SLIDING TABLE SAW

COMPACT SERIES

ORIGINAL OPERATING MANUAL

PLEASE CAREFULLY READ THIS OPERATING MANUAL BEFORE USE

Thank you very much for your purchasing our SLIDING TABLE SAW.
For personal safety and excellent performance of the machine, please first carefully read the Operating Manual and other attachments to be familiar with the machine's functions, safe instructions and notes.

Noise range

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include characteristics of the work room, the other sources of noise, etc. i.e. the number of machines and other adjacent processes.

Also the permissible exposure level can vary from country to country, this information; however, will enable the user of the machine to make a better evaluation of the hazard and risk.

If the environmental noise level exceeds the permissible value, the customer is requested to adopt addition noise control measures.

Noise level :
According to EN1870-1/ISO3746 (The uncertainty K = 4 dB)

Sound pressure level: 78dB(A)

From the above measured results, this sliding table sawing machine present a little hearing or noise hazard to operator, the operator is required to wear ear caps whenever possible during operation and conform to the local safety regulations of labors.

NOTES
1. The contents in this Operating Manual may be changed without pre-notice. Sorry.
2. The contents in this Operating Manual have been carefully noted. In case there is a mistake that directly or indirectly results in damage, sorry our company will not be responsible for it.
3. This Operating Manual is a part of the machine, so please make sure to include it when the machine is moved, transferred and sold.

CATALOG

SAFE INSTRUCTIONS

1. If you are not fully familiar with the machine's operation, you must be instructed by your supervisor or qualified person.
2. If the running direction of the saw is wrong, it will cause danger.
3. The anti-skid floor cushion is put at the operator's standing area and the machine's working area. There should be a proper working space around the machine.
4. When the saw doesn't completely stop, please don't use extra pressure to stop it.
5. Don't operate the machine until the saw guard is well installed.
6. Please wear the approved safety glasses to protect eyes.
7. Before you repair or maintain the machine or change saw, please first shut down the machine's power.
8. When you rip small work piece (<120mm), please use the push stick or wood block.
9. When the saw hasn't completely stopped, please don't adjust the saw guard.
10. When power is ON, don't clean saw and don't use hands to clean sawdust and use brush to clean chips.
11. Confirm if the machine is well installed with the earth wire.
12. When you finish the job or operator leave the working area, please make sure to turn the power to OFF.
13. While working, don't fail to pay full attention. Looking around, talking and clamoring are careless behaviors and will incur serious injury.
14. While operating the machine, please keep stable, balanced and coordinated gesture. Operator and others can't stand at the same line with the saw or the work piece.
15. While the machine is running, no matter if the guard is installed, don't go near the saw or attach yourself to the machine.
16. The weight of work piece can't exceed 70kgs.
17. Before you replace parts, maintain or repair the machine, please first shut down the machine's power.
18. Only tools made in conformity to EN 847-1 : 1997 shall be used on the machine.
19. It should have enough lights and lighting around the machine's place location.
20. Machine use for cutting for small amount or quantity and various working piece, it may cut the wood, aluminum, imitation marble…non metal material. Prohibit to cutting the steel metal stuffs.

EXPLANTION OF WARNING SIGN

To secure safety

Please make sure to carefully read the safe instructions to be familiar with the machine's functions, safe information and notes before you start, run & start the machine.

Please carefully read the trouble-shooting guide to be familiar with the machine's functions, safe information and notes before you repair or check the breakdown.

If you wrongly operate the machine, different degrees of personal injury or damage may happen. So, to avoid such wrong operation, we list the following 3 classes of warning signs:

WARNING SIGN	WARNING CLASS	WARNING CONTENTS
	DANGER	If you wrongly operate it, assume the user to be dead or seriously injured with high danger.
	WARNING	If you wrongly operate it, assume the user to be dead or seriously injured.
	NOTE	Remind the user to surely close power.

It's listed as " **CAUTION** ", but the related serious damages may happen as per different situations.

The definition of " seriously injured ", " lightly injured ", " property damaged " shown in the above contents is as follows：

Seriously injured：Because of becoming blind, injury, electric shock, bone fracture, there is an after-effect that requires to stay hospital or go to hospital for treatment for a long time.

Lightly injured：Don't need to stay hospital or go to hospital for treatment for a long time.

Property damaged：Property and machine are directly or indirectly damaged.

1-1 SPECIFICATION

ITEM / MODEL		LS100	
Rectifiedcast iron fixed table dimension		570x880	
Sliding table dimension		350x1600	350x3200
Main saw blade dimeter max. Ø350 mm(14")		●	
Main saw bladeØ250mm(10") (CE)		●	
Main saw bladeØ305mm(12") (CE)		V	
Main saw bore		Ø30(Ø25.4)	
Main motor	5HP(3.7kw)	●	
	7.5HP(5.5kw)	V	
Main blade speed		4500rpm	
Scoring saw blade Ø 120		●	
Scoring saw blade bore		Ø22	
Scoring motor power	0.5HP(0.37kw)	●	
	1HP(0.75kw)	V	
Scoring saw blade speed 8000 rpm		●	
Cutting width 1000mm		●	—
Cutting width 1300mm		—	●
Cutting width 1500mm		—	V
Cutting width adjustment		Manual	
Saw table extension 450 mm(CE)/Std.		V	●
Miter fence		—	●
Blade tilting adjustment		Manual(0°~ 45°)	
Main saw height adjustment		Manual	
Scoring saw height adjustment		Manual	
Scoring saw + / - direction adjustment		Manual	
Blade tilting angle show		●	
Overhead saw guard	Simple type	V	
	Luxurious type	V	
Crosscut fence digital display		V	
Rip fence digital display		V	
Rip clamp		V	
Tool frame	Non CE	V	
	CE	●	
Dust collection system		Main channel 4", Simple typle 4",Lux. type 4"	

■ Specifications subject to change without prior notice ● : STANDARD V : OPTIONAL

1-2 MACHINE DIMENSION

Technical specifications

Sliding table cutting lengths	Cross cut unit with scoring saw blade
1600 mm (63")	1500 mm (59")
3200 mm (126")	**3100 mm (122.05")**

Cutting depths Unit : mm

Saw blade diameter	Ø 250 (10")	Ø 305 (12")	Ø 355 (14")
Cutting depths at 90°	50 (0-2")	72 (0-2.83")	102 (0-4")
Cutting depths at 45°	32 (0-1.25")	50 (0-2")	70 (0-2.76")

1-3 FEATURES

A : Dust guard---------- Not only reduce dust produced by chips while cutting, but also warning the operator where the saw-blade position.

B : Main table---------- Main working table.

C : Rip fence ---------- Reference positioning while ripping.

D : Sliding table---------- Table for main feeding while cutting.

E : Controlling panel ---------- Control bottoms for start and stop.

F : Miter fence---------- Reference positioning while 0~45°cutting.

G : Main saw tilting adjusting hand wheel----- Hand wheel for adjusting main saw tilting 0~45°.

H : Main saw lifting adjusting hand wheel ----- Hand wheel for adjusting main saw up/down.

I : Cross cut table---------- Used to put the workpiece while cross cutting.

J : Cross cut fence---------- To position the size of the movable positioning board.

K : Movable positioning stops--------- To position while cross cutting.

1-4 INDICATION

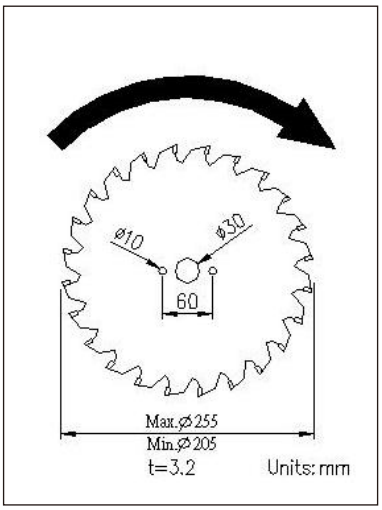


Fig.1

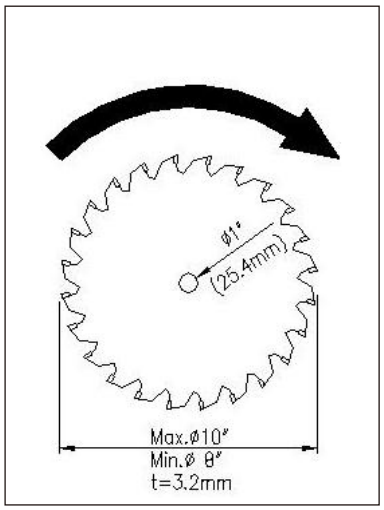


Fig.2

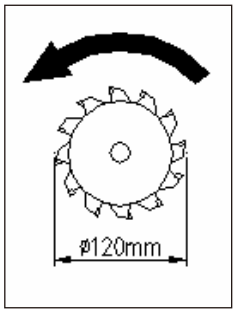


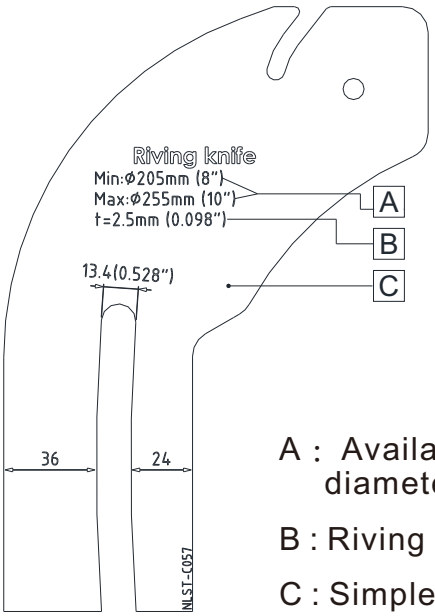
Fig.3

Note

Fig.1 : the main saw's size and running direction.

Fig.2 : the main saw's size and running direction.

1-5 RIVING KNIFE SPECIFICATION

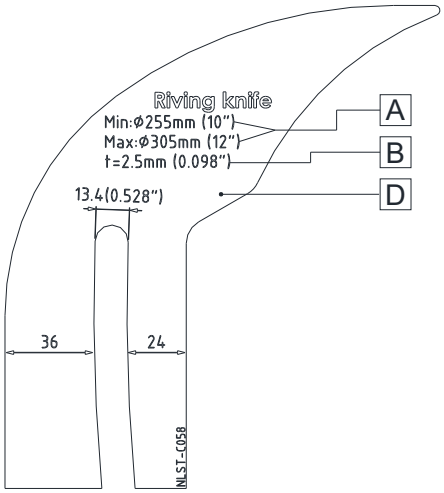


A : Available Main Saw diameter range.

B : Riving knife depth.

C : Simple riving knife.

D : Luxurious riving



⚠ WARNING

Prior to setting the riving knife, check whether it matches the saw blade diameter and body thickness.
Always switch off the main switch prior to setting the riving knife preventing cause danger.

The machine is delivered as standard with the following riving knives. 205~255 / 2.5 specification : Saw blade diameter 205~255mm.
Saw blade basic body thickness up to maximum : 2.5mm.
Diameter range and thickness are both engraved at the bottom end of the riving knife.

The thickness of the riving knife was selected so that they match the commercially available saw blade thickness in the respective diameter

1-6 MACHINE NOISE

DECLARED NOISE EMISSION VALUES in accordance with ISO 7960.

	Idling	Operating
Declared A-weighted Sound Power Level, Lward, in dB re 1 pW.	73	75
Declared A-Weighted Emission Sound Pressure Level , lpAd , in dB re 20 μPa , at the operator's position.	60	62

Values determined according to specific test code ISO 3746.

Noise range

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include characteristics of the work room, the other sources of noise, etc. i.e. the number of machines and other adjacent processes.

Also the permissible exposure level can vary from country to country, this information; however, will enable the user of the machine to make a better evaluation of the hazard and risk.

If the environmental noise level exceeds the permissible value, the customer is requested to adopt addition noise control measures.

Noise level：
According to EN848-1/ISO3746 (The uncertainty K = 4 dB)

Sound pressure level: 83dB(A)

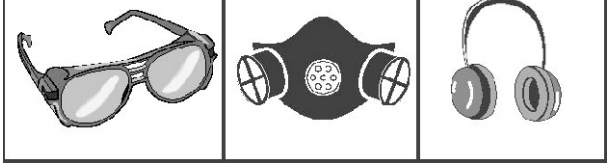
From the above measured results, this sliding table sawing machine present a little hearing or noise hazard to operator, the operator is required to wear ear caps whenever possible during operation and conform to the local safety regulations of labors.

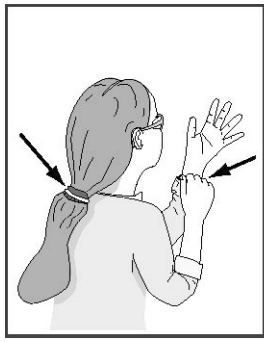
Noise level

From the above measured results, this auto planer machine present no sever hearing or noise hazard to operator, However, the operator is recommended to wear ear caps whenever possible during operation and conform to the local safety regulations of labors.

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.





⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

The following section was designed to give instructions on the basic operations of this machine. However, it is in no way comprehensive of all of the machine's applications. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your machine.

2-1 TRANSPORT

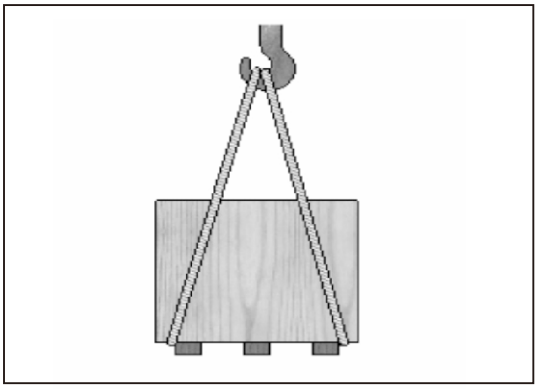
TRANSPORT WOODEN CRATE

⚠ WARNING

To transport the machine, please request the person who has licenses of gantry, crane, lift truck, etc, to operate. The weight of machine is listed in the chapter 2-1 and 2-2. After confirming, please proceed as per the weight. To suspend and move the machine, please follow Notes of Chapter 2-1 and 2-2 to operate. During transport, if the machine collapses or drops, it will cause an accident.
While transporting or assembling, please don't damage the wiring. After assembly is completed, please execute protective measures to avoid the workers, other persons or lift truck damaging the wiring.

The machine's gross weight is about:
Body box(Cutting width 1m): 720kgs
Body box(Cutting width 1.3m): 760kgs
Body box(Cutting width 1.5m): 800kgs
Please refer to Chapter 1-2 for detailed data.

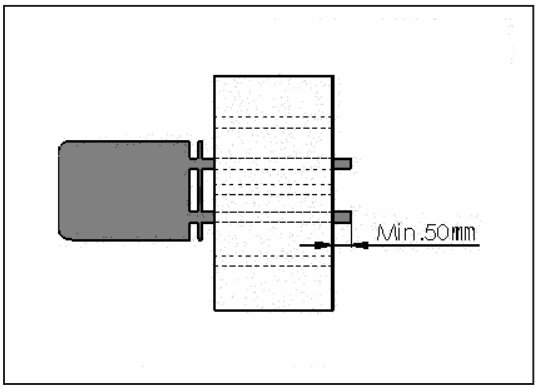
1. USE CRANE TO MOVE WOODEN CRATE



⚠ WARNING

The crane's rope must be able to bear the machine's gross weight to prevent its breaking from happening danger.

2. USE LIFT TRUCK TO MOVE WODEN CRATE



⚠ WARNING

Please put the wooden crate in the middle of the forks and keep over 50mm distance between the front of the forks and the wooden crate to avoid the case collapsing and secure safe transport.

TRANSPORT MACHINE

The machine' s net weight is about :
Body (Cutting width 1m) : 670kgs
Body (Cutting width 1.3m) : 710kgs
Body (Cutting width 1.5m) : 750kgs
Please refer to Chapter 1-2 for detailed data.

1. USE LIFT TRUCK TO TRANSPORT MACHINE

⚠ WARNING

- The lift truck must be able to bear to least 5tons.
- Make sure the machine is balanced. While transporting, please don' t vibrate it and keep at least 2m safe distance away from the transport area.
- The machine is equipped with the slots as shown in left Fig. that are specially designed for transport of

2. USE GANTRY OR CRANE TO MOVE MACHINE AWAY PALLET

Fig.1

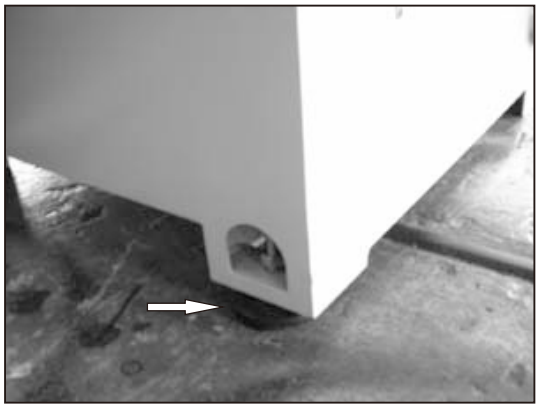


Fig.2

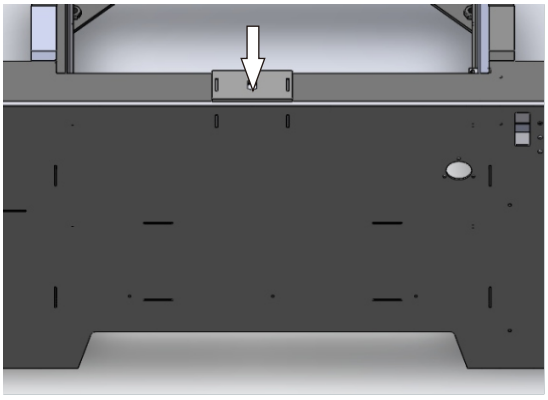
⚠ WARNING

- Before the machine is put on the floor, please first install level adjusting bases (as shown in Fig. 2 arrow marked) and adjust the level of the machine's working table to secure the sliding table's smooth movement and the machine's balanced running.
- Fig. 2 as marked is the machine after adjustment should be fixed to the floor.

2-2 SLIDING TABLE UNIT

ASSEMBLE

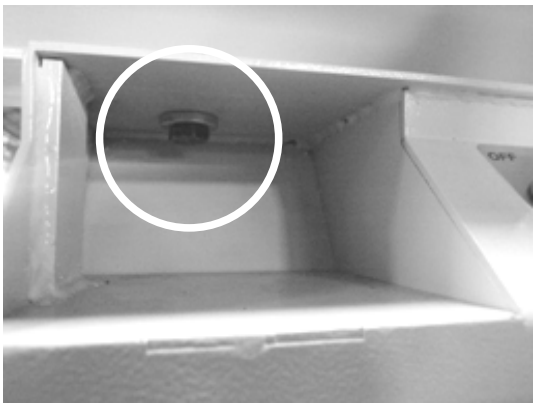
★Prior to setting sliding table , release the trimming planks (Fig.2-2-1). Ensure the trimming planks releasing before 1st working operation or the machine damaged.



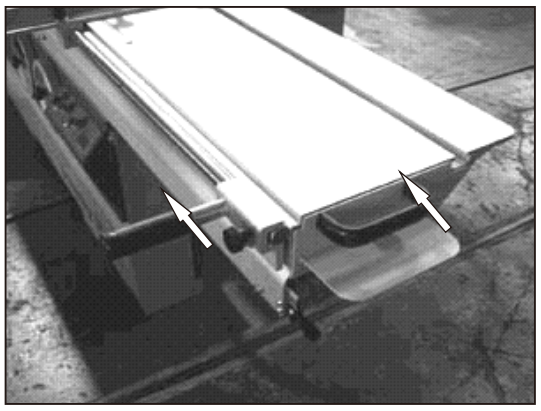
Clean the contact surface of the machine and the sliding table (Total 3 contact surfaces).

Put the sliding table on the contact surface and tightly against the adjusting screw.

Note : Ask persons to move the sliding table onto the machine to prevent hitting from influencing level during transportation. As per different size, the required manpower is 4-6 persons.



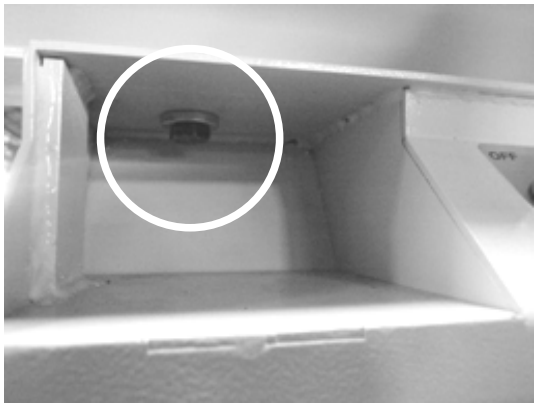
Tighten the fixing screw of the machine and the sliding table.



Put the handle and the sliding table handle onto the sliding table.

Note : After assembly of the sliding table is completed, the parallelism of the sliding table and the saw blade must be first adjusted.

ADJUST



Loosen 3 fixing screws.

Adjust the adjusting screws at two sides of the machine to make the sliding table parallel to the saw blade and keep the gap as shown in the left drawing with the working table. After assembling, tighten the fixing screws.

Note : The sliding table must 0.3mm higher than the working table (The height has been set before delivery, so don't freely adjust the height of the sliding table or the working table).

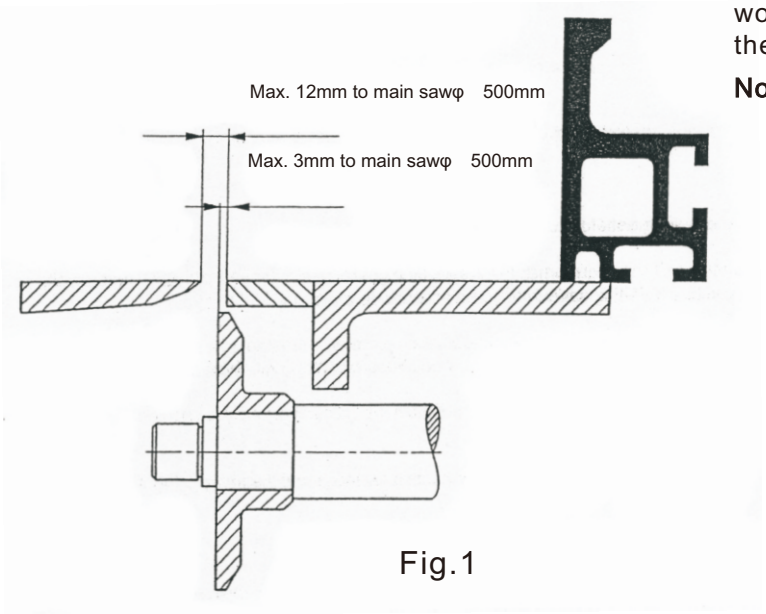
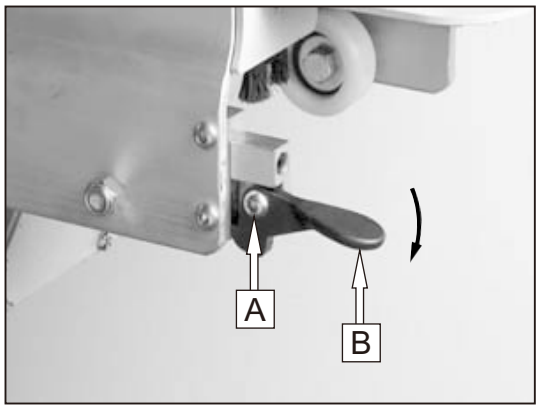


Fig.1

How to Use the Sliding Table Lock

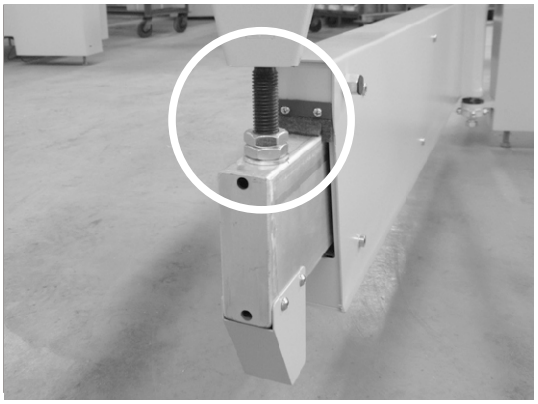


- Due to limitation of packing, Part A & B in the left drawing are put in the tool box before delivery.
- After the sliding table is installed at the back of the machine, please first install Part A & B at the position of the end of the sliding table in the left drawing.
- The safety lock can fasten the sliding table in the middle and the end.

