AXMINSTER PROFESSIONAL

Code 107662

Original Instructions

AP254PS16

Panel Saw

AXMINSTER 3 THREE YEAR GUARANTEE

AT: 31/10/2023
BOOK VERSION: 08

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General information

OAV Equipment &Tools, Inc. is specialized to supply full range of panel saw from 1600, 2200, 2600, 3200 to 3800mm. The outlook design of this machine is so unique with complete cast iron bracket instead of sheet metal, enlarged outrigger and carriage, direct dust collection outlet.

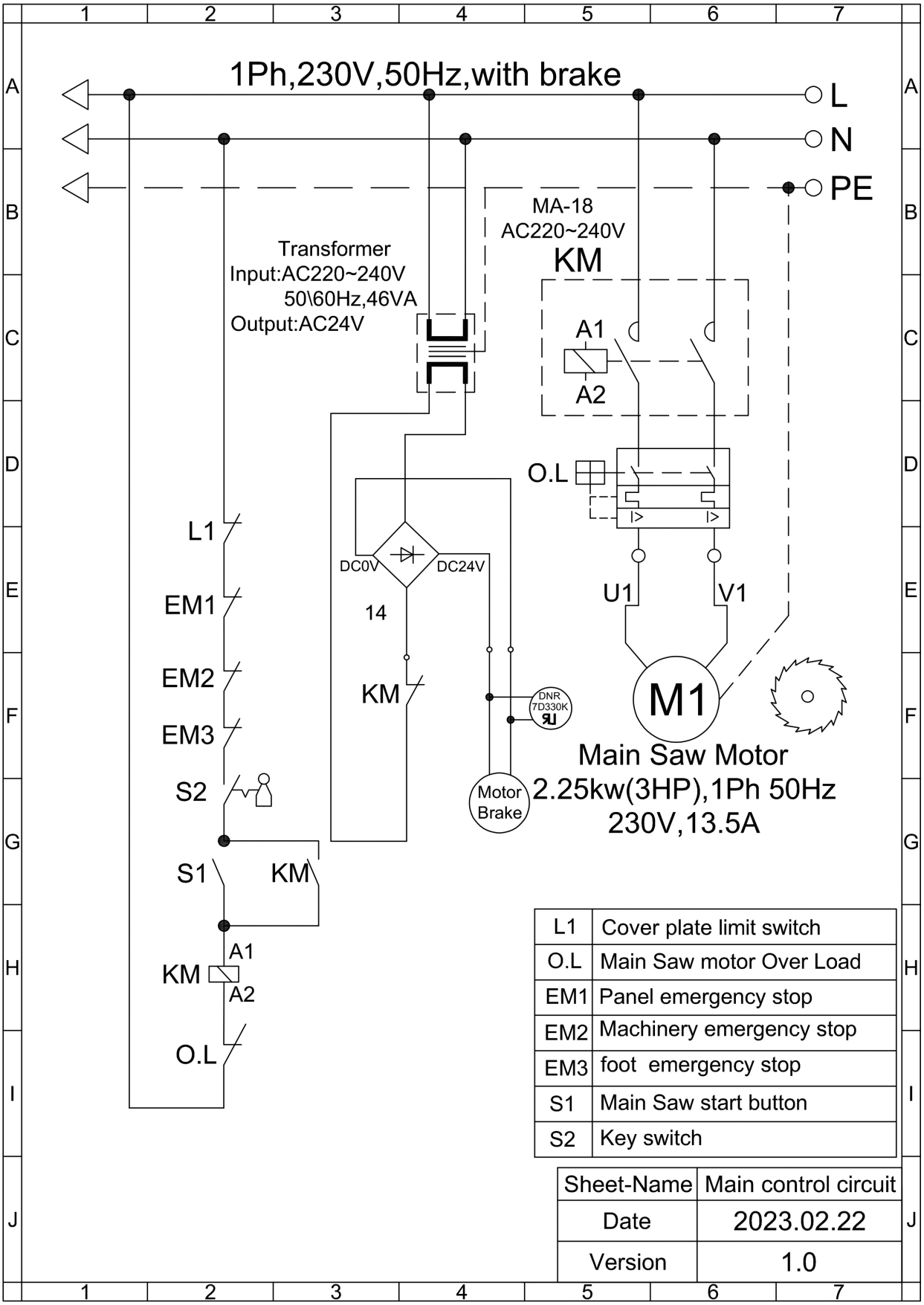
Besides of our Band Saw series, these Table Saw series are also innovative products. Please enjoy your operation on this machine and if you have any comment to improve them, please don't hesitate to contact us through your agent

Safety Rules

For your own safety, please read instruction manual carefully before operating.

1. To avoid dangerous working environments, do not use stationary machine tools in wet or damp locations, keep working area clean and well-lit.
2. Wear proper apparel, no loose clothing or jewelry which can get caught in moving parts.
3. Never leave when machine is running.
4. Disconnect electrical power before tools are serviced.
5. Remove adjusting keys and wrenches before turning machine on.
6. Make sure that the keys and adjusting wrenches have been removed and all the nuts and bolts are secured.
7. Keep guards in place and in working order.
8. Keep children and visitors away, they should keep with a safe distance from the working area. Never leave the machine with power on.
9. Keep hands well away from blades and all moving parts. Do not clear chips and sawdust away with hands.

WIRING DIAGRAM



L1	Cover plate limit switch
O.L	Main Saw motor Over Load
EM1	Panel emergency stop
EM2	Machinery emergency stop
EM3	foot emergency stop
S1	Main Saw start button
S2	Key switch

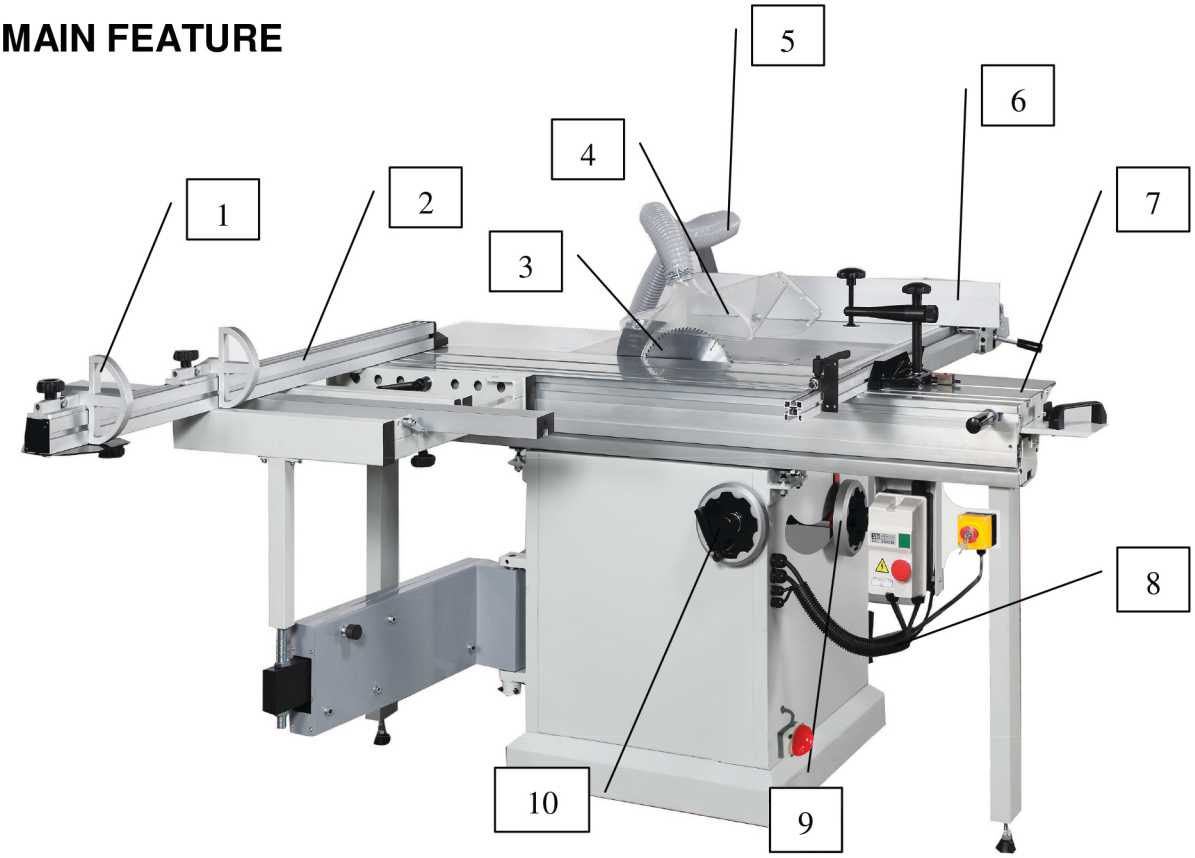
Sheet-Name	Main control circuit
Date	2023.02.22
Version	1.0

SPECIFICATION

Model		**10" PANEL SAW**
Sliding table dimension		**1600 X 316MM**
Max. Sliding Stroke with crosscut Fence		1600mm
Max. Sliding Stroke w/o crosscut Fence		1900mm
Table Height		912mm
Table Size W/ext. Wing		W: 377mm x D: 688mm (1020mm x 1193mm)
Main Saw	**Max Saw Blade Dia.**	254mm
	Saw Blade Arbor Diameter	30mm
	Cutting Height at 90°,45°	80/57mm
	Motor Power	2.25KW/1PH (Optional: 2.25KW/ 1PH/3.75KW/3PH)
	Spindle RPM	4,000 (Motor RPM 2850)
Scoring Saw	**Saw Blade Dia.**	80mm
	Saw Blade Arbor Diameter	20mm
	Cutting Height at 90°,45°	5mm/3mm
	Motor Power	
	Spindle RPM	8,000
Ripping Width		838mm
Crosscut Width		1,380mm/2,350mm
Blade Height Adjustment		Manual
Blade Tilting Adjustment		Manual, 0~45°
Electric Control System		Magnetic switch
Dust Collection System		Main Channel 4" (100mm), Saw blade guard extract 2-1/2" (60mm)
Standard Accessories		Extruded Profile Rip fence
		Sheet Metal Extension Table x2 pcs
		Standard Saw Blade Guard
		Standard Miter Fence, Scoring Saw Blade
Optional Accessories		Main Saw Blade, Edge Shoe
		Saw Blade Hose Support Plate and Hose

Due to needs of continuous improvement, specification is subject to change without prior notice

MAIN FEATURE



1. Flip Stop**:** Large stopper for accurate measurements
2. Crosscut Fence: 90° and 45° quick position design for a precise crosscutting operation
3. Riving Knife: It is prevent kickback cause by the knife closing behind the blade
4. Saw Blade Guard: Fully adjustable blade maintains maximum protection around the saw blade
5. Hose Support Plate and Hose: To collect the dust chip efficiency
6. Rip Fence: For smooth and precise cutting
7. Sliding table: For smooth cutting, precise sliding table glides the work- piece through the blade
8. Control panel: Simple push button controls for operation
9. Main Saw Blade height adjusting hand wheel: Manual adjusts the height of saw blade
10. Main Saw Blade angle adjusting hand wheel: Manual adjusts the angle of saw blade

(1) Control Panel

1. Main Switch: Power on and power off the panel saw.
2. Emergency Stop Button disconnects power to motor.
3. Blade on Button: Starts the main saw blade and scoring saw blade.
4. Blade off Button: Stops the main saw blade and scoring saw blade.

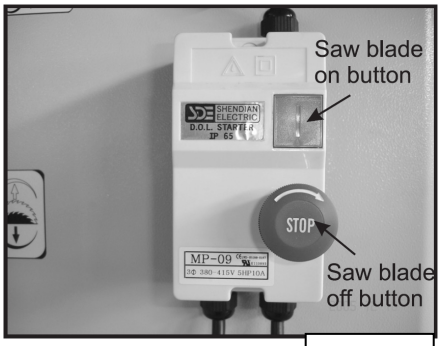


Fig. 1

(2) Rip Fence

1. One single lock down lever: Simple and precise to lock the fence assembly into fence rail.
2. Micro adjust knob: Precisely adjustment.
3. Forward and backward slide lock handle: To firm the high/low profile alum. Fence on its forward/Backward slide track.
4. Micro-adjust lock knob: secures the fence after it has been adjusted with micro-adjustment knob.
5. Rip fence scale: Allows precise measurement of rip cutting operations.

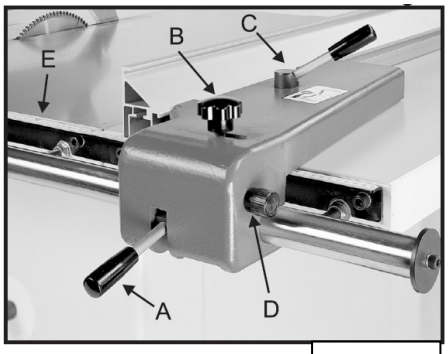


Fig. 2

(3) Miter Fence

1. Fine adjustment handle. (Fig. 3)
2. To hold the wood firmly.

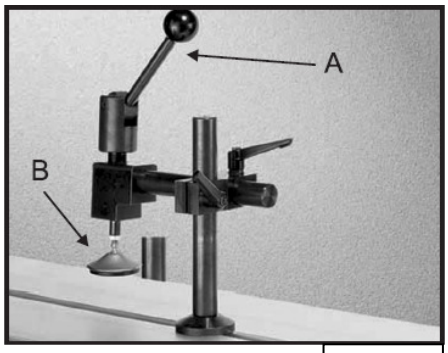


Fig. 3

(4) Riving Knife and saw blade

1. Riving knife: Maintains kerfs opening during cutting operations. The purpose is crucial to prevent kickback caused by the kerfs closing behind the blade.
2. Main saw blade: The maximum is 254mm. (Optional accessories)
3. Scoring blade: It is rotates opposite the main saw blade, the blade cores the workpiece before the actual cutting operation is performed preventing teat-out in laminate materials. The scoring is adjustable forward and backward, upper and down. (Fig. 4)

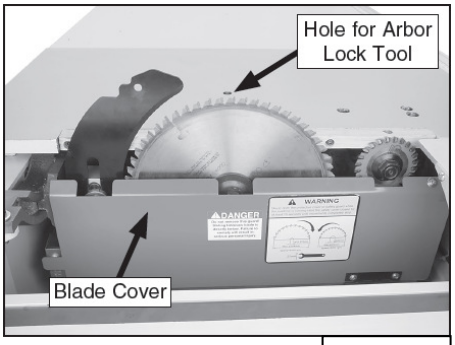


Fig. 4

Assembly and set up

(1) Sliding Table

Sliding table contents:

- T-Bolt M12-1.75 x 2
- Flat washer 12mm x 2
- Sliding table locate plate handle x 1
- Sliding table lock plate x 1
- Lock washer M12 x 2
- Hex nut M12 x 1.75 x2
- Switch
- Stand

- Button head bolt M6 x 16
- Cap screw M8 x 20
- Locate plate

1. Lift the sliding table up to the cabinet, with another person's help inset the T-bolt (Fig. 5.1) and space them apart the same distance and the mounting bolts to the cabinet (Fig. 5.2). Lift up the sliding table again and fit the T-bolts into the mounting holes on the cabinet. Secure the sliding table to the cabinet with two M12x1.75 Hex nut. Inset the locate plate into the track use two M5 x 12 Hex socket bolt to mount the main switch. Insert another lock plate to install two side stand and fasten the stand use 2 pcs M8 x 20 cap screws at the bolt left and ring hand sides. (Fig. 5.3 & 5.4)
2. Install the end handle of the sliding table with M6 x 16L Button head screws 2pcs, the sliding is located when the table lock is in the right position, (Fig. 5.5) rotate the table lock 180 degree to unlock the sliding table.
3. Install the locate plate use 4 pcs of M6 x 12 button head screws at the two sides of sliding table.

