

10" Sliding Table Saws



For your safety, please read this manual carefully before operation

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SAFETY!!

The symbols shown on the cover of this manual advise that you wear the correct safety protection when using this machine.



General Instructions for Machines...

Work Place/Environment

The machine is not designed for sub-aqua operation, do not use when or where it is liable to get wet. If the machine is to be used outside and it starts to rain stop work and move it inside. If machine has got wet; dry it off as soon as possible, with cloth or paper towel.



DO NOT use machines anywhere within a site area that is flooded or puddled, and do not trail extension cables across wet areas.

Keep the machine clean; it will enable you to more easily see any damage that may have occurred. Clean the machine with a damp soapy cloth if needs be, 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. It is also recommended that you use switched supply outlets.

Carry out a final check e.g. check the cutting tool, drill bit, saw blade etc., is securely tightened in the machine, check you have the correct speed and function set, check that the cutting path of the timber is unobstructed, etc.,

Most machines these days are fitted with NVR contact switches so that machines cannot remain inadvertently switched 'ON'. However, it is a good habit to train yourself to check that the machine is not 'Switched On' prior to connecting the mains supply. (In case you happen to be using one of the older machines).

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.

DO NOT work with cutting or boring machines of any description 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!

General Instructions for 230v Machines...

DO NOT use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases. There are very expensive, very specialised machines for working in these areas, **THIS IS NOT ONE OF THEM.**



Check that cutters, drills, blades 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.

If possible always fit dust extraction to machines that are producing high rates of sawdust, shavings, chips etc.

Above all, **OBSERVE....** make sure you know what is happening around you, and **USE YOUR COMMON SENSE.**

REMEMBER, YOU ARE ULTIMATELY RESPONSIBLE FOR YOUR OWN SAFETY

THIS MACHINE IS DESIGNED TO CUT TIMBER AND TIMBER DERIVATIVE PRODUCTS. DO NOT use for any other materials.

Specification

M2325D	
Motor	Single phase 230V, 50 Hz
Motor Power	2.2 Kw
Motor Speed	2840 rpm
Blade Diameter	10" (254mm)
Bore Size	25.4mm
Blade speed	2840 rpm
Table Size	560mm x 800mm
Table Size with 2 side extensions fitted (305 X 800 ea.)	1170mm wide x 800mm deep
Table height	845mm
Tilt Angle	0-45 degrees
Minimum Kerf	3mm
Maximum Depth of Cut (at 0 degrees)	10" (75mm)
Maximum Depth of Cut (at 45 degrees)	10" (60mm)
Lpa (sound pressure)	dB(A) 99.5
Lwa (acoustic power)	dB(A) 112.5
Weight	10" (260kgs)



IT IS RECOMMENDED THAT YOU WEAR EAR PROTECTION WHEN USING THIS MACHINE

Initial Assembly Instructions...

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



**TWO PERSON
SYMBOL**

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

You will require: A cross point screwdriver in addition to the tools supplied

Unpack all the boxes and check all the components

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

Assembling the Main Saw Bench...

Having unpacked the boxes, (please dispose of any unwanted packaging responsibly), put the parts and components whereby 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. (See fig 1). Identify the short rear panel with the dust extraction cutout, locate the dust extraction moulding and fit to the panel using the nuts and bolts provided. (See fig 3) (The orientation of the moulding should leave the 30mm outlet pointing upwards i.e. pointing up the long length of the panel).

Put the panel aside, and locate the remaining three panels, the lower chassis legs and 20 No. M8x20mm bolts, nuts and double washers. Fix the lower legs to the upper legs using a washered bolt through the legs and secure with washer and nut, only turn the nuts up finger tight at this time. (See figs 2 & 2a) Take up the rear panel with the dust extraction moulding fitted and fit between the rear legs, using washered bolt through the leg and panel and securing with washer and nut. Again, secure the nuts finger tight only. With easy open access, now is a good time to fit the dust extraction hose. Locate the hose and the two large jubilee clips. Stretch the hose out to its full length. Slip the jubilee clips over the ends of the hose, fit the hose to the outlet on the saw box and the dust extraction moulding and clamp in place with the clips. (See fig 3)

Fit the remaining panels to the legs, using the same securing sequence. Wiggle, push, pull, press, lever etc., the legs and the panels into the best alignment with the upper chassis and tighten the nuts and bolts using the spanners provided. When everything is tightened up, the machine can now be tipped over, towards its blind face (as seen in fig 4) until it is resting on the pallet with its legs on the floor. Lift the machine upright. (See fig 5)

M8x20mm bolts, nuts
and double washers

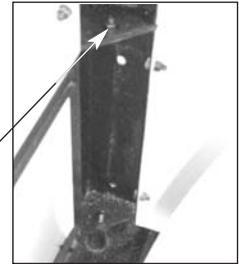


Fig 1

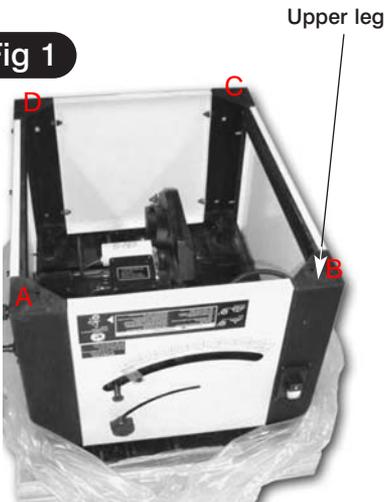


Fig 2a

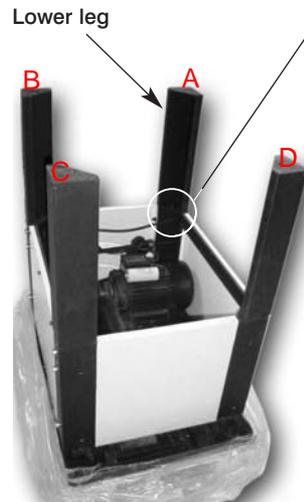
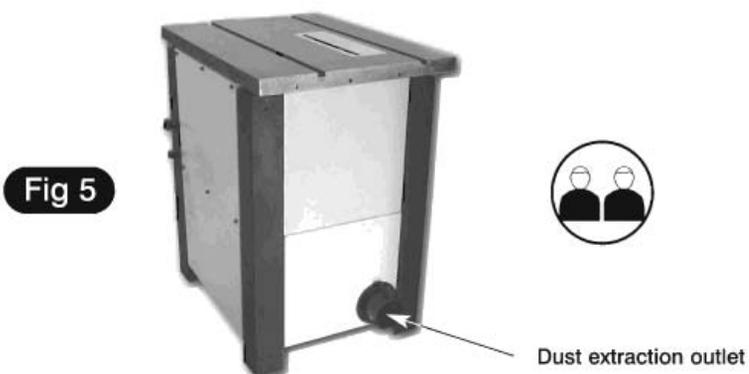
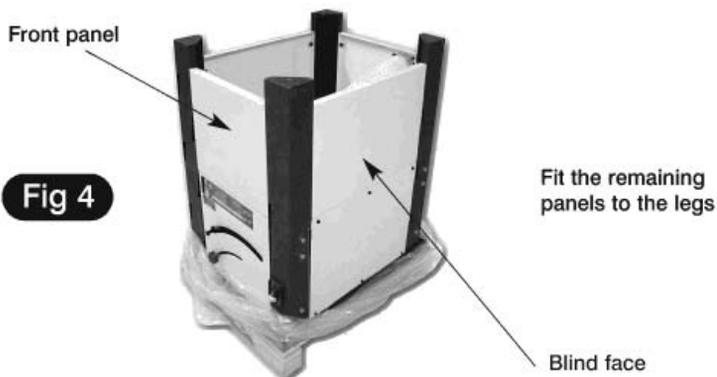
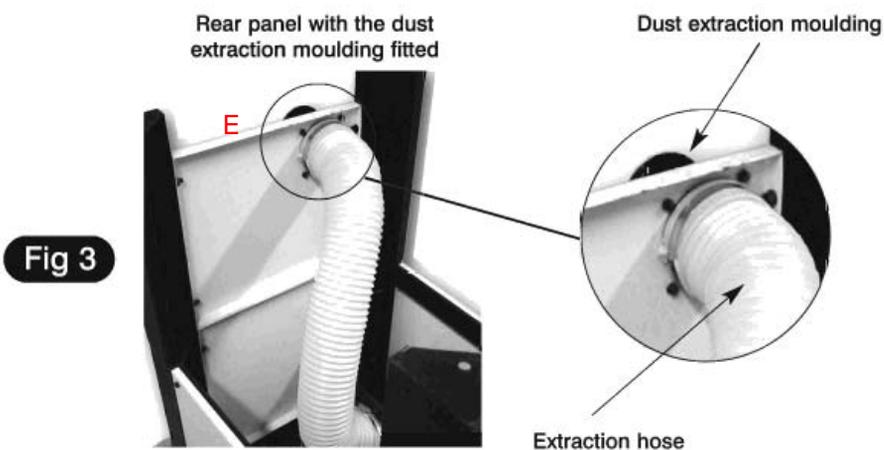


Fig 2

Note: We have made "A,B,C,D" labels on the upper and lower legs separately, when assembling the legs, pls take note to make them one-to-one according to the labels

Assembling the Main Saw Bench...



