LAGUNA

P14|12XC

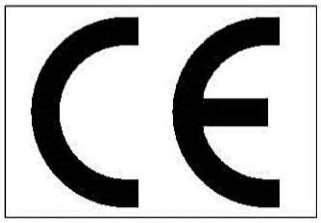
Panelsaw

OPERATING MANUAL

- Before you use the machine , please carefully read the manual and obey all related notes for safety and instructions.
- This manual is a part of the machine , so please make sure to include this manual when the machine is moved , transferred and sold.

PLEASE CAREFULLY READ THIS OPERATING MANUAL BEFORE USE

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



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

SAFE INSTRUCTIONS

1. If you are not fully familiar with the machine's operation, you must be instructed by your supervisor or qualified person.
2. If the running direction of the saw is wrong, it will cause danger.
3. The anti-skid floor cushion is put at the operator's standing area and the machine's working area. There should be a proper working space around the machine.
4. When the saw doesn't completely stop, please don't use extra pressure to stop it.
5. Don't operate the machine until the saw guard is well installed.
6. Please wear the approved safety glasses to protect eyes.
7. Before you repair or maintain the machine or change saw, please first shut down the machine's power.
8. When you rip small workpiece (<120mm), please use the push stick or wood block.
9. When the saw hasn't completely stopped, please don't adjust the saw guard.
10. When power is ON, don't clean saw and don't use hands to clean sawdust and use brush to clean chips.
11. Confirm if the machine is well installed with the earth wire.
12. When you finish the job or operator leave the working area, please make sure to turn the power to OFF.
13. While working, don't fail to pay full attention. Looking around, talking and clamoring are careless behaviors and will incur serious injury.
14. While operating the machine, please keep stable, balanced and coordinated gesture. Operator and others can't stand at the same line with the saw or the workpiece.
15. While the machine is running, no matter if the guard is installed, don't go near the saw or attach yourself to the machine.
16. The weight of workpiece can't exceed 40kgs.
17. Before you replace parts, maintain or repair the machine, please first shut down the machine's power.

EXPLANTION OF WARNING SIGN

To secure safety

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

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

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

WARNING SIGN	WARNING CLASS	WARNING CONTENTS
	WARM	If you wrongly operate it, assume the user to be dead or seriously injured.
	CAUTION	If you wrongly operate it, assume the user to be light injured or property damaged.
	MOTE	Remind the user to surely close power.

For special notes, the following sign is used：

★ is a special note.

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

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

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

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

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

CATALOG

CHAPTER 1

BRIEF INTRODUCTION TO MACHINE

1-1 SPECIFICAITON

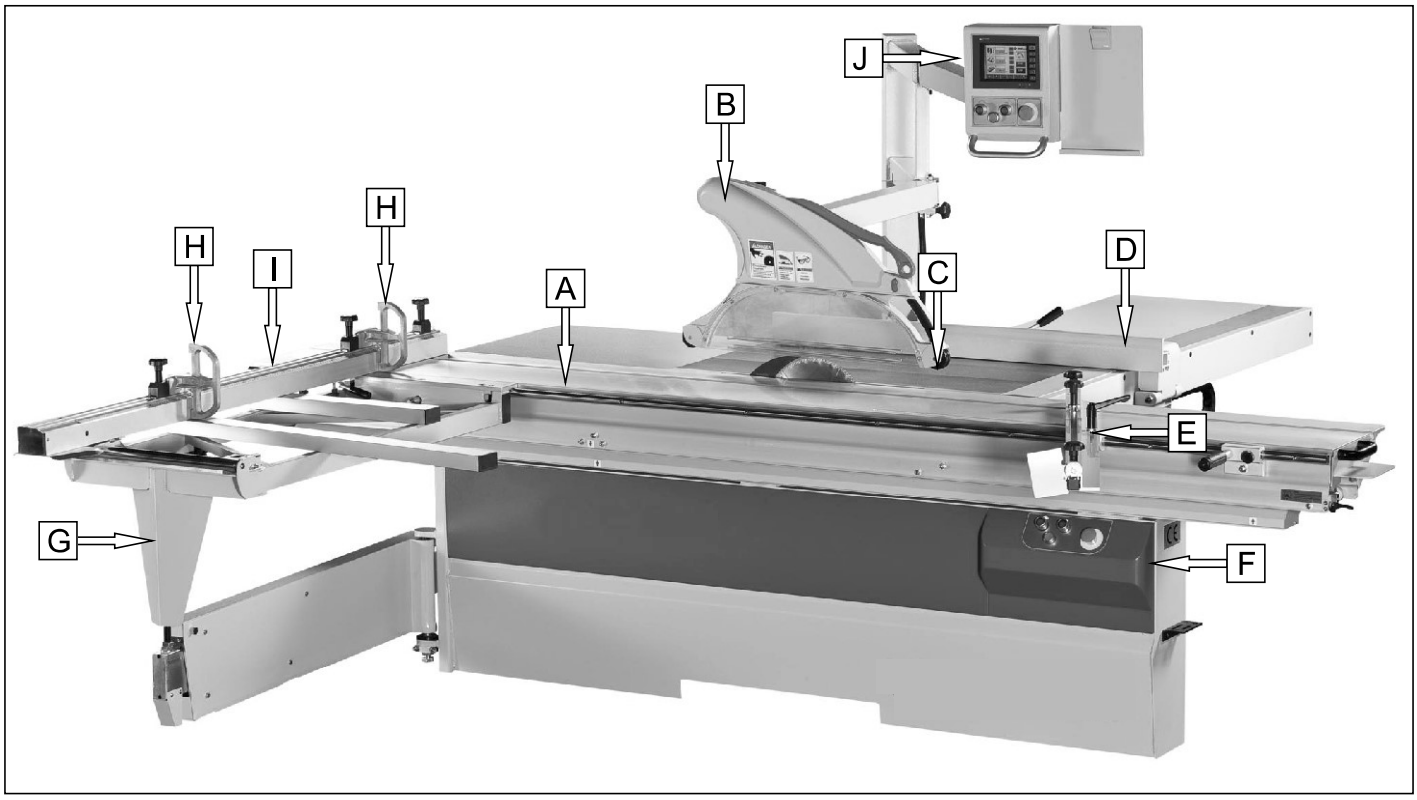
TECHNICAL DATA,STANDARD AND OPTIONAL EQUIPMENT

Unit: mm

ITEM / MODEL			
Rectified cast iron fixed table dimension	570 x 1000		
Sliding table dimension	380 x 2600	380 x 3200	380 x 3800
Max sawing carriange ∅355mm (14")	●		–
Sawing carriange ∅400mm (16")	√		●
Main saw blade ∅305mm (12")	●		
Main saw blade ∅355mm (14")	√		
Main saw bore	∅30 (∅25.4)		
Max. cutting height with blade at 90°	105		125
Max. cutting height with blade at 45°	73		88
Main motor power 7.5HP (5.5 kw)	●		
Main blade speed	3000 / 4000 / 5000 rpm		
Scoring saw blade ∅120	●		
Scoring saw blade bore	∅22		
Scoring motor power 1HP (0.75 kw)	●		
Scoring blade speed	8000 rpm		
Cutting width 1300 mm	●		
Cutting width 1500 mm	√		
Cutting width adjustment	CNC Control		
Saw table extension 370 mm	●		
Saw table extension 720 mm (CE)	√		
Mitre fence	●		
Blade tilting adjustment	CNC Control (0°~45°)		
Main saw height adjustment	CNC Control		
Scoring saw height adjustment	Motorize		
Scoring saw +/- direction adjustment	Motorize		
Overhead saw guard	Luxurious		
Crosscut fence digital display	√		
Rip clamp	√		
Tool frame	√		
	● (CE)		
Dust collection system	Main chanel 4", Luxurious 3"		

● : Standard √ : Optional

1-2 FEATURES



ILLUSTATION OF EACH MAIN PART :

A : Scoring table ---------- Table for main feeding while cutting .

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

C : Main table ---------- Main working table .

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

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

F : Electric controlling box --------- The machine's main electric controlling box including power switch, emergency stop button.

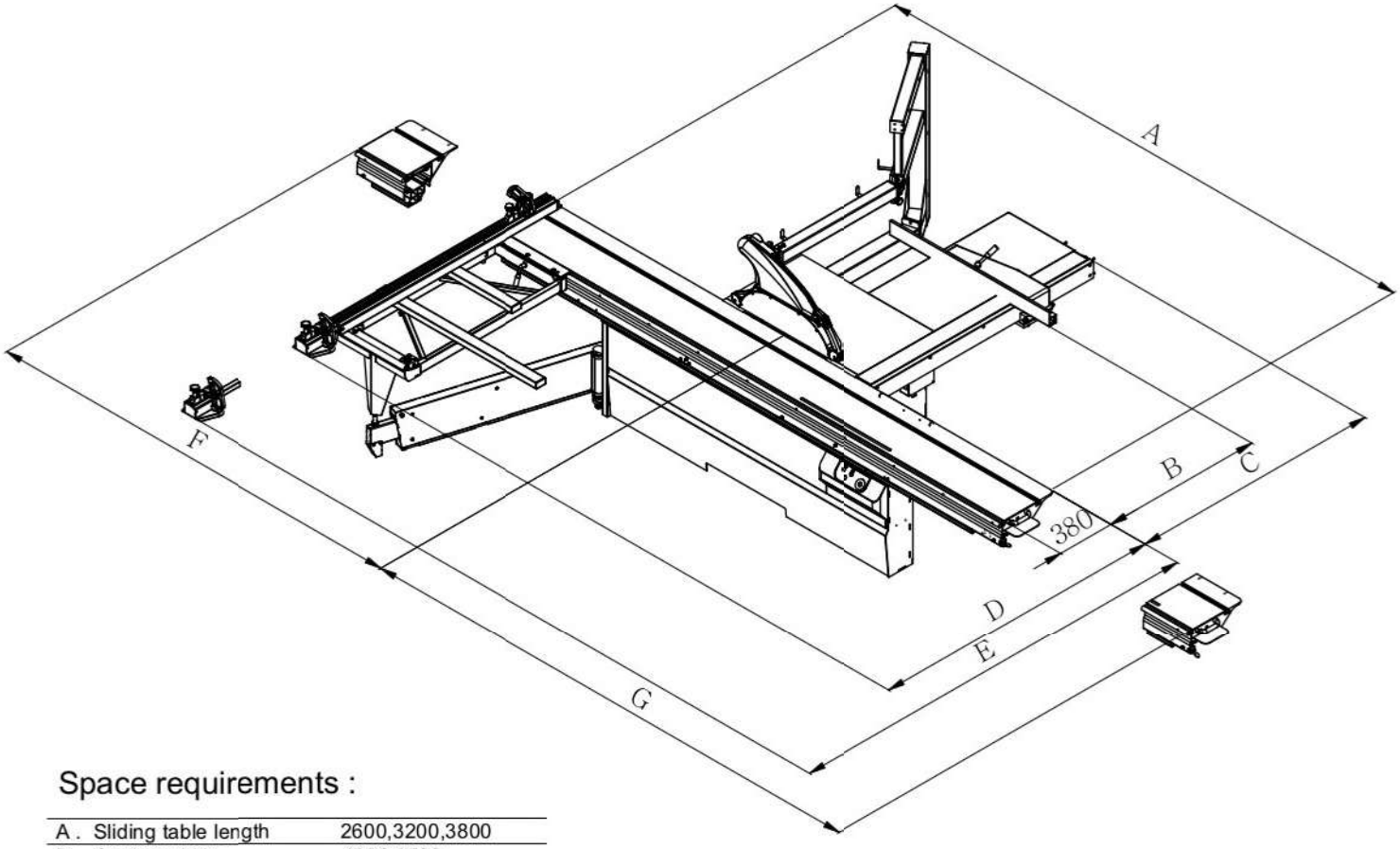
G : Cross cut table ---------- Used to put the work piece while cross cutting .

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

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

J : Touch screen control panel --- Control machine's running, display, stop, etc.

1-3 MACHINE DIMENSION



Space requirements :

A . Sliding table length	2600,3200,3800
B . Cutting width	1300,1500
C . Cutting width + 420	
D . Crosscut fence	1800
E . Crosscut fence	max.3215
F . Sliding table length + 340	
G . Sliding table length + 260	

Technical specifications :

Sliding table cutting lengths	With cross cut fence
2600 mm (102.36 in)	2500 mm (98.43in)
3200mm (126 in)	3100 mm (122.05 in)
3800mm (149.61 in)	3700 mm (145.67 in)

Cutting depths

Saw blade diameter	Ø250 (10")	Ø300 (12")	Ø350 (14")	Ø400 (16")
Cutting depths at 90°	0 ~ 50 mm (0 ~ 2 in)	0 ~ 75 mm (0 ~ 2.95 in)	0 ~ 100 mm (0 ~ 4 in)	28 ~ 125 mm (1.1 ~ 4.92 in)
Cutting depths at 45°	0 ~ 35 mm (0 ~ 1.38 in)	0 ~ 53 mm (0 ~ 2.09 in)	0 ~ 70 mm (0 ~ 2.76 in)	19.8 ~ 88 mm (0.8 ~ 3.5 in)

1-4 INDICATION

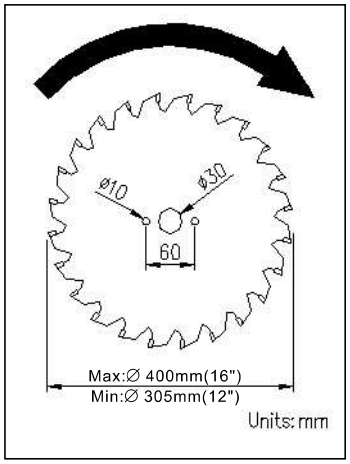


Fig.1-4-1

Operation scope of main saw				
Main saw dim.		305mm (12")	355mm (14")	400mm (16")
Saw blade speed	3000rpm	○	○	○
	4000rpm	○	○	○
	5000rpm	○	○	○

Fig.1-4-2

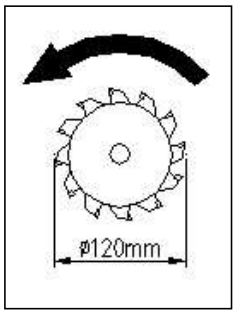


Fig.1-4-3

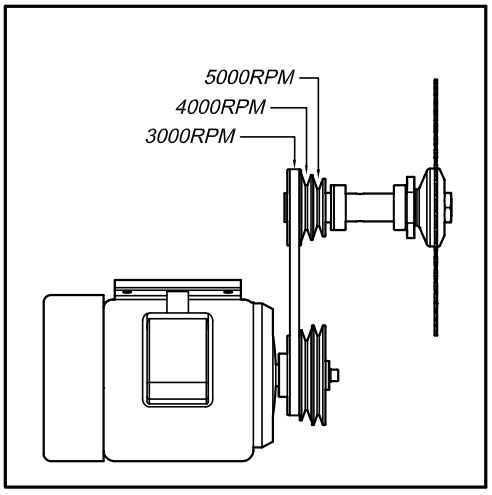
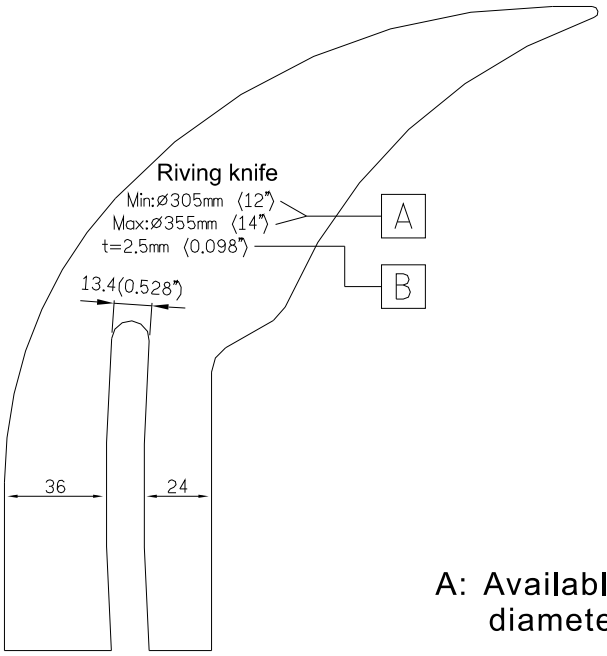


Fig.1-4-4

1. Fig.1-4-1 is the main saw's size, running direction.
2. Fig.1-4-2 is the main saw's size and main saw's permit speed diagram.
3. Fig.1-4-3 the scoring saw's size and running direction.
4. Fig.1-4-4 belt speed diagram.

NOTE : Using 16" main saw belt speed limit 3000rpm~5000rpm.
Main shaft speed ration follow up the ration limiting range to preventing the danger.

1-5 RIVING KNIFE SPECIFICATION



A: Available Main Saw diameter range.

B: Riving knife depth.

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

The machine is delivered as standard with the following riving knives.
305~355/2.5 specification : Saw blade diameter 305~355mm.
Saw blade basic body thickness up to maximum : 2.3mm.

Diameter range and thickness are both engraved at the bottom end of the riving knife.

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

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

B: Fig. 1 is the default installation

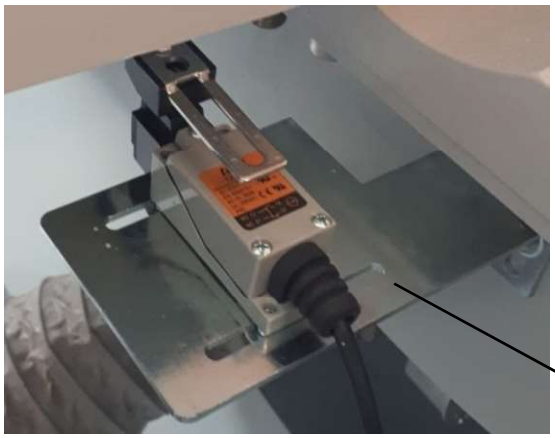


Fig. 1

C: How to adjust this protect switch

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

(b) Please refer to Fig. 2

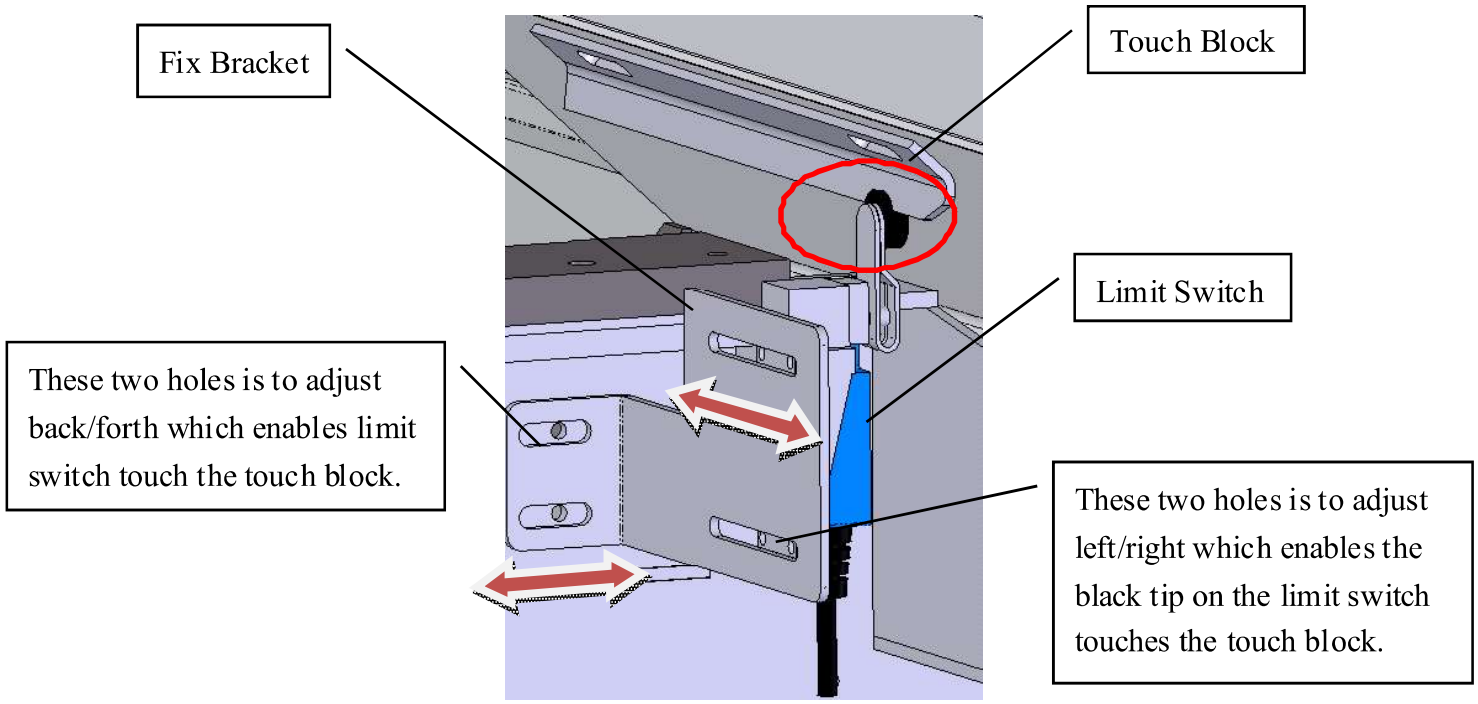


Fig. 2

CHAPTER 2

TRANSPORT / ASSEMBLE

2-1 TRANSPORT

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

2-1-1 TRANSPORT WOODEN CRATE

The machine's gross weight is about：

Main crate (Cutting width 1.3m) -------- 1070 kgs.

Main crate (Cutting width 1.5m) -------- 1090 kgs.

USE CRANE TO MOVE WOODEN CRATE

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

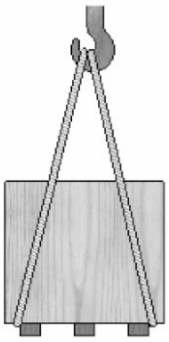


Fig.2-1-1

USE LIFT TRUCK TO MOVE WODEN CRATE

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

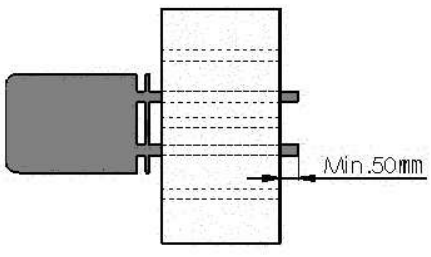


Fig.2-1-2

2-1-2 TRANSPORT MACHINE

The machine's net weight is about:

Main crate (Cutting width 1.3m) -------- 898 kgs.

Main crate (Cutting width 1.5m) -------- 918 kgs.

USE LIFT TRUCK TO TRANSPORT MACHINE

Fig.2-1-3

1. The lift truck must be able to bear at least 5tons.
2. Make sure the machine is balanced. While transporting, please don't vibrate it and keep at least 2m safe distance away from the transport area.
3. The machine is equipped with the slots as shown in Fig. 2-1-3 that are specially designed for transport of lift truck and manual (electric) trolley.

USE GANTRY OR CRANE TO MOVE MACHINE AWAY PALLET

Fig.2-1-4

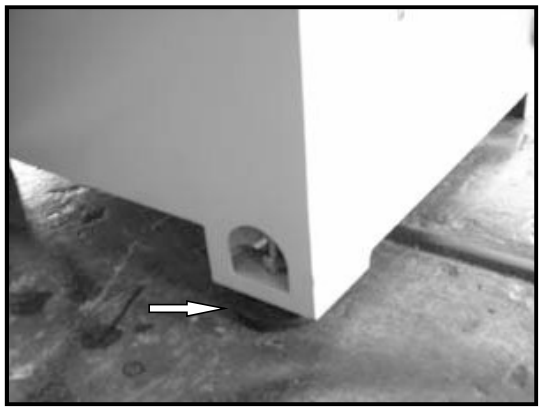


Fig.2-1-5

Before the machine is put on the floor, please first install 4 level adjusting bases (as shown in Fig. 2-1-5) and adjust the level of the machine's working table to secure the sliding table's smooth movement and the machine's balanced running.

2-2 ASSEMBLE

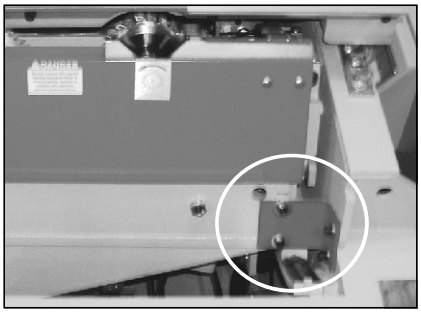


Fig.2-2-1

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

2-2-1 ASSEMBLE THE SLIDING TABLE

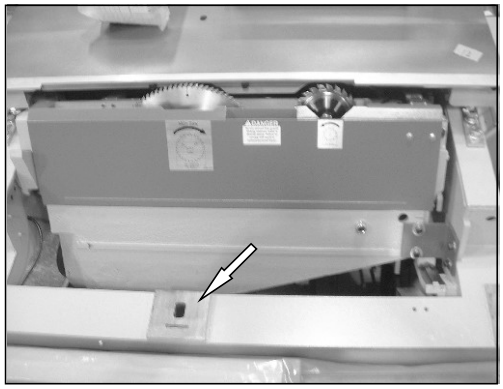


Fig.2-2-1-1

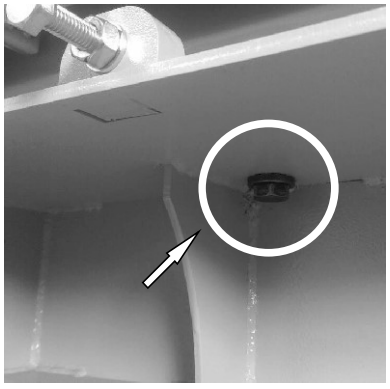


Fig.2-2-1-2

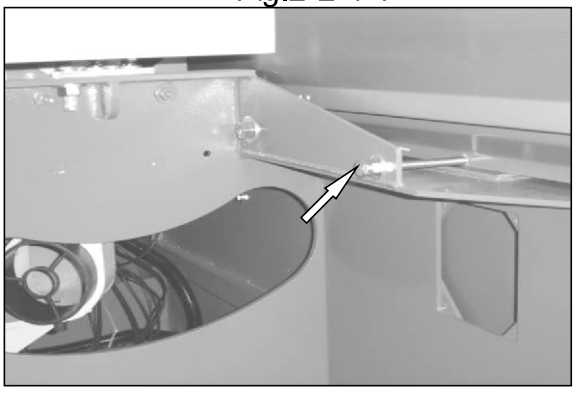


Fig.2-2-1-3

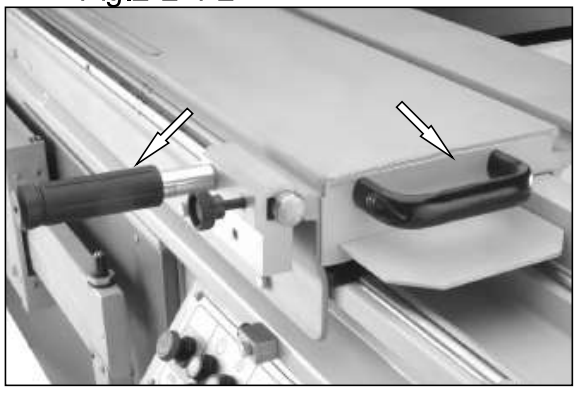


Fig.2-2-1-4

Assembling steps as follows：

1. Please first clean the position shown in Fig. 2-2-1-1 on the machine.
   The three planes are the position of assembling the sliding table and machine.
2. Please ask workers to move the sliding table onto the machine to prevent hitting from influencing its levelness during transport.
   The sliding table's size is different, so 4~ 6 workers are required.
3. Put the sliding table on the structure frame and tighten three screws as shown in Fig.2-2-1-2.
4. For clean & straight cut, the sliding table must be parallel to the knife.
5. Install the grip and the sliding table's handle into the sliding table as shown in Fig.2-2-1-4.

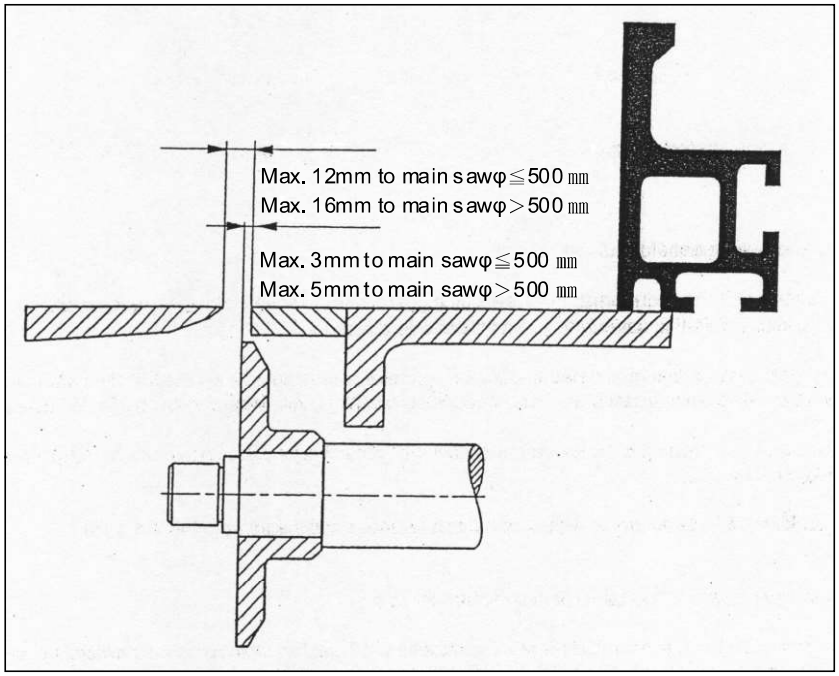


Fig. 2-2-1-5

Steps of adjusting the sliding table as follows：

1. Loosen three screws (as shown in Fig. 2-2-1-2) and use the parallel adjusting bolts at the two sides of the machine to do adjustment (as shown in Fig. 2-2-1-3).

2. For the gap between the sliding table and the main saw, please refer to Fig. 2-2-1-5.

3. Tighten three screws.

NOTE: The sliding table must be 0.15mm higher than the main cast iron table to enable to move up or down the casting on the main table. Please don't adjust the height of the sliding table.

2-2-2 ASSEMBLE CROSS CUT TABLE & SCALE BASE

ASSEMBLE CROSS CUT TABLE

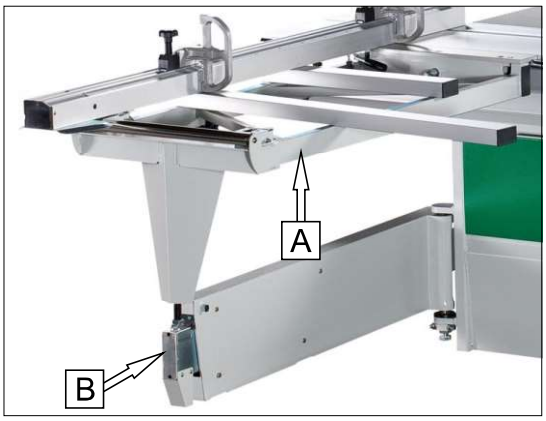


Fig. 2-2-2-1

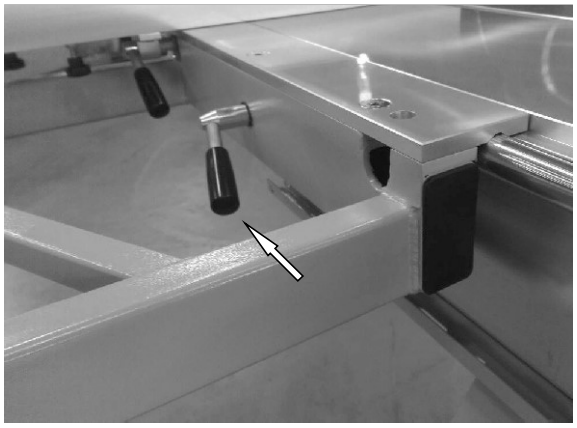


Fig. 2-2-2-2

Fig. 2-2-2-3

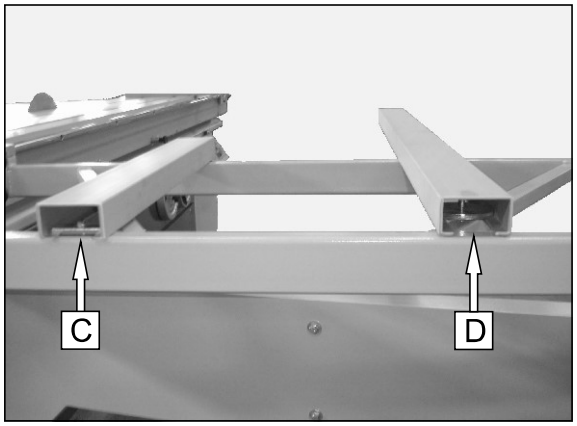


Fig. 2-2-2-4

Assembling way：

1. Put one end of the cross cut table into the projecting rod of the expanding bar (as Fig. 2-2-2-1).

   Avoid the noise by greasing the lubricant on the supporting bolt on the swimming arm (Figure 2-2-2-1 B) before connect the cross cut fence (Figure 2-2-2-1 A) and swimming arm fence .

2. The other end of the cross cut table is against the rod of the sliding table and the cross cut table's fastening sliding block must put under the rod (as Fig.2-2-2-2)

3. Tighten the handle to fasten the cross cut table (as position shown in Fig. 2-2-2-3).

4. Put two C-shaped aluminum pipes into the cross cut table and tighten them (as Fig. 2-2-2-4) and cover the two ends by the plastic caps. In the Fig. C is for fastening and D is for adjusting.

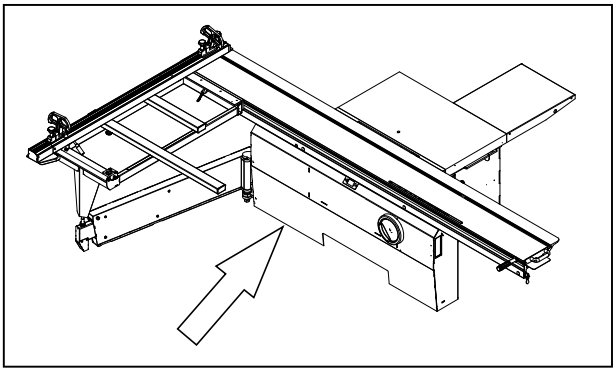


Fig. 2-2-2-5

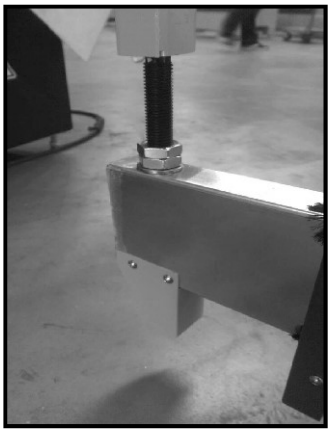


Fig. 2-2-2-6

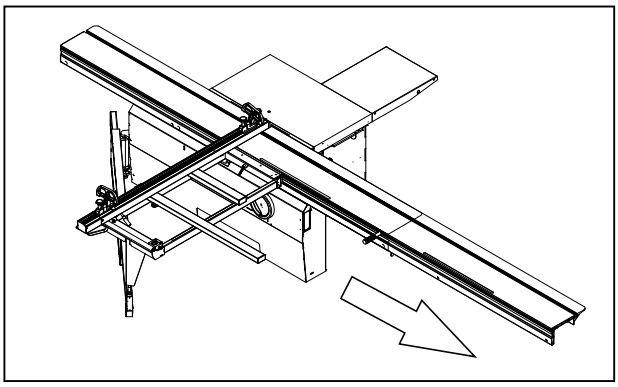


Fig. 2-2-2-7

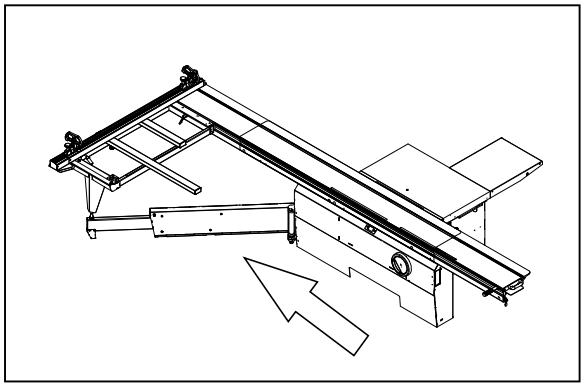


Fig2-2-2-8

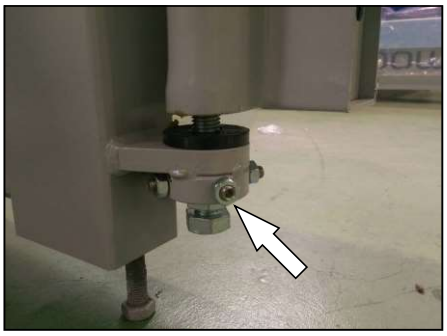


Fig. 2-2-2-9

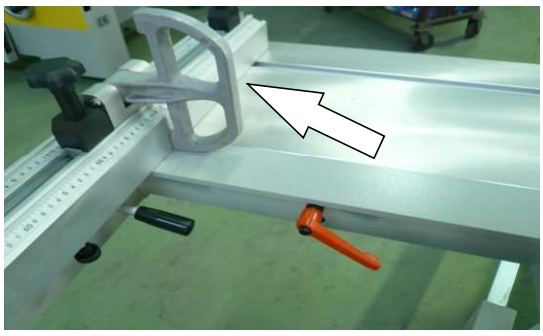


Fig. 2-2-2-10

Adjustments

1.(fig.2-2-2-5) is the first adjust part for crosscut fence and sliding table.if crosscut fence doesn`t parallel with sliding table,adjust the round bar,nut and the(fig.2-2-2-6)

2.(fig.2-2-2-7)is the second adjust part for crosscut fence andsliding table.Move the sliding table to right to reach its limit,if crosscut fence doesn`t parallel with sliding table,adjust nut (fig.2-2-2-9)

3.(fig.2-2-2-8)is the third adjust part for crosscut fence and sliding table.Move the sliding table to the left to reach its limit, if crosscut fence doesn`t parallel with sliding table, adjust nut(fig.2-2-2-9)

4.Once finish the adjustment for crosscut fence and sliding table, check of the crosscut fence and sliding table is parallel(fig.2-2-2-10) check gap between crosscut fence and sliding table.

ASSEMBLE CROSS CUT SCALE BASE

Fig. 2-2-2-5

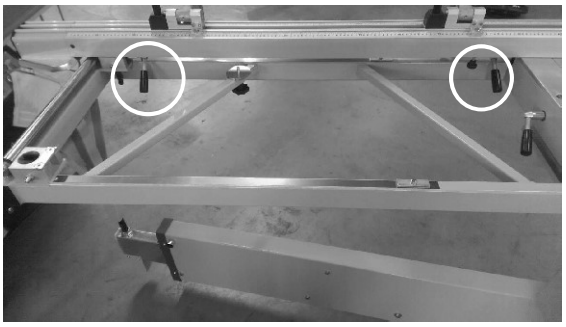


Fig. 2-2-2-6

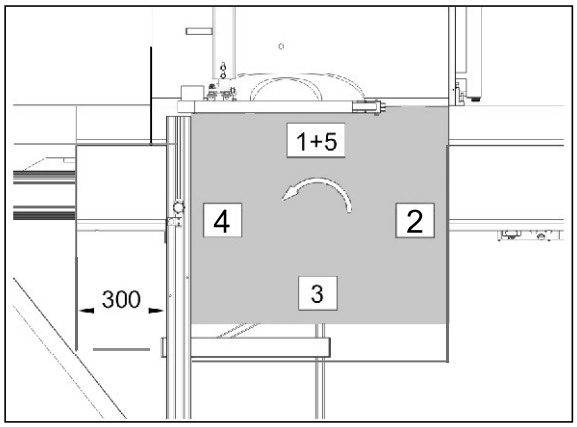


Fig. 2-2-2-7

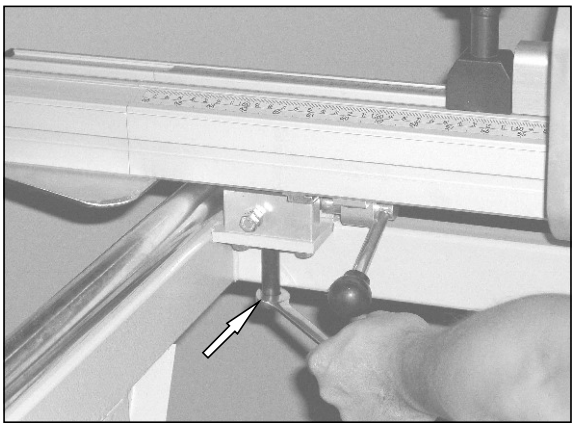


Fig. 2-2-2-8

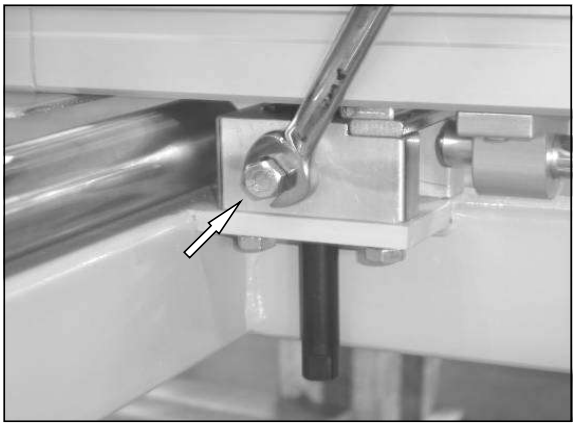


Fig. 2-2-2-9

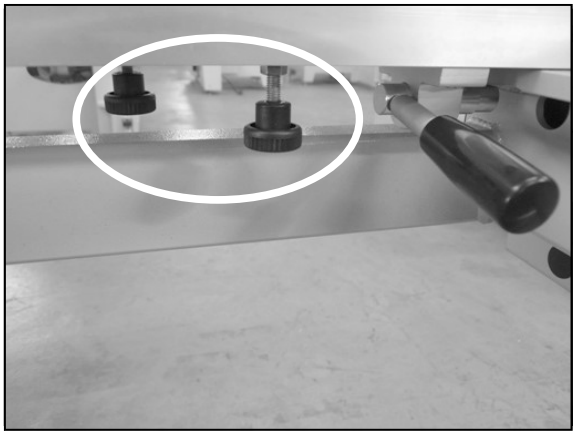


Fig. 2-2-2-10

Assembling steps as follows：

1. Put the fence into the position as shown in Fig. 2-2-2-5.
2. Turn the handle to fasten the fence (as position shown in Fig. 2-2-2-6).
3. Adjust the perpendicurity of the fence and the saw. Please use actual cutting error to proceed adjustment (as Fig. 2-2-2-7).

Adjusting method as follows：

1. Distance between crosscut fence and sliding table needs 300mm, anjust the saw blade to proper heighht and set the rotation speed at 5000rpm. Trial cutting by a 1000x1000x19 or 6/8" wood board.
2. Cutting in sequence from #1 to #5.(fig.2-2-2-7).
3. Measure the diagonal's error of the wood board to proceed adjustment (the adjusting position as shown in Fig. 2-2-2-8 and fig.2-2-2-9.Lock nuts in fig.2-2-2-8 and 2-2-2-9)
4. After adjusting, tighten the nut (as Fig. 2-2-2-9).
5. The part shown in Fig. 2-2-5-10 is the knob for fastening scale.

2-2-3 INSTALL EXTENSION TABLE

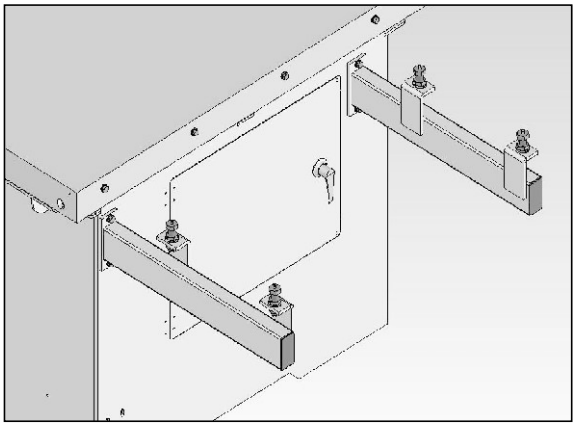


Fig.2-2-3-1

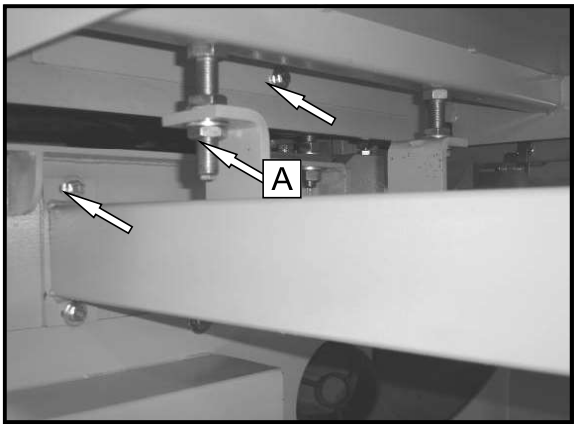


Fig.2-2-3-2

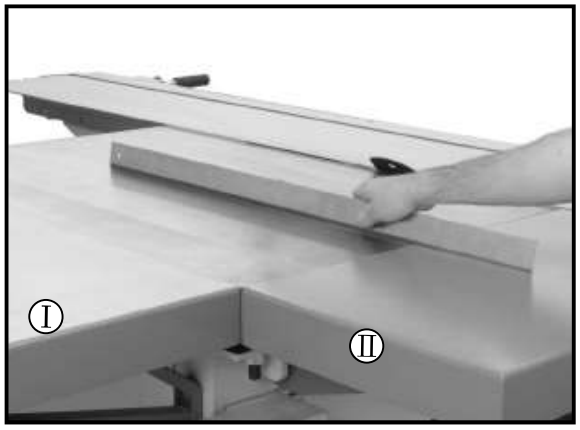


Fig. 2-2-3-3

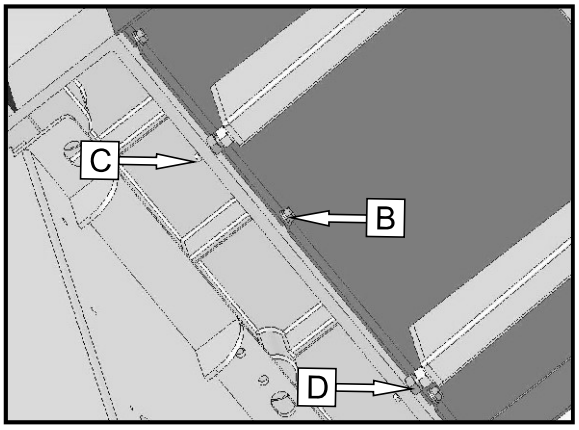


Fig. 2-2-3-4

Ⅰ :Width Cutting Extension Table.
Ⅱ :Extension Table.

