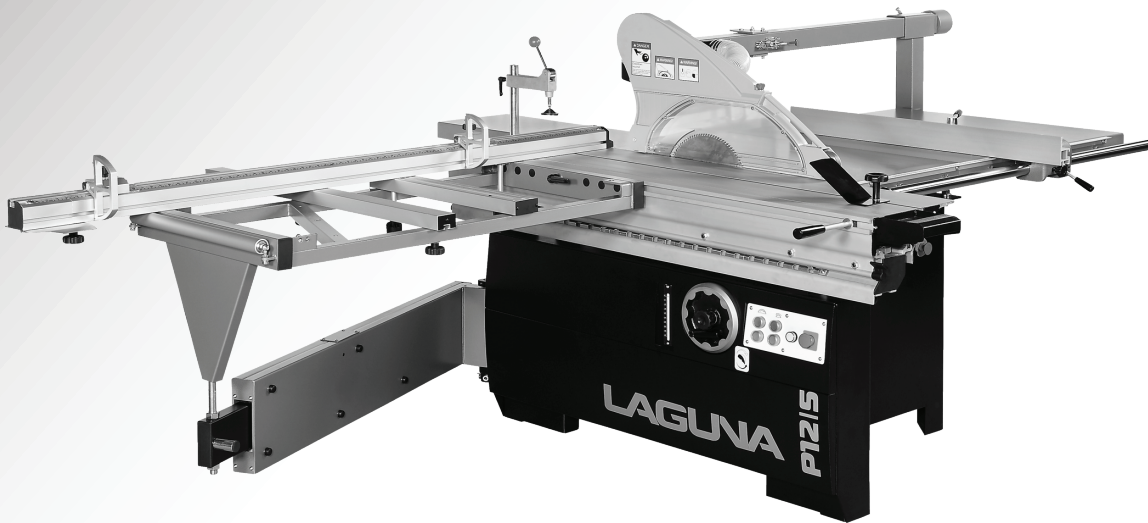


# Panelsaw 1215 Manual



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Model Numbers: MPSP12-5-0135

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Wiring diagram

Parts list

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# 1. GENERAL INFORMATION & SAFETY RULES

Laguna Tools, Inc. specializes in supplying a full series of panel saws: from 1600, 2300, 2500, and 3200 to 3800mm. The design of this machine is unique, and includes an enlarged outrigger and carriage, and a direct dust collection outlet. We sincerely hope that you enjoy operating this machine. If you have any suggestions as to how we can improve this product, please don't hesitate to contact us through a regional Laguna Tools representative.

Panel saws are professional woodworking machines, designed to rip solid wood, chipboard, fiberboard, plywood and other similar materials. It is very important to take note of the rigidity of the materials you will be working with; please do not use the saw to cut metals, stone, or other materials that are not suitable for cutting by panel saw.

HSS (High Speed Steel) saw blades and milling tools should not be used. Only saw blades made in accordance with EN847-1: 1997 should be used with this machine.

Generally speaking, this machine should be installed under the following conditions:

- 1) Supply voltage: 0.9 - 1.1 is normal supply voltage
- 2) Source frequency : 0.99 - 1.01 is normal frequency
- 3) Ambient temperature: 5°C – 40°C.
- 4) Altitude: the altitude should be up to 1000m above sea level
- 5) Relative humidity: the humidity should not exceed 50% at 40°C.
- 6) Atmosphere: free of excess dust, acid fumes, corrosive gases and salt.
- 7) Avoid exposure to direct sunlight or heat rays, as they can change the environmental temp.
- 8) Avoid exposure to abnormal vibration.
- 8) The electrical equipment can withstand the effects of transportation and a storage temperature of -25°C to 55°C. It can then withstand temperatures of +70°C for short periods of time (Period of time cannot exceed 24 hours)

This machine was designed for certain applications only. We strongly recommend that this machine **NOT** be modified and/or used for any applications, other than the ones for which it was designed.

If you have any questions regarding its application, **DO NOT** use the machine until you have received detailed instruction from our representative in your region.

## Safety Rules

**For your own safety, please read the instruction manual before operating this machine.**

### 1) Read the instruction manual before operating the machine.

Anyone who operates the machine must first be properly trained. It is very important that anyone who operates the machine first reads and understands all of the safety measures outlined in this manual.

They must also obey and execute the regulations stated in this manual, and learn the machine's applications and limitations, as well as the specific hazards particular to the machine.

**2) Ground all machines.**

It is important to make sure that the "PE" terminal is connected before operating the machine.

**3) Keep guards in place and the work area clean.**

Keep guards in place and in working order. Keep the work area clean, as cluttered working environments make accidents more likely.

**4) Do not use the machine in dangerous environments.**

Do not use the machines in damp or wet locations, or ever expose them to rain. Please provide suitable lighting around the machine to reduce the risk of injury.

**5) Keep children and visitors away.**

All children and visitors should be kept at a safe distance away from the work area.

**6) Store idle tools (saw blades).**

When not in use, please remove all saw blades, and store them in a dry place, out of reach of children.

**7) Wear proper apparel.**

Do not wear any loose clothing, neckties, gloves, rings, bracelets, or any other jewelry that can get caught in moving parts. If you have long hair, it is important to wear a protective hair covering.

**Please wear gloves to install/replace saw blades, and wear safety goggles/ear protection during operation.**

**8) Stay alert.**

Be mindful of what you are doing. Do not operate the machine if you are tired.

**9) Do not force the machines.**

The machines will work both better and safer if they are operated at the cutting speeds they are designed for.

10) **SHUT OFF** the power, remove the work pieces, and turn off the power before leaving the machine.

Please turn off the power before carrying out any inspections, maintenance, adjustments, or cleaning.

11) **No smoking!!** Please do not smoke while operating the machine.

**12) Have your machine repaired by a qualified person.**

Repairs should only be carried out by specially trained, qualified people, using original spare parts; failure to do this may result in injury or death..

