

# AT254PS13

## Panel Saw



# Index of Contents

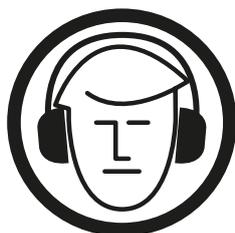
|                                        |                               |
|----------------------------------------|-------------------------------|
| EU Declaration of Conformity           | 02                            |
| What's Included                        | 03-04-05                      |
| General Instructions for 230V Machines | 06                            |
| Specific Safety Precautions            | 06-07                         |
| Specifications                         | 07                            |
| Assembly                               |                               |
| Main Saw Body                          | 08-09-10-11                   |
| Side Access Door knob                  | 11                            |
| Rear Extension Table                   | 11                            |
| Side Extension Table                   | 11-12                         |
| Crown Guard                            | 12-13                         |
| Sliding Table                          | 14-15-16-17                   |
| Rip Fence                              | 17-18                         |
| Micro Adjuster                         | 19                            |
| Mitre Fence                            | 19-20                         |
| Mounting Plate                         | 20                            |
| Machine Footprint                      | 21-22                         |
| Illustration and Parts Description     | 23-24-25-26-27                |
| Positioning the Machine                | 28                            |
| Setting Up the Machine                 | 28-29-30-31                   |
| Operating Instructions                 | 32-33-34                      |
| Changing the Saw Blade                 | 35-36                         |
| Routine Maintenance                    | 36-37-38                      |
| Wiring Diagram                         | 38                            |
| Exploded Diagrams/Lists                | 39-40-41-42-43-44-45-46-47-48 |
| Notes                                  | 49-50                         |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                            |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|------------------|-------|------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|----------------------------|------------|-----------------------|-----------------|-----------------|---------------------|-----------------|---------------------|-------------------|
| <p><b>Cert No: P250/230</b></p> <p>Axminster Tool Centre Ltd<br/>Axminster Devon<br/>EX13 5PH UK<br/><a href="http://axminstertools.com">axminstertools.com</a></p> <p>declares that the machinery described:-</p> <table border="1"> <tr> <td>Type</td> <td><b>Panel Saw</b></td> </tr> <tr> <td>Model</td> <td><b>AT254PS13</b></td> </tr> </table> <p>Signed </p> <p><b>Andrew Parkhouse</b><br/>Operations Director</p> <p>Date: 11/11/2019</p> | Type                       | <b>Panel Saw</b> | Model | <b>AT254PS13</b> | <p><b>EU Declaration of Conformity</b></p> <p><b>This machine complies with the following directives:</b></p> <table border="0"> <tr> <td>2006/42/EC</td> <td>06/42/EC - Annex I/05.2006</td> </tr> <tr> <td>2006/95/EC</td> <td>EN IEC 61000-3-2:2019</td> </tr> <tr> <td>EN 60204-1:2018</td> <td>EN 55014-1:2017</td> </tr> <tr> <td>EN ISO 19085-5:2017</td> <td>EN 55014-2:2015</td> </tr> <tr> <td>EN ISO 19085-1:2017</td> <td>EN 61000-3-3:2013</td> </tr> </table> <p>and conforms to the machinery example for which the EC Type-Examination Certificate No <b>BM 50439320, AE 50451697</b> has been issued by Laizhou Futian Machinery Co., Ltd. at: Fenghuang Science and Technology Park, Development Zone Laizhou, Shandong 261400 Shandong China (Mainland)</p> <p>and complies with the relevant essential health and safety requirements.</p> | 2006/42/EC | 06/42/EC - Annex I/05.2006 | 2006/95/EC | EN IEC 61000-3-2:2019 | EN 60204-1:2018 | EN 55014-1:2017 | EN ISO 19085-5:2017 | EN 55014-2:2015 | EN ISO 19085-1:2017 | EN 61000-3-3:2013 |
| Type                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>Panel Saw</b>           |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
| Model                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <b>AT254PS13</b>           |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
| 2006/42/EC                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 06/42/EC - Annex I/05.2006 |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
| 2006/95/EC                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | EN IEC 61000-3-2:2019      |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
| EN 60204-1:2018                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | EN 55014-1:2017            |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
| EN ISO 19085-5:2017                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | EN 55014-2:2015            |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |
| EN ISO 19085-1:2017                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | EN 61000-3-3:2013          |                  |       |                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |            |                            |            |                       |                 |                 |                     |                 |                     |                   |

**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

| Quantity       | Item                                                                                 | Part      | Model Number |
|----------------|--------------------------------------------------------------------------------------|-----------|--------------|
|                |                                                                                      |           | AT254PS13    |
| 1              | Main Saw Assembly (upper chassis with motor, table, saw blade and NVR switch fitted) | <b>1</b>  |              |
| 2              | Side Panels and Front and Back Panels                                                | <b>2</b>  |              |
| 4              | Lower Leg Columns                                                                    | <b>3</b>  |              |
| 1              | Side Table Extension                                                                 | <b>4</b>  |              |
| 1              | Rear Extension Table                                                                 | <b>5</b>  |              |
| 1              | Extension Support Arm                                                                | <b>6</b>  |              |
| 1              | Rip Fence Rail                                                                       | <b>7</b>  |              |
| 1              | Micro Adjuster                                                                       | <b>8</b>  |              |
| 1              | Rip Fence Assembly                                                                   | <b>9</b>  |              |
| 1              | Sliding Table Assembly                                                               | <b>10</b> |              |
| 1              | Sliding Table Extension                                                              | <b>11</b> |              |
| 1              | Riving Knife                                                                         | <b>12</b> |              |
| 1              | Crown Guard                                                                          | <b>13</b> |              |
| 1              | Mitre Fence Assembly                                                                 | <b>14</b> |              |
| 1              | Mitre Fence Extension                                                                | <b>15</b> |              |
| 2              | Operating Wheels with (Square Keys) in packet                                        | <b>16</b> |              |
| 1              | 100mm Dust Extraction Moulding                                                       | <b>17</b> |              |
| 1              | 100mm Extraction Flexible Hose                                                       | <b>18</b> |              |
| 1              | 50mm Crown Guard Flexible Hose                                                       | <b>19</b> |              |
| 2              | 100mm Hose Clips                                                                     | <b>20</b> |              |
| 2              | 50mm Hose Clips                                                                      | <b>21</b> |              |
| 1              | Hose Support Bracket                                                                 | <b>22</b> |              |
| 1              | Workpiece Support Shoe                                                               | <b>23</b> |              |
| 1              | Sliding Table Fence Assembly                                                         | <b>24</b> |              |
| 1              | Sliding Table Operating Handle                                                       | <b>25</b> |              |
| 1              | Distance Stop Assembly                                                               | <b>26</b> |              |
| 1              | Sliding Table Supporting Leg                                                         | <b>27</b> |              |
| 1              | Overhead Clamp                                                                       | <b>28</b> |              |
| 2              | Steel Shafts for (Overhead Clamp)                                                    |           |              |
| 1              | Push Stick                                                                           | <b>29</b> |              |
| 1              | Mounting Plate                                                                       | <b>30</b> |              |
| <b>Fixing:</b> |                                                                                      |           |              |
| 20             | M8 x 20mm Hex Bolts, Washer, Nuts                                                    | <b>A</b>  |              |
| 4              | M8 x 25mm Hex Bolts, Washer, Nuts                                                    |           |              |
| 3              | M8 x 25mm Square Head Bolts, Washers                                                 | <b>B</b>  |              |
| 1              | Blade Locking Bar                                                                    | <b>C</b>  |              |
| 2              | Rip Fence Capping Plates                                                             | <b>D</b>  |              |
| 2              | Fence rail Capping Plates                                                            |           |              |
| 8              | Small Phillips Screws for (Capping Plates)                                           | <b>E</b>  |              |
| Spanners       |                                                                                      |           |              |
| 1              | 10-13mm                                                                              |           |              |
| 2              | 13-15mm                                                                              |           |              |
| 1              | 14-17mm                                                                              |           |              |
| 1              | 24mm                                                                                 |           |              |
| 1              | Hex Keys 2.5-3-4-5mm                                                                 |           |              |
| 1              | Instruction Manual                                                                   |           |              |

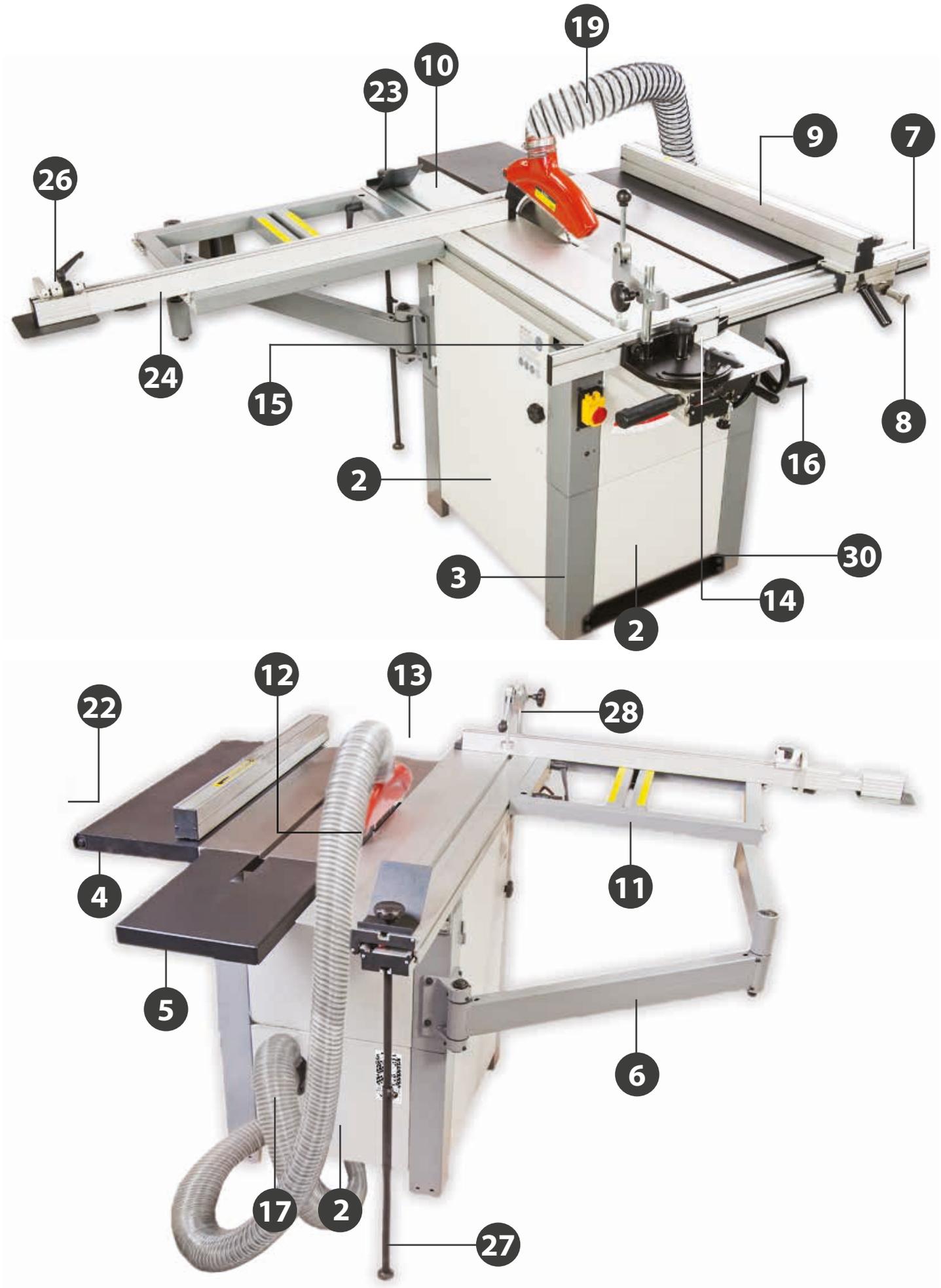


Main saw assembly

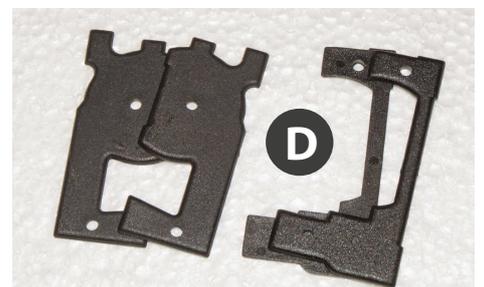
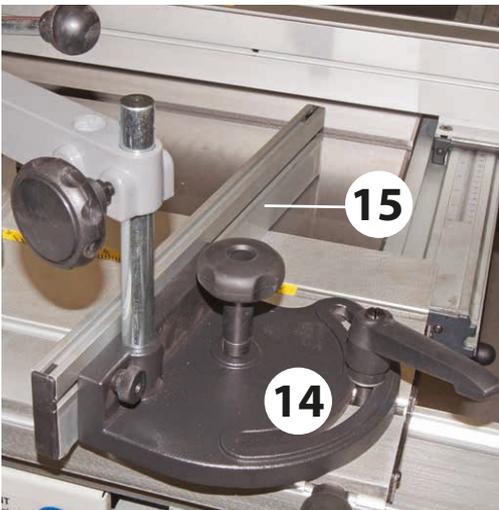
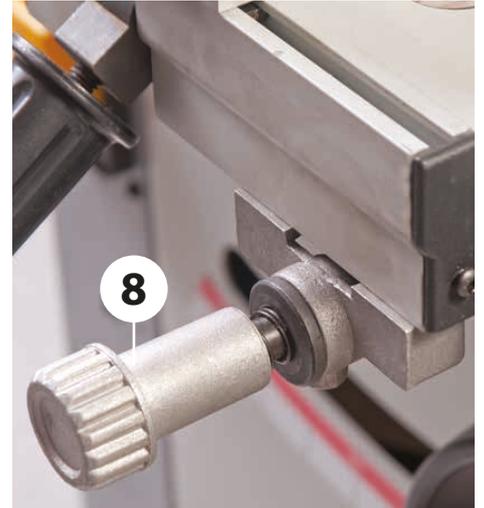


Panel saw parts contained inside main saw frame

# What's Included



## What's Included



Eight small Phillips screws for mounting the capping plates above.

# General Instructions for 230V Machines

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## Good Working Practices/ Safety

The following suggestions 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 THE REACH OF YOUNG CHILDREN**

## Mains Powered Tools

### Mains Powered Tools Primary Precautions

This machine is supplied with a moulded 16 Amp. Plug and 3 core power cable. Before using the tool inspect the cable and the plug to make sure that neither are damaged. If any damage is visible, have the tool inspected/repaired by a suitably qualified person. If it is necessary to replace the plug, it is preferable to use an 'unbreakable' type that will resist damage on site. Only use a 16 Amp plug, and make sure the cable clamp is tightened securely. Fuse as required. If extension leads are to be used, carry out the same safety checks on them, and ensure that they are correctly rated to safely supply the current that is required for your machine.

### Work Place/Environment

If the machine gets wet; dry it off as soon as possible with a cloth. Do not use 230V a.c. powered tools in damp locations and do not trail extension cables across wet areas. Keep the tools clean, do not use any solvents or cleaners, as these may cause damage to any plastic parts or to the electrical components.

**Keep** the work area as uncluttered as is practical, this includes personnel as well as material.

**Under** no circumstances should **CHILDREN** be allowed in work areas.

It is good practice to leave the machine unplugged until work is about to commence, also make sure to unplug the machine when it is not in use, or unattended. Always disconnect by pulling on the plug body and not the cable. Once you are ready to commence work, remove any tools used in the setting operations (if any) and place safely out of the way. Re-connect the machine. Carry out a final check e.g. check the cutting tool, drill bit etc., are securely tightened in the machine, check you have the correct speed and function set, check that the power cable will not 'snag' etc.

Make sure you are comfortable before you start work,

balanced, not reaching etc. If the work you are carrying out is liable to generate flying grit, dust or chips, wear the appropriate safety clothing, goggles, gloves, masks etc. If the work operation appears to be excessively noisy, wear ear-defenders. If you wear your hair in a long style, wearing a cap, safety helmet, hairnet, even a sweatband, will minimise the possibility of your hair being caught up in the rotating parts of the machine, likewise, consideration should be given to the removal of rings and wristwatches, if these are liable to be a 'snag' hazard. Consideration should also be given to non-slip footwear, etc. If you are allowing another person to use the machine, ensure that they are suitably qualified to use it.

**Do not** use the machine if you are tired, your attention is wandering or you are being subjected to distraction. A deep cut, a lost fingertip or worse is not worth it!

Check that cutters, drills etc., are the 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. Above all, **OBSERVE....** make sure you know what is happening around you, and **USE YOUR COMMON SENSE.**

## Specific Safety Precautions

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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 damaged 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.

**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.

## Specific Safety Precautions

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



**FOR YOUR OWN SAFETY NEVER OPERATE THE TABLE SAW WITHOUT THE RIVING KNIFE IN PLACE!**

**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 (with a piece of wood?) 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 material and the sliding carriage for larger workpieces. 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 the blade ensure that the push stick is to hand, and that 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.

## Specification

|                                 |                                        |
|---------------------------------|----------------------------------------|
| Code                            | 508339                                 |
| Model                           | AT254PS13                              |
| Rating                          | Trade                                  |
| Power                           | 2.2kW 230V 1ph                         |
| Blade Dia/Bore                  | 254 x 30mm                             |
| Blade Speed                     | 3,500rpm                               |
| Blade Tilt                      | 0°-45°                                 |
| Max Depth of Cut @ 45°          | 60mm                                   |
| Max Depth of Cut @ 90°          | 80mm                                   |
| Max Width of Cut with Fence     | 600mm                                  |
| Max Ripping Width               | 600mm                                  |
| Table Size                      | Main 760 x 350mm, side ext 760 x 300mm |
| Table Height                    | 865mm                                  |
| Sliding Table Size              | 1,300 x 238mm                          |
| Dust Extraction Outlet          | 100mm                                  |
| Min Extraction Airflow Required | 850m <sup>3</sup> /hr                  |
| Overall L x W x H               | 3,210 x 3,720 x 1,120mm                |
| Weight                          | 155kg                                  |

# Assembly



**PLEASE NOTE:** Some of this assembly procedure is best accomplished by two persons, 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.

Unpack all the boxes, see fig 01-02-03 and check all the components against the 'What's Included' list. If any parts or components are missing, please contact our customer service department using the procedures and telephone numbers listed in our catalogue, and you will be dealt with quickly and efficiently.

## Fig 01-02-03



Remove all the components from inside the saw frame



Remove the polyurethane block from around the motor assembly, see image above.

**PLEASE NOTE:** The panel saw comes **80% assembled**, in order to reduce the footprint of the machine for packaging, several items are dismantled from the machine and need to be re-affixed. Please check all the boxes, packets etc, to make sure that all the parts have been accounted for.

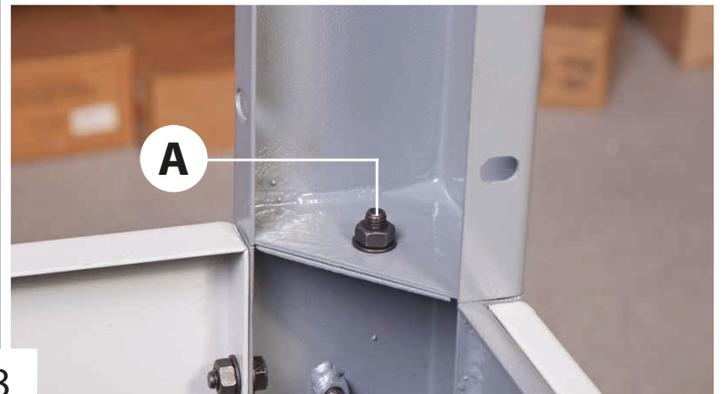
Having unpacked the boxes, (please dispose of any unwanted packaging responsibly), put the parts and components where by they are readily to hand. Break down the main box by knocking the sides away (be careful of exposed nails etc.), but leave the machine sitting on its pallet. Remove the protective grease film that is coating all the unpainted parts of the machine. Use a proprietary de-greasing agent. Unfortunately, this cleaning process is always a bit 'mucky'. You are advised to wear overalls or coveralls etc., during the process. After cleaning, lightly coat the exposed metal surfaces with 'anti rust' oil spray to prevent any rusting.

### Main Saw Body

Identify the side, back and front panels (2), lower leg columns (3), dust extraction moulding (17) and M8 x 20mm Hex bolts, washer and nuts (A).

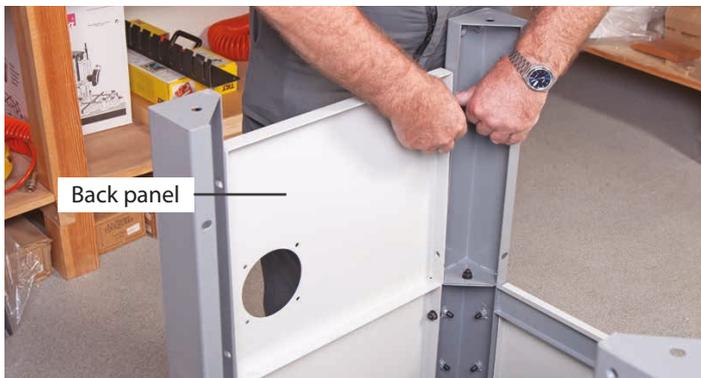
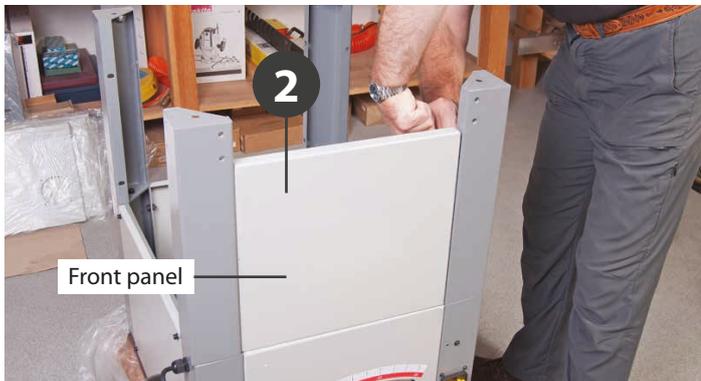
1. Locate the four leg columns (3), place a column on top of the upper legs on the main saw assembly (1). Using four M8 bolt, washers and nuts (A) secure the columns in position, see fig 01-02.

