

W486 HAFCO ST254 table saw

3-12-14

Assembly instructions (use in conjunction with factory supplied manual)

Your HAFCO ST254 saw bench comes supplied in 2 cartons

1 of 2 contains main saw bench assembly and 2 off 2 contains parts for rip fence.

Open both boxes and inspect for any damage etc before assembly.

Main Carton # 1

Carefully remove the 2 x cast tables and then loose parts packed inside machine and around it.

Note 2 x small pieces of key steel wrapped in brown paper with the 2 hand wheels. Put these aside so as not to lose them they will be needed later

Break off all four sides of the main carton and remove out of the way. Hammer over any sharp nails left in the base of carton.

Find the 4 Legs marked A, B, C, D and the rear panel "E" with the dust extraction cut out.

Locate the dust extraction moulding and fit it to the panel "E" with the bolts and nuts provided.

The orientation of the moulding should leave it fitted with the 30mm port pointing upwards when machine is right side up later. (ie pointing towards the long side of the panel. The sides of the panel being those with the holes in)

Below picture may help. Tighten all nuts.

Find 20 x M8x16 long mm Bolts nuts and double washers

Fit the legs to the upside down machine, noting the corresponding letters A,B,C,D on the legs fit to the corresponding letters on the machine and that the orientation of the legs are fitted so the tapped holes in the legs point up when fitted on the upside down machine

Fit legs using a washered bolt through the legs and secure with washer and nut (Secure the nuts finger tight only)

Fit the Rear panel "E" with the dust extraction cut fitted to the rear of the machine on the side marked "E"

Using washered bolts through the sides to the panel/legs and secure with washer and nut (Secure the nuts finger tight only)

Now is a good time to fit the dust extraction hose

Locate the hose and the two large hose clamps, slip the clamps over the hose and first fit one end to the outlet of the saw blade box. Slip hose clamp over and ensuring the hose is pushed on correctly tighten the clamp checking to ensure the hose is on tightly.

Fit the other end to the inside of the dust extractor moulding and slide on clamp and tighten.

Now fit the other 3 side panels using washered bolts through the sides to the panel/legs and secure with washer and nut (Secure the nuts finger tight only)

While aligning the side panels in the legs tighten all sets of bolt/nuts around the base then tighten the 4 bolt/nut sets holding the base to the machine.

When all are tight the machine can now be lifted upright. At least two people should be used to do this.

Hint! Tilt it over towards the side of the body with nothing coming out of it (Hand wheel shaft/Switch/Dust Cute)

That way if you come into difficulty and have to lay machine down it will not rest on anything that can get damaged.



Fit the *Tilt* and the *Raise and Lower* hand wheels onto the shafts of the machine
ew.
Tighten 2 x Screw tightly onto flats on shafts



Fitting extension Tables to main table..

Note the machine can now be set up in one of two configurations

SET UP # 1 With an extension table on each side of the machine.

NB: as above, the tape fitted to the fence rail as delivered is split in two, having the ability to use the fence on the left and right of the blade .
If set up like this the Support Leg is not needed but can be used if you want (Pick a side!)



SET UP #2 With both extension tables on the Right hand side and the support leg supplied used to prop it up.
If set up like this, the original measurement tape gets taken off the front fence rail and the new one put on.

This set up is also used when fitting optional sliding table # W487



Assembly Cast extension tables

Select one of the Extension tables (they are identical)

Find the 4 off M8 x 25mm long Bolts and flat washers and 4 x M8 x 30mm long bolts washers and nuts supplied. Ensure the front edge of the extension table is correctly orientated (The front edge of the Extension tables are Chamfered. This matches the front edge of the main table that is also chamfered.)

Stand the back end of the table on the floor on the right hand side of the main table, then lift it up and putting one of the M8 x 25mm washered bolts through the top hole screw the bolt into the front tapped hole in the main table until almost home.

Carefully lift up the bottom edge of the table and swing up, aligning the tops faces fit another bolt and washer and then the middle two.

Nip up the front and rear bolts. Now with a soft hammer, line up the front edge and rear edges of the cast table with the main table. This is needed to ensure Fence rail can be attached easily and accurately

With the soft hammer you can level up the tops of both main table and extension table as needed.

If there is a slight lump or drop in the middle of the joining top edges, this can be reduced by removing two off end bolts and working from one end to the other, lift or lower table to line up top faces as you go tightening the attachment bolts ensuring the front and rear ends are still in line with the main table

When done tighten all 4 bolts.

For set up # 1 Repeat the above with the second Cast Extension table on the left side of the main table using the M8 x 30mm long bolts and washers

For set up # 2 Repeat the above with the second Cast Extension table bolted to the side of the first cast extension with the 4 off M8 x 30mm long bolts nuts and double washers supplied to bolt Second table onto the first one, So both tables are now on the Right hand side of the main table....

