



# OPERATOR'S MANUAL

Wood Working



## TABLE SAW MODEL: TS-1040E-1.0 30 & 50

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## **THANK YOU & WARRANTY**

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

**Inspection & Acceptance.** Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without a RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without a RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

**Specifications.** Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

**Limited Warranty.** Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 30 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

**EXCLUSION OF OTHER WARRANTIES.** THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

**Limitation of Liability.** IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing, and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator's manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorneys' fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

#### Summary of Return Policy.

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

#### For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:  
(920) 684-4990 or e-mail us at [sales@baileighindustrial.com](mailto:sales@baileighindustrial.com)



## **INTRODUCTION**

*The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.*

*Our technical staff will do their best to help you get your machine back in working order.*

### **In this manual you will find: (when applicable)**

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

## **GENERAL NOTES**

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



**Note:** This symbol refers to useful information throughout the manual.

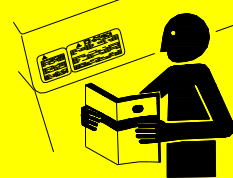




## IMPORTANT

### PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



## SAFETY INSTRUCTIONS

### LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**

Follow recommended precautions and safe operating practices.

### UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** is used with the safety alert symbol. **DANGER** identifies a hazard or unsafe practice that will result in severe **Injury or Death.**

Safety signs with signal word **DANGER** or **WARNING** are typically near specific hazards.

General precautions are listed on **CAUTION** safety signs. **CAUTION** also calls attention to safety messages in this manual.



**DANGER**



**WARNING**



**CAUTION**

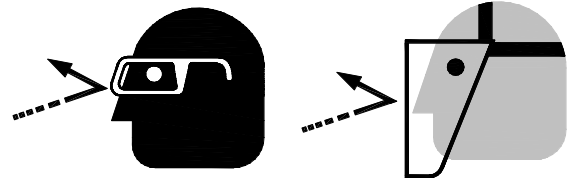


**SAVE THESE INSTRUCTIONS.**  
**Refer to them often and use them to instruct others.**



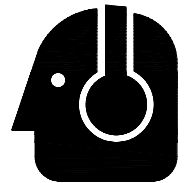
### **PROTECT EYES**

Wear safety glasses or suitable eye protection when working on or around machinery.



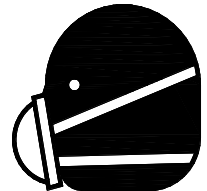
### **PROTECT AGAINST NOISE**

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



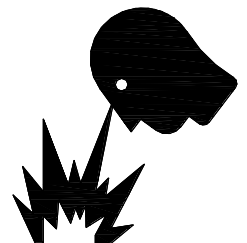
### **DUST HAZARD**

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long term respiratory damage. Be aware of the dust hazards associated with all types of materials.



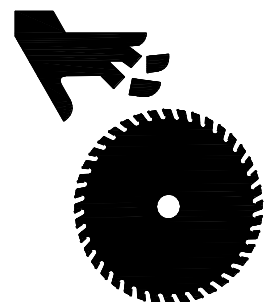
### **DUST PARTICLES AND IGNITION SOURCES**

**DO NOT** operate the table saw in areas where explosion risks are high. Such areas include locations near pilot lights, open flames, or other ignition sources.



### **ROTATING BLADE HAZARD**

Moving saw blade may result in loss of fingers or limb. **DO NOT** operate with guard removed. **Follow lockout/tagout procedures before servicing.**

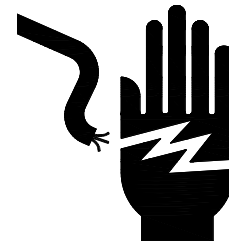






## HIGH VOLTAGE

**USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT** assume the power to be off.  
**FOLLOW PROPER LOCKOUT PROCEDURES.**



## EMERGENCY STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset.

**Note:** Resetting the E-Stop will not start the machine.



Wear Eye Protection



Read Manual



Wear Ear Protection



Wear Respiratory Protection



Electric Shock



Do NOT Remove Guards



## **SAFETY PRECAUTIONS**



Wood working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, push sticks, hold-downs, feather boards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

**REMEMBER: Your personal safety is your responsibility.**



**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY**

### **Dear Valued Customer:**

- All Baileigh woodworking machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

**Please enjoy your Baileigh machine! ....Please enjoy it SAFELY!**

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel should operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Kickback.** Kickback happens when the piece part is thrown back toward the operator at a high rate of speed. Before operating this saw, understand how kickback occurs, and how to prevent it.
5. **Reaching Over Saw Blade. NEVER** reach behind or over the blade with either hand while the saw is operating. If kickback of a piece part were to occur, you could amputate your hands, arms, or fingers.



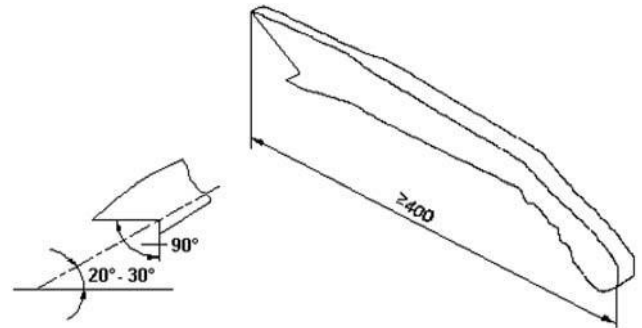
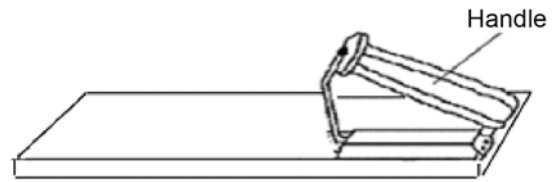
6. **Blade Height.** Adjust the blade to the correct height above the piece part so it does not kickback toward the operator causing injury.
7. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
8. **Blade Guard / Riving Knife.** To reduce the risk of kickback, always use the riving knife and blade guard. Make sure they are properly installed during cutting operations.
9. **Dado and Rabbet Operations.** Dado and Rabbeting operations require that the blade guard be removed. Be aware of your personal safety while the guard is off, and replace the blade guard after these operations are completed.
10. **Keep work area clean.** Cluttered areas invite injuries.
11. **Push Sticks and Push Blocks.** When ripping narrow stock, there is a risk of your hands and fingers contacting the rotating blade, resulting in **serious personal injury.**
12. **Overloading machine.** By overloading the machine, you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
13. **Crosscutting Operations.** Remove the rip fence whenever using the miter gauge to crosscut a piece part.
14. **Operator Position.** If kickback occurs, the blade will eject the piece part into the path of the operator. **NEVER** stand in- line with the cutting path of the blade during operation.
15. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
16. **Awkward Positions.** Avoid awkward hand and body positions where a sudden slip could cause your hands or body to contact the spinning blade.
17. **Use eye and ear protection.** Always wear ISO approved impact safety goggles
18. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
19. **Damaged Saw Blades.** A damaged saw blade can cause kickback. If in doubt as to the condition of the blade, **DO NOT** use it.
20. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
21. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for binding of moving parts that may affect proper machine operation.
22. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
23. **DO NOT** bypass or defeat any safety interlock systems.



24. Know the location of the **ON - OFF** switch and the “**E**”- **STOP** button.
25. **Removing Piece Parts.** Before removing cut-offs, always turn the saw **OFF**, and wait for the blade to stop turning, to avoid contact with a moving blade.
26. **Control of the Piece Part.** If the piece part should unexpectedly move or bind the blade, kickback could occur. Make sure the piece part is supported by either the rip fence or the crosscut fence. **NEVER** back a piece part out of a cut.
27. **Supporting Piece Part.** Provide adequate support to the sides and rear of the saw table for material that is extra wide and long.
28. Keep visitors a safe distance from the work area.
29. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
30. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
31. **DO NOT** touch live electrical components or parts.
32. **Be Sure** all equipment is properly installed and grounded per national, state, and local codes. If machine is equipped with a three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.
33. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
34. **Maintain machine in top condition.** Keep clean for best and safest performance. Follow instructions for lubricating and changing accessories.
35. **Reduce the risk of unintentional starting.** Make sure switch is in “**OFF**” position before plugging in power cord.
36. **Never leave machine running unattended. TURN POWER OFF.** Don't leave machine until it comes to a complete stop.
37. **Make sure machine is disconnected from power supply** while motor is being mounted, connected or reconnected.
38. **Saw Appropriate Material.** Only use this saw for natural wood stock and wood stock products such as particle board, plastics, laminates, and medium-density fiber board (MDF). **DO NOT** try and cut metal, glass, ceramics, or products containing asbestos or lead paint. **Some of these materials contain hazardous dust and can cause severe respiratory problems.**
39. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well-ventilated areas and provide for proper dust removal. Use a wood dust collection system whenever possible.



40. A push block and/or a push stick must be used if the workpieces is less than 5" (127mm) to prevent your hands from getting too close to the saw blade. Push block must be used to cut narrow workpieces and, when necessary, to push the workpiece against the fence, a push block can be easily made by the operator.



### EMERGENCY STOP

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **ON/OFF** switch. Remove the Safety Lockout Key insert to prevent unauthorized startup.

## TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990, and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileigh.com, Phone: 920.684.4990, or Fax: 920.684.3944.



**Note:** The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



**Note:** The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.



## **TECHNICAL SPECIFICATIONS**

Dimensions	Weight	408lbs (185kg)
	L x W x H	60" x 38" x 40" (1524 x 965 x 1016mm)
	Foot Print (L x W)	20.25" x 19.625" (514 x 499mm)
Electrical	Switch	Magnetic with Thermal Overload Protection
	Switch Voltage	220V / 1ph / 60hz (50hz)
Motor	Type	TEFC Capacitor Start Induction
	Horsepower	2.5hp (1.86kw)
	Voltage	220V
	Phase	Single
	Cycle	60hz (50hz)
	Speed	3450rpm (2850rpm)
	Amps	10A (9.6A)
	Power Transfer	V-Ribbed Belt Drive
Blade Information	Maximum Blade Diameter	10" (255mm)
	Riving Knife / Spreader, Thickness	0.1" (2.5mm)
	Required Blade Body, Thickness	0.071"-0.086" (1.8-2.2mm)
	Required Blade Kerf, Thickness	0.102"-0.126" (2.6-3.2mm)
	Maximum Width of Dado	13/16" [.8125"] (20.6mm)
	Blade Tilt	Left 0-45°
	Arbor Size	5/8" [.625"] (16mm)
	Arbor Speed	3850 RPM
	Arbor Bearings	Sealed & Permanently Lubricated
Cutting Capacities	Maximum Depth of Cut At 90°	3.125" (80mm)
	Maximum Depth of Cut At 45°	2.125" (54mm)
	Maximum Rip to Right of Blade – 30"	31.5" (800mm)
	Maximum Rip to Right of Blade – 50"	50" (1270mm)
	Maximum Rip to Left of Blade	11.375" (289mm)
Table Information	Floor to Table Height	34" (864mm)
	Main Table (L x W x T)	20" x 27" x 1.5" (508 x 686 x 38mm)
	Table with Extension Wings (L x W) 30"	40" x 27" (1016 x 686mm)
	Table with Extension Wings (L x W) 50"	60" x 27" (1524 x 686mm)
	Front of Table to Center of Blade	17.25" (438mm)





	Front of Table to Blade, Maximum Cut	12.25" (311mm)
Fence Information	Fence Size (L x W x H)	34.25" x 2.9375" x .59" (870 x 75 x 15mm)
Miter Gauge Information	Miter Gauge Slot Type	T-Slot
	Miter Gauge Slot Type (W x H)	.75" x .375" (19 x 9.5mm)
Other Information	Dust Port Size	4" (102mm)

## **INTENDED USE**

Table saw and the workpiece guide equipment supplied with it are intended to be used exclusively for the following purposes:

- Laminated and unlaminated board materials (e.g. chipboard, coreboard, MDF board, ...)
- Solid wood
- Gypsum plasterboard, Cardboard, Veneer with a suitable clamping device.
- Dimensionally stable plastics (thermoset plastics, thermoplastics). Sawing these materials does not normally involve any risks in respect of dust, chips, and thermal degradation products.

## **Tools:**

The chosen saw blade must be suitable both for the specific work cycle and for the specific material.

- Only circular blades which are solid chrome vanadium (CV) or tungsten carbide tipped (TCT) and have a diameter of 10" (255mm), arbor size 5/8" (16mm), as well as a maximum width of 13/16" (20mm) are allowed for the main saw.
- Saw blades made of high-alloy high-speed steel (HSS) are not allowed to be used.
- Saw blades and their fixing devices shall conform to EN 847-1:2005.



## UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.



**WARNING: SUFFOCATION HAZARD!** Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

## Cleaning



**WARNING: DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.



**CAUTION:** When using cleaning solvents, work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



**Important:** This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.





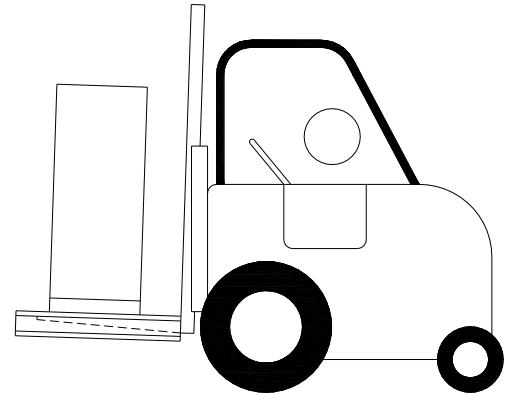
## **TRANSPORTING AND LIFTING**



**IMPORTANT:** *Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.*

### **Follow these guidelines when lifting with truck or trolley:**

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a fork lift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.