## Fig 01-02



2. Introduce the front panel (2) between the two columns to the front of the saw body. Line up the holes and lightly secure with M8 bolts (A). Repeat the procedure for the back and one of the side panels, see fig 03-04-05.

**Fig 03-04-05**



3. Locate the dust extraction moulding (17). Remove the screws, washers and nuts from the moulding, see fig 06. Inset the moulding through the machined hole in the back panel, line up the holes and secure using the fixing you just removed, see fig 07.

**Fig 06-07**



4. Locate the 100mm extraction flexible hose (18) and hose clips (20), see fig 08. Slide one of the clips over one end of the hose, introduce the hose over the extraction moulding (17) and tighten the clip to secure the hose in place, see fig 09.

**Fig 08-09**



5. Insert the remaining clip (20) over the opposite end of the hose. Introduce the hose over the saw assembly's dust housing outlet and tighten the clip to secure the assembly in place, see fig 10-11-12.

**NOTE: You will need to squeeze the end of the hose to enable you to fit it over the saw's dust outlet as it's oval in shape.**

**Fig 10-11-12**



Continues Over...



6. Locate the remaining side panel (2) and four M8 Hex bolts, washers and nuts (A) and secure in place, see fig 13.

7. Go round and securely tighten all the bolts.

## Fig 13



### Fitting the Operating Wheels

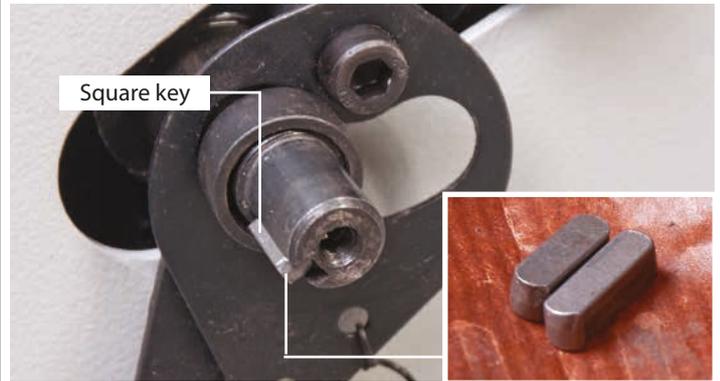
8. Locate the two operating wheels (16) and the square keys. Remove the protective cap from one of the drive shafts and remove the Hex screw/washer, place safely aside, see fig 14-15.

## Fig 14-15



9. Insert one of the square keys into the machined slot on the drive shaft, see fig 16. Line up the machined key slot to the centre of the hand wheel (16) with the key and slide the wheel onto the drive shaft. Replace the Hex screw/washer you removed earlier and tighten securely, see fig 17-18. Repeat for the other operating wheel.

## Fig 16



## Fig 17-18





**10.** With everything secure, with assistance tip the main saw over towards its blind face until it is resting on the pallet. With its legs on the floor lift the machine upright, see fig 19.

**Fig 19**



**Side Access Door Knob (If not already assembled)**

**11.** Introduce the threaded knob through the pre-drilled hole in the side access door, slot the washer over the thread and secure the knob in place with the nut, see fig 20-21.

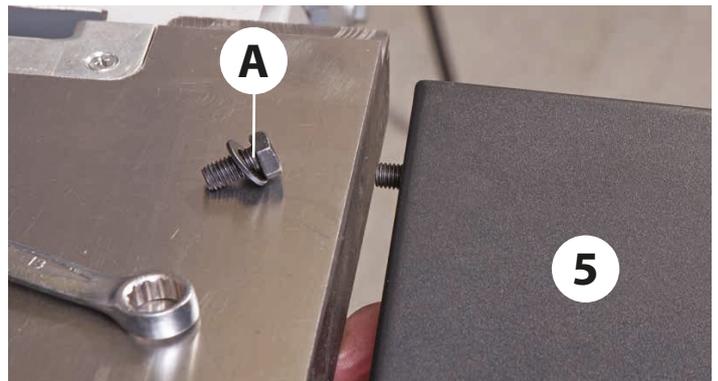
**Fig 20-21**



**Rear Extension Table**

**12.** Locate the rear extension table (5) and two M8x20mm Hex bolts and washers (A). Lift the table up, line up the pre-drilled holes with the threaded holes to the rear of the main saw table (1). Introduce a bolt with a washer through one of the holes in the rear table (5) and screw it into the threaded hole in the main table. Lightly finger tighten. Repeat the process for the remaining bolt/washer. Place a straight edge across both tables and gradually tighten the bolts until both tables are level, see fig 22-23.

**Fig 22-23**



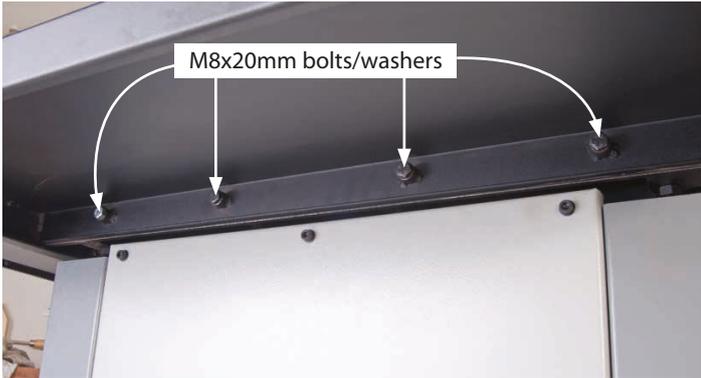
**Side Extension Table**

**13.** Locate the side extension table (4) and four M8x25mm Hex bolts and washers (A). Lift the table up, line up the pre-drilled holes with the threaded holes to the side of the main saw table (1). Introduce a bolt with a washer (A) through one of the holes in the side table (4) and screw it into the threaded hole in the main table. Lightly finger tighten. Repeat the process for the remaining bolts/washers. Place a straight edge across both tables and gradually tighten the bolts until both tables are level, see fig 24-25-26.

**Fig 24-25-26**



# Assembly



## Crown Guard

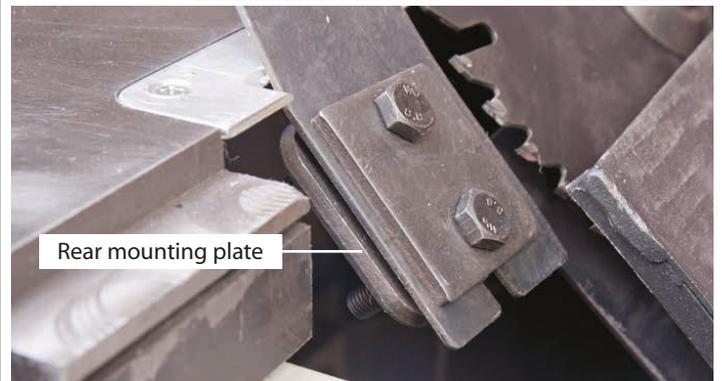
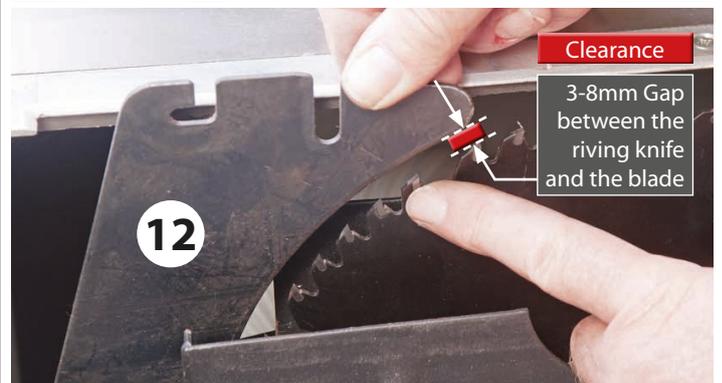
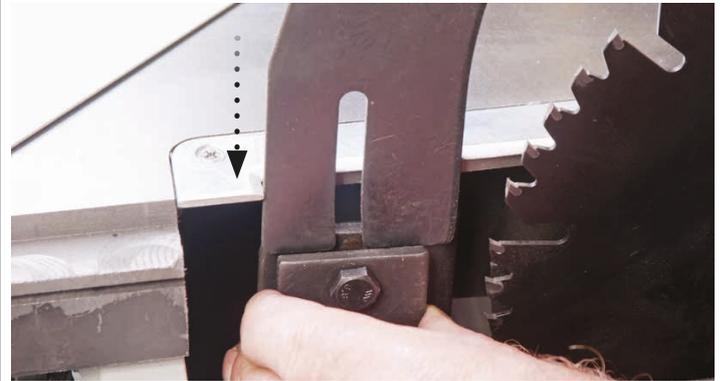
**14.** Locate the crown guard assembly (13), riving knife (12), 50mm flexible hose (19), the two 50mm hose clips (21) and the hose support bracket (22). Remove the two Phillips screws holding the inner guard assembly and place safely aside, see 27-28.

## Fig 27-28



**15.** Loosen the two bolts holding the mounting plates. Lower the riving knife (12) down between the mounting plates, set the riving knife close to the blade and check the clearance between the blade. It should have a gap of (MIN 3mm - MAX 8mm), tighten the two bolts to secure the setting, see fig 29-30-31-32.

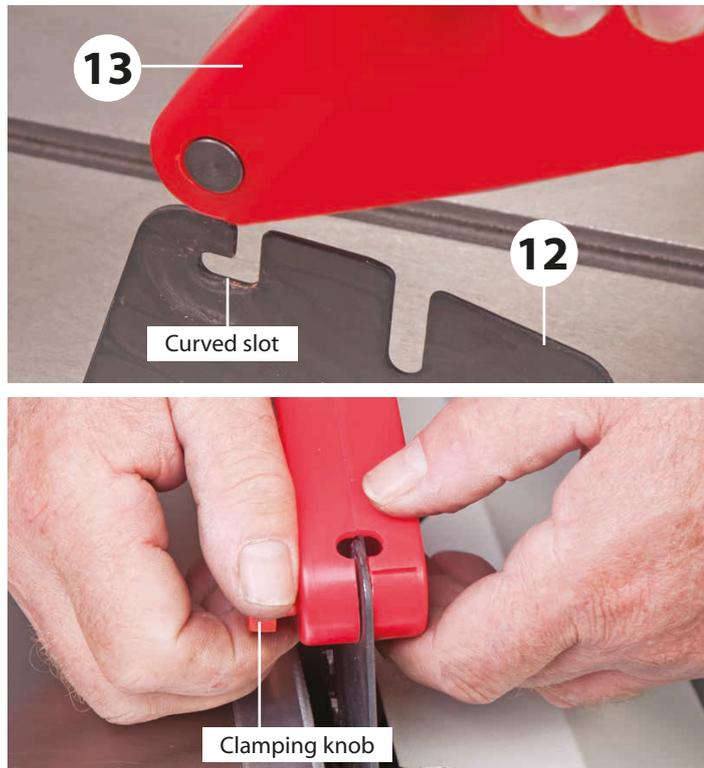
## Fig 29-30-31-32



**16.** Locate the crown guard assembly (13) and loosen the clamping knob. Introduce the slot to the rear of the guard over the riving knife and slot the pin bolt into the

curved slot in the riving knife. Tighten the clamping knob, see fig 33-34.

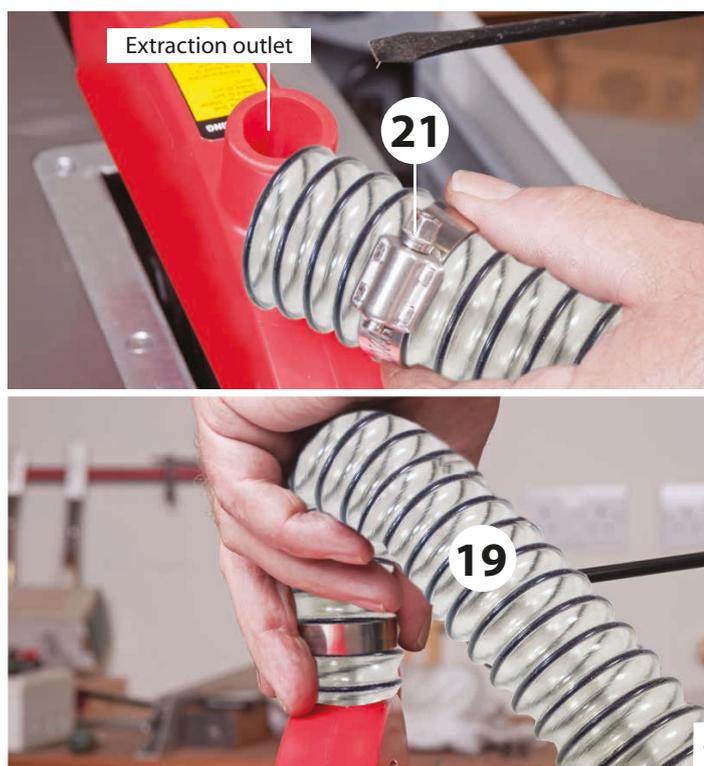
**Fig 3-34**



17. Place a 50mm hose clip (21) over the end of the hose (19), see fig 35. Insert the hose over the extraction outlet on the crown guard (13) and tighten the clip, see fig 36.

**NOTE: DO NOT OVER TIGHT AS THE CROWN GUARD IS PLASTIC AND LIABLE TO BREAK!**

**Fig 35-36**



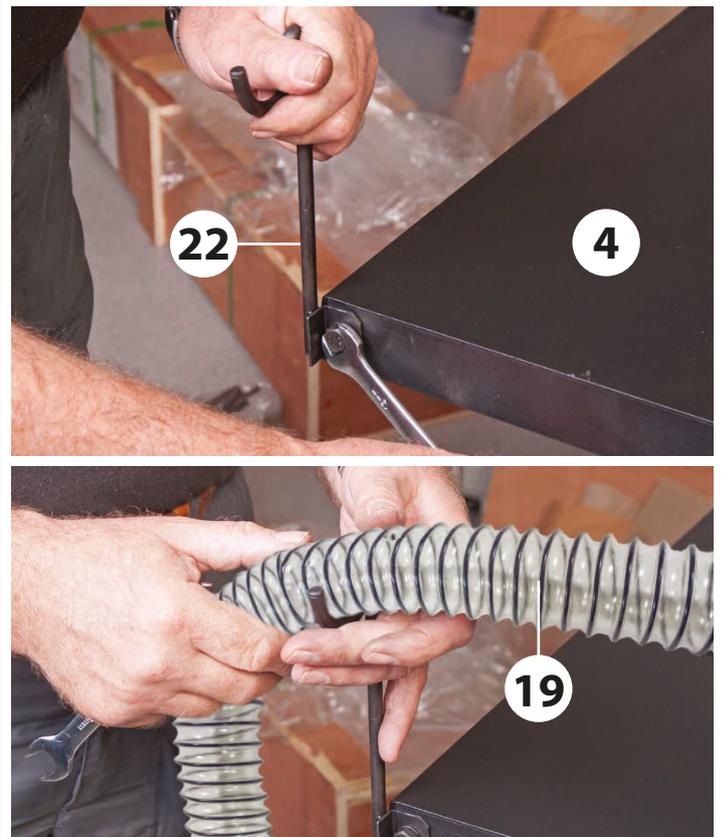
18. Place the remaining clip over the opposite end of the hose. Insert the hose over the 50mm inlet on the 100mm extraction moulding (17) and tighten the clip, see fig 37.

**Fig 37**



19. Locate the hose support bracket (22). Remove the bolt/washer and nut, line up the hole in the bracket with the mounting hole to the end of the side extension table (4) and secure with the fixings you just removed, see fig 38. Slot the hose (19) onto the bracket, see fig 39.

**Fig 38-39**



20. Replace the inner guard assembly.

# Assembly

## Sliding Table

You will require the following: the sliding table extension support arm (27), sliding table assembly (10), sliding table fence (24), sliding table extension (11), mitre fence (14) for sliding table, workpiece support shoe (23).

**21.** Remove the four bolts and washers from the bottom corner of the main saw table's frame, see fig 40. Locate the extension support arm (6), line up the holes in the support bracket with the holes in the saw frame and secure with the bolts/washers you removed earlier, see fig 41.

**Fig 40-41**



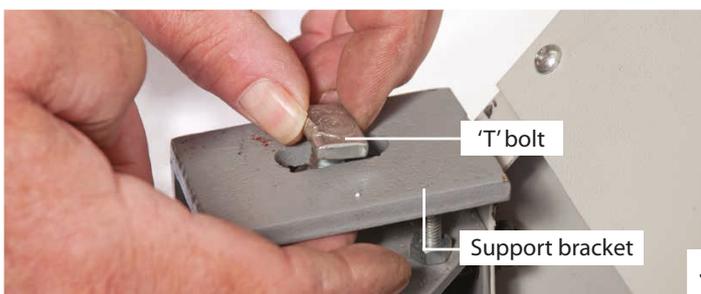
**22.** Loosen the two 'T' bolts/nuts and washers from the angled support brackets on the main saw (1), see fig 42.



**NOTE: YOU WILL REQUIRE HELP FOR THIS NEXT STEP!**

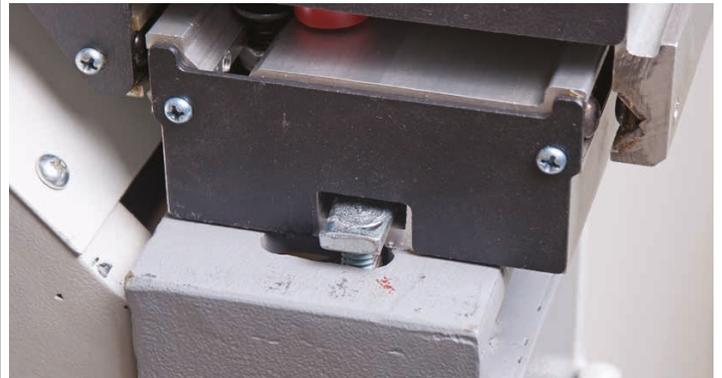
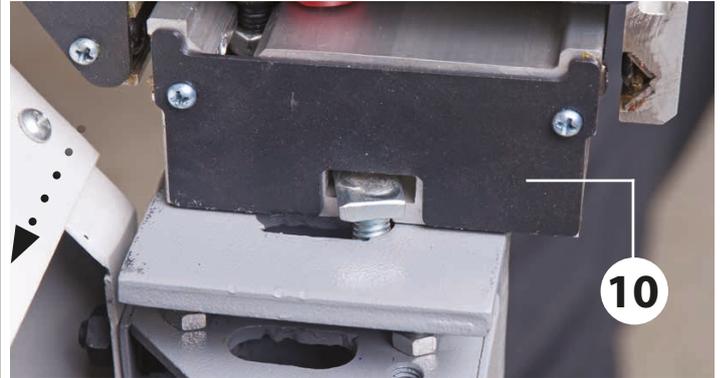
**23.** With assistance, insert the first 'T' bolt into the machined slot to the end of the sliding table assembly (10). Slide the table on and repeat the process to the

**Fig 42**



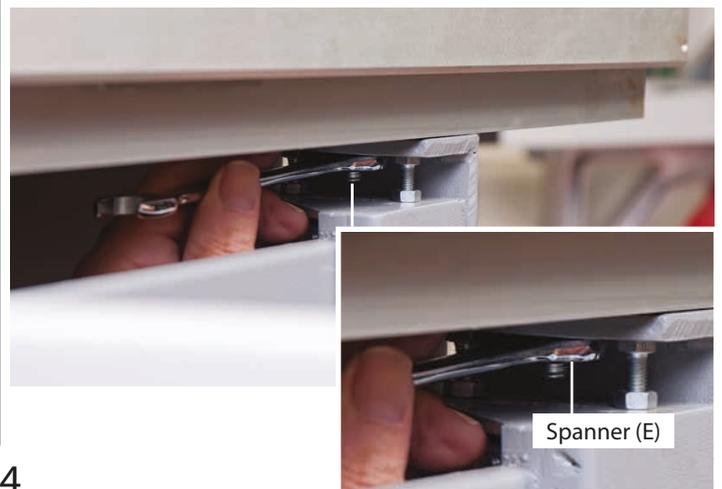
opposite end of the main saw table (1), see fig 43-44. Position the sliding table (10) so its over hangs equally to both end of the main table (1).

