Wadkin ULTRACARE
At the Cutting Edge of Industry

SP12

PANEL SIZING DIMENSION SAW

INSTRUCTION MANUAL No.B857/2

BOOK NO. B857/2

IMPORTANT

It is our policy and that of our suppliers to review constantly the design and capacity of our products. With this in mind, we would remind our customers that whilst the dimensions and performance data contained herein are current at the time of going to press, it is possible that, due to the incorporation of latest developments to enhance performance, dimensions and supplies may vary from those illustrated.

PLEASE INSERT SERIAL NUMBER OF MACHINE

Instruction Manual For

SP12

Panel Sizing Dimension Saw

HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

Wadkin plc supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the users responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.
2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No. 41, "Safety in the use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin plc.
3. Only personnel trained in the safe use of a machine should operate it.
4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.
5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

Safety is our watchword but the user must comply with the above rules in his own interest. We would be pleased to advise on the safe use of our products.

Telephone: (0116) 2769111

Safety

CAREFULLY READ INSTRUCTION MANUAL WITH PARTICULAR REFERENCE TO THE FOLLOWING INSTRUCTIONS:-

1) SLINGING, ie SAFE LIFTING LIMITS FOR SLINGS ETC.

2) INSTALLATION AND FOUNDATION, ie SAFE WORKING AREA OF MACHINE AND BOLT POSITIONS, ETC.

3) WIRING DETAILS, ie WIRING DIAGRAM AND INSTRUCTIONS FOR SAFE WIRING OF MACHINE.

4) MACHINE CONTROLS AND OPERATING INSTRUCTIONS.

5) SELECT CORRECT SPEED FOR CUTTER EQUIPMENT AND ENSURE CUTTERS ARE SECURELY LOCKED IN POSITION.

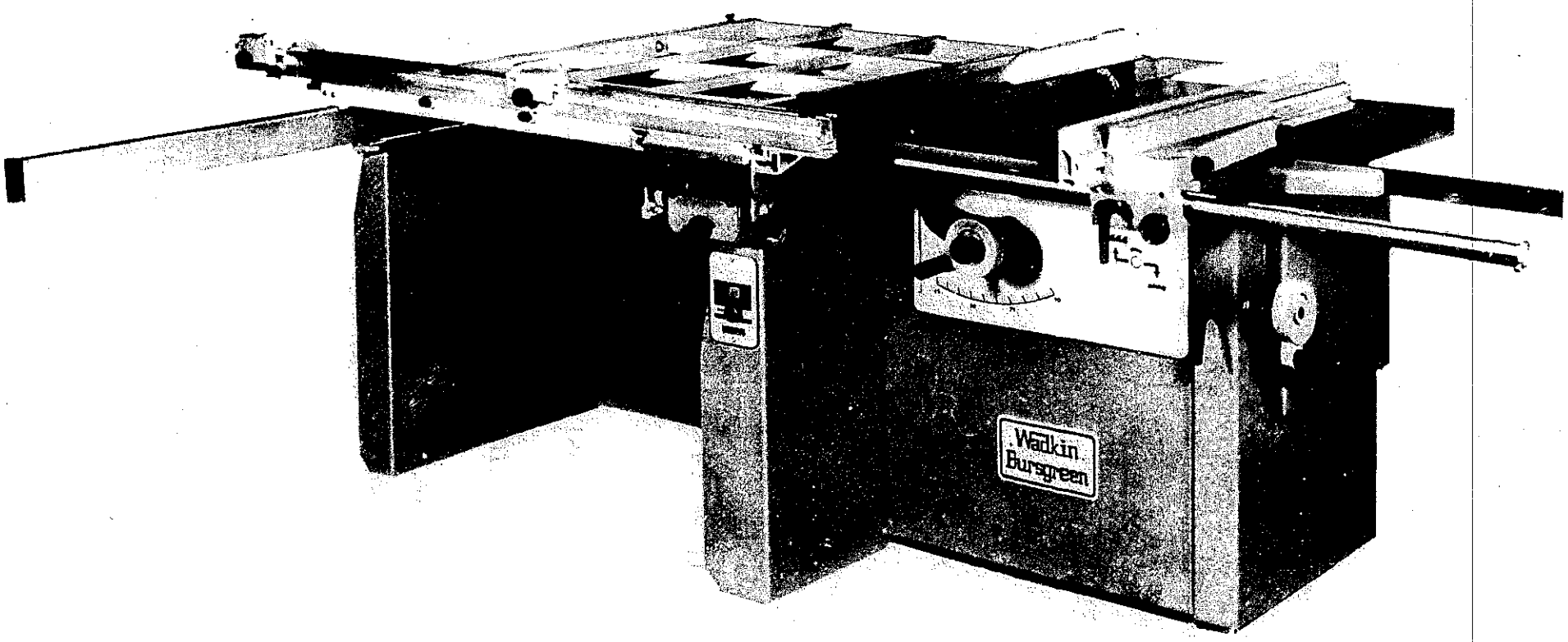
6) SET GUARDS CORRECTLY TO COVER CUTTER EQUIPMENT AS MUCH AS POSSIBLE.

7) NOTE START/STOP CONTROL POSITION AND ISOLATOR SWITCH POSITION (IF FITTED) BEFORE OPERATING MACHINE.

8) USE FEEDING DEVICES WHERE POSSIBLE.

9) REFER TO HEALTH AND SAFETY AT WORK BOOKLET No.41 (IN UK) FOR SAFETY IN THE USE OF WOODWORKING MACHINERY.

10) DO NOT RUN LARGE SAWBLADES AT HIGH SPEED.



PANEL SIZING AND DIMENSION SAW

FIG.1

SPECIFICATION

Max. dia of saw	300mm	12 in	
Max. saw projection with 300mm saw	100mm	4 in	
Max. dia saw when scoring	250mm	10 in	
Max. saw projection with 250mm saw	75mm	3 in	
Max. thickness of panel when scoring	30mm	1.3/16 in	
Max. width of cut using sliding table when scoring	1250mm	49 in	
Max. width of cut using sliding table without scoring	1350mm	53 in	
Max. distance saw to stops on sliding table crosscut fence	2500mm	96 in	
Max. distance saw to rip fence	916mm	36 in	
Max. distance saw to rip fence with extension table	1250mm	50 in	
Size of sliding table	1350 x 1300mm	53 x 51 in	
Size of main table	865 x 610mm	34 x 24 in	
Height of table	870mm	34¼ in	
Dia saw spindle	20mm		(1 in USA)
Power of motor - standard	2.2kw	3 hp	(6.6 hp USA)
- optional	3.7kw	5 hp	
Speed of main sawblade	3850rpm		
Dia of scorer blade	105mm		
Speed of scorer blade	7000rpm		
Approximate floor space	2700 x 3700mm	107 x 145 in	
Approximate net weight of machine	342kg	742 lb	
Approximate gross weight of machine	350kg	770 lb	
Approximate net weight outer support rail	46kg	101 lb	
Approximate gross weight outer support rail	48kg	105 lb	
Shipping dimensions of machine	1.45 x 1.14 x 1.09m	57 x 45 x 43 in	
Shipping dimensions outer support rail	2.32 x 0.15 x 0.87m	91 x 6 x 34 in	

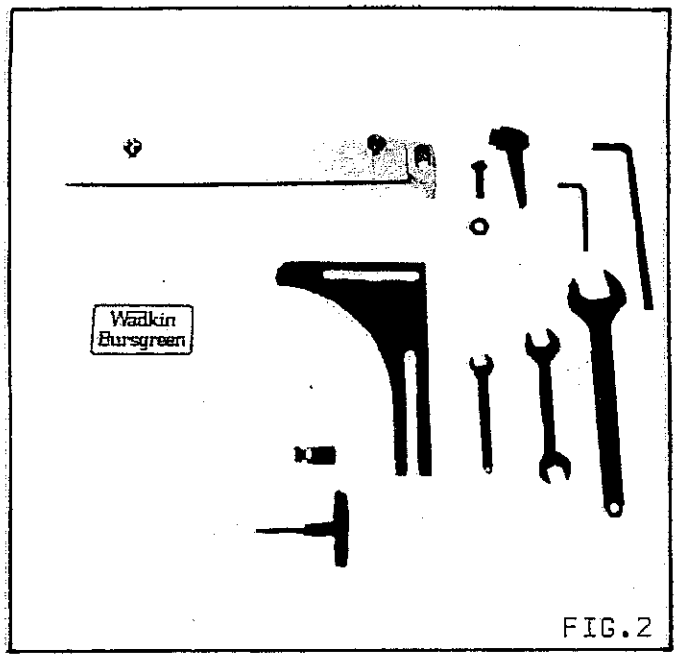


FIG.2

STANDARD ITEMS DESPATCHED WITH MACHINE

FIG.2

1 - Instruction Manual
1 - Sawguard SP12/64 c/w Visor and Locking Handles
1 - 5mm Hexagon Wrench
1 - 8mm Long Arm Hexagon Wrench
1 - 32A/F Spanner
1 - 17/19A/F Spanner
1 - 13A/F Spanner
1 - Setting Gauge
1 - 6mm A/F T-Handle Wrench

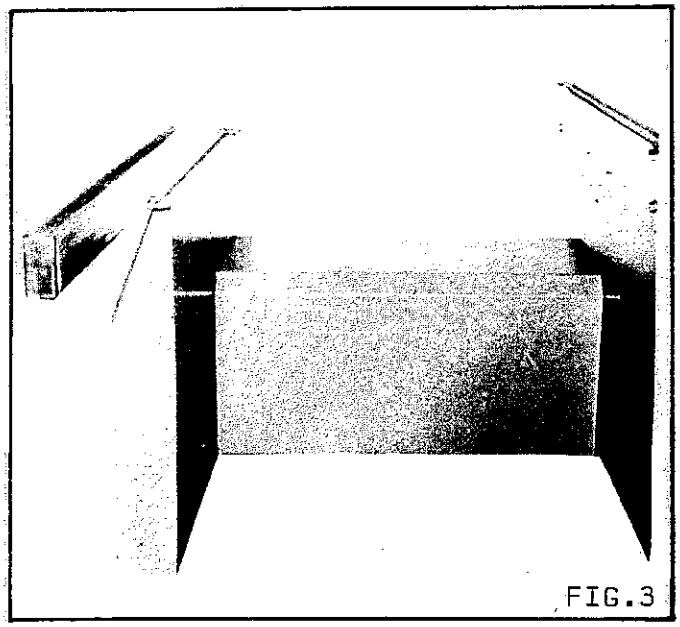


FIG.3

FIG.3

1 - Outer Support Rail
1 - Tie Piece

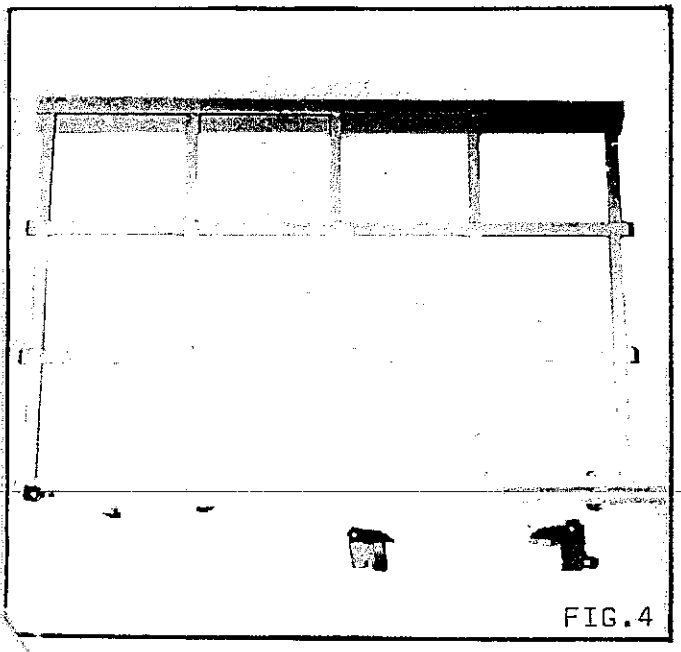


FIG.4

FIG.4

1 - Outrigger Table c/w Crosscut Fence
2 - Turnover Stops c/w Locking Shoes

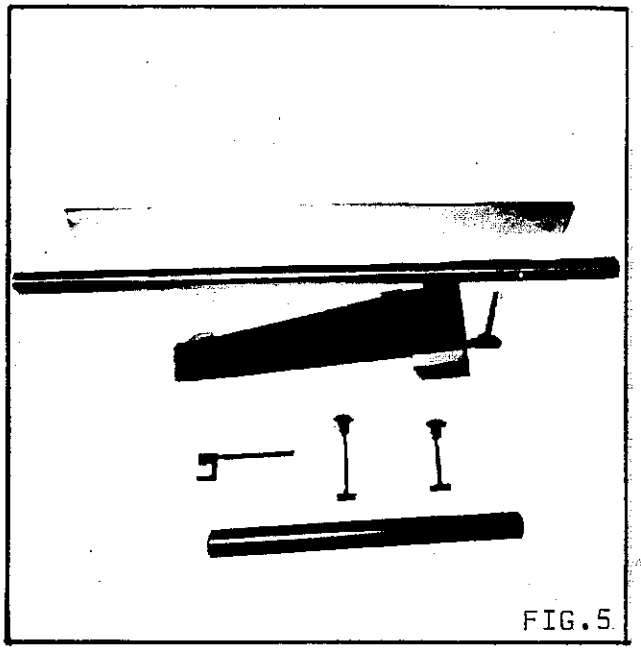


FIG.5

FIG.5

1 - Rip Fence Plate
1 - Fence Bar
1 - Rip Fence Bracket
2 - Rip Fence Plate Locking bolt c/w Plastic Handwheels
1 - Rip Fence Pointer
1 - Rip Fence Support Bar

EXPORT ONLY

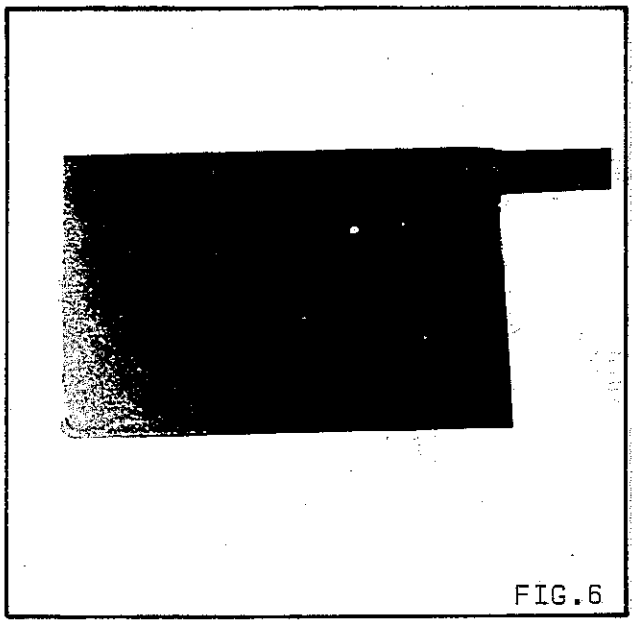
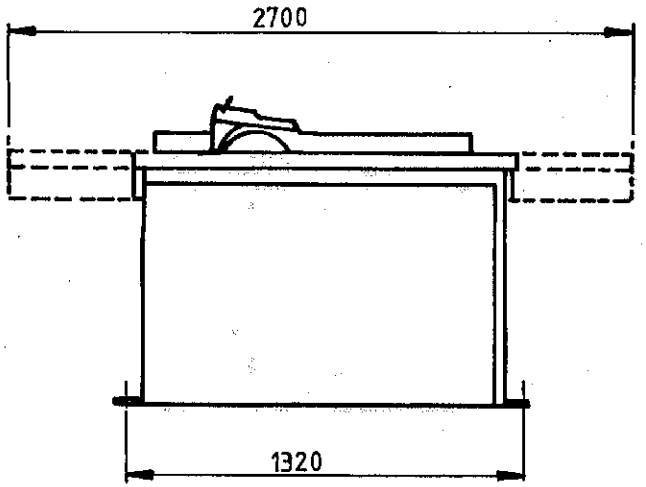


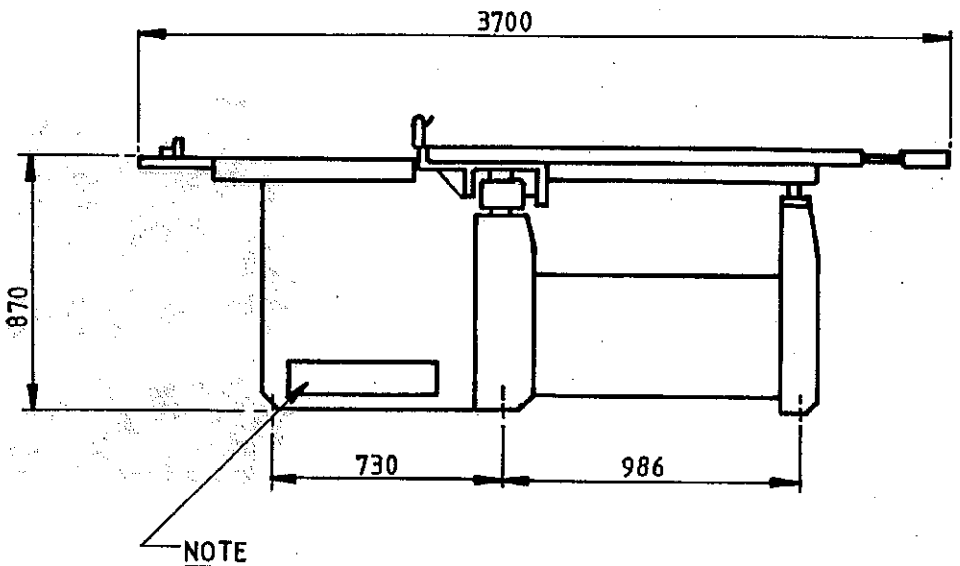
FIG.6

FIG.6

2 - Sliding Table Guards

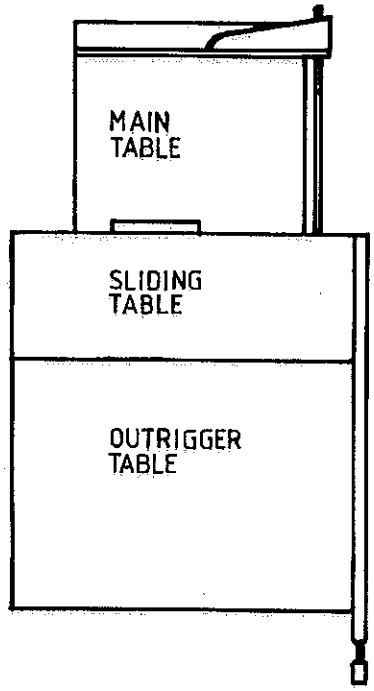
HOME ORDERS ONLY

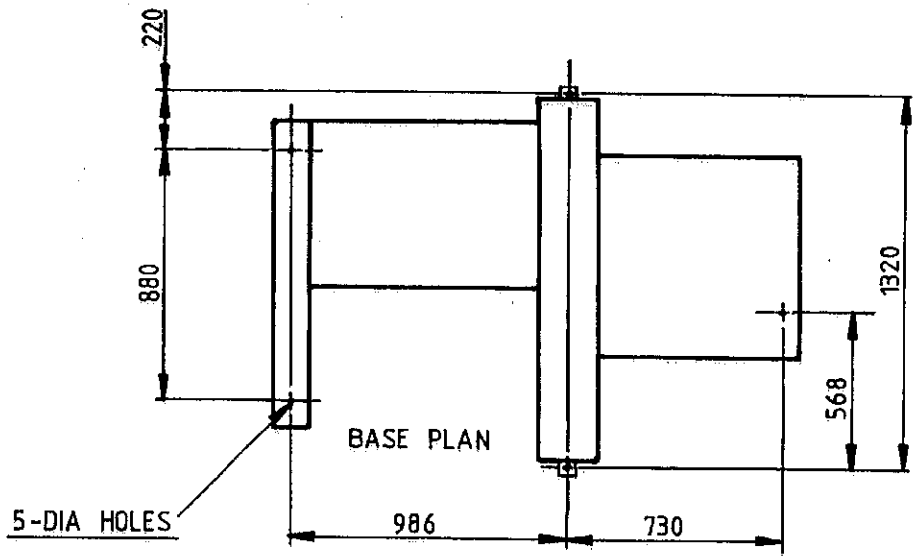




NOTE

VOLUME OF AIR TO BE EXTRACTED WHEN MACHINE IS FITTED WITH 100mm DIA EXHAUST OUTLET (EXTRA) = 375 CU. FT/MIN.





