

AT254SB, AT315SB Saw Bench



Sliding Table Kit



AT254SB AT315SB
Code: **951539**

Table Extension Set



AT254SB Code: **951538**
AT315SB Code: **951541**

Saw Bench Package



AT254SB Code: **718652**
AT315SB Code: **718653**

AT&M: 10/07/2020
BOOK REF: 508304
BOOK VERSION: 2



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Cert No: MJ2325D / MJ2330D

Axminster Tools & Machinery Ltd
Axminster Devon
EX13 5PH UK

axminster.co.uk

declares that the machinery described:-

Type	Saw Table
Model	AT234SB, AT315SB

Signed



Andrew Parkhouse
Operations Director

Date: **12/06/2020**

EU Declaration of Conformity

This machine complies with the following directives:

2006/42/EC	EN 61000-3-3:2013+A1
06/42/EC - Annex I/05.2006	EN IEC 61000-3-2:2019
EN 60204-1:2006	EN 55014-2:2015
EN 1870-1:2007+A1	EN 55014-1:2017

and conforms to the machinery example for which the
EC Type-Examination Certificate No AE 50471185, AN 50170241
has been issued by **Laizhou Fulin Machinery Co., Ltd.**

at: Wenchang Road Street, Nanwuli Industry Yard, Laizhou, 261400, Shandong, China (Mainland)

and complies with the relevant essential health and safety requirements

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



Fully read manual
and safety instructions
before use



Ear protection
should be worn



Eye protection
should be worn



Dust mask
should be worn



HAZARD

What's Included

Model Number:

MJ2325D/MJ2330D

501196 10" and 501197 12" Saw Bench (Box 1 of 2)

1	Saw Table on upper chassis (with motor, table insert, saw blade & NVR Switch fitted)	1
2	Side Panels and Front & Back Panels	2
4	Lower Leg Columns	3
1	Side Table Extension	3A
1	Dust Extraction Moulding 100mm	4
1	Dust Extraction Hose 100mm	4A

Bag Containing:

8	M8 x 25mm Square bolts, washer and nuts(for 501196,8pcs;for 501197,7pcs)	4B
4	M8 x 20mm Bolts, washers (for the connection of worktable & extension table)	
4	M6 x 16mm Phillips screws, washers/nuts	5
4	M8 x 16mm Bolts, washers and nuts	5A
16	M8 x 16mm Bolts, washers and nuts	5B
1	Rear Extension Table	6
2	Extension Table Support Brackets	7
1	Kick-Plate with M8 Bolts & Washers	8

Bag Containing:

4	M8 x 20mm Caphead Bolts	
4	M8 x 20mm Caphead Bolts and washers	9
2	Hand Wheels and locating keys	10
1	Mitre Fence and Mitre Fence Extension with clamping screw knobs	11
1	Mitre Fence Steel Plate with pre-drilled holes	12
1	Saw Guard with Phillips screw/nut and coach bolt/knob	13
1	Riving knife	14
1	M6 x 40mm Coach bolt and knob	15
2	125mm and 50mm Hose Clips	16
1	30mm hose	17

Bag Containing:

1	Tommy Bar	18
1	Spanner for (Changing the Blade)	18A
1	Push stick	18B

Bag Containing:

2	13/17mm Spanners	19
	Hex Keys: 3,4,5,6 and 8mm	19A
1	Instruction Manual	

501196 10" and 501197 12" Saw Bench (Box 2 of 2)

1	Rip Fence Assembly (partially assembled)	20
1	Rip Fence Extension	21
1	Short Rip Fence (front rail)	22
1	Short Rip Fence (back rail)	23

Bag Containing:

2	'T' bolts M6 x 70mm and M6 knobs	24
2	Plastic Capping Plates (for ends of the rip fence mounting bracket)	24A
2	Plastic Capping Plates (for ends of front rip fence rail)	24B
8	4mm Round head self tapping screws	24C
1	Micro Adjuster Assembly	25

951538 10" and 951541 12" Table Extension Kits (Box 1 of 2)

2	Extension Tables with M8 x 25mm 'T' bolts, washers and nuts	26
1	Table support leg	27
1	Threaded rubber foot	28

Bag Containing:

8	M8 x 30mm bolts, washers and nuts	30
2	M8 x 20mm bolts washers and nuts	31

951538 10" and 951541 12" Table Extension Kits (Box 2 of 2)

1	Long Rip Fence (front rail)	32
1	Long Rip Fence (back rail)	33
1	Measuring scale extension label	34

951539 10" and 12" Sliding Table Kits (Box 1 of 2)

2	Sliding Table Mounting Brackets	35
2	Steel Clamping Plates (for Mounting brackets)	36
1	Work Clamp and Tool Post	37
1	Sliding Table Assembly	38

Bag Containing:

6	M10 x 19mm Hex bolts (for table adjustment)	39
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951539 10" and 12" Sliding Table kits (Box 2 of 2)

1	Sliding Table Rail Assembly	40
1	Mitre Angle Rip Fence Assembly	41

What's Included

951539 10" and 12" Sliding Table kits (Box 2 of 2)

1	Mitre Angle Rear Quadrant (with lift and shift handle)	42
1	Table Fence Mounting Casting	43
1	Mitre Angle Rip Fence	44
2	Height Adjusting Blocks	45
1	Distance Stop (with lift and shift handle)	46

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



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



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

Mains Powered Tools

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

Workplace

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

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

Specification

Code	501196	501197
Model	AT245S	AT315SB
Rating	Trade	Trade
Power	2.2kW 230V 1ph	3kW 230V 1ph
Blade Dia/Bore	254 x 30mm	315 x 30mm
Blade Tilt	0-45°	0-45°
Max Depth of Cut @ 45°	60mm	75mm
Max Depth of Cut @ 90°	75mm	100mm
Max Width of Cut with Fence (with optional table extensions)	840mm	1,160mm
Max Ripping Width (with optional table extensions)	990mm	1,320m
Table Size (incl side table)	800 x 830mm	800 x 870mm
Table Height	865mm	865mm
Table Size With Extensions	800 x 1,170mm	800 x 1,480mm
Dust Extraction Outlet	100mm	100mm
Min Extraction Airflow Required	1,000 m ³ /hr	1,000m ³ /hr
Overall L x W x H	1,170 x 800 x 865mm	2,030 x 840 x 865mm
Weight	184kg	215kg

Initial Assembly

Please read through the Section entitled Illustration & Parts Description, this will enable you to more readily identify those parts of the saw to which we will be referring.



Please note. Some of this assembly procedure is best accomplished by two persons. Although the tasks are not impossible, some of the items are heavy and awkward, and a mishandling error could cause injury. Please think about what you are doing, your capabilities and your personal safety. We have added the 'two person symbol' to any operation that we recommend should be a two person task.

You will require: A pozi screwdriver in addition to the tools supplied.

Unpack all the boxes and check all the components against the **"What's Included"**. If any parts or components are missing, please contact our customer services department using the procedures and telephone numbers listed in our catalogue, and you will be dealt with quickly and efficiently.

Please note: that, on occasion, the packing list is not strictly adhered to, please check all the boxes, packets etc, to make sure that all the parts have been accounted.



PLEASE RECYCLE ANY UNWANTED PACKAGING RESPONSIBLY

Saw Body Assembly

Having unpacked the boxes, put the parts and components where they are readily to hand. Break down the main box by knocking the sides away (**be careful of exposed nails etc.**), but leave the machine sitting on its pallet. Identify the short rear panel with the dust extraction cutout (**2**), locate the dust extraction moulding (**4**) and fit to the panel using the nuts and bolts (**5**) provided. (See fig 1)

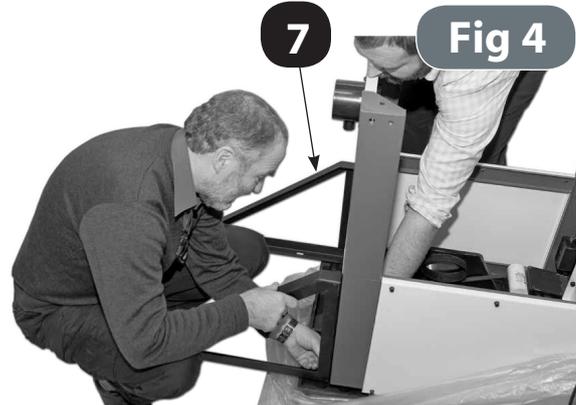
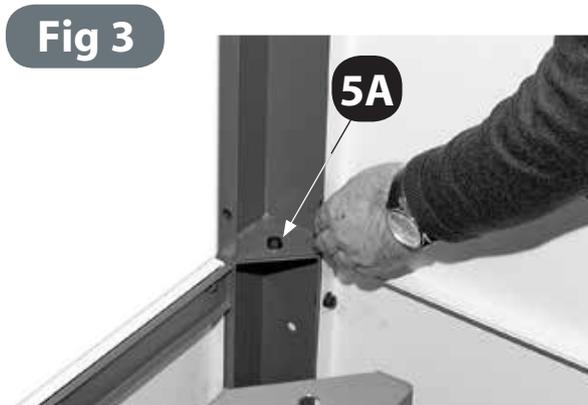
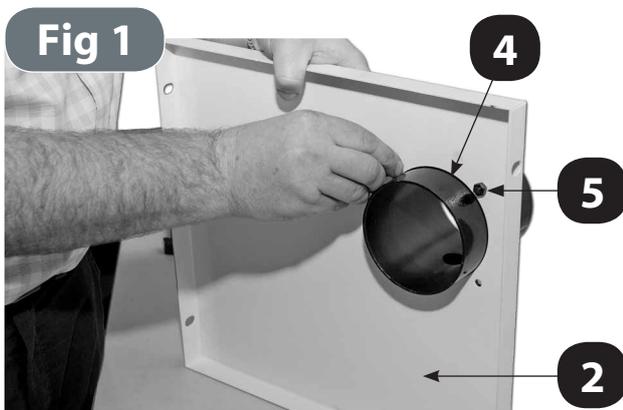
The orientation of the moulding should leave the 30mm outlet pointing upwards i.e. pointing up the long length of the panel. Put the panel aside, and locate the lower leg columns (**3**) and 4 No. M8x16mm (**5A**) bolts, nuts and double washers. Fix the lower legs to the upper legs using a washered bolt through the legs and secure with washer and nut, only turn the nuts

up finger tight at this time. (See fig 2) Locate the rear extension table (**6**), table support brackets (**7**) and 4 No. M8 x20mm caphead bolts and washers (**9**).

NOTE: the manufacturer has fitted adjusting bolts to the brackets, these are the faces that back against the legs.

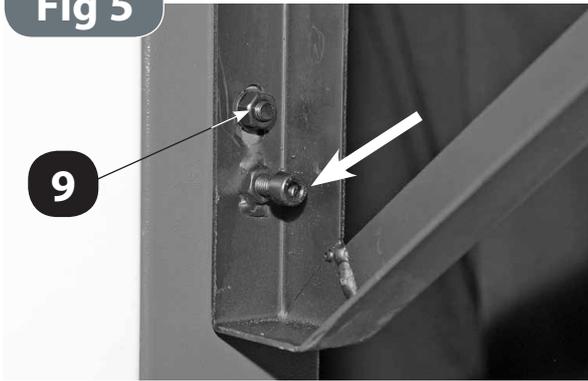
NOTE: The upper leg columns (3) has welded nuts to the inside face to mount the support brackets (7)

Fasten the support brackets (**7**) to the upper leg columns (**3**) using the bolts washers (**9**) and finger tighten the at this time. (See fig 4-5-6)



Initial Assembly

Fig 5



Adjusting bolt

Fig 6

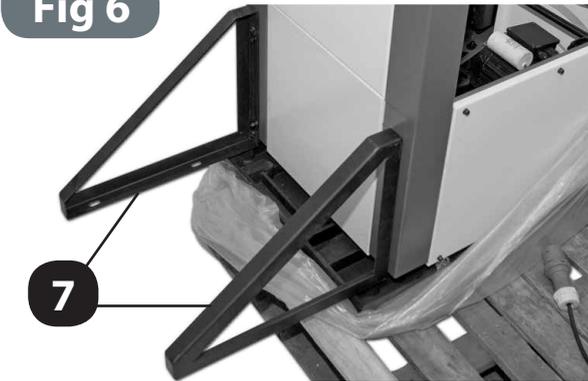


Table supporting brackets assembled

Locate the remaining three panels (**2**) and 20 No. M8x16mm (**5B**) bolts, nuts and double washers. Take up the rear panel with the dust extraction moulding fitted and fit between the rear legs, using washered bolt through the leg and panel and securing with washer and nut. Again, secure the nuts finger tight only. (See fig 7)

Fig 7



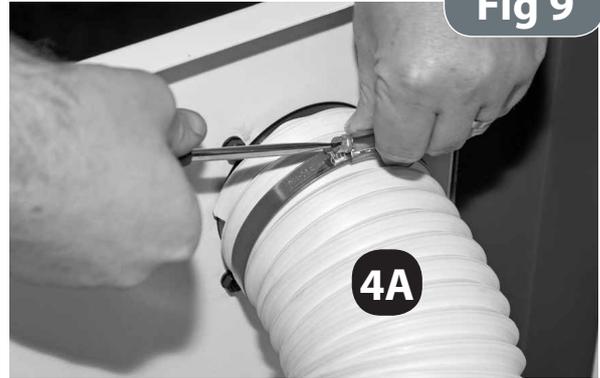
Fig 8



10

With easy open access, now is a good time to fit the dust extraction hose. Locate the hose (**4A**) and the two 125mm hose clips (**16**). Stretch the hose out to its full length. Slip the hose clips over the ends of the hose, fit the hose to the outlet on the saw box and the dust extraction moulding and tighten the hose clips to clamp them in place. (See figs 8-9-10)

Fig 9



Fit the hose over the dust extraction moulding and clamp in place

Fig 10



Fit the hose over to the saw box outlet and clamp in place

Fit the remaining panels to the legs, using the same securing sequence. Wriggle, push, pull, press, lever etc., the legs and the panels into the best alignment with the upper chassis and tighten the nuts and bolts using the spanners provided. (See figs 11-12)

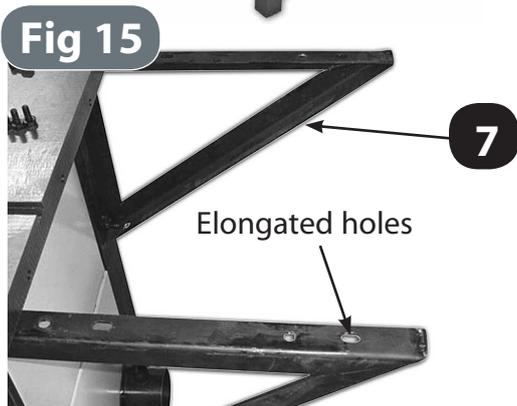
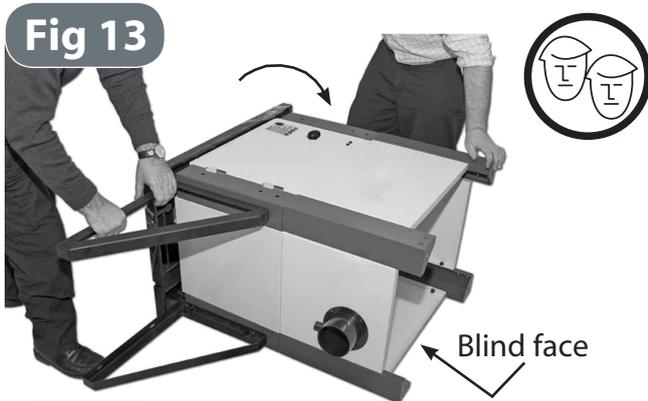
Fig 11



When everything is tightened up, the machine can now be tipped over, towards its blind face until it is resting on the pallet with its legs on the floor. Lift the machine upright. (See figs 13-14)

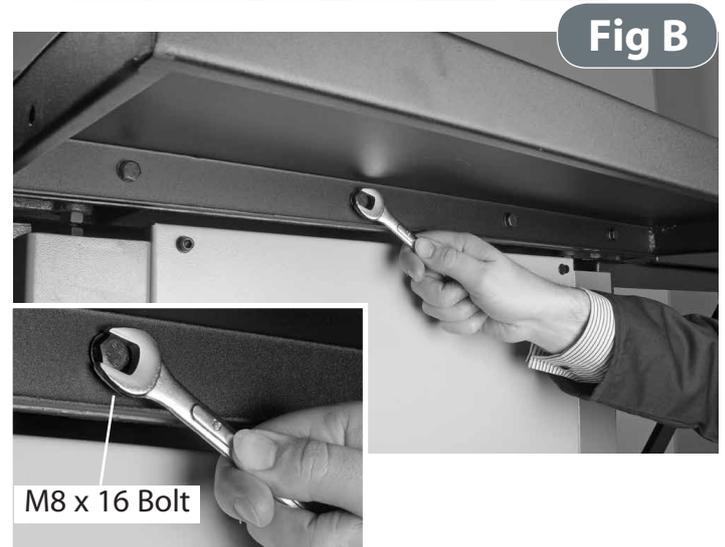
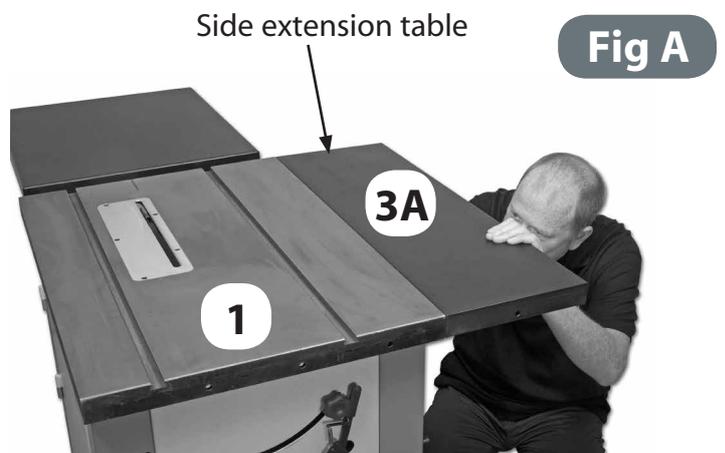


Locate the rear table (6) and the other 4 No. M8 caphead bolts and washers (9). Mount the table onto the brackets, **Note:** that the securing bolts need to feed through the elongated holes in the bracket (7), the rear extension table is spaced off the main table to allow clearance for the rear clamping rail and the rip fence. Leave all bolts finger tight at this time. (See figs 15-16)



Side Extension Table

Locate four M8 x 16mm hexhead bolts and washers. Ensure the table is correctly orientated. Stand the back end of the side extension table (3A) on the floor, close to the front and edge of the main saw table (1), with the underside of the table facing the front of the saw. Lift the table up and introduce a bolt and washer through the first hole in the table and screw it into the first threaded hole along the main table edge. Repeat for the remaining bolts. Place a level across both table surfaces and tighten the bolts, (See figs A-B).



Initial Assembly

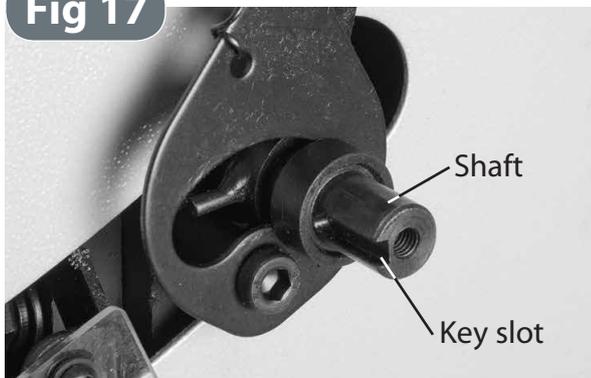
Fitting Hand Wheels

Locate the two hand wheels (10). Remove the Hex screw and washer from both drive shafts and place aside. Insert a square key into each machined slot on the drive shafts and slide the hand wheels onto the shafts. Replace the Hex screws and washers and tighten securely, (See figs 17-18-19-20)

NOTE: Line up the key slot in the hand wheel with the square key and slide the wheel onto the shaft, tighten securely.

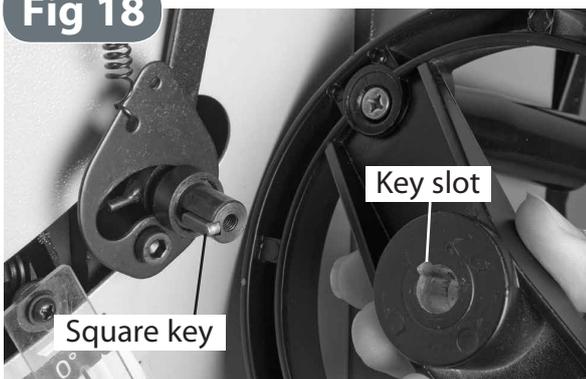
NOTE. Please ensure that the rise and fall **LOCK** is unlocked before operating the mechanism.

