Instruction Manual

CWI-T1204-S5B / S5S
SLIDING TABLE SAW

IMPORTANT

For your safety, read instructions carefully before assembling or using this product. Save this manual for future reference.

Original Instruction
V.1-201501

HEALTH AND SAFETY GUIDELINES

Always follow the instructions provided with the manual. Always wear safety glasses when using woodworking equipment. Always disconnect the power before adjusting any equipment. Failure to observe proper safety procedures and guidelines can result in serious injury.

WARNING: Do not allow familiarity (gained from frequent use of your machine and accessories) to become commonplace. Always remember that a careless fraction of a second is sufficient to inflict severe injury.

Always wear safety glasses when using woodworking equipment.

Always read the instructions provided before using woodworking equipment.

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1. GENERAL INFORMATION

1.1 FOREWORD

This machine is desinged to make straight and angle cut for wood material, especially for wood board cutting.

Some information and illustrations in this manual may difer from the machine in your possession, since all the configurations inherent in the machine complete with all the optionals are described and illustrated. Therefore, refer only to that information strictly connected with the machine configuration you have purchased.

With this manual we would like to provide the necessary information for maintenance and proper use of the machine. The distribution network is at your service for any technical problem, spare parts or any new requirement you may have for the development of your activity.

This manual must be read and understood before operating the machine. This will provde a better working knowledge of the machine, for increased safety and to obtain the best results.

To facilitate its reading, the manual has been divided into sections pointing out the most important operations. For a quick research of the topics, it is recommended to consult the index. To better stress the importance of some basic passages, they have been marked by some preceding symbols:

WARNING Indicates imminent risks which may cause serious injury to the operator or other persons. Be careful and scrupulously follow the instructions.

CAUTION A statement advising of the need to take care lest serious consequences result in harm to material items such as the asset or the product.

1.2 MACHINE IDENTIFICATION

There is a identification plate fixed to the machine, containing the manufacturer's data, year of construction, serial number and technical specifications.

1.3 CUSTOMER SERVICE RECOMMENDATIONS

Apply the machine to skilled and authorized technical staff to carry out any operation dealing with parts disassembly. Keep to the instructions contained in this manual for the correct use of the machine.

CAUTION Only skilled and authorized staff shall use and service the machine after reading this manual. Respect the accident prevention regulations and the general safety and industrial medicine rules.

2. SAFETY PRECAUTIONS

2.1 SAFETY REGULATIONS

WARNING

Wood machinery is equipment which is of high-speed and high-safe risk. User can only operate this equipment only after professional training. If any personnal injury or equipment breakdown is caused by disobeying following safe operation rules, the manufacter will not be responsible for the results.

- The machine operator shall have all necessary prerequisites in oder to operate a complex machiery.

- It is prohibited to use the machine when under the influence of alcohol, drugs or medication.

- All the operators must be suitably trained for use, adjustment and operation of the machine.

- The operators must carefully read the manual paying particular attention to the warning and safety notes. Furthermore, they must be informed on the dangers associated with use of the machine and the precautions to be taken, and must be instructed to periodically inspect the guards and safety devices.

- Before carrying out adjustment, repair or cleaning work, disconnect the machine from the electric power and lock the disconnect switch in its “OFF” position by setting the main switch to stop.

- After an initial bedding-in period or many hours of operation, the driving belts may slacken; this causes an increase in the tool stopping time (the stopping time must be less than 10 seconds). Immediately tighten them.

- The working area around the machine must be kept always clean and clear, in order to have an immediate and easy access to the switchboard.

- Never insert materials which are different from those which are prescribed for the machine utilization. The material to be machined must not contain any metal parts.

- Never machine pieces which may be too small or too wide ithrespect to the machine capacity.

- Do not work wood which has evident defects (cracks, knots, metal parts, etc.)

- Never place hands among the moving parts and/or materials.

- Keep hands clear from the tool; feed the piece with the aid of a pusher.

- Keep the tools tidy and far away from those not authorized persons.

- Never employ cracked nor uckled, neither not correctlyreground tools.

- Never use the tools beyond the speed limit recommended bythe producers.

- Carefully clean the rest surfaces of tools and make surethat they find perfectly horizontally positioned, and with no dents at all.

- Always wear gauntlets when handling the tools.

- Mount the tools in the right machining direction.

- Never start the machine before having correctly installed all the protections.

- Connect the dust suction hoods to an adequate suction system; suction must always be activated when the machine is switched on.

- Never open doors or protections when the machine or the system is operating.

- Many unpleasant experiences have shown that anybody may wear objects which could cause serious accidents. Therefore, before starting working, take any bracelet, watch or ring off.

- Button the working garment sleeve well around the wrists.

- Take any garment off which, by hanging out, may get tangled in the MOVING UNITS.

- Always wear strong working footwear, as prescribed by the accident-prevention regulations of all countries.

- Use protection glasses. Use appropriate hearing protection systems (headsets, earplugs, etc.) and dust protection masks.
- Never let unauthorized people repair, service or operate the machine.

- The manufacturer is not responsible for any damage deriving from arbitrary modifications made to the machine.

- Any transport, assembly and dismantling is to be made only by trained staff, who shall have specific skill for the specified operation.

- The operator must never leave the machine unattended during operation.

- During any working cycle break, switch the machine off.

- In case of long working cycle breaks, disconnect the general power supply.

- The operating method to be followed in the event of accident or breakdown, the machine should be turned off immediately and unplug from main power and ask for assistance for the authorized people. If a blockage is likely to occur, the workpiece should be move back a little and enable the equipment to be safely unblocked.

WARNING If any accident happened because of unqualified connected electric components or disordered assembly, the manufacturer will not be responsible for the results.

WARNING If any accident happened because of changing machinery function or spare parts without permission, the manufacturer will not be responsible for the results.

WARNING If any accident happened because of operation with spare parts missing or broken, the manufacturer will not be responsible for the results.

2.2 RESIDUAL RISKS

WARNING Even if the user obeserve the saft operation rules and operate this equipment according to the user manual, risk still exsits. Any result caused by force majeure, the manufacturer will not be responsible for it.

- contact with tool

- contact with moving parts (belts, pulleys, etc..)

- workpiece might be kicked back. Please stand outside the side of blade and out of the kick-back area.

- accidents due to wood splinters or fragments

- tool insert ejection

- electrocution from contact with live parts

- danger due to incorrect tool installation

- inverse tool rotation due to incorrect electrical connection

- danger due to dust inhalation in case of working without vacuum cleaner.

Bear in mind that the use of any machine tool carries risks.
Use the appropriate care and concentration for any type of machining (also the most simple).

2.3 SAFETY AND INFORMATION SIGNALS

This signals may be applied on the machine; in some cases they indicate possible danger conditions, in others they serve as indication.
Always take the utmost care.

SAFETY SIGNALS:

Risk of eye injury. Wear eye protection.

Wear hearing protection systems.

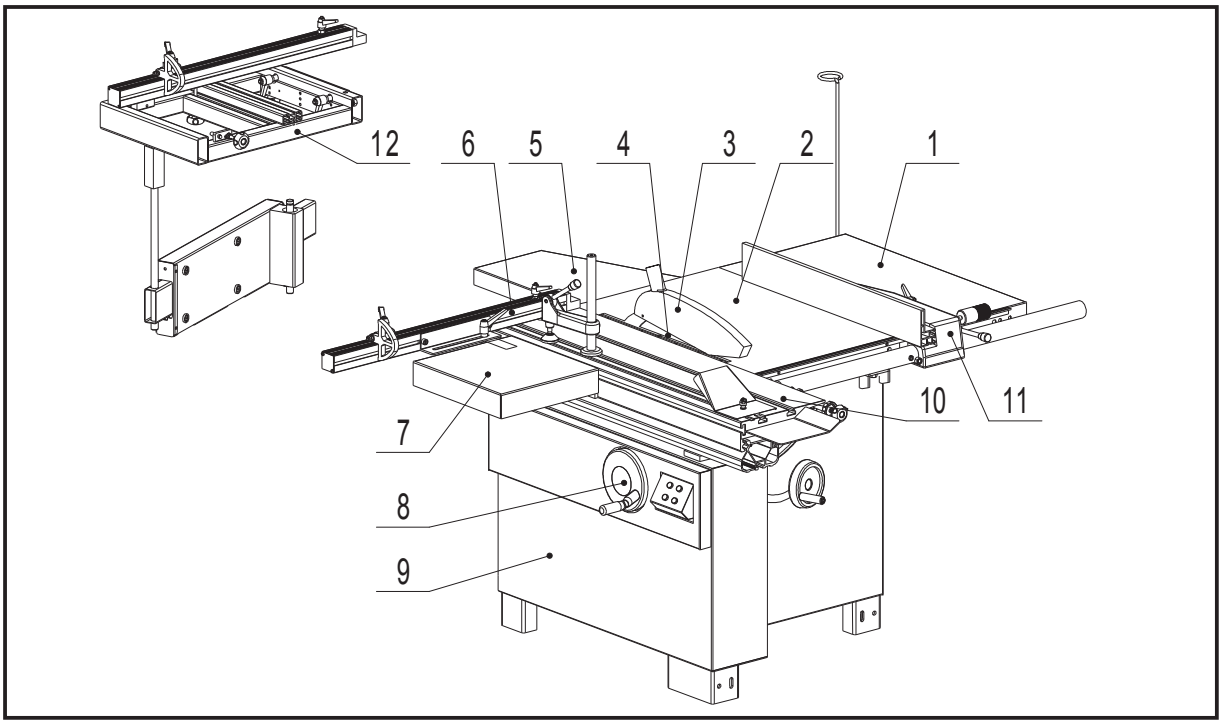
Danger of electric shock. Do not access the area when the machine is powered.