FOUNDATION PLAN

FIG.7

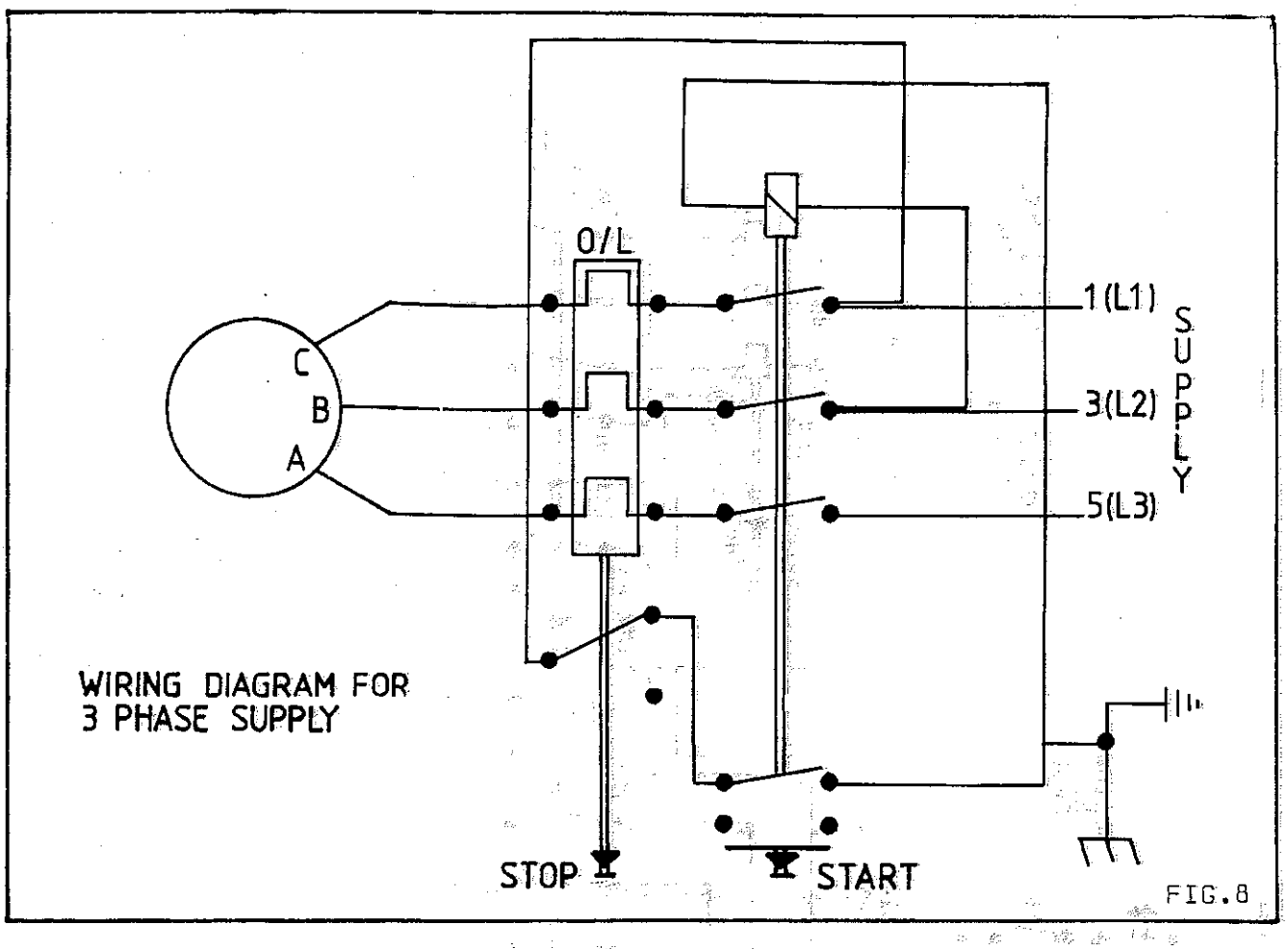
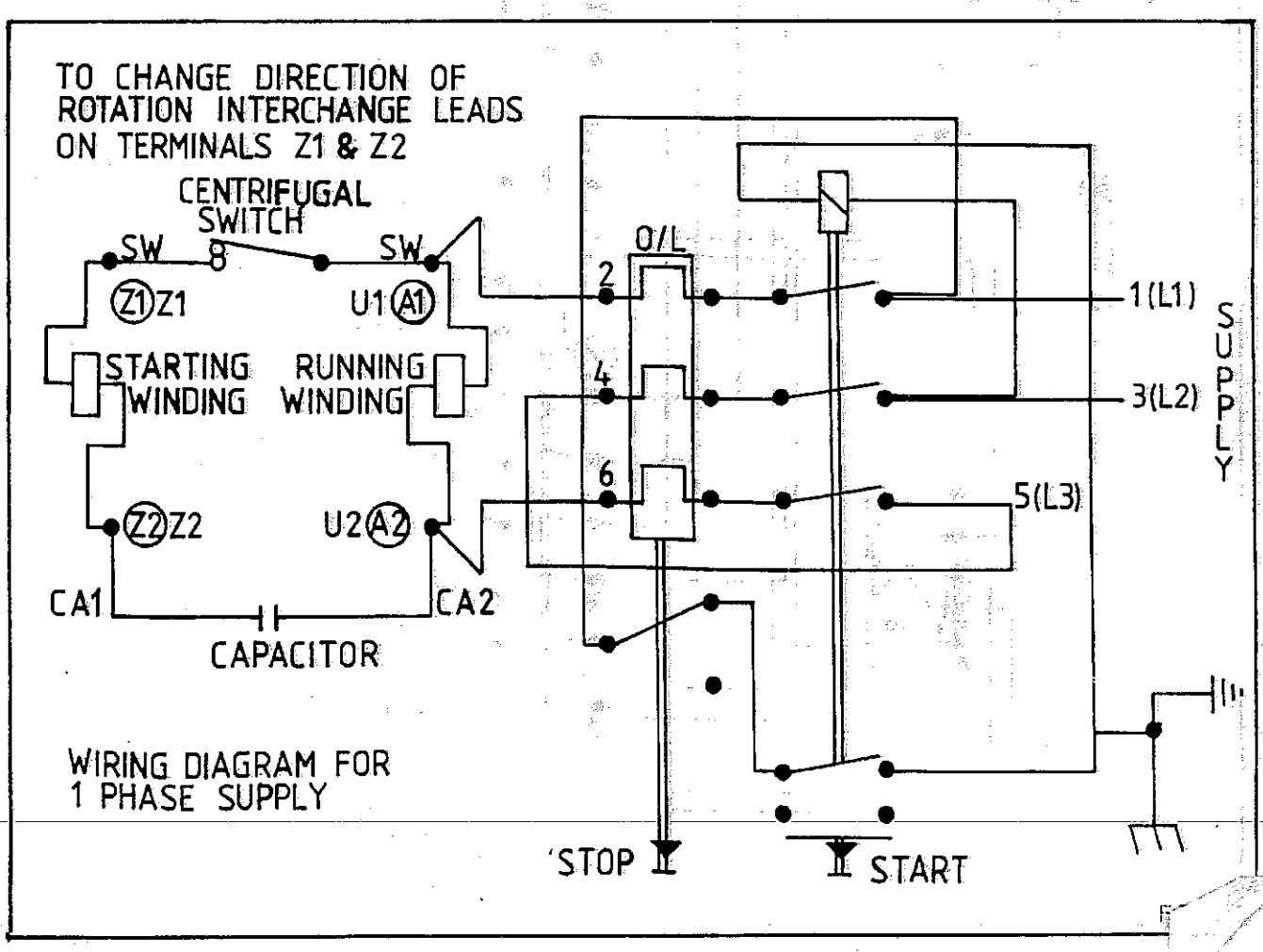

O/L
C
B
A
1(L1)
3(L2)
5(L3)
SUPPLY
WIRING DIAGRAM FOR
3 PHASE SUPPLY
STOP
START

FIG.8


TO CHANGE DIRECTION OF
ROTATION INTERCHANGE LEADS
ON TERMINALS Z1 & Z2
CENTRIFUGAL
SWITCH
SW
SW
Z1 Z1
U1 A1
STARTING
WINDING
RUNNING
WINDING
Z2 Z2
U2 A2
CA1
CA2
CAPACITOR
O/L
2
4
6
1(L1)
3(L2)
5(L3)
SUPPLY
WIRING DIAGRAM FOR
1 PHASE SUPPLY
STOP
START

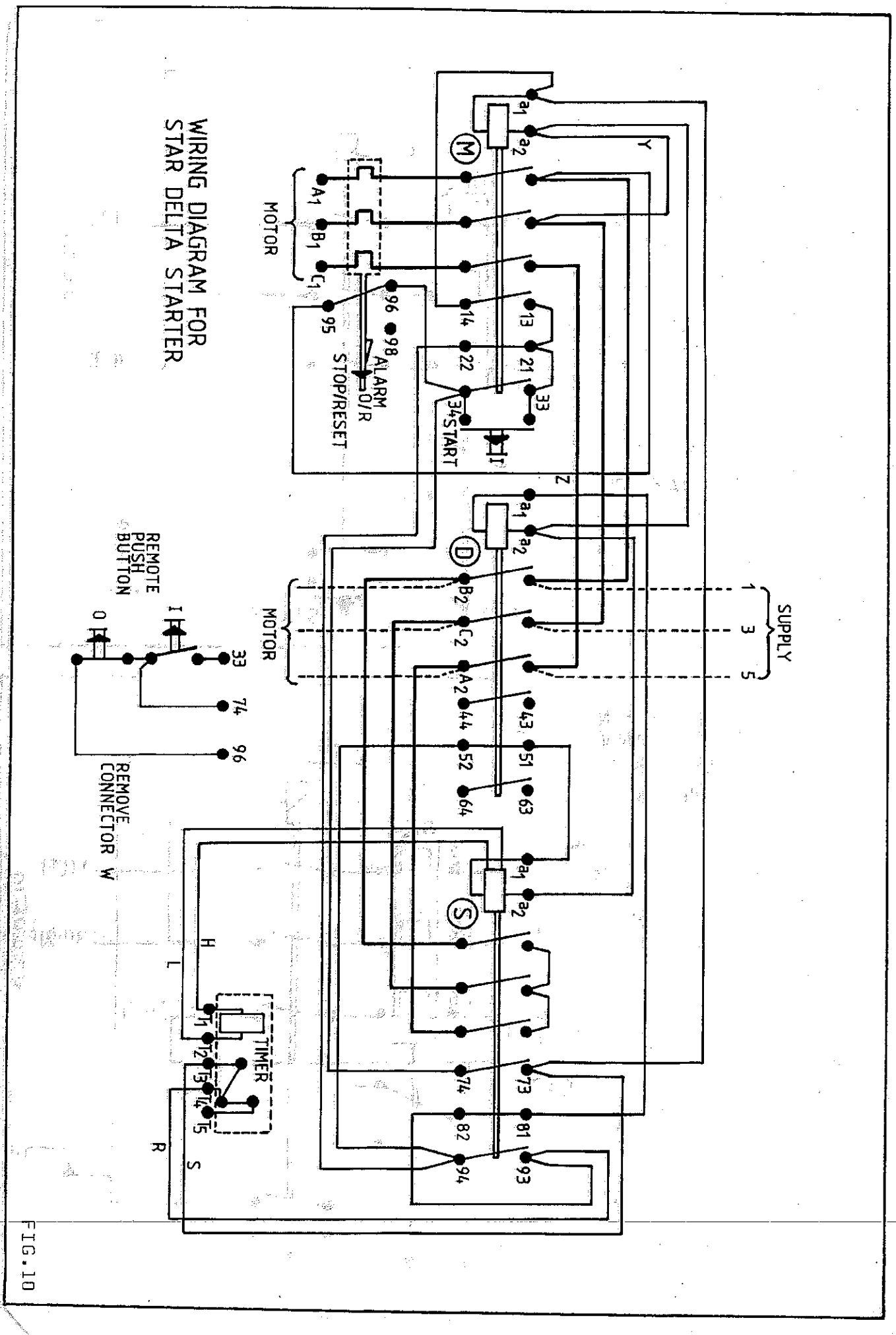

WIRING DIAGRAM FOR
STAR DELTA STARTER
MOTOR
A1
B1
C1
96
98
95
ALARM
O/R
STOP/RESET
14
22
13
21
33
34
START
Y
Z
M
D
S
a1
a2
B2
C2
A2
44
52
43
51
64
63
74
73
82
81
94
93
SUPPLY
1
3
5
REMOTE
PUSH
BUTTON
O
I
33
74
96
REMOVE
CONNECTOR W
H
L
R
S
TIMER
T1
T2
T3
T4
T5

FIG.10

SLINGING

Always use a sling within safe working load of machine weight.

Approximate net weight of machine - 342 kg
Approximate gross weight of machine - 350 kg

Attach slings to machine as shown in FIG.11, ensuring damage will not be caused to machine during slinging operation.

IMPORTANT: DO NOT WALK OR STAND UNDER MACHINE DURING SLINGING OPERATION.

CLEANING

Clean protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

FOUNDATION

The machine is front loading and should be sited to allow working room for all capacities. Refer to foundation plan FIG.7. Ensure floor is level, then mark floor to suit 5-M12 rawlbolts. Drill floor to suit rawlbolts. These bolts are not supplied with the machine but can be supplied at an additional charge.

WIRING DETAILS

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to starter or isolator when fitted.

Points to note when connecting power supply:-

1) Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
2) It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.
3) Check the main line fuses are correct capacity. See fuse list inside front cover of instruction manual.
4) Connect the line leads to the appropriate terminals. See wiring diagrams FIG.8, FIG.9 or FIG.10.
5) Check all connections are sound.
6) Check the rotation of the motor for the correct direction, if this is incorrect, reverse any two of the line lead connections.

LUBRICATION

All bearings are sealed for life and require no lubrication.
Oil Rise/Fall screw and slides - once weekly.

Approved lubricants, see page 26.

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

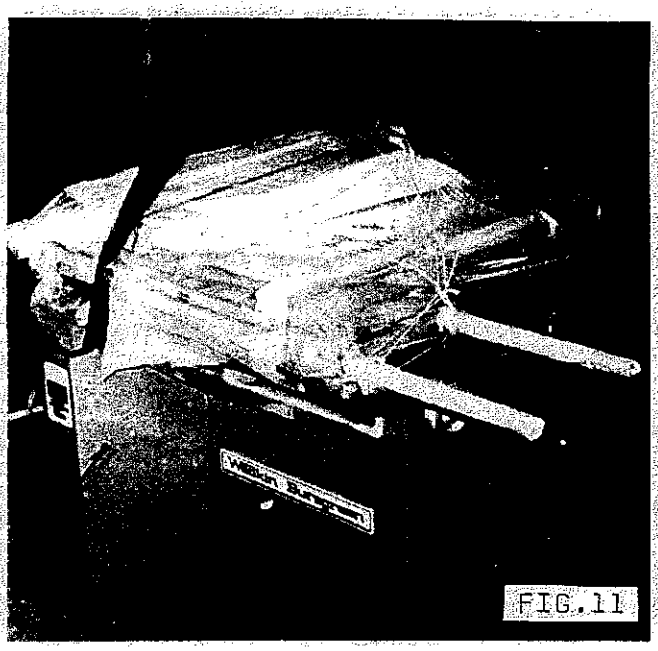


FIG.11

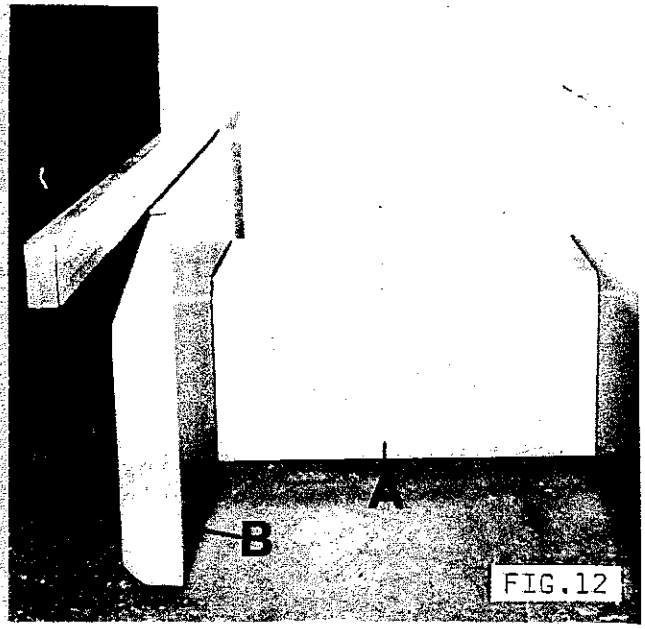


FIG.12

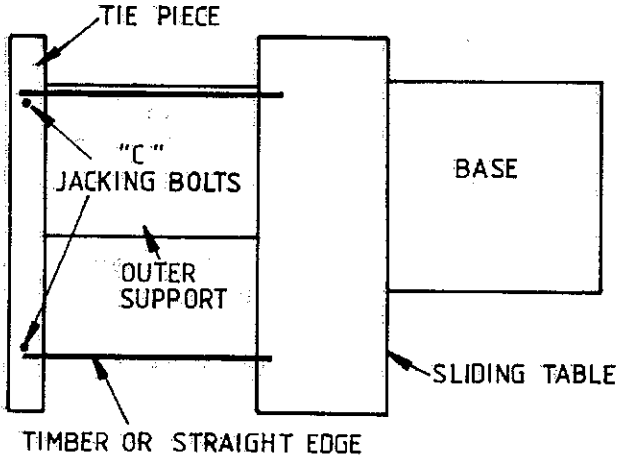


FIG.13

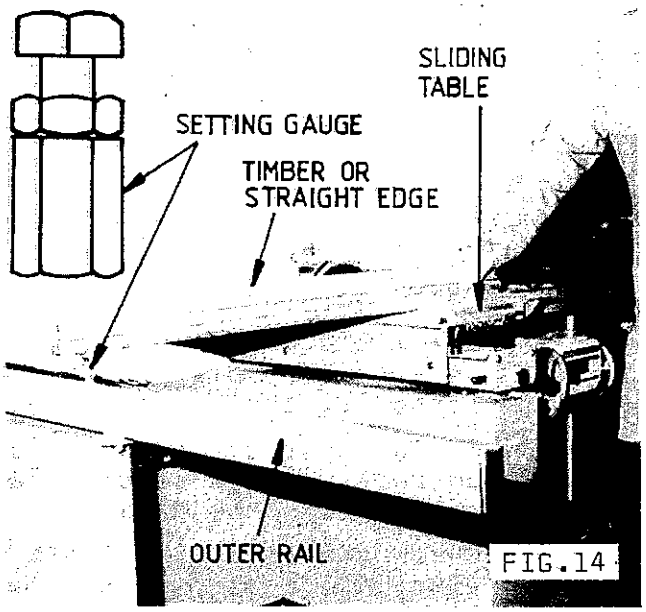


FIG.14

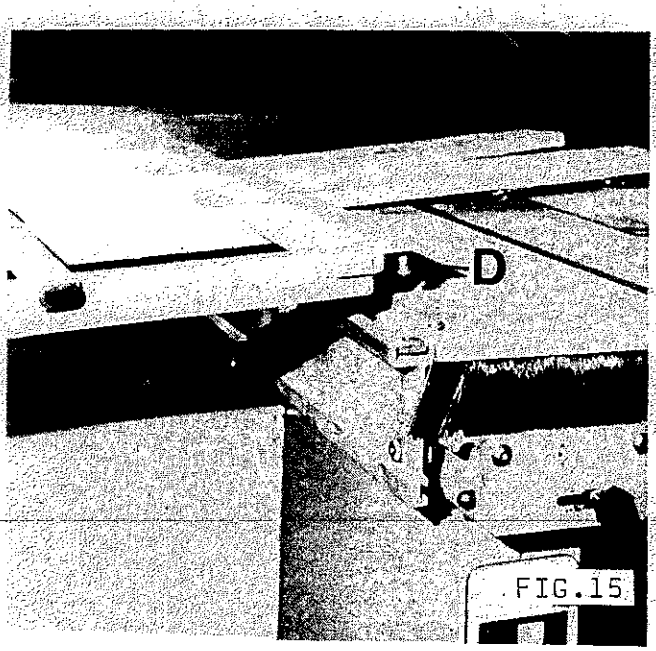


FIG.15

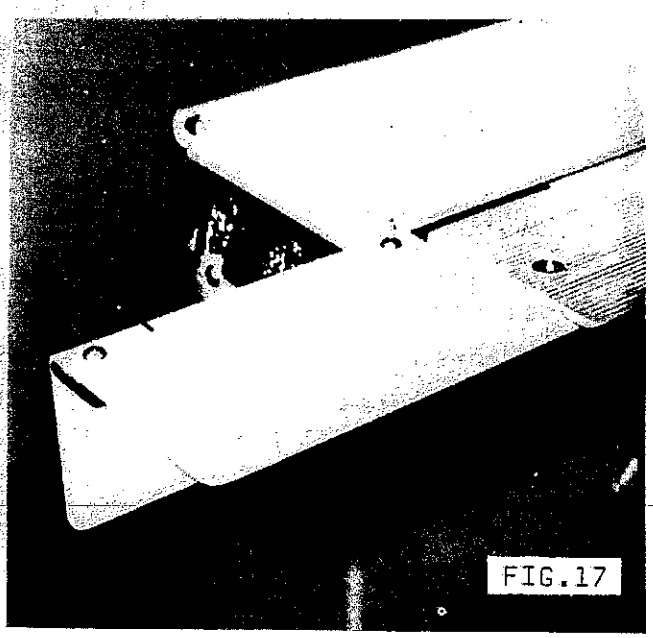


FIG.17

ASSEMBLY OF MACHINE

Machines for home market have the outer support, tie piece, outrigger table, crosscut fence and scorer guards, removed for the ease of transportation.

Machines for export market have the outer support packed in a separate case. The tie piece, outrigger table, crosscut fence and rip fence are removed and packed with the machine.

To assemble outrigger table, proceed as follows:-

1) Locate tie piece "A" FIG.12 over studs in base and lock with 4 - M8 nuts and washers provided, locate studs in outer support "B" in tie piece, lock with 4 - M8 nuts and washers provided.

   NOTE: ENSURE JACKING BOLTS IN OUTER SUPPORT ARE CLEAR OF FLOOR BEFORE SECURING TO TIE PIECE.

2) Position timber or straight edge over sliding table and outer support as FIG.14, above jacking bolt "C", FIG.13.

   Place setting gauge on outer support rail and check height to straight edge. Adjust outer support rail, jacking bolts "C" until setting gauge touches straight edge. Check in both positions.

3) Position outrigger table over outer support and locate spiggots "D" into shoes in sliding table slot FIG.15.

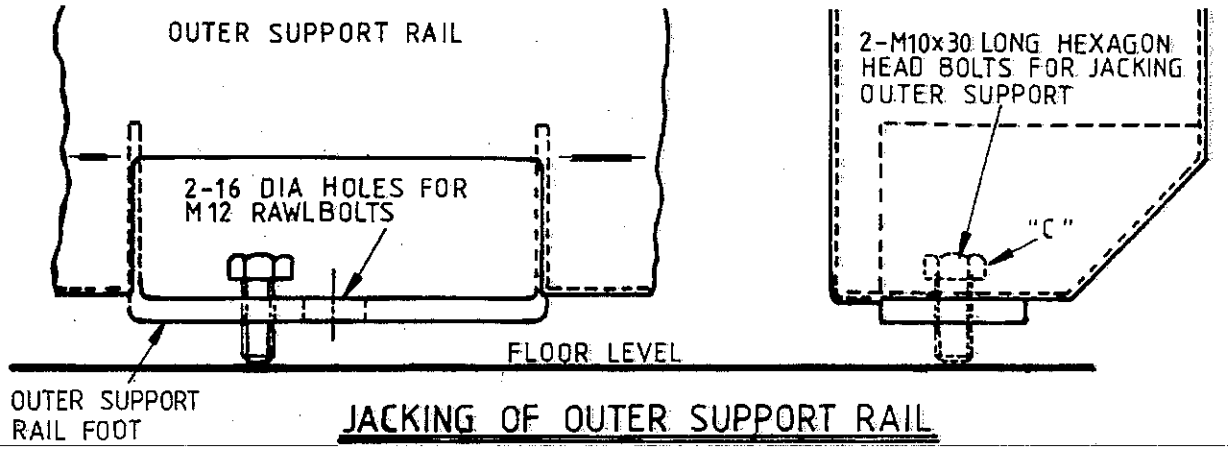
To re-assemble rip fence, proceed as follows and refer to FIG.22.