**Fig 43-44**



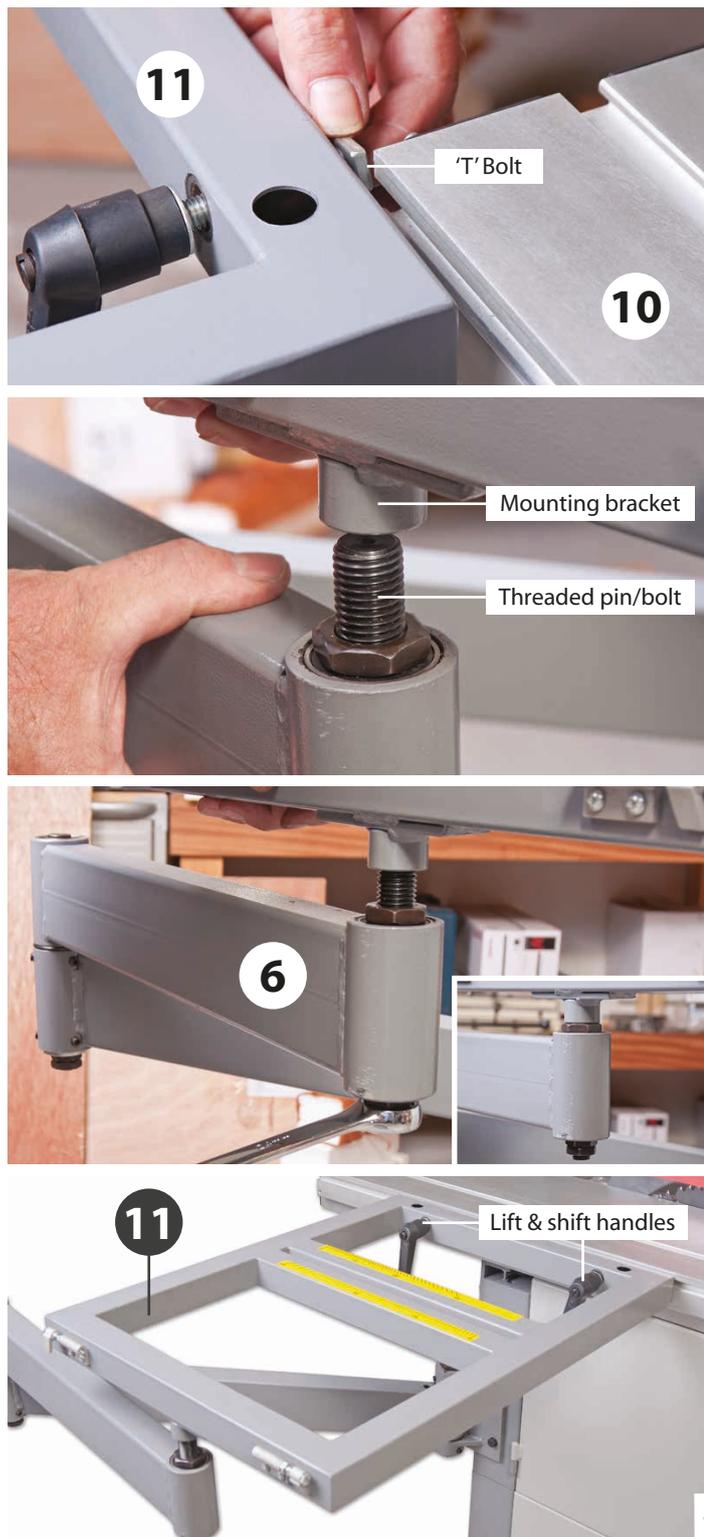
**24.** Open the side access door to gain access to the support brackets and using the supplied spanner (E) securely tighten the two 'T' bolt nuts, see fig 45-46.

**Fig 45-46**



**25.** Locate the sliding table extension (11), line up the two 'T' bolts on the extension table with the 'T' slots to the side of the sliding table (10) and slide on the extension table, see fig 47. Open up the supporting arm (6), insert the extension table mounting bracket onto the threaded pin/bolt on the supporting arm, see fig 48. Using a spanner turn the bolt beneath the supporting arm (6) to lock the two components together, see fig 49. Lock the extension table (11) in place with the two lift and shift handles, see fig 50.

**Fig 47-48-49-50**



**26.** Locate the sliding table supporting leg (27), loosen the square bolt on top of the leg support. To the underside of the sliding table (10), insert the square bolt into the 'T' slot to the end of sliding table assembly. Rotate the leg, clockwise to secure the leg in position, see fig 51.

**27.** Using a Hex key loosen the Hex screw to the centre of the leg and adjust the leg until the foot is resting on the floor, retighten the screw, see fig 52-53.

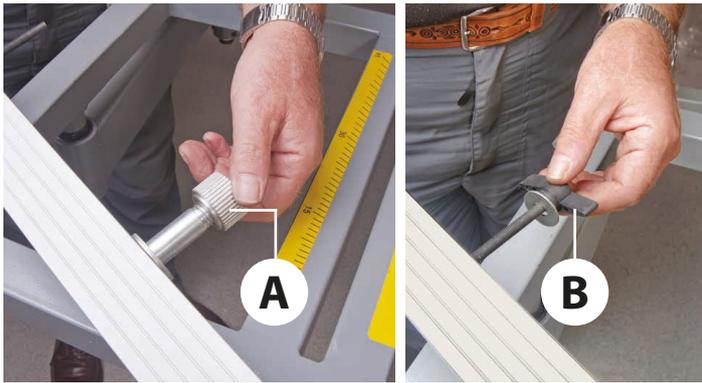
**Fig 51-52-53**



**28.** Put to hand the sliding table fence assembly (24), remove both the steel clamping knob (A) and butterfly knob (B) with washers from the fence and place to one side. Lower the fence on top of the table extension (11), insert the larger threaded pin into one of the pre-drilled holes to the corners of the table extension (11). Insert the other between the centre column of the table then replace the clamping knobs and washers you removed earlier, see fig 54-55-56-57-58. **NOTE: Don't tighten at this point.**

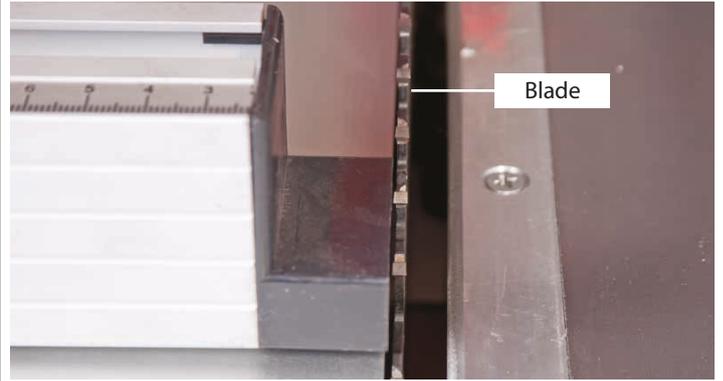
Continues Over....

**Fig 54-55-56-57-58**



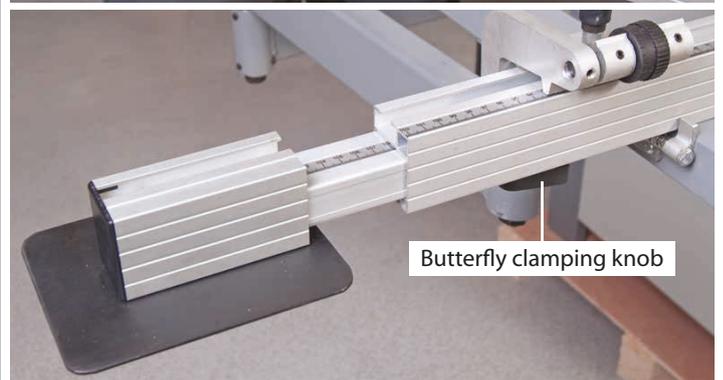
29. Lift-up the 90° stop located to the corners of the extension table, push the fence up against the stop, see fig 59. Slide the fence (24) near the blade but not touching, see fig 60 and tighten both knobs (A) and (B).

**Fig 59-60**



30. Locate the distance stop assembly (26). Loosen the butterfly clamping knob beneath the fence assembly (24) and pull out the telescopic fence section out. Loosen the clamping handle on the distance stop (26), insert the 'T' bolt into the 'T' slot to the centre of the fence assembly and slide the distance stop on, see fig 61-62.

**Fig 61-62**



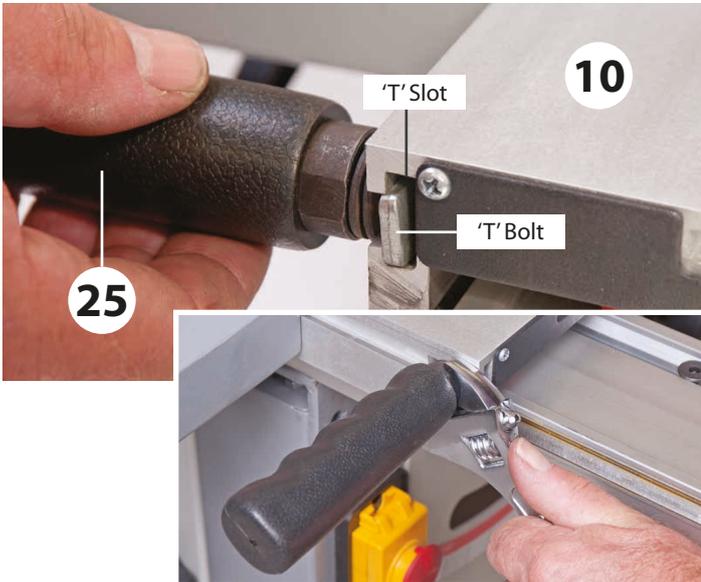
31. Locate the Workpiece support shoe (23), insert the 'T' bolt into the 'T' slot to the left side of the sliding table (10), slide the shoe on and clamp in place with the clamping knob, see fig 63.

**Fig 63**



**32.** Loosen the 'T' bolt in the sliding table's operating handle (25). Insert the 'T' bolt into the 'T' slot into the opposite end of the table and secure in place, see fig 64-65.

**Fig 64-65**



**33.** Locate the overhead clamp and shaft (28). Remove the mounting bar (a) from the sliding table. Slide the shaft with the 'T' bolt into the 'T' slot to the centre of the table and secure in place by rotating the shaft. Insert one of two pre-drilled holes in the overhead clamp assembly down over the shaft and lock in place with the clamping knob, see fig 66-67.

**Fig 66-67**

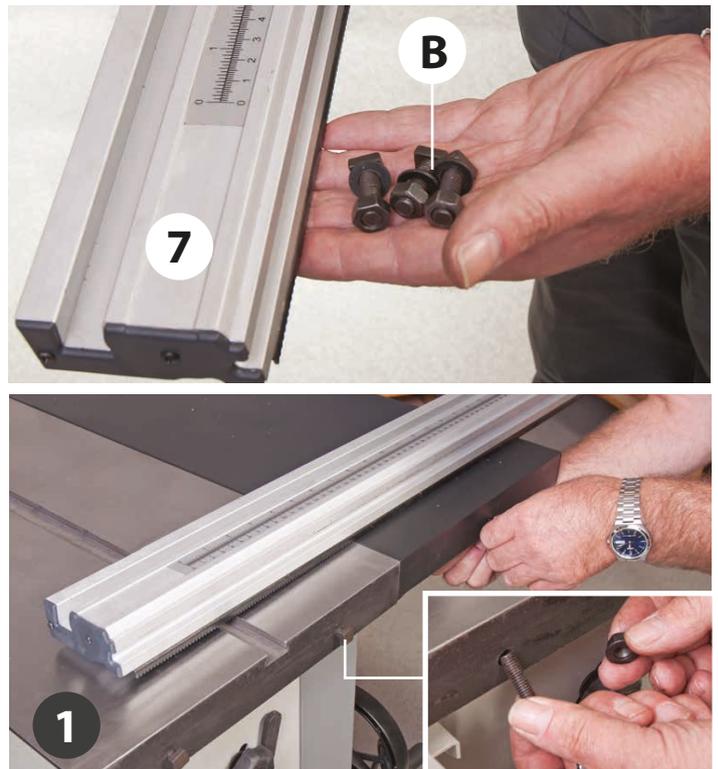


## Rip Fence

You will require the following: the rip fence (9), rip fence rail (7), micro adjuster (8), capping plates (D), small Phillips screws (E) and the three M8x 25mm square head bolts/washer/nuts (B).

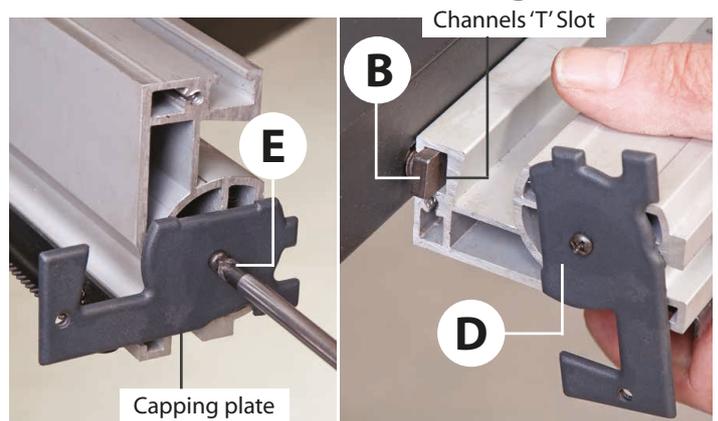
**34.** Put to hand the fence rail (7) and square bolts (B). Remove the washers and nuts and place safely aside. Insert the square bolts into the machined holes to the front of the main saw table (1) and replace the washers/nuts you removed earlier. **(Leave the bolts loose for the next stage)**, see fig 68-69.

**Fig 68-69**



**35.** Attach the capping plates (D) to the fence rail (7) as shown in fig 70. Introduce the furthest right hand square bolt (B) into the channels 'T' slot to the side of fence rail (7) and slide on. Repeat for the remaining bolts, see fig 71-72.

**Fig 70-71-72**



# Assembly

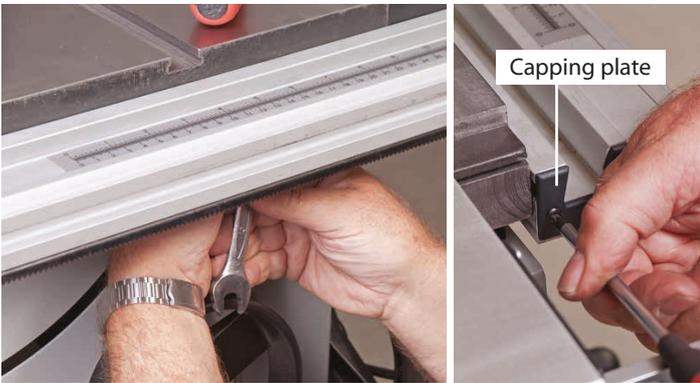


**36.** Reach under the table's edge and lightly tighten all the nuts. Re-attach the capping plate (D), see fig 73-74.

**37.** Locate the rip fence assembly (9) and lower the clamping assembly over the fence rail (7). Raise the clamping handle and slide the rip fence up against the blade, see fig 75.

**38.** Look at the 'RED' line on the magnifying glass to check it's set to '0' on the scale, see fig 76. If the scale is out of alignment, loosen the fence rail (7) and tap the side until the scale reads '0' then re-secure the fence rail, see fig 77-78.

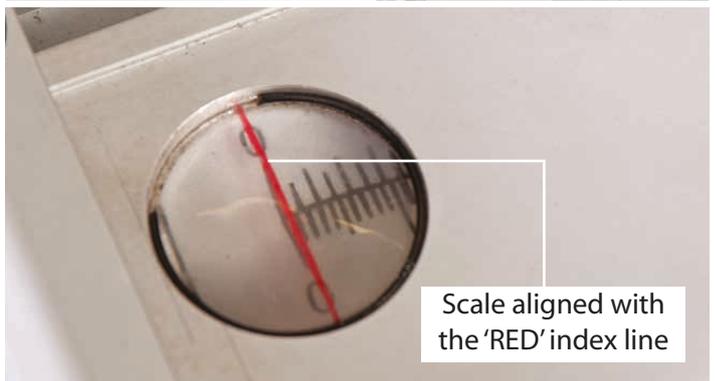
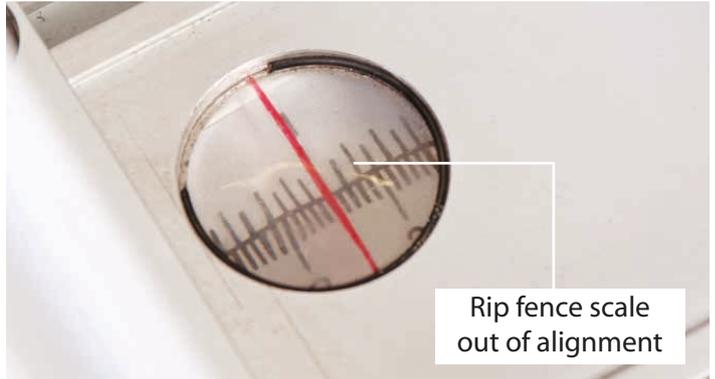
**Fig 73-74**



**Fig 75**



**Fig 76-77-78**



**39.** Raise the clamping handle again and position the rip fence so it's in line with the edge of the main table's 'T' slot, push the handle down to lock in place. If the fence is out of alignment, loosen the four cap head bolts (a) on top of the clamping assembly, see fig 79, adjust the rip fence until its in alignment with the edge of the main tables 'T' slot. Once complete tighten the cap head bolts (a), see fig 80.

**Fig 79-80**





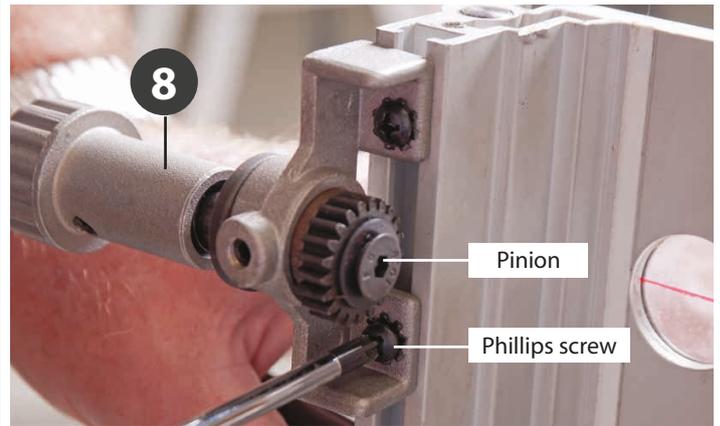
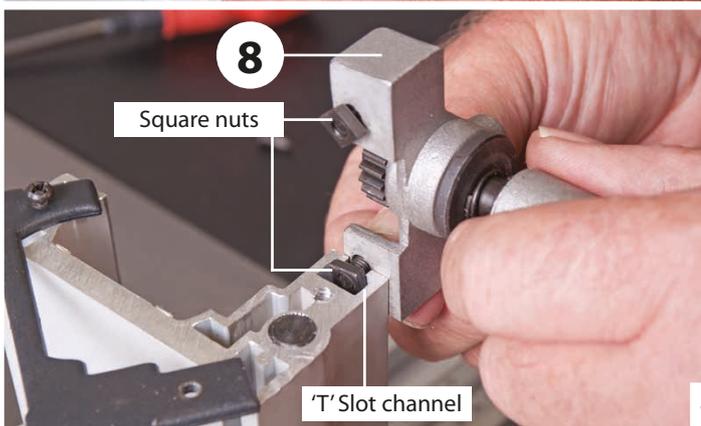
### Micro Adjuster

**40.** Locate the micro adjuster (8). Remove the rip fence assembly from the fence rail (7) and remove the capping plate from the left side of the fence clamping assembly, see fig 81.

**41.** There are two Phillips screws through the micro adjuster's mounting bracket with square nuts on them. Undo the nuts sufficiently to allow them to slide into the 'T' slot channel to the side of the rip fence assembly, see fig 82. Position as required, normally slightly to the right of the rip fence then tighten the two Phillips screws to secure the assembly, see fig 83. Replace the capping plate.

**NOTE:** making sure the pinion engages into the rack beneath the fence rail (7).

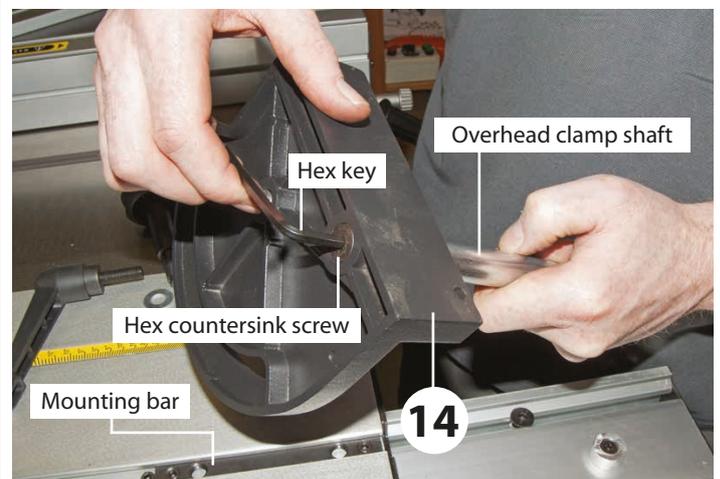
### Fig 81-82-83



### Mitre Fence assembly for sliding Table

**42.** Locate the mitre fence housing (14), mitre fence extension (15), locking knob, clamping handle and workpiece clamp shaft. Replace the mounting bar (a) as shown in step 33. Insert the Overhead clamp shaft into the mitre fence housing and secure with a countersink Hex screw, see fig 84. Lower the mitre fence housing on top of the mounting bar to the right side of the sliding table (10). Line up the threaded pre-drilled holes, introduce the locking knob through the centre hole in housing (14) and lightly tighten, see fig 85. Insert the clamping handle through the machined cutout slot in the housing and into the mounting bar, see fig 86.