Carefully read and understand the manual before using the machine.

INFORMATION SIGNALS:
Indicate the technical characteristics, direction of rotation and inclination, block and release, etc.
Carefully following the directions to simply the use and adjustment of the machine.
The signals are graphically described and do not require further explanation.

3. SPECIFICATIONS

3.1 MAIN COMPONENTS



1 - Right extension table
2 - Main table
3 - Blade guard assembly
4 - Blade
5 - Rear extension table
6 - Sliding table
7 - Telescopic fence
8 - Square sliding table
9 - Tilting handwheel
10 - Lifting handwheel
11 - Frame assembly
12 - Rip fence assembly
13 - Square sliding table

3.2 TECHNICAL SPECIFICATION

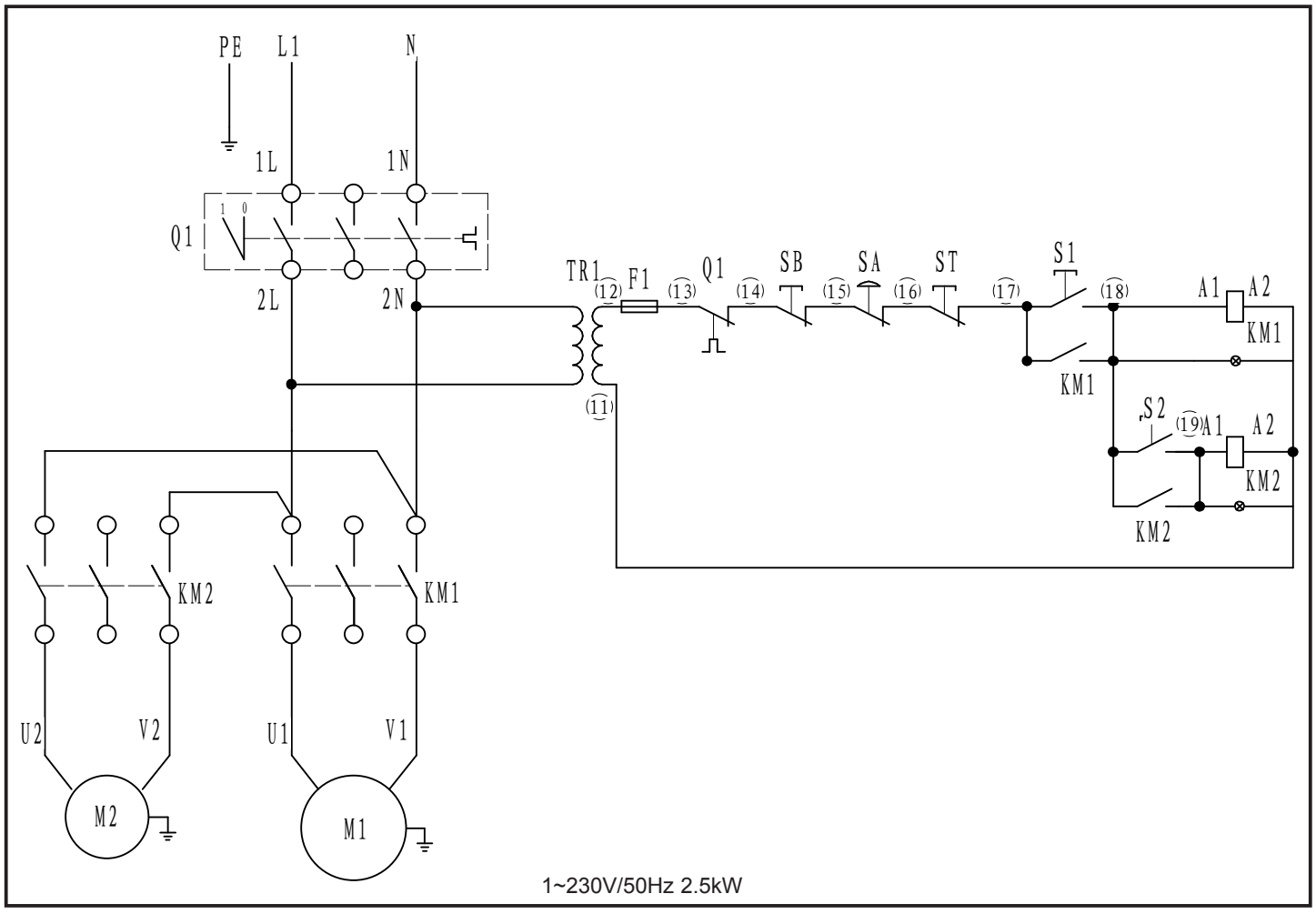
SPECIFICATION	
Motor Voltage	230V/50Hz / 3~400V/50Hz
Main motor power	2.5kW,S1
Scoring motor power	550W,S1
Main blade diameter	315mm
Main blade speed	4000rpm
Scoring blade diameter	120mm
Scoring blade speed	8000rpm
Blade tilt	0~45°
Main table size	800x530mm
Right extension table size	800x470mm
Max.rip capacity	900mm
Max.depth of cut	102mm@90°,72mm@45°
Sliding table size	1200x360mm/1600x360mm
Sliding table stroke	1200mm/1600mm
Square sliding table size	600x460mm