**13) Check any damaged parts.**

Before using the machine further, the guard or other damaged part should first be carefully checked to determine if it will operate properly and perform its intended function. Check the alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

**14) Waste Disposal**

Dispose of all waste with extreme care, and in accordance with local regulations.

**15) Fire extinguisher:**

The workshop of the user must be equipped with a fire extinguisher, or other device specified by local safety regulations.

**16) Stand in a proper position for operation.**

Please stand in front of machine for operation.

**17) Use recommended auxiliary equipment.**

Please consult the “drawings” section of the operation manual for recommended auxiliary equipment and accessories.

The use of improper accessories may result in personal injury.

If auxiliary equipment is removed, the original guards or safety devices must be replaced.

Laguna Tools is responsible for a connection of the machine to auxiliary equipment only if the auxiliary equipment has been designed or specifically approved by Laguna Tools for used with this machine.

**18) Reduce the risk of unintentional starting.**

Make sure the switches on the control panel are in the OFF position before operating.

**19) Never leave the machine running unattended.** Turn the main power off before leaving the machine unattended. Do not leave the machine until all moving parts come to a complete stop.

**20) Make sure the machine is disconnected from the power supply:**

Make sure the machine is disconnected from the power supply before beginning any maintenance, service, adjustments, or repairs.

**21) What to do in an emergency:**

This machine is equipped with two emergency buttons. One is a self-latching push button on the control panel. The other emergency button is positioned on the front side of the machine, near in-feed work area. The emergency button is red with a yellow background. After the emergency stop, unlock the emergency stop button, and follow normal start up procedure and perform the suitable operation to eliminate the hazard. Please see the subsequent pages for a diagram of the locations of the emergency stop buttons.

22) Never open the protective cover or the service door while the machine is running.

23) If the machine malfunctions while running, shut it down and call servicemen for help as quickly as possible.

24) Wear ear protection (plugs or muffs) during extended periods of operation.

25) Remove all service items or tools before turning the machine on. Be sure to check that all service tools and wrenches have been removed, and that all the nuts and bolts adjusted during servicing are tightened.

26) After switching off the saw motor, allow the saw blade to stop on its own. Never attempt to stop the blade with any body parts, or any other objects.

27) Never cut a wood panel if it is cracked, damaged, or too small in size.

28) The max. allowed rotation speed of the saw blade used on the machine must never be exceeded.

- 29) Do not load more than one workpiece at a time onto the machine.
- 30) When wood panels are cut, harmful dust is produced. The machine must be equipped with a proper dust-collecting system.
- 31) Use only properly sharpened and serviced saw blades. Never exceed the maximum RPM marked on the saw blade. The optimum cutting speed must be selected by the user.
- 32) Report any problems with the machine, guards, or saw blades as soon as they are discovered.
- 33) Implement safe procedures for cleaning and maintenance. It is important to remove chips and dust regularly to avoid the risk of fire.
- 34) The saw blades should be sharpened and maintained in compliance with instructions supplied by the saw blade manufacturers.
- 35) Ensure that any spacers and spindle rings are used in strict accordance with the recommendations of the manufacturer.
- 36) Never remove any cut-off parts of the work piece from the cutting area while the machine is running.
- 37) Ensure that the guards and other safety devices necessary for the machine's operation are in position, in good working order, and properly placed, well-maintained, and secured.
- 38) Safe working practices.
  - a) Use of push block and push stick: a push stick should be used in cases when the operator's body parts could get close to the area of the saw blade. Push blocks should be between 300mm and 400mm long, 80mm to 100mm wide and 15mm to 20mm tall. Push blocks should be utilized when cutting small work pieces and in circumstances where it is necessary to push the work piece against the fence.
  - b) Selection of the saw blade and riving knife: the operator should only select a saw blade that has a diameter and thickness suitable for the machine.
  - c) Selection of riving knife slot: the riving knife guiding slot should be no more than 0.5mm wider than the riving knife guiding elements.
  - d) Mounting of the saw blade: If the spindle diameter is less than the diameter of the saw blade bore, a proper bushing should be used. The bushing must be provided by the machine's manufacturer. The usage of loose rings or bushes may result in serious injury or death.
  - e) Lighting: it is important to provide adequate lighting around the machine.
- 39) If you need to guide the work piece along the rip fence, always use the push stick. Please make sure to keep clear of the rotating saw blade. In case the push stick is damaged, it must be replaced with a new one.
- 40) Do not operate this machine while tired or under the influence of drugs, alcohol or any medications.
- 41) **The dust generated by certain wood products can be hazardous to your health.** Always operate the machinery in well-ventilated areas. All machines must be equipped with a proper dust-collecting system.
- 42) Please contact our authorized representative in your area for any other questions.

## Specification Sheet

Model	P30 (two motors)
Cast iron fixed table dimension	548x896mm
Sliding table dimension	1,600x378mm 2,200x395mm
Main saw blade	305mm (Max. 355mm)
Main saw bore	30mm
Max. cutting height with blade at 90°	80mm
Max. cutting height with blade at 45°	55mm
Main motor power(3ph)	5HP(3Kw)
Main blade speed	4,000rpm
Scoring saw blade	120mm
Scoring saw blade bore	20mm
Scoring blade motor power(optional)	3/4HP(0.56Kw)
Scoring blade speed	8,000rpm
Cutting width	835 (1300mm ,optional)
Blade tilting adjustment	Manual(0~45°)
Main saw height adjustment	Manual
Dust collection system	120mm/64mm
Dust collection system (overhead guard)	120mm/100mm
N.W./G.W./MEAS. (Machine)	317/376KGS 1,400*1,100*1,060mm
N.W./G.W./MEAS. (Sliding table)	63/70GS 2,320x420*210mm
Ctn. Q'ty.	14/32 sets

Due to need of continuous improvement, specifications are subjected to change without prior notice.