## **INSTALLATION**

### **IMPORTANT:**

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.



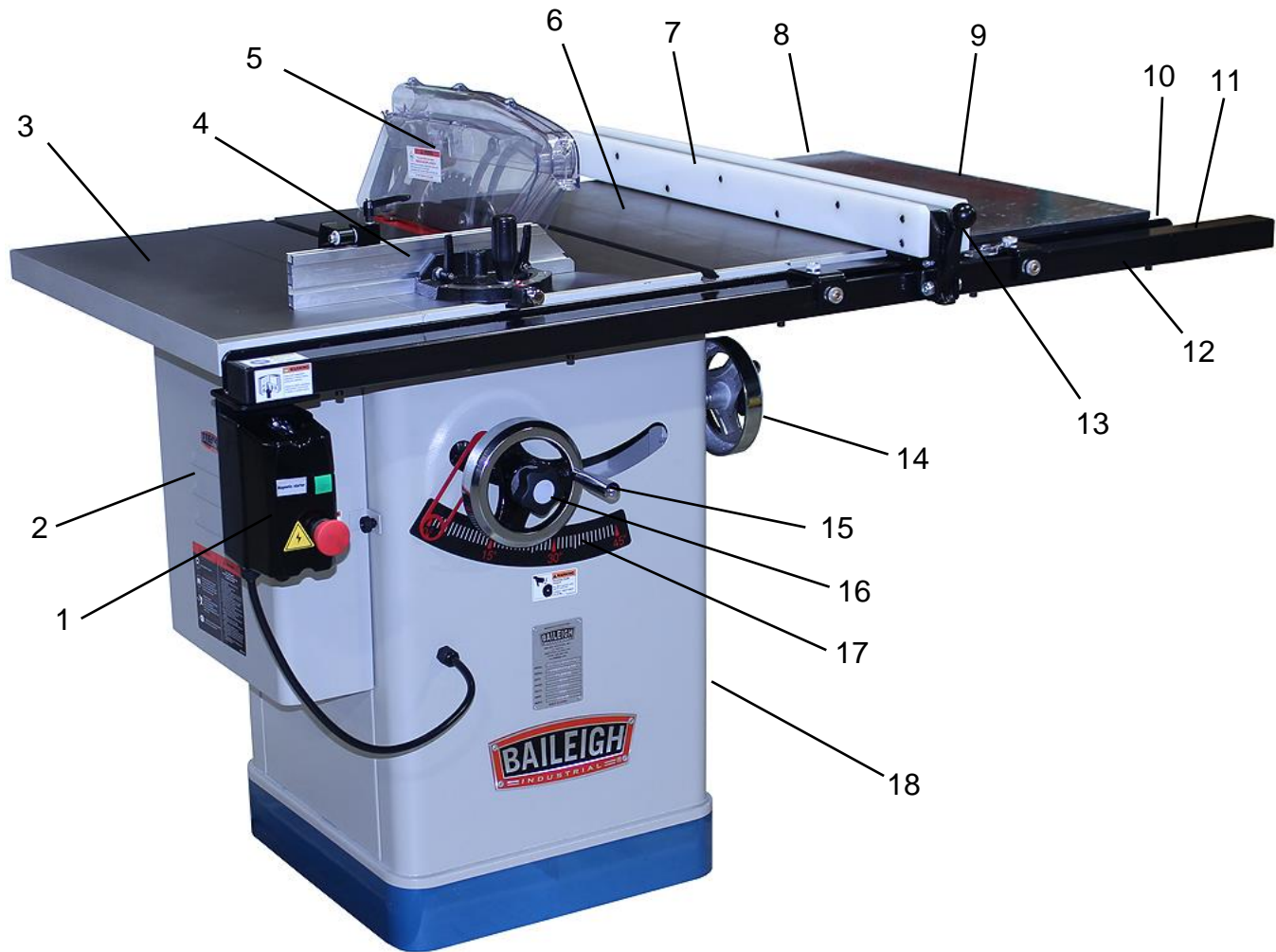
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- It is important to maintain free area around the machine, which is required for the working place. If any long material is machined, it is necessary to have a sufficient room in front of the machine as well behind it in the places of material input and output.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.



**WARNING:** Before operating; make sure it is positioned firmly on a solid work surface. If it tips over on you, it could cause severe injury or death.



## GETTING TO KNOW YOUR MACHINE



### Identification

1.	On/Off Switch; Power Box	10.	Front rail;
2.	Motor Cover	11.	Scale;
3.	Left Extension Wing;	12.	Front Rail Tube;
4.	Miter Gauge;	13.	Fence Lock Handle
5.	Blade Guard;	14.	Blade Tilt Handwheel;
6.	Right Extension Wing;	15.	Blade Height Handwheel;
7.	Fence;	16.	Blade Height Lock;
8.	Back Rail;	17.	Table Tilt Scale;
9.	30" Extension Table	18.	4" (100mm) Dust Port; (hidden)

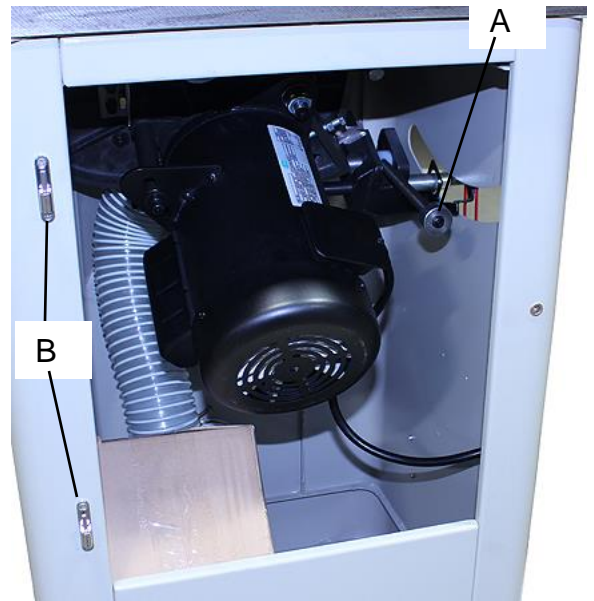


## ASSEMBLY AND SET UP



**WARNING:** For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

1. Turn the tilting lead screw (A) to tilt the motor and trunnion into the 90° position. This will allow for the boxes packed into the cabinet to be removed.
2. Install the door by inserting the door pins into the hinge sockets on the cabinet.



3. Install the handwheels onto the Blade Tilt and Blade Height leadscrew shafts. Engage the slots on the handwheels over the roll pin in the shafts.
4. Use the hand knobs to tighten the handwheels to the shafts just enough so that it is difficult to turn the handwheel to either raise the blade or tilt the blade.
5. Loosen the hand knob 1/2 to 1 turn to allow the handwheels to turn more freely during adjustment.
6. When tightening the hand knobs, Do Not over tighten the knobs.

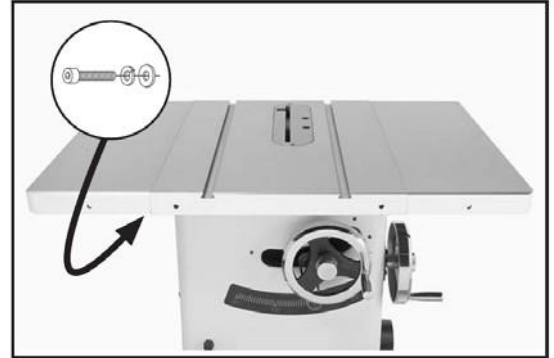




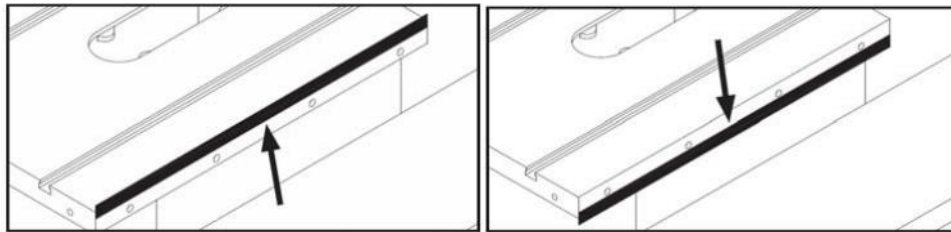


### Extension Wings

7. Inspect the extension wings and main table mating surfaces for burrs or foreign materials that may inhibit assembly.
8. The mating edges of the wings and the table must be clean, smooth, and flat, use a wire brush or file if necessary to clean up the edges, this step will ensure that the wings mount properly to the main table.
9. Loosely attach the wings to the main table with the M10 Flat washers, lock washers and M10 screws.



10. Place the straightedge across the extension wings and main table to make sure that the table surface is flat. Use soft surface clamps to assist as needed.
  - If the outside end of extension wings tilts down or up, use a strip of masking tape to shim the extension wing up or down.



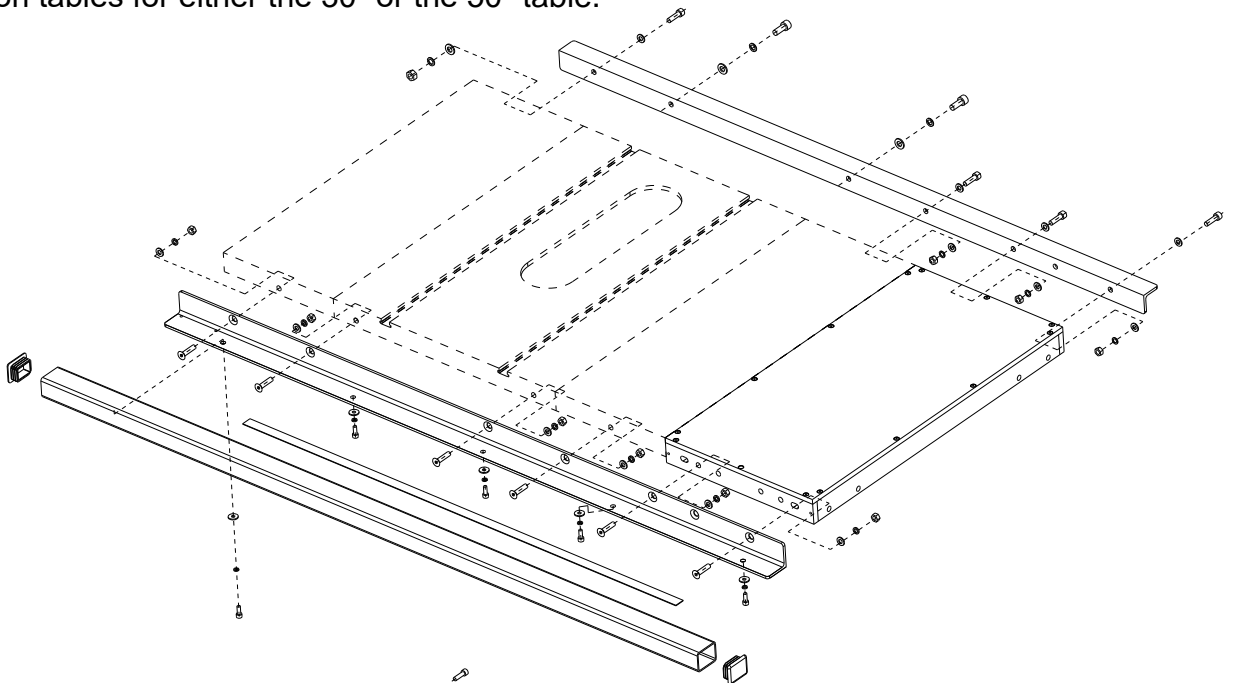
- Shim the top (above the holes) if the table is tilted upward, and shim the bottom (below the holes) if the table is tilted downward.
11. When the tables are aligned, and flat across the entire surface, fully tighten the three M10 screws for each extension.