Locate studs "M" into the holes in the front of main table. Set fence bar parallel to table top and lock in position with nuts provided.

NOTE: DO NOT DISTURB LOCKNUTS AS THESE ARE SET IN FACTORY TO GIVE CORRECT FENCE ALIGNMENTS.

Assemble fence and lock stop screw in end of fence bar. Fit fence support "N" to table edge and ensure support is set level to table top.

Fit front and rear sliding table guards "E" FIG.17 (home order only) into tee slot on sliding table and lock into position with allen key supplied.



JACKING OF OUTER SUPPORT RAIL

FIG.16

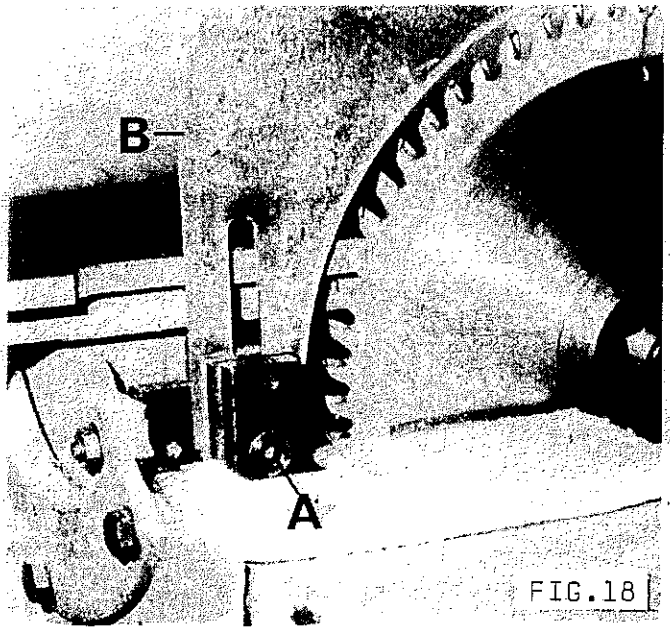


FIG.18

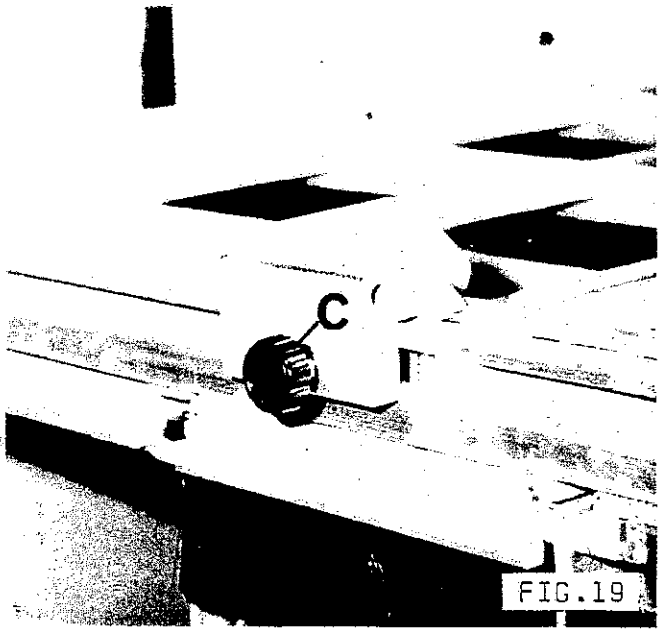


FIG.19

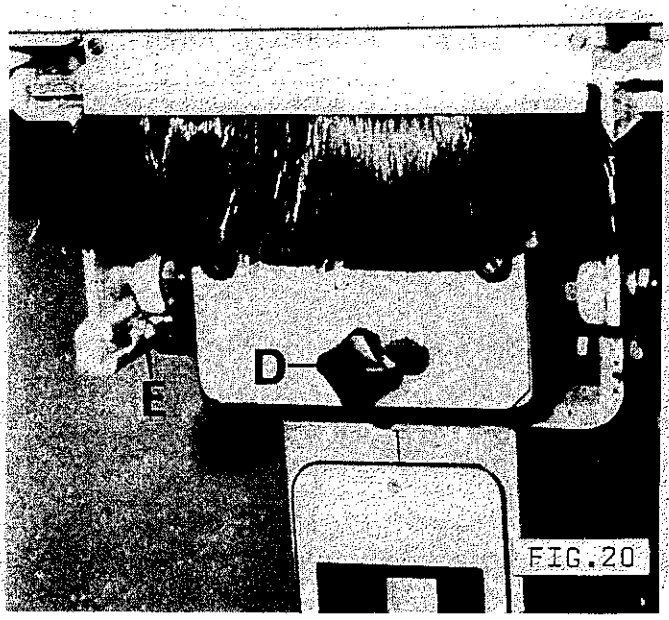


FIG.20

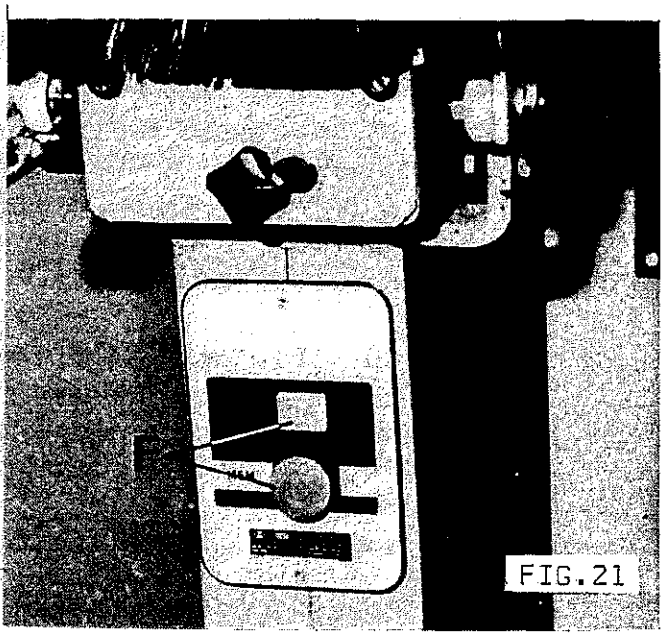


FIG.21

GUARD AND RIVING KNIFE ADJUSTMENT

The riving knife and guard rise and fall with the saw. The riving knife should be adjusted to the closest practicable distance from the saw teeth.

To adjust the riving knife to this position, proceed as follows:

1) Isolate machine electrically.
2) Move sliding table for access to riving knife adjustment, FIG.18.
3) Loosen M16 socket head screw "A" and move riving knife "B" to correct position.
4) Tighten securely socket head screw "A".

The sawguard should then be adjusted to cover as much of the saw as possible.

CROSSCUT FENCE

The crosscut fence is fitted to the front of the sliding table and positioned square to the saw. It is held by a pivot pin on the outrigger table and a spring loaded plunger on the sliding table. For ripping operations lock sliding table FIG.20. Release spring loaded plunger and swing crosscut fence clear.

TURN OVER STOPS

2 - turn over stops are supplied with machine and are fitted to the crosscut fence as shown in FIG.19. These stops are fitted to enable timber to be positioned in correct relation to sawblade and for repeat cuts on the same size timber.

To move each stop, loosen handwheel "C" position stop as required, then re-lock handwheel "C".

POSITIONING OF SLIDING TABLE CARRIAGE

At the start of each working day, push sliding table to maximum forward position, then to maximum rear position, to ensure sliding table carriage is correctly positioned in relation to table stops.

SLIDING TABLE LOCK

When the machine is used for ripping operations, the sliding table can be locked by locating the locking bar "D" between domed nuts "E" as shown in FIG.20.

START/STOP CONTROLS

The start/stop buttons "F" FIG.21, are conveniently situated on front of machine.

ISOLATOR SWITCH (OPTIONAL EXTRA)

A lockable isolator switch can be fitted to the right hand side of the start/stop controls.

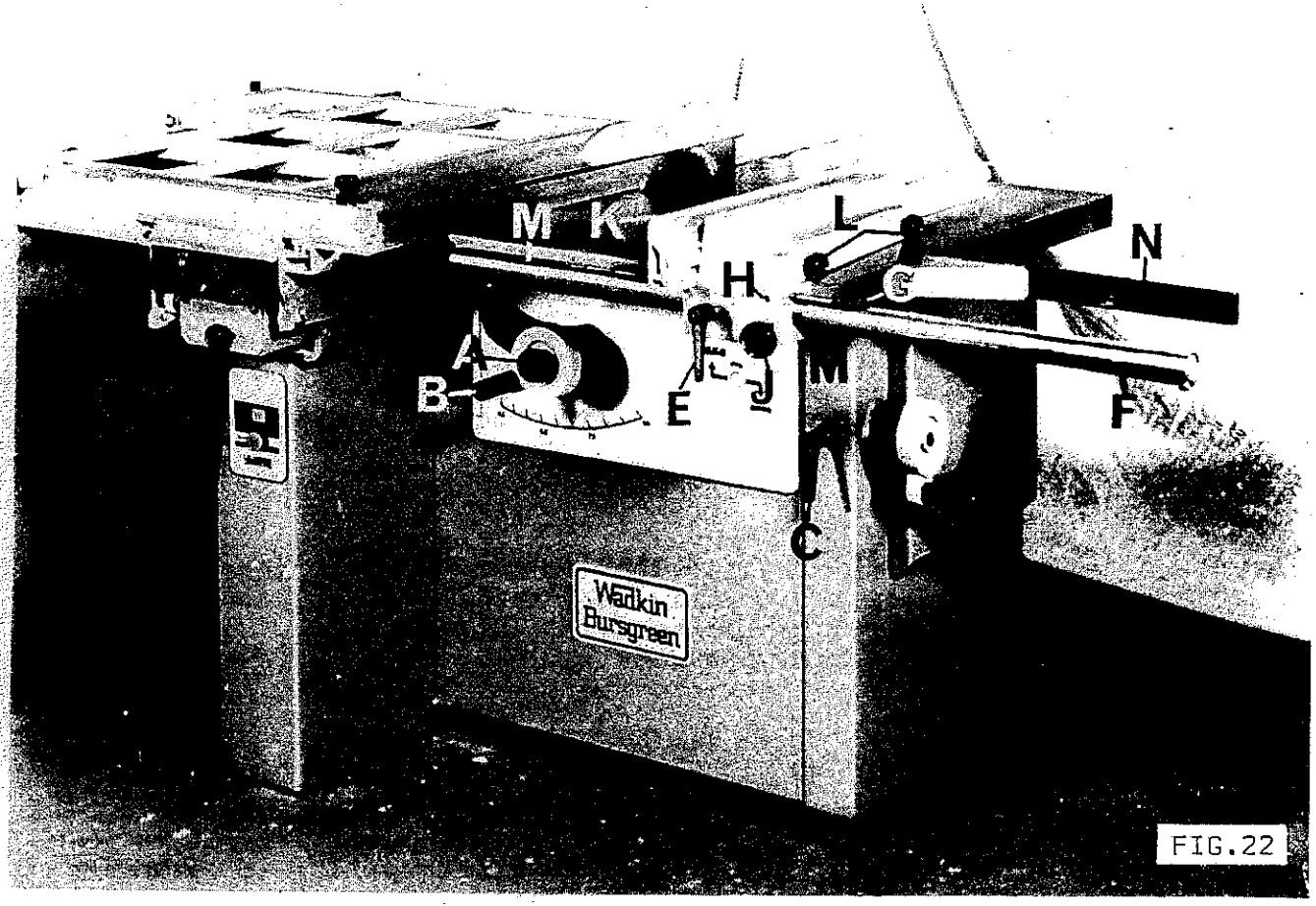


FIG.22

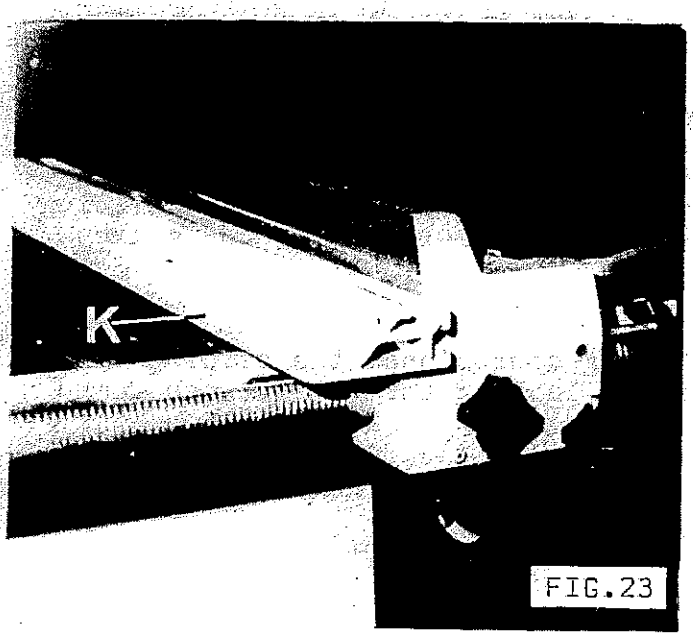


FIG.23

RISE AND FALL CONTROLS

For rise and fall of saw arbor, proceed as follows:-

Release locking handle "A" in FIG.22 and raise or lower the saw arbor by the handwheel "B" to the required position then relock handle "A".

NOTE: Before proceeding to raise or lower saw arbor at 45^{o}, ensure sliding table is moved towards rear of machine.

CANTING CONTROLS

The saw cants 45^{o} to the right with positive stops at 90^{o} and 45^{o}. For canting of saw arbor, proceed as follows:-

Release locking handle "C" in FIG.22 and turn handwheel "D" working in conjunction with the canting scale indicated by the pointer to the required saw position. Relock handle "C".

RIP FENCE CONTROLS

The rip fence slides on a round bar fitted to front of table. Rapid fence adjustment and micro-adjustment are provided with an effective lock.

for rapid fence adjustment, proceed as follows:-

1) Loosen locking handle "E" FIG.22.
2) Position fence where required then turn locking handle "E" to lock fence in position. A ripping capacity scale on fence slide bar "F" is indicated by an adjustable pointer "G" located in the fence body and secured by grubscrew "H".
3) For micro-adjustment, engage spring loaded handwheel "J" in the racked fence slide bar.

Fence Plate Positions

The fence plate "K" in FIG.22 has two positions. Position shown in FIG.22, is for use with deep stock, fence can be moved longitudinally to facilitate this. Position shown in FIG.23, is for use with faced panels, melamine, veneer, etc.

To change the fence plate position, proceed as follows:-

1) Loosen handwheels "L" in FIG.22 the slide fence plate from fence body.
2) Slide fence plate over the two locking plates to position shown in FIG.23, then relock handwheels "L".

Fence Pointer Adjustment

When the fence plate position has been changed as previously described, the pointer "G" in FIG.22, must be reset accordingly.

To reset pointer, proceed as follows:-

1) Loosen locking handle "E" FIG.22, then move fence to a position which would allow a reasonable cut to be taken. Turn locking handle "E" to lock fence in position.
2) Start machine, then feed a piece of timber past the sawblade keeping timber firmly against the fence. Stop machine.
3) Accurately measure the width of timber, then loosen grubscrew "H" and set pointer "G" accordingly. Relock grubscrew "H".

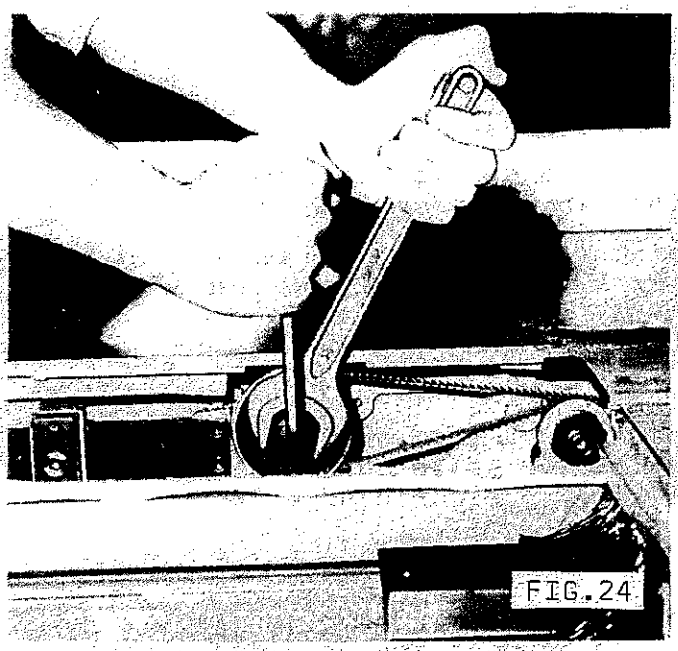


FIG.24

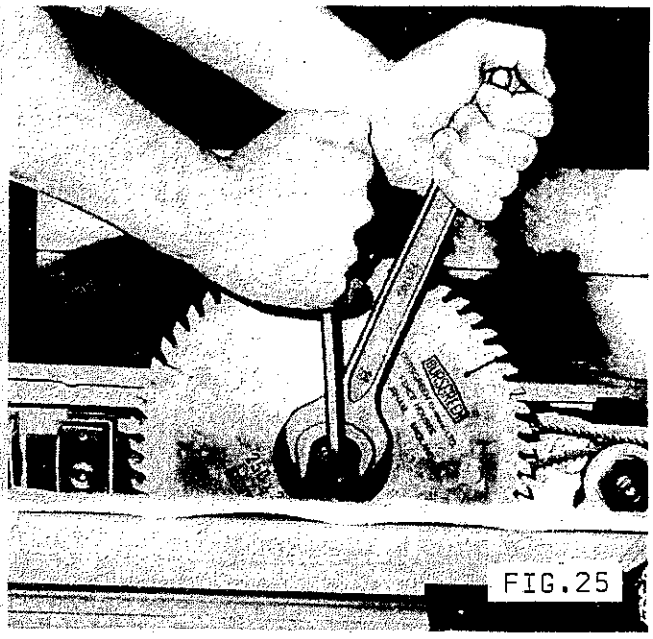


FIG.25

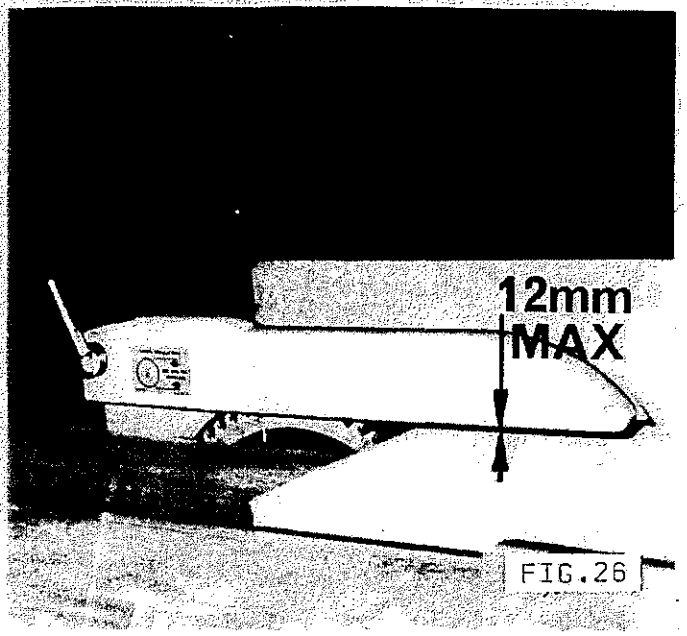


FIG.26

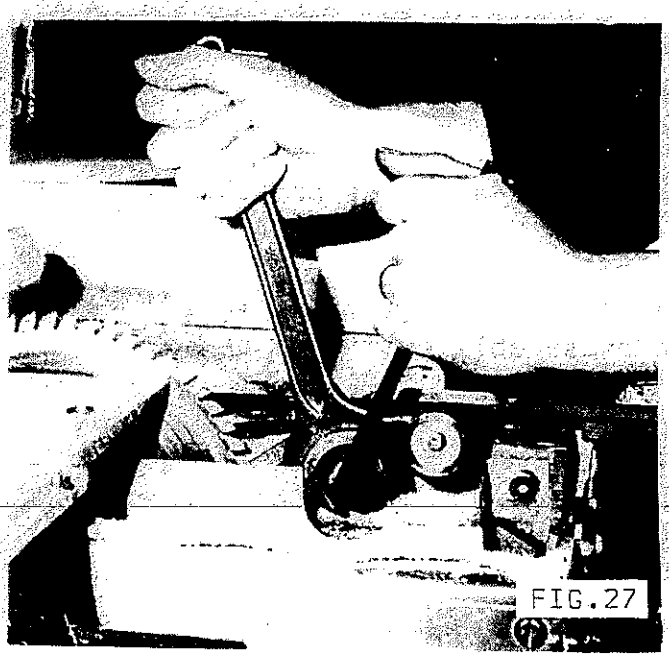


FIG.27

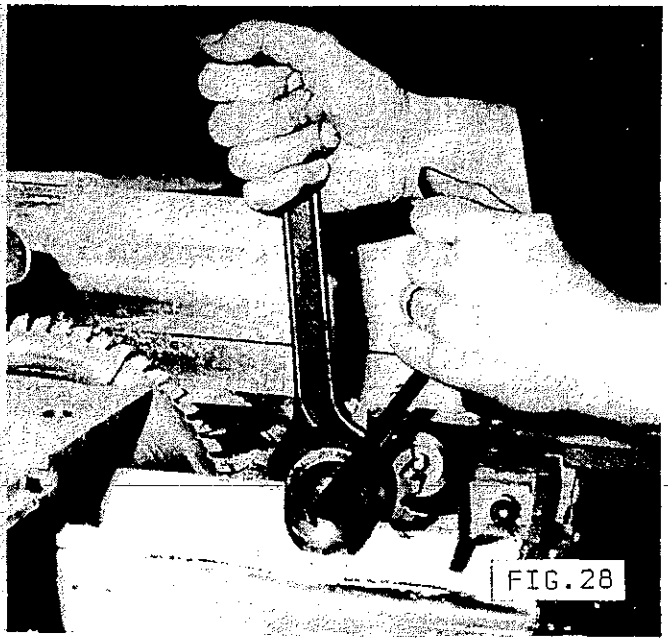


FIG.28

MOUNTING MAIN SAWBLADE

To mount the main sawblade, proceed as follows:-

1) Isolate machine electrically.

2) Move sliding table for access to front of machine and unhook undertable guard.

3) Move saw spindle to uppermost position.

4) Move sliding table for access to main sawblade.

5) Locate 8mm allen key (supplied) in main saw spindle as shown in FIG.24, then remove arbor nut (left hand thread) and front saw flange.

6) Select required blade (254 dia max. if scoring is required) and check blade is free from dirt, gum or sawdust, especially where it will be gripped by saw flanges. Check rear saw flange is clean and fit saw on arbor.

