

Круглопильные станки JIB MJ10-1300, JIB MJ10-1600. Руководство по эксплуатации.

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For Your Own Safety, Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WHICH** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

This symbol is used to alert the user to useful information about proper operation of the equipment.

Safety Instructions for Power Tools

- 1. KEEP GUARDS IN PLACE** and in working order.
- 2. REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
- 3. KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 4. DO NOT USE IN DANGEROUS ENVIRONMENT. DO NOT** use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
- 5. KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
- 6. MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
- 7. DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
- 8. USE RIGHT TOOL. DO NOT** force tool or attachment to do a job for which it was not designed.
- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with amperage rating. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire. Always repair or replace extension cords if they become damaged.
- 10. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are **NOT** safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
- 13. DO NOT OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. USE RECOMMENDED ACCESSORIES. Consult the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. REDUCE THE RISK OF UNINTENTIONAL STARTING. On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. MANY WOODWORKING TOOLS CAN "KICKBACK" THE WORKPIECE toward the operator if not handled properly. Know what conditions can create "kickback" and know how to avoid them. Read the manual accompanying the machine thoroughly.

18. CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

19. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. DO NOT leave tool until it comes to a complete stop.

20. NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL. Full mental alertness is required at all times when running a machine.

21. NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE. Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

Additional Safety Instructions for Panel Saws

1. SAFETY ACCESSORIES. Always use the blade guard and riving knife on all "through-sawing" operations.

Through-sawing operations are those when the blade cuts completely through the work-piece.

2. KICKBACK. Be familiar with kickback. Kickback happens when the work-piece is thrown towards the operator at a high rate of speed. Until you have a clear understanding of kickback and how it occurs, DO NOT operate this table saw!

3. WORKPIECE CONTROL. Make sure the work-piece is placed in a stable position on the table and is either supported by the rip fence or the crosscut table during cutting operations.

4. PUSH STICK. Always use a push stick when ripping narrow stock.

5. OPERATOR POSITION. Never stand or have any part of your body directly in-line with the cutting path of the saw blade.

6. REACHING OVER SAW BLADE. Never reach behind or over the blade with either hand while the saw is running. If kickback occurs while reaching over the blade, hands or arms could be pulled into the spinning saw blade.

7. USING THE RIP FENCE AND THE CROSSCUT FENCE TOGETHER DURING A CUTTING OPERATION. When using the crosscut fence, the work-piece should never be contacting the rip fence while the saw blade is cutting.

8. STALLED BLADE. Turn the saw off before attempting to "free" a stalled saw blade.

9. COMFORTABLE CUTTING OPERATIONS. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the spinning saw blade.

10. EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact your agent.

11. BLADE HEIGHT. Always adjust the blade to the proper height above the work-piece.

12. DAMAGED SAW BLADES. Never use blades that have been dropped or otherwise damaged.

13. RIVING KNIFE ALIGNMENT. Only operate the saw if the riving knife is aligned with the main blade.

Like all machines there is danger associated with this Sliding Panel Saw. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

 **Caution!**

No list of safety guidelines can be complete.

Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect.

Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

 **Warning!**

Statistics prove that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward its operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Preventing Kickback

Never attempt freehand cuts. If the work-piece is not fed perfectly parallel with the blade, a kickback will likely occur. Always use the rip fence or crosscut fence to support the work-piece.

Make sure the riving knife is always aligned with the blade. A misaligned riving knife can cause the work-piece to bind or stop the flow of the cut, resulting in an increased chance of kickback. If you think that your riving knife is not aligned with the blade, check it immediately!

Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table.

Use the riving knife during every cut. The riving knife helps maintain the kerf in the work-piece after it is cut, therefore, reducing the chance of kickback.

Feed cuts through to completion. Anytime you stop feeding a work-piece that is in the middle of a cut, the chance of binding, resulting in kickback, is greatly increased.

Protecting Yourself from Kickback

Even if you know how to prevent kickback, it may still happen. Here are some tips to reduce the likelihood of injury if kickback DOES occur.

Stand to the side of the blade during every cut. If a kickback does occur, the thrown Work-piece usually travels directly in front of the blade.

Always wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.

Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade.

Use a push stick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.

SITE CONSIDERATIONS

General Condition

1. Electrical connection: Steady state voltage: 0.9-1.1 of nominal voltage. Frequency: 0.99-1.01 of nominal frequency continuously; 0.98-1.02 short time The mains connection must have maximum 16A fuse. Electrical supply which has protection devices of under-voltage, over-voltage, over-current as well as a residual current device (RCD) which maximum residual current rated at 0.03A.

2. Altitude are not exceeding 1000m, Maximum ambient air temperature is +40 °C, minimum ambient air temperature is not less than +5°C, storage and transportation temperature range is -25 °C~+55 °C. The relative humidity does not

exceed 50% at a maximum temperature of +40 °C, higher relative humidity may be permitted at lower temperature (e.g. 90% @ 20 °C).

Floor Load

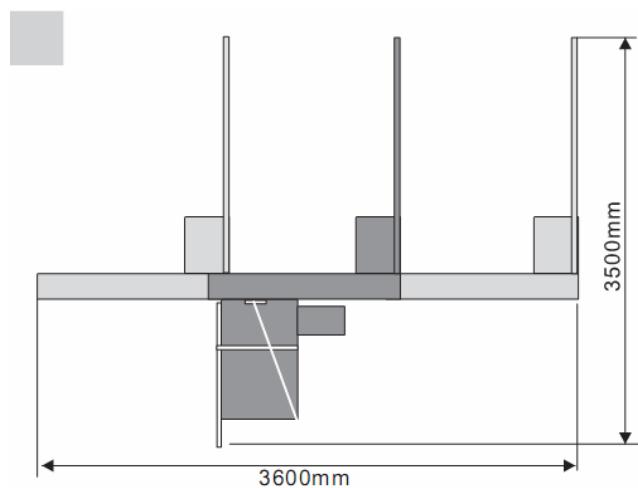
This machine represents a moderately large weight load in a small footprint. Most commercial shop floors will be adequate for the weight of the machine. Some floors may require additional support. Contact an architect or structural engineer if you have any question about the ability of your floor to handle the weight.

To ensure sufficient upright stability of the machine it should be bolted to floor. For this purpose 4 holes are provided in the machine's bracket of workstand.

Working Clearances

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See above figure for the maximum working clearances of the Sliding Panel Saw.



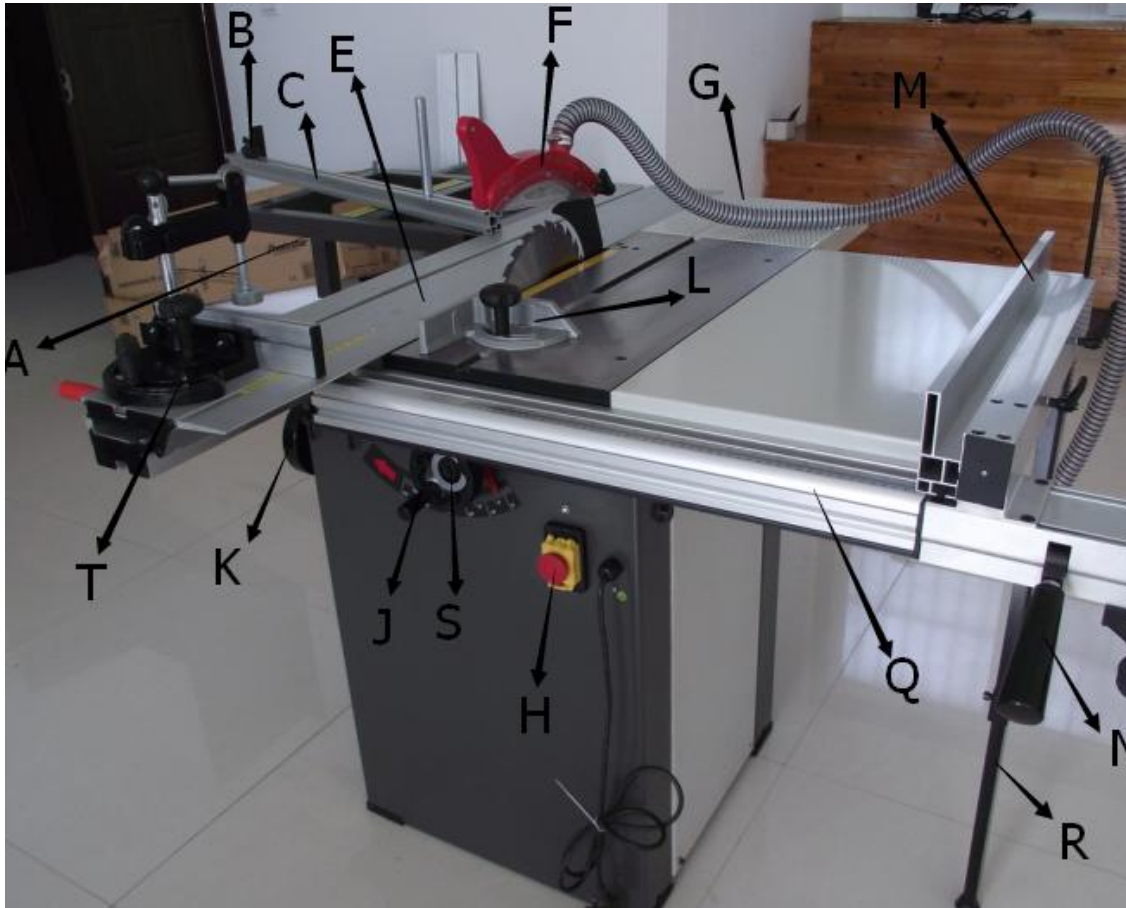
Lighting and Outlets

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets, or circuits.

Dust Collector

As a rule, this machine must be vacuumed during use. A time relayed socket is available as an accessory. In addition, the vacuum performance must be sufficient to achieve the required negative pressures and a maximum air speed of 20m/sec at the connector.