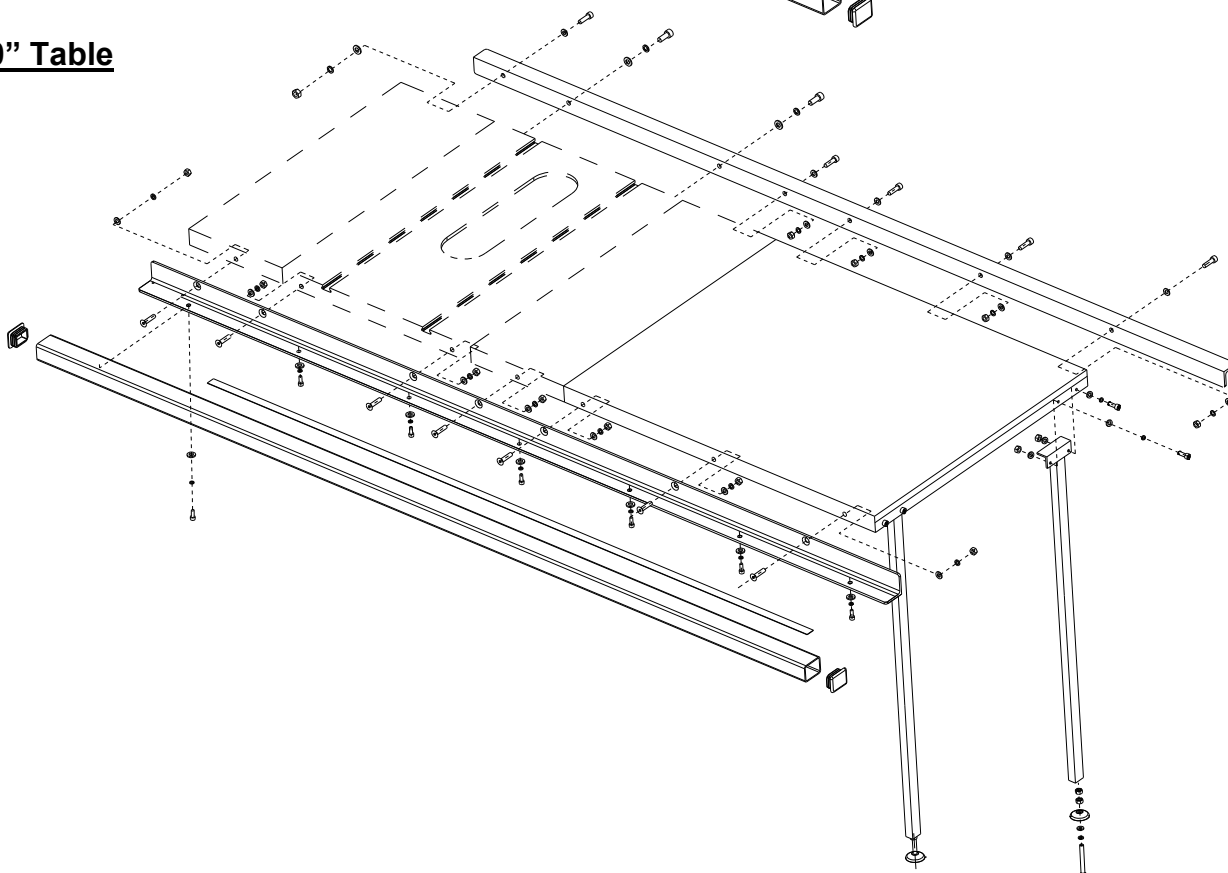
## **Install the Rail & Fence & Extension Table**

1. Use the drawings below to assist in laying out and assembling the fence rails and the extension tables for either the 30" or the 50" table.

### **30" Table**



### **50" Table**



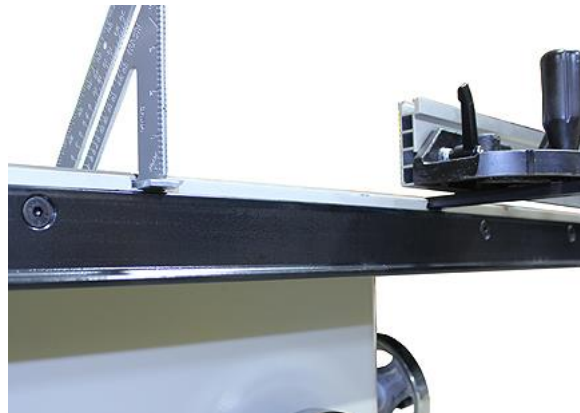


2. Work from the left end of the table toward the right and loosely install the mounting screws to support and align the rails and extensions.



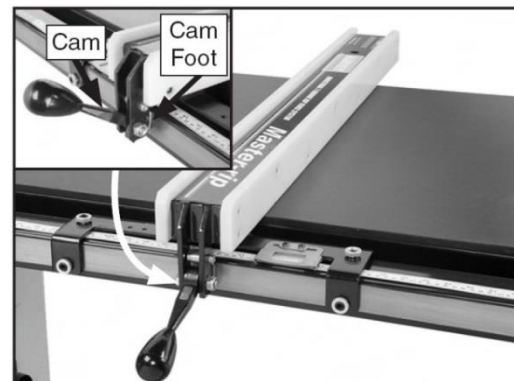
**Note:** Do Not install the fence guide tube onto the front rail until the rails and extensions are aligned and tightened.

3. Using the miter gauge and then another straight edge, allow for a  $1/16"$  (1.58mm) gap between the bottom of the straightedge and the top of the rail.
4. Hold the rail in this position and fully tighten the fasteners
5. Check to make sure the top edge of front and rear rails allow the miter gauge to slide smoothly when installed later.
6. Install and tighten the fence guide tube to the front rail.
7. Place the fence on the rails to the right side of the blade.

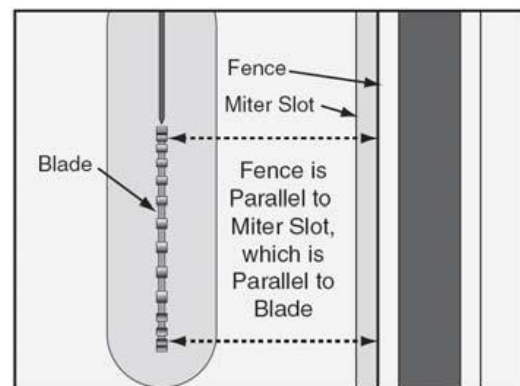


**Note:** Make sure the cam foot contacts the cam on the fence lock handle before you place the fence on the rail, otherwise the fence will not lock into the rail tube.

8. Checking fence parallelism.
  - Slide the fence along the rail. If it drags across the table, adjust the foot at the rear of the fence to raise the fence off of the table just enough so that the gap between the fence and the table is even from front to back.
  - Slide the fence up against the right-hand edge of the miter slot and lock it in place. Examine how the fence lines up with the miter slot.



**Note:** It is permissible for the back of the fence to pivot outward not more than  $1/64"$  (.39mm) from being parallel to the blade. This creates a slightly larger opening between the fence and the blade, at the rear of the blade, to reduce the risk of workpiece binding or burning as it is fed through the cut. Many woodworkers intentionally set up their fence in this manner. Keep this in mind before adjusting your fence.

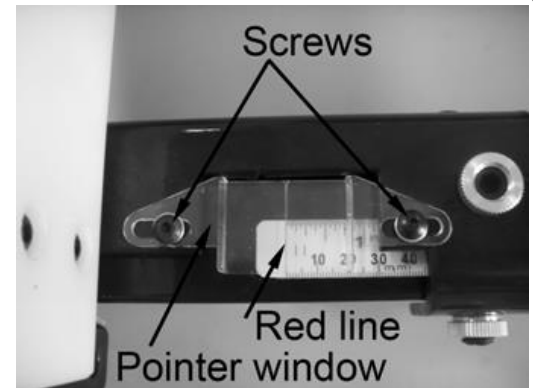


**Important:** Never have the adjustment set to have the back of the fence closer to the blade than the front of the fence.



9. Install the fence scale.

- Slide the fence up against the saw blade, and lock it in place.
- Place the front rail tape scale on the fence tube. Make sure it is parallel with the tube and the "0" end is directly under the red line on the pointer window as shown. Lightly mark the "0" location on the tube with a pencil. Then remove the fence, peel the tape and carefully align the "0" mark on the scale with the pencil mark you made.



- If you make a mistake, loosen the screws on the point window, slide the fence against the blade, and adjust the pointer window, so the red line on the window is over the "0" mark on the tape, then secure the screws.

**Install the Switch**

1. Install the switch mounting bracket onto the bottom left hand side of the front rail using two M5-8 x 8 hex socket bolts, 5mm lock washers, and 5mm flat washers.
2. Install the switch box onto the mounting bracket using the two M5-8 x 10 hex socket bolts supplied in the switch box.



**Install the Miter Gauge**

1. Slide the miter gauge into the T-slot on the left-hand side of the blade.





### **Install / Change the Blade**

The standard blade included with the saw is a general-purpose starter blade. It is recommended that blades be chosen and sourced from a reputable supplier based upon the specific materials and type of cutting being performed.



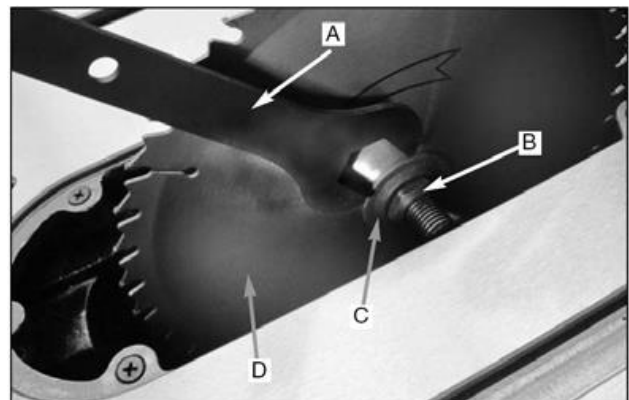
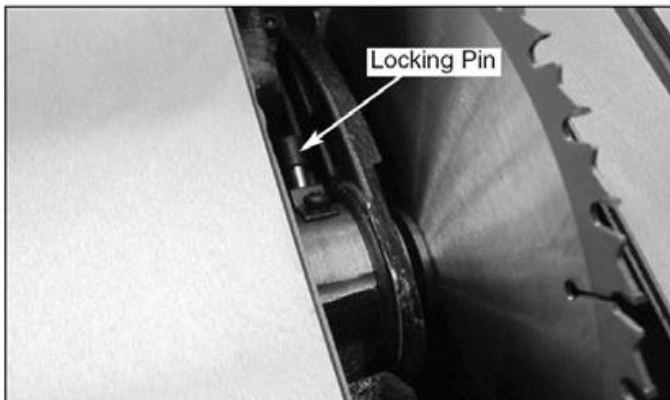
**WARNING:** Turn the power switch “OFF” and unplug the power cord from its power source when changing the saw blade.

Blades are dangerously sharp. Use extreme caution when working with or around the blade. Wear proper safety protection such as heavy gloves.

When replacing blades, check the thickness stamped onto the riving knife. You must select a blade with a kerf width larger than the thickness of the riving knife. Thinner blades may cause the workpiece to bind during cutting.

**USE ONLY 10" diameter blades with 5/8" arbor holes, rated at or higher than 3800 rpm.**

1. Disconnect and lockout power to the saw!
2. Remove blade guard assembly & table insert.
3. Unlock the raise/lower handwheel lock and raise sawblade to maximum height.
4. Depress locking pin and slowly rotate blade toward you until pin engages into arbor. Hold arbor in the locked position.
5. Place supplied open-end wrench (A) on the arbor nut (B). Turn wrench counterclockwise to loosen nut. Remove arbor nut, blade flange (C) and saw blade (D).
6. Place new blade on arbor. Make sure saw blade teeth point down at the front side of saw table. Place flange and nut on arbor and securely snug blade in position.
7. Replace the blade guard assembly & table insert.



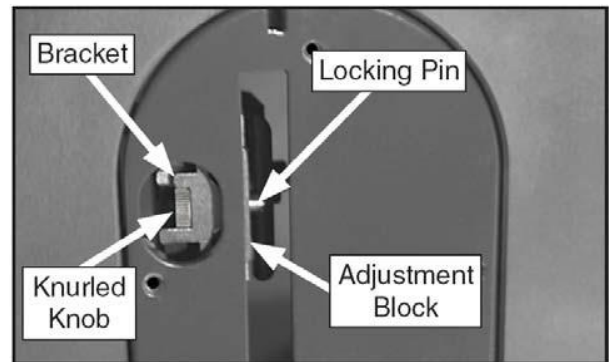


## Install the Blade Guard and Riving Knife

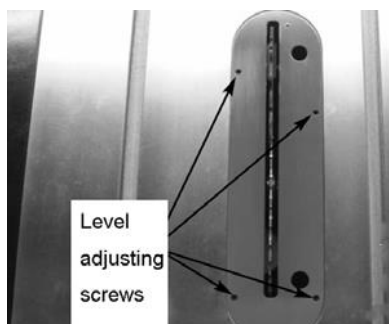


**CAUTION:** After changing a saw blade, always check that the Riving knife or Blade Guard is correctly set!

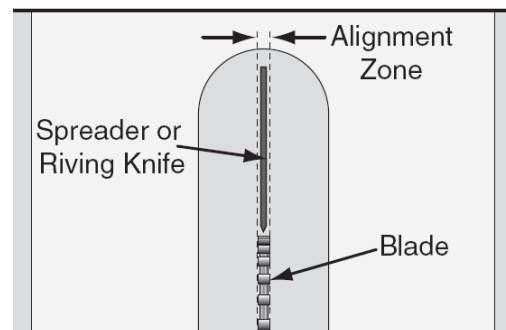
1. Reinstall the insert, slide the knurled knob out and rotate it forward so it engages the upper bracket.
2. Slide the blade guard spreader all the way down into the block, then rotate the knurled knob so it disengages the bracket and the locking pin engages the hole in the center of the spreader.
3. Give the spreader an upward tug to verify that it is locked the blade guard. When properly installed, it should look like Fig. on right, and should pivot freely so it touches the table surface in the down position. It should also swing up high enough to accommodate the workpiece.