Installing Width Cutting Extension Table :

1. Tighten the supporting rack into the machine and its opening is towards outside (as Fig. 2-2-3-1).
2. Tighten the screws of the table, the machine and the supporting rack (as Fig. 2-2-3-2).
3. Use the adjusting screw A shown in Fig. 2-2-3-2 to make the extension table and the main table be at the same plane (as Fig. 2-2-3-3).

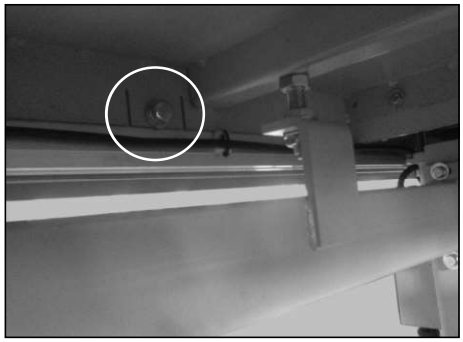
Installing Extension Tables:

1. Use the adjustment screw under the extension table to level the top surface with the saw table (Fig 2-2-3-4-B,C).
2. Adjustment the screw (Fig2-2-3-4-D) and check the surfaces of the table with a straight edge as shown in Fig2-2-4-3.

3.Fasten the screw (Fig 2-2-3-4-B,C,D nuts).

2-2-4 ASSEMBLE ELECTRIC RIP FENCE

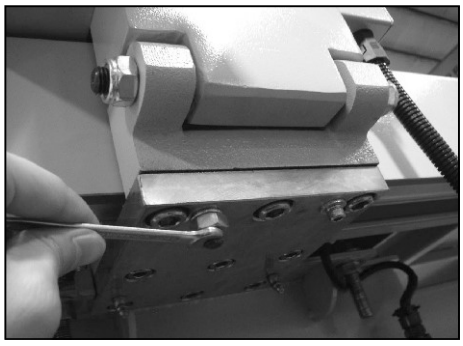
Sequence of Assembling and Adjusting Electric Rip fence:



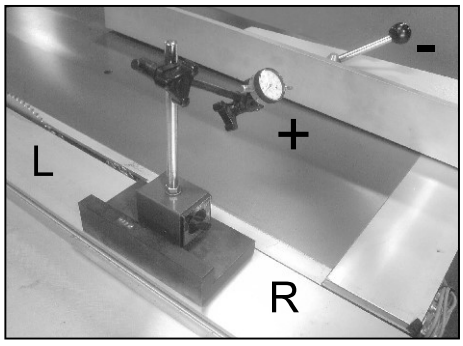
Step 1 : Put on the screw which is used to electric rip fence, working table and extension table (See the left drawing).

Step 2 : Adjust the gap between electric rip fence and main working table and then tighten the screw shown in Step 1.(Electric rip fence must be in the gap 0~0.1mm under the main working table.)

Step 3 : Put on the screw which is used to fasten the fence base and the electric rip fence. (See the left drawing)

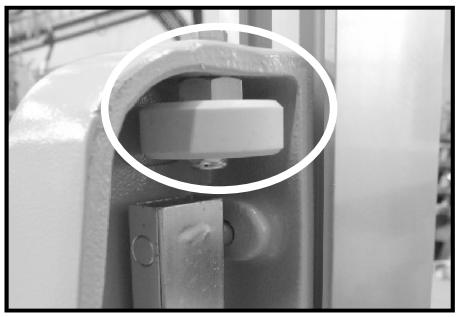


Step 4 : Use the open wrench 8 to adjust the screw to make the fence parallel to main saw blade. (See the left drawing)

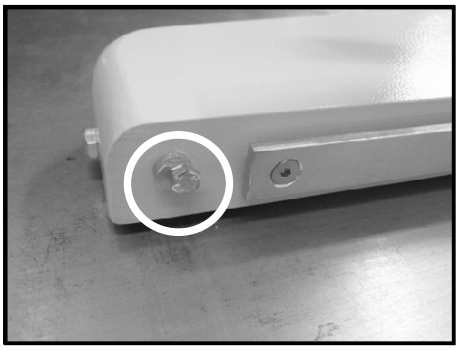


Step 5 : Use the measuring gauge to measure parallelism of the fence and the main saw blade.

Measuring method : Fix the rip fence. Push the sliding table to the left. The measuring tolerance is 0~0.1mm from the right to the left as the direction of the left drawing shows. (Parallelism of the sliding table and the main saw blade must be first adjusted within tolerance)



Step 6 : Adjust the eccentric wheel at front end of the fence base to make the fence base parallel to the working table.



Step 7 : Adjust the eccentric wheel at the side of the fence base to make aluminum fence parallel to the wokring table. At this time, assembly of electric rip fence is completed.

Fig 2-2-4-1

Fig 2-2-4-2

Fig 2-2-4-3

When the safety guard is used (Fig 2-2-4-1), aluminum fence must be put at low position.
Fig 2-2-4-2 shows the position of the fence when the cutting angle is at 0~45 degree.
Fig 2-2-4-3 shows the position of the fence when the cutting angle is at 90 degree.

2-2-5 ASSEMBLE SAFETY GUARD

2-2-5-1 LUXURIOUS DUST GUARD

Fig. 2-2-5-1

Fig. 2-2-5-2

Fig. 2-2-5-3

Fig. 2-2-5-4

Fig. 2-2-5-5

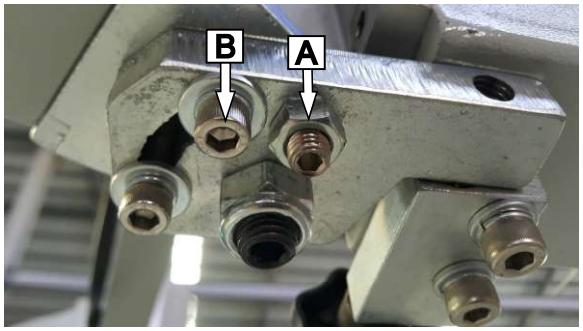


Fig. 2-2-5-6

Assembling steps：

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

1.Install the dust collection fixing rack onto the left side of the machine as shown in above drawing. (Fig.2-2-5-1)

2.Adjust the guard parallel with the saw and tighten the screw as shown in above drawing. (Fig.2-2-5-2)

3.Loose nuts on the arrow parts to adjust the distance between dust collector and saw blade. (Fig.2-2-5-3) (distance please refer to fig.2-2-5-7)

4.Tighten the knob to fix the guard.Loosen the knob, the guard can be moved as shown in above drawing. (Fig.2-2-5-4)

5.Adjust nuts on the arrow parts if slidingtable does not parallel with dust collector. (Fig.2-2-5-5)

6.Adjust nuts on the arrow partsif dust collector dors not parallel with saw blade. To adjust,loosen screw A and then loosen screw B.
Dnce adjustment has heen done, lock screw B and then lock screw A. (Fig.2-2-5-6)

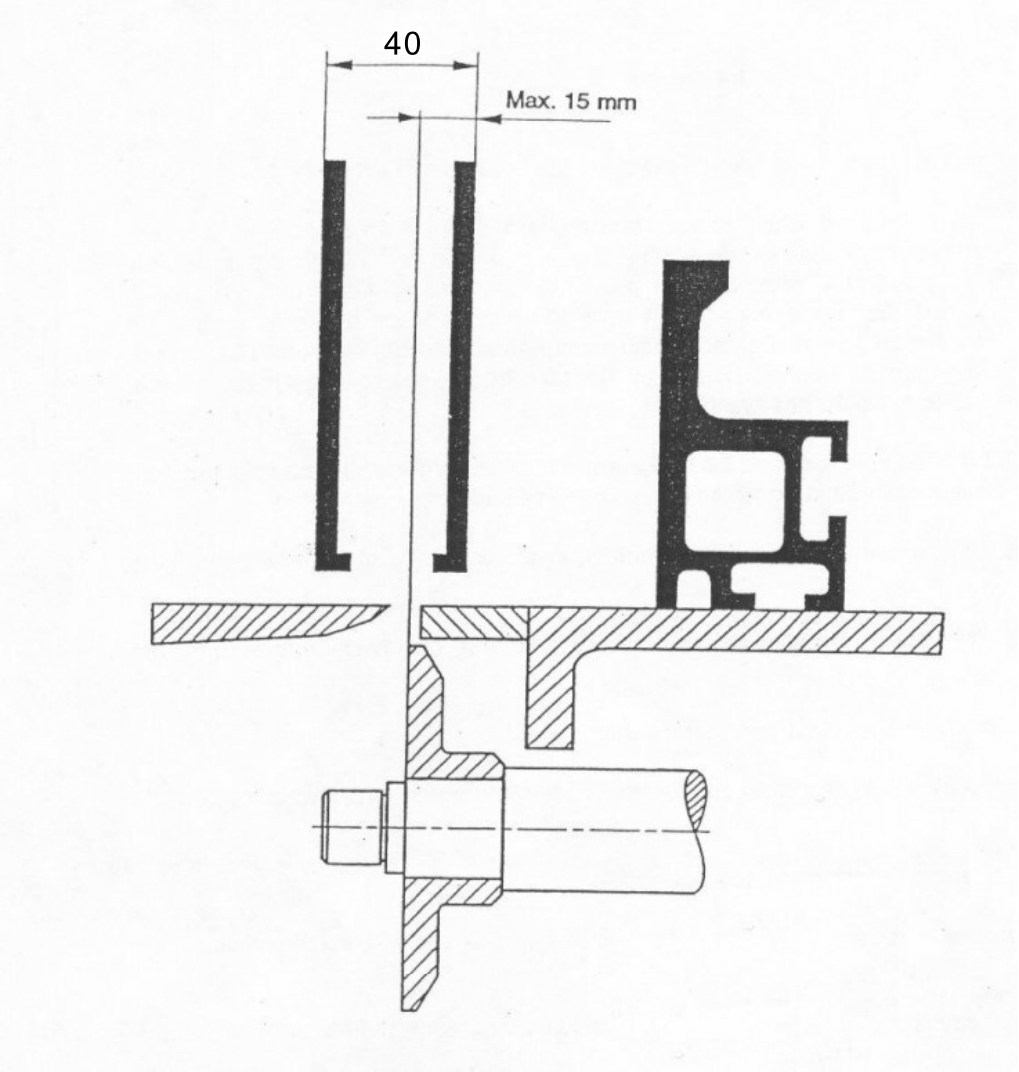


Fig.2-2-5-7

★ Please keep safe distance between the safety guard and the saw (as Fig. 2-2-5-7) to avoid the saw and the guard interfering each other.

2-2-5-2 PUSHING STICK INSTALLING

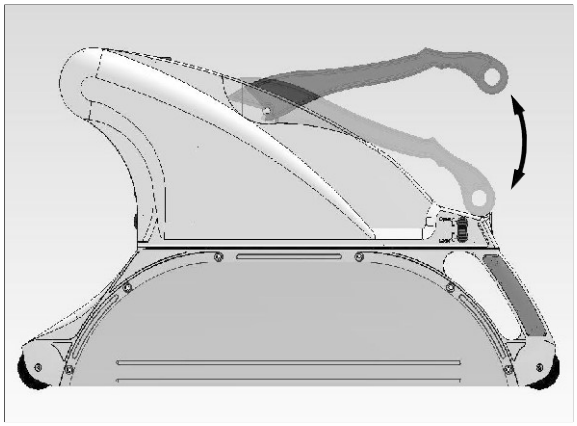


Fig.2-2-5-2-1

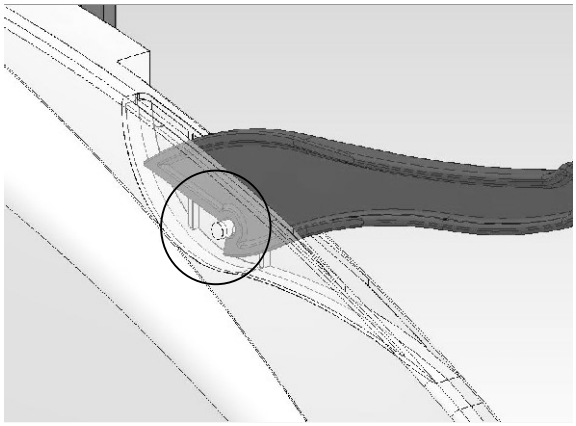


Fig.2-2-5-2-2

Instruction Manual :

The pushing stick holder is located inside the saw guard by the pushing stick in degree 45 (Figure 2-2-5-2-2) and the sharp top one parallel with the pushing stick holder (Figure 2-2-5-2-2) so that can located the stick (Figure 2-2-5-2-1) ; opposite is take out the pushing stick.

2-2-6 INSTALL MITER FENCE

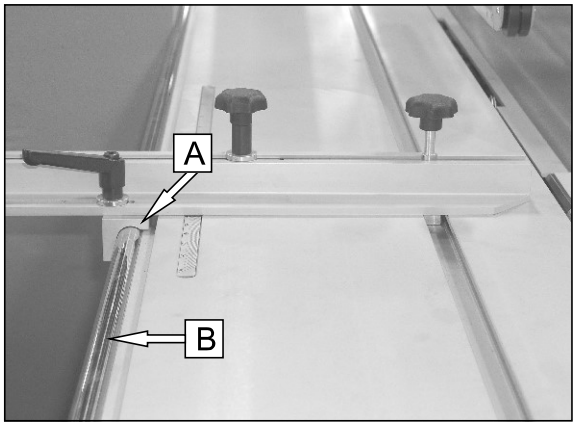


Fig.2-2-6-1

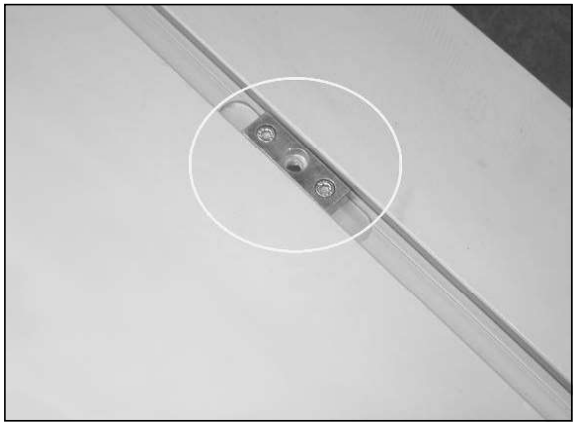


Fig.2-2-6-2

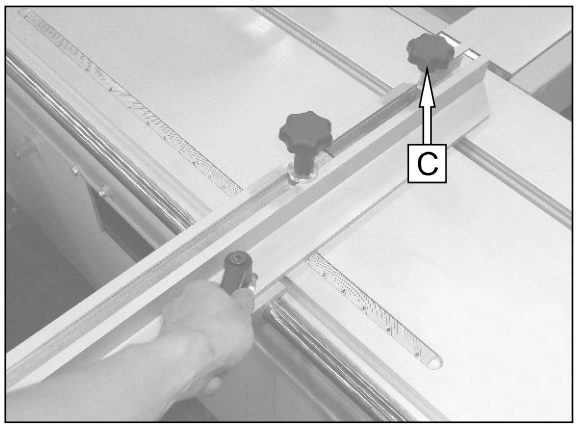


Fig.2-2-6-3

Assembling steps:

1. Put the sliding block of the miter backing board (As A shown in Fig2-2-6-1) handle into the slot (As B shown in Fig 2-2-6-1)
2. Tighten the knob (as C shown in Fig 2-2-6-3) of the miter backing board into the sliding table (as shown in Fig 2-2-6-2)
3. Tighten the handle to fasten the miter backing board. (As Fig 2-2-6-3). Loosen it to adjust angle)

2-2-7 CONNECT DUST-COLLECTING DUCT

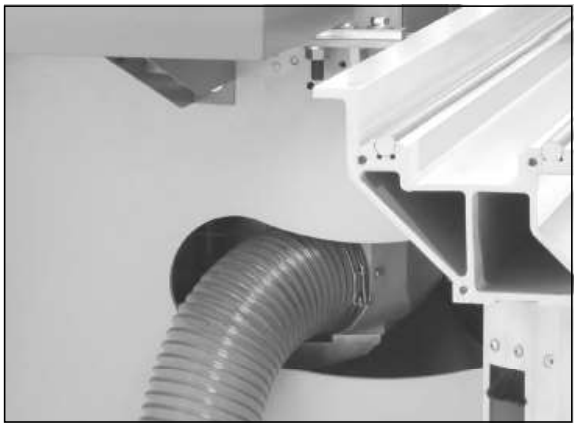


Fig.2-2-7-1

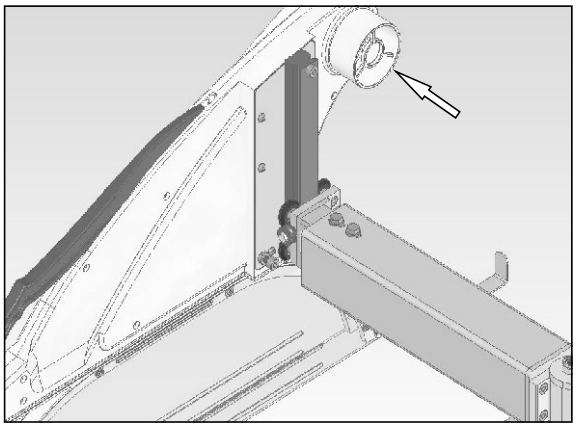


Fig.2-2-7-2

Assembling method：

1. Two dust-collecting guard outlets are installed at the left side of the machine and one dust-collecting guard outlet at the right side. They can be connected to the dust collector by one flexible hose in proper diameter. The diameter of the dust-collecting guard outlet is **5” and 3”** (as Fig. 2-2-7-1).

2. Fig. 2-2-7-2 shows the dust-collecting guard outlet 3”.

The required air flow speed of the flexible hose’s end is 30-34m/sec.
The required air volume of the machine is 1120 – 1390 m3 (43000 -49000 m3).
★ Before the machine starts cutting, please make sure the dust collector is working.

CHAPTER 3

ADJUST / CHANGE

3-1 SLIDING TABLE LOCK

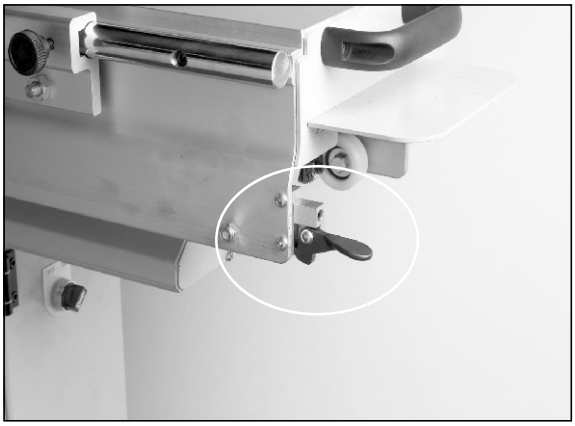


Fig. 3-4-1

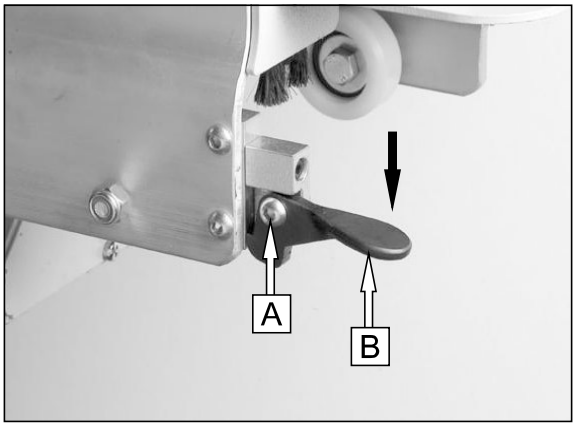


Fig. 3-4-2

Sliding table safety luck:

Safety luck button of new profile sliding table settle in the end of sliding table(as picture); The safety button can fix the sliding table in the middle and the end position , Downward part B could unlock ,Otherwise is lock.

Accessories A and B would be taken off and put into the tooling box in order to put the machines in the wooden case . When new sliding table is settled on themachine , Kindly put the accessories A and B into the position as picture.

★Take your attention if the Part B is downward (unlock) or not before moving the sliding table.

3-2 ADJUST THE RIVING KNIFE

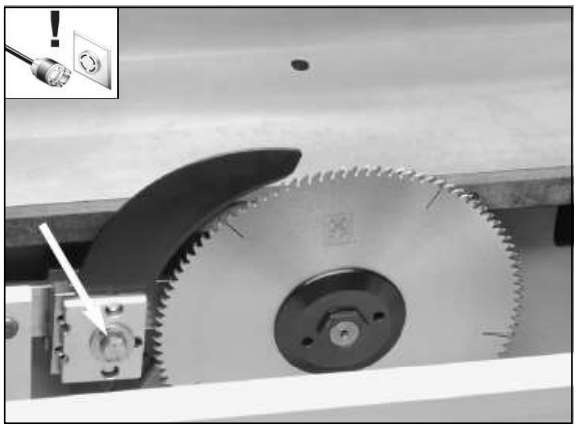


Fig.3-2-1

Fig3-2-2

Adjusting method：

1. Loosen the hexagon screw of the riving knife base (as Fig. 3-2-1) and use three adjusting screws at the side to adjust the riving knife.
2. Max. gap between the riving knife and the saw is 0.2mm (as Fig. 3-2-3).
3. The highest point of the riving knife can't be 3mm higher than the highest saw tooth in the wood. Gap between the saw and knife must be the min. 3mm and the max. 8mm crossing the saw (as Fig. 3-2-4).

★ **After adjusting, please make sure to lock the hexagon screw of the riving knife base (as Fig. 3-2-1).**

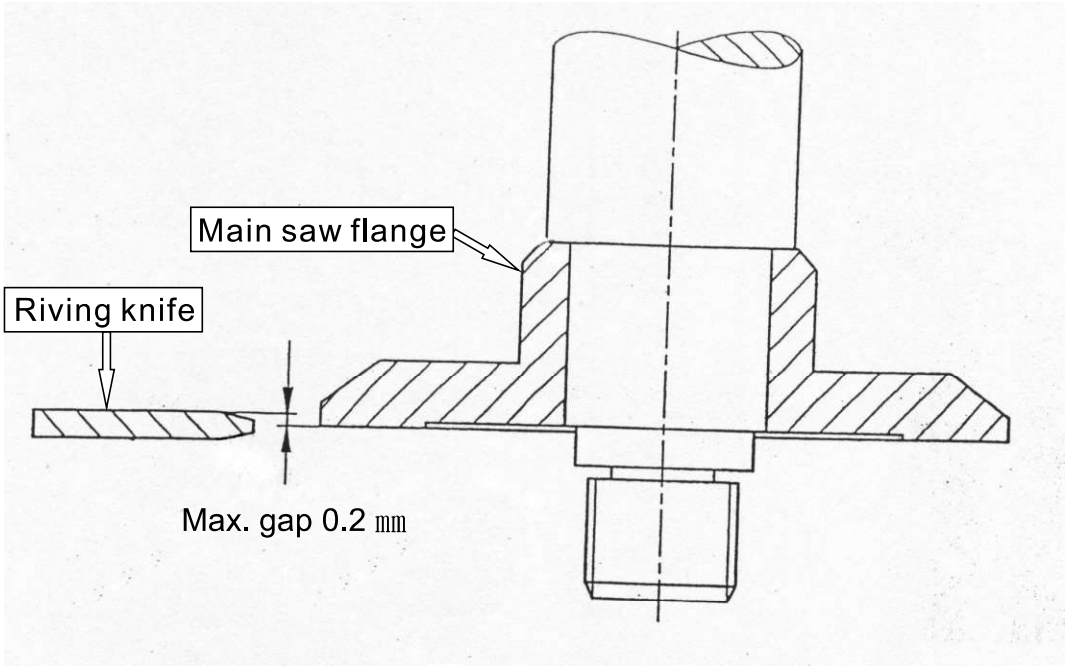


Fig.3-2-3

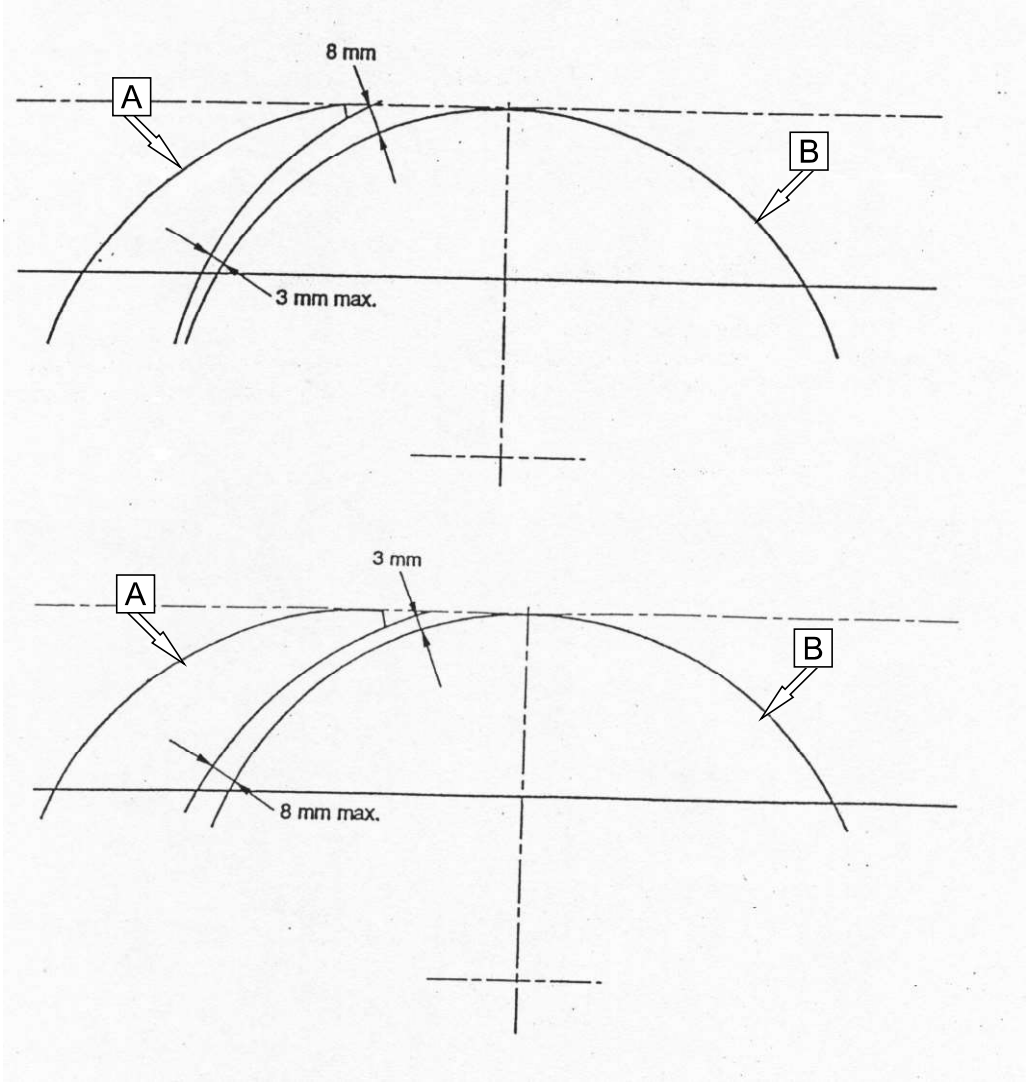


Fig.3-2-4

In above Fig., A is the riving knife and B is the saw.

3-3 CHANGE MAIN SAW

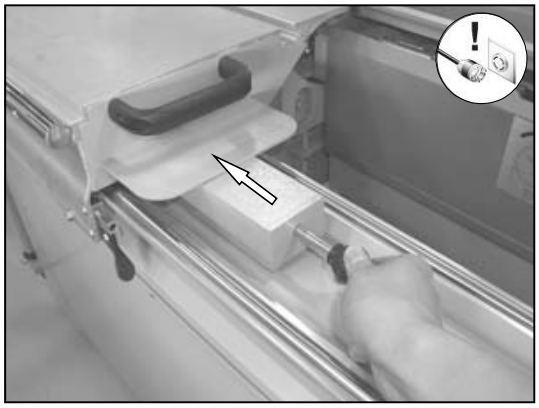


Fig.3-3-1

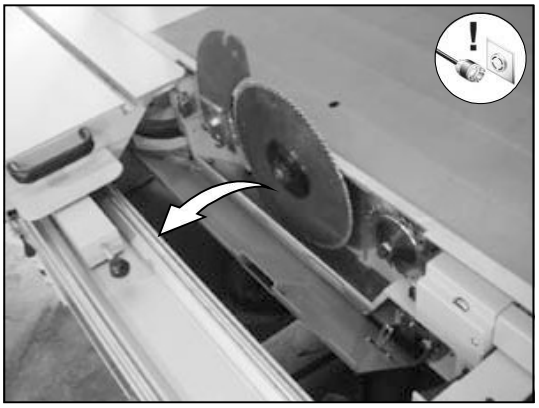


Fig.3-3-2

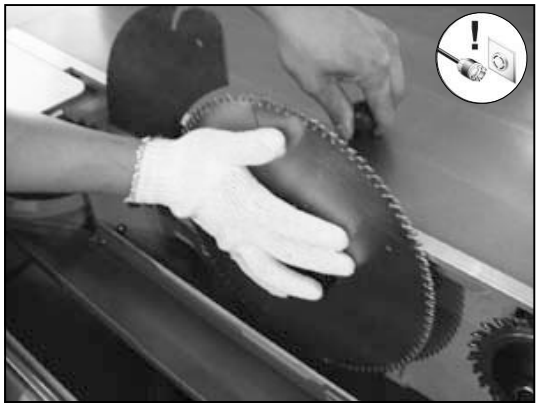


Fig.3-3-3

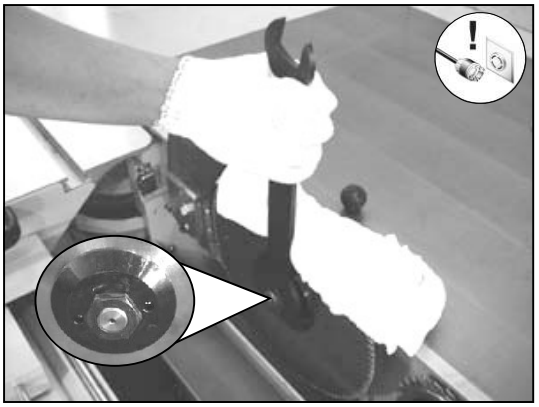


Fig.3-3-4

Before changing the saw, please make sure if the power is closed to avoid danger. Before changing the saw, please install the protective film to protect the saw and avoid injury while changing the saw.
Main shaft speed ration follow up the ration limiting rage to preventing the danger.

Assembling steps as follows：

1. Move the sliding table forwards and push the inside ball bead inwards and then put the sliding table forwards to the position of changing the saw.
2. Open the saw cover (as Fig. 3-3-2).
3. Lift the arbor of the saw to the highest position and insert the fixing pin into the hole of the cast iron table to fasten the saw (as Fig. 3-3-3).
4. Use the wrench in the tool box to turn the arbor until the fixing pin and hole inside the arbor align (as Fig. 3-3-4). Clockwise turn to remove the nut and cam (main saw's nut is left thread, so clockwise turn to loosen and anticlockwise turn to tighten).

CHANGE

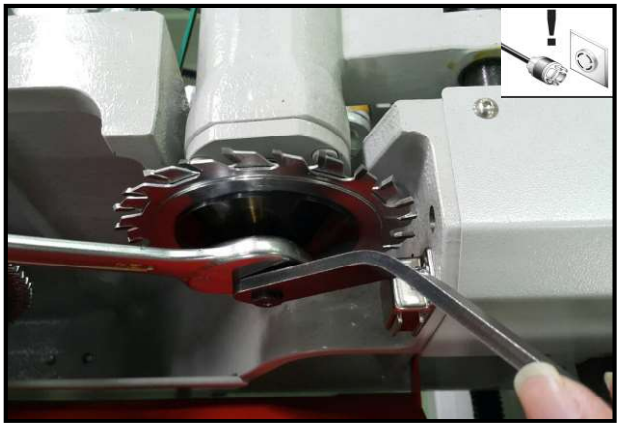


Fig.3-4-4

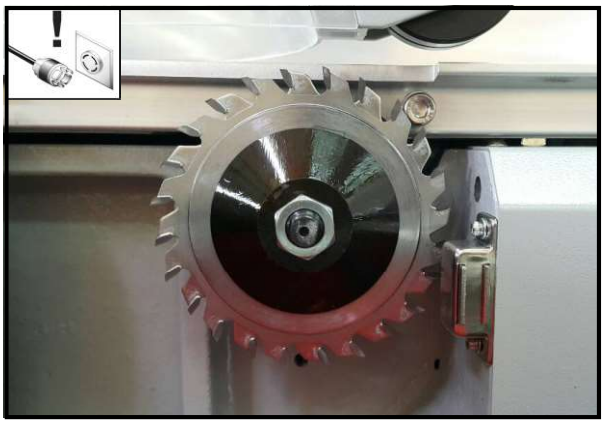


Fig.3-4-5

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

Assembling steps as follows：

1. Same as item 1 of 3-3 Change Main Saw.
2. Lower the scoring saw to the floor and put the wrench on the even place of the arbor and then grip it.
3. Use knob to release and tighten the clamping screw. CW. for tighten. CCW. for release. (as Fig. 3-4-4).
4. Make sure the new saw and flange are clean. Install the new saw and use 250kg/cm torque to tighten the arbor's nut (as Fig. 3-4-5).

★ **After changing, please make sure if the arbor's nut of the scoring saw is tightened to prevent its drop from causing danger while machine is running.**

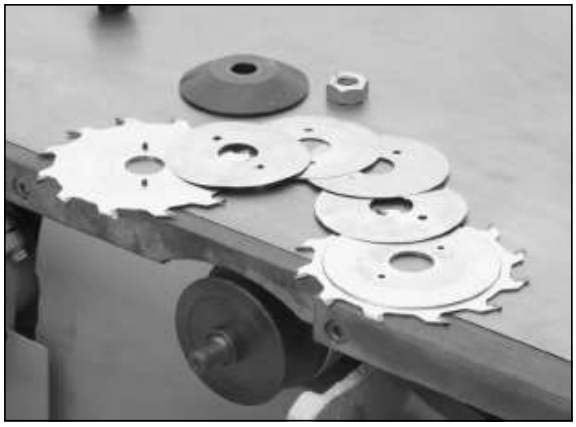


Fig.3-4-6

Gasket shown in Fig. 3-4-6 is to adjust the cutting width of the scoring saw to be bigger than the cutting width of main saw so that the workpiece will be nicer looking.
The thickness of the attached scoring saw is 2.8mm. It can be adjusted to 4.3 mm.
Gasket of the scoring saw is 1pcs for 0.1mm , 1pcs for 0.2mm and 4pcs for 0.3mm.

3-5 CHANGE SPINDLE ROTATING SPEED

Belt tension of main motor is set at about 220kg.cm. The steps of changing main motor's rotating speed as follows：

1. Turn the hand wheel to make the saw lower to the bottom (as Fig. 3-5-1).
2. Loosen the screw to open the rear door.
3. Loosen the adjustable handle (as A shown in Fig. 3-5-2).
4. Press down the handle (as B shown in Fig. 3-5-2) to lift the motor board to loosen the belt.
5. Put the belt into the slot of the pulley to be changed (please refer to Fig. 3-5-4 for each rotating speed's position).
6. Push the rotation speed switching rod to required position (as the position shown in Fig. 3-5-3).
7. Make sure belt has been set onto the groove of the pulley. Check if rotation speed switching rod is on a correct rotation speed position.
8. Push the handle (as B shown in Fig. 3-5-2) to lower the motor board to pull tightly the belt and lock the adjustable handle (as A shown in Fig. 3-5-2).
9. The machine has the rotating speed 3000, 4000, 5000, r.p.m. available for change (as Fig. 3-5-4).

⚠ Main shaft speed ration follow up the ration limiting range to preventing the danger.

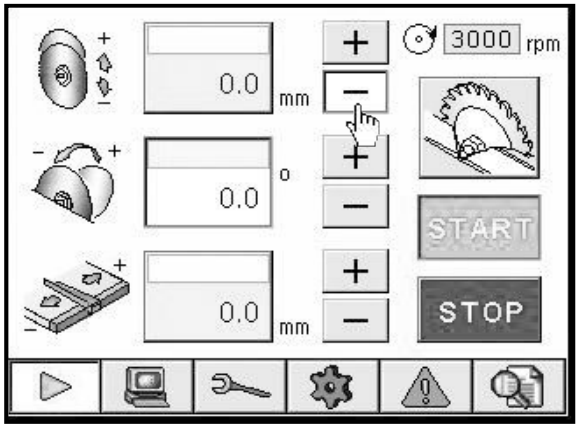


Fig.3-5-1

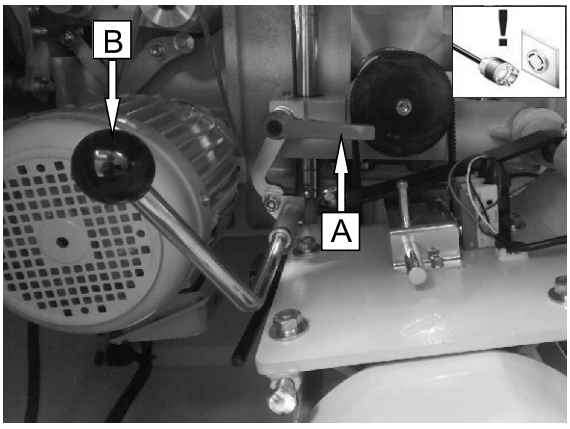


Fig.3-5-2

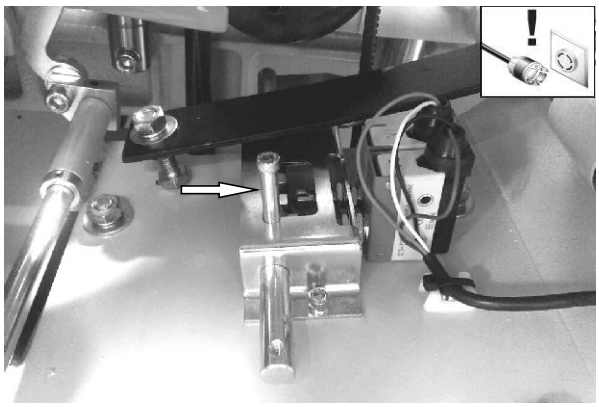


Fig. 3-5-3

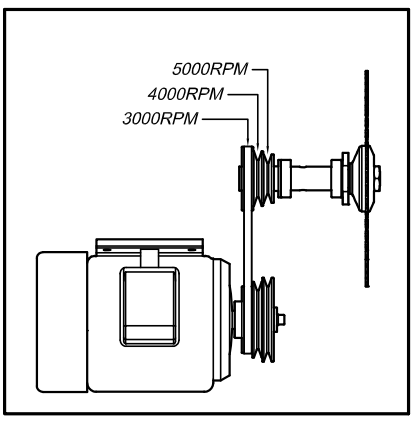


Fig.3-5-4

3-6 ADJUST SAFETY GUARD

ADJUST

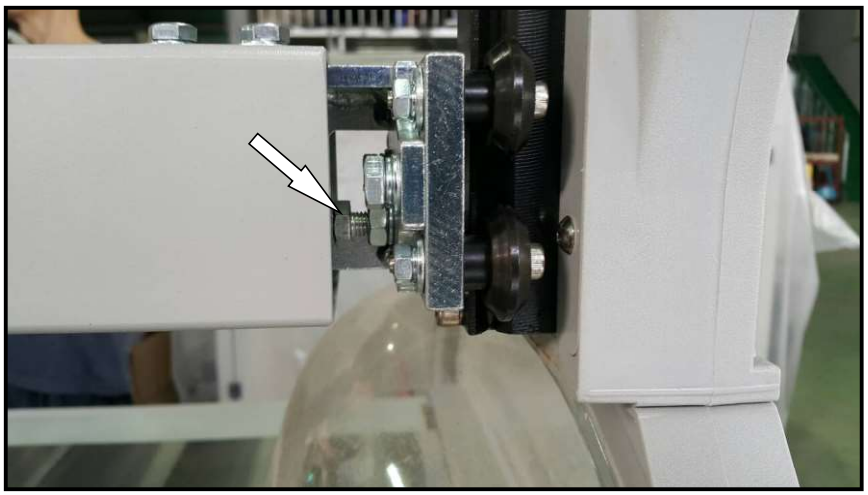


Fig.3-6-1

Adjust up/down of the saw guard：

1. Use hand to slightly move the saw guard up or down.
2. The screw shown in Fig. 3-6-1 is to adjust the tightness/looseness of up / down movement of the saw guard.

The safety guard can be moved up to any place but must be firmly tightened at that place to avoid it moving down. After it's used for a long time, the part will be worn. So, please adjust its tightness again.

CHANGE

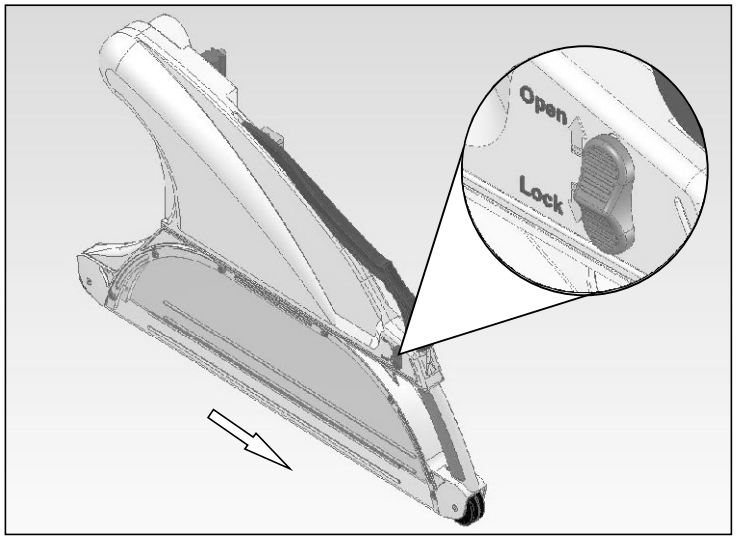


Fig.3-6-2

Replacement：

Push up the lock button on the saw guard (Figure 36-2) loosen the saw blade shield to outward can be replacement. (As Figure arrow direction)

Attention!

In order to prevent the saw blade touch the saw shield during the replacement, kindly downward the saw blade to the bottom and move the saw guard unit to the upward.

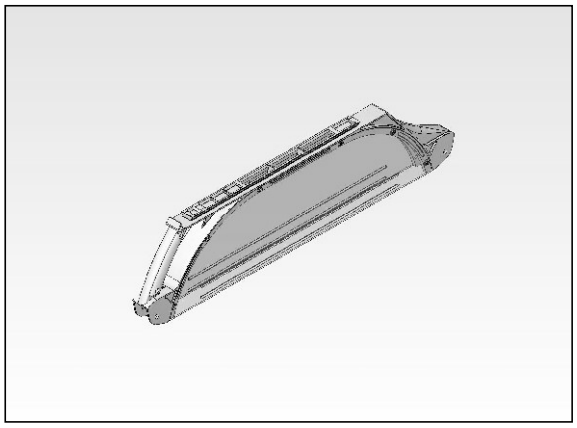


Fig.3-6-3

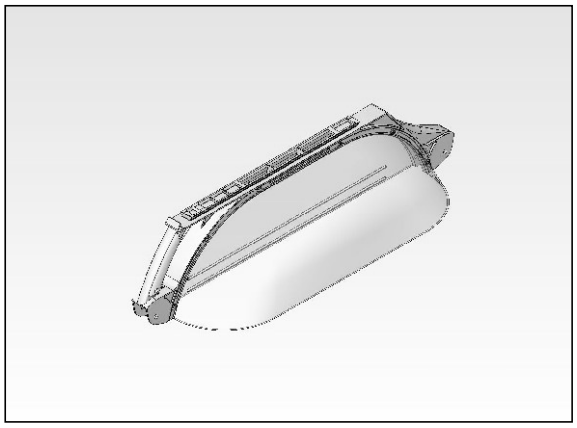


Fig.3-6-4

★ **While cutting workpiece：**

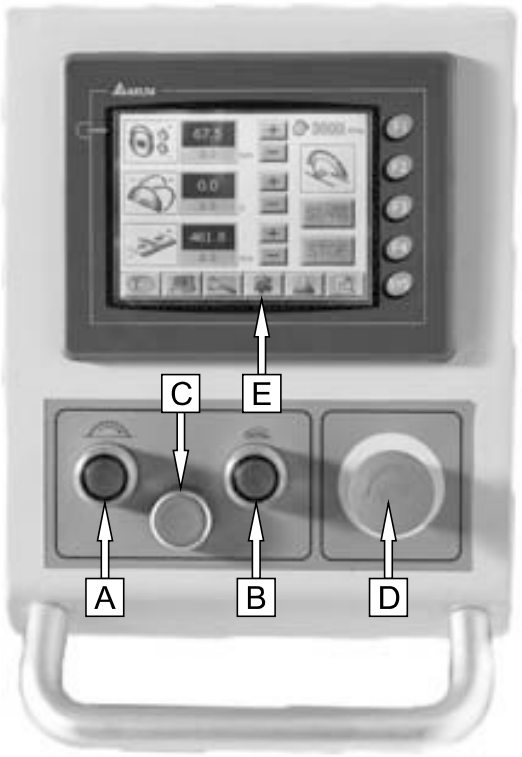
At 90 cutting, 90 special safety guard must be used (as Fig. 3-6-4).