Read the manual before assembly and operation. Become familiar with the machine and it's operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.



A. Crosscut Table-Provides a wide, stable platform for supporting full-size panels during crosscutting operations.

B. Flip Stops-Used for quick measurements for crosscutting.

C. Crosscut Fence-Used during crosscutting operations. Features a scale and multiple flip-style stopblocks for precise, repeatable crosscutting operations.

E. Sliding Panel-Conveniently glides the work-piece through the blade with effortless precision and ease.

F. Blade Guard-Fully-adjustable blade guard allows high visibility of the cutting operation while maintaining maximum protection around the saw blade.

G. Rear extension table

H. Power Switch-Start/stops the machine and has emergency stop function.

J. Blade Elevation Hand-wheel-Adjust the height of the main saw blade.

K. Blade Angle Hand-wheel-Adjust the angle of the saw blades.

L. Mitre Gauge-This gauge aligns the wood for a cross-cut.

M. Rip Fence-Fully adjustable with fine adjustments. Fence face can be positioned for standard cutting operations, or in the lower position for blade guard clearance during narrow ripping operations.

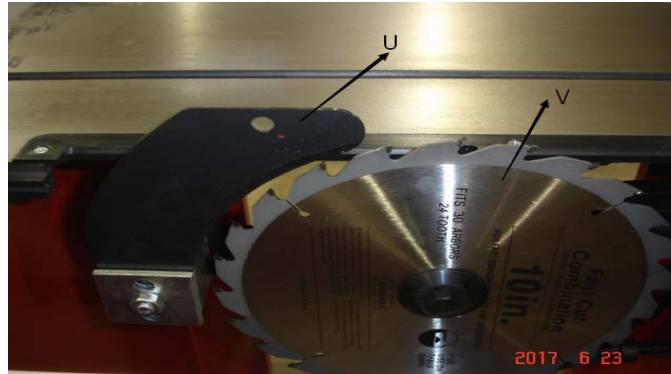
N. Fence Assembly Lock Down lever-Secures the fence assembly into position along the fence rail.

Q. Rip Fence Rail-Provides the support for rip fence.

R. Support Leg-Provides the support for the extension table.

S. Main Blade Angle Lock Knob-Secures the angle of main blade.

T. Hold Down w/Mitre Gauge-Holds the work-piece for sliding or mitre cutting.



U. Riving Knife-Maintains kerf during cutting operations. This function is crucial to preventing kickback caused by the kerf closing behind the blade.

V. Main Blade-Performs the cutting operations.

UNPACKING

The Sliding Panel Saw is shipped from the manufacturer in a carefully packed crate. If you discover the machine is damaged after you have signed for delivery, please call Customer Service immediately for advice. When you are completely satisfied with the condition of your shipment, you should inventory its parts.

The Sliding Panel Saw is a heavy machine. **DO NOT** over-exert yourself while unpacking or moving your machine you will need assistance and power equipment. Serious personal injury may occur if safe moving methods are not followed.



Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

Clean Up

The unpainted surfaces are coated with a light oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser. To clean thoroughly, some parts may need to be removed. For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.

Warning!

Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used.

 **Caution!**

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

ASSEMBLY

Moving & Placing Saw Base Unit

 **Warning!**

The Sliding Panel Saw is a heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.

 **Warning!**

Use lifting straps with a minimum of 500 kgs lifting capacity. If the lifting strap breaks, serious personal injury may occur.

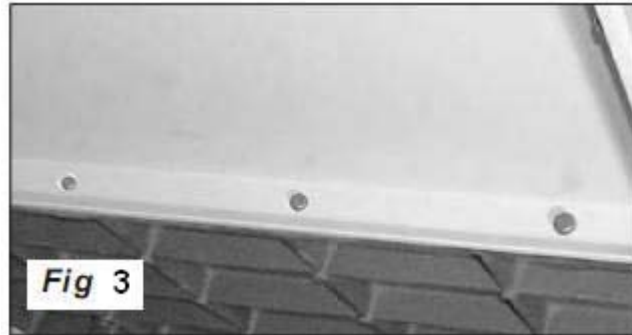
1. Remove the top of crate and position the forklift forks together and directly above the saw.
2. Place four lift rings onto Saw Base Unit and place two lifting straps over the forks and attach the lifting rings
3. Insert a wood block for protecting the main switch.
4. Lift the saw base unit and move it to your predetermined location.
5. Before lowering the saw into position, place four rubber blocks under the frame.
6. Lower the saw on the floor.

Install the extension table

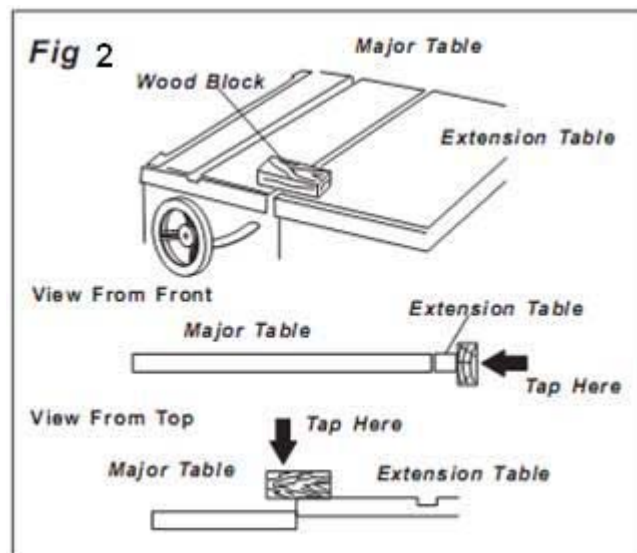
Take out the extension table, steel plate extension table and rear extension table from the Saw Base Unit crate.

1. Attach the extension table to major table with 4-M8x20 hex head screws/ washers.
2. Center the extension table over the edges and tap it. Check the surface alignment.

- 1 . Attach the extension table to major table with 4-M8x20 hex head screws/ washers.

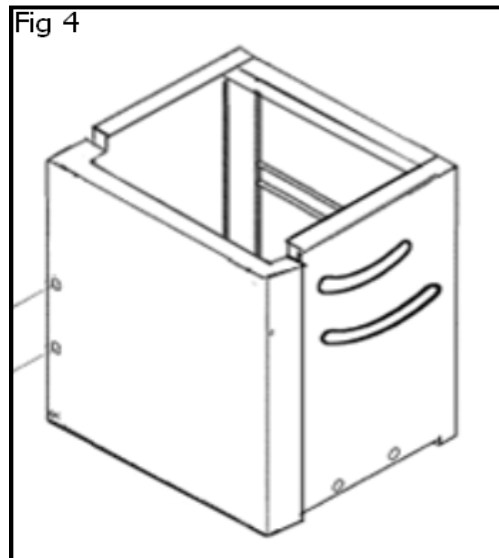


2. Center the extension table over the edges and tap it. Check the surface alignment.



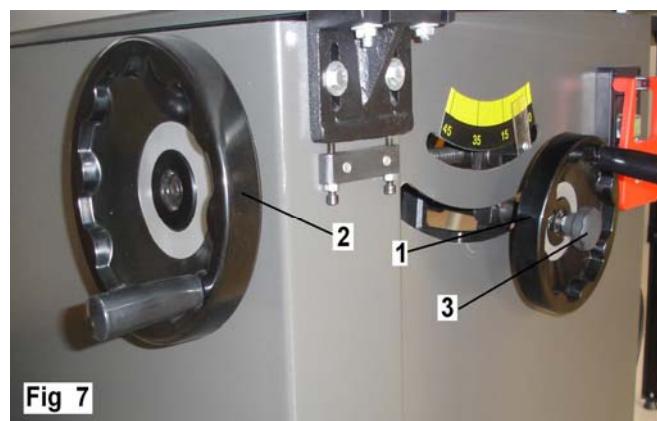
Install the sub-support (model MJ10-1300E / MJ10-1600E)

1. Attach the front sub-support to saw base unit and Tight it with 4-M8x25 allen screws w/spring washers.
2. Attach the front sub-support to main saw base on same way.
2. Align the front sub-support. Rear sub-support and the main saw base on the same level.



Install the main blade elevation & angle handwheel

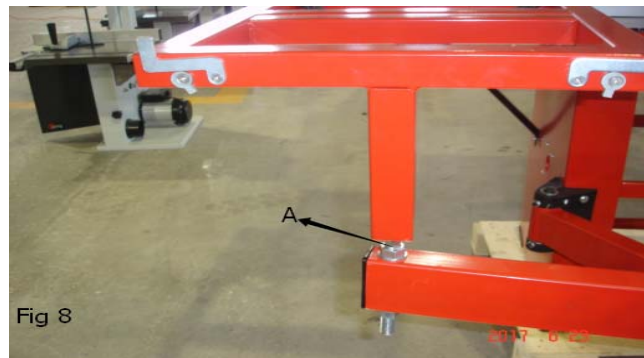
1. Fitting the elevation handwheel(1) and angle handwheel (2) onto the elevation and angle shaft.
3. Screw the blade lock knob(3) onto the elevation handwheel.



Install the swing arm assembly

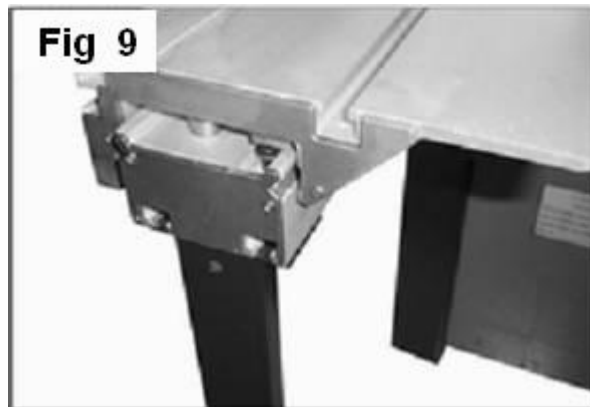
1. Place 4 M8x30 hex head screws to mount the swing arm assembly to the saw base unit, and keep the arm on horizontal level.
2. Place the cross-cut table support (A) onto the swing arm assembly, and hand tighten the lock nuts.