4. Adjust the level adjust screws to make sure the table insert is flush with the table.
5. Place a straightedge against the blade and the spreader. When properly aligned, the spreader/riving knife will be in the "alignment zone," shown in Fig, and will be parallel with the blade.



Insert



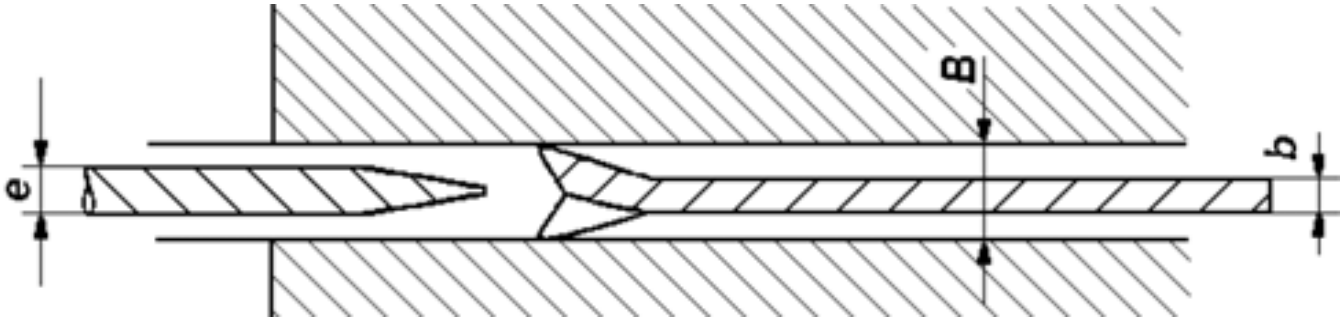
Alignment zone





After changing a saw blade, always check that the Riving knife or Blade Guard is correctly set!

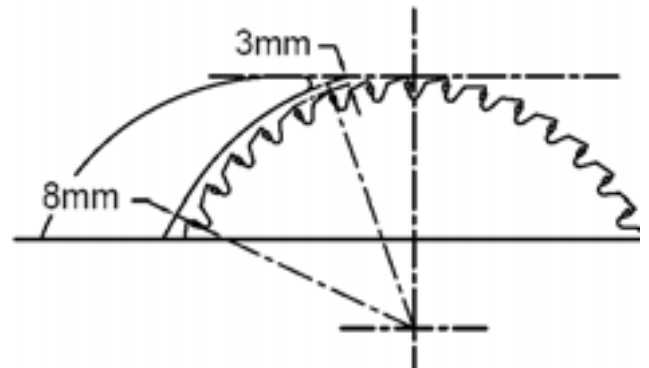
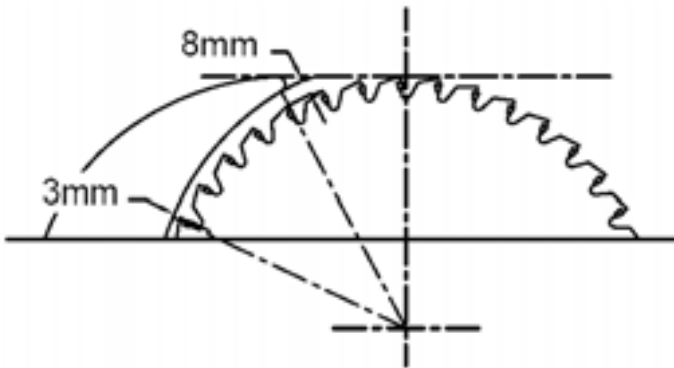
- e Riving Knife Thickness
- b Saw Blade Thickness
- B Blade Kerf (width of saw blade cut)



6. The distance of the riving knife from the gear rim must be between 3mm and 8mm. measured radially through the center of the saw spindle.



**Note:** The highest point of the riving knife must be set beneath the topmost teeth on the blade.





### **Dust collection**

It is recommended that you use a dust collector (not included) when using this machine. The minimum air flow requirements for this machine are listed below. The machine comes with a 4" (100mm) dust port located on the side of the machine.

The dust extraction equipment is to be switched on before commencing machining.

Air current speed is 20m/s for vacuum suction dust emission index.

When air current speed of dust collector device (in accordance with EN12779:2004) is not lower than 20m/s, ensure machine can be normal exhausted. User must wear dustproof mask.

1. Required air flow: 1500 m<sup>3</sup>/h.
2. Ensure pressure drop of each dust collector outlet carrying air current speed: 1100Pa.
3. Wind speed of dust collector tube m/s:  
Dry Chips: 20m/s,  
Wet chips: 28m/s (water content is equal to 18%)





## **ELECTRICAL**



**CAUTION:** HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

Check if the available power supply is the same as listed on the machine nameplate.



**WARNING:** Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

### **Power Specifications**

Your tool is wired for 220 volts, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is  $\pm 5\%$ , and for the frequency is  $\pm 1\%$ .

### **Considerations**

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your tools. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.



**WARNING:** In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.



- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Repair or replace damaged or worn cord immediately.

### **Extension Cord Safety**

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

	LENGTH		
AMP RATING	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
	WIRE GAUGE		

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

### **Power cord connection:**

1. Turn the main disconnect switch on the control panel to the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
  - a. Route the power cord so that it will NOT become entangled in the machine in any way.
  - b. Route the cord to the power supply is a way that does NOT create a trip hazard.
3. Have an electrician install the correct plug for the application.
4. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
5. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation. Turn the switch OFF when the machine is not in operation.





## **ADJUSTMENT**



**WARNING:** Make sure the electrical disconnect is OFF before working on the machine.

Always follow proper safety precautions when working on or around any machinery.

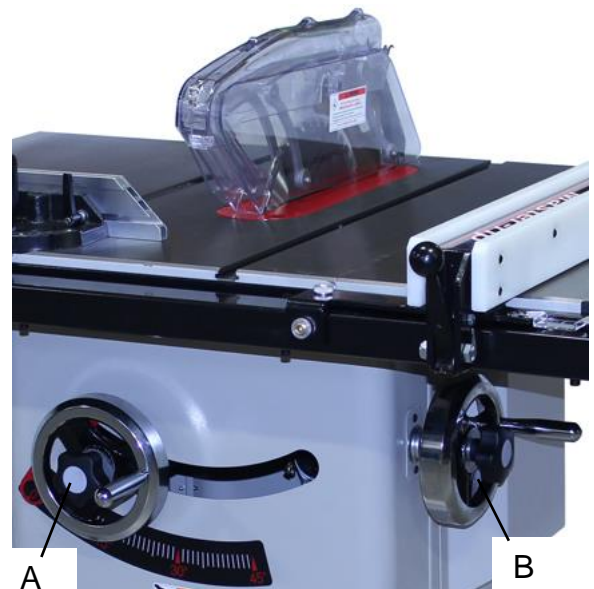
Before operation, the machine should be carefully adjusted for best performance.

### **Blade Raising and Tilting Mechanism**

1. To raise or lower the blade, use the handwheel (A) located on the front of the saw cabinet. Loosen lock knob and turn handwheel as needed.
2. When desired height is obtained, tighten lock knob.

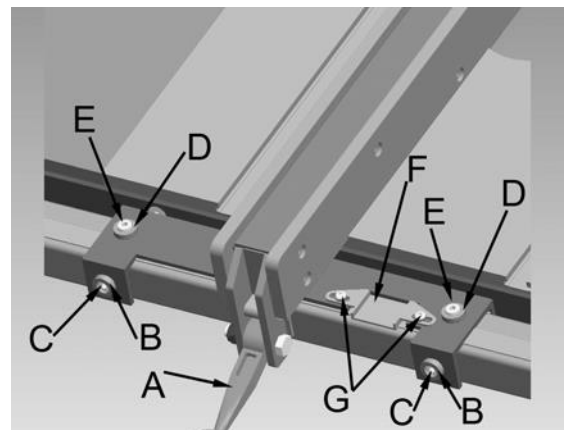
The blade should be raised 1/8" to 1/4" (2 - 6mm) above the top surface of the material being cut. With hollow ground blades the blade should be raised to the maximum to provide chip clearance.

3. To tilt the saw blade, use the handwheel (B) located on the side of the saw cabinet. Loosen lock knob and turn handwheel as needed.
4. When desired angle is obtained, tighten lock knob.



### **Adjusting Rip Fence**

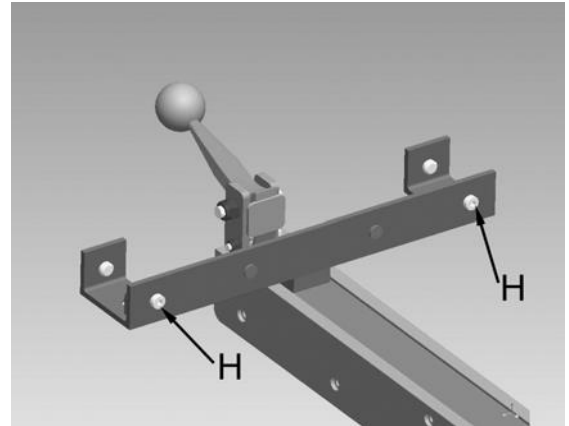
1. The rip fence must be perfectly aligned with the table T-slot, to verify this, align the edge of the rip fence with the table T-slot and lower the locking lever (A) to lock in into place.
2. Check to see if the edge of the rip fence and the table T-slot are parallel.
3. If they are not parallel, unlock the rip fence and turn it upside down.
4. Adjust the set screws (H, next page) in or out. Verify your adjustment, repeat if necessary.
5. The lock lever pressure can be adjusted by loosening the front lock nuts (B) and adjusting the set screws (C) the same amount, make sure the fence remains parallel with the table T-slot. Retighten lock nuts.





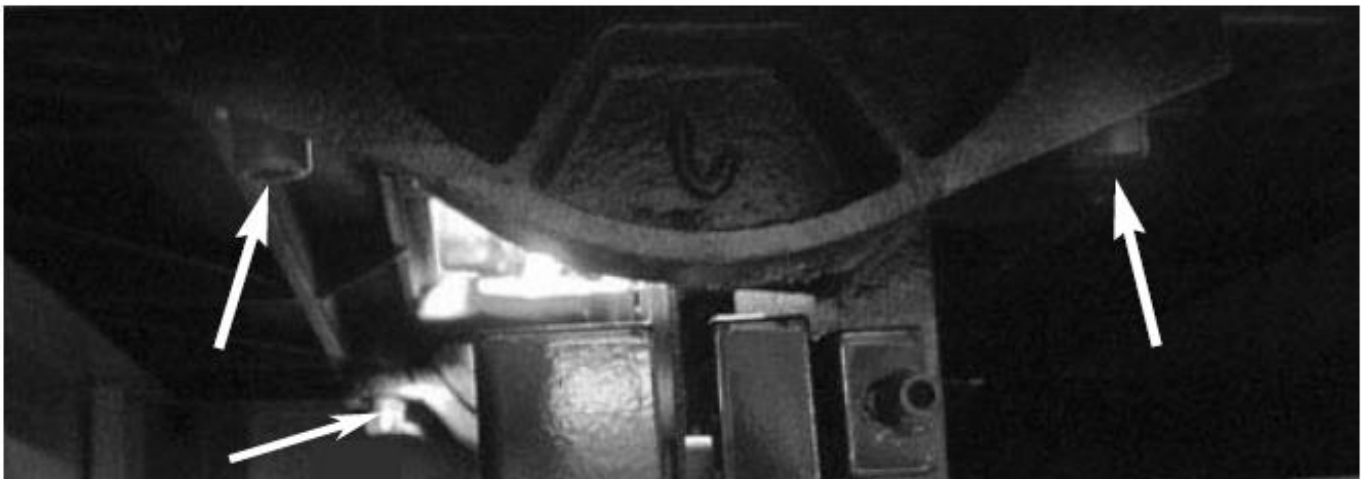
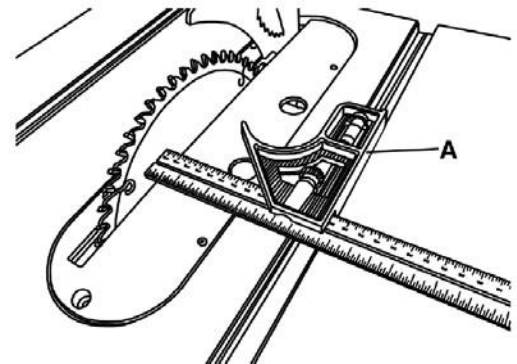


6. To set the fence perpendicular to the table, place a square on the table and against the side of the fence, loosen the top lock nuts (D) and adjust the setscrews (E) until the fence is perpendicular. Retighten lock nuts.
7. The pointer window (F) position can be adjusted if needed. Loosen pan head screws (G), reposition the pointer window and retighten pan head screws.



### **Aligning Table T-Slot Parallel with Blade**

1. The table T-slot must be aligned parallel with the blade. Using a combination square (A), measure the distance from the back edge of the blade to the table T-slot.
2. Pivot blade forward 180° and measure the distance using the exact same point on the blade. The difference between both measurements must be equal to or less than 1/64" (0.39mm).
3. If an adjustment is necessary, loosen the screws which fix the table.
4. Make the needed adjustment until both measurements are equal or less than 1/64" (0.39mm) and retighten the screws.