Mounting the First Side Extension Leaf...



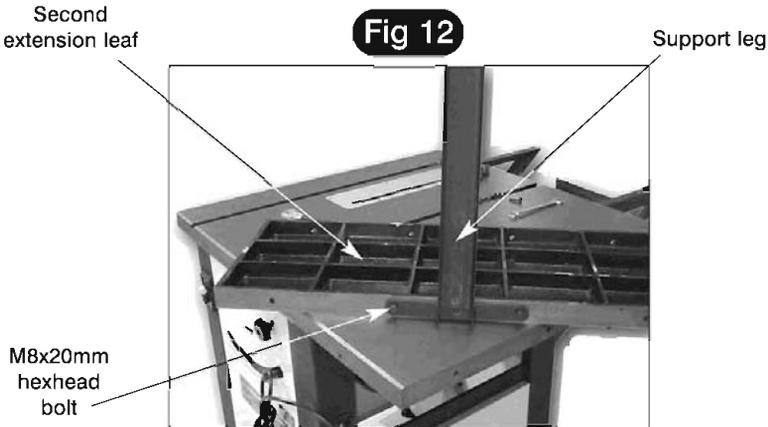
**THE EXTENSION LEAF IS HEAVY YOU MAY REQUIRE
A SECOND PERSON TO HELP LIFT IT IN PLACE**



Select one of the extension leaves, (either one, they are identical) locate 4 No. M8 hexhead bolts and washers. Ensure the table is correctly orientated (the front edge of the table is bevelled). Stand the back end of the table on the floor, close to the front and edge of the main saw table, with the underside of the table facing the front of the saw. Lift the table up and introduce a washered bolt through the first hole in the leaf and screw it into the first threaded hole along the main table edge.

Screw the bolt in until it is almost home. You can now relax the lifting effort. The extension will hang pivoted on the bolt. Carefully lift the bottom end of the extension up until the edges are level and introduce a washered bolt through the rear hole and the last threaded hole in the table edge, screw it almost home. The extension should be hanging in approximately its correctly position held by the two bolts. Introduce and almost screw home the other two washered bolts. Align the top and front edges at the front of the saw, 'nip' the front bolt to hold the extension in place; carefully manoeuvre the rear of the extension to align the two top edges and 'nip' the rear bolt. Check this movement has not disturbed the alignment at the front of the table, if it has, repeat the procedure until the front and top edges are aligned. Tightened all the bolts securely.

Mounting the Second Side Extension Leaf...



Turn the leaf upside down on a work surface (or the saw table?) and attach the support leg to the outside edge, using the 20mm bolts and fastening through the two middle holes.

Mounting the Front Guide Rail and Rear Clamping Rail for the Rip Fence...

Locate the 10 No. M8 SQUARE head bolts washers and nuts. We have ascertained the best way to fit the rails is to introduce the bolts through the holes in the front and rear edges of the tables, hold in position by adding the washer and fitting the nut a couple of turns onto the bolt. Select the front guide rail and introduce the square head of the furthest right hand bolt into the channel in the extrusion; slide the rail along the front of the machine picking up all the bolt heads as you go along. (See fig 13) Reach under the table edge and finger tighten all the nuts. Repeat the process for the rear rail.

Locate the capping plates for the front rail and fit carefully using the self tapping screws. (See fig 14) Set the front rail in position, remembering that it must be slightly inside the front left hand edge of the main saw table, so that the sliding table does not collide with it. Tighten ONLY the 3 bolts in the main saw table. Repeat the process for the rear rail (without the capping plate operation!).

Fig 13



Fig 14



Setting the Machine Tables...

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

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

NOTE: The rear extension table brackets can be moved up and down within the slotted fixing holes, and 'tilted' forward or backward using the adjusting bolts in the frames adjacent to the fixing bolts. Remember to loosen or tighten the adjacent fixing bolt if you are moving an adjusting bolt.

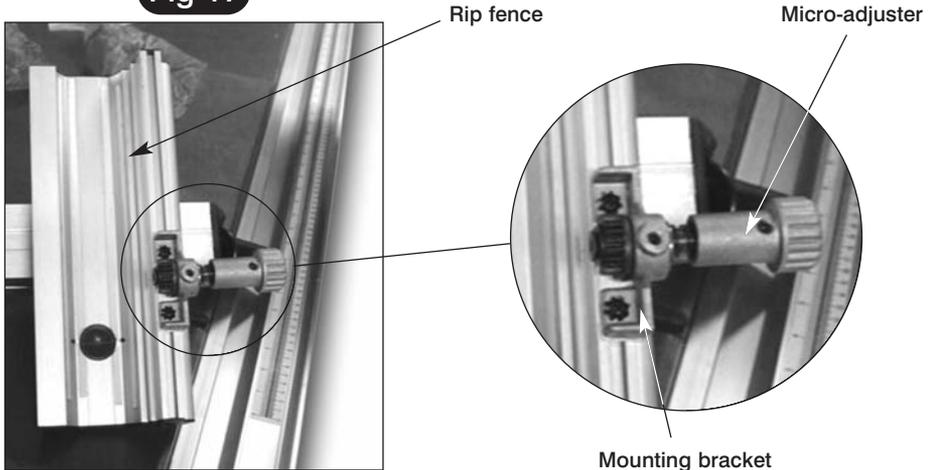
Make sure all the fixing bolts are generally finger tight. Set the near corner of the table to the straight edge, by pushing, pulling, tapping etc. 'Nip' the securing bolts. Move the straight edge to the other edge of the extension table, repeat the procedure. Now, if necessary, adjust the 'tilt' to bring the far corner up to the straight edge, tapping the near edge down (or up), if necessary. Move the straight edge back to the original edge and repeat the procedure. When the table is set tighten the fixing bolts securely. **THEN** check the table again. Repeat any part of the procedure if necessary.

Place the straight edge across the table and the two extension leaves. (There may be some slight 'sag' at the outer most edge of the leaves due to their weight). If there is any 'falling off' adjust the table support leg to correct this. When you are satisfied that the main table and the side extension leaves are in plane tighten the remaining 4 bolts that secure the front and rear rails.

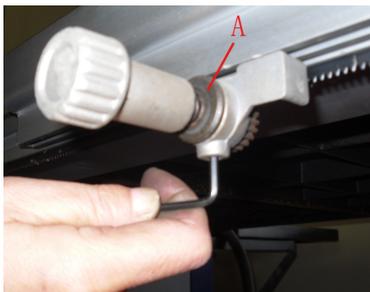
Mounting the Micro-Adjustor to the Rip Fence Mounting Bracket...

Locate the Micro-Adjustor and the Rip Fence. There are two fixing screws through the adjustor mounting bracket with square nuts on them. Ensure the nuts are undone sufficiently to allow them to slide into the channel in the Rip Fence mounting bracket extrusion, position as required, normally slightly to the right of the rip fence, (See fig 17) and tighten the screws securely. Locate the capping plates for the Rip Fence Mounting Bracket and fit carefully using the self tapping screws. Fit the Rip Fence assembly to the saw by ensuring the clamping lug at the rear of the fence is 'hooked over' the rear rail, lower the fence and manoeuvre the bracket over the guide rail.

Fig 17



Fitting the micro-adjustor to the rip fence mounting bracket

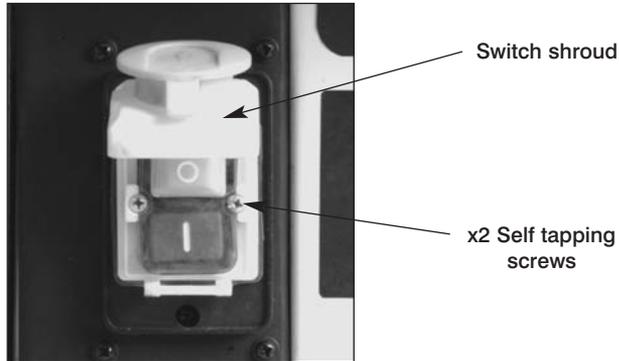


Pls loosen eccentric wheel (as A shown) with the Inner Hex spanner, then adjust the clearance between the rack and the gear to make them engaged well.