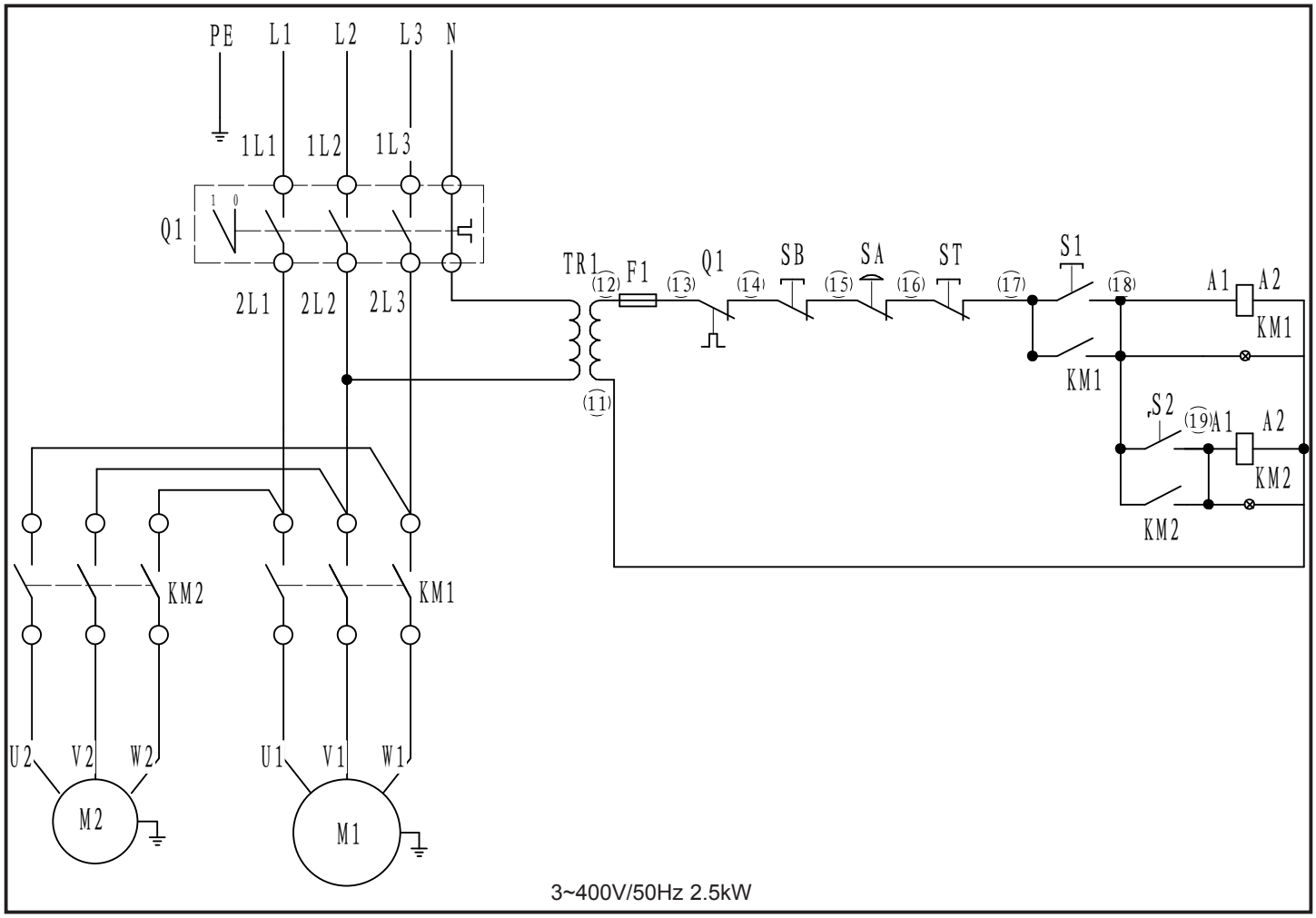
3.3 ELECTRICAL CONNECTION

- Electrical installation should be carried out by competent, qualified personnel.
- The mains connection should be made using the terminal box.
- Replacement of the power supply cable should only be done by a qualified electrician.
- Connect the main leads to a standard 400V±10% for TS315 and 230V±10% for TS315 (50Hz+1%Hz) electrical supply which has protection devices of under-voltage, over-voltage, over-current as well as a residual current device (RCD) which maximum residual current rated at 0.03A, the main connection must have maximum 20A time-lag fuse for TS315 and 10A for TS315. The test specified in 18.2 of EN 60204-1:2006 should be performed by end user after final installation.

WARNING

To avoid electrocution or fire, any maintenance or repair to electrical system should be done only by qualified electricians using genuine replacement parts.





3.4 NOISE LEVEL

	No load	Load
Sound Pressure Level	< 80.4dB(A)	< 85.7dB(A)
Sound Power Level	< 98.1dB(A)	< 100.7dB(A)

Associated uncertainty *K*=4dB
Measurement made in accordance with EN ISO 3746:1995 and EN ISO 11202:1995

The noise levels measured are emission levels and not necessarily the safe working level. Although there is a correlation between the emission levels and the exposure levels, this cannot be used reliably to determine whether or not further precautions are required. The factors which affect the actual level of operator exposure include the duration of exposure, the ambient characteristics and other sources of emission, for example, the number of machines and other adjacent machining. The permitted exposure values may also vary from country to country. Nevertheless, this information allows the user of the machine to better evaluate the dangers and risks.

Other factors which reduce exposure to noise are:

- correct tool choice

- tool and machine maintenance

- use of hearing protection systems (e.g. headsets, earplugs,...)

WARNING Please always use the hearing protection systems.

3.5 DUST EXTRACTION

Proper suction eliminates the risks of dust inhalation and aids better functioning of the machine. The tables list the minimum air flow and speed values referenced to each single suction operation.The related pressure drop at the dust port is 530Pa.

Saw	
Upper hood	Lower hood
Air flow 140 cu.m/h	690 cu.m/h
Minimum air speed 20 m/s	

Ensure that the suction system guarantees these values at the hood-houth connection point. (Fig.3.5)

Suction mouth diameter:
A - Blade guard ..... ø40 mm
B - Body dust suction ..... ø100 mm

Connect the mouths to the suction system with flexible tubes of adequate diameter. Tighten with clamps. The tube must be positioned in such a way so as not to obstruct the operator during machining.

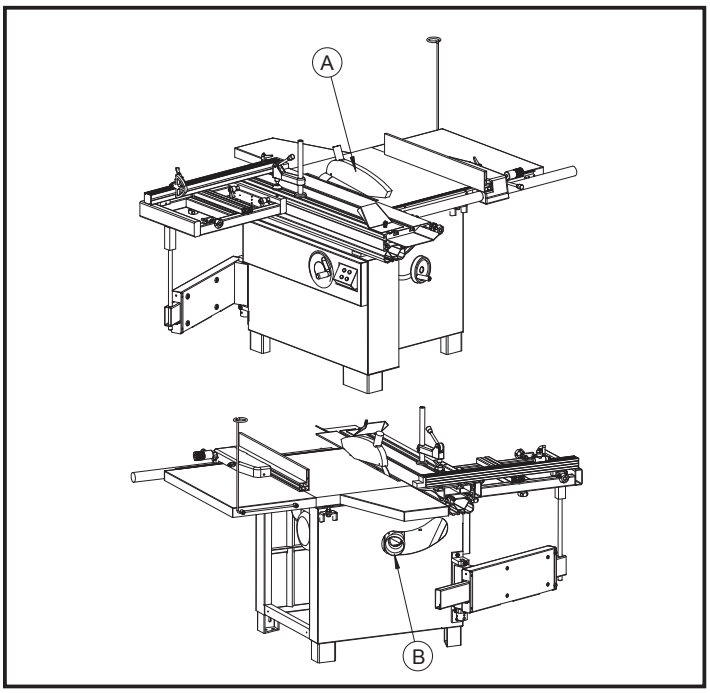


Fig.3.5

WARNING

Always work with the suction system on. Always start the suction system and the machine at the same time.

3.6 SAFETY DEVICES

The machine is equipped with the following safety devices: (Fig.3.6)

A - Safety Switch.
Stops the machine if the guard D is opened to perform operations on the blade.

B - Saw blade guard

Emergency Switch
When the button is pressed, the power will been cut immediately. It is a mechanical-operated push-button. Reset this button by turning it clockwise.

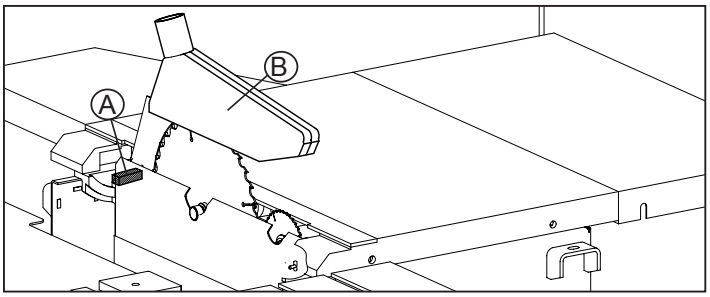


Fig.3.6

4. INSTALLATION

CAUTION

Assembly need to be done by an experienced and trained person.

4.1 CONTENTS OF PACKAGE

- The machine is supplied partly assembled. Prior to use, further assembly is required.
- When unpacking the machine the following components are included for the initial assembly.
- If any parts are missing, do not attempt to assemble the machine; plug in the power cord, or turn the switch on until the missing parts are obtained and properly installed.

TS315/TS315X,Total two carton:
1.Blade guard
2.Rear extension table
3.Fence
4.Outrigger assy.
5.Frame assy.
6.Extension table
7.Sliding table(packed separately)
8.Guide rail
9.Scale seat
10.Rip fence assy.
11.Right extension table
12.Support bracket of dust hood