   NOTE: SAW TEETH MUST POINT TOWARDS FRONT OF MACHINE. CHECK FRONT SAW FLANGE IS CLEAN AND FIT ON ARBOR.

   NOTE: IF FLANGES AND SAW ARE NOT CLEAN, THE SAW WILL RUN OUT OF TRUE CAUSING VIBRATION.

7) Lock saw securely in position with arbor nut (left hand thread) as shown in FIG.25.

8) Replace undertable guard.

9) Position sawguard depending on thickness of timber to be worked.

   NOTE: SAW GUARD MUST COVER BLADE AS MUCH AS IS PRACTICABLE. CLEARANCE BETWEEN SAW GUARD AND TIMBER SHOULD NEVER EXCEED 12mm. (WOODWORKING MACHINE REGULATION 1974 16(3), FIG.26.

MOUNTING SCORING SAWBLADE

To mount the scoring sawblade, proceed as follows:-

1) Isolate machine electrically.

2) Remove sliding table guard.

3) Move sliding table for access to front of machine and unhook undertable guard.

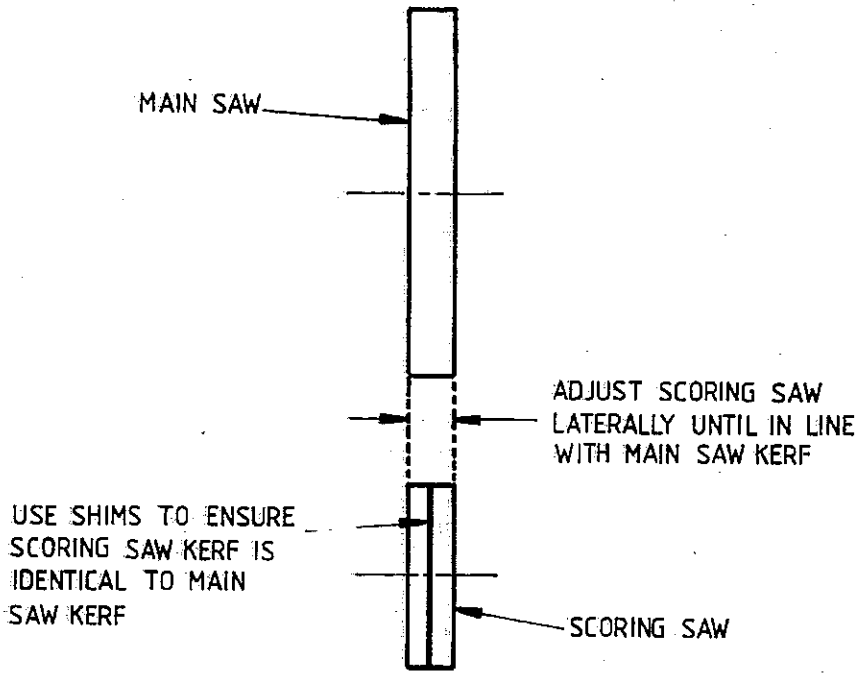
4) Move scoring spindle to uppermost position.

5) Locate 8mm allen key (supplied) in scoring saw spindle as shown in FIG.27 and remove scoring saw nut (right hand thread) with spanner supplied.

6) Fit scoring saw with teeth pointing towards rear of machine FIG.28.

   NOTE: SEE FIG.29 FOR USE OF SHIMS AS FITTED BETWEEN SCORING SAWBLADES FOR CORRECT KERF ALIGNMENT.

7) Replace undertable guard and scorer guard.



PLAN VIEW OF SAWBLADES

FIG.29

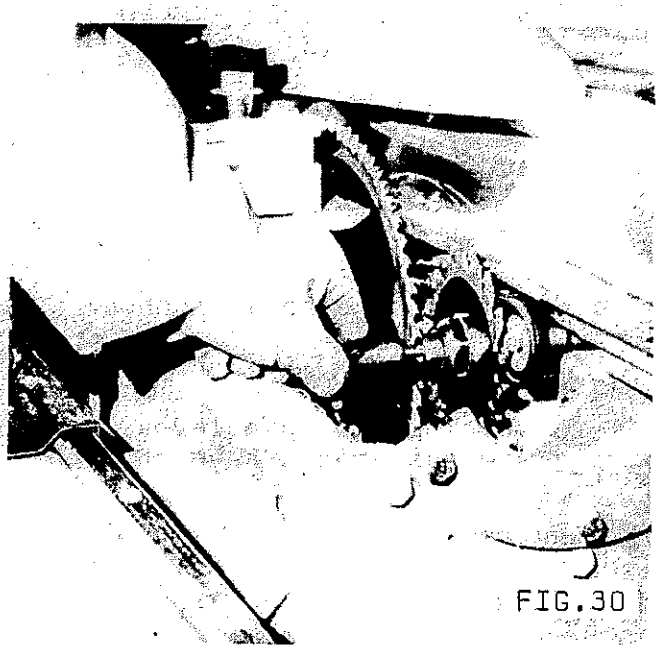


FIG.30

SCORING SAW

Is designed to prevent spelching of all materials including plywood, fibreboard, chipboard, thicker solid plastics and materials having two face layers of veneer, etc.

A twin blade scoring saw must be used and is supplied with 3 shims of 0.010", 0.005" and 0.003" thick. These shims can be positioned between the blades as required to ensure the scoring saw kerf is identical to, or wider than, the main saw kerf.

Scoring saw lateral and vertical adjustments are provided to ensure accurate alignment to thickness of main sawblade so that brittle materials can be cut with perfect finish on upper and lower edges at both sides of cut.

NOTE: SET SCORING SAW VERTICALLY TO ALLOW A MINIMUM SCORE IN MATERIAL TO BE CUT.

SCORING SAW ALIGNMENT TO MAIN SAWBLADE

1) Place a steel rule or similar straight edge across main blade and scoring blade to check approximate lateral alignment.

2) Laterial adjustment to scoring saw blade is by locating 6mm tee wrench (supplied) in scoring saw spindle as shown in FIG.30 and laterally adjust sawblade by turning tee wrench in a clockwise or anticlockwise direction.

3) Vertical adjustment of scoring sawblade is automatically compensated by raising or lowering the main sawblade.

   NOTE: MAXIMUM THICKNESS OF TIMBER WHEN SCORING - 30MM.

4) Proceed to take trial cuts to establish the accuracy of the alignment of the scoring blade with the main blade. The correct alignment is shown in FIG.29.

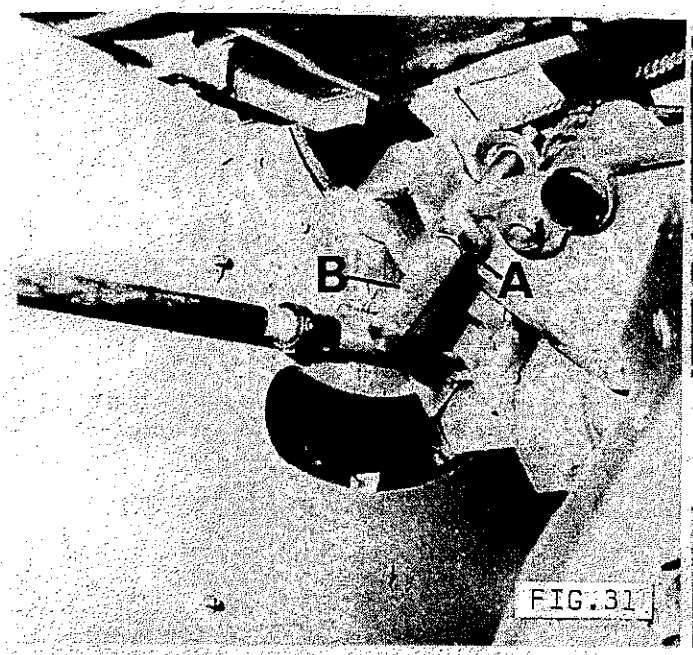


FIG.31

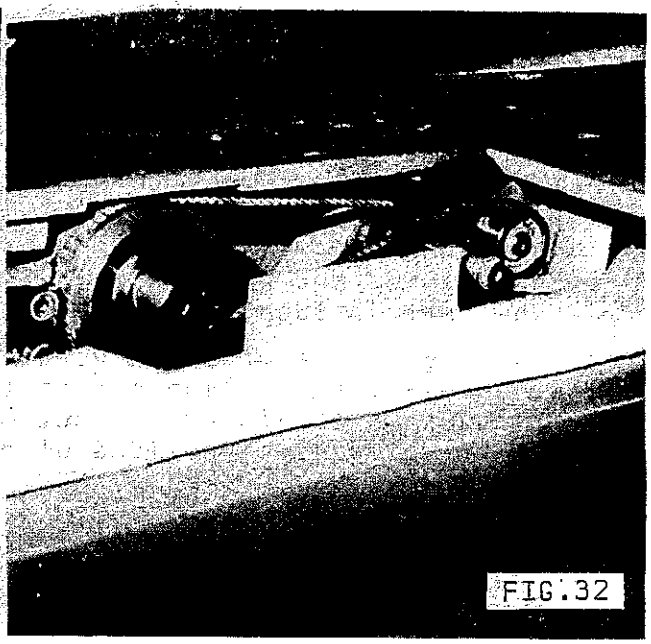


FIG.32

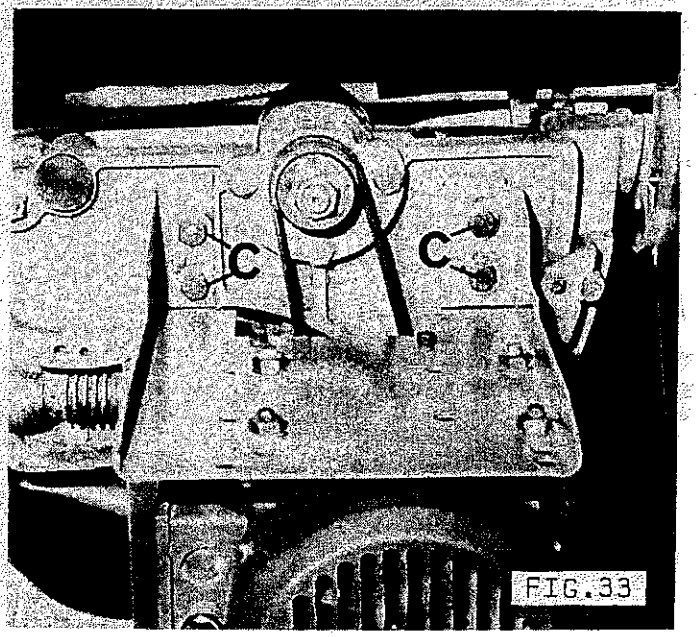


FIG.33

BELT TENSION OR BELT CHANGING ON SCORING SAW

The scoring saw is driven by a 'Poly-Vee' belt from the main saw spindle.

To tension or change belt, proceed as follows:-

1) Isolate machine electrically.
2) Remove both saws as previously described, page 19.
3) Cant saw arbor to 45° as previously described, page 17.
4) Remove door.
5) Release belt tension from inside of machine by loosening locknut "A" with spanner (supplied) FIG.31 and turning handle "B" clockwise.
6) Move sliding table to rear most position and remove old belt from scoring saw tension pulley.
7) Move sliding table to front position and remove belt from main saw flange.

   To fit new belt, proceed as follows:-

   NOTE: REVERSE BELT SO GROOVES ARE ON OUTSIDE.

8) Replace belt over main saw flange as shown in FIGS.32 & 34.
9) Move sliding table to rear most position.

   NOTE: TAKE CARE NOT TO CATCH BELT IN SLIDING TABLE.

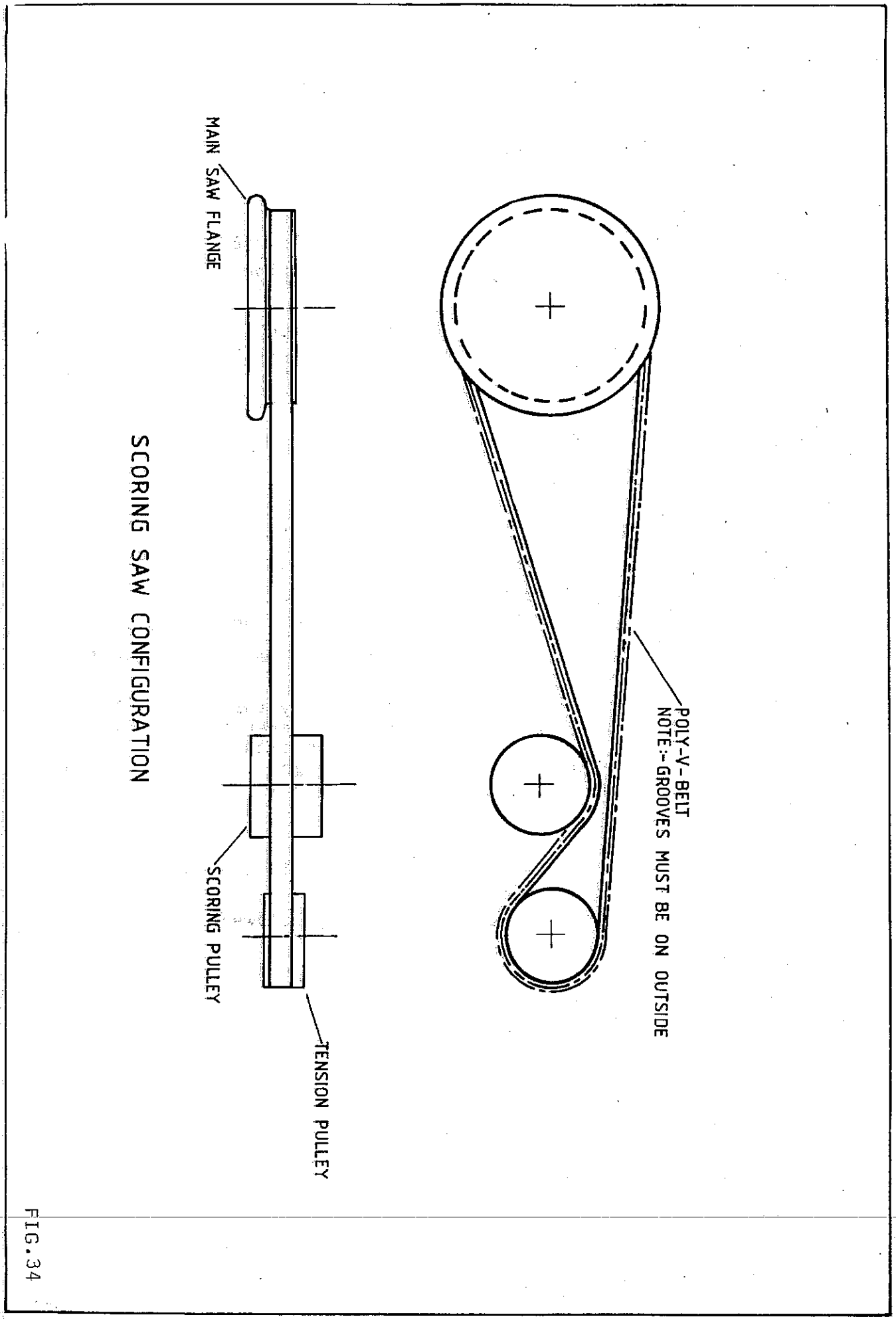
10) Place belt over the top of scoring pulley and round tension pulley as shown in FIGS.32 & 34.
11) Re-tension belt from inside of machine by turning handle "B" anti-clockwise until freeplay has been taken out of belt. Turn handle a further 1/16 of a turn to obtain correct tension, belt should feel reasonably tight. Re-lock locknut "A" with spanner while holding handle "B".

BELT TENSION ON MOTOR

The saw spindle is driven by a 'Poly-Vee' belt from a 2.2kw or 4kw motor giving a speed of 3850 rpm.

To tension or change the belt, proceed as follows:-

1) Isolate machine electrically.
2) Remove access door.
3) Loosen the 4 - M10 hexagon head bolts "C" FIG.33.
4) Move motor until belt is tensioned.
5) Relock hexagon head bolts.
6) Replace access door.



SCORING SAW CONFIGURATION

FIG. 34

SAFETY SECTION

All safety precautions should be taken to comply with relevant safety regulations, i.e. Woodworking Machine Safety Regulations 1974 No. 903 (Great Britain). Always adjust the riving knife and guard to protect as much of the saw as is possible. The adjustments have been previously described.

Do not use sawblades at higher than recommended speed. When changing sawblades, belts or any other maintenance etc., always isolate the machine electrically. Use a wood push stick as FIG.39 much as practicable when feeding timber, to avoid accidents.

SAWBLADES

For best results, we recommend the purchase of sawblades from Wadkin (Durham).

Sawblades available for scoring (kerf to be 3.2mm).

250mm diameter x 20mm bore TCT sawblade B-S-337
105mm diameter x 20mm bore TCT split scoring sawblade B-S-247

Other sawblades available:-

305mm diameter x 20mm bore alloy rip sawblade B-S-281
305mm diameter x 20mm bore alloy crosscut sawblade B-S-284
254mm diameter x 20mm bore alloy rip sawblade B-S-278
254mm diameter x 20mm bore alloy crosscut sawblade B-S-276

254mm diameter x 20mm bore TCT sawblade for ripping B-S-293

NOTE: 254mm DIAMETER MAXIMUM SAWBLADE WHEN SCORING IS REQUIRED.

305mm diameter x 20mm bore TCT sawblade for ripping B-S-345

NOTE: FOR USE ONLY WHEN 3.7kw (5HP) MOTOR IS FITTED.

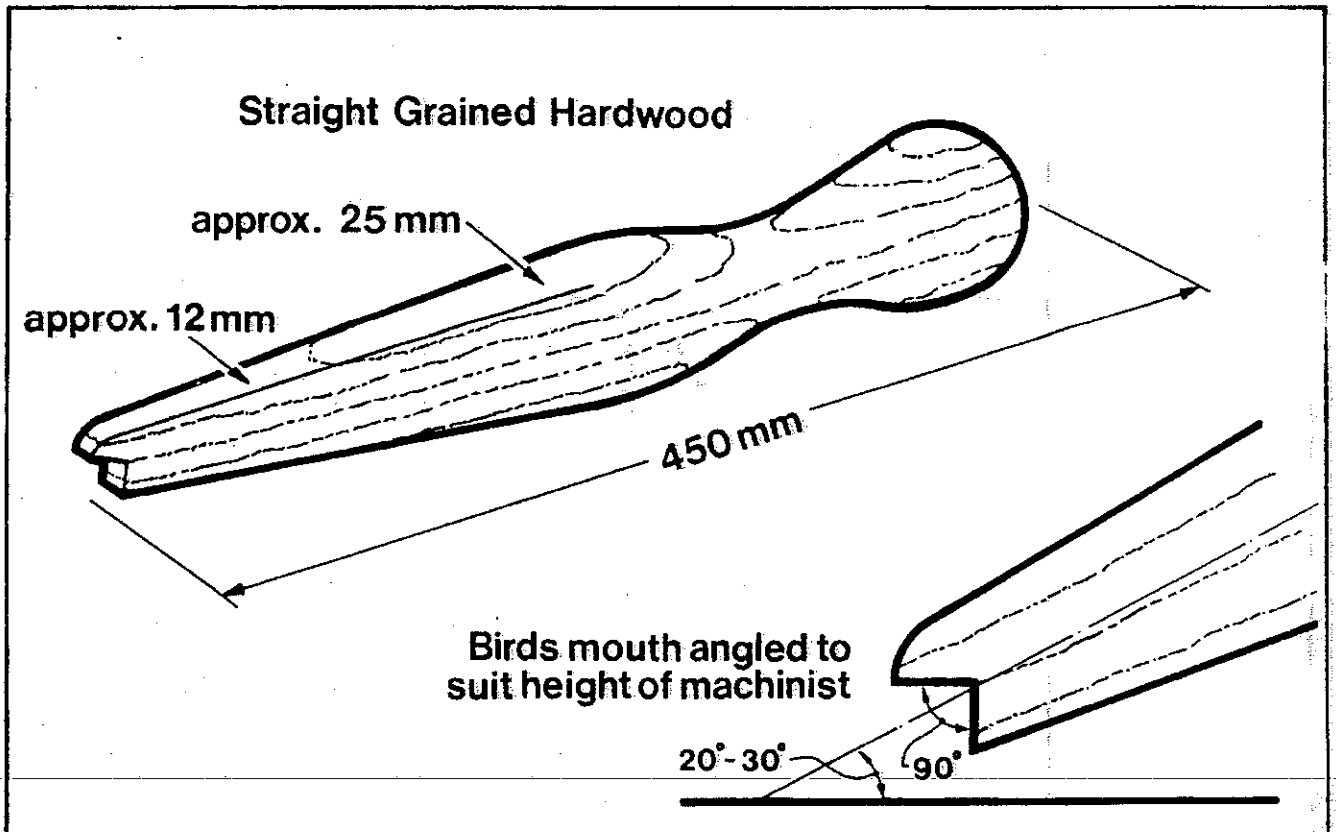


FIG.39

Application	APPROVED LUBRICANTS					
	Castrol	B.P.	Shell	Esso	Texaco/Caltex	Wadkin
Worm Boxes	ZN220	Energol CS320	Vitrea 320	Spartan EP220	Regal Oil 320	L2
General Lubrication	Magna 68	Energol HP68	Vitrea 68	Nuray	Ursa Oil P68	L4
Pneumatic Lubricators	Hyspin AWS32	Energol HL32	Tellus 37	Nuto H32	Rando Oil HD32	
Grease	Spheerol AP3	Energrease L53	Alvania R3	Beacon 3	Regal Starfak Premium 3	L6
Brake Cables	Brake Cable grease	Energrease L21M	Alvania R3	Esso Multi-purpose grease		