Then fit the support leg supplied to the 2 middle taped holes on the outer edge of the second cast extension table.

When the Saw bench is located in its final position the support leg can be adjusted up to the correct height using a straight edge across the main table over the cast extensions to adjust as needed.

Assembly Rip Fence

Find the 10 off M8 SQUARE Head bolts washers and nuts

The best way to fit the rails is to fit the M8 x Square head bolts in front and back holes (5 each) with the Square head of the bolt on the outside and the washer and nut in under table lip

Slide on front and back rails, introducing the square head of the bolt into the Tee slot of the extruded front and rear rails

For Set up # 1 Align each rail approximately central on the machine then finger tighten up both rails end bolts only (2 of, each rail)



For set up #2 Align each rail so it is in from the left edge of the main cast table about 8 to 10mm

Ensuring machine is not plugged in.

Wind blade fully up **## Caution of sharp teeth on blade!! ##**



Find the Rip fence assembly complete with the Side extension plate.
Remove the fence extension side plate off the fence and put it aside.

For set up # 1 Front rail as supplied with 2 tapes on 0-64 on the left and 0-62 on the right

From the right hand side, slide the fence on to the front and rear rails
Zero the sight line over the "0" of the right hand tape.

While pushing forward to hold the fence square on the front rail, slide the front rail across with fence held on the Zero mark until the fence touches the blade,

Checking fence sight line is still over "0", nip up the end bolts of the front rail *while at the same time lifting rail up each end while locking the nut.* (To ensure clearance between fence and table surface)

Recheck the Zero line and that the fence is touching blade, then tighten the end nuts only of the front rail..

Line up rear fence rail were needed and while lifting that up, tighten the end nuts and then the remaining 3 nuts to fasten the rear rail secure.



For set up # 2 Remove the existing measurement tapes 0-64 on the left and 0-62 on the right of the front fence rail as these are only needed for set up #1.

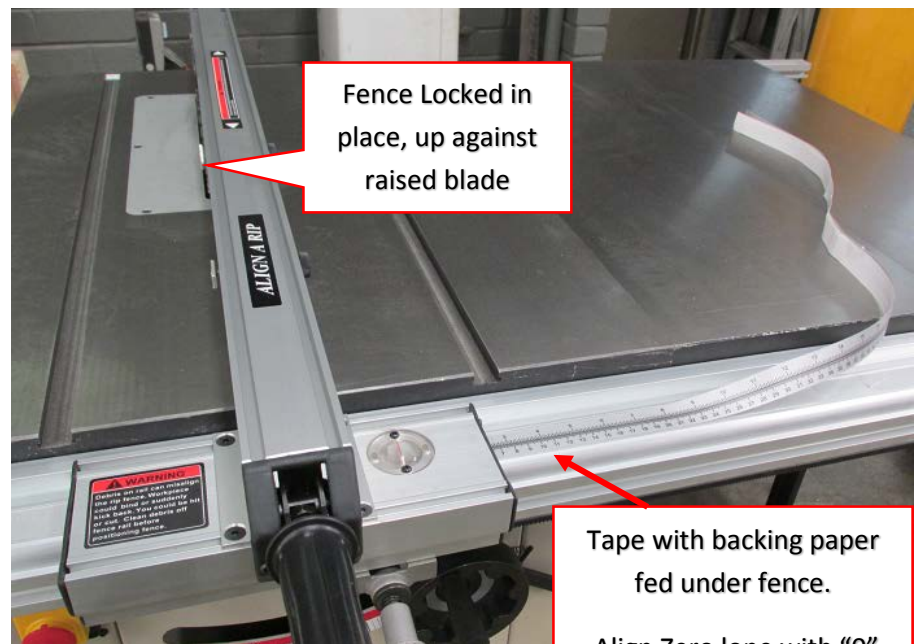
The tape can be carefully lifted with a sharp blade and peeled off. Residue glue on rail can be removed with kerosene and a small scraper.

The new Tape left to Right reading 0-98 now has to be fitted in the correct position. To do this, From the right hand side, slide the fence on to the front and rear rails and then slide the fence all the way across to be touching the blade lightly. Lock the fence down.

Feed the tape (with backing paper still on!) under the fence and "Zero the sight line over the "0" of the tape.

With a black marker put a mark on the tape and front rail as shown, checking the Zero line is still over the "0" of the tape.

Pull the tape out and remove the Fence. Clean the front rail with a dry cloth in the slot the tape will be going being careful not to remove the black mark just put on.



Start peeling the backing tape off the new tape and position the tape on the rail, lining up the black marker lines as you go, then if all Ok, peel the rest of the backing paper off as you put the rest of the tape into the groove. Press the tape down firmly along its length.



Continue For set up # 1 and # 2

Move the fence in line with the mitre slot in the table and check it is parallel with the slot.

If needed, loosen the 4 x screws holding the fence to the rail and square it up, tightening the 4 screws when finished.