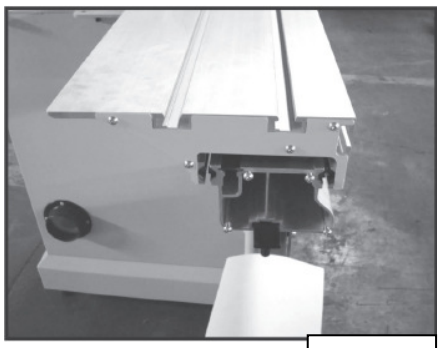


Fig. 5.1

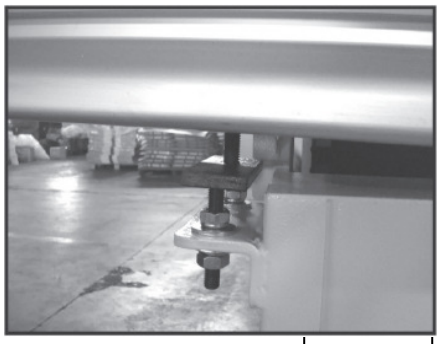


Fig. 5.2

(2) Extension Tables content

- Large extension table x 1
- Small extension table x 1
- Hose support plate x 1
- Cap screws M10-1.5 x 25 x 6pcs, Set Screw M8-1.25 x 25 x 6pcs
- Hex nuts M8-1.25 x 6pcs
- Lock washer 10mm x 6pcs
- Flat washers 10mm x 6pcs
- Hex nut M10-1.5 x1pc

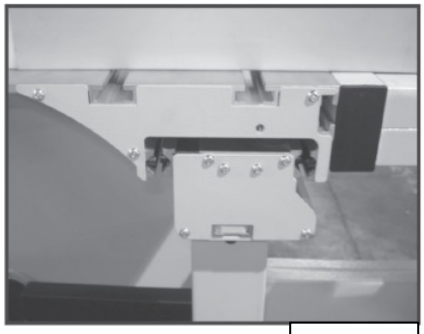


Fig. 5.3

How to install the extension tables

1. Thread the set screws into the 6mm holes from the inside of both extension tables.
2. Before the tables are leveled, please do not completely tighten the bolts in follow steps.
3. Attach the large extension table with three M10-1.5 x 25 cap screws, lock washers and flat washers. (Fig. 6)
4. Attach the small extension table with two M10-1.5 x 25 cap screws, lock washers and flat washers (Fig. 7).
5. Place the hose support plate to the extension table and thread M10-1.5 x25 screws, lock washers and hex nut (Fig. 8).
6. Check the surface 0 the table with a straightedge (Fig. 9).

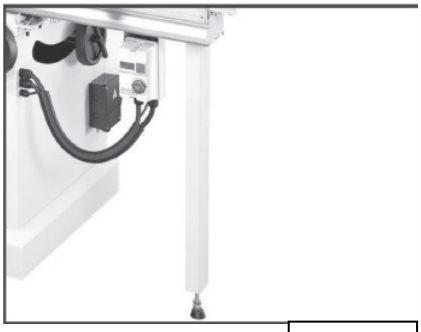


Fig. 5.4

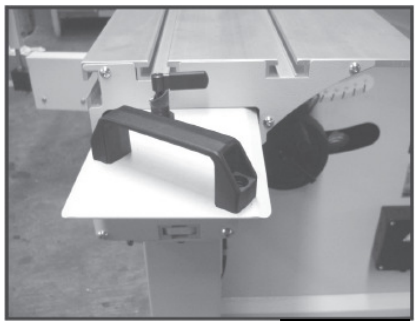


Fig. 5.5

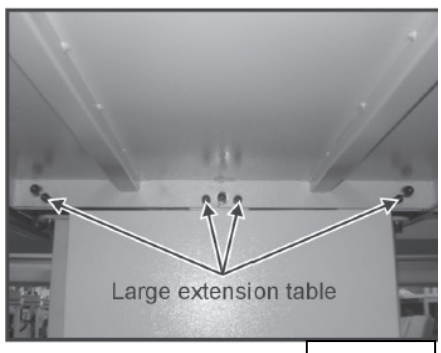


Fig. 6

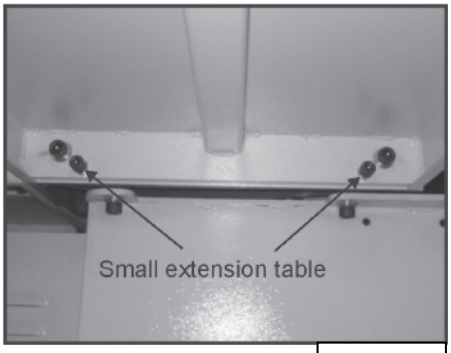


Fig. 7

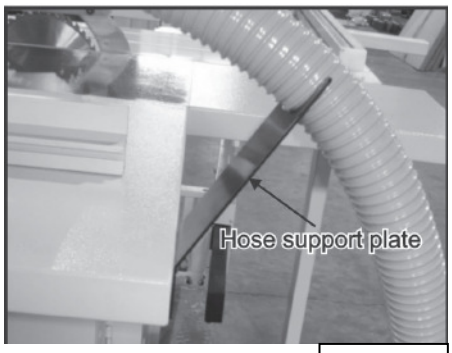


Fig. 8

Fig. 9

(3) Scale adjustment

- Loosely thread 2 pcs M6 x 16 hex screw and 1 pc M6 x 25 hex screw with lock and flat washers through the scale and into table. (Fig. 10)
- Tight the cap screws to the extension table with M6 hex nuts.
- Line the scale up with the top of the table and tighten the hex nuts.

Fig. 10

(4) Rip fence

Rip fence content

- Rip fence x 1pc
- Bracket x 1pc
- Rip fence body x1pc
- Screw M12-1.75 x 90 x 3pcs
- Hex nut M12-1.75 x9pcs
- Flat washer 12mm x 9pcs
- Lock washer 12mm x3pcs

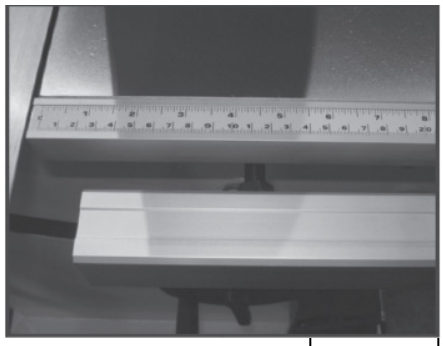


Fig.11

How to adjust the rip fence

1. Thread 4pcs studs into bracket.
2. Thread an M12-1.75 hex nut onto each stud and tighten the nut against the bracket.
3. Thread and M12-1.75 hex nut and a flat washer half way onto each stud.
4. Insert the studs into the table (Fig. 11). Tighten with an M12-1.75 hex nut, lock washer and a flat washer on each stud.
5. Slide the rip fence body onto the bracket.
6. Thread the lock handles into the rip fence body.
7. Lock the rip fence with the handle on the right hand side of the rip fence body. (Fig. 12)
8. Check the height of rip fence rail by sliding rip fence along the rail and comparing the gap between the fence body and the table.
9. Adjust the height of the rip fence rail, then tighten all nuts against the table showed. (Fig. 13)

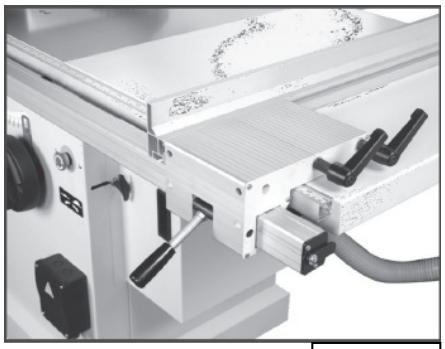


Fig. 12

(5) Crosscut table

Crosscut content

1. Crosscut table x 1
2. Crosscut table brace x 1
3. T-nut M8-1.25 x 2
4. T-nut M12-1.75 x 1
5. Flat washer 12mm x 1
6. Adjustment handle M12-1.75 x 55 x1
7. Knob M8-1.25 x 50 x 2
8. Flat washer 8mm x 2

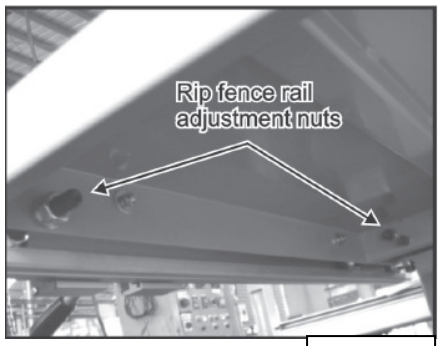


Fig. 13

1. Thread the M12-1.75 x 55 adjustable handle with a 12mm flat washer through the crosscut table and into a M12-1.75 T-nut (Fig. 14)
2. Secure the pivot pin to the crosscut table first, place the extension table set on the swing arm and sliding the T-nut into the T-slot in the sliding table. (Fig. 15.16)
3. Slide two M8-1.25 T-nuts into the crosscut table brace.
4. Align the T-nuts in the crosscut table supporter with the holes in the crosscut table and thread the M8-1.25 x 50 knobs, with 8mm flat washers, into the T-nuts (Fig. 17)

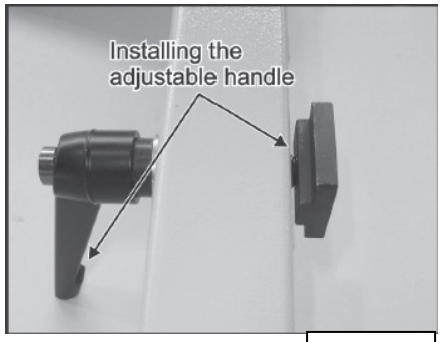


Fig. 14

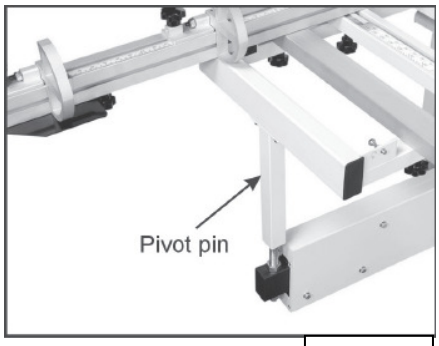


Fig. 15

Fig. 16

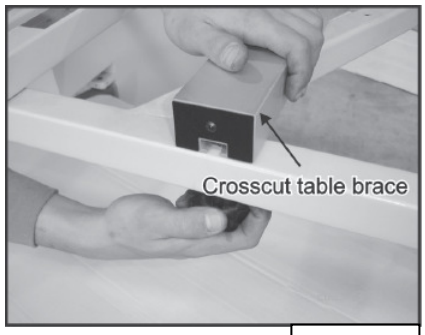


Fig. 17

(6) Crosscut fence

Crosscut fence content

1. Crosscut fence x 1
2. Crosscut fence support plate x 1
3. Centre stud M8-1.25 x 10 x 1
4. Flat washer 8 x Ø20 x 1
5. T-nut M8-1.25 x 5
6. Knob M8-1.25 x 25 x 1
7. Knob M-1.25 x 1
8. T-bolt M8-1.25 x 60 x 1
9. Flat washer 8mm x 1
10. Lock washer 8mm x 3
11. Button head screw M8-1.25 x 16 x 2
12. Fence support plate

1. Thread the centre stud and the flat washer 8 x Ø20 into the remaining M8-1.25 T-nut.

2. Sliding the centre stud, an M8-1.25 x 60 T-bolt and screw M8-1.25 x 25 Knob into the crosscut fence (Fig. 18)
3. Slide the centre stud to the end with the plastic cap and tighten it in place.
4. Insert the center stud and T-bolt in the places indicated (Fig. 19)
5. Secure the crosscut fence with the M8-1.25 knob with an 8mm flat washer threaded onto the T-bolt.
6. Unlock the crosscut fence extension and slide the flip stops into the fence.
7. Sliding two M8-1.25 T-nuts into the crosscut fence extension and attach the cross fence extension and attach the crosscut fence support plate to the fence extension with two M8-1.25 button head screws and lock washers.

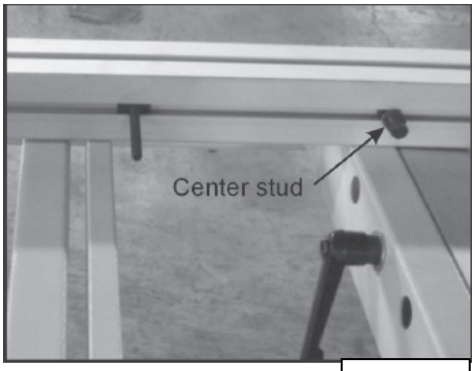


Fig. 18

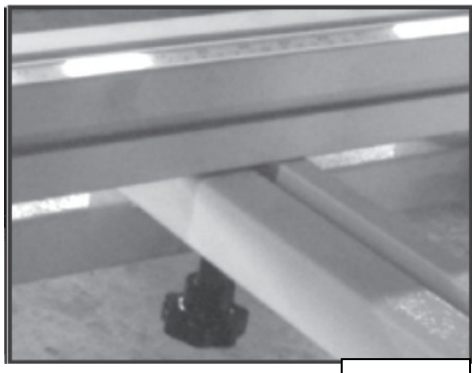


Fig. 19

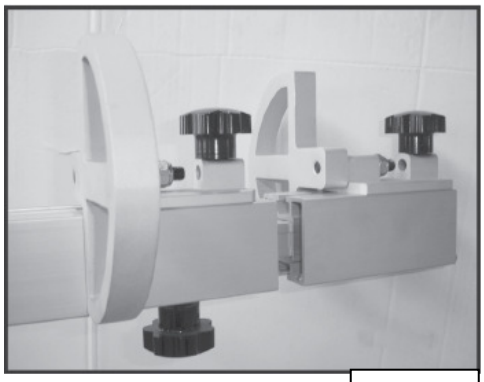


Fig. 19.1

(7) Main Blade

Main blade contents

1. Blade 10” (as option) x1
2. Flat belt 15 x 1,080 mm x1
3. Riving Knife x1

The saw is designed with 10” main saw blade, before you change blade size, the riving knife must be adjusted to match the size of blade you install.

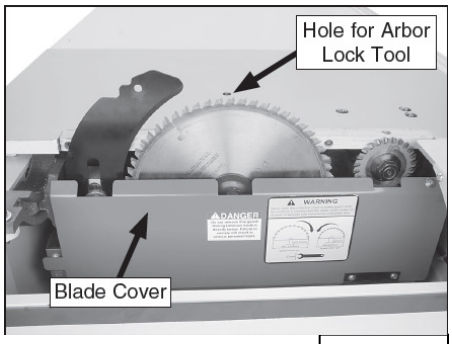


Fig. 20

1. Before adjusted the blade, open the motor compartment and remove the foam shipping block and the red shipping brackets from the motor.
2. Place the flat belt on the scoring blade arbor (Fig. 21), lift the scoring motor and slide the flat belt over the scoring motor pulley. (Option)
3. Move the blade tilt to 0° and raise the main blade as far as it will go.
4. Slide the table all the way forward to access the blade arbor and pull open the blade guard. (Fig. 22)
5. Use the arbor wrench to remove the arbor nut and arbor flange, the arbor nut has left hand threads and loosens by turning clockwise. (Fig. 23.1 & 23.2)
6. Slide the blade over the arbor with the teeth facing the front of the saw.

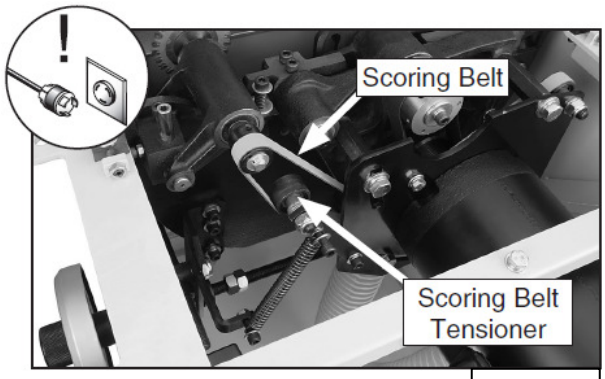


Fig. 21

7. Re-install the arbor flange and the arbor nut and tighten them against the blade.

8. Loosen the riving knife center bolt, slide the riving knife over the bolt (Fig. 24) and slightly tighten.
9. Position the riving knife about 3mm or 1/ 8" away from the nearest carbide tooth on the main blade. For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife. (Fig. 25)
10. Tighten the centre bolt to secure the riving knife in position.
11. Move the blade guard back to its original position, and move the sliding table back to centre.