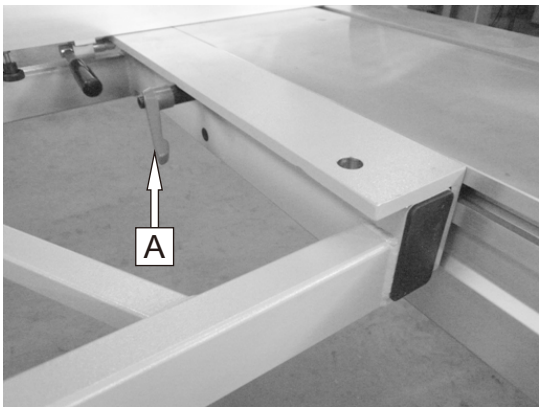
Note : Before the sliding table is moved, make sure the safety lock is un-locked. Part Bin the left drawing is

2-3 CROSSCUT TABLE UNIT

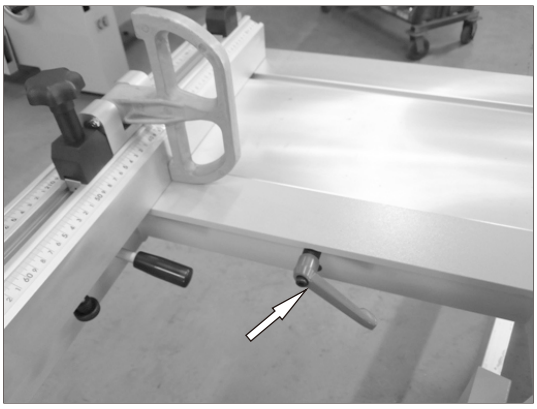
ASSEMBLE



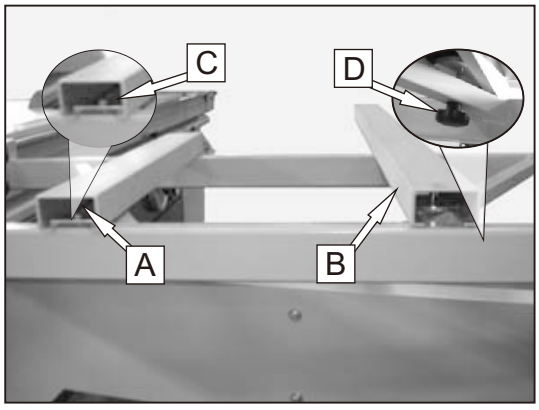
Put one end of the crosscut table into the projected round rod of the expansion pipe（apply the lubricating oil to the balls to prevent friction from



Lock part A to fixcd the sliding table.



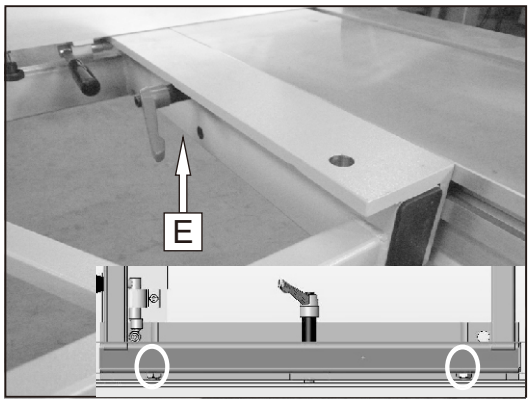
Tighten the handle to fasten the crosscut table.



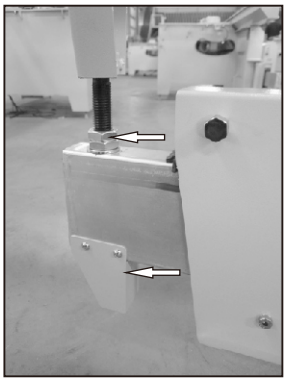
Put two C-shaped aluminum pipes into the crosscut table.

A aluminum pipe is the fixing aluminum pipe (Use the open wrench to tighten C for fixing).
B aluminum pipe is the moving aluminum pipe (Use hand to tighten D for fixing. Loosen D to make B aluminum pipe be movable).

ADJUST



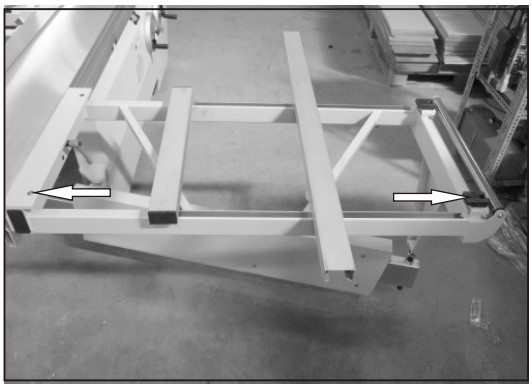
If the crosscut table and the sliding table are not parallel use the adjustment shafts as shown on the highlight part to parallel.



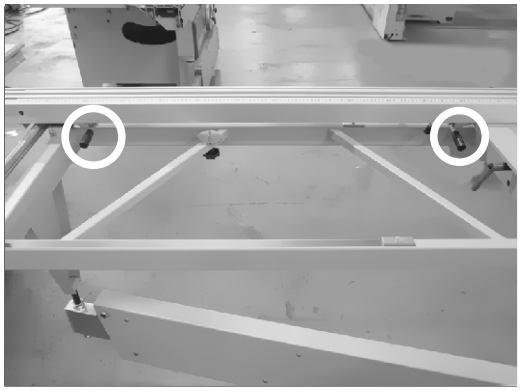
If the corosscut table isn't parallel to the working table, adjust the nut of the crosscut table and the expansion pipe and also adjust the nut in the cover plate.(See the left drawing)

2-4 CUOSSCUT FENCE UNIT

ASSEMBLE



Put the crosscut fence into the positioning point of the crosscut table.



Press down the handle to fix the crosscut fence.

Note : If the crosscut fence is moved, please first adjust the perpendicularity of fence and saw blade before use.

ADJUST

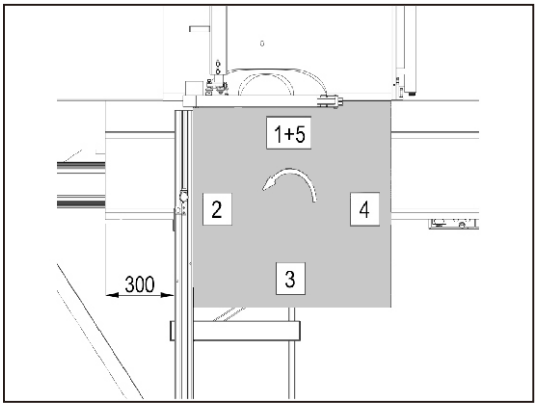


Fig.1

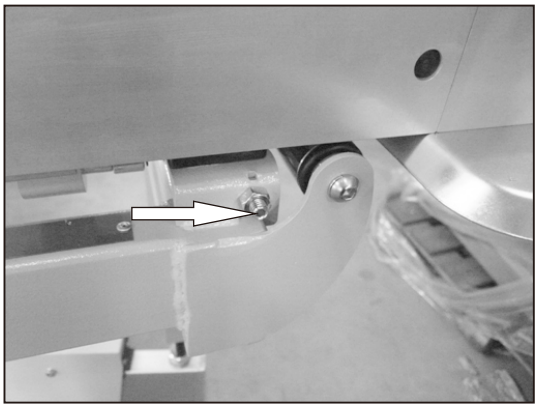


Fig.2

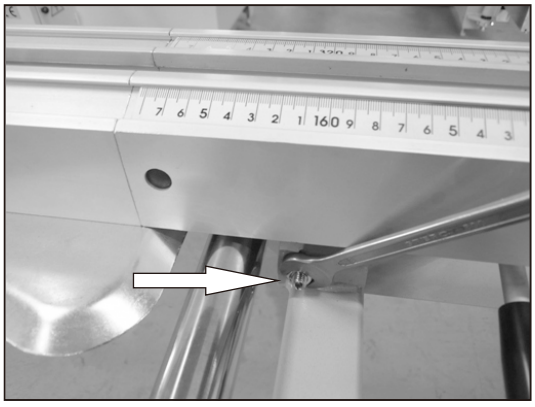


Fig.3

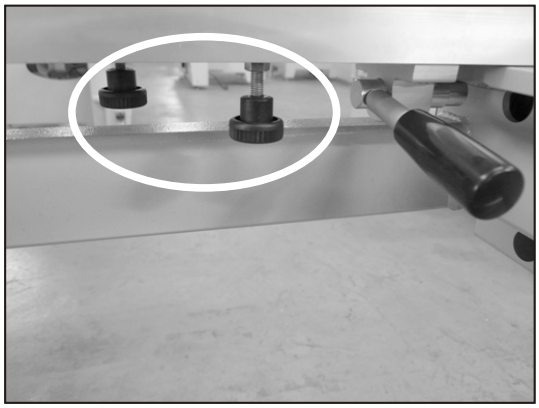


Fig.4

Adjusting Way :

1.Please keep 300mm distance between the fence and the sliding table. While cutting, please use saw in dia255mm/3.2t/100T, at 4400 r.p.m speed and wood board in 1000x1000x19 or (6/8") for trial cut.

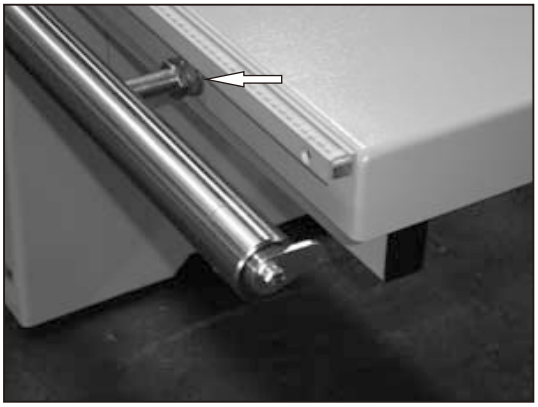
2.Sequentially cutting NO.1~5 as Fig.1.

3Adjust the nuts on Fig. 2 and 3 to measure the error of wood board; after adjustment lock the nuts..

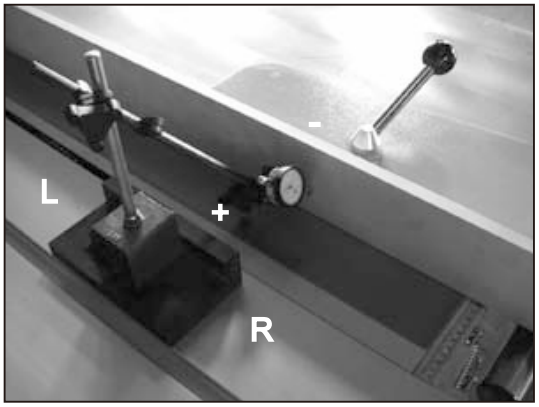
4. 2 knobs in Fig. 4 is to fasten the scale on the crosscut fence.

2-5 RIP FENCE UNIT

ASSEMBLE

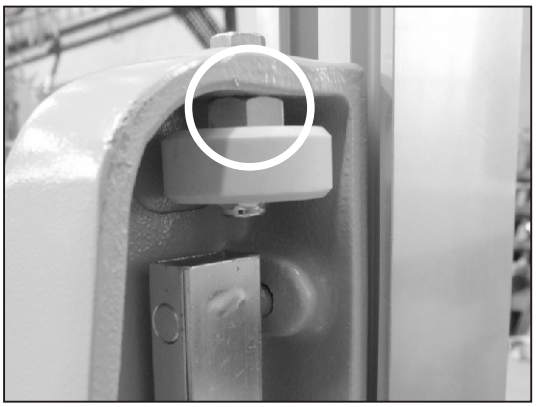


Lock the screw on the round rod into the rihgt side of the working table, put into the rip fence base, adjust three nuts on the round rod to make rip fence parallel to the saw blade.

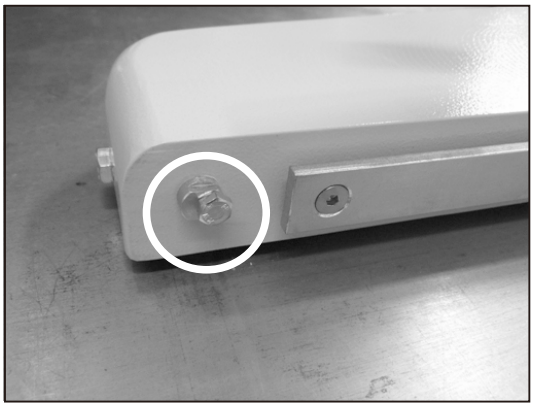


Use the gage to measure the parallelism of the rip fence and the main saw blade.

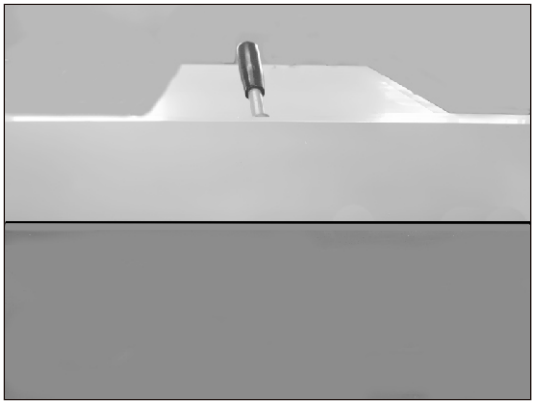
Measuring way : The rip fence is fixed and the sliding table is pushed to the left. Measured tolerance is 0~0.1mm from the left to the right as the direction shown in the above drawing. (parallelism of the sliding table and the main saw blade must be first adjusted within tolerance.)



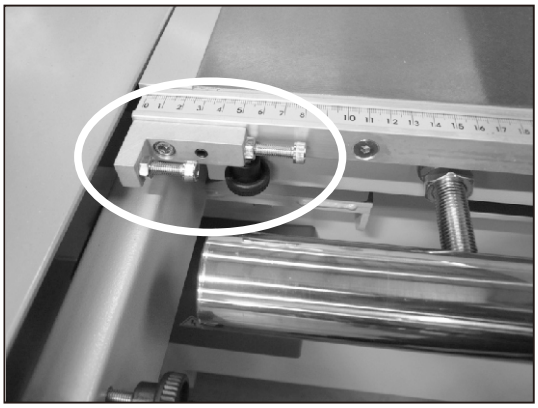
Adjust the eccentric wheel of the front end of the fence base to make the fence base parallel to the working table.



Adjust two eccentric wheels at the side of the fence base to make the aluminum fence parallel to the working table.

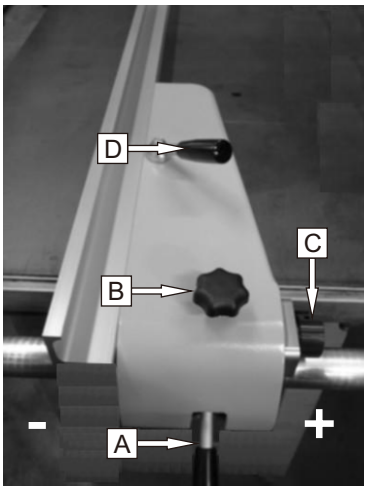


Aluminum fence parallels l to the working table



- Tighten the rip scale, adjust the limit screw on the stop block. The safe gap between the fence and the saw blade is suggested at 15mm.
- The screw at the left side of above drawing is the limit for cutting 90 degree.
- The screw at the right side of above drawing is the limit for cutting angle.

ADJUST

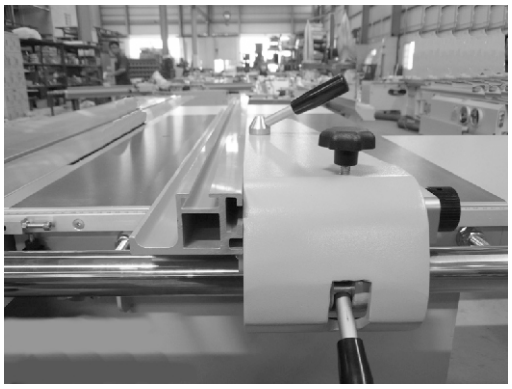


After the rip fence is moved, if the moving size and the target size have slight difference, the following is the operating way of the micro-knob :

1. Pull the handle (Part A) upwards, move the rip fence to near the target size.
2. Loosen the knob (part B)
3. Turn the micro-knob (Part C) to the target size. To fasten rip fence, do above steps in reverse order.Fasten the knob (part B).

micro-knob : - direction movement Anti-clockwise turn
micro-knob : + direction movement
To change the aluminum fence, loosen the handle (Part D).

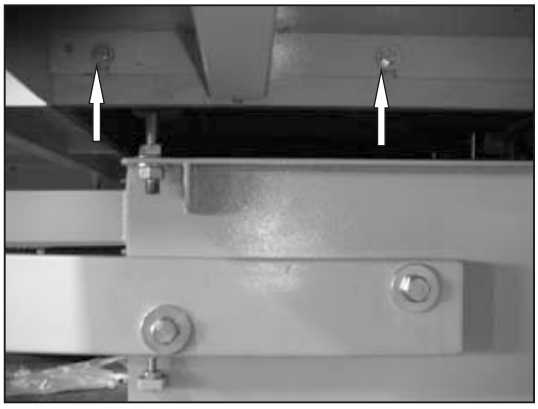
Above drawing is the position of aluminum fence at 90 degree cutting.



Above drawing is the position of aluminum fence at cutting angle.

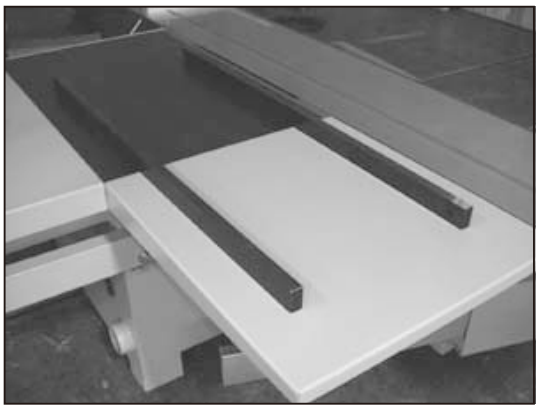
2-6 EXTENSION TABLE

ASSEMBLE MAIN TABLE EXTENSION

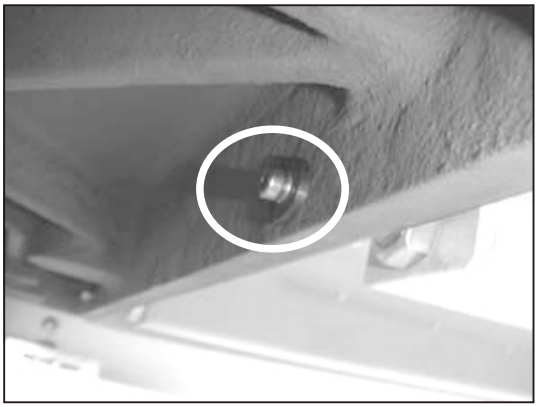


Loosen about 3~5mm of 3 metal sheet fixing screws at the left side of the machine, put extensnion metal sheet on the fixing screws and slightly tighten the screws.

Adjust 2 adjusting bolts of the extension metal sheet to make the metal sheet and the main working table become a plane.



Measure if the main table extension and the main table become a plane.

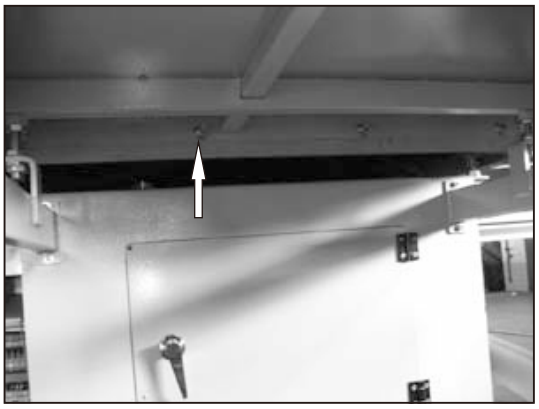


Adjust and fasten 2 adjusting bolts and 3 metal sheet fixing screws.

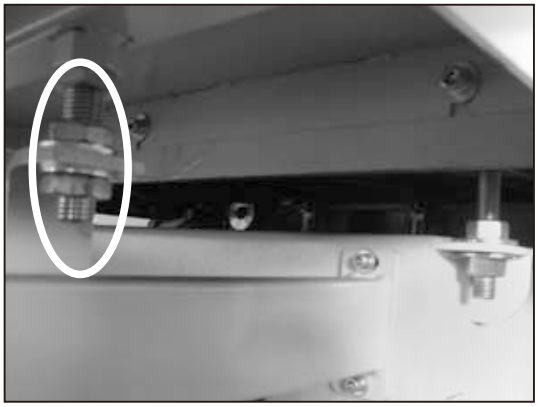
ASSEMBLE WIDTH EXTENSION TABLE

Lock the support into the back of the machine.

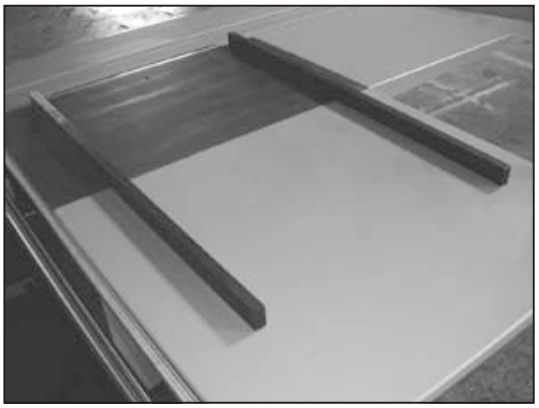
Note : The opening of the support must be outwards as shown in above drawing.



Loosen 3~5mm of 4 metal sheet fixing screws at the left side of the machine, put width extension table on the fixing screws, slightly tighten the screws.



Put the adjusting bolt on the metal sheet onto the support and adjust the nut to make width extension table and main table become a plane.



Measure if the width extension table and the main table become a plane.

2-7 DUST GUARD UNIT

SIMPLE TYPE SAW GUARD

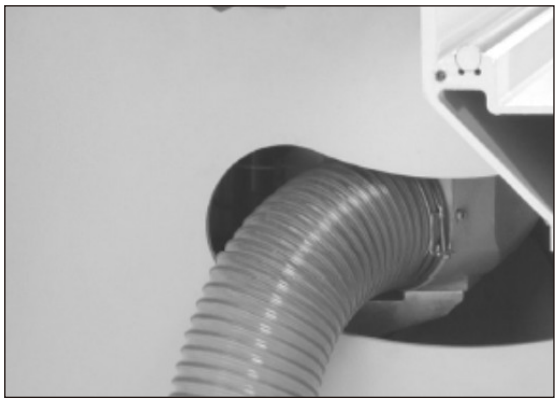
Install the dust collection fixing rack and the dust collection pipe onto the left side of the machine as shown in above drawing.

Install the dust collecting hood on the ribbing knife, connect dust collection hose, use clamp to fix the hose as shown in above drawing.

Diameter of dust collection hose is

Put the dust collection hose into the dust collection hole under the fixing rack.

Diameter of the fixing rack's hose



Put the dust collection hose into the dust collection hole .

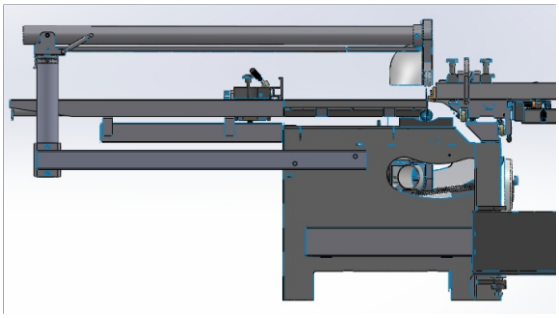
Diameter of hose is 4".

⚠ WARNING

Before the machine is used to cut workpiece, Please make sure the dust collector work normally.

Note1 : The required air speed at the end of flexible tube is 30~34m/sec. The required air volume of the machine is 1220~1390 m³/hr. (43,000~49,000 cuft/hr)

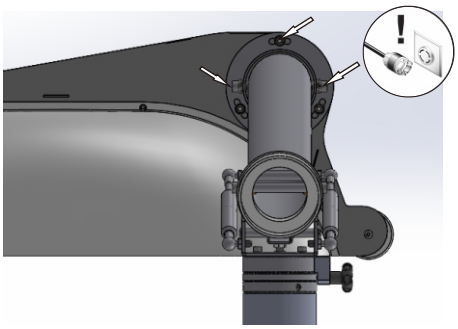
Note2 :Antistatic and electrically conductive hoses only.