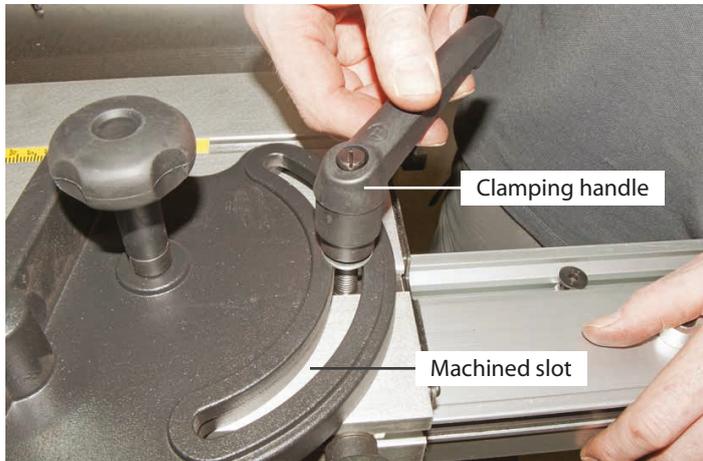
### Fig 84-85



# Assembly

**43.** Locate the overhead clamp assembly (28), insert either mounting hole down over the shaft and lock in place with the clamping knob, see fig 87.

**Fig 86**



**Fig 87**



**44.** Put to hand the mitre fence extension (15), remove the two locking knobs then introduce the threaded bolts through the two pre-drilled holes in the mitre fence housing (14) and tighten securely with the locking knobs, see fig 88.

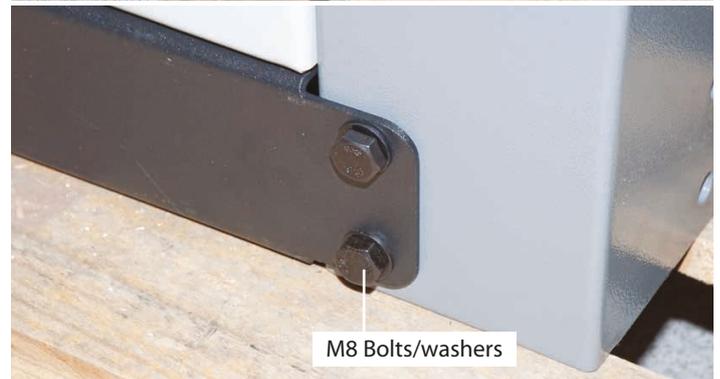
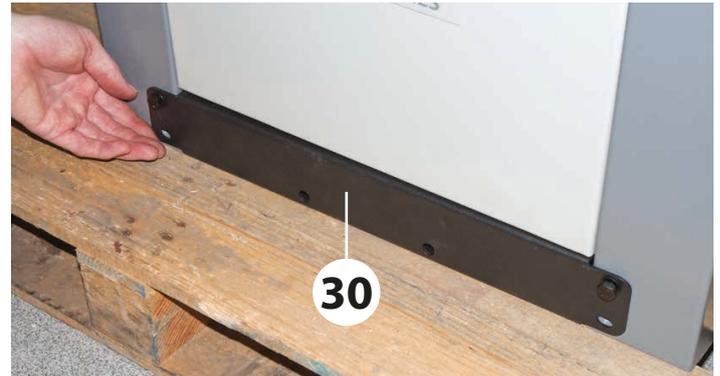
**Fig 88**



**45.** Adjust the mitre fence assembly until it reads 'zero' on the sliding tables scale.

**46.** Locate the mounting plate (30) 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 89-90.

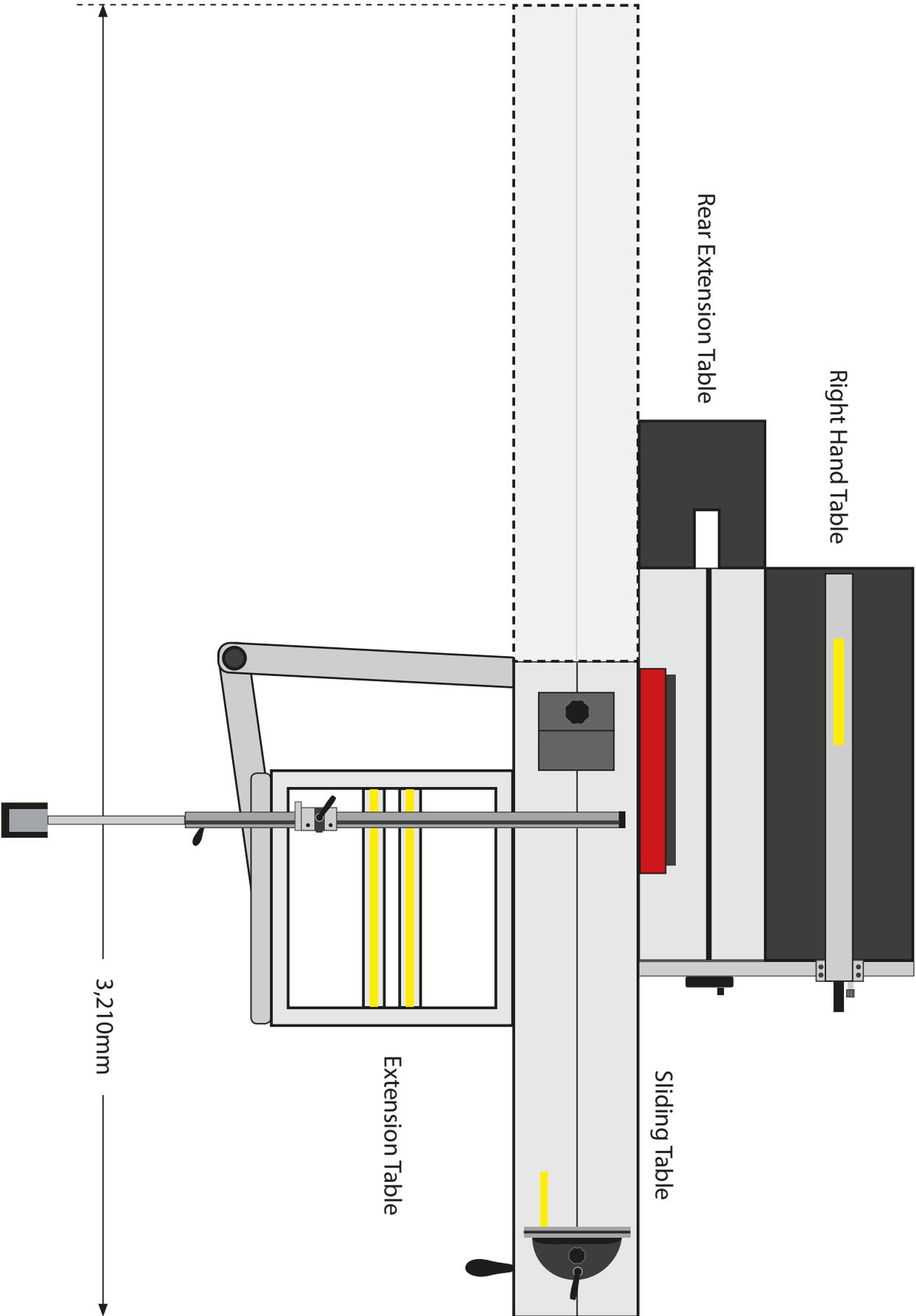
**Fig 89-90**



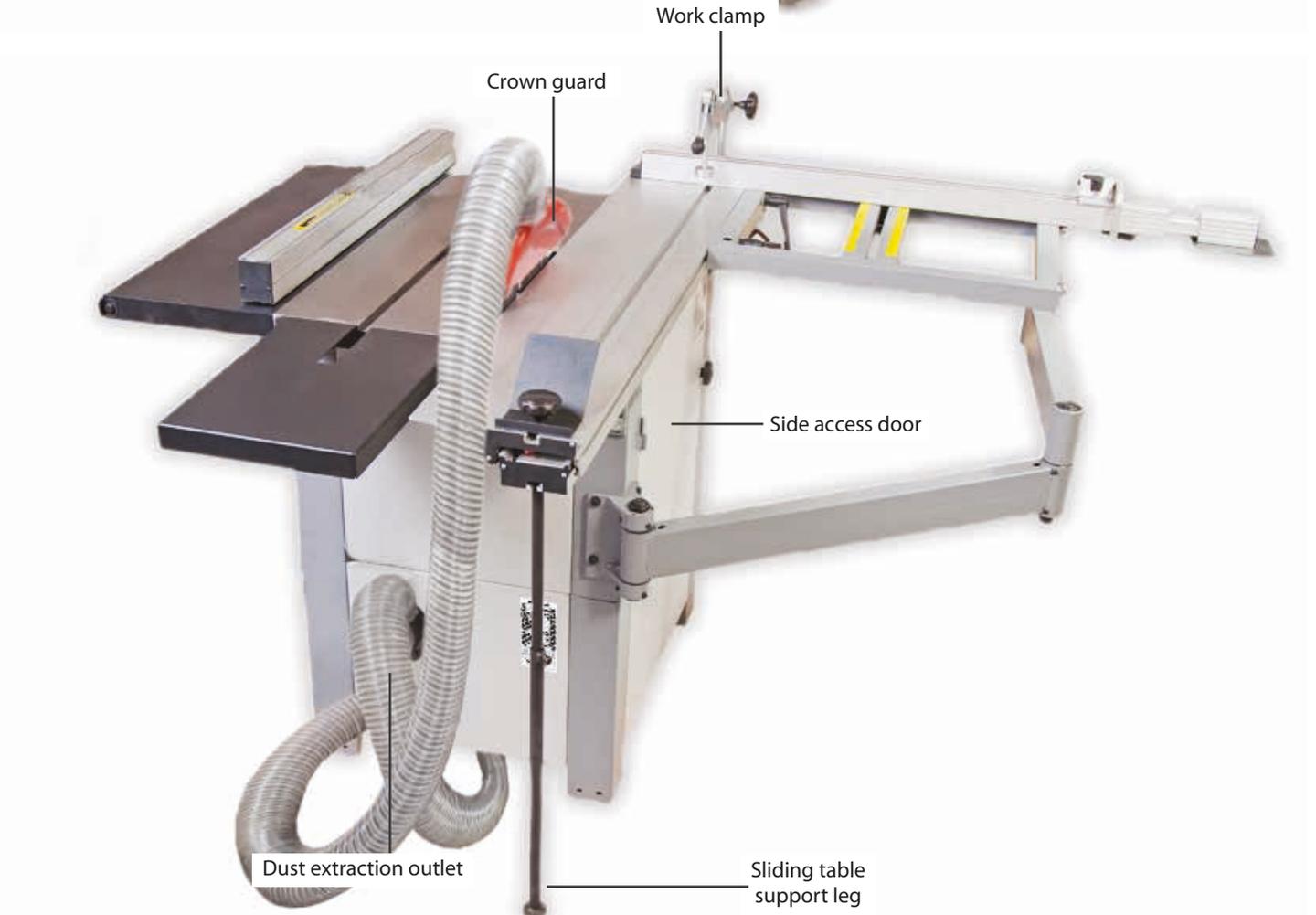
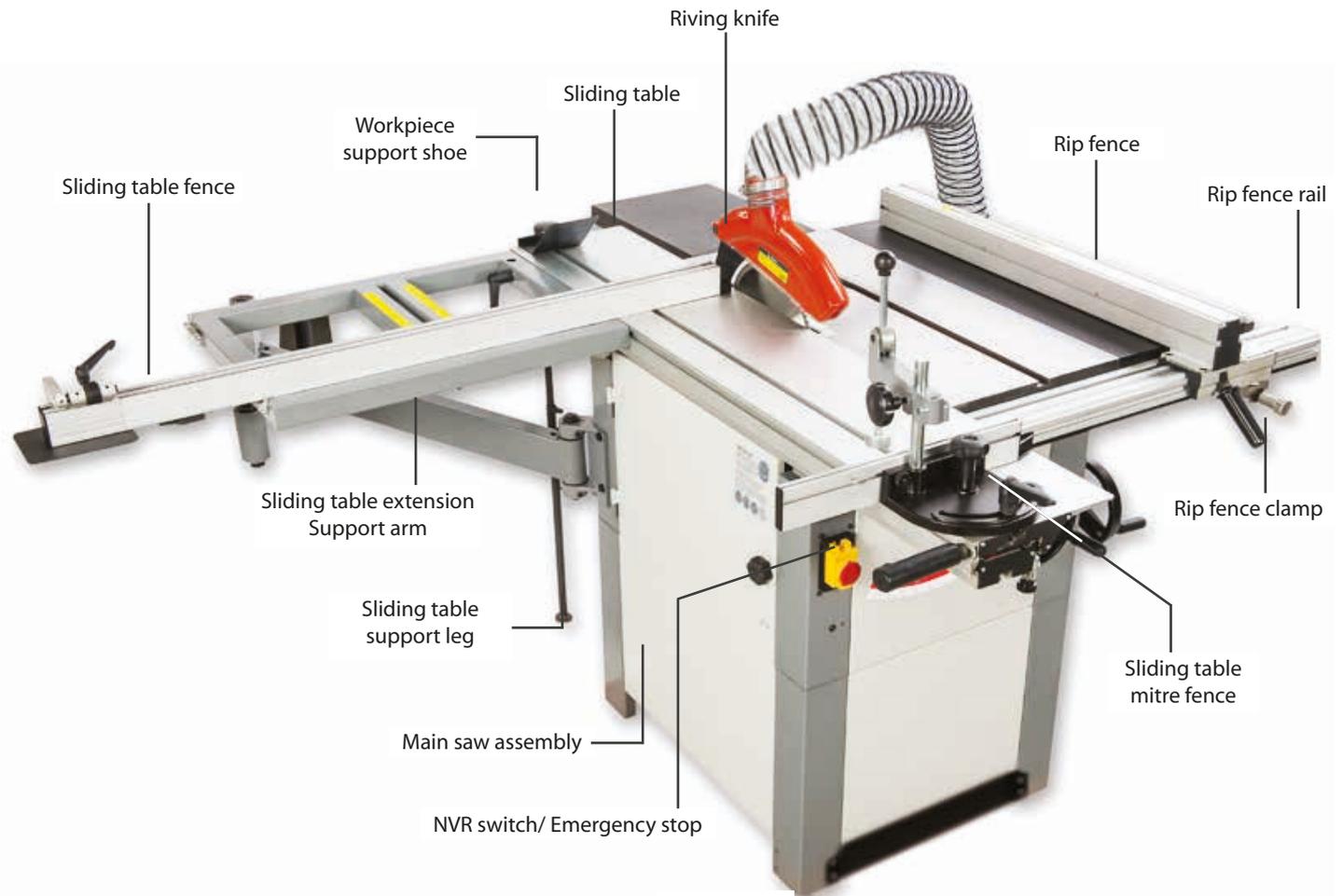
# Machine Footprint



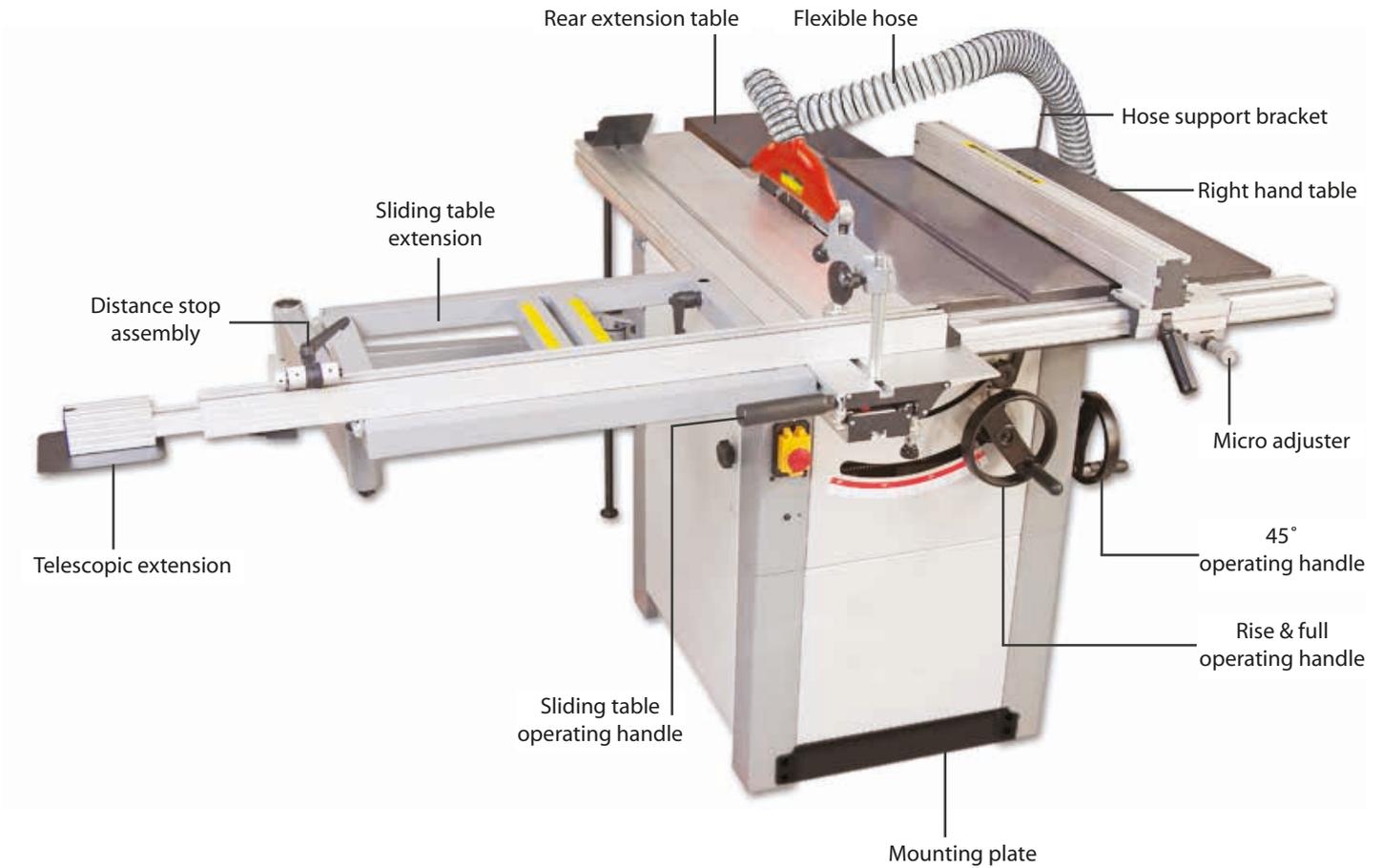
# Machine Footprint



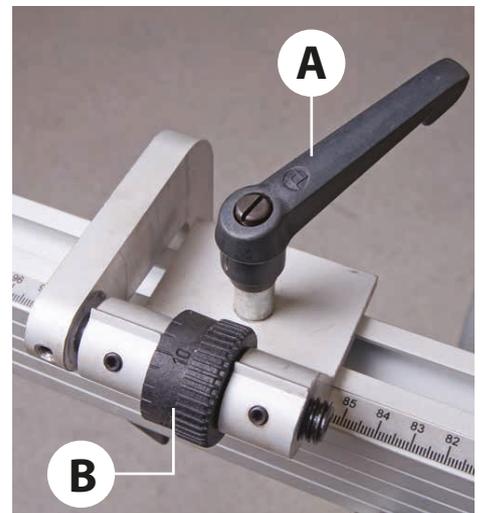
# Illustration and Parts Description



# Illustration and Parts Description



NVR Switch with Emergency stop shroud



Distance stop assembly. Loosen the handle (A) to reposition the stop. For fine adjustment turn the adjusting knob (B).