Fig 17



Drive shaft for the tilt mechanism

Fig 18



Insert the hand wheel over the shaft for the tilt mechanism

Fig 19



Fig 20



Secure the hand wheel in place using a Hex screw and washer then tighten using the supplied Hex key

Saw Guard Assembly

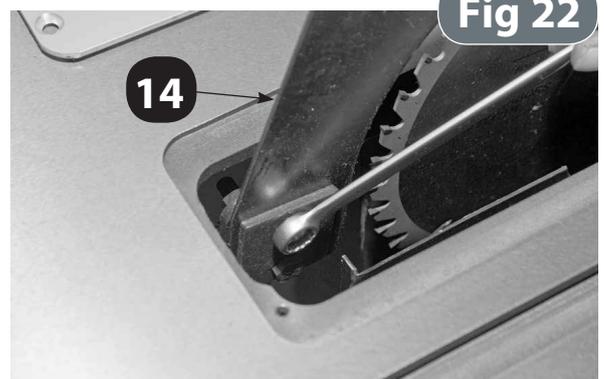
Locate the Riving Knife (14), remove the 5 screws that secure the saw gullet, place both carefully aside. (See figs 21 22) Raise the saw blade up to its highest point.

NOTE: The mounting plate for the riving knife has been factory set to ensure that the riving knife is aligned with the blade. **DO NOT** alter the setting bolts.

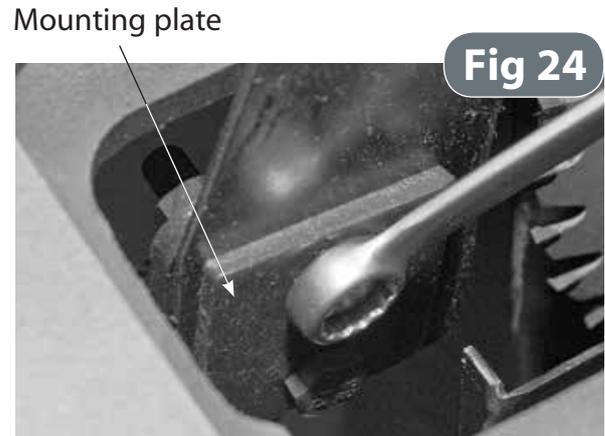
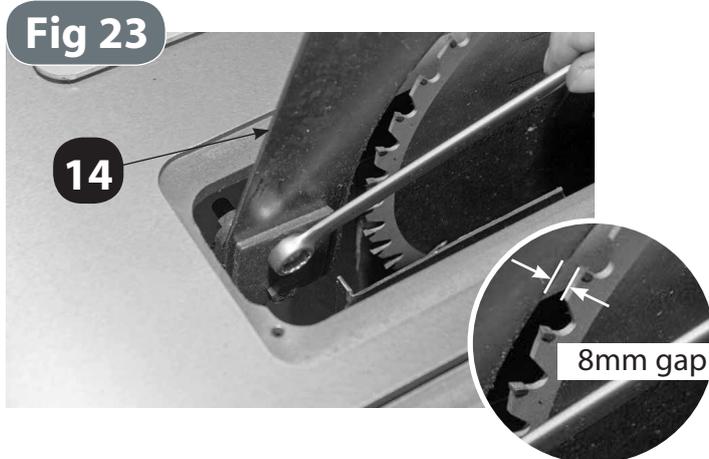
Fig 21



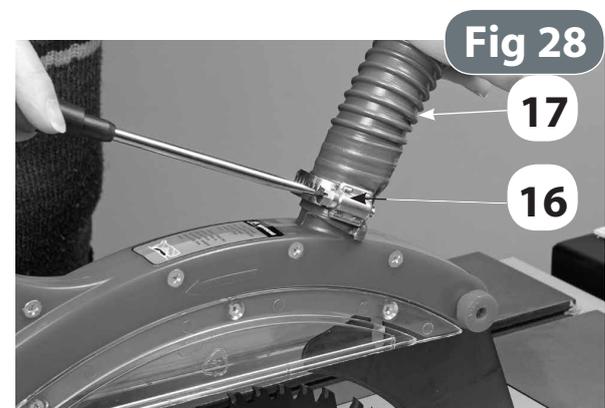
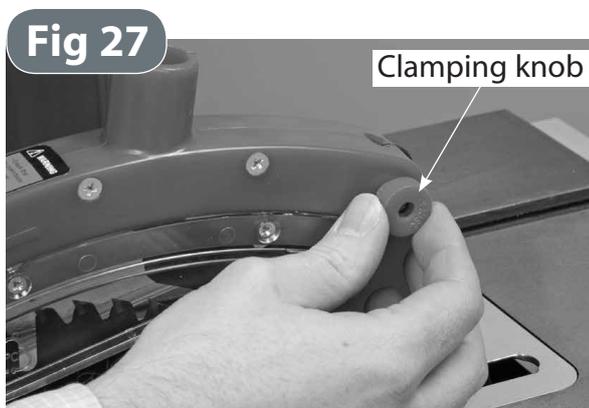
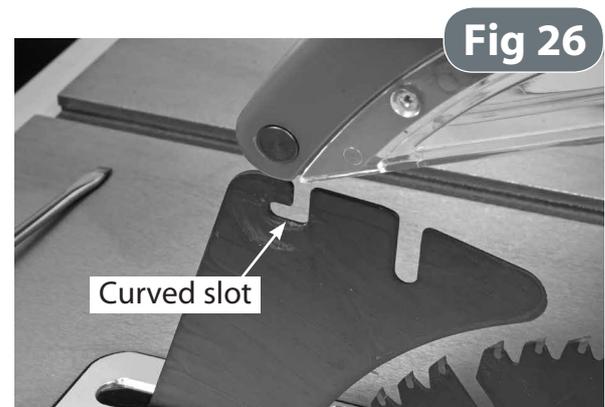
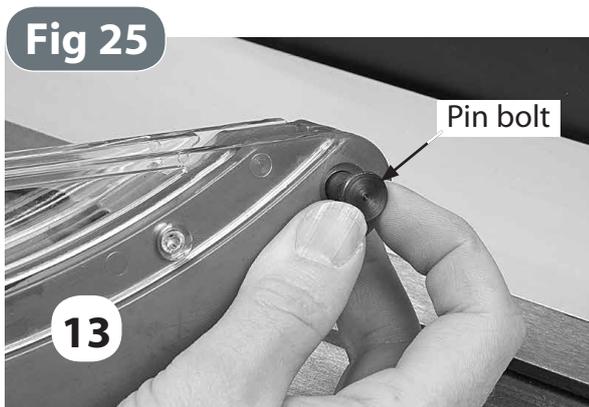
Fig 22



Introduce the slot in the riving knife (14) over the two centre line bolts, behind the washers and nip the bolts to just hold the riving knife against the mounting plate. Set the riving knife so its close to the blade, (gap with in 8mm). Tighten the clamping bolts securely. (See figs 23-24) Replace the saw gullet.



Locate the saw hood guard (13), the 30mm extraction hose (17) and the 50mm hose clips (16). Introduce the pin bolt through the pre-drilled hole in the guard (13) and lightly screw on the clamping knob. Lower the guard so the pin bolt fits into the curved slot in the riving knife then tighten the clamping knob to pinch the guard to the riving knife. (See fig 26-27)

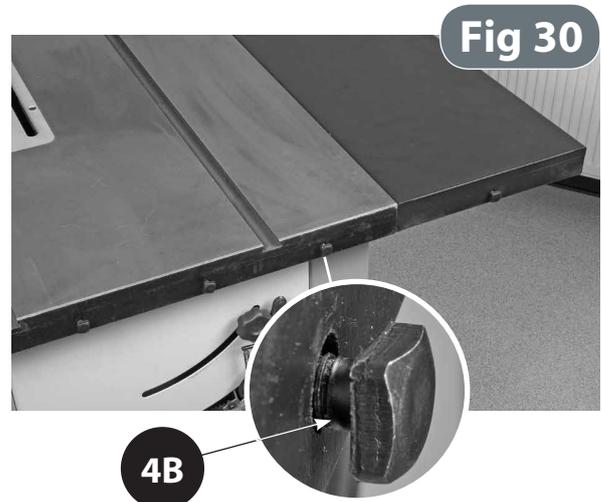
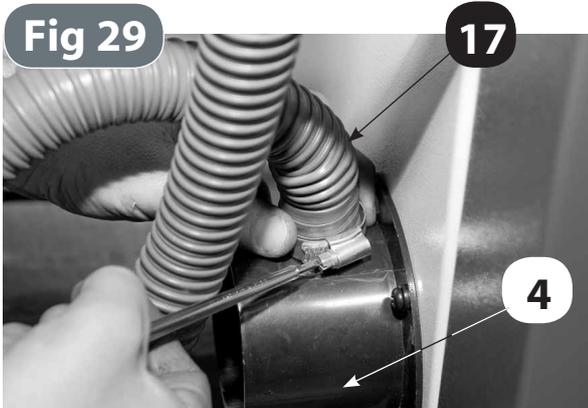


Push the hose clips (16) over the ends of the hose (17), push the hose onto the dust extraction outlet on the guard (13) and the main dust extraction moulding (4) and tighten the hose clips to hold it in place. (See figs 28-29)

Initial Assembly

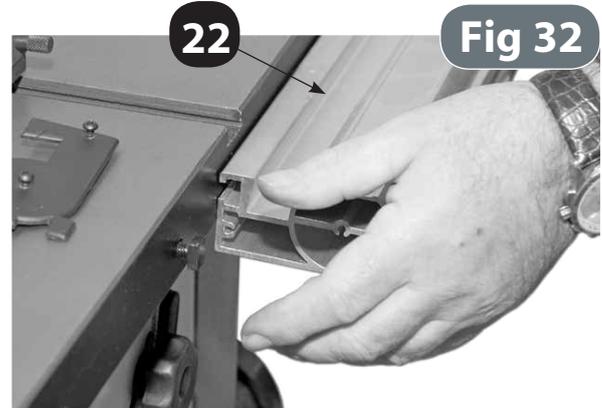
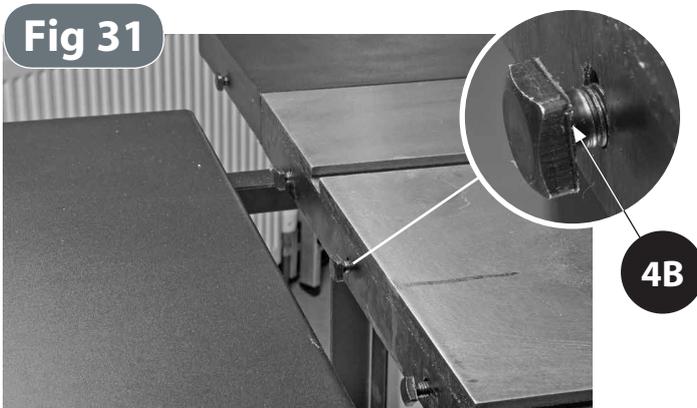
There is no requirement to remove the guard. The profile of the riving knife precludes the use of the saw for slotting or grooving, and the maximum depth of cut can be achieved with the guard in place.

NOTE: The positioning of the extraction hose could be a nuisance if you are cutting big boards, in such a case it is better to remove the hosing from the guard, then there is less risk getting the workpiece snagged and perhaps 'slewing' on the saw.



Rip Fence Assembly

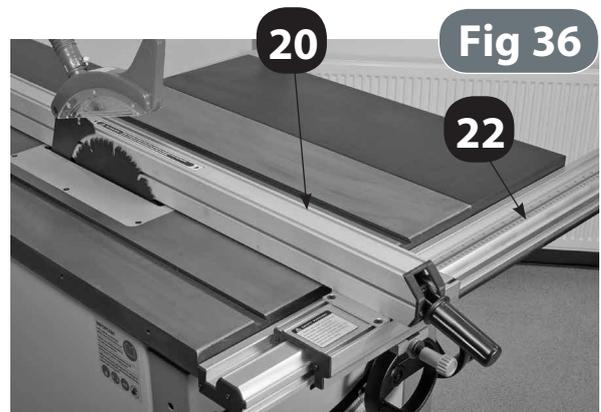
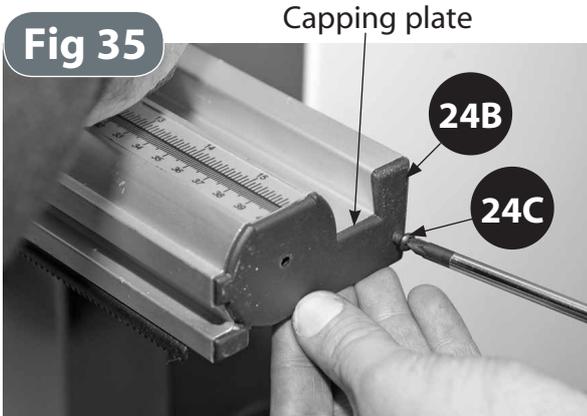
Locate the M8 x 25mm **SQUARE** head bolts washers and nuts (**4B**). The best way to fit the rails is to introduce the bolts through the holes in the front and rear edges of the tables, hold in position by adding the washer and fitting the nut a couple of turns onto the bolt. (See figs 30-31)



Select the front short rip fence guide rail (**22**), introduce the square head of the furthest right hand bolt into the channel in the extrusion; slide the rail along the front of the machine picking up all the bolt heads as you go along. (See fig 32) Reach under the table edge and lightly tighten all the nuts. (See fig 33) Repeat the process for the back rail (**23**). (See fig 34)



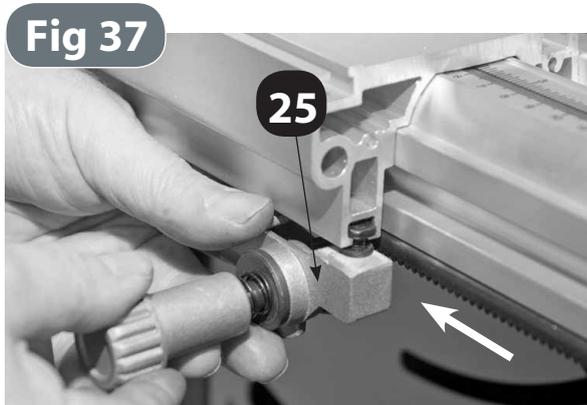
Locate the capping plates for the front rail (**24B**) and using the self tapping screws (**24C**), secure in place. (See fig 35) Set the front rail in position, remembering that it must be slightly inside the front left hand edge of the main saw table, so that the sliding table does not collide with it. Tighten **ONLY** the 3 bolts in the main saw table. Repeat the process for the back rail.



Locate the Rip Fence assembly (**20**), fit the rip fence assembly to the saw by ensuring the clamping lug at the rear of the fence is hooked over the back rail (**23**), lower the fence and manoeuvre the bracket over the front guide rail (**22**). (See fig 36)

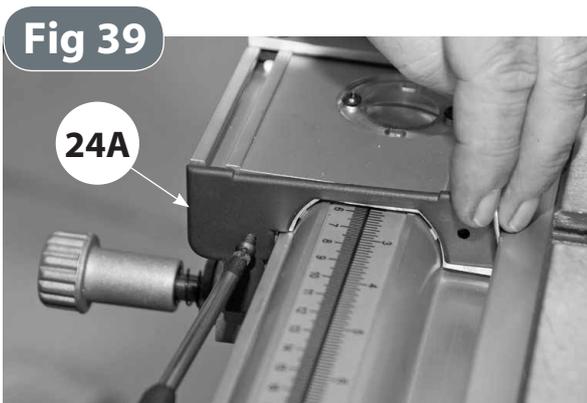
Micro-Adjuster Assembly

Locate the Micro-Adjuster (**25**) there are two Phillips screws through the adjustor mounting bracket with square nuts on them. Ensure the nuts are undone sufficiently to allow them to slide into the channel in the Rip Fence mounting bracket, position as required, normally slightly to the right of the rip fence, (See figs 37-38) and tighten the screws securely.



Tighten the Phillips screws securely

Locate the capping plates for the Rip Fence Mounting Bracket (**24A**) and fit carefully using the self tapping screws. (See figs 39-40)

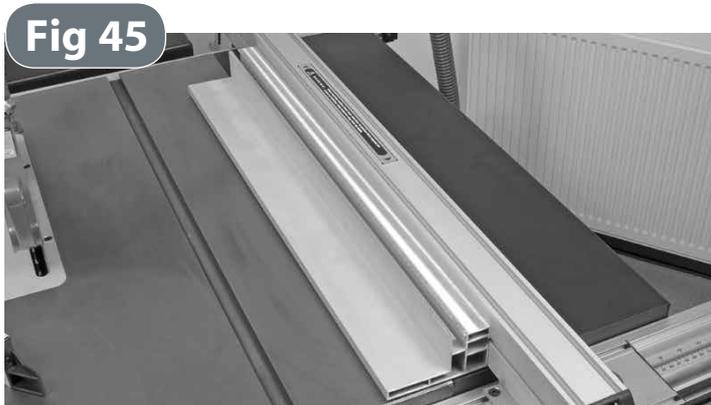
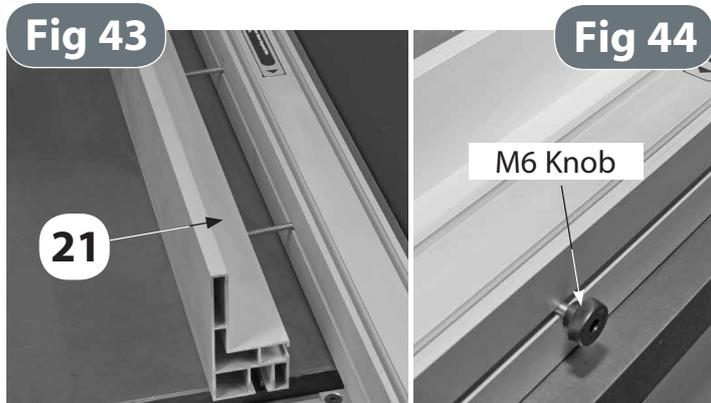
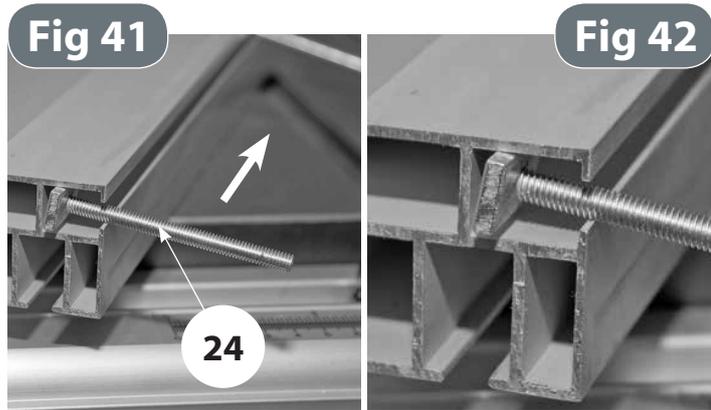


Initial Assembly

Rip Fence Extension

Locate the Rip Fence Extension (21), the two M6 x 70mm 'T' bolts and M6 knobs (24). Slot the two 'T' bolts into the fence extension recess, see figs 41 and 42. Slot the bolts into the pre-drilled holes in the fence extension and secure in place with the M6 knobs. (See fig 43-44)

NOTE: The rip fence extension (21) can be repositioned to the opposite direction for guiding thin timber pieces through. (See fig 45)

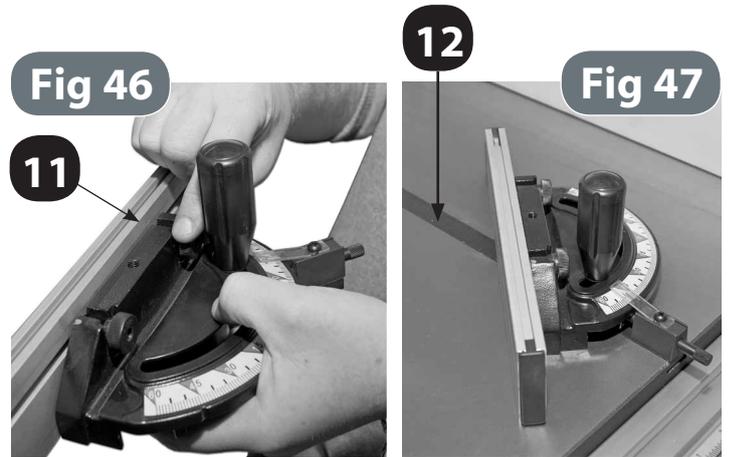


Mitre Fence

Locate the Mitre Fence and Extension (11), loosen the clamping screw knobs on the extension and slot each into the slot recesses on the mitre fence,

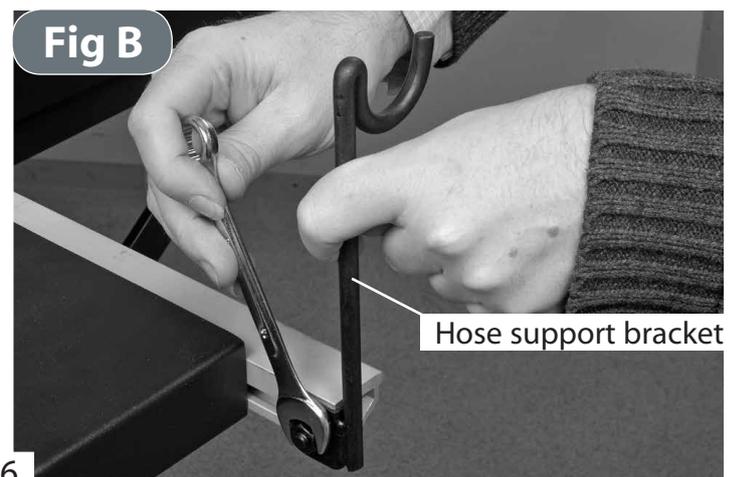
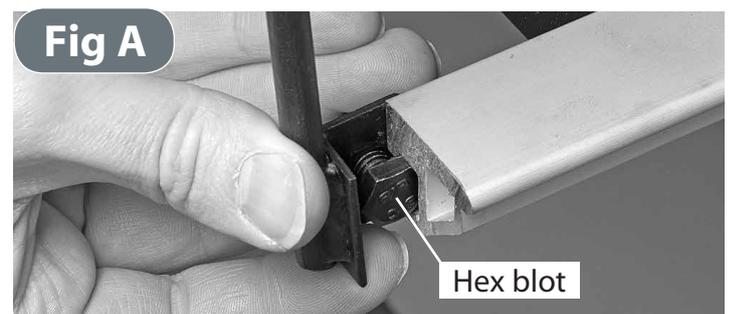
tighten to clamp the extension in place. (See fig 46) Introduce the nose of the bar (12) into the required 'T' slot in the main table. (See fig 47)

Note: With the rear extension table fitted it is not possible to push the small mitre fence completely through. However, the travel is such that the fence is able to travel well past the cutting edge of the saw.