Fitting the Switch Shroud...

Locate the switch shroud. Position the shroud over the switch block, such that the knob shaped cover is hinged at the top. See fig 20. Secure using the two small self tapping screws provided.

Fig 20



Fixing the Riving Knife...

See IPB on Page 42 & 43

Locate the Riving Knife. Remove the 5 No. screws that secure the saw gullet, place carefully aside. Remove the saw gullet and place it aside. Raise the saw blade up to its highest point.

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

Introduce the slot in the riving knife over the two centre line bolts, behind the washers, (no. 16 and 11 in the diagram) and nip the bolts to just hold the riving knife against the mounting plate. Set the riving knife so that it is close to the blade, (gap about 2-3mm if possible). Tighten the clamping bolts securely. Replace the saw gullet.

Lower the saw blade, making sure the riving knife does not foul the gullet.

Attaching the Saw Hood Guard and the Extraction Hose...

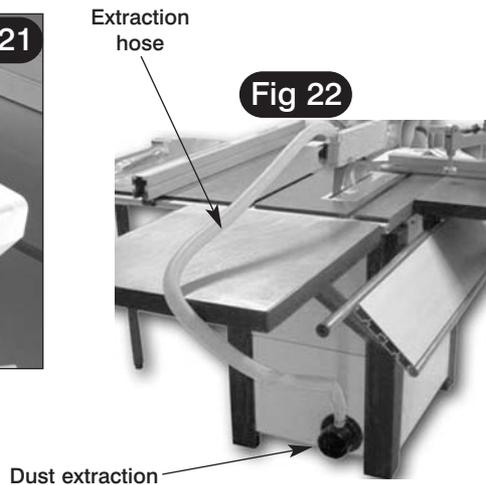
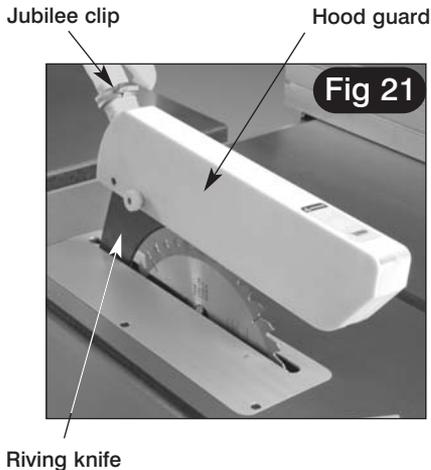
Locate the saw hood guard, the extraction hose and the jubilee clips. There are two fastenings in the guard, a fixed bolt at the rear and a clamping bolt just in front of it. Introduce the fixed bolt into the 'L' shaped slot in the riving knife and push it down and back so that the bolt is locked into the slot. Lower the guard so that the clamping bolt fits into the curved slot in the riving knife. Tighten the clamp to pinch the guard to the riving knife and hold it in position.

Push the jubilee clips over the ends of the hose, push the hose onto the spigots of the guard and the main dust extraction moulding and tighten the clips to hold it in place.

See figs 21 & 22

Attaching the Saw Hood Guard and the Extraction Hose...

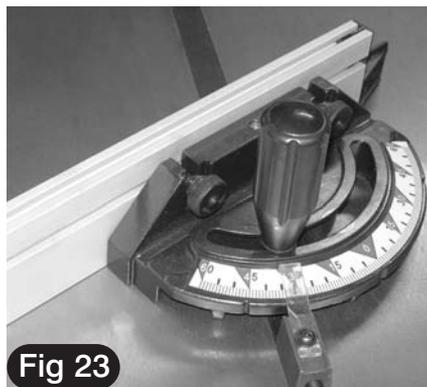
There is no requirement to remove the guard. The profile of the riving knife precludes the use of the saw for slotting or grooving, and the maximum depth of cut can be achieved with the guard in place. The positioning of the extraction hose could be a nuisance if you are cutting big boards, et al. In such a case it is better to remove the hosing from the guard, than risk getting the workpiece snagged and perhaps 'slewing' on the saw.



Fitting the Small Mitre Fence...

Locate the small mitre fence. Introduce the nose of the bar into the required slot in the main table. Lay the bar flat and push forward. The 'locking T' is produced by a washer screwed to the underside of the bar, make sure this engages in the 'T' slot in the table. (See fig 23)

NOTE: With the rear extension table fitted it is not possible to push the small mitre fence completely 'through'. However, the travel is such that the fence is able to travel well past the cutting edge of the saw, and the rear of the 'T' slot is open so that saw dust can be pushed clear of the slot.



Setting and Checking the Machine...

Raise the blade to its maximum height, check that it is upright to the table. Set the sliding table fence to zero angle against the preset post. Slacken the two fence mounting bolts and slide the fence up close to the saw blade. Fasten the two mounting bolts again.

Using a known 90° square place it against the fence and the blade (not on the teeth), and check that the angle is correct, if not, adjust the preset post on the Mitre Angle Rear Quadrant. (See fig D) This preset post is a small eccentric cam mounted on the shaft of a caphead bolt. By loosening the bolt and turning the head of the post with a spanner, the position of the stop can be altered.

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

Loosen the fence mounting bolts, slide the nose of the fence (the orange tongue) up to the blade, secure. Check the parallelity 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) and pro rata. If not, or the discrepancy is too large, the slide rail assembly will need to be re-adjusted, to achieve a parallel motion.

Set the distance stop to a predetermined measurement against the inset scale. Loosen the fence mounting bolts and using a tape or a distance piece set the fence so that the saw blade to stop is that measurement. Tighten the mounting bolts securely.

Tilt the blade fully over. Using a mitre square et al; set the angle of the saw to 45°. Check that the index mark gives a corresponding reading against the scale. Adjust the pointer if necessary. Reset the blade upright, check that the angle scale reading is correct. Set the rip fence a predetermined distance from the saw blade and lock in position. Check that the rip fence is held securely when it is locked in position. If the locking appears a little 'slack' adjust the position of the clamping lug at the rear of the rip fence by tightening the nut. Check that the preset distance corresponds to the measurement on the scale against the index mark in the magnifying lens. If not, adjust the position of the rip fence on its mounting bracket.

Fit the small mitre fence to the machine. Loosen the clamping handle.

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

Set the face to zero angle using the preset position. Check that the angle is correct (and the lug is on the correct side of the pin). Check that the indexing pointer gives the correct reading against the scale. Adjust the pointer if necessary. Check left and right positions. Check the pointer is still correct. If the preset positioning is wrong, set the fence with a square/mitre gauge, set the pointer accurately against the scale, and clamp the fence in position without recourse to the presets.

Remove the small mitre fence from the table and stow carefully aside.

Setting and Checking the Machine...

Check the belt tension (see fig 24) the belt should be tight, but not unduly so. Remove all tools and stow away. Check that the machine tables are clear. Lower the saw to leave about 25mm protruding, set the saw upright.

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

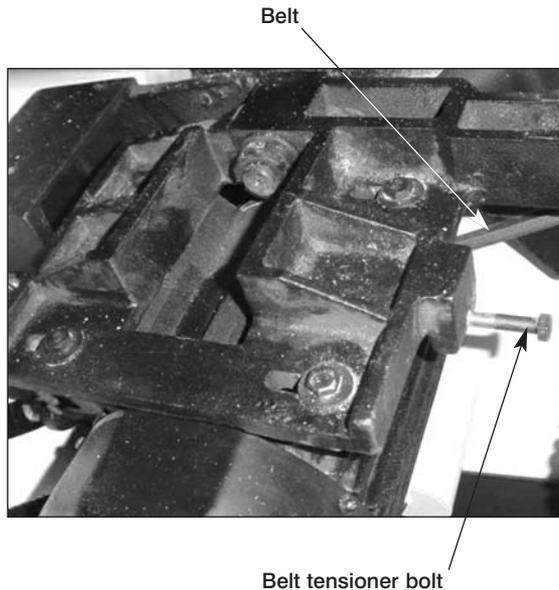
Connect the machine to the mains supply, lift the switch shroud and give the machine a quick burst. i.e. On/Off. Check that everything is sound and feels O.K. (No knocking, scraping, belt squeal, rubbing etc.)