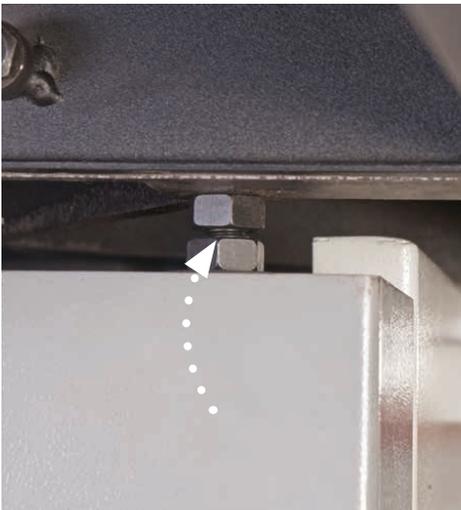
# Illustration and Parts Description



Rip fence scale magnifying glass



45° Scale and pointer



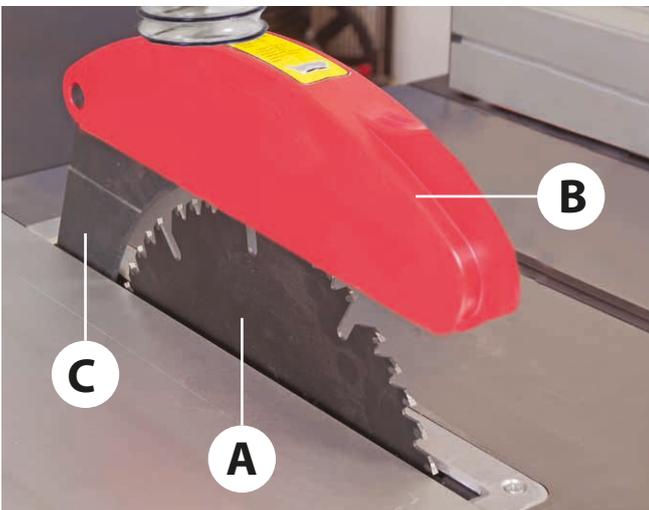
Main saw table, height adjusting bolts, one to each corner beneath the table



Over head clamp assembly



100 mm Dust extraction outlet



Saw assembly: The Blade (A), Crown Guard (B) and Riving Knife (C)



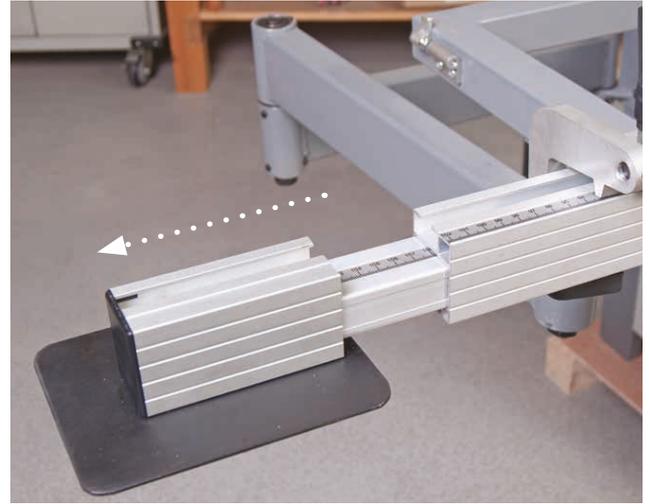
Sliding locking pin assembly  
Twist the knob to engage or disengage the locking pin



# Illustration and Parts Description



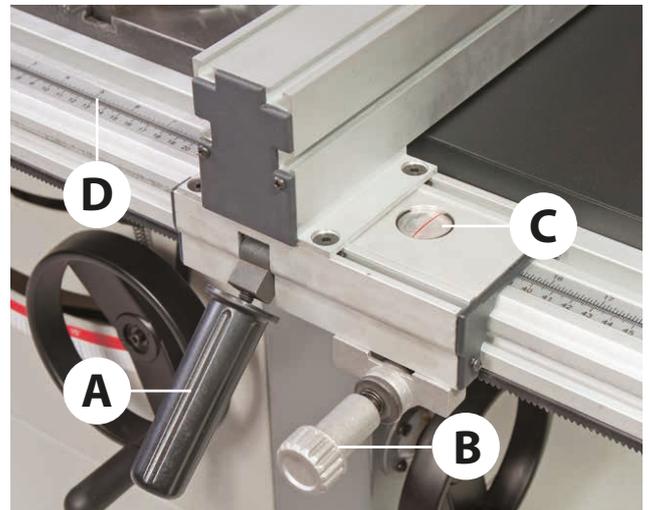
Motor/tilt assembly side access door



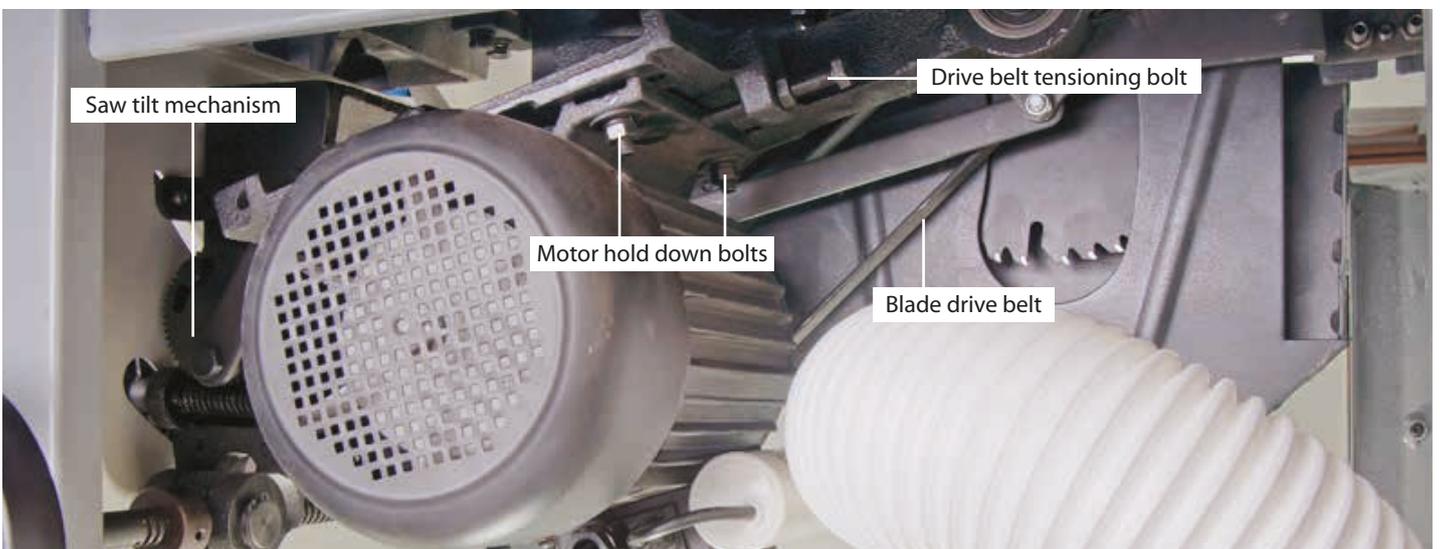
Telescopic fence extension  
Unlock the butterfly clamp beneath the fence to extend the fence by a metre



Sliding table mitre fence with over head clamp (A),  
Fence angle clamp (B), Over head clamp (C)



Rip Fence assembly  
Rip fence clamp (A), Micro adjuster (B),  
Magnifying glass (C) and Scale (D)



Motor and saw assembly

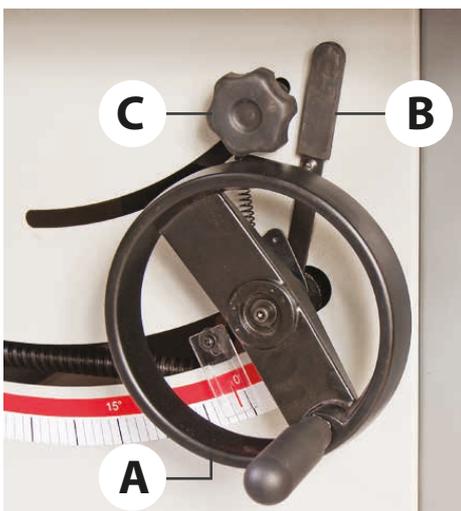
# Illustration and Parts Description



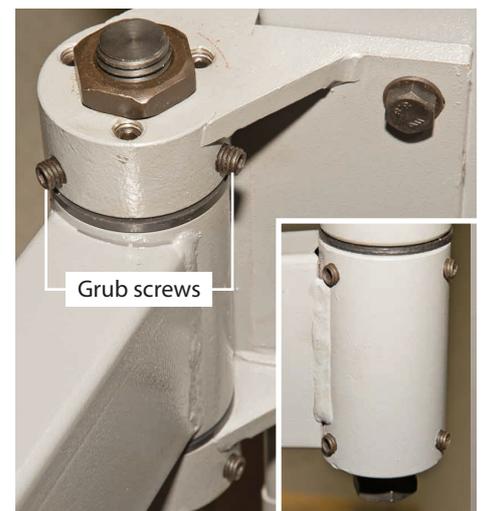
90° fence stop



Sliding table extension scale



Rise and full control wheel (A), Control wheel locking lever (B), Blade tilt locking knob (C) and 45° Control wheel (D)



Grub screws

Sliding table extension angle adjusting grub screws

# Positioning the Machine

Ascertain the orientation of the machine and move it to its desired position in the workshop. Ensure that the machine is positioned to allow sufficient clearance all round to cater for the maximum length of timber you

wish to machine. The machine should be positioned on a flat level surface. Manoeuvre the machine to the chosen location, then carefully lower the machine down.

## Setting Up the Machine

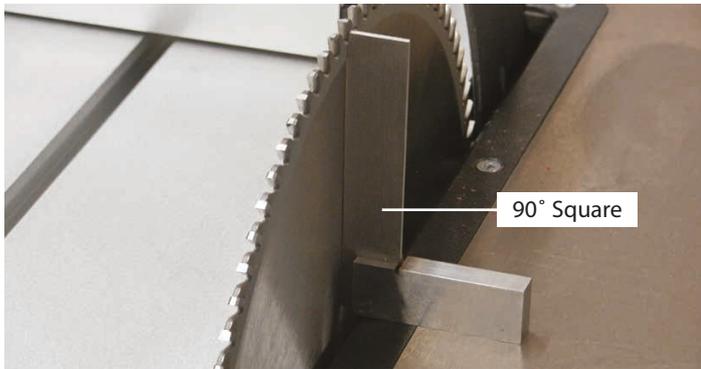


**WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!**

### Setting the Saw Blade at 90°

1. Remove the crown guard and place to one side, raise the saw to its maximum height by turning the operating wheel counterclockwise. Place a 90° square up against the saw blade and check the blade is 90° to the table, see fig 91.

**Fig 91**



2. If the blade needs adjustment loosen the grub screws on the 90° stop collar on the saw assembly, see fig 92 and adjust the collar in small increments until the blade is perpendicular with the table. Nip up the collar to lock the setting. Reset the scale pointer if required.

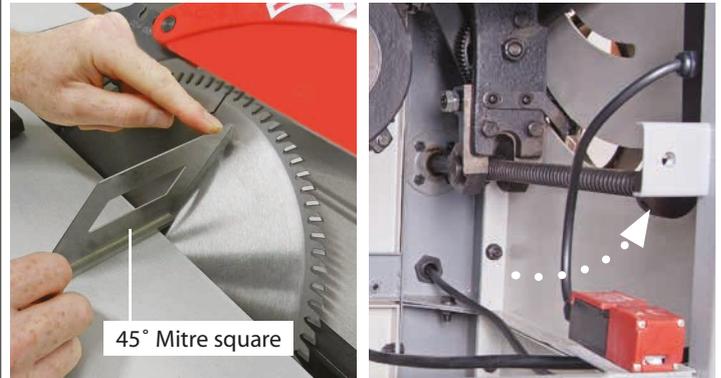
**Fig 92**



### Setting the Saw Blade at 45°

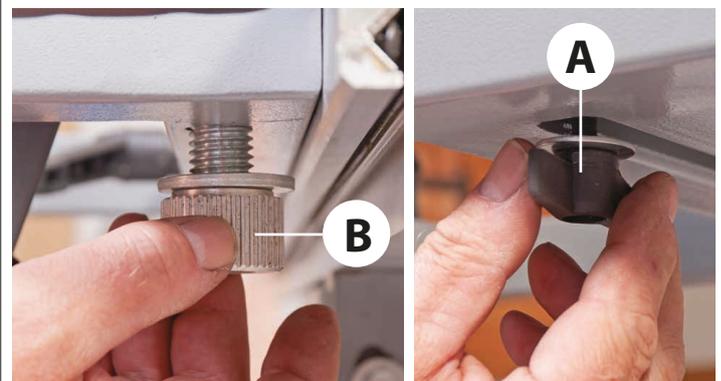
3. Set the angle of the saw to 45°, place a mitre square up against the blade and check it is 45° with the table. If adjustment is required loosen the grub screws on the 45° stop collar on the saw assembly, see fig 93. Adjust the collar in small increments until the blade is perpendicular with the table. Nip up the collar to lock the setting.

**Fig 93**



### Extension Table Fence

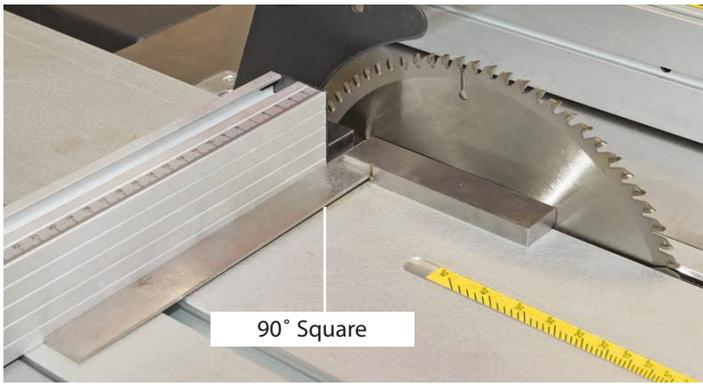
1. Raise the blade to its maximum height, slacken the butterfly knob (A) and the steel pin by loosening the clamping knob (B). Slide the fence up close to the saw



blade, make sure the extension fence is up against the 90° fence stop, see fig 94. Using a 90° square, place it against the fence and the blade (not on the teeth), see fig 95. Check that the angle is correct, if not adjust the 90° adjusting nut until the fence is square to the blade, see fig 96.

**Fig 94-96**





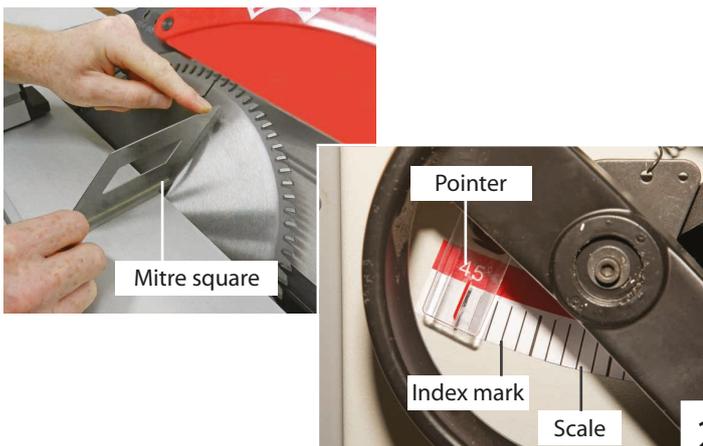
**Fig 96**



2. Slide the nose of the fence (the black tongue) up to the blade. 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 fully extended is about one quarter of a degree).

3. 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, see fig 97. Adjust the pointer if necessary. Reset the blade upright, check that the angle scale reading is correct.

**Fig 97**



4. Using a steel rule measure 30mm back from the saw tip, so the scale on the rule lines up with the 30mm on the fence scale (24), see fig 98. Secure the fence again as described in step 1.

**Fig 98**



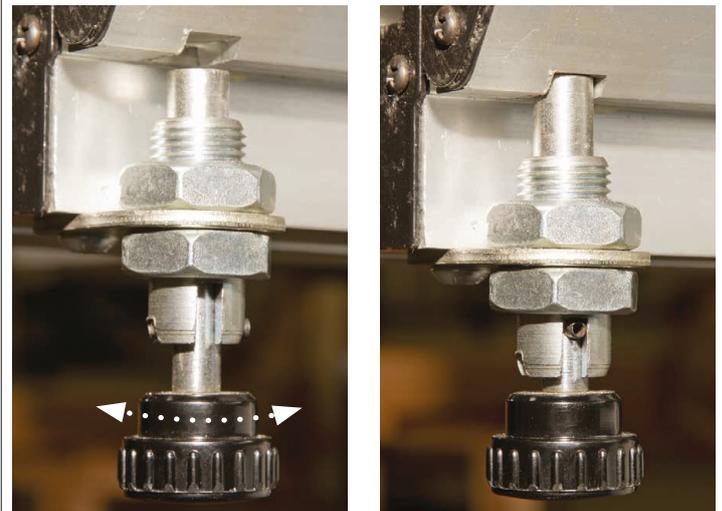
## Sliding Table

### Table Clearance

There should be 0.5 to 2mm clearance between the main saw table and the sliding table (10) to allow the blade to turn freely without it snagging.

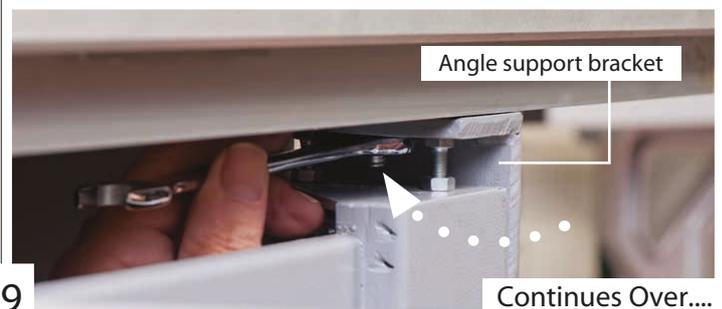
1. Raise the saw to its highest point and lock the sliding table (19) in position with the locking pin knob, see fig 99.

**Fig 99**



2. Open the side access door. Using a feeler gauge, loosen the centre nuts on the angled support brackets below the sliding table (10), see fig 100. Slot the feeler gauge down the gap between the two tables from one side and adjust until the gap is set between (0.5 to 2mm), repeat the procedure for the opposite side, see fig 101.

**Fig 100**



# Setting Up the Machine

**Fig 101**



3. Place a rule across both tables and measure the distance between both 'T' slots, do the same to the opposite end and check the distances are the same, see fig 102-103. If there is any deviation between the 'T' slots repeat step 2 and check again.

**Figure 102-103**



4. Once correct, tighten nuts on the supporting brackets to the underside of the sliding table to lock the setting, see fig 100.

## Sliding Table Height

Place a straight edge across both tables. Loosen the two clamping bolts on the support brackets beneath the sliding table, see fig 104. Adjust the rise full Hex bolts by loosening the locking nut, see fig 105 and adjust until the sliding table (10) is level with the main saw table. Once level, re-tighten the nuts to secure the setting.

**NOTE:** Check that the sliding table is still level with the main table as it may have shifted when tightening up the bolts.

**Fig 104-105**



## Setting the Riving Knife Gap

1. Raise the saw blade up to its maximum height and remove the crown guard assembly.
2. Check the clearance between the riving knife and the saw blade, it should have a gap of (MIN 3mm - MAX 8mm), see fig 106.

**Fig 106**



3. If adjustment is required, move the sliding table to one side, remove the two Phillips screws holding the inner guard assembly and place safely aside, see fig 107.

**Fig 107-108**



4. Loosen the bolts holding the riving knife, see fig 108. Adjust the knife until the required clearance is correct and then retighten the bolts. Replace the inner guard and crown guard.

## Rip Fence

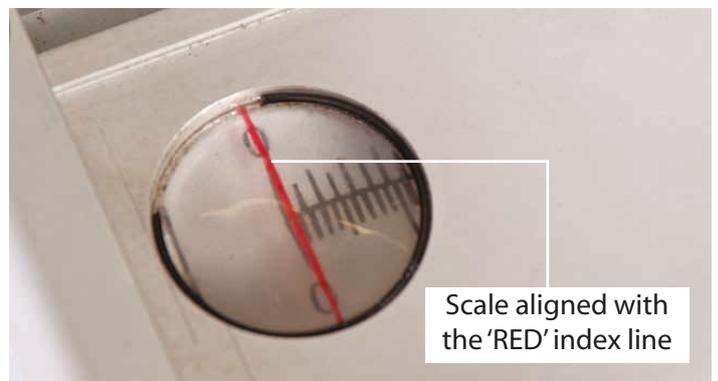
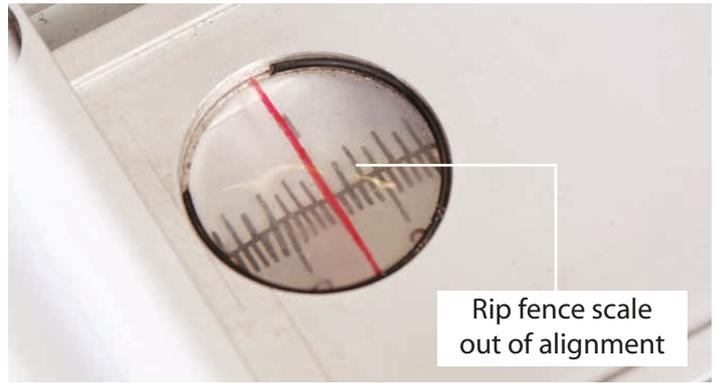
1. Raise the clamping handle and slide the rip fence up against the blade, see fig 109.

2. Look at the 'RED' line on the magnifying glass to check it's set to '0' on the scale, see fig 110. If the scale is out of alignment, loosen the fence rail (7) and tap the side until the scale reads '0' then re-secure the fence rail, see fig 111-112-113

**Fig 109**



**Fig 110-111-112-113**



# Operating Instructions



## CONNECT THE MACHINE TO THE MAINS!

Connect the machine to the mains supply, give the machine a test run, by pressing the On/Off buttons, see fig 114.

Check that everything sounds and feels OK. (No knocking, scraping, belt squeal, rubbing etc). Switch off the machine, wait until the saw comes to a complete stop



## RECONNECT THE MACHINE TO THE MAINS!

and disconnect the machine from the mains supply. Give the machine a longer run, and press down the emergency stop shroud on the front of the machine, see fig 115. Check that the blade comes to a complete stop. When you are happy that everything seems OK, switch the machine off, disconnect from the mains supply.

### Fig 114-115



Emergency stop shroud



## WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!

### Operating Procedures

1. Regulate the cutting height by raising or lowering the rise and fall control hand wheel (A). Lock the blade in place by turning the rise & fall control handle lock (B), see fig 116.
2. Lift the fence clamping handle and adjust the rip-fence to the desired position then press the clamping handle down to lock the fence in position.
3. Check that the room is well lit.
4. Use the extension table/fence when cutting large pieces of board at 90°, see fig 117.