At angular cutting, special angular safety guard must be used (as Fig. 3-6-5).

CHAPTER 4

OPERATION OF TOUCH SCREEN CONTROL PANEL

4-1 Functional Explanation of Main Keys



A. Main saw blade on button----------Starts the main saw blade.

B. Scoring saw blade on button--------Starts the scoring saw blade.

C. Saw blade off button----------Stop the main saw blade and scoring saw blade.

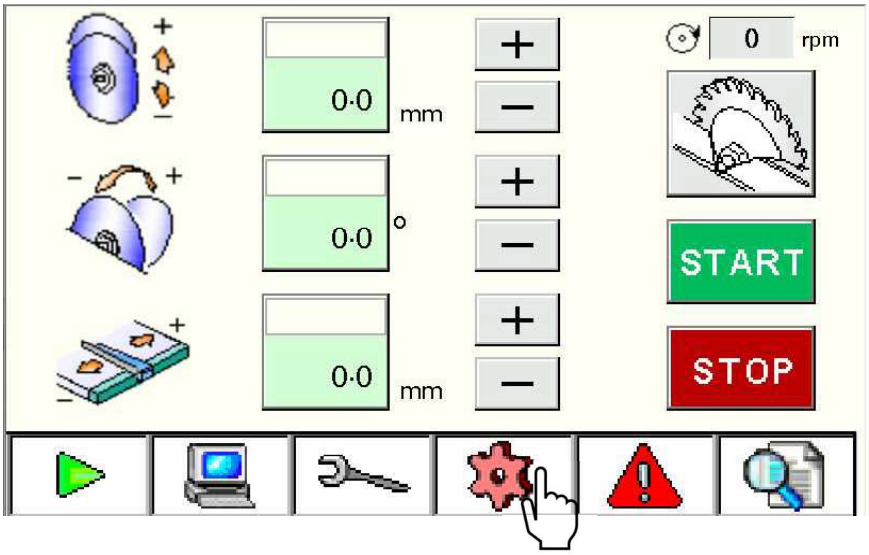
D. Emergence----------Disconnects power to all motors in the motor cabinet.

E. Touch screen----------Touch screen for control all the axises movement.

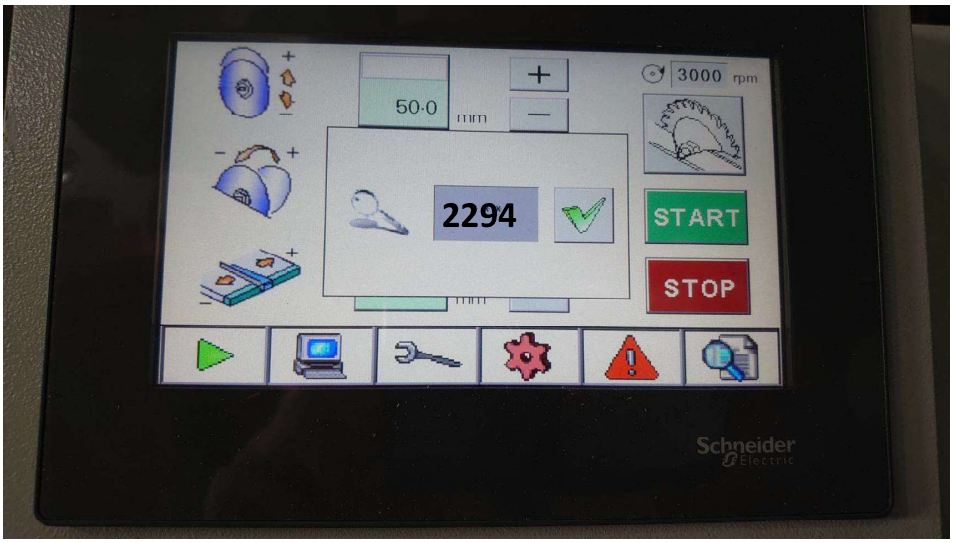
Rip fence Self Learning

Please do rip fence Self Learning on All the machines when finishing machine installing and machine just with power connected at the beginning.

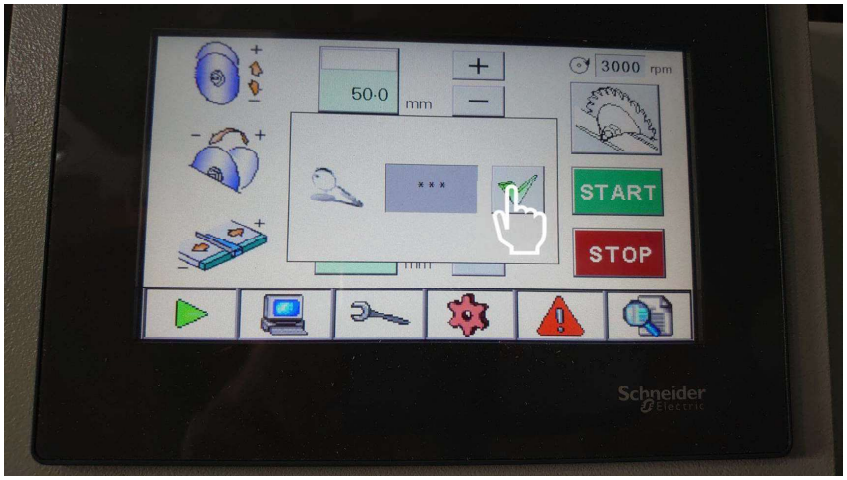
1-1 press  in the bottom of screen



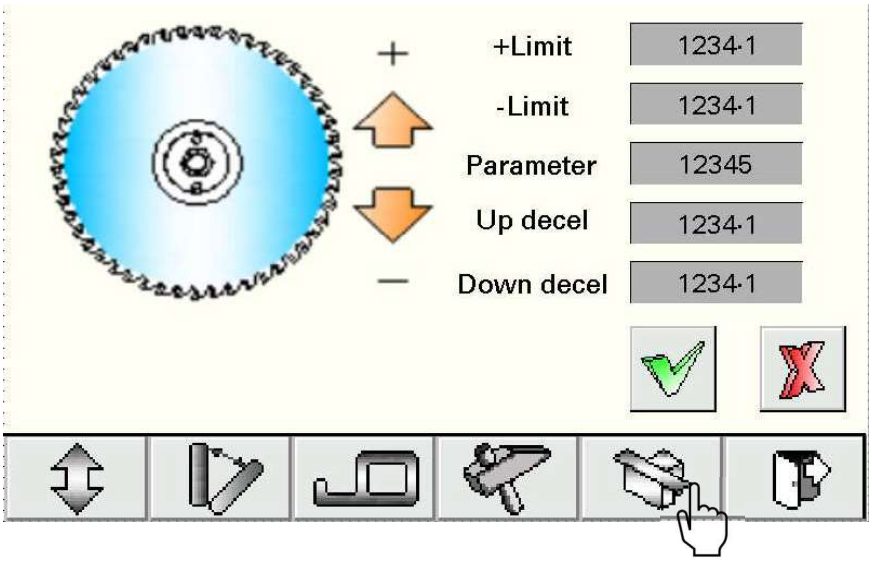
1-2 Please enter password: 2294



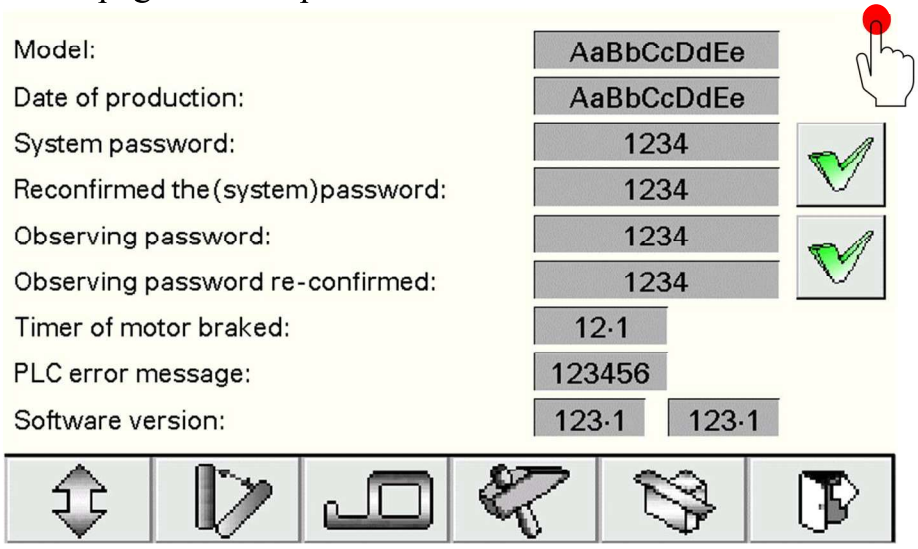
1-3 Confirm 

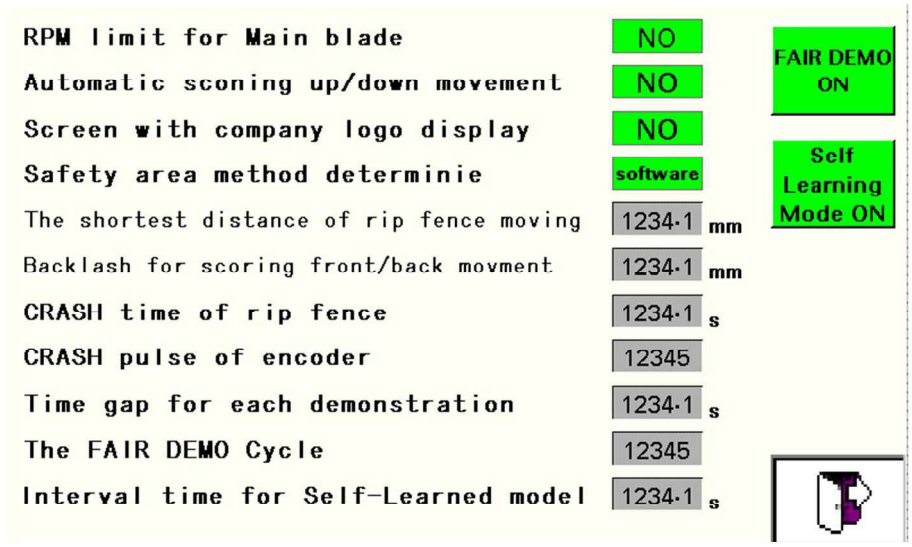


1-4 Press  in the bottom of screen

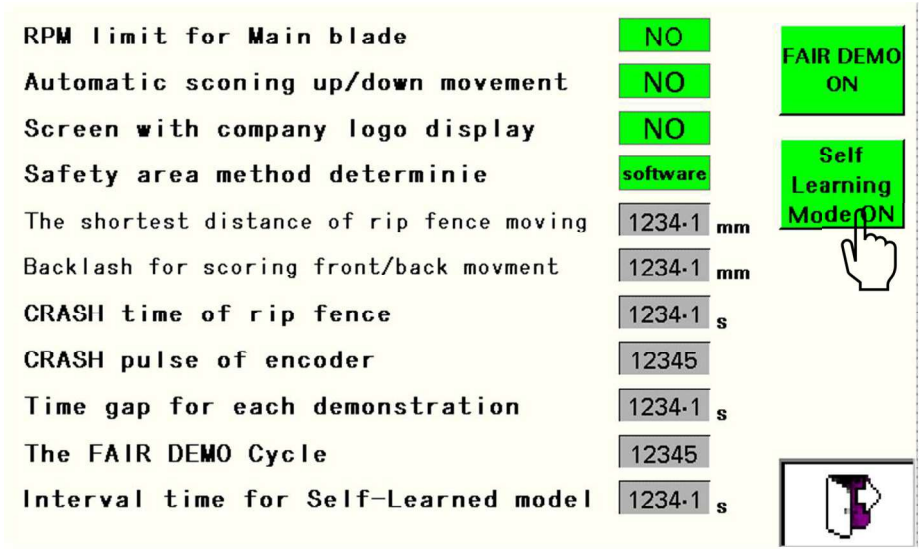


1-5 Press point on the upper right of screen for a period of time (3-5 seconds around) till below page shows up



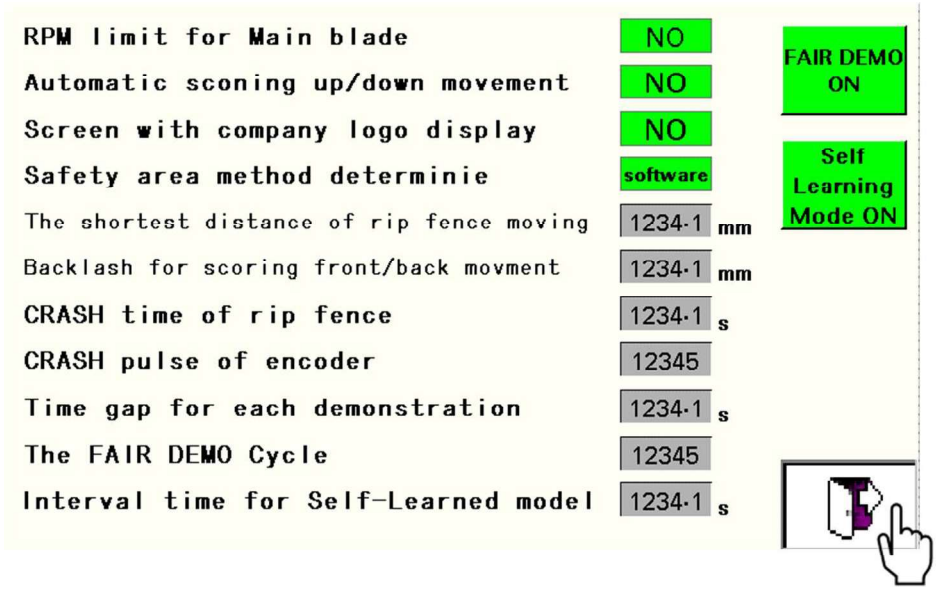


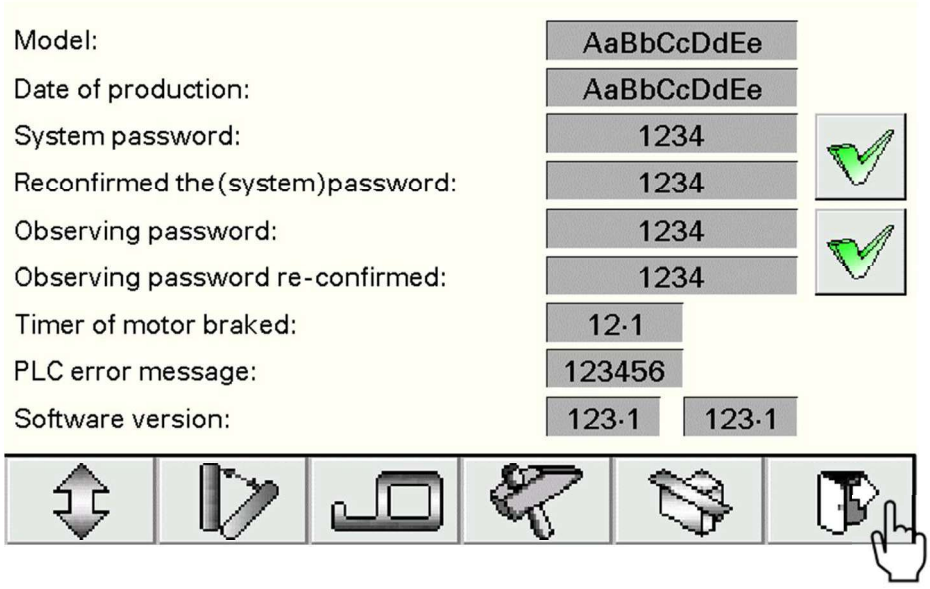
1-6 Press button “Self Learning Mode On” to run “Self Learning”, rip fence will run self learning automatically

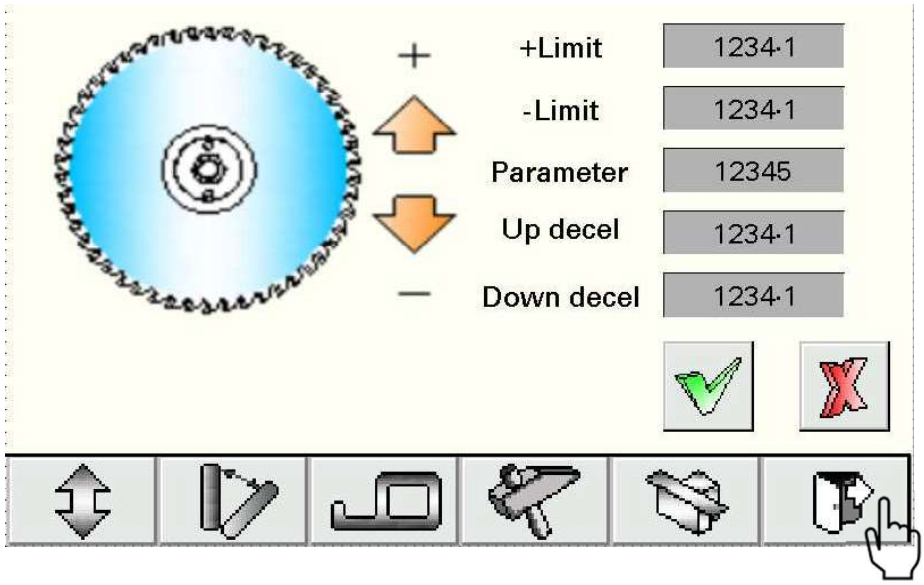


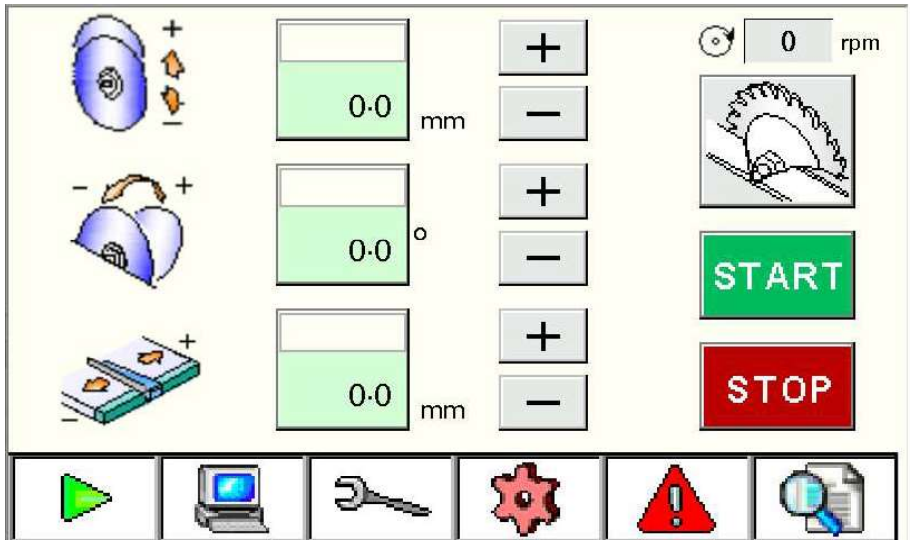
1-7 Please let the rip fence to run self learning for at least 15-20 minutes.

1-8 After 15-20 minutes of Self Learning, please press EXIT button  in the right bottom corner to exit from page to page, and finally return back to Main Page.

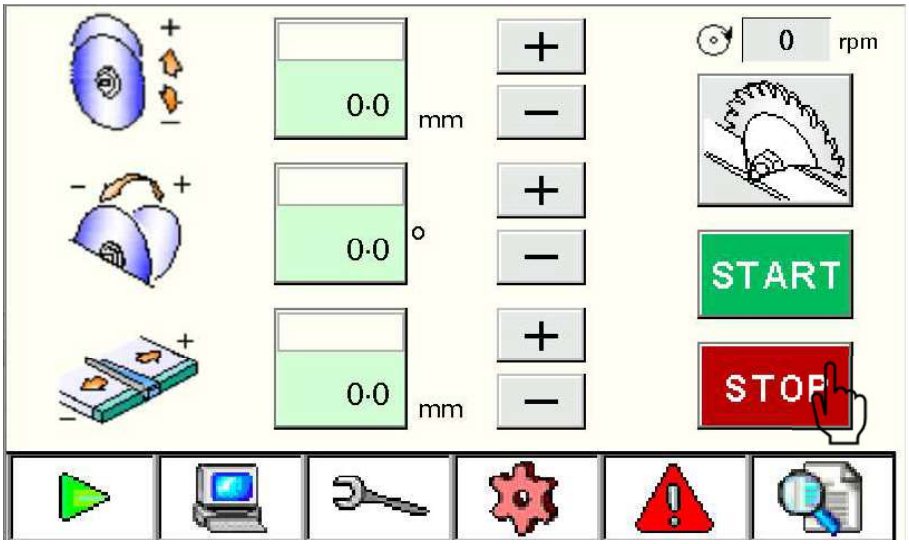



Model:
AaBbCcDdEe
Date of production:
AaBbCcDdEe
System password:
1234
Reconfirmed the(system)password:
1234
Observing password:
1234
Observing password re-confirmed:
1234
Timer of motor braked:
12·1
PLC error message:
123456
Software version:
123·1
123·1

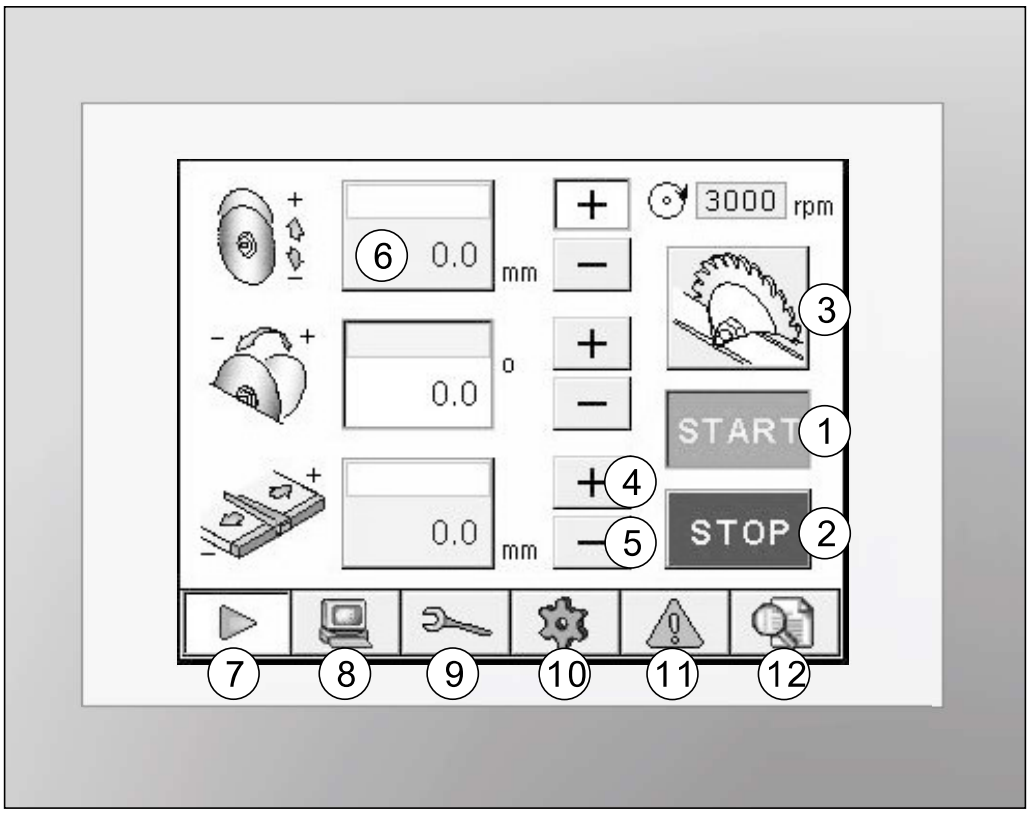

+Limit
1234·1
-Limit
1234·1
Parameter
12345
Up decel
1234·1
Down decel
1234·1


0·0
mm
0·0
o
0·0
mm
0
rpm
START
STOP

1-9 Please press STOP button  in the main page to finish Self Learning mode.