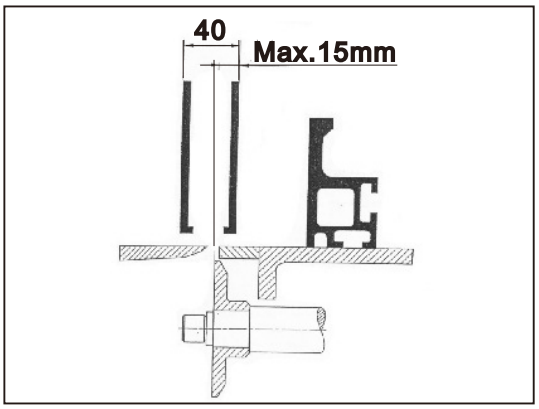
Install the dust collection fixing rack onto the left side of the machine as shown in above drawing.

⚠ WARNING

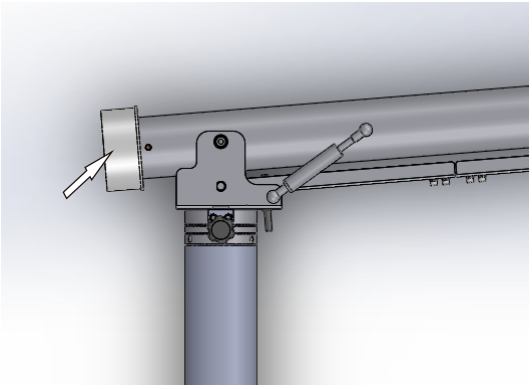
Before you install the safety guard, please lower the saw under the table.



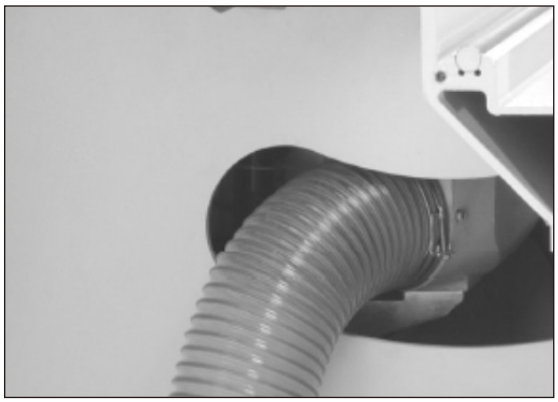
Parallelize the safety guard and the sliding table. then lock withe nuts.



Please keep safe distance between the safety guard and the saw as shown in above drawing.



Put the dust collection hose into the dust collection hole at the back of the guard.
Diameter of hose at the back of machine is 3".

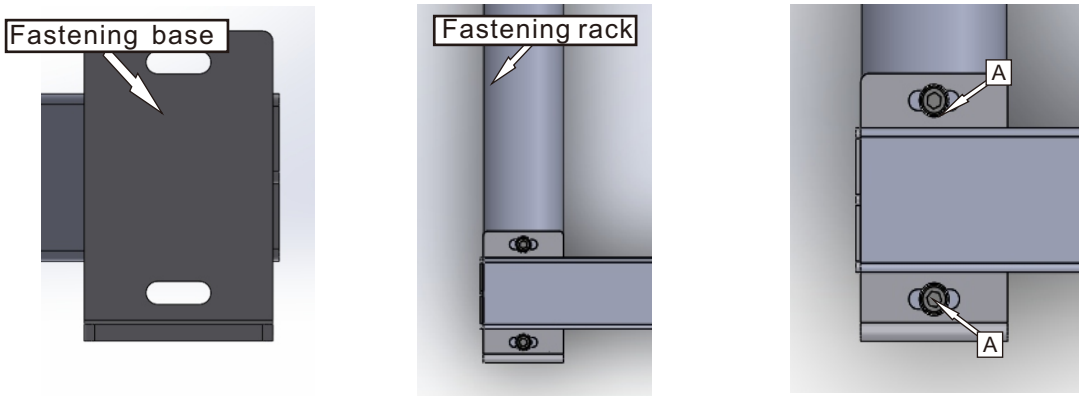


Put the dust collection hose into the dust collection hole .
Diameter of hose is 4".

ASSEMBLE

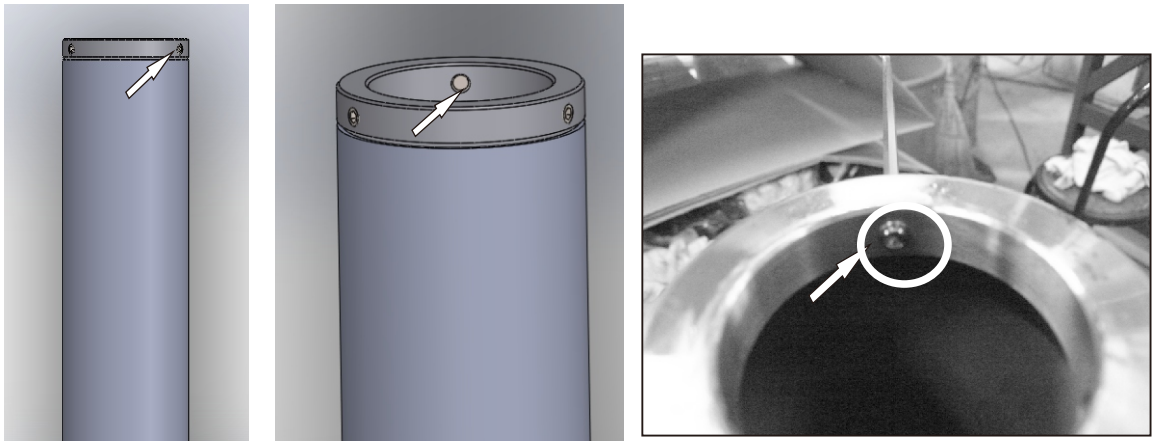
It needs 2 people to install the safety guard .

Fig 01



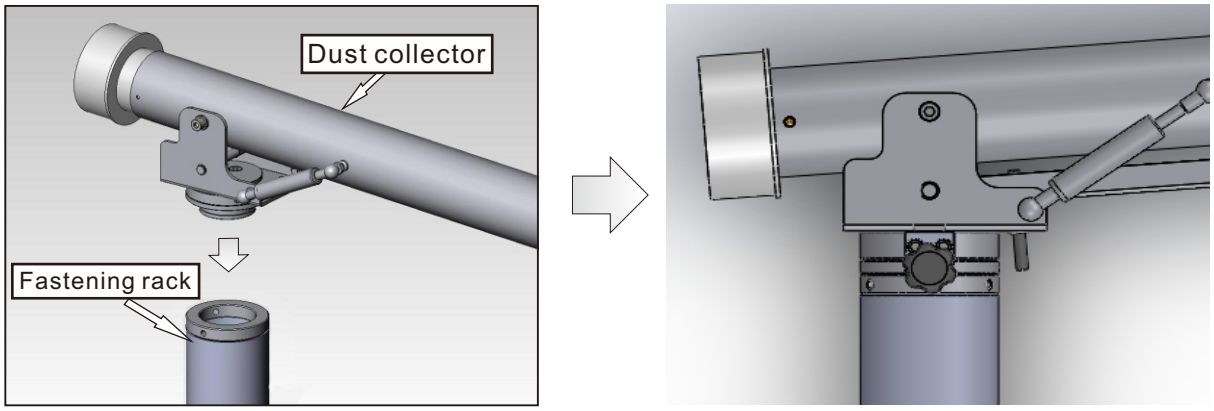
Dust colletor fixed base and dust collector frame screw with nexagon screw and fixed as figA.

Fig 02



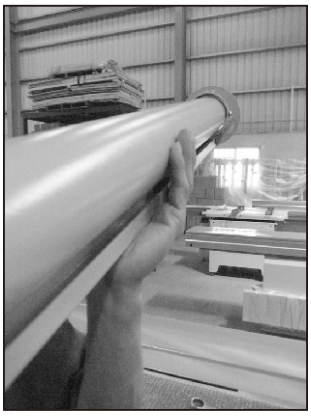
After fixed check the nuts and make sure it's being completely locked.

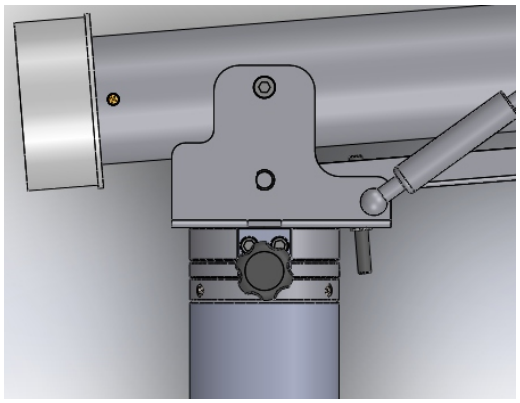
Fig 03

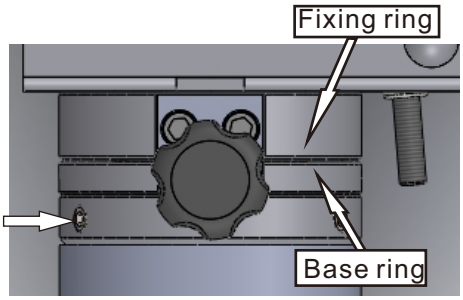


Insert the dust collector into the fastening rack.

Fig 04



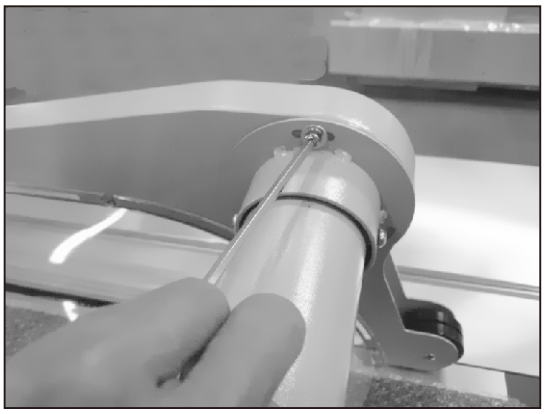




Prop up the dust collector, tighten up part Fixing ring and part Base ring and then lock with nuts.

Fig 05

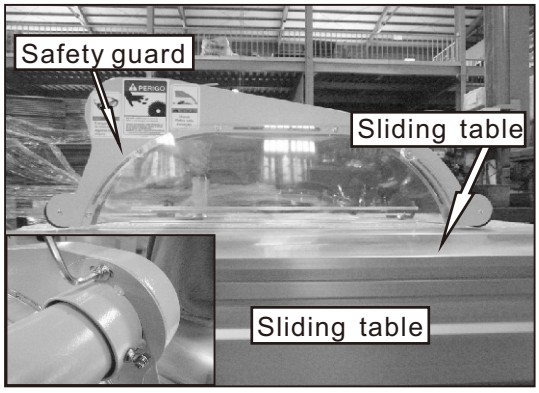
Take out the nuts on the guard.



Staff A lowers the dust collector down; staff B inserts the dust collector into the hole on the guard and lock with nuts.

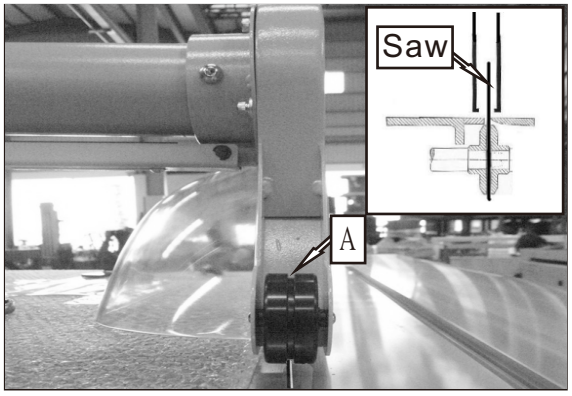
Fig 06 (A)

Check and adjust if the guard parallel to the sliding table.



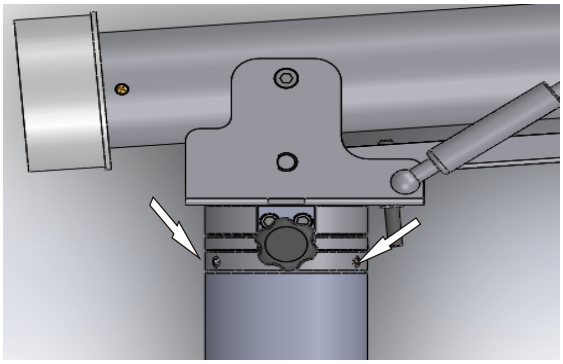
Once complete Fig.6 (A) lock with nuts as shown on B1.

Fig 07



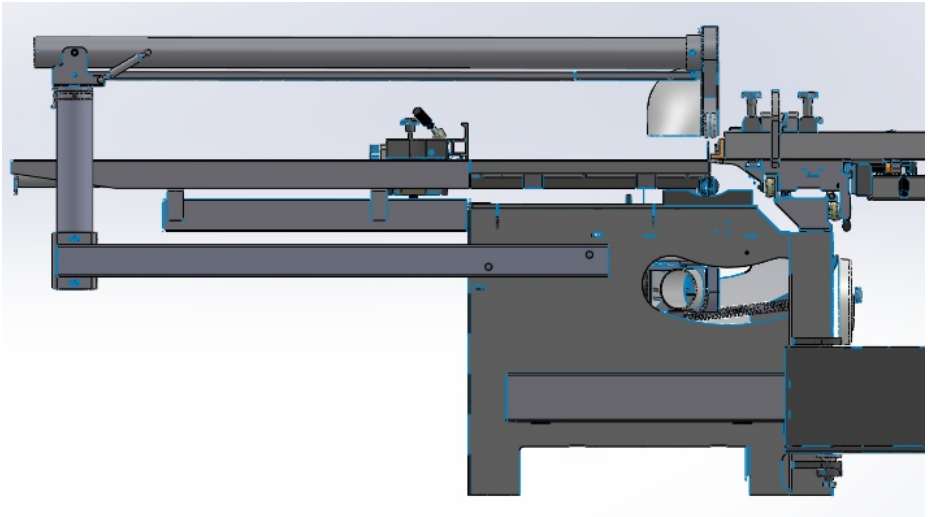
Check the grooving Fig. A in the guard if parallel to the saw.
(If not parallel please refer to Fig. 10 and 11, P.2-16)

Fig 08



Make sure the guard parallel to the saw. Insert the indexing plungers to part A and lock the fixing ring with nuts.

Fig 09



Install completed.

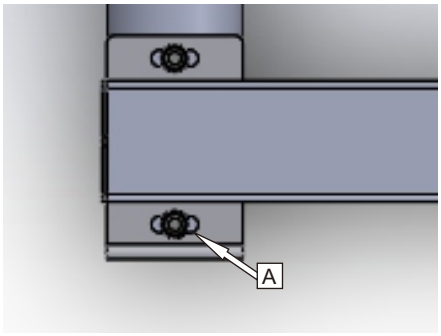
PUSHING STICK INSTALLING

⚠ WARNING

Before the machine is used to cut workpiece, Please make sure the dust collector work normally.

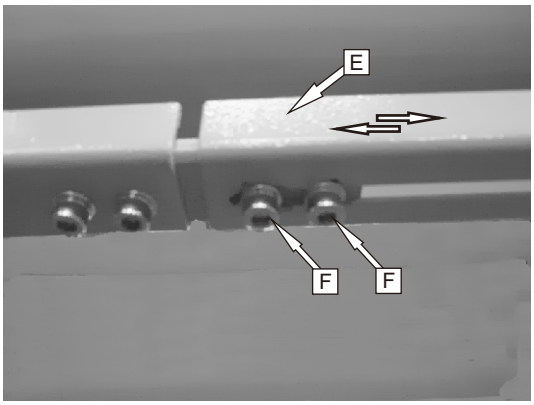
Note1 : The required air speed at the end of flexible tube is 30~34m/sec. The required air volume of the machine is 1220~1390 m³/hr. (43,000~49,000 cuft/hr)

Fig 10



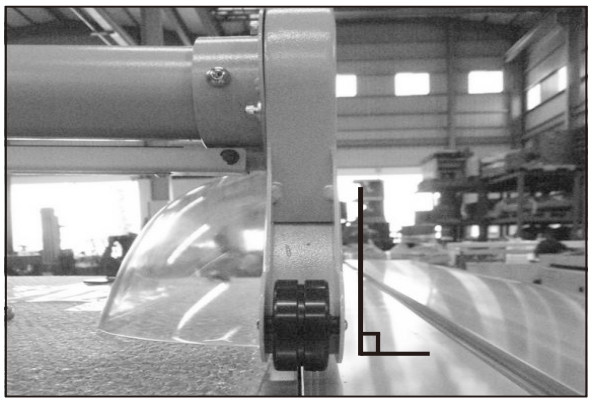
Adjust dust collector to proper position and vertical to sliding table.Tighten hexagon screw on arrow sign A.

Fig 11



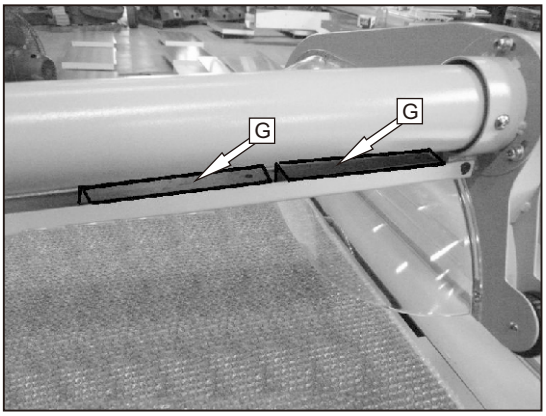
E:Clamp links F: Cap screw

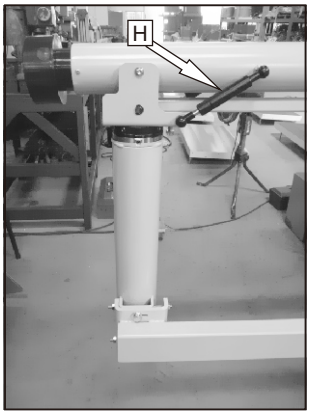
Loosen part F , and part E can be slide back and forth which parallels the safety guard.and the sliding table.



Make the guard vertical to the sliding table.

Fig 12

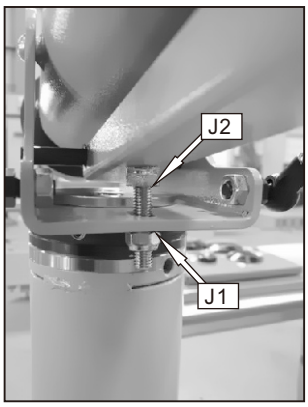


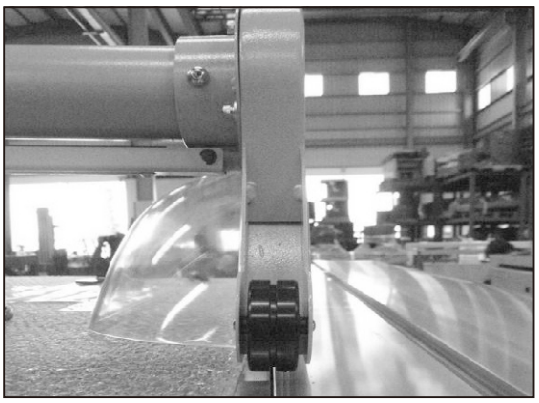


G: Block H: Gas spring

Adjust the part G and the part H will make the guard in a float position.

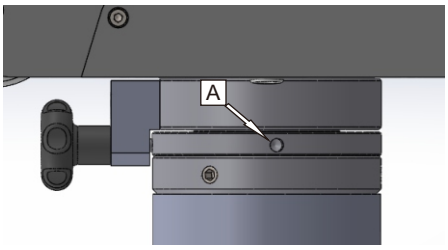
Fig 13

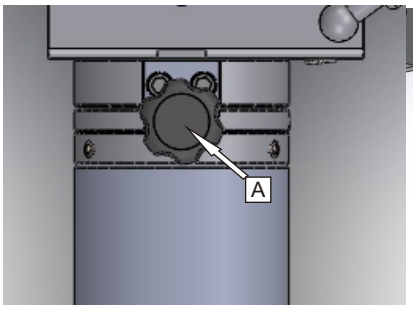


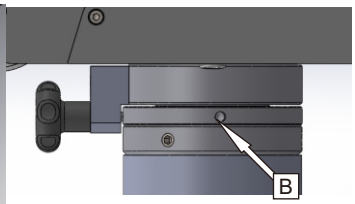


Make the guard to a proper position then adjust and fasten J1.
(J1 is the max. height position; J2 is the max. low position.)

Fig 14

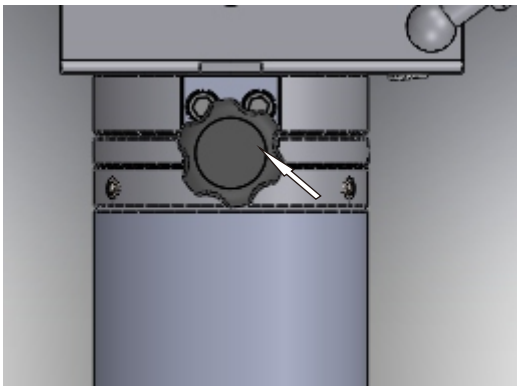


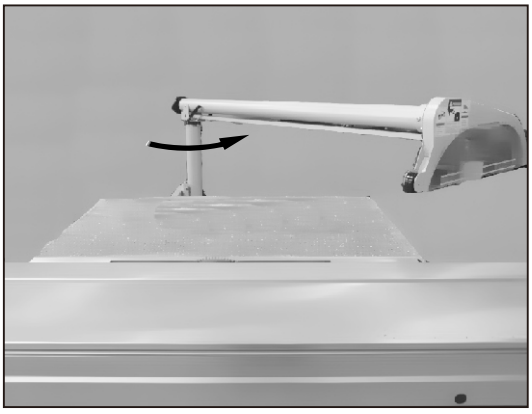




2 position holes on the dust collector (as shown on).
(A) positioning hole is being used when the guard works.
(B) positioning hole is being used when the guard stops.

Fig 15



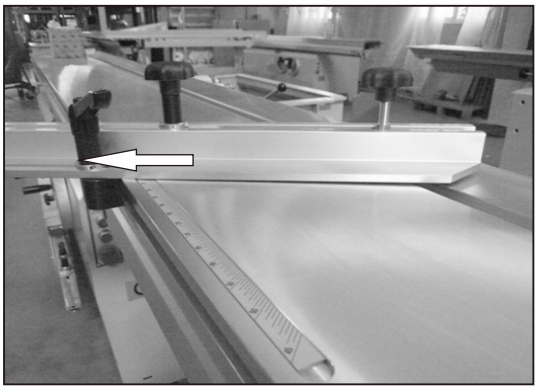


Pull back ward the position bar and spin 90 degrees. Spin the dust collector to part B, shown on Fig. 14 and the position bar inserts to part B automatically. The dust collector and the safety guard are in a fixed position.

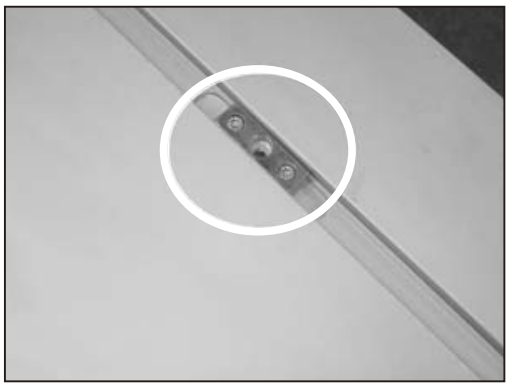
- Application of force with hands to float the safety guard.
- Adjustment: to get a proper position for the guard please refer to Fig 12 and Fig 13.

2-8 MITER FENCE UNIT

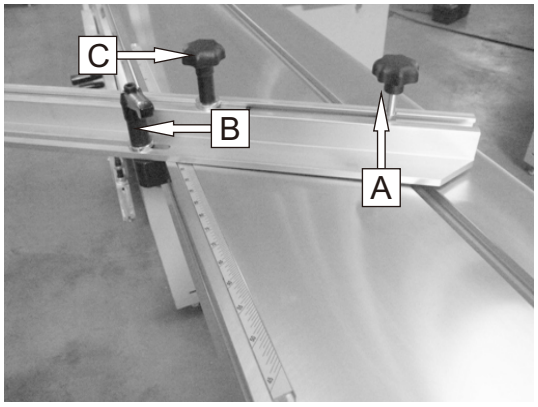
ASSEMBLE



Put the slide block on the bevel cutting fence into the round rod of the sliding table.