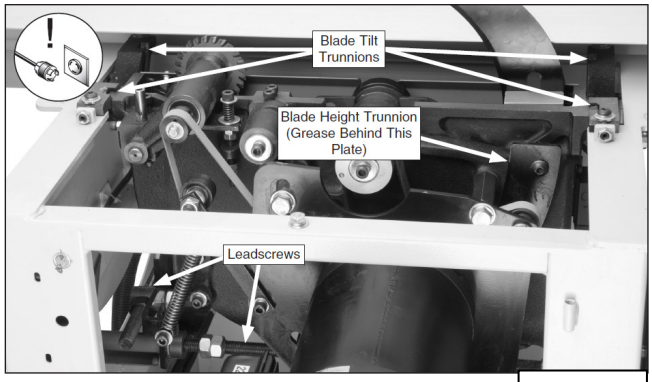


Fig. 22


Fig. 23.1

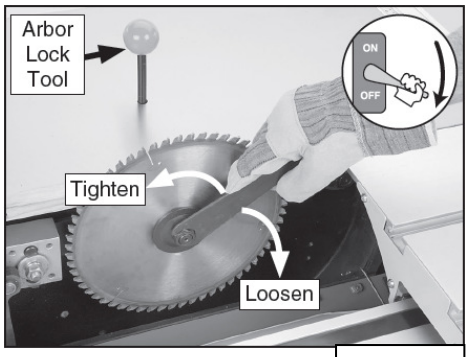


Fig. 23.2

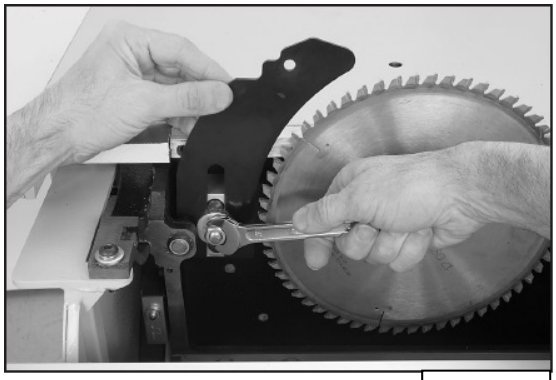


Fig. 24


Fig. 25

(8) Scoring Blade

Aligning Scoring Blade set

The scoring blade must be aligned with the main blade to ensure satisfactory cutting results.

1. Move the blade tilt to 0° (blade 90° to blade) and raise the main blade all the way up.
2. Release the screw in Hole A before adjust the scoring blade and tighten the screw each time after adjustment. (Fig. 26, Hole A)
   Hole B to adjust the scoring blade up and down.
   Hole C to adjust the scoring forward and backward.
   <u>Important notice: tighten the Hole A when finish adjustment.</u>
3. Move the rip fence against the main blade (or scoring blade) (Fig. 27)
4. Use the adjustment controls to move the scoring blade so that the rip fence can touch both the scoring blade and the main blade.

5. Lower the scoring blade to the correct height (2mm or 5⁄ 64”), perform a test cut, and then make any final adjustment.

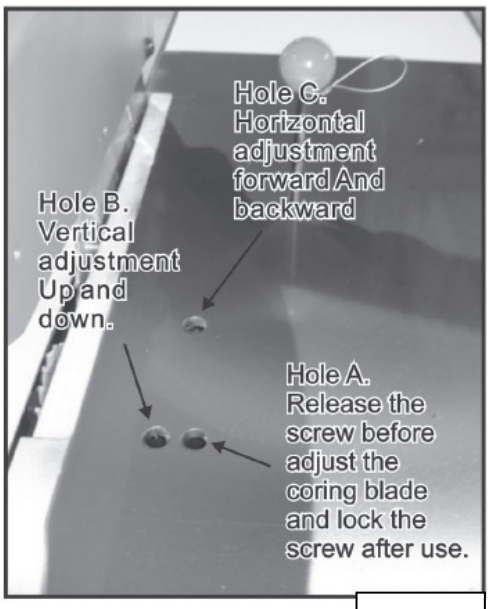


Fig. 26

(9) Fence Scale Alignment

Before operation, the 0” mark on the rip fence scale must be aligned the right side of the blade to unsure that the rip fence measurements will be accurate.

1. Move the blade tilt to 0” (blade 90° to table), and raise the main blade all the way up.
2. Move the rip fence against the main blade (Fig. 27)
3. Loosen the cap screws securing the fence scale.
4. Slide the fence scale to line up the first mark on the scale with the left edge of the rip fence and tighten the cap screws.

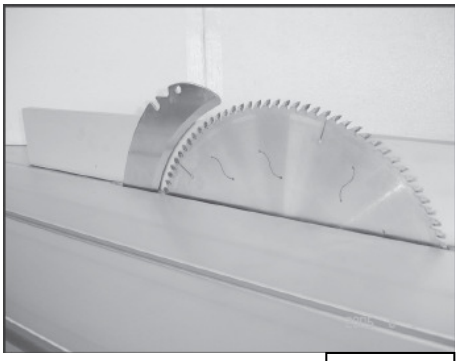


Fig. 27

(10) Dust Collection

There are dust ports are designed on this machine, please connect the dust collection system before operations.

1. Secure a 4” dust hose to the dust port. (Fig. 28)
2. Run the 4” hose to your dust collection system. Slide the blade guard/dust hood over the riving knife and attach it with a M8-1.25 x 40 button head cap screw and a flat washer. (Fig. 29)
3. Secure a 2-1⁄ 2” hose over the hose support (Fig. 30) and connect it to the dust collection system.
4. Run the 2-1⁄ 2” hose over the hose support (Fig. 30) and connect it to the dust collection system.

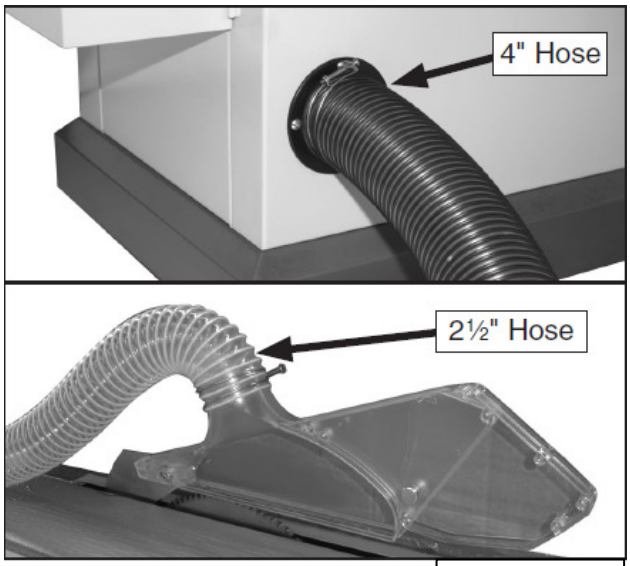


Fig. 28 & 29

5. Run a ground wire along the dust hose and attach the wire to the machine to protect against static electricity.
   Notice: Hose is optional accessories.

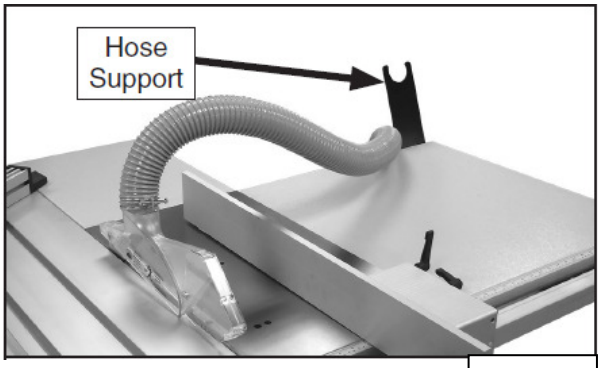


Fig. 30

(11) Power cord

1. Power the terminal box (Fig. 31)
2. Feed the power cord through the strain relief on the bottom of the control panel and connect the cord to the terminals. If finish, close the terminal box.
3. Shut off the main power at the power source circuit breaker and install the cord to the disconnect switch.

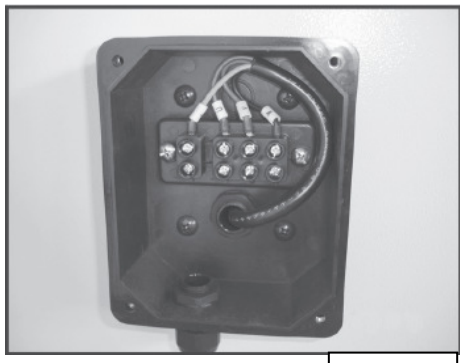


Fig. 31

(12) Test Run

Before operation, it must be testing this machine to make sure all the controls are working properly.

WARNING

Before starting the saw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury or even death!

1. Connect the machine to the power source.
2. To check the machine light is turning on.
3. Press the main blade button, if the main blade is rotating counter-clockwise, then press the scoring blade button. If the main blade is rotating clockwise, disconnect the saw from power and exchange wires in the terminal box.

Operation

You must follow these instructions EVERY time you use your saw.

1. Stand to the left of the blade line-of-cut when performing a cutting operation.
2. Turn off the saw and allow the blade to come to a complete stop before removing the cut-off piece.
3. Make sure the riving knife is always aligned with the main blade before cutting.
4. Always position the blade guard to the correct height above the work-piece.
5. Carefully plan each cutting operation to avoid injuries.
6. When you release the sliding table lock, make sure that the knob is positioned so that it will not lock the table during a cut.

(1) Changing Main Blade

The main blade size for this machine 10", it is as option. Any time you change the blade size, adjust the riving knife to 3mm away from the blade you install.

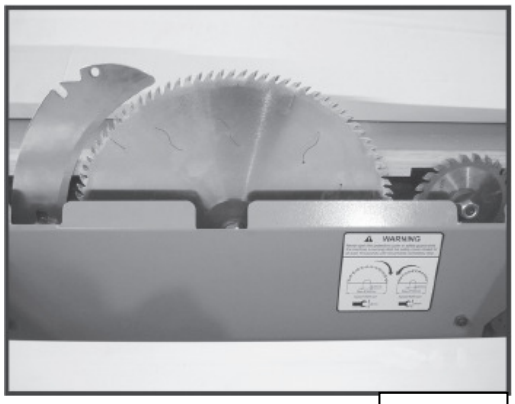


Fig. 32

1. Disconnect the power source.
2. Move the blade tilt to 0° (blade 90° to blade) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife. (Fig. 32)
4. Pull the blade guard away from the blades to expose the mounting assembly.
5. To remove the main blade, use the stopper rod to fix blade, use the arbor wrench to remove the arbor nut and arbor flange. (The arbor nut has left hand threads and loosens by turning clockwise.)
6. Install the new blade, re-install the arbor flange and the arbor nut and tighten them against the blade. (Fig. 33)

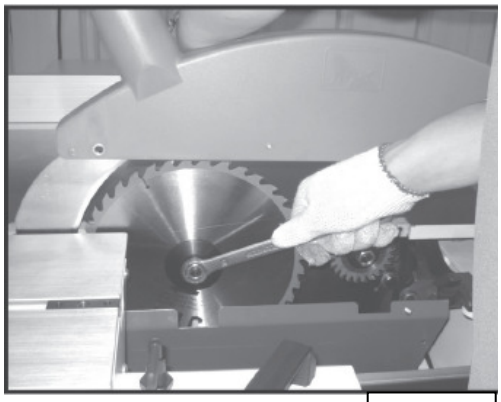


Fig. 33

WARNING

Wear gloves to protect your hands when installing or removing blades.

7. Move the orange blade guard back into its original position, next to the blades and centre the sliding table.

(2) Riving Knife Adjustment

Whenever the blade size is changed (maximum 10”), then ring knife must be adjusted to 2mm away from the blade you install.

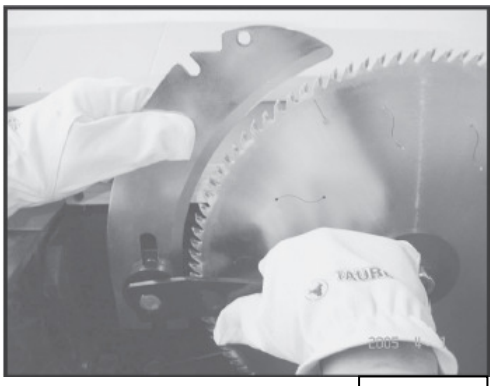


Fig. 34

1. Disconnect the saw from power source
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife.
4. Pull the blade guard sway from the riving knife to expose the mounting assembly.
5. Loose the riving knife centre bolt, slide the riving knife away from the blade and slightly tighten. (Fig. 34)
6. Position the riving knife about 3mm or 1⁄8” away from the nearest carbide tooth on the main blade. (Fig. 35)
7. Tighten the centre bolt to secure the riving knife in position.
8. Move the blade guard back to its original position, and move the sliding table to centre.

Fig. 35

(3) Changing Scoring Blade

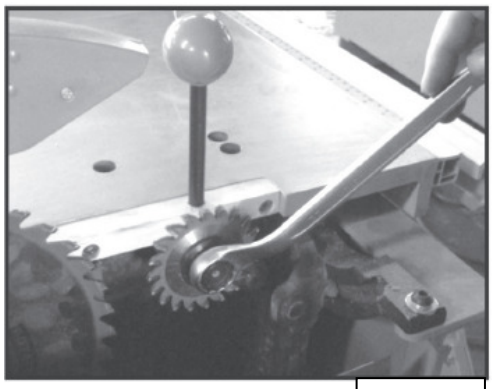


Fig. 36

1. Discount the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table), and raise the scoring blade all the way up.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blade and riving knife.
4. To remove the scoring blade set, use the stopper rod to fix the blade, use the arbour wrench to remove the arbour nut and arbour flange. (The arbour nut has right hand threads and loosens by turning counterclockwise.
5. Measure the main blade, and use the shims to stack the scoring blade set so the thickness matches the thickness of the main blade.
6. Install the blade set, re-install the arbour flange and the arbour nut, and tighten them against the blade set.
7. Move the orange blade guard back into its original position, next to the blades, and centre the sliding table.
8. Align the scoring blade set to the main blade.

(4) Rip Fence

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

The saw also with the capability of rip cutting smaller boards which is using the machine as a traditional table saw. (Fig. 37) Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.

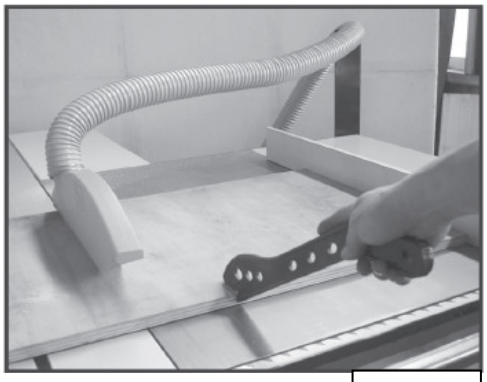


Fig. 37

Rip Cutting With The Sliding Table:

1. Install the crosscut fence in the center stud hole. (Fig. 38)
   Note: Drop the crosscut fence into the center stud hole and rotate it to the 90° stop.
   Check and make sure the fence is at 90° and adjust it.
2. Slide the protection block against the blade teeth to calibrate the scale, then tighten the lock knob, and make sure the scale will not be accurate if the protection block is cut.
3. Set a flip stop to the desired width-of-cut.
4. Place the blade guard to the correct height for your work-piece.
5. Load the work-piece onto the table saw.
6. Take all the necessary safety precautions, and then perform the cutting operation.