**Main Feature**



1. Flip Stopper-Large stopper for accurate measurements
2. Crosscut Fence-90° and 45° quick position design for a precise crosscutting operation
3. Hold Down : Strong design with fine adjustment and floating rubber pad.
4. Saw Blade Guard : Fully adjustable blade maintains maximum protection around the saw blades.
5. Cast Iron Rip Fence : Micro adjustment for smooth and precise cutting
6. Sliding table : Double roller carriage with steel bar guidance for smoothly cutting, precise sliding guides the workpiece through the blade.
7. Control Panel : Simple push button controls for operation
8. Blade Angle Adjusting Handwheel : Manual adjusts the angle of saw blade
9. Blade Height Adjusting Handwheel : Manual adjusts the height of saw blade
10. Cross table : Stronger table and stable to support large size panel during crosscutting operation.
11. Riving Knife : It is prevent kick back caused by the knife closing behind the blade.

**Assembly and set up**

**(1) Control panel**

1. Main Switch : Power on the panel saw.
2. Emergency stop button : Disconnects power to all motors in the machine body.
3. Main blade on button : Starts the main saw blade.
4. Main blade off button : Stops the main saw blade.]
5. Scoring blade on button : Starts the scoring saw blade.
6. Scoring blade off button : Stops the scoring saw blade.



Fig. 1

**(2) Rip fence**

- A. One single lock down lever : Simple and precise to lock the fence assembly into fence rail
- B. Micro adjust knob Precisely adjustment.
- C. Forward and backward slide lock handle : To firm the high/low profile alum. Fence on its forward/backward slide track
- D. Micro-adjust lock knob : Secures the fence after it has been adjusted with micro-adjustment knob.
- E. Rip fence scale : Allows precise measurement of rip cutting operations.

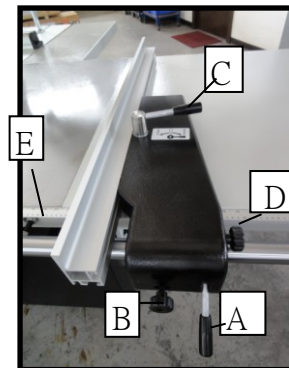


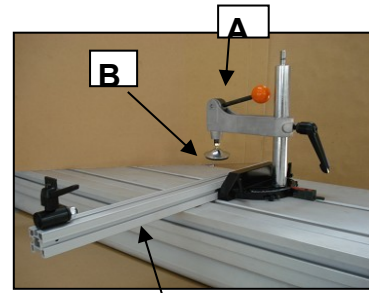
Fig. 2

**(3) Hold Down**

- A. Fine adjustment handle
- B. Floating rubber to fix the wood firmly

**(4) Riving knife and saw blade**

1. Riving knife : Maintains kerfs opening during cutting operations. The Purposes crucial to preventing kick back caused by the kerfs closing behind the blade.
2. Main saw blade : The maximum is 305mm. (it is as option)
3. Scoring saw blade : It is rotates opposite the main saw blade, the blade cores the workspace before the actual cutting operation is performed preventing tear-out in laminate materials. The scoring is adjustable forward and backward, upper and down.



**Optional**



**Fig. 4**

**(5) Moving & fixing the base unit**

Place a level on the saw table and adjusting foot stands, so the saw table is level from left to right and from front to back. Lock the foot studs in position by tightening their jam bolts against the machine body. (Fig.5)

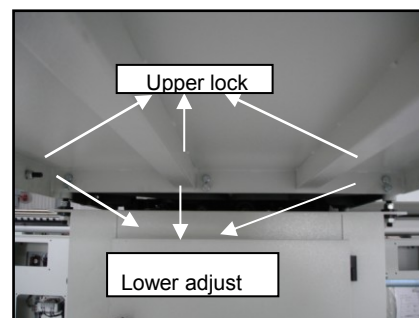
**\*Remind firstly to remove the wood ad supporting of motor before starting the table saw.**



**(6) Extension Tables content**

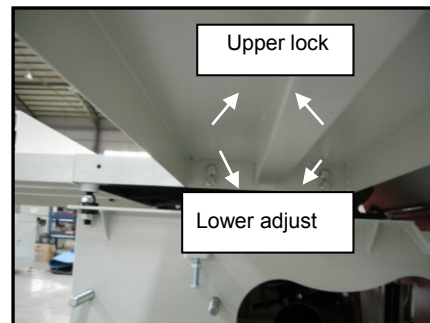
**How to install the extension tables**

1. Thread the set screws into the suitable holes from the instead of both extension tables.
2. Before the tables are leveled, please don't completely tighten the bolts in follow steps.
3. Attach the large extension table with three cap screws, lock washers and flat washers (Fig. 6)



**Fig. 6**

4. Attach the small extension table with cap screws, washer and flat washers (Fig. 7)
5. Check the surfaces 0 degree the table with a straightedge (Fig. 8)
6. Assemble the support bracket into the extension table (we have rest holes for fixing), then adjust the leveling screw of foot studs in order to make left ext. Table is parallel with saw table.



**Fig. 9**

### **(7) Scale adjustment**

1. Tight the cap screws to the extension table and adjust to be with the top of the table.



### **(8) Rip fence**

- Rip fence content :
- Rip fence x 1
  - Round rail for rip fence x 1
  - Rip fence body x 1
  - Stud m12-1.75 x 115 x 4
  - Hex Nut M12-1.75 x 12
  - Flat washer 12mm x 8
  - Lock washer 12mm x 4
  - Lock washer 8mm x 1
  - Cap screw M8-1.25 x 16 x 1
  - End washer 8mm x 1
  - Adjustable ring & set screw x 1
  - Lock handle M10-1.5 x 12 x 2
  - Knob M10-1.5 x 70 x 1