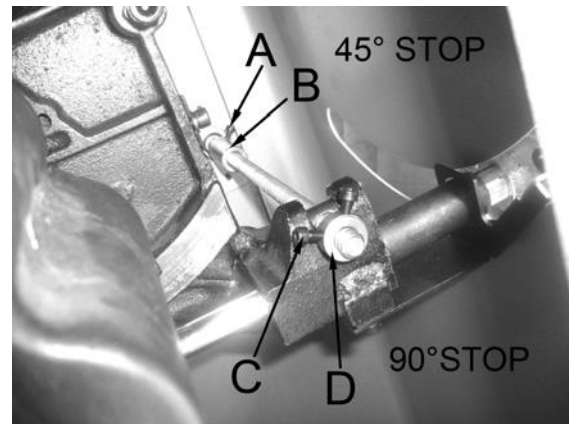




### **Adjusting 45 and 90 Degree Positive Stops**

The blade tilting mechanism of your saw is equipped with a positive stop at 45 and 90 degrees. To check and adjust these positive stops, proceed as follows:

1. Raise the saw blade to its maximum height.
2. Set the blade at 90 degrees to the table by turning the blade tilting handwheel counterclockwise as far as it will go.
3. Place a square on the table and check to see if the blade is at a perfect 90 degree angle to the table.
4. If the blade is not at 90 degrees loosen lock nut (C) and turn stop ring (D) in or out. The stop ring (D) should stop against the front trunnion bracket when the blade is at 90 degrees to the table. Recheck and adjust further if necessary. Retighten lock nut (C).
5. If the 45 degree positive stop is not set properly, turn the same handwheel clockwise as far as it will go and follow the same procedure using lock nut (A) and stop ring (B). The stop bolt (B) should stop against the front trunnion bracket when the blade is at 45 degrees to the table. Recheck and adjust further if necessary. Retighten lock nut (A).





## OPERATION

### Safety Precautions Before Operations

The operation of power tools involves a certain amount of hazard for the operator. Before attempting regular work, we recommend you get the feel of operations using scrap lumber to check settings. Read entire instructions before you start to cut workpiece.

**Always** pay attention to safety precautions to avoid personal injury.



**WARNING:** Never operate the saw with any guards or covers removed missing or damaged. It could cause severe injury or death.



**CAUTION:** Always wear proper eye protection with side shields or a face shield, safety footwear, dust mask, and possibly heavy gloves to protect from, chips, dust, burrs, and slivers.



**WARNING:** Check that saw blade clamping system is tight before operating the machine.

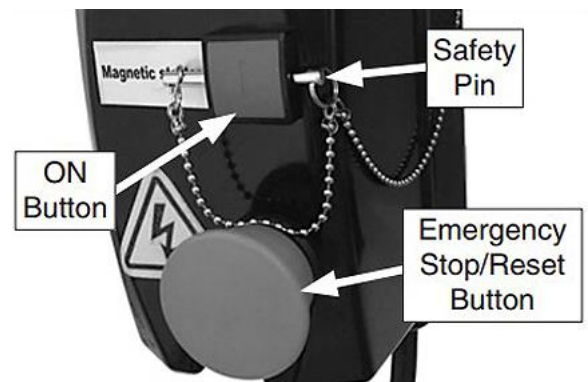
### Electrical Operation

Become familiar with the location and operation of the Start and Stop buttons. Practice reaching for the buttons, especially the Stop button, with power disconnected from the saw.

- ON Button: Starts the motor.
- Safety Pin & Chain: When installed, disables the ON Button to prevent accidental startup.
- Emergency Stop/Reset Button: Turns machine OFF. Rotate clockwise to reset.



**IMPORTANT:** DO NOT stand directly in line with the saw blade when starting.





## **Operation**

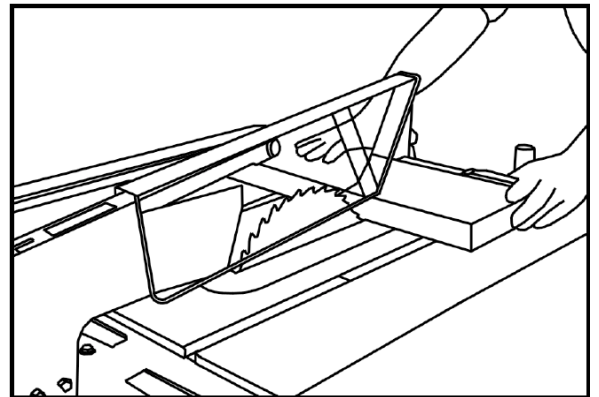
Plain sawing includes ripping and crosscutting, plus a few other standard operations of a fundamental nature.

- As with all power tools there is a certain amount of hazard involved with the operation and use of the saw.
- Using the saw with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. If normal safety precautions are overlooked or ignored, personal injury to the operator can develop.
- It is good practice to make trial cuts using scrap material when setting up you saw for operation.

## **Crosscutting**

Crosscutting requires the use of the miter gauge to position and guide the workstock.

- Place the workstock against the miter gauge and advance both the miter gauge and workstock toward the saw blade.
- The miter gauge may be used in either table slot, however, most operators prefer the left groove for average work.
- When bevel cutting (blade tilted), use the table groove that does not cause interference of your hand or miter gauge with the saw blade guard.
- Start the cut slowly and hold the workstock firmly against the miter gauge and the table.
- One of the rules in running a saw is that you never hang onto or touch a free piece of workstock.
- Hold the supported piece, not the free piece that is cut off.
- The feed in crosscutting continues until the workstock is cut in two.
- The workstock is then slid sideways slightly away from the blade and then the miter gauge and workstock are pulled back to the starting point.
- Never pick up any short length of free workstock from the table while the saw is running.
- A smart operator never touches a cut-off piece unless it is at least a foot long.
- Never use the fence as a cut-off gauge when crosscutting.
- Never use the miter gauge in combination with the rip fence.

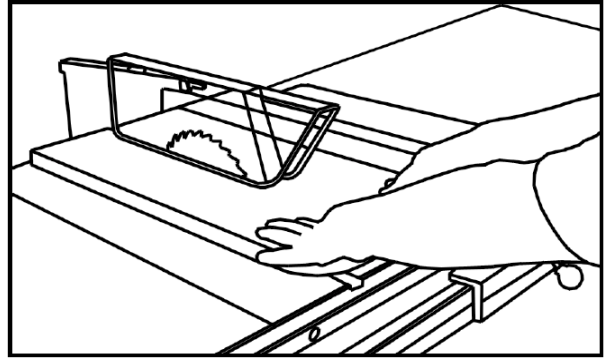




## **Ripping**

Ripping is the operation of making a lengthwise cut through a board.

- The rip fence is used to position and guide the workstock.
- One edge of the workstock rides against the rip fence while the flat side of the board rest on the table.
- Since the workstock is pushed along the fence, it must have a straight edge and make solid contact with the table.
- The saw guard must be used. The guard has anti-kickback fingers and a splitter to prevent the saw kerf from closing.
- Start the motor and advance the workstock holding it down and against the fence.
- Never stand in direct line of the saw blade cut when ripping.
- Hold the workstock with both hands and push it along the fence and into the saw blade. The workstock can then be fed through the saw blade with one or two hands.
- When this is done, the workstock will either stay on the table, tilt up slightly and be caught by the rear end of the guard or slide off the table to the floor.
- Alternately, the feed can continue to the end of the table, after which the workstock is lifted and brought back along the outside edge of the fence.
- The waste stock remains on the table and is not touched with the hands until the saw is stopped unless it is a large piece allowing safe removal.





## Using Dado Blade Set and Dado Insert



**WARNING:** Blades are dangerously sharp. Use extreme caution when working with or around the blade. Wear proper safety protection such as heavy gloves.

Dadoing is cutting a rabbet or a wide groove into the work.

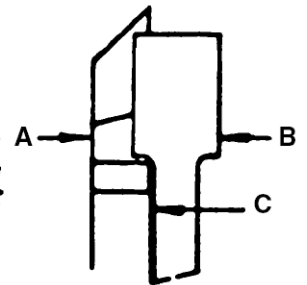
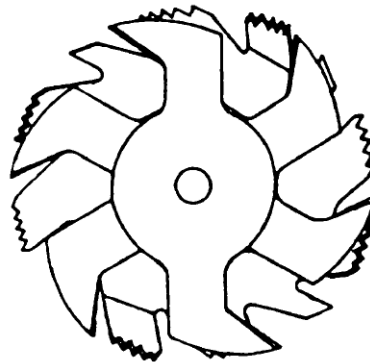
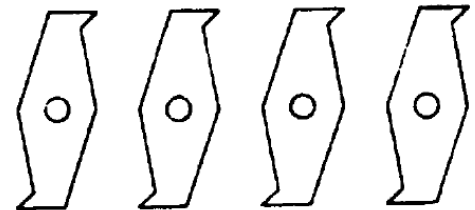
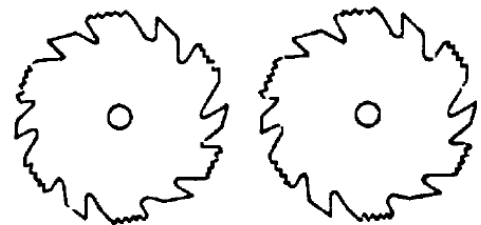
Most dado head sets are made up of two outside blades and four or five inside cutters.

Various combination of saws and cutters are used to cut grooves from 1/8" to 13/16" for use in shelving, making joints, tenoning, grooving, etc.

The cutters are heavily swaged and must be arranged so that this heavy portion falls in the gullet of the outside blades.

The saw and cutter overlap (A) being the outside blade, (B) and inside cutter, and (C) a paper washer which can be used as needed to control the exact width of groove.

A 1/4" (6.3mm) groove is cut by using the two outside blades. The teeth of the blades should be positioned so that the raker on one saw is beside the cutting teeth on the other saw. The dado head set is assembled to the saw arbor in the same manner as the saw blade.



**Important:** The guard splitter and anti-kickback finger assembly cannot be used during dadoing operations and must be removed from the saw. The dado head table insert must be used in place of the standard table insert during dado operations.



**WARNING:** NEVER use the dado head in a bevel position unless you make your own dado insert!  
**ALWAYS** install blade guard after operation is complete!





## MAINTENANCE



**WARNING:** Make sure the electrical disconnect is OFF before working on the machine. Maintenance should be performed on a regular basis following proper safety precautions.

This table saw requires very little maintenance other than minor lubrication and cleaning. The following sections detail what will need to be done to assure continued operation of your saw.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.
- Clean and oil the tables so that the material will slide easily. Clean any rust spots that may develop on the bed with a commercial rust remover.
- Use a vacuum to clean out the interior of the machine to keep chips and sawdust from accumulating on the belts and pulleys.



**Note:** When cleaning chips and debris from the machine, use a brush and a shop vacuum. **DO NOT** blow off the machine with compressed air. The force of the compressed air may force chips into critical mechanisms or may inflict injury to yourself or others.

- Check the drive belt for tightness. It should be snug but not overly tight.
- Use a mill file to remove any nicks or dings from the infeed or outfeed tables.



**Note:** Proper maintenance can increase the life expectancy of your machine.



### **Cleaning**

Cleaning the 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.

After cleaning, treat all unpainted cast iron and steel with a non-staining lubricant.

Occasionally it will become necessary to clean the internal parts with more than a vacuum. To do this, remove the table top and clean the internal parts with resin/pitch dissolver or mineral spirits and a stiff wire brush or steel wool.

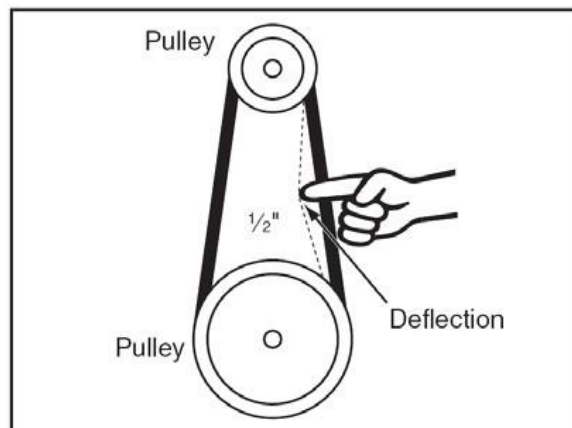
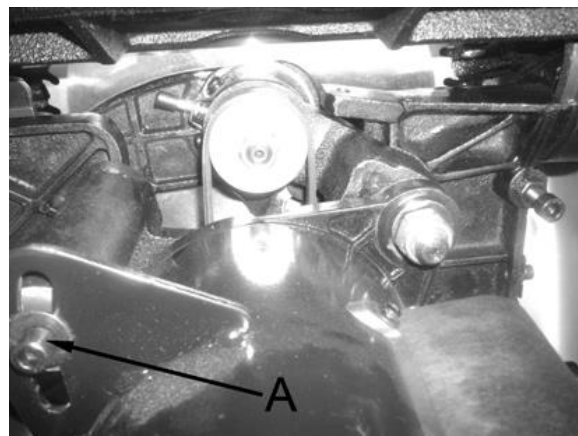
Make sure the internal workings are dry before using the saw again, so that wood dust will not accumulate. If any essential lubrication is removed during cleaning, re-lubricate those areas.