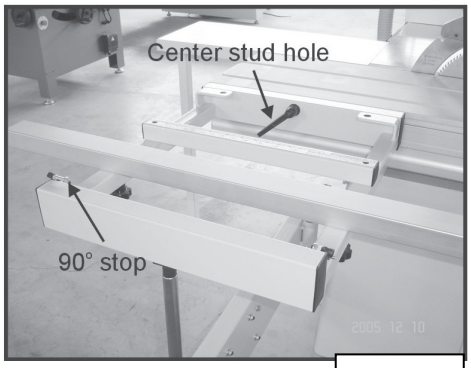


Fig. 38

Trading Table Saw Cutting

1. Place the fence in the vertical position (Fig. 40) for larger work-piece, or in the horizontal position (Fig. 41) for angled cuts
2. Slide the leading end of the rip fence so it is even with the center of the main saw blade.
   Note: This technique allows the finished cut-off piece to “fall” away from the blade when the cutting operation is complete, reducing the possibility of kickback.

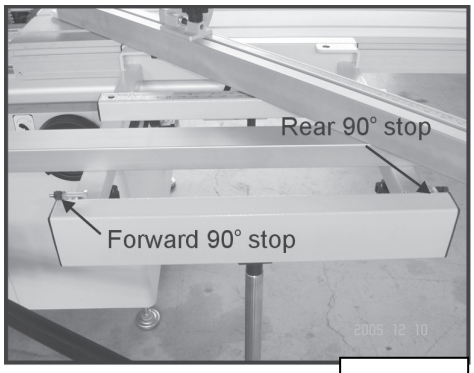


Fig. 39

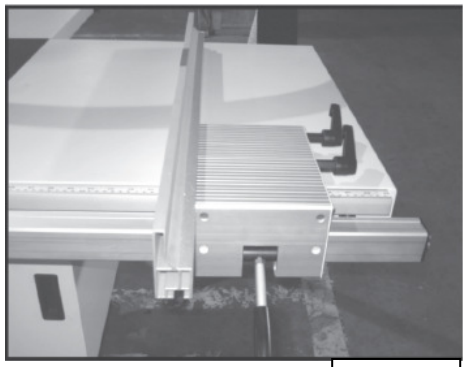


Fig. 40

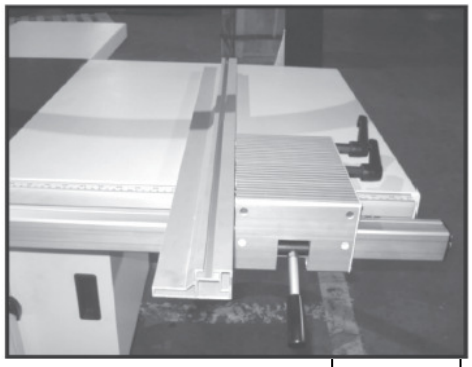


Fig. 41

(5) Crosscutting

This saw can crosscut full size panels with the fence in the forward or rear position, although it is easier to load full size panels with the crosscut fence mounted in the forward position.

Mounting the crosscut fence in the rear position gives greater stability for crosscutting

smaller panels. (Fig. 42)

Lately, this machine has capability of crosscutting work-piece while using the rip fence as a cut-off gauge. (Fig. 43)

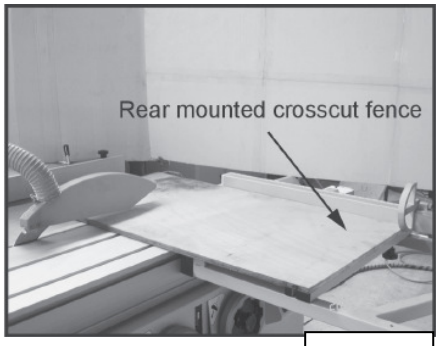


Fig. 42

Crosscutting full size panels

1. Install the crosscut fence to the forward 90° stop (Fig. 44) and lock it in place.
   Note: Drop the crosscut fence in the centre stud hole and rotate it to the 90° stop. Should make sure the fence is at 90° and adjust it. (Fig. 44)
2. Set either flip stop to the desired width-of-cut, if the work-piece is more than 120m/m, you must extend the crosscut fence slide.
3. Load the work-piece onto the table saw.
4. Once all the necessary safety precautions have been taken, perform the cutting operation.

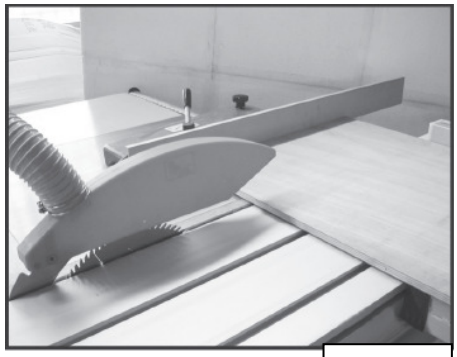


Fig. 43

Crosscutting using rip fence as a cut-off gauge:

1. Install the crosscut fence in the rear mounting points (Fig. 45) and lock it in place.
2. Position the rip fence for the desired width.
3. Load the work-piece onto the table saw.
4. Slide the leading end of the rip fence behind the back edge of the blade. (Fig. 45)
5. Take all the necessary safety precautions, and then perform the cutting operation.

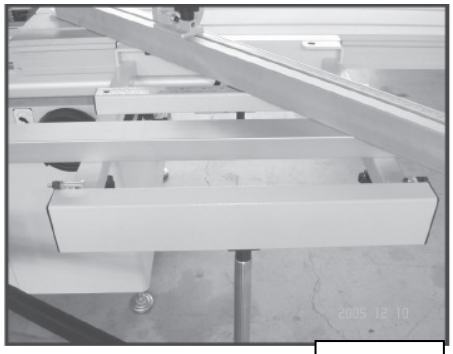


Fig. 44

(6) Miter Cutting

The miter fence allows miter cuts from 0° through 135°. The table mounted miter scale has a resolution of 1°.

1. Slide the crosscut table to the front edge of the sliding table and lock it in place.
2. Place the crosscut fence center stud in the center stud hole of the crosscut table. The fence can be installed for 90° to 135° cuts (Fig. 46), or 0° to 90° cut.
3. Rotate the fence to the desired angle and use lock knob to lock the fence in place.
4. Position the flip stop according to the length of the work-piece you want to cut off to the left of the blade.
5. Load the work-piece onto the table saw.

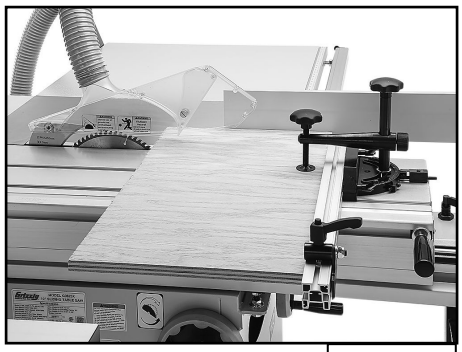


Fig. 45

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

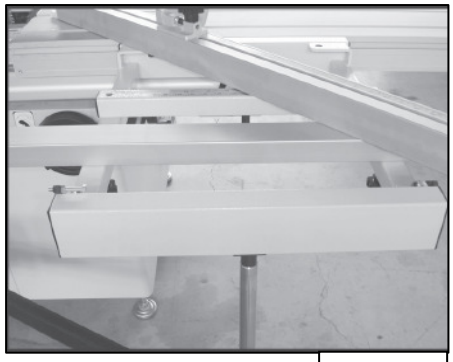


Fig. 46

(7) Lubrication

Lubrication the areas indicated below every 6-12 months, depending on frequency of use.

- Blade angling trunnion
- Sliding table track
- Scoring blade worm gear
- Blade height bearing
- Blade tilt worm gear
- Blade height linkage
- Blade height slide

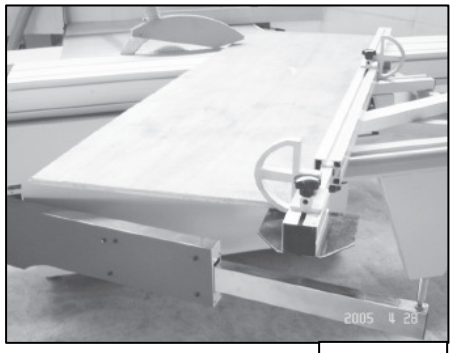


Fig. 47

Fig. 48

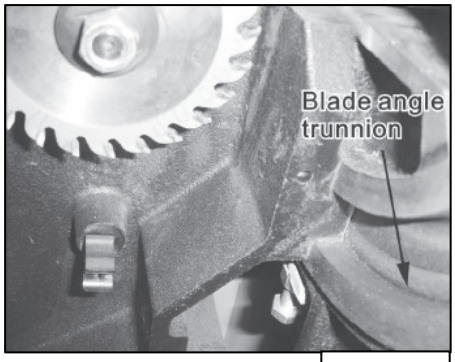


Fig. 49

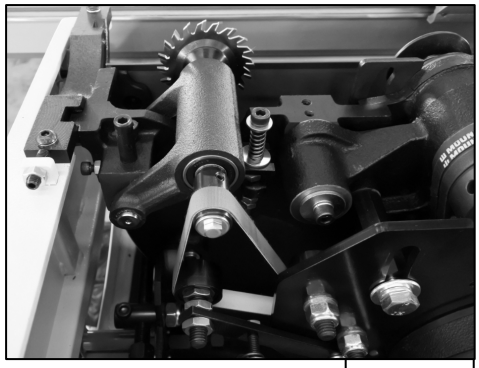


Fig. 50

(8) Replace Belts

1. Disconnect the saw from the power source.
2. Move the blade tilt to 45° and raise the main blade and scoring blade set up.
3. Open the motor cabinet door.
4. Loosen the three M12 bolt (Fig. 51)
5. Slowly upper the motor and then tighten the bolt. Pull off the old V-belts and replace them with new ones.
6. Ensure the motor pulley and arbor pulley are lined up.
7. Loosen the M12 bolt, and pivot the motor down.
8. Tighten the M12 bolt after adjusting suitable tension.
9. Close and secure the motor cabinet door.

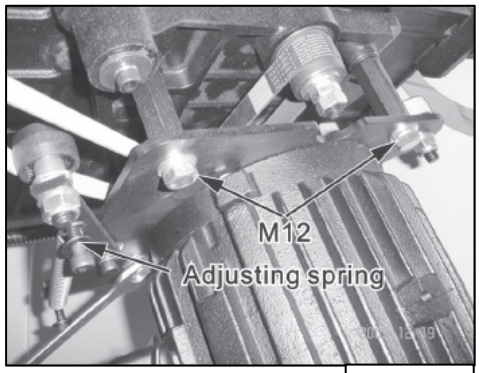


Fig. 51

To change flat belt for the scoring motor (Optional)

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade and scoring blade set up.
3. Open the motor cabinet door.
4. Push the scoring blade motor and remove the flat belt.
5. Place the flat belt on the scoring blade arbor, lift the scoring motor and slide the flat over the scoring motor pulley.
6. Close and secure the motor cabinet door.

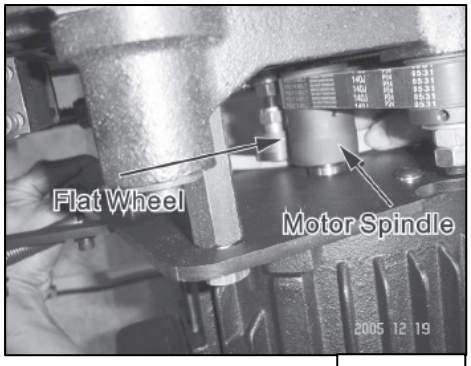


Fig. 52

(9) Blade Tilt

1. Disconnect the saw from the power source.
2. Move the blade tilt to 90° according to the gauge, and raise the main blade.
3. Place a machinist's square between the teeth on the blade and on the table surface and inspect for gaps between the blade and the square.
4. If a gap exists at either the top or bottom of the square, loosen the 90° tilt stop hex nut. (Fig. 53)
5. Turn the hand-wheel until the blade and square are flush from top to bottom.
6. Sung the adjustment hex nut against the underside of the table and tighten the lock nut and set screw.
7. Recheck the blade with the square to ensure the screw has not been over-tightened.
8. Adjust the blade angle until you hit the 45° positive stop hex nut. Check the bevel with and adjustable square set to 45° hex nut.
9. If variations exist, adjust the 45° tilt stop hex nut until the blade and square match. (Fig. 54)
10. Tighten the lock nut set screw and recheck the bevel by adjusting the blade back to 90° then back to 45°.

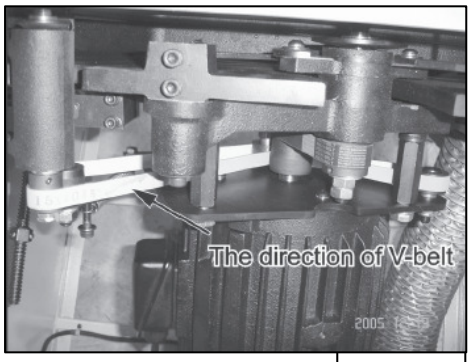


Fig. 53

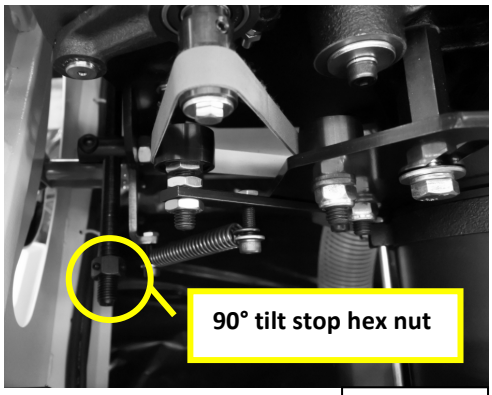


Fig. 54

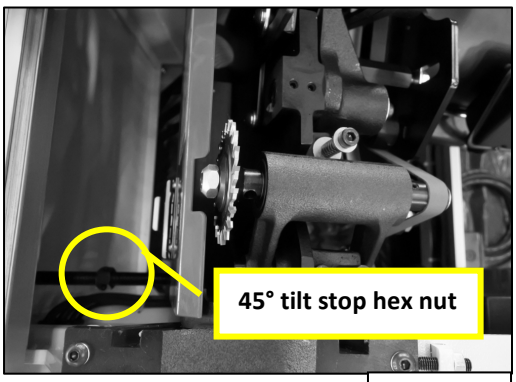


Fig. 55

(10) Sliding Table Parallel Adjustment

The table has been calibrated at the factory. If it changed during the transportation, please follow the instructions below and adjust it.

1. Disconnect the saw from the power resource.
2. Move the blade tilt to 0° (blade 90° to the table) and raise the main blade and scoring blade set up.
3. Mark the center of the blade with a felt tip pen, this will allow you to take your measurements from the exact same place on the blade.
4. Move the sliding table all the way to one end, and using a precision ruler, measure the gap between the edge of the table and you mark on the blade. (Fig. 56)
5. Move the other end of the sliding table in front of the blade and measure the gap.
6. Loosen the table mounting bolts.
7. Move the end of the sliding table that needs to be adjusted in front of the table.
8. Using the ruler, watch the gap measurement and have your assistant slowly make the adjustment to the parallelism adjustment bolts (Fig. 58) until the gap size is equal to the other side.
9. Repeat steps 7-8 until the gap between your mark on the blade and the edge of the sliding table is even at both ends.
10. Tighten the jam nuts on the parallel adjustment bolts to secure them in place.
11. Tighten the table mounting bolts and replace the access plates.