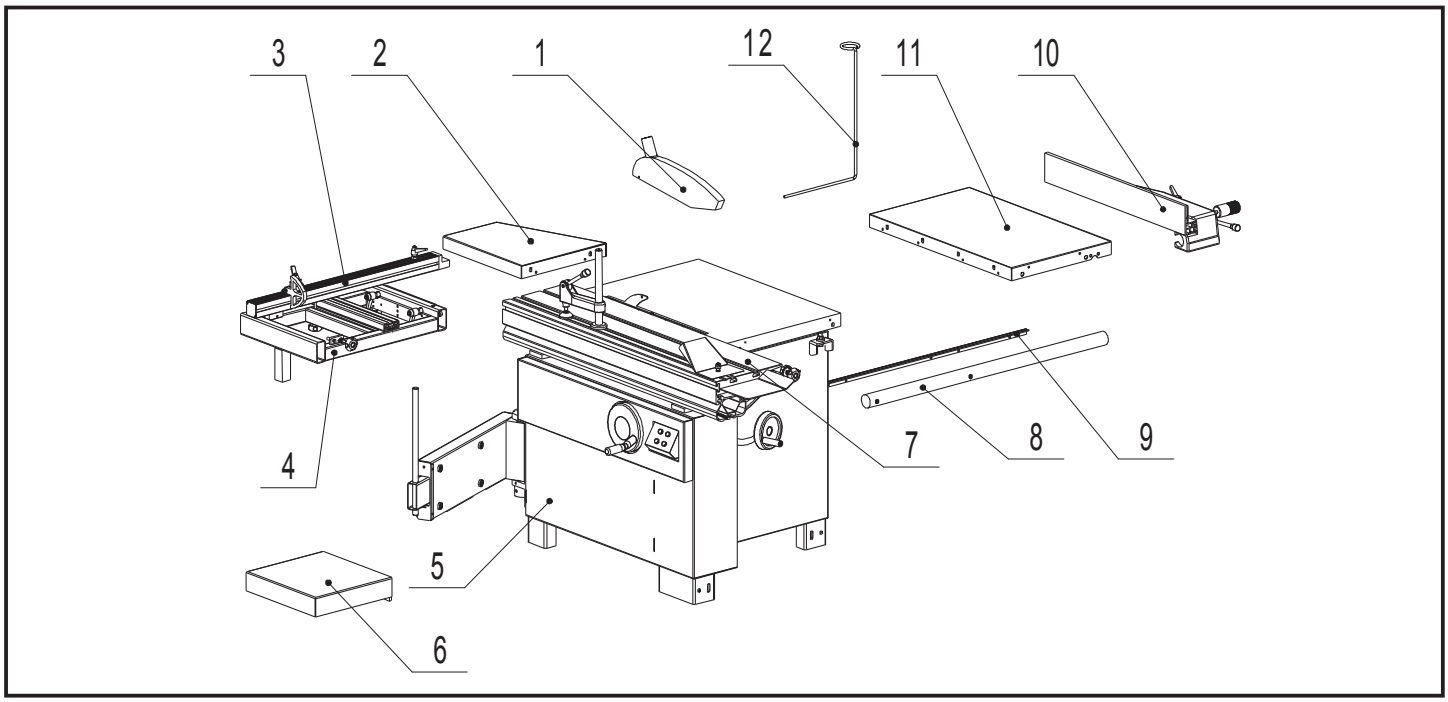


Fig.4.1

4.2 LIFTING AND UNLOADING

WARNING

Lifting and handing should only be carried out by skilled personel specially trained to execute this kind of operations. During loading and unloading, avoid knocks to prevent damages to persons and things. Make sure no one is standing under the overhung load and/or within the bridge crane working range during machine lifting and handing.

Lifting may be carried out by bridge crane or self-propelled lift truck. Before starting the manoeuvres, free the machine of all the parts used for transport or Packaging that have remained on the machine. Check that the capacity of the lifting equipment is adequate for the gross weight of the machine indicated Fig.4.2.

If hoisting is carried out with a lift truck, proceed as follows:
– adjust the width of the forks A to 550 mm
– Insert forks A as in the figure in correspondence to name plates E ensuring that these are wedged against the back of the rear feet D.

If a bridge crane or a crane is available,proceed as follows:
– provide two slings B of suitable length and capacity (Belts minimum length 4000mm)
– lift the slings and position them as is shown in the Fig.4.2
– fasten the slings to the bridge crane C having adequate lifting power
– move the bridge crane by small steps to allow the slings B to settle, until optimum stability conditions are reached
– lift carefully and slowly, without causing the load to swing, and place the machine in the selected setting
– remove the protective wax coat from all tables and unpainted surfaces, using kerosene or its derivative products. Do not use any solvent, petrol or gas oil, which might dull the paint or oxidate machine parts.

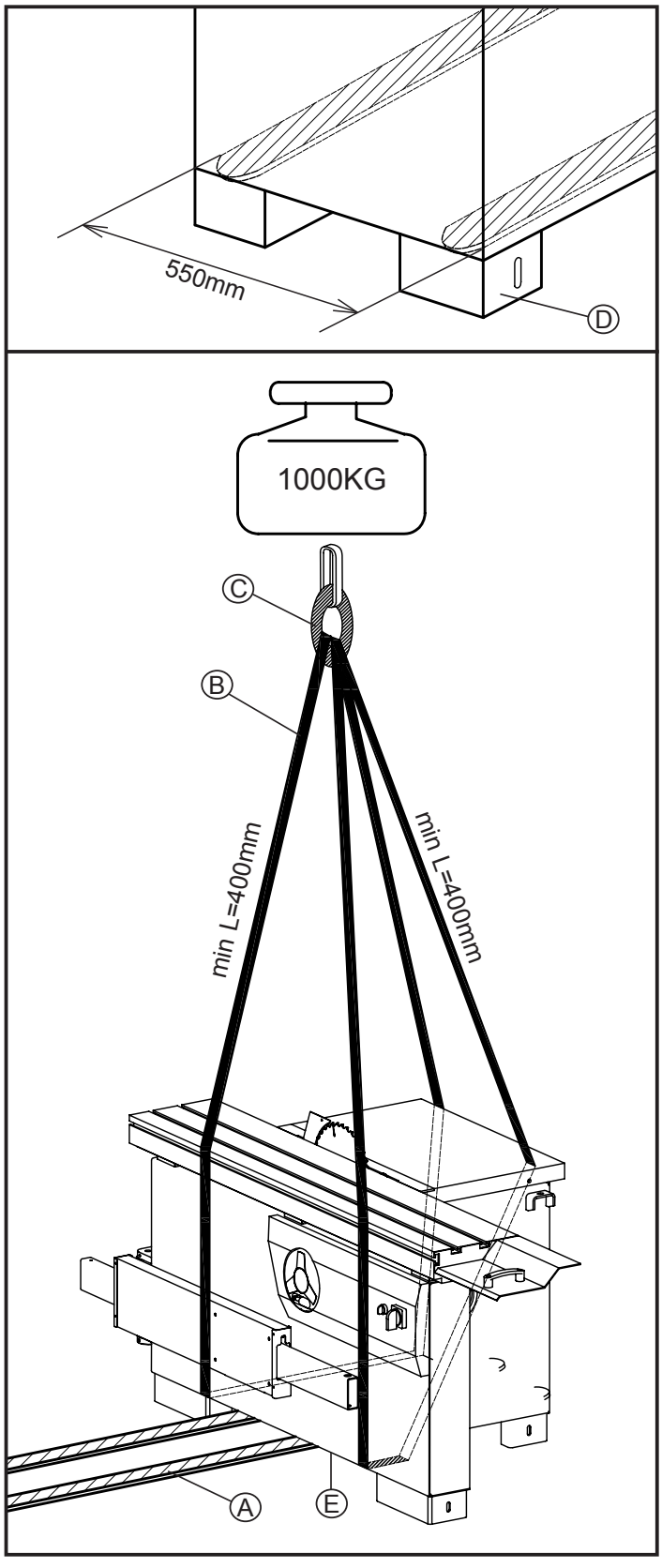


Fig.4.2

4.3 INSTALLATION ZONE CHARACTERISTICS

WARNING

It is prohibited to install the machine in explosive environments.

The installation zone must be selected evaluating the work space required depending on the dimension of the pieces to be machined,and taking into account that a free space of at least 800 mm must be left around the machine.It is also necessary to check the floor capacity and its surface, so that the machine base is evenly resting on its four supports.A power outlet and a chip-suction system connection shall be close to the selected machine setting and it must be conveniently lighted (luminous intensity: 500 LUX).

Fixing to the floor

The machine must be fixed to the floor.
-Use bolt/nut A to level the feet to ensure machine is well located.
-Put expansion bolts D (not supplied) into ground, use washer/lock washer C and hex nut B to fasten the bolts.

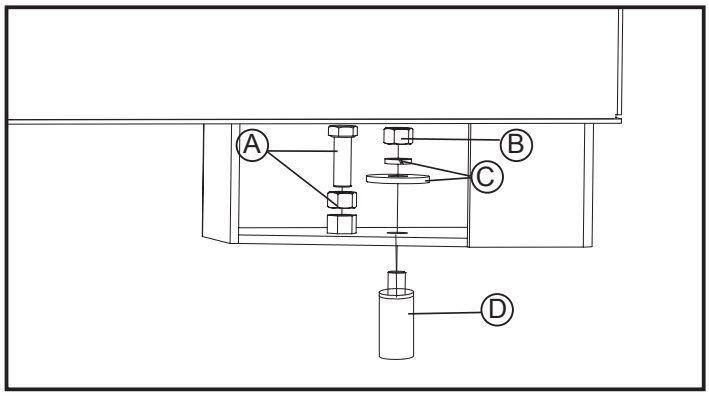


Fig.4.3

4.4 INSTALL OF LOOSE PARTS - INTRODUCTION

A few elements will be disassembled from the machine main structure due to packaging and shipping requirements. These loose parts should be installed as follows.

WARNING

Please tighten all bolts and nuts absolutely. Otherwise, may cause machine wobble or serious injury to the operator or other persons.

4.4.1 INSTALL EXTENSION TABLE

Tools Required for Assembly:
- Wrench 16mm
- L Wrench 6mm

- Install Extension tables A to main table C with bolt 1 and washer 2.
- Install set screw 3 for micro-adjustment.

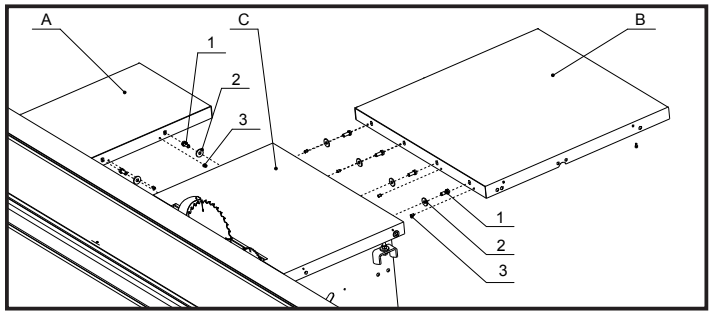


Fig.4.4.1

4.4.2 INSTALL BLADE GUARD AND HOSE SUPPORT ROD

Tools Required for Assembly:
- Wrench 13mm
- Philips screwdriver

- Install Blade guard A to Riving knife C with part 1 and 2.
- Install Hose support rod B to right extension table with part 3, 4, 5 and 6.