### **Lubrication**

The table saw has sealed lubricated bearings in the motor housing and the arbor assembly, they will not require any additional lubrication. Use a wire brush to clean off the worm gears and trunnions and apply a white lithium grease to keep them lubricated.

### **Changing Belts**

1. Make sure the power cord is disconnected from the power source!
2. Lower the blade completely, and then open the motor access cover.
3. Loosen the hex nuts that secure the motor (A) and raise the motor fully to remove tension on the V-belts.
4. Roll the V-belts off of the arbor and motor pulleys.
5. While continuing to raise the motor, install a new matching set of V-belts onto the pulleys, lower the motor to tension the V-belts, then tighten the hex nuts.
6. Check V-belt tension.
7. Close the motor access cover.





## **TROUBLESHOOTING**

**⚠ WARNING:** Disconnect machine from the power source before attempting any troubleshooting

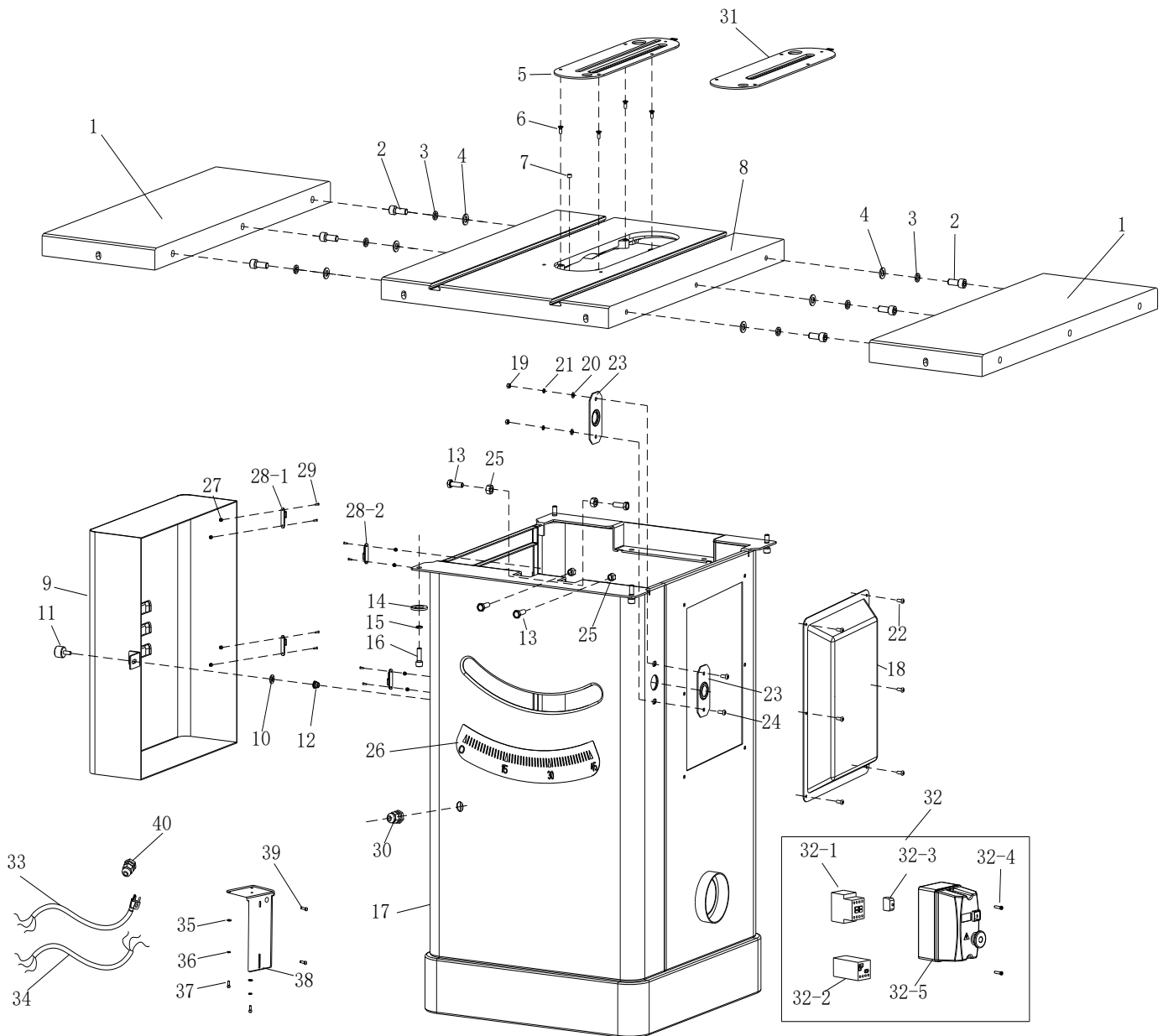
PROBLEM	SOLUTION
<b>SAW WILL NOT START</b> 1. Saw not plugged in. 2. Fuse blown or circuit breaker tripped. 3. Cord damaged.	1. Plug in saw. 2. Replace fuse or reset circuit breaker. 3. Have cord replaced by a certified electrician.
<b>OVERLOAD KICKS OUT FREQUENTLY</b> 1. Extension cord too light or too long. 2. Feeding stock too fast. 3. Blade in poor condition (dull, warped, gummed). 4. Blade binding due to misaligned rip fence. 5. Blade binding due to warped wood. 6. Low house current.	1. Replace with adequate size cord 2. Feed stock more slowly. 3. Clean or replace blade. 4. Check and adjust the rip fence. See rip fence instructions. 5. Select another piece of wood. 6. Contact your electrical company.
<b>DOES NOT MAKE ACCURATE 45 AND 90 RIP CUTS</b> 1. Positive stop(s) not adjusted properly. 2. Tilt angle pointer not set properly.	1. Check blade with square and adjust positive stop. 2. Check blade with square and adjust pointer to zero.
<b>MATERIAL PINCHES BLADE WHEN RIPPING</b> 1. Rip fence not aligned with blade. 2. Warped wood.	1. Check and adjust rip fence. 2. Select another piece of wood.
<b>MATERIAL BINDS ON SPLITTER</b> 1. Splitter not aligned correctly with blade kerf.	1. Check and align splitter with blade kerf.
<b>SAW MAKES UNSATISFACTORY CUTS</b> 1. Dull blade. 2. Blade mounted backwards. 3. Gum or pitch on blade. 4. Incorrect blade for work being done. 5. Gum or pitch on table causing erratic feed.	1. Replace blade. 2. Turn blade around. 3. Remove blade and clean with turpentine and steel wool. 4. Change the blade. 5. Clean the table with turpentine and steel wool.



<b>BLADE DOES NOT COME UP TO SPEED</b> 1. Extension cord too light or too long. 2. Low house current. 3. Motor not wired for correct voltage.	1. Replace with adequate size extension cord. 2. Contact your electric company. 3. Refer to motor and /or nameplate.
<b>MACHINE VIBRATES EXCESSIVELY</b> 1. Table not mounted securely to cabinet stand. 2. Stand is on uneven floor. 3. Damaged saw blade. 4. Bad V-belt(s). 5. V-belts not tensioned properly. 6. Bent pulley. 7. Improper motor mounting. 8. Loose hardware.	1. Tighten all mounting hardware. 2. Reposition on flat level surface. 3. Replace blade. 4. Replace V-belt(s). 5. Adjust V-belt tension. 6. Replace pulley. 7. Check and adjust motor mounting. 8. Tighten all nuts, bolts and set screws.
<b>BLADE DOES NOT RAISE OR TILT FREELY</b> 1. Sawdust or dirt in raising or tilting mechanisms.	1. Brush or blow out loose dust or dirt.



## TABLE SAW BODY PARTS DIAGRAM





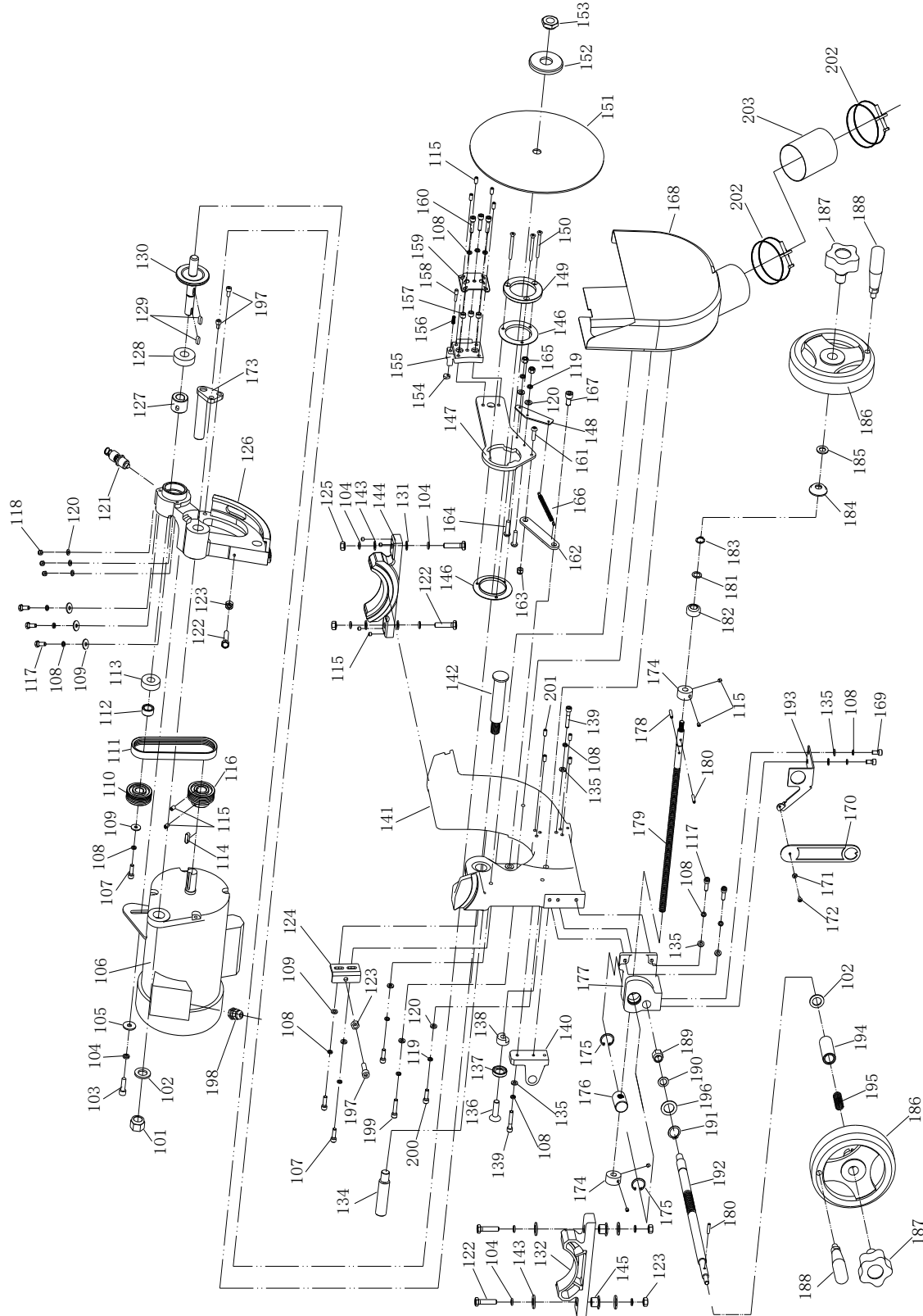
### Table Saw Body Parts List

Item	Description	Qty.	Item	Description	QTY.
1	Extension Wing	2	25	Hex Nut 8mm	2
2	Cap Screw M10 X 25	6	26	Angle Scale	1
3	Lock Washer 10mm	6	27	Lock Nut 3mm	8
4	Flat Washer 10mm	6	28-1	Upper Hinge	2
5	STD Table Insert	1	28-2	Lower Hinge	2
6	Flat Head Screw M5 X 10	4	29	Flat Head Screw M3x 12	8
7	Magnet	1	30	Strain Relief	1
8	Main Table	1	31	Dado Insert	1
9	Motor Cover	1	32	Mag Switch Assembly Ms-15	1
10	Tooth Washer 6mm	1	32-1	Contactor Chint NC1-18	1
11	Knob M6-1	1	32-2	OL Relay Chint NR2-25 12-18	1
12	Riveted Nut 6x15mm	1	32-3	On/Off Switch Chint NP2	1
13	Hex Bolt M8 X 25	4	32-4	Tap Screw M4.8x19	2
14	Flat Washer(W) 8mm	8	32-5	Switch Box Front/Back	1
15	Lock Washer 8mm	6	33	Power Cord	1
16	Cap Screw M8 X 25	4	34	Motor Cord	1
17	Cabinet	1	35	Flat Washer 5mm	2
18	Cover Plate	1	36	Lock Washer 5mm	2
19	Hex Nut 5mm	2	37	Cap Screw M5 X 14	2
20	Flat Washer 5mm	8	38	Switch Bracket	1
21	Lock Washer 5mm	8	39	Cap Screw M5 X 16	2
22	Button Head Screw M5x 12	6	40	Strain Relief	2
23	Plate	2	41	Set Screw M5x 8	2
24	Button Head Screw M5x 16	2	\		