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

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

Congratulations; one 10" bench saw; assembled and ready to work.

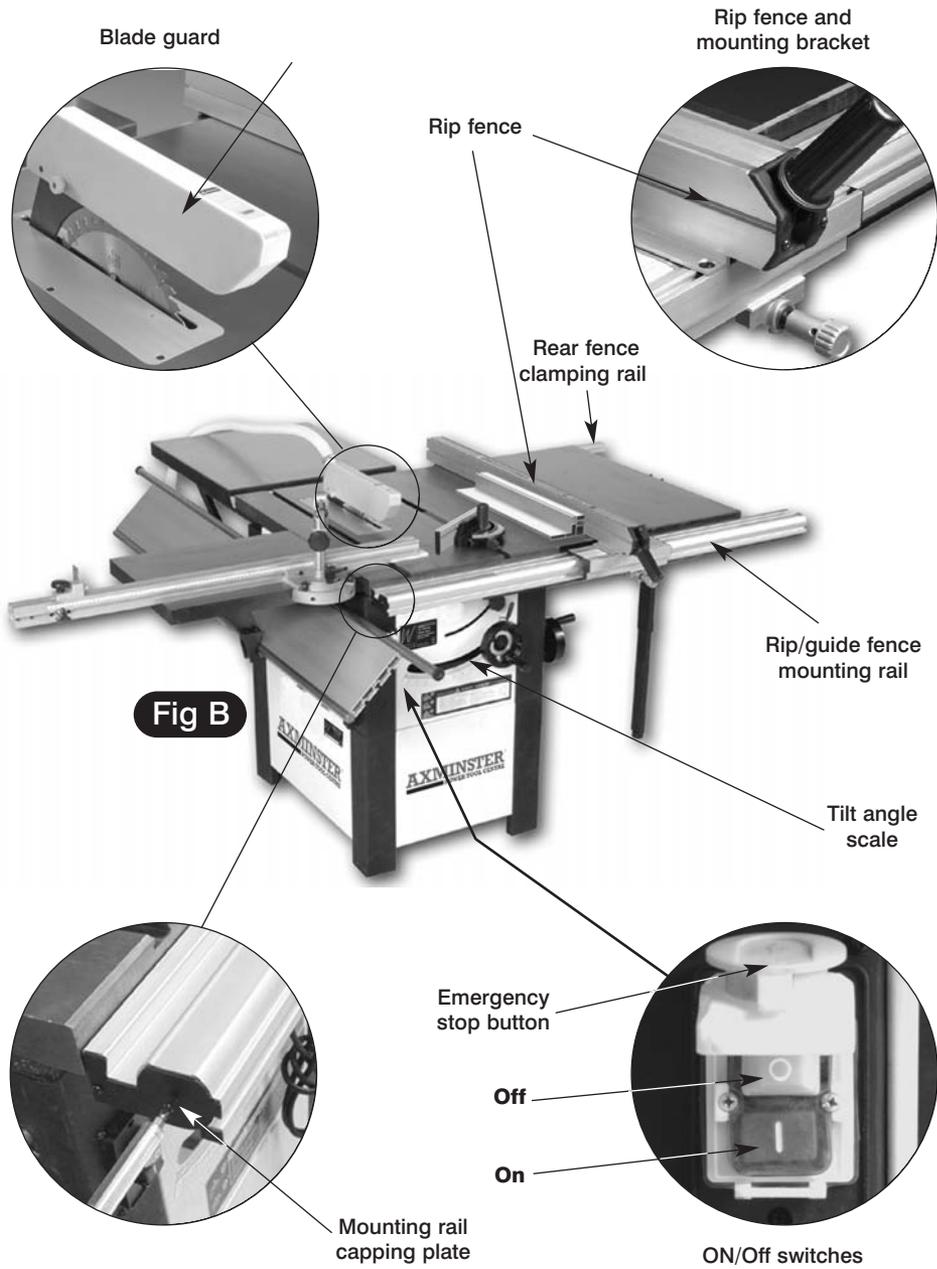
Fig 24



Identification & Description of the Saw Table...

- Saw table**
(See fig A)
- This is the actual machine, it comprises a cast iron table with the cut-out to allow the saw blade to project through, the two slots into which the small mitre fence can be fitted. The edges of the table have various combinations of drilled and tapped holes to allow the mounting of the extension tables and the fence mounting rails; the saw assembly and the motor are bolted to the underside of the table. The saw assembly comprises the saw shaft with its rise and fall and tilt mechanism. The drive is provided by the motor pulley via a drive belt to the saw shaft. The saw table is bolted into the tops of the legs of the Upper Chassis using 4 adjustable bolts and locking nuts to enable the table to be set correctly. The table has been factory set, and unless it is significantly 'out' should not be adjusted.
- Upper chassis**
(See fig A)
- The Upper Chassis comprises 4 steel fabricated legs and 4 pressed steel panels bolted in position between them. The two upper side panels are mounted to the chassis frame such that they can be removed, to allow access to the saw assembly, the motor, the drive belt etc.; these panels are each held in position by 6 caphead bolts. The Front panel has two cutouts for the rise and fall drive shaft and the locking mechanism actuator to come through. The cutout for the rise and fall shaft has a decal applied to the lower edge to enable the angle of the saw tilt to be read off, using an index pointer mounted on the saw mechanism.. The front right leg mounts the drive shaft for the tilt system. The NVR ON/Off Switch plate is mounted on the upper left front leg.
- Lower chassis**
(See fig A)
- This comprises a further 4 steel fabricated legs and 4 pressed steel panels bolted in position between them. The lower rear panel has a cutout to allow the mounting of the dust extraction moulding.
- Table insert**
(See fig A)
- This is a metal alloy insert that covers the hole in the saw table through which the blade protrudes, and which allows access to the inside of the saw table, to enable the riving knife to be adjusted, the saw blade to be changed, et al. The left side of the gullet has been relieved so that the saw blade can be tilted.
- Extension tables**
(See fig A)
- The cast iron extension tables provide added support for the workpiece beyond the boundaries of the saw table to the rip side.
- Extension table support leg**
(See fig A)
- Because of the weight of the extension leaves, a support leg is provided to increase stability. The height adjustment is effect by loosening the caphead bolt and allowing the inner channel to slide in the outer channel. Tighten the bolt to lock the leg at the height selected.
- Rise and fall control hand wheel**
(See fig A)
- This is an engineers wheel handle attached to the shaft of the rise and fall mechanism of the saw. Turning the handle clockwise will cause the saw blade to fall, anti-clockwise to rise. Rotate control behind clockwise to lock spindle.
- Tilt angle lock**
(See fig A)
- A small star knob situated above the rise and fall control handle that locks the tilt mechanism to prevent any movement that could be caused by vibration during the saw operation.

Illustration & Parts Description of the Saw...



Note: There are no sliding table assembly and the rear extension table on W486

Illustration & Parts Description of the Saw...