Hose Support Bracket

Locate the hose support bracket and the Hex bolt/nut. Insert the bolt through the pre-drilled hole in the bracket and loosely screw on the nut. Insert the bolt into the end of the rear guide rails 'T' slot, see fig A until the bracket support is up against the guide rail. Tighten the nut to secure the assembly in position. (See fig B)





WARNING!! THE EXTENSION TABLES ARE VERY HEAVY YOU WILL REQUIRE A SECOND PERSON TO HELP!

951538 10" and 951541 12" Table Extension Kits (Box 1 of 2)

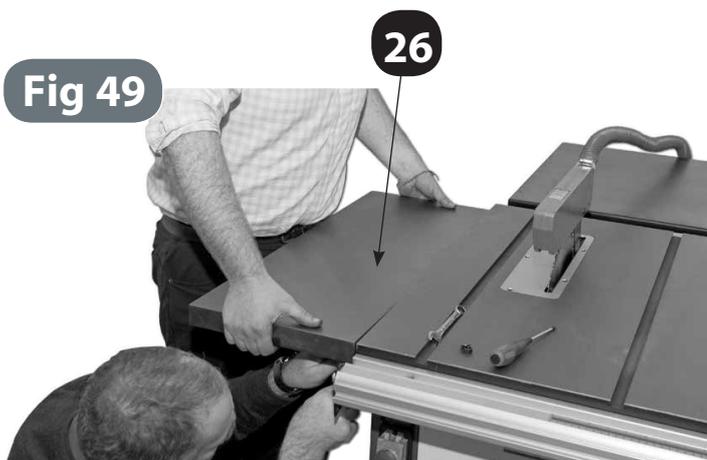
Setup 1

Select one of the extension tables **(26)**, locate four M8 x 30mm hexhead bolts and washers **(30)**. Ensure the table is correctly orientated (the front edge of the table is bevelled). Stand the back end of the table on the floor, close to the front and edge of the main saw table **(1)**, with the underside of the table facing the front of the saw. Lift the table up and introduce a washered bolt through the first hole in the table and screw it into the first threaded hole along the main table edge.

Fig 48



Fig 49



Screw the bolt in until it is almost home. You can now relax the lifting effort. The extension will hang pivoted on the bolt. Carefully lift the bottom end of the extension up until the edges are level and introduce a bolt and washer through the rear hole and the last threaded hole in the table edge, screw

it almost home. The extension should be hanging approximately in its correct position held by the two bolts. Introduce and almost screw home the other two bolts and washers. Using a level, align the top and front edges at the front of the saw, nip the front bolt to hold the extension in place; carefully manoeuvre the rear of the extension to align the two top edges and 'nip' the rear bolt.

Check this movement has not disturbed the alignment at the front of the table, if it has, repeat the procedure until the front and top edges are aligned. Tightened all the bolts securely. (See figs 48-49-50 and 51) Repeat using the other extension table **(26)** for the opposite side of the saw bench **(1)**.

Fig 50



Fig 51



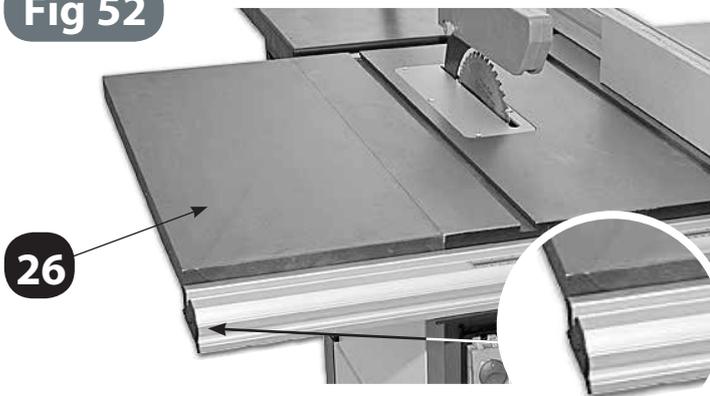
Initial Assembly

501196 10" and 501197 12" Table Extension Kits (Box 2 of 2)

Locate the long Rip Fence (front rail) (32) and (back rail) (33), remove the short rip fence front and back rails (22-23) from the saw bench (1), (follow the instruction on pages 14 and 15, "Rip Fence Assembly" to assemble the long rip fence rails.

NOTE: Make sure the both rip fence rails are parallel to the far left of the left extension table (26), (See fig 52). Replace the rip fence assembly (20) on the saw bench (1), as described on page 15.

Fig 52



The left extension table, with both fence rails parallel to the edge.

Fig 53



Table Extension Kit, (Setup 1) assembled

Setup 2



The Left extension table (26) can be repositioned to the end of the right extension table to create a large surface area, in doing so it also free's up the space to attach the sliding table assembly (code no: 951539).

First remove the rip fence assembly (20) and place safely aside, loosen both rip fence rails (32-33) and slide them to the right. Undo the four M8 x 30mm hex bolts and remove the left table. Attach the left table to the right table using the four M8 x 30mm bolts, washers and nuts as before, (**WARNING: YOU MUST ENSURE THAT THE NUTS IS FULLY ENGAGED ON THE BOLTS BY SEVERAL TURNS, BEFORE RELAXING THE LIFTING EFFORT**). Tighten all the bolts securely. (See fig 54)

Fig 54

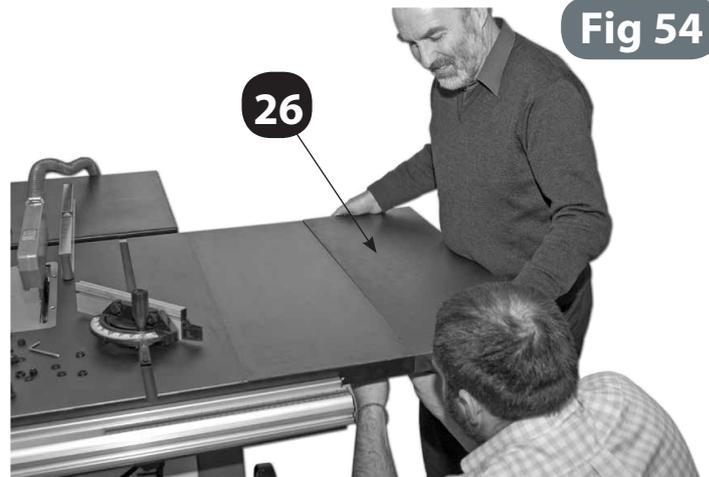
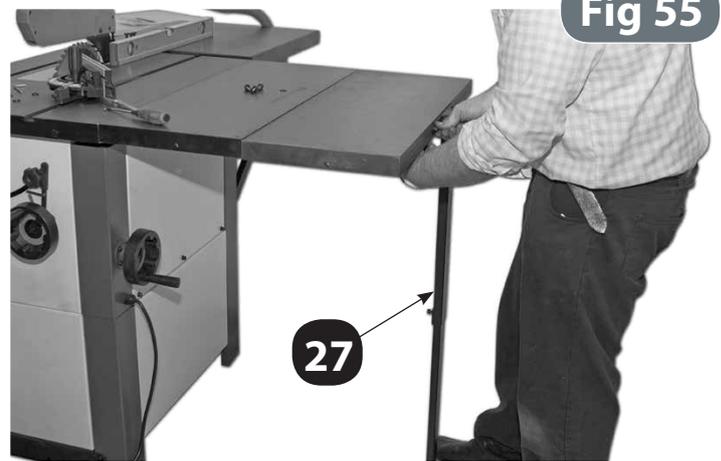
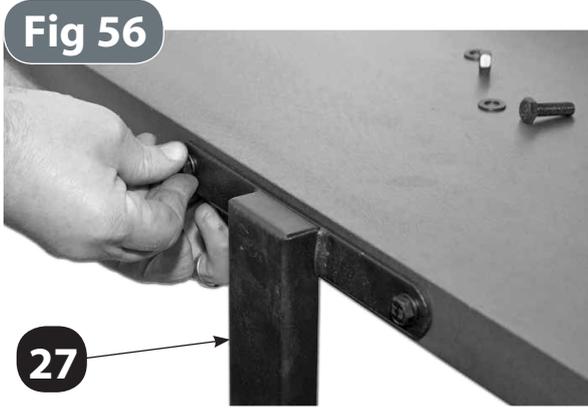


Fig 55

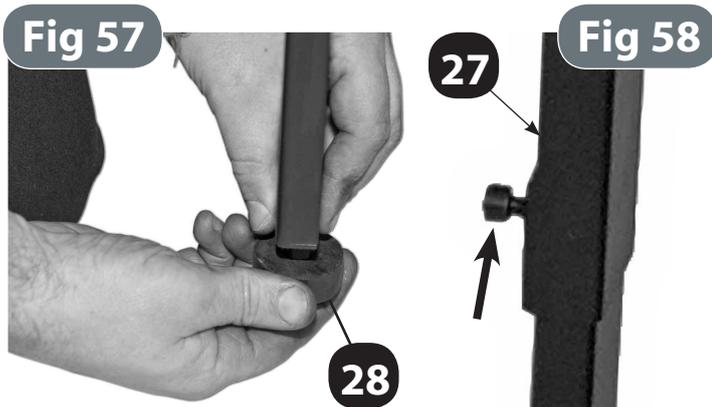


Locate the table support leg (27), the threaded rubber foot (28) and two M8 x 20mm hex bolts, washers and nuts (31).

Line up the two middle holes to outside edge of the table with the pre-drilled holes in the support leg bracket (27) and fasten securely using the M8 bolts, washers and nuts. (See figs 55-56)



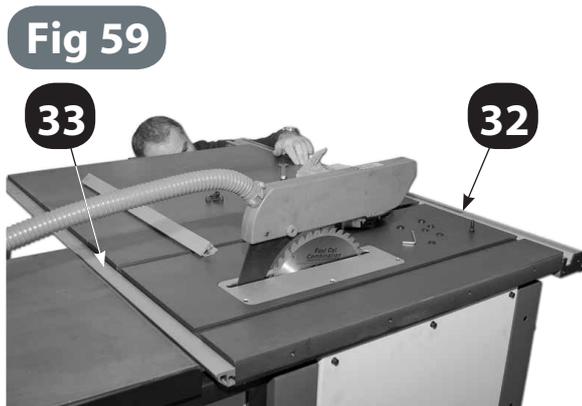
Screw the threaded rubber foot (28) on to the end of the support leg (27), until it's tight. (See fig 57) Unlock the caphead clamping bolt of the support leg and allow the inner section to slide through until the foot is resting on the floor. **DO NOT put the leg under tension at this time.** 'Nip' up the clamp bolt (See fig 58)



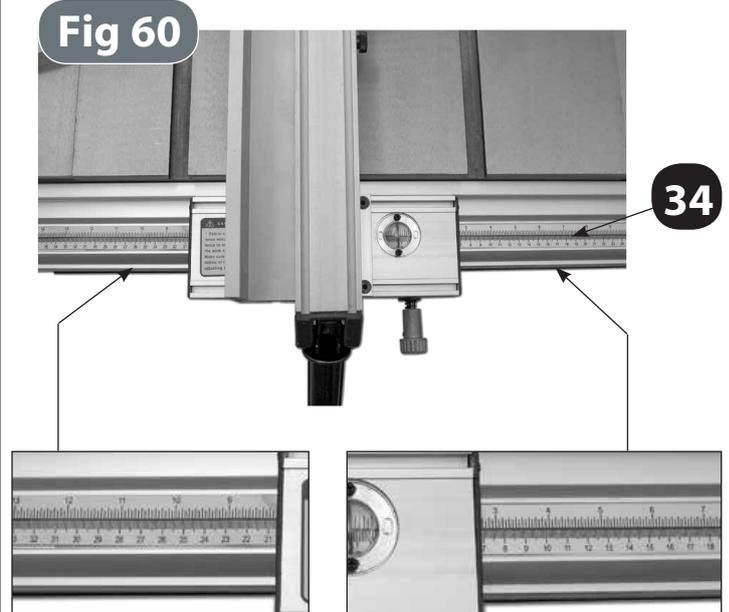
Support leg foot and caphead clamping bolt

Replace both long rip fence rails (32-33) as described on the previous page and replace the rip fence assembly (20) on the saw bench (1), as described on pages 15 and 18.

The Measuring Scale extension label (34) can be used for the different setup configurations. (See fig 60)



Replacing both rip fence rails

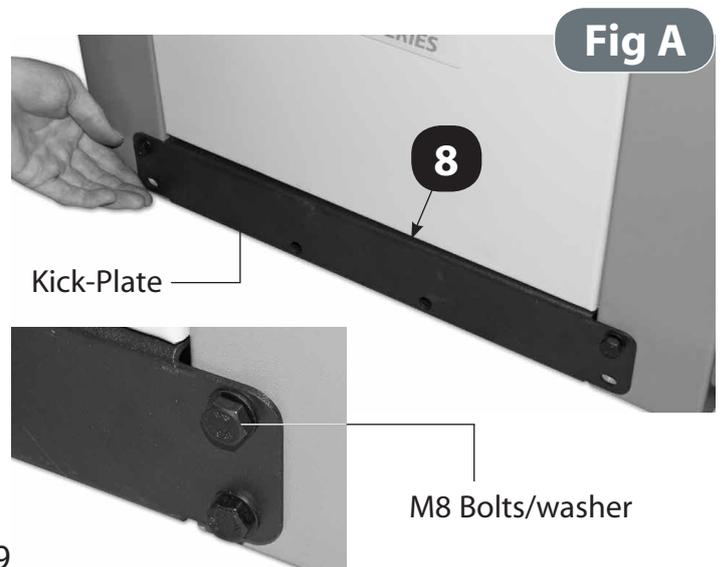


Measuring Scale Extension label



Table Extension Kit, (Setup 2) assembled

Locate the 'Kick-Plate' and the remaining four M8 bolts/washers. Line up the pre-drilled holes in the plate with the threaded holes to the front of the panel saw frame and secure with the M8 bolts and supplied spanner. (See fig A)



Initial Assembly

951539 10" and 12" Sliding Table Kits (Box 1 of 2) and (Box 2 of 2)

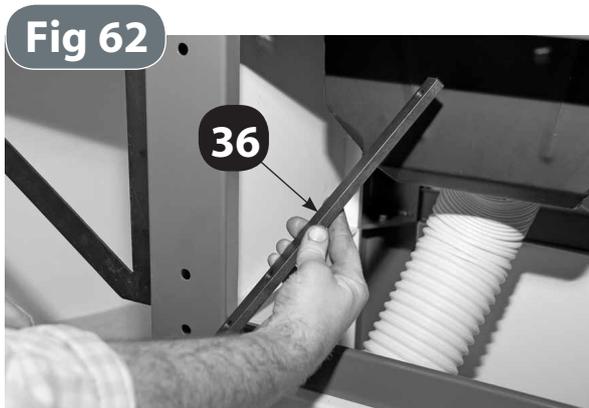


Mounting Bracket/Adjuster Block Assembly

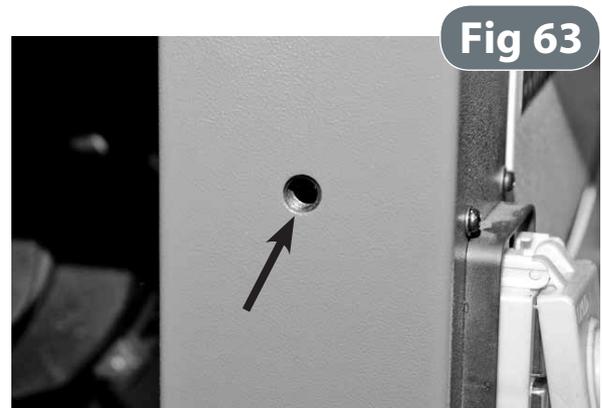
Locate and identify the mounting brackets (35) and the height adjuster blocks (45). These are mounted on the outside faces of the upper chassis legs. They are anchored against clamping the plates (36) that are behind the face of the legs.

NOTE: These clamping plates are 'loose items', each is initially held in place by three M10 x 19mm hex

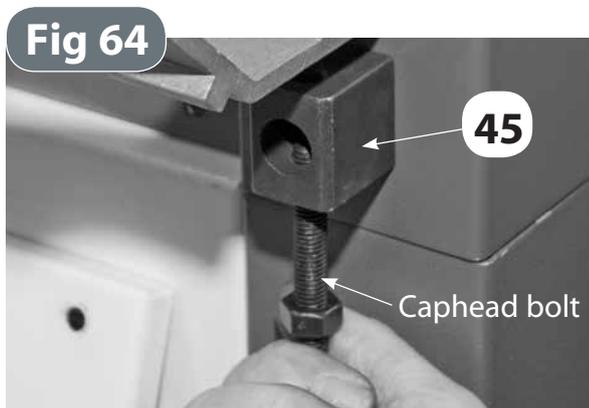
bolts (39). Unscrew the caphead bolt in the height adjuster block (45), see fig 64, until the recessed hole for the caphead bolt (39) is clear, fit it through the height adjuster block and screw it back into its position. Screw it almost home. Next fit a caphead bolt through the top hole of the bracket (35), and with the bracket tilted to one side, screw it back into its position. (See figs 62-63 and 65)



Line up the holes in the clamping plate in ready ness for fitting mounting bracket



Mounting plate in position



Unscrew the caphead bolt until the recessed hole is clear



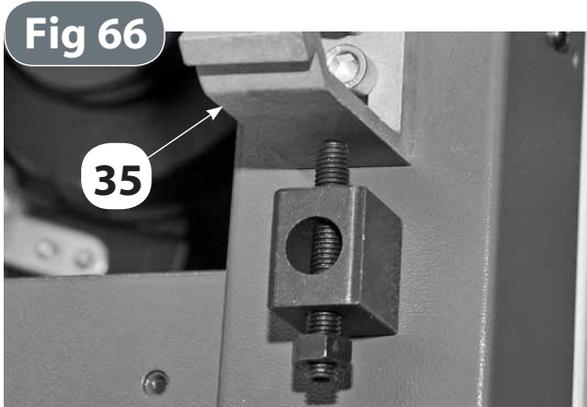
Attaching the mounting bracket (35) to the side of the saw bench (1)

Fit a bolt (39) through the bottom hole of the bracket, screw it back into its position. Align the adjuster block (45) as near vertical as you can judge and fasten the caphead bolt.

Screw the adjusting caphead bolt back through the block until it touches the lower face of the mounting bracket (35). (See fig 66) Nip the securing bolts for

the mounting bracket. Fit the other bracket in the same way. **NOTE:** When screwing the adjusting bolt back through the block, set it to leave the brackets at approximately the same height. (See fig 67)

Unscrew the slide rail assembly lift and shift handles (A) so that the square clamps have plenty of movement.



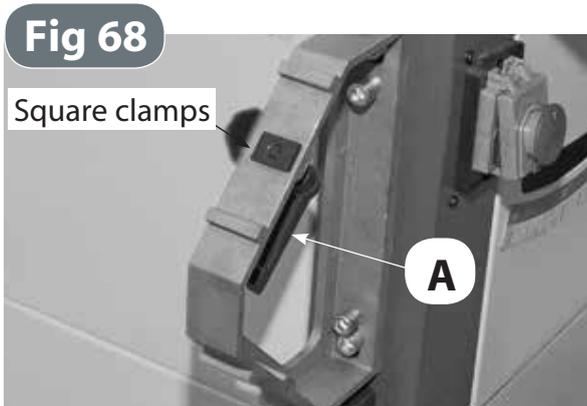
Screw the adjusting caphead bolt back through until it touches the lower face of the mounting bracket.