The support needs further adjustment.

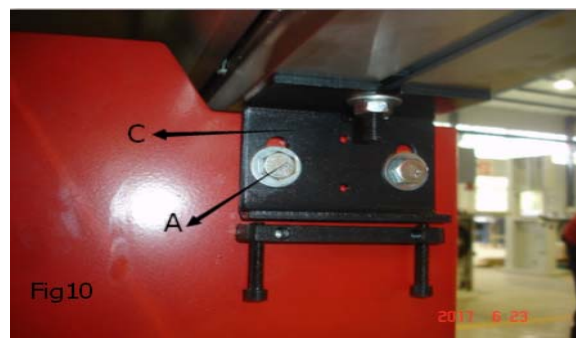


Install the Sliding panel assembly

1 .Place 2 sets of star-type screws (include 8mm washer, insert, screw guide) into the lower slot of sliding panel carrier.



2.Put the sliding panel assembly onto the sliding panel supports, and lay two star-type screws.



3.Tighten two star-type screws.



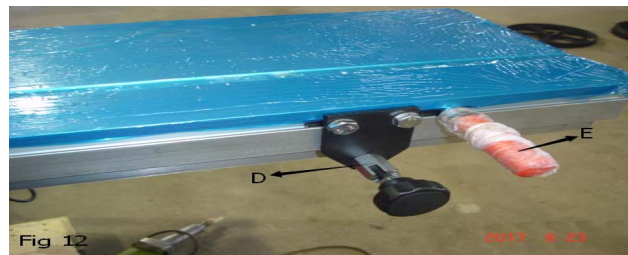
4.Install the support leg to the sliding carrier.

Adjust the sliding panel level

1. Place a level rule (cross cut fence) on to major table and sliding panel.
2. Loosen 4-M8x25 hex screws(A) , adjust the M8x40 hex screw(B) to adjust the sliding panel level.
3. Then re-tighten 4-M8x25 hex screws (A).
4. To fine adjust, using 3 mm "L" wrench to adjust 4- M8x12 set screws(C).

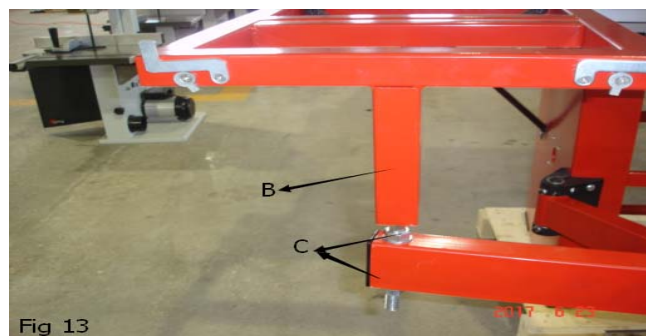
Install the push handle and lock pin

1. Sliding the M12x1.75 T-nut into the sliding panel and thread in push handle(D) with a 17 mm open end wrench.
2. Insert the star-type lock pin (E) into sliding panel, and lock the M10 hex nut on the opposite side.



Install the cross cut table

1. Slide two M8x70 carriage bolts with T-blocks into the side slot of sliding panel. Attached the crosscut table to sliding panel.
2. Use 2 wing nuts mounted the cross cut table to sliding panel.
3. Use 2 M6x30 Hex head screws mounted the cross cut table to support (B).
4. Adjust 4-M12 thin hex nut (C) to adjust the cross cut table on the line with sliding panel.
5. Then tighten 4-M12 thin nut (C).



Install the hold down/Mitre Gauge

1. Slide the hold down/Mitre Gauge onto the sliding table and push it as far as possible. And lock the hold down/mitre gauge on table with the star-type lock handle (A) locked.
2. Aligned the Mitre Gauge fence on it.



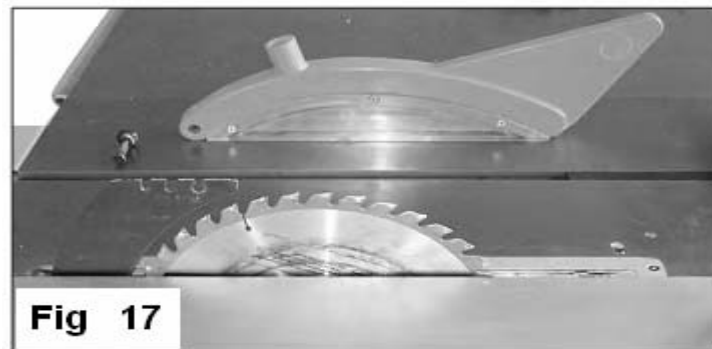
Install the dust port

Place the dust port onto the bottom of rear panel, tighten it with 4 M6x12 pan head screws washers and nuts (nuts inside stand).



Install the blade guard

The riving knife cuts 3 slot for different blade size, and the blade guard mounts to the 254 slot.



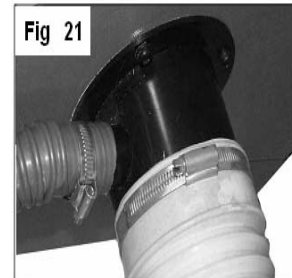
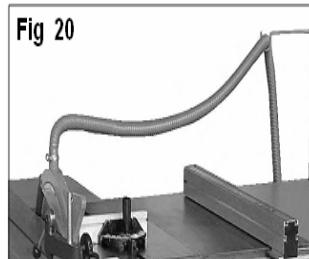
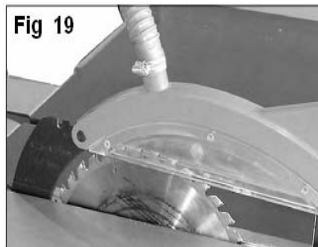
Install the dust hose support

To install the dust hose support onto the rear portion of steel plate extension table with 2 M6x20 hex head screws washers and nuts(nuts under the table).



Install dust hoses

1. Install the 2" dust hose onto the blade guard with 2" hose clamp.
2. Put the 2" dust hose onto dust hose support, keep free with the working table.
3. Another end of 2" dust hose clamps to the main dust port on the bottom of rear panel.
5. Install 4" dust hose to main dust port with 4" hose clamp



REPLACEMENT & ADJUSTMENT

Replace the main blade, disconnect the saw from the power source!

The main blade dimension suitable for the machine is 254x30x3(outer diameter, core diameter, thickness).

But any time you change blade thickness, the appropriate sized riving knife and scoring blade must also be changed to match the size of main blade you install.

To change main blade:

- 1 . Move the blade tilt to 0° (Blade 90° to table) on the control panel and raise the blade as far as it will go.
- 2 . Move the sliding panel all the way to the right and remove two M6x12 pan head screws to expose the internal blade guard that covers the blades and riving knife.
- 3 . Remove the blade guard from the riving knife to expose the mounting assembly.
- 4 . Remove the table insert.
- 5 . Insert the arbor pin into the hole on blade inner flange and locks the blade.
- 6 . Using the arbor wrench, remove the arbor nut that secures the main blade (turn clockwise to loosen).
- 7 . Remove the arbor flange and the old main blade.
- 8 . Install the new main blade, replace the arbor flange and nut, and tighten the arbor nut to secure the main blade.
- 9 . Make sure the correct size riving knife is installed and aligned with the blade.
10. Move the internal blade guard back into its original position, next to the blades, and center the sliding panel.



If you change blade diameter sizes during this procedure, now is the time to adjust the riving knife.

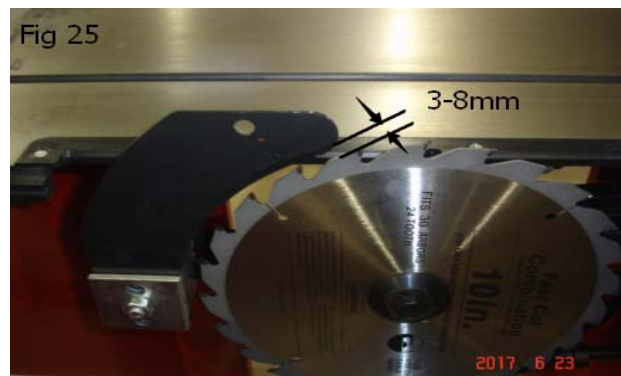
If the kerf thickness is different from your old blade, the scoring blade kerf and riving knife thickness must match the new main blade kerf.

Disconnect the saw from the power source!

The riving knife is carved with different blade size, just put the carved line under table.

The center carriage bolt is mounted in a horizontal slot, so the riving knife can move far or near the main blade.

1. Move the blade tilt to 0° (Blade 90° to table) on the control panel and raise the blade as far as it will go.
 2. Move the sliding panel all the way to the right and remove two M6x12 pan head screws to expose the internal blade guard that covers the blades and riving knife.
 3. Remove the blade guard from the riving knife to expose the mounting assembly.
 4. Remove the center bolt in the mounting assembly to remove the mounting plate.
 5. Remove the currently installed riving knife and install the correct riving knife.
 6. Replace the mounting plate and thread in the center bolt without completely tightening it.
 7. Position the riving knife about 3mm to 8mm away from the nearest carbide tooth on the main blade.
- Note** *For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife.*
8. Tighten the center bolt to secure the riving knife in position.
 9. Move the internal blade guard (from step 4) back to its original position, and move the sliding panel back to center.



Sliding Panel Parallel Adjustment

Disconnect the saw from the power source!