Fig 116

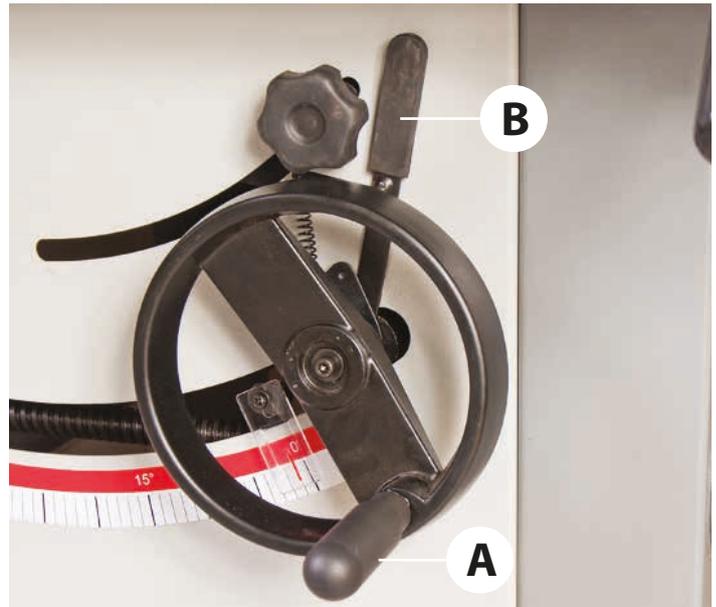
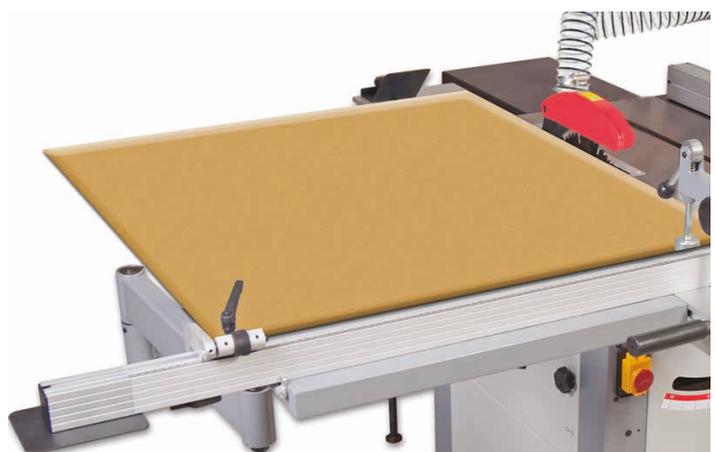


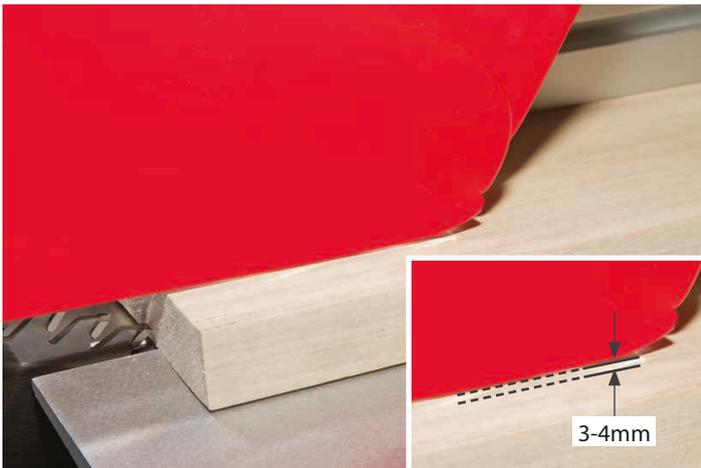
Fig 117



5. DO NOT use damaged or blunt blades as they can increase the effort required for feeding the workpiece through and the risk of accidents from 'KICKBACK'.
6. MAKE SURE that the saw table is clear of any tools and other accessories.
7. CHECK for deposits of gum or resin build up near the teeth as this tends to cause the saw to stall or the timber to stick.
8. CHECK that the crown guard is 3-4mm above the top of the workpiece, see fig 118.
9. CHECK the riving knife and saw blade have a gap of a between 3-8mm, see 'setting the riving knife' on page 30.

**NOTE: The riving knife acting as a back guard stops**

**Fig 118**



**the wood from closing up onto the blade and being ejected. The riving knife must be thicker than the plate of the saw blade but less than the kerf (this is the thickness of cut).**

**10. MAKE SURE** your workpiece is securely clamped in place.

### Dust Extraction

The panel saw has a 100mm dust extraction outlet to the rear of the machine, attach a chip extractor to the machine.



**WARNING!! ONLY USE AN EXTRACTOR WITH AN AIR FLOW OF 1,000M3/HR OR ABOVE WITH THIS PANEL SAW. CONTACT OUR SPECIALIST AFTER SALES TEAM FOR HELP. PHONE: 03332 406 406**



**RECONNECT THE MACHINE TO THE MAINS!**

**1.** Start the saw by pressing the 'ON' button on the NVR switch, wait until the saw is at full speed and carefully guide the workpiece safely through.



**WARNING!! DO NOT PUSH THE WORKPIECE TWO QUICKLY THROUGH OTHERWISE THE BLADE MIGHT STALL OR KICKBACK.**

**2.** Once complete, turn off the saw, wait until the saw comes to a complete stop before removing the workpiece.



**NOTE: DURING OPERATION IF YOU NOTICE A BUILD UP OF SAW DUST STOP THE MACHINE AND FOLLOW THE INSTRUCTIONS BELOW.**

**3.** Wait until the saw has stopped and disconnect the machine from the mains supply.

**4.** Move the sliding table (10) to one side, using a vacuum cleaner clean out any build up of dust debris or resin then slide the table to the opposite side and repeat the procedure.

**5.** Remove the two Phillips screws holding the inner guard assembly, see fig 119 and place safely aside. Remove the build up of dust debris around the blades, riving knife and the extractor housing.

**NOTE: To gain full access to the extractor housing it may be easier to remove the main blade, see fig 120. (see the section on changing the blade).**

**Fig 119-120**



**6.** Remove the hoses from the crown guard and extraction moulding and clean out any build up of dust and debris or resin from within. Once done, replace the hoses, saw blade, crown guard and inner guard.

**7.** Check your extractor and empty the collecting bags if full, also check and make sure the filters are clean.

# Operating Instructions



## RECONNECT THE MACHINE TO THE MAINS!

Start the saw by pressing the 'ON' button on the NVR switch. Wait until the saw is at full speed, if everything sounds and feels OK, carefully guide a test workpiece safely through, checking there is no build up of dust.

If all is OK., turn off the saw, wait until the saw comes to a complete stop before removing the workpiece.



## DISCONNECT THE MACHINE FROM THE MAINS!

### Rip Saw Cutting



## WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!

A push stick must be used when making cuts less than 300mm in length. The push stick should be at least 450mm long with a 'bird's mouth' to one end, see illustration below.



1. Set the crown guard 3-4mm above the top of the workpiece, see fig 118.

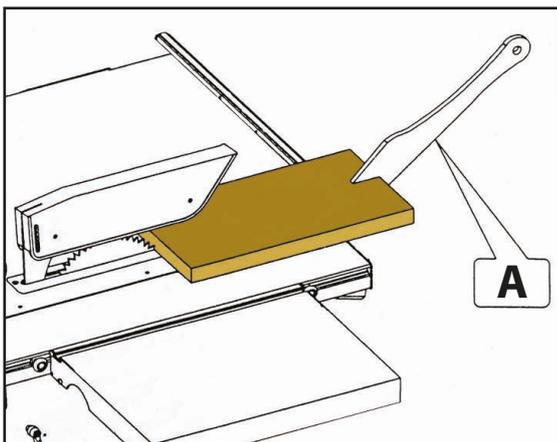
2. Set the fence for the width of cut.



## WARNING!! IT IS IMPORTANT THE FRONT EDGE OF THE FENCE NEVER PASSES THE CENTRE OF THE BLADE.



## RECONNECT THE MACHINE TO THE MAINS!

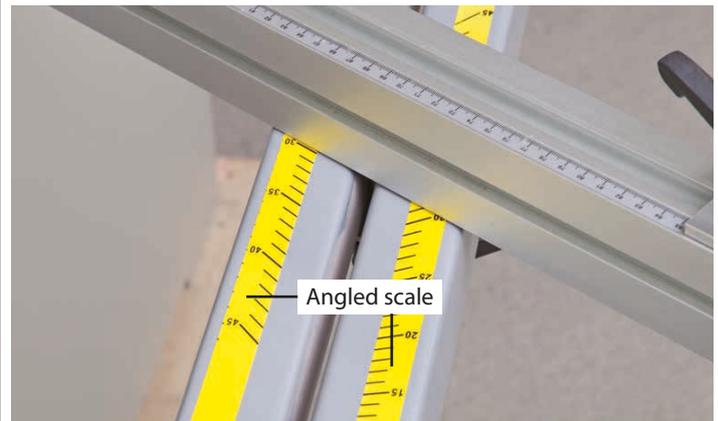


3. Start the saw, wait until it's at full speed and carefully feed the workpiece through using a 'push stick'. Make sure the workpiece is clear of the blade then turn off the saw, wait until the saw comes to a complete stop before removing the workpiece.

### Bevel Cut

There is an angle scale mounted on top of the extension table, to set the fence at required angles for cutting bevel cuts, see fig 121.

Fig 121



### HSE Health and Safety Executive

To operate the 'Panel Saw' correctly, it is recommended to visit the HSE (Health and Safety Executive) website at [www.hse.gov.uk](http://www.hse.gov.uk) and read the information on the safe practices.

Health and Safety Executive

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fall cross-cut saws that operate with a table. They can be either 'stand alone' or part of a production line with other types of panel-finishing machinery. The panel ...

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15 Aug 2013 ... As with the panel saw as well as risk from contact with the blade there is also a risk of being struck by an ejected workpiece. A riving knife must ...

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[Safety topics - Introduction to woodcutting machinery](#)

7 Feb 2013 ... Circular saw bench - Dimension (panel) saw - Cross-cut saw ... for their assistance in producing Introduction to woodcutting machinery.

[www.hse.gov.uk/woodworking/woodcutting.htm](http://www.hse.gov.uk/woodworking/woodcutting.htm)

# Changing the Saw Blade

## Changing the Blade

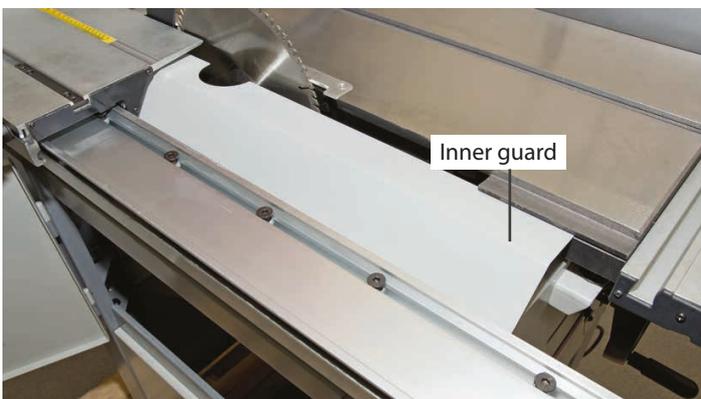


**WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!**

1. Raise the saw blade to its highest point. Remove the saw blade crown guard and place to one side. Pull the sliding table locking knob down and slide the table to the side exposing the blade.

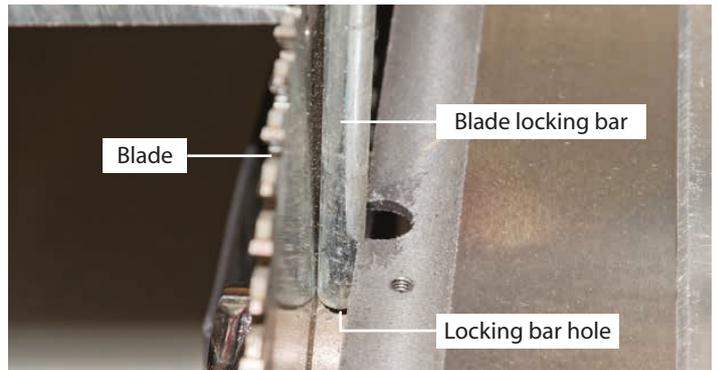
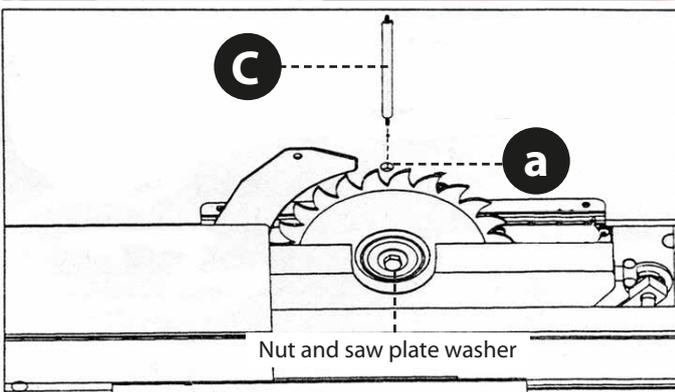
2. Remove the two Phillips screws holding the inner guard and place both safely to one side, see fig 122.

**Fig 122**



3. Locate the 24mm the supplied spanner and the blade locking bar (C). Remove the kerf plate and place it and the four Phillips screws aside, see fig 123. Turn the saw until the locking bar hole (a) is visible and insert the locking bar (C) into the hole, see fig 124-125.

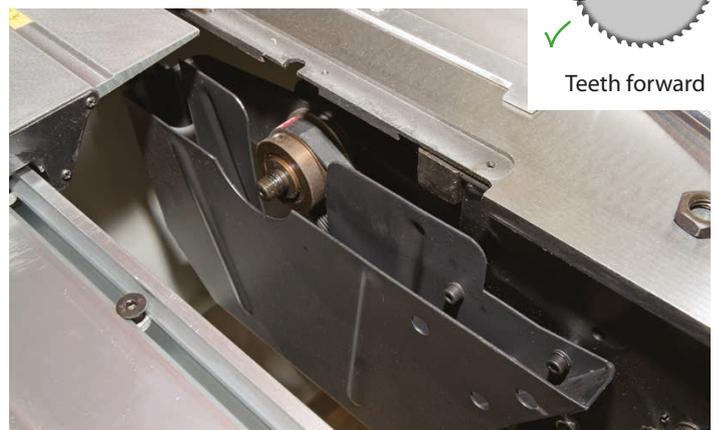
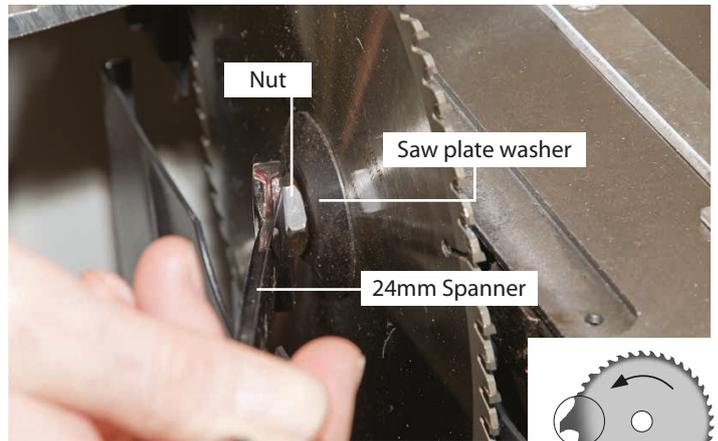
**Fig 123-124-125**



4. Remove the 'Nut', (remember left hand thread). Remove the saw plate washer and the saw blade, place to one side, see fig 126.

5. Now is a good time to give the interior of the machine, the dust extraction channels, etc. a thorough clean, see fig 127.

**Fig 126-127**



6. 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. Put the saw plate washer onto the shaft and replace the 'Nut' until finger tight and check the saw is correctly seated. Tighten up the 'Nut', using the blade locking bar (C) to hold the shaft steady. Check the riving knife is aligned with the saw blade, and correctly positioned, (see setting the riving knife gap on page 30).

# Changing the Saw Blade

7. Replace the kerf plate and inner guard assembly. Slide the table back until the locking knob pin engages the pin recess. Turn the saw blade once by hand to check it spins freely and replace the crown guard. When everything is

satisfactory, reconnect the machine to the mains supply. Give the machine a test run ( i.e. quick ON-OFF) to ensure everything is OK. If everything is satisfactory, continue to use the panel saw.

## Routine Maintenance

### General Information

- Keep the saw as clean and free from saw dust build up as practical.
- Periodically, unlock the sliding table and push to one side and remove the inner guard to gain access to the saw mechanism. Raise the saw blade to it's highest point, remove the crown guard and blow, brush or vacuum out the saw inner workings, using a proprietary resin cleaner.
- Check the saw blade regularly for chipped ,missing, damaged teeth etc. and remove any resin build up from the blade/s, riving knife etc.
- After several months of constant use the condition of the chains, sprockets, tension of the drive belts and the threaded drive shafts of the rise and fall tilt mechanisms will need to be checked; that may require a service engineer to oversee the job.
- **If you find that the machine is not performing as it should please contact our "Specialist After Sales Team" by phone on 03332 406 406 or visit our website at axminster.co.uk.**
- If the "Panel Saw" is not going to be used for a period of time, spray a light coat of oil over the table surface and blades that will help prevent rust.

### Sliding Table (Side Play Movement)

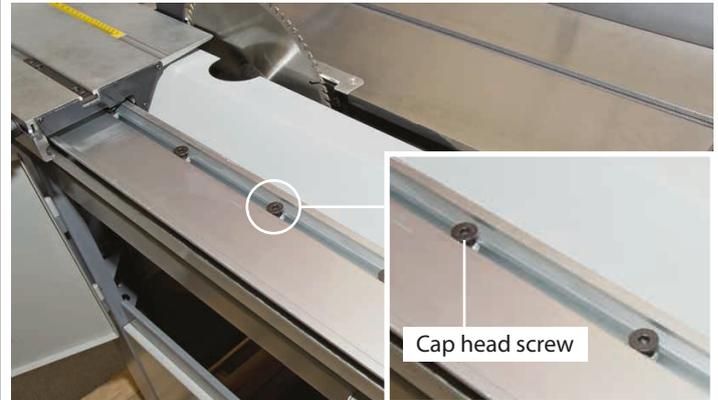
**After several months of use, if you notice the sliding table shows signs of 'slide play' movement follow the instruction below.**



**WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!**

1. Pull the sliding table locking knob towards you and slide the table to the side exposing the cap head screws beneath, see 128.
2. Adjust each screw in turn, (one rotation) should be sufficient. Slide the table to the opposite end and repeat the procedure. Check the table to see that the slide play has been queried. If OK, re-lock the table.

**Fig 128**



### Inspecting and Changing the Drive Belts

Check the blade drive belts for any signs of wear including fraying, stretching, missing teeth and basic wear and tear etc. Follow the instructions below.



**WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!**

### Main Saw Blade

1. Slide the table to one side and remove the crown guard and inner guard, place safely aside.
2. Remove the main blade, as instructed on page 35.
3. Remove the fixing that secures the extractor housing assembly, see figs 129 place them safely aside and lower housing assembly down to the floor.

**Fig 129**



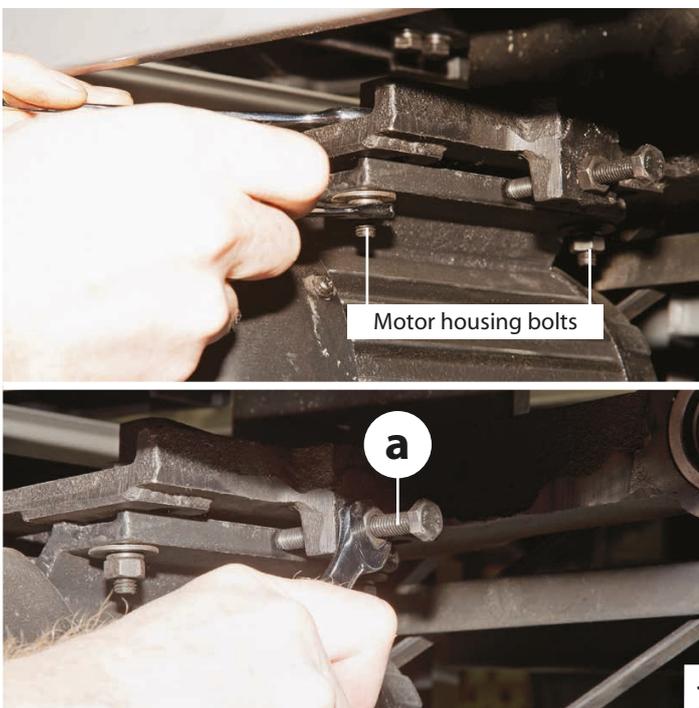
4. Open the side access door, see fig 130-131, this gives access to the motor saw assembly. Loosen the four bolts holding the motor housing, see fig 132 then loosen the belt tension bolt (a), see fig 133. Pull the motor forward to slacken off the drive belt.