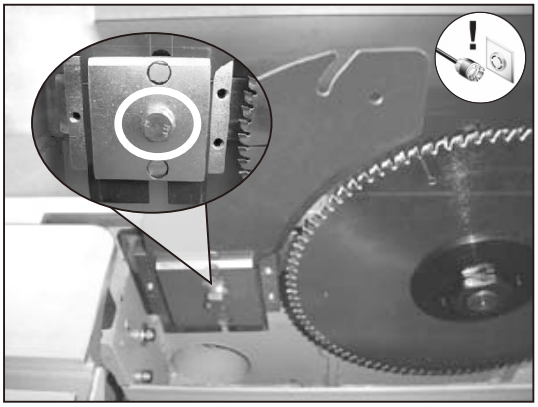
Lock the fixing block on the sliding table.

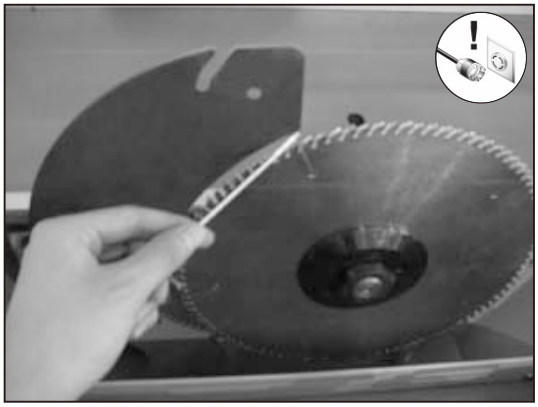


- Tighten knob A to fasten the center point of bevel cutting fence.
- Spin part B to fix miter fence loose part B and the miter fence sways.
- Loosen knob C and push outwards to extend the bevel cutting fence.

2-9 RIVING KNIFE UNIT

ADJUST





- Loosen the fixing screw on the riving knife base.
- Adjust the 3 adjusting screws at the two sides of the fixing screws as the projected place shown in the above drawing.

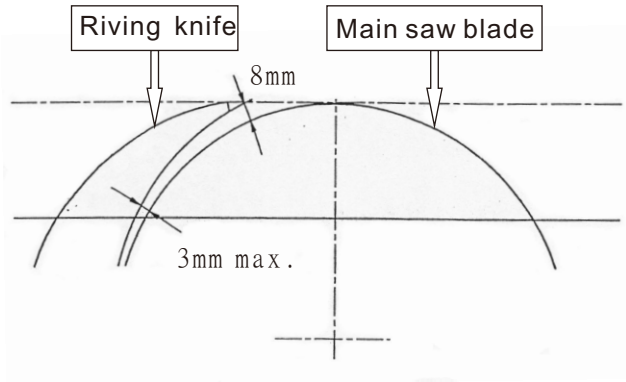
Note : Before adjusting the ribbing knife, please first open the saw blade guard. Please refer to 2-10 for detailed operation.

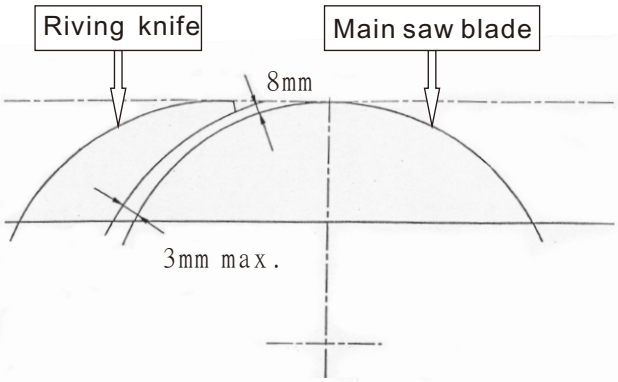
Measure the relative size of the riving knife and saw blade.

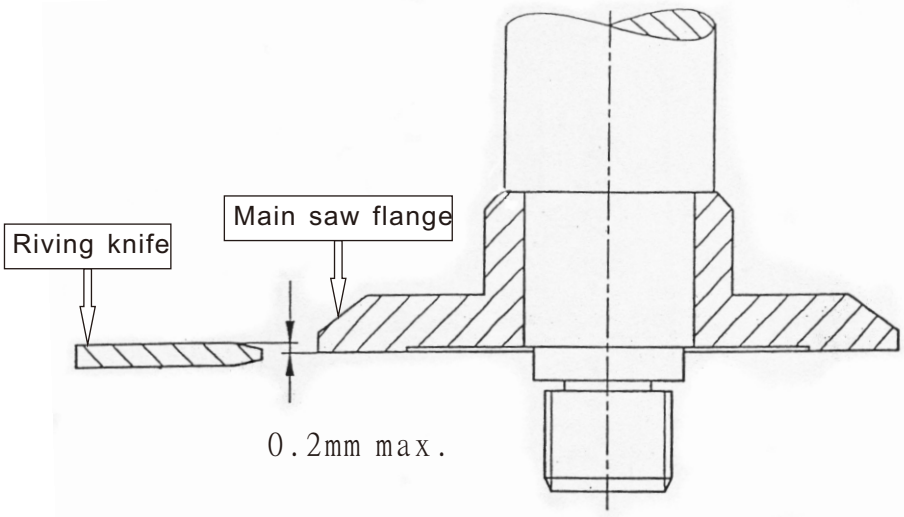
⚠ WARNING

After adjustment of the riving knife is completed, please make sure to tighten the fixing screw on the riving knife base.

RELATIVE SIZE OF THE RIVING KNIFE AND MAIN SAW BLADE





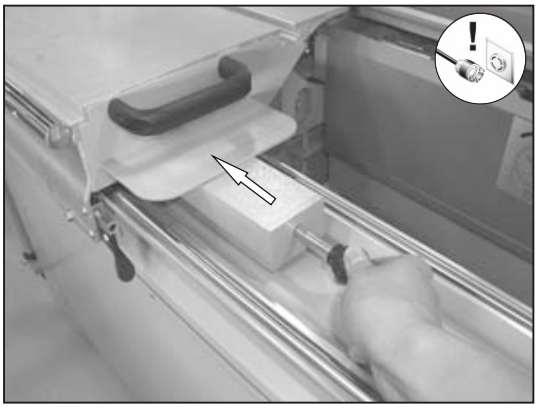


2-10 MAIN SAW UNIT

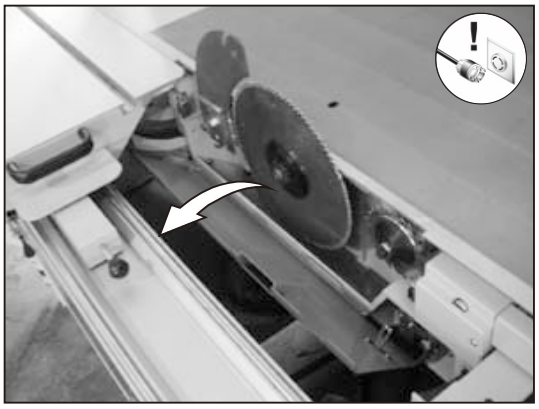
CHANGE MAIN SAW BLADE

⚠ DANGER

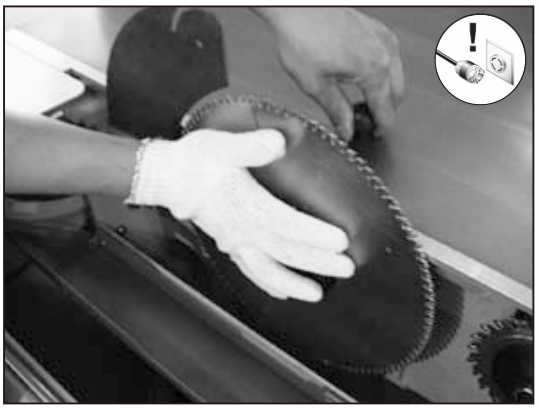
- Before changing saw blade, please confirm if power is closed.
- At changing saw blade, please put on the protective film to avoid any damage during changing.



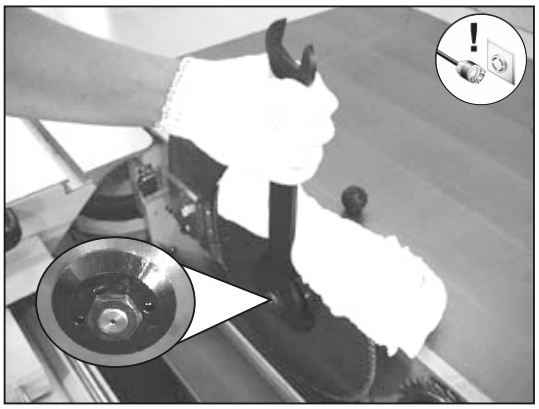
Push the sliding table towards the bottom. When the pusher rod is seen, push the ball on the pusher rod inwards to push the sliding table to the bottom.



Open the saw blade guard.



Raise the main saw blade to the highest position. Turn the saw blade until the fixing pin is inserted into the spindle fixing hole.



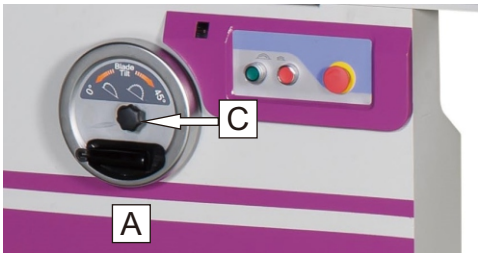
Use wrench to clockwise loosen the nut, clean the flange and new saw blade and then install them back to the spindle.

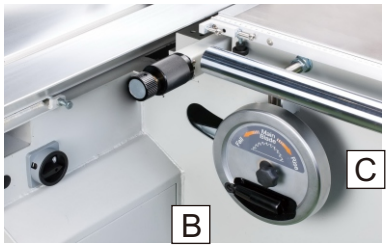
⚠ DANGER

The flange fixing nut of main saw blade must be tightened by torque 300kg/cm.

ADJUSTMENT FOR MAIN SAW HEIGHT AND TILTING.

Hand wheel operation





A. Hand wheel for main saw blade height adjustment. (As displaying in the diagram, the arrow direction is downward, on the contrary, upward.)

B. Hand wheel for main saw blade tilting adjustment. (As displaying in the diagram, the arrow direction is tilting angle increasing, on the contrary, tilting angle decreasing.)

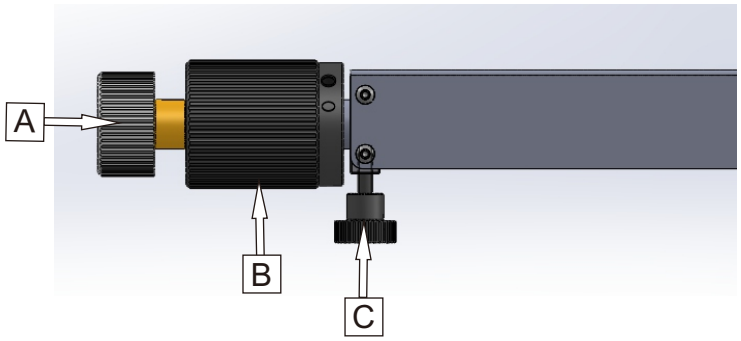
C. After adjusting the hand wheel, please lock up the knob as the C part in the diagram for fixing the hand wheel.

Tilting angle display

Tilting angle display for main saw blade.

2-11 SCORING SAW UNIT

OPERATE



A : Forward/backward adjusting knob.

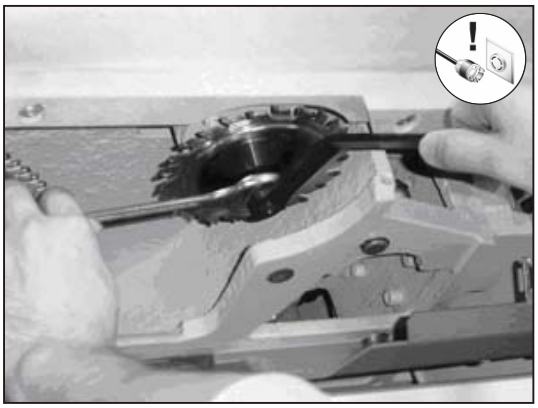
B : Lifting displacement knob.

C : Lifting fixing knob.

CHANGE

⚠ DANGER

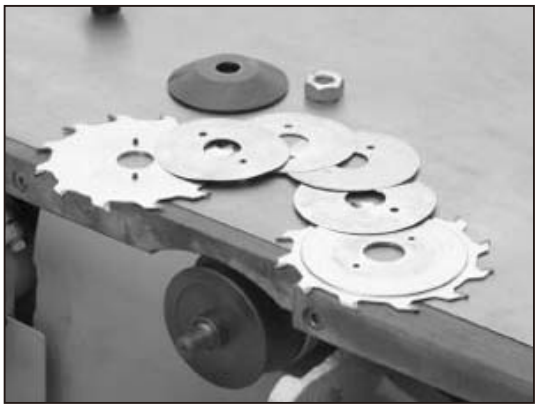
- Before changing the saw, please make sure if the power is closed to void danger.
- Before changing the saw, please install the protective film to protect the saw and avoid danger while change.



Push the sliding table to the ottom, open the saw blade guard (refer to 2-10 for detailed operation), use the handle to remove the flange fixing nut, clean the flange and new saw blade and then install them back to the scoring saw's arbor.

⚠ DANGER

The flange fixing nut of the scoring saw must be tightened by torque 250kg/cm.



- The cushion in above drawing is used to adjust the cutting width of the scoring saw being bigger than the cutting width of the main saw blade to make the cutting workpiece look nicer.
- Thickness of the attached scoring saw is 2.8mm but it can be adjusted to 4.3mm.
- Cushion's size & quantity :
  0.1mm → 1pcs.
  0.2mm → 1pcs.
  0.3mm → 4pcs.

2-12 PROTECT SWITCH ON THE END OF SLIDING TABLE

A: Should you accidently press the ON button when changing saw blade, this protect switch is able to keeps the saw blade standstill so that the operator won't get hurt.

B: Fig. 1 is the default installation

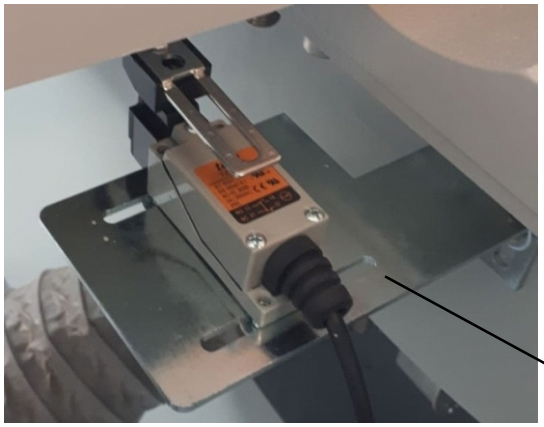


Fig. 1

C: How to adjust this protect switch

(a) Make the limit switch touches on the fix bracket touches the touch block

(b) Please refer to Fig. 2

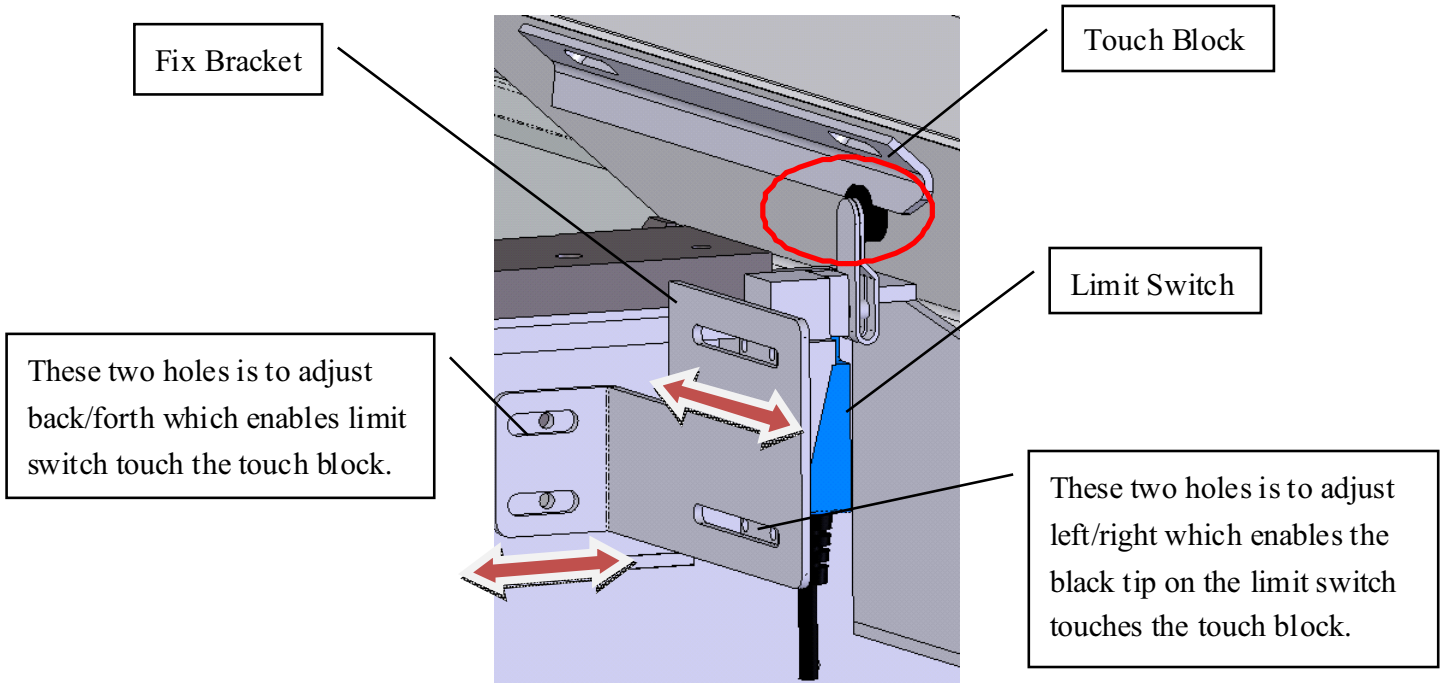


Fig. 2

3-1 POWER CONNECTION

⚠ DANGER

- Power connection must be done by the qualified electrical engineer.
- The machine must have an earth wire to prevent electric leakage from happening electric shock and even death.

Connect the wiring step :

1.Make sure the voltage of the machine conforms to your company's power.
2.Use the specific tool to open the power controlling box to connect power.
3. Connect three power wires to terminal L1(R),L2(S),L3(T) as shown in the Fig.1 and Fig.3. Connect the earth wire (green-yellow) to PE terminal.
4.Start motor to check if the rotating direction of the main saw blade and the scoring saw is the same direction as indicated in chapter 1-4.
5. If the saw blade rotates in reverse direction, please stop rotating

POWER DISTRIBUTION UNIT

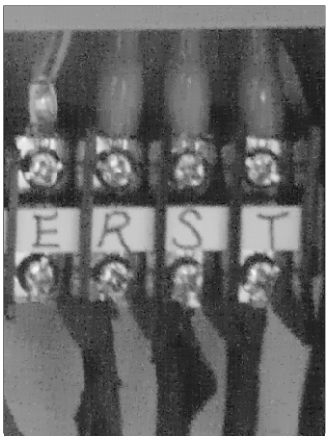


Fig.1

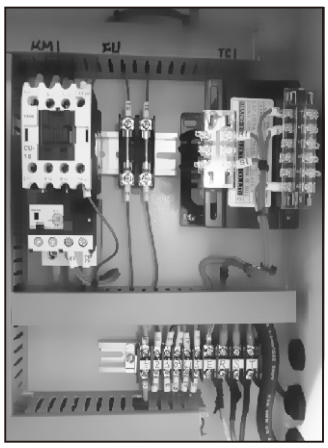


Fig.2

POWER DISTRIBUTION UNIT CE TYPE

Fig.3

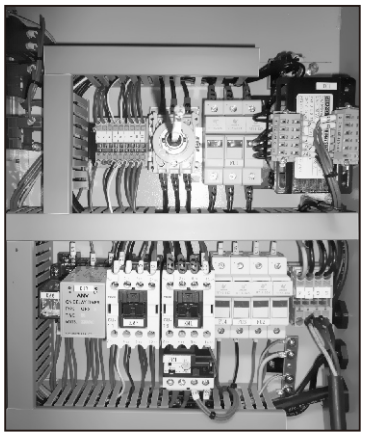


Fig.4

⚠ WARNING

- A/C load of fuse do not excess 3A, please use proper fuse
- Any arbitrarily change that burn the controller or destroy the machine is at the owner's risk

OPEN POWER CONTROLLING BOX

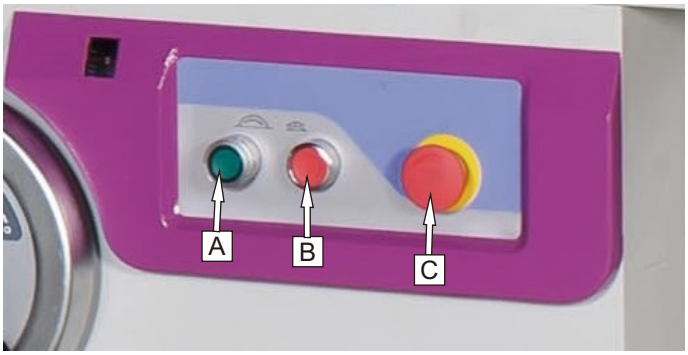
ATTENTION

Electricity input: make sure the voltage conform to company or country.

⚠ DANGER

Please make sure the power is turned off before opening the electric cabinet door.

3-2 OPERATION OF CONTROL PANEL

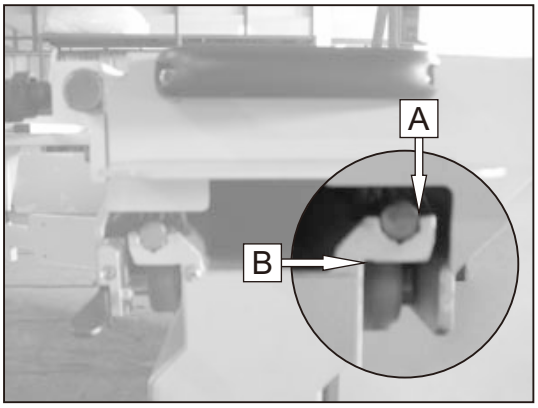


A. Main saw and Scoring saw start button
Start the main saw and scoring saw.

B. Main saw and Saw blade stop button
Stop the main saw and scoring saw.

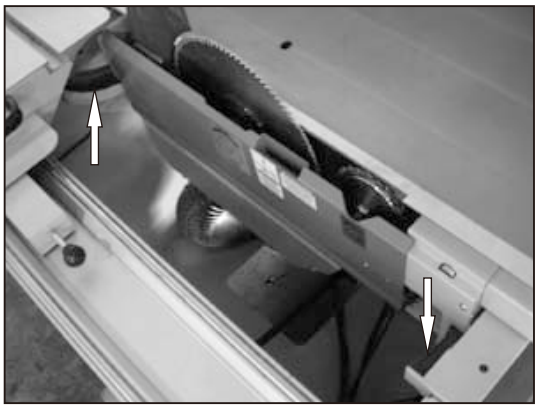
C. Emergency stop button
Urgently shut down the machine's power.

4-1 MAINTENANCE OF THE SLIDING TABLE



- Clean the machine on a daily basis for its optimal performance.
- Clean the contact surface (Surface A) of upper slide base and lower slide base.
- Clean the contact surface (Surface B) of lower slide base and the roller.
- Periodically clean above contact surfaces to keep long-term accuracy of machine.

4-2 MAINTENANCE OF ANGLE SLIDE RAIL



- Clean the machine on a daily basis for its optimal performance.
- Clean dust or wood chips on slide rail.
- After cleaning, apply the lubricating oil. Please refer to the following list to choose the lubricating oil.
- Periodically maintain above contact surfaces to keep long-term accuracy of machine.

List 1

ISO DIS-3498	LUBRICATING CYCLE	LUBRICATING WAY
XM2	6 months	Lubricate on the machine
BRAND		
MOBIL	ESSO	SHELL
MOBILUX 2	BEACON 2	ALVANIA R2

4-3 SAFETY CHECK【CE】

⚠ WARNING

Do safety check at least twice every week to secure emergency switch's normal function.