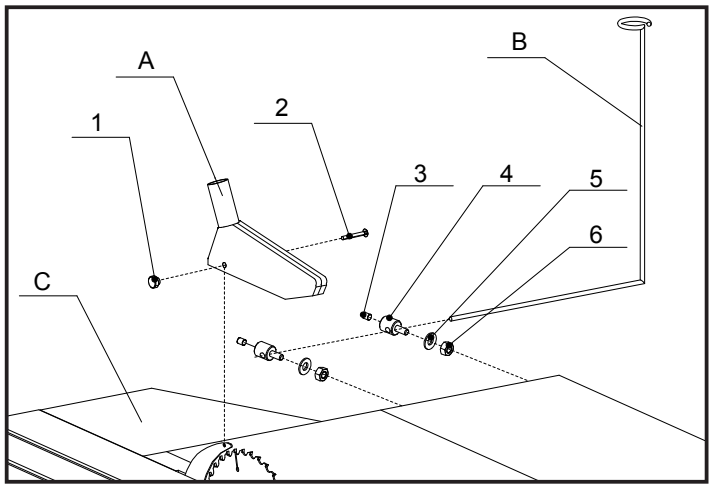


Fig.4.4.2

4.4.3 INSTALL SQUARE SLIDING TABLE

- Put the square sliding table C into the slot of sliding table A.(Deputy C/F not recommended installation)
- Put the support rod D into the hole of square sliding table C and the hole on support arm E.
- Lock the handle B.

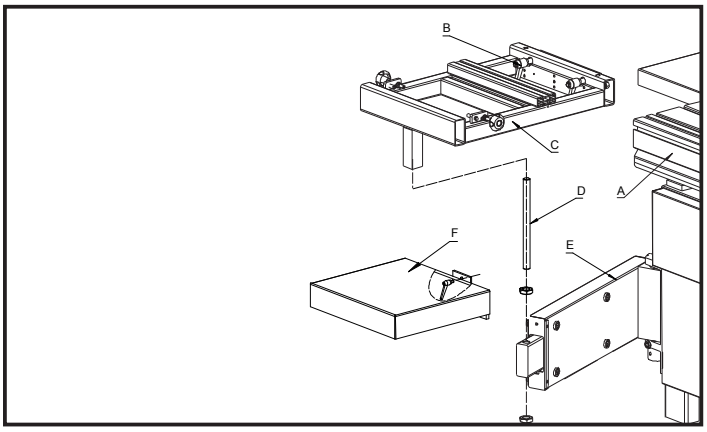


Fig.4.4.3

4.4.4 INSTALL TELESCOPIC FENCE

- Put the pin A of telescopic fence into the hole which is on the square sliding table, and mount the handle B to the pin.
- Lock the knob C for stable tighting.
- The Knob D is designed to micro-adjust perpendicularity between telescopic fence and blade.

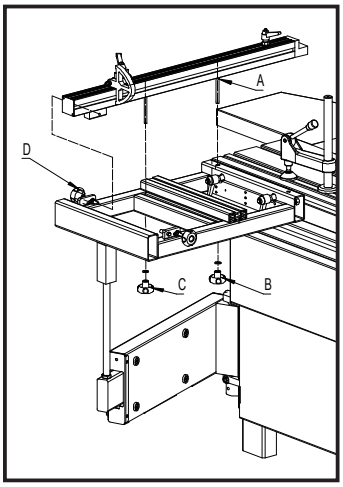


Fig.4.4.4（1）

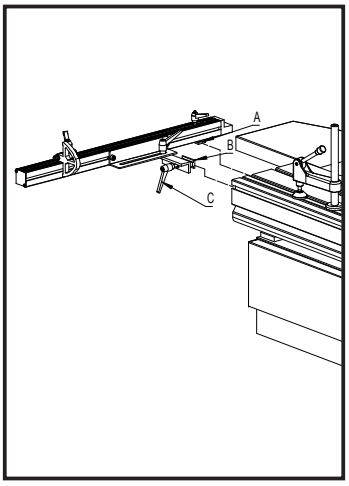


Fig.4.4.4（2）

4.4.5 INSTALL FENCE RAIL

Tools Required for Assembly:
- Wrench 18mm
- L Wrench 16mm

- Install scale seat B to tables with screw 1.
- Put the scale A into the slot of scale seat B.
- Install shaft 6 onto the guide rail C, and then mount the guide rail to tables with part 2, 3, 4, 5 and 6.

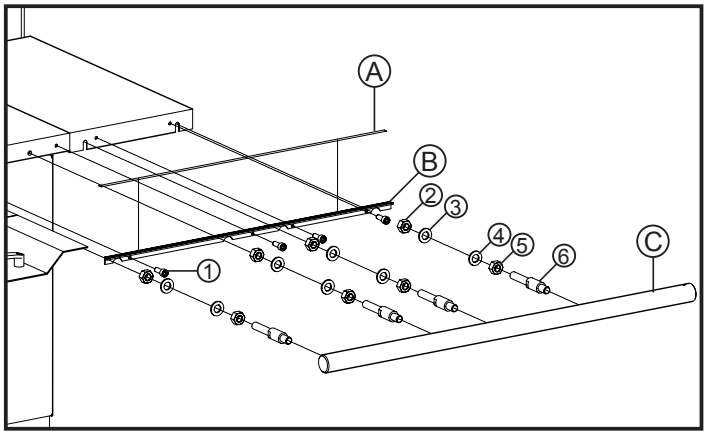


Fig.4.4.5

4.4.6 INSTALL RIP FENCE

- Install the rip fence seat A to guide rail B as the picture shown.
- Install the screw C onto the guide rail B.
- Install the rip fence D to the fence seat A along its slot.

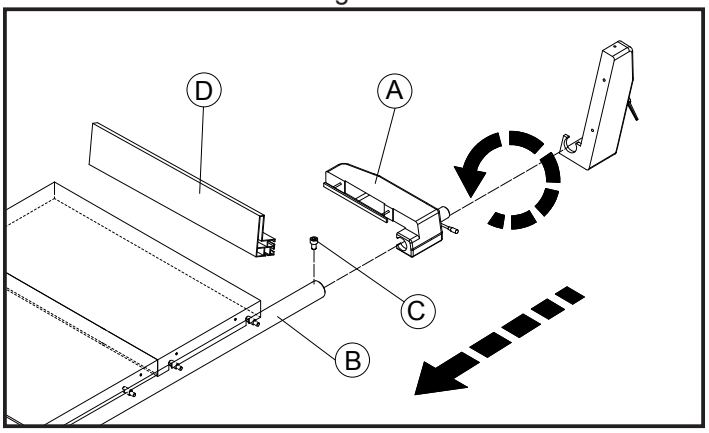


Fig.4.4.6

5.3 RIP FENCE PRECISION ADJUSTMENT

Tools Required for Assembly:
- 16mm fork wrench

- Let B,C,D go through the frame, then fix on A (Don't fix too tight, there are 2 sets)
- Let the sliding table go through A, then align the sliding table to the frame according to E sticker
- Position the sliding table towards the saw unit and fix the position. Then tighten the screw.

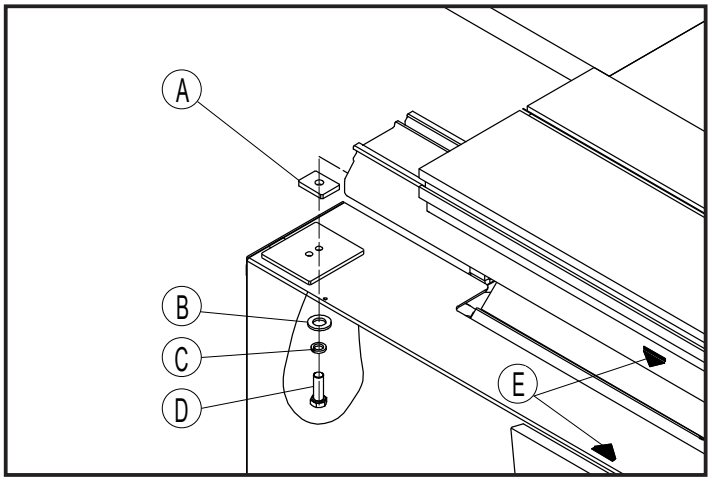


Fig.4.4.7

5. ADJUSTMENT

WARNING

Handle the tools with protective gloves.

5.1 SCORER ADJUSTMENT

CAUTION

For cutting panels coated with finishingmaterial, you have to use the scorer D. Position the scoring saw blade in order to have an engraving equal to 2mm.