### How to adjust the rip fence

1. Thread 4pcs M12-1.75 x 115 studs into round rail.
2. Thread an M12-1.75 hex nut onto each stud and tighten the nuts against the round rail
3. Thread an M12-1.75 hex nut and a flat washer half way onto each studs
4. Insert the studs into the table (Fig. 12) Tighten with an M12-1.75 hex nut, lock washer and a flat washer on each stud.
5. Slide the rip fence body onto the rail, then place the adjustable ring on the sliding table end of the rail and secure the ring with the set screw (Fig. 13)
6. Thread the lock handles (Fig. 14) into the rip fence body and loosely install the fine adjustment knob.
7. Place the end washer on the end of the rip fence rail and secure it with the M8-1.25 cap screw and lock washer.
8. Slide the alum. Rip fence onto the clamping plate (Fig. 14) and lock it with the handle on the top of the rip fence body.
9. Adjust the nuts on the outside of the table until the edge of the rip fence is parallel with the sliding table (Fig. 14), aligning the fence with the edge of the sliding table.
10. Check the height of the rip fence rail by sliding the rip fence along the rail and comparing the gap between the fence body and the table.
11. Adjust the height of the rip fence rail, then tighten all of the nuts against the table showed (Fig. 15)
12. Check if the bottom of the rip fence rests on the surface of the table. If the rip fence does not rest on the table, then the fence is correctly adjusted, otherwise, loose the set screw (Fig. 16) and rotate the hex bolt to raise the roller, tighten the set screw to lock the ride height.

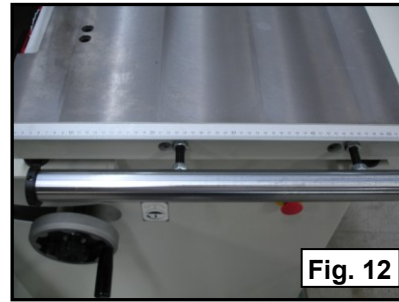


Fig. 12



Fig. 13

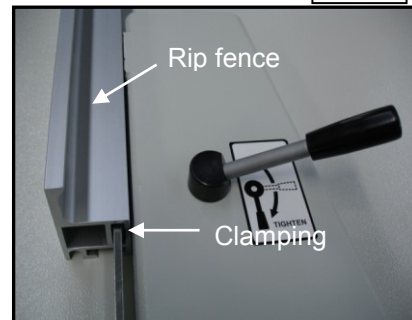


Fig. 14

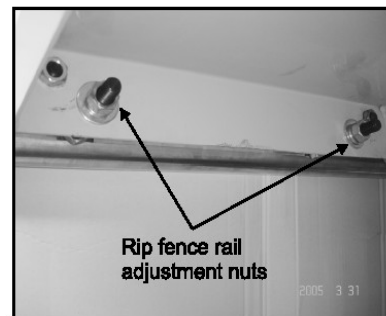


Fig. 15

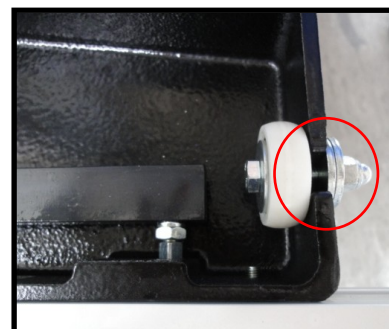


Fig. 16

### (9) Cross table

Crosscut content :

Crosscut table x 1

Crosscut table brace x 1

T-nut M8-1.25 x 2

T-nut M12-1.75 x 1

Flat washer 12mm x 1

Adjustment handle M12-1.75 x 55 x 1

Knob M8-1.25 x 25 x 2

Flat washer 8mm x 2

1. Thread the M12-1.75 x 55 adjustable handle with a 12mm flat washer through the crosscut table and into a M12-1.75 T-nut. (Fig. 17)
2. place the extension table on the pivot pin of the swing arm and slide the T-nut into the T-slot in the sliding table.
3. Slide two M8-1.25 T-nuts into the crosscut table brace.
4. Align the T-nuts in the crosscut table supporter with the holes in the crosscut table and thread the M8-1.25 x 25 knobs, with 8mm flat washers, into the T-nuts (Fig. 20)

### (10) Crosscut fence

Crosscut fence content :

Crosscut fence x 1

Crosscut fence support plate x 1

Center stud M8-1.25 x 10 x 1

Fiber washer 8mm x 1

T-nut M8-1.25 x 2

Knob M8-1.25 x 25 x 1

Knob M8-1.25 x 1

T-bolt M8-1.25 x 60 x 1

Flat washer 8mm x 1

Lock washer 8mm x 2

Button head screw M8-1.25 x 16 x 2

1. Thread the center stud and the fiber washer into the remaining M8-1.25 T-nut.
2. Sliding the center stud, and M8-1.125 x 60 T-bolt and screw M8-1.25 x 25 knob into the crosscut fence (Fig. 21)
3. Slide the center stud to the end with the plastic cap and tighten it in place.