## TRUNNION ASSEMBLY PARTS DIAGRAM





### Trunnion Assembly Parts List

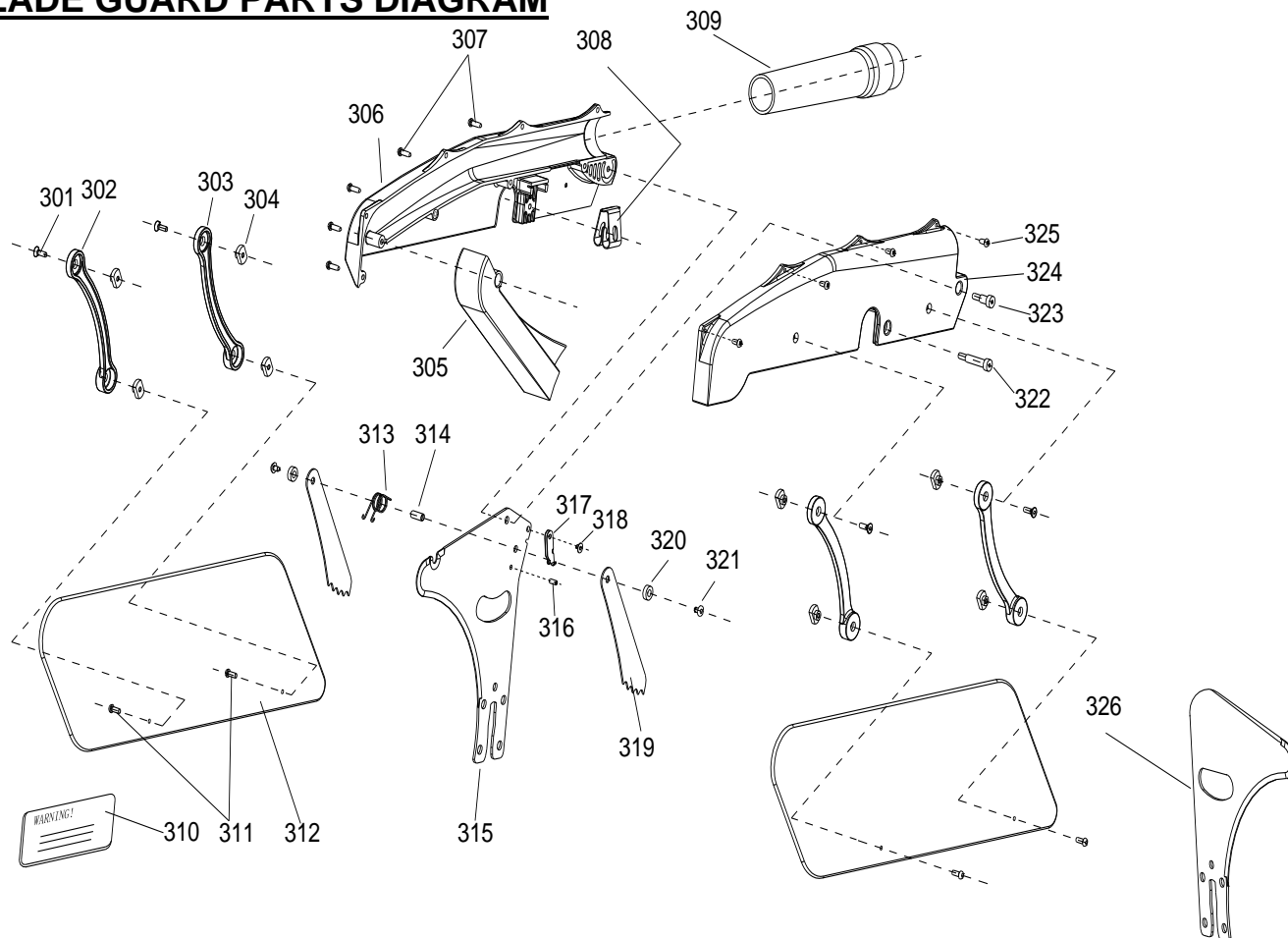
Item	Description	Qty.	Item	Description	Qty.
101	Lock Nut M16	1	153	Arbor Nut	1
102	Flat Washer 16mm	2	154	Knurled Knob	1
103	Cap Screw M8x 25	1	155	Splitter Adjust Block	1
104	Lock Washer 8mm	9	156	Spring	1
105	Flat Washer(W) 8mm	1	157	Spacer	3
106	Motor	1	158	Locking Pin	1
107	Cap Screw M6x 16	3	159	Splitter Tighten Clip	1
108	Lock Washer 6mm	17	160	Cap Screw M6x 25	3
109	Flat Washer 6mm	7	161	Button Head Screw M6x 20	1
110	Arbor Pulley	1	162	Connected Plate	1
111	V-Belt PJ150	1	163	Lock Nut 6mm	1
112	Bushing	1	164	Button Head Screw M5x 16	3
113	Bearing 6202ls	1	165	Hex Nut 5mm	2
114	Key 6 X 6 X 20	1	166	Spring	1
115	Set Screw M6x 8	14	167	Shoulder Screw M6	1
116	Motor Pulley	1	168	Dust Collector Case	1
117	Hex Bolt M6x 16	3	169	Cap Screw M5x12	2
118	Lock Nut M5	3	170	Pointer	1
119	Lock Washer 5mm	7	171	Flat Washer(W) 5mm	1
120	Flat Washer 5mm	7	172	Button Head Screw M4x 8	1
121	Blade Brake Device	1	173	Motor Fixed Shaft	1
122	Hex Bolt M8x40	5	174	Tilt Limit Block	2
123	Hex Nut M8	3	175	Internal Retaining Ring 24	2
124	Height Limit Block	1	176	Tilt Leadscrew Nut	1
125	Lock Nut M8	2	177	Tilt Leadscrew Base	1
126	Motor Mount	1	178	Roll Pin 4x16	1
127	Arbor Bushing	1	179	Tilt Leadscrew	1
128	Bearing 6202-2rs	1	180	Roll Pin 4x 20	2
129	Key 5 X 5 X 15	2	181	Flat Washer 12mm	2
130	Arbor	1	182	Bearing Washer	1
131	Flat Washer 8mm	2	183	External Retaining Ring 12	1
132	Front Trunnion	1	184	Beveled Bushing	1
133	/	/	185	Washer 12mm	1



Item	Description	Qty.	Item	Description	Qty.
134	Limit Block	1	186	Handwheel	2
135	Flat Washer 6mm	6	187	Locking Handle	2
136	Flat Head Screw M10x30	1	188	Handwheel Handle	2
137	Spacer	1	189	Lock Nut 12mm	1
138	Nylon Spacer	1	190	Flat Washer 12mm	1
139	Cap Screw M6x 35	2	191	External Retaining Ring 16	1
140	High Shaft Bracket	1	192	Elevation Shaft	1
141	Main Trunnion	1	193	Pointer Base	1
142	Motor Shaft	1	194	Handwheel Bushing	1
143	Flat Washer(W) 8mm	6	195	Compression Spring	1
144	Rear Trunnion	1	196	Elevation Shaft Spacer	1
145	Adjustment Screw	2	197	Cap Screw M8x 20	3
146	Nylon Gasket	2	198	Strain Relief	1
147	Splitter Bracket	1	199	Cap Screw M5x 30	1
148	Spring Bracket	1	200	Cap Screw M5x 20	2
149	Flange Ring	1	201	Set Screw M6x 20	4
150	Flat Head Screw M5x 50	3	202	Wire Hose Clamp	2
151	Blade	1	203	Clear Flexible Hose	1
152	Arbor Flange	1			



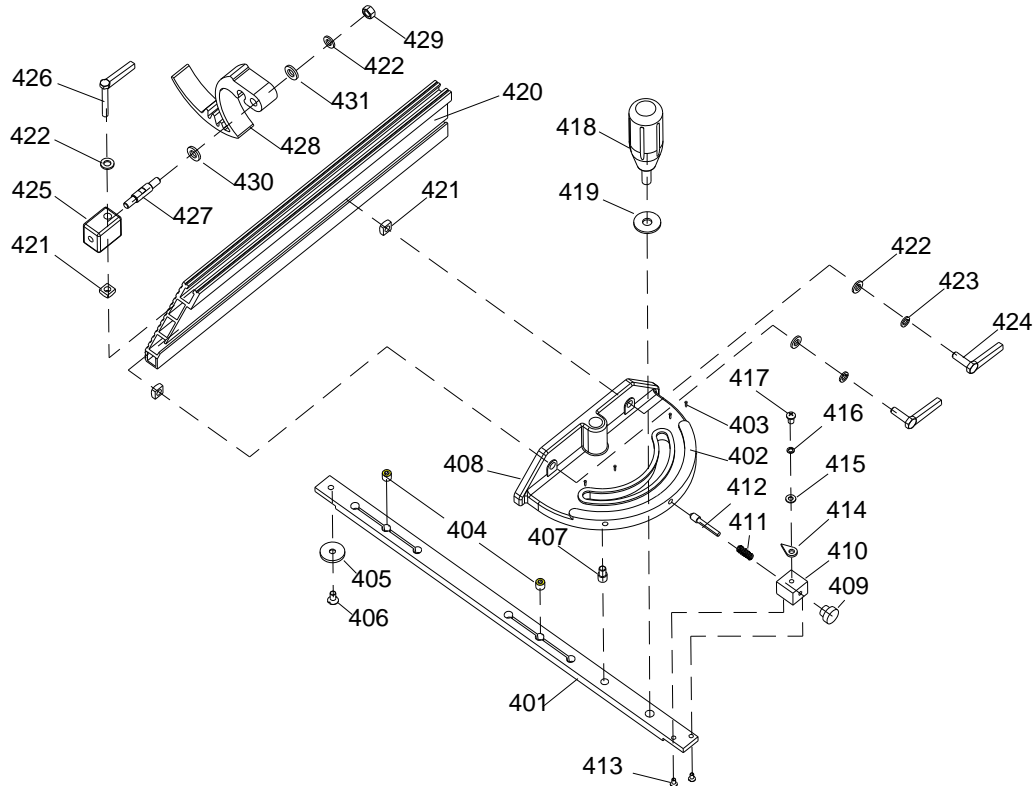
## BLADE GUARD PARTS DIAGRAM



Item	Description	Qty.	Item	Description	Qty.
301	Flat Head Screw M4x10	4	314	Pawl Shaft	1
302	Guard Support 1	2	315	Splitter	1
303	Guard Support 2	2	316	Roll Pin 4x16	1
304	Stepped Nut M4	8	317	Pawl Hook	1
305	Vacuum Cleaner	1	318	Rivet 4x8	1
306	Left Guard	1	319	Pawl	2
307	Tap Screw M3.5x16	5	320	Spacer	2
308	Spring Clamp	1	321	Button Head Screw M4x 6	2
309	Dust Outlet Port	1	322	Shoulder Screw M6.5x25	1
310	Warning Label	2	323	Shoulder Screw M6.5x10	1
311	Button Head Screw M4x10	4	324	Right Guard	1
312	Side Guard	2	325	Tap Screw M2.9x9.5	4
313	Torsion Spring	1	326	Riving Knife	1