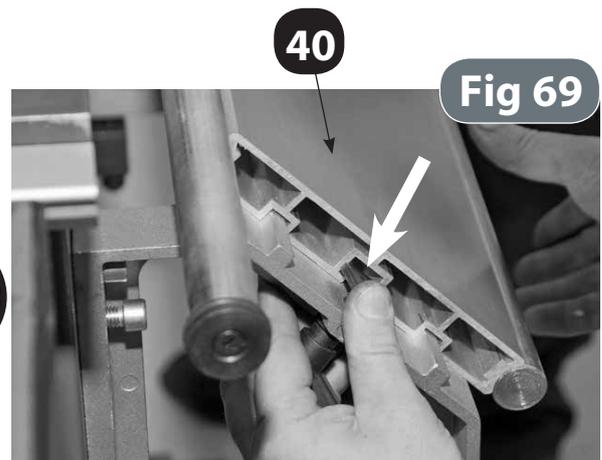
Leave the brackets at approximately the same height.

Slide Rail and Table Assembly

Locate the slide rail assembly (40), orientate it so that the longest rail is at the top, and the channels etc., of the extrusion are underneath. Offer it up to the front bracket (35) and introduce the square clamp into the main channel in the extrusion. The two open channels should fit over the guide lands on the bracket face. Slide the assembly forward and repeat the procedure with the rear bracket. Slide the assembly forward until it is set approximately equi-distant about the brackets; tighten the lift and shift lever handles (A) to 'pinch' the slide assembly (40) in place. (See figs 68-69 and 70)



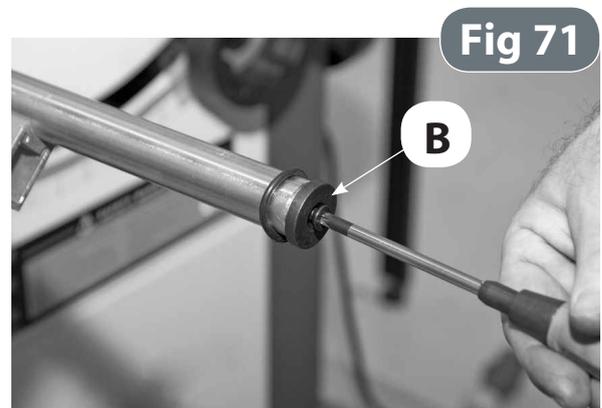
Unscrew the slide rail assembly lift and shift handles (A) to give the clamps plenty of movement.



Offer up the front bracket (35) and introduce the square clamp into the main channel of the slide rail (40).

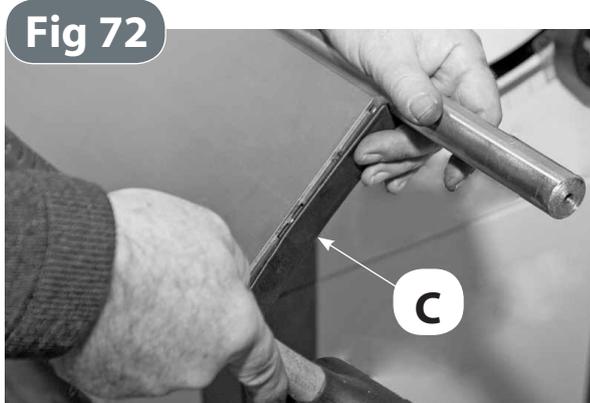


Remove the safety stop and the 'rubber buffer ring' (B) at the end of the top rail, place carefully aside. (See fig 71) Locate the clamping plates (C) and clip them to ends of the rail assembly (40) (See figs 71)

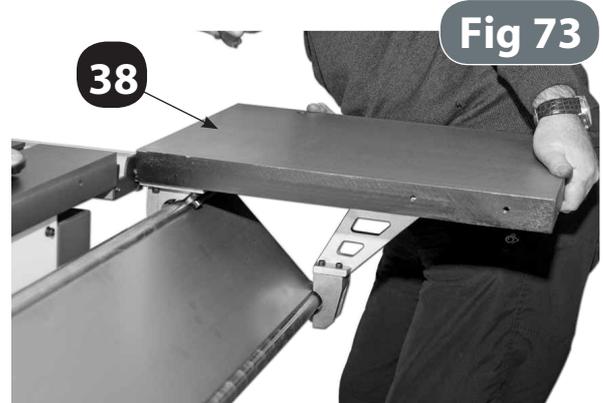


Initial Assembly

Locate the sliding table assembly (38) and manoeuvre the bearing bogies onto the rails (40), slide the table onto the rails and position it safely within the boundary of the table. (See fig 73) Ensure that the initial setting of the slide rail assembly will not cause the sliding table (38) to collide with the main table (1). Replace the buffer ring (B) and the safety stop.



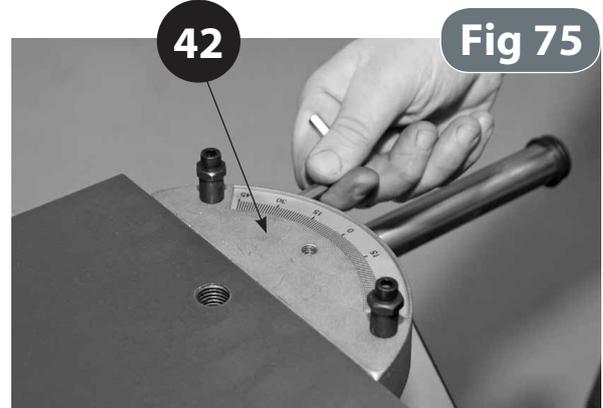
Locate the capping plates (C) for sliding rail and clip them in place



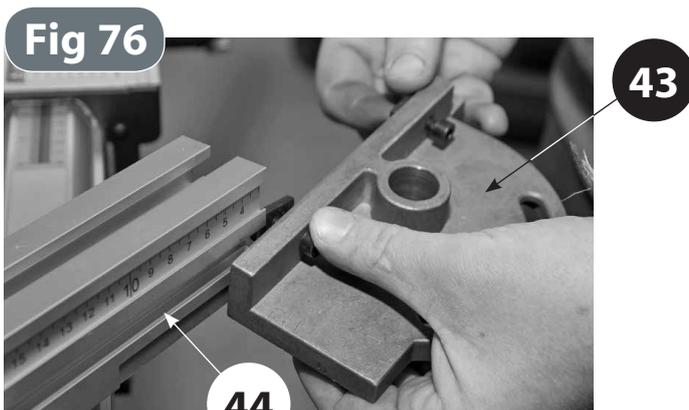
Slide the table onto the rails and position it safely within the boundary of the table.

Mitre Angle Rip Fence Assembly

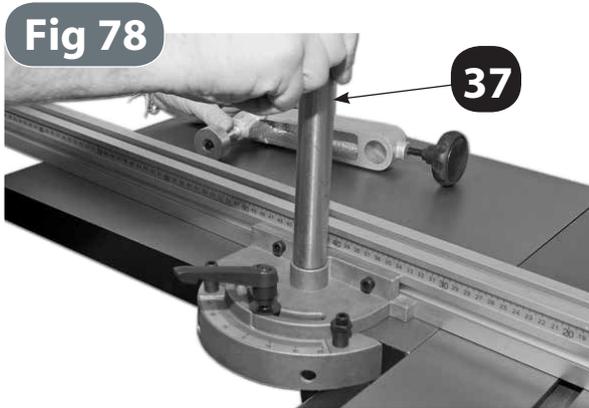
Locate the mitre angle rip fence assembly and mitre angle rip Fence (44). Remove the clamping handle and washer from the mitre angle rip fence assembly and place safely aside. Undo the two caphead bolts from the sliding table assembly (38) and bolt the mitre angle rear quadrant (42) to the table. (See figs 74-75)



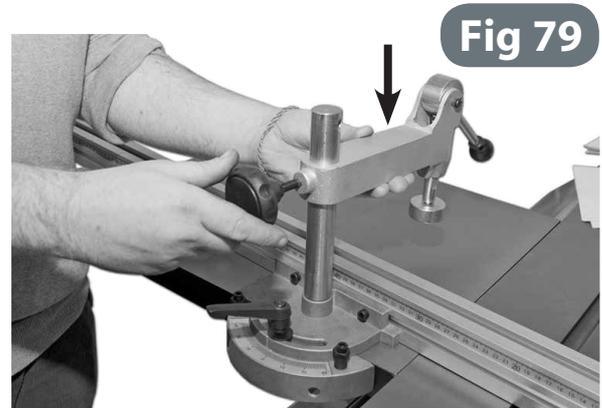
Loosen the two caphead bolts on the table fence mounting casting (43), allowing sufficient movement to be able to be slid into the extrusion in the rear of the fence. introduce the square clamps into the main channel in the extrusion on the fence (44), leave the caphead bolts loose at this time.(See fig 76).



Lower the fence mounting (**43**) onto the rear quadrant **NOTE:** position the fence so the sacrificial plastic orange tongue is against the table to the right of the mounting. Position the fence so when it is pivoted it will not encroach into the saw slot. Lightly tighten the two caphead bolts on the fence mounting (**43**). Replace the clamping handle and washer you removed earlier. (See fig 77)

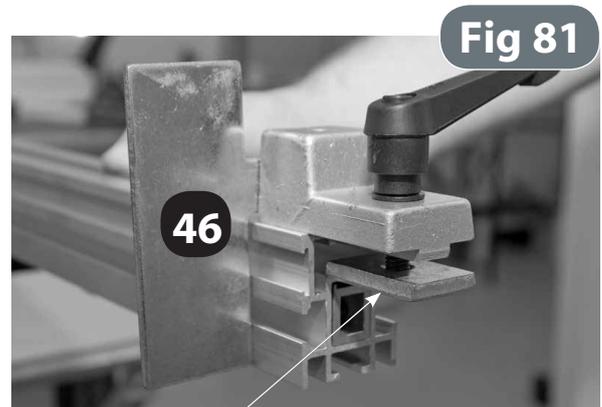


Screw the post into the tapped hole in the sliding table (**38**)



Fitting the workpiece hold down clamp onto the main tool post

Introduce the Tool Post (**37**) through the table fence mounting (**43**) and screw the post into the tapped hole in the sliding table (**38**) (See fig 78). The post is shouldered so it holds the Fence Mounting in position against the table. Fit the workpiece hold down clamp onto the main tool post and pinch up the clamping knob, see fig 79 and tighten the caphead bolts on the table fence mounting casting. (**43**) (See fig 80) Mount the distance stop (**46**) by introducing the square clamp into the wide channel in the top of the fence extrusion and clamp it in position using the lever handle. (See fig 81-82) Sliding table assembled. (See fig 83)



Square clamp



Setting the Machine

Setting the Tables



PLEASE ENSURE THAT BY NOW, THE SAW BENCH IS PLACED IN ITS WORKING LOCATION IN THE WORKSHOP.

Place a long straight edge (as long as ext. table plus 2/3 metres main saw table min.) along one long edge of the rear table and along the main table.

NOTE: The rear extension table brackets (7) can be moved up and down within the slotted fixing holes (A), and tilted forward or backward using the adjusting bolts (B) in the frames adjacent to the fixing bolts. Remember to loosen or tighten the adjacent fixing bolt if you are moving an adjusting bolt. (See figs 84-85)

Make sure all the fixing bolts are generally finger tight. Set the near corner of the table to the straight edge, by pushing, pulling, tapping etc. Nip the securing bolts. Move the straight edge to the other edge of the extension table, repeat the procedure. Now, if necessary, adjust the tilt to bring the far corner up to the straight edge, tapping the near edge down (or up), if

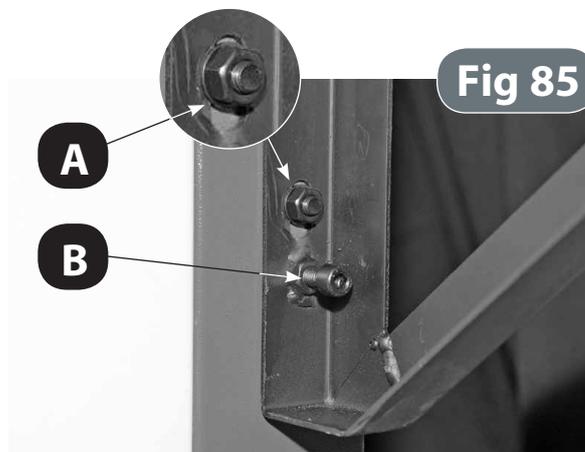
necessary. Move the straight edge back to the original edge and repeat the procedure. When the table is set tighten the fixing bolts securely, then check the table again. Repeat any part of the procedure if necessary.

Place the straight edge across the saw table (1) and the two extension table (26). (There may be some slight sag at the outer most edge of the tables due to their weight). If there is any falling off adjust the table support leg (27) to correct this. When you are satisfied that the main table and the side extension tables are in plane tighten the remaining four bolts that secure the front and rear rails.

Fig 84



Fig 85



Setting the Sliding Tables

NOTE 1. With the bracket fixing bolts in a loose condition ensure that the slide rail assembly is clamped flat to the brackets. Retighten the fixing bolts finger tight.

NOTE 2. The slide rail mounting brackets (35) can be moved up and down within the slotted fixing holes, using the height adjuster blocks (45) and 'tilted' forward or backward using the adjusting bolts in the frames, see fig 89 adjacent to the fixing bolts. **REMEMBER** to slacken the fixing bolts (A) off if you are adjusting the height, or carrying out a dramatic alteration, otherwise you may stress the bracket casting (35); loosen or tighten the adjacent fixing bolt (B) if you are adjusting the bracket 'tilt'. **REMEMBER** also that the final 'tighten' of the fixing bolts may alter the setting slightly. Re-check all settings after the final tightening. (See figs 86-87-88-89)

Fig 86



Place a level across the main and the sliding tables to check both are level

Fig 87



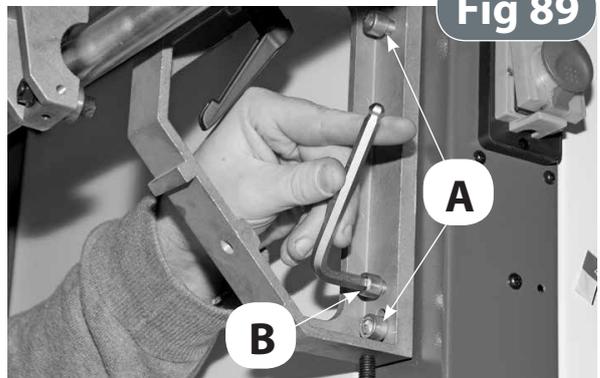
Place a level in the horizontal position on the sliding table and adjust until it's level

Fig 88



Use the height adjusting blocks to adjust the height of the sliding table

Fig 89



The mounting bracket (36) fixing bolts (A) and (B)

The overall setting process is done in 3 phases. 1) Setting the table level against the main table; front and rear. 2) Setting the sliding table/main table gap, to ensure a parallel feed. 3) Raising the sliding table slightly proud of the main table. The reason it is done in this manner and this order, is that phases 1) and 2) are interactive e.g. tilting the sliding table to bring it level can change the gap between the two tables, (See fig 90) whereas if the tables are set level a uniform adjustment to the brackets, should not alter the level, merely the gap. (See figs 90 & 91) The final phase is only a 'jacking' exercise and should not affect the previous settings.

Make sure all the fixing bolts are generally finger tight.

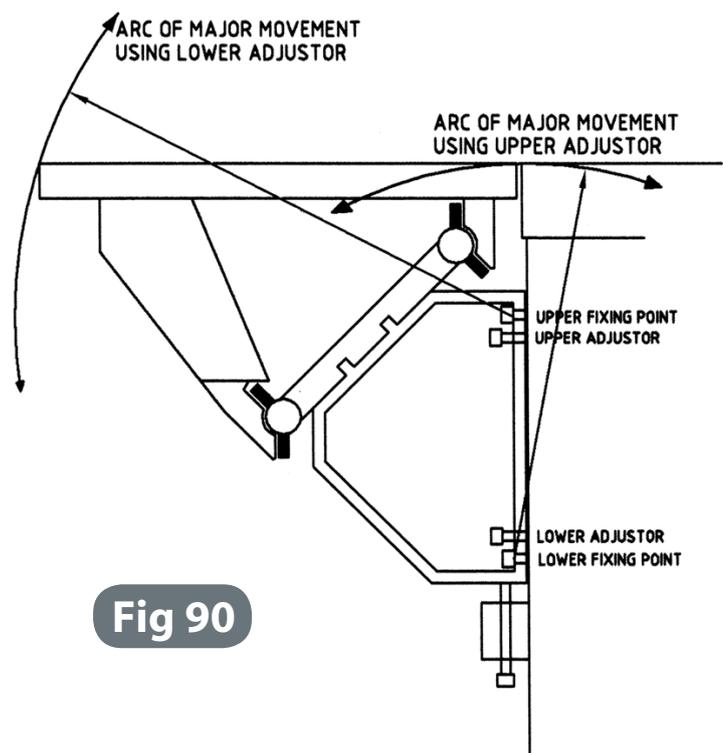


Fig 90

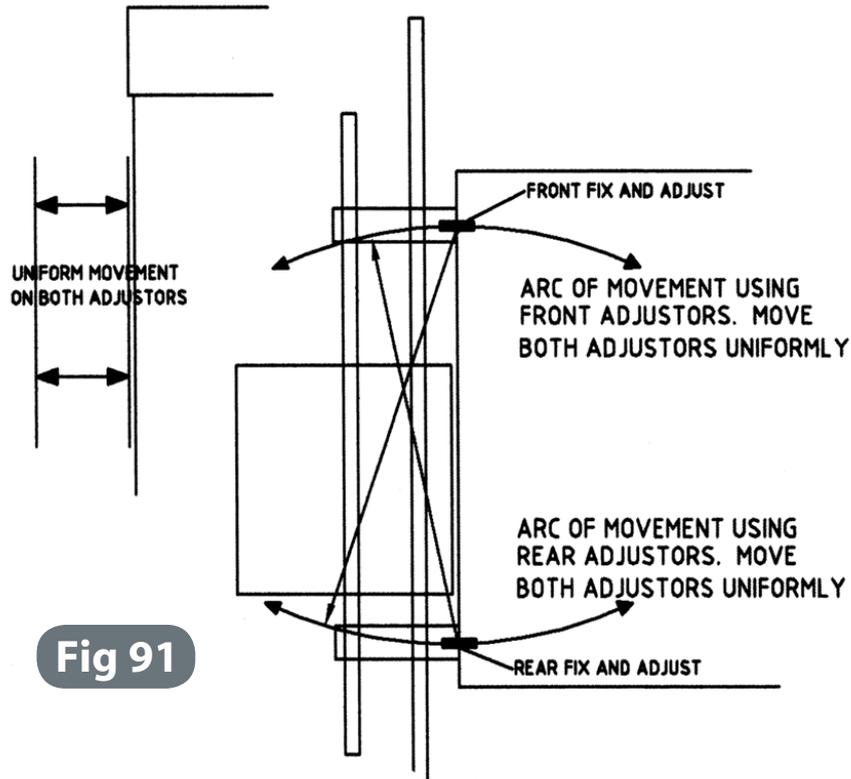
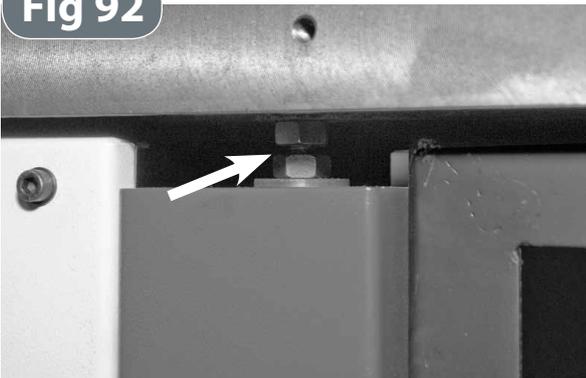


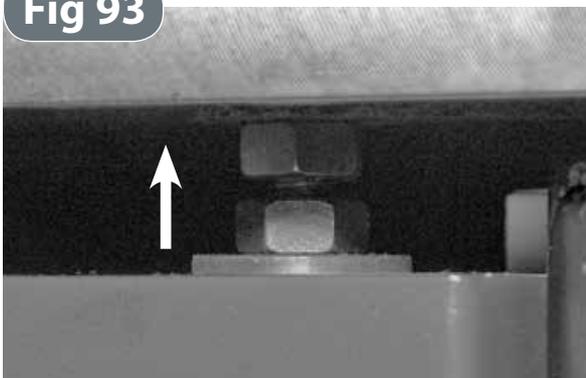
Fig 91

Fig 92



Main table height adjusting bolt, one to each corner of the table

Fig 93



'Jack' the table up by screwing both the height adjusting bolts UP approximately 3/4 turn.

Set the sliding table so that the front edge is in line with the front edge of the saw table. Place a long straight edge (a bit more than twice the width of the sliding table) along the front edges of the two tables. Set the near corner of the table to the straight edge.

Move the table and the straight edge to the rear of the **MAIN** table. Set the rear corner to the straight edge. Adjust the table to bring it level under the straight edge. Move the table and the straight edge back to the front of the main table and check the table is level; adjust if necessary. Once you are satisfied, and all the bolts are now 'nipped', slide the table back and forth and check the gap between the sliding table and the main table.