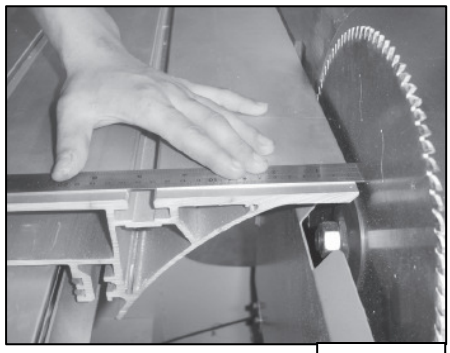


Fig. 56

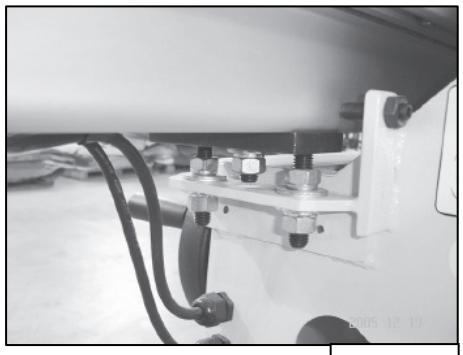


Fig. 57

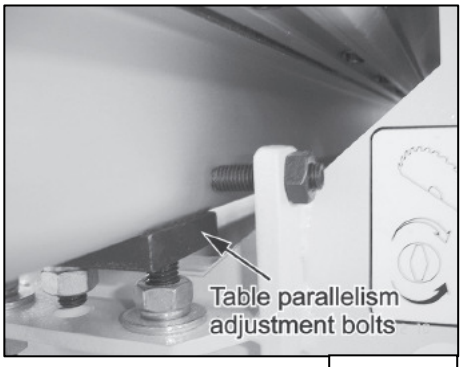


Fig. 58

(11) Squaring Crosscut Fence to Blade

1. Make sure the blade is parallel with the sliding table.
2. Prepare the scrap test piece by cutting it to 32” x 32” and number all four sides of the test piece.
3. Using the crosscut fence, cut 1/2” off of each side of the test piece.
4. Measure the testing work-piece diagonally from corner to corner.
   Note: If both measurements are not within 1/16” then the crosscut fence needs to be adjusted.
5. Loosen the hex nut and adjustment screw to square the crosscut fence.
6. Tighten the hex nut and repeat 3-6.

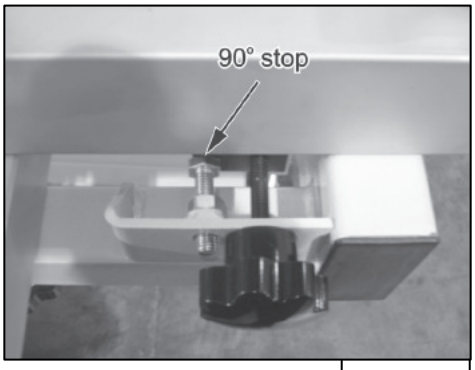


Fig. 59

(12) Troubleshooting

WARNING

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

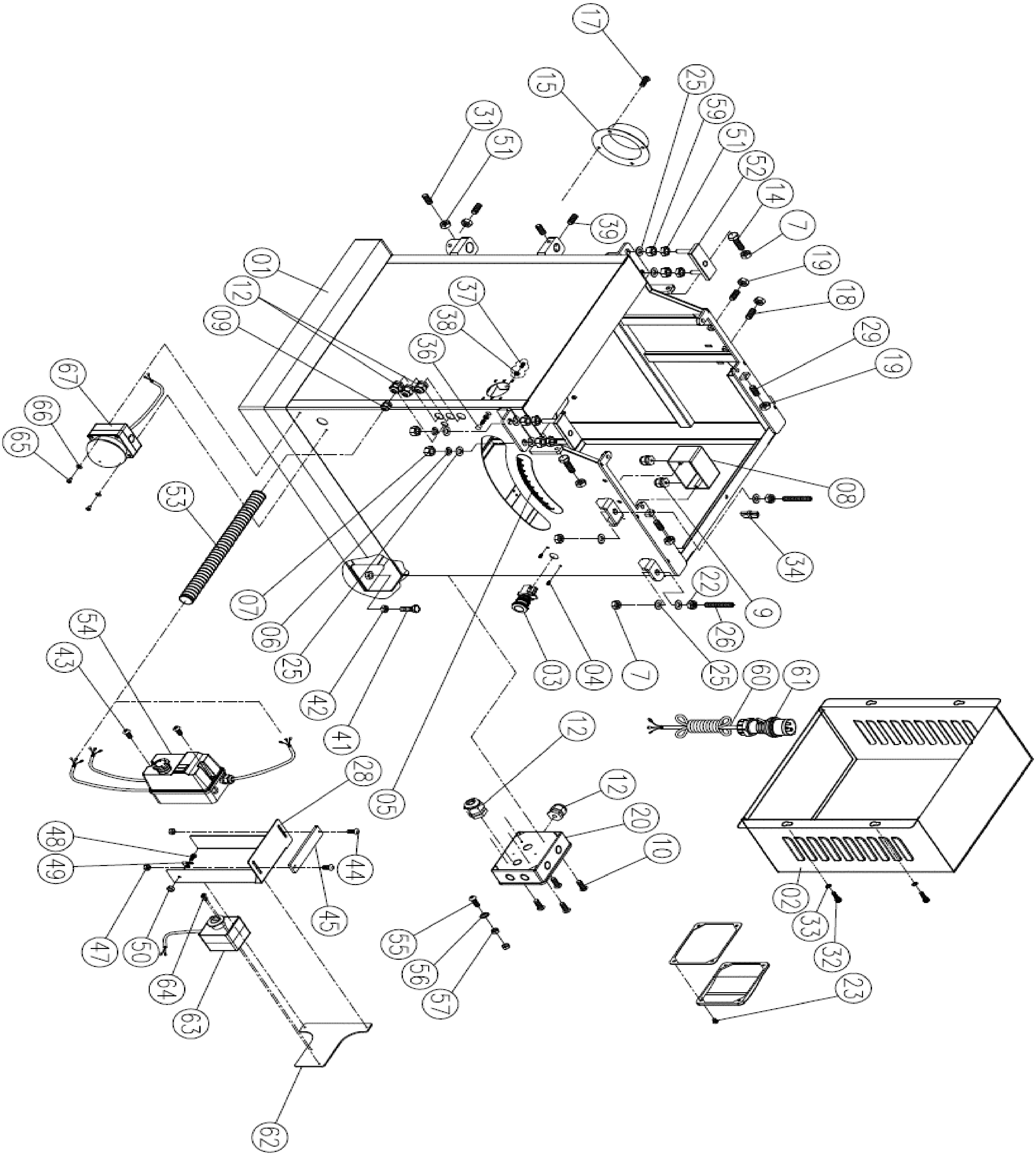
Saw does not start

1. Check the switch is being fully depressed.
2. Check the electrical power cord is plugged into the power outlet.
3. Check the electrical supply is on (rest).
4. With the power disconnected from the machine, check that the wiring in the plug is correct. Check that the rubber insulation is stripped enough and is not causing a bad connection. Check that all screws are tight.
5. With the machine power disconnected from the machine, check that the wiring to the machine is correct. Check that the rubber insulation is tripped enough and is not causing a bad connection. Check that all screws are tight.
6. Check that you have correct power.
7. Check that the ground wire is wired correctly.

Motor does not start

1. Emergency stop button is depressed.
2. Start capacitor is damaged.
3. Motor is damaged.
4. With the power disconnected from the machine, try to turn the blade by hand. If the blade does not turn around, check the reason for the jamming, typical reason is wood jamming the table.

If any trouble you cannot solve from above solutions, please contact your senior engineer or the agent you bought this machine from.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ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
0010	204325R	Machine Body		1	
0020	204225R	Door Cover		1	
0030	994808	Emergency Button Switch	R2PNR4-1B-R	1	
0040	ST059400	Tapping Screw	M5*0.8*16	2	
0050	LM204034	45 Degree Ruler		1	
0060	WS100000	Spring Washer	M10	4	
0070	NH101700	Nut	M10x1.5	10	
0080	605408	Switch Box		1	
0090	709409	Strain Relief		3	
0100	SP060210	Pan Head Screw	M6*1.0*10	4	
0110	NF061000	Hex. Flange Nut	M6	4	
0120	136013	Strain Relief	PG-13.5	5	
0140	SH100700	Hex. Head Screw	M10*1.5*35	2	
0150	412007	Inlet	φ4"	1	
0170	SP060210	Pan Head Screw	M6*1.0*10	4	
0180	SS080600	Set Screw	M8*1.25*30	4	
0190	NH081300	Nut	M8*13	6	
0200	201105A	Power Box		1	
0220	NL101700	Nylon Nut	M10*1.5	4	
0230	SP050400	Pan Head Screw (+)	M5*0.8*20	4	
0250	WF102730	Flat Washer	M10*27*3	16	
0260	SS101800	Set Screw	M10*1.5*90	4	
0280	207373R	Switch Bracket		1	
0290	SS080600	Set Screw		2	
0310	SS100500	Set Screw	M10*1.5*25	4	
0320	SJ089400	Pan Head Socket Screw	M8*1.25*16	4	
0330	WS080000	Spring Washer	M8	4	
0340	136019	Cord Connector	224-201	1	
0360	203230	Clip Plug	HP-16	1	
0370	204224	Fixed Screw	M12*1.75*35	2	
0380	NH121900	Nut	M12*1.75*10t	2	
0390	SS109400	Set Screw	M10*1.5*16	3	
0410	SH120900	Hex. Head Screw	M12*1.75*45	4	
0420	NH121900	Nut	M12*1.75*10t	4	
0430	SP049400	Pan Head Screw (+)	M4*0.7*16	2	
0440	SJ050500	Pan Head Socket Screw	M5*0.8*25	2	
0450	204210	Fixed Block		1	
0470	NF050800	Hex. Flange Nut	M5*0.8	2	
0480	SH059300	Hex. Head Screw	M5*0.8*12	1	
0490	998627	Wire Fixed Clamp	3/8	1	
0500	NH050800	Nut	M5*0.8	1	

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
0510	NH101704	Nut	M10x1.5x6T	8	
0520	204146	Adjustment Block	V1.2	2	
0530	204196	Hose		0.4	
0540	ABID130C1E-A	Magnetic Switch	2.25KW 1PH 50HZ	1	
0550	SF059300	Pan Head Screw(+)/W	M5*0.8*12	1	
0560	WS050000	Spring Washer	M5	1	
0570	NH050800	Nut	M5*0.8	2	
0590	NL101700	Nylon Nut	M10*1.5	4	
0600	IC204002	Power Cord	CE 1.5x3Cx4.33Mx6P	1	
0610	IC290009	CE Single-phase Plug		1	
0620	207374	Emergency Stop Fixied Plate		1	
0630	AB135109			1	
0640	SP049300	Pan Head Screw (+)	M4*0.7*12	2	
0650	SJ050200	Pan Head Socket Screw	M5*0.8*10	2	
0660	WF051210	Flat Washer	M5*φ12	2	
0670	AB994510A	Foot Switch Asm.		1	

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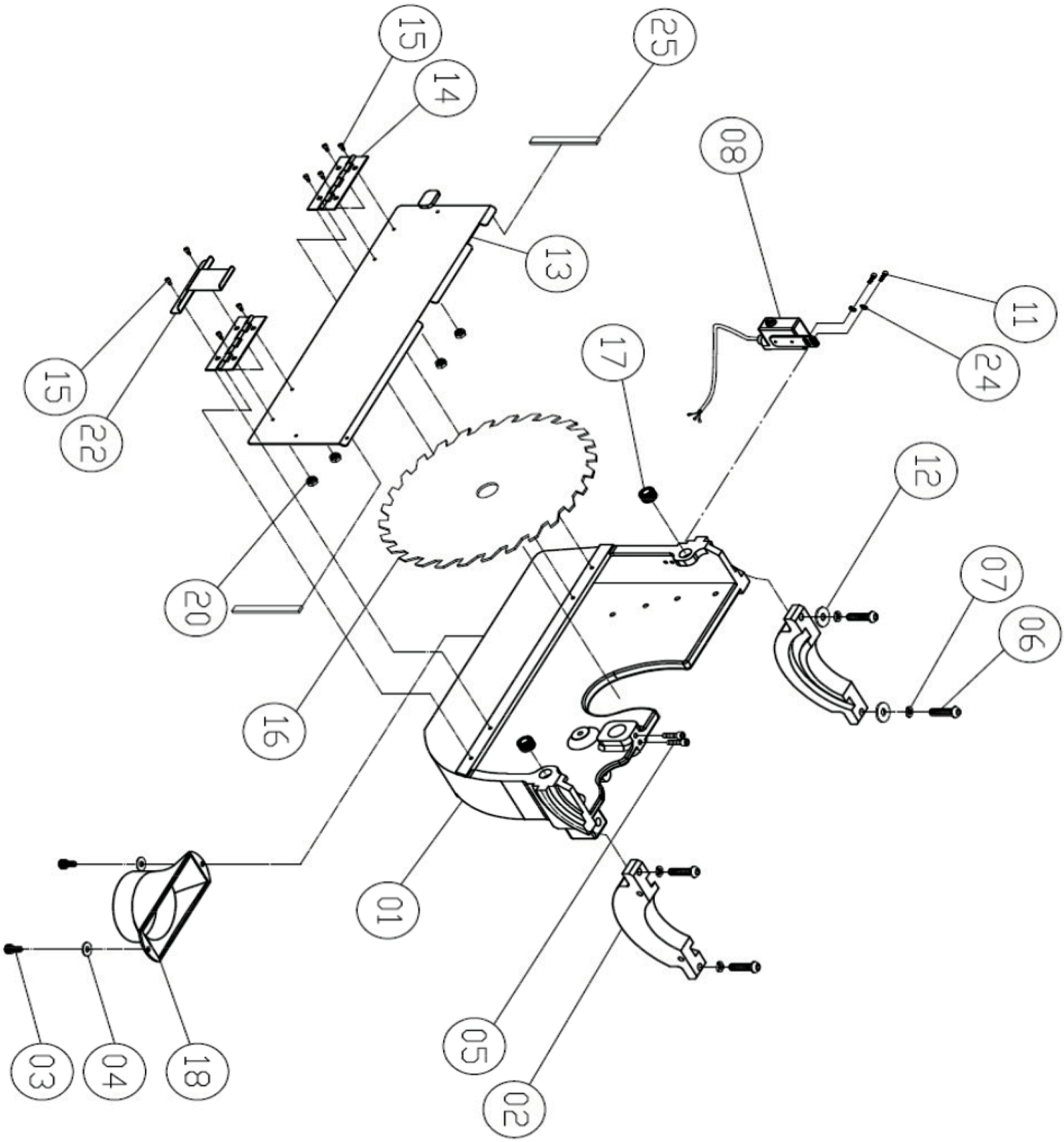

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	204060	Channel Base		1	
2	204033	Trunnion Bracket		2	
3	SR050400	Cap Screw	M5x8	2	
4	WF061310	Lock Washer	M6xψ13	2	
5	SR089300	Cap Screw	M8x12	2	
6	SJ060700	Button Head Screw	M8x35L	4	
7	WS080000	Lock Washer	M8	4	
8	AB204021A	SWITCH (ASM.)	Z15G1306+AA8000	1	CSA
11	SR050200	Cap Screw	M5x10L	2	
12	WF081818	Lock Washer	M8xψ18xt1.8mm	4	
13	204013	Cover Plate		1	
14	612030	Hinge		2	
15	SF059200	Pan Head Bolt	M5x8L	8	
16	204002	Saw Blade	250x2.6x5/8x40P	1	
17	AB203249	Magnetic Iron(assembly)		2	
18	204061	Dust port		1	
20	NF050800	Pan Head Nut	M5	4	
22	204256	Plate		1	
24	WF050810	Lock Washer	M5xψ8xt1.0mm	2	
25	150527	Pad		1	