Proceed as follows if it is necessary to adjust scorer positioning with respect to the saw:

- Loosen the knob A, and then adjust scoring saw height using the knob C.Lock the knob A.
- Loosen the knob B, and then adjust scoring saw height using the knob D.Lock the knob B.

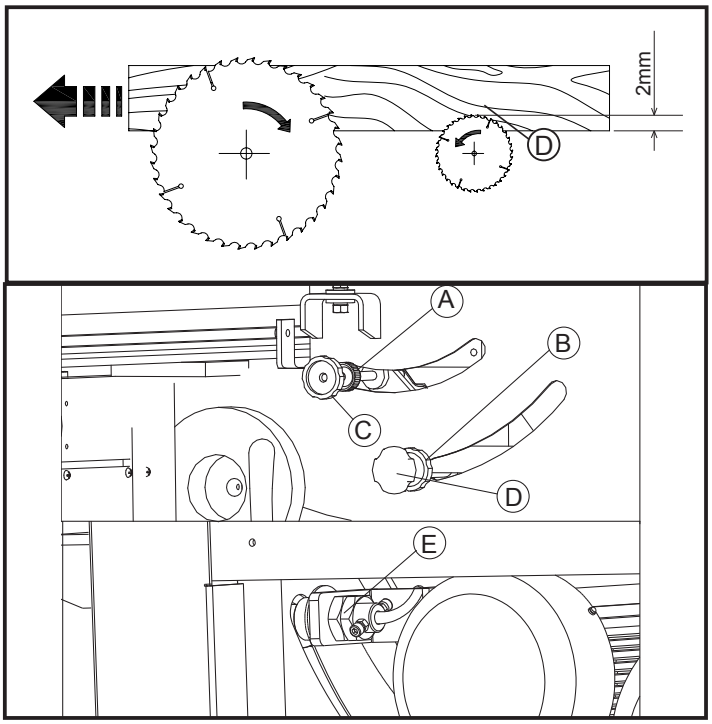


Fig.5.1

WARNING

The nut at E has been adjusted and fixed correctly. No random adjusting is permitted.

5.2 EXTENSION TABLE FLATNESS ADJUSTMENT

Tools Required for Assembly:
- Straight edge
- Feeler gauge
- L wrench 4mm
- Wrench 16mm

- Put the straight edge B on the main table and extension tables, use feeler gauge to check the flatness.
- Re-tighten the bolts A to micro-adjust the flatness.

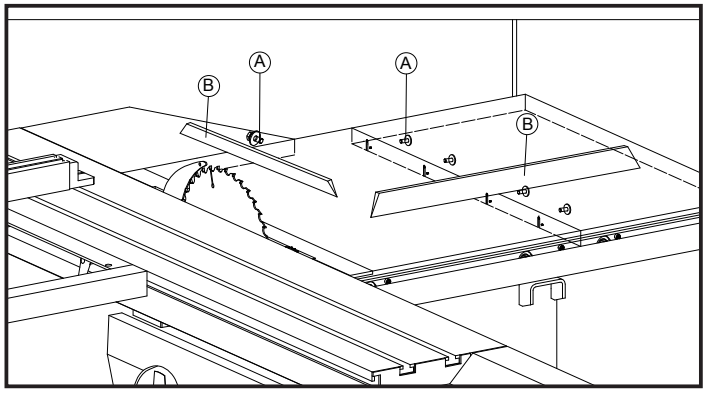


Fig.5.2

5.3 RIP FENCE PRECISION ADJUSTMENT

Tools Required for Assembly:
- Straight edge, Angle gauge, Depth gauge
- Feeler gauge
- Wrench 18mm

- Check the perpudicularity between the rip fence and table with triangle compass and feeler guage. Loosen 4pcs short shaft B, then adjust the guide rail up and down to get best perpudicularity.
- Check the parallelism between the blade and rip fence with straight edge and depth guage. Loosen 4pcs short shaft B, then adjust the guide rail up and down to get best parrallelism.

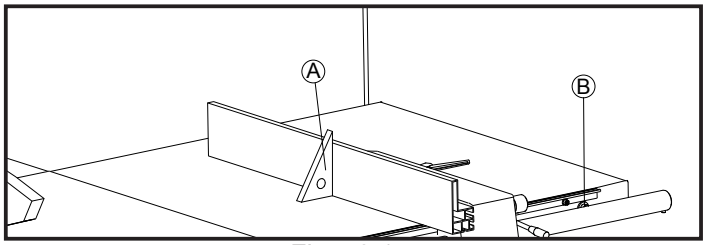


Fig.5.3.1

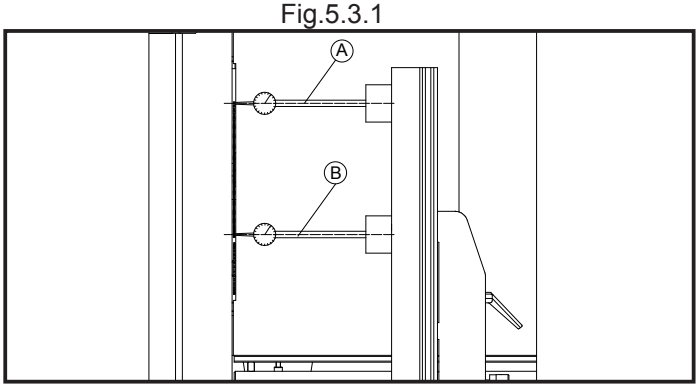


Fig.5.3.2

6. OPERATING PROCEDURES

WARNING

Please be careful to operate the machine while saw blade is running and always DO NOT to use the machine unless all of the guards and other safety devices are in good working order.

6.1 MACHINE START AND STOP

The switch's positon of the machine is as the picture shown.

-A is the main saw motor start button
-B is a saw blade stop button
-C is an emergency switch
-D is a control switch groove sawing machine

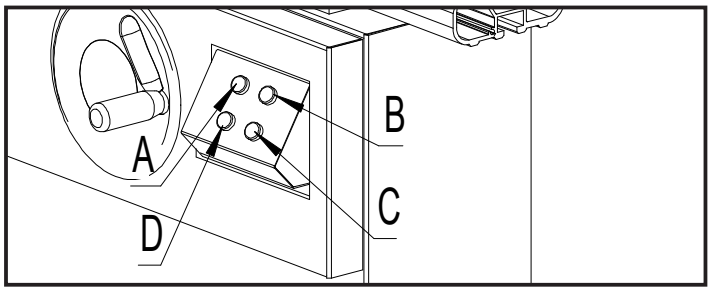


Fig.6.1

6.2 WORKING STATION

WARNING

The machine has been designed to be used by one operator only. Plastic pusher shall be used when cutting small workpieces and in circumstances where it is necessary to push the workpiece against the fence.

A - Working with the sliding table (squaring)
B - Parallel cut side

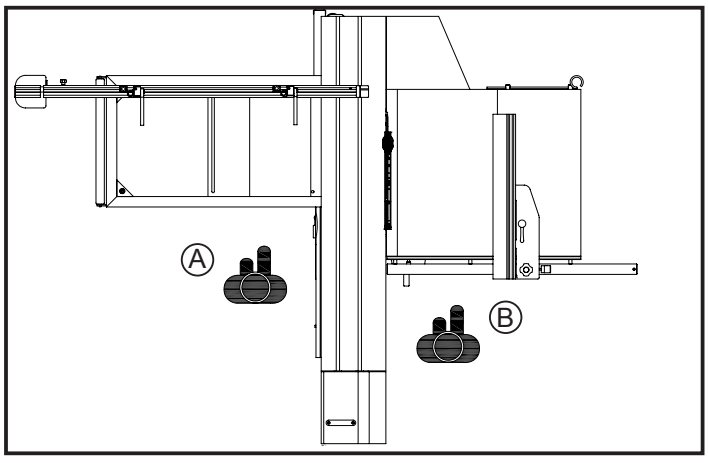


Fig.6.2

6.3 WORKING WITH THE MACHINE

The choice of the method to use to make a cut with the circular saw depends on the dimensions of the wood to be machined and the type of machining to be carried out. For cutting ennobled wood, use of the engraver is indispensable to prevent chipping.When the engraver is not needed,lower it completely underneath the table.

6.3.1 WORKING WITH THE SLIDING TABLE

- Put workpiece on the sliding table. Fix it with the aluminium stoper B and gripping arm C.
- Stand on position A, push the operating lever which is on sliding table forward to across blade.