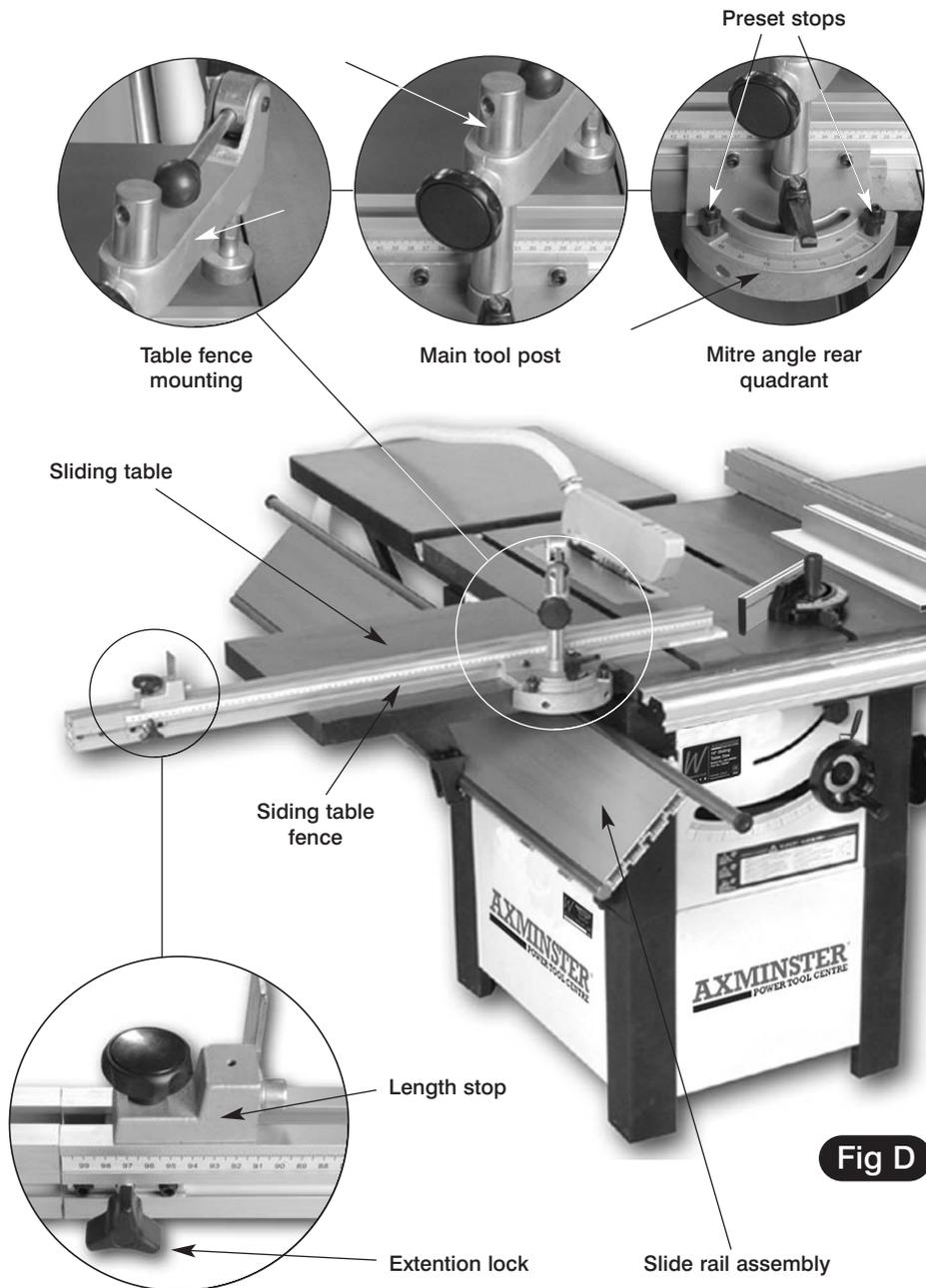


Fig D

Identification & Description of the Saw Table...

Length stop
(See fig D)

A 'flip over' blade that can be moved up and down the length of the fence, and clamped in position. The distance from the blade can be set against the tape decal.

Rear extension table
(See figE)

The rear extension table consists of 5 pieces, the table itself, two support brackets, and two clamping plates. The clamping plates fit behind the faces of the two rear upper chassis legs. They have tapped holes top and bottom to accept the fixing bolts fitted through the brackets and the legs. The mounting brackets are symmetrical and can be fitted either way 'up'. The fixing holes are elongated to allow the height of the table to be adjusted to be in the same plane as the saw table. The table is bolted to the brackets. It is set off the back of the main table sufficiently to clear the rip fence rear clamping rail and allow the clamping end of the rip fence to move freely past it.

Drive belt tensioning

See Maintenance Section.

Maintenance...

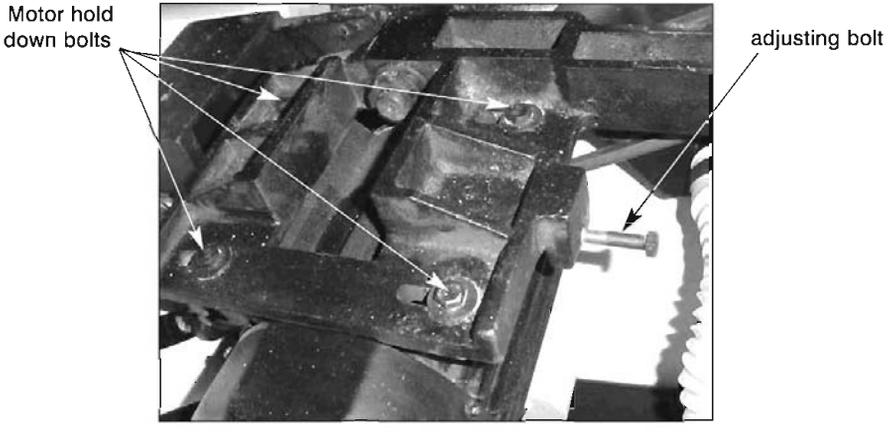
Keep the saw as clean and free from saw dust build up as is practical.

Periodically, remove the saw gullet and blow out brush out clean out the saw box and the extraction hosing. Remove any resin build up in the saw box, using a proprietary resin cleaner.

Remove the upper side panels and clean the threaded drive shafts of the rise and fall and tilt mechanisms. At the same time check the belt drive, i.e. the belt is not 'glazing' with resin build up, likewise with the pulley wheels. Check the belt tension. If the belt is becoming slack, loosen the motor hold down bolts and drive the motor backward with its adjusting bolt. See fig 25.

Check the saw blade regularly for chipped, missing, damaged teeth etc. and remove any resin build up from the blade, riving knife etc.

Fig 25



Changing the Saw Blade...



WARNING!!

**DISCONNECT THE MACHINE FROM
THE MAINS SUPPLY**

Raise the saw blade to it's highest point. Remove the saw blade guard. Remove the 5 screws that secure the table insert, place carefully aside and remove the table insert. Using the spanner and the tommy bar provided, put the spanner onto the flats on the nut. Turn the saw until the tommy bar hole is visible. Insert the tommy bar and turn the saw to allow it to rest against the front edge of the saw slot.



Remove the saw guard and
the table insert

The tommy bar hole is in the inside
platewasher component (see item 92 of
the IPB on page 42.)

Slacken off the saw nut (remember left hand thread). Remove the saw nut, then remove the sawplate washer and the saw blade. Now is a good time to give the interior of the machine, the dust extraction channels, etc. a thorough clean. 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 sawplate washer onto the shaft and twist on the saw nut. Spin the nut up finger tight and check the saw is correctly seated.

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

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

Specific Instructions/Precautions for the Saw Bench...

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

DO NOT force the saw, if the saw begins to 'stall' you are 'forcing the cut' or over working the saw.

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

DO NOT use blades that are deformed in any way.

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

DO NOT remove the riving knife.

DO NOT use any blades that cut a smaller kerf than the riving knife thickness.

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

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

DO NOT start the saw with the workpiece touching the blade.

DO NOT commence sawing until the blade has run up to full speed.

After switching off, never try to slow the saw down more quickly by applying side pressure (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 stuff and the sliding carriage for larger work pieces.

Unless you are an experienced machine operator, do not attempt to 'rip' freehand, always use the guiding facility of the rip fence.

It is perfectly acceptable to support guide and feed the timber with your hands whilst ripping stuff of some length, however, as you approach the blade ensure that the push stick is to hand, and you use it.