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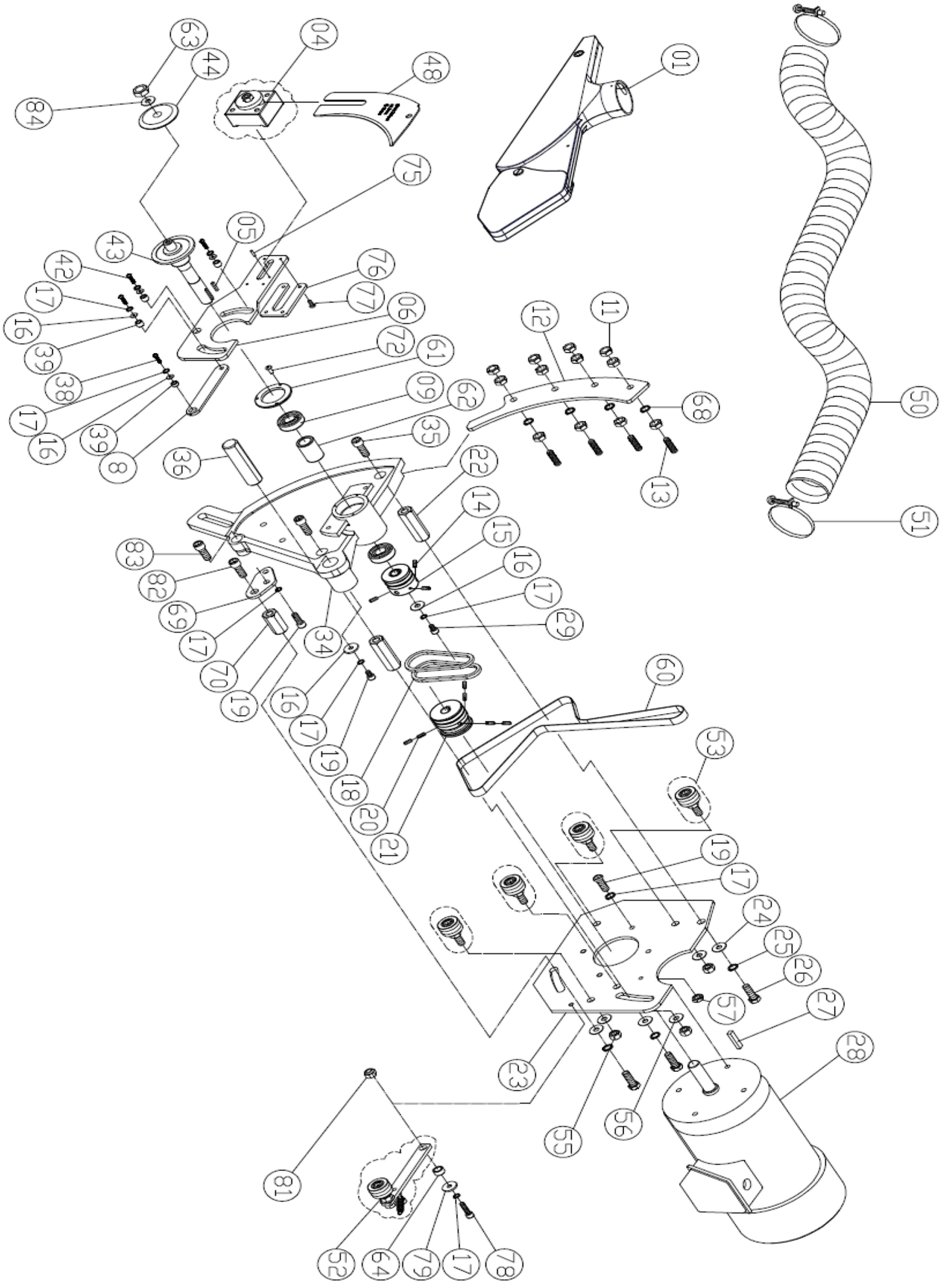
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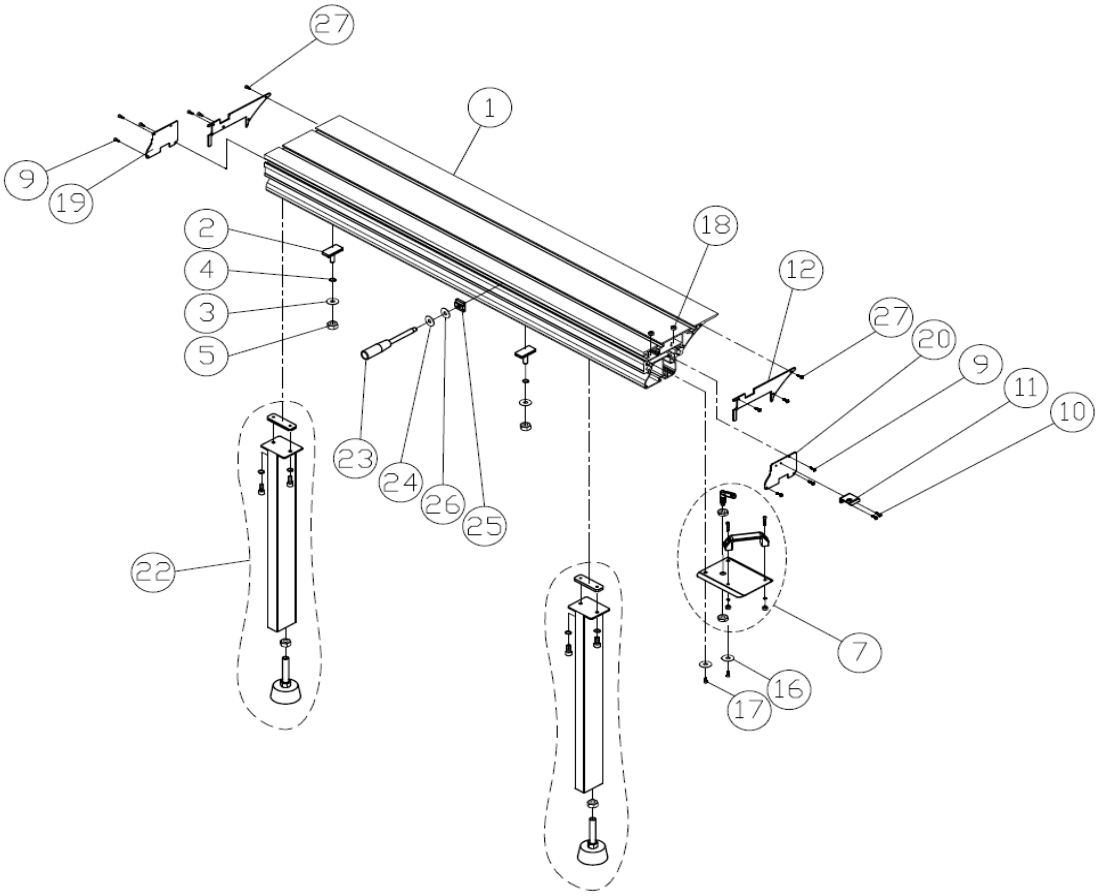
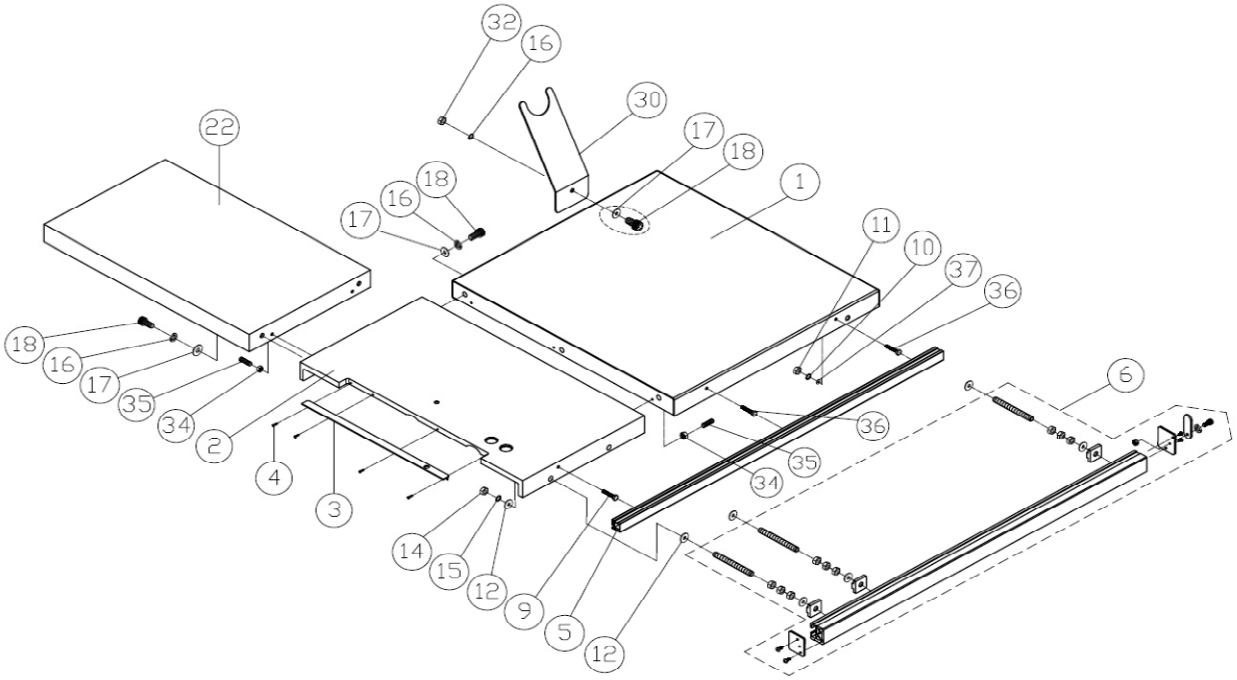
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
0010	AB205075	Hood Assembly		1	
0040	AB204020	Splitter Fixed Block Asm.	V1.1 SS-160MLB	1	
0050	KD050520	Parallel Key	5*5*20	1	
0060	204190	Fixed Block		1	
0080	204065	Connecting Block		1	
0090	BB600404	Ball Bearing	6004LLB	2	
0110	NH101700	Nut	M10x1.5	12	
0120	204029	Fixed Plate		1	
0130	SJ100900	Pan Head Socket Screw	M10*1.5*45	4	
0140	SS050200	Set Screw	M5*0.8*10	3	
0150	204283X2	Idle Pulley	60HZ	1	
0160	WF083030	Flat Washer	M8*φ30	2	
0170	WS080000	Spring Washer	M8	11	
0180	LM200000	V-belt (M)		2	
0190	SR080400	Hex. Socket Screw	M8*1.25*20	6	
0200	SS089400	Set Screw	M8*1.25*16	6	
0210	204285X2	Drive Pulley		1	
0220	201333	Spindle		2	
0230	204211	Motor Fixed Plate	V1.1	1	
0240	WF122430	Flat Washer	M12*φ24	3	
0250	WS120000	Spring Washer	M12	3	
0260	SH120600	Hex. Head Screw	M12*1.75*30	3	
0270	KS070730	Parallel Key	7*7*30	1	
0280	MH204005-1	Motor	SS-160G CE	1	
0290	SS069100	Set Screw	M6*1*6	2	
0340	YF204023A	Rotate Plate	SS-160G V1.2	1	
0350	SR120600	Hex. Socket Screw	M12*1.75*30	2	
0360	204129	Spindle		1	
0380	SJ080400	Pan Head Socket Screw	M8*1.25*20	3	
0390	204179	Bushing	V1.1 5.1~5.2mm	4	
0400	WF083030	Flat Washer	M8*φ30	4	
0420	SJ089400	Pan Head Socket Screw	M8*1.25*16	1	
0430	204053	Main Spndle		1	S
0440	204004	Flange	CE	1	S
0480	204308	Splitter	SS-100G	1	
0500	HS330009	Hose	φ3"x0.95M	1	
0510	204158	Hose Clamp	3-1/4"	2	
0520	AB204251	Idle Pulley (With Rotate Plate)	V1.2 SS-160MLB	1	
0530	AB204251-1	Idle Wheel Asm.	V1.2 SS-160MLB	4	
0550	NL121900	Nylon Nut	M12*1.75	3	
0560	WF122620	Flat Washer	M12*φ26*2.0	3	

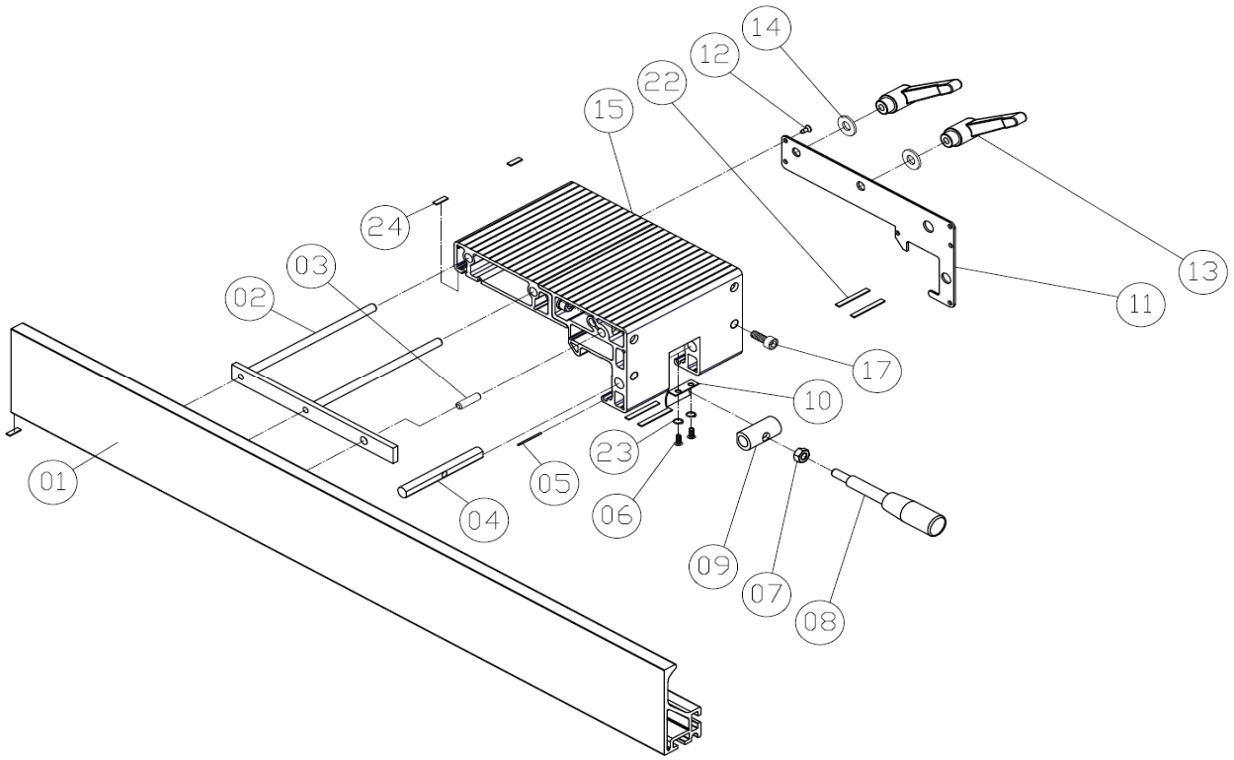
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
0570	NH121904	Nut	M12*1.75*6t	1	
0600	LF450000	Flat Belt	15x1140	1	
0610	204118	Cover Pate		1	
0620	204148	Bushing		1	
0630	NH121910	Nut	M12*1.75(L,H)	1	
0640	200964	Bushing		1	
0680	WS100000	Spring Washer	M10	4	
0690	204248	Fixed Plate		1	
0700	204249	Spindle		1	
0720	SJ059300	Pan Head Socket Screw	M5*0.8*12	3	
0750	PS041000	Spring Pin	φ4*10	1	
0760	204164	Fixed Plate		1	
0770	SJ059200	Pan Head Socket Screw	M5*0.8*8	4	
0780	SR080500	Hex. Socket Screw	M8*1.25*25	1	
0790	WF081818	Flat Washer	M8*φ18*t1.8	1	
0810	NL081300	Nylon Nut	M8*1.25	1	
0820	SR120500	Hex. Socket Screw	M12*1.75*25	1	
0830	SR121900	Hex. Socket Screw	M12*1.75*95	1	
0840	WF122325	Flat Washer	M12*φ23	1	