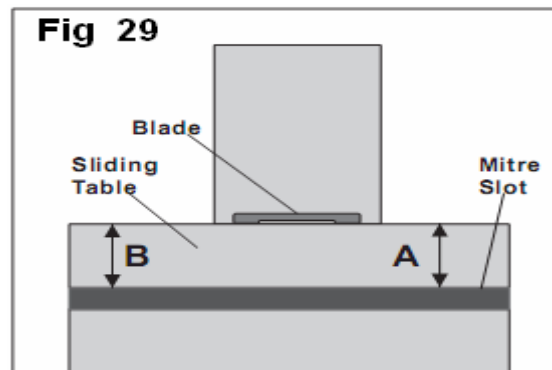
Now is the point in the assembly process to make the sliding panel parallel with the main saw blade and secure the sliding panel to the saw base.

Besides the tools included with the saw, this procedure requires you to have a precision ruler, a felt tip pen, and the assistance of another person.

To adjust the sliding panel parallel with the main blade

1. Set the blade to 0° on the control panel (90° with the cast iron table).
2. Raise the main blade up as far as it will go.
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 panel all the way to one end, and using a precision ruler, measure the gap between the edge of the

panel and your mark on the blade as shown in **Fig 29**.



5. Move the other end of the sliding panel in front of the blade and measure the gap. If the gap is the same on both sides, then the sliding panel is already parallel with the main blade. If the gap on one side is different than the other, then continue with **step6**.

6. Move the end of the sliding panel that needs to be adjusted in front of the blade.

7. Loosen the two hex head screws (**C**) and light tap the sliding carrier support to adjust the gap.



8. Repeat **steps 7** until the gap between your mark on the blade and the edge of the sliding panel is even at both ends.

9. Tighten the four hex head screws (**C**) and secure supports in place

10. Now tighten the two star-type screws that secure the sliding panel to the base.

OPERATIONS

Rip Cutting

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



This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw. Smaller,

lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.



Determine which cutting operation will be best suited for the workpiece to be ripped.

To use the sliding table, read the instructions titled "Rip cutting with the sliding panel."

To use the machine as a traditional table saw, skip ahead to "Rip cutting using the traditional table saw technique."

Rip cutting with the sliding panel:

1. Mount the crosscut table to the sliding panel.
2. Slide and secure the crosscut table to the end of the sliding table opposite the sliding table handle.
3. Install the crosscut fence in the guide pin holes and lock it in place with the knurled nut.

Note *First, drop the crosscut fence into the forward guide pin hole, turn the "Z"lock plate to align the fence, then tighten the knurled nut.*



4. Set either flip stop to the desired width-of-cut.
5. Load the workpiece onto the table saw.
6. Mount the hold down arm onto the stud and lock the work-piece in place.
7. Once all the necessary safety precautions have been taken, perform the cutting operation.

Rip cutting using the traditional table saw technique:

1. Slide the crosscut table out of the way.
2. Lock the sliding panel into a stationary position.
3. Position the rip fence to the desired width-of-cut.
4. Once all the necessary safety precautions have been taken, load the workpiece onto the table saw and perform the cutting operation.

Crosscutting

With the crosscut fence mounted in the forward position, the sliding panel saw has the capability of crosscutting full

size panels.



With the crosscut fence mounted in the rear position, this machine also has the capability of crosscutting smaller panels.



This machine has the capability of crosscutting workpieces while using the hold down w/mitre gauge .



Lastly, this machine has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge.



Determine which cutting operation will be best suited for the workpiece to be crosscut.

If you will be crosscutting full size panels, then skip ahead to "Crosscutting full size panels."

If you will be crosscutting smaller panels, then skip ahead to "Crosscutting smaller panels."

If you will be crosscutting workpieces using the hold down, then skip ahead to "Crosscutting using the hold down w/mitre gauge."

If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to "Crosscutting using the rip fence as a cut-off gauge."

Crosscutting full size panels:

1. Mount the crosscut table to the sliding panel.

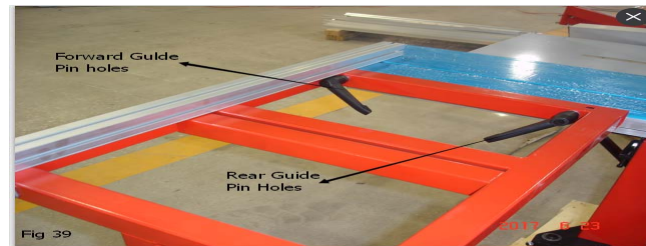
2. Install the crosscut fence in the forward guide pin holes and lock it in place.

Note First, drop the crosscut fence into the forward guide pin hole, turn the "Z" lock plate to align the fence, then tighten the knurled nut.

3. Set either flip stop to the desired width-of-cut.

Note If the workpiece extends to the left of the saw blade more than 1200mm, then the crosscut fence slide needs to be extended.

4. Load the workpiece onto the table saw.



5. Mount the hold down arm onto the stud and lock the work-piece in place.

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

Crosscutting smaller panels:

1. Mount the crosscut table to the sliding panel.

2. Install the crosscut fence in the rear guide pin holes and lock it in place.

Note First, drop the crosscut fence into the rear guide pin hole, turn the "Z" lock plate to align the fence, then tighten the knurled nut.

3. Set either flip stop to the desired width-of-cut.

Note If the workpiece extends to the left of the saw blade more than 1200mm, then the crosscut fence slide needs to be extended.

4. Load the workpiece onto the table saw.

5. Mount the hold down arm onto the stud and lock the work-piece in place.

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

Crosscutting using the hold down:

1. Mount the hold down onto the sliding panel.

2. Load the workpiece onto the table saw. Secure it using clamp.

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

Crosscutting using the rip fence as a cut-off gauge:

1. Mount the crosscut table to the sliding panel.

2. Install the crosscut fence in the rear guide pin holes and lock it in place.

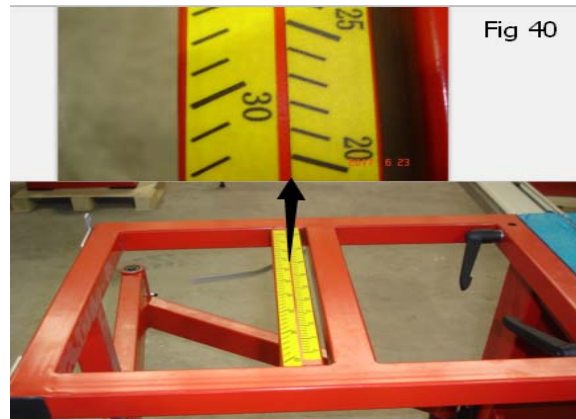
Note First, drop the crosscut fence into the rear guide pin hole, turn the "Z" lock plate to align the fence, then tighten

the knurled nut.

3. Position the rip fence to the desired width-of-cut.
4. Load the workpiece onto the table saw.
5. Mount the hold down arm onto the stud and lock the work-piece in place.
6. Once all the necessary safety precautions have been taken, perform the cutting operation.

Miter Cutting

The cross cut table built two scales for forward and rear mount fence to perform mitre cut.



Also the sliding panel built a scale for hold down to perform mitre cut.



Lastly, this machine has the capacity of mitre cutting work-piece using the mitre gauge.

To perform a miter cut using the cross cut fence:

1. Mount the cross cut fence onto the cross cut table.
2. Position the cross cut fence at the desired angle and use the ratchet lever to lock the cross cut fence in position.



3. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.

Note *If the workpiece extends to the left of the saw blade more than 1200mm, then the crosscut fence slide needs to be extended.*

4. Load the workpiece onto the table saw.
5. Mount the hold down arm onto the stud and lock the work-piece in place.
6. Once all the necessary safety precautions have been taken, perform the cutting operation.

To perform a miter cut using the hold down w/ mitre gauge:

1. Mount the hold down onto sliding panel and fit a cut fence.
2. Position the hold down w/mitre gauge at the desired angle and use the ratchet lever to lock the mitre gauge in position.
3. Load the workpiece onto the sliding panel. Secure the workpiece with clamp.
4. Once all the necessary safety precautions have been taken, perform the cutting operation.



MAINTENANCE

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Cleaning

Cleaning the sliding panel saw is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all cast iron and unpainted steel with a non-staining lubricant after cleaning.

Once a week:

- Clean sliding panel surface and grooves.
- Clean the cast iron or steel plate saw table.
- Clean the roller guide ways for the sliding table.
- Clean the aluminum rip fence and sliding grooves.
- Clean the rip fence bracket.

Once a month:

- Vacuum inside the motor cabinet.

Miscellaneous

Always be aware of the condition of your machine. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts.

Worn switch.
Worn or damaged blade.
Worn or damaged blade guard.

V-Belts

To ensure optimum power transmission from the motor to the blade and to the hydraulic pump, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension. Check the V- belts at least every 3 months; more often if the saw is used daily.

Replace the belts, if needed.

Bearings

The bearings are sealed and pre-lubricated and require no lubrication during their usable life. However, your saw components will operate at their best if the bearing surfaces are kept clean this is especially important for the trunnion bearings.

There is thermo cut-out inside the motor, this device protect the motor from being damaged in high temterature's condition. When the motor's temperature is too high the fuse will shut off automatically.

you should check the reasons to cause the high temperature or be carried out by qualified specialists at once.

The thermo cut-out will return to normal automatically once the temperature low down.

ELECTRICAL

Main switch

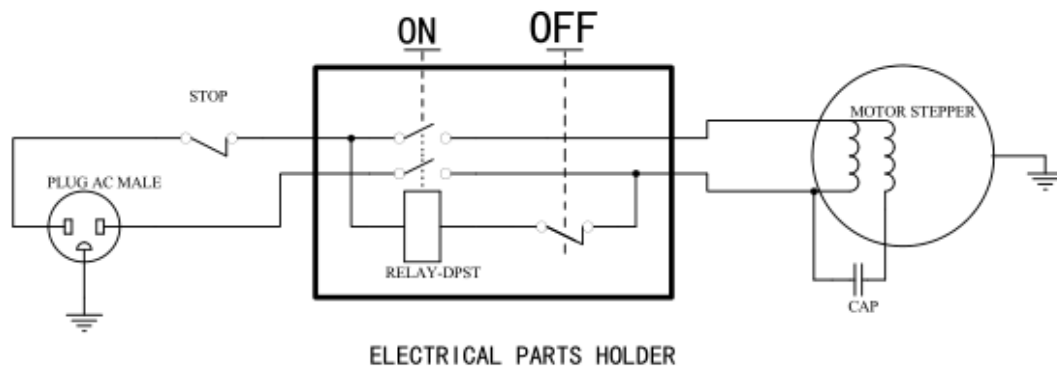
This machine is equipped with a knee touch no-volt release main switch and a limit switch.