**Fig 130-131**

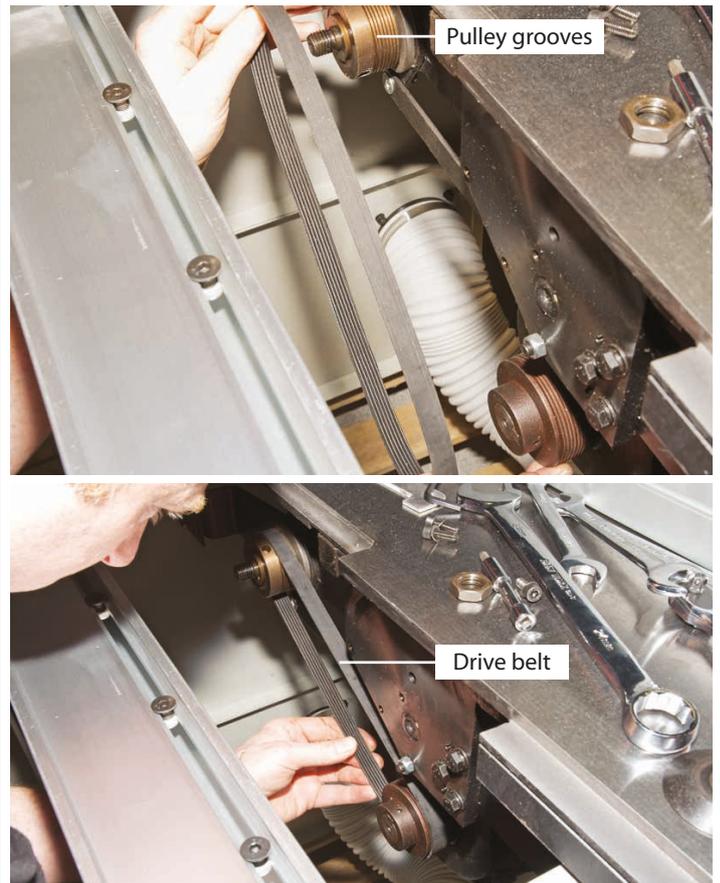


5. Remove the belt from the pulleys and check the condition of the belt. If there are signs of fraying or stretching, replace with a new one.

**Fig 132-133**



**Fig 134-135**



6. Place the new belt over the two pulleys and insert the belt groove into the grooves on the pulleys, see fig 134-135. Turn the belt by hand to make sure the belt has seated down properly.

7. Push the motor assembly back, re-tension the belt by adjusting the tensioning bolt (a) then tighten the four bolts to clamp the motor in position.

8. Close the side access door, replace the blade and kerf plate. Check the clearance of the riving knife as shown on page 30. Slide the table back until the locking knob pin engages the pin recess, turn the saw blade once by hand to check it spins freely and replace the crown guard. When everything is satisfactory reconnect the machine to the mains supply.

9. Give the machine a test run ( i.e. quick ON-OFF) to ensure everything is OK. If everything is satisfactory, continue to use the panel saw.

# Routine Maintenance

## Lubrication

After every three or four months we recommend you lubricate the blade and the tilt, rise and fall screw threads using 'Ambersil Dry PTFE Film Antistick' spray, see fig 136-137.



Ambersil Dry PTFE Film Antistick spray

Fig 136

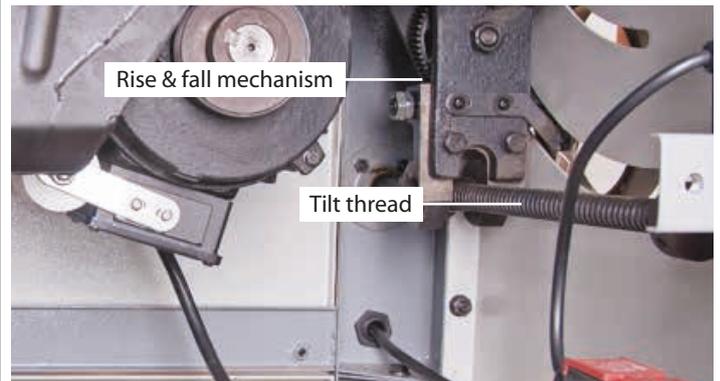
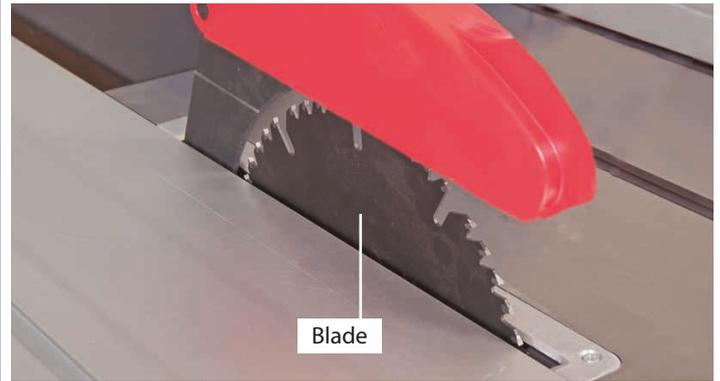


Fig 137

## Wiring Diagram

1~, Motor

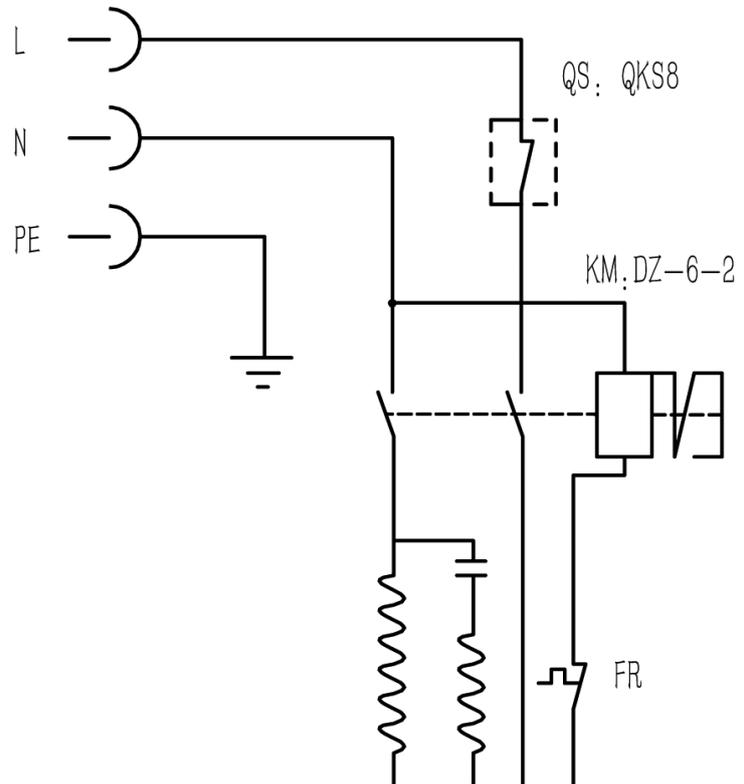
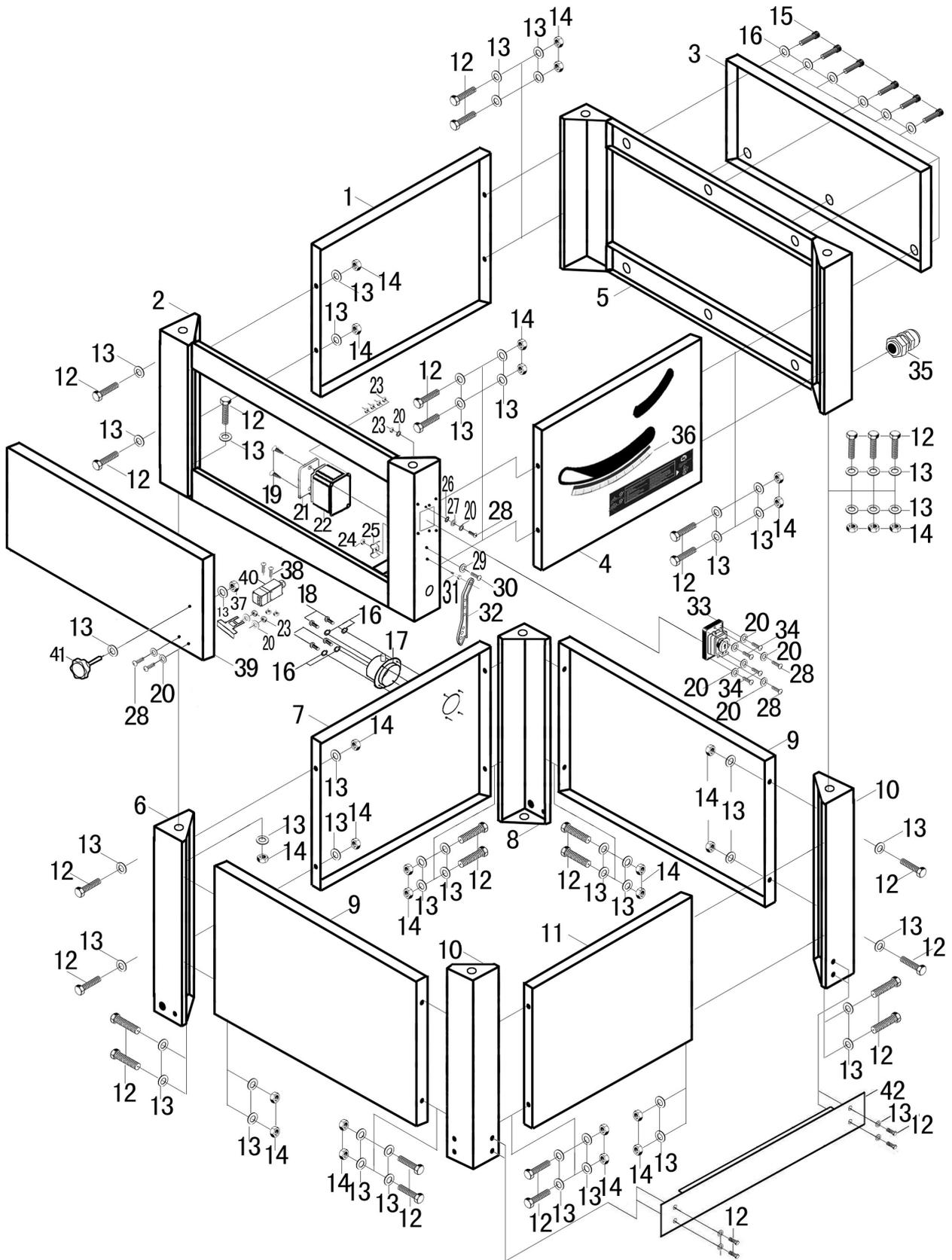


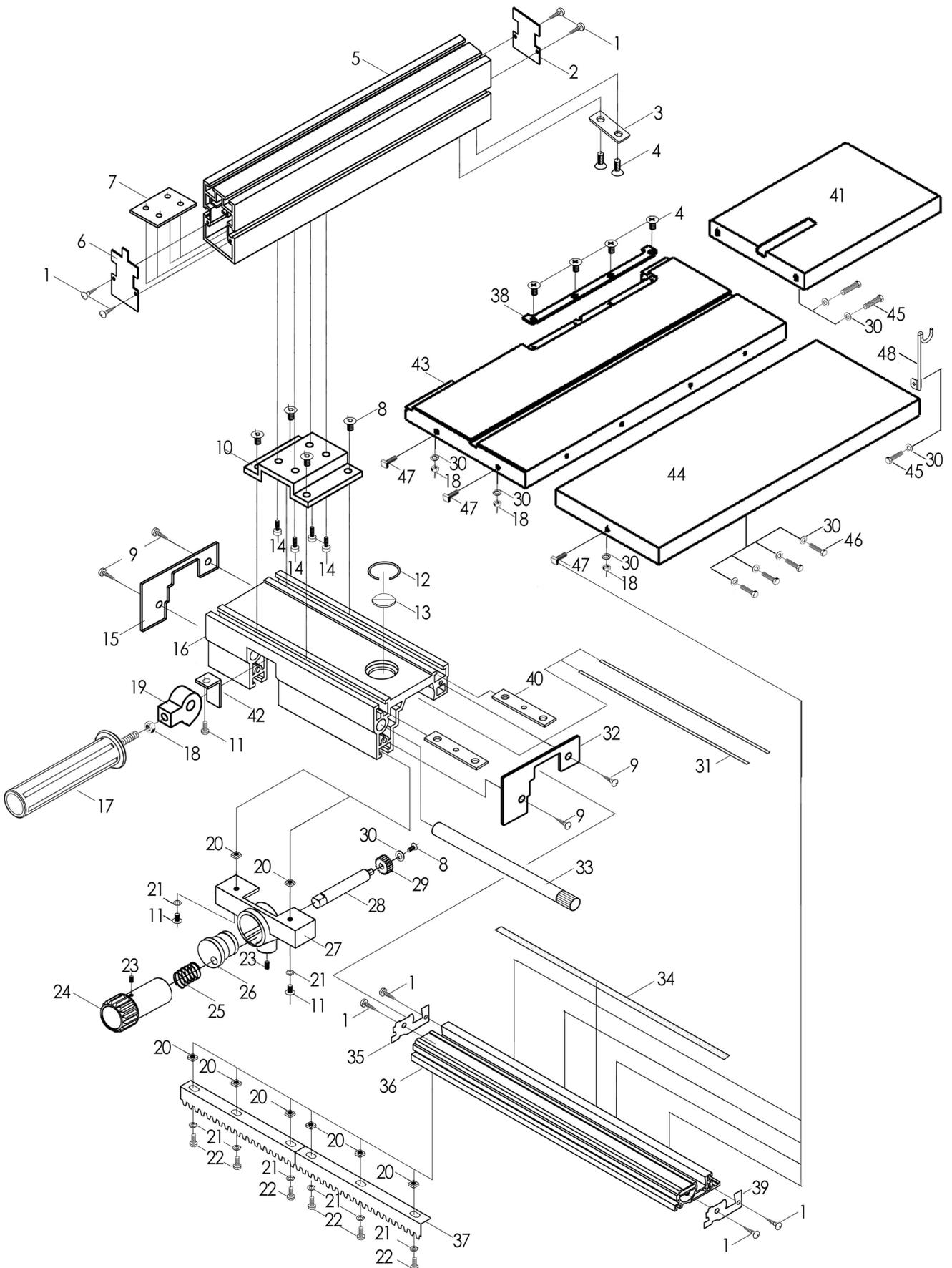
DIAGRAM A



## Exploded Diagrams/Lists

| No.  | Description                       | Qty |
|------|-----------------------------------|-----|
| A-1  | Rear panel, machine housing       | 1   |
| A-2  | Lest frame, machine housing       | 1   |
| A-3  | Right panel, machine housing      | 1   |
| A-4  | Front panel, machine housing      | 1   |
| A-5  | Right frame, machine housing      | 1   |
| A-6  | Column A                          | 1   |
| A-7  | Rear panel, work stand            | 1   |
| A-8  | column B                          | 1   |
| A-9  | Side panel, work stand            | 2   |
| A-10 | Column C, work stand              | 2   |
| A-11 | Front panel, work stand           | 1   |
| A-12 | Hex screw M8x16                   | 28  |
| A-13 | Washer 8mm                        | 58  |
| A-14 | Hex nut M8                        | 28  |
| A-15 | Allen screw M6x22                 | 6   |
| A-16 | Washer 6mm                        | 10  |
| A-17 | Dust outlet                       | 1   |
| A-18 | Pan head screw M6x16              | 4   |
| A-19 | Taping screw ST4.2x12             | 2   |
| A-20 | Washer 4mm                        | 10  |
| A-21 | Switch bottom board               | 1   |
| A-22 | Switch box                        | 1   |
| A-23 | Hex nut M4                        | 9   |
| A-24 | Hex nut M5                        | 1   |
| A-25 | Wire clamp                        | 1   |
| A-26 | External teeth lock washer 5mm    | 1   |
| A-27 | Spring washer 4mm                 | 1   |
| A-28 | Pan head screw M4x10              | 5   |
| A-29 | Washer 5mm                        | 1   |
| A-30 | Pan head screw M5x20              | 1   |
| A-31 | Holder, push sitcker              | 1   |
| A-32 | Push sticker                      | 1   |
| A-33 | Switch                            | 1   |
| A-34 | Pan head screw M4x14              | 4   |
| A-35 | Strain relief M20                 | 1   |
| A-36 | Scale, 45 degree                  | 1   |
| A-37 | Lock nut M8                       | 1   |
| A-38 | Pan head screw M4x30              | 2   |
| A-39 | Door                              | 1   |
| A-40 | Micro. Switch                     | 1   |
| A-41 | Konb M8                           | 1   |
| A-42 | Connectiom plate for mobile wheel | 1   |

DIAGRAM B

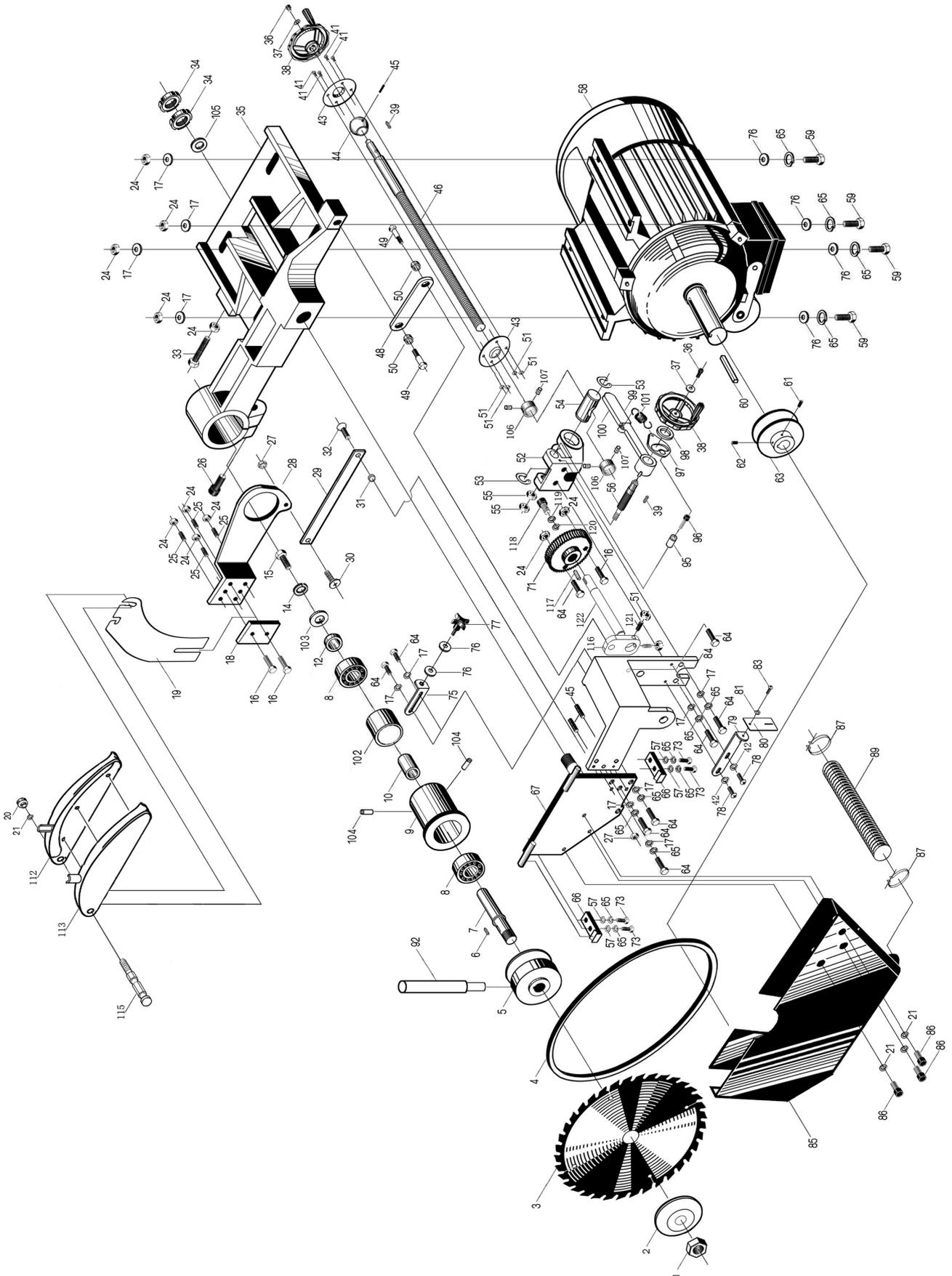


## Exploded Diagrams/Lists

| No.         | Description            | Qty      |
|-------------|------------------------|----------|
| <b>B-1</b>  | Taping screw ST4.2x10  | <b>8</b> |
| <b>B-2</b>  | Cap , fence            | <b>1</b> |
| <b>B-3</b>  | Plate, fence           | <b>1</b> |
| <b>B-4</b>  | Sunk head screw M5x6   | <b>2</b> |
| <b>B-5</b>  | Fence                  | <b>1</b> |
| <b>B-6</b>  | Cap,fence              | <b>1</b> |
| <b>B-7</b>  | Guide plate, screw     | <b>1</b> |
| <b>B-8</b>  | Countersunk screw M5x8 | <b>5</b> |
| <b>B-9</b>  | Taping screw ST4.0x10  | <b>4</b> |
| <b>B-10</b> | Jointer, fence         | <b>1</b> |
| <b>B-11</b> | Pan head screw m4x6    | <b>3</b> |
| <b>B-12</b> | Ring circle            | <b>1</b> |
| <b>B-13</b> | Lens                   | <b>1</b> |
| <b>B-14</b> | Allen screw M6x12      | <b>4</b> |
| <b>B-15</b> | Left cap, fence guide  | <b>1</b> |
| <b>B-16</b> | Fence guide            | <b>1</b> |
| <b>B-17</b> | Lock handle, fence     | <b>1</b> |
| <b>B-18</b> | Hex nut M8             | <b>4</b> |
| <b>B-19</b> | Lock eccentric cam     | <b>1</b> |
| <b>B-20</b> | Square nut M5          | <b>8</b> |
| <b>B-21</b> | Washer 5mm             | <b>8</b> |
| <b>B-22</b> | Pan head screw M5x8    | <b>6</b> |
| <b>B-23</b> | Set screw M6x6         | <b>2</b> |

|             |                        |           |
|-------------|------------------------|-----------|
| <b>B-24</b> | Handle, fine adjust    | <b>1</b>  |
| <b>B-25</b> | Spring,gear            | <b>1</b>  |
| <b>B-26</b> | Eccentric, fine adjust | <b>1</b>  |
| <b>B-27</b> | Seat, fine adjust      | <b>1</b>  |
| <b>B-28</b> | Rod,gear               | <b>1</b>  |
| <b>B-29</b> | Gear                   | <b>1</b>  |
| <b>B-30</b> | Washer 8mm             | <b>10</b> |
| <b>B-31</b> | PVC sticker            | <b>2</b>  |
| <b>B-32</b> | Right cap ,fence guide | <b>1</b>  |
| <b>B-33</b> | Rod,lock handle        | <b>1</b>  |
| <b>B-34</b> | Scale, fence guide     | <b>1</b>  |
| <b>B-35</b> | Left cap, fence rail   | <b>1</b>  |
| <b>B-36</b> | Fence rail             | <b>1</b>  |
| <b>B-37</b> | Rack, fine adjust      | <b>2</b>  |
| <b>B-38</b> | Table insert           | <b>1</b>  |
| <b>B-39</b> | Right cap,fence rail   | <b>1</b>  |
| <b>B-40</b> | Screw guide plate      | <b>2</b>  |
| <b>B-41</b> | Rear extension table   | <b>1</b>  |
| <b>B-42</b> | Lock plate             | <b>1</b>  |
| <b>B-43</b> | Main table             | <b>1</b>  |
| <b>B-44</b> | Extension table        | <b>1</b>  |
| <b>B-45</b> | Hex screw M8x12        | <b>2</b>  |
| <b>B-46</b> | Hex screw M8x22        | <b>4</b>  |
| <b>B-47</b> | Square head bolt M8x25 | <b>3</b>  |