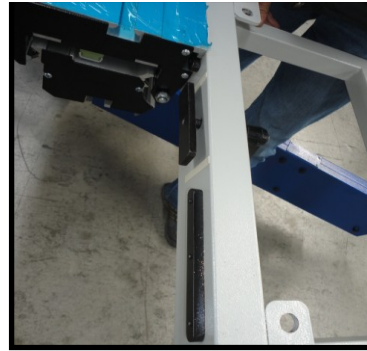


Fig. 17



Fig. 18

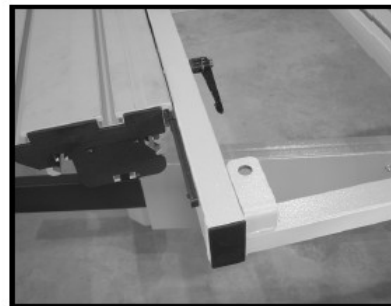


Fig. 19

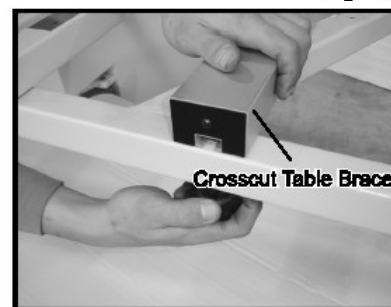


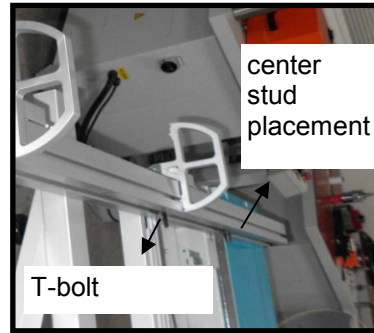
Fig. 20



Fig. 21



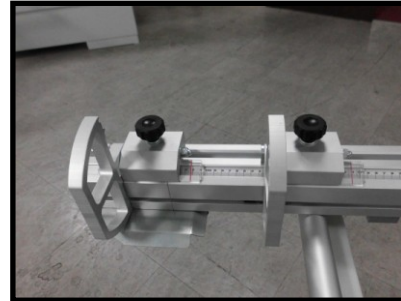
4. Insert the center stud and the T-bolt in the places indicated (Fig. 23)
5. Secure the crosscut fence with the M8-1.25 knob with and 8mm flat washer threaded onto the T-bolt.
6. Unlock the crosscut fence extension and slide the flip stops into the fence (Fig. 24)
7. Slide two M8-1.25 T-nuts into the crosscut fence extension and attach the crosscut fence support plate to the fence extension with two M8-1.25 button head screws and lock washers.



**Fig. 23**

### (11) Sliding Table

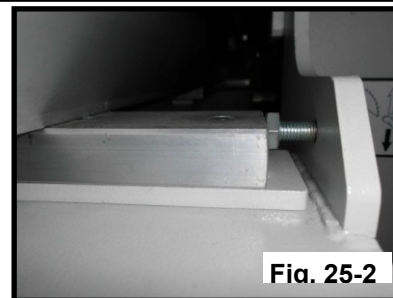
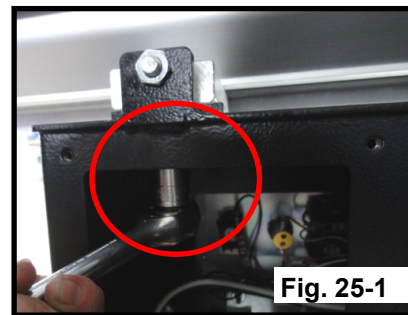
1. The accessories bag contains hex head bolts for fixing the sliding table. Reset the sliding table complete with rail on the machine frame. To lock the rail with the machine frame, screw down into the threaded hole. Push the sliding table up against the stop screws prior to be tighten(fig. 25-1/25-2)



**Fig. 24**

Edge shoe x 1  
Hold down x 1

1. Slide the M12-1.75 T-nut into the sliding table and thread in the M12-1.75 x 12 push handle with a washer. (Fig. 28)
2. Thread the remaining M12-1.75 T-nut into the edge shoe and slide it into the table. (Fig. 29)
3. Slide the hold down onto the table when needed and lock it in place.



**Fig. 28**



**Fig. 29**

## (12) Main Blade

Main blade content

Blade 12" (as option) x 1

Flat belt 15 x 1,045 mm x 1

Riving knife x 1

This saw is designed with 12" main saw blade, before you change blade sizes, the riving knife must be adjusted to match the size of blade you install.

1. Open the motor compartment and remove the foam shipping block and the red shipping brackets from the motors.
2. Place the flat belt on the scoring blade arbor (Fig. 31), lift the scoring motor and slide the flat belt over the scoring motor pulley. (Option)
3. Move the blade tilt to 0° and raise the main blade as far as it will go.
4. Slide the table all the way forward to access the blade arbor and pull open the blade guard.
5. Use the arbor wrench to remove the arbor nut and arbor flange, the arbor nut has left hand threads and loosens by turning clockwise.

\* Fix the saw blade by T Tool. (Fig. 31)



Fig. 31

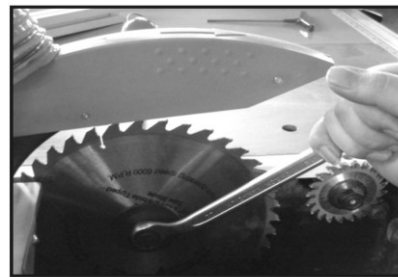
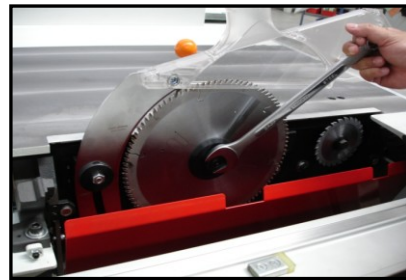


Fig. 32

6. Slide the blade over the arbor with the teeth facing the front of the saw (Fig. 32)
7. Re-install the arbor flange and the arbor nut and tighten them against the blade (Fig. 32)
8. Loosen the riving knife center bolt, slide the riving knife over the bolt (Fig. 33) and slightly tighten.
9. Position the riving knife about 3mm or 1/8" away from the nearest carbide tooth on the main blade. For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife. (Fig. 35)

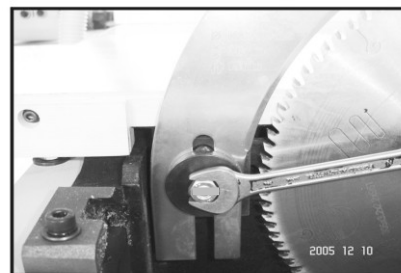


Fig. 33

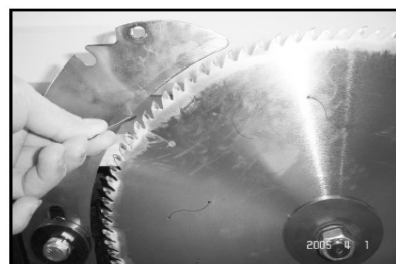


Fig. 35

### (13) Scoring Blade

#### Aligning Scoring Blade Set

The scoring blade must be aligned with the main blade to ensure satisfactory cutting results.