CHECK OF EMERGENCY STOP SWITCH

Steps of check :

1. Connect to power, start the main saw blade and the scoring saw to make the machine run.
2. Push each emergency stop of machine and check if the saw blade and the scoring saw completely stop within 7 seconds.
3. When the emergency stop starts, operate the machine to see if it works.
   Remarks : When the emergency stop starts, the machine doesn't have any action.
4. If the emergency stop is out of order, please immediately stop operation and respond to the supplier.

CHECK OF SAFETY CONNECTION SWITCH

Steps of check :

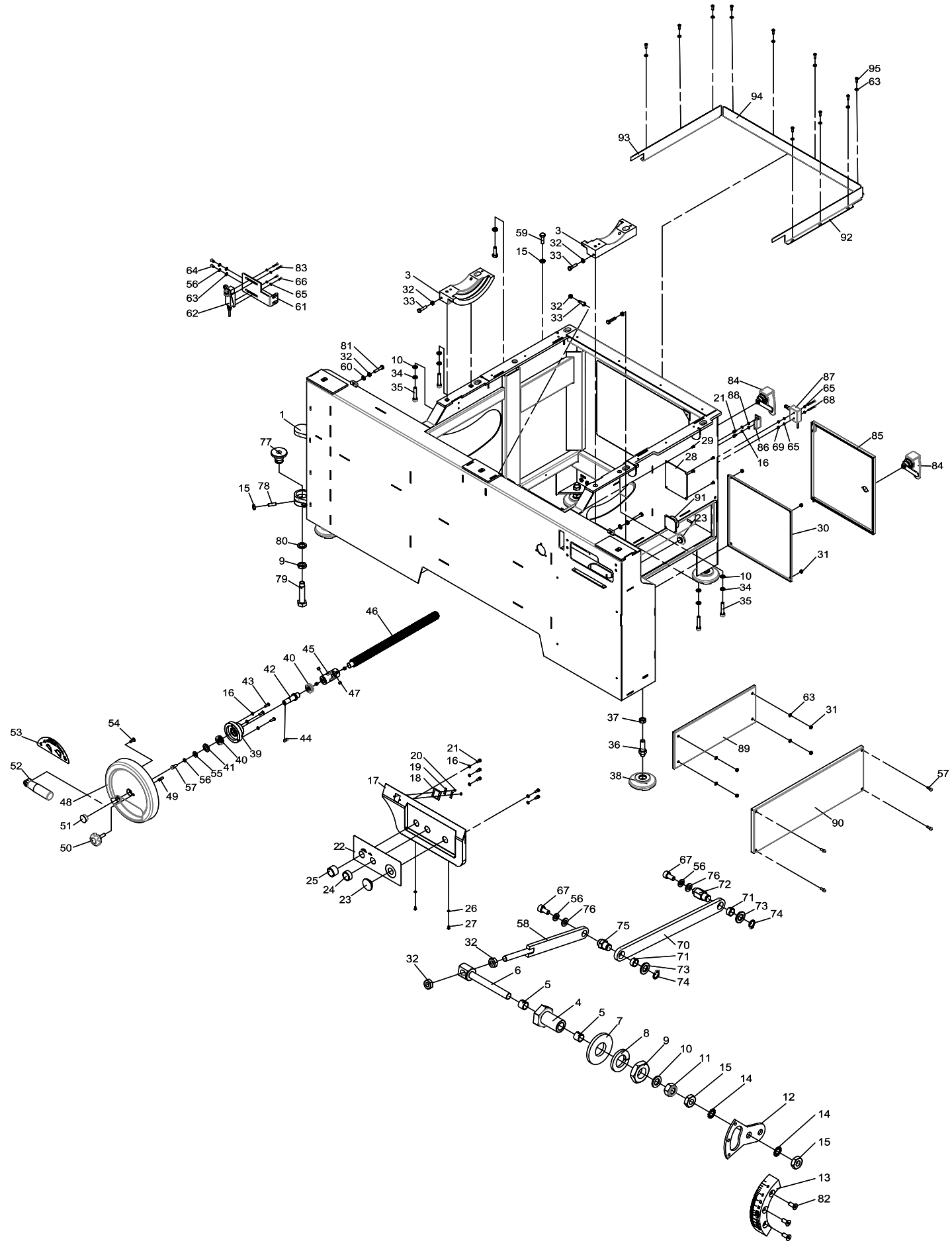
1. Connect to power, open safety door (i.e. saw blade's guard and service door at the back of the machine).
2. Operate the machine. At this time, the machine doesn't have any action.
3. Close the safety door and operate the machine again.
4. If machine works normally, that means the safety connection switch is normal.
5. If machine doesn't have any action when the safety door is closed, please stop operation immediately and respond to the supplier.

CHECK OF BRAKE

Steps of check :

1. While the saw blade and the scoring saw are running, push the saw stop switch or the emergency stop switch.
2. At this time, the saw blade and the scoring saw should completely stop within 7 seconds.
3. If the brake time exceeds 7 seconds, please immediately stip operating machine and respond to the supplier.

ERROS	REASON(s)	TROUBLE SHOOTIONG
PRESS ON BUT THE MACHINE ISN'T WORKING	1. NO POWER. 2. EMERGENCY STOP BUTTION HAS BEEN PRESSED. 3.INACCURATE VOLTAGE. 4.THE SAFETY GURAD HAS NOT BEEN COVERED	1.CHECK THE POWER. 2.LOOSEN THE EMERGENCT STOP BUTTON 3.CHECK THE VOLTAGE. 4.COVER THE SAFETY GUARD.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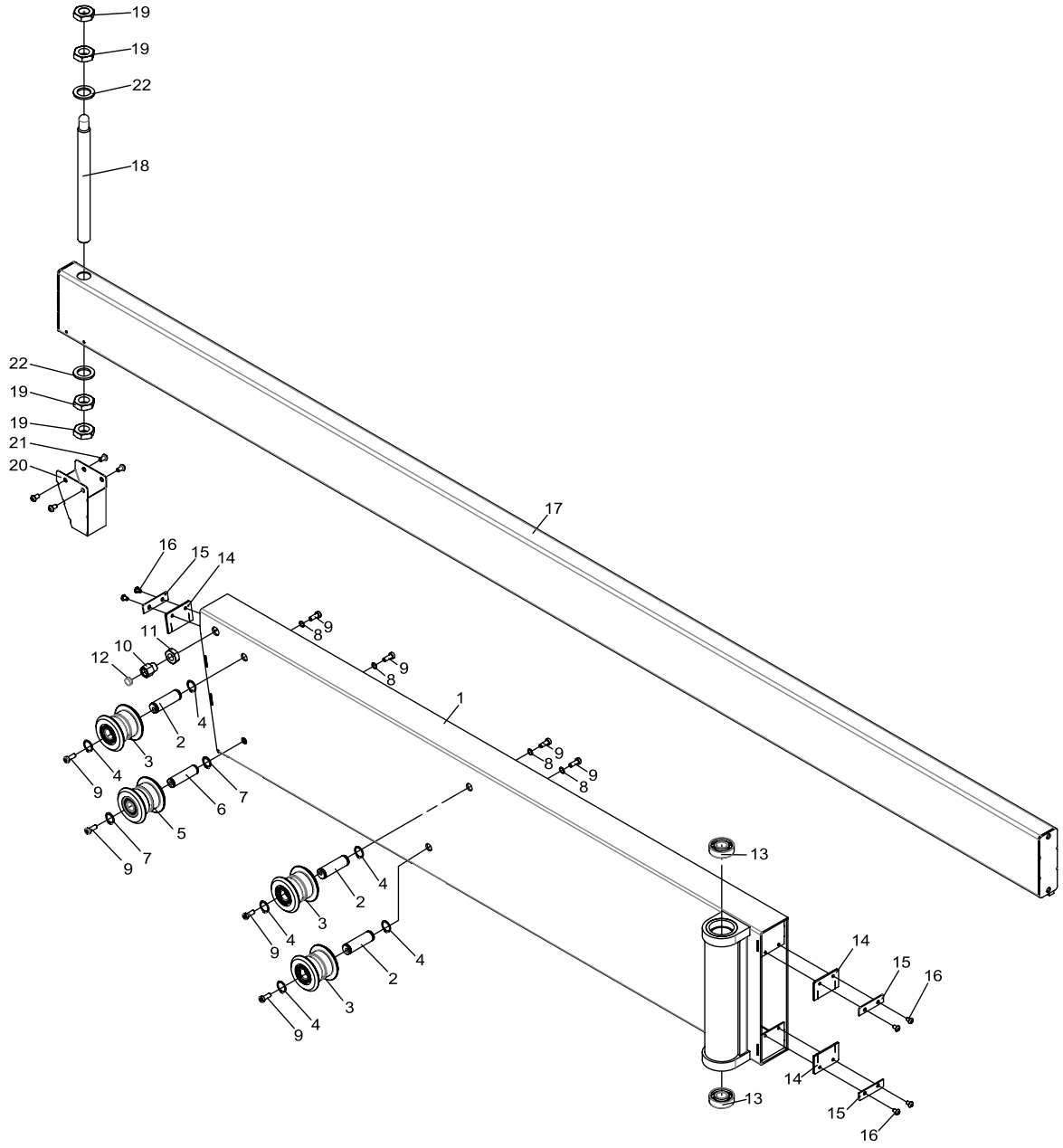
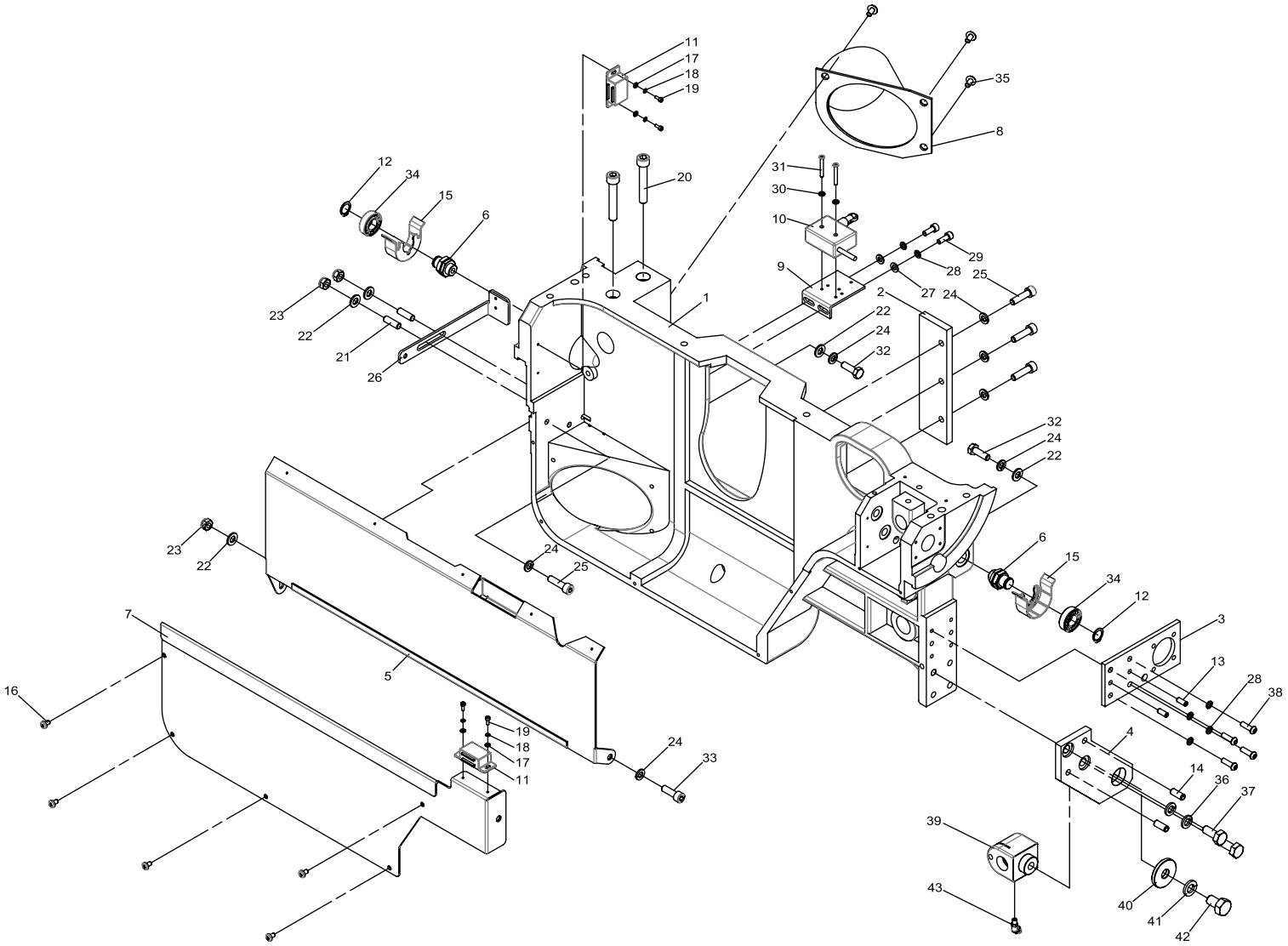
NO	FIG.NO.	DESCRIP TION	SPEC
1	20411001-B	Saw frame body	
3	20427005-0	Right slide base	
3	20427006-0	Trunnion(Left)	
4	20425011-0	Shaft	
5	403090044	Bushing	
6	20425012-0	Spmdle	
7	401151007	Washer	Ø20
8	401150009	Lock washer	Ø20
9	401101009	Hex nut	M20
10	401140005	Flat washer	Ø10
11	401103002	Lock nut	M10
12	20425013-0	Sway board	
13	20425016-0	Scale meter	
14	401151002	Spring washer	Ø8
15	401101019	Hex nut	M10
16	401150002	Lock washer	Ø5
17	20412003-0	Cover pad	
18	20412006-0	Plastic	
19	20412007-0	Gasket	
20	401101001	Hex nut	M3
21	401022027	Cap scre	M5x10
22	20412004-B	Membrane	
23	416010046	Emergency button	ZB4-BS844+ZB4-BZ102(1B)
24	416010048	Button	ZB4-BA4+ZB4-BZ102(1B)
25	416010047	Button	ZB4-BW33+ZB4-BZ101(1A)
26	401150001	Lock washer	Ø4
27	401032008	Button head serew	M4x8
28	20411002-0	Access Cover	
29	401032017	Button head serew	M5X10
30	20412002-0	Control panel access cover	
31	401101004	Hex nut	M6
32	401101005	Hex nut	M8
33	401010022	Hex head bolt	M8x35
34	401150005	Lock washer	Ø10
35	401022109	Cap scre	M10x50
36	LST-A017	Levelng pads	
37	401101012	Hex nut	M16
38	401260004	Adjust base	
39	20413001-0	Bearing base	
40	403060003	Thrust bearing	51102
41	NST-434-0-0	Washer	
42	NST-433-0-0	Shaft	
43	401032020	Button head serew	M5x16
44	401230026	Key	5x5x16
45	NST-404-0-0	Universal joint	
46	20425003-0	Driving nut	
47	401072033	Set screw	M6x6
48	NST-403-1-0	Handwheels	
49	NST-427-0-0	Set straight	
50	402070007	Star knobs	HS40AM825
51	414080001	Retaining plug head	HP-22
52	402010001	Revolving hadles	HL90
53	NST-430A	Tilt mark	
54	401052131	Counter sunk head cap screw	M6x16
55	NST-432-0-0	Washer	
56	401150003	Lock washer	Ø6
57	401022053	Cap scre	M6x16
58	20425015-0	Join arm	
59	401010038	Hex head bolt	M10x35
60	401140004	Washer	Ø8
61	LST-A013	Switch fixing plate	
62	416040005	Limit switch	ME-8104
63	401140010	Washer	Ø6xØ13
64	401032029	Round head screw	M6x10
65	401140001	Washer	Ø4
66	401042013	Phillips sunk head cap screw	M4x12
67	401022051	Cap screw	M6x12
68	401042003	Phillips sunk head cap screw	M4x35
69	401101002	Hex nut	M4
70	20425014-0	Join arm	
71	403090043	Oilless bearing	MB1006
72	20425018-0	Adjust shaft	
73	20425019-0	Washer	
74	401252005	Retaing rings for shaft	
75	20425017-0	Adjust shaft	
76	401140003	Washer	Ø6xØ16
77	ST-J025	Support adjusting baes	
78	401072069	Set serew	M10x30
79	ST-J013	Lower positioning shaft	
80	401140021	Washer	Ø20
81	401010023	Hex head bolt	M8x40
82	401052118	Counter sunk head cap screw	M5x12
83	401042014	Phillips head screw	M4x25
84	402010025	Handle	
85	20412001-B	Electrical Panel door	
86	20213003-0	Touch block	
87	416040002	Limit switch	TZ7312
88	401140002	Washer	Ø5
89	20212005-0	Electrical box bottom plate	
90	20412001-0	Electrical box cover	
91	416010045	Power Switch	ZH-28-2-80-BY
92	20411101-0	Shutter	
93	20411102-0	Shutter	
94	20411103-0	Shutter	
95	401032032	Button head screw	M6x16



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-G001G	Crosscut Swing Arm	P26/P32
2	LST-G004	Adjustment shaft	
3	ST-J014K	Roller/Ball bearing	6003-ZZ TPI
4	401252012	Ext Retaining Ring	S-17
5	ST-J014L	Roller/Ball bearing	6202-ZZ TPI
6	ST-J015	Roller for shaft	
7	401252010	Retaining rings for shaft	S-15
8	401151002	Washer	Ø8
9	401212001	Low head cap screw	M8x16
10	LST-A008A	Houshing for magnet	
11	401101008	Hex nut	M14

NO	FIG.NO.	DESCRIP TION	SPEC
12	402120001	Magnet	Ø12x5 S03302
13	403015133	Ball Bearing	6203-LLU TPI
14	LST-G003	Way wipers	
15	LST-G002	Locating plate	
16	401032016	Button Head Serew	M5x8
17	LST-G009B	Crosscut Swing Arm Extension(2220mm)	3.2
18	LST-G008	Threaded Shaft	M20xP2.5
19	401102002	Hex nut	M20-9.5t
20	ST-J023B	Cover plate	
21	401032029	Round head screw	M6x10
22	LST-G032	Washer	Ø22-Ø34-3t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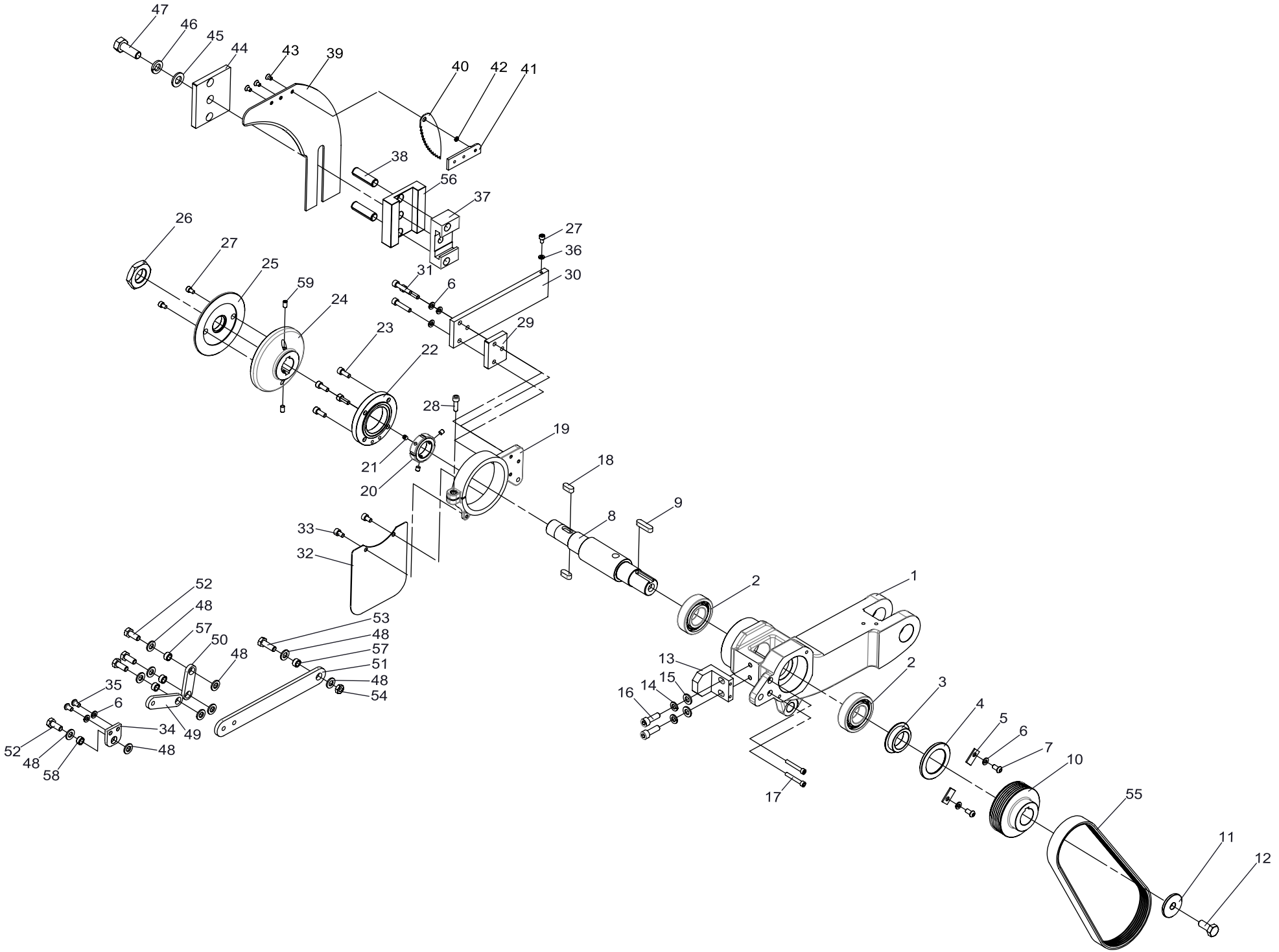
NO	FIG.NO.	DESCRIP TION	SPEC
1	20421001-0	Motor mount casting	
2	20421003-0	Fixed bar	
3	20423023-0	Fix base	
4	20425001-0	Tilting nut bas	
5	20427001-A	Lpwer blade cover	
6	20427003-A	Eccentric shaft	
7	20427004-A	Lower blade cover	
8	20427008-0	Dust collector connector	
9	LST-B014A	Fixed sheet	
10	416040001	Limit switch	TZ7311
11	402120004	Magnets	H-22-C
12	401252010	Retaingrings for shaft	S-15
13	401200036	Spring pin	Ø6x15
14	401200015	Spring pin	Ø8x20
15	20225001-0	Scraper	
16	401042107	Phillips sunk head cap screw	M5x8
17	401140015	Washer	Ø3
18	401150010	Lock washer	Ø3
19	401022002	Cap screw	M3x8
20	401021111	Cap scre	M10x60
21	401072055	Set screw	M8x25
22	401151002	Safety Washer	Ø8