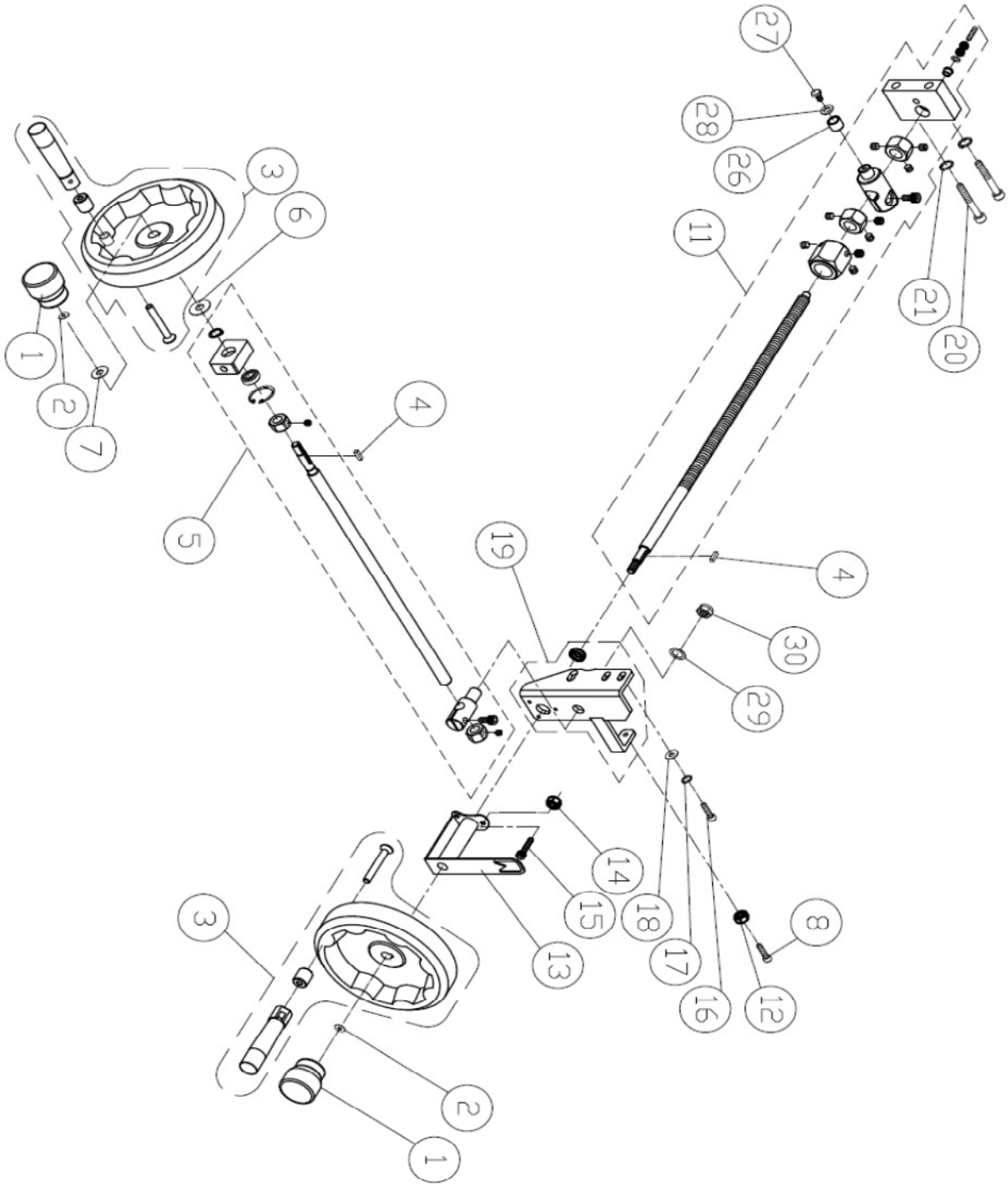
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	2316160S	Sliding Table Set	316x1600mm	1	
2	204242	Cap Screw	M12x35L	2	H
3	WF122430	Washer	M12xψ24xt3	2	H
4	WS120000	Lock Washer	M12	2	H
5	NH121900	Hex Nut	M12xP1.75	2	H
7	AB206528	PUSH-PULL HANDLE ASM.	S sliding table	1	A,H
9	SJ069300	Button Head Screw	M6x12L	2	
10	ST047008	Tap Screw	M4x8	6	
11	206536	Locate Plate		1	H
12	206530	Locate Plate		2	
16	WF061320	Washer	M6xψ13xt2	2	H
17	SJ069400	Button Head Screw	M6x16L	2	H
18	SF061000	Hex Nut	M6	2	H
19	206529	Locate Plate		1	
20	206535	Locate Plate		1	
22	AB204147	Sliding Table Support (ASM.)		2	A,R4
23	204244	Handle		1	H
24	WF123030	Washer	M12xψ30xt3	1	H
25	201855	T-Nut	M12xP1.75	1	H
26	992496	Plastic Washer	ψ13xψ25xt2	1	H
27	SJ050200	Button Head Screw	M5x10L	6	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	204028	Right Ext.Plate		1	
2	204141	Table		1	
3	204321	Table Insert		1	
4	SJ059300	Button Head Screw	M5x12L	4	
5	201161	Right Support Plate		1	
6	AB201506	Fixed Seat (ASM.)		1	
9	SH060500	Hex Head Bolt	M6x25L	1	H
10	WS060000	Lock Washer	M6	3	H
11	NH061000	Hex Nut	M6	3	H
12	WF122130	Flat Washer	M12xψ20	6	
14	WS120000	Spring Washer	M12	3	
15	NH121900	Hex Nut	M12	3	
16	WS100000	Spring Washer	M10	6	H
17	WF102025	Flat Washer	M10xψ20	6	H
18	SR100500	Hex Socket Bolt	M10x25L	6	H
22	204049	Rear Ext.Plate		1	
30	204232	Dust hose support		1	H1
32	NL101700	Nylon Nut	M10	1	H
34	NH081300	Hex Nut	M8	5	H
35	SS080500	Set Screw	M8x25L	5	H
36	SH069400	Hex Head Bolt	M6x16l	2	H
37	WF061310	Flat Washer	M6xψ13	3	H

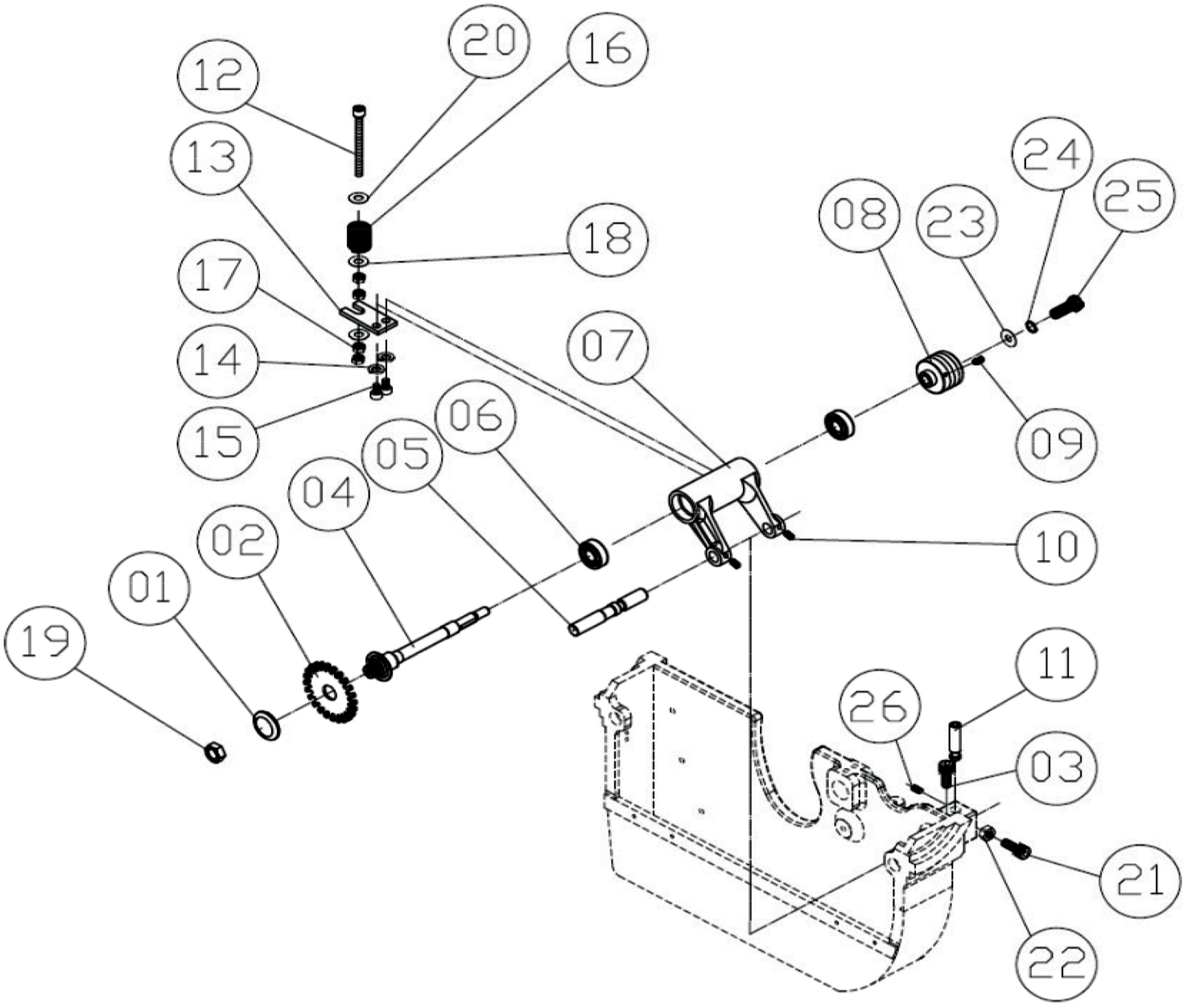


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	204282	Fence Plate		1	R
2~23	AB204016	Rear Fence (ASM.)		1	
2	204288	Clamp Plate		1	
3	PS083000	Spring Pin	ψ8x30L	1	
4	204075	Rod		1	
5	201479	Strip		4	
6	SP050200	Pan Head Screw	M5x10L	2	
7	NH081300	Hex Nut	M8xP1.25	1	R
8	204152	Handle		1	R
9	204076	Sleeve		1	
10	204074	Spring Piece		1	
11	204051	Cover Plate		1	
12	ST049200	Tap Screw	M4x8	6	
13	204278	Quick Release	M8	2	
14	WF081818	Washer	M8xψ18xt1.8	2	
15	YFAC204016	Rear Fence Housing		1	
17	990312	Screw-Plastic	M5x16L	2	
22	204101	Strip	50x5mm	6	
23	WE050000	Star Washer	M5	2	
24	136470	Strip		3	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	204220	Adjust Handle		2	
2	204263	Disc washer		2	
3	AB204176	Handwheel ASM.	ψ12	2	A
4	KD050520	Key	5x5x20	2	
5	AB204192	Tilt Adjuster ASM.		1	A
6	WF133025	Flat Washer	ψ13xψ30xt2.5	1	