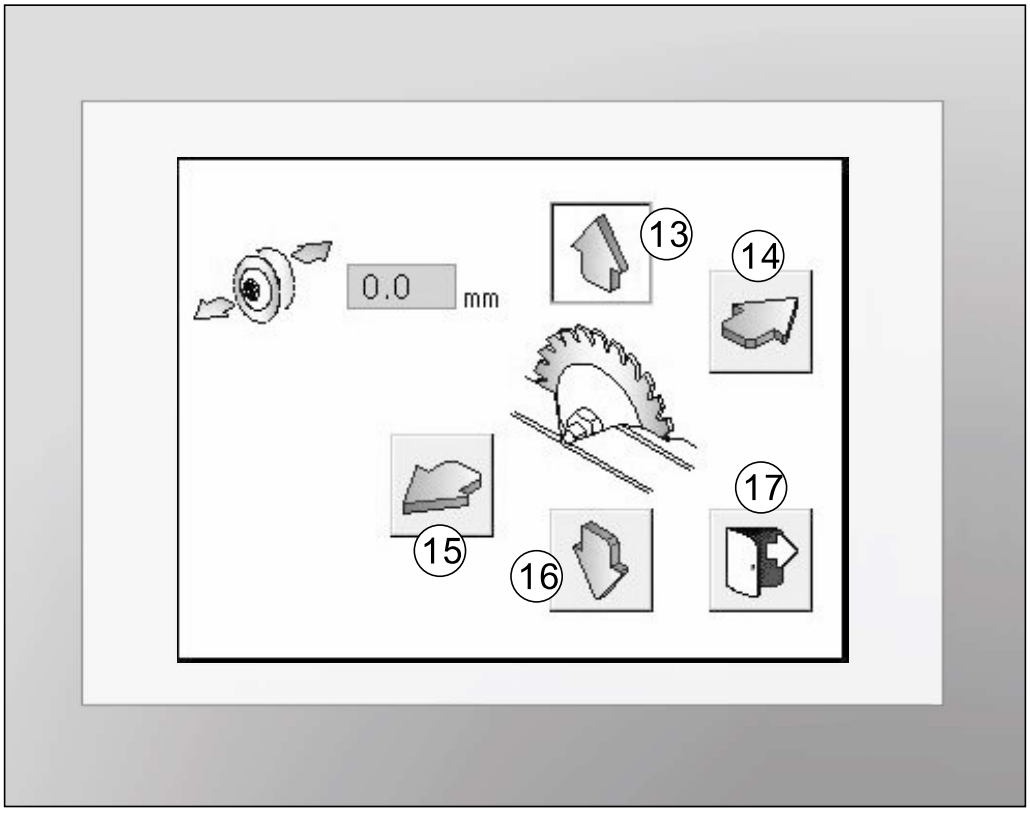


1. Home page



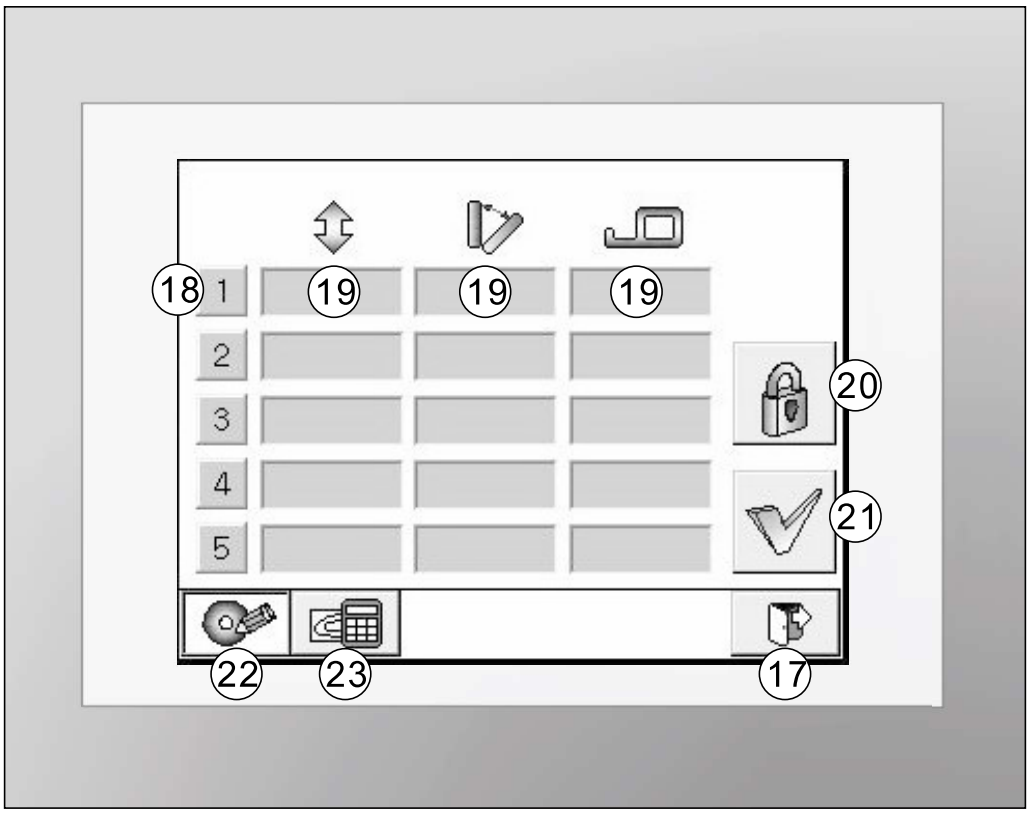
1. Home page

1.1 Operation Page of Scoring Saw

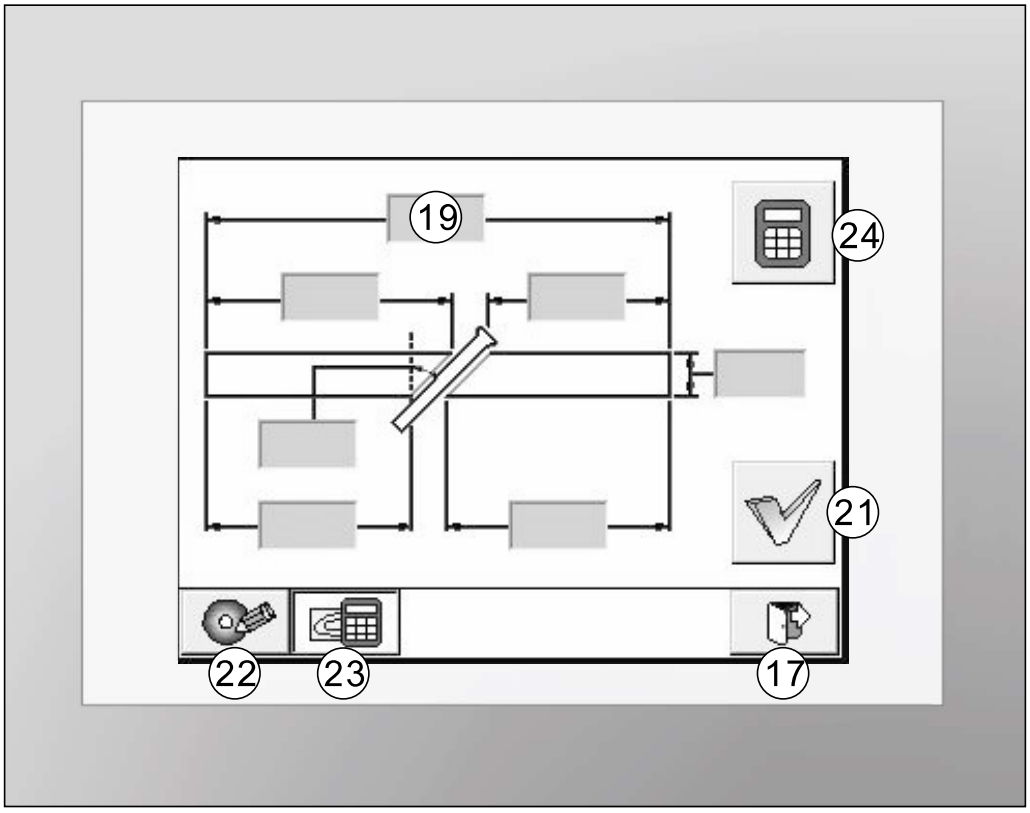


2. Functional Operation Page

2.1 Processing Editing Page

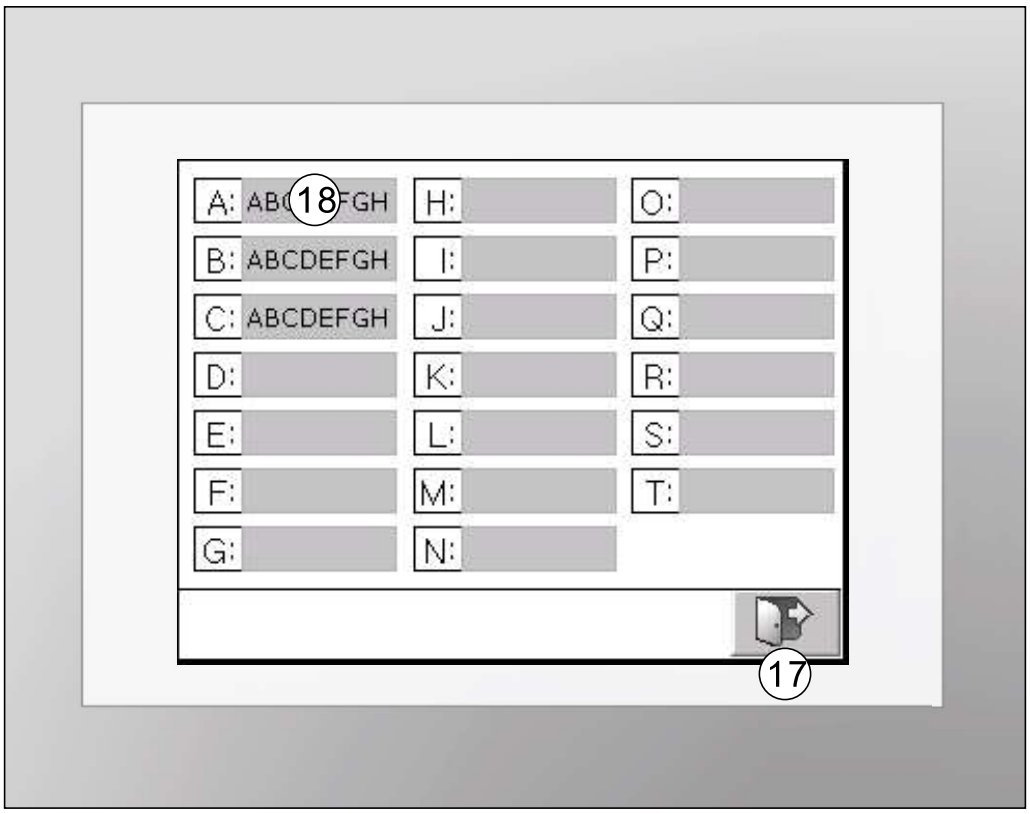


2.2 Dimension Calculating Page

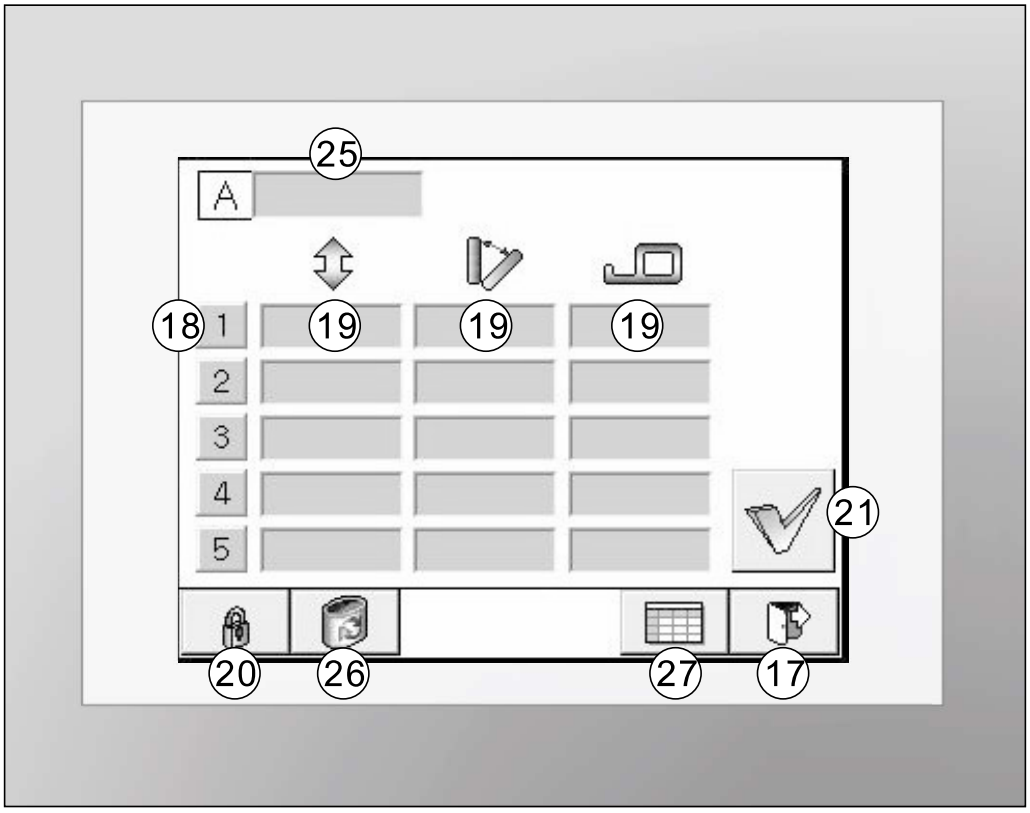


3. Program Operation Page

3.1 Group Selection Page

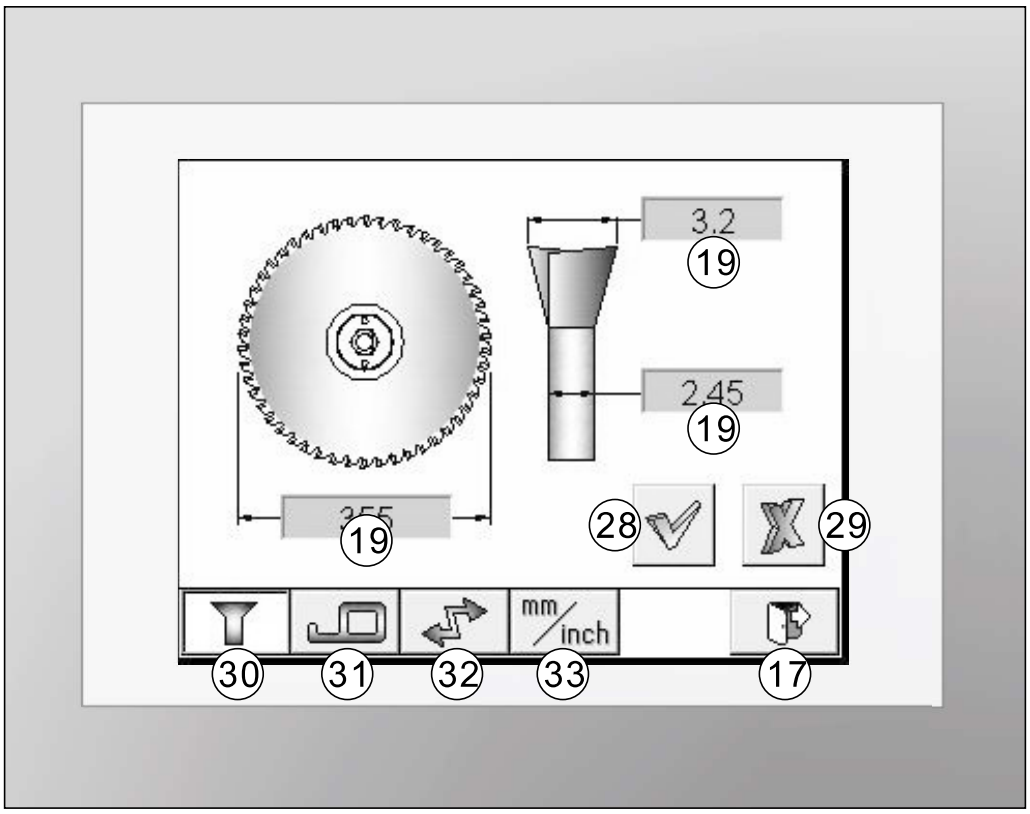


3.2 Program Editing Page

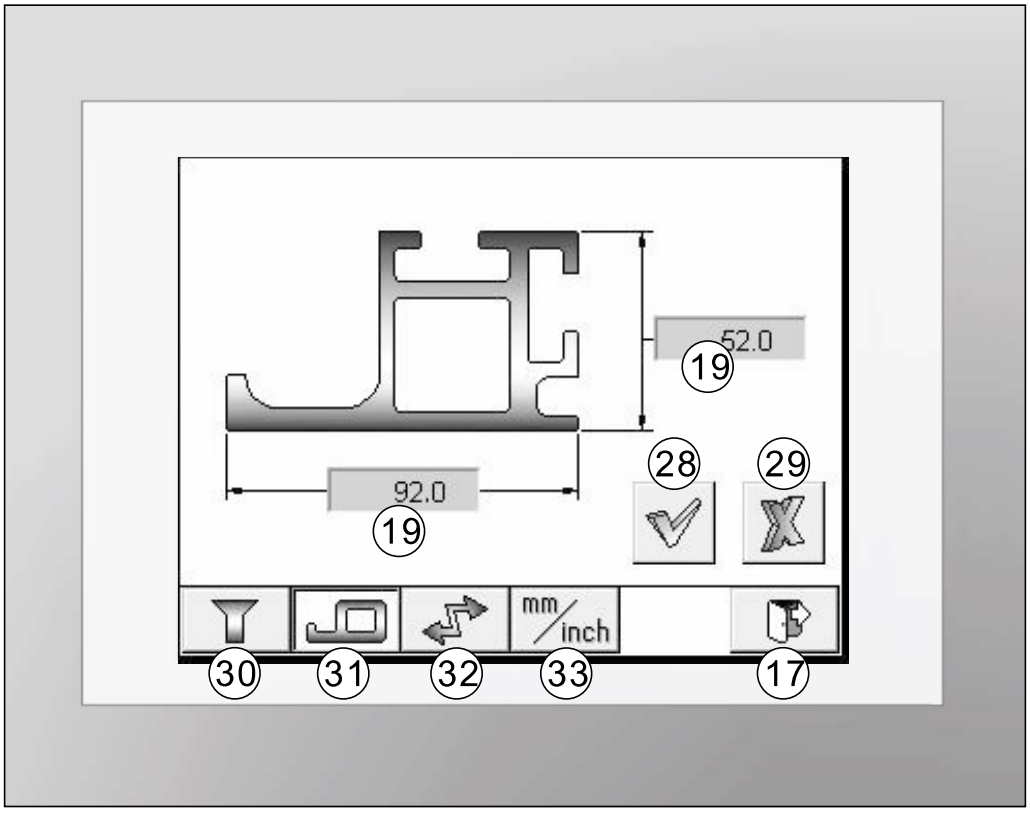


4. Setting Operation Page

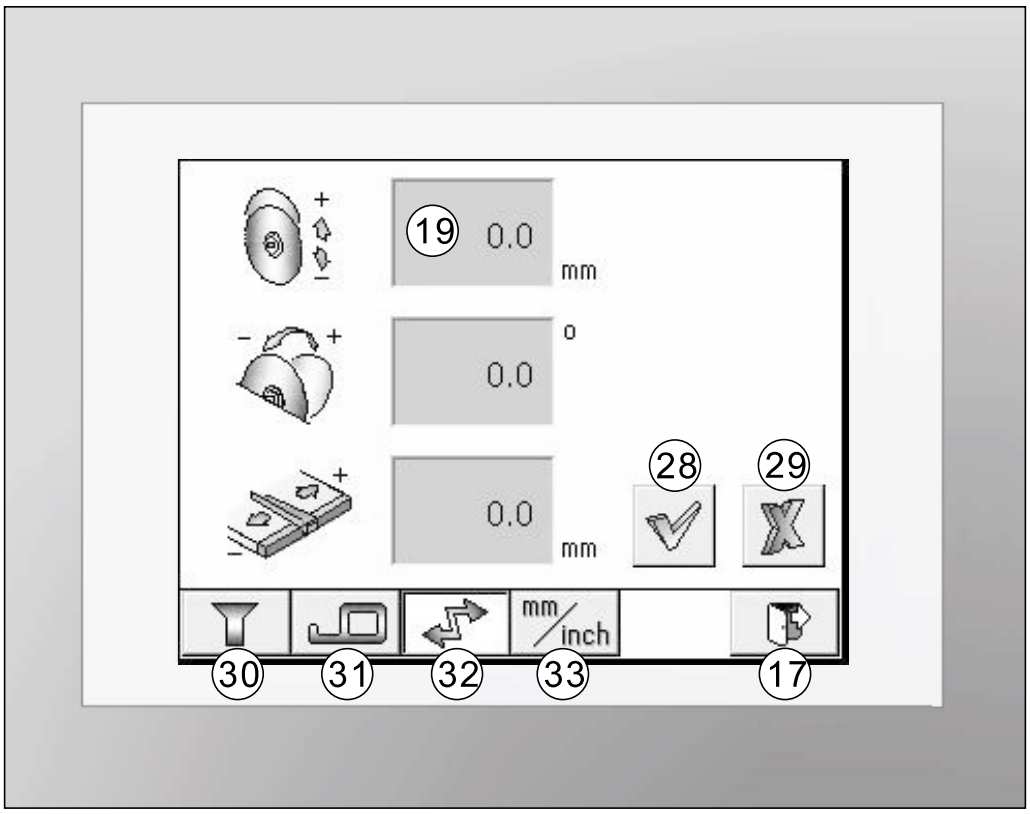
4.1 Saw Blade Specification Page



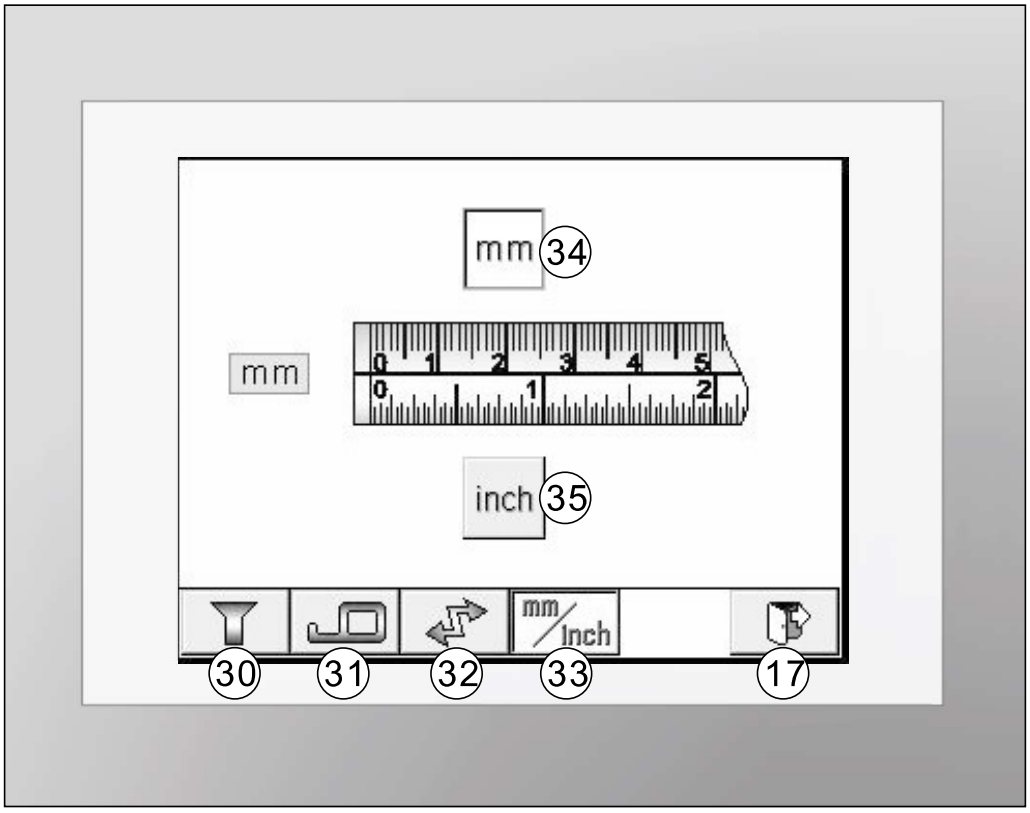
4.2 Fence Size Page



4.3 Position Correction Page

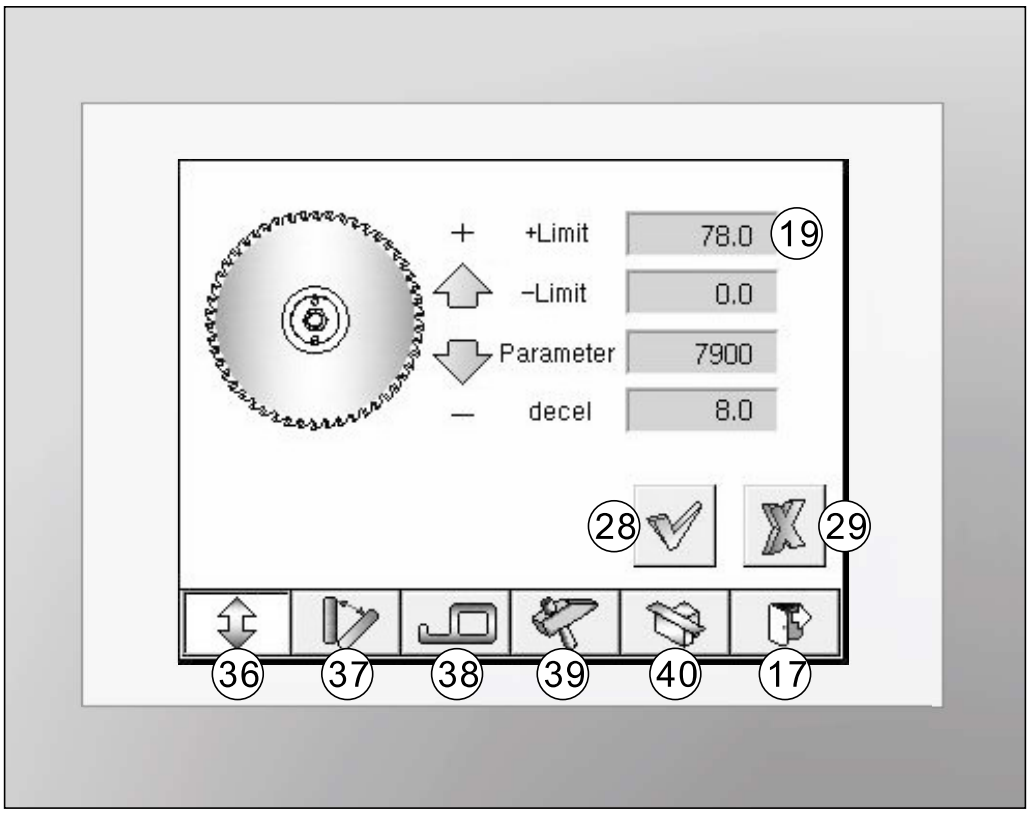


4.4 Unit Change Page

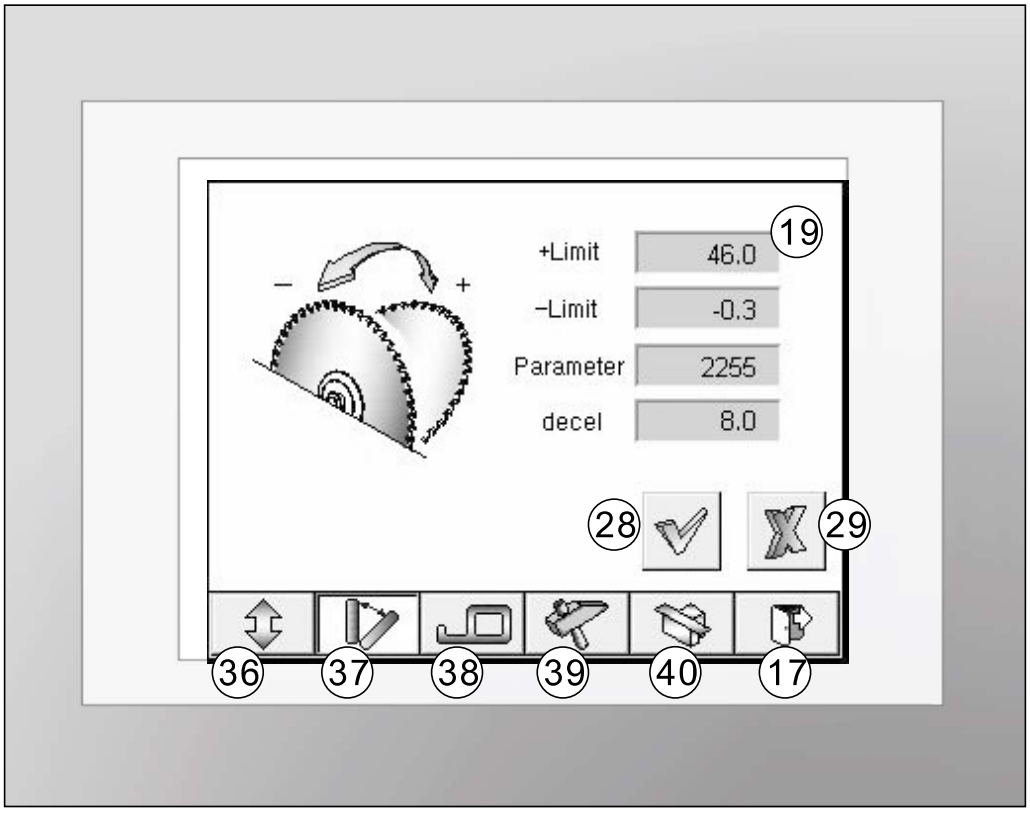


5. System Operation Page

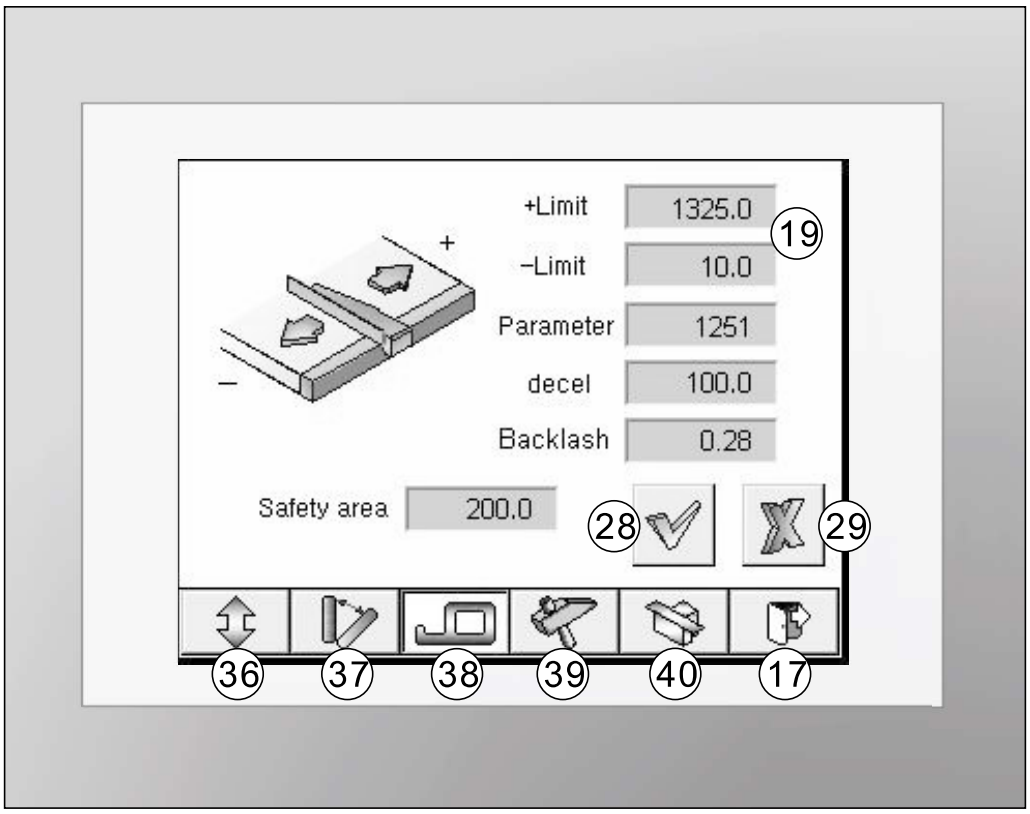
5.1 UP/DOWN Parameter Page



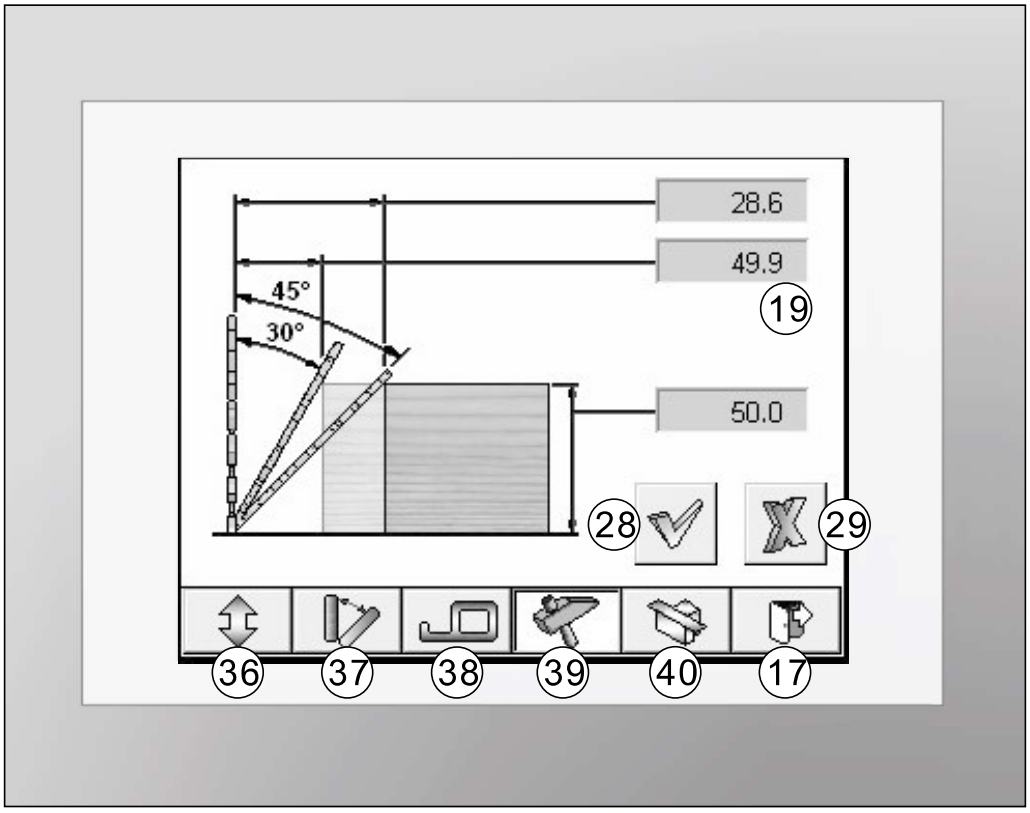
5.2 Tilting Parameter Page



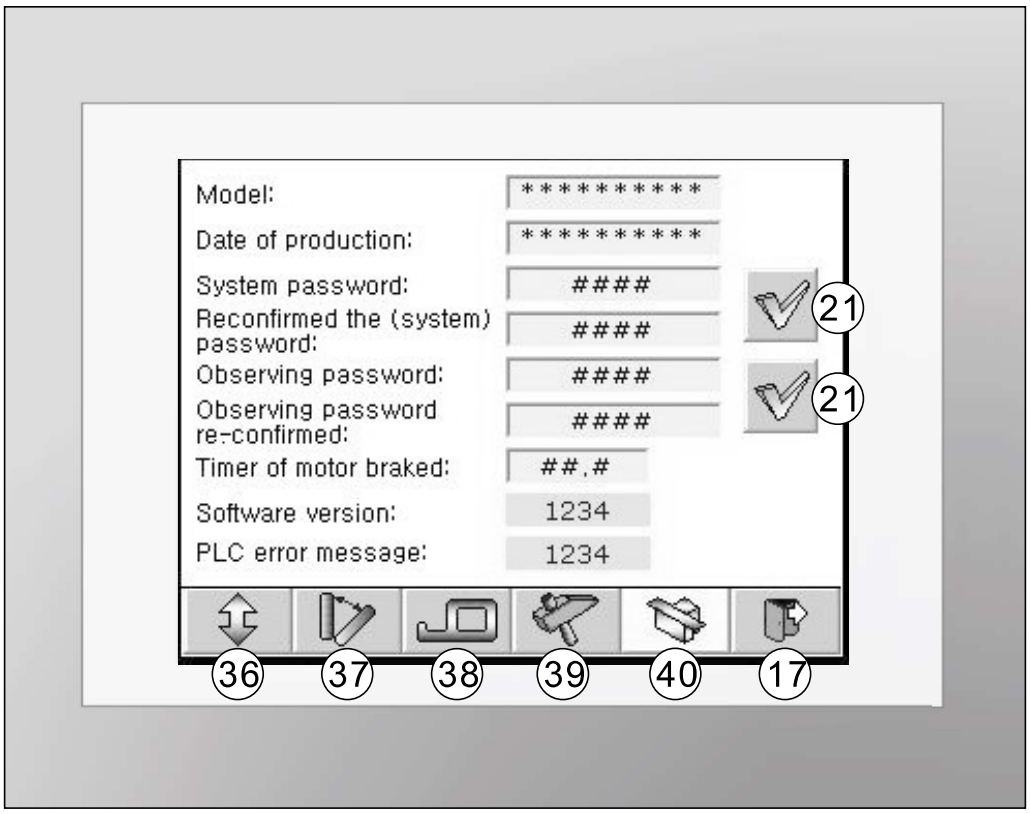
5.3 Rip Cut Fence Parameter Page



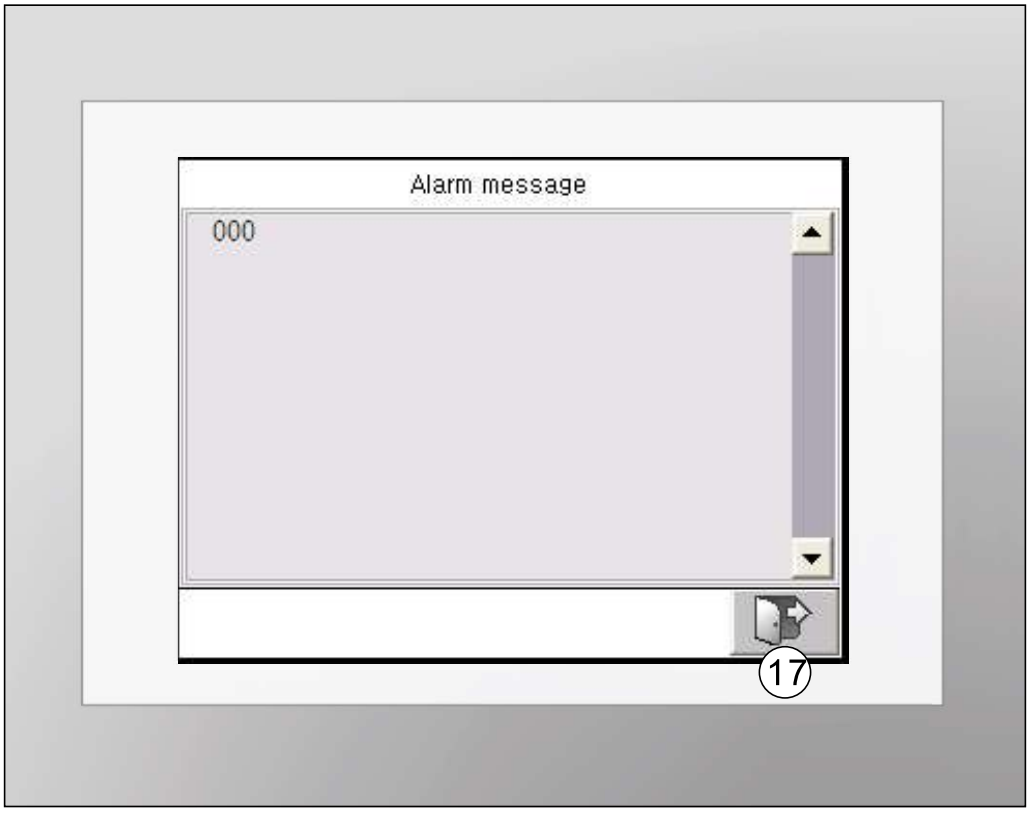
5.4 Main Saw Blade tilting Rotary Center Correction



5.5 Machine's Data Page

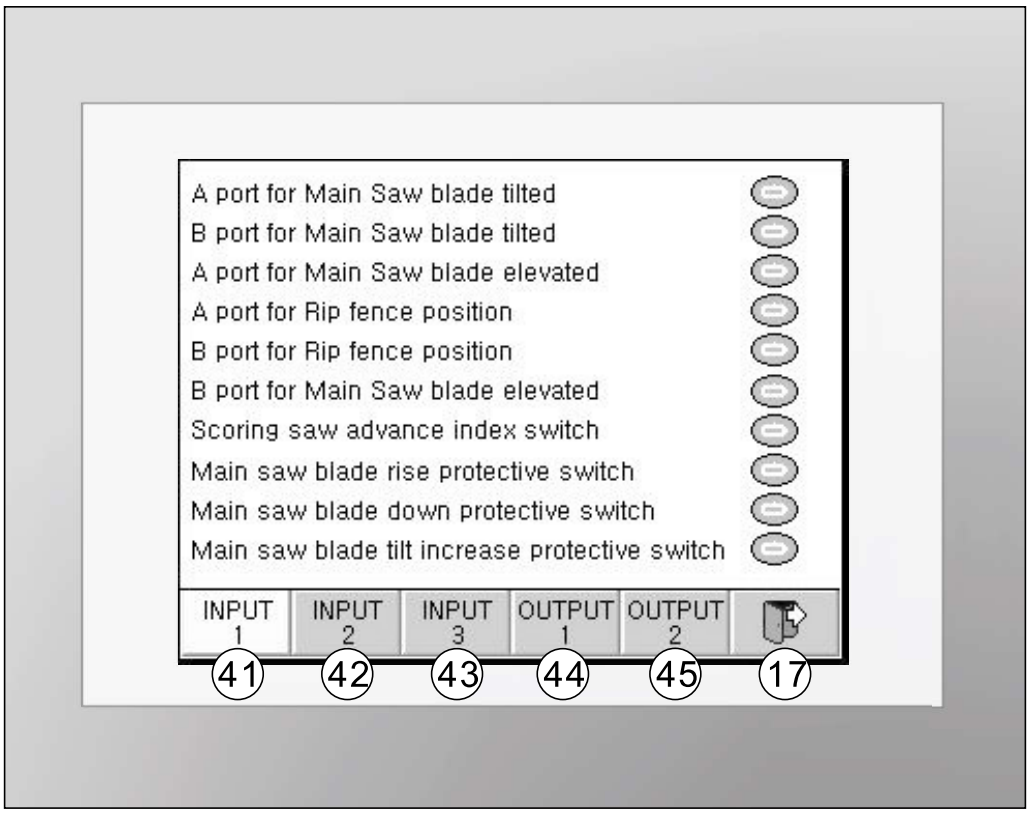


6. Error Data Page

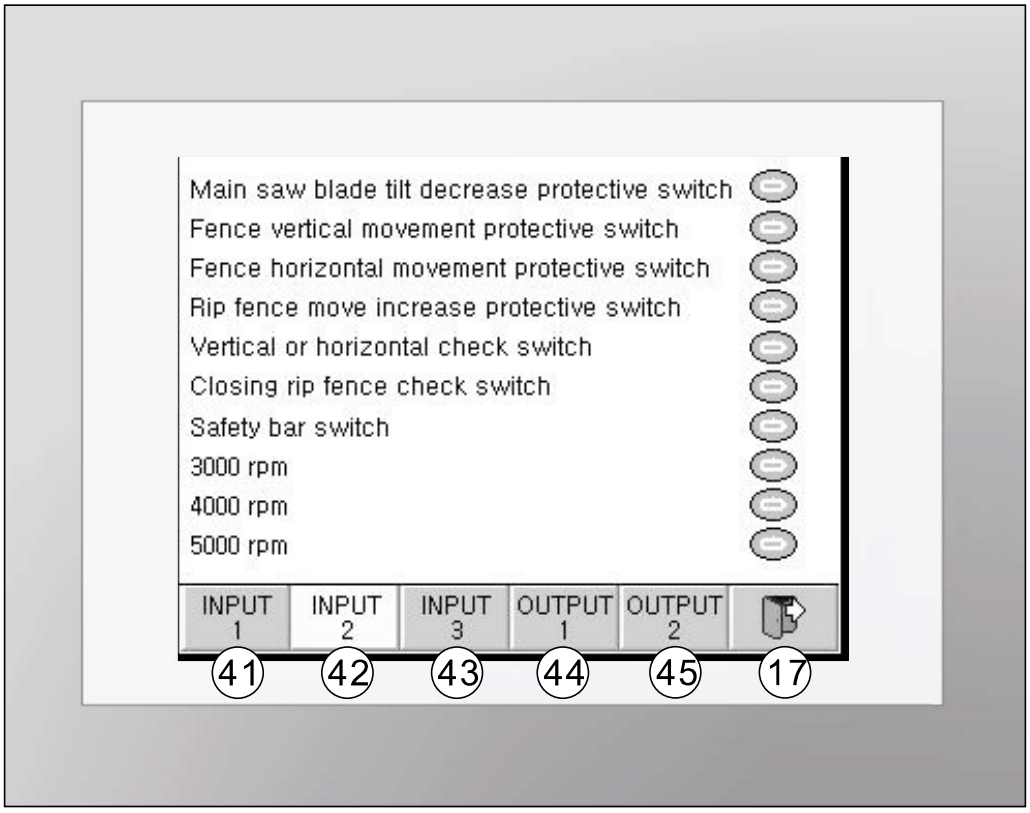


7. Monitor Data Page

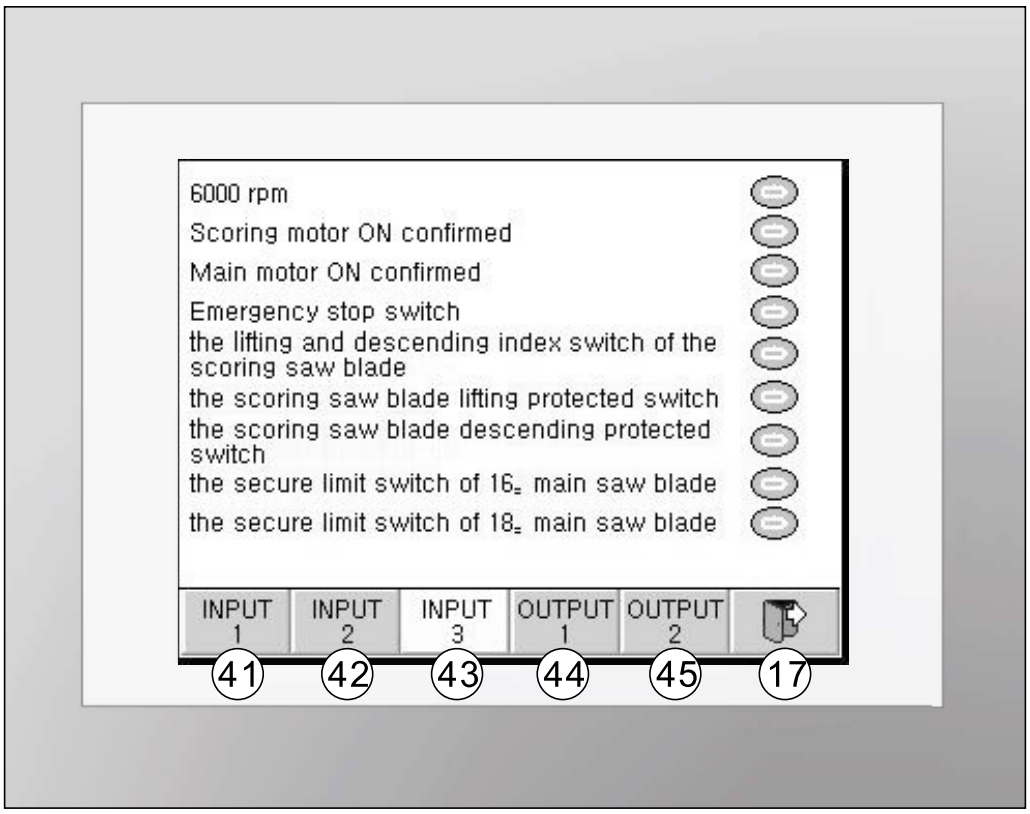
7.1 Input Data Page (1)



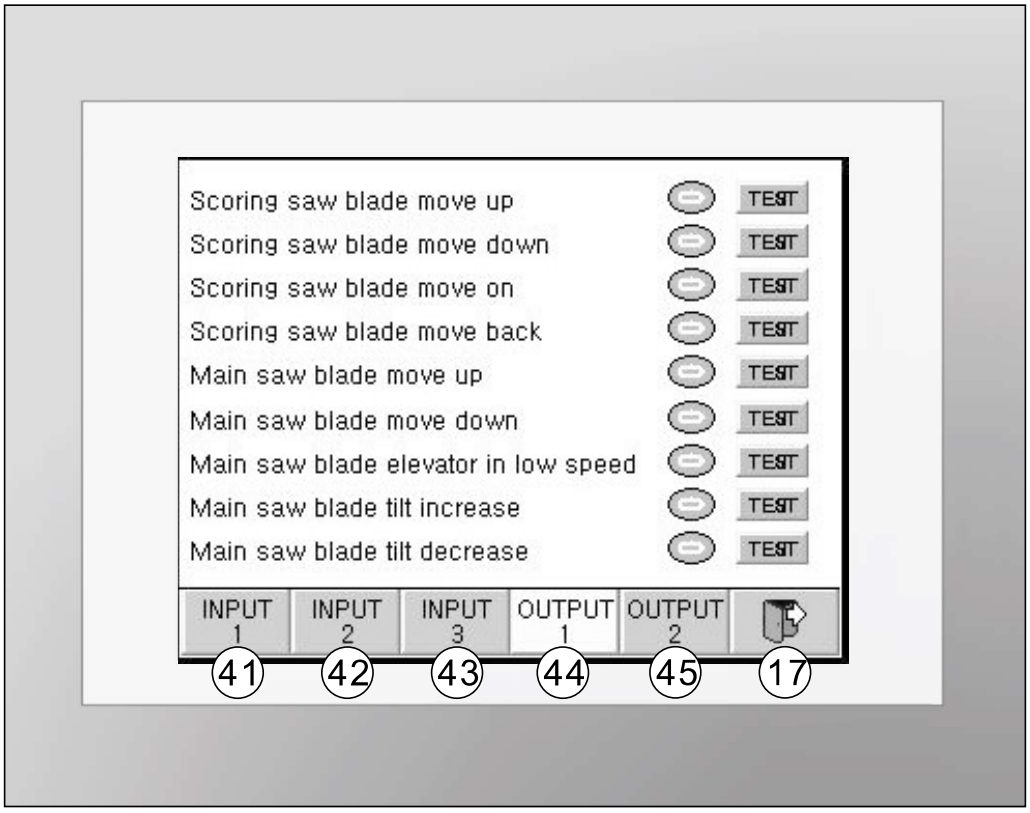
7.2 Input Data Page (2)



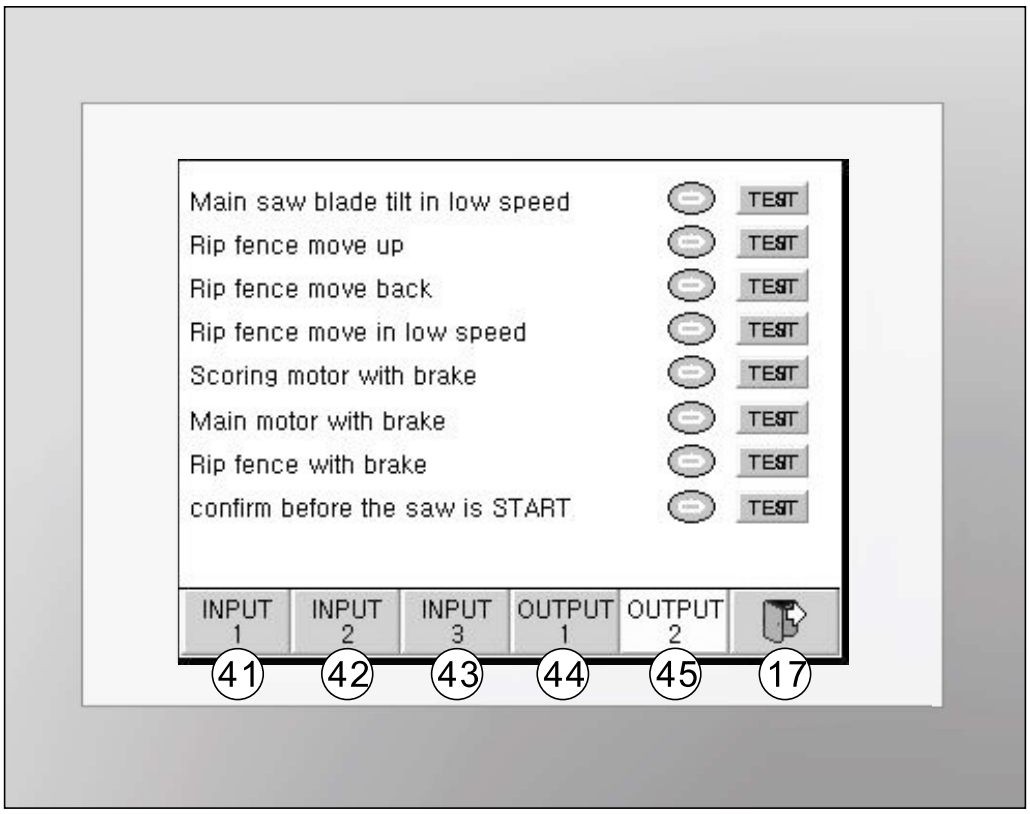
7.3 Input Data Page (3)



7.4 Output Data Page (1)



7.5 Output Data Page (2)



8. Functional Explanation of Keys

1. START : ..... A key for starting running such as main saw blade up/down movement, tilting angle, etc.

   Note: The START is only for controlling movement excluding saw blade's running.

2. STOP: ..... A key for stopping running such as main saw blade up/down movement, tilting angle, etc.

   Note: The STOP is only for controlling movement excluding saw blade's stop.

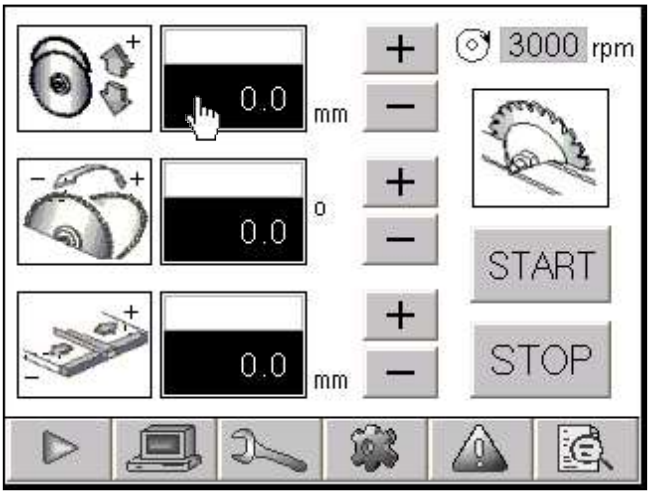
3. Scoring Saw Setting key: ..... A key for setting scoring saw forward/backward and up/down.
4. Increase (+) key:..... A key for slightly increasing movement.
5. Decrease (-) key: ..... A key for slightly decreasing movement.
6. Numerical Value Display Setting key: ..... A key for showing present value and setting value movement (please refer to Chapter 4-2-1 for details)
7. Function key:..... A key for entering functional operation page.
8. Program key:..... A key for entering program operation page.
9. Setting key:..... A key for entering setting operation page.
10. System key: ..... A key for entering system operation page.
11. Error key:..... A key for entering error data.
12. Monitor key: ..... A key for entering monitor operation page.

13. Movement key:..... A key for scoring saw movement.
14. Movement key:.....A key for scoring saw movement.
15. Movement key:.....A key for scoring saw movement.
16. Movement key:.....A key for scoring saw movement.
17. Exit key:.....A key for departing and returning to home page.
18. Group key:.....A key for selecting the processing group.
19. Numerical Value Editing key:.... A key for editing input, parameter, etc.
20. Lock/Release key:.....A key for locking and releasing.
21. Confirmation key:.....A key for confirming present selection, value, parameter, etc.
22. Processing Editing key:.....A key for entering the processing editing page.
23. Dimension Calculating key:.....A key for entering the dimension calculating page.
24. Calculation key:.....A key for calculating dimension.
25. Data editing key:.....A key for editing the shown data.
26. Delete key:.....A key for deleting the selected group.
27. Group Listing key:.....A key for showing all groups.
28. Save key:.....A key for saving input.
29. Cancel key:.....A key for canceling input.
30. Saw Blade Specification key:....A key for entering saw blade specification page.
31. Fence Size key:.....A key for entering fence size page.
32. Position Correction key:.....A key for entering position correction page.
33. Unit Change key:.....A key for entering unit change page.
34. Metric Unit key:.....A key for changing to metric unit.
35. Inch Unit key:.....A key for changing to inch unit.
36. UP/DOWN Parameter key:.....A key for entering UP/DOWN parameter page.
37. Tilting Parameter key:.....A key for entering the tilting parameter page.
38. Rip Fence Parameter key:.....A key for entering rip fence parameter page.
39. Parameter Correction key:.....A key for entering parameter correction page.
40. Machine Data key:.....A key for entering machine data page.
41. Input Data (1) key:.....A key for entering input data page (1).
42. Input Data (2) key:.....A key for entering input data page (2).
43. Input Data (3) key:.....A key for entering input data page (3).
44. Output Data (1) key:.....A key for entering output data page (1).
45. Output Data (2) key:.....A key for entering output data page (2).

4-2 Display and Operation of Each Function of Home Page

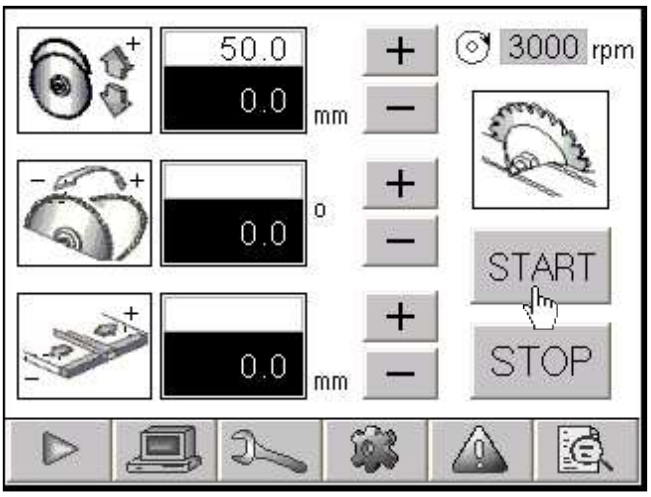
4-2-1 Numerical value Positioning Operation

Ex: If main saw blade's present value is 0.0 and you want to rise main saw blade to 50.0, the operating way as follows:



Step 1 : Push  key to make Numeric Keypad show up.

Step 2 : Input 50, push  key to finish input. After input, system returns to home page automatically.

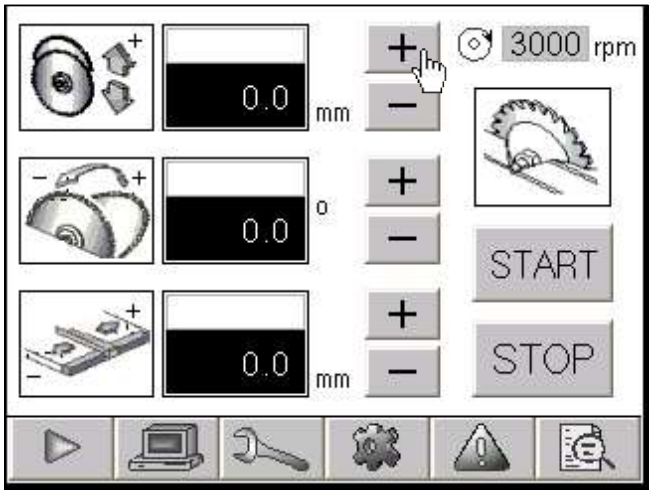


Step 3 : The target value 50.0 will show on  key. Push  key to make the main saw blade rise to 50.

Note:  key is for executing target value on  key and single axis or multi axis can act simultaneously.

4-2-2 Micro-motion Positioning Operation

Ex: If main saw blade's present value is 0.0 and you want to rise the main saw blade to 30.0, the operating way as follows:



Step : Push + key until -0.0 key shows present value 30.0.

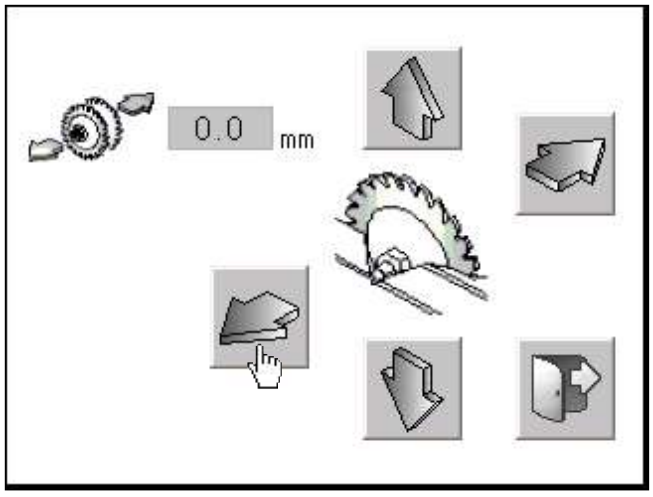
Note: When micro-motion positioning movement is used, 30.0 key won't show any target value.

4-2-3 Scoring Saw Operation

Accuracy of the scoring saw movement of this system is 0.05mm (i.e. touch it and it moves 0.05mm. The adjustable range is +/- 1mm. The following is the scoring saw operation.

Remarks: Accuracy of UP/DOWN movement of scoring saw is 0.01mm (i.e. touch it and it moves 0.1mm) This system can memorize the last setting height of the scoring saw UP/DOWN movement even though the power is closed. The using way: Start the scoring saw, it will automatically rise to the last setting height. Stop the scoring saw, it will fall under the working table (Please refer to chapter 4-1 for details).Itps an optional function.

Ex: The scoring saw scoring saw forward/ backward shows 0.0 and you want to move to scoring saw to -0.1, the operating way as follows:



Step : Push key on home page to enter the scoring saw control page and then push key until -0.1 shows on the left -0.10 mm 0.10mm.

Note: Only touching key or key can make the scoring saw up or down.

4-2-5 Display of Motor RPM

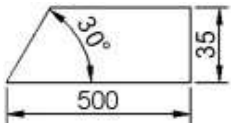
Motor rpm is shown on the upper right c 3000 rpm of home page.

Note: This system's RPM is only for display without setting function. If rpm needs to be changed, please refer to Chapter 3-5.

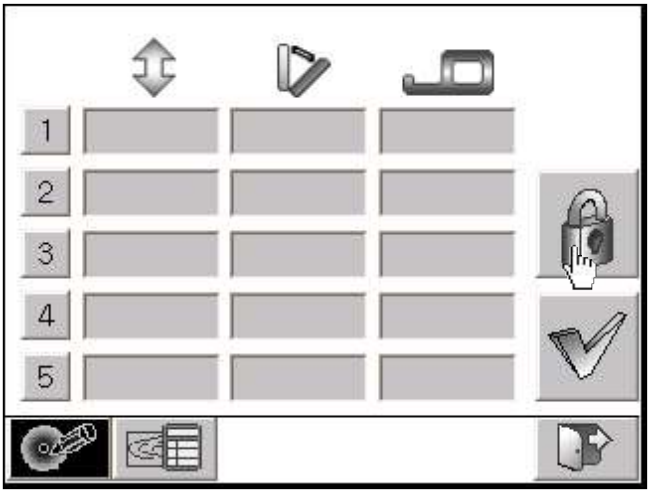
4-3 Function Page Operation

4-3-1 Processing Editing Operation

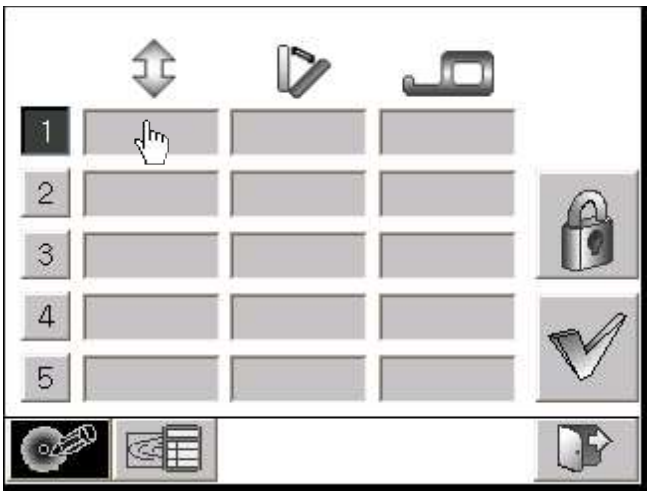
The processing edition is a temporarily processing group provided by this system without memory function. When power is off, the processing group will be cleared automatically. If you want to memorize the input group, please use 4-4 program function.

Ex: If you want to cut 

wooden board, please input the desired group. The operating way as follows:

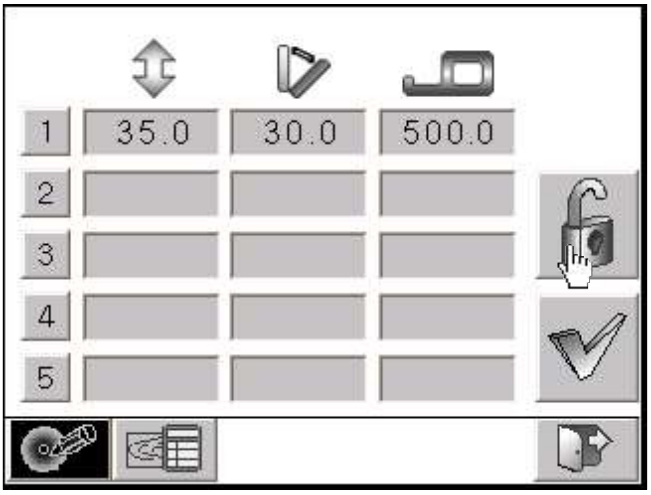


Step 1 : Push key on home page to enter the processing editing page. Push key to release lock.