It should be approximately 2-3mm and uniform alongside the main table. Adjust as necessary, making uniform adjustments of the bolts in each bracket. Again, when you are satisfied; jack the table up by screwing both the height adjusting bolts up approximately $\frac{3}{4}$ turn (See figs 92-93). This will raise the table by something less than a millimetre and will reduce the drag of the workpiece at the main table edge, giving easier, more controllable movement. Check all bolts are tightened up, recheck all your settings.

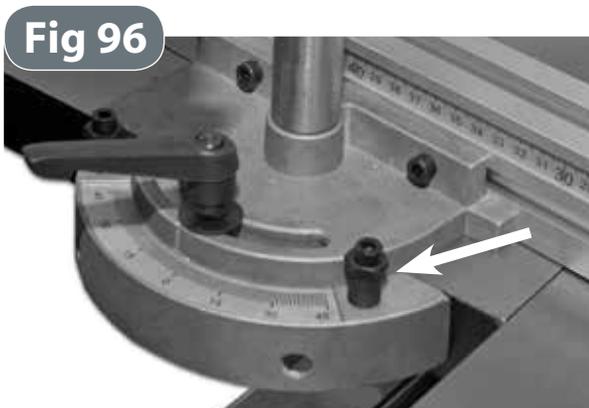
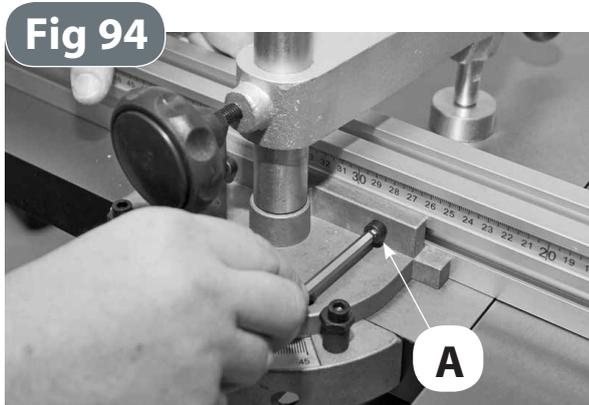
Setting the Angle Fence to the Saw Blade

Raise the blade to its maximum height, check that it is upright to the table. Set the sliding table fence to zero angle against the preset post. Slacken the two fence mounting bolts **(A)** and slide the fence up close to the saw blade. Fasten the two mounting bolts again. (See fig 94-95)

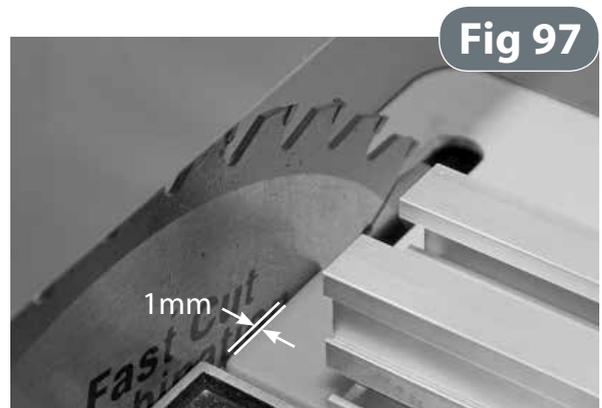
Using a known 90° square place it against the fence and the blade **(not on the teeth)**, and check that the angle is correct, if not, adjust the preset post on

the Mitre Angle Rear Quadrant. (See figs 95-96) This preset post is a small eccentric cam mounted on the shaft of a caphead bolt. By loosening the bolt and turning the head of the post with a spanner, the position of the stop can be altered. (See fig 96)

Check the angle again, continue to check and adjust until it is correct. Pivot the fence to the 45° stop. Using a mitre square, check the angle. Repeat the procedure as previously. Reset the saw to zero angle.



The preset posts on the mitre angle rear quadrant.



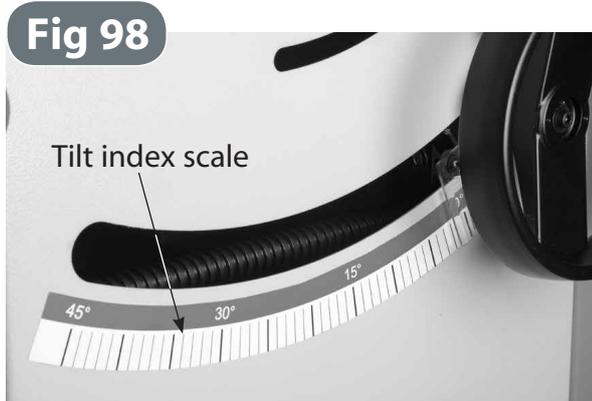
Set a 1mm difference across the face of the blade

Loosen the fence mounting bolts **(A)**, slide the nose of the fence (the orange tongue) up to the blade, secure. Check the parallelism of the sliding table movement by sliding the table forward and checking the tongue/blade are still in contact, or that the movement has not jammed the tongue against the saw. If there is a slight discrepancy, it may be acceptable to you (a 1mm difference across the face of the blade, see fig 97 (fully extended) is

about one quarter of a degree and pro rata. If not, or the discrepancy is too large, the slide rail assembly will need to be re-adjusted, to achieve a parallel motion. Set the distance stop to a predetermined measurement against the inset scale. Loosen the fence mounting bolts **(A)** and using a tape or a distance piece set the fence so that the saw blade to stop is that measurement. Tighten the mounting bolts securely.

Setting the Machine

Tilt the blade fully over. Using a mitre square, set the angle of the saw to 45°. Check that the index mark gives a corresponding reading against the scale. Adjust the pointer if necessary. Reset the blade upright, check that the angle scale reading is correct. (See figs 98-99)



Check that the index mark gives a corresponding reading against the scale.

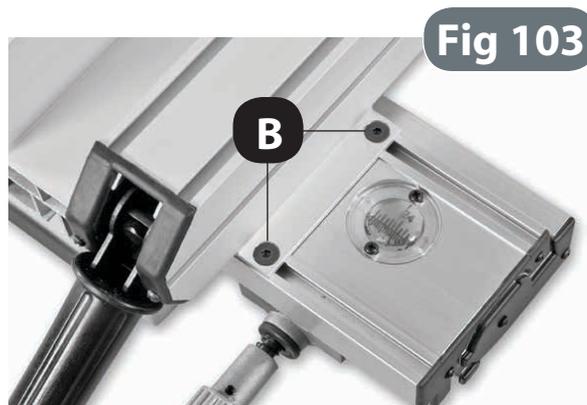
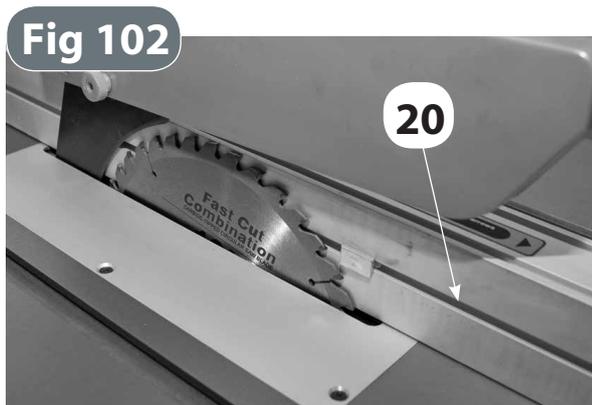


Set the rip fence a predetermined distance from the saw blade and lock in position. Check that the rip fence is held securely when it is locked in position. If the locking appears a little 'slack' adjust the position of the clamping lug at the rear of the rip fence by tightening the nut. **(A)** Check that the preset distance corresponds to the measurement on the scale against the index mark in the magnifying lens. If not, adjust the position of the rip fence on its mounting bracket.



Setting the Rip Fence (See figs 102-103)

Check that the fence **(20)** is parallel to the saw blade by sliding the fence up against it, press the clamping lever down to lock the fence in position. If you find the fence is not perpendicular to the blade loosen the four Hex screws **(B)** on the fence clamp assembly, see fig 103 and manoeuvre the fence until its square to the saw blade. Re-tighten the four Hex screws. **NOTE:** Lubricate the fence rails and the underside of the rip fence clamp assembly **(20)** with a ptfе dry lubricant, so the fence assembly runs smoothly back and forth.



Setting the Mitre Fence

Fit the small mitre fence (11) to the machine. Loosen the clamping handle (A).

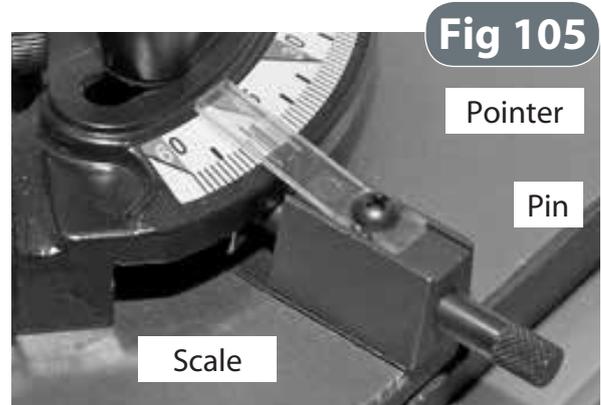
NOTE: There are 3 preset positions available with the small mitre fence. $+45^\circ$, 0° , and -45° , these are achieved using lugs in the casting and a push/pull pin against which the lugs are stopped. The pin has to be fully withdrawn to allow the fence to pivot from one side to the other.

Set the face to zero angle using the preset position.

Check that the angle is correct (and the lug is on the correct side of the pin). Check that the indexing pointer gives the correct reading against the scale. Adjust the pointer if necessary. Check left and right positions. Check the pointer is still correct. If the preset positioning is wrong, set the fence with a square/mitre gauge, set the pointer accurately against the scale and clamp the fence in position without recourse to the presets. Remove the small mitre fence from the table and stow carefully aside. (See figs 104-105)



Fit the small mitre fence (11) into the machines 'T' slot. Loosen the clamping handle (A).



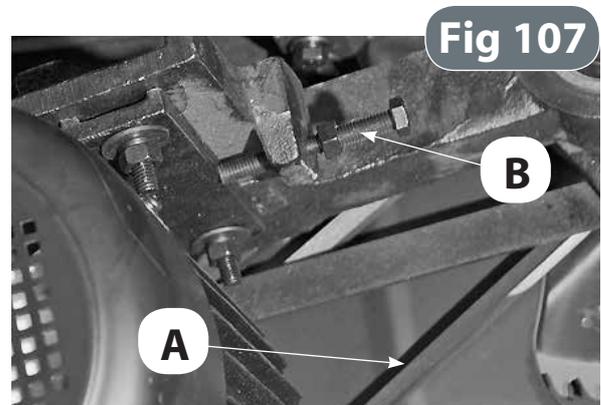
Check that the indexing pointer gives the correct reading against the scale.

Checking the Belt Tension

Check the belt tension, see figs 106-107, the belt should be tight, but not unduly so. Remove all tools and stow away. Check that the machine tables are clear. Lower the saw to leave about 25mm protruding, set the saw upright.



Motor assembly



Belt (A) and Belt tensioner bolt (B)



CHECK that everything that should be tight, is tight; saw blade guard, rise and fall lock mechanism, fence clamps etc.

Setting the Machine

Connect the machine to the mains supply, lift the switch shroud and give the machine a quick burst. i.e. On/Off. Check that everything is sound and feels O.K. (No knocking, scraping, belt squeal, rubbing etc.,)

Give the machine a longer run, and 'SLAP' the Emergency switch shroud down. Check that this gives a fast and easy method of switching the machine off, without searching for the stop switch button.

When you are happy that everything seems O.K. switch the machine off, disconnect from the mains supply. Locate the two upper side panels and their fixing bolts and secure them in place.

Specific Instructions/Precautions for the Saw Bench

Make sure the saw blade is the correct type for the job in hand.

Do not force the saw, if the saw begins to stall you are forcing the cut or over working the saw.

Ensure that the saw blade is clean and sharp. Resin build up on the blades will increase the friction of the saw passing through the timber, and cause over heating of the blade, blunt teeth will work harder tearing the fibre of the timber as opposed to shearing it, also with subsequent overheating. Both faults unnecessarily load the machine beyond normal usage, and shorten its longevity.

Do not use blades that are deformed in any way.

Do not remove the blade guard. The design of the riving knife on the machine will not allow for slotting or blind grooving, so there is no reason to remove the guard. There is adequate clearance under the guard for the capacity of the machine (75mm).

Do not remove the riving knife. **Do not** use any blades that cut a smaller kerf than the riving knife thickness.

Make sure the riving knife is correctly adjusted to the blade and is securely fastened.

If the table insert becomes damaged or broken, and will not support the timber 'up close' to the blade, replace it.

Do not start the saw with the workpiece touching the blade.

Do not commence sawing until the blade has run up to full speed.

After switching off, **never** try to slow the saw down more quickly by applying side pressure to the blade. **Apply** the old joiner's adage of never getting hands within one handbreadth of the blade. **Leave** the machine disconnected from the mains supply until you are about to commence work. Always disconnect the machine if you are leaving it unattended.

Never leave the vicinity of the machine unless the blade has come to a complete stop.

Do not attempt to carry out any maintenance, corrective work, setting up etc., unless the machine is disconnected from the mains supply.

If any tools have been used during setting up procedures, make sure they are removed from the machine and stowed safely away.

Do not attempt to carry out cross cutting operations freehand, always use the mitre fence for small stuff and the sliding carriage for larger work pieces.

Unless you are an experienced machine operator, do not attempt to rip freehand, always use the guiding facility of the rip fence. It is perfectly acceptable to support guide and feed the timber with your hands whilst ripping stuff of some length, however, as you approach

Specific Instructions/Precautions for the Saw Bench

the blade ensure that the push stick is to hand, and you use it.

Remember the emphasis of the push should be between the blade and the fence and close to the fence. Use your free hand to support and guide the material on the offside of the saw blade and at least 100mm away from it. If the timber does not extend to at least 100mm to the offside of the saw blade, the material possibly? does not need guiding or supporting.

Check (especially on site), that there are no

foreign objects e.g. old nails, screws, small stones etc embedded in the material you are about to cut. If necessary take a wire brush to the timber before working.

If you are being assisted whilst using the saw (by a take off or support number, remember there is only one sawyer at a machine, and they stand in front of it. The assistant does not push, pull, guide etc., unless specifically asked or instructed to do so by the sawyer.

Operating Instructions



NOTE: Before using your table saw, go round and make sure everything is secure, down, that all tool, are cleared away from the work area.



CHECK the blade for sharpness, missing teeth, resin buildup, etc., clean if necessary **CHECK** the blade is securely clamped in place. (i.e. not loose).



WARNING!

UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN THE WORK AREA AND KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN

Feeding Work by Hand



CONNECT A DUST EXTRACTION MACHINE TO THE SAW

Start up the saw, wait until it has reached full speed and slowly feed the timber through using both handles, (**making sure to keep your hands well clear of the blade and using a push stick for small pieces**), until the timber is behind the riving knife. Switch off the saw, wait until the blade has come to a complete stop and remove the timber. (See figs 108-109).

Fig 108

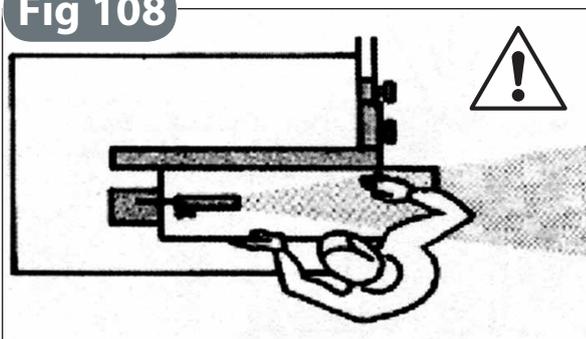


Fig 109



NOTE: Secure larger pieces of timber to the table by using the clamp assembly (37), see page 23.

Use the small flat surface of the fence (21) to cut thin timber narrower than 120mm. (**Use a push stick**).

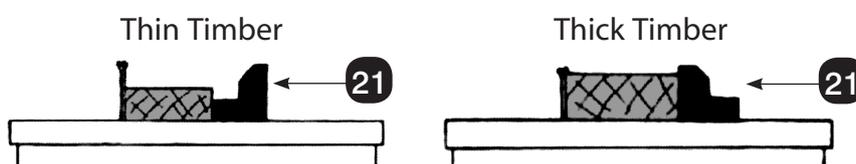
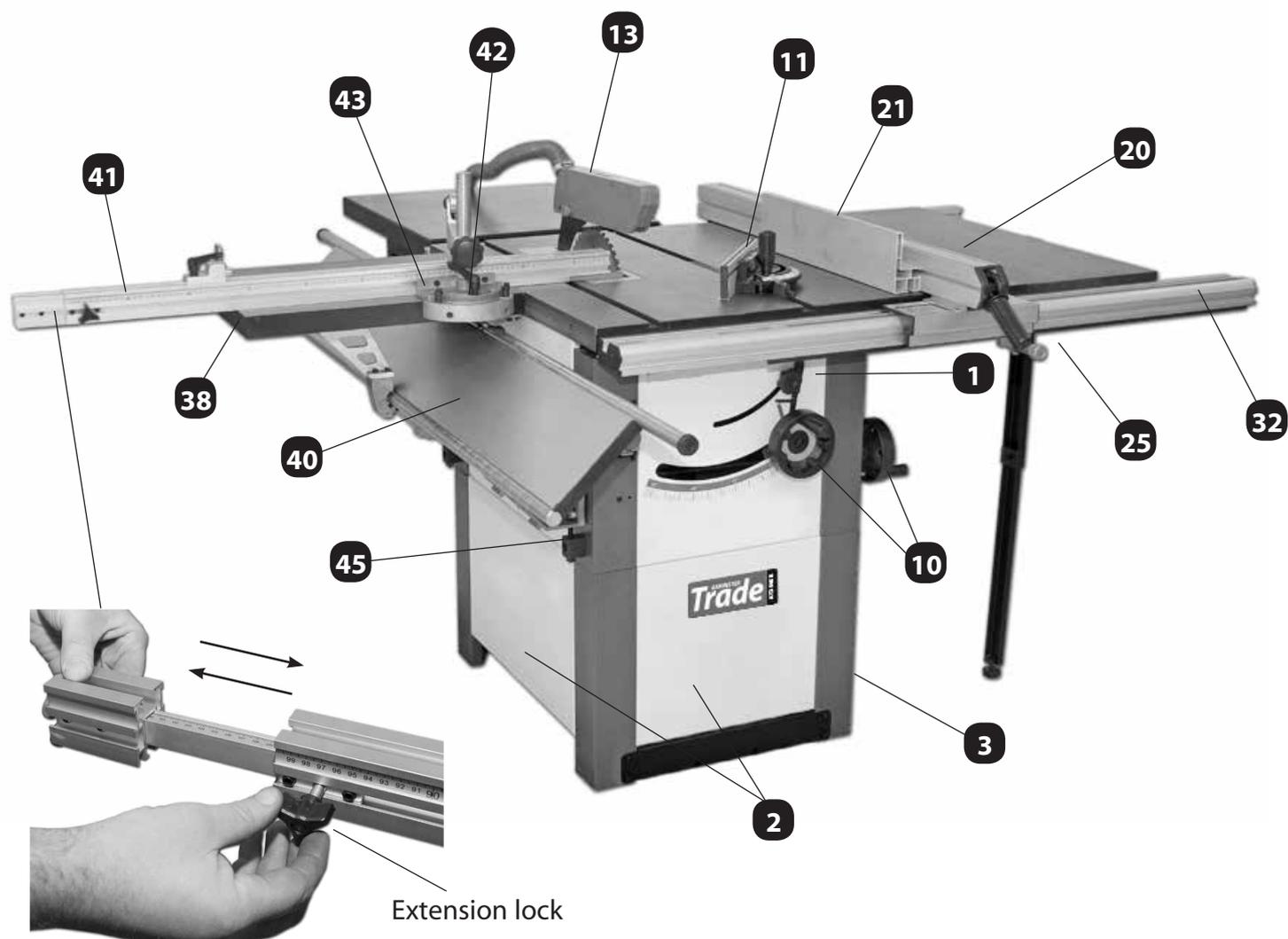


Illustration and Parts Description



1. Saw Bench	25. Micro Adjuster Assembly
2. Front and Side Panels	26. Extension Tables
3. Lower Leg Columns	27. Table Support Leg
4. Dust Extraction Moulding 100mm	28. Threaded Rubber Foot
6. Extension Table	32. Long Rip Fence (front rail)
7. Extension Support Brackets	33. Long Rip Fence (back rail)
10. Hand Wheels	37. Work Clamp and Tool Post
11. Mitre Fence	38. Sliding Table Assembly
13. Saw Guard	40. Sliding Table Rail Assembly
14. Riving Knife	41. Mitre Angle Rip Fence Assembly
17. 30mm Hose	42. Mitre Angle Rear Quadrant
20. Rip Fence Assembly	43. Table Fence Mounting Casting
21. Rip Fence Extension	45. Height Adjusting Block
	46. Distance Stop

