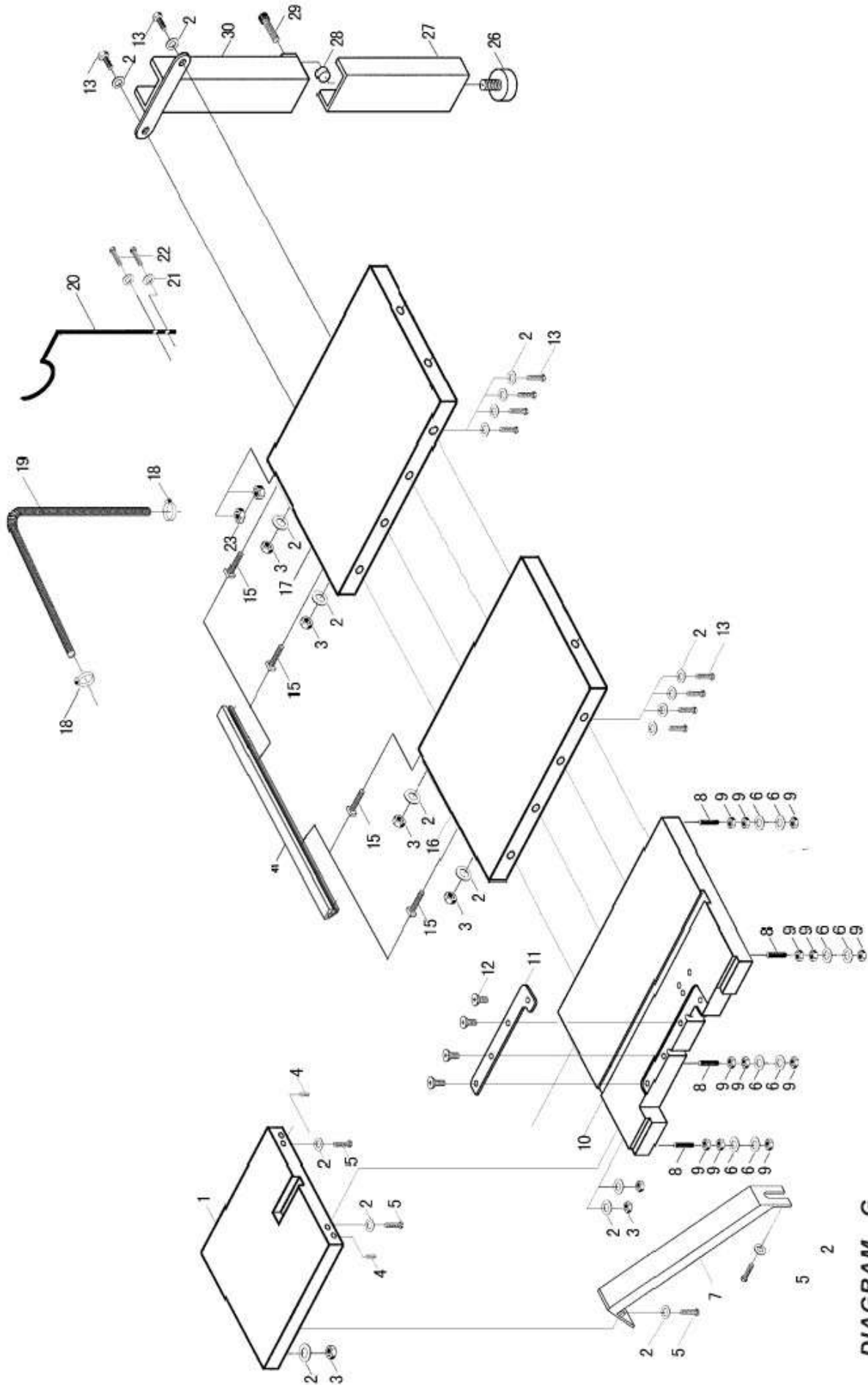
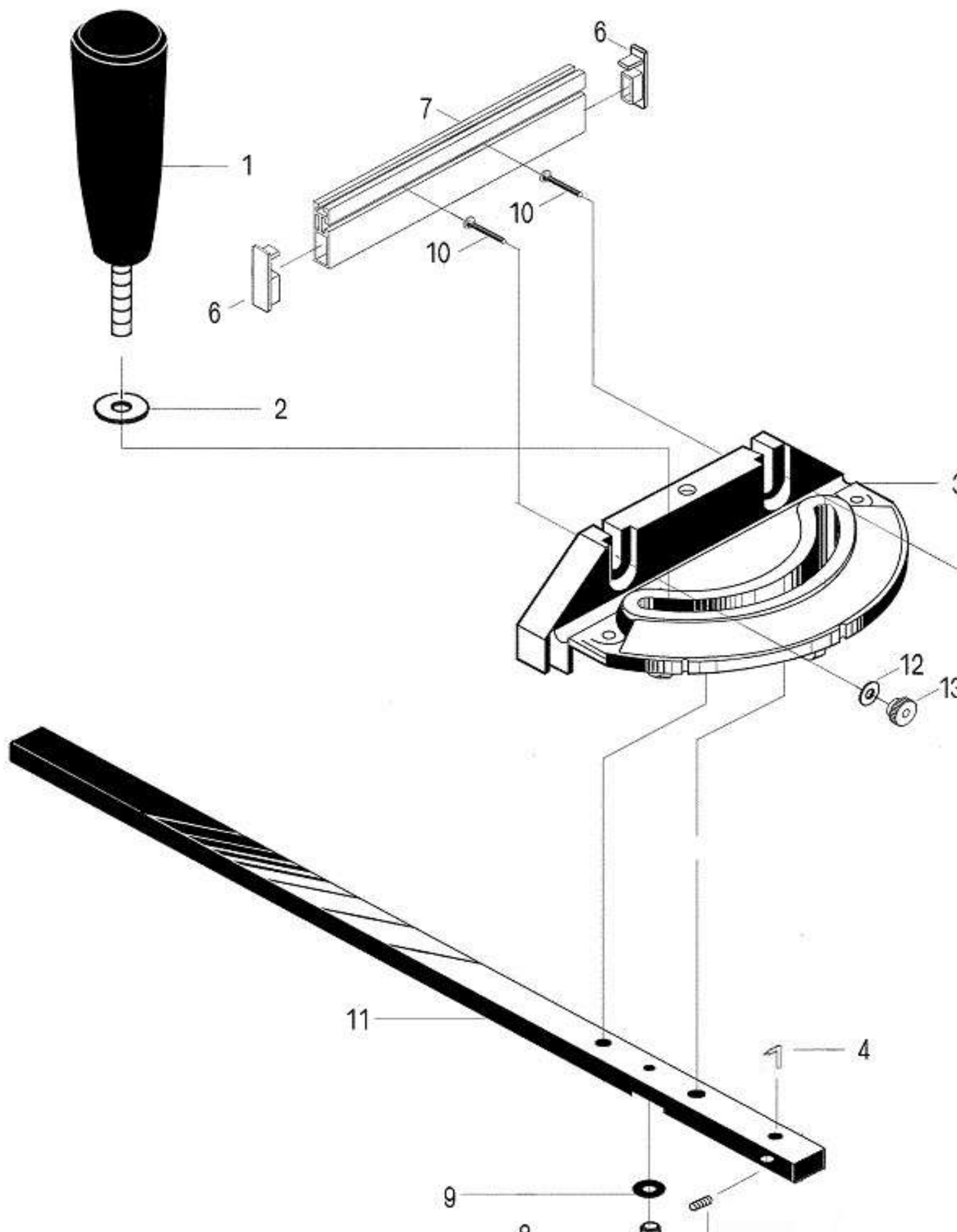


DIAGRAM G



Parts List Diagram K

<u>No</u>	Description	<u>No</u>	Description
K-1.	Cross head screw M5X8	K-3.	Left guard
K-2.	Washer M5	K-4.	Right guard