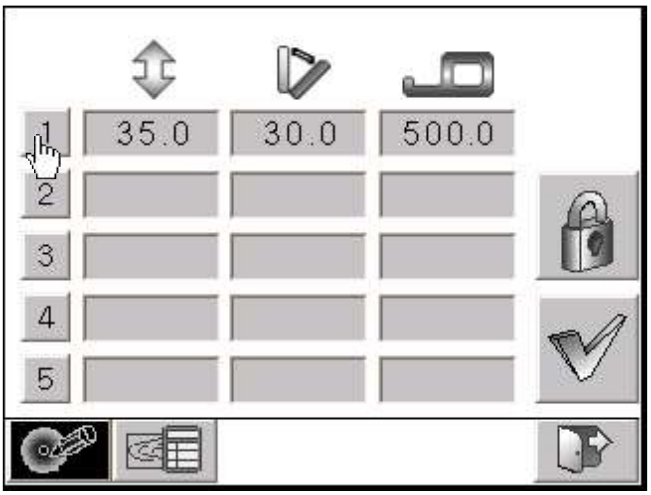


Step 2 : Push 1 key to select the desired input group. Push key to make Numerical Keypad showup.

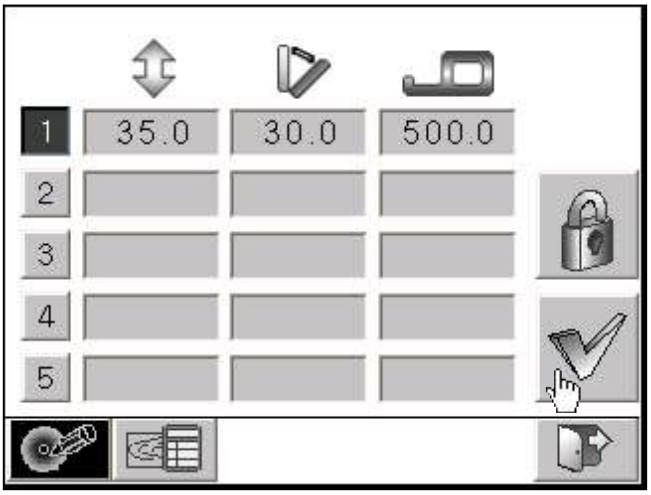
Step 3 : Input 35, push Enter key to finish input. The value input way of the tilting angle and rip fence is the same.



Step 4 : Push  key to save and lock system.

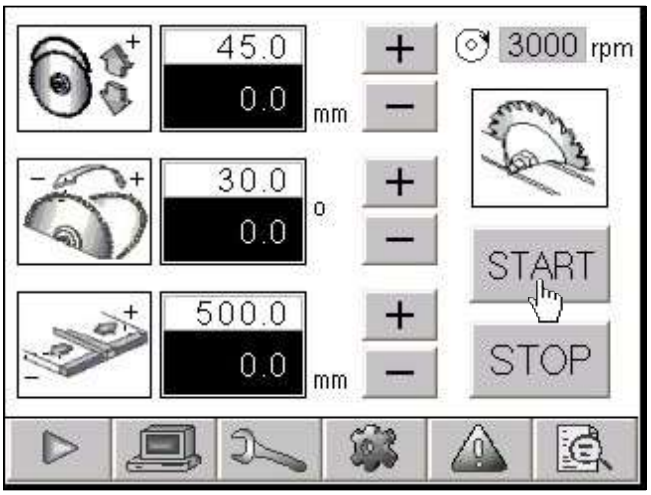


Step 5 : Push  key to release lock. Push 1 key to select processing group.



Step 6 : Push  key to confirm all selected groups. After confirmation, system will return to home page automatically.

Note: When this system wants to select group key 1 , you must first release lock and then can select. If lock isn't released, group key 1 can't be selected.

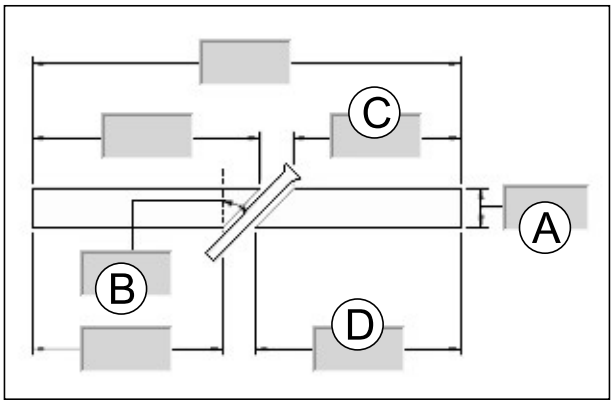


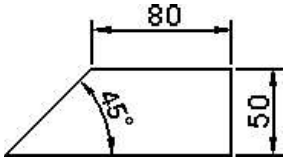
Step 7 : After returning to home page, the numerical value is automatically saved into target value. Push START key to start action.

4-3-2 Dimension Calculation Operation

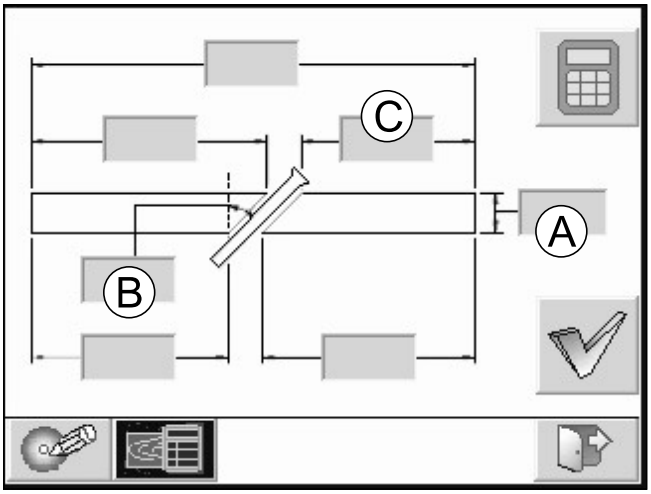
When dimension calculation function is used, the wooden board's height, angle and distance must be input. The height and angle as shown on A and B of the right drawing are the necessarily input numerical values. The calculating way as follows:
1. Input A, B and C to calculate D.
2. Input A, B and D to calculate C.

Note: A~D are machine's saved size. Other sizes are for calculating and are not needed by machine.



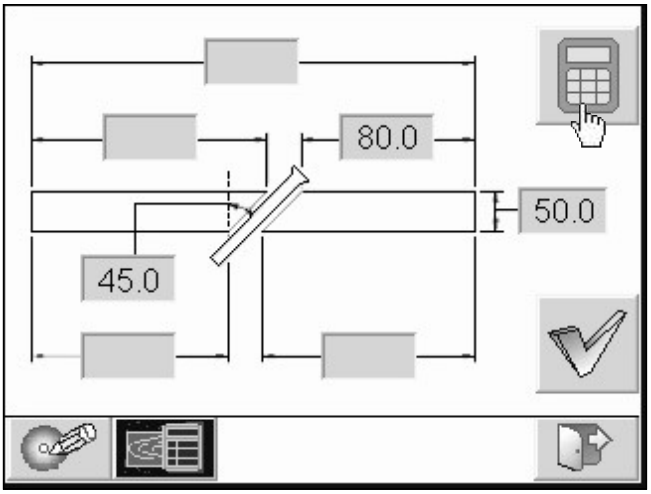
Ex 1 : It's size 

. If you want to cut it into your calculated size, the operating way as follows:

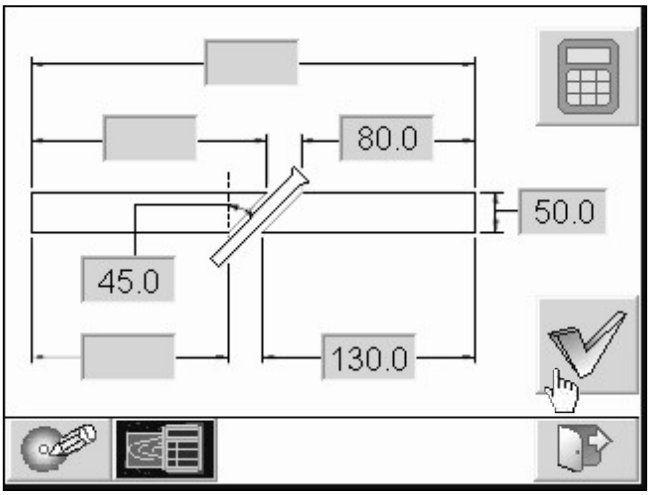


Step 1 : Push key on home page to enter the processing editing page. Push key to enter dimension calculation page and then input the known dimension. A=50, B=45, C=80.

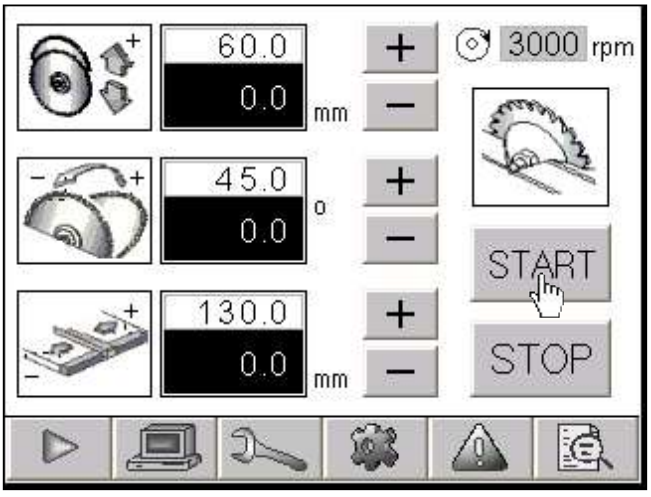
Note: For detailed numerical value input way, please refer to Step 2 and Step 3 of Chapter 4-3-1.



Step 2 : Push  key to start calculating. After finishing calculation, system will show the calculated value on the page.



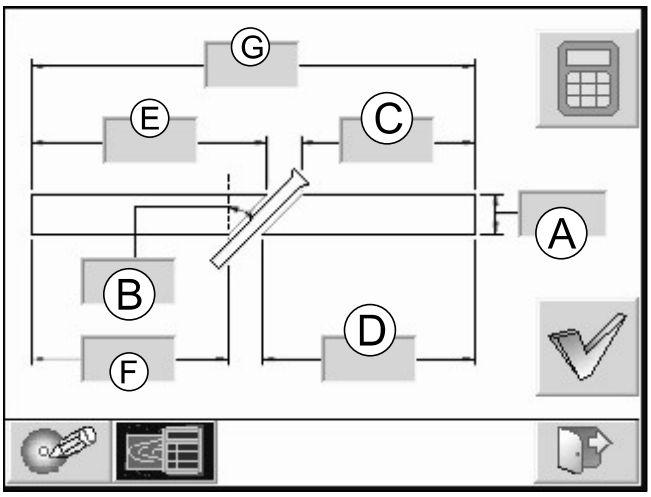
Step 3 : Push  key to save the calculated result onto the target value of home page. (or push  key to return to home page but the calculated result will be cancelled and won't be saved into target value.)



Step 4 : Push START key to start action.

Note: for main saw blade's height setting, the pre-setting height is material height + cutting value 10mm. So, the target value of the main saw blade UP/DOWN mentioned in step 4 shows 60.0. If material height + cutting value exceed system's cutting height, system will show error data. At this time, you can input the cutting height by yourself. Such situation is not error of system.

Ex 2 : If the total length and the desired cutting size are known and you want to calculate the size of the remaining material, the operating way as follows:

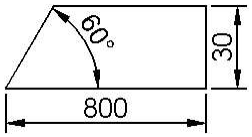


Step : Input material height A, angle B, cutting size D and total length G. Push  key to calculate the size of the remaining material E, F.

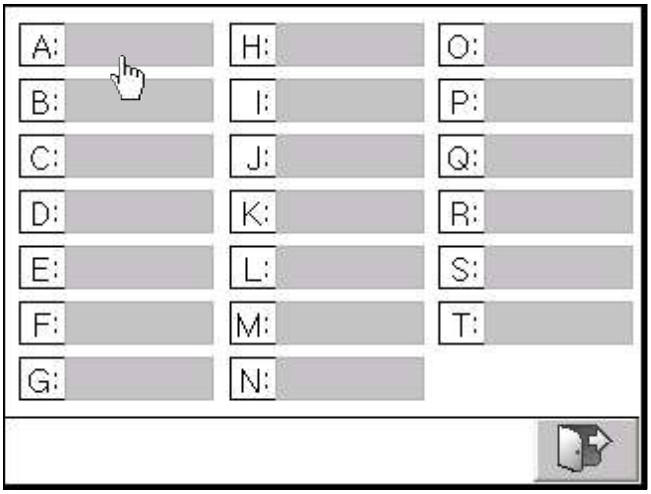
Note: For detailed operating way, please refer to Step 1 and Step 2 of Ex 1.

4-4 Program Page Operation

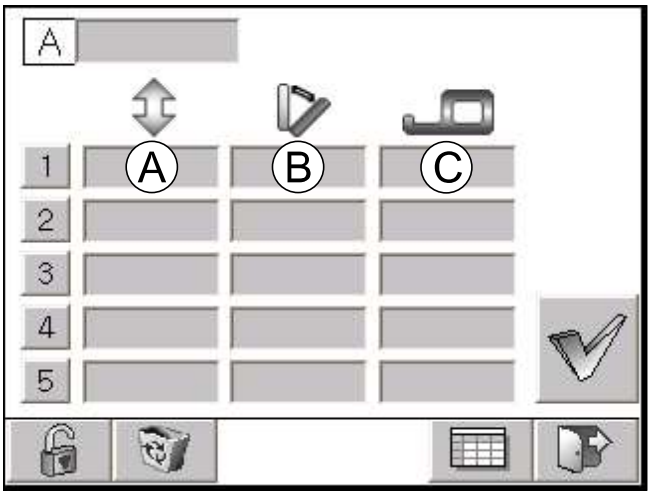
The page is a memory group function provided by this system. A~T stands for a code and each code can memorize 5 groups, so total 100 groups.

Ex: If you want to memorize one cutting size 

on A area and select that group cutting size, the operating way as follows:

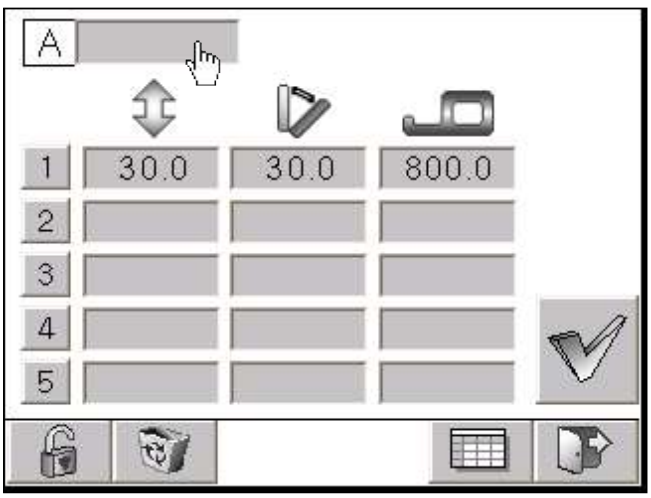


Step 1 : Push key on home pagte to enter the group listing page. Push A: key to select A area.



Step 2 : Push key to release lock, input the processing dimension A=30, B=30, C=800.

Note: For detailed value input way, please refer to Step 2 and Step 3 of Chapter 4-3-1.



Step 3 : Push A to number that group After selection, ASCII-KEY is shown up.

Step 4 : Input the number to be classified, push ENT to finish input.

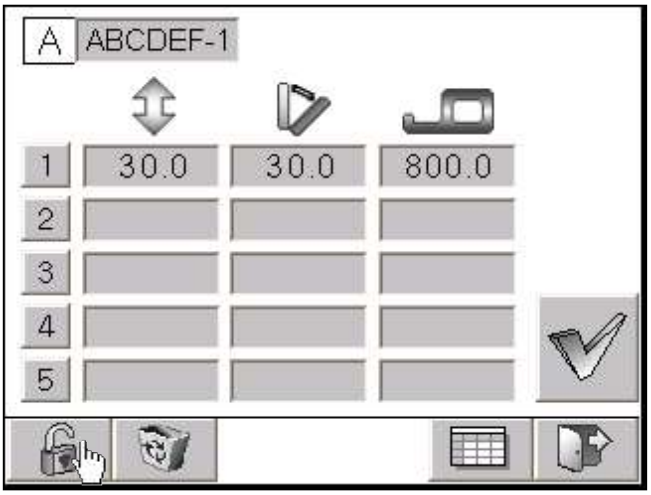
Note: The ASCII-KEY of this system can input signs. The following is explanation of each key.

ALT : Sign shift key.

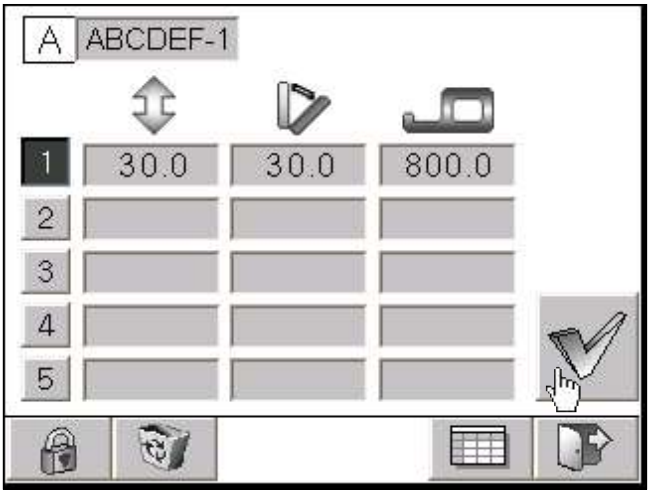
CLR : Clear key.

DEL : Return key.

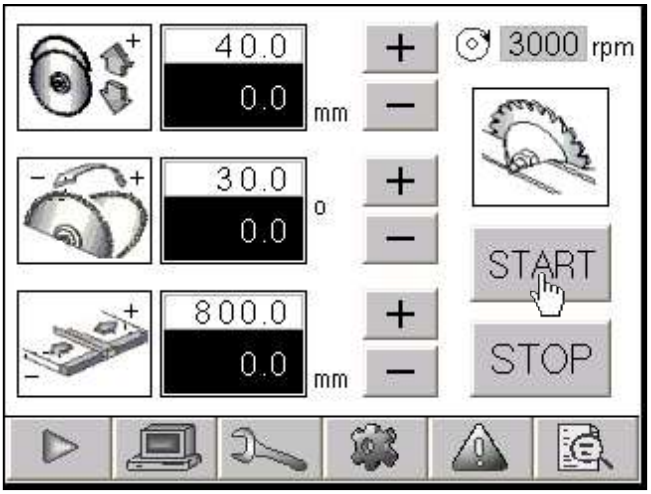
ENT : Finish key.



Step 5 : Push key to save and lock data.



Step 6 : Push key to release lock. Push 1 key to select group and then push key to confirm the selected group. After confirmation, the system will return to home page automatically.



Step 7 After returning to home page, the numerical value will be saved into the target value automatically. Push START key to start action.

Note: For explanation of numerical value of target value of main saw blade UP/DOWN, please refer to Note of page 5-19.

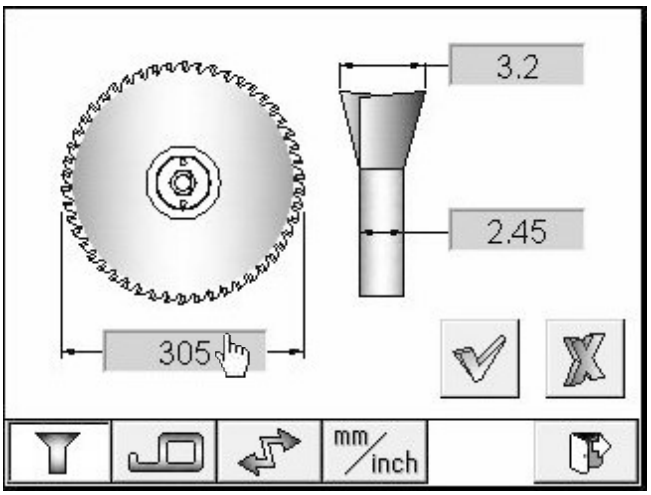
Note: When this system wants to select group 1 , you must first release lock and then can select. If lock isn't release, group key 1 can't be selected.

4-5 Operation of setting page

4-5-1 Operation of saw Blade Specification

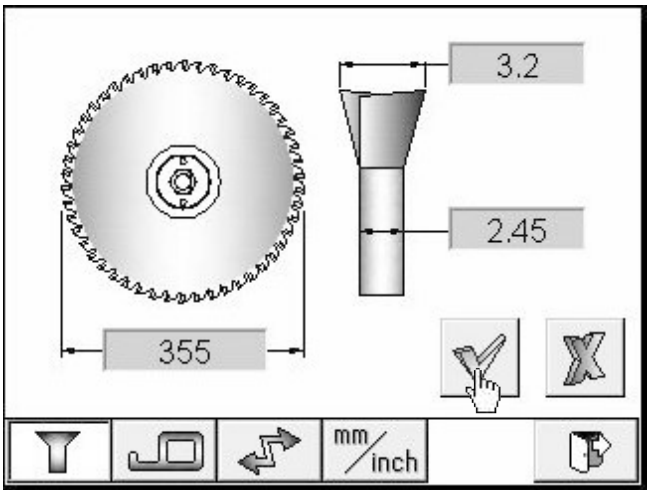
The function is for changing saw blade specification.

Ex: If the present saw blade is 12” and you want to change it into 14”, the operating way as follows:



Step 1 : Push key on home page to enter saw blade specification page. Push 305 key to edit value.

Step 2 Input 14” saw blade’s specification, push Enter key to finish input. For the remaining value, the input way is the same.



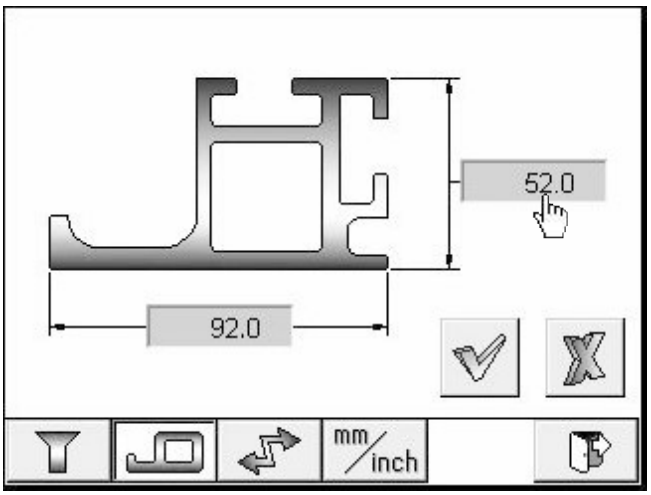
Step 3 : Push key to save, The setting is completed.

Note: After the specification of main saw blade is changed, the saw blade’s height fence’s position, saw blade’s UP/DOWN +/- limit parameter will be meet the specification parameter of the present main saw blade.

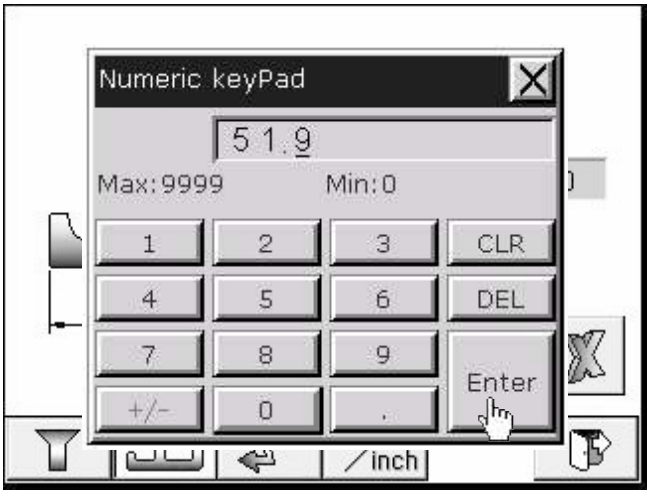
4-5-2 Operation of Fence Size 

The function is for setting rip fence size.

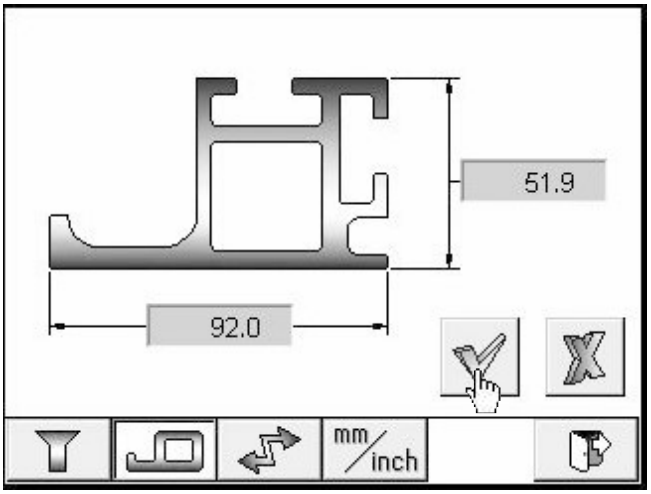
Ex: If the present rip fence's size is set at 52, 92 but actually measured size is 51.9, 92 and you want to change the setting size, the operating way as follows:



Step 1 : Push  key on home page, Push  key to enter fence size page. Push 52 key to change rip fence's size.



Step 2 : Input the actually measured size, 51.9 and then push Enter key to finish input.



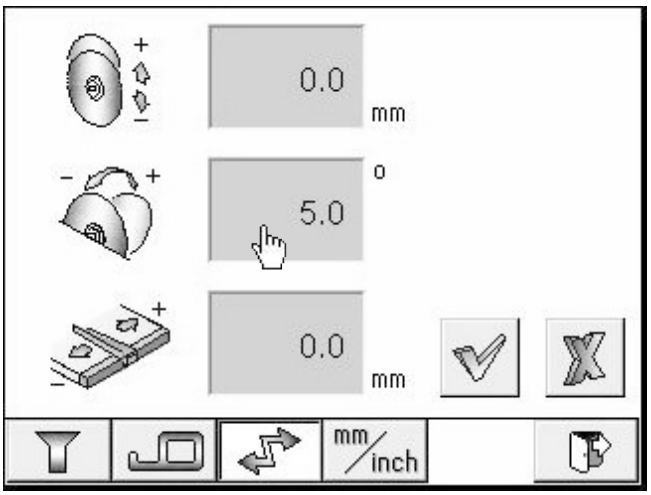
Step 3 : Push  key to save. The setting is completed.

Note: This setting will influence rip fence's position.

4-5-3 Operation of Position Correction 

The function is for setting the present value of each shaft's position.

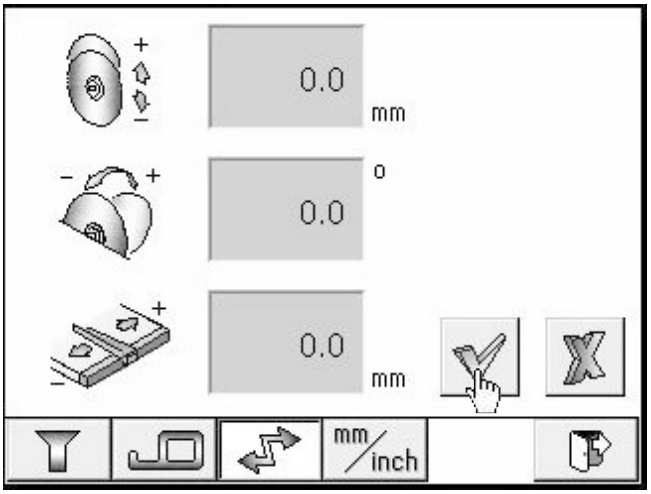
Ex: If the main saw blade shown on the page is 5 degree but actual angle is 0 degree, the operating way as follows:



Step 1 : Push  key on home page. Push  key to enter position correction page. Push  key to change value of angle of main saw blade.

Step 2 : Input actual angle, 0 degree and then push 

key to finish input.



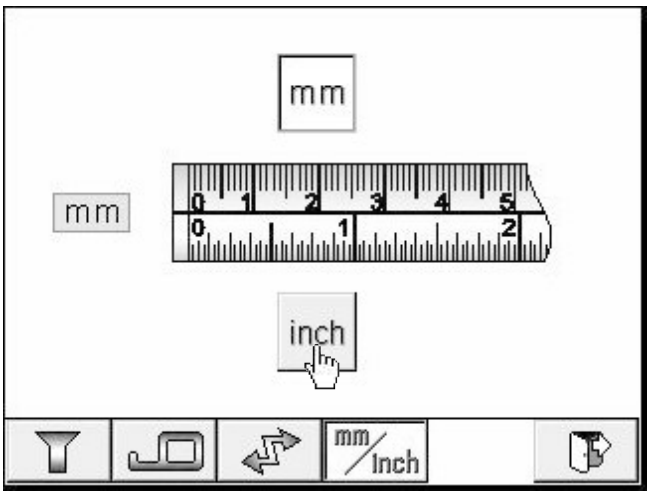
Step 3 : Push  key to save. The setting is completed.

Note: The correction way of main saw blade UP/DOWN and rip fence is the same above-mentioned way.

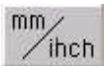
4-5-4 Operation of Unit Change 

The function is for changing unit.

Ex: The pre-setting unit of this system is mm and you want to change it into inch, the operating way as follows:



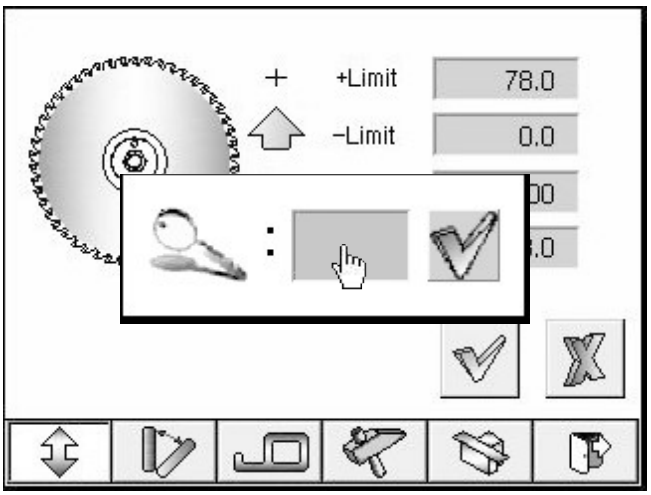
Step : Push  key on home page.

Push  key to enter unit change page. Push  key to change unit.

4-6 Operation of System Page

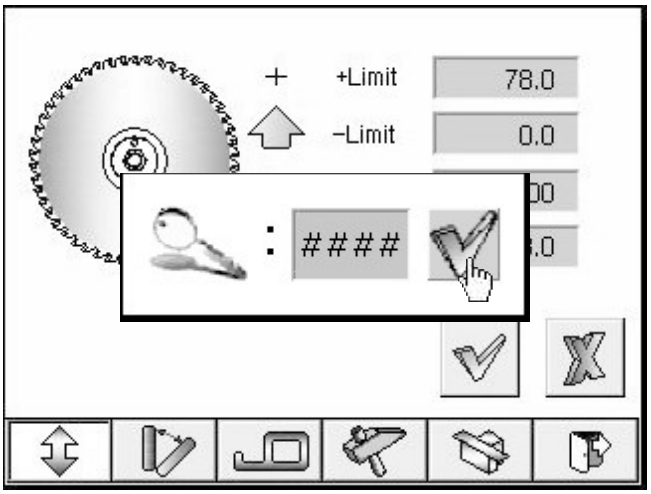
4-6-1 Operation of UP/DOWN Parameter

The function is for setting each parameter of main saw blade UP/DOWN such as +/- limit value, UP/DOWN parameter, deceleration distance.
Ex: If parameter of main saw blade UP/DOWN is 7900 and you want to change it into 7950, the operating way as follows:

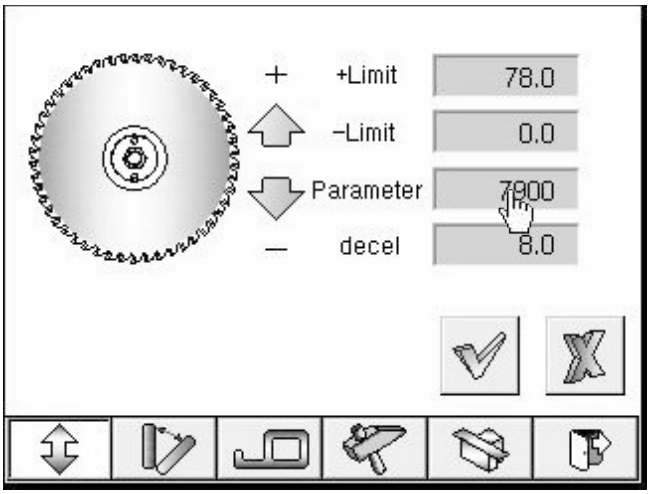


Step 1 : Push key on home page to enter system operation page. At this time, the password input window is shown up. Push key to let Numeric Keypad show up.

Step 2 : Input the system password.
Push Enter key to finish input.

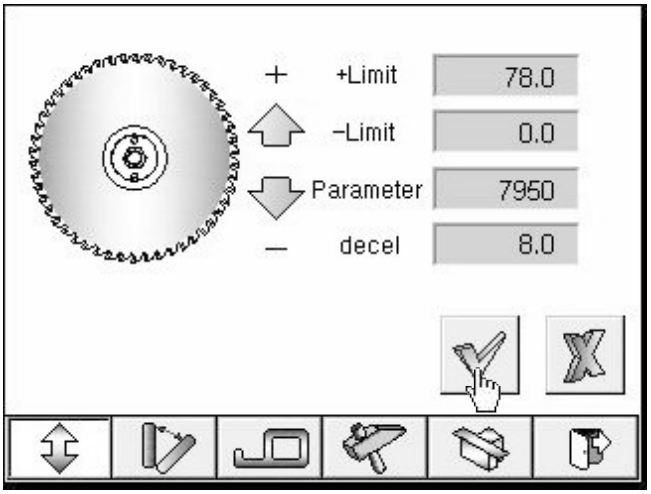


Step 3 : Push key for confirmation.



Step 4 : Push 7900 key to edit parameter value.

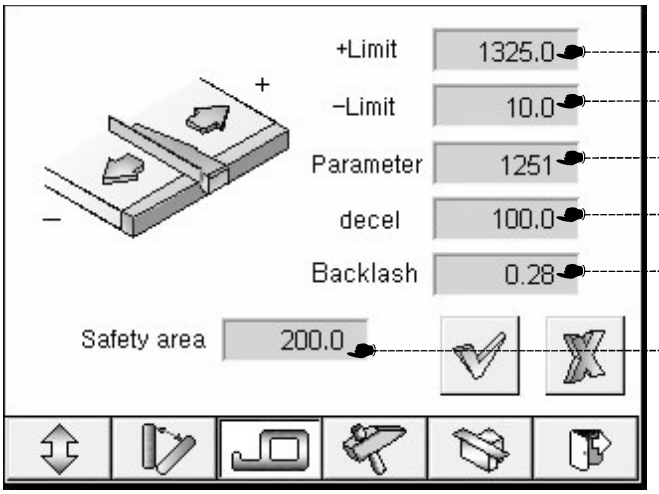
Step 5 : Input parameter 7950. Push Enter key to finish input.



Step 6 : Push key to save. The setting is completed.

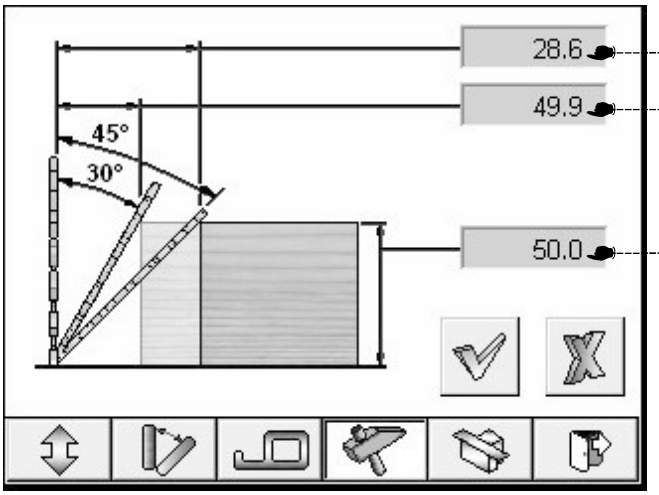
Note: The parameter changing way of tilting parameter, rip fence, main saw blade tilting rotary center correction parameter is the same as 5-6-1.

4-6-2 Introduction to Rip Fence Parameter Page



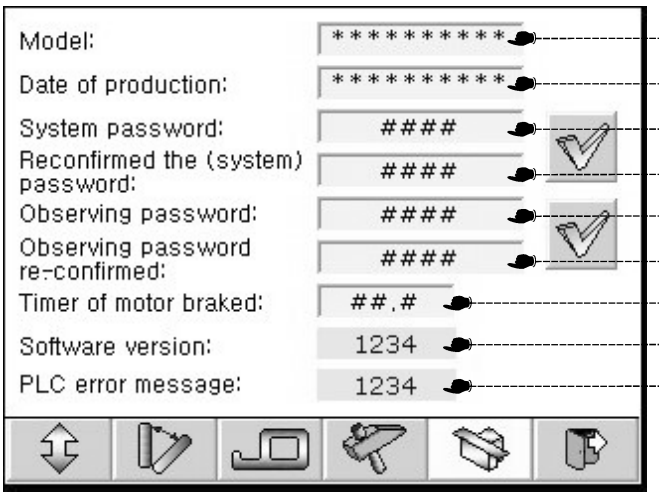
1. + Limit value.
2. - Limit value.
3. Parameter value.
4. Deceleration distance.
5. Backlash value
   (Clear rip fence backlash setting value)
6. Safety are a
   (protection value at saw blade cutting angle)

4-6-3 Introduction to Rotary Center correction Page



7. 45° degree tilting correction value.
8. 30° degree tilting correction value.
9. Cutting height value.

4-6-4 Introduction to Machine Data Page

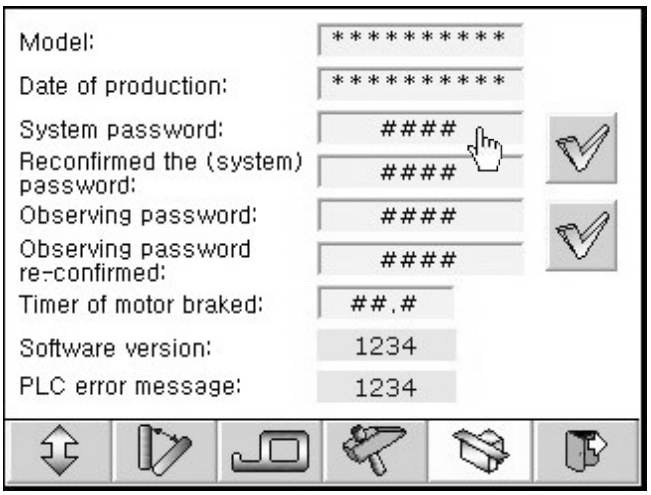


10. Model.
11. Date of production.
12. System password.
13. Reconfirm the system password.
14. Observing password.
15. Observing password reconfirmed.
16. Timer of motor braked.
17. Software version.
18. PLC error message.

Note: If above setting values are freely changed, it results in reducing machine's accuracy and even seriously machine damaging.

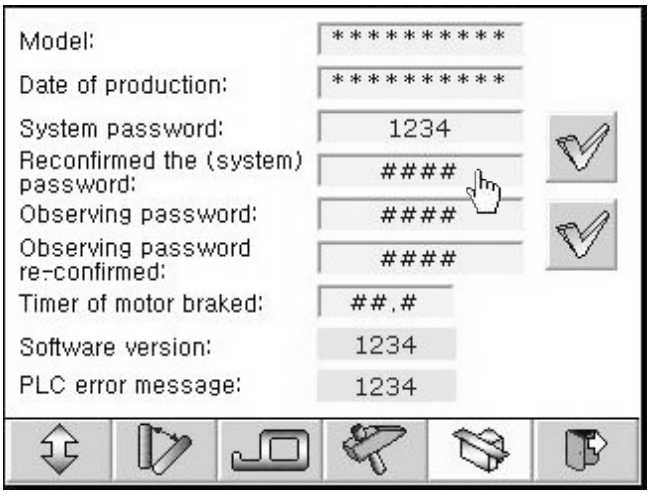
4-6-5 Operation of Changing System Password 

The following is the operating sequence of changing system password. When you enter the machine data page, please refer to step 1~step 3 of chapter 4-6-1.



Step 1 : Push  key on system operation page to enter machine data page. Push system password #### to let the Numeric Keypad show up.

Step 2 : Input the password you want to change. Push Enter key.



Step 3 : Push Reconfirmed the system password #### key to make Numeric Keypad show up. Repeat Step 2 to change password, push  key to finish changing password.

Note: the changing way of the observing password is the same as above.

CHAPTER 5

CLEAN / MAINTAIN

5 MAINTAIN

5-1 SLIDING TABLE MAINTENANCE

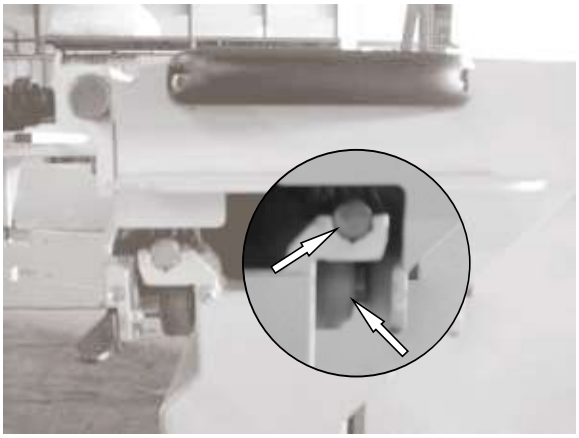


Fig.5-1

After work is finished, please clean the slide guide, rod guide, roller and contact surface between roller and lower slide base as shown in Fig. 5-1 to secure good accuracy.

5-2 Lubrication

5-2-1 Lubrication for main saw blabe up/bown

Must turn off machine when maintenance and lubricate machines

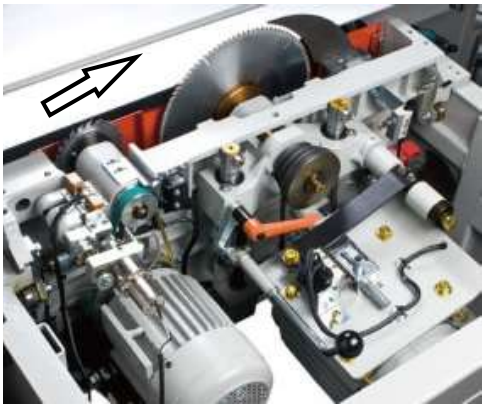


fig. 5-2-1 -1

- clean bust or wood chpps on the roller.
- lubricate after clearance (please refer to fig.5-2-3-2 for lubrication selection)
- maintenance regularly on above mentioned touched surface ensures the accuracy of machine.
- clean daily after usage.

5-2-2 Lubrication of rotary table

Fig.5-2-2-1

- clean machine daily after usage it helps machine in best condition.
- clean dust or wood chops on the roller.
- lubricate after clearance (please refer to below chart 5-2-3-2 for lubrication selection)
- maintenance regularly on above mentioned touched surface ensures the accuracy of machine.

5-2-3 Lubrication of sliding up and down of the safety guard

Fig.5-2-3-1

- keep clean for the safety guard roller (as shown on the left photo)
- lubricate roller (please refer to below chart5-2-3-2 for lubrication selection)

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

LIST 5-2-3-2

5-3 EMERGENCY STOP & SAFETY CONNECTING SWITCH CHECKING [CE]

★ Check Emergency Stop and Safety Connecting Switch twice every week.

The checking steps as follows：

1. Connect to power. Push main saw START button and scoring saw button to run the machine.
2. Push Emergency STOP. Check if the main saw and scoring saw's brake stops in 5 seconds.
3. Push any key and there will be no any action.
4. Release Emergency STOP button, otherwise stop operating machine at once and send it to the factory or inform the factory to repair it.

Check the safety connecting switch as follows：

1. Connect to power. Push main saw START button and scoring saw button to run the machine.
2. Open the cover and check if the main saw or scoring saw stopped running.
3. Push any key and there will be no any action.
4. Close the cover, push main saw START button and main saw UP or DOWN button. If they acts, it means OK.
5. Open the door at the back of the machine and check if the main saw or scoring saw stopped. Repeat 3.
6. Close the door, push main saw START button and main saw UP or DOWN button. If they acts, it means OK, otherwise stop operating machine at once and send it to the factory or inform the factory to repair.
7. PUSH the main saw OFF button or the scoring saw OFF button to stop running.

5-4 BRAKE CHECKING [CE]

While pushing Emergency STOP Brake button, the main saw and scoring saw will stop immediately. Check the brake twice every week. If the main saw or scoring saw doesn't stop for over 5 seconds, please send it to the factory or inform the factory to repair it.

CHAPTER 6

TROUBLE SHOOTING GUIDE

6 TROUBLE SHOOTING GUIDE

TROUBLE	CAUSE	GUIDE
Display can't show	1. Check if power or voltage is normal.	Input correct voltage.
	2. If above 1 is correct, it means controller is damaged.	Send it to the factory for repair.
Display can show digit but the digit can't be changed as per machine's size.	1. If encoder is used, please check if encoder runs together with the machine.	Check if the shaft connector of encoder and machine drops or is damaged. If yes, replace it or repair it.
	2. Check if A.B. phase has DC12V or 0V change. Please measure it with wattmeter.	If A.B phase doesn't change, please replace the encoder.
Push START button but machine doesn't act.	1. No power. 2. Emergency STOP button is pushed. 3. Voltage is incorrect. 4. Unlock the orange guard.	1. Check power. 2. Release Emergency STOP button. 3. Check voltage unit. 4. Fold down the orange guard.
Overheat	Overload isn't set or faulty.	Contact service person or factory.