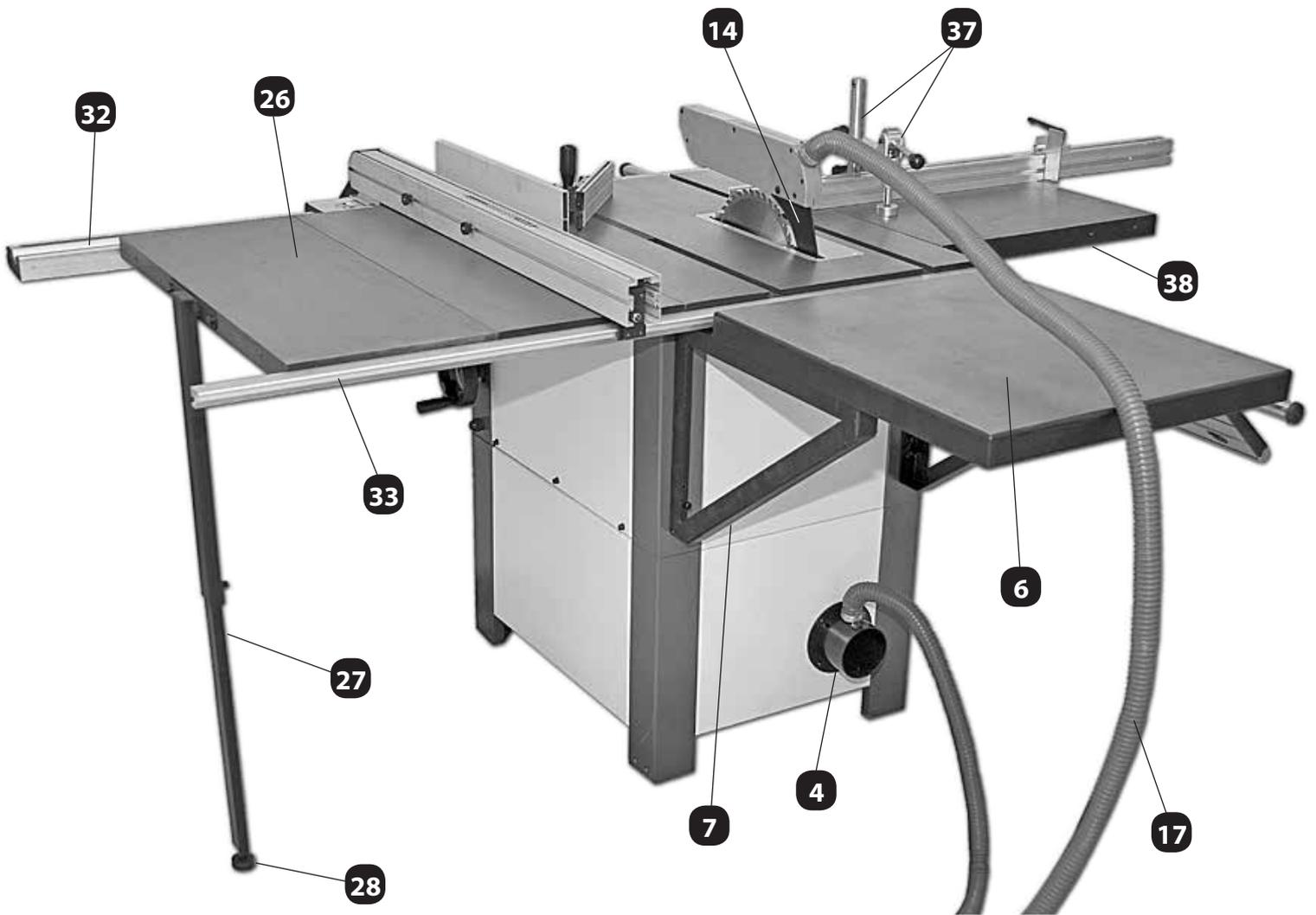
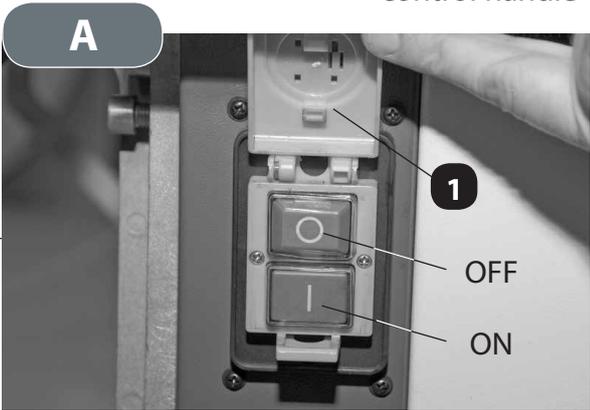
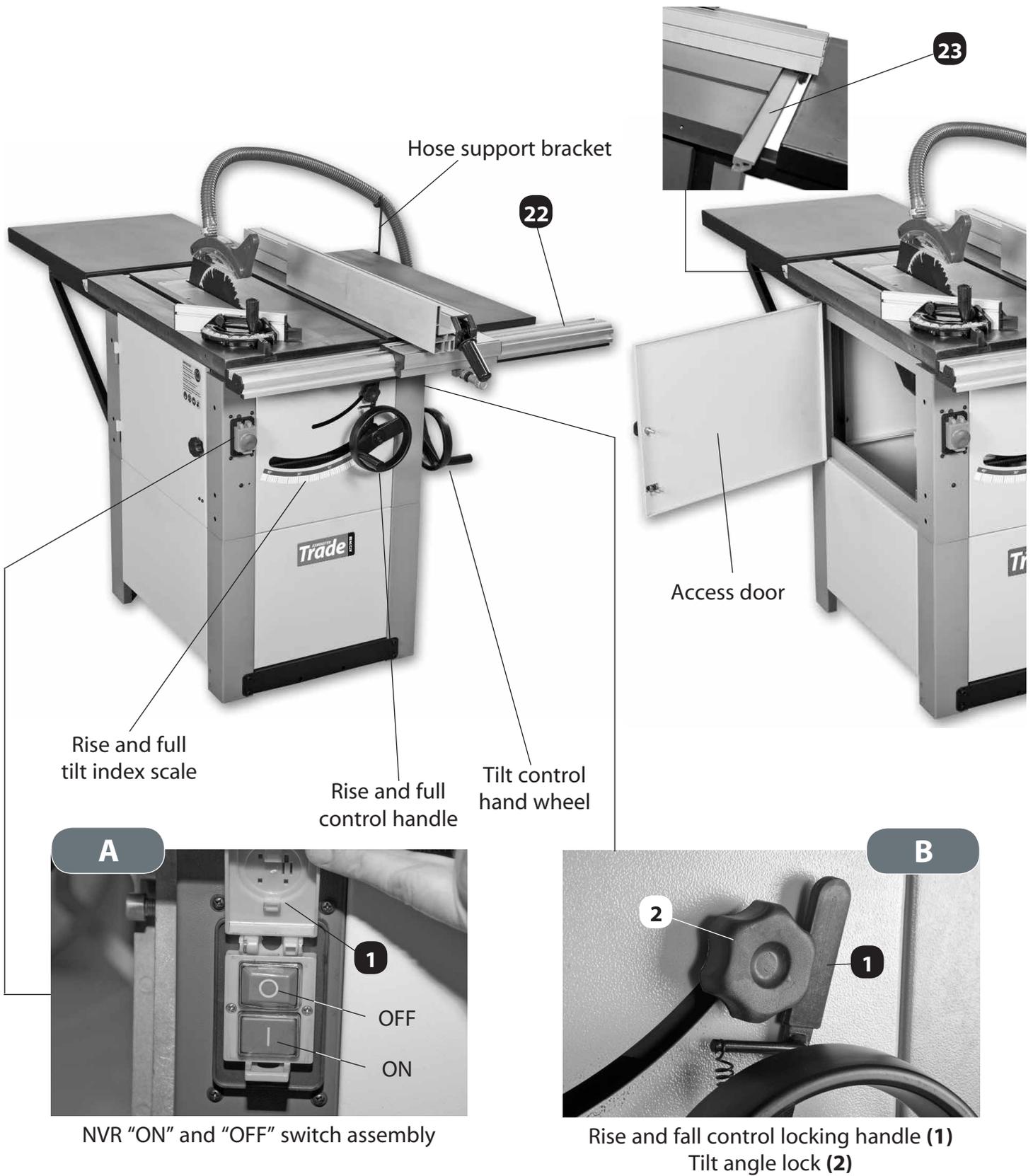


Table Extensions **Setup 1**

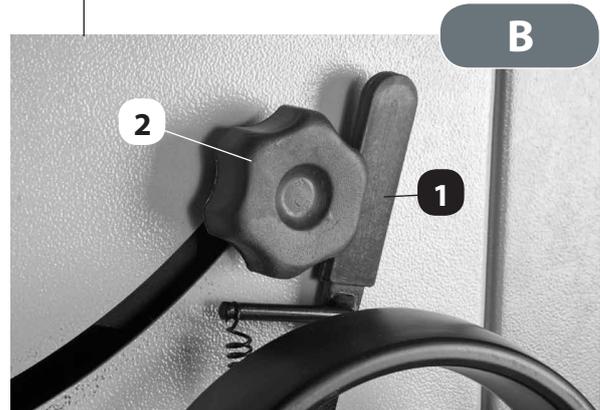


Table Extensions **Setup 2**

Illustration and Parts Description



NVR "ON" and "OFF" switch assembly



Rise and fall control locking handle (1)
Tilt angle lock (2)

22. Short Rip Fence (front rail)	23. Short Rip Fence (back rail)
A. NVR ON/Off Switch	B. Rise and Full Lock (1)
A. Emergency Stop Shroud (1)	B. Tilt Angle Lock (2)



WARNING! DISCONNECT THE MACHINE FROM THE MAINS!

Raise the saw blade to its highest point. Remove the saw blade guard. Remove the 5 screws that secure the table insert, place carefully aside and remove the table insert. **(A)** Using the spanner and the tommy bar provided, put the spanner onto the flats on the nut. Turn the saw until the tommy bar hole **(B)** is visible. Insert the tommy bar **(18)** and turn the saw to allow it to rest against the front edge of the saw slot. The tommy bar hole is in the inside platewasher component. (See figs 110-111-112)

Fig 110



Fig 111

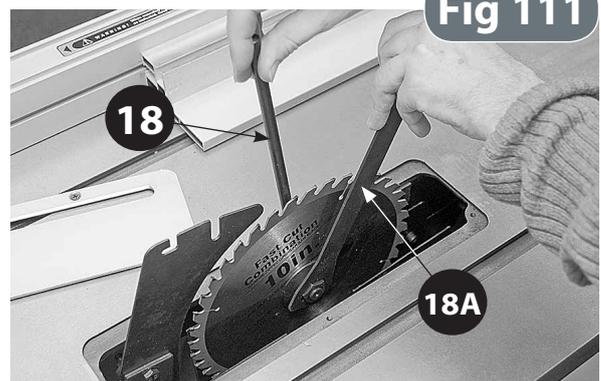


Fig 112

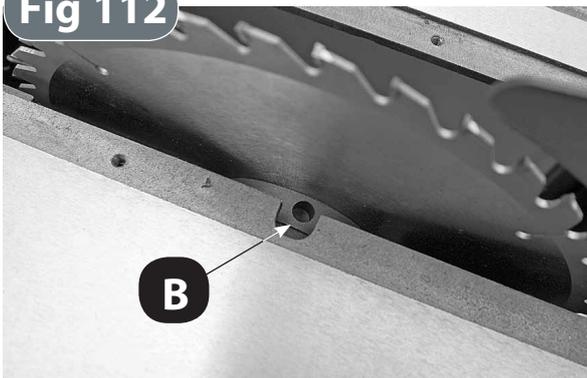


Fig 113

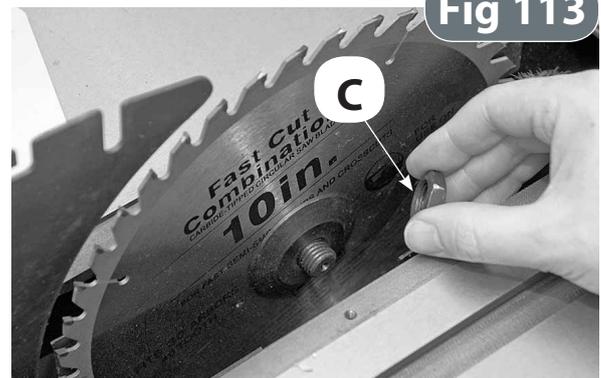
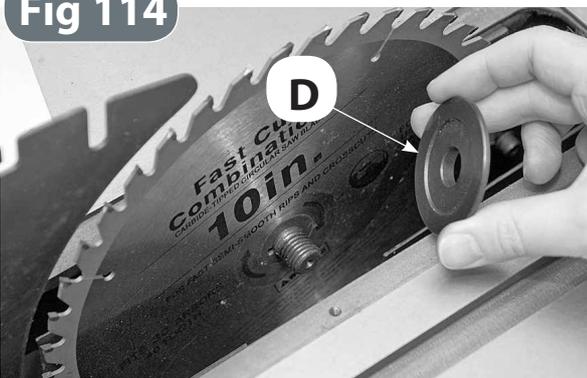
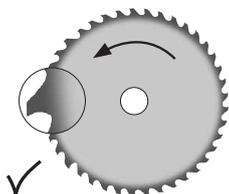


Fig 114



Slacken off the saw nut (remember left hand thread). Remove the saw nut **(C)**, then remove the sawplate washer **(D)** and the saw blade. Now is a good time to give the interior of the machine, the dust extraction channels, etc. a thorough clean. (See figs 113-114)

Check the new blade for damage, missing teeth, sharpness etc. Fit the new blade, ensure that the teeth are pointing towards the front of the machine. (See fig 115) Put the sawplate washer onto the shaft and twist on the saw nut. Spin the nut up finger tight and check the saw is correctly seated.



Teeth forward

Fig 115

Changing the Saw Blade

Tighten up the saw nut, using the tommy bar to hold the shaft steady. Check the riving knife is aligned with the saw blade, and correctly positioned. Replace the table insert and secure with the 5 screws. Replace the saw blade guard. When everything is satisfactory, turn the saw blade once by hand to check it doesn't foul anywhere. Reconnect the machine to the mains supply.

Give the machine a 'quick' burst check (i.e. quick ON-OFF) to ensure everything is O.K. If everything is satisfactory, continue to use the machine. Check the old blade for sharpness, missing teeth, resin buildup, etc., clean if necessary and send for refurbishment/resharpening if required. If the blade is not to be re-sharpened, clean and pack away in its stowage case.

Maintenance

Keep the saw as clean and free from saw dust build up as is practical. Periodically, remove the saw gullet and vacuum out and clean out the saw box and the extraction housing. Remove any resin build up in the saw box, using a proprietary resin cleaner.

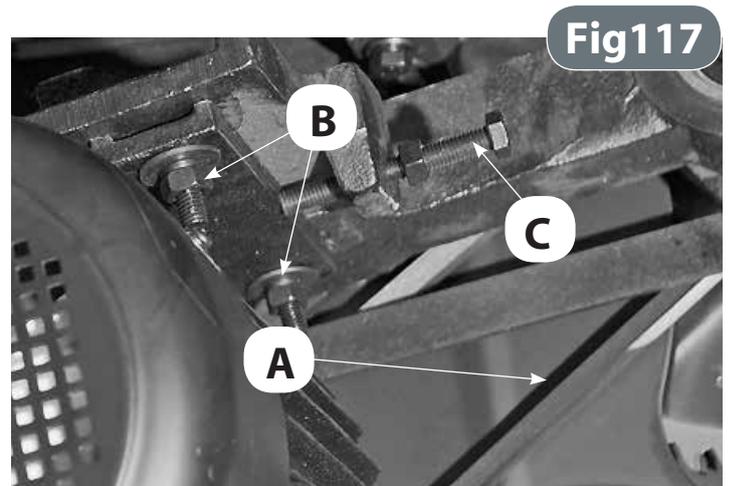
Remove the upper side panels and clean the threaded drive shafts of the rise and fall and tilt mechanisms. At the same time check the belt drive, i.e. the belt is not 'glazing' with resin build up, likewise with the pulley wheels. Check the belt tension. If the belt **(A)** is becoming slack, loosen the motor hold down bolts **(B)** and drive the motor

backward with its adjusting bolt **(C)**. (See figs 116-117) Check the saw blade regularly for chipped, missing, damaged teeth etc. and remove any resin build up from the blade, riving knife etc.

If you have finished using the saw bench, clean above and below the work table and using a damp cloth wipe the saw bench over. If the saw bench is not going to be used for a period of time, use a rustproofing spray (see our catalogue), spray a light coat over the work table and place a dust sheet over the saw bench.



Motor assembly



Belt **(A)**, Motor hold down bolts **(B)** and Belt tensioner bolt **(C)**

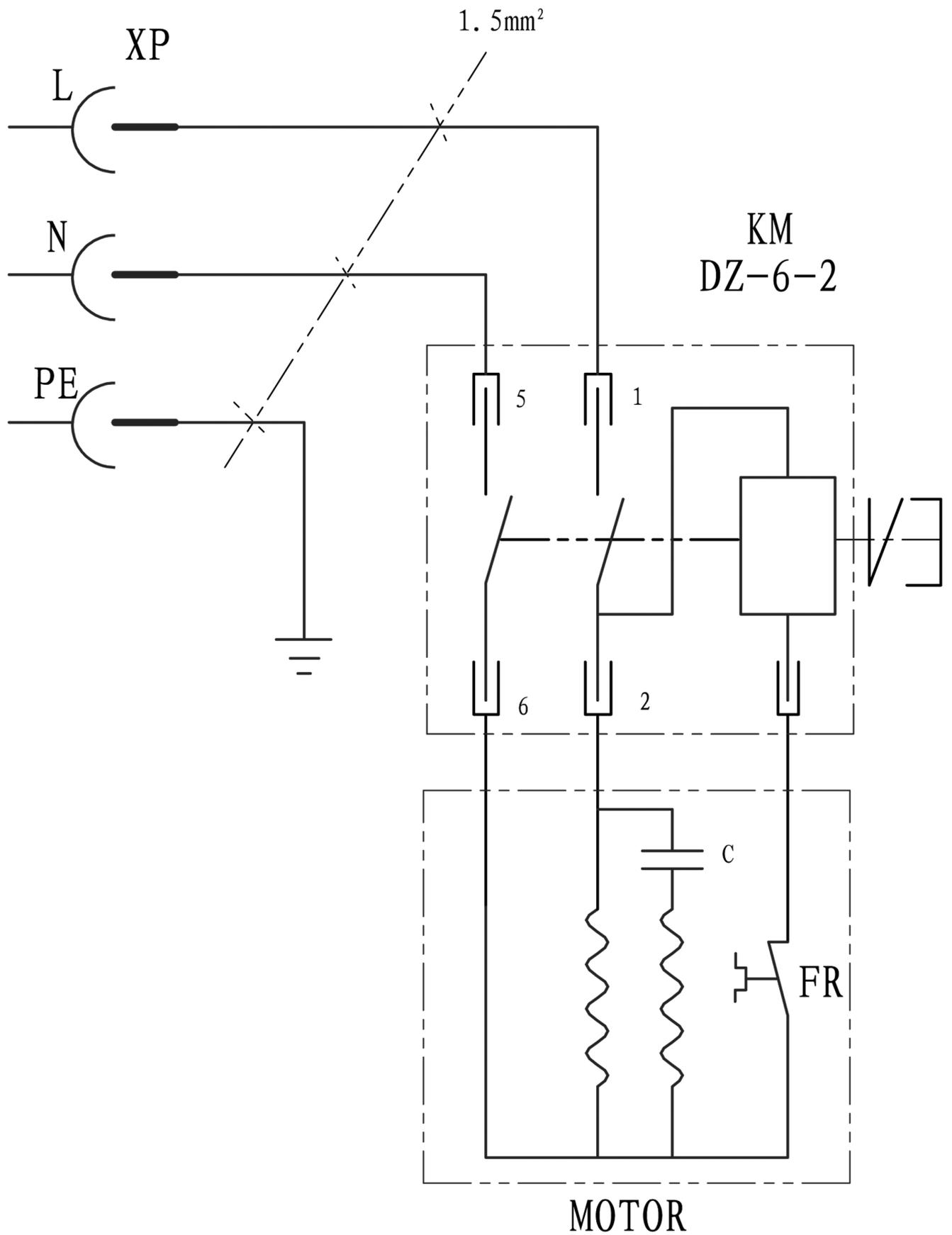
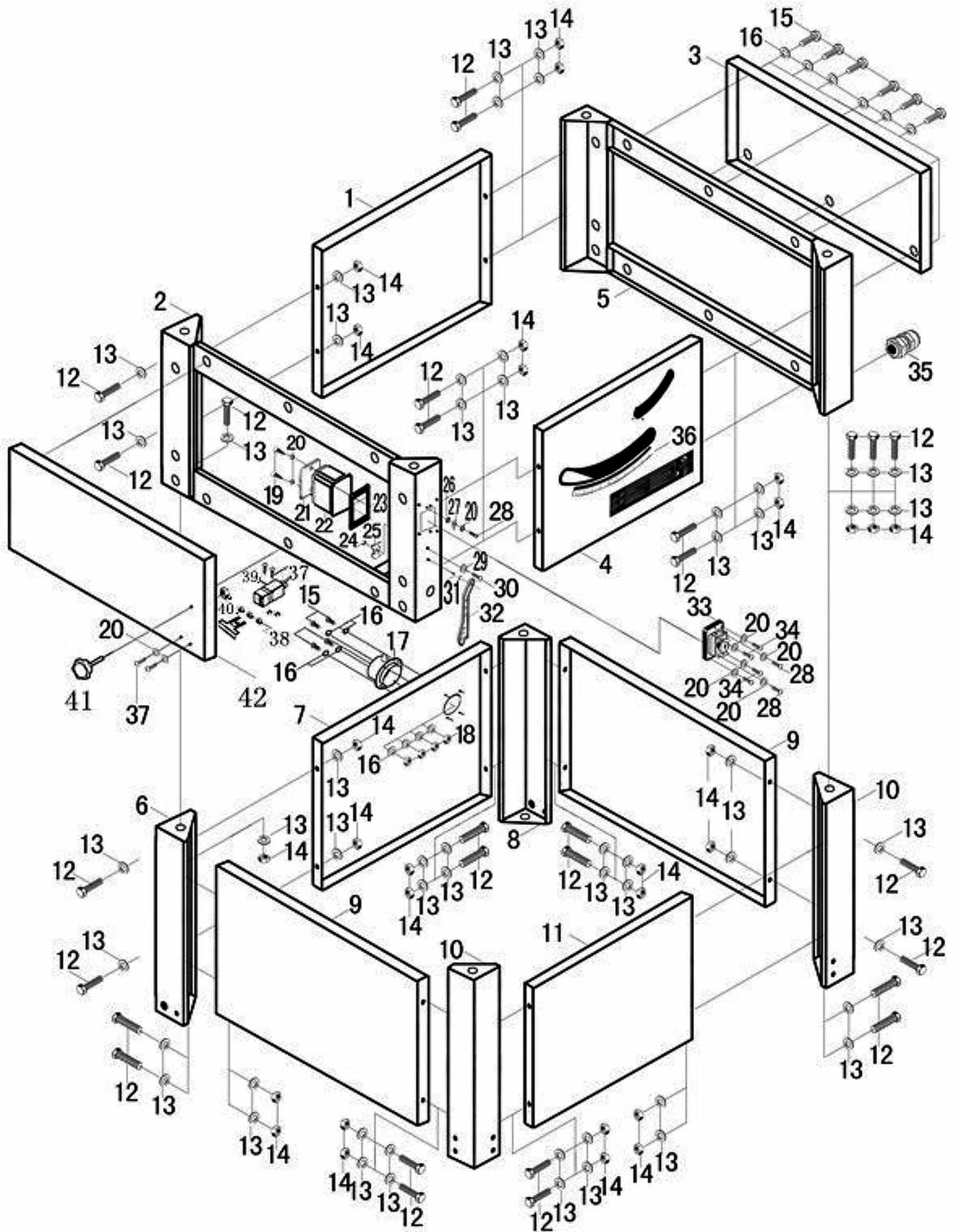