NO	FIG.NO.	DESCRIP TION	SPEC
23	401103001	Lock nut	M8
24	401150004	Lock washer	Ø8
25	401022080	Cap screw	M8x30
26	20427002-0	Limit switch stop	
27	401140010	Washer	Ø6
28	401150003	Lock Washer	Ø6
29	401022053	Cap scre	M6x16
30	401140001	Washer	Ø4
31	401042002	Phillips sunk head cap screw	M4x30
32	401010020	Hex Bolt	M8x25
33	401022079	Cap Screw	M8x25
34	403017102	Ball bearing	6002LLB
35	401042101	Phillips Head Screw	M6x12
36	401150005	Lock washer	Ø10
37	401010036	Hex head bolt	M10x25
38	401032033	Button head screw	M6x20
39	20425002-0	Porca direcionadora	
40	20421006-0	Washer	
41	401150006	Lock washer	Ø12
42	401011019	Hex Head Bolt	M12x20
43	410030002	Grease nipples	M6-45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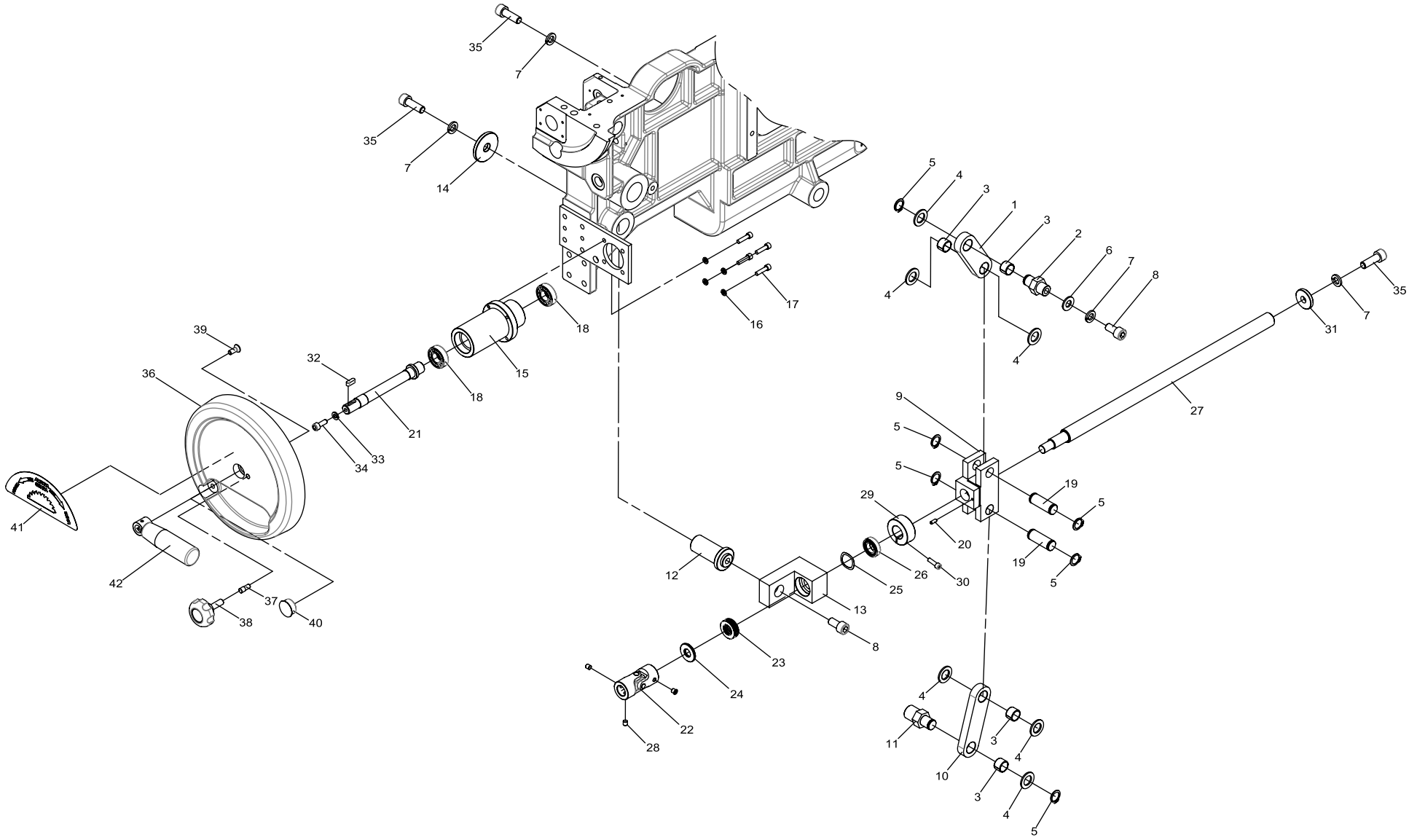
NO	FIG.NO.	DESCRIPTION	SPEC
1	20431001-0	Spindie base	
2	403010319	Ball bearing	TPI 6206 LLB
3	LST-C004	Bearing cover	
4	LST-C005	Bearing cover	
5	ST-H070	Fixed Sheet	
6	401150003	Lock Washer	Ø6
7	401032030	Button Head serew	M6x12
8	20431002-0	Spindle	
9	401230005	Key	8x7x32
10	20431006-0	Spindle pulley	
11	LST-C007	Fixed ring	
12	401010036	Cap scre	M10x25
13	20421002-0	Auxiliary slide rail	
14	401150004	Lock Washer	Ø8
15	401140004	Washer	Ø8
16	401010020	Cap scre	M8x25
17	401022035	Cap scre	M5x35
18	401230016	Key	8x7x20
19	20434001-0	Support bracket	
20	401110007	Exact nut	M30xP1.5-L
21	401071033	Set serew	M6x6
22	20431003-0	Bearing cover	
23	401022053	Cap scre	M6x16
24	LST-C008	Shaft flange	
25	ST-H064A	Shaft Cover	
26	ST-H060A	Lock nut	M25xP2.0(Left tooth)
27	401022026	Cap scre	M5x8
28	401022055	Cap scre	M6x20
29	20434010-0	Fixed block	
30	20434006-0	Sliding rail	

NO	FIG.NO.	DESCRIPTION	SPEC
31	401022057	Cap scre	M6x30
32	20431004-0	Cover	
33	401032029	Cap scre	M6x10
34	20434002-0	Fixed block	
35	401032029	Round head screw	M6x10
36	401150002	Lock washer	Ø5
37	20434008-0	Fixed block	
38	401200034	Roll Pin	D13x45
39	20234001-A	Riving Knife	
40	20234002-0	Bulletproof claw	
41	20234003-0	Connecting piece	
42	20234004-0	Collar	
43	401052118	Counter sunk head cap screw	M5x12
44	20434009-0	Riving Knife Adjustment Plate	
45	401140014	Washer	Ø12
46	401150006	Lock Washer	Ø12
47	401010053	Hex Head Bolt	M12x35
48	401140004	Washer	Ø8
49	20434004-0	Connecting bar	
50	20434003-0	Connecting bar	
51	20434005-0	Connecting bar	
52	401010019	Hex Head Bolt	M8x20
53	401010020	Hex Head Bolt	M8x25
54	401101005	Hex nut	M8
55	405150006	Multi-grooved skin	6pk730
56	20434007-0	Adjust block	
57	20439002-0	Bushing	
58	20439003-0	Bushing	
59	401072035	Set screw	M6x10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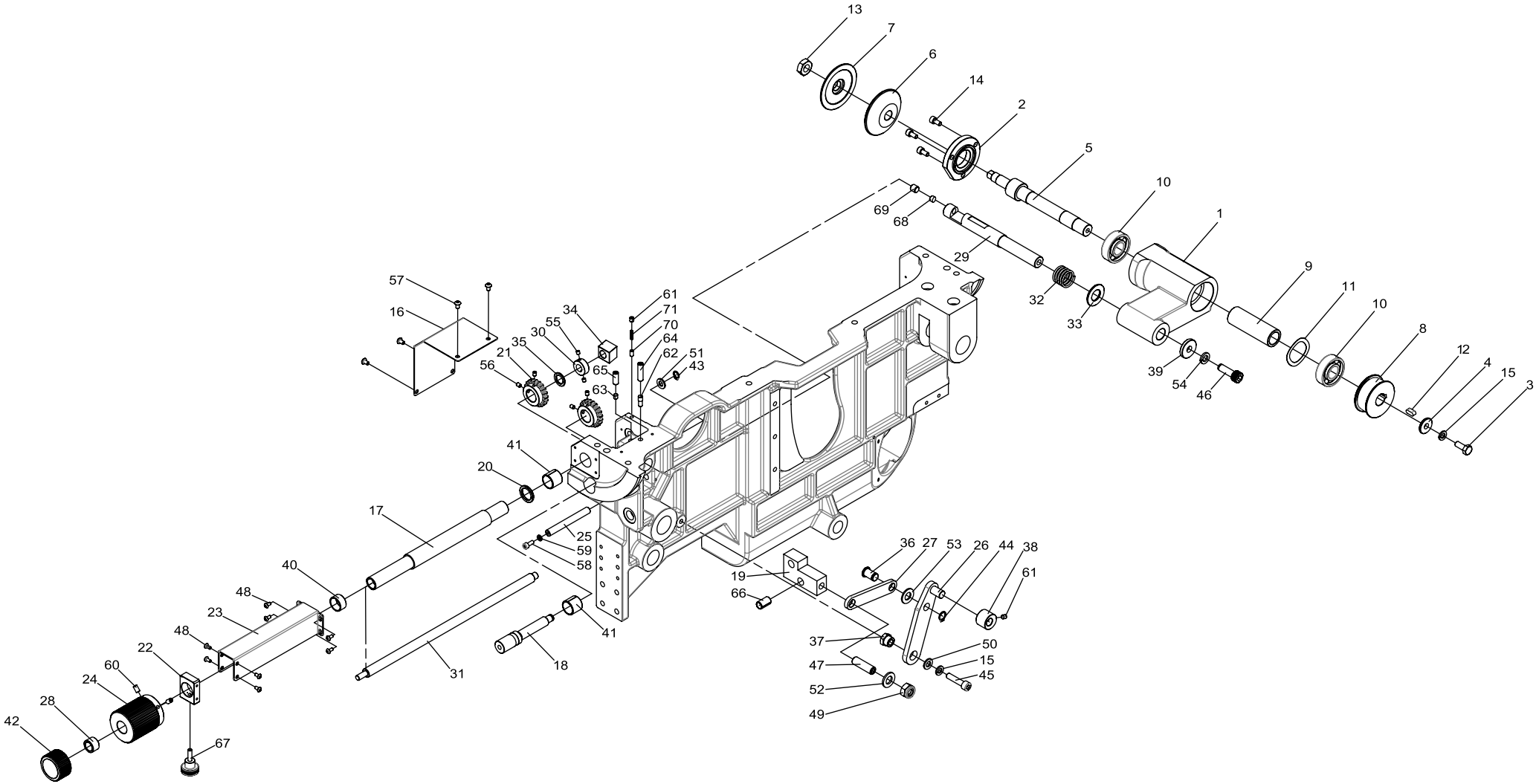
NO	FIG.NO.	DESCRIP TION	
1	20423009-0	Join arm	
2	20423010-0	Fixed shaft	
3	403090041	Oilless Bearing	BM1512
4	20423013-0	Washer	
5	401252010	Retaing rings for shaft	STW- Ø15
6	401140005	Washer	Ø10
7	401150005	Lock Washer	Ø10
8	401022103	Cop screw	M10x20
9	20423007-0	Main saw blade up/down adjust	
10	20423008-0	Join arm	
11	20423011-0	Fixed shaft	
12	20423003-0	Fixed shaft	
13	20423001-0	Worm base	
14	20421006-0	Washer	
15	20423021-0	Gear base	
16	401150002	Lock Washer	Ø5
17	401022032	Cap screwM	M5x20
18	403017102	Ball bearing	6002-LLU
19	20423012-0	Adjust shaft	
20	401071015	Set serew	M4x10
21	20423022-0	Shaft	

NO	FIG.NO.	DESCRIP TION	
22	20423004-0	Universal joint	
23	403060003	Thrust bearing	51102
24	20423006-0	Washer	
25	411050003	Waves spring	
26	403013234	Ball bearing	6902 LLU
27	20423002-0	Driving shaft	
28	401072033	Setscrew	M6X6
29	20423024-0	Fixed ring	
30	401022030	Cap scre	M5x16
31	RH-2040	Washer	
32	401230007	Key	5x5x15
33	401150003	Lock Washer	Ø6
34	401022053	Cap scre	M6x16
35	401022105	Cap scre	M10x30
36	NST-403-1-0	Handwheels	
37	NST-427-0-0	Set straight	
38	402070007	Star Knobs	HS40AM825
39	401052132	Countersink Hend Screw	M6x16
40	414080001	Retaining plug head	HP-22
41	NST-429A	Elevator mark	
42	402010001	Revolving hadles	HL90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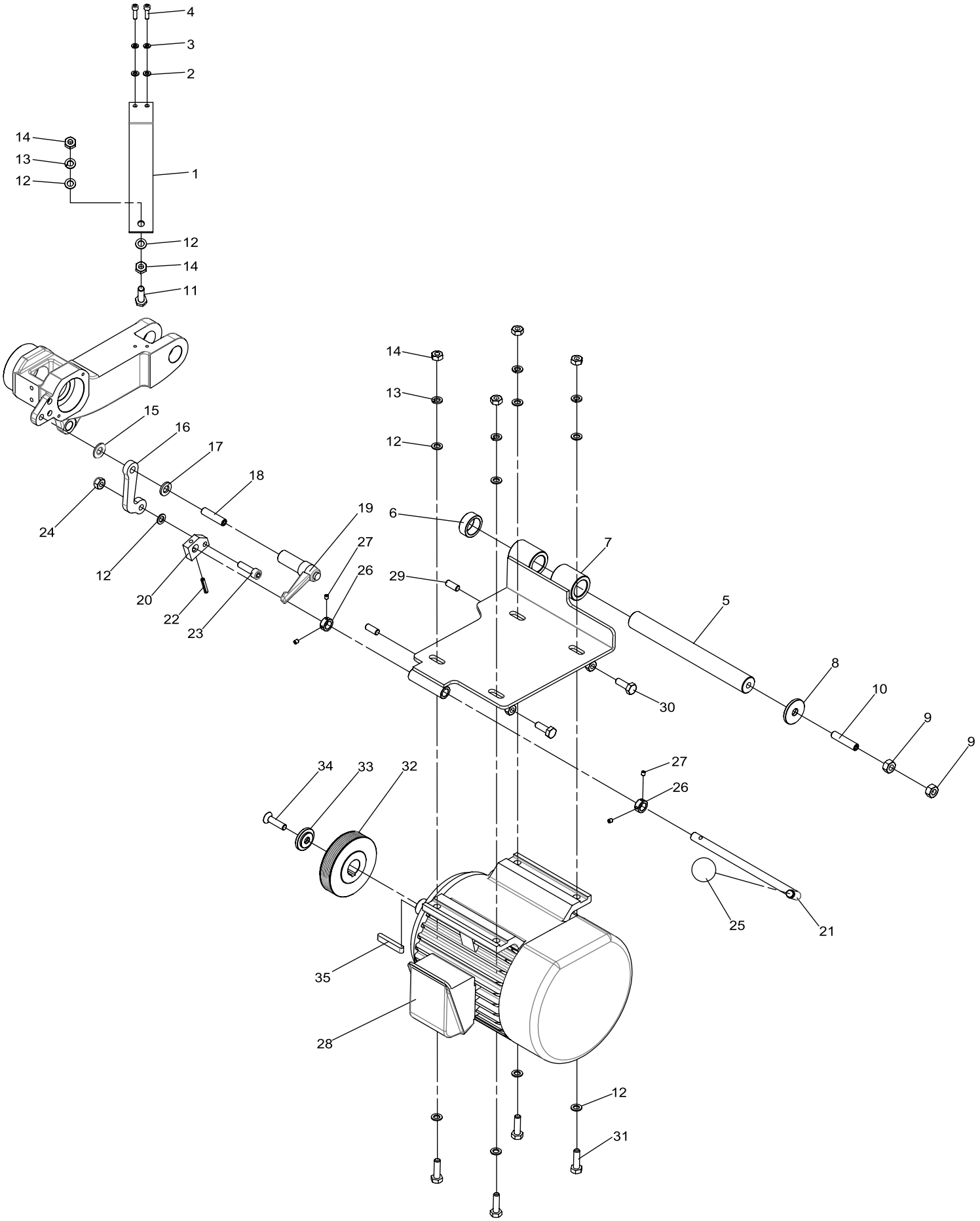
NO	FIG.NO.	DESCRIPTION	SPEC
1	20441001-0	Spindle base	
2	NST-321-0-0	Bearing's front cover	
3	ST-I038A	Left hex head bolt	
4	ST-I039A	Fixing Ring	
5	ST-I044	Small spindle	
6	ST-I046	Rear cover	
7	ST-I047	Front cover	
8	ST-I048C	Pulley	
9	ST-I081	Collars	
10	403010305	Ball bearing	6204LLB CM
11	411050001	Waves spring	WB-6303
12	401230006	Key	6x6x15
13	401101008	Hex nut	M14-8t
14	401022051	Cap scre	M6x12
15	401150003	Lock Washer	Ø8
16	20427007-0	Cover	
17	20443001-0	Hollow adjust shaft	
18	20443002-0	Adjust shaft	
19	20443003-0	Sliding block	
20	20443004-0	Washer	
21	20443005-0	Gear	
22	20443007-0	Fixed block	
23	20443008-0	Fixed rack	
24	20443009-0	Control knob	
25	20443010-0	Pivot axis	
26	20443011-0	Arm sawying	
27	20443012-0	Join arm	
28	20443013-0	Bushing	
29	20445001-0	Driving shaft	
30	20445003-0	Fixed ring	
31	20445004-0	Driving shaft	
32	LST-D024	Spring	
33	20445006-0	Washer	
34	LST-D009	Caterpilar block	
35	LST-D017A	Washer	
36	NST-315-0-0	Pivot axis	

NO	FIG.NO.	DESCRIPTION	SPEC
37	NST-317-0-0	Pivot axis	
38	NST-328-0-0	Adjustment collars	
39	RH-2040	Washer	
40	20445007-0	bushing	
41	403090040	Oilless Bearing	BM2020
42	402080007	Control knob	
43	401252005	Retaing ring for shaft	STW-10
44	401252007	Retaing rings for shaft	STW-12
45	401022081	Cap scre	M8x35
46	401022105	Cap scre	M10x30
47	401072083	Set serew	M12x40
48	401032008	Button head serew	M4x8
49	401103003	Lock nut	M12
50	401140016	Washer	Ø8
51	401140004	Washer	Ø8
52	401140014	Washer	Ø12
53	401140022	Washer	Ø12
54	401150005	Lock washer	Ø10
55	401072136	Set serew	M5x4
56	401072023	Set serew	M5x6
57	401032016	Button Head Serew	M5x8
58	401022028	Cap scre	M5x12
59	401150002	Lock Washer	Ø5
60	401072035	Set serew	M6x10
61	401072033	Set serew	M6x6
62	NST-427-0-0	Set straight	
63	20429004-0	Stop column	
64	401072056	Set serew	M8x30
65	401072054	Set serew	M8x20
66	403090045	Oilless Bearing	BM1020
67	402100004	Embossing screw	8010-25-M6-20
68	20445008-0	Stop column	
69	401072064	Set serew	M10X10
70	20445009-0	Stop column	
71	411010024	cpmpressed spring	AH04-15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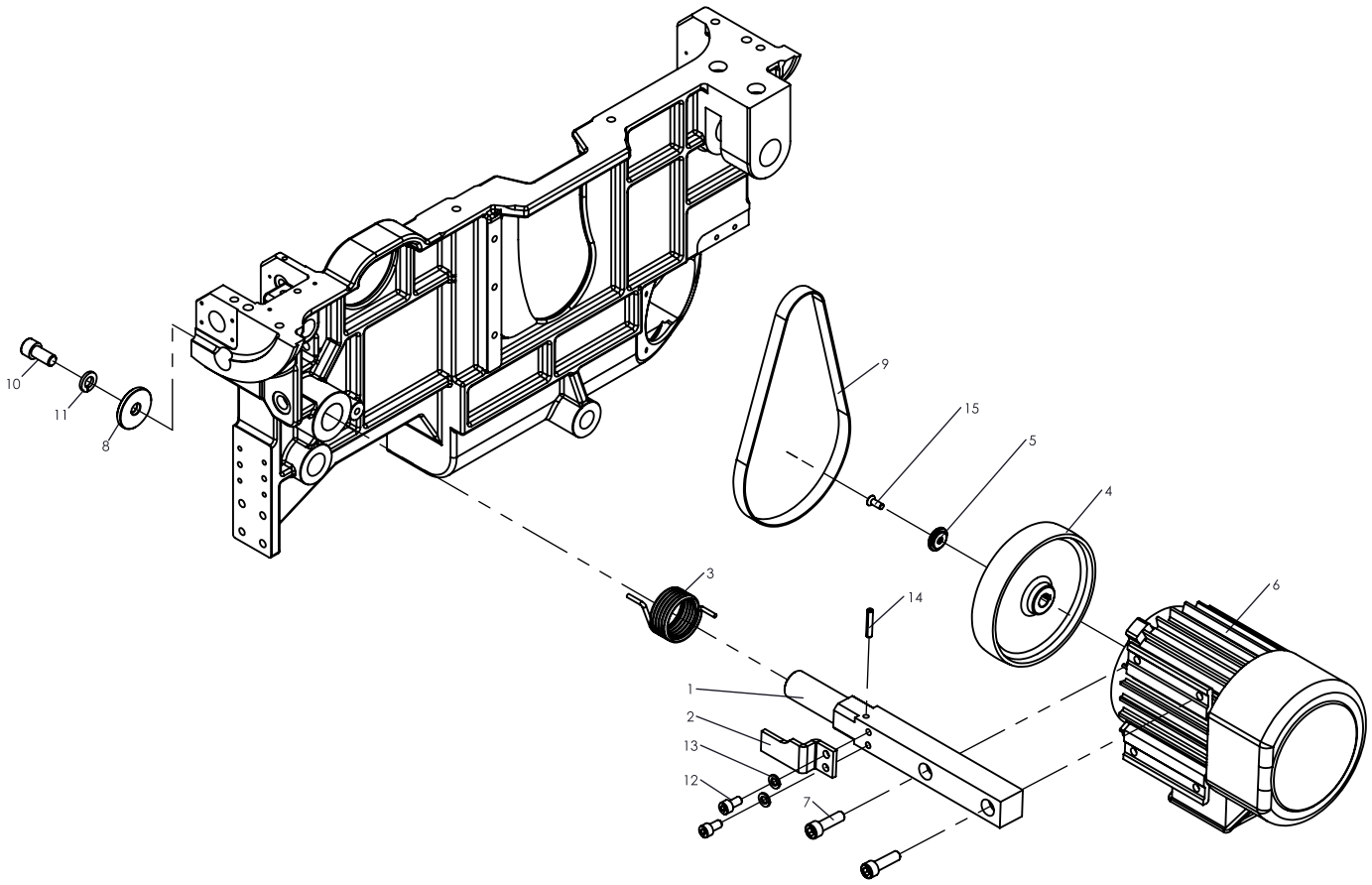
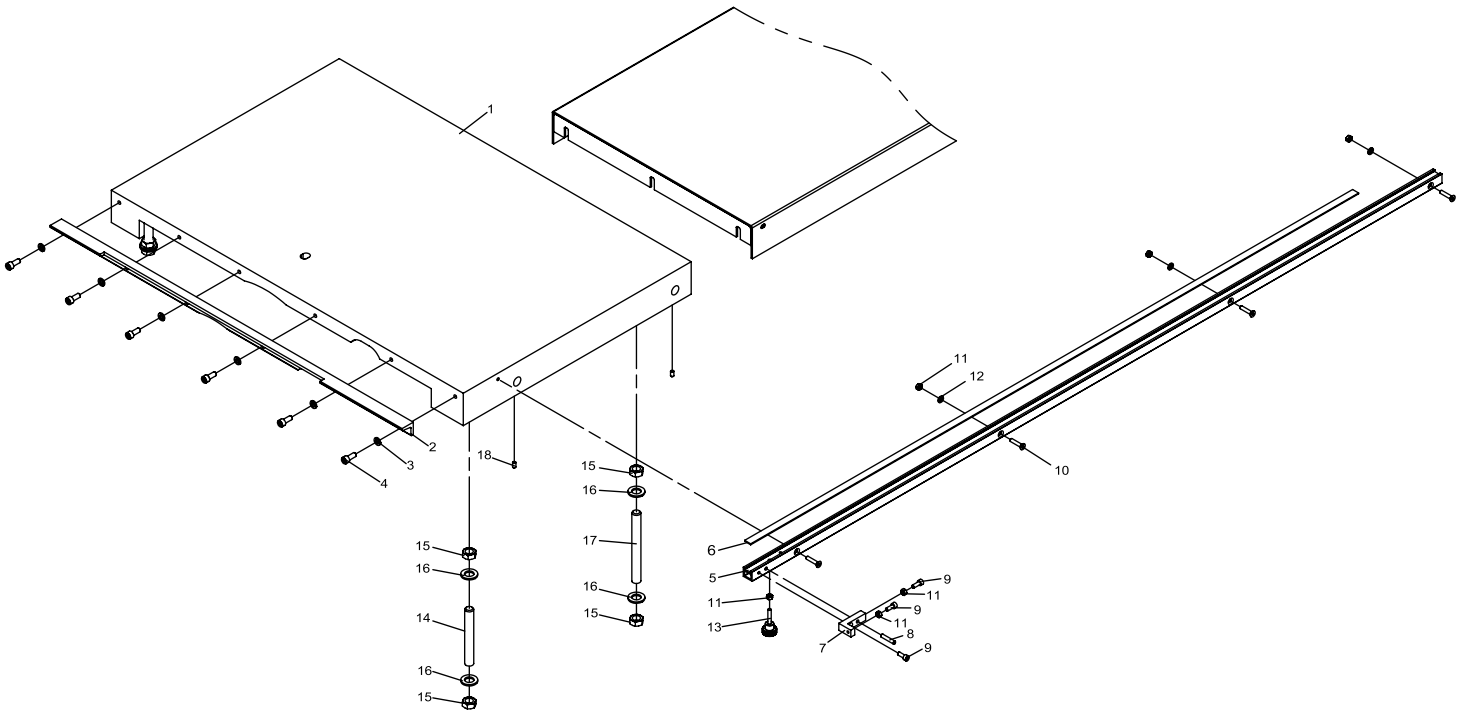
NO	FIG.NO.	DESCRIP TION	SPEC
1	20433002-0	Spring sheet	
2	401140010	Washer	Ø6
3	401150003	Lock Washer	Ø6
4	401022055	Cap scre	M6x20
5	20421004-A	Pivot axis	
6	20421005-A	Spacer	
7	20433001-0	Motor board	
8	20421006-0	Washer	
9	401101007	Hex nut	M12
10	401072086	Setscrew	M12x55
11	401010039	Hex Head Bolt	M10x40
12	401140005	Washer	Ø10
13	401140005	Lock Washer	Ø10
14	401101006	Hex nut	M10
15	401140022	Washer	Ø12
16	LST-C018	Elbow	
17	401140014	Washer	Ø12
18	401072085	Sew serew	M12x50