MACHINE PARTS LIST

INDEX

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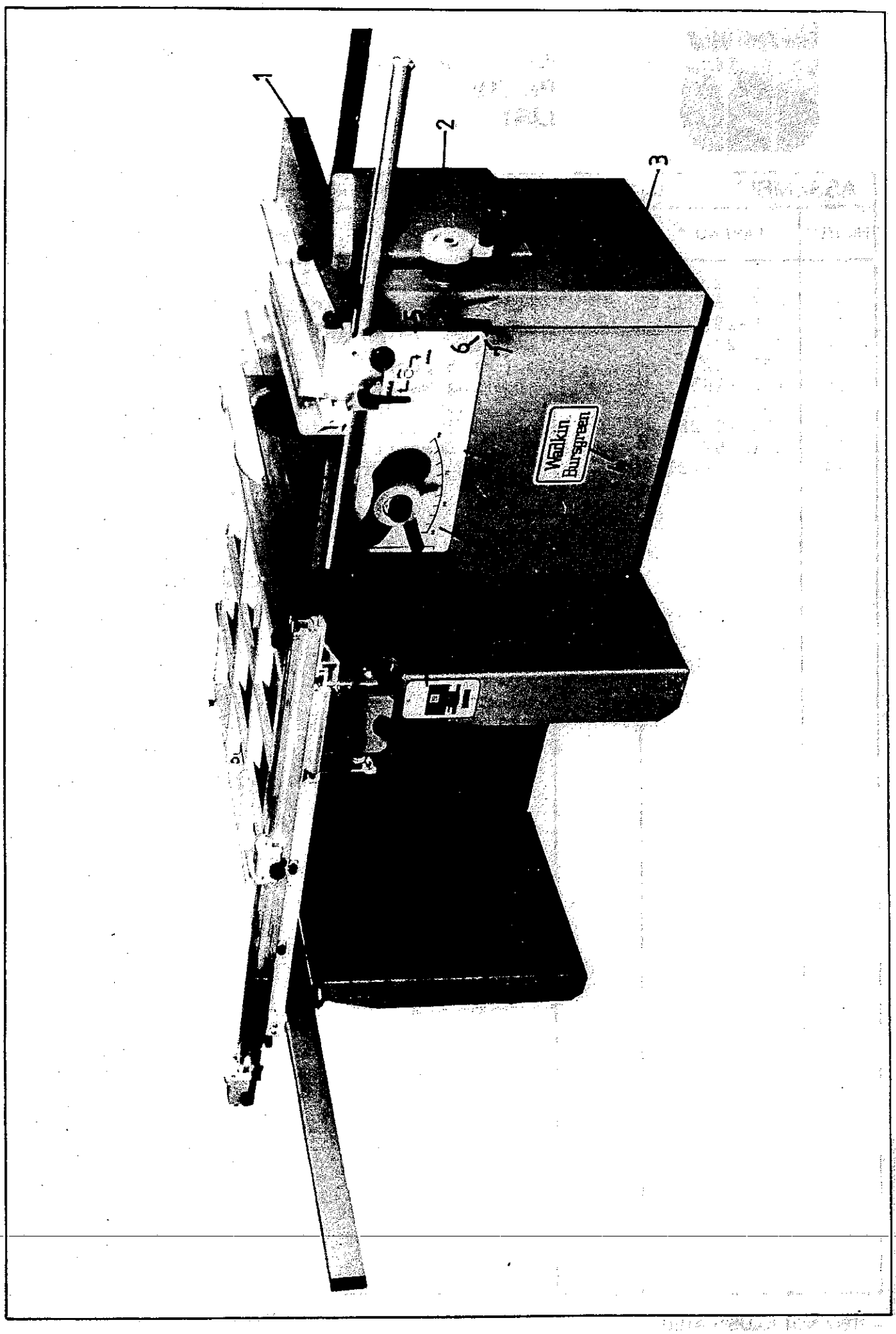
ILLUSTRATED PARTS LIST

ASSEMBLY:- BASE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
1	SP12-157	1	Main Table
2	S25-601	1	Side Door for Base
3	SP12-117	1	Base
4	C-S-348	1	Nameplate
5	SP12-154	2	Extrusion for Nameplate
6	BEL-52	4	Cap for Corner Moulding
7	BEL-51	4	Corner Moulding
8	SP12-155	2	Extrusion for Nameplate
9	SP12-119	1	Control Plate
10	K51-16-155	1	MEM 647 ADS/F Starter 415-3-50 2.2kw
	K51-16-154	1	MEM 637 ADS/F Starter 380-3-50 2.2kw
	K51-16-156	1	MEM 817 ADS/F Starter 220-3-50 2.2kw
	K51-16-158	1	MEM 847 ADS/F Starter 415-3-50 4kw
	K51-16-160	1	MEM 1237 ADS/F Starter 380-3-50 4kw
	K51-16-161	1	MEM 1627 ADS/F Starter 220-3-50 4kw

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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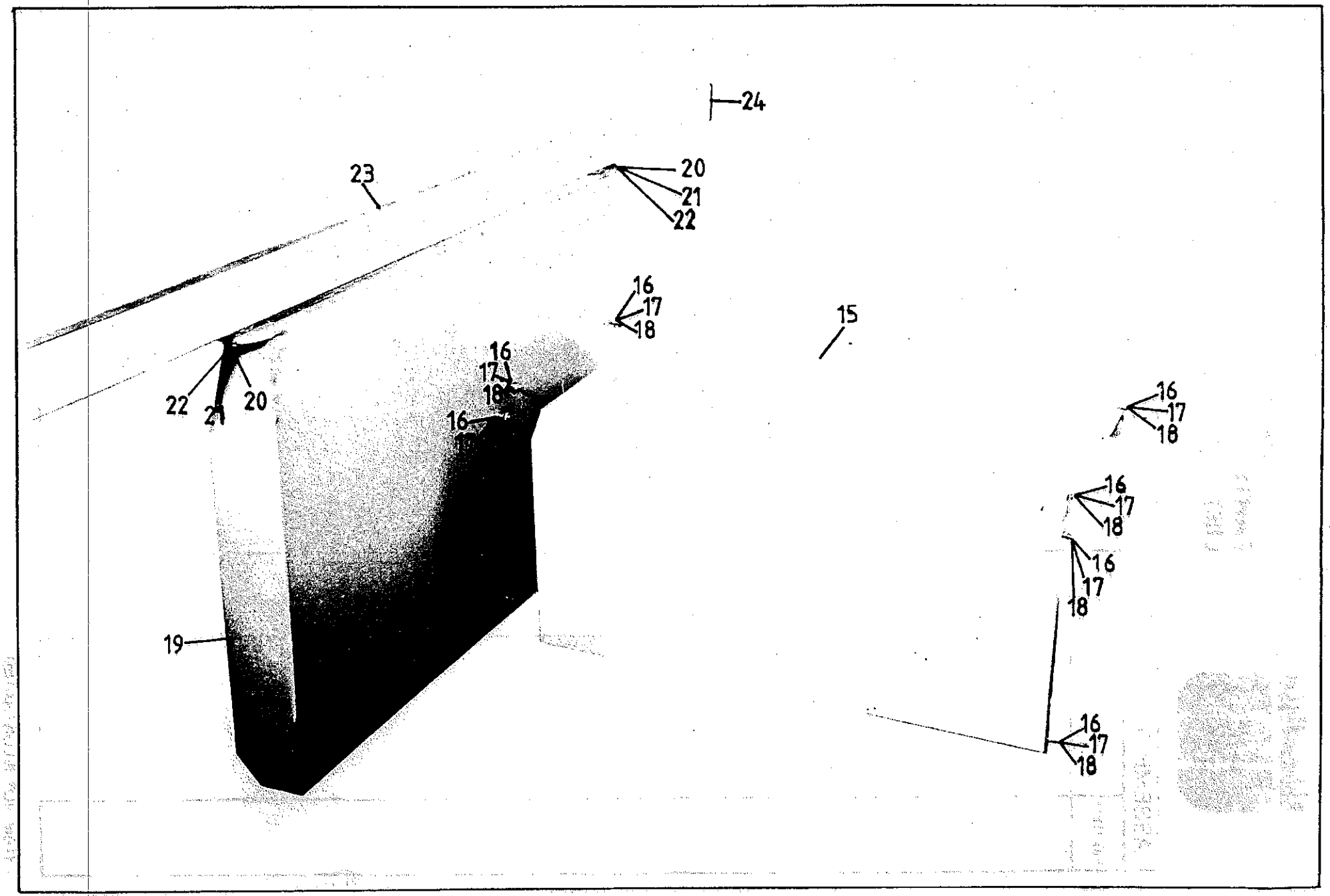
ILLUSTRATED PARTS LIST

ASSEMBLY:- OUTER SUPPORT FOR OUTRIGGER TABLE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
15	CP12-2	1	Tie Piece
16	K05-26-233	8	Studs for Tie Piece
17	K05-28-103	8	8mm Washers
18	K05-27-102	8	M8 Nuts
19	SP12-120	1	Outer Support
20	1070-193	2	Packing Washers
21	K05-27-103	2	M10 Nuts
22	K05-26-263	2	M10 x 30 Long Studs
23	SP12-67	1	Outer Support Rail
24	K51-61-181	2	Ribbed Inserts

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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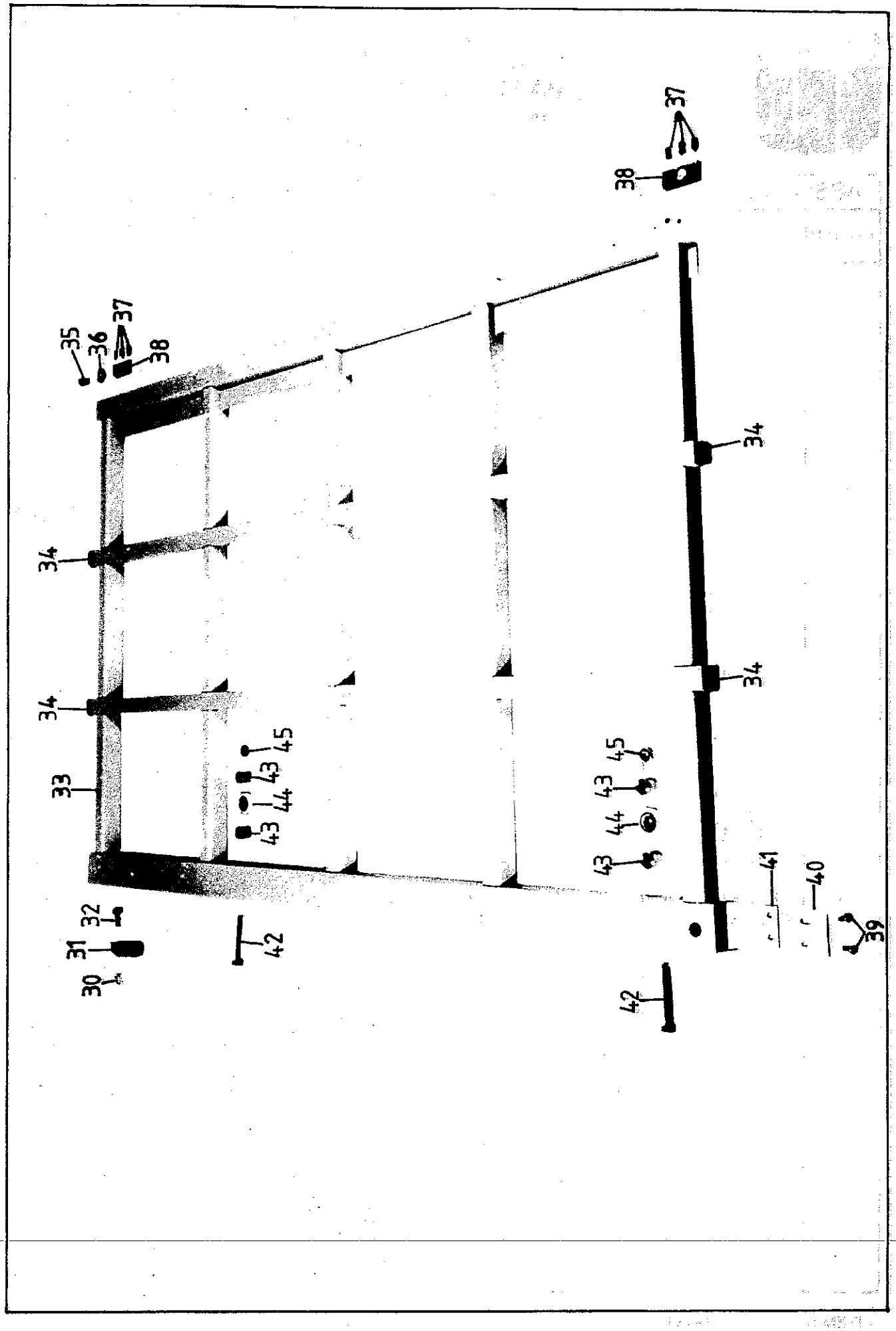
ILLUSTRATED PARTS LIST

ASSEMBLY:- OUTRIGGER TABLE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
30	KO5-27-152	1	M10 Aerotight Nut
31	S25-418	1	Knock Down Stop
32	KO5-25-530	1	M10 x 25 Long Hexagon Set Screw
33	SP12-158	1	Outrigger Table
34	K51-61-112	4	A2822 Blanking Plugs
35	KO5-25-515	1	M8 x 16 Long Hexagon Set Screw
36	1041-88	1	Washer
37	KO5-26-127	6	M8 x 16 Long Socket Set Screws
38	SP12-53	2	Shoes for Outrigger
39		4	M6 x 12 Long Pan Head Screws
40	SP12-69	2	Felt Wiper for Outrigger
41	SP12-76	2	Trapping Plate for Wiper
42	KO5-25-538	2	M10 x 70 Long Hexagon Set Screws
43	SP12-55	4	Bearing Distance Pieces
44	KO6-30-402	2	0.4705.00 CGR Rollers
45	KO5-27-103	2	M10 Nuts

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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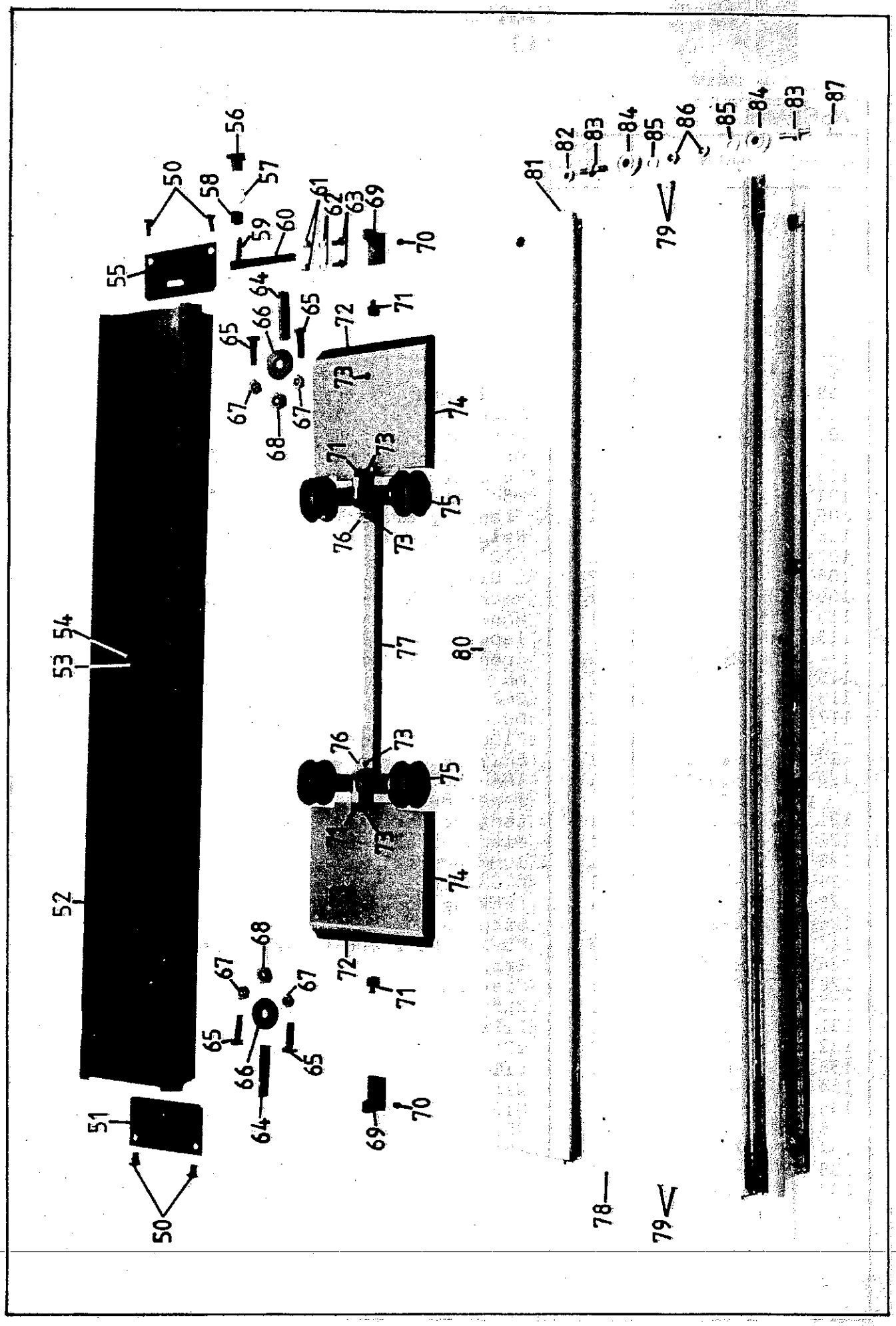
ILLUSTRATED PARTS LIST

ASSEMBLY:- SLIDING TABLE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
50		4	M10 x 20 Long Socket Button Head Screws
51	CP32-19	1	End Plate for Beam
52	SP12-6	1	Beam
53	CP12-20	1	Stop for Beam
54		2	M8 x 20 Long Socket Capscrews
55	CP32-18	1	End Plate for Beam with Lock
56	K51-27-127	1	M8 Locking Knob
57	1041-88	1	Washer
58	DL-735	1	Spacer
59		1	M8 x 40 Long Stud
60	P32-49	1	Locking Plunger
61		2	M8 Domed Nuts
62		2	8mm Washers
63		2	M8 x 12 Long Countersunk Machined Screws
64		2	M16 x 80 Long Studs
65	P32-286	4	Beam Adjusting Screws
66	1014-201	2	Washers
67		4	M12 Nuts
68		2	M16 Nuts
69	CP32-118	2	Stops for Sliding Table
70		2	M8 x 20 Long Socket Set Screws
71	BRA-69	4	Rubber Stops
72	SP12-205	2	Brushes for Sliding Table
73		6	M6 x 10 Long Socket Button Head Screws
74	SP12-204	2	Covers for Carriage
75	CP32-16	2	Diablo Rollers
76	CP32-116	3	Trapping Brackets for Diablo
77	SP12-13	1	Carriage
78	CP12-13	1	Rear End Plate for Sliding Table
79		4	M6 x 25 Long Hexagon Set Screws
80	SP12-113	1	Sliding Table
81	CP12-12	1	Front End Plate for Sliding Table
82		4	M10 Locknuts
83	SP12-72	8	Eccentric Pins for Undertable Roller
84	K06-30-402	8	CGR Roller 0.4705.00
85		8	10mm Washers
86		8	M10 Nuts
87		4	M10 Domed Nuts
–	SP12-80	2	Shoes for Scorer Guard
–	SP12-79	1	Front Scoring Sawguard
–	SP12-159	1	Rear Scoring Sawguard

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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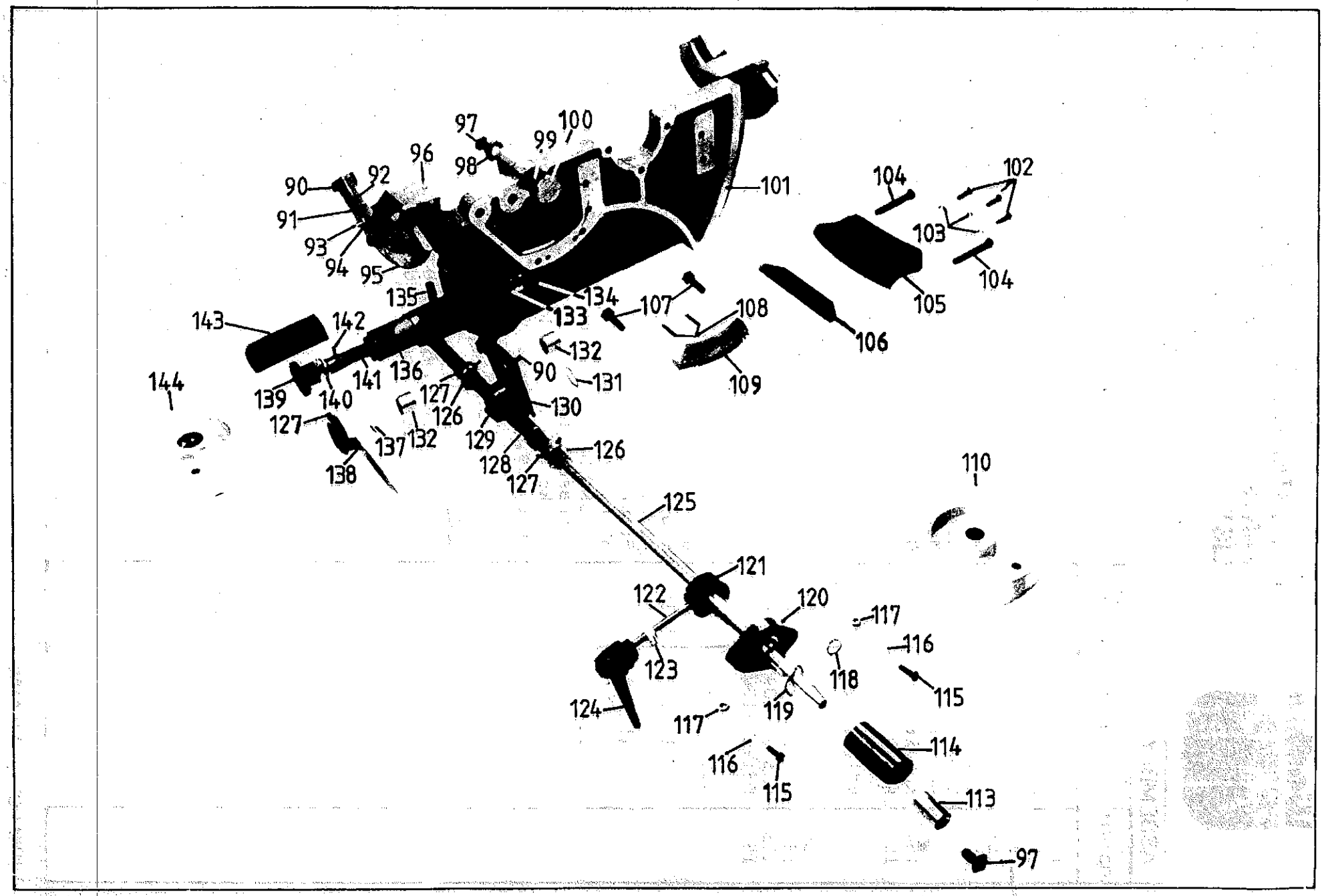
ILLUSTRATED PARTS LIST