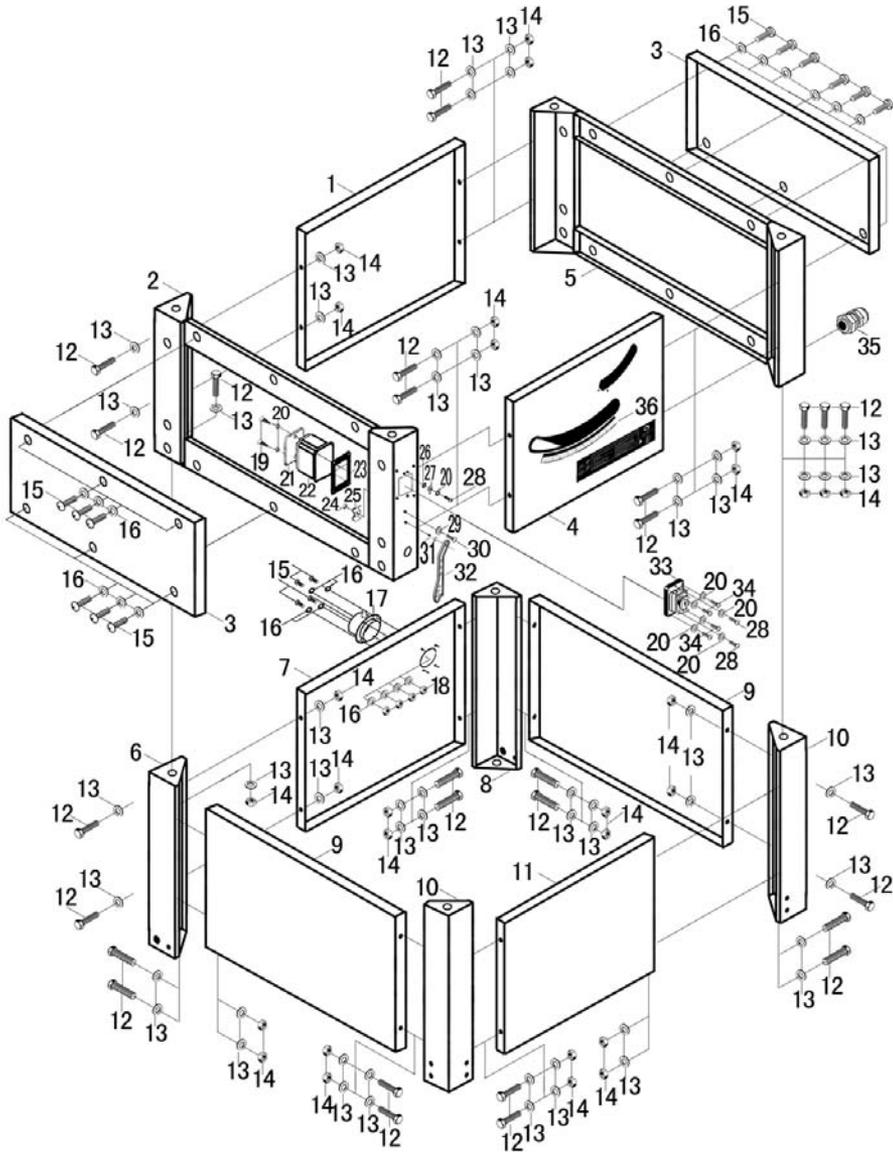
REMEMBER the emphasis of the 'push' should be between the blade and the fence and close to the fence. Use your free hand to support and guide the material on the offside of the saw blade and at least 100mm away from it. If the timber does not extend to at least 100mm to the offside of the saw blade,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

CHECK (especially on site), that there are no foreign objects e.g. old nails, screws, small stones etc embedded in the material you are about to cut. If necessary take a wire brush to the timber before working.

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

Parts List/Breakdown for the 10" Saw Table...

DIAGRAM A

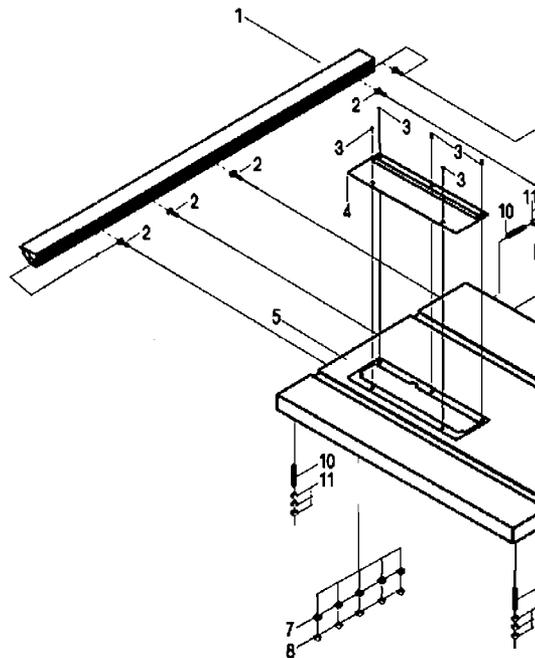


Parts List/Breakdown for the 10" Saw Table...

No.	DESCRIPTION	Qty
A-1	front panel	1
A-2	left frame	1
A-3	side panel	2
A-4	rear panel	1
A-5	right frame	1
A-6	left leg	1
A-7	front side board	1
A-8	right leg	1
A-9	right and left side board	2
A-10	rear leg	2
A-11	rear side board	1
A-12	hexagon head bolt M8X20	28
A-13	washer 8	56
A-14	hexagon nut M8	28
A-15	cross recessed pan head screw M6X22	16
A-16	washer 6	20
A-17	tie-in	1
A-18	hexagon nut M6	4
A-19	pan head tapping screw ST4X12	2
A-20	washer 4	9
A-21	switch bottom board	1
A-22	switch house	1
A-23	rubber washer of switch house	1
A-24	hexagon nut M5	1
A-25	wire strain	1
A-26	external teeth lock washer	1
A-27	earth-plate	1
A-28	cross recessed pan head screw M4X10	3
A-29	washer 5	1
A-30	cross recessed pan head screw M5X20	1
A-31	nail	1
A-32	push stick	1
A-33	switch	1
A-34	cross recessed pan head screw M4X16	4
A-35	cablegland	1
A-36	label	1

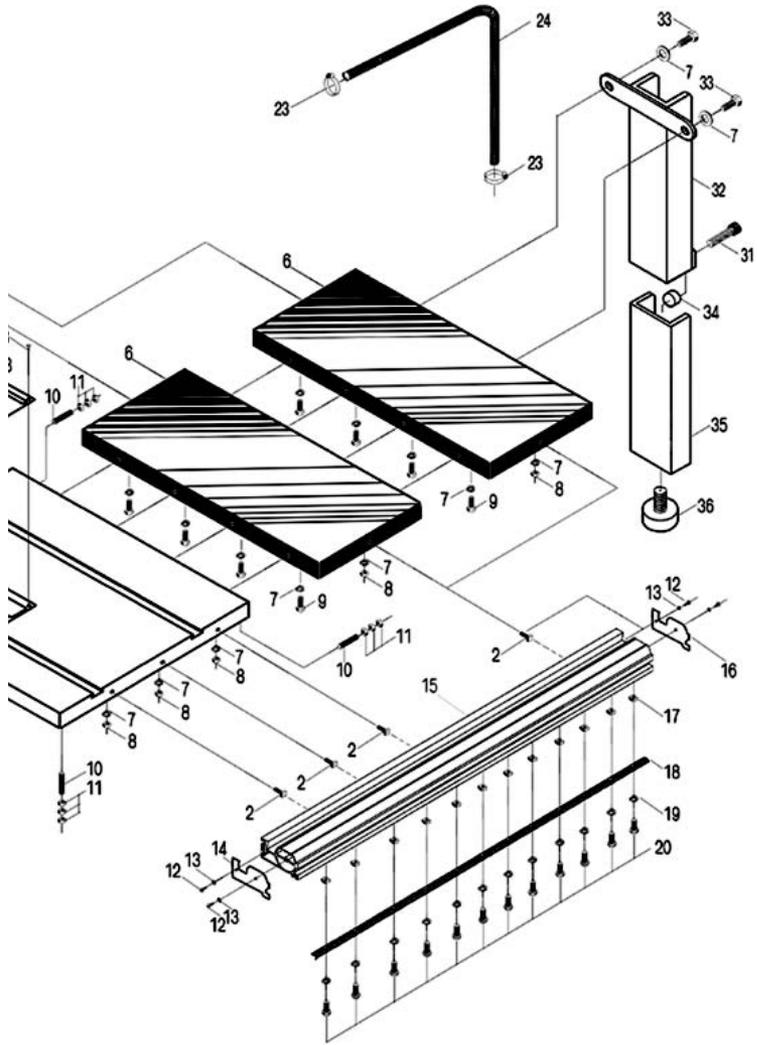
No.	DESCRIPTION	Qty
B-1	rear rail	1
B-2	step bolt M8x25	10
B-3	cross recessed countersunk head screw M5x8	5
B-4	insert	1
B-5	worktable	1
B-6	extension table	2
B-7	washer 8	28
B-8	hexagon nut M8	10
B-9	hexagon head bolt M8x22	8
B-10	slotted set screw with flat point M10x80	4
B-11	hexagon nut M10	12
B-12	cross recessed pan head tapping screw ST4.0x12	4
B-13	washer 4	4
B-14	left end cap for front rail	1
B-15	front rail	1
B-16	right end cap for front rail	1
B-17	square nut M5	12

B-18	rack	4
B-19	external teeth washer 5	12
B-20	cross recessed pan head screw M5x8	12
B-23	neck chain	2
B-24	dust collection tube	1
B-31	hexagon socket cap head screw M8x25	1
B-32	upper stand leg	1
B-33	hexagon head bolt M8x25	2
B-34	washer block	1
B-35	lower stand leg	1
B-36	foot bolt	1