NO	FIG.NO.	DESCRIP TION	SPEC
19	402040006	Adjustable handle	95KA-M12-O
20	LST-C019	Rotary block	
21	LST-C020	Adjust handle	
22	401200006	Spring pin	Ø6X32
23	401022106	Cap scre	M10x35
24	401103002	Lock Nut	M10
25	40206006	Ball knob	M12
26	LST-D014	Sleeve ring	
27	401071033	Set serew	M6x6
28		Motor	
29	401071068	Set serew	M10x25
30	401010037	Hex Head Bolt	M10x30
31	401010038	Hex Head Bolt	M10x35
32	20433005-0	Motor Pulley	
33	20433004-0	Fixed ring	
34	401052154	Counter sunk head cap screw	M10x35
35	401230002	key	10x8x50



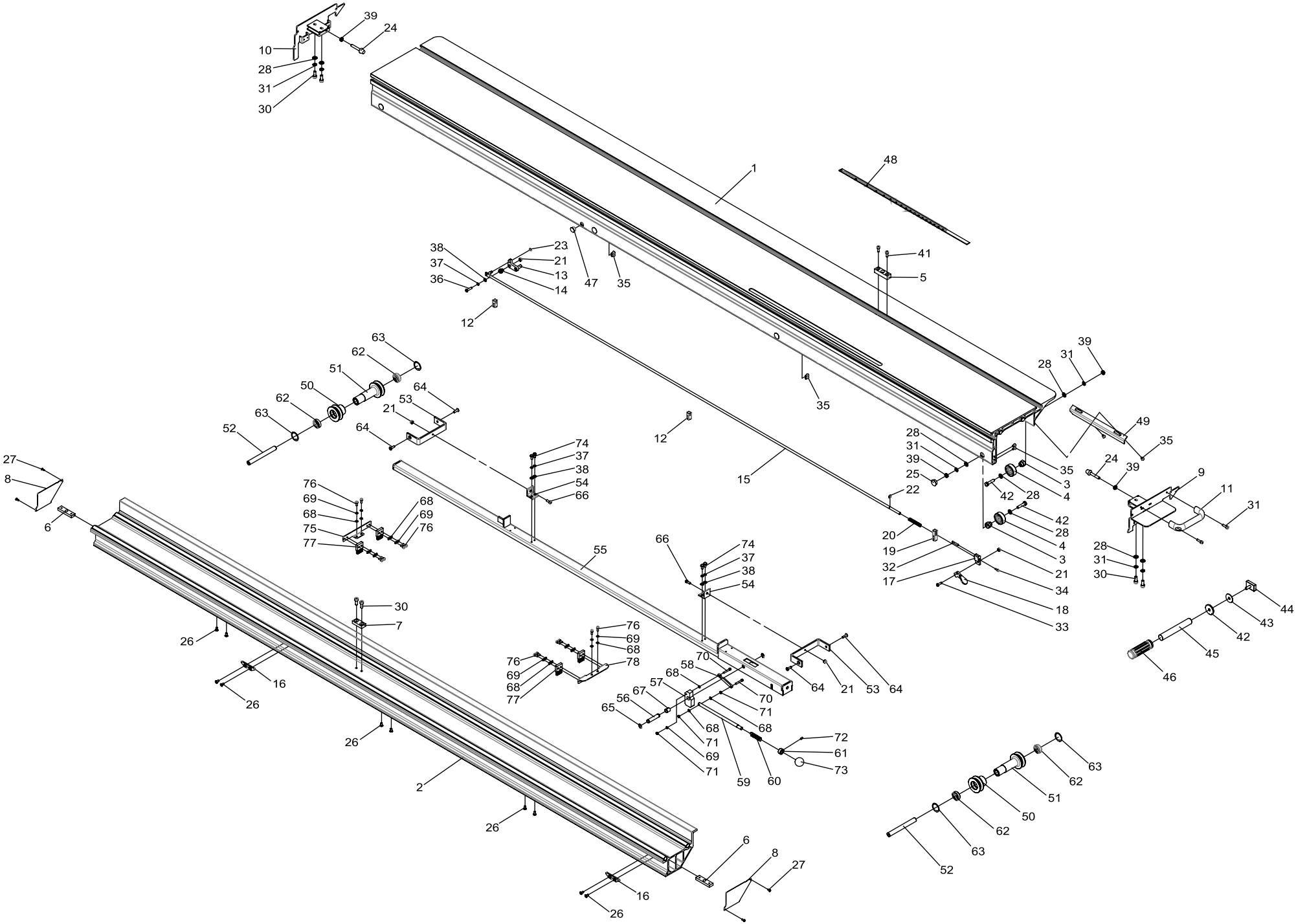
NO	FIG.NO.	DESCRIP TION	SPEC
1	20442001-A	Pivot axis	
2	20442002-0	Stop board	
3	NST-104-0-0	Torque Spring	
4	ST-I032A	Pulley	
5	ST-I040	Lock Ring	
6		Moto	1_2HP
7	401022106	Cap Scre	M10x35
8	20421006-0	Washer	

NO	FIG.NO.	DESCRIP TION	SPEC
9	405040006	Flat belt	15x670x1.8t
10	401021126	Cap scre	M12x25
11	401150006	Lock washer	Ø12
12	401022076	Cap scre	M8x16
13	401150003	Lock washer	Ø8
14	401200006	Spring pin	Ø6x32
15	401052131	Counter sunk head cap screw	M6x16



NO	FIG.NO.	DESCRIP TION	SPEC
1	20451001-0	Main table	
2	20451002-0	Table insert	
3	401150003	Lock nut	Ø8
4	401080012	Hex head bolt	M8x15
5	ST-O016A	Scale base	1.3m
6	ST-N436	Scale	1.3m/1.5m
7	ST-O026	Scale base rubber guide	
8	401200019	Poll pin	
9	401022053	Cap scre	M6x16

NO	FIG.NO.	DESCRIP TION	SPEC
10	401052134	Counter sunk head cap screw	M6x30
11	401101004	Hex nut	M6
12	401140010	Washer	Ø6
13	402100001	Knob bolt	M6 X30
14	401071130	Set screw	
15	401101012	Hex nut	M16
16	401140007	Flat washer	Ø16
17	401071130	Set serew	M16
18	401072035	Set screw	M6x10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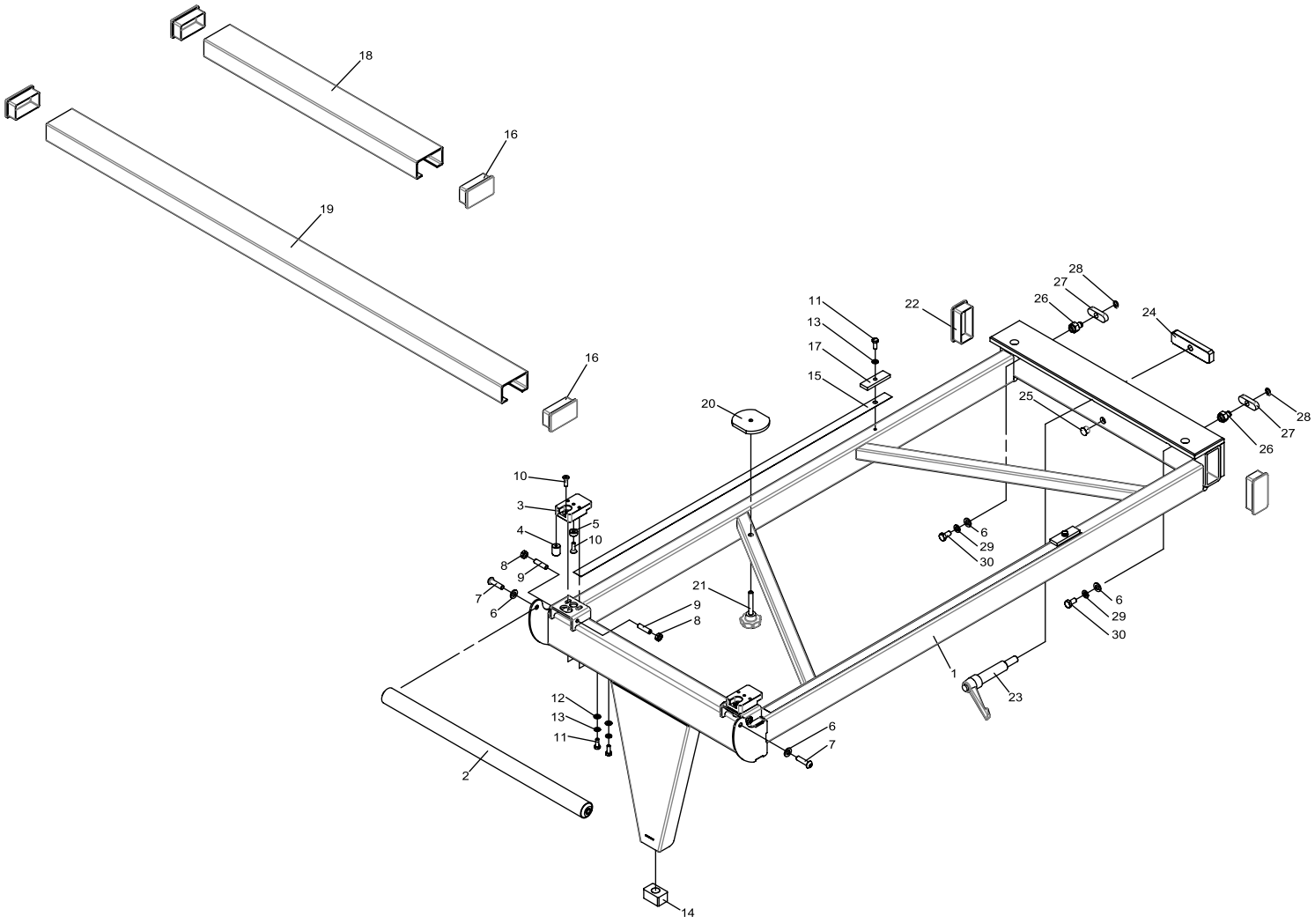
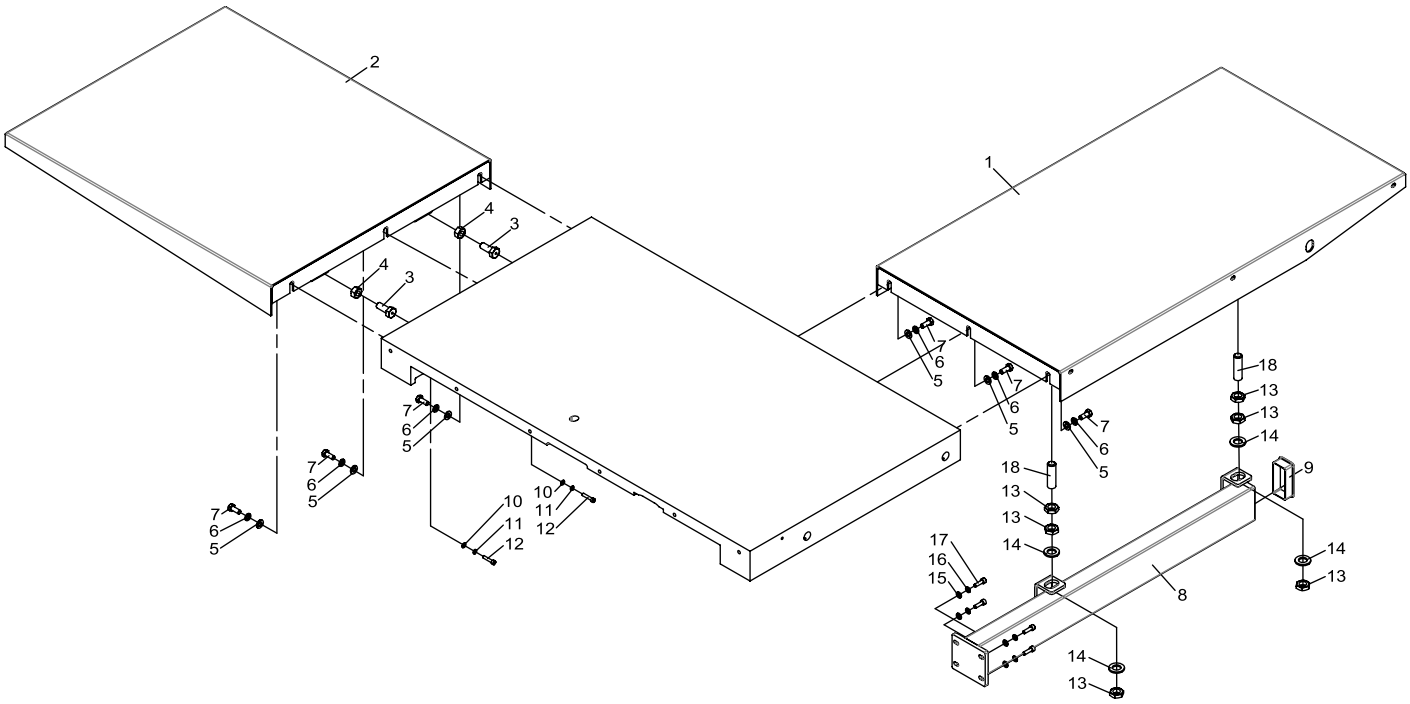
NO	FIG.NO.	DESCRIPTION	SPEC
1	NLST-J001E	Sliding table	
2	NLST-J002E	Supporting base	
3	ST-K044	Sliding wheel adjusting block	
4	ST-K043A	Sliding Wheel	
5	ST-L007	Positioning block	
6	NLST-J003	Lock black	
7	ST-K041C	Stop block	
8	NLST-J031	Cover	
9	NLST-J032	Right dust gunrd metal sheet	
10	NLST-J033	Left dust guard metal sheet	
11	402020001	Handle U type	1053-310
12	NLST-J041	Fixed block	
13	NLST-J042	Connecting block	
14	NLST-J043	Pivot axis	
15	NLST-J045E	Conneting bar	3.2
16	ST-K316	Positioning block	
17	ST-K308A	Stop block	
18	ST-K307A	Handle	
19	NLST-J044	Fixed block	
20	ST-K317	Spring	
21	401103005	Lock nut	M6
22	401253012	Retaining Rings E Type	E6
23	401253009	Retaining Rings E Type	E4
24	402160002	Stop block	SSP-FC-806312
25	414080003	Hole plugs	HP-19
26	401052129	Counter sunk head cap screw	M6x12
27	401032009	Button head serew	M4x10
28	401151002	Safety Washer	Ø8
29	401150003	Lock nut	Ø8
30	401022078	Cap scre	M8x20
31	401022055	Cap scre	M6x20
32	401200016	Spring Pin	5x30
33	401032033	Button head screw	M6x20
34	401022014	Cap Screw	M4x12
35	401032029	Round head screw	M6x10
36	401032034	Button head screw	M6x25
37	401150003	Lock Washer	Ø6
38	401140010	Washer	Ø6
39	401101005	Hex Head Bolt	M8

NO	FIG.NO.	DESCRIPTION	SPEC
40	401010022	Hex head bolt	M8x35
41	401022053	Cap scre	M6x16
42	NLST-J054	Washer	
43	NLST-J053	Washer	
44	NLST-J052	T shape block	
45	ST-K004	Handle	
46	402010011	Handle sleeve	
47	414080004	Hole plugs	HP-16
48	ST-K010	Scale	
49	NLST-J036	Touch block	
50	ST-K095	Sliding wheel	
51	NLST-J016	Sliding wheel	
52	NLST-J017	Sliding wheel axle	
53	NLST-J018	Sliding wheel base	
54	NLST-J019	Packing-up block	
55	20461031-0	Sliding bar	
56	NLST-J021	Fixed shaft	
57	NLST-J022	Stop block	
58	ST-K073	Join element	
59	ST-K080	Pull bar	
60	ST-K082	Spring	
61	ST-K083	Fixing ring	
62	403017102	Ball bearing	6002LLB
63	401251024	Retain Ring	R32
64	401052132	Counter sunk head cap screw	M6x12
65	401252007	Retain Ring	S12
66	401022229	Low head cap screw	M6-16
67	403090013	Bush	LFB1215
68	401140002	Washer	Ø5
69	401150002	Lock Washer	Ø5
70	401022034	Cap screw	M5x30
71	401101003	Hex screw	M5
72	401072024	Set serew	M5x8
73	402060005	Ball-shaped knob	32-M10
74	401010007	Hex head bolt	M6x12
75	20461034-0	Brush rack	
76	401022028	Cap scre	M5x12
77	ST-K031B	Bristle brush	
78	20461033-0	Brush rack	



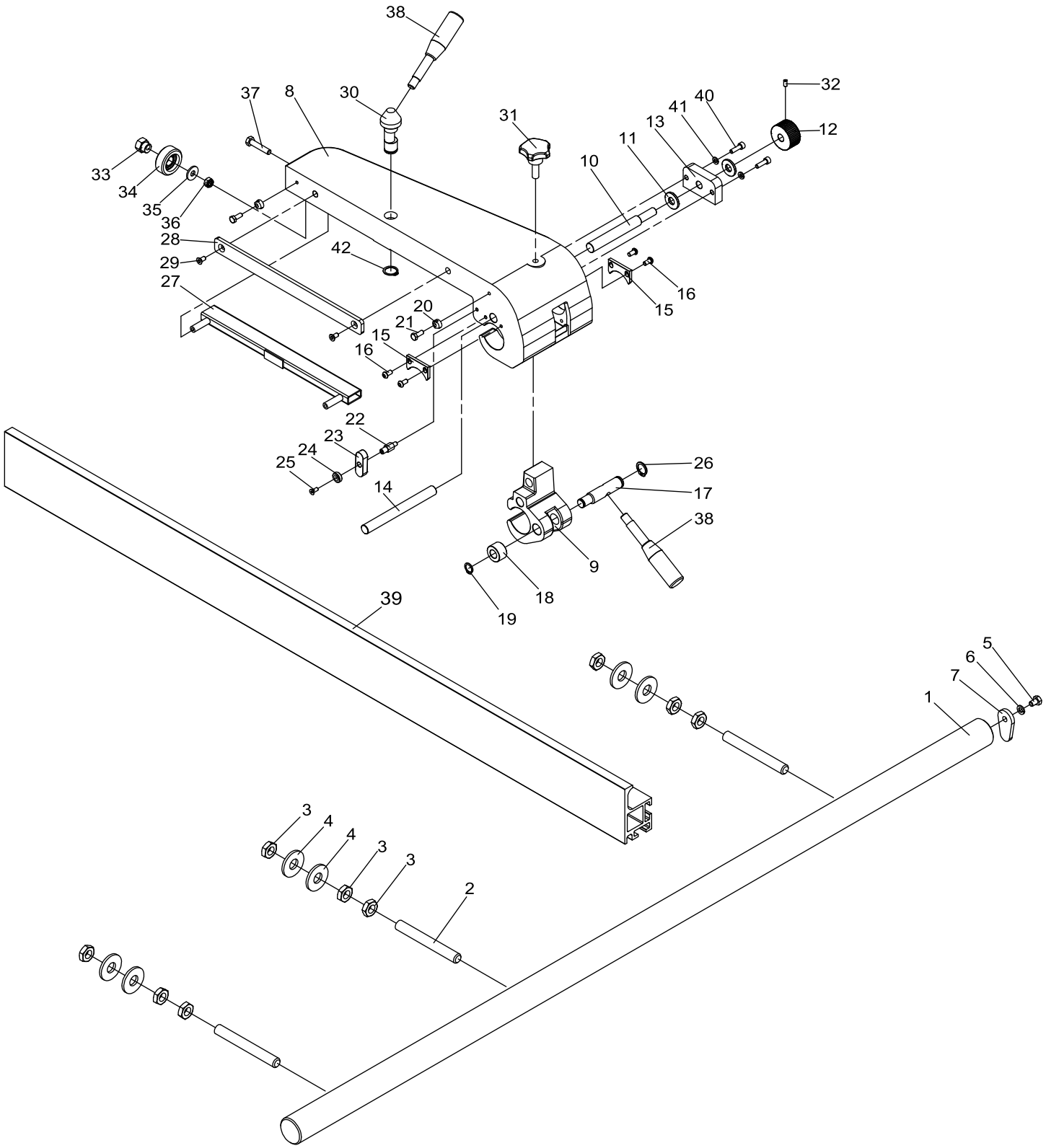
NO	FIG.NO.	DESCRIP TION	SPEC
1	NLST-J034C	Crosscut table frame	
2	403140001	Roller	U-318 SC-RL524-12/M8X15
3	NLST-J046	Guide	
4	NLST-J048	Adjust cloumn	
5	NLST-J047	Positioning pin	
6	401140004	Washer	Ø8
7	401032046	Button Head Screw	M8x30
8	401101005	Hex Head Bolt	M8
9	401072056	Set serew	M8x30
10	401052132	Counter sunk head cap screw	M6x12
11	401010008	Hex head bolt	M6x16
12	401140010	Washer	Ø6
13	401150003	Lock Washer	Ø6
14	NST-713-0-0	Rubber guide	
15	ST-N095E	Avert friction sheet	

NO	FIG.NO.	DESCRIP TION	SPEC
16	ST-M017	Caps	70-40-3t
17	ST-M016	Block	
18	ST-M018	Short cross-support	
19	ST-M019	Long cross-support	
20	ST-M020	Clampingn element	
21	402070005	Knob bolt	6050-40-M8-50
22	ST-M037	Caps	80-40-4t
23	402040022	Adjusttable handle	M12
24	NLST-J024	Square lock	
25	414080005	Hole plugs	HP-13
26	20471021-0	Adjust shaft	
27	20471022-0	Block	
28	401252005	Retaing ring for shaft	STW- 10
29	401150003	Lock nut	Ø8
30	401010018	Hex head bolt	M8x16



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-F014B	Width extension	1.3m
2	LST-F011A	Small Extension Table	Normal
3	ST405-505	Hex screw	
4	401101007	Hex Nut	M12
5	401151002	Safety Washer	Ø8
6	401150003	Lock nut	Ø8
7	401010019	Hex Head Bolt	M8x20
8	LST-F015A	Support rack	1.3m/1.5m
9	402130001	Square pipe plug	80-40-3t