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES

ASSEMBLY:- RISE AND FALL AND TRUNNION

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
90		8	M8 x 20 Long Hexagon Set Screws
91	S25-7	2	Trunnion Trapping Plates
92		4	6 Dia x 12 Long Groverlok Dowels
93		2	M8 x 16 Long Nicked Brass Grubscrews
94		2	M8 Locknuts
95	S25-3	2	Trunnion Slides
96	SP12-7	1	Trunnion Bracket
97		2	M10 x 20 Long Countersunk Socket Screws
98	SP12-39	1	Washer for Rise and Fall Pivot
99	K51-88-800	3	EPL26 Bump Washers
100	SP12-38	1	Rise and Fall Pivot
101	SP12-8	1	Rise anf Fall Slide
102		3	M6 x 20 Long Hexagon Set Screws
103		3	M6 Locknuts
104		2	M8 x 55 Long Hexagon Set Screws
105	S25-571	1	Trapping Bracket
106	S25-570	1	Retaining Strip
107		2	M10 x 30 Long Hexagon Set Screws
108		2	6 Dia x 30 Long Groverlok Dowels
109	S25-14	1	Racked Quadrant for Rise and Fall
110	K51-27-208	1	Handwheel
113	BEL-24	1	Tapered Bush for Handwheel
114	SP12-136	1	Spacer for Canting Handwheel
115		2	M6 x 16 Long Hexagon Set Screws
116		2	6mm Washers
117		2	M6 Nuts
118	K51-10-405	1	7100-016 External Circlip
119	K51-88-808	1	EPL25 Bump Washer
120	K06-30-413	1	INA FLCTE 16 Flanged Bearing with RHP SLF16 Inner Bearing
121	1073-127	1	Canting Lock Bush
122		1	M10 x 90 Long Stud
123	K51-66-153	1	10mm Grommet
124	K51-27-191	1	M10 Bristol Locking Handle
125	SP12-137	1	Canting Screw
126	CP32-25	2	Stop Nuts
127		5	M6 x 6 Long Socket Set Screws
128	CP32-26	1	Stop Collar
129	CP32-37	1	Rise and Fall Nut
130	S25-613	1	Canting Nut Pivot Plate
131	K51-10-407	1	7100-025 External Circlip
132	K51-05-115	2	20 x 25 x 20 Oilite Bush
133	K06-04-131	1	51104 Trust Race
134	S25-458	1	Worm
135		1	M12 x 30 Long Dog Point Socket Screw
136	S25-46	1	Rise and Fall Screw Bearing Shaft
137	1057-127	1	Thrust Washer
138	S25-660	1	Canting Pointer
139	K51-27-139	1	M10 Locking Knob
140	1069-293	1	Handwheel Washer
141	SP12-141	1	Rise and Fall Shaft
142		2	5 Dia x 30 Long Groverlok Dowels
143	SP12-40	1	Sleeve for Rise and Fall Shaft
144	S25-678	1	Handwheel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ILLUSTRATED PARTS LIST

ASSEMBLY:- SAWDRIVE MOTOR

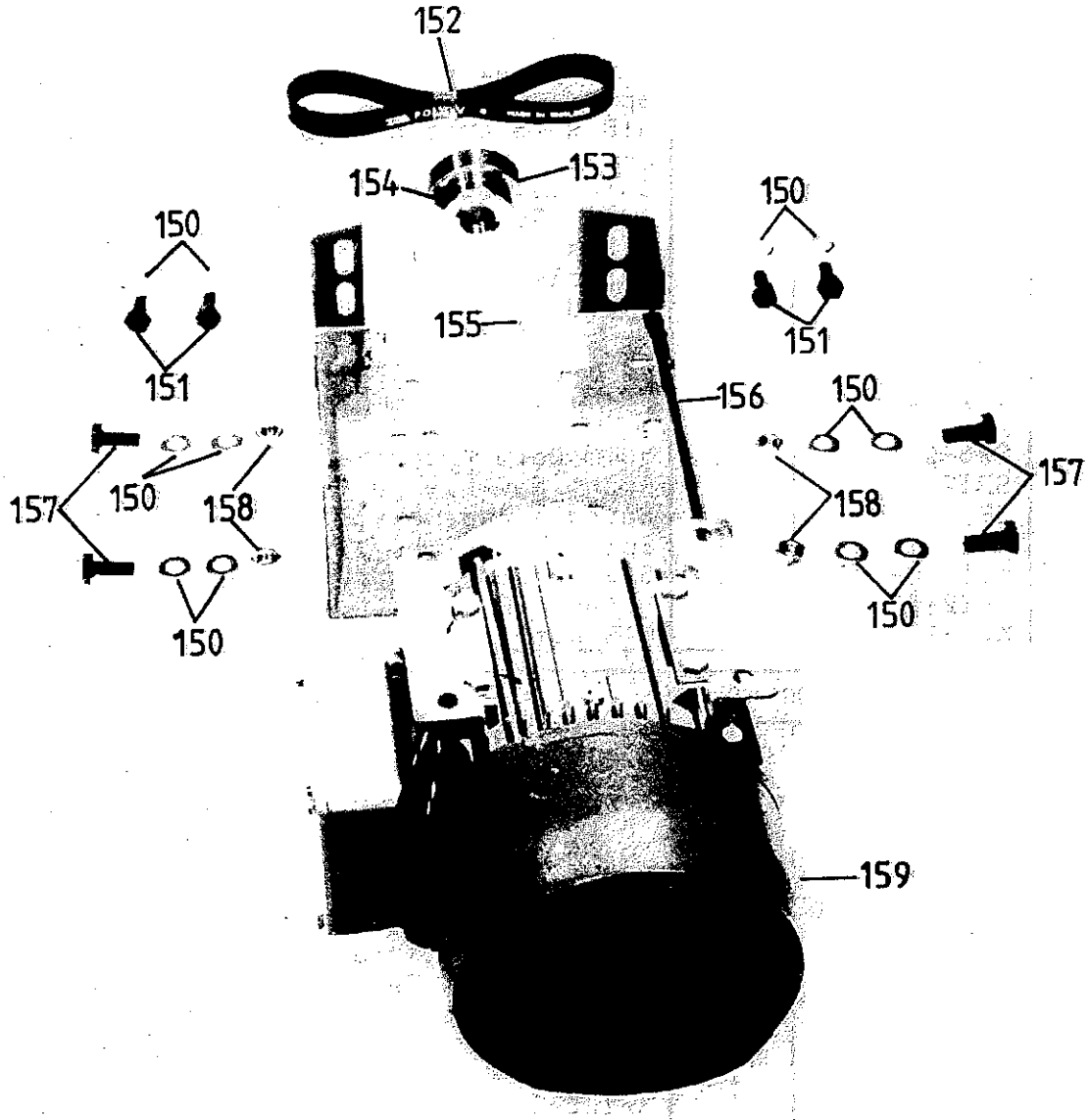
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
150	K05-25-104	12	10mm Washers
151	K05-25-530	4	M10 x 25 Long Hexagon Set Screws
152	K51-04-503	1	220 J8 Poly V Belt
153	SP12-44	1	Motor Pulley (2.2kw 50 cycle 3 PH and 1 PH)
	SP12-46	1	Motor Pulley (4kw 50 cycle)
	SP12-45	1	Motor Pulley (3HP 60 cycle 3 PH and 1 PH)
	SP12-47	1	Motor Pulley (5.5HP 60 cycle)
154	K05-26-126	2	M8 x 12 Long Socket Set Screws
155	K51-20-110	1	8 x 7 x 32 Long Feather Key (50 cycle 2.2kw) (60 cycle 3HP)
	K51-20-113	1	8 x 7 x 40 Long Feather Key (50 cycle 4kw) (60 cycle 5.5HP)
156	S25-238	1	Motor Platform
157	K05-25-531	4	M10 x 30 Long Hexagon Set Screws
158	K05-25-104	4	M10 Nuts
159	K51-15-108	1	Brooks D90S, Foot Mounted TEFC 2.2kw, 3000rpm 50 cycle motor
	K51-15-133	1	Brooks D100L, Foot Mounted TEFC 4kw, 3000rpm 50 cycle motor
	K51-15-117	1	Brooks D90S, Foot Mounted TEFC 3HP, 3000rpm 60 cycle motor
	K51-15-141	1	Brooks D100L, Foot Mounted TEFC 5.5HP,3000rpm 60 cycle motor
	K51-15-461	1	Brooks D90L, Foot Mounted TEFC 2.2kw, 3000rpm 1 phase motor
	K51-15-471	1	Brooks D90L, Foot Mounted TEFC 3HP, 3000rpm 60 cycle, 1 phase motor

NOTE

When ordering replacement motors, state Kw/HP, Volts, Phase and Cycle

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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ILLUSTRATED PARTS LIST

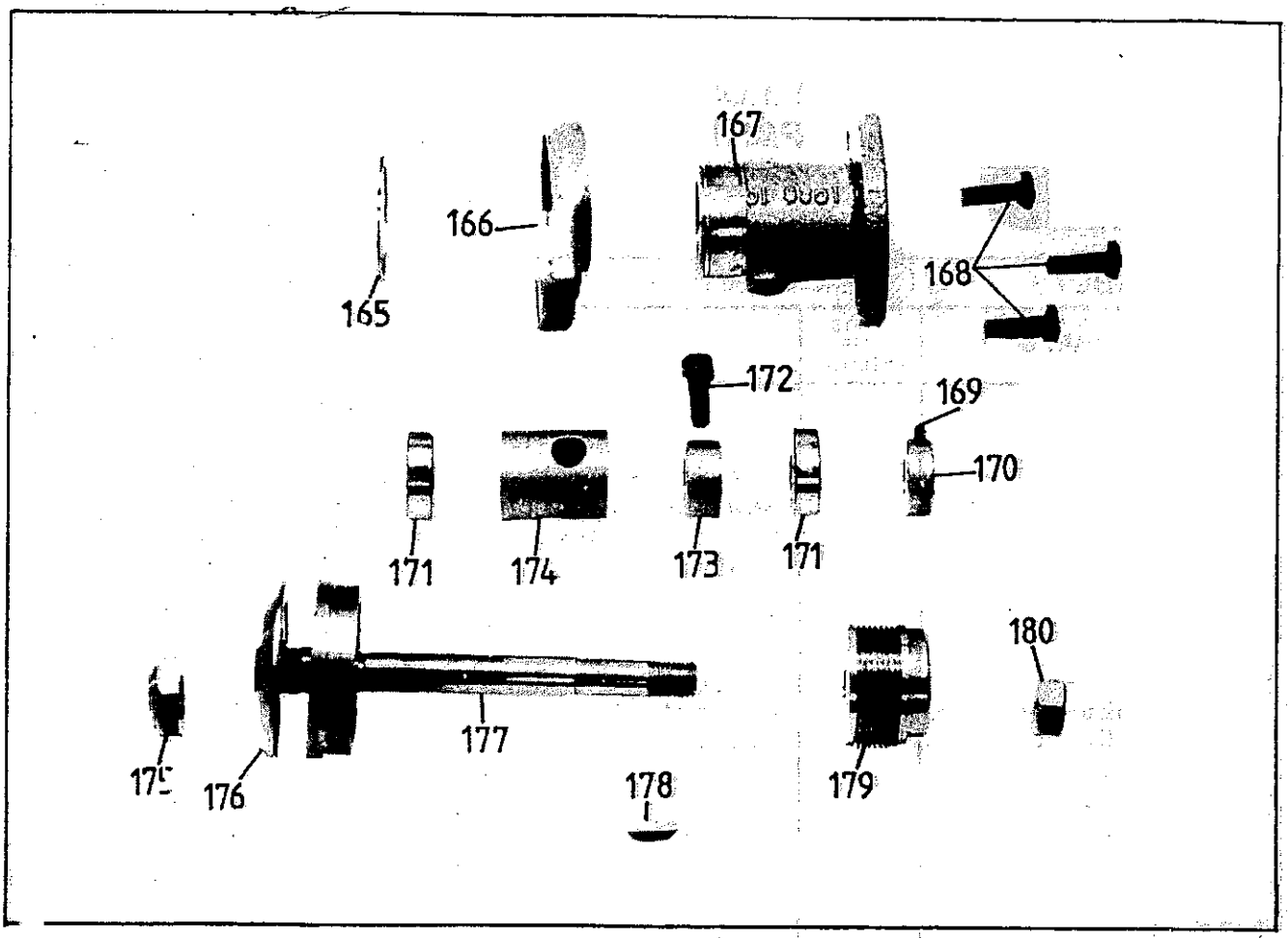
* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES

ASSEMBLY:- MAIN SAW SPINDLE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
165	K51-10-304	1	5100-225 External Circlip
166	S25-550	1	Riving Knife Pivot Bracket
167	S25-101	1	Spindle HOusing
168	K05-25-530	3	M10 x 25 Long Hexagon Set Screws
169	K05-26-114	2	M6 x 10 Long Socket Set Screws
170	S25-41	1	Spindle Locking Collar
171	K06-01-192	2	6203-2RS Bearings
172	K05-25-209	1	M10 x 25 Long Socket Capscrew
173	S25-394	1	Spindle Trapping Collar
174	S25-40	1	Spindle Distance Piece
175	SP12-42	1	Saw Spindle Nut (20mm Spindle)
	SP12-196	1	Saw Spindle Nut (1" Spindle)
176	SP12-107	1	20mm, 1" and 25mm Bore Front Saw Flange (20mm Spindle)
	S25-98	1	30mm Bore Front Saw Flange (20mm Spindle)
	SP12-195	1	Front Saw Flange (1" Spindle)
177	SP12-57	1	Spindle Assembly (20mm Spindle)
	SP12-192	1	Spindle Assembly (1" Spindle)
178	K51-20-176	1	5 x 22 Long Woodruff Key
179	SP12-43	1	Spindle Pulley
180	K05-25-105	1	M16 Nut

ASSEMBLY:- SCORING SAW

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
183	K51-27-141	1	M12 Blind Handwheel
184		1	M12 Nut
185		1	12mm Washer
186	SP12-151	1	Tension Spindle
187	K51-10-201	2	7000-028 Internal Circlips
188	SP12-182	1	Scoring Saw Tension Pulley
189	K06-01-107	1	6001-2RS Bearing
190		1	8mm Washer
191		1	M8 x 12 Long Socket Button Head Screw
192	K51-10-404	1	7100-015 External Circlip
193	K51-88-807	2	EPL 11 Bump Washers
194	K06-01-149	2	6002-2RS Bearings
195	SP12-23	1	Bearing Spacer
196	K51-10-413	1	7100-018 External Circlip
197	SP12-206	1	Scoring Saw Spindle
198	K51-10-402	1	7000-032 Internal Circlip
199	SP12-139	1	Scoring Saw Pulley
200	SP12-118	1	Washer
201	1041-76	1	Scoring Saw Nut
202	K51-61-161	1	Plastic End Tip
203	SP12-207	1	Bot for Scoring Spindle Lock
204		1	M12 x 20 Long Plain Cup Socket Set Screw
205		1	M12 Locknut
206	K51-04-509	1	260 J4 Poly 'V' Belt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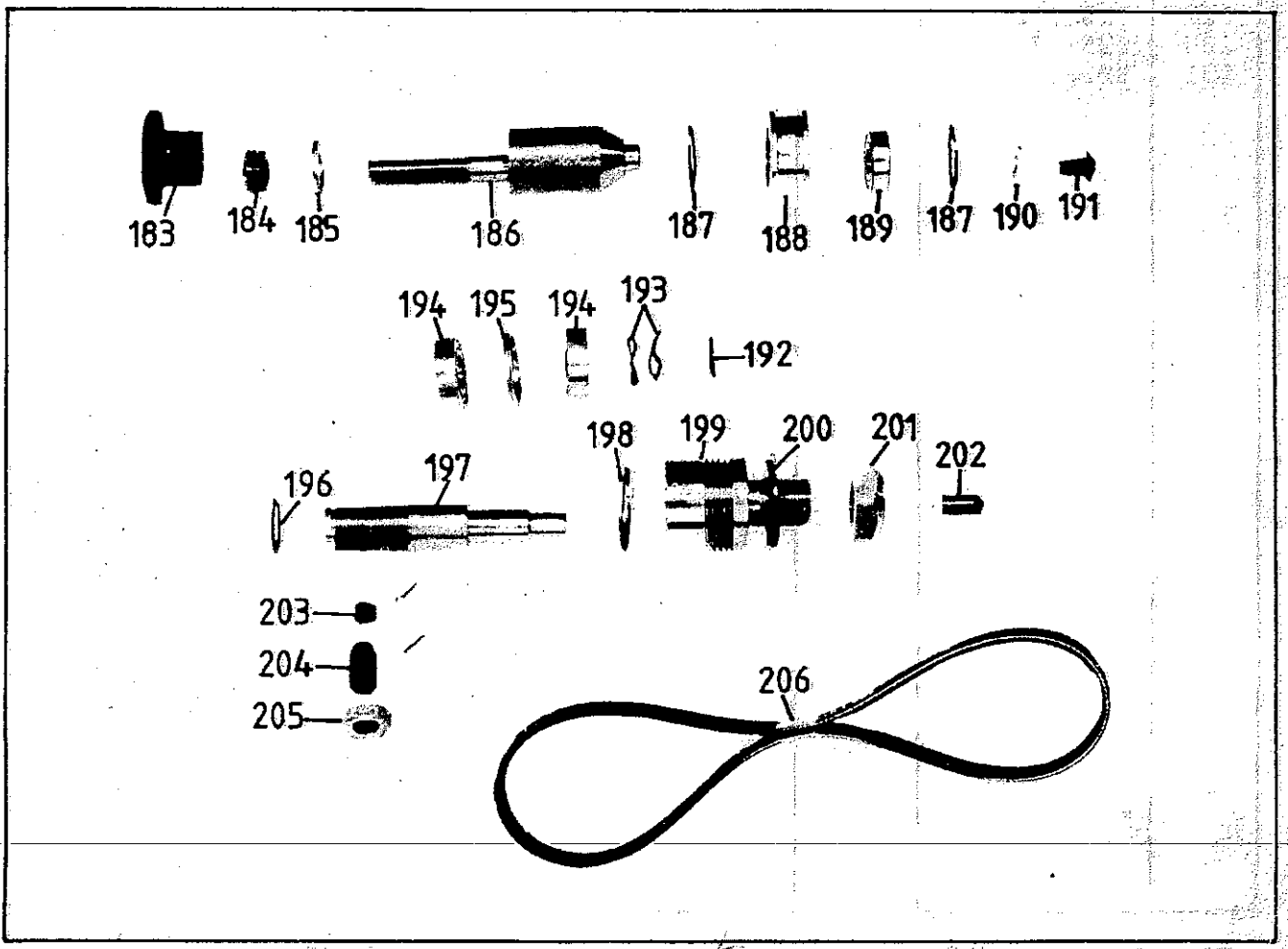
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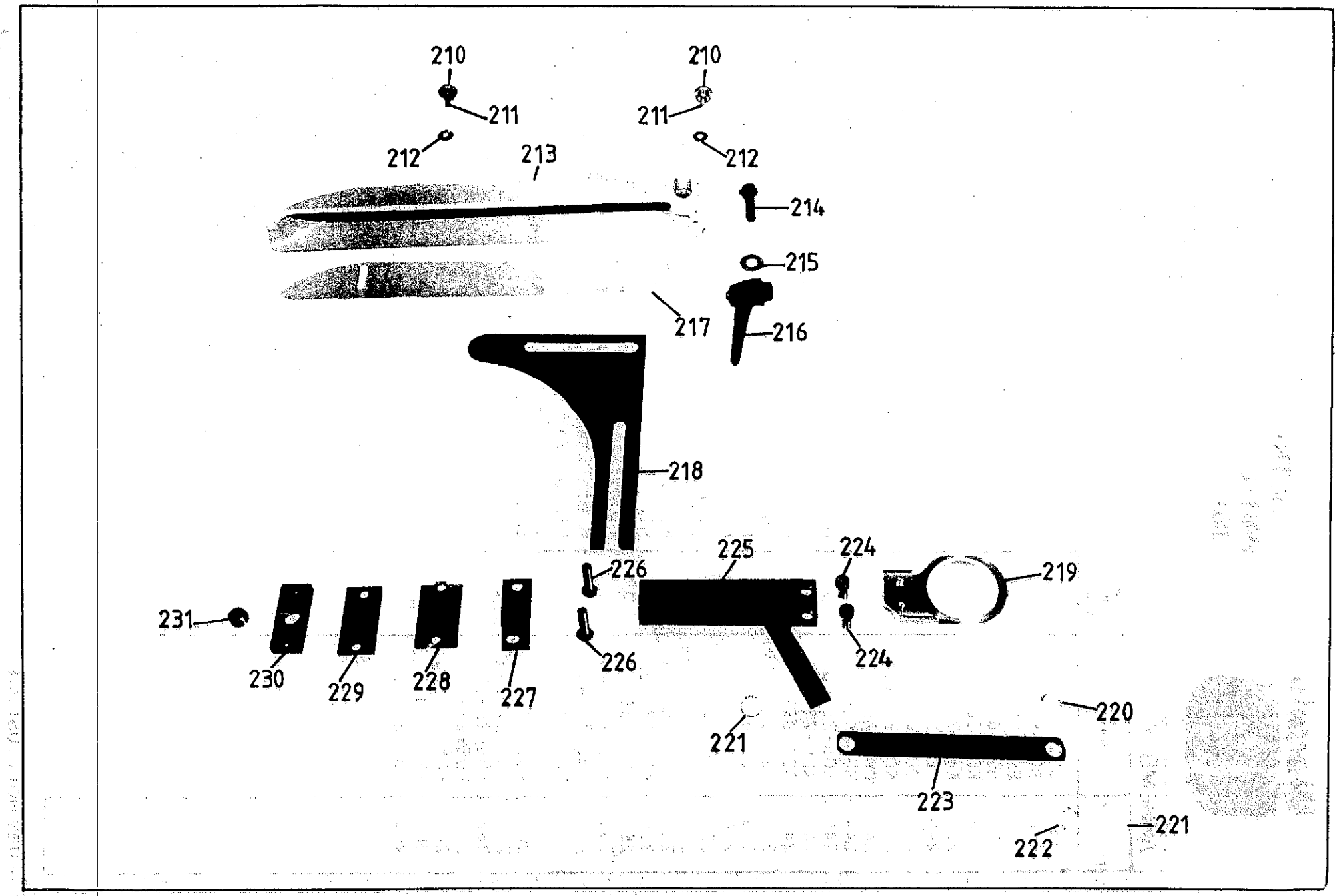
ILLUSTRATED PARTS LIST