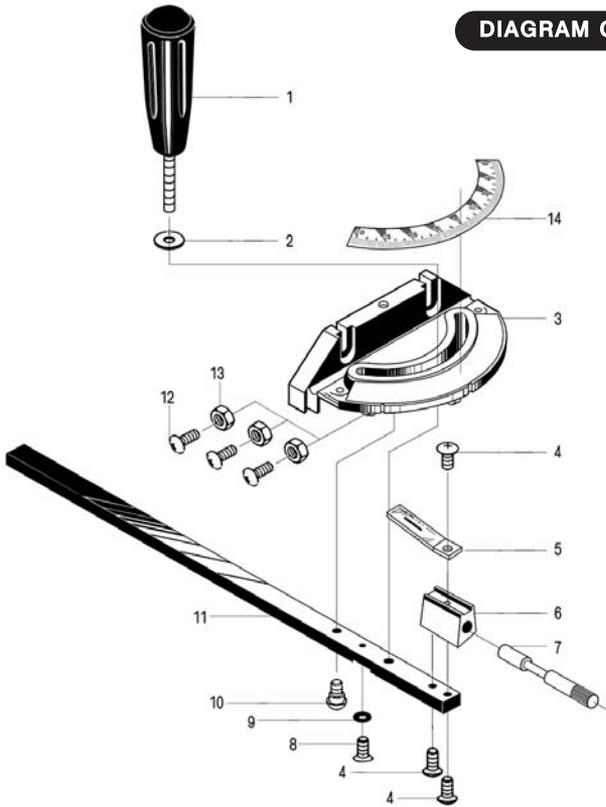
Parts List/Breakdown for the 10" Saw Table...

DIAGRAM B



Parts List/Breakdown for the 10" Saw Table...

DIAGRAM C

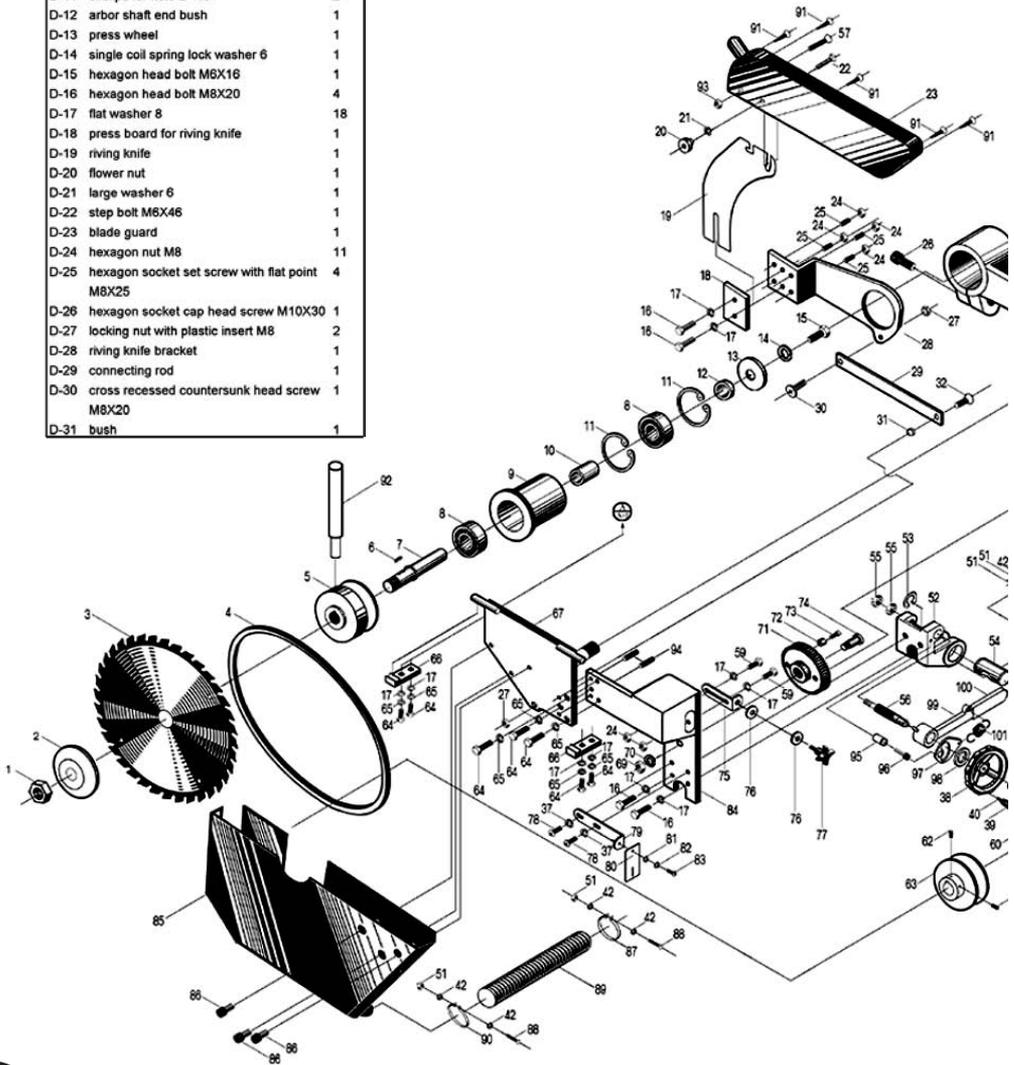


No.	DESCRIPTION	Qty
C-1	lock handle for mitre gauge	1
C-2	washer 8	1
C-3	mitre gauge	1
C-4	cross recessed pan head screw M5X10	3
C-5	mitre gauge pointer	1
C-6	mitre gauge block	1
C-7	stop pin	1
C-8	cross recessed countersunk head screw M5X8	1
C-9	guide board washer	1
C-10	shoulder screw	1
C-11	guide board	1
C-12	cross recessed pan head screw M4X8	3
C-13	hexagon nut M4	3

Parts List/Breakdown for the 10" Saw Table...

No.	DESCRIPTION	Qty
D-1	blade nut M16(left-hand)	1
D-2	outer blade washer	1
D-3	blade	1
D-4	A-belt	1
D-5	pulley	1
D-6	key (A-type)	1
D-7	arbor shaft	1
D-8	bearing 80203	2
D-9	arbor shaft sleeve	1
D-10	arbor shaft bush	1
D-11	circlips for hole D=40	2
D-12	arbor shaft end bush	1
D-13	press wheel	1
D-14	single coil spring lock washer 6	1
D-15	hexagon head bolt M8X16	1
D-16	hexagon head bolt M8X20	4
D-17	flat washer 8	18
D-18	press board for riving knife	1
D-19	ripping knife	1
D-20	flower nut	1
D-21	large washer 6	1
D-22	step bolt M8X46	1
D-23	blade guard	1
D-24	hexagon nut M8	11
D-25	hexagon socket set screw with flat point M8X25	4
D-26	hexagon socket cap head screw M10X30	1
D-27	locking nut with plastic insert M8	2
D-28	ripping knife bracket	1
D-29	connecting rod	1
D-30	cross recessed countersunk head screw M8X20	1
D-31	bush	1

D-32	cross recessed countersunk head screw M8X30	1
D-33	hexagon head bolt M8X85	1
D-34	locking nut for motor base	2
D-35	motor base	1
D-36	hexagon socket cap head screw M5X12	2
D-37	large washer 5	4
D-38	hand wheel	2
D-39	handle	2
D-40	handle bolt	2
D-41	cross recessed pan head screw M6X16	4

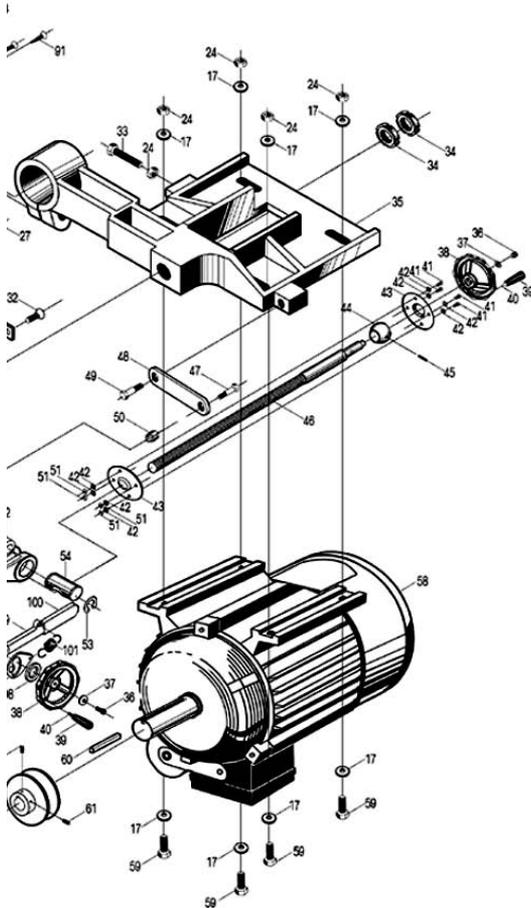


Parts List/Breakdown for the 10" Saw Table...