NO	FIG.NO.	DESCRIP TION	SPEC
10	401140002	Washer	Ø5
11	401150002	Lock Washer	Ø5
12	401022033	Cap screw	M5x25
13	401101012	Hex Nut	M16
14	401140020	Washer	Ø16
15	401140010	Washer	Ø6
16	401150003	Lock Washer	Ø6
17	401022055	Cap scre	M6X20
18	401072086	Set serew	M12x55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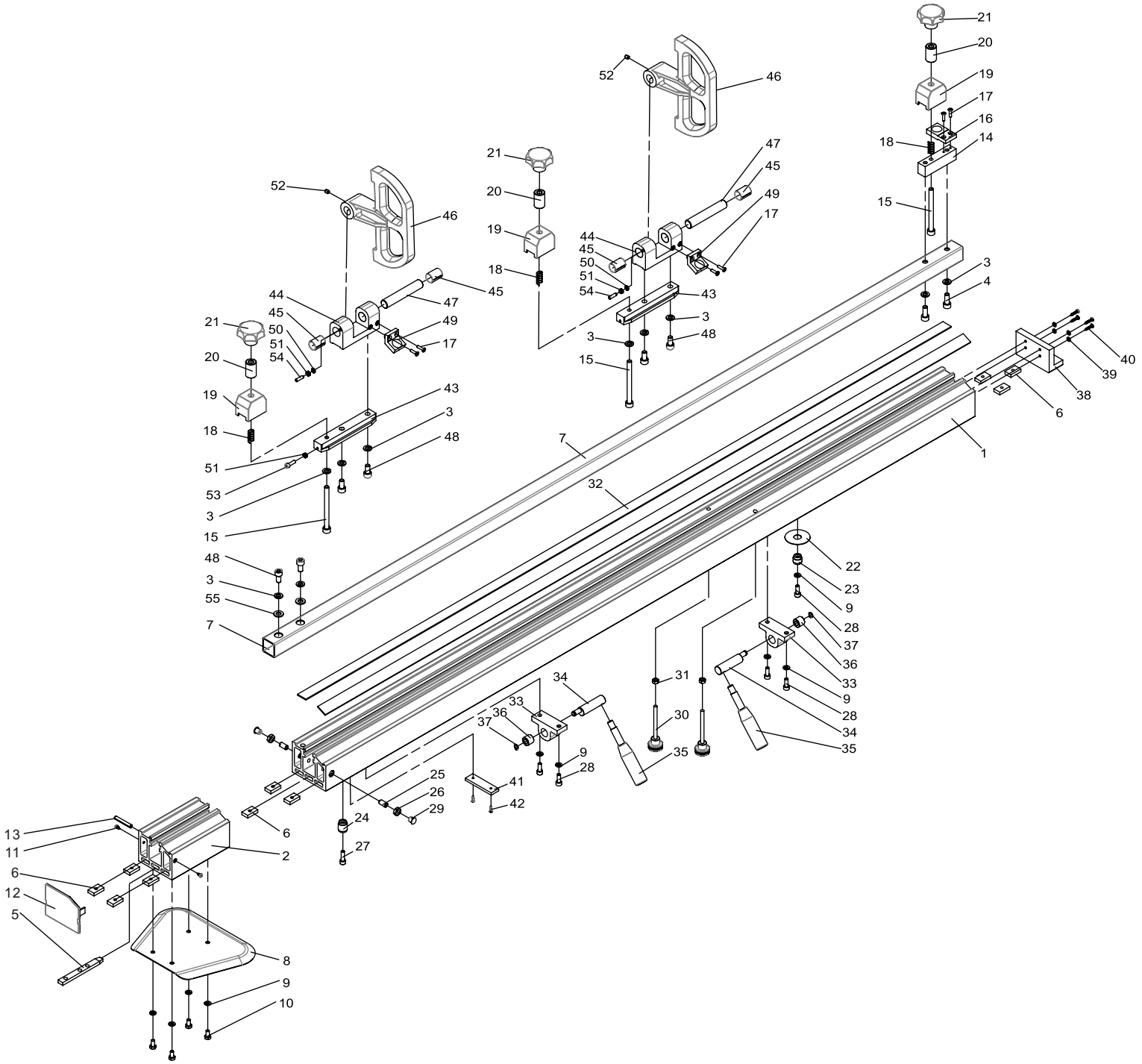
NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-F002J	Rip Fence Rail	1.3M
2	401072135	Set screw	M16x130
3	401102001	Hexagon Thin Nut	M16-8t
4	401140007	Washer	Ø16
5	401011015	Hex Bolt	M8x12
6	401150003	Lock nut	Ø8
7	ST-Q077	Stop block	
8	LST-F004	Fixed base	
9	LST-F005	Slide base	
10	ST-Q026	Adjust shaft	
11	ST-Q027	Washer	
12	402080003	Control knob	7021-42-B12
13	LST-F006	Fixed base	
14	LST-F007	Slide rail	
15	LST-F008	Dust scraper	
16	401032029	Button Head serew	M6x10
17	LST-F010	Fixed shaft	
18	ST-Q038	Lock ring	
19	401252009	Retaining rings for shaft	S14
20	ST-Q002	Guide wheel	
21	401010008	Hex head bolt	M6x16

NO	FIG.NO.	DESCRIP TION	SPEC
22	ST-Q035	Hex head screw	
23	LST-F009	Guide key	
24	ST-Q033	Fixed Ring	
25	401052118	Counter sunk head cap screw	M5x12
26	401252013	Retaining rings for shaft	S18
27	ST-Q010	Lashing bar	
28	ST-Q005	Lashing plate	
29	401052129	Counter sunk head cap screw	M6x12
30	ST-Q011A	Fixed shaft	
31	402070006	Knob	HS50AM1030
32	401071025	Set serew	M5x10
33	ST-K044	Sliding wheel adjusting block	
34	ST-K043A	Sliding Wheel	
35	401140028	Washer	Ø8xØ23x3t
36	401103001	Lock nut	M8
37	401010023	Hex head bolt	M8x40
38	402010009	Handle	7107-M12-137
39	ST-Q014	Rip fence	
40	401022055	Cap scre	M6x20
41	401150003	Lock Washer	Ø6
42	401252015	Retaining rings for shaft	S20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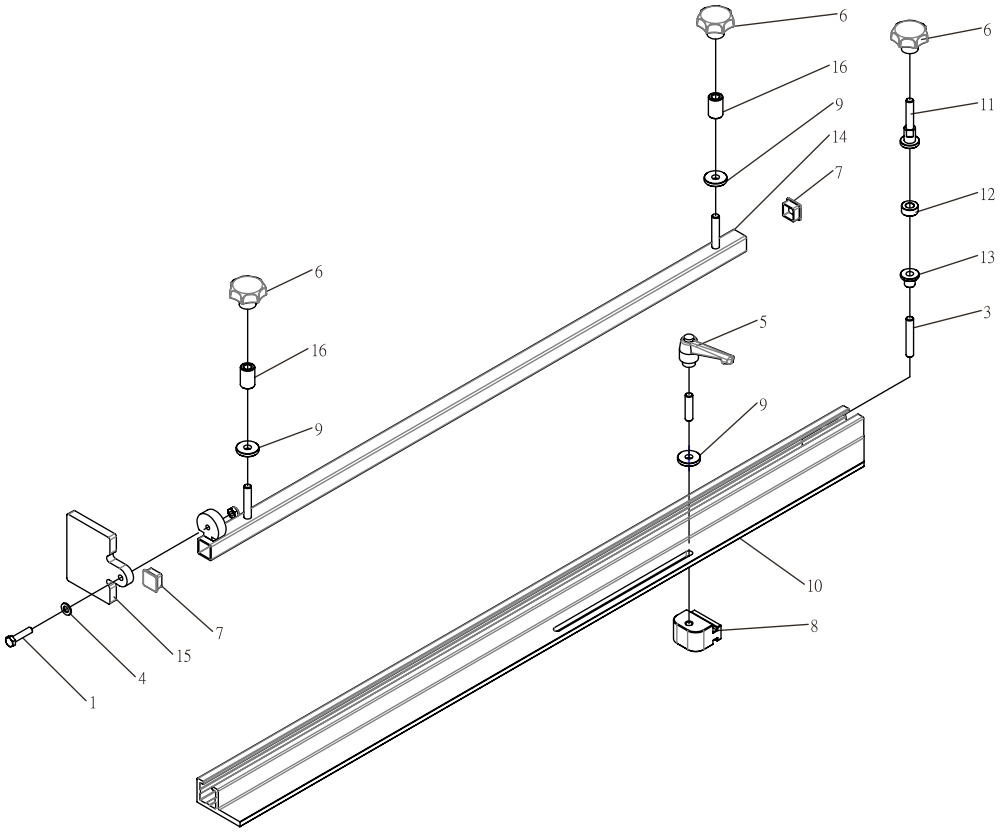
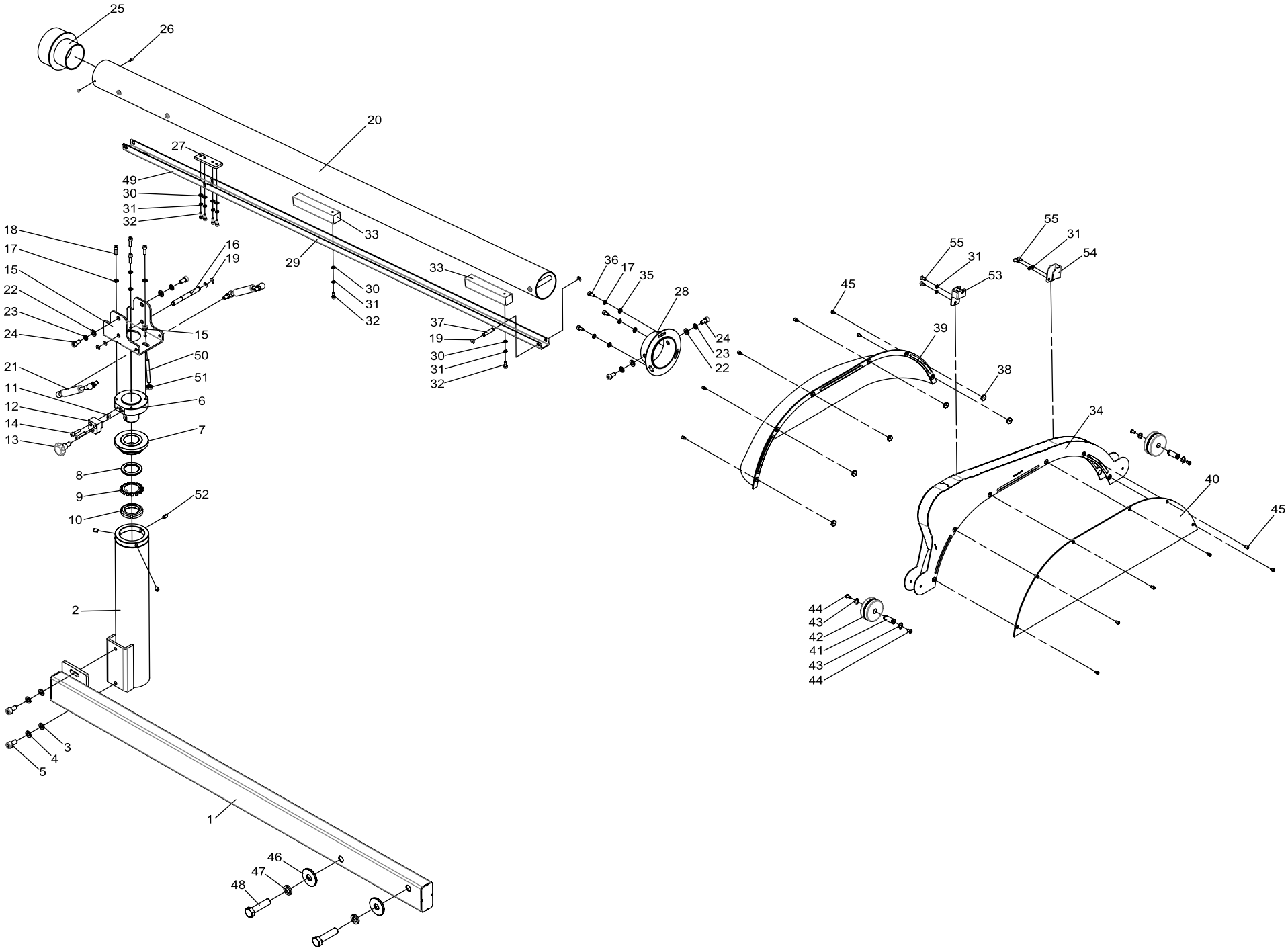
NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-N058	Fence Scale Base	2.6、3.2m
	ST-N058C	Fence Scale Base	1.9m
2	ST-N061	Scale Base	
3	401150003	Lock nut	Ø8
4	401022078	Cap scre	M8x20
5	ST-N055	Positioning pin	
6	ST-N059	Fixing sheet	
7	ST-N006	Positioning pipe	30x30x2tx1733L
8	ST-N054A	Butterly-shaped plate	
9	401150003	Lock Washer	Ø6
10	401010005	Hex head bolt	M6x12
11	401060004	PLUG	1/8"-3/8"
12	ST-N060	Left cover plate	
13	401200008	Spring Pin	Ø6x40
14	ST-N018	Locking lower slide block	
15	401021092	Cap screw	M8x90
16	ST-N015	Magnifier	
17	401051110	Counter sunk head cap screw	M4x12
18	ST-N022	Spring	
19	ST-N013	Locking slide block	
20	ST-N014	Locking bush	
21	402070002	Star-ahaped knob	HS50AM8
22	ST-N005	Washer	
23	ST-N004	Front positioning pin	
24	ST-N003	Rear Positioning Pin	
25	ST-N107	Set screw	
26	401101005	Hex Head Bolt	M8
27	401022055	Cap scre	M6x20
28	401022053	Cap scre	M6x16

NO	FIG.NO.	DESCRIP TION	SPEC
29	414080008	Hole plug	HP-9
30	ST-N023	Embossing screw	ST-N023-01+402100003
31	401101004	Hex Nut	M6
32	ST-N434	2.6、3.2Fence Scale	60~1670mm
	ST-N435	2.6、3.2Fence Scale	1670~3270mm
33	ST-N035	Tigthening base	
34	ST-N031	Rotary fastening base	
35	402010002	Round Knob	7108-63(M10-110)
36	ST-N036	Tightening ring	
37	401252003	Retaining rings for shaft	S8
38	ST-N052	Lengthening scale base	
39	401140001	Washer	Ø4
40	401080011	Phillips sunk head cap scre	M3x20
41	ST-N062	Packing-up Block	
42	401290001	Draw Naill	4_2
43	ST-N027	Locking lower slide base	
44	ST-N007	Adjusting block	
45	403090028	Bush	MB1625
46	ST-N008	Positioning plate	
47	ST-N011	Shaft	
48	401022076	Cap screw	M8x16
49	ST-N053	Magnifier	
50	401150002	Lock Washer	Ø5
51	401101003	Hex Nut	M5
52	401072033	Setscrew	M6X6
53	401022032	Cap scre	M5x20
54	ST-N091B	Set Screw	M5x16
55	401151002	Washer	Ø8



NO	FIG.NO.	DESCRIPTION	SPEC
1	401010022	Hex head bolt	M8x35
2	401071071	Set screw	M10x40
3	401072075	Set screw	M10-60
4	401151002	Safety Washer	Ø8
5	402040025	Adjustable handle	92ZN-M10
6	402070003	Star-shaped knob	HS50AM10
7	402130008	Caps	25-25-2t
8	NLST-J027A	Blacket	
9	RH-2040	Washer	
10	ST-L001D	45 Fence	
11	ST-L003	Set screw	
12	ST-L005	Gap ring	
13	ST-L006	Positing ring	
14	ST-L013	Displacement pipe	
15	ST-L014	Damper	
16	ST-L015	Lock collars	
17	401103001	Lock nut	M8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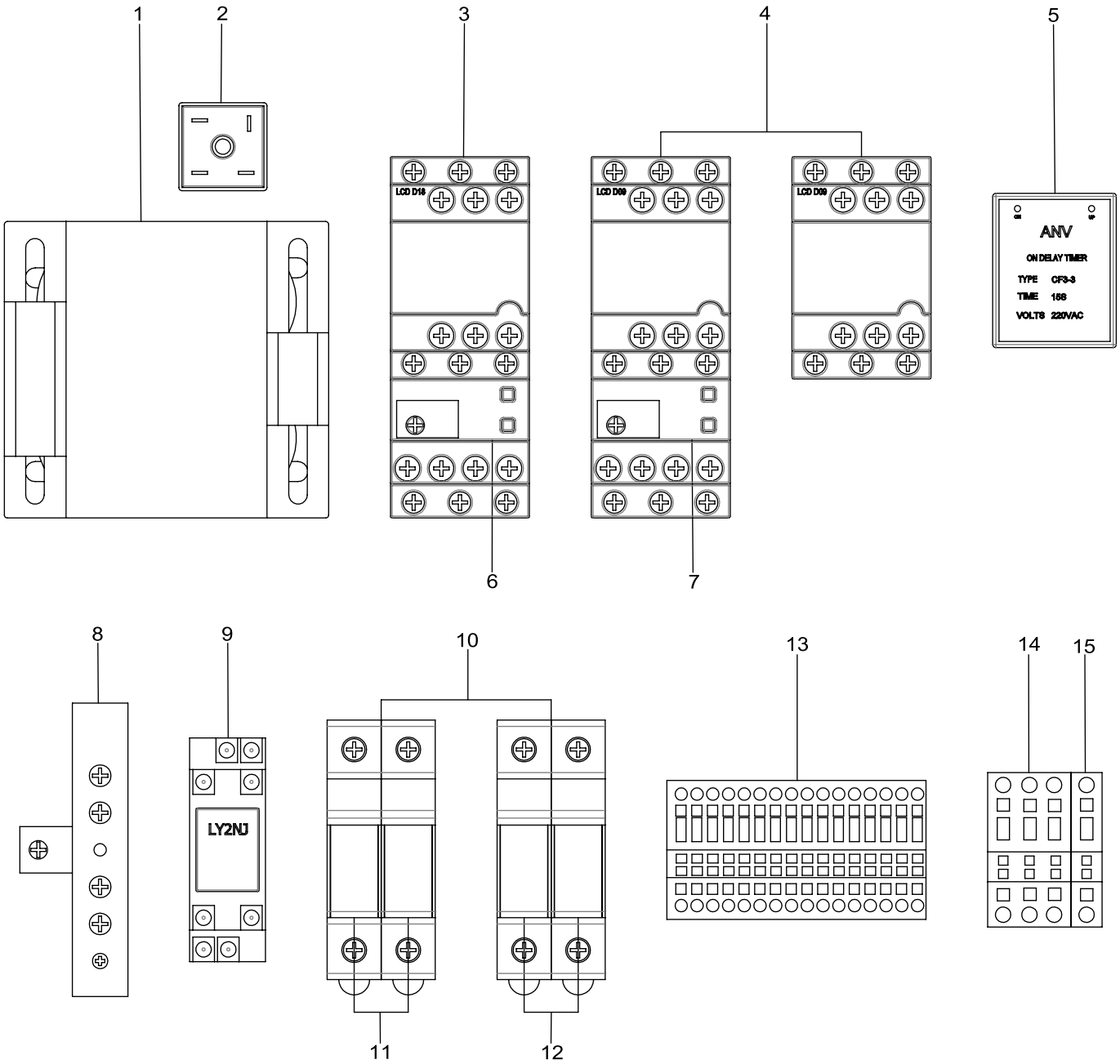
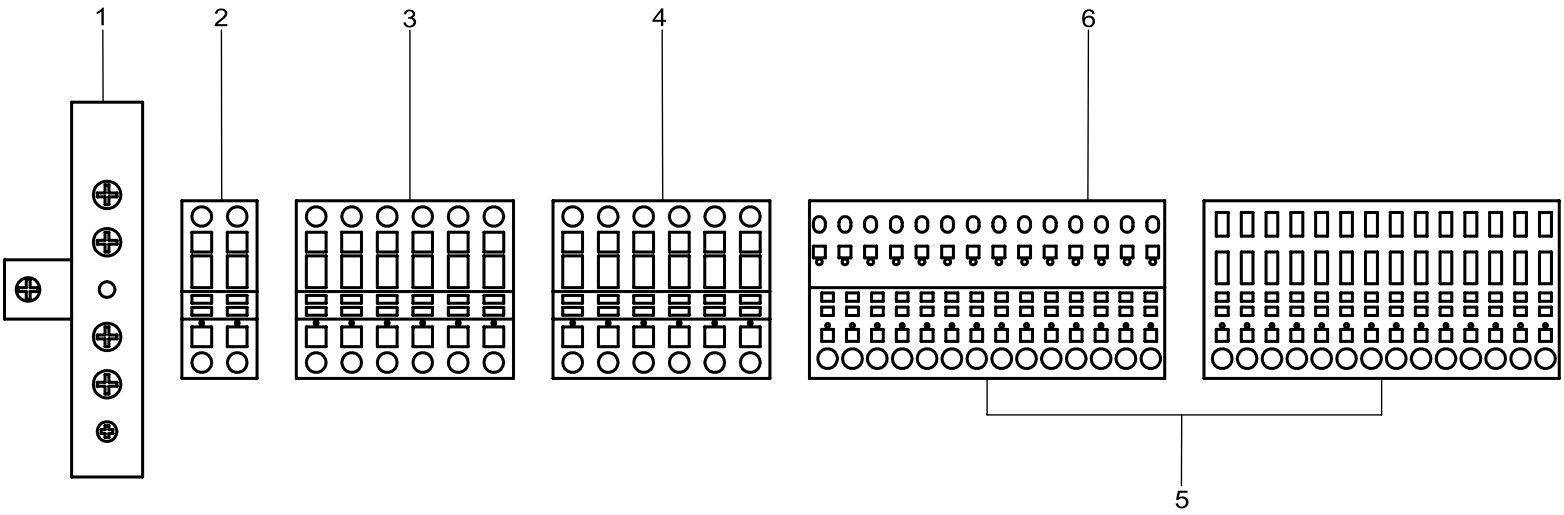
NO	FIG.NO.	DESCRIP TION	SPEC
1	20481001-B	Fixed base	1.3M
2	20481002-0	Dust guard stand	
3	401140005	Washer	Ø10
4	401150005	Lock washer	Ø10
5	401022103	Cap scre	M10x20
6	20481004-0	Spining shaft	
7	20481003-0	Base	
8	20481005-0	Washer	
9	401160003	Washer	AW08
10	401120003	Spanner lock nut	AN08
11	401230050	Key	6x6x15
12	20481007-0	Positioning pin	
13	402110014	Indexing plungers	9015-35-5
14	401022056	Cap scre	M6x25
15	20481006-0	Fastening base	
16	NLST-H014	Shaft	
17	401150003	Lock Washer	Ø6
18	401022055	Cap scre	M6x20
19	401253012	Retaining rings e type	E6
20	NLST-H007B	Dust collector	1.3M
21	409080035	Gas springs	N500
22	401140004	Washer	Ø8
23	401150003	Lock nut	Ø8
24	401022076	Cap scre	M8x16
25	410050027	Reducer	
26	401060004	Plug	
27	NLST-H019	Clamp Links	
28	NLST-H006	Fastening base	

NO	FIG.NO.	DESCRIP TION	SPEC
29	NLST-H011B	Links	1.3M
30	401150002	Washer	Ø5
31	401150002	Lock washer	Ø5
32	401022028	Cap screw	M5x12
33	20481018-0	Block	
34	NLST-H005	Safety guard	
35	401140010	Washer	Ø6
36	401022051	Cap scre	M6x12
37	NLST-H015	Shaft	
38	NLST-H017	Nut	
39	ST-D304A	Chip guard cover	
40	ST-D303A	Chip guard cover	
41	ST-D032A	Shaft	
42	ST-D033A	Rollers	
43	401252007	Retain Ring	S12
44	401032017	Button head serew	M5x10
45	401022011	Cap screw	M4x6
46	LST-H003	Washer	
47	401150008	Lock washer	Ø16
48	401010089	Hex cap screw	M16x65
49	NLST-H020	Links	
50	401072127	Set serew	M8x70
51	401103001	Lock nut	M8
52	401072049	Set serew	M8x10
53	20481019-A	Bracket	
54	20481020-B	Bracket	
55	401052118	Counter sunk head cap screw	M5x12



NO	FIG.NO.	DESCRIP TION	SPEC
1	416071036	transformer	120VA
2	416081001	Bridge Rectifler	KBPC 2506
3	416021125	Electromagnetic contactor	LC1-D18(M7)
4	416021109	Electromagnetic contactor	LC1-D09(M7)
5	416091008	Timer	CF3-3 6S(220V)
6	416220002	Thermal Relay	LR3-D21
7	416220001	Thermal Relay	LR3-D08
8	416230001	Ground plate	5P

NO	FIG.NO.	DESCRIP TION	SPEC
9	416023001	Rely	MY-2NJ AC220V
10	416051014	Fuse Holder	DF102 10x38 2P
11	416052025	lnput fuses	4A GG
12	416052012	lnput fuses	2A GG
13	414041017	Terminal Block	PT-2.5
14	414041018	Terminal Block	PT-6
15	414041019	Terminal Block	PT-6PE



NO	FIG.NO.	DESCRIP TION	SPEC
1	416230001	Ground plate	5P
2	414041017	Terminal Block	PT-2.5
3	414041020	Terminal Block	PT-4
4	414041018	Terminal Block	PT-6
5	414041021	Terminal Block	PT4/1P
6	414041022	Terminal Block(Active end)	PP-H4/14