ASSEMBLY:- RIVING KNIFE AND SAWGUARD

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
210	SP12-163	2	Locking Knobs for Sawguard Visor
211		2	M6 x 16 Long Studs
212	K51-19-163	2	6mm Fibre Washers
213	SP12-64	1	Sawguard
214	K05-25-533	1	M10 x 40 Long Hexagon Set Screw
215	1069-293	1	Washer
216	K51-27-191	1	M10 Adjusting Handle
217	SP12-162	1	Sawguard Visor
218	S25-358	1	Riving Knife
219	S25-550	1	Riving Knife Pivot Bracket
220	S25-376	1	Locknut
221	K51-10-403	2	7100.012 External Circlip
222	S25-552	1	Link Plate Pivot Pin
223	S25-363	1	Rise and Fall Link Plate
224	K05-25-187	2	M8 x 20 Long Socket Capscrews
225	S25-551	1	Slide Plate for Riving Knife
226		2	M8 x 35 Long Socket Button Head Screws
227	S25-369	1	Rear Clamp Plate
228	S25-359	1	Riving Knife Guide Plate
229	S25-368	1	Pressure Plate
230	S25-370	1	Front Clamp Plate
231	S25-537	1	Clamp Screw

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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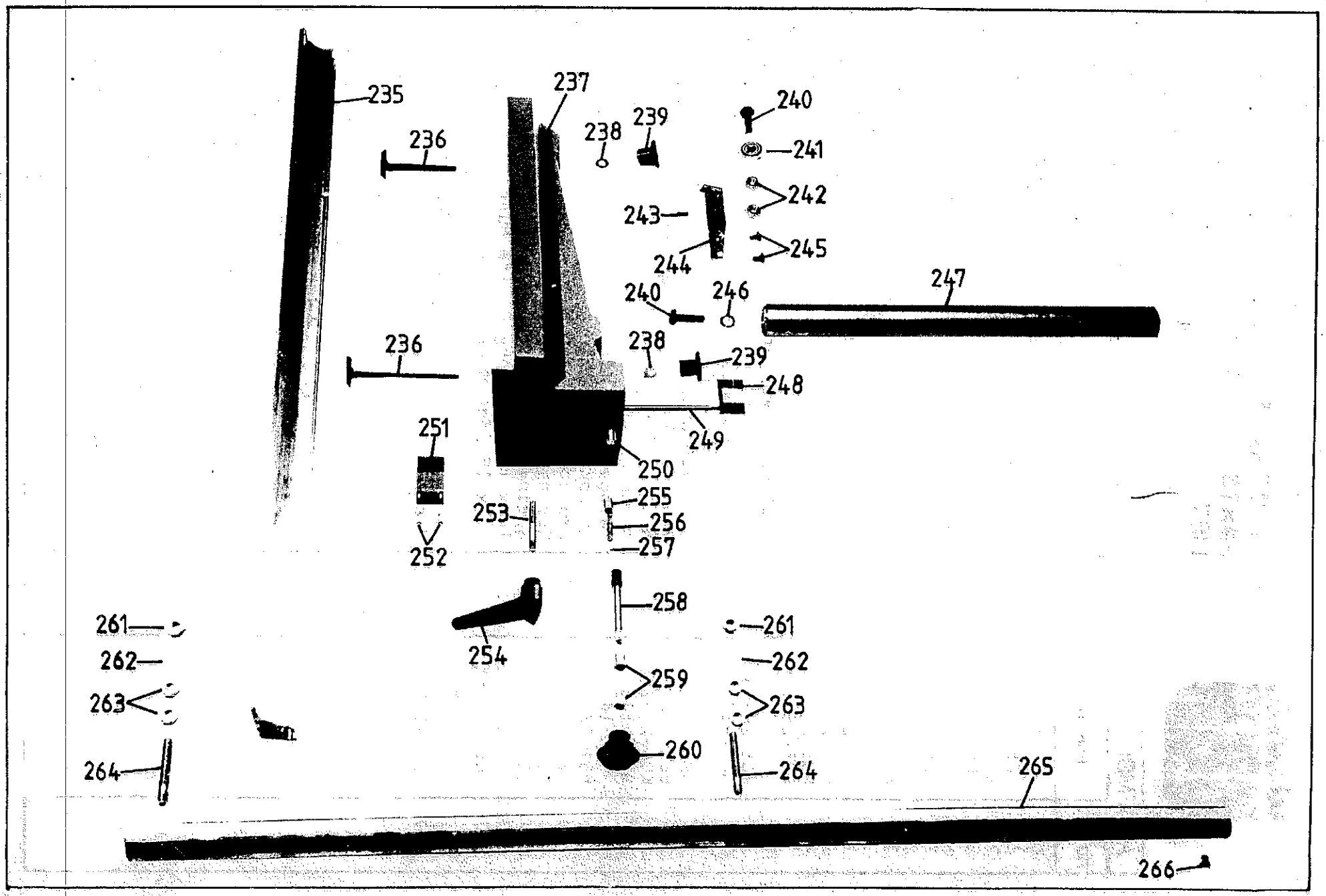
ILLUSTRATED PARTS LIST

ASSEMBLY:- RIP FENCE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
235	S25-114	1	Rip Fence Front Plate
236	S25-532	1	Stud for Rip Fence Front Plate 90mm Long
	S25-596	1	Stud for Rip Fence Front Plate 120mm Long
237	S25-624	1	Rip Fence
238	K05-28-103	2	8mm Washers
239	K51-27-127	2	M8 Locking Knobs
240	K05-25-531	2	M10 x 30 Long Hexagon Set Screw
241	K06-30-402	1	0.4705.00 CGR Roller
242	K05-27-103	2	M10 Nuts
243	K05-26-116	1	M6 x 16 Long Socket Set Screw
244	S25-605	1	Rip Fence Roller Spring
245	K05-25-500	2	M6 x 10 Long Hexagon Set Screw
246	K05-28-104	1	10mm Washer
247	S25-652	1	Rip Fence Support Bar
248	S25-60	1	Pointer
249	S25-638	1	Pointer Bar
250		1	M10 x 25 Long Brass Machine Screw
251	S25-64	1	Locking Plate
252		2	5 Dia x 12.7 Long Pop Rivets
253	K05-26-269	1	M10 x 60 Long Stud
254	K51-27-191	1	M10 Adjusting Handle
255	S25-635	1	Pinion Spring Retainer
256	K51-73-140	1	ETS18 Compression Spring
257	K06-30-408	1	6 Dia Steel Ball
258	S25-634	1	Pinion for Rip Fence
259	K51-05-103	2	9 x 14 x 14 Long Oilite Bush
260	K51-27-137	1	8mm Plain Handwheel
261	K05-27-103	2	M10 Nuts
262	K05-25-104	2	10mm Washers
263	K05-27-110	4	M10 Locknuts
264	K05-26-270	2	Stud for Fence Bar
265	P32-329	1	Rip Fence Bar
266	K05-25-163	1	M6 x 10 Long Socket Capscrew

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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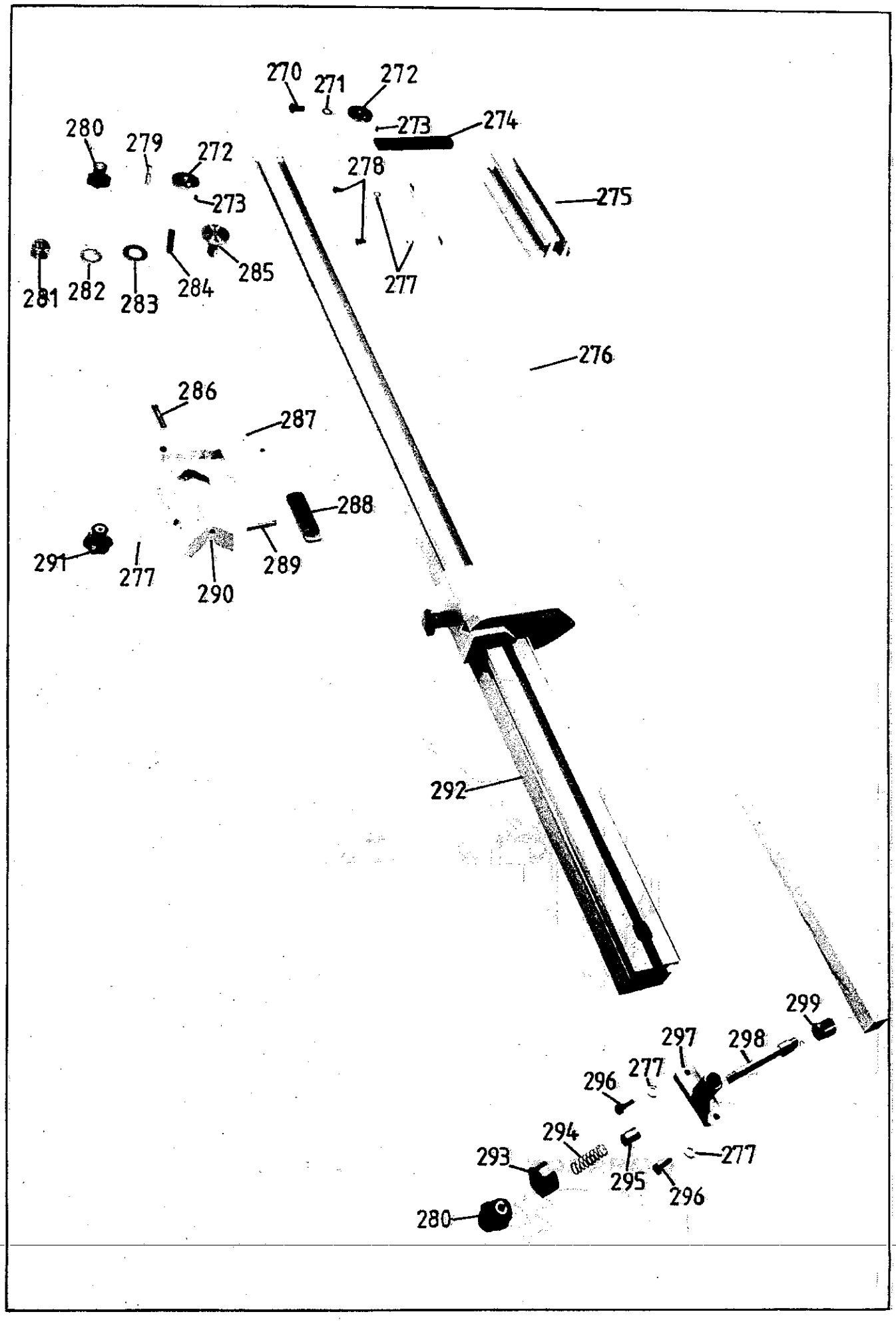
ILLUSTRATED PARTS LIST

ASSEMBLY:- CROSSCUT FENCE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
270	K05-25-516	1	M8 x 20 Long Hexagon Set Screw
271	K05-28-103	1	8mm Washer
272	1073-347	2	Locking Boss for Extension
273	K05-26-112	2	M6 x 6 Long Socket Set Screws
274	S25-418	1	Extension Support
275	S25-413	1	Fence Extension
276	S25-425	1	Extension Stop Bar
277	K05-28-102	6	6mm Washers
278	K05-25-163	2	M6 x 10 Long Socket Capscrews
279	K05-26-234	1	M8 x 30 Long Stud
280	K51-27-127	2	M8 Locking Knobs
281	K05-27-154	1	M16 Aerotight Nut
282	K05-28-106	1	16mm Washer
283		1	5/8" Brass Washer
284	K05-26-142	1	M10 x 35 Long Socket Set Screw
285	SP12-37	1	Pivot for Crosscut Fence
286		2	10 x 40 Long Fluted Dowels
287	SP12-146	2	Turnover Stop
288	BEL-102	2	Shoe for Turnover Stop
289	K05-26-208	2	M6 x 45 Long Stud
290	SP12-148	1	Turnover Stop Bracket RH
	SP12-149	1	Turnover Stop Bracket LH
291	K51-27-126	2	M6 Locking Knobs
292	S25-625	1	Crosscut Fence
293	1041-157	1	Spring Distance Piece
294	1041-158	1	Spring for Locking Plunger
295	K51-05-105	1	10 x 14 x 16 Long Oilite Bush
296	K05-25-165	2	M6 x 16 Long Socket Capscrews
297	1041-156	1	Fence Locking Plunger
298	1041-155	1	Plunger
299	1041-160	1	Bush for Sliding Table

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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MAINTENANCE

GENERAL

1) Regularly clear chips and dust from inside of machine.

2) Clean saw spindles from time to time with resin solvent and lightly oil.

3) To stop sawdust sticking to the rails of double roller carriage, wipe over with a rag soaked in diesel.

SETTING SAW TO RIVING KNIFE

The saw and riving knife are preset at works and require no adjusting unless spindle bearings have been changed or saw is cutting out of line, proceed as follows:-

1) Loosen the socket head capscrew "A" in FIG.35 with 8mm allen key (supplied with machine) and tap spindle (with hide face hammer) as required, taking care not to damage the threads on spindle ends.

   Place a steel rule along both sides of riving knife to check that saw is central.

2) When set, re-tighten the socket head capscrew.

3) To check this setting, feed a short piece of timber from the rear, along both sides of the riving knife. If riving knife is set correctly, the blade will cut equal shoulders as shown in FIG.36A and when set incorrectly, unequal shoulders as shown in FIG.36B.

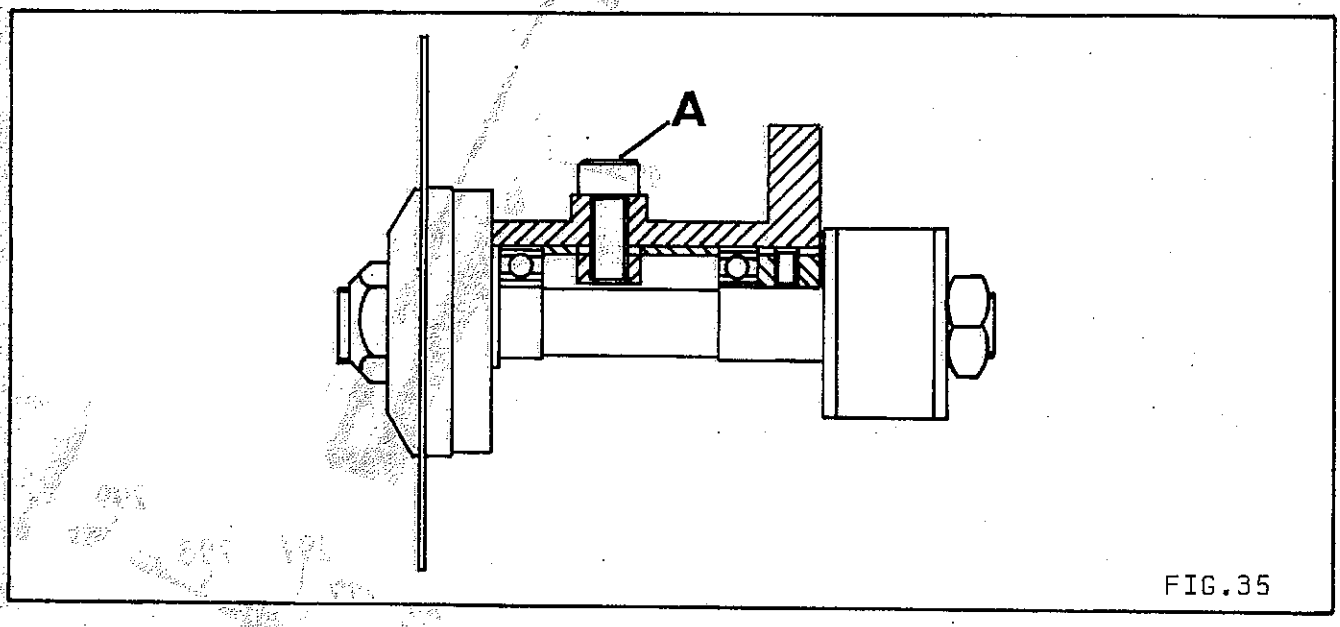

FIG.35

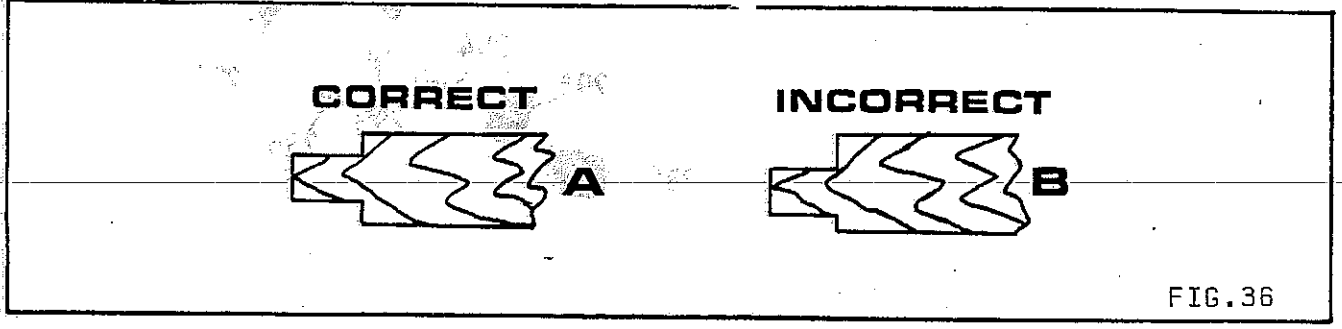

FIG.36

All machines leave our factory with all fences etc., precisely set, should any of these settings require adjustments at a later date, proceed as follows:-

Rip Fence Alignment FIG.37

Loosen locknuts on the outer of the two bolts holding the rip fence bar, reset locknuts and retighten in new position, retighten nut behind main table.

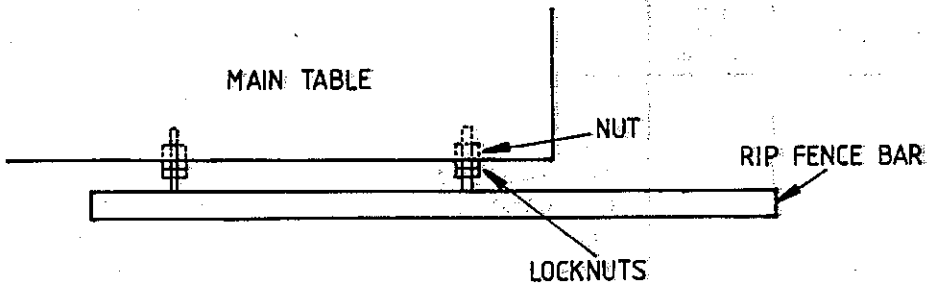

FIG.37

Crosscut Fence Squareness FIG.38

The crosscut fence is held by a spring loaded plunger on the sliding table and a pivot pin on the outrigger table. To adjust fence if out of square, loosen 4 socket set screws in shoes holding outrigger table to sliding table. Check adjustment till square and relock socket set screws

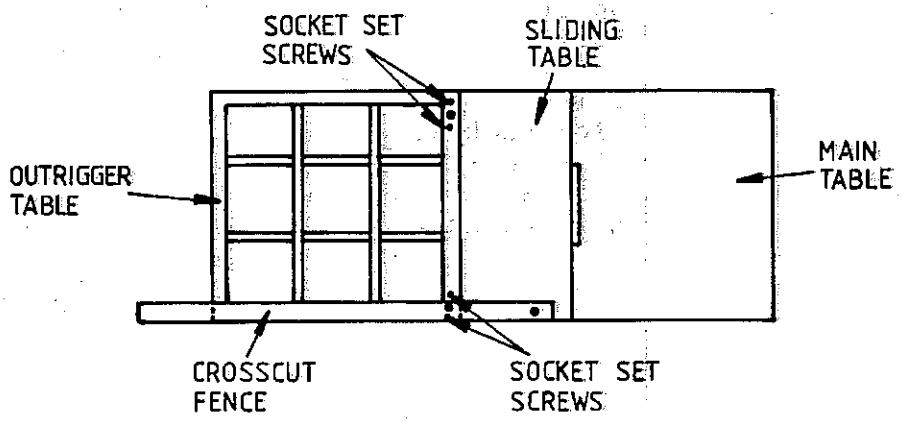

FIG.38

Breakout of Panels

1) Blunt or incorrect sawblades.
2) Scoring saw not in correct alignment to main sawblade refer to page 21 for correct alignment.
3) Scoring using rip fence. Scoring should be done using sliding table.
4) Riving knife misalignment.

IMPORTANT: On no account should adjustments be made to sliding table settings.