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
7	WF104030	Flat Washer	M10xψ40xt3.0	1	
8	SR080500	Cap Screw	M8x25L	1	
11	AB201221	Raising Mechanism ASM.		1	A
12	NH081304	NUT	M8x1.25x4t	1	
13	204030	Point		1	
14	NH061000	NUT	M6	3	
15	SR069400	Cap Screw	M6x16L	3	
16	SR080400	Cap Screw	M8x20L	3	
17	WS080000	Spring Washer	M8	3	
18	WF081818	Flat Washer	M8xψ18xt1.8	3	
19	AB204185	Supporting Bracket ASM.		1	A
20	SR081003	Cap Screw	M8x50L	2	
21	WS080000	Lock Washer	M8	2	
26	204245	BUSHING		1	
27	SH060200	Hex Head Bolt	M6x10L	1	
28	WF072414	Washer	ψ7xψ24xt1.4	1	
29	201500	Copper Washer	ψ16.6xψ23.5x0.2t	1	
30	NL162400	Nylon Nut	M16	1	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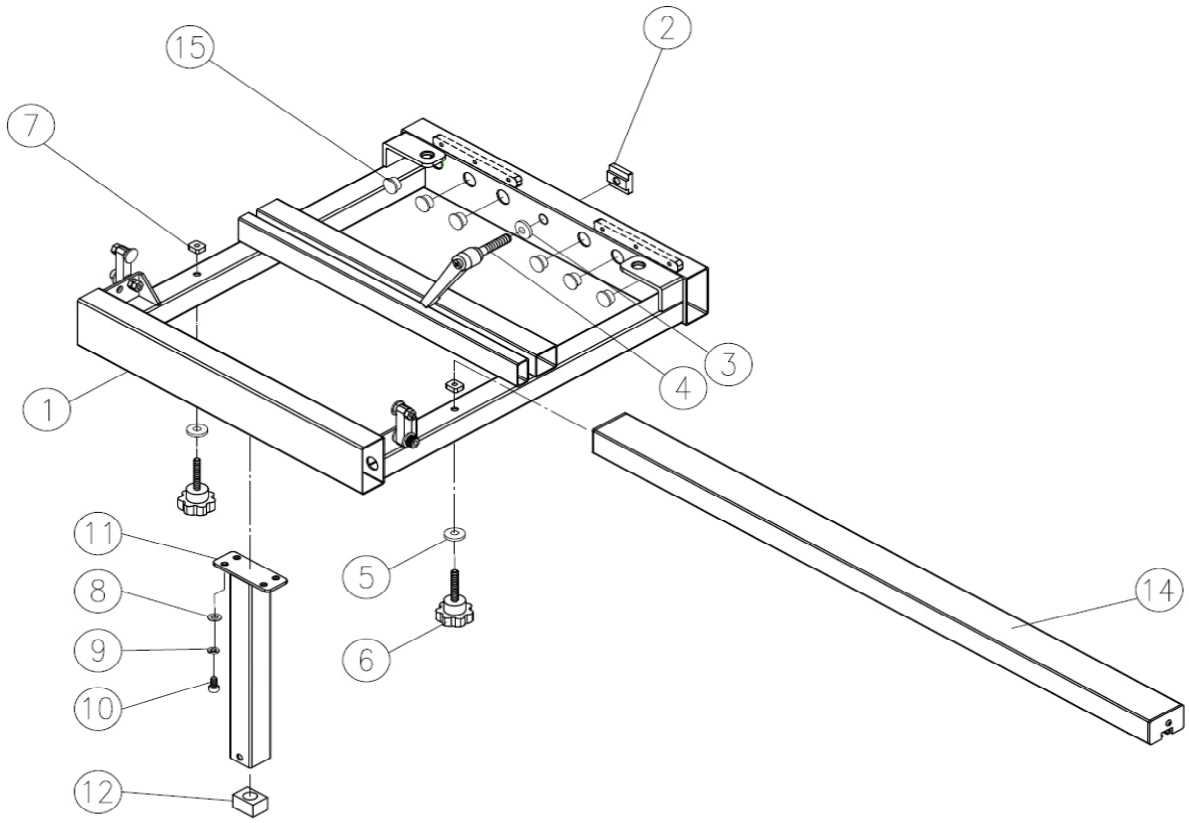
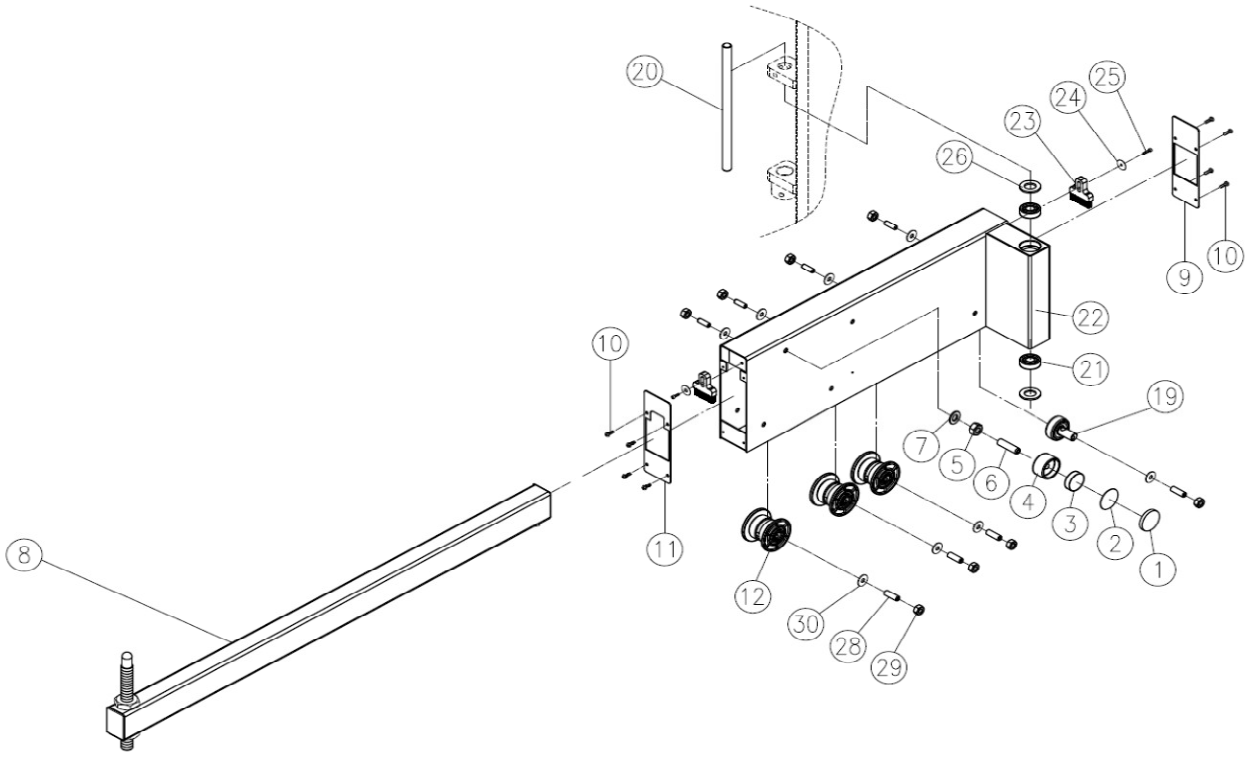
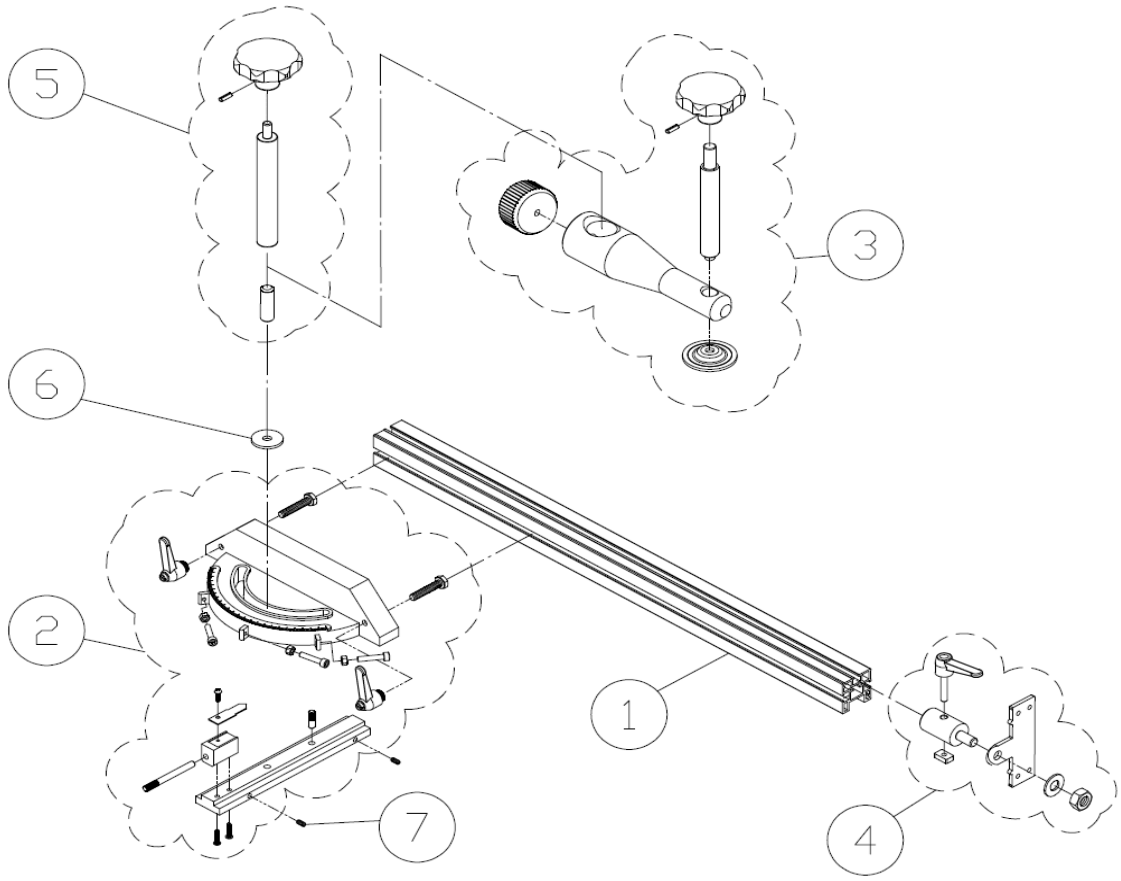
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	204175	Arbor Flange		1	
2	204057	Scoring Saw Blade	CE(ψ20)	1	
3	SR080500	Cap Screw	M8x25L	2	
4	204078	Shaft	CE(ψ20)	1	
5	204003	Shaft		1	
6	BB620204	Bearing	6202LLB (black)	2	
7	204063	Regulator		1	
8	201833	Scoring Pully	50HZ	1	
9	SS069100	Setscrew	M6x6L	2	
10	SS069100	Setscrew	M6x6L	2	
11	204064	Adjust Shaft		1	
12	SR082000	Cap Screw	M8x1.25Px100L	1	
13	204019	Plate		1	
14	WS080000	Lock Washer	M8	2	
15	SR080500	Cap Screw	M8x25L	2	
16	204156	Lock		1	
17	NH081300	Hex NUT	M8	4	
18	WF082320	Washer	M8xψ23xt2	2	
19	204260	Hex Nut	M12	1	
20	WF081818	Washer	M8xψ18xt2	1	
21	SR060500	Cap Screw	M6x25L	1	
22	NH061000	Hex Nut	M6	1	
23	WF063030	Washer	M6xψ30xt3	1	
24	WS060000	Lock Washer	M6	1	
25	SH069402	Hex Head Bolt	M6x16L(L.H)	1	
26	SS069200	Setscrew	M6x8L	1	



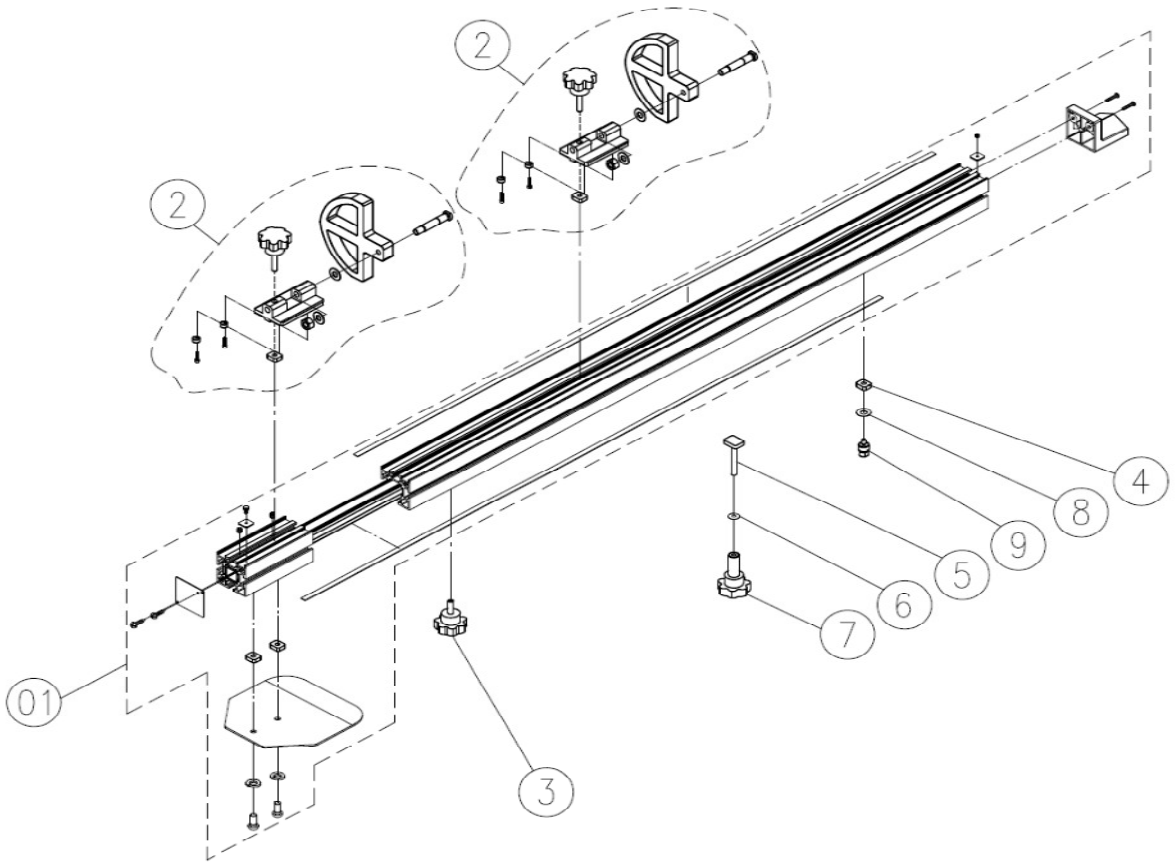
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	AB201951G	EXTENSION FRAME		1	A
2	201855	T-NUT	M12xP1.75	1	H
3	WF123030	WASHER	M12xψ30xt3	1	H
4	200815	ADJUST HANDLE	M12xP1.75x55L	1	H
5	WF083030	WASHER	M8xψ30xt3mm	2	H
6	200954	KNOW SCREW	M8x50L	2	H
7	201103	T-NUT	M8xP1.25	2	H
8	WF061620	WASHER	M6	4	H
9	WS060000	LOCK WASHER	M6	4	H
10	SR069400	HEX SOCKET BOLT	M6x16L	4	H
11	204169	SUPPORT STRUT		1	
12	203094	PLUG		1	
14	AB208181	SQUARE BRACE ASM.		1	A,R1
15	201458	PLUG		6	



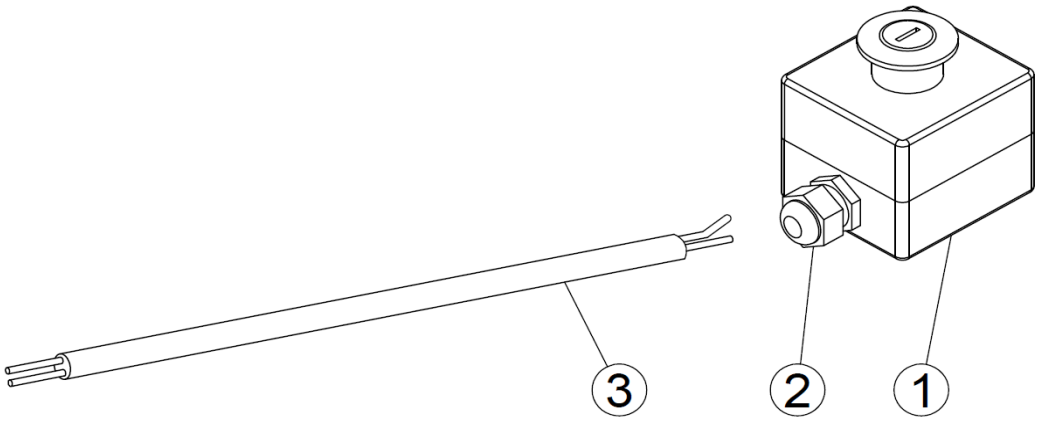
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	204280	Foam Rubber	ψ28	1	
2	204281	Paster	ψ28	1	
3	200934-2	Magnetic		1	
4	204279	Magnetic Iron		1	
5	NH081300	Hex Nut	M8	1	
6	SS080700	Setscrew	M8x35L	1	
7	WF082320	Washer	M8xψ23xt2	1	
8	AB204241	SLIDING TUBE ASM.		1	A
9	204239	Cover		1	
10	SP049100	Pan Head Screw	M4x6L	8	
11	204240	Cover		1	
12	AB203348	ROLL ASM.		3	A
19	AB203356	ROLL ASM.		1	A
20	204135	Setscrew		1	
21	BB620202	Bearing	6202ZZ	2	
22	204323	Swing Arm		1	
23	135051	Brush		2	
24	WF061310	Washer	M6xψ13xt1	2	
25	SR060400	Cap Screw	M6x20L	2	
26	WF173030	Washer	ψ17xψ30xt3	2	
28	SS080600	Setscrew	M8x30L	8	
29	NH081300	Hex Nut	M8	8	
30	WF081818	Washer	M8x18	8	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	017210	Square Fence		1	
2	AC204295	Miter Gauge Body		1	A
3	AB204201	Holding-Down Clamp		1	A
4	AB017219	Location Stop Asm.		1	A
5	AB204106A	Rotary Shaft		1	A
6	WF102825	Flat Washer	M10xψ28xt2.5	1	
7	201632	Spring plungers with ball	M4x9	2	

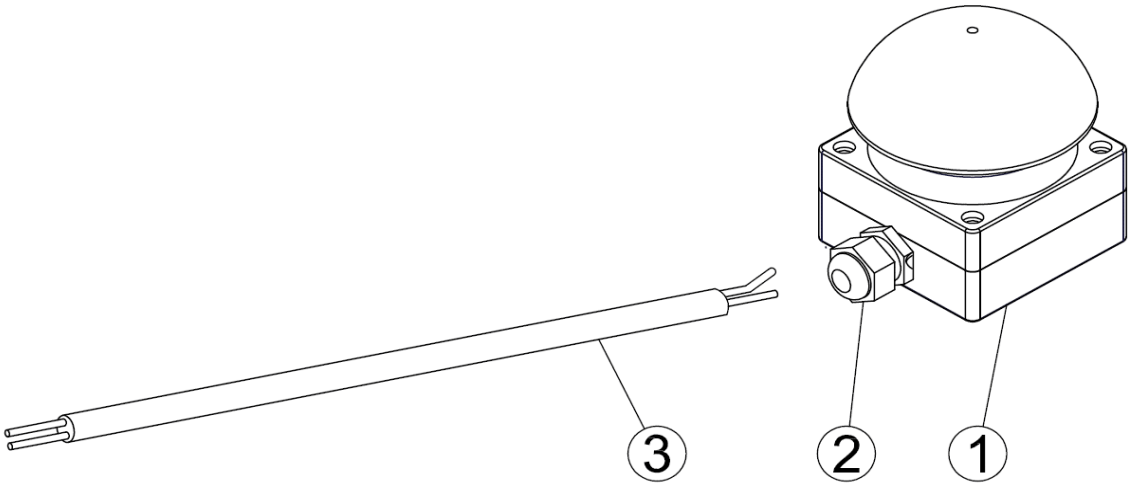


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	AB204310	Ext. Fence Asm.		1	A,R1
2	AB200823	Flip Stop		2	A,R2
3	201886	Knob Screw	M8x1.25px25L	1	H
4	201103	T-Nut	M8x1.25p	2	H
5	200953	T-Bolt	M8×1.25p×60L	1	H
6	WF083030	Washer	M8x30	1	H
7	200952	Knob Screw	M8×55	1	H
8	WF102015	Washer	M10x20x1.5T	1	H
9	200832	Rotate Shaft		1	H



AB135109

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	135109	EM Stop Switch		1	
2	136013	Outlet Beads	PG-13.5	1	
3	IC204005	control code	0.75mm²x2Cx2.1Mx3Y1	1	



AB994510A

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	994510A	Door Safety Switch	NFP-B02R	1	
2	709409	Outlet Beads	PG-9	1	
3	IC200812	control code	0.75mm²x2Cx1.5Mx2Y2	1	

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The packaging is suitable for recycling.
Please dispose of it in a responsible manner.

EU Countries Only

Do not dispose of electric tools together with household waste material.
By law they must be collected and recycled separately.

Axminster Tools, Axminster Devon EX13 5PH
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