6-2 TROUBLE SHOOTING GUIDE OF TOUCH SCREEN

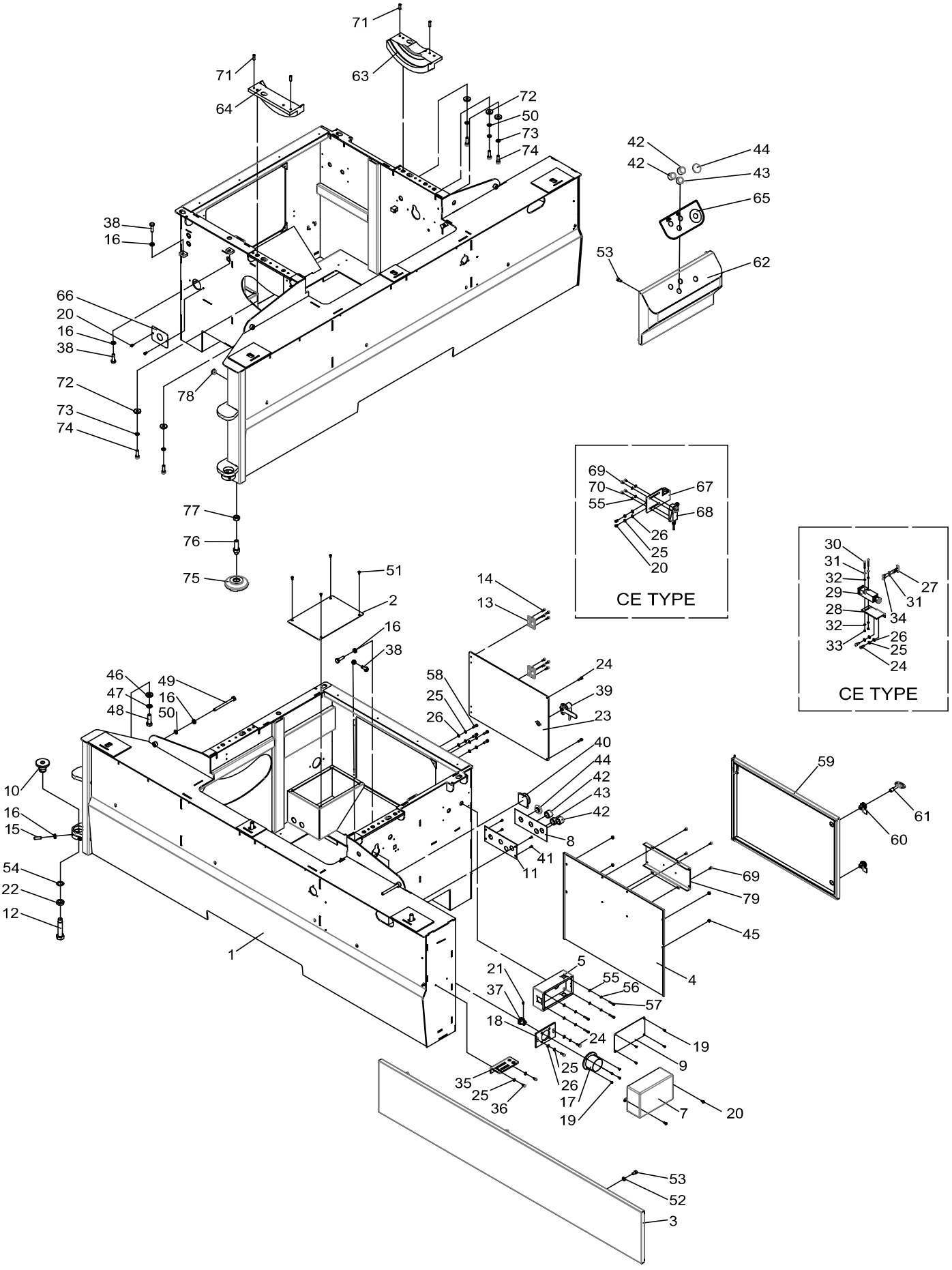
NO.	TROUBLE	ACTION
1	Error dimension statistics	Input correct numerical value
2	Rip fence paused	Safety bar is touched.Please release it and push START key again.
3	Rip fence moved into safety area	Push START key until rip fence reaches the position of the input value.
4	Rip fence do not load on the working table	Turn the rip fence over to the working table.
5	Main saw blade rise protective switch ON	Check if the main saw blade rise limit value setting and the sensor's position are correct.
6	Main saw blade down protective switch ON	Check if the main saw blade rise limit value setting and the sensor's position are correct.
7	Main saw blade titlt increase protective switch ON	Check if main saw blade tilt increase (+) limit value setting and the limit switch's position are correct.
8	Main saw blade titlt decrease protective switch ON	Check if main saw blade tilt decrease (-) limit value setting and the limit switch's position are correct.
9	Fence vertical movement protective switch ON	Check if fence(aluminum fence is vertically put)(+) limit value setting and the limit switch's position are correct.
10	Fence horizontal movement protective switch ON	Check if fence(aluminum fence is horizontally put) (-) limit value setting and the limit switch's position are correct.
11	Rip fence move increase protective switch ON	Check if fence(aluminum fence is horizontally put)(+) limit value setting and the limit switch's position are correct.
12	External safety switch or EMG stop did not switch to the correct place	Turn EMG switch to OFF. Release EMG switch.
13	Main saw blade did not move after START	Check if the encoder's wiring is correct and the relay runs normally.
14	Main saw blade did not elevator to the target position	Check if the input value exceeds the limit position, the limit parameter is correct and the saw blade's size is correct.
15	Main saw blade did not tilt after START	Act as No. 13.
16	Main saw blade did not tilt to the target opsition	Act as No. 14.
17	Rip fence did not move after START	Check if the encoder wiring is correct and the motor runs normally.
18	Rip fence did not move to the target position	Act as No. 14.
19	PLC-ERROR	1. Start the machine again to see if the trouble can be solved. 2. Enter the machine's data page to search PLC's error number and advise the factory.
20	The scoring saw cannot move up and down	Check if motor and wiring are normal.
21	Scoring saw blade cannot move back and forward	Check if motor and wiring are normal.
22	Scoring saw blade rise protective switch ON	Check if the moving position exceeds the moving range of the scoring saw blade.
23	Scoring saw blade down protective switch ON	Act as No. 22.
24	Error set up of the saw diameter	Input the correct diameter of the proper saw for machine.

CHAP TER7

DSYSTEM DRAWING

7.DSYSTEM DRAWING

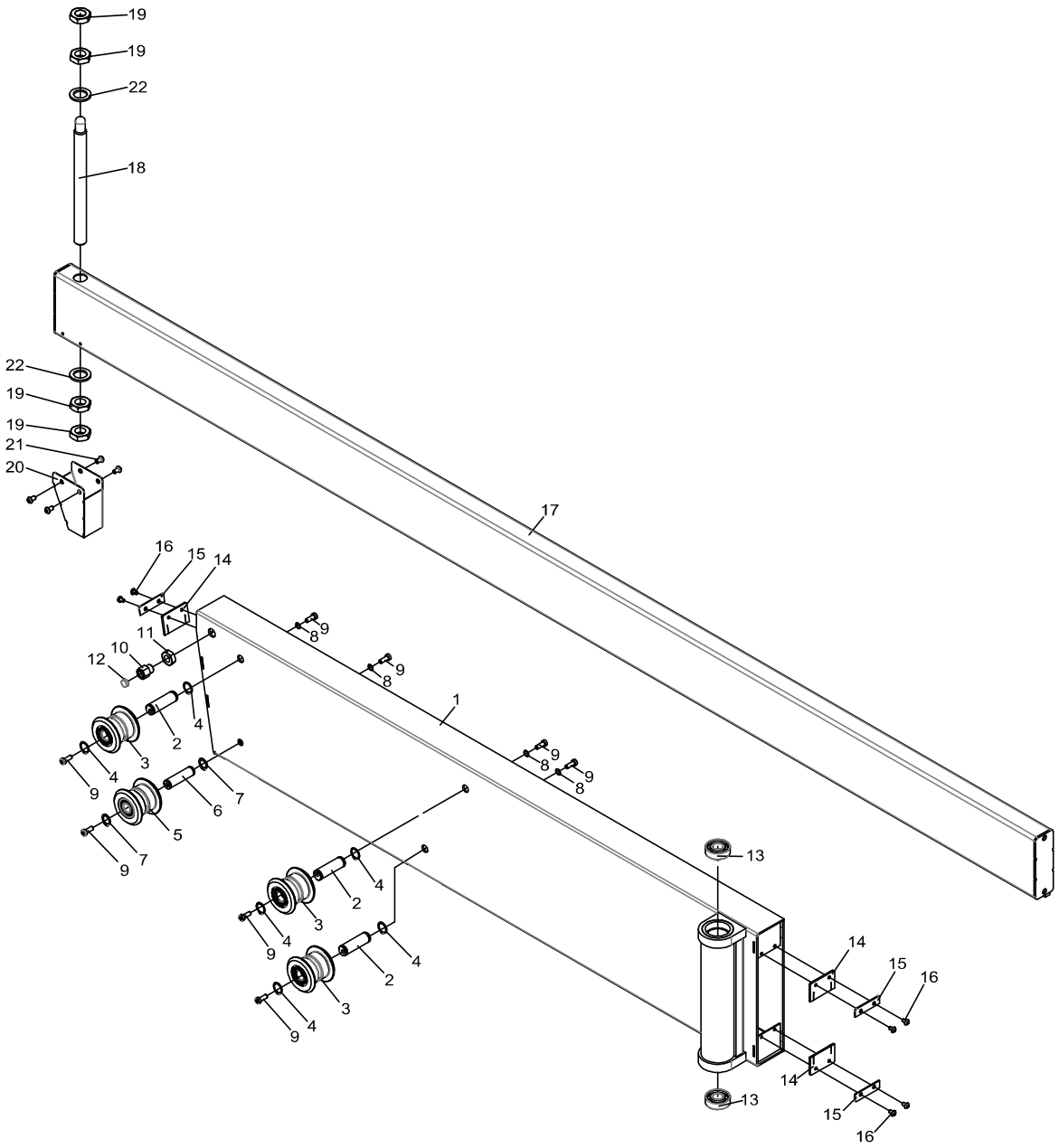
MACHINE BODY



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-A001C	body	
2	LST-A001C_48	Cover	
3	LST-A006H	Cover	
4	LST-A010C	Electron Part	
5	ST-T038B	Adapter box	
6	LST-A039	Washer	
7	ST-C005A	Cover	
8	ST-A142	Mask	
9	ST-T039A	Transfer box cover	
10	ST-J025	Support adjusting baes	
11	ST-A138	Aluminum plate	
12	ST-J013	Lower positioning shaft	
13	402090005	Aluminum Hinges	CL-208
14	401022028	Cap scre	M5x12
15	401072069	Set serew	M10x30
16	401101006	Hex nut	M10
17	415071113	encoder	HSK-XA074
18	ST405-105	Fixed Board	
19	401032008	Button head screw	M4x8
20	401032029	Round head screw	M6x10
21	401072033	Setscrew	M6X6
22	401102002	Hex nut	M20-9.5t
23	LST-A001C_53	Back plate	
24	4701022053	Button hd capscr	M6x16
25	401150003	Lock Washer	Ø6
26	401140010	Washer	Ø6
27	416140002	Safety Switch Key	
28	ST-A009	Fixed Black	
29	416140002	Safety Switch	EK-1-15-R
30	401042015	Phillips Head Screw	M4x35
31	401150001	Lock washer	Ø4
32	401140001	Washer	Ø4
33	401101002	Hex nut	M4
34	401022013	Cap screw	M4x10
35	ST-A110	Tool Block	
36	401022050	Cap screw	M6x10
37	ST405-104	Gear	
38	401010038	Hex Bolt	M10x35
39	402010017	Handle	
40	416010037	Power Switch	

NO	FIG.NO.	DESCRIP TION	SPEC
41	401051108	Countersink Hend Screw	M4x10
42	416010003	Button, ON	
43	416010008	Button, OFF	
44	416010001	Emergency button	
45	401101004	Hex Nut	M6
46	ST-F062	Washer	14.2-30-5t
47	401150007	Lock Washer	Ø14
48	401011017	Hex Bolt	M14x45
49	401010047	Hex head bolt	M10-120
50	401140005	Washer	Ø10
51	401032017	Button head serew	M5x10
52	401140004	Washer	
53	401022076	Cap screw	M8x16
54	401151007	Safety Washer	Ø20
55	401140002	Washer	Ø5
56	401150002	Spring washer	Ø5
57	401022033	Cap screw	M5x25
58	401022055	Cap scre	M6X20
59	LST-A007B	Electron Door	
60	402170002	Lock	
61	402170003	Key	
62	LST-A004D	Electron Part Box	
63	LST-A002A	Right slide base	
64	LST-A003	Left slide base	
65	NST-028	Mask	
66	ST-T047B	Wire connector	
67	LST-A013	Switch fixing plate	
68	416040005	Micro-motion witch	ME-8104
69	401042008	Phillips Head Serew	M5x10
70	401042107	Phillips sunk head cap screw	M5x8
71	401200034	Fixed Ring	Ø8x25
72	RH-2040	Washer	
73	401150005	Spring washer	Ø10
74	401022105	Cap scre	M10x30
75	401260004	Adjust Base	
76	LST-A017	Levelng pads	
77	401101012	Hex Nut	M16
78	414080003	Hole plugs	HP-19
79	ST-A159	Electrical board	

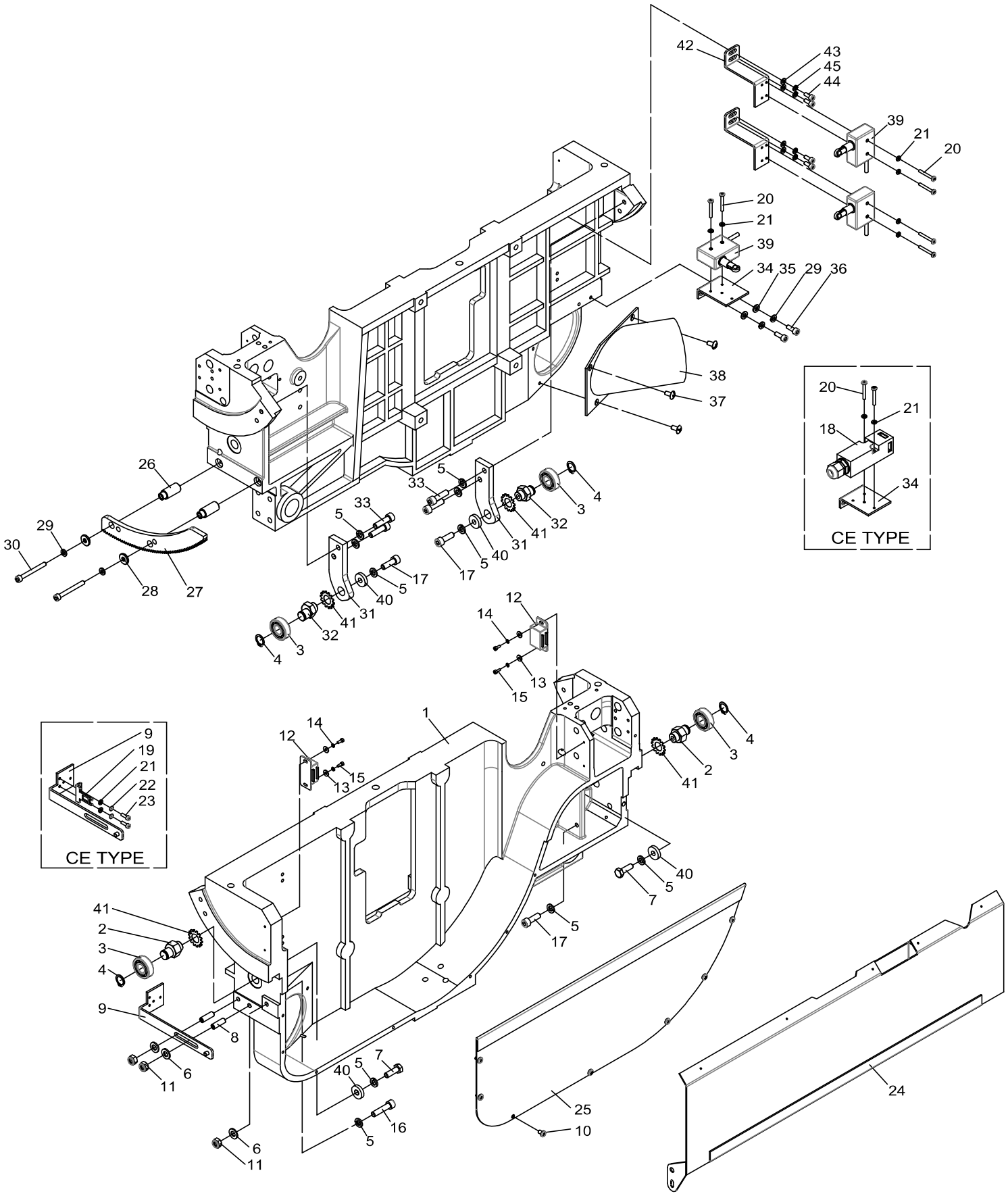
SUPPORTING ROCKER ARM



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-G001G	Crosscut Swing Arm	P26/P32
	LST-G001H	Crosscut Swing Arm	P19
2	LST-G004	Adjustment shaft	
3	ST-J014K	Roller/Ball bearing	6003-ZZ TPI
4	401252012	Ext Retaining Ring	S-17
5	ST-J014L	Roller/Ball bearing	6202-ZZ TPI
6	ST-J015	Roller for shaft	
7	401252010	Retaining rings for shaft	S-15
8	401151002	Washer	Ø8
9	401212001	Low head cap screw	M8x16
10	LST-A008A	Houshing for magnet	
11	401101008	Hex nut	M14
12	402120001	Magnet	Ø12x5 S03302

NO	FIG.NO.	DESCRIP TION	SPEC
13	403015133	Ball Bearing	6203-LLU TPI
14	LST-G003	Way wipers	
15	LST-G002	Locating plate	
16	401032016	Button Head Serew	M5x8
17	LST-G009B	Crosscut Swing Arm Extension(2220mm)	3.2
	LST-G009	Crosscut Swing Arm Extension 350(1490mm) 400(1700mm) Model	1.9
	LST-G009A	Crosscut Swing Arm Extension(1700mm)	2.6
	LST-G009C	Crosscut Swing Arm Extension(2590mm)	3.8
18	LST-G008	Threaded Shaft	M20xP2.5
19	401102002	Hex nut	M20-9.5t
20	ST-J023B	Cover plate	
21	401032029	Round head screw	M6x10
22	LST-G032	Washer	Ø22-Ø34-3t

ROTARY BASE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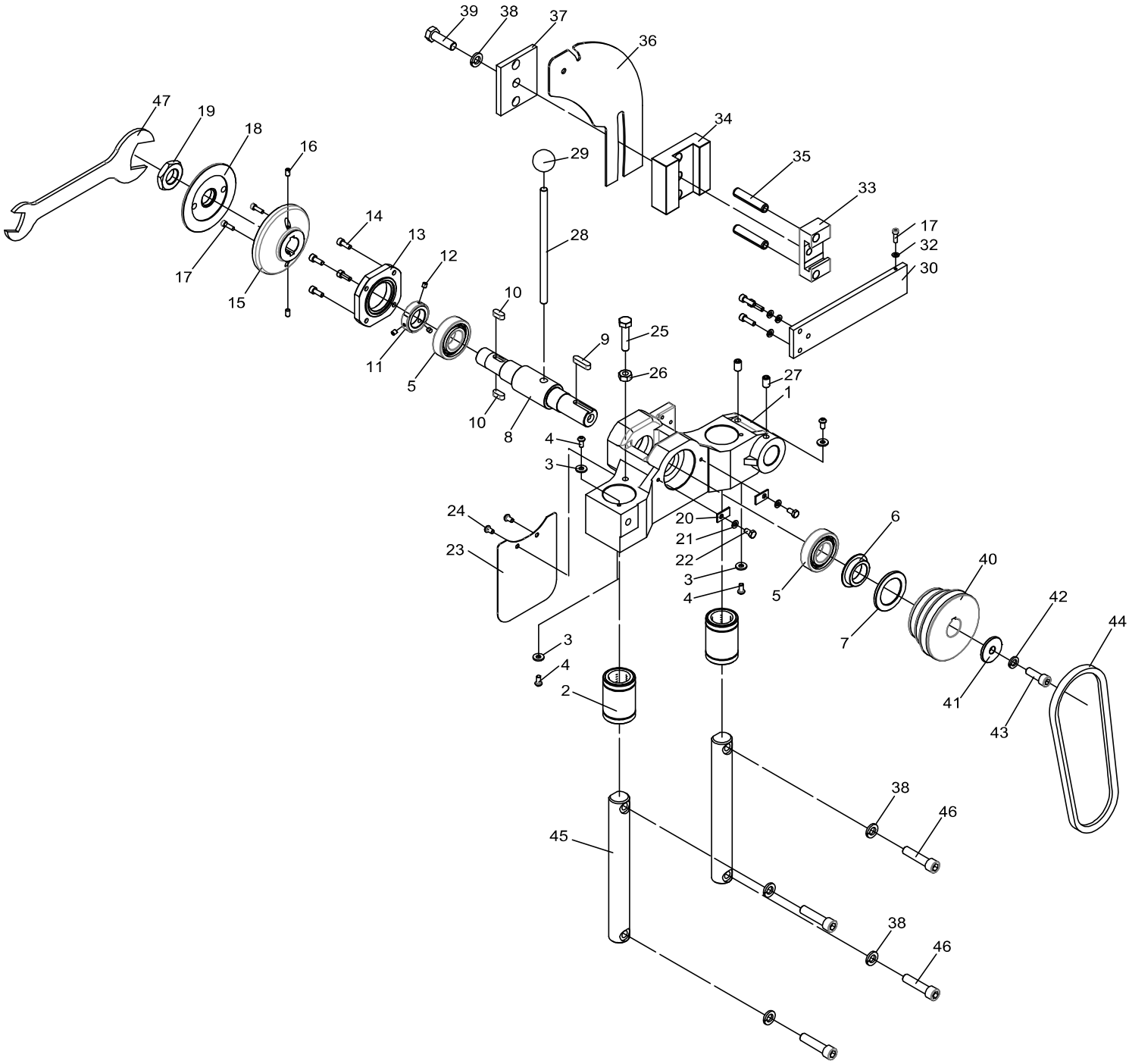
NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-B001A	Rotary Base	Model 400
	LST-B001B	Rotary Base	Model 350
2	LST-B002	Adjust shaft	
3	403015132	Ball Bearing	6202 ZZ
4	401252010	Retaining rings for shaft	S15
5	401150003	Lock nut	Ø8
6	401140004	Washer	Ø8
7	401010020	Hex Bolt	M8x25
8	401072055	Set screw	M8x25
9	LST-B013A	Join bar	
10	401042107	Phillips sunk head cap screw	M5x8
11	401103001	Lock nut	M8
12	402120004	Magnets	H21-C
13	401140015	Washer	Ø3
14	401150010	Lock washer	Ø3
15	401022002	Cap screw	M3x8
16	401022081	Cap Screw	M8x35
17	401022079	Cap Screw	M8x25
18	416140002	Safety Switch	EK-1-15-R
19	416140002	Safety Switch Key	
20	401042002	Phlp Hd Scr	M4x30
21	401140001	Washer	Ø4
22	401150001	Lock washer	M4
23	401022014	Cap Screw	M4x12

NO	FIG.NO.	DESCRIP TION	SPEC
24	LST-B009	Cover	Model 350
	LST-B009A	Cover	Model 400
25	LST-B011A	Lower Blade Cover	Model 400
	LST-B011B	Lower Blade Cover	Model 350
26	LST-B005	Fixed Pole	
27	LST-B006	Rack	
28	NST-432-0-0	Washer	
29	401150003	Lock Washer	Ø6
30	401022062	Cap Screw	M6x55
31	LST-B004	Fixed block	
32	LST-B002A	Adjust shaft	
33	401022080	Cap screw	M8x30
34	LST-B014A	Fixed sheet	
35	401140010	Washer	Ø6
36	401022053	Cap scre	M6x16
37	401042101	Phillips Head Screw	M6x12
38	LST-B015	Exhaust pipe	
39	416040001	Limit switch	TZ7311
40	401140036	Washer	Ø8x22x5t
41	401170008	Toothed washer	Ø15
42	LST-B017A	Fixed block	
43	401140002	Washer	Ø5
44	401022028	Cap scre	M5x12
45	401150002	Spring washer	Ø5

7-2 SAW BLADE UNIT

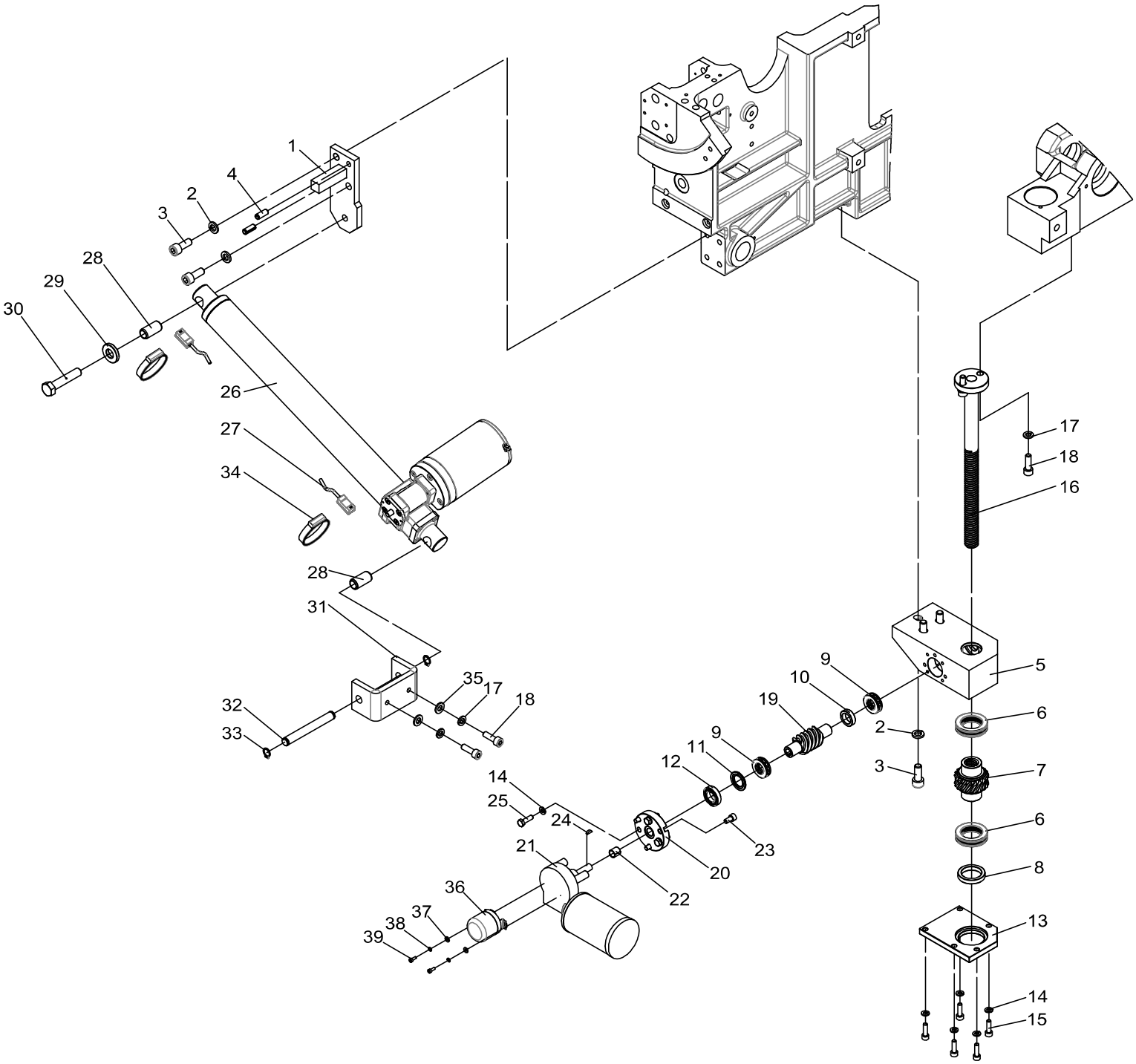
MAIN SAW



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-C001	Arbor Mount	Model 350
	LST-C001A	Arbor Mount	Model 400
2	404020003	Linear bushing	UBM-30AWW
3	401140010	Lock Washer	Ø6
4	401032030	Button Head serew	M6x12
5	403010307	Ball bearing	6206-VV-CM
6	LST-C004	Bearing Seat	
7	LST-C005	Bearing Cover	
8	LST-C002	Spindle	
9	401230005	Key	8x7x32
10	401230016	Key	8x7x20
11	401110007	Spanner Nut	M30xP1.5-L
12	401072033	Setscrew	M6X6
13	LST-C003	Bearing Cover	
14	401022053	Cap scre	M6x16
15	LST-C008	Main Blade Flange	Ø25.4
	LST-C008A	Main Blade Flange	Ø30
16	401072035	Set screw	M6x10
17	401020030	Cap screw	M5x16
18	ST-H064A	Shaft Cover	
19	ST-H060A	Arbor Flange Nut	
20	ST-H070	Fixed Sheet	
21	401150003	Lock Washer	Ø6
22	401010007	Hex head bolt	M6x12
23	LST-C009	Dust guard	

NO	FIG.NO.	DESCRIP TION	SPEC
24	401032029	Round head screw	M6x10
25	401010039	Hex Bolt	M10x40
26	401101006	Hex head bolt	M10
27	401072065	Set Screw	M10x16
28	ST-H089	Fixed Bar	
29	402060005	Ball-shaped knob	32-M10
30	LST-C010	Riving kinfe's slide rail	
31	401022055	Cap scre	M6x20
32	401140002	Washer	Ø5
33	NLST-C054	Riving knife's rear fixed block	
34	NLST-C055	Riving knife adjusting block	
35	401200032	Spring Pin,	Ø13x60
36	LST-C029	Riving Knife(Simple)	
	ST405-202	Riving Knife(Luxury)	
37	NLST-C056	Riving knife's front fixed block	
38	401150006	Lock washer	Ø12
39	401010054	Hex head boit	M12x40
40	LST-C006A	Pulley	
41	LST-C007	Fixed Ring	
42	401150005	Lock washer	Ø10
43	401022105	Cap scre	M10x30
44	405050020	Belt	Gates-11M875
45	LST-B003	Shaft	
46	401022131	Cap Screw	M12x50
47	ST-Q044A	Wrench	

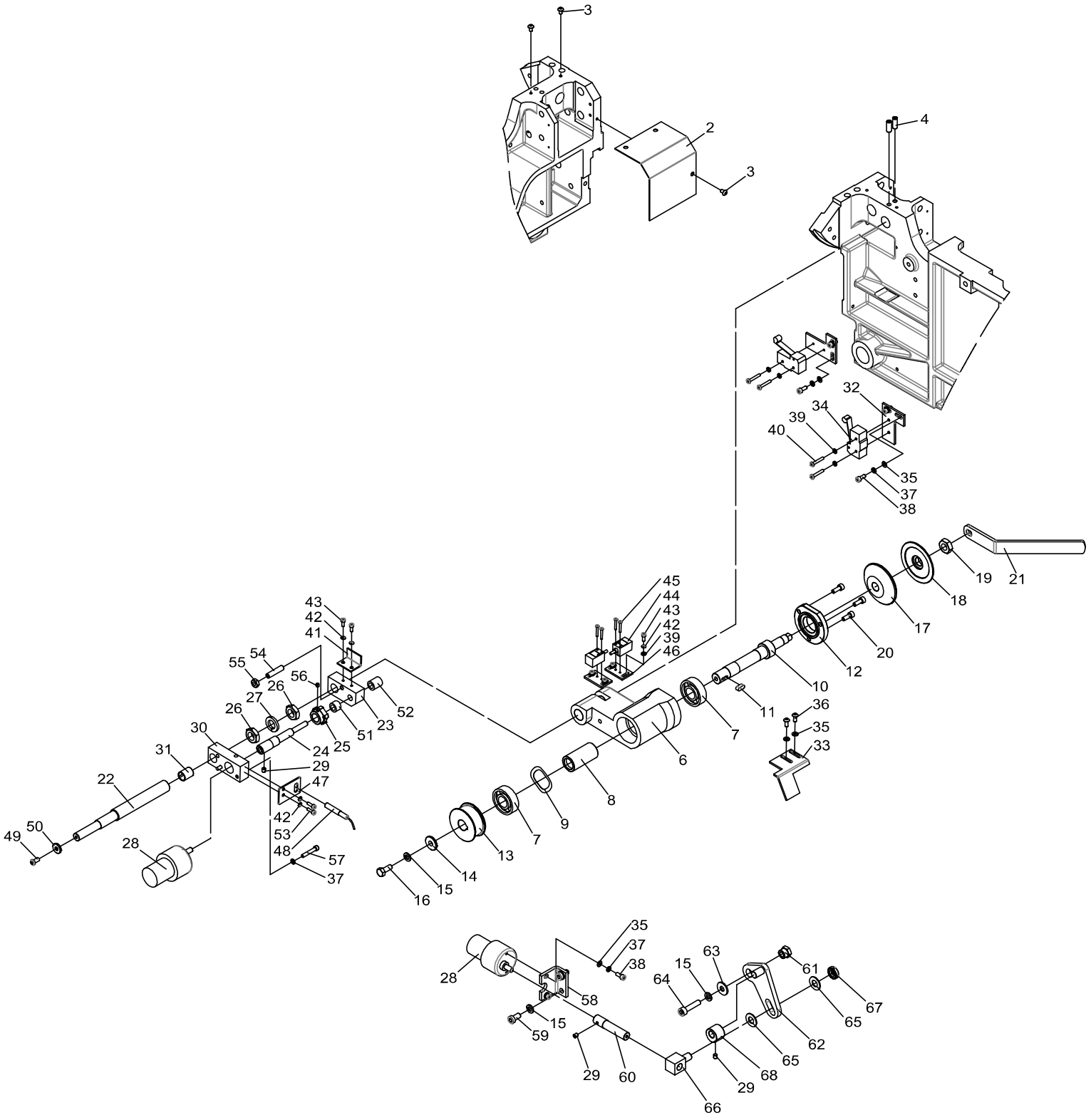
MAIN SAW ELEVATOR AND TILT



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-E015A	Motor Mount Bracket	
2	401150005	Lock washer	Ø10
3	401022104	Cap screw	M10x25
4	401200015	Fixed Ring	Ø8x20
5	LST-E002	Gear hous	
6	403060009	Therust Bearing	51106
7	LST-E003	Worm gear	
8	LST-E005	Adjustment nut	
9	403060002	Thrust Bearing	51103
10	NST-414-0-0	Collars	
11	LST-E007	Washer	
12	403017235	Ball Bearing	6903LLB
13	LST-E004	Cover	
14	401150003	Lock Washer	Ø6
15	401022055	Cap scre	M6X20
16	LST-E014	Screw	
17	401150004	Lock nut	Ø8
18	401022079	Cap Screw	M8x25
19	LST-E006A	Worm Shaft	
20	LST-E020	Fixed Base	

NO	FIG.NO.	DESCRIP TION	SPEC
21	406100020	DC Motor	AN1/M11030A1
22	403090026	Bush	LFB-1012
23	401022051	Cap scre	M6x12
24	401242001	Key	Ø3x10
25	401010009	Hex Head Bolt	M6x20
26	90310001-0	Linear Actuator	
27	409070001	Limit Switch	
28	ST-F069	Gasket	
29	ST-F062	Washer	14.2-30-5t
30	ST-F071	Join Shaft	
31	ST-F075	Fixed Base	
32	ST-F072	Rear Join Shaft	
33	401252007	Retain Ring	S12
34	409070003	Continuous fixed piece	
35	401151002	Safety Washer	Ø8
36	415071109	Decoder	HTR-HB-6-200-2-C
37	401140015	Washer	Ø3
38	401150010	Lock washer	Ø3
39	401022002	Cap screw	M3x8

SCORING SAW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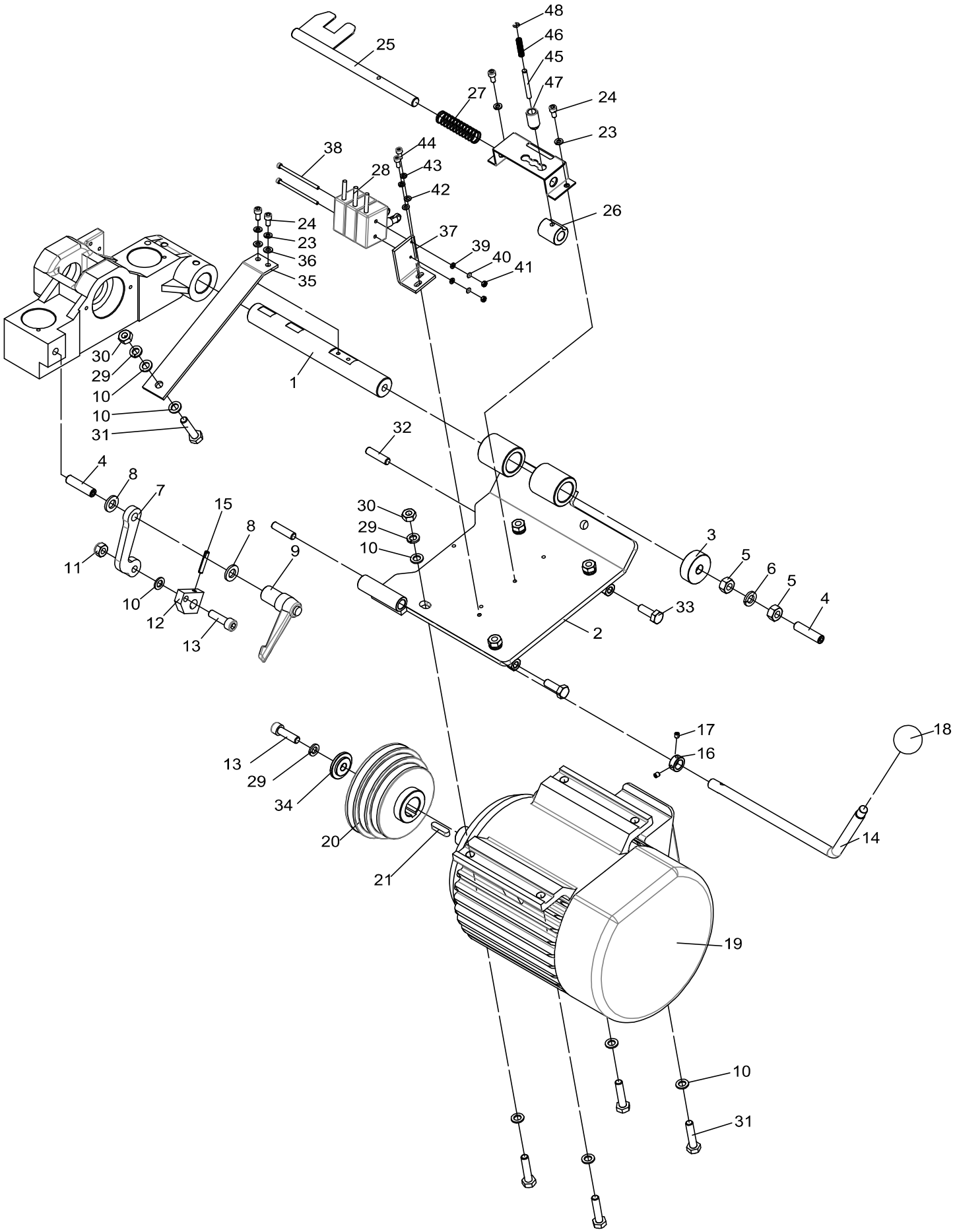
NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-D019A	Block	
2	LST-B010	Cover	
3	401032016	Button Head Serew	M5x8
4	401072054	Set screw	M8x20
5	401071025	Set serew	M5x10
6	LST-D001	Scoring Spindle Housing	
7	403015034	Ball Bearing	6204
8	LST-D003	Splndle Sleeve	
9	411050001	Wave washer	
10	LST-D002	Scoring Blade Spindle	
11	401230006	Key	6_6_15
12	NST-321-0-0	Bearing's front cover	
13	ST-I048C	Pulley	
14	ST-I039A	Fixing Ring	
15	401150003	Lock nut	Ø8
16	ST-I038A	Left hex head bolt	
17	ST-I046	Rear cover	
	ST-I046A	Rear cover	
	ST-I046B	Rear cover	
	ST-I046C	Rear cover	
18	ST-I047	Front cover	
19	401101008	Hex nut	M14-8t
20	401022053	Cap scre	M6x16
21	ST-I058	Scoring Blade Wrench	
22	LST-D029	Guide rod	
23	LST-D027	Adjustment block	
24	ST-I056C	Adjust Screw	
25	ST-I087	Split wheel	
26	401102001	Hex Nut	M16
27	401150008	Lock Washer	Ø8
28	406100023	DC Motor	
29	401072033	Setscrew	M6x6
30	LST-D028	Fixed block	
31	403090029	Oilless bearing	LFB-1420

NO	FIG.NO.	DESCRIP TION	SPEC
34	416040008	Micro switch	
35	401140002	Washer	Ø5
36	501032018	Button head screw	M5x12
37	401150002	Lock Washer	Ø5
38	401022028	Cap scre	M5x12
39	401140001	Washer	Ø4
40	401042014	Phillips sunk head cap screw	M4x25
41	ST405-321A	Dogs For Limit Switch	
42	401150001	Lock washer	Ø4
43	401022013	Cap screw	M4x10
44	416031010	Proximifty Switch	TL_Q5MC1
45	401042021	Phillips head screw	M3x20
46	ST-405-322	Bracket	
47	LST-D040	Stand by	
48	416031005	Proximity switch	
49	401042010	Phillips head screw	M6x12
50	NST-432-0-0	Washer	
51	408100005	Protective case	
52	408100002	Protective case	
53	401022014	Cap Screw	M4x12
54	401072057	Set serew	M8x35
55	401101005	Hex Head Bolt	M8
56	401072023	Setscrew	M5x6
57	401022034	Cap screw	M5x30
58	LST-D030	Motor mount	
59	401022222	Low Head Cap Screw	M8x16
60	LST-D032	Screw	
61	NST-317-0-0	Pivot axis	
62	LST-D018A	Crank	
63	401140028	Washer	8x23x3t
64	401022081	Cap Screw	M8x35
65	403150001	Bush	LFW1215
66	LST-D031	Driving Nut	
67	401103006	Lock Nut	GUK-12

7-3 MOTOR UNIT

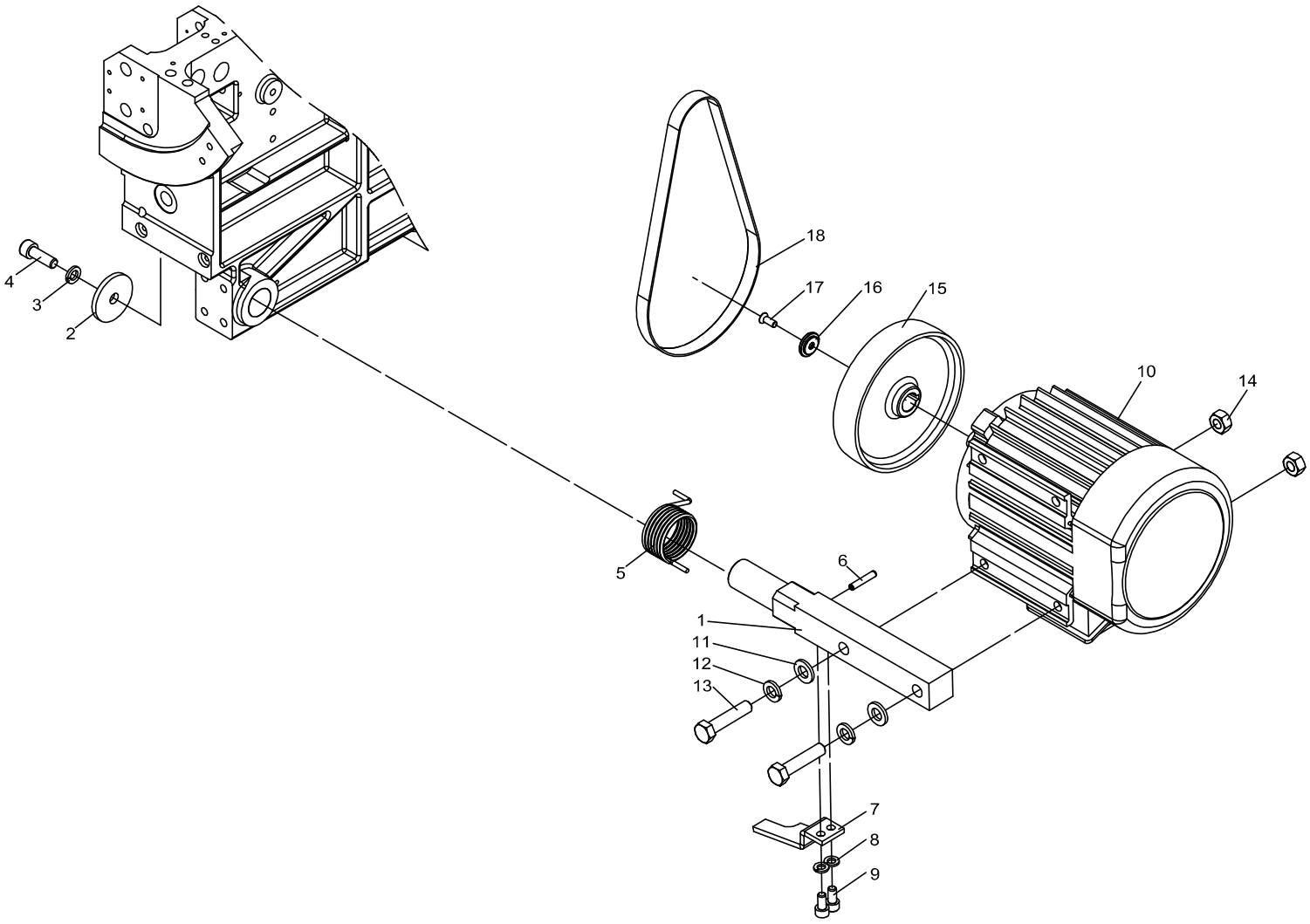
MAIN SAW MOTOR



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-C015A	Shaft	
2	LST-C016A	Main Motor Pivot Plate	
3	LST-C033	End caps	
4	401072085	Sew serew	M12x50
5	401101007	Hex Nut	M12
6	401150006	Lock washer	Ø12
7	LST-C018	Elbow	
8	401140014	Washer	Ø12
9	402040024	Adjustable handle	92KA-M12-O
10	401140005	Washer	Ø10
11	401103002	Lock Nut	M10
12	LST-C019	Rotary Block	
13	401022106	Cap Screw	M10x35
14	LST-C020	Adjust Handle	
15	401200019	Spring pin	Ø6x32
16	LST-D014	Sleeve ring	
17	401072033	Setscrew	M6X6
18	402060006	Knob	1/2"
19		Motor	7.5HP
20	LST-C034	Main Motor Puller	
21	401230005	Key	8x7x32
22	LST-C027	Fixed plate	
23	401150003	Lock Washer	Ø6
24	401022051	Cap scre	M6x12