DIAGRAM C

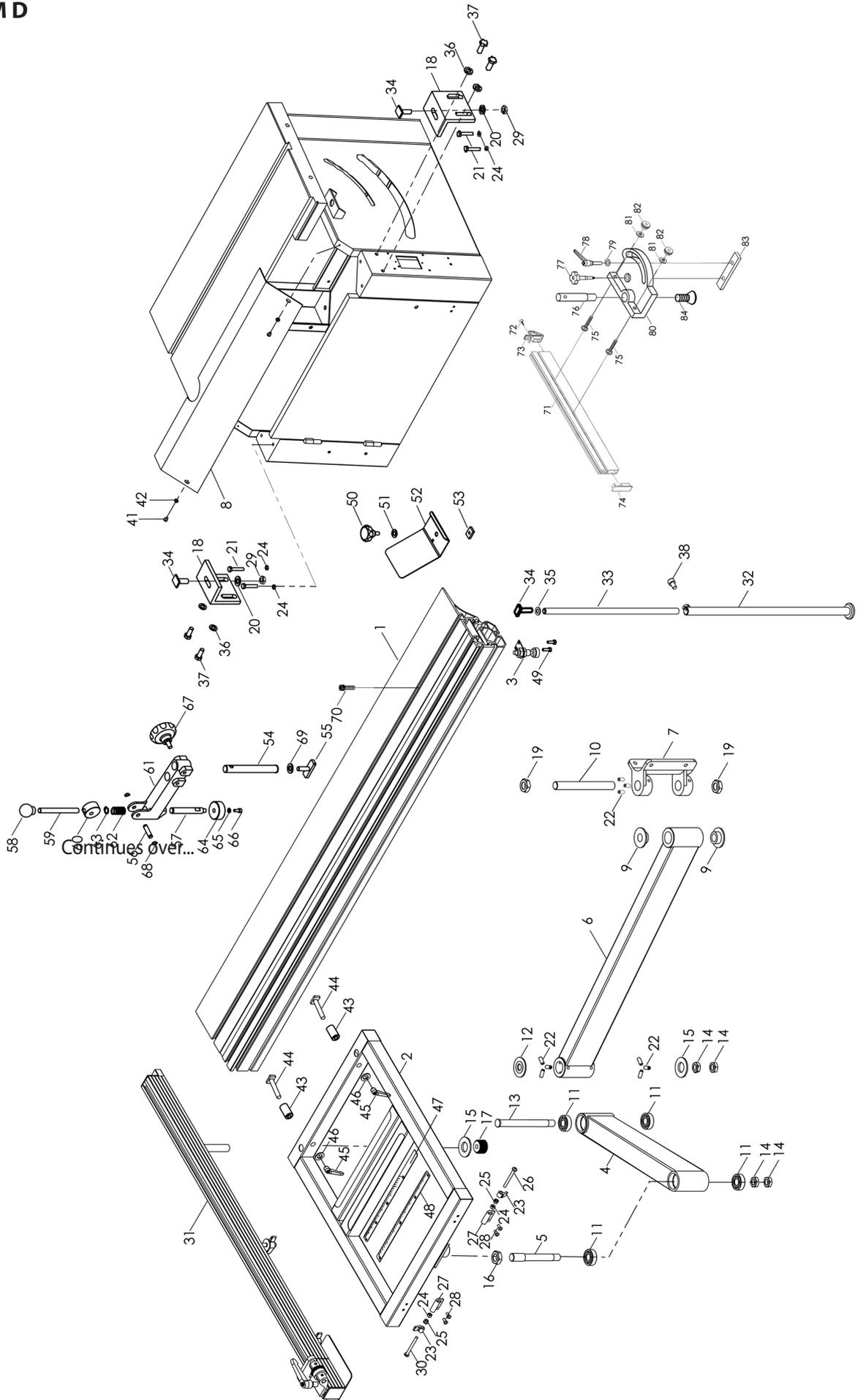


# Exploded Diagrams/Lists

| No.  | Description                                    | Qty |
|------|------------------------------------------------|-----|
| C-1  | Blade nut M16 left-hand                        | 1   |
| C-2  | Outer blade washer                             | 1   |
| C-3  | Blade                                          | 1   |
| C-4  | Driving belt                                   | 1   |
| C-5  | Pulley                                         | 1   |
| C-6  | Key A-type                                     | 1   |
| C-7  | Arbor shaft                                    | 1   |
| C-8  | Bearing 80203                                  | 2   |
| C-9  | Arbor shaft sleeve                             | 1   |
| C-10 | Arbor shaft bush                               | 1   |
| C-12 | Arbor shaft end bush                           | 1   |
| C-14 | Single coil spring lock washer 6               | 1   |
| C-15 | Hexagon head bolt M6X16                        | 1   |
| C-16 | Hexagon head bolt M8X20                        | 3   |
| C-17 | Flat washer 8                                  | 11  |
| C-18 | Press board for riving knife                   | 1   |
| C-19 | Riving knife                                   | 1   |
| C-20 | Flower nut                                     | 1   |
| C-21 | Flat washer 6                                  | 4   |
| C-24 | Hexagon nut M8                                 | 11  |
| C-25 | Hexagon socket set screw with flat point M8X25 | 4   |
| C-26 | Hexagon socket cap head screw M10X35           | 1   |
| C-27 | Locking nut with plastic insert M8             | 2   |
| C-28 | Riving knife bracket                           | 1   |
| C-29 | Connecting rod                                 | 1   |
| C-30 | Cross recessed countersunk head screw M8X20    | 1   |
| C-31 | Bush                                           |     |
| C-32 | Cross recessed countersunk head screw M8X30    | 1   |
| C-33 | Hexagon head bolt M8X65                        | 1   |
| C-34 | Locking nut for motor base shaft               | 2   |
| C-35 | Motor base                                     | 1   |
| C-36 | Hexagon socket cap head screw M5X12            | 2   |
| C-37 | Large washer 5                                 | 2   |
| C-38 | Hand wheel                                     | 2   |
| C-39 | Key 4x4x12                                     | 2   |
| C-41 | Cross recessed pan head screw M6X16            | 4   |
| C-42 | Flat washer 5                                  | 2   |
| C-43 | Ball bracket                                   | 2   |
| C-44 | Thread rod ball                                | 1   |
| C-45 | Spring-type straight pins-slotted 4x25         | 1   |
| C-46 | Adjusting thread rod                           | 1   |
| C-48 | Worm-wheel connecting rod                      | 1   |
| C-49 | Worm-wheel connecting rod nail B               | 1   |
| C-50 | Connecting rod bush                            | 2   |
| C-51 | Hexagon nut M6                                 | 6   |
| C-52 | Adjusting frame                                | 1   |
| C-53 | Circlips for shaft D=24                        | 2   |
| C-54 | Knuckle                                        | 1   |
| C-55 | Thin nut M12                                   | 2   |
| C-56 | Height adjusting rod                           | 1   |

|       |                                                 |    |
|-------|-------------------------------------------------|----|
| C-57  | Thicken washer 8                                | 4  |
| C-58  | Motor                                           | 1  |
| C-59  | Hexagon head bolt M8X40                         | 4  |
| C-60  | Key 8X7X50                                      | 1  |
| C-61  | Hexagon socket set screw with flat point M6X8   | 1  |
| C-62  | Hexagon socket set screw with flat point M6X6   | 1  |
| C-63  | Motor pulley                                    | 1  |
| C-64  | Hexagon head bolt M8X25                         | 9  |
| C-65  | Single coil spring lock washer 8                | 13 |
| C-66  | Rotation press block                            | 2  |
| C-67  | Adjusting cradle                                | 1  |
| C-71  | Worm-wheel                                      | 1  |
| C-73  | Hexagon head bolt M8X30                         | 4  |
| C-75  | Locking block                                   | 1  |
| C-76  | Large washer 8                                  | 6  |
| C-77  | Flower screw M8X20                              | 1  |
| C-78  | Cross recessed pan head screw M5X12             | 2  |
| C-79  | Pointer bracket                                 | 1  |
| C-80  | Pointer                                         | 1  |
| C-81  | Flat washer 4                                   | 1  |
| C-83  | Cross recessed pan head screw M4X10             | 1  |
| C-84  | Adjusting worm-wheel bracket                    | 1  |
| C-85  | Dust collection cover                           | 1  |
| C-86  | Hexagon socket cap head screw M6X18             | 3  |
| C-87  | Neck chain                                      | 2  |
| C-89  | Dust collection tube                            | 1  |
| C-92  | Tommy Bar                                       | 1  |
| C-95  | Lock nail bush                                  | 1  |
| C-96  | Hexagon socket cap head screw M6X25             | 1  |
| C-97  | Active board                                    | 1  |
| C-98  | Active board block                              | 1  |
| C-99  | Lock handle                                     | 1  |
| C-100 | Lock handle sleeve                              | 1  |
| C-101 | Lock handle spring                              | 1  |
| C-102 | Bush of arbor shaft                             | 1  |
| C-103 | Thicken washer 6                                | 1  |
| C-104 | Spring-type straight pins-slotted 6x10          | 2  |
| C-105 | Big flat washer 20                              | 1  |
| C-106 | Stop collar                                     | 2  |
| C-107 | Hexagon socket set screw with flat point M8X110 | 4  |
| C-112 | Blade guard A,half                              | 1  |
| C-113 | Blade guard B,half                              | 1  |
| C-115 | Lock bolt,guard                                 | 1  |
| C-116 | Connection rod,worm wheel shaft                 | 1  |
| C-117 | Key 5x5x15                                      | 1  |
| C-118 | Hexagon socket cap head screw M5X10             | 1  |
| C-119 | Spring washer 5                                 | 1  |
| C-120 | Flat washer 6                                   | 1  |
| C-121 | Hexagon socket set screw with flat point M6X16  | 2  |
| C-122 | Worm wheel shaft                                | 1  |

DIAGRAM D

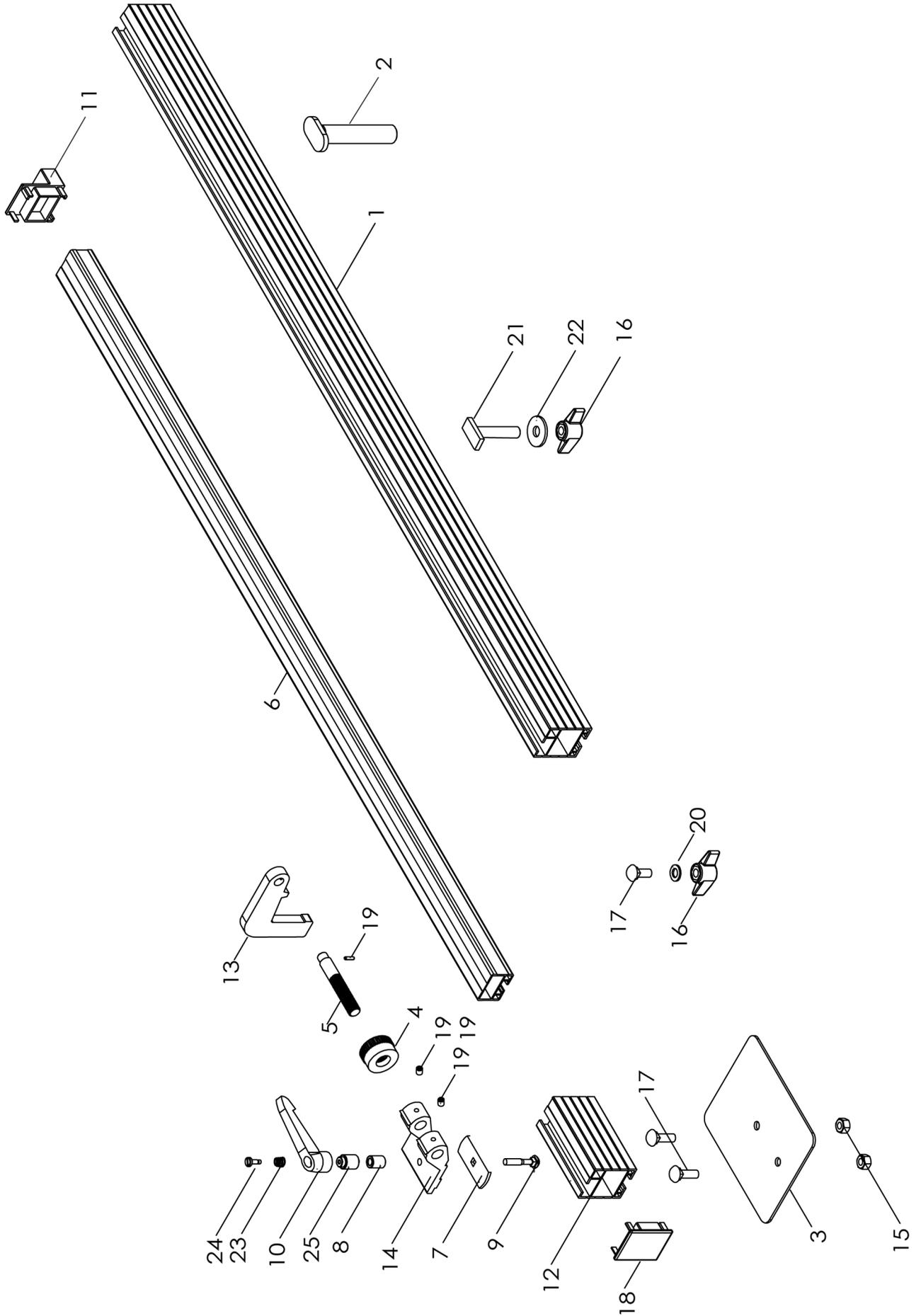


## Exploded Diagrams/Lists

| No.  | Description                   | Qty |
|------|-------------------------------|-----|
| D-1  | Sliding tale                  | 1   |
| D-2  | Cross cut table               | 1   |
| D-3  | Locating pin set              | 1   |
| D-4  | Swing arm A                   | 1   |
| D-5  | Shaft A, swing arm            | 1   |
| D-6  | Swing arm B                   | 1   |
| D-7  | Support, swing arm            | 1   |
| D-8  | Protect plate                 | 1   |
| D-9  | Nylon washer                  | 2   |
| D-10 | Shaft B, swing arm            | 1   |
| D-11 | Bearing 6203                  | 4   |
| D-12 | Gaskets                       | 1   |
| D-13 | Shaft C, swing arm            | 1   |
| D-14 | Thin nut M16                  | 4   |
| D-15 | Flat washer 20mm              | 2   |
| D-16 | Thin nut M20x1.5              | 1   |
| D-17 | Knurled knob fence            | 1   |
| D-18 | Adjust plate A, sliding table | 2   |
| D-19 | Thin nut M20x1.5              | 2   |
| D-20 | Adjust plate B, sliding table | 2   |
| D-21 | Hex blot M6x12                | 8   |
| D-22 | Set screw M8x20               | 9   |
| D-23 | Lock plate                    | 2   |
| D-24 | Hex Nut M6                    | 2   |
| D-25 | Locking nut M6                | 2   |
| D-26 | Hex bolt M6X50                | 1   |
| D-27 | Position shaft sead           | 2   |
| D-28 | Pan head screw M5x12          | 6   |
| D-29 | Think hex nut M10             | 2   |
| D-30 | Hex bolt M6X50                | 1   |
| D-31 | Cross cut fence assembly      | 1   |
| D-32 | Support rod A                 | 1   |
| D-33 | Support rod B                 | 1   |
| D-34 | T type blot,leg               | 3   |
| D-35 | Flat washer 10mm              | 3   |
| D-36 | Large washer 8mm              | 4   |
| D-37 | Hex head screw M8x25          | 4   |
| D-38 | Allen screw M8x16             | 1   |
| D-39 | Allen head set screw M8x40    | 2   |
| D-40 | Hex nut M8                    | 2   |
| D-41 | Hexagon bolt M4x8             | 2   |
| D-42 | Large washer 4mm              | 2   |

|      |                                             |   |
|------|---------------------------------------------|---|
| D-43 | Bush, cross cut table                       | 2 |
| D-44 | T type bolt, sliding table                  | 2 |
| D-45 | Ratchet lever                               | 2 |
| D-46 | Flat washer 10mm                            | 2 |
| D-47 | Scale A                                     | 1 |
| D-48 | Scale B                                     | 1 |
| D-49 | Allen Pan head screw M6x12                  | 2 |
| D-50 | Star knob                                   | 1 |
| D-51 | Large washer 8mm                            | 1 |
| D-52 | Edge shoe                                   | 1 |
| D-53 | Nut plate                                   | 1 |
| D-54 | Rod, hold down                              | 1 |
| D-55 | T-nut, hold down                            | 1 |
| D-56 | Eccentric shaft hold down                   | 1 |
| D-57 | Stud, hold down                             | 1 |
| D-58 | Handle knob, hold down                      | 1 |
| D-59 | Handle, hold down                           | 1 |
| D-60 | Eccentric block, hold down                  | 1 |
| D-61 | Arm, hold down                              | 1 |
| D-62 | Spring, hold down                           | 1 |
| D-63 | Circlip, hold down                          | 1 |
| D-64 | Disc, hold down                             | 1 |
| D-65 | Flat washer 5mm, hold down                  | 1 |
| D-66 | Allen screw M5x10, hold down                | 1 |
| D-67 | Star-type knob, hold down                   | 1 |
| D-68 | Circlip 8mm                                 | 2 |
| D-69 | Flat washer 10mm                            | 1 |
| D-70 | Allen screw M5x10                           | 1 |
| D-71 | Fence,miter gauge                           | 1 |
| D-72 | Cross recessed pan head taping screw ST5X10 | 1 |
| D-73 | End cap A,fence                             | 1 |
| D-74 | End cap B,fence                             | 1 |
| D-75 | Carriage bolt M6X30                         | 2 |
| D-76 | Stud, hold down                             | 1 |
| D-77 | Locking handle                              | 1 |
| D-78 | Ratchet lever                               | 1 |
| D-79 | Flat washer 10mm                            | 1 |
| D-80 | Mitre gauge,hold down                       | 1 |
| D-81 | Flat washer 6mm                             | 2 |
| D-82 | Locking nut                                 | 2 |
| D-83 | Screw guide                                 | 1 |
| D-84 | Sunk head screw M8x20                       | 1 |

DIAGRAM E



## Exploded Diagrams/Lists

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| No.  | DESCRIPTION                 | Qty |
|------|-----------------------------|-----|
| E-1  | Guide rail                  | 1   |
| E-2  | T type bolt,cross cut fence | 1   |
| E-3  | Lock plate                  | 1   |
| E-4  | Knurled knob                | 1   |
| E-5  | Locating plate shaft        | 1   |
| E-6  | Extension fence             | 1   |
| E-7  | Locking plate               | 1   |
| E-8  | Locking sleeve              | 1   |
| E-9  | Step bolt M6x35             | 1   |
| E-10 | Ratchet lever               | 1   |
| E-11 | End cap A                   | 1   |
| E-12 | End,extension fence         | 1   |

|      |                        |   |
|------|------------------------|---|
| E-13 | Flip stop              | 1 |
| E-14 | Flip stop base         | 1 |
| E-15 | Hex nut M8             | 2 |
| E-16 | Wing nut M8            | 2 |
| E-17 | Carriage bolt M8x25    | 3 |
| E-18 | End cap B              | 1 |
| E-19 | Set screw M5x6         | 3 |
| E-20 | Fap washer 8mm         | 1 |
| E-21 | Carriage bolt M10X60   | 1 |
| E-22 | Large flat washer 10mm | 1 |
| E-23 | Sping,ratchet lever    | 1 |
| E-24 | Screw,ratchet lever    | 1 |
| E-25 | Gear M6,ratchet lever  | 1 |







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