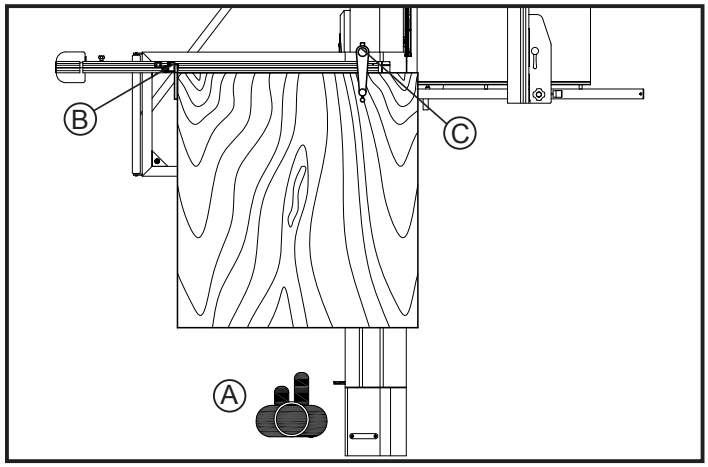


Fig.6.3.1

6.3.2 WORKING WITH RIP FENCE

- Lock the sliding table. Put the workpiece against the side surface of rip fence. Push the workpiece forward across blade.
- For your safety, please use the plastic push block.
- When cutting off a small workpiece, please use the push stick to prevent accident cutting of hands.

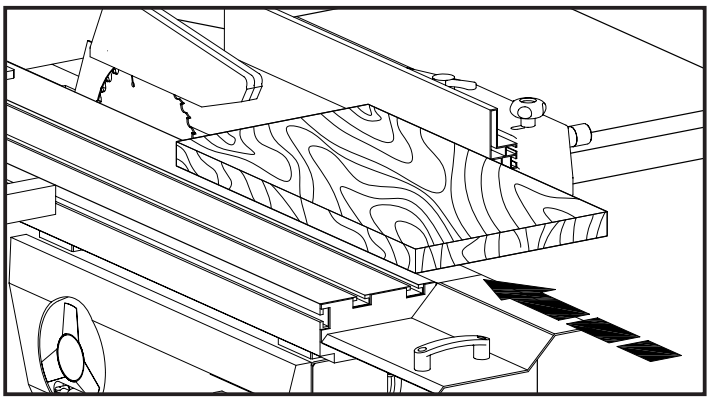


Fig.6.3.2

6.4 CORRECT USE FOR THIS MACHINE

- First make sure that the machine does not vibrate.Do not try to take off the material when the cut has already started; proceed with a continuous and uniform speed. Workpiece feeding towards the blade (especially where there are knots) should not be too fast (feeding speed should be in accordance with workpiece thickness). Do not let workpieces stop between the saw fence and the blade.
- Avoid contact of the tips against metallic objects. When necessary sharpen the saw blade.Often clean the steel body and the tips with proper liquid products. Let the saw blade in the bath, then clean it with brush: don't use metallic brushes. As regards the toothing at least 2-3 teeth shall cut at the same time A. If only one tooth cuts B, you don't get a good cutting. Whenever this is possible, it is also critical to lift the blade until the whole tooth cutting part protrudes from the wood thickness.

WARNING

Before touching the machine parts, ensure to turn OFF the main switch and disconnect the general power supply.

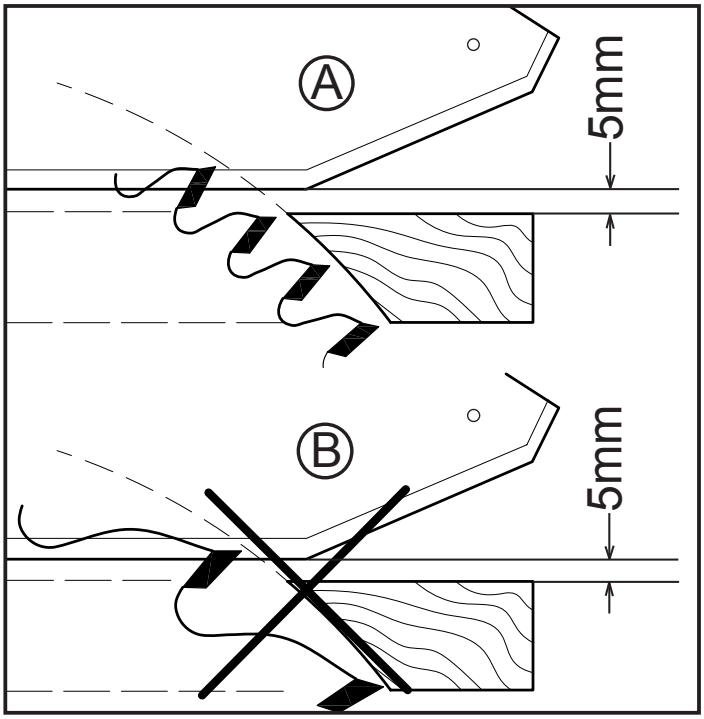


Fig.6.4

6.5 CUTTING CHECK AFTER THE MACHINE ADJUSTING IS FINISHED

Before cutting workpiece, please make sure the sliding table and fence is adjusted correctly. Choose sharp and high-quality blade. Please choose a 1000mmX1000mm chipboard or destiny board. The board thickness should be more than 19mm. Put the workpiece with the cutting side close to the fence, then rotate the workpiece anticlockwise. Cut 10mm every time, and cut 5times. Then check the width of the fifth cutted woodpiece. The requested tolerance should be within 0.2mm.

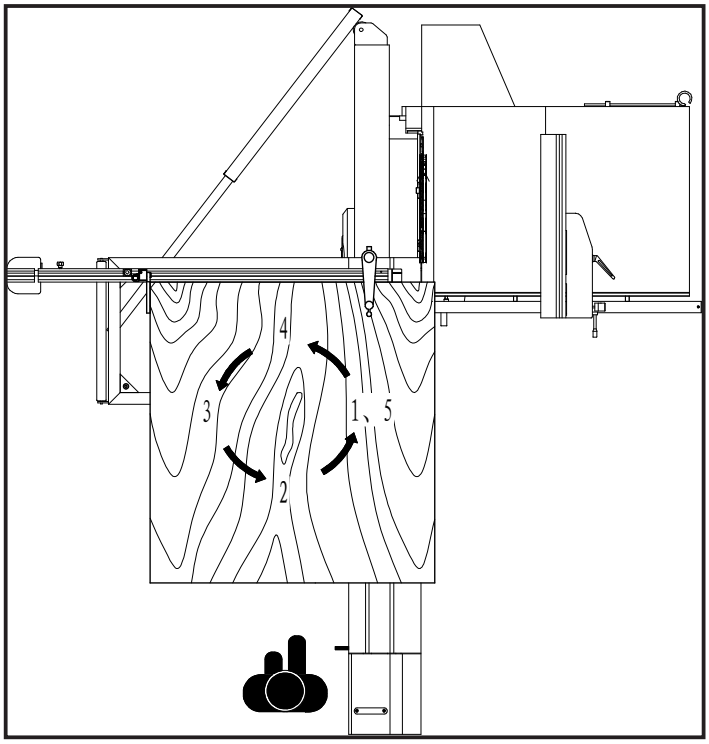


Fig.6.5

6.6 MATERIAL AND BLADE (JUST FOR REFERENCE)

Material	Cutting speed (m/s)	Diameter of scoring blade D=250mm	Diameter of scoring blade D=300mm	Diameter of scoring blade D=350mm	Diameter of scoring blade D=400mm
soft woodpiece rip cutting	60-80	24W	28W	32W	36W
soft woodpiece cross cutting	60-80	40W	48W	54W	60W
hard workpiece rip cutting	60-80	24W	28W	32W	36W
hard workpiece cross cutting	60-80	40W	48W	54W	60W
veneer board	70-80	60W	72W		
chipboard	50-70	40W	48W		
compound board	60-80	48W	60W	72W	
plywood board	50-80	40W	48W	54W	
particle board	60-80	48W	60W	72W	
particle board with coating	60-80	60TF	72TF	84TF	
destiny board	60-80	48W	60W	72W	
destiny board with coating	60-80	60W	72W	84W	
fibre board	60-80	60W	72W	84W	
thin board	50-70	60TF	72TF	84TF	
plaster board	40-60	48W	60W	72W	

Remarks: W: alternate teeth (left and right teetch)
TF: ladder flat teeth
The dimension of scoring blade: diameter=120mm, 24 teeth, ladder flat teeth, inner hole diameter=20mm

7. MAINTENANCE

WARNING Disconnect the general power supply before doing any maintenance.

7.1 REPLACE SAW BLADE

WARNING

Only correctly sharpened saw blades manufactured in accordance with the requirements of EN 847-1:2005 shall be used. Don't use the saw blade whose maximum marked speed is lower than the maximum rotational speed of the saw spindle. Please always keep the gap between the riving knife and the saw blade to be at least 3mm and not exceed 8mm.

- Rotate the blade lifting handwheel to move the blade to toppest position.
- Take out the blade guard A.
- Remove the table insert B.
- Push the sliding table to backmost position.
- Open the blade cover D.
- Unscrew the nut C to take out the blade for replacement.