NO	FIG.NO.	DESCRIP TION	SPEC
25	LST-C022	Cahahg Shaft	
26	LST-C040	Sensing Block	
27	LST-C041	Compressed Spring	
28	416040002	Limit Switch	TZ7312
29	401150005	Lock washer	Ø10
30	401101006	Hex head bolt	M10
31	401010039	Hex Bolt	M10x40
32	401071071	Set screw	M10x40
33	401010037	Hex Bolt	M10x30
34	LST-C007	Fixed Ring	
35	LST-C026	Spring Sheet	
36	401140010	Washer	Ø6
37	LST-C039	Fixed seat	
38	401022231	Cap screw	M4x75
39	401140001	Washer	Ø4
40	401150001	Lock washer	Ø4
41	401101002	Hex nut	M4
42	401140002	Washer	Ø5
43	401150002	Lock Washer	Ø5
44	401022028	Cap scre	M5x12
45	LST-C024	Positioning axis	
46	LST-C028	Spring	
47	LST-C025	Bushing	
48	401253009	Retaining Rings E Type	E4

SCORING SAW MOTOR

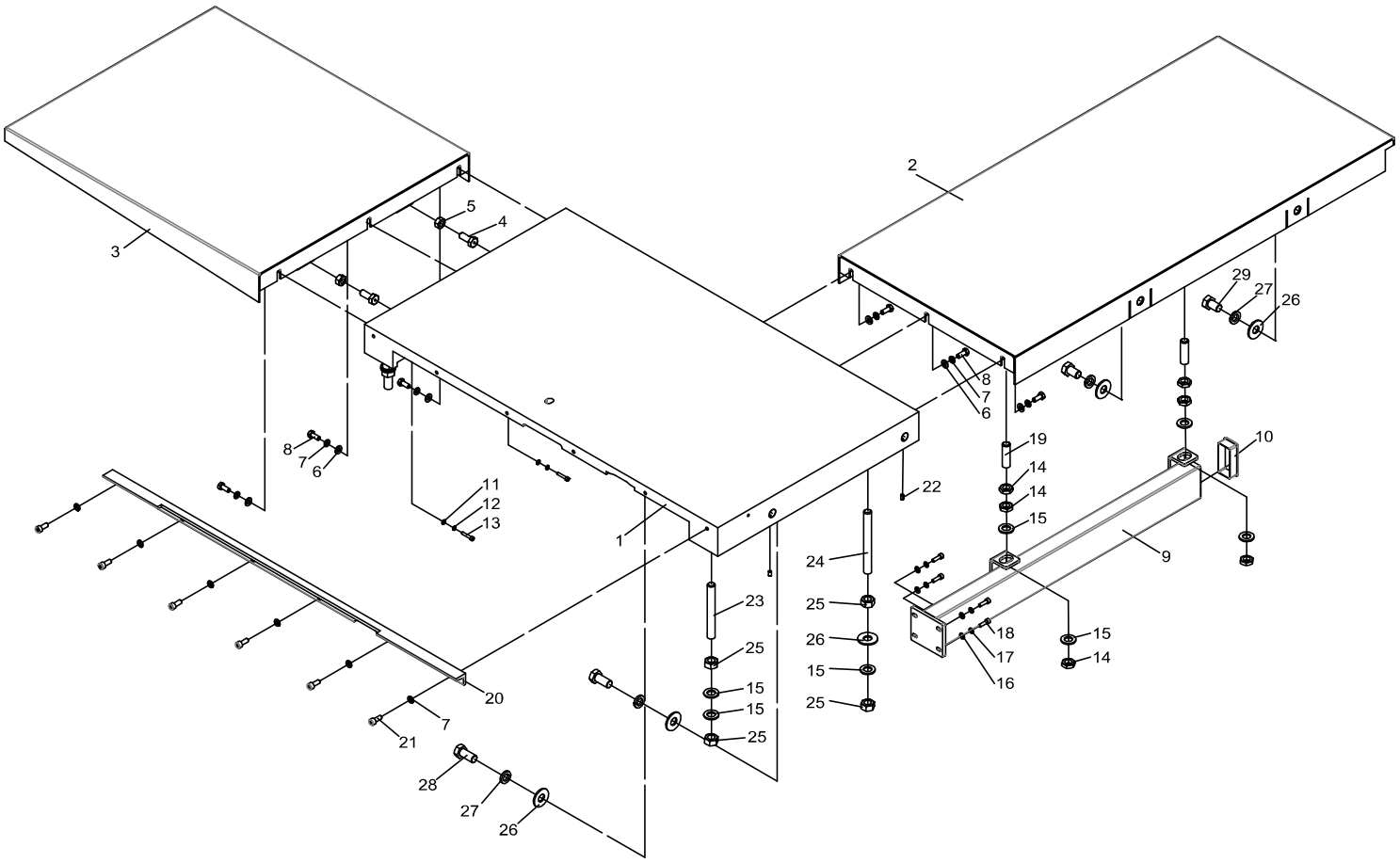


NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-D005	Pivot axis	
2	LST-D007A	Washer	
3	401150005	Lock Washer	Ø10
4	401022105	Cap scre	M10x30
5	NST-104-0-0	Spring	
6	401200019	Spring pin	Ø6x32
7	LST-D025	Stop Board	
8	401150003	Lock nut	Ø8
9	401022076	Cap Screw	M8x16

NO	FIG.NO.	DESCRIP TION	SPEC
10		Motor	
11	401140014	Washer	Ø12
12	401150006	Lock Washer	Ø12
13	401011023	Hex Bolt	M12x55
14	401101007	Hex Nut	M12
15	ST-I032	Pulley	
16	ST-I040	Lock Ring	
17	401052131	Counter sunk head cap screw	M6x16
18	405040006	Belt	15x670x1.8t

7-4 TABLE UNIT

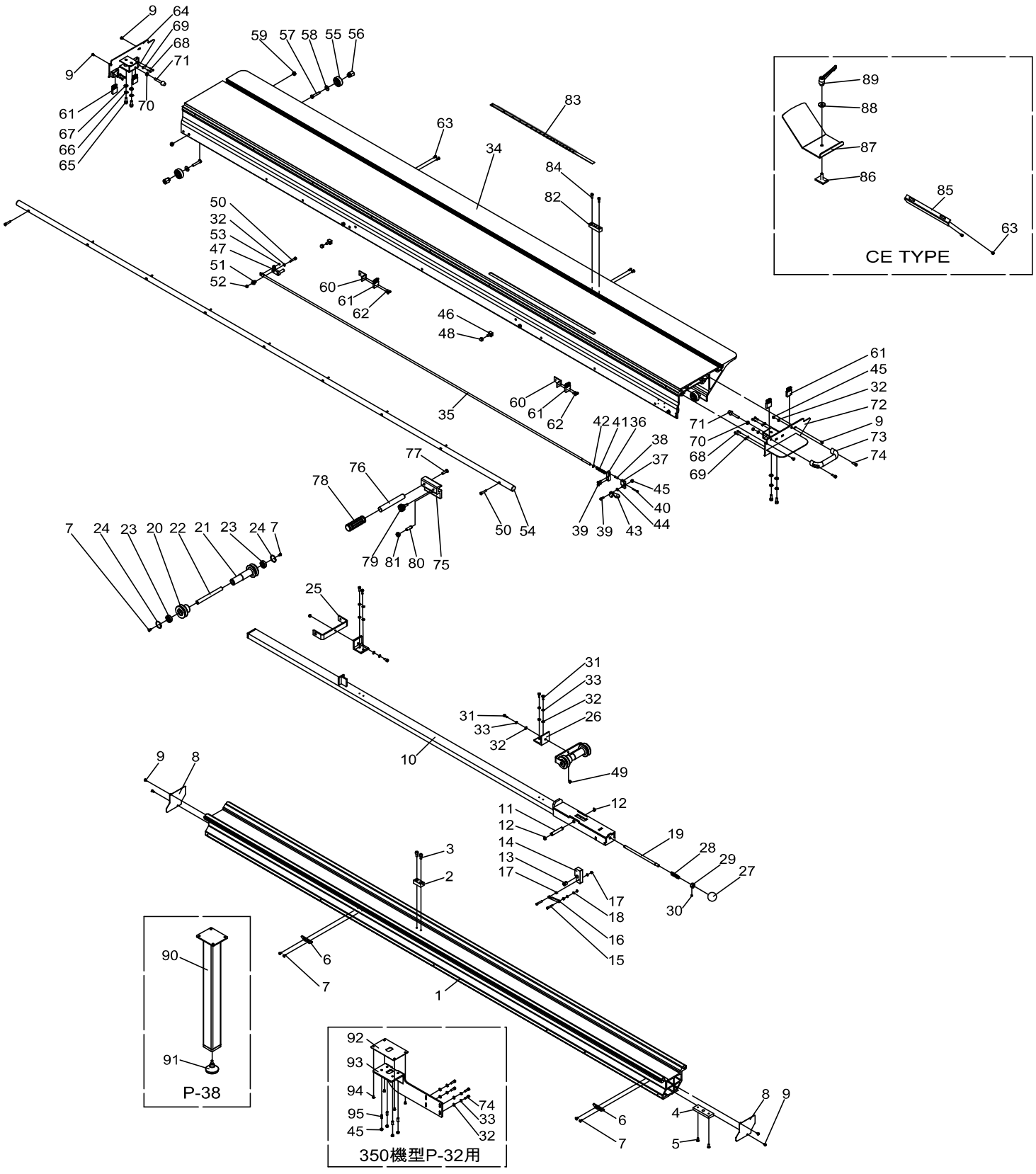
MAIN TABLE



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-F001H	Workbench	
2	LST-F014G	Width extension	1.3m
	LST-F014I	Width extension	1.5m
3	LST-F011	Small Extension Table	CE
	LST-F011A	Small Extension Table	
4	ST405-505	Hex screw	
5	401101007	Hex Nut	M12
6	401151002	Safety Washer	Ø8
7	401150003	Lock nut	Ø8
8	401010019	Hex Head Bolt	M8x20
9	LST-F015A	Support rack	1.3/1.5
10	402130001	Square pipe plug	80-40-3t
11	401140002	Washer	Ø5
12	401150002	Lock Washer	Ø5
13	401022033	Cap screw	M5x25
14	401101012	Hex Nut	M16

NO	FIG.NO.	DESCRIP TION	SPEC
15	401140020	Washer	Ø16
16	401140010	Washer	Ø6
17	401150003	Lock Washer	Ø6
18	401022055	Cap scre	M6X20
19	401072086	Set serew	M16x55
20	LST-F003A	Table Insert	
21	401022078	Cap scre	M8x20
22	401072035	Set screw	M6x10
23	401072135	Set screw	M16x130
24	401071131	Set Screw	M16x150
25	401101012	Hex Nut	
26	401140007	Washer	Ø16-40
27	401150008	Lock Washer	Ø16
28	401010076	Hexagon screw	M16x35
29	401010077	Hexagon screw	M16x25

SLIDING TABLE



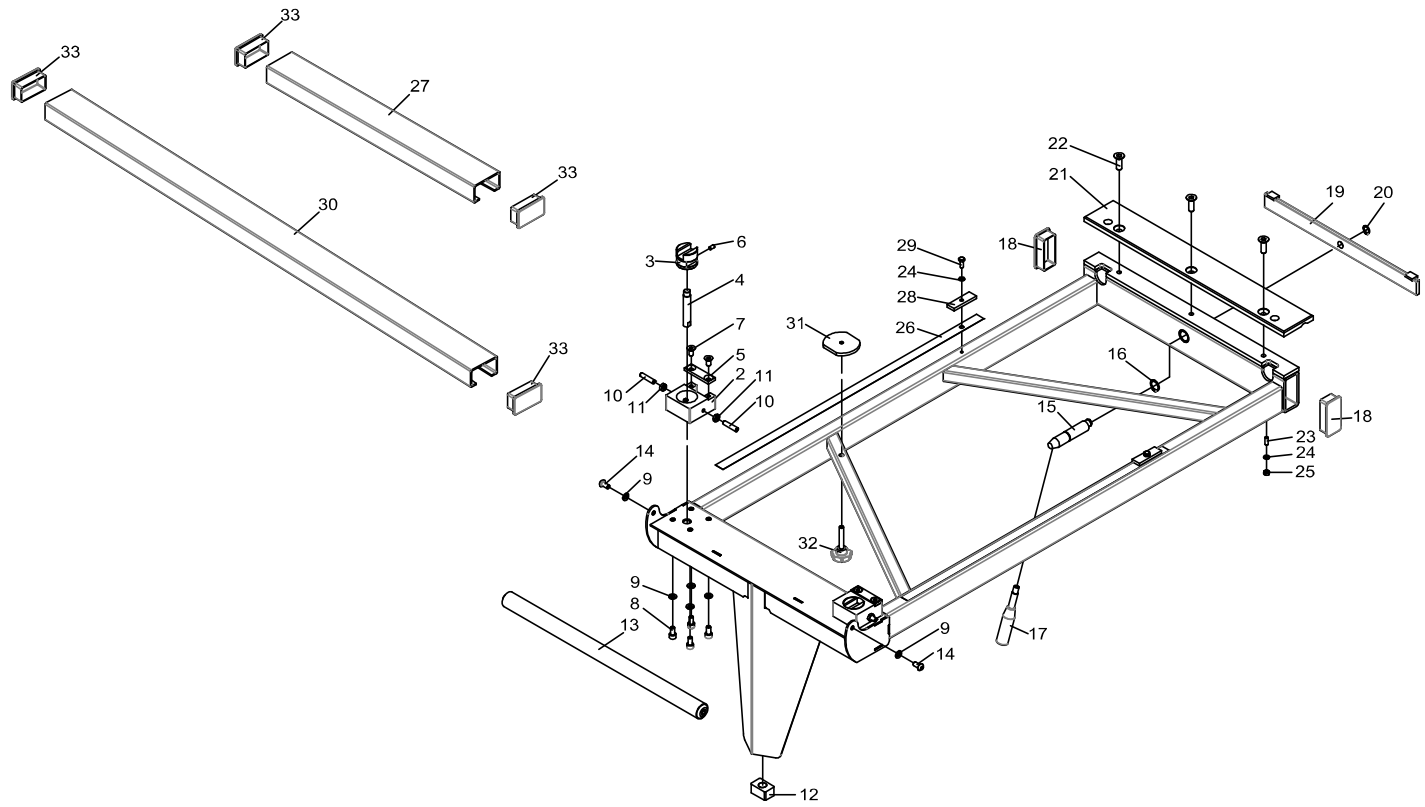
NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-K302E	Support Base	1.9m
	ST-K302D	Support Base	2.6m
	ST-K302B	Support Base	3.2m
	ST-K302C	Support Base	3.8m
2	ST-K041A	Stop block	
3	401022076	Cap screw	M8x16
4	ST-K002	Lock Block	
5	401052131	Counter sunk head cap screw	M6x16
6	ST-K316	Positioning block	
7	401052129	Counter sunk head cap screw	M6x12
8	ST-K320	Cover	
9	401042107	Phillips sunk head cap screw	M5x8
10	ST-K203C	Slide Bar	1.9m
	ST-K203B	Slide Bar	2.6m
	ST-K203	Slide Bar	3.2m
	ST-K203A	Slide Bar	3.8m
11	ST-K071	Fixed Shaft	
12	401252007	Retain Ring	S12
13	403090013	Bush	LFB1215
14	ST-K069A	Stop Block	
15	401022034	Cap screw	M5x30
16	ST-K073	Join element	
17	401101003	Hex Nut	M5
18	401140002	Washer	Ø5
19	ST-K080	Pull bar	
20	ST-K095	Sliding wheel	
21	ST-K094	Slide Wheel	
22	ST-K096	Slide Wheel Shaft	
23	403017102	Ball bearing	6002LLB
24	401251024	Retaining rings for hole	R32
25	ST-K097A	Slide Wheel Base	
26	ST-K098A	Fixed Base	
27	402060005	Knob	
28	ST-K082	Spring	

NO	FIG.NO.	DESCRIP TION	SPEC
29	ST-K083	Fixing ring	
30	401072033	Set Serew	M6x6
31	401010008	Hex head bolt	M6x16
32	401140010	Washer	Ø6
33	401150003	Lock Washer	Ø6
34	ST-K301E	Slide Table	1.9m
	ST-K301D	Slide Table	2.6m
	ST-K301B	Slide Table	3.2m
	ST-K301C	Slide Table	3.8m
35	ST-K323D	Connect Block	1.9m
	ST-K323C	Connect Block	2.6m
	ST-K323A	Connect Block	3.2m
	ST-K323B	Connect Block	3.8m
36	ST-K309A	Fixed Block	
37	ST-K308A	Stop block	
38	401200001	Spring Pin	Ø5-20
39	401032032	Button head screw	M6x16
40	401021020	Cap screw	M4x30
41	ST-K317	Spring	
42	401253012	Retaining Rings E Type	E6
43	ST-K307A	Handle	
44	ST-K322	Washer	
45	401101004	Hex Nut	M6
46	ST-311	Fixed Pillar	
47	ST-K313A	Connect Block	
48	401104003	Cap Nup	M8
49	401103005	Lock Nut	M6
50	401022057	Cap screw	M6x30
51	ST-K312	Pivot Axis	
52	401104004	Cap Nut	M6
53	401253009	Retaining Rings E Type	E4
54	ST-K204C	Slide Rall	1.9m
	ST-K204B	Slide Rall	2.6m
	ST-K204	Slide Rall	3.2m

NO	FIG.NO.	DESCRIP TION	SPEC
	ST-K204A	Slide Rall	3.8m
55	ST-K043A	Sliding Wheel	
56	ST-K044	Adjust Block	
57	401010025	Hex head bolt	M8x45
58	401140028	Washer	Ø8
59	401103001	Lock nut	M8
60	ST-K034	Bristle Brush Base	
61	ST-K031	Bristle brush	
62	401022028	Cap scre	M5x12
63	401032030	Button Head serew	M6x12
64	ST-306	Cover	
65	401022078	Cap scre	M8x20
66	401151002	Spring washer	Ø8
67	401140004	Washer	Ø8
68	401022016	Cap scre	M4x16
69	401101002	Hex nut	M4
70	401101005	Hex Head Bolt	M8
71	402160002	Stop block	
72	ST-K305	Cover	
73	402020001	Handle	
74	401022055	Cap scre	
75	ST-K003A	Fixed Block	
76	ST-K004	Handle	
77	401052143	Counter sunk hear cap screw	M8X25
78	402010011	Handle sleeve	
79	402100002	Emboss sscrew	8010-30-M8-20
80	RS-4025	Screw	
81	401101006	Hex head bolt	M10
82	ST-L007	Positioning block	
83	ST-K010	Scale	
84	401022053	Cap scre	M6x16
85	ST-K318	Touch Block	
86	ST-L011	T-Shape Block	
87	ST-L029	Stop Board	

NO	FIG.NO.	DESCRIP TION	SPEC
88	RH-2040	Washer	
89	402040025	Adjustable handle	92ZN-M10
90	ST-K207	Support Stand	
91	401260002	Level adjustmene block	
92	LST-A052	Extended bracket spacer	
93	LST-A051	Extension bracket	
94	401032016	Button Head Serew	M5x8
95	401072052	Set screw	M8x16

CROSSCUT TABLE

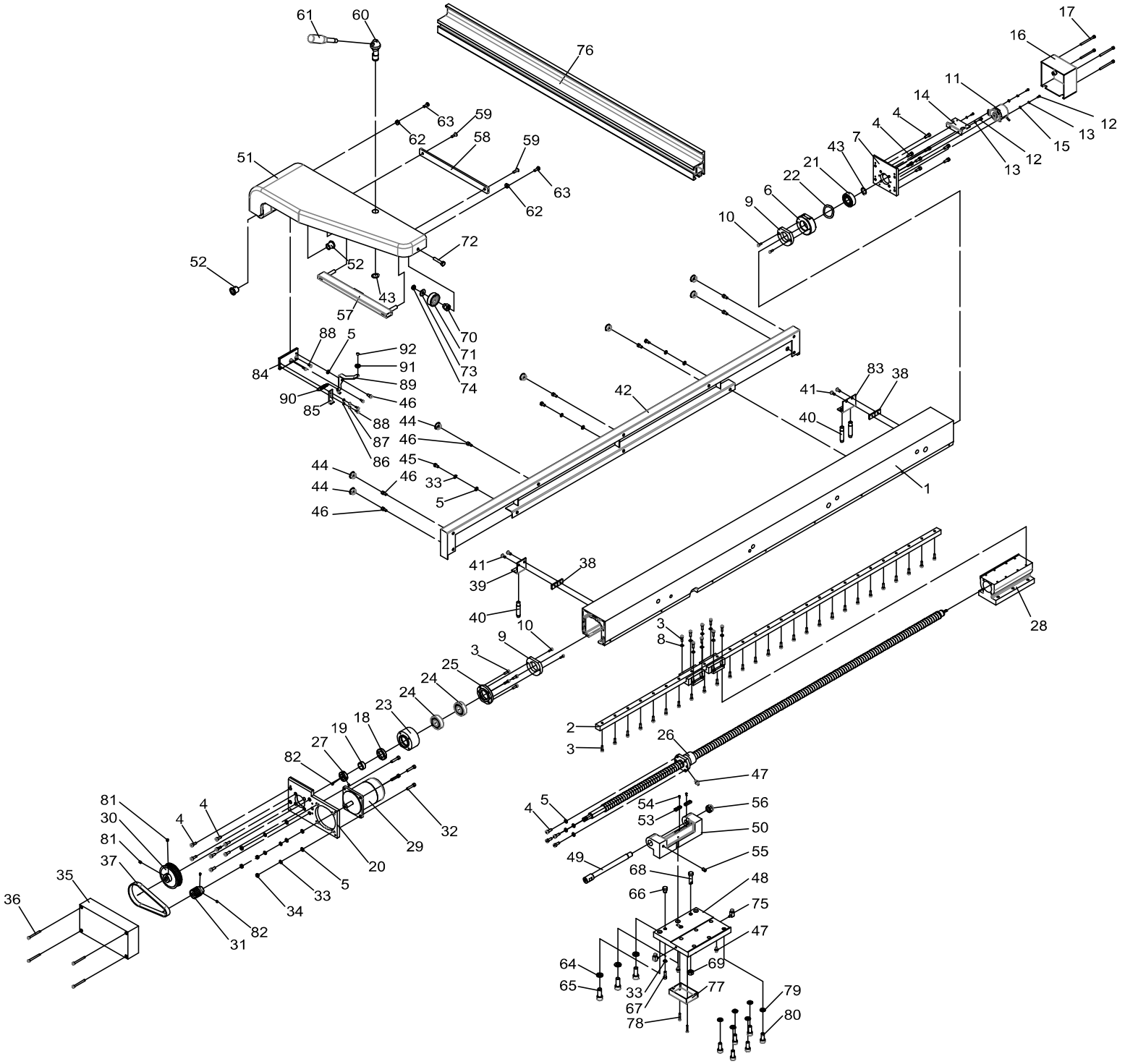


NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-G005	Crosscut Table Frame	P26/P32
	LST-G005A	Crosscut Table Frame	P19
2	ST-M022B	Fixed Base	
3	ST-M028A	Adjust Block	
4	ST-M029	Screw	
5	ST-M023	Clamp Element	
6	401072035	Set screw	M6x10
7	401052139	Counter sunk head cap screw	M8x12
8	401022076	Cap screw	M8x16
9	401150003	Lock nut	Ø8
10	401072057	Set serew	Mx35
11	401101005	Hex Head Bolt	M8
12	NST-713-0-0	Rubber guide	
13	403140001	Roller elementU-318	SC-RL524-12/M8x15
14	401032043	Button Head Screw	M8x16
15	ST-M005	Fixed Shaft	
16	401252015	Retaining rings for shaft	S-20
17	402010002	Round Knob	7108-M10-100

NO	FIG.NO.	DESCRIP TION	SPEC
18	ST-M037	Caps	80-40-4t
19	ST-M006	Lock Bar	
20	401252009	Retaining rings for shaft	S-14
21	ST-M002A	Fixed Board	
22	401052152	Counter sunk head cap screw	M10x25
23	401072038	Set Screw	M6x16
24	401150003	Lock Washer	Ø8
25	401101004	Hex Nut	M6
26	ST-N095	Avert Friction Sheet	2.6m、3.2m
	ST-N095A	Avert Friction Sheet	1.9m
27	ST-M018	Short cross-support	
28	ST-M016	Block	
29	401010008	Hex head bolt	M6x16
30	ST-M019	Long cross-support	
31	ST-M020	Clampingn element	
32	402070005	Knob bolt	HS50AM850
33	ST-M017	Caps	70-40-3t

7-5 FENCE UNIT

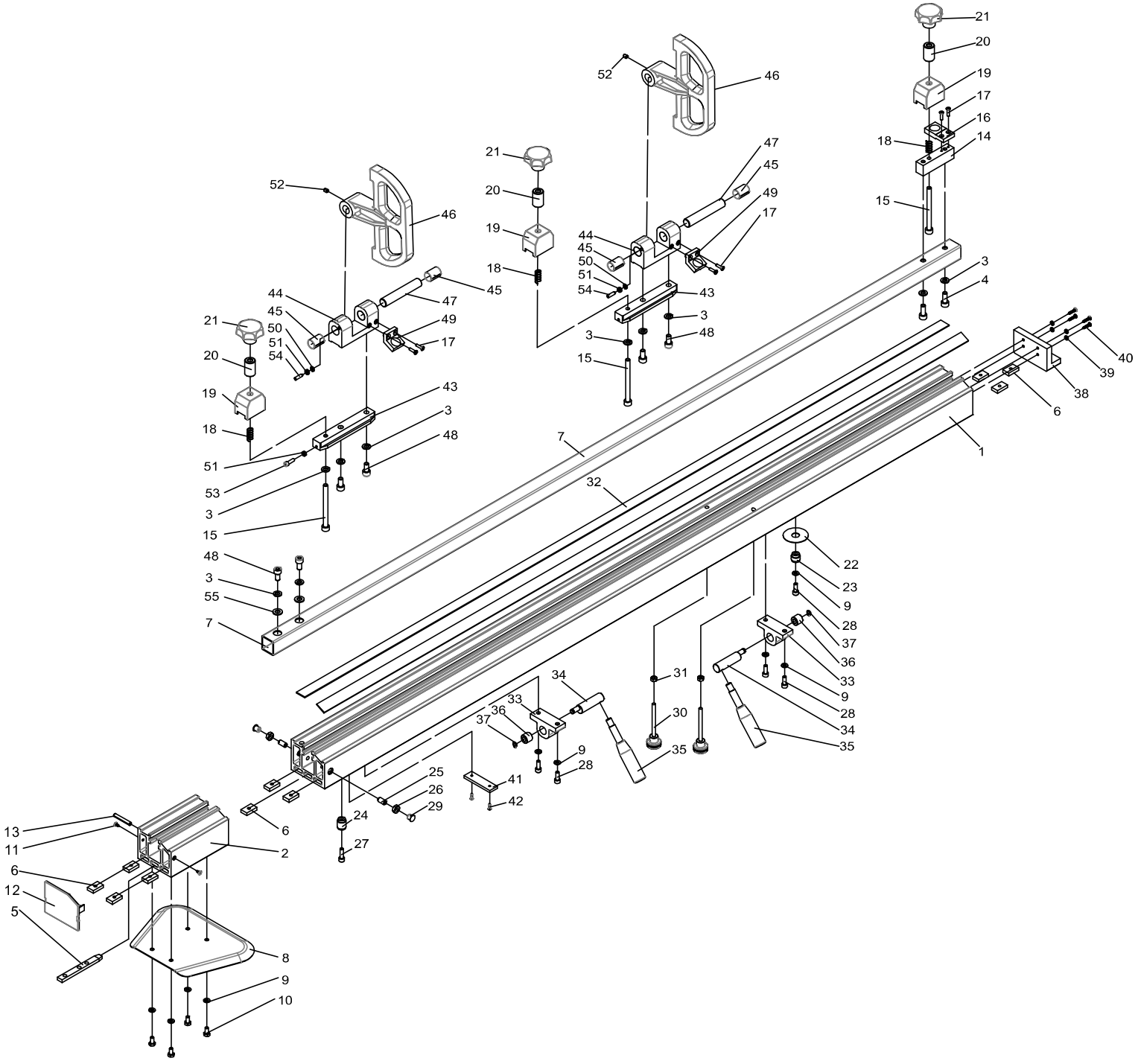
AUTO FENCE



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-T803	Plate slide	1.3M
	ST-T804	Plate slide	1.5M
2	404010008	Linear slide(1.3M)	HGW-20-HC-2-R1600-ZA-C
	404010005	Linear slide(1.5M)	HGW-20-HC-2-R1780-ZA-C
3	401020030	Cap screw	M5x16
4	401022053	Cap scre	M6x16
5	401140010	Washer	Ø6
6	ST-N212	Bearing housing	
7	ST-T108B	Fixed plate	
8	401140002	Washer	Ø5
9	ST-T115	Urethance Washer	
10	401022014	Cap Screw	M4x8
11	415071106	Decoder	HTR-HB-6-200AH
12	401022002	Cap screw	M3x8
13	401150010	Lock washer	Ø3
14	ST-T078	Termial block	
15	401140015	Washer	Ø3
16	ST-T045A	Cover	
17	401022040	Cap screw	M5x60
18	408010001	Grease seal	25X38X8 TC
19	ST-T105	Spacer Ring	
20	ST-T106A	Base Plate	
21	403015134	Deep groove ball bearing	6204-2NSE-CM
22	411050001	Wave washer	D46.2xD35.66xT0.51
23	ST-T103A	Bearing Holder	
24	403020005	Angular contact ball bearing	7204 BWDBCP10 NSK
25	ST-T104A	Bearing cover	
26	ST-T004F	Ball screw(1.3M)	R25x10k3XFSCX1573x1700x0.05
	ST-T004E	Ball screw(1.5M)	R25x10k3XFSCX1773x1900x0.05
27	401110001	Precision Nut	YSR M20x1.0
28	ST-T102D	Slider	
29	406100024	DC Motor	D12A(K)24-1800-12-M
30	ST-T026D	Pulley	
31	ST-T027D	Pulley	
32	401022057	Cap screw	M6x30
33	401150003	Lock Washer	Ø6
34	401101004	Hex Nut	M6
35	ST-T036	Cover	
36	401021038	Cap scre	M6x50
37	405030003	Timing belt	HTD-420-5M-15
38	ST-N059A	Fixed piece	
39	ST-T035	Sensor holder	
40	416031007	Proximity open	PM12-04N
41	401032030	Button Head serew	M6x12
42	ST-T111	Shield	1.5M
	ST-T111A	Shield	1.3M
43	401252015	Retaining rings for shaft	STW-20
44	414080003	Hole plugs	HP-19
45	401010007	Hex head bolt	M6x12
46	401022051	Cap scre	M6x12
47	410030001	Butt mouth straight	M6xP1
48	ST-T110C	Connector	
49	ST-T014B	Rotating shaft	
50	ST-T005C	Connecting shaft seat	
51	ST-T017D	Plate flxing arm	
52	ST-T238	Copper bushing	
53	416031006	Proximity switch	TL-W1R5MC1
54	401051101	Countersink Hend Screw	M3x6
55	401072050	Set screw	M8x12
56	401103004	Hex nut	M14
57	ST-Q010	Lashing bar	
58	ST-Q005	Lashing plate	
59	401052132	Countersink Head Screw	M6x12
60	ST-Q011A	Fixed shaft	
61	402010009	Handle	7108-M12-137
62	ST-Q002	Guide wheel	
63	401010008	Hex head bolt	M6x16
64	401150006	Lock washer	Ø12
65	401022127	Cap screw	M12x30
66	ST-T019	Location pins	
67	401022055	Cap scre	M6X20
68	ST-T018A	Adjust the location pins	
69	401101006	Hex head bolt	M10
70	ST-K044	Sliding wheel adjusting block	
71	ST-K043A	Sliding Wheel	
72	401010023	Hex head bolt	M8x40
73	401140028	Washer	Ø8
74	401101005	Hex Head Bolt	M8
75	410071005	L type oil joint	M6
76	ST-Q014	Rip fence	
77	ST-T076	Wire connector cover	
78	401042014	Phillips head screw	M4x25
79	401150005	Lock washer	Ø10
80	401022104	Cap screw	M10x25
81	401072033	Setscrew	M6X6
82	401072023	Setscrew	M5x6
83	ST-T035A	Sensor holder	
84	ST-T065C	Detect block	

NO	FIG.NO.	DESCRIPTION	SPEC
85	ST-T067B	Detect block	
86	401140001	Washer	Ø4
87	401150001	Lock washer	Ø4
88	401022013	Cap screw	M4x10
89	ST-T064B	Detect block	
90	411020007	Stretch bomb	0.9x8x42.5
91	ST-T066A	Touch block	
92	401052108	Countersink Head Screw	M4x6

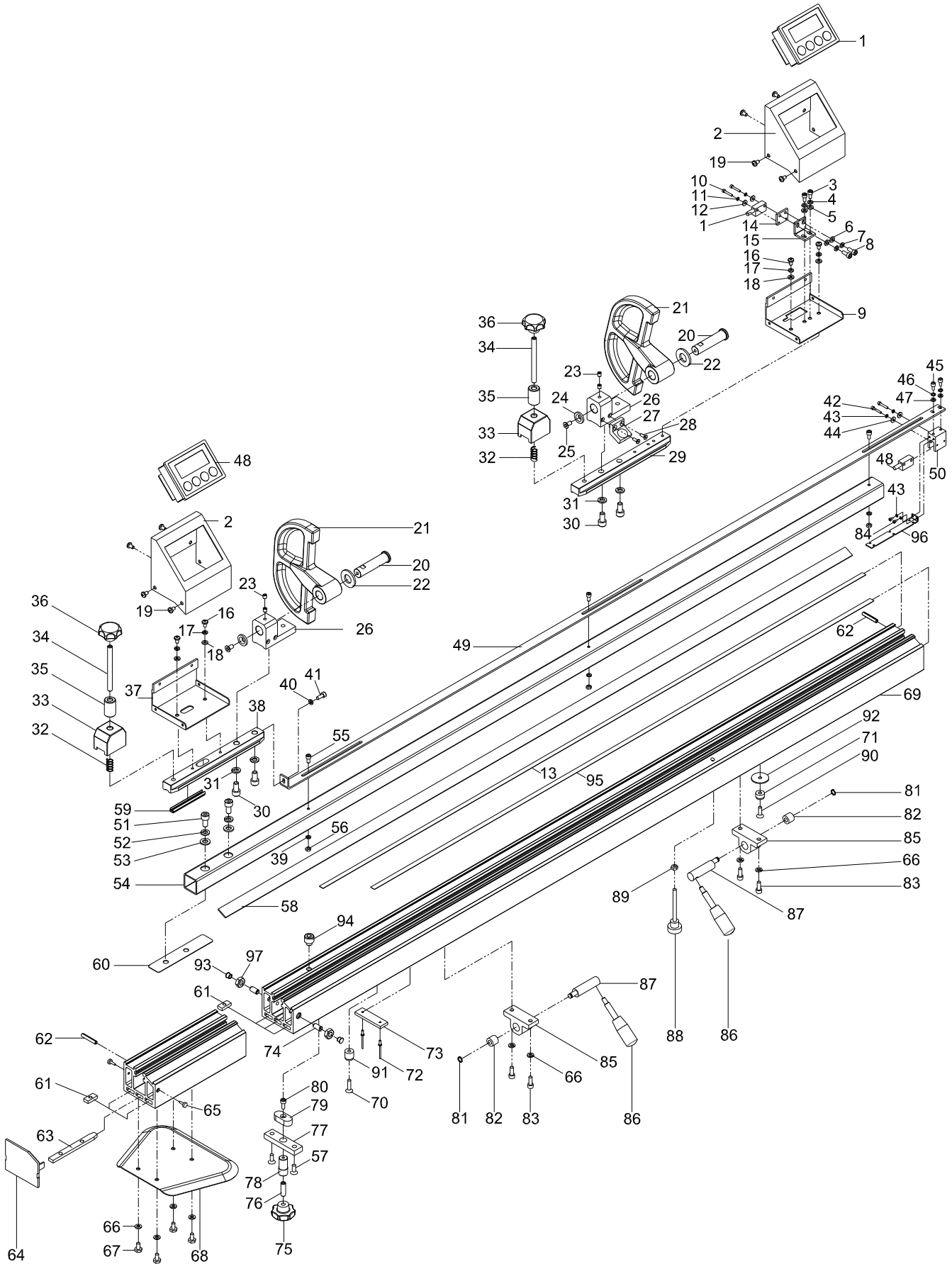
CROSSCUT FENCE



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-N058	Fence Scale Base	2.6、3.2m
	ST-N058C	Fence Scale Base	1.9m
2	ST-N061	Scale Base	
3	401150003	Lock nut	Ø8
4	401022078	Cap scre	M8x20
5	ST-N055	Positioning pin	
6	ST-N059	Fixing sheet	
7	ST-N006	Positioning pipe	30x30x2tx1733L
8	ST-N054A	Butterly-shaped plate	
9	401150003	Lock Washer	Ø6
10	401010005	Hex head bolt	M6x12
11	401060004	PLUG	1/8"-3/8"
12	ST-N060	Left cover plate	
13	401200008	Spring Pin	Ø6x40
14	ST-N018	Locking lower slide block	
15	401021092	Cap screw	M8x90
16	ST-N015	Magnifier	
17	401051110	Counter sunk head cap screw	M4x12
18	ST-N022	Spring	
19	ST-N013	Locking slide block	
20	ST-N014	Locking bush	
21	402070002	Star-ahaped knob	HS50AM8
22	ST-N005	Washer	
23	ST-N004	Front positioning pin	
24	ST-N003	Rear Positioning Pin	
25	ST-N107	Set screw	
26	401101005	Hex Head Bolt	M8
27	401022055	Cap scre	M6x20
28	401022053	Cap scre	M6x16
29	414080008	Hole plug	HP-9
30	ST-N023	Embossing screw	ST-N023-01+402100003
31	401101004	Hex Nut	M6

NO	FIG.NO.	DESCRIP TION	SPEC
32	ST-N063	2.6、3.2Fence Scale	60~1670mm
	ST-N063C	2.6、3.2Fence Scale	1670~3270mm
	ST-N063D	1.9Fence Scale	60~1410mm
	ST-N063E	1.9Fence Scale	1410~2750mm
	ST-N028	2.6、3.2Fence Scale	3"~66"
	ST-N028C	2.6、3.2Fence Scale	66"~129"
	ST-N028D	1.9Fence Scale	3"~55"
	ST-N028E	1.9Fence Scale	55"~109"
33	ST-N035	Tigthening base	
34	ST-N031	Rotary fastening base	
35	402010002	Round Knob	7108-63(M10-110)
36	ST-N036	Tightening ring	
37	401252003	Retaining rings for shaft	S8
38	ST-N052	Lengthening scale base	
39	401140001	Washer	Ø4
40	401060001	PLUG	1/8"-3/4"
41	ST-N062	Packing-up Block	
42	401290001	Draw Naill	4_2
43	ST-N027	Locking lower slide base	
44	ST-N007	Adjusting block	
45	403090028	Bush	MB1625
46	ST-N008	Positioning plate	
47	ST-N011	Shaft	
48	401022076	Cap screw	M8x16
49	ST-N053	Magnifier	
50	401150002	Lock Washer	Ø5
51	401101003	Hex Nut	M5
52	401072033	Setscrew	M6X6
53	401022032	Cap scre	M5x20
54	ST-N091B	Set Screw	M5x16
55	401151002	Washer	Ø8

CROSSCUT FENCE TWO DIGITAL DISPLAY



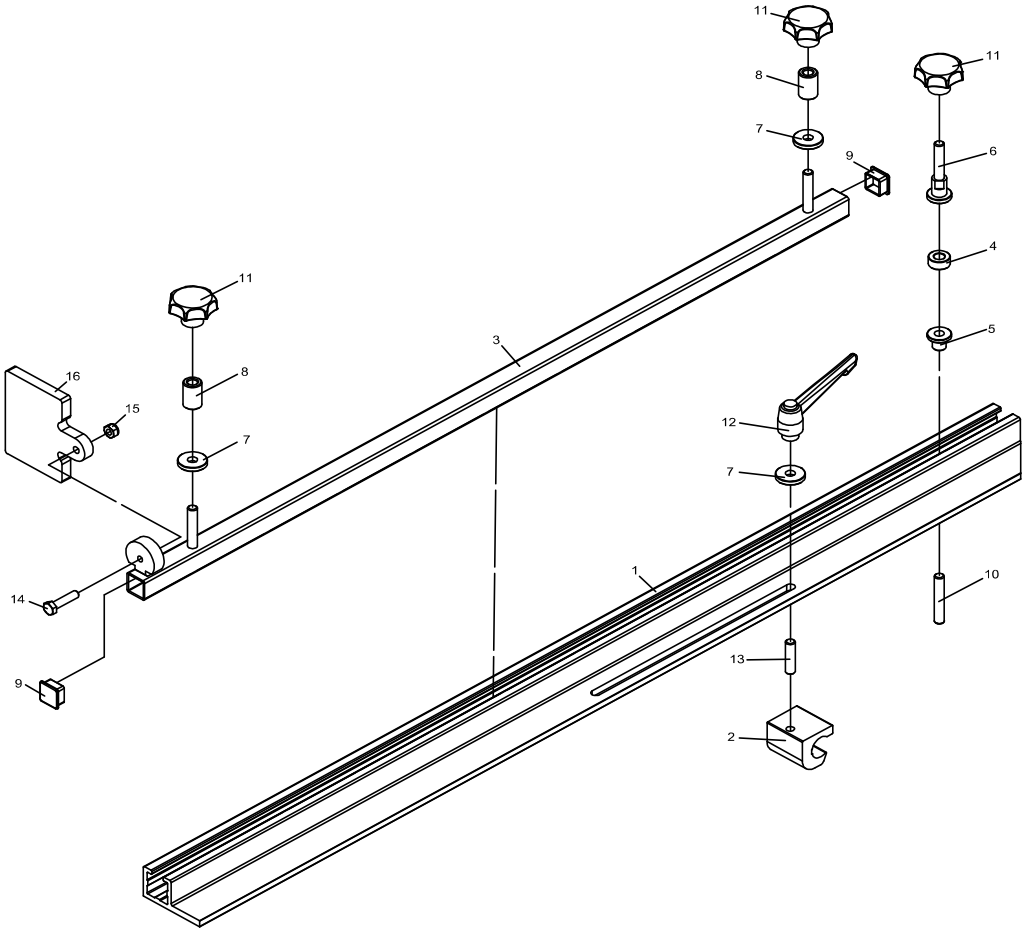
NO	FIG.NO.	DESCRIP TION	SPEC
1	415020001	Digital Display	50cm
2	ST-N064	Cover	
3	401022028	Cap Screw	M5x12
4	401150002	Lock Washer	φ5
5	401140002	Washer	φ5
6	401140002	Washer	φ5
7	401150002	Lock Washer	φ5
8	401022026	Cap Screw	M5x8
9	ST-N065	Cover Base	
10	401022003	Cap Screw	M3x10
11	401150010	Lock Washer	φ3
12	401140015	Washer	φ3
13	415020014	Magnetic Ruler	
14	ST-N068	Fixed Board	
15	ST-N067	Fixed Rack	
16	401022026	Cap Screw	M5x8
17	401150002	Lock Washer	φ5
18	401140002	Washer	φ5
19	401042008	Phillips Head Screw	M5x8
20	ST-N099	Pivot Axis	
21	ST-N008	Position Plate	
22	ST-N100	Washer	
23	401072035	Setscrew	M6x10
24	ST-N101	Washer	
25	401052129	Countersink Head Screw	M6x12
26	ST-N073A	Fixed Base	
27	ST-N053	Magnifier	
28	401052111	Countersink Head Screw	M4x14
29	ST-N066D	Lock Slide Base	
30	401022076	Cap Screw	M8x16

NO	FIG.NO.	DESCRIP TION	SPEC
31	401150004	Lock Washer	φ8
32	ST-N022	Spring	
33	ST-N013	Lock Slide Block	
34	401072138	Setscrew	M8x90
35	ST-N014	Lock Bush	
36	402070002	Star-Shaoed Knob	M8
37	ST-N065B	Cover	
38	ST-N066E	Lock Slide Base	
39	401140002	Lock Washer	φ5
40	401150002	Lock Washer	φ5
41	401022026	Cap Screw	M5x8
42	401022007	Cap Screw	M3x18
43	401150010	Lock Washer	φ3
44	401140015	Washer	φ3
45	401022013	Cap Screw	M4x10
46	401150001	Lock Washer	φ4
47	401140001	Washer	φ4
48	415020012	Digital Dispay	3m
49	ST-N102	Join Bar	2.6m、3.2m
	ST-N102A	Join Bar	1.9m
50	ST-N103	Fixed Block	
51	401022076	Cap Screw	M8x16
52	401150004	Lock Washer	φ8
53	401140004	Washer	φ8
54	ST-N006D	Position Pipe	2.6m、3.2m
	ST-N006E	Position Pipe	1.9m
55	401022223	Cap Screw	M5x10
56	401101003	Hex Nut	M5
57	401052132	Countersink Head Screw	M6x20
58	ST-N028F	Scale	2..6m、3.2m