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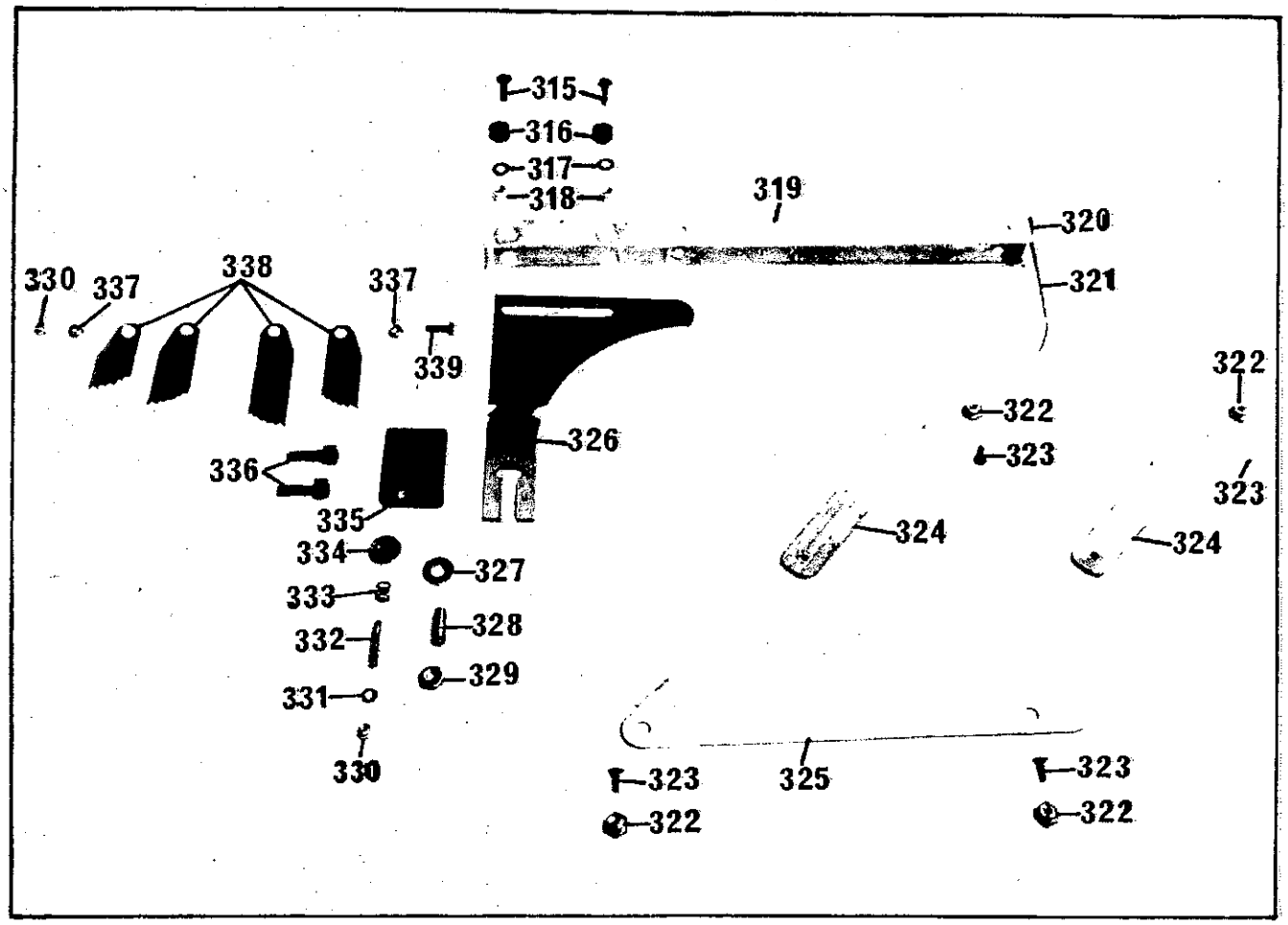
ILLUSTRATED PARTS LIST

ASSEMBLY:- AMERICAN SAWGUARD

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
315		2	M8 x 30 Long Countersunk Socket Head Screws
316	SP12-203	2	Spacers for Splitter
317		2	8mm Washers
318		2	M8 Aerotight Nuts
319	S25-685	1	Top Support for Sawguard
320	SP12-201	1	Angle Piece for Front Flap
321	SP12-202	1	Front Flap
322	SP12-188	8	Shouldered Washers for Sawguard
323		8	M6 x 16 Long Countersunk Socket Head Screws
324	SP12-189	4	Tie Pieces For Sawguard
325	SP12-200	2	Sawguards
326	S25-460	1	Splitter
327	1069-293	1	Washer
328		1	M10 x 30 Long Stud
329		1	M10 Full Nut
330		2	M6 Aerotight Nuts
331		1	6mm Washer
332		1	M6 x 40 Long Stud
333	1026-63	1	Spring for Splitter
334	S25-62	1	Splitter Pivot
335	S25-267	1	Splitter Packing Piece
336		2	M10 x 30 Long Socket Capscrews
337	S25-109	2	Splitter Pivot Bushes
338	1030-32	1	Kick Back Finger (2 7/8" Long)
	1030-225	2	Kick Back Fingers (3 5/8" Long)
	1030-226	1	Kick Back Finger (4 3/8" Long)
339		1	M6 x 25 Long Hexagon Set Screw

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES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INSTRUCTION FOR CROWN GUARD

CP, SP12 AND AGS RANGE OF MACHINE

1) Position outer arm "A" to rear of machine as shown in FIG.1.

   NOTE: CP and AGS range require 4 fixing holes. SP12 range requires 5 fixing holes. Refer to FIG.2 for dimensions.

2) Locate inner slide arm "B" FIG.3 and secure with locking handle "C" through slot "D".

3) Attach crown guard as shown in FIG.4 between ferodo washers on studs.

   NOTE: When locking crown guard on studs, tighten sufficiently so guard does not fall under its own weight.

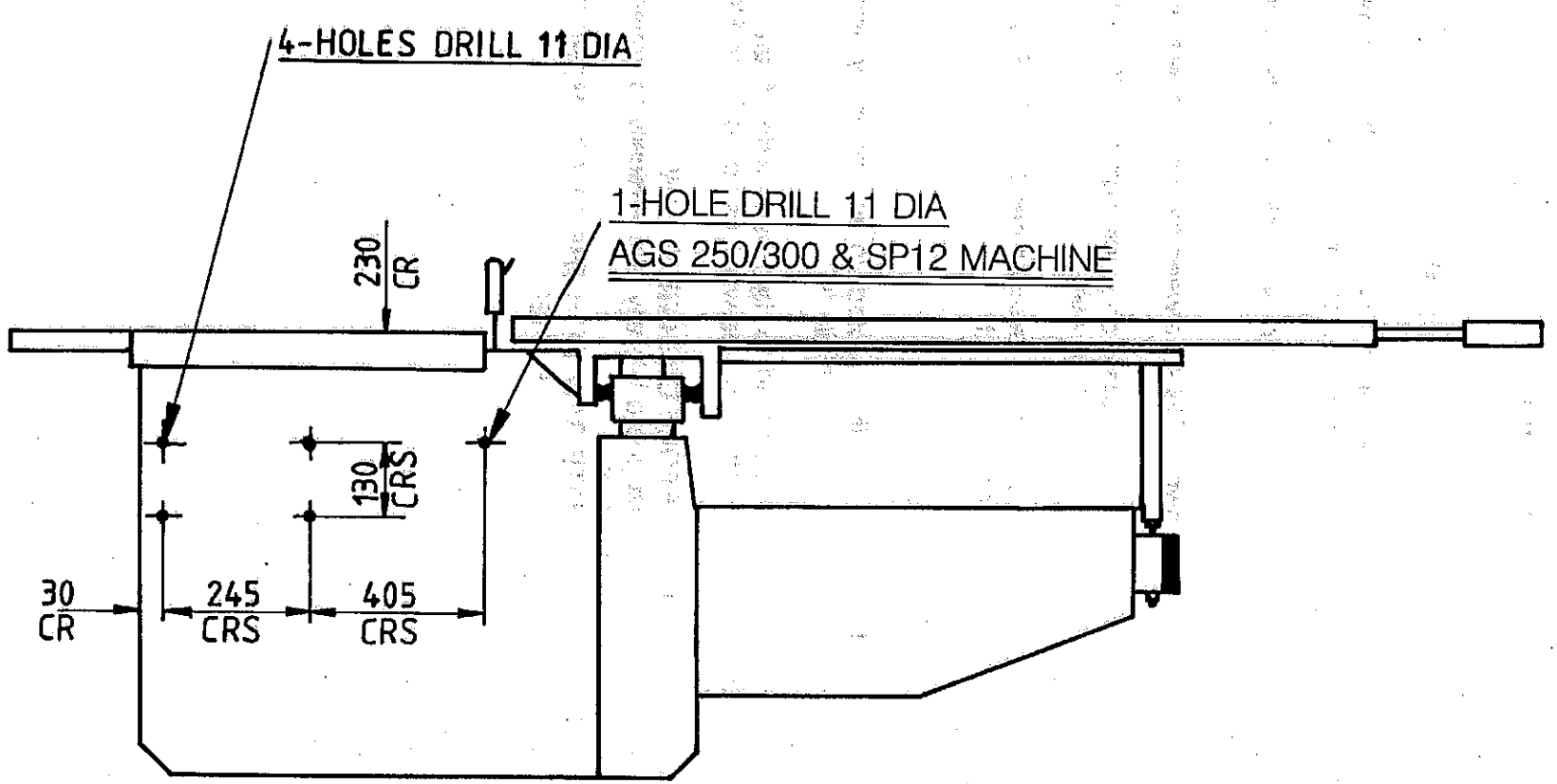
4) To adjust guard parallel to table, loosen hexagon head bolt "E" FIG.4 and adjust as necessary. Relock hexagon head bolt.

ADJUSTMENT OF GUARD

1) The crown guard can be manually adjusted up and down by using lever "F" FIG.4 and laterally by using locking handle "C".

2) The crown guard should be adjusted to right hand side of saw when using crosscut fence FIG.5 and to left hand side when using rip fence FIG.6.

   Important: **WARNING:- BEFORE OPERATING SAW**
   Manually adjust guard laterally and vertically to cover saw blade above workpiece.
   NEVER OPERATE SAW WITH THE GUARD MORE THAN 6MM (1/4") ABOVE THE WORKPIECE



REAR VIEW OF MACHINE

FIG. 2

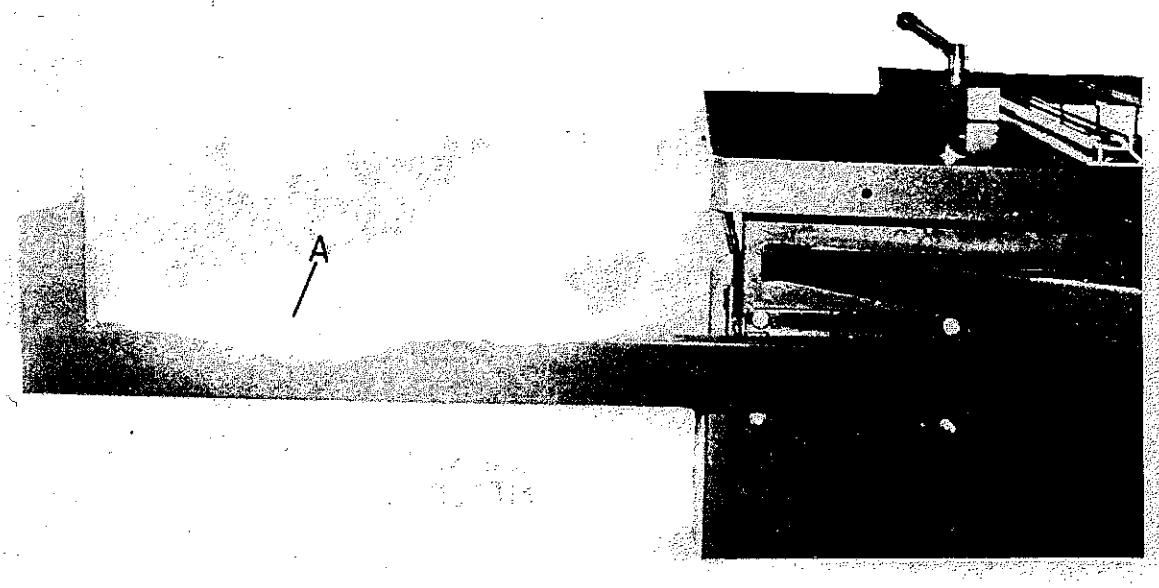


FIG.1

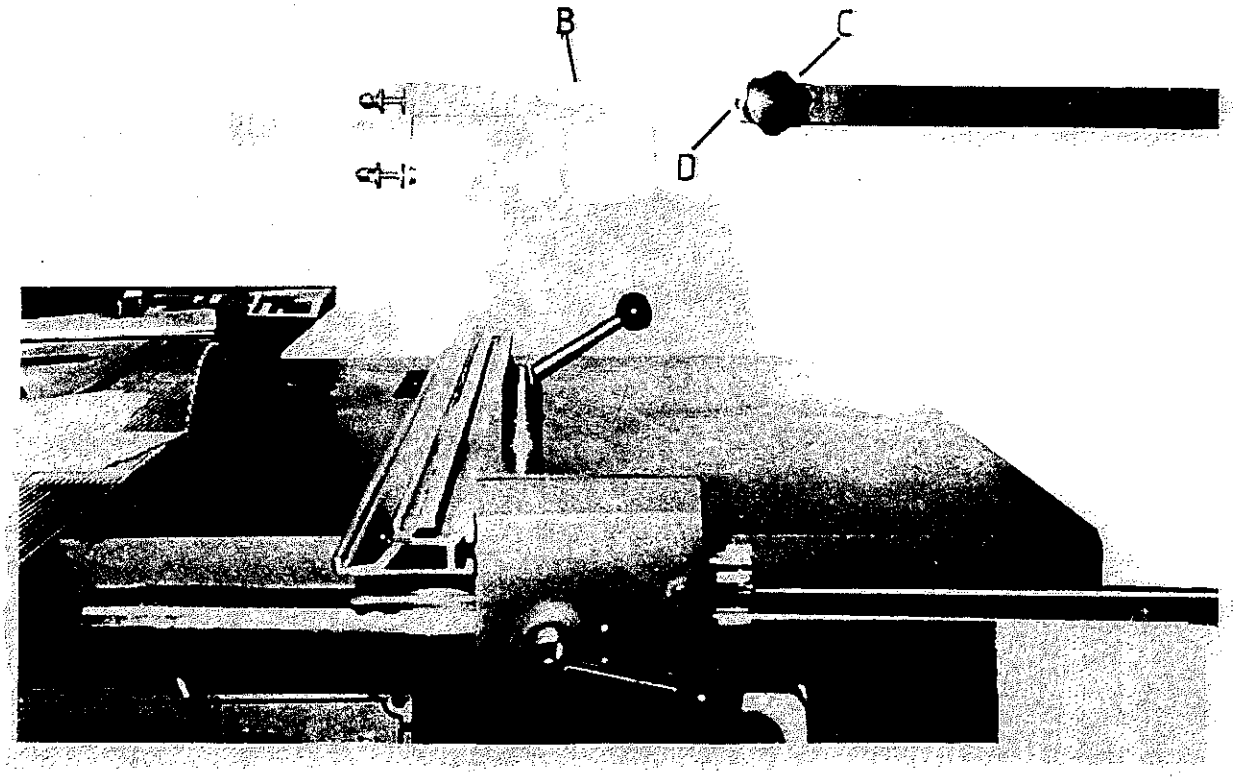


FIG.3

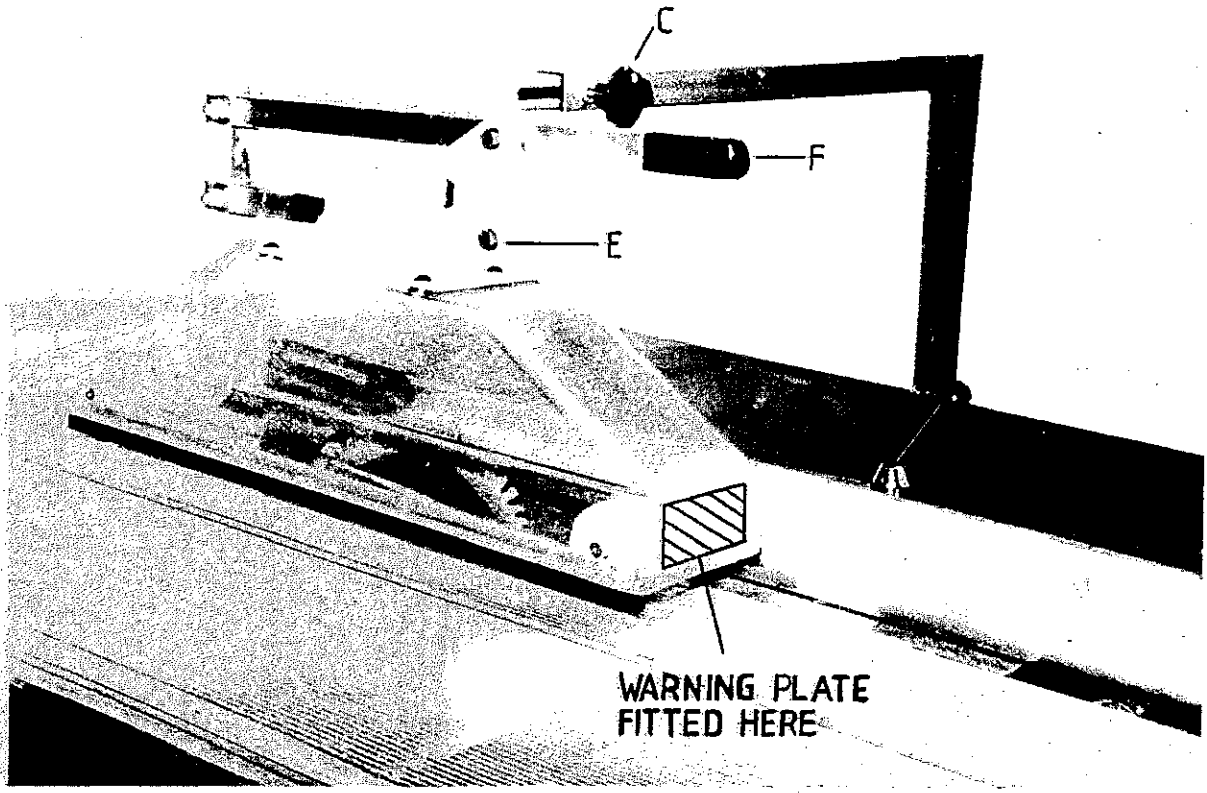


FIG. 4

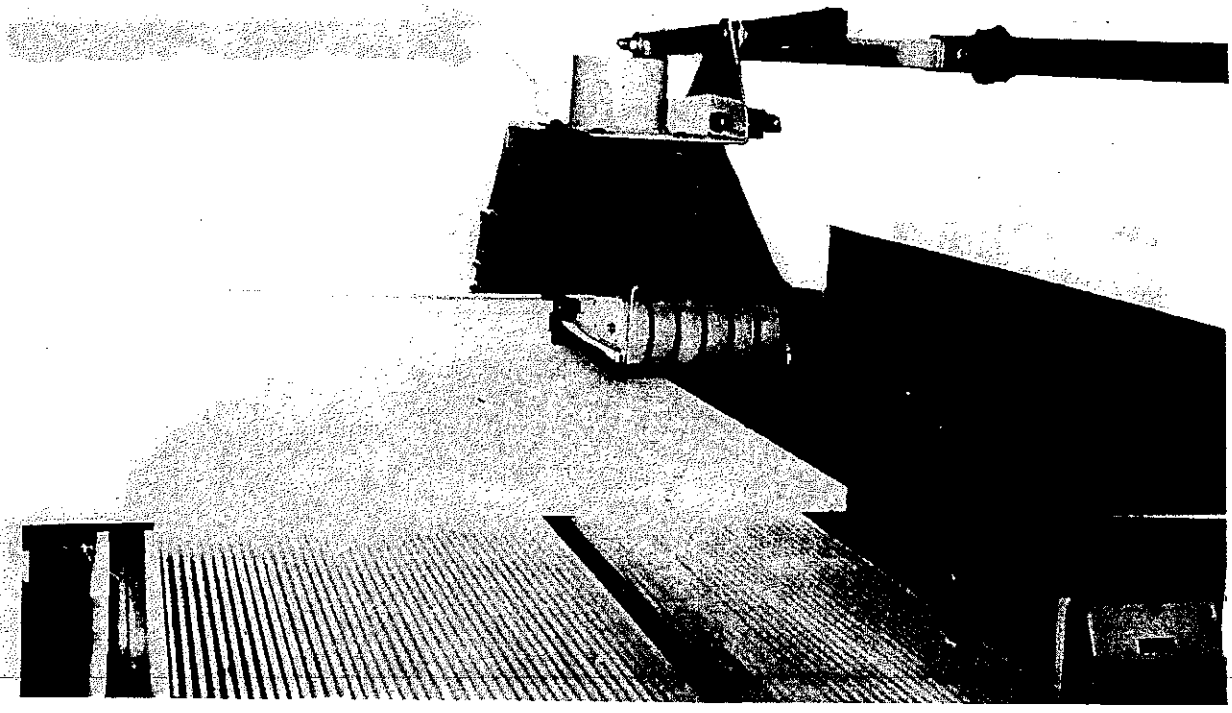


FIG. 5

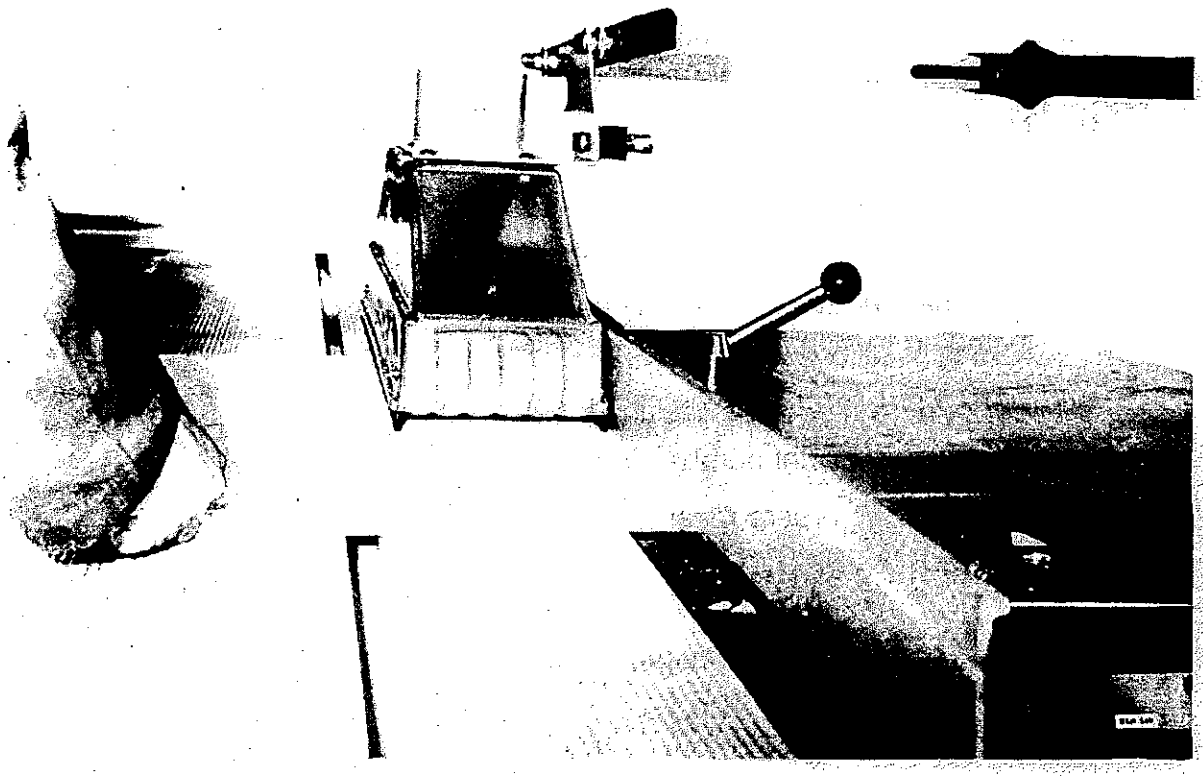


FIG. 6

INSTRUCTIONS WHEN ORDERING SPARE/REPLACEMENT PARTS

The undermentioned information should be given with all orders requesting spare/replacement parts.

1) Machine Type.
2) Machine serial number.
3) Part number of required parts, as stated in the instruction manual.
4) If no manual available, as full a description as possible of the required part, including location within the machine.
5) Order number and full company name and address.
6) Company account number, with WADKIN, if known.
7) All telephone orders **must** be followed by an official order, clearly marked **"Confirmation order".**

NOTE:

The company operates a "Minimum order charge" on all spare/replacement part orders.