The main switch is equipped a large size touch panel, during performance cutting work, any part of man body touched the switch panel, it can bring the saw stop.



Limit switch

The limit switch is mounted under the inner guard, if your make scoring blade or main blade replacement, remove the inner guards, the limit switch keep "off" position. Reduce the risk of unintentional starting.



Symptom	Possible Cause	Possible Solution
Motor will not start.	<ol style="list-style-type: none"> 1. Low voltage. 2. Open circuit in motor or loose connections. 	<ol style="list-style-type: none"> 1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	<ol style="list-style-type: none"> 1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line. 	<ol style="list-style-type: none"> 1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	<ol style="list-style-type: none"> 1. Motor overloaded. 2. Air circulation through the motor restricted. 	<ol style="list-style-type: none"> 1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> 1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded. 	<ol style="list-style-type: none"> 1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows when operating.	<ol style="list-style-type: none"> 1. Applying too much pressure to workpiece. 2. Belts loose 	<ol style="list-style-type: none"> 1. Feed workpiece slower. 2. Tighten belts.
Loud, repetitious noise coming from machine.	<ol style="list-style-type: none"> 1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective 	<ol style="list-style-type: none"> 1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Tighten fan or shim cover. 3. Replace V-belts.
Blade is not square w/ miter slot or fence is not square to blade	<ol style="list-style-type: none"> 1. Blade is warped. 2. Table top is not parallel to blade. 3. Fence is not parallel to blade 	<ol style="list-style-type: none"> 1. Replace blade. 2. Make table parallel to blade. 3. Make fence parallel to blade.
Fence hits table top when sliding on to the table.	<ol style="list-style-type: none"> 1. Front rail is bolted too low on table. 2. Rear rail is bolted too low on the table. 	<ol style="list-style-type: none"> 1. Raise front rail. 2. Raise rear rail.
Blade does not reach 90°.	<ol style="list-style-type: none"> 1. 90° stop bolt is out of adjustment. 	<ol style="list-style-type: none"> 1. Adjust 90° stop bolt.
Blade hits insert at 45°.	<ol style="list-style-type: none"> 1. Hole in insert is inadequate. 2. Table out of alignment. 3. Blade position is incorrect. 	<ol style="list-style-type: none"> 1. File or mill the hole in the insert. 2. Align table. 3. Adjust blade position.
Blade will not go beneath table surface.	<ol style="list-style-type: none"> 1. Table top too low. 	<ol style="list-style-type: none"> 1. Raise table top w/ washers.
Hand wheels won't turn.	<ol style="list-style-type: none"> 1. Hand wheel key is inserted too far. 2. Roll pin or setscrew in worm gear is contacting geared trunnion. 	<ol style="list-style-type: none"> 1. Remove hand wheel and adjust key. 2. Inspect roll pins and setscrews in the worm gear. Tighten if necessary.
Workpiece has chip out on the bottom edge.	<ol style="list-style-type: none"> 1. Scoring blade height is incorrect. 2. Scoring blade is not aligned with the main blade. 3. Scoring blade kerf does not match the main blade. 	<ol style="list-style-type: none"> 1. Adjust the height of scoring blade. 2. Align the scoring blade. 3. Change the scoring blade.
Sliding table saw does not cut square.	<ol style="list-style-type: none"> 1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Cross cut fence is not perpendicular to the blade. 	<ol style="list-style-type: none"> 1. Adjust the sliding table. 2. Adjust the fence. 3. Adjust the cross cut fence perpendicular to the blade.

PARTS LIST & DIAGRAMS

Parts List Diagram A

No	Description	No	Description
1	Allen screw M6x12	14	Cover, switch box
2	Washer 6mm	15	Pan head screw M4x12
3	Right panel, saw base 1	16	Main switch
4	Saw base frame	17	Taping screw ST4.2x20
5	Washer 5mm	18	Knee touch plate
6	Knee touch plate	19	Internal guard
7	Taping screw ST4.2x20	20	Knee touch plate
8	Right panel, saw base 2	21	Washer 5mm
9	Plastic plate		
10	Switch box		
11	Nut M6		
12	Hold screw, push stick		
13	Push stick		

Parts List Diagram B

No	DescriptionScale,	No	Description
1	sliding table	22	Lower support
2	Sliding panel set	23	Adjustable disc
3	Allen screw M5x8	24	Hex screw M8x25
4	Push handle	25	Stop screw
5	Nut plate	26	Bracket, sliding carrier
6	Lock pin	27	Hex screw M8x40
7	Flat pad 8	28	T-base, adjust
8	Outer six angle bolt 8 × 14	29	Screw
9	Hex nut M8	30	T-base, adjust
10	End cap, knob	31	Sunk head screw M8x25
11	Star-type knob, lock pin	32	Washer 6mm
12	Roll pin 3x18	33	Wing nut
13	Bush, lock pin	34	Flat washer 10mm
14	Spring, lock pin	35	Ratchet lever
15	Lock pin	36	Star-type lock handle
16	Hex nut M10	37	Set
17	Scew guide	38	Mitre gauge, hold down
18	End cap, knob	39	Carriage bolt M6x40
19	Upper support	40	Stud, hold down
20	Allen screw M8x25	41	End cap, fence
21	Disc, insert	42	Fence, mitre gauge

Parts List Diagram B*cont...*

No	Description
43	End cap, fence
44	Allen screw M5x16
45	Disc, hold down
46	Star-type knob, hold down
47	Arm, hold down
48	Circle ring 8mm
49	Pin, hold down
50	spring, hold down
51	Stud, hold down
52	Circle ring 12mm
53	Eccentric, hold down
54	Handle, hold down
55	Handle knob, hold down

Parts List Diagram C

No	Description	No	Description
1	Screw	25	Flat pad
2	Flange	26	Motor base
3	Main blade	27	Sunken head screw M8×25
4	A type triangular belt 450	28	Motor
5	Spindle belt wheel	29	Hex head screw M8X35
6	Drive shaft	30	Pulley-motor
7		31	Flower screw
8	Spacer	32	Wheel handle
9	Pulley	33	Set screw M6X8
10	Screw	34	Circle ring
11	wave washer	35	Bearing house
12	Frame segment	36	Flat key 5×16
13	Outer six angle bolt M8×45	37	Thread
14	Nut M8	38	Roll pin 6×14
15	Elastic cylindrical pin	39	Hex head screw M8×25
16	Ring	40	Flat pad 8
17	Inner six angle bolt M6×12	41	Spring washer 8
18	Gear house	42	Rotating support
19	Nut M24×1.5	43	Flat pad 6
20	Inner six corner tight nail	44	Outer six angle bolt M6×10
21	Circle ring	45	Screw
22	Nut	46	Main shaft
23	Shaft	47	Inner six corner tight nail M8×20
24	Hex nut M8	48	Nut M8

Parts List Diagram C

cont...

No	Description	No	Description
49	Rod	C2-1	Lock bolt, guard
52	Washer	C2-2	Half, blade guard
53	Hex head screw M10X25	C2-3	Half, blade guard
54	Chip house	C2-4	Lock washer 8mm
55	Hose clamp 50mm	C2-5	Knuried nut
56	Dust removing tube 50	C2-6	Taping screw ST4.2X10
57	Flat key 4×16	C2-7	Head bolt M4×10
58	Inner six angle bolt M6×30	C2-8	Taping screw ST4.2X26
59	Thread	C2-9	Segement, blade guard 1
60	Hex nut	C2-10	Segement, blade guard 2
61	Frame-blade	C2-11	Hex nut M10
62	Set	C2-12	Spring washer 10mm
63	Pointer fixing plate	C2-13	Stop screw
64	Bolt M8×16	C2-14	Segement
65	Flat pad 4	C2-15	Riving knife
66	Round head bolts M4×8	C2-16	Set screw M8X20
67	Pointer	C2-17	Set screw M8X20
68	Bolt M8×20	C2-18	Carriage bolt M10X80
69	Big flat mat 8	C2-19	Insert
70	Head bolt M6×16		
71	Ball box 1		
72	Ball box 2		
73	Wheel handle		
74	Ring		
75	Head bolt M5×10		

Parts List Diagram D

No	Description	No	Description
1	Fence "L" shape	28	T-nut M5
2	Carriage screw M6x50	29	Washer 5mm
3	Cap screw	30	Pan head screw M5x10
4	Bush	31	Set screw M6x6
5	Fence	32	Fine adjusting handle
9	Flat pad 6	33	Coil spring, fine adjust
10	T type lock handle	34	Eccentric arbor
11	Sunk head screw M6x12	35	Frame, fine adjust gear
12	Fence plate	36	Gear rod, fine adjust
13	End cap, lock handle	37	Core gear
14	Self tapping M4 × 12	38	Washer 4mm
15	Taping screw ST4.2x12	39	Sunk head screw M6x12
16	End cap, fence carrier	40	Axis
17	Fence carrier	41	Pan head screw M5x8
18	Eccentric shaft	42	Lock washer 5mm
19	Circle ring	43	Rack, fence
20	Len	44	T-Nut M5
21	Nut plate	45	Taping screw ST4.2x12
22	End cap, fence carrier	46	Left end cap, front rail
23	Screw guide	47	Square head screw M8x25
24	Lock plate	48	Right end cap, front rail
25	Pan head screw M4x10		
26	Hex nut M8		
27	Lock handle, fence		