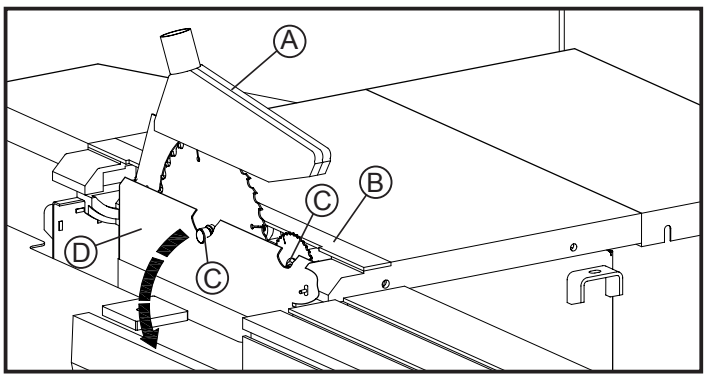


Fig.7.1

7.2 REPLACE BELT

Tools Required for Assembly:
- 4mm allen wrench
- 6mm allen wrench

-Open right side plate with 4mm allen wrench, then rotate the screw rod at A of figure 7.2 with 6mm allen wrench.

-When rotating the wrench clockwise, belt becomes loose; when rotating the wrench anticlockwise, belt becomes tight.

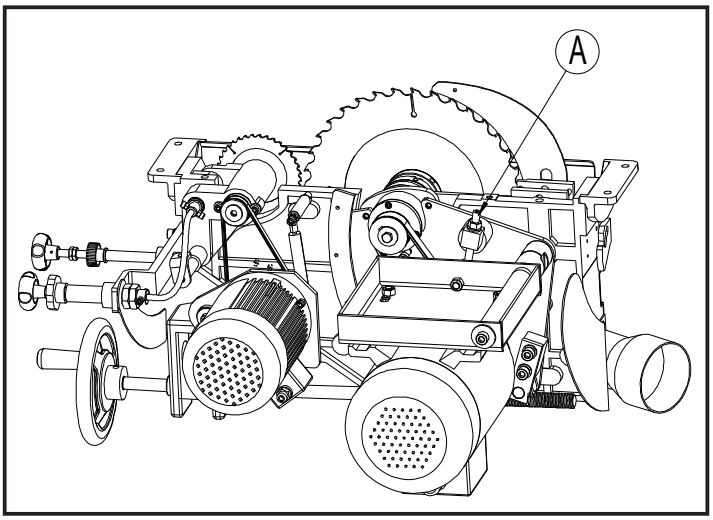


Fig.7.2

7.3 OVERALL CLEANING

WARNING

Please DO NOT to try removing chips while the saw blade is running.

After each working cycle, thoroughly clean the machine and all of its parts, vacuum the shavings and dust and remove any resin residues.
Use compressed air only when strictly necessary, using protective glasses and a mask.

In particular, clean the following parts:
- the sliding table rail A;
- the sliding support extension B;

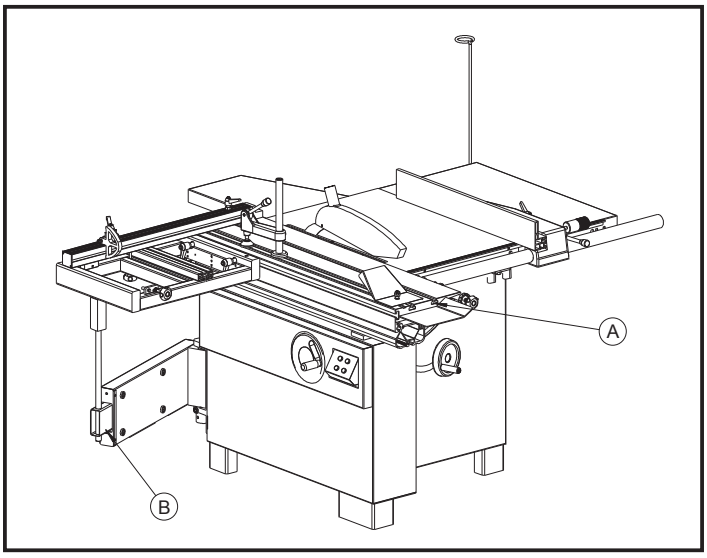


Fig.7.3

7.4 GENERAL LUBRICATION

- Weekly clean and lubricate all the mobile couplings of the machine A with a thin film of oil and grease.
- Protect all belts and pulleys to avoid contamination with oil.

7.5 REPLACEMENT AND DISPOSAL

Should replacement become necessary, the machine parts must be replaced with original components in order to guarantee their efficiency.

The replaced parts must be disposed of in compliance with the laws in force in the country of use.

Component replacement requires specific training and technical skills; for this reason, the above interventions must be carried out by qualified personnel to prevent damage to the machine and risks to the safety of persons.

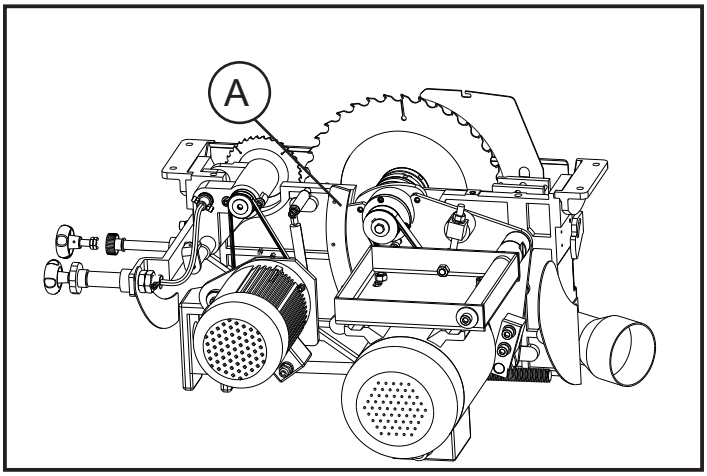


Fig.7.4

CAUTION

- In case of mechanical or functional faults in the machine, including guards or tools, please call the local authorized agent for technical assistance and maintenance.
- Any maintenance must be only done when the machine is isolated from all energy sources (plug out).

8. TROUBLE SHOOTING

WARNING

- For any information or problem contact your area dealer or our technical service center. The necessary interventions must be carried out by specialised technical personel.
- Before carrying out any fault service or maintenance work, please always TRUN OFF THE SWITCH, UNPLUG POWER CABLE, WAIT FOR SAW BLADE TO COME TO STANDSTILL.

Trouble	Possible Cause	Solution
Saw stops or will not start	1. Overload tripped on motor 2. Saw unplugged from wall or motor 3. Fuse blown or circuit breaker tripped 4. Cord damaged	1. Allow motor to cool and reset overload switch on motor 2. Check all plug connections 3. Replace fuse or reset circuit breaker 4. Replace cord
Does not make accurate 45° or 90° cuts	1. Stops not adjusted correctly 2. Angle pointer not set accurately	1. Check blade with square and adjust stops 2. Check blade with square and adjust pointer
Material binds blade when ripping	1. Fence not aligned with blade 2. Warped wood 3. Excessive feed rate 4. Splitter not aligned with blade	1. Check and adjust fence 2. Select another piece of wood 3. Reduce feed rate 4. Align splitter with blade
Saw makes unsatisfactory cuts	1. Dull blade 2. Blade mounted backwards 3. Gum or pitch on blade 4. Incorrect blade for cut 5. Gum or pitch on table	1. Sharpen or replace blade 2. Turn blade around 3. Remove blade and clean 4. Change blade to correct type 5. Clean table
Blade does not come up to speed	1. Extension cord too light or to long 2. Low shop voltage 3. Motor not wired for correct voltage	1. Replace with adequate size cord 2. Contact your local electrical company 3. Refer to motor junction box
Saw vibrates excessively	1. Stand on uneven floor 2. Damaged saw blade 3. Bad V-belts 4. Bent pulley 5. Improper motor mounting 6. Excessive play in raising mechanism 7. Loose hardware	1. Reposition on flat, level surface 2. Replace saw blade 3. Replace V-belts 4. Replace pulley 5. Check and adjust motor 6. Adjust worm and arbor bracket 7. Tighten hardware
Rip fence binds on guide rails	1. Guide rails or extension wing not installed correctly 2. Guide of rip fence not adjusted properly	1. Reassemble guide rails, refer to fence manual 2. Adjust guides, refer to fence manual
Material kicked back from blade	1. Rip fence out of alignment 2. Splitter not aligned with blade 3. Feeding stock without rip fence 4. Splitter not in place 5. Dull blade 6. Letting go of material before it is past blade 7. Anti-kick back plates dull	1. Align rip fence with miter slot 2. Align splitter with blade 3. Install and use rip fence 4. Install and use splitter (with guard) 5. Replace blade 6. Push material all the way past blade before releasing work 7. Replace or sharpen anti-kick back plates
Blade does not raise or tilt freely	1. Too much tension in raising mechanism 2. Sawdust and debris in raising and tilting mechanisms	1. Adjust raising worm and arbor bracket 2. Clean and regrease

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