DIAGRAM D

No.	DESCRIPTION	Qty
D-42	flat washer 6	12
D-43	ball bracket	2
D-44	thread rod ball	1
D-45	spring dowel 4x28	1
D-46	adjusting thread rod	1
D-47	worm-wheel connecting rod nail A	1
D-48	worm-wheel connecting rod	1
D-49	worm-wheel connecting rod nail B	1
D-50	connecting rod bush	1
D-51	hexagon nut M6	6
D-52	adjusting frame	1
D-53	circlips for shaft D=24	2
D-54	knuckle	1
D-55	thin nut M12	2
D-56	height adjustment rod	1

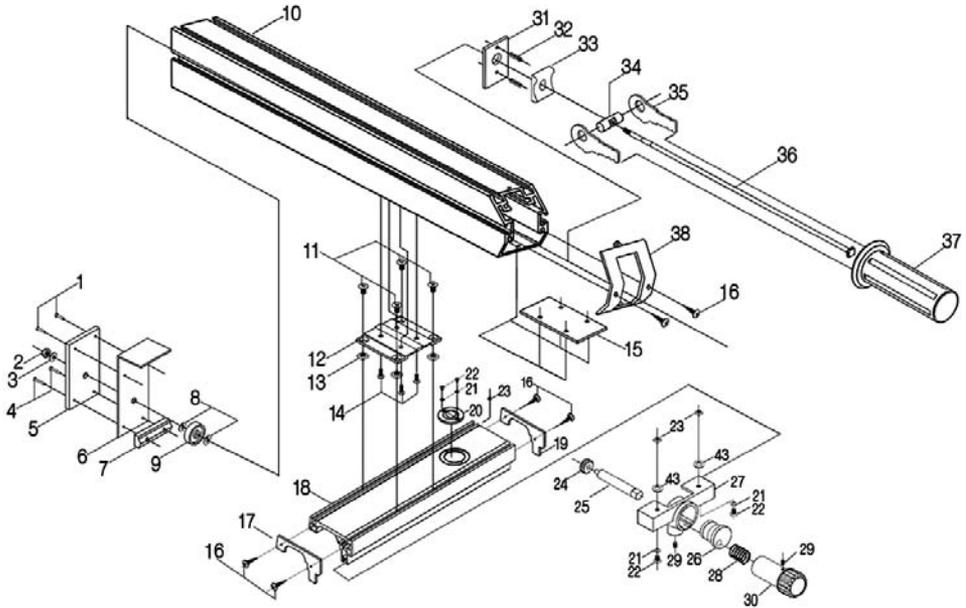
D-56	height adjustment rod	1
D-57	cross recessed countersunk head screw M5X32	1
D-58	motor	1
D-59	hexagon head bolt M8X40	6
D-60	key 8x7x50	1
D-61	hexagon socket set screw with flat point M6X9	1
D-62	hexagon socket set screw with flat point M6X6	1
D-63	motor wheel	1
D-64	hexagon socket cap head screw M8X24	7
D-65	single coil spring lock washer 8	7
D-66	rotation press block	2
D-67	adjusting cradle	1
D-69	hexagon nut M12	1
D-70	single coil spring lock washer 12	1
D-71	worm-wheel	1
D-72	eccentric sleeve	1
D-73	hexagon socket cap head screw M8X30	1
D-74	worm-wheel shaft nail	1
D-75	locking block	1
D-76	large washer 8	2
D-77	flower bolt	1
D-78	cross recessed pan head screw M5X12	2
D-79	pointer bracket	1
D-80	pointer	1
D-81	flat washer 4	1
D-82	single coil spring lock washer 4	1
D-83	cross recessed pan head screw M4X10	1



No.	DESCRIPTION	Qty
D-84	adjusting worm-wheel bracket	1
D-85	dust collection cover	1
D-86	hexagon socket cap head screw M6X18	3
D-87	neck chain	1
D-88	hexagon head bolt M6X25	2
D-89	dust collection tube	1
D-90	elliptic neck chain	1
D-91	cross recessed countersunk head tapping screw ST4.0X26	5
D-92	Tommy Bar	1
D-93	hexagon nut M5	1
D-94	elastic lock	2
D-95	lock nail bush	1
D-96	hexagon socket cap head screw M6X25	1
D-97	active board	1
D-98	active board block	1
D-99	lock handle	1
D-100	handle sleeve	1
D-101	lock handle spring	1

Parts List/Breakdown for the 10" Saw Table...

DIAGRAM E



No.	DESCRIPTION	Qty
E-1	round head rivet with small head $\phi 3 \times 7$	2
E-2	hexagon nut M8	1
E-3	washer 8	1
E-4	round head rivet with small head $\phi 3 \times 13$	2
E-5	lock plate	1
E-6	lock spring	1
E-7	lock block	1
E-8	spring ring D6	2
E-9	rolling wheel	1
E-10	rip fence	1
E-11	cross recessed countersunk head screw M6X12	4
E-12	fence plate	1
E-13	square nut M6	4
E-14	cross recessed pan head screw M6X16	4
E-15	board instead of nut	1
E-16	cross recessed countersunk head tapping screw ST4.0X12	6
E-17	left end cap for scale indicator housing	1
E-18	scale indicator housing	1
E-19	right end cap for scale indicator housing	1

E-20	scale indicator	1
E-21	washer 5	4
E-22	cross recessed pan head screw M5X10	4
E-23	square nut M5	3
E-24	small gear	1
E-25	gear rod	1
E-26	eccentric wheel	1
E-27	gear rod frame	1
E-28	spring for gear rod	1
E-29	hexagon socket set screw with flat point M6X5	2
E-30	rip fence handle	1
E-31	rear board	1
E-32	pin $\phi 5 \times 16$	2
E-33	rear block	1
E-34	lock eccentric rod	1
E-35	lock eccentric	2
E-36	rip fence lock rod	1
E-37	rip fence handle	1
E-38	rip fence cover	1
E-43	washer 4	2

Installing Mobile Wheel Kit (optional)

1. Place "U" Shape Bracket(1) onto Front Wheel Kit Ass'y(2).
2. Insert Hex Head Screw M10x70(3), secure Front Wheel Kit and Sleeve(4) to work stand.
3. Insert Special Thread(5) and secure Front wheel kit.
4. Secure Rear Castor Frame(7) to workstand with two Hex Head Screw M10x20 & washer.
5. When move the machine adjust the Allen Bolt M12x50, and raise the machine about 5mm above floor. Insert the Rear Castor Ass'y, push the lever down and pull the machine round the workshop.

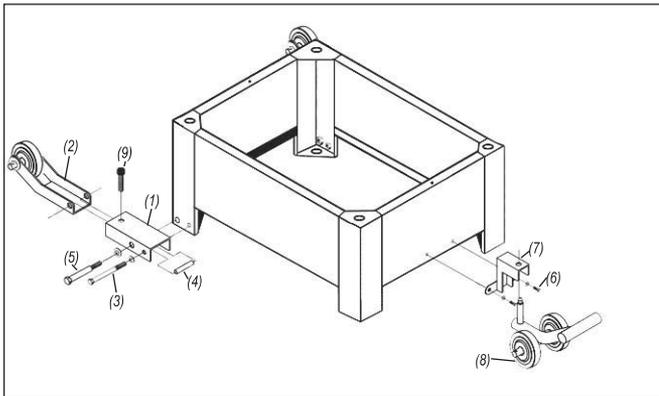


DIAGRAM AND PARTS LIST(OPTIONAL)

No.	DESCRIPTION	Q'ty
1	Flat washer 16mm	12
2	Castor	4
3	Roll pin	6
4	Fork, castor	2
5	Allen bolt M12x50	2
6	Adjustable U-shape bracket	2
7	Flat washer 14mm	2
8	Hex head screw M10x70	2

No.	DESCRIPTION	Q'ty
9	Flat washer 10mm	4
10	Sleeve	2
11	Rear castor frame	1
12	Hex head screw M10x20	2
13	Lever, Wheel kit	1
14	Special thread	1
15	Pin, castor	2