Parts List Diagram D 2

No	Description	No	Description
1	Sliding aluminum profile	11	Fixed bolt
2	slider	12	Cylindrical guideway
3	Fixed block	13	Trim handle
4	Flat pad 6	14	Hand
5	Lock the handle	15	Sliding seat
6	Hex screw M10x30	16	Hex screw M6x12
7	Ruler	17	Self locking nut M6
8	Ruler holder	18	Trimming seat
9	Nut 8		
10	Flat pad 8		

Parts List Diagram E

No	Description	No	Description
1	Scale, cross cut table	20	Big flat mat 16
2	Scale, cross cut table	21	End cap, swing arm
3	End cap, cross cut table	22	Shaft, swing arm
4	T-block	23	Inner six corner tight nailM8×20
5	Flat washer M8	24	Swing arm
6	Wing nut M8	25	Block
7	Cross cut table	26	Hex screw M6x35
8	Knurled knob, fence	27	Big flat mat 17
9	Flat washer M8	28	Support, swing arm
10	Wing nut M8	29	Hex bolt M6X35
11	Self locking nut M6	30	Locating pole
12	"Z" lock plate	31	Washer φ6
13	Sunk head screw M6x20	32	Small handgrip
14	Eccentric cam	33	Turing plate
15	"Z" lock plate	34	Washer φ10
16	Shaft ring 17	35	Locking nut M10
17	Bearing 6202	36	Stud, hold down
18	Support rod, cross cut table	37	T-block, hold down
19	Thin hex nut M10	38	T-block
		39	Lock stud, cross cut fence
		40	End cap, cross cut fence
		41	Half round head self tapping M4×12

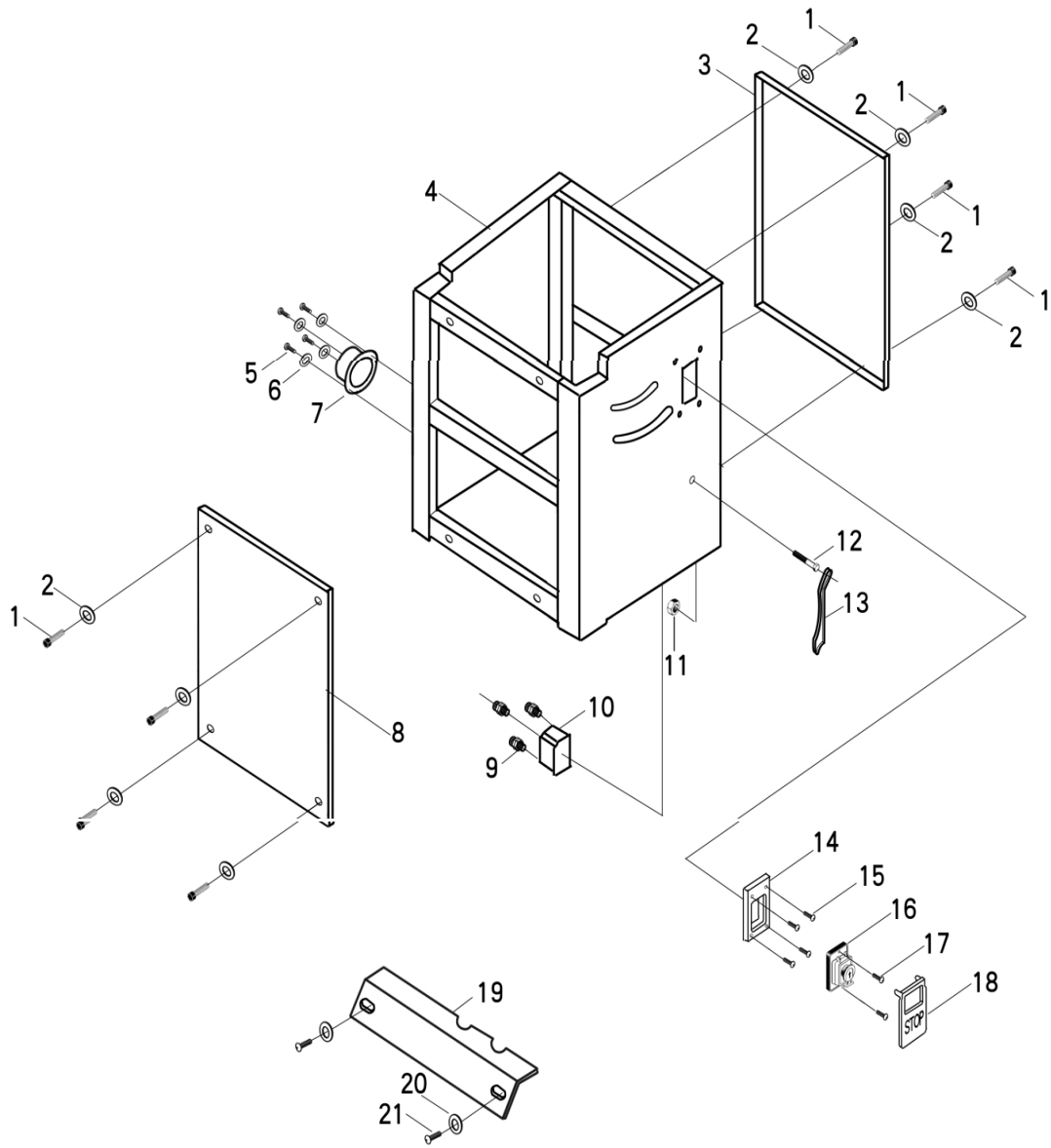
Parts List Diagram G

No	Description	No	Description
1	Rear extension table	13	Extension table
2	Washer 8mm	14	Hex screw M6x20
3	Hex nut M8	15	Adjustable disc
4	Flat pad 6	16	Lower, support
5	Bolt M6×12	17	Disc insert
6	Hex screw M8x16	18	Allen screw M8x25
7	Rea table support	19	Upper, support
8	Flat pad 10	20	Dust hose support
9	Set screw M10x60	21	Nut M6
10	Major table	22	Hose clamp 35mm
11	Sunk head screw M5x10		
12	Table insert		