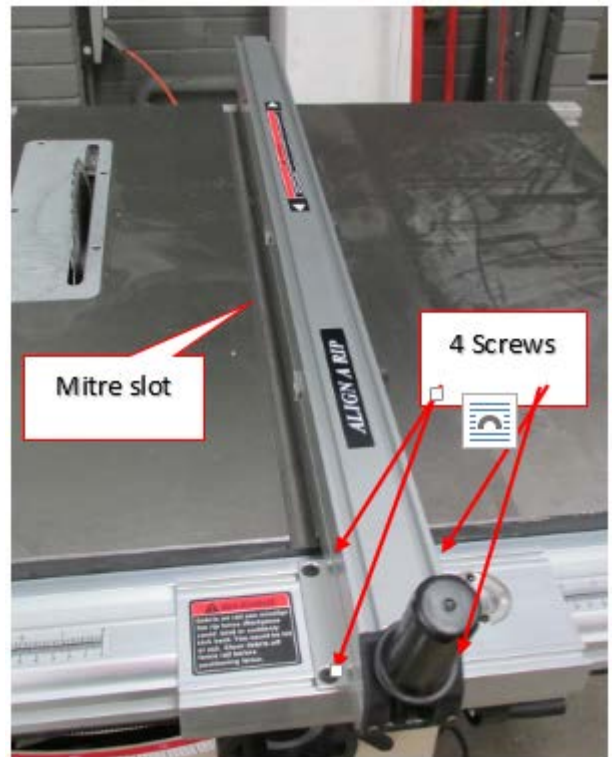
Recheck the "0" on the sight line of the fence is correct with fence touching the blade!

If needed reset front rail to get this correct

Then tighten the other remaining 3 nuts to fasten the front rail secure.

Lower the blade all the way down under table surface.

Slide the fence assembly off and mount the fence "Micro-Adjuster" to the rip fence front bracket on the right hand side (when up the correct way) .



Refit the Fence onto the rails.

The micro -Adjuster is used by pushing in the spring loaded knob and then turning it.

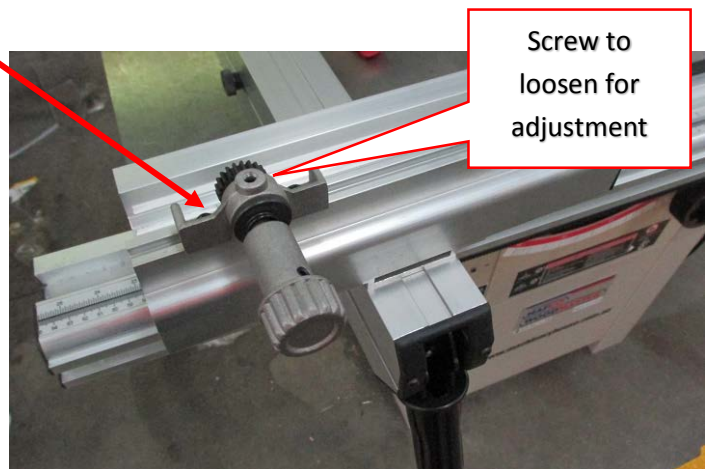
This engages the gear on the rack running along the bottom of the fence rail.

It may need adjusting to allow the gear to come better into mesh with the rack, or it may be too tight.

To adjust this if needed, the shaft of the gear is in an adjustable black cam bush.

Loosen the screw under the bush with an Allen key and turn the black bush to move the shaft/gear up or down as needed. Tighten screw when set as required.

If the gear is still too tight on the rack an extra washer can be fitted between the mounting bracket and rip fence to drop the gear down further.



Fit the 4 x plastic end caps with the self-tapping screws supplied, then check for any protruding plastic and file flush if needed so it doesn't catch when the fence is slid to the further most ends of the rails.
Fit the fence "side extension" back on...



Assembly Riving Knife and blade guard

Ensuring machine is not plugged in.

Wind blade fully up **!!Caution of sharp teeth on blade!!**

Undo and remove the 5 screws holding table insert in and remove insert

Undo the 2 x bolts on the front of the riving knife holder behind the blade just enough to allow the slot in the riving knife to go over the center bolts in the assembly push the riving knife towards the blade and tighten the bolts of the front bracket, Note the mounting plate for the riving knife has been factory set. Do not adjust the 4 bolts

Refit the table insert and lower the blade checking the knife does not foul the table insert.

Fit the blade guard onto the riving knife
The attachment bolt in the knife slides down into the "L" shaped slot when all the way down slide it back into the "L"

Wind the blade down then fit the 30mm Dust hose from the blade guard to the rear dust chute Hole in place with the 2 x 30mm hose clamps supplied.



Fit the small mitre fence....

Connect machine to Suitable Dust Collector

Your Hafco Sawbench is now ready to use.

Further information on setting, maintenance and spare parts available can be found in the Main Factory manual.