DIAGRAM A



NO.	DESCRIPTION	Qty
A-1	Front panel	1
A-2	Left frame	1
A-3	Side panel	2
A-4	Real panel	1
A-5	Right frame	1
A-6	Left leg	1
A-7	Front side board	1
A-8	Right leg	1
A-9	Right and left side board	2
A-10	Real leg	2
A-11	Real side board	1
A-12	Hexagon head bolt M8X20	28
A-13	Washer 8	56
A-14	Hexagon nut M8	28
A-15	Cross recessed pan head screw M6x22	16
A-16	Washer 6	20
A-17	Tie-in	1
A-18	Hexagon nut M6	4
A-19	Pan head tapping screw ST4X12	2
A-20	Washer 4	11
A-21	Switch bottom board	1

A-22	Switch house	1
A-23	Rubber washer of switch house	1
A-24	Hexagon nut M5	1
A-25	Wire strain	1
A-26	Externalteeth lock washer	1
A-27	Earth-plate	1
A-28	Cross recessed pan head screw M4X10	3
A-29	Washer 5	1
A-30	Cross recessed pan head screw M5X20	1
A-31	Nut	1
A-32	Push stick	1
A-33	Switch	1
A-34	Cross recessed pan head screw M4X16	6
A-35	Cablegland	1
A-36	Label	1
A-37	Cross recessed pan head screw M4X30	2
A-38	Nut M4	4
A-39	Microswitch	1
A-40	Lock nut M8	1
A-41	Flower handle	1
A-42	Door	1

DIAGRAM B Part 1

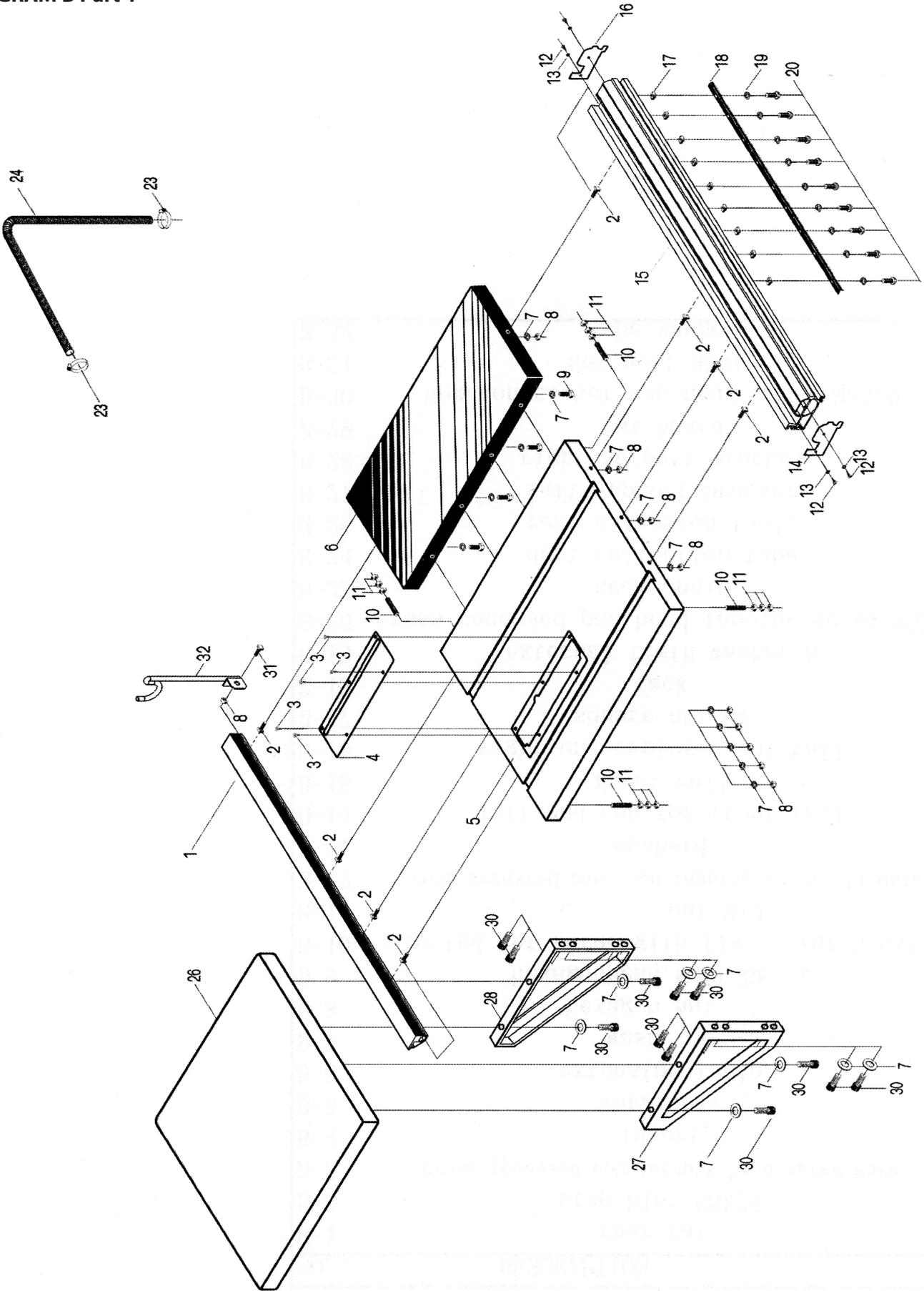
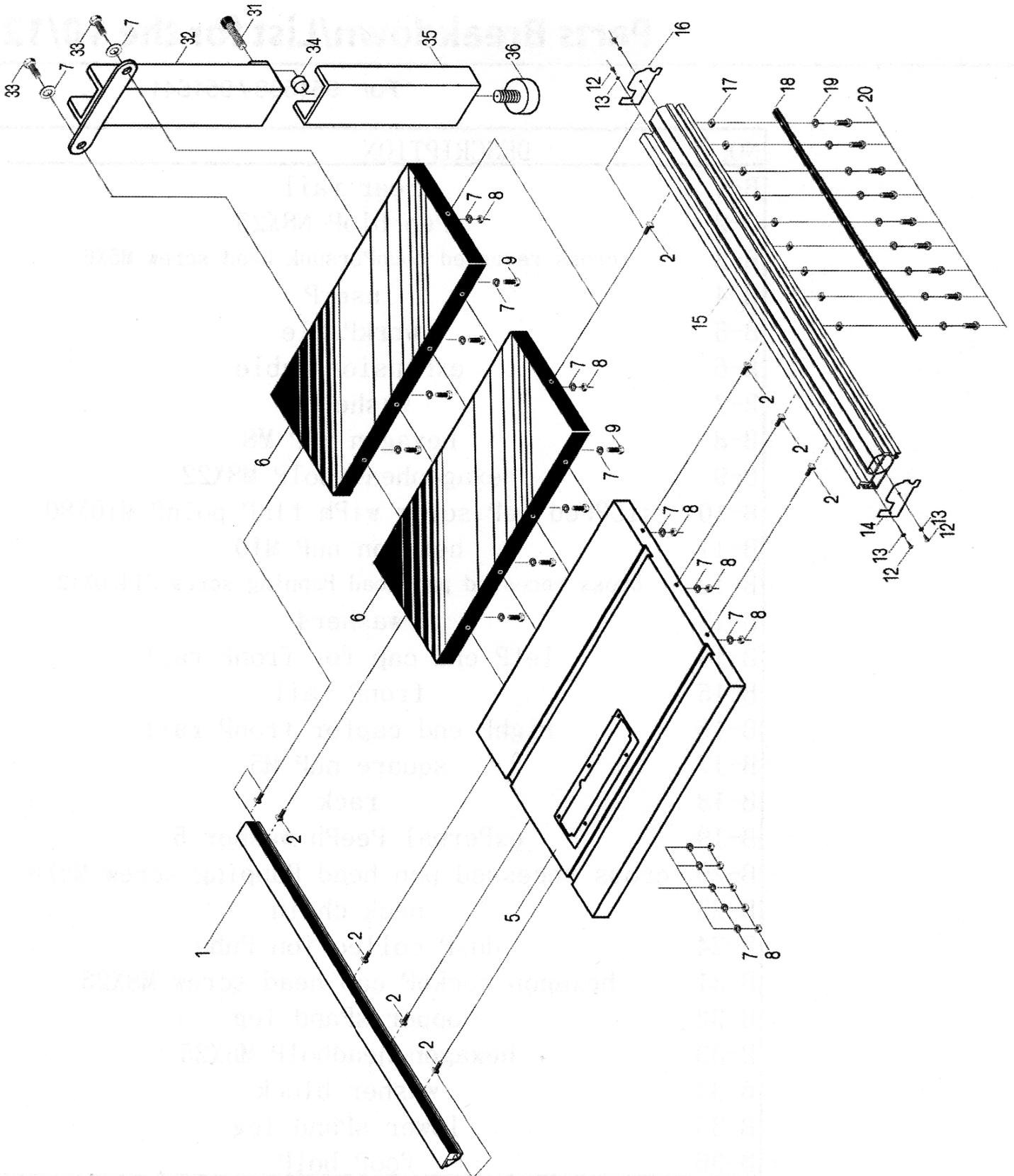


DIAGRAM B Part 2



Exploded Diagrams/Lists

DIAGRAM B Part 1

NO.	DESCRIPTION	Qty
B-1	Rear rail	1
B-2	Step blot N8X25	10
B-3	Cross recessed countersunk head screw M5X6	5
B-4	Insert	1
B-5	Worktable	1
B-6	Extension table	2
B-7	Washer 8	32
B-8	Hexagon nut M8	12
B-9	Hexagonhead bolt M8X22	8
B-10	Slotted set screw with flat point M10X80	4
B-11	Hexagon nut M10	12
B-12	Cross recessed pan head tapping screw ST4.0X12	4
B-13	Washer4	4

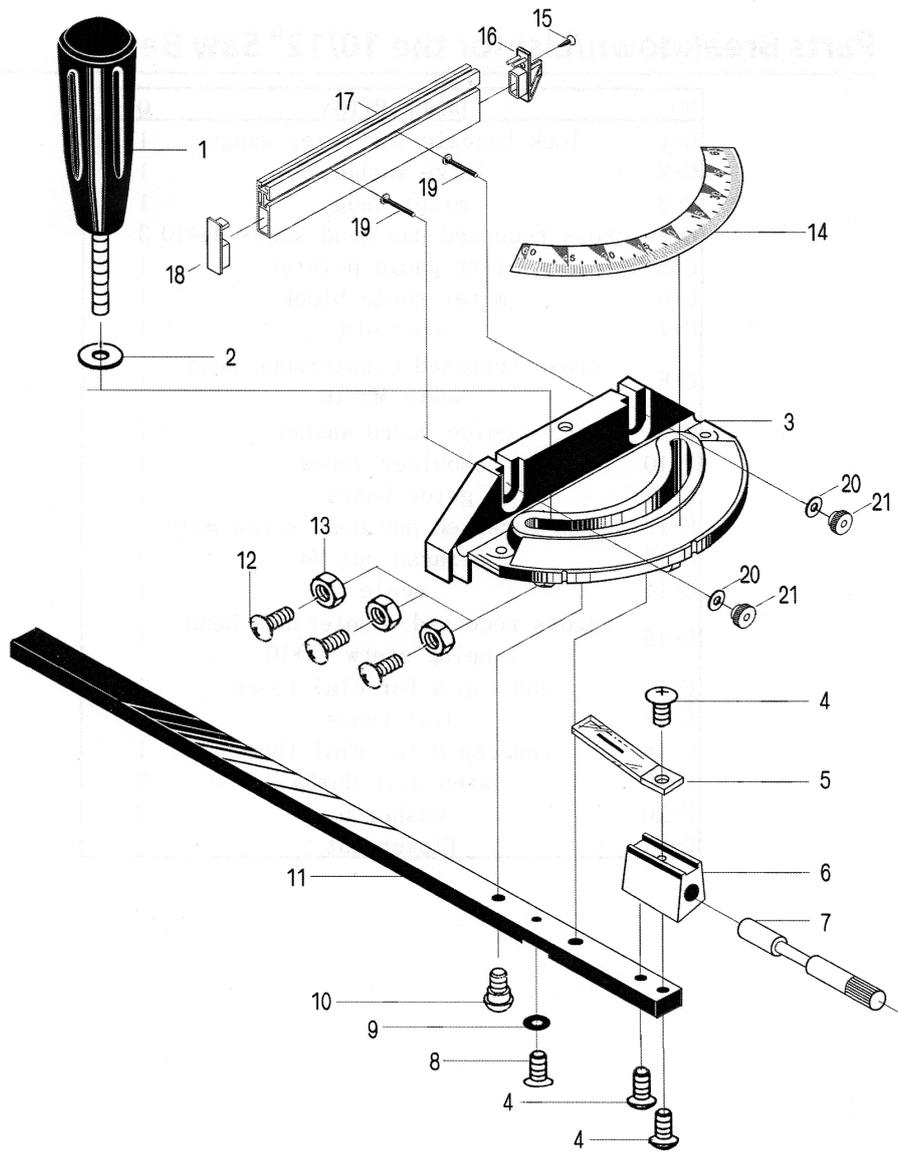
B-14	Left end cap for front rail	1
B-15	Front rail	1
B-16	Right end capfor front rail	1
B-17	Square nut M5	12
B-18	Rack	4
B-19	External teeth washer 5	12
B-20	Cross recessed pan head tapping screw M5X8	12
B-23	Neck chain	2
B-24	Dust collection tube	1
B-26	Rear extension table	1
B-27	Left support bracket	1
B-28	Right support bracket	1
B-30	Hexagon socket cap head screw M8X20	12
B-31	Hex bolt M8X12	1
B-32	Tube support	1

DIAGRAM B Part 2

NO.	DESCRIPTION	Qty
B-1	Rear rail	1
B-2	Step blot N8X25	10
B-3	Cross recessed countersunk head screw M5X6	5
B-4	Insert	1
B-5	Worktable	1
B-6	Extension table	2
B-7	Washer 8	32
B-8	Hexagon nut M8	12
B-9	Hexagonhead bolt M8X22	8
B-10	Slotted set screw with flat point M10X80	4
B-11	Hexagon nut M10	12
B-12	Cross recessed pan head tapping screw ST4.0X12	4
B-13	Washer4	4

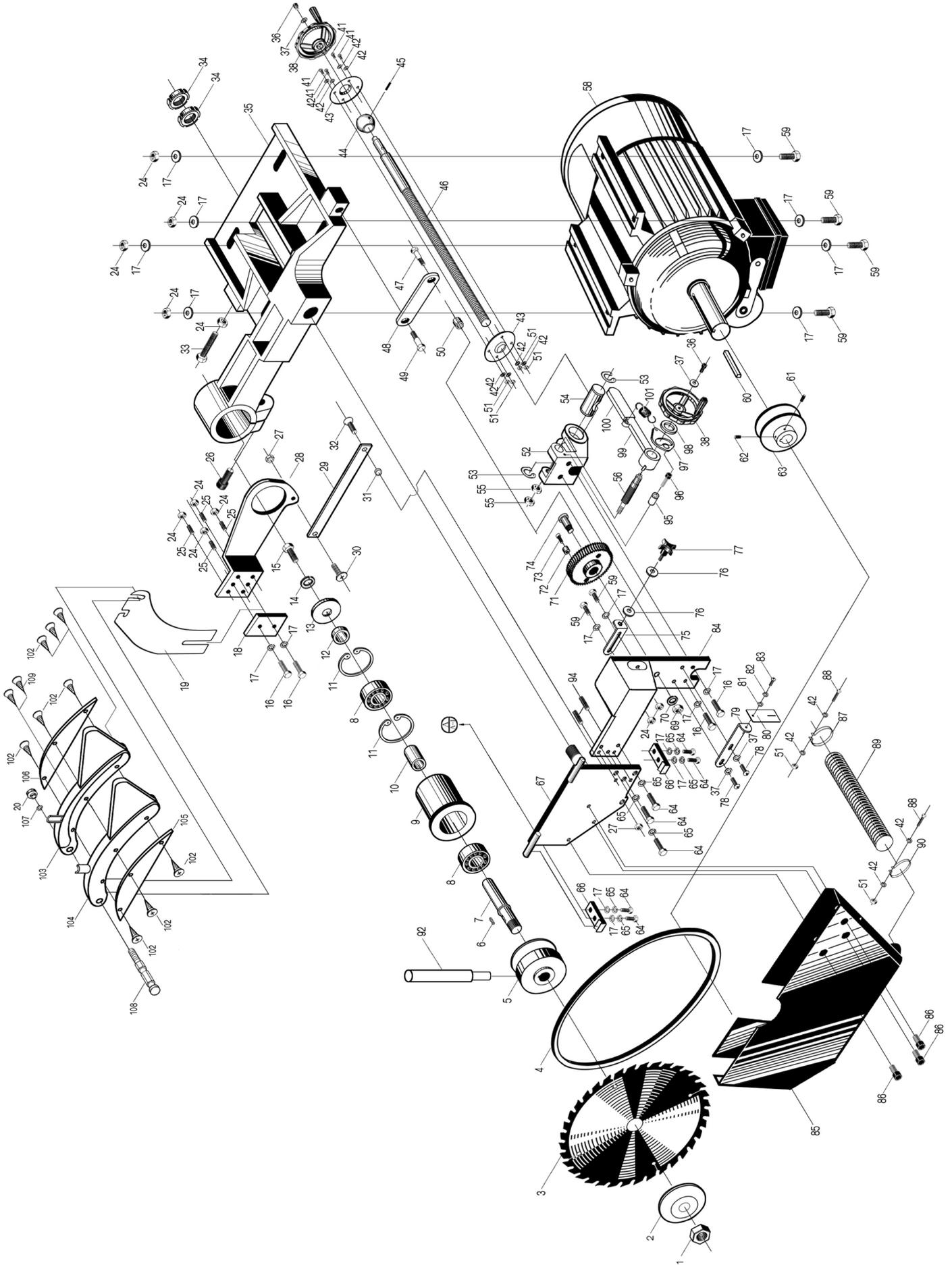
B-14	Left end cap for front rail	1
B-15	Front rail	1
B-16	Right end cap for front rail	1
B-17	Square nut M5	12
B-18	Rack	4
B-19	External teeth washer 5	12
B-20	Cross recessed pan head tapping screw M5x8	12
B-23	neck chain	2
B-24	dust collection tube	1
B-31	Hexagon socket cap head screw M8x25	2
B-32	Upper stand leg	2
B-33	Hexagon head bolt M8x25	4
B-34	Washer block	2
B-35	Lower stand leg	2
B-36	Foot bolt	2