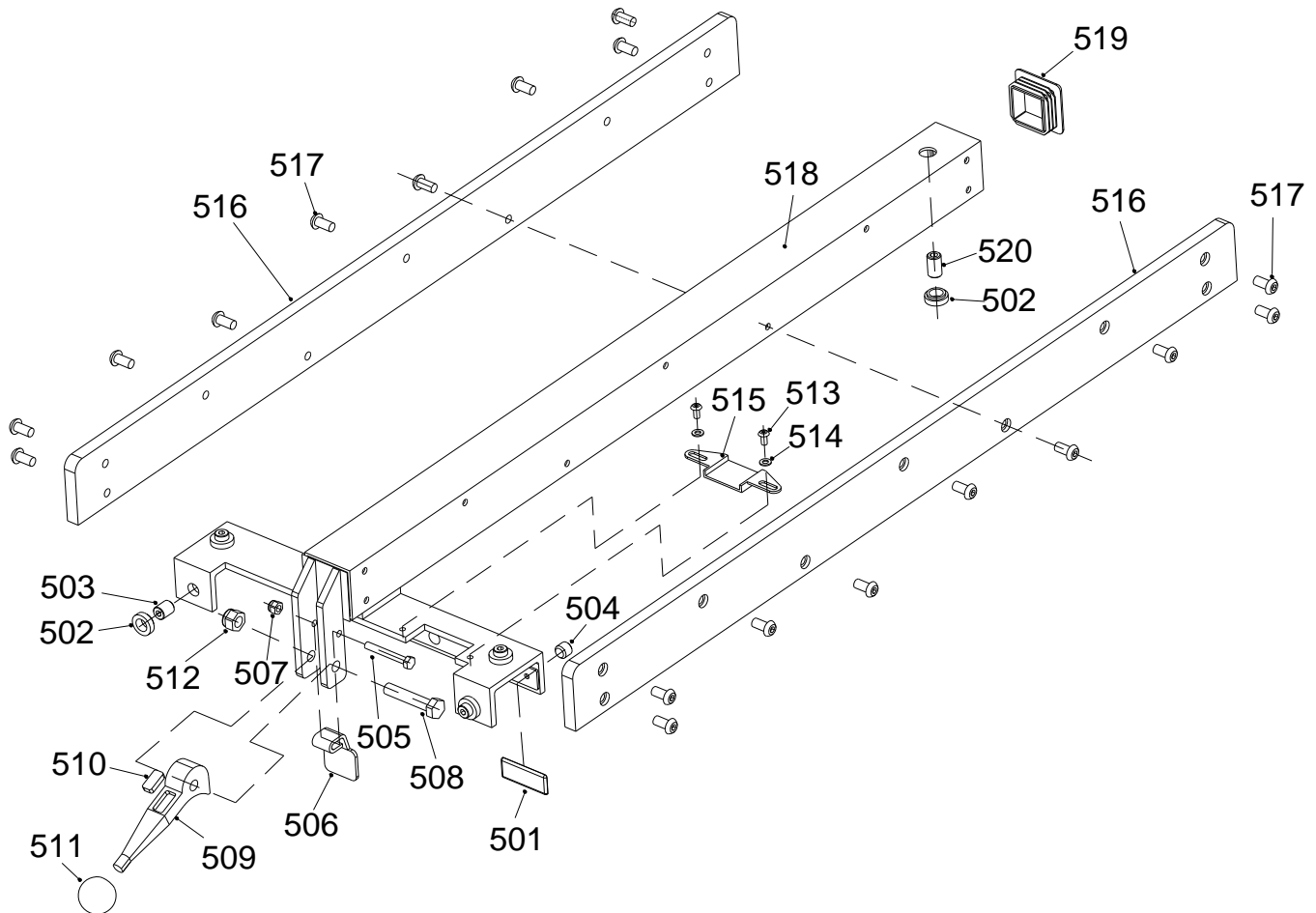
## MITER GAUGE PARTS DIAGRAM



Item	Description	Qty.	Item	Description	Qty.
401A	Miter Gauge Assembly	1	416	Lock Washer 4mm	1
401	Guide Bar	1	417	Button Head Screw M4x 6	1
402	Angle Scale	1	418	Miter Knob	1
403	Rivet	4	419	Flat Washer 4mm	1
404	Set Screw M8x 6	2	420	Crosscut Fence	1
405	Miter Ring	1	421	Square Nut M6	3
406	Flat Head Screw M5x8	1	422	Flat Washer 6mm	4
407	Miter Body Pivot Pin	1	423	Lock Washer 6mm	3
408	Miter Gauge Body	1	424	Lock Lever M6	2
409	Miter Stop Pin Knob	1	425	Flip Stop Bracket	1
410	Miter Stop Pin Block	1	426	Lock Lever M6	1
411	Compression Spring	1	427	Flip Stop Pivot Pin	1
412	Miter Stop Pin	1	428	Flip Stop	1
413	Button Head Screw M4x 10	2	429	Lock Nut 6mm	1
414	Pointer Miter Gauge	1	430	Teflon Flat Washer 8mm	1
415	Flat Washer 4mm	1	431	Teflon Flat Washer 6mm	1



## RIP FENCE PARTS DIAGRAM

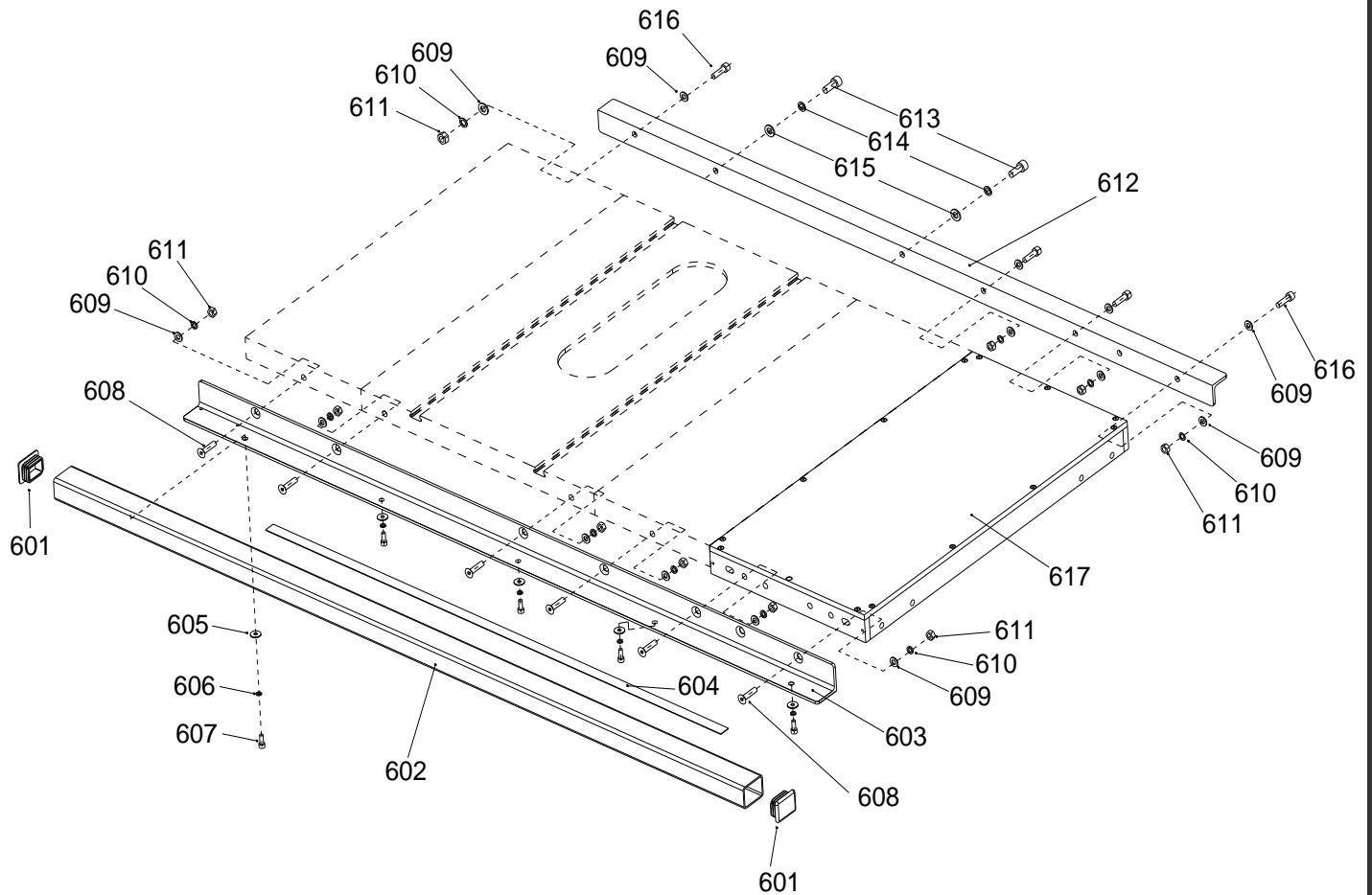


Item	Description	Qty.	Item	Description	Qty.
501	Glide Pad	2	511	Handle Ball	1
502	Hex Nut 12mm	5	512	Lock Nut 10mm	1
503	Set Screw M12x 15	4	513	Button Head Screw M5x 8	2
504	Set Screw M12x10	2	514	Flat Washer 5mm	2
505	Hex Bolt M6x40	1	515	Ruler X-Ray Film	1
506	Cam Plate	1	516	Fence Face	2
507	Lock Nut 6mm	1	517	Button Head Screw M6x16	18
508	Hex Bolt M10x45	1	518	Fence Body	1
509	Cam	1	519	Fence Insert	1
510	Permanent Magnet	1	520	Set Screw M12x 30	1





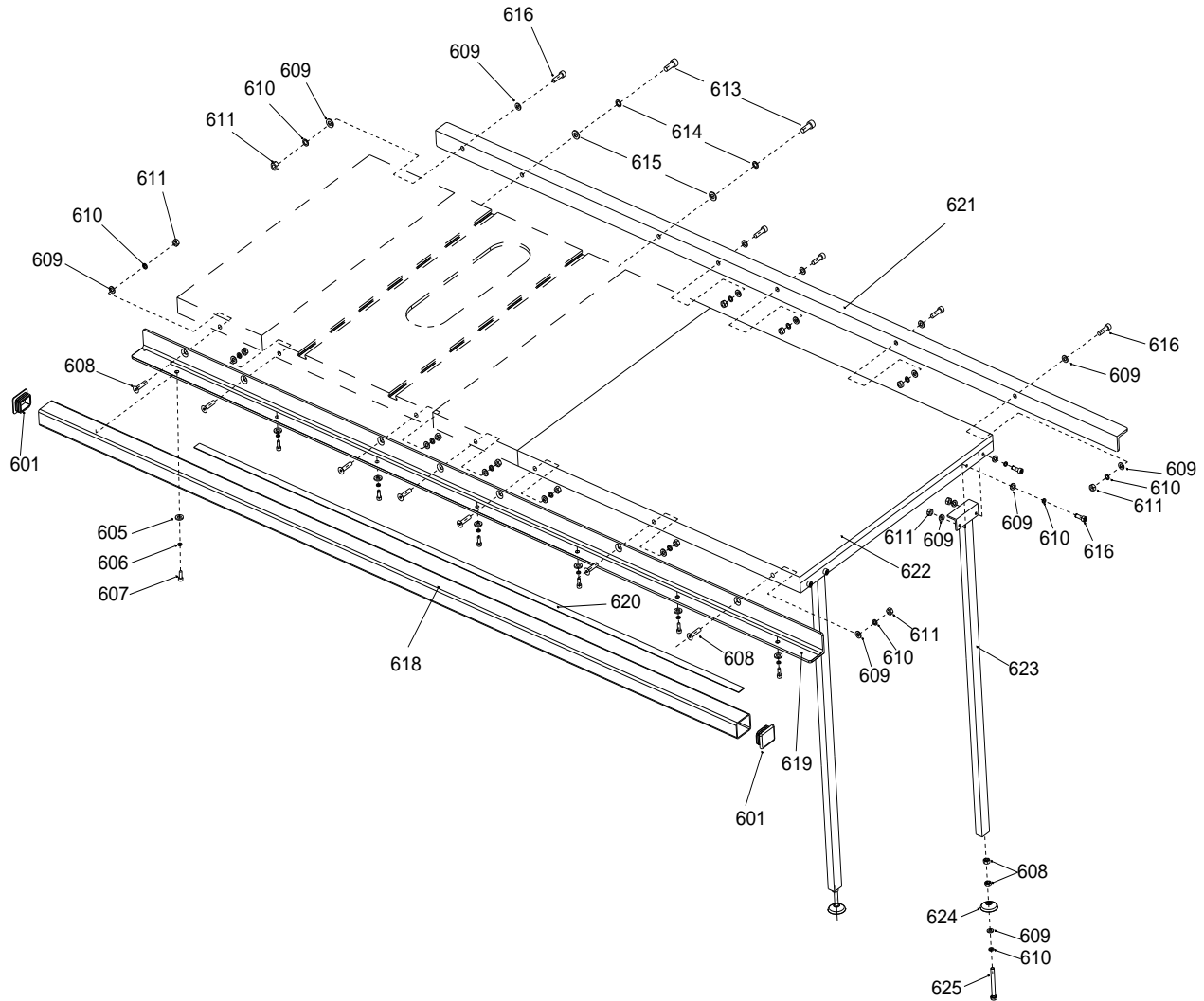
## 30" RAIL & EXTENSION TABLE PARTS DIAGRAM



Item	Description	Qty.	Item	Description	Qty.
601	End Cap	2	610	Lock Washer 8mm	10
602	Guide Tube	1	611	Hex Nut 8mm	10
603	Front Rail	1	612	Rear Rail	1
604	Scale	1	613	Cap Screw M10x25	2
605	Flat Washer 6mm	5	614	Lock Washer 10mm	2
606	Lock Washer 6mm	5	615	Flat Washer 10mm	2
607	Cap Screw M6x16	5	616	Cap Screw M8x35	4
608	Flat Head Screw M8x35	6	617	Extension Board	1
609	Flat Washer 8mm	14			



## 50" RAIL & EXTENSION TABLE PARTS DIAGRAM



Item	Description	Qty.	Item	Description	Qty.
601	End Cap	2	615	Flat Washer 10mm	2
605	Flat Washer 6mm	7	616	Cap Screw M8x35	9
606	Lock Washer 6mm	7	618	Guide Tube	1
607	Cap Screw M6x16	7	619	Front Rail	1
608	Flat Head Screw M8x35	7	620	Scale	1
609	Flat Washer 8mm	27	621	Rear Rail	1
610	Lock Washer 8mm	18	622	Extension Board	1
611	Hex Nut 8mm	20	623	Leg	2
613	Cap Screw M10x25	2	624	Supporting Plate	2
614	Lock Washer 10mm	2	625	Cap Screw M8x60	2



## NOTES



## NOTES



## NOTES



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