1. Move the blade tilt to 0° (blade 90° to table) and raise the main blade all the way up.
2. Use T tool to adjust scoring blade (Fig. 36- 1/ -2)
3. Move the rip fence against the main blade (or scoring blade) (Fig. 37)
4. Use the adjustment controls to move the scoring blade so that the rip fence can touch both the scoring blade and the main blade.
5. Lower the scoring blade to the correct height (2mm or 5/64"), perform a test cut, then make any final adjustment.

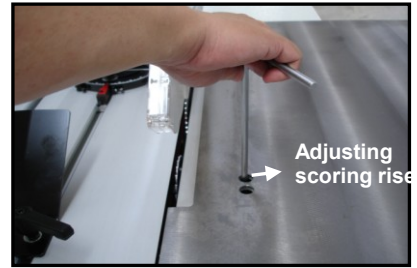
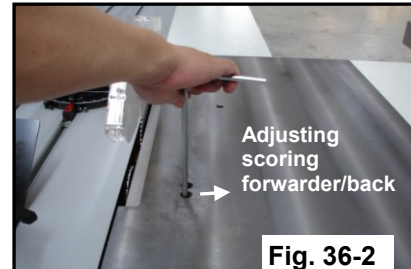


Fig. 36-1



### (14) Fence Scale Alignment

Before operation, the 0" mark on the rip fence scale must be aligned with the right side of the blade to ensure that the rip fence measurements will be accurate.

1. Move the blade tilt to 0° (blade 90° to table), and raise the main blade all the way up.
2. Move the rip fence against the main blade (Fig. 37)
3. Loosen the cap screws securing the fence scale.
4. Slide the fence scale to line up the first mark on the scale with the left edge of the rip fence and tighten the cap screw.
5. Set the rip fence at 1/8" , slide the adjustable right against the rip fence body, and lock the ring in place. This will prevent the fence from hitting the blade.

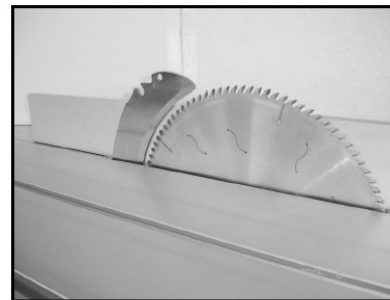


Fig. 37

### (15) Dust Collection

There are dust ports are designed on this machine, please connect the dust collection system before operations.

#### Dust Collection Content

- Blade guard / Dust hold x 1
- Flat washer 8mm x 1
- Button head screw M8-1.25 x 40 x 1
- Dust collection system x 1
- 4" Dust hose x 1
- 4" Hose clamp x 2
- 2-1/2" Dust hose x 1
- 2-1/2" Hose clamp x 2



Fig.38



#### Vertical

1. Secure a 4" dust hose to the dust port located under the saw table. (Fig. 38)
2. Run the 4" hose to your dust collection system. Slide the blade guard/dust hood over the riving knife and attach it with a M8-1.25 x 40 button head cap screw and a flat washer (Fig. 39)
3. Secure a 2-1/2" dust hose to the dust port on the top of the blade guard (Fig. 39)
4. Run the hose over and connect it to the dust collection system.
5. Run a ground wire along the dust hose and attach the wire to the machine to protect against static electricity.



Fig. 39

#### (16) Power Cord

1. Open the terminal box (Fig. 40)
2. Feed the power cord through the strain relief on the bottom of the control panel and connect the cord to the terminals. If finished, close the terminal box.
3. Shut off the main power at the power source circuit breaker and install the cord to the disconnect switch.



Fig. 40

#### (17) Test Run

Before operation, it must be testing this machine to make sure all the controls are working properly.

#### **WARNING**

Before starting the saw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine.

Failure to follow this warning could result in serious personal injury or even death !

1. Connect the machine to the power source.
2. To check the machine light is turning on.
3. Press the main blade button, if the main blade is rotating in a counter-clockwise, then press the scoring blade button, if the main blade is rotating in a clockwise direction, disconnect the saw from power and exchange wires in the terminal box.

#### **Operation**

**You must follow these instructions EVERY time you use your saw.**

1. Stand to the left of the blade line-of-cut when performing a cutting operation.
2. Turn off the saw and allow the blade to come to a complete stop before removing the cut-off piece.
3. Make sure the riving knife is always aligned with the main blade before cutting.
4. Always position the blade guard to the correct height above the workpiece.
5. Carefully plan each cutting operation to avoid injuries.
6. When you release the sliding table lock, make sure that the knob is positioned so that it will not lock the table during a cut.

## (1) Changing Main Blade

The main blade size for this machine 12" , it is as option.  
Any time you change the blade size, adjust the riving knife to 3mm away from the blade you install.

1. Disconnect the power source.
2. Move the blade tilt to 0° (blade 90° to blade) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife. (Fig. 42)
4. Pull the blade guard away from the blades to expose the mounting assembly.
5. To remove the main blade, use the arbor wrench to remove the arbor nut and arbor flange. (the arbor nut has left hand threads and loosens by turning close wise.)

6. Install the new blade, re-install the arbor flange and the arbor nut and tighten them against the blade. (Fig. 43)

### **WARNING**

Wear gloves to protect your hands when installing or removing blades.

7. Move the orange blade guard back into its original position, next to the blades and center the sliding table.

## (2) Riving Knife Adjustment

Whenever the blade is changed, then riving knife must be adjusted to 3mm away from the blade you install.

1. Disconnect the saw from power source
2. move the blade tilt to 0° (blade 90° to table) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife.
4. Pull the blade guard away from the riving knife to expose the mounting assembly.
5. Loose the riving knife center bolt, slide the riving knife away from the blade and slightly tighten. (Fig. 44)
6. Position the riving knife about 3mm or 1/8" away from the nearest carbide tooth on the main blade. (Fig. 45)
7. Tighten the center bolt to secure the riving knife in position.
8. Move the blade guard back to its original position, and move the sliding table to center.