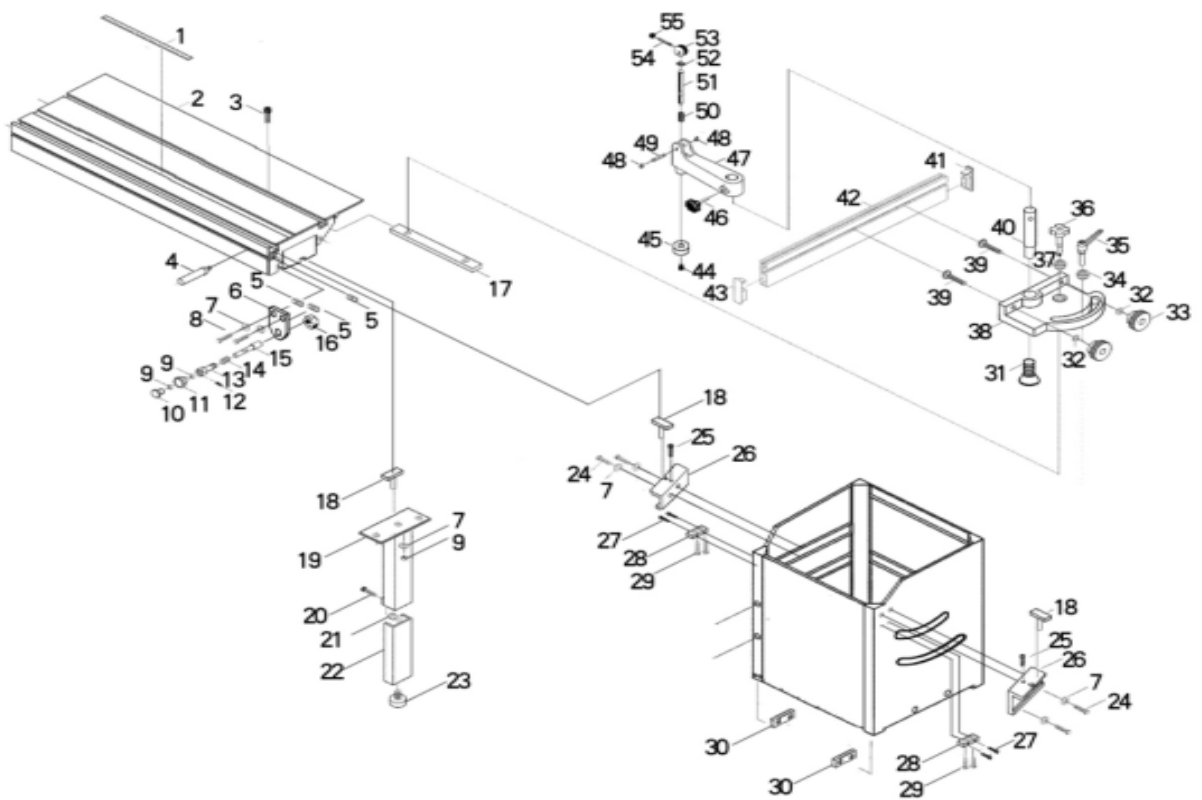
Parts List Diagram H

1	Mitre gauge knob
2	Mitre gauge rod
3	Mitre gauge base

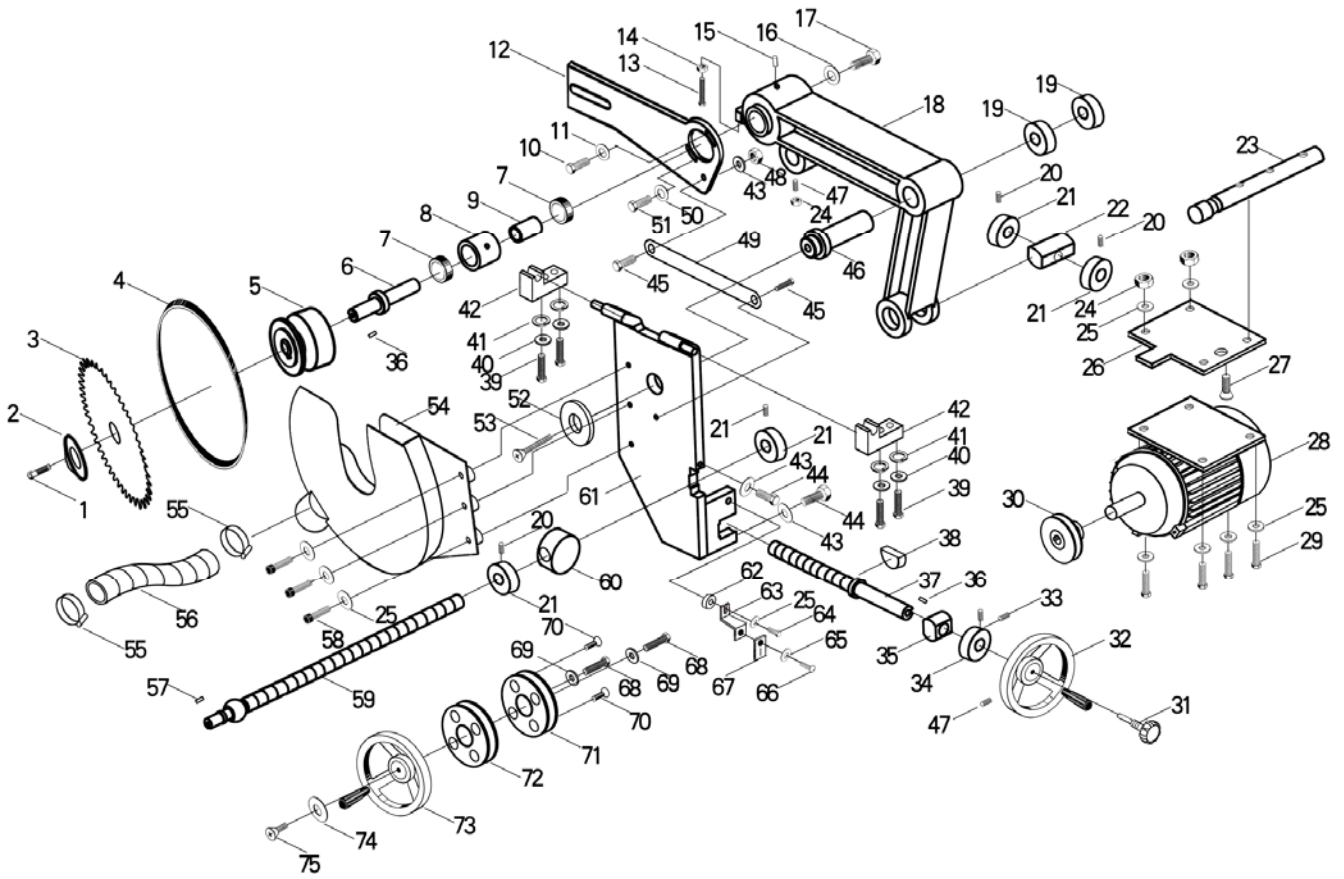
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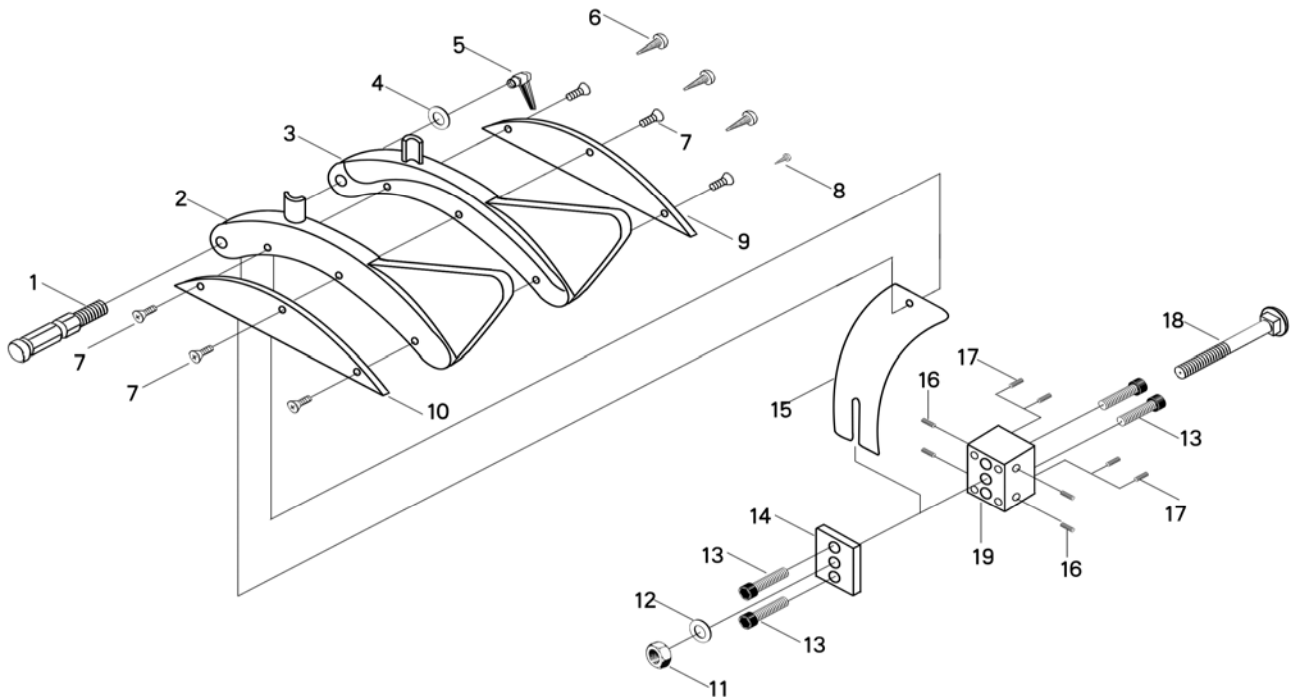
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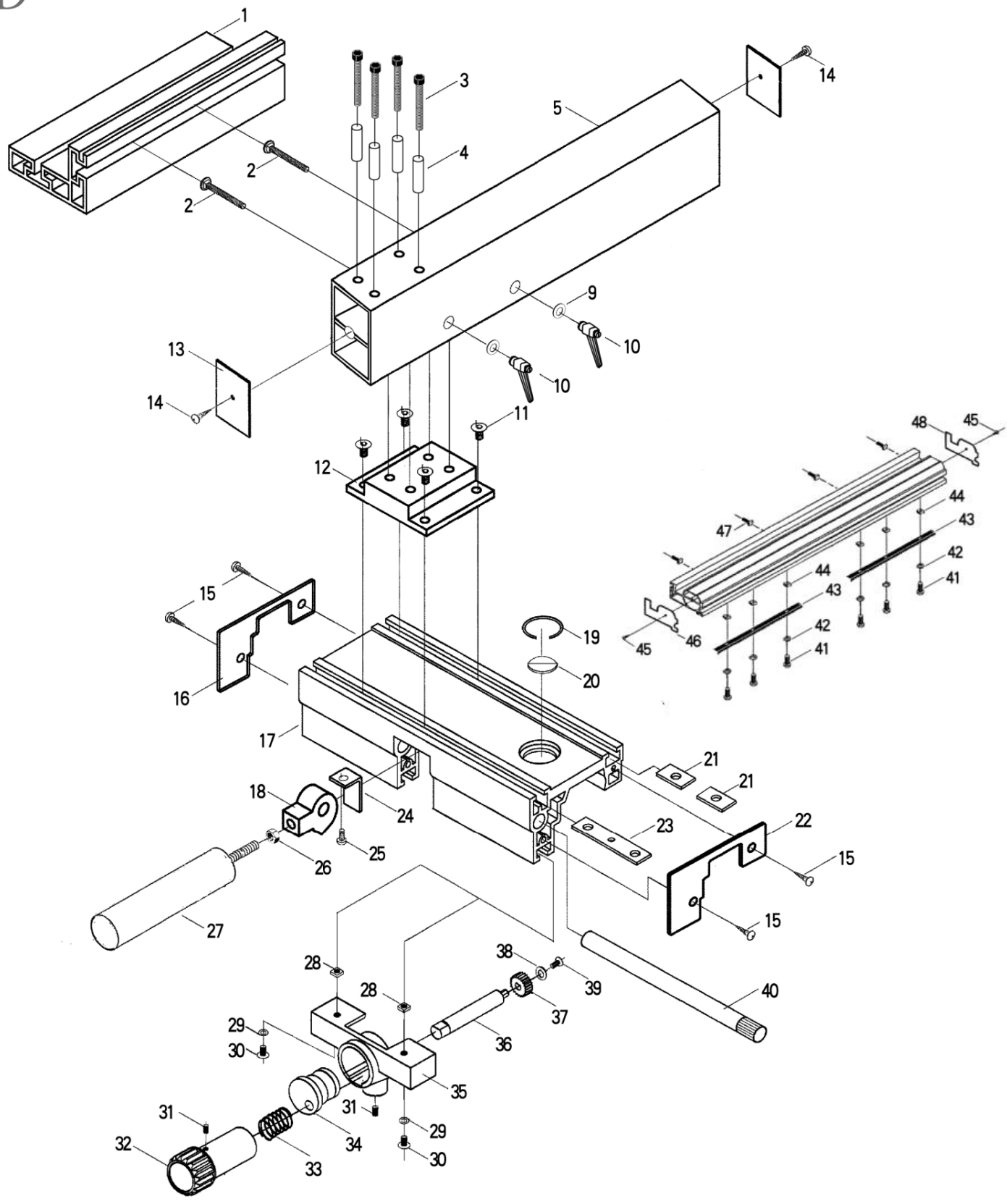