DIAGRAM C



NO.	DESCRIPTION	Qty			
C-1	Lock handle for miter gauge	1	C-11	Guide board	1
C-2	Large washer 8	1	C-12	Cross recessed pan head screw M4x8	3
C-3	Mitre gauge	1	C-13	Hexagon nut M4	3
C-4	Cross recessed pan head screw M5x10	3	C-14	Scale	1
C-5	Mitre gauge pointer	1	C-15	Cross recessed countersunk head tapping scerw M5x10	1
C-6	Mitre gauge block	1	C-16	End cap A for dial fence	1
C-7	Stop pin	1	C-17	Dial fence	1
C-8	Cross recessed countersunk head scerw M5x10	1	C-18	End cap B for dial fence	1
C-9	Guide board washer	1	C-19	Step bolt M6x35	2
C-10	Shoulder screw	1	C-20	Washer 6	2
			C-21	Flower nut	2

DIAGRAM D

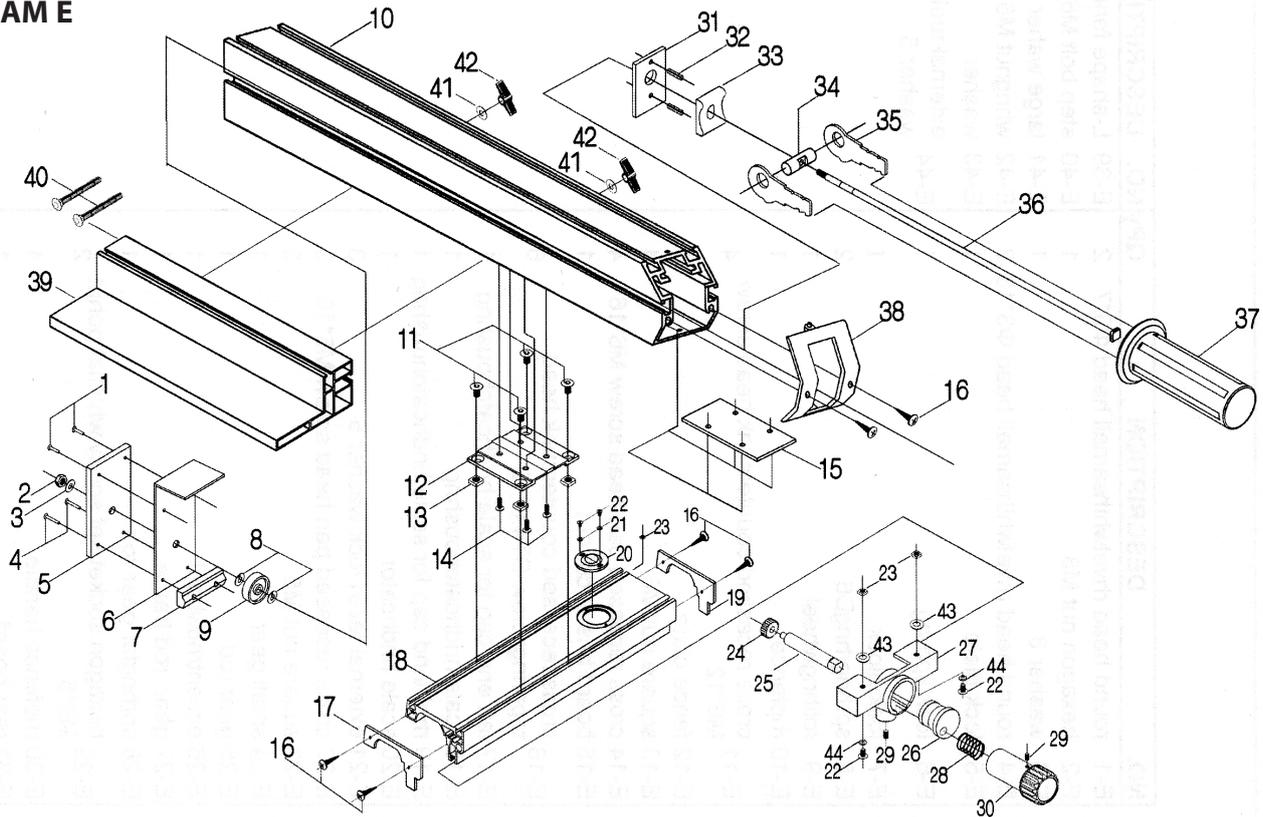


Exploded Diagrams/Lists

NO.	DESCRIPTION	Qty			
D-1	Blade nut M16(left-hand)	1	D-55	Thin nut M12	2
D-2	Outer blade washer	1	D-56	Height adjusting rod	1
D-3	Blade	1	D-58	Motor	1
D-4	A-blet	1	D-59	Hexagon head bolt M8X40	6
D-5	Pulley	1	D-60	Key 8X7X50	1
D-6	Key (A-type)	1	D-61	Hexagon socket set screw with	1
D-7	Arbor shaft	1		Flat point M6X9	
D-8	Bearing 80203	2	D-62	Hexagon socket set screw with	1
D-9	Arbor shaft sleeve	1		Flat point M6X6	
D-10	Arbor shaft bush	1	D-63	Motor wheel	1
D-11	Circlips for hole	2	D-64	Hexagon socket cap head screw M8X24	7
D-12	Arbor shaft end bush	1	D-65	Single coil spring lock washer 8	7
D-13	Press wheel	1	D-66	Rotation press block	2
D-14	Single coil spring lock washer 6	1	D-67	Adjusting cradle	1
D-15	Hexagon head bolt M6X16	1	D-69	Hexagon nut M12	1
D-16	Hexagon head bolt M8X20	4	D-70	Single coil spring lock washer 12	1
D-17	Flat washer 8	18	D-71	Worm-wheel	1
D-18	Press board for riving knife	1	D-72	Eccentric sleeve	1
D-19	Riving knife	1	D-73	Hexagon socket cap head screw M8X30	1
D-20	Flower nut	1	D-74	Worm-wheel shaft nail	1
D-24	Hexagon nut M8	11	D-75	Locking block	1
D-25	Hexagon socket set screw with	4	D-76	Large washer 8	2
	Flat point M8X25		D-77	Flower bolt	1
D-26	Hexagon socket cap head screw M10X30	1	D-78	Cross recessed pan head screw M5X12	2
D-27	Locking nut with plastic insert M8	2	D-79	Pointer bracket	1
D-28	Riving knife bracket	1	D-80	Pointer	1
D-29	Connecting rod	1	D-81	Flat washer 4	1
D-30	Cross recessed countersunk head	1	D-82	Single coil spring lock washer 4	1
	Screw M8X20		D-83	Cross recessed pan head screw M4X10	1
D-31	Bush	1	D-84	Adjusting worm-wheel bracket	1
D-32	Cross recessed countersunk head	1	D-85	Dust collection cover	1
	Screw M8X20		D-86	Hexagon socket cap head screw M6X18	3
D-33	Hexagon head bolt M8X65	1	D-87	Neck chain	1
D-34	Locking nut for motor base	2	D-88	Hexagon head bolt M6X25	2
D-35	Motor base	1	D-89	Dust collection tube	1
D-36	Hexagon socket cap head screw M5X12	2	D-90	Elliptic neck chain	1
D-37	Large washer 5	4	D-92	Tommy Bar	1
D-38	Hand wheel	2	D-94	Elastic lock	1
D-41	Cross recessed pan head screw M6X16	4	D-95	Lock nail bush	1
D-42	Flat washer 6	12	D-96	Hexagon socket cap head screw M6X25	1
D-43	Ball bracket	2	D-97	Active board	1
D-44	Thread rod ball	1	D-98	Active board block	1
D-45	Spring dowel 4X28	1	D-99	Lock handle	1
D-46	Adjusting thread rod	1	D-100	Handle sleeve	1
D-47	Worm-wheel connecting rod nail A	1	D-101	Lock handle spring	1
D-48	Worm-wheel connecting rod	1	D-102	Taping screw ST4.2X10	9
D-49	Worm-wheel connecting rod nail B	1	D-103	Blade guard,half	1
D-50	Connecting rod bush	1	D-104	Blade guard,half	1
D-51	Hexagon nut M6	6	D-105	Segment,blade guard	1
D-52	Adjusting frame	1	D-106	Segment,blade guard	1
D-53	Circlips for shaft D=24	2	D-107	Lock washer 8mm	1
D-54	Knuckle	1	D-108	Lock bolt,guard	1
			D-109	Taping screw ST4.2X26	2

Exploded Diagrams/Lists

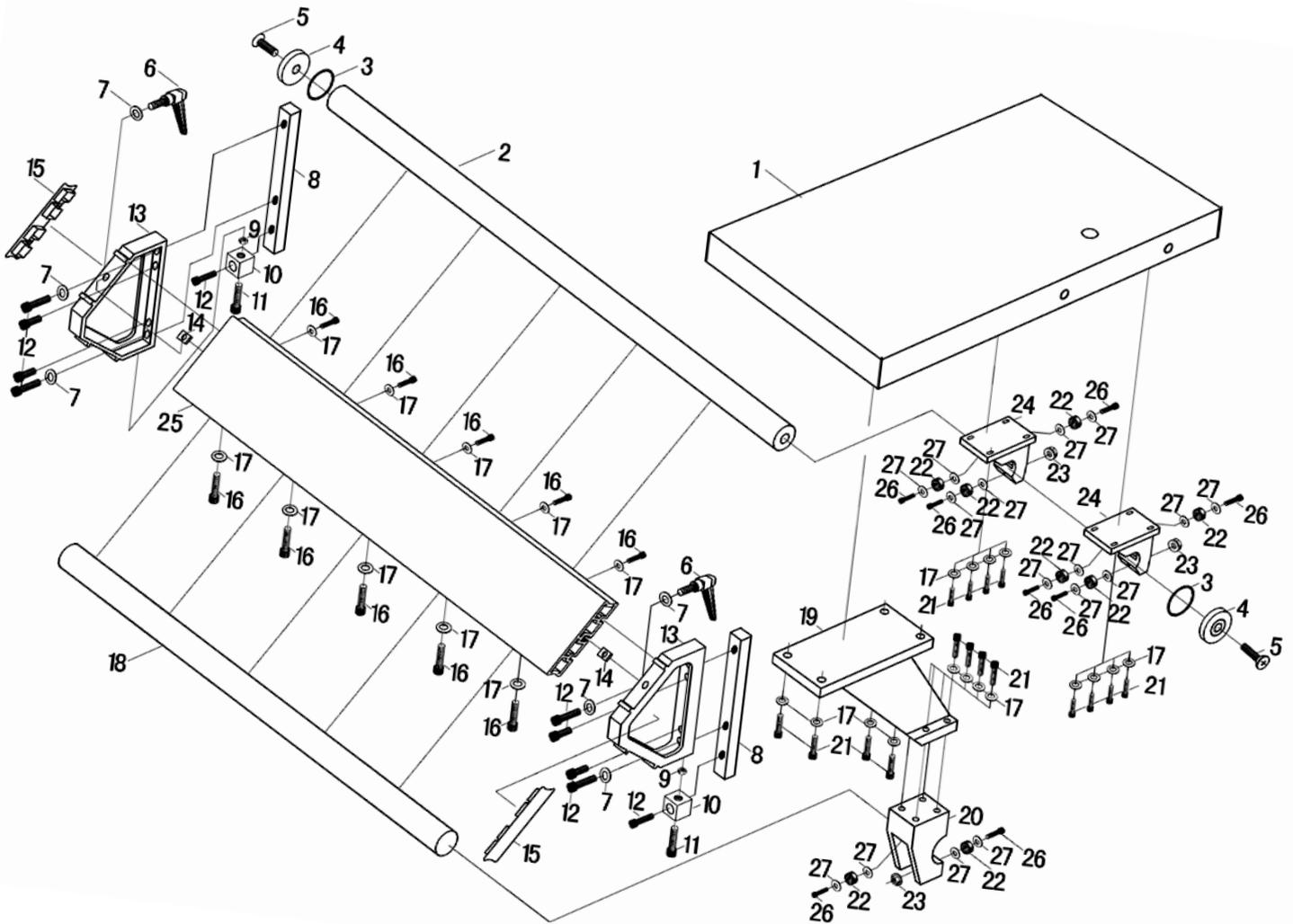
DIAGRAM E



NO.	DESCRIPTION	Qty
E-1	Round head rhvetwhthsamall head $\phi 3 \times 7$	2
E-2	Hexagon nut M8	1
E-3	Washer 8	1
E-4	Round head screw $\phi 3 \times 13$	2
E-5	Lock plate	1
E-6	Lock sprhng	1
E-7	Lock block	1
E-8	Spacer washers D6	2
E-9	Bearing	1
E-10	Rip fence	1
E-11	cross recessed countersunk head screw M6x12	4
E-12	Fence Plate	1
E-13	Square nut M6	4
E-14	Cross recessed pan head screw M6x16	4
E-15	Board hinsteadof nut	1
E-16	Cross recessed countersunk head tapphngscrew ST4.0x12	6
E-17	Left end cap for scale rail housing	1
E-18	Scale rail housing	1
E-19	Right end cap for scale rail housing	1
E-20	Scale indicator	1
E-21	External teeth lock washer 5	3

E-22	Cross recessed pan head screw M5x10	3
E-23	Square nut M5	3
E-24	Small gear	1
E-25	Gear rod	1
E-26	Eccentric wheel	1
E-27	Gear rod frame	1
E-28	Spring for gear rod	1
E-29	Hexagon socket set screw with flat point M6x5	2
E-30	Ripfence handle	1
E-31	Rear board	1
E-32	Pin nut $\phi 5 \times 16$	2
E-33	Rear block	1
E-34	Lock eccentric rod	1
E-35	Lock eccentric	2
E-36	Rip fence lock rod	1
E-37	Rip fence handle	1
E-38	Rip fence cover	1
E-39	L-shape fence	1
E-40	Step bolt M6x70	2
E-41	Large wagher 6	2
E-42	Wing nut M6	2
E-43	Washer	2
E-44	External teeth washer 5	2

DIAGRAM F

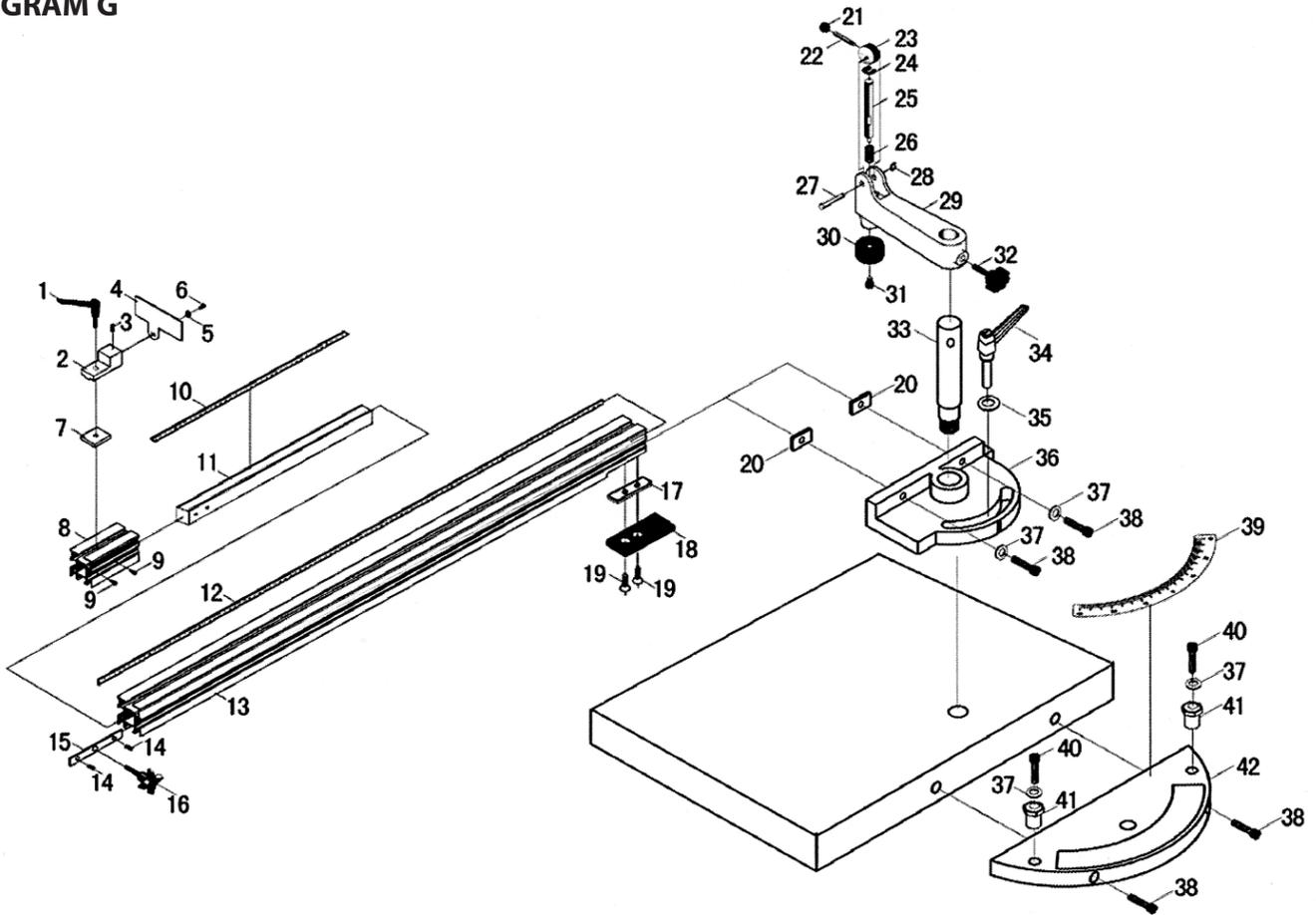


No.	DESCRIPTION	Qty
F-1	Sliding table	1
F-2	Long round rail	1
F-3	O-shape rubber ring $\phi 20$	2
F-4	Stop block	2
F-5	Cross recessed countersunk head screw M6X12	2
F-6	Self-locking handle M8X24	2
F-7	Washer 10	6
F-8	Nut board	2
F-9	Hexagon nut M10	2
F-10	Adjustment base	2
F-11	Hexagon socket cap head screw M10X55 hexagon	2
F-12	Hexagon socket cap head screw M10X30	10
F-13	Support bracket	2

F-14	Strip-shape nut	2
F-15	End cap for guide rail	2
F-16	Hexagon socket cap head screw M6X18	10
F-17	Washer 6	22
F-18	Short round rail	1
F-19	Angle bracket	1
F-20	Lower bearing base	1
F-21	Hexagon socket cap head screw M8X20	16
F-22	Bearing 80018	8
F-23	Flange nut M8	3
F-24	Upper bearing base	2
F-25	Guide rail	1
F-26	Hexagon socket cap head screw M8X35	8
F-27	Washer 8	16

Exploded Diagrams/Lists

DIAGRAM G



No.	DESCRIPTION	Qty
G-1	Self-locking handle M8X25	1
G-2	Stop block	1
G-3	Hexagon socket set screw M5x12	1
G-4	Stop board	1
G-5	Washer 8	1
G-6	Hexagon socket cap head screw M 10x20	1
G-7	Stop block nut	1
G-8	End stop	1
G-9	Cross recessed pan head screw M5X12	2
G-10	Ruler	1
G-11	Square pole	1
G-12	Long ruler	1
G-13	Rip fence	1
G-14	Hexagon socket set screw M8x8	2
G-15	Intermediate plate	1
G-16	Handle screw M8X20	1
G-17	Nut board	1
G-18	Plastic board	1
G-19	Hexagon socket countersunk head screw M8X22	2

G-20	Strip-shape nut	2
G-21	Knob-lever	1
G-22	Eccentric lever	1
G-23	Cam	1
G-24	Circlip for shaft d=14	1
G-25	Holder rod	1
G-26	Spring	1
G-27	Eccentric shaft	1
G-28	Circlip for shaft d=8	1
G-29	Workpiece clamp	1
G-30	Holder	1
G-31	Hexagon socket cap head screw M5x16	1
G-32	Handle screw M8X20	1
G-33	Swing rod	1
G-34	Self-locking handle M8X30	1
G-35	Large washer 8	1
G-36	Graduated disc	1
G-37	Washer 6	4
G-38	Hexagon socket cap head screw M6X20	4
G-39	Ruler	1
G-40	Hexagon socket cap head screw M6X30	2
G-41	Eccentric sleeve	2
G-42	Graduated disc base	1

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