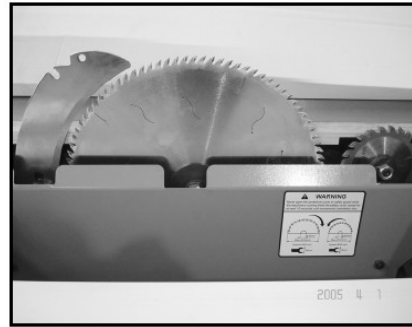


Fig.42

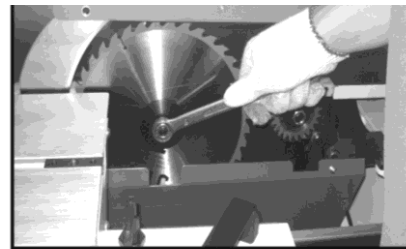


Fig.43



Fig. 44



Fig. 45



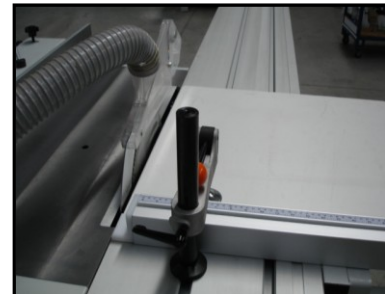
Fig.45-1

### (3) Changing Scoring Blade

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table), and raise the scoring blade all the way up.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blade and riving knife.
4. To fix the scoring by offered U Tool and using the arbor wrench to remove the nut. (The arbor nut has right hand threads and loosens by turning counterclockwise. (Fig. 45-1)
5. Measure the main blade, and use the shims to stack the scoring blade set so the thickness matches the thickness of the main blade.
6. Install the blade set, re-install the arbor flange and the arbor nut, and tighten them against the blade set.
7. Move the orange blade guard back into its original position, next to the blades, and center the sliding table.
8. Align the scoring blade set to the main blade.

### (4) Rip Cutting.

The panel saw has the capability of rip cutting full size panel panels, the sliding table removes the burden of sliding a large and heavy panel over a stationary table surface. (Fig. 46)



The saw also with the capability of rip cutting smaller boards which is using the machine as a traditional table saw. Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.

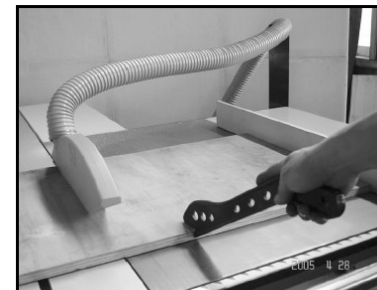


Fig. 47

### Rip Cutting With The Sliding Table :

1. Install the crosscut fence in the center stud hole. (Fig. 48)  
Note : Drop the crosscut fence into the center stud hole and rotate it to the 90° stop.  
Check to make sure the fence is at 90° and adjust it. (Fig. 48)



Fig. 48

2. Slide the protection block against the blade teeth to calibrate the scale, then tighten the lock knob, and make sure the scale will not be accurate if the protection block is cut.
3. Set a lip stop to the desired width-of-cut.
4. Position the blade guard to the correct height for your workpiece.
5. Load the workpiece onto the table saw.
6. Take all the necessary safety precautions, then perform the cutting operation.

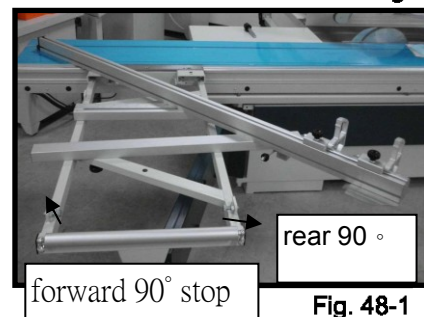


Fig. 48-1

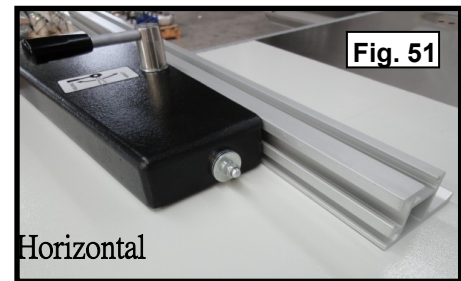
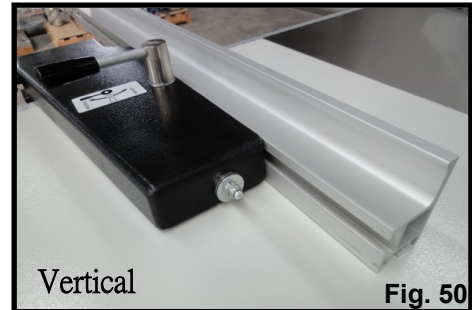
### Trading Table Saw Cutting

1. Slide the crosscut table out of the way.
2. Lock the sliding table into a stationary position. (Fig. 49)



Fig. 49

3. Place the fence in the vertical position (Fig. 50) for larger workpiece, or in the horizontal position (Fig. 51) for angled cuts and for small workpiece.



4. Slide the leading end of the rip fence so it is even with the center of the main saw blade (Fig. 52)  
Note : This technique allows the finished cut-off piece to "fall" away from the blade when the cutting operation is complete, reducing the possibility of kickback.

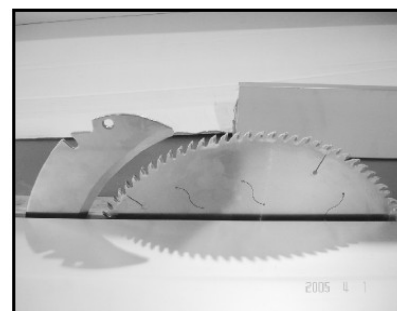


Fig. 52

5. Lift the lock lever and position the rip fence to approximately the desired width-of-cut.
6. Tighten down the micro-adjust lock knob (Fig. 53) and turn the micro-adjust lock to zero in on the desired width-of-cut.