NO	FIG.NO.	DESCRIP TION	SPEC
	ST-N028H	Scale	1.9m
59	408110003	Slot Cover	
60	ST-N113	Packing Up Block	
61	ST-N059	Fixed Sheet	6x25x15L
62	401200008	Spring Pin	φ6x40
63	ST-N055	Position Pin	
64	ST-N060	Cover	
65	401060001	Wooden Screw	1/8"x3/4"L
66	401150003	Lock Washer	φ6
67	401011004	Hex Head Screw	M6x12
68	ST-N054A	Butterfly-Shaped Plate	
69	ST-N058E	Fence Scale Base	2.6、3.2m
	ST-N058I	Fence Scale Base	1.9m
70	401022055	Cap Screw	M6x20
71	ST-N003	Position Pin	
72	401290002	Draw Nail	4-3
73	ST-N062	Packing Up Block	
74	ST-N107	Setscrew	
75	402070002	Star-Shaped Knob	M8
76	401072058	Setscrew	M8x40
77	ST-N105	Fixed Block	
78	ST-N106	Lock Screw	
79	ST-N104	Fixed Block	
80	401022223	Cap Screw	M5x10
81	401252003	Retain Ring	STW-08
82	ST-N036	Tighten Ring	
83	401022053	Cap Screw	M6x16
84	401022003	Cap Screw	M3x10
85	ST-N035	Tightening Base	
86	402010002	Handle	7108-M10-100

NO	FIG.NO.	DESCRIP TION	SPEC
87	ST-N031	Rotary Fastening Base	
88	ST-N023	Embossing Screw	
89	401101004	Hex Nut	M6
90	401022053	Cap Screw	M6x16
91	ST-N004	Pin	
92	ST-N005	Washer	
93	414080008	Fence Scale Base	HP-09
94	ST-N094	Stop Screw	
95	415020013	Magnetic Ruler	1450mm
96	ST-N112	Safe Sheet	
97	401101005	Hex Nut	M8

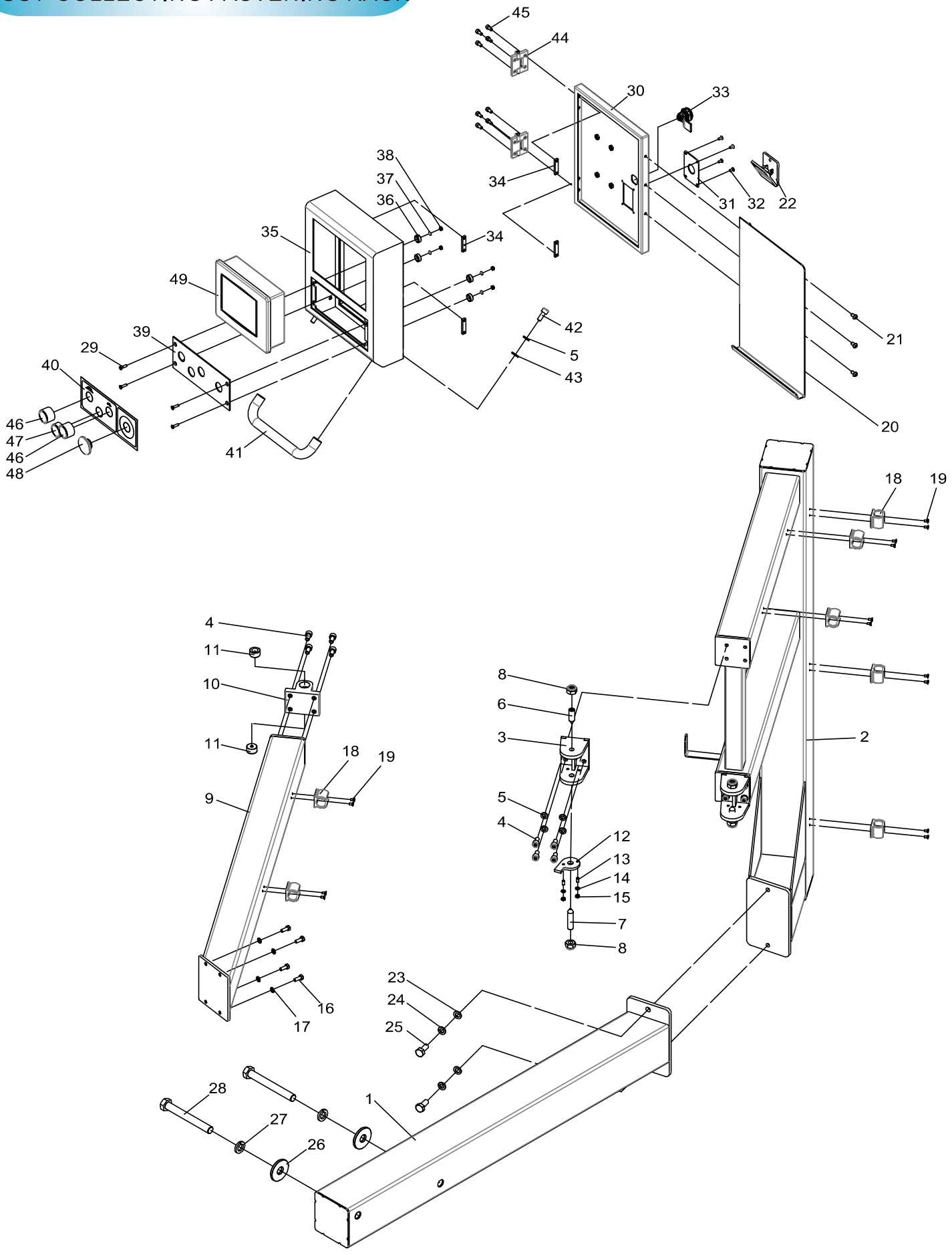
MITER FENCE



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-L001B	45?Fence	
2	ST-L031A	C-Fastening Block	
3	ST-L013	Displacement pipe	
4	ST-L005	Gap ring	
5	ST-L006	Positing ring	
6	ST-L003	Set screw	
7	RH-2040	Washer	
8	ST-L015	Lock collars	
9	402130008	Caps	25-25-2t
10	401072075	Set screw	M10x60
11	402070003	Star-shaped knob	HS50AM10
12	402040025	Adjustable handle	92ZN-M10
13	401071071	Set screw	M10x40
14	401010022	Hex head bolt	M8x35
15	401103001	Lock nut	M8
16	ST-L014	Damper	

7-6 SAFETY GUARD UNIT

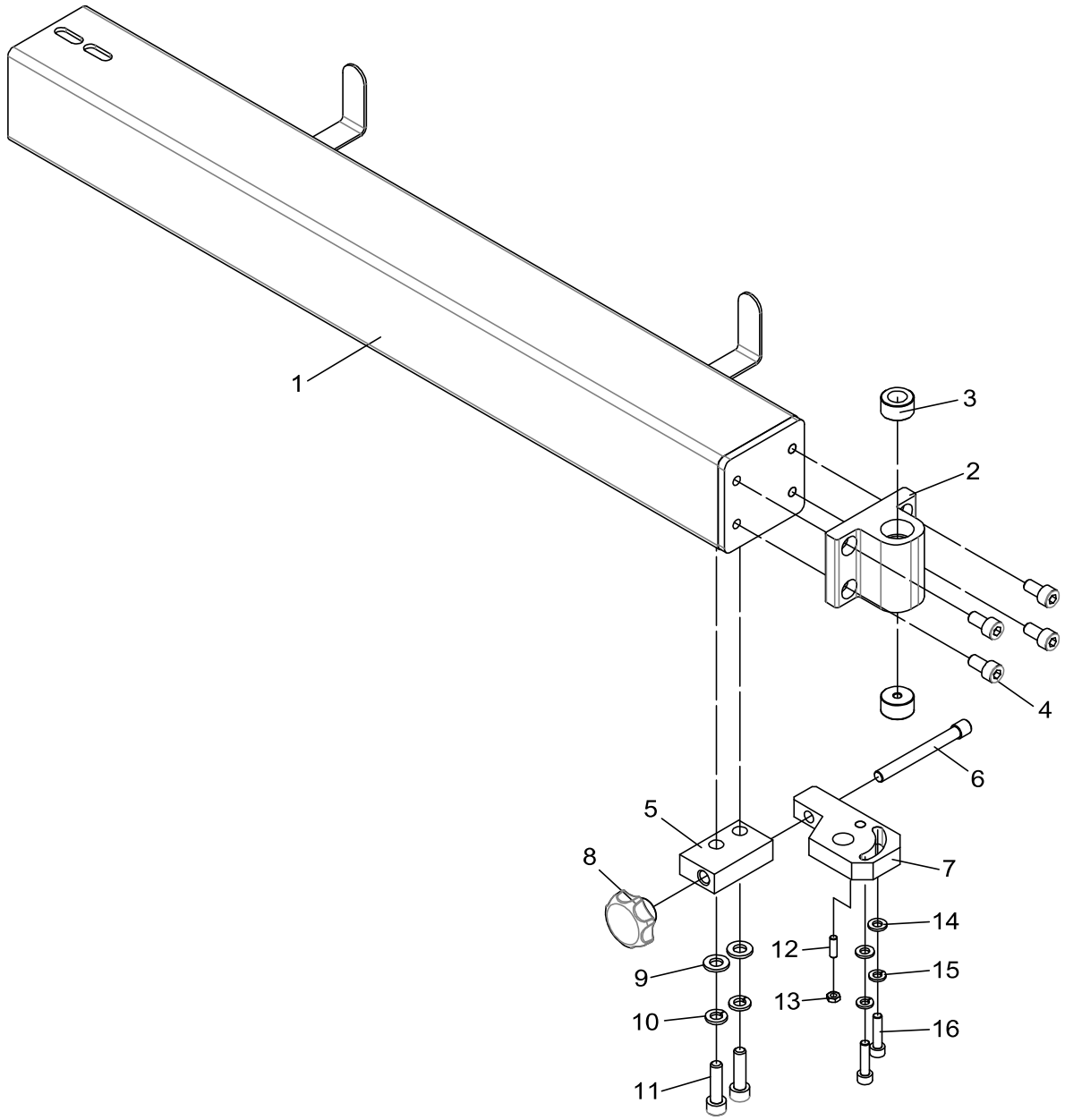
DUST-COLLECTING FASTENING RACK



NO	FIG.NO.	DESCRIP TION	SPEC
1	LST-H004A	Vacuum cleaner	1.3M
	LST-H004B	Vacuum cleaner	1.5M
2	LST-H009A	Vacuum cleaner	
3	ST-D525-0-1	Fasten Base	
4	401022076	Cap screw	M8x16
5	401150003	Lock nut	Ø8
6	ST-I023	Set Screw	
7	ST-D533-0-1	Set Screw	
8	401103003	Lock nut	M12
9	ST-D544-0-1	Connecting elbow	1.3M
	ST-D544-1-1	Connecting elbow	1.5M
10	ST-D027B	Connect Block	
11	ST-D527-0-0	Bush	
12	ST-D537-0-1	Stop block	
13	401071025	Set serew	M5x10
14	401150002	Lock Washer	Ø5
15	401101003	Hex Nut	M5
16	401010008	Hex head bolt	M6x16
17	401150003	Lock Washer	Ø6
18	414021001	C Shape glides	9F22-1
19	401051108	Countersink Head Screw	M4x8
20	ST-D543-0-1	Board clamp	
21	401032029	Round head screw	M6x10
22	402150001	Plastic clip	
23	401140005	Washer	Ø10
24	401150005	Lock washer	Ø10

NO	FIG.NO.	DESCRIP TION	SPEC
25	401010037	Hexagon screw	M10x25
26	LST-H003	Washer	
27	401150008	Lock Washer	Ø16
28	401010075	Hex Head Bolt	M16x130
29	401052112	Counter sunk head cap screw	M4x16
30	ST-A139D	Control box	
31	ST-A140	Joint plate	
32	401032008	Button head serew	M4x8
33	402170002	Lock	A-705-3-20 PCS
34	ST-A114	Fixed piece	
35	ST-A130C	Control box	
36	ST-A141	Washer	
37	401150001	Lock washer	Ø4
38	401101002	Hex nut	M4
39	ST-A138	Control panel	
40	ST-A142	Mask	
41	402020005	U type handle	129-20-200-SR
42	401022078	Cap scre	M8x20
43	401151002	Safety Washer	Ø8
44	402090005	Aluminum Hinges	CL-208
45	401022027	Cap scre	M5x10
46	416010003	Button, ON	
47	416010008	Button, OFF	
48	416010001	Emergency button	
49	415040007	HITECH	PWS6600T-P

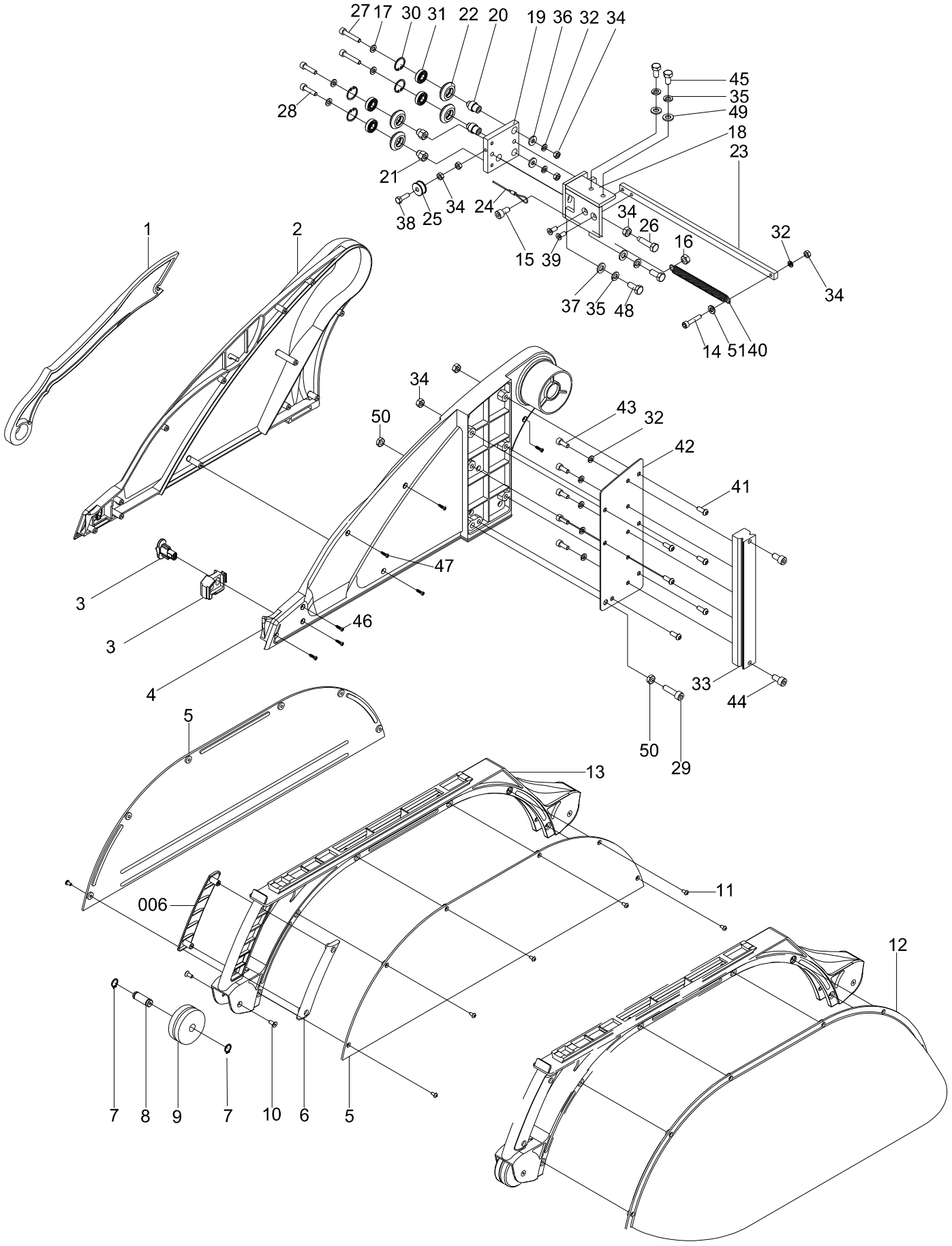
SAFETY GUARD CONNECTING ARM



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST405-609	Rotery Arm	1.3m
	ST405-610	Rotery Arm	1.5m
2	ST-D027B	Connect Block	
3	ST-D527-0-0	Bush	
4	401022076	Cap screw	M8x16
5	ST-D529-0-1	Fixed Base	
6	ST-D531-0-0	Lock Shaft	
7	ST-D526-0-0	Adjust Block	
8	402070002	Knob	6020-40-M8

NO	FIG.NO.	DESCRIP TION	SPEC
9	401140004	Washer	Ø8
10	401150003	Lock nut	Ø8
11	401022080	Cap screw	M8x30
12	401072055	Set screw	M8x25
13	401101005	Hex Head Bolt	M8
14	401140010	Washer	Ø6
15	401150003	Lock Washer	Ø6
16	401022056	Cap screw	M6x25

LUX SAW GUARD

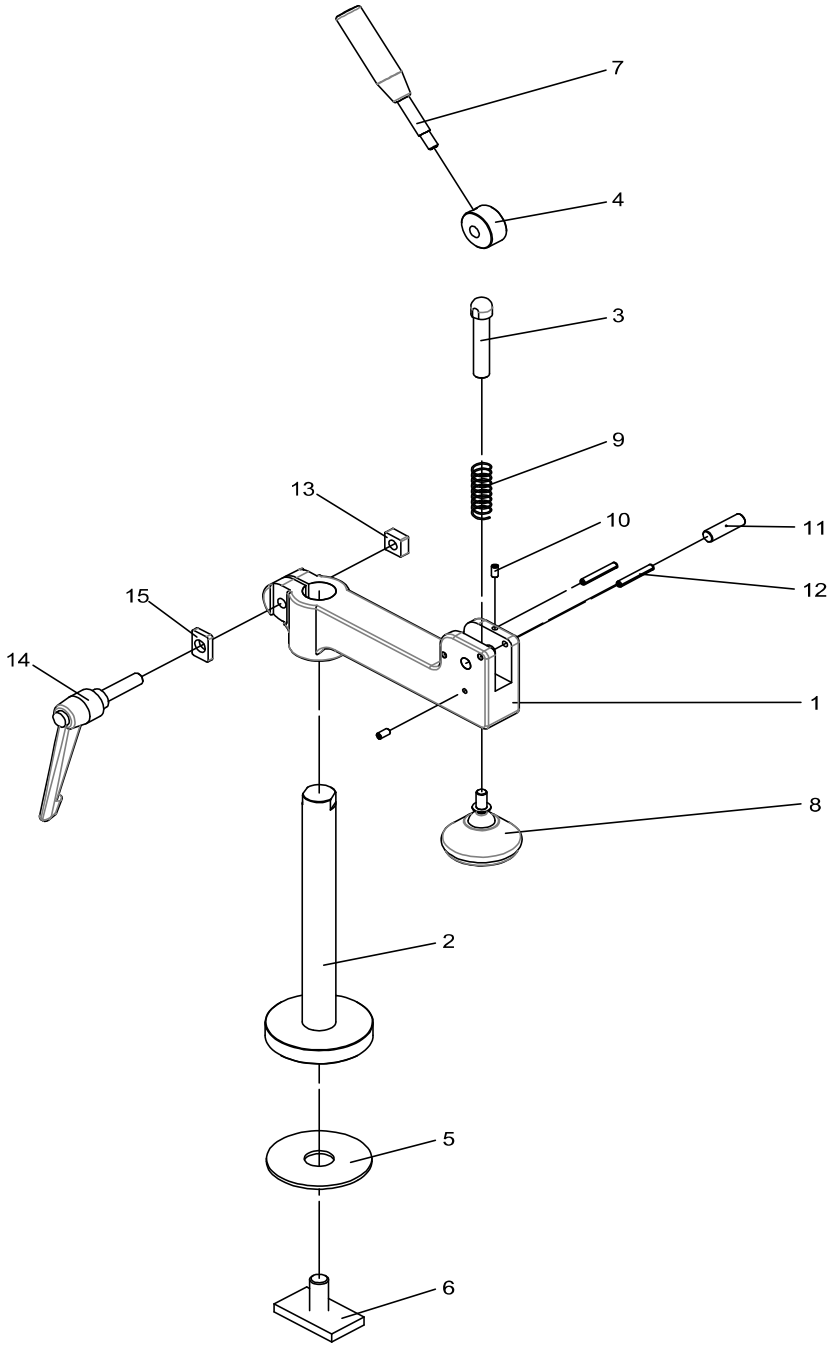


NO.	FIG. NO.	DESCRIP TION	SPEC
1	ST-Q047B	Push Stick	
2	ST-D311A	Left Safety Guard	
3	ST-D314	Open/Lock Button	
4	ST-D311B	Right Safety Guard	
5	ST-D303A	Chip Guard Cover	
6	ST-D313	Grip Cover	
7	401252007	Retain Ring	φ12
8	ST-D032A	Pin	
9	ST-D033A	Slide Wheel	
10	401052118	Countersink Head Screw	M5x12
11	401032008	Button Head Screw	M4x8
12	ST-D304A	Chip Guard Cover	
13	ST-D312	Grip Cover Base	
14	401022057	Cap Screw	M6x30
15	401022051	Cap Screw	M6x12
16	401103005	Lock Nut	M6
17	ST-D522-0-0	Washer	
18	ST-D512-0-1	Fixed Base	
19	ST-D513-0-1	Fixed Block	
20	ST-D514-0-1	Fixed Shaft	
21	ST-D515-0-1	Adjust Shaft	
22	ST-D516-0-1	Slide Wheel	
23	ST-D519-0-1	Spring Fixed Bar	
24	ST-D521-0-0	Wire Rope	
25	ST-D524-0-0	Slide Wheel	
26	ST-D520-0-1	Setscrwe	

NO.	FIG. NO.	DESCRIP TION	SPEC
27	401022058	Cap Screw	M6x35
28	401022056	Cap Screw	M6x25
29	401022082	Cap Screw	M8x40
30	401251017	Retain Ring	φ22
31	403013232	Ball Bearing	6900
32	401150003	Lock Washer	φ6
33	ST-D518-1-0	Slide Wheel	
34	401101004	Hex Nut	M6
35	401150004	Lock Washer	φ8
36	401140003	Washer	φ6x φ16
37	401140016	Washer	φ8x φ23
38	401032035	Button Head Screw	M6x30
39	401052129	Countersink Head Screw	M6x12
40	ST-D038A	Spring	
41	401032033	Button Head Screw	M6x20
42	ST-D315	Join Block	
43	401022015	Cap Screw	M6x12
44	401022076	Cap Screw	M8x16
45	401010019	Hex Head Bolt	M8x20
46	401060001	Phillips Head Screw	1/8"x3/4"L
47	401060003	Phillips Head Screw	1/8"x5/8"L
48	401010018	Hex Head Bolt	M8x16
49	401140016	Washer	φ8x φ23x3t
50	401103005	Hex Nut	M8
51	401140010	Washer	φ6x φ13

7-7 OPTION ACCESSORIES UNIT

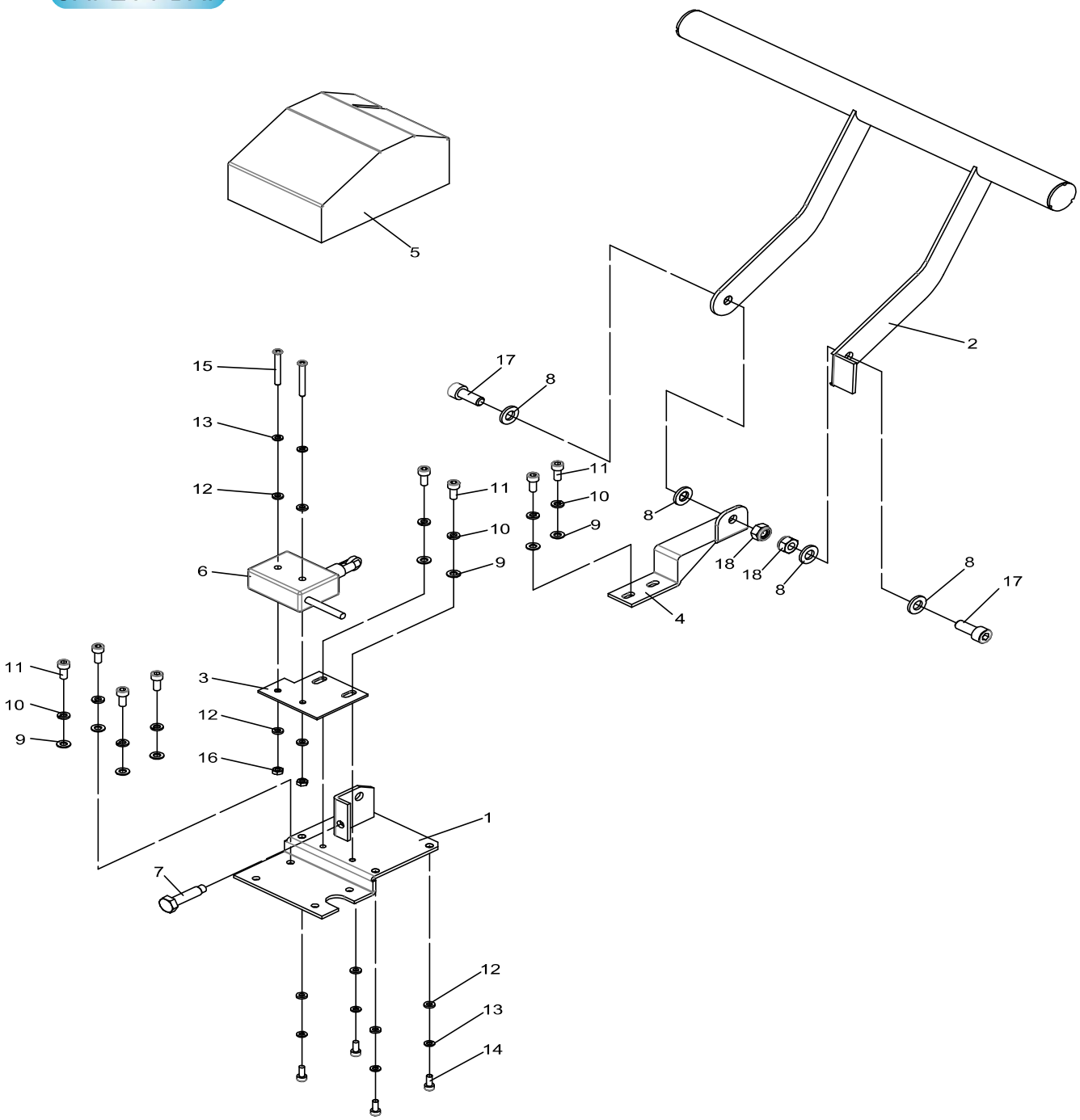
RAPID CLAMP BASE



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-L022A	Adjust Mounting	
2	ST-L020	Fixed Mounting	
3	ST-L025	Carry Cylider	
4	ST-L026	Eccentric Wheel	
5	ST-L021	Washer	
6	ST-L023	T-Block	
7	402010006	Round Knob	7108-M8-137
8	401260008	Adjust Clides	5/16"

NO	FIG.NO.	DESCRIP TION	SPEC
9	ST-L028	Sporing	
10	401071025	Set serew	M5x10
11	ST-L027	Spindle	
12	401200003	Spring Pin	Ø5x35
13	401130002	Square nut	M10
14	402040003	Adjust Handle	4020-80-M10x40
15	ST-L112	Washer	

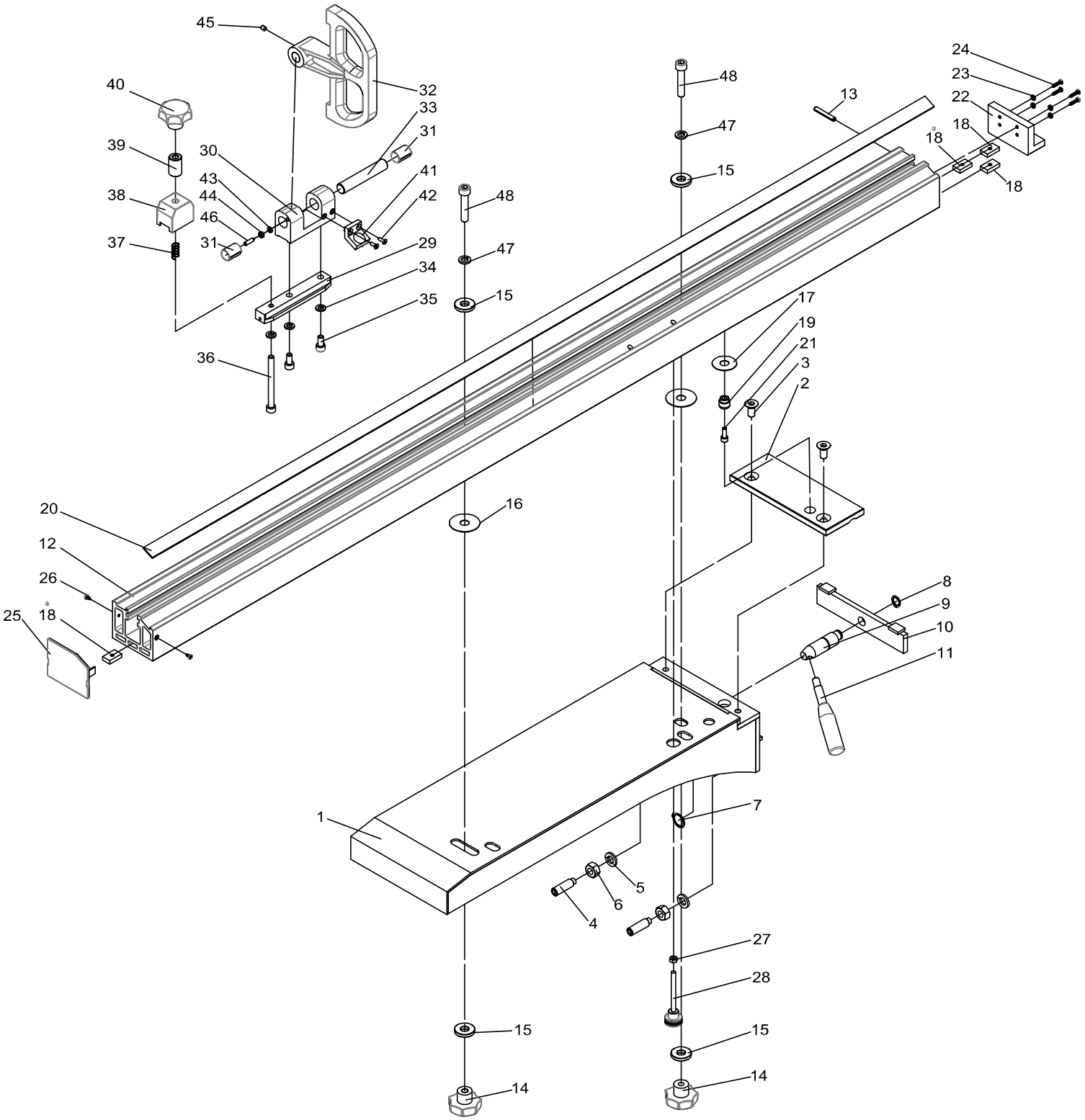
SAFETY BAR



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-T070	Safety rod switch seat	
2	ST-T071B	Safety bar	
3	ST-T072	Micro switch seat	
4	ST-T073	Safety bar support	
5	ST-T074	Shield	
6	416040002	Limit switch	TZ7312
7	ST-D520-0-1	Set Screw	
8	401140004	Washer	Ø8
9	401140002	Washer	Ø5

NO	FIG.NO.	DESCRIP TION	SPEC
10	401150002	Spring washer	Ø5
11	401022028	Cap scre	M5x12
12	401140001	Washer	Ø4
13	401150002	Lock Washer	Ø5
14	401022013	Cap screw	M4x10
15	401042015	Phillips Head Screw	M4x35
16	401101002	Hex nut	M4
17	401022078	Cap scre	M8x20
18	401103001	Lock nut	M8

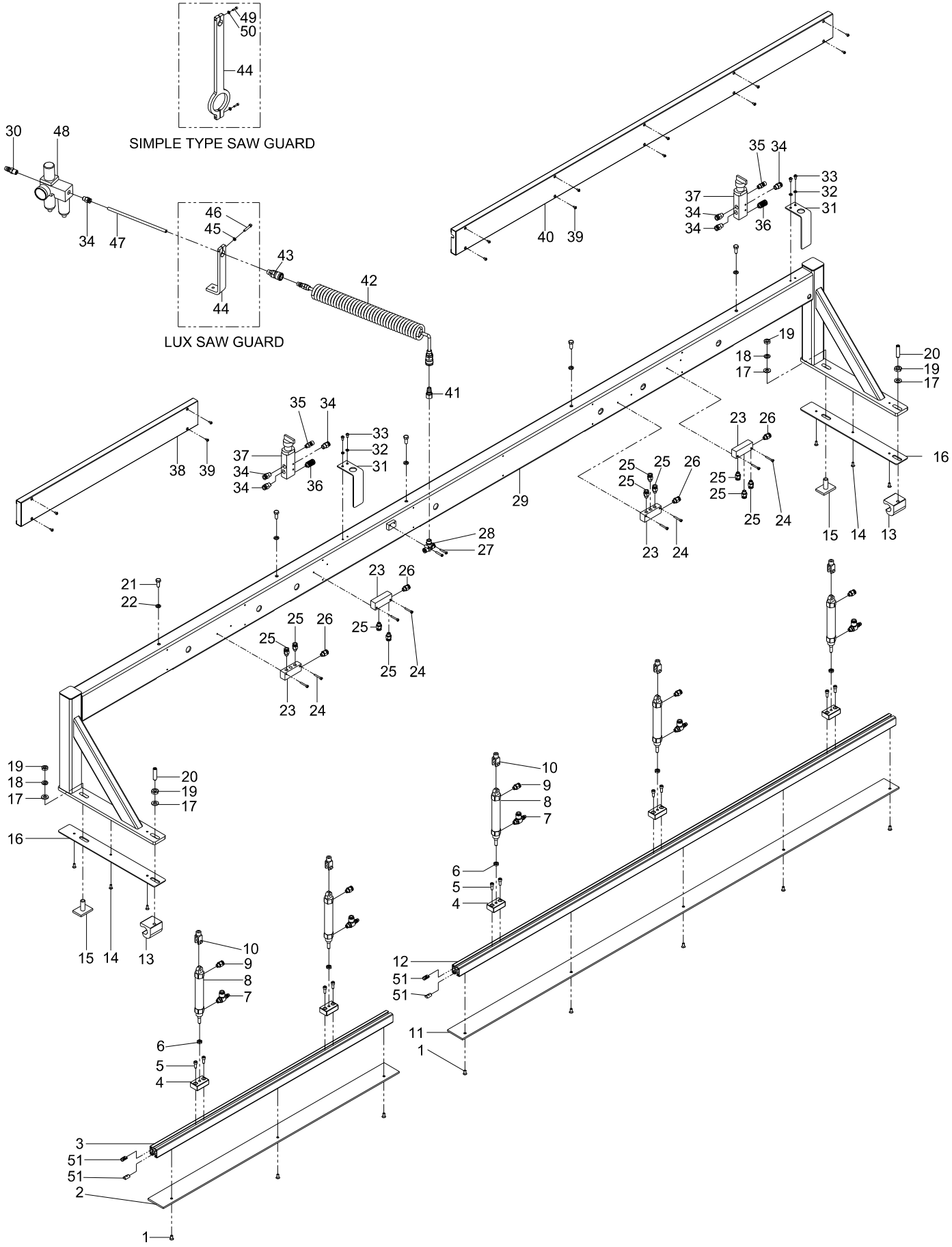
AUXILIARY CROSSCUT CARRIAGE



NO	FIG.NO.	DESCRIP TION	SPEC
1	ST-N088A	Fastening Base	
2	ST-N087A	Fixed Board	
3	401052150	Countersink Head Screw	M6x20
4	ST-N091A	Setscrew	M12x35
5	401150006	Lock washer	Ø12
6	401101007	Hex Nut	M12
7	401252015	Retaining rings for shaft	S20
8	401252009	Retaining rings for shaft	S14
9	ST-N090	Adjust Shaft	
10	ST-N089	Lock Bar	
11	402010010	Handle	7107-M10-137
12	ST-N058A	Fence Scale Base	
13	401200008	Spring Pin	Ø6x40
14	402070006	Star knob	HS50AM1030
15	RH-2040	Washer	Ø30xØ10.2x5t
16	ST-N005	Washer	
17	ST-N092	Washer	
18	ST-N059	Fixing sheet	*UseST-N059 M6ChangeM10Threaded Hole
19	ST-N004	Positioning Pin	
20	ST-N063	Fence Scale	80~1690
21	401022053	Cap scre	M6x16
22	ST-N052	Lengthening scale base	
23	401140001	Washer	Ø4
24	401060001	PLUG	1/8"-3/4"

NO	FIG.NO.	DESCRIP TION	SPEC
25	ST-N060	Left cover plate	
26	401060004	PLUG	1/8"-3/8"
27	401101004	Hex Nut	M6
28	ST-N023	Embossing screw	ST-N023-01+402100003
29	ST-N027	Locking lower slide base	
30	ST-N007	Adjusting block	
31	403090028	Bush	MB1625
32	ST-N008	Positioning plate	
33	ST-N011	Shaft	
34	401150003	Lock nut	Ø8
35	401022076	Cap screw	M8x16
36	401021092	Cap screw	M8x90
37	ST-N022	Spring	
38	ST-N013	Locking slide block	
39	ST-N014	Locking bush	
40	402070002	Star-ahaped knob	HS50AM8
41	ST-N053	Magnifier	
42	401051110	Counter sunk head cap screw	M4x16
43	401150002	Lock Washer	Ø5
44	401101003	Hex Nut	M5
45	401072033	Setscrew	M6X6
46	ST-N091B	Set Screw	M5x16
47	401150005	Lock nut	Ø10
48	401022109	Cap scre	M10x50

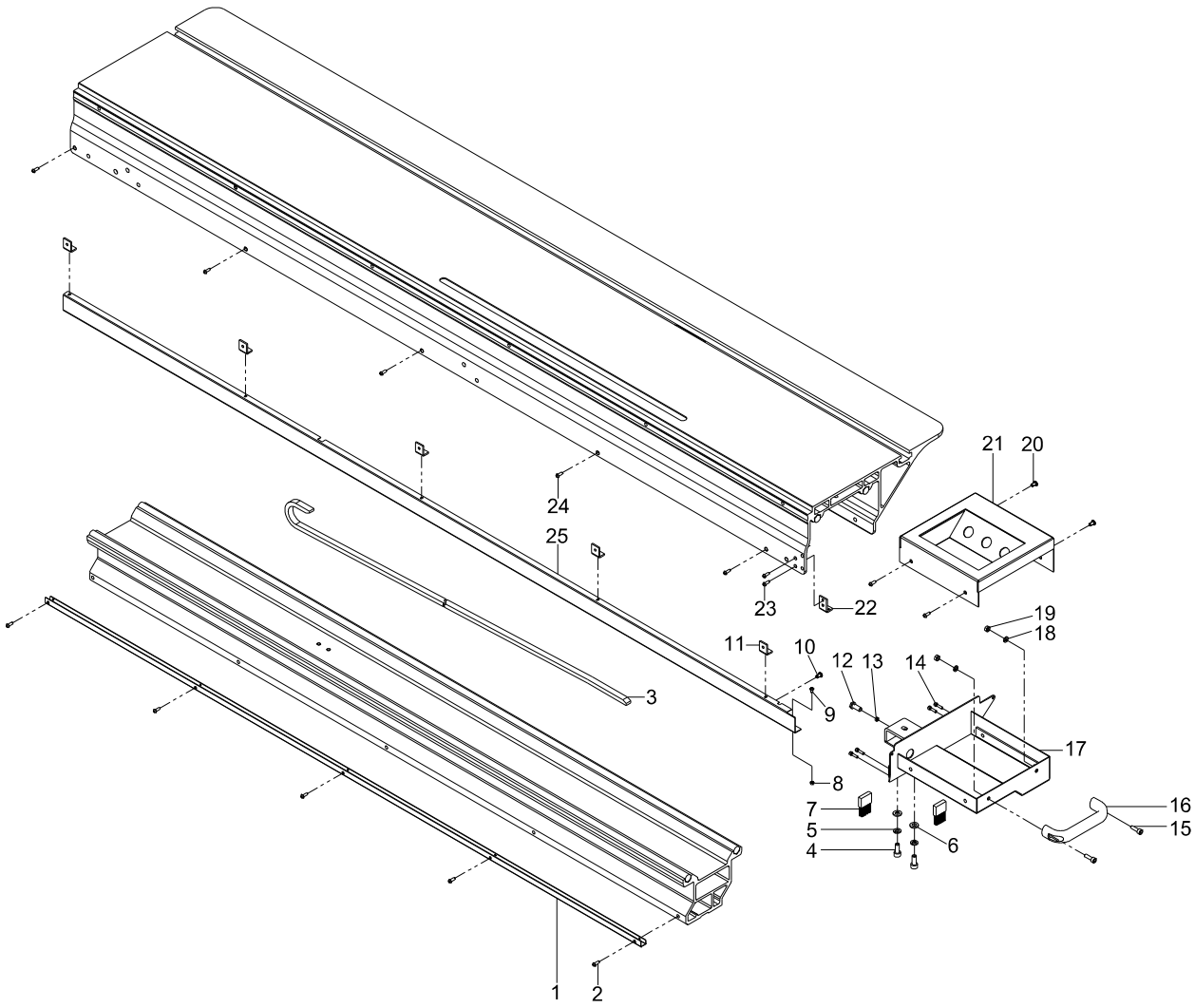
PNEUMATIC CLAMP



NO.	FIG. NO.	DESCRIP TION	SPEC
1	401052129	Countersink Head Screw	M6x12
2	ST-R029	Clamp Element	2.6m
	ST-R006	Clamp Element	3.2m
3	ST-R027	Clamp Bar	2.6m
	ST-R004	Clamp Bar	3.2m
4	ST-R007	Join Block	
5	401022053	Cap Screw	M6x16
6	401101005	Hex Nut	M8
7	410040005	Quick Joint	1/8"-4x6
8	409010001	Cylinder	φ20x80
9	410010017	Quick Joint	1/8"-4x6
10	ST-R008	Y-Shape Connector	
11	ST-R028	Clamp Element	2.6m
	ST-R005	Clamp Element	3.2m
12	ST-R026	Clamp Bar	2.6m
	ST-R003	Clamp Bar	3.2m
13	ST-L031A	Fixed Block	
14	401052118	Countersink Head Screw	M5x12
15	ST-L011	T-Block	
16	ST-R002	Clamp Element	
17	401140017	Washer	φ10
18	401150005	Lock Washer	φ10
19	401101006	Hex Nut	M10
20	401072071	Setscrew	M10x40
21	401010018	Hex Head Bolt	M8x16
22	401150004	Lock Washer	φ8
23	ST-R014B	Fork Lump	
24	401042002	Pillips Head Screw	M4x30
25	410010017	Quick Joint	1/8"-4x6
26	410010009	Quick Joint	PC8-01

NO.	FIG. NO.	DESCRIP TION	SPEC
27	401042002	Pillips Head Screw	M4x30
28	410010013	Therr Joint	1/4" φ8
29	ST-R001C	Clamp Base	2.6m
	ST-R001	Clamp Base	3.2m
30	410010014	Quick Joint	1/4"
31	ST-R009	Fixed Rack	
32	401150002	Lock Washer	φ5
33	401032016	Button Head Screw	M5x8
34	410010010	Quick Joint	PC8-02
35	409080009	Throttle Silencer	1/8"
36	409080008	Plastic Silencer	1/8"
37	409030001	Control Valve	5/2
38	ST-R038	Cover	2.6m
	ST-R011	Cover	3.2m
39	401032008	Button Head Screw	M4x8
40	ST-R039	Cover	2.6m
	ST-R012	Cover	3.2m
41	410010007	Quick Joint	1/4"
42	410050002	Tube	5x8
43	410010006	Quick Joint	5x8-
44	ST-R013	Fixed Rack	LUX
	ST-R013A	Fixed Rack	SIMPLE
45	401150002	Lock Washer	φ5
46	401022034	Cap Screw	M5x30
47		Tube	5x8
48	409040001	F.R.L Connection	
49	401022056	Cap Screw	M6x25
50	401150003	Lock Washer	φ6
51	401130001	Special Nut	TSN 306

ON/OFF SWITCH ON THE END OF SLIDING TABLE



NO.	FIG. NO.	DESCRIPTION	SPEC
1	ST-K550B	Fixed base(3.2m)	
	ST-K550D	Fixed base(2.6m)	
2	401032030	Button head screw	M6x12
3	414010009	Cablechain(3.2m)	3165L
	414010011	Cablechain(2.6m)	2670L
4	401021078	Cap Screw	M8x20
5	401150004	Lock washer	φ8
6	401140004	Washer	φ8
7	ST-K031	Bristle brush	
8	401101002	Hex.Nut	M6
9	401032008	Button head screw	M4x8
10	401032029	Button head screw	M6x10
11	ST-K559	Fixed base	
12	402160002	Stop screw	FC-086312

NO.	FIG. NO.	DESCRIPTION	SPEC
13	401101005	Hex.Nut	M8
14	401021016	Cap Screw	M4x16
15	401021055	Cap Screw	M6x20
16	402020001	Handle	
17	ST-K552A	Box	
18	401150003	Lock washer	φ6
19	401101002	Hex.Nut	M6
20	401032029	Button head screw	M6x10
21	ST-K558	Cover	
22	ST-K551	Fixed base	
23	401032029	Button head screw	M6x10
24	401032029	Button head screw	M6x10
25	ST-K554B	Cover(3.2m)	
	ST-K554C	Cover(2.6m)	