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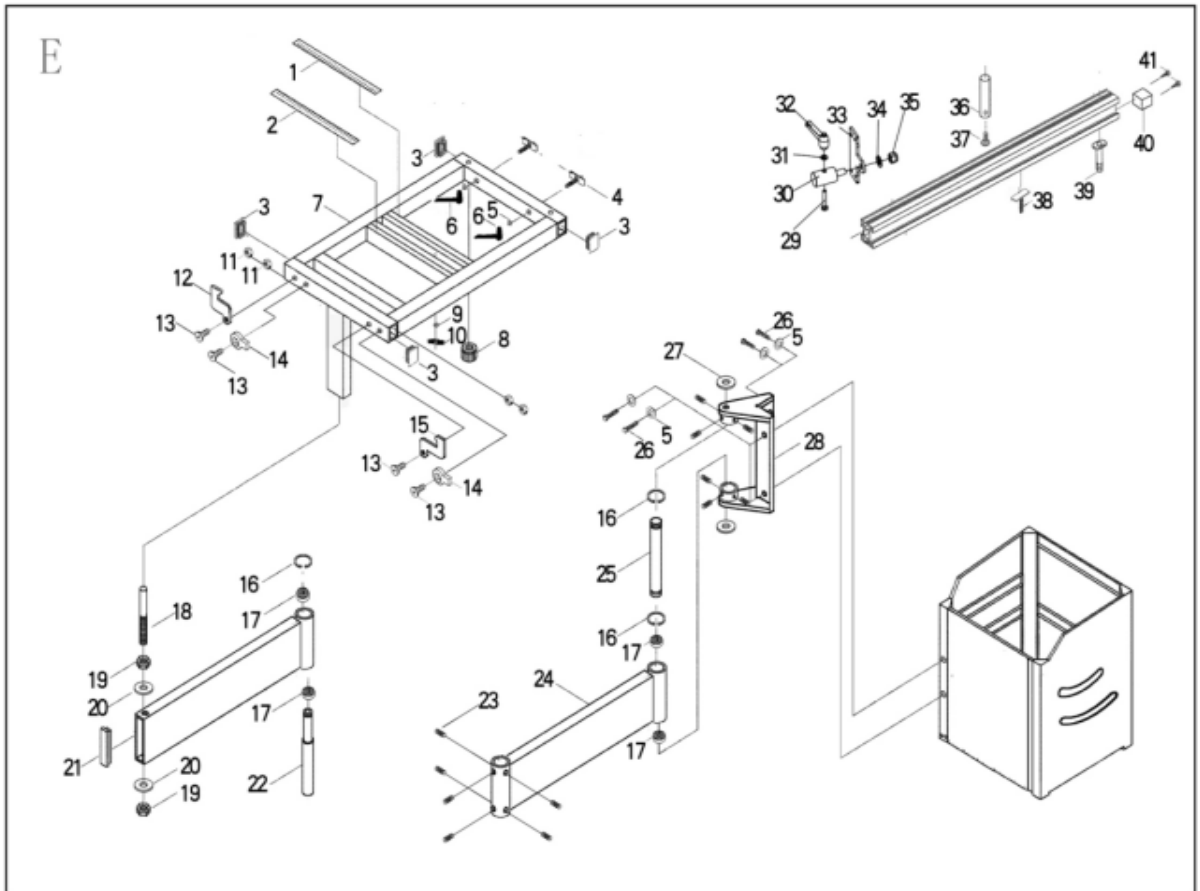
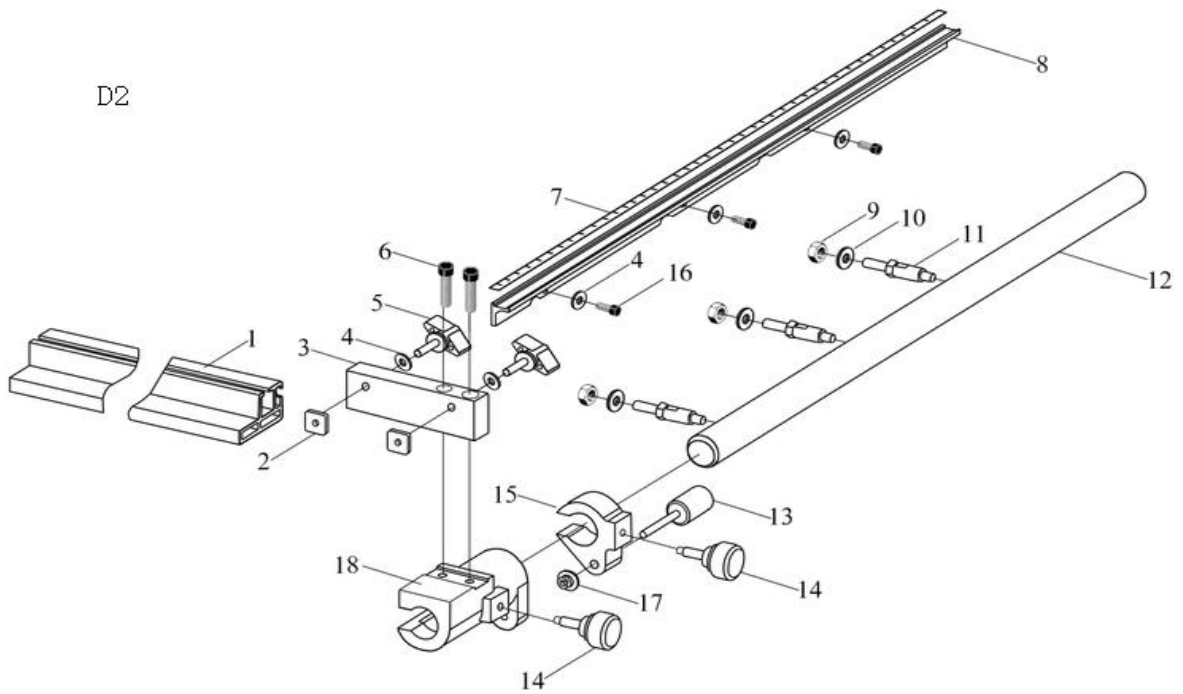
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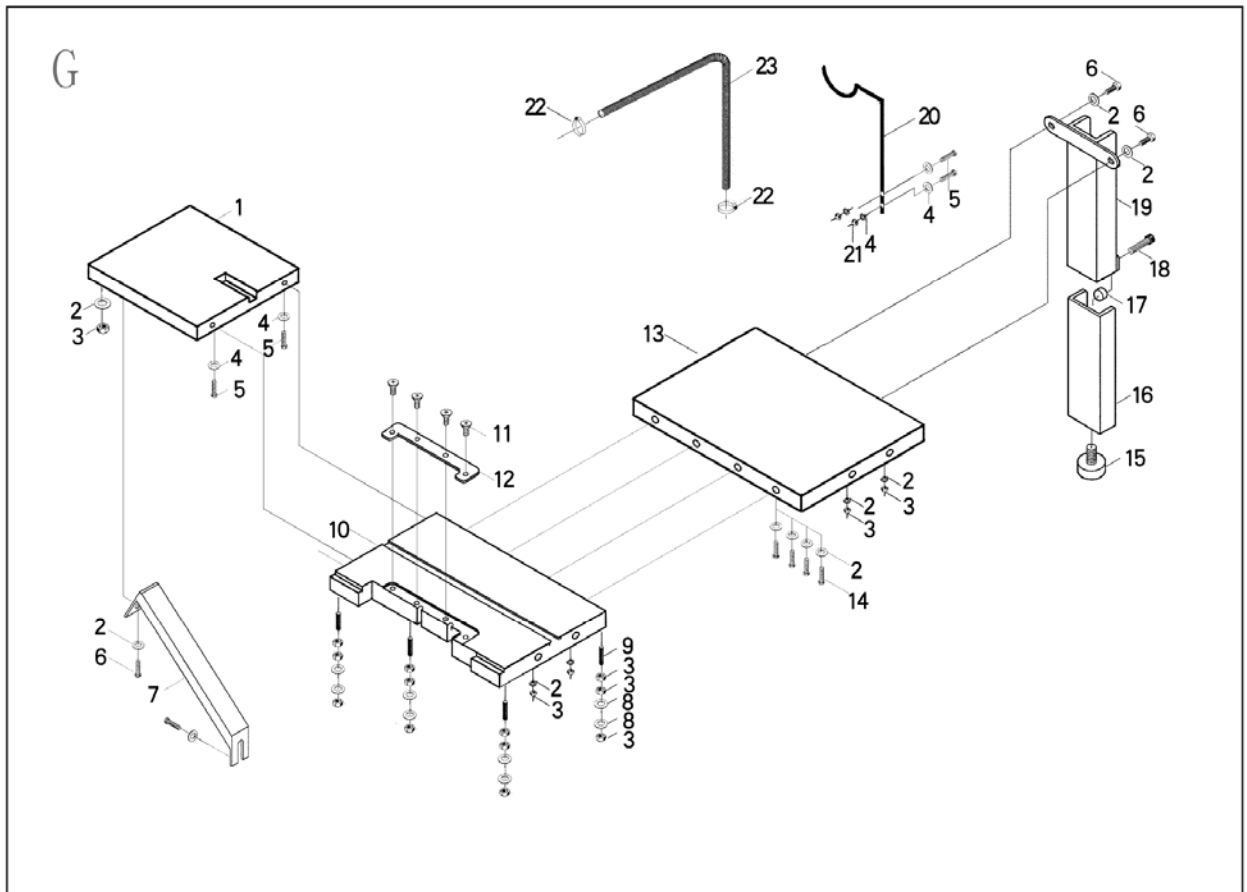


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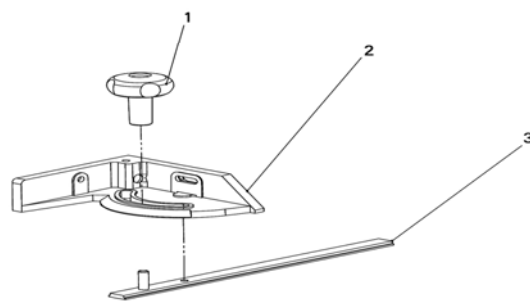


D2





H



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