7. Push down the lock lever, then perform the cutting operation.

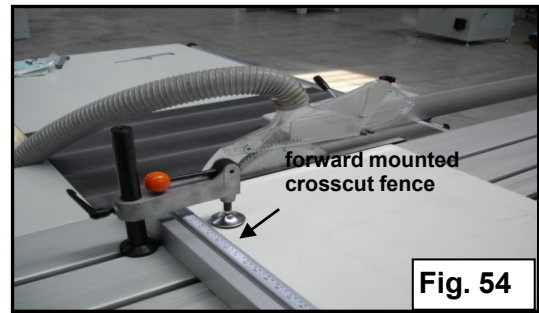


Fig. 53



## (5) Crosscutting

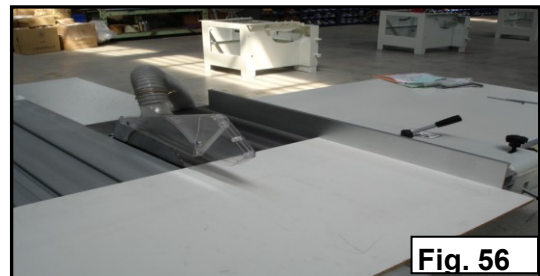
This saw can crosscut full size panels with the fence in the forward or rear position, although it is easier to load full size panels with the crosscut fence mounted in the forward position. (Fig. 54)



Mounting the crosscut fence in the rear position gives greater stability for crosscutting smaller panels. (Fig. 55)



Lastly, this machine has capability of crosscutting workpiece while using the rip fence as a cut-off gauge. (Fig. 56)



### Crosscutting full size panels

1. Install the crosscut fence in the forward mounting points (Fig. 57) and lock it in place. ]  
Note : Drop the crosscut fence in the center stud hole and rotate it to the 90° stop. Check to make sure the fence is at 90° and adjust it.
2. Set either flip stop to the desired width-of-cut, if the workpiece is more than 74", extend the crosscut fence slide.
3. Load the workpiece onto the table saw.
4. Once all the necessary safety precautions have been taken, perform the cutting operation.

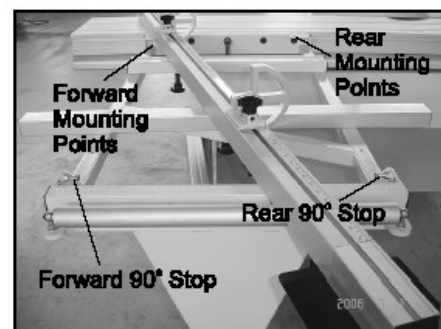


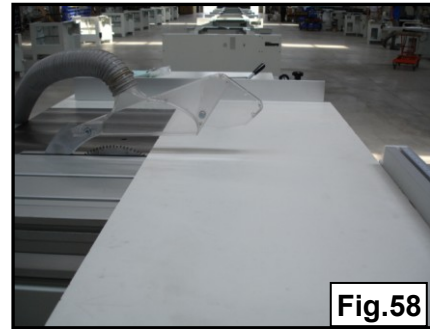
Fig. 57

### Crosscutting small panels

1. Install the crosscut fence in the rear mounting point and lock it in place.  
Note : Drop the crosscut fence in the center stud hole and rotate it until the spring pin snaps into the T-slot. Check to make sure the fence is at 90° and adjust it.
2. Set wither flip stop to the desired width-of-cut, if the workpiece is more that 74", you must extend the crosscut fence slide.
3. Load the workpiece onto the table saw.
4. Once all the necessary safety precautions have been taken, perform the cutting operation.

### Crosscutting using rip fence as a cut-off gauge

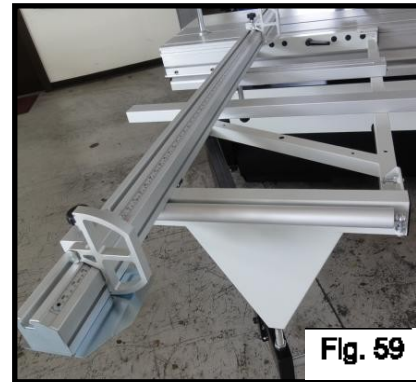
1. Install the crosscut fence in the rear mounting points (Fig. 58) and lock it in place.
2. Position the rip fence for the desired width.
3. Load the workpiece onto the table saw.
4. Slide the leading end of the rip fence behind the back edge of the blade. (Fig. 58)
5. Take all the necessary safety precautions, then perform the cutting operation.



### (6) Miter Cutting

The miter fence allows miter cuts from 0° through 135°. The table mounted miter scale has a resolution of 1°.

1. Slide the crosscut table to the front edge of the sliding table and lock it in place.
2. Place the crosscut fence center stud in the center stud hole of the crosscut table. The fence can be installed for 90° to 135° cuts (Fig. 59), or 0° to 90° cut.
3. Rotate the fence to the desired angle and use lock knob to lock the fence in place.
4. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.
5. Load the workpiece onto the table saw.
6. Once all the necessary safety precautions have been taken, perform the cutting operation.



### (7) Lubrication

Lubrication the areas indicated below every 6-12 months, depending on frequency of use.

1. Blade angling trunnion.
2. Sliding table ways.
3. Scoring blade worm gear
4. Blade height linkage.
5. Blade height bearing
6. Blade tilt worm gear
7. Blade height slide



### (8) Replace Belts

To change V-belt for the main motor

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table ) and raise the main blade and scoring blade set up.
3. Open the motor cabinet door.
4. Loosen the hex head bolt A and B, and tight the hex head bolt B. (Fig. 64)
5. Remove the V-belt and replace them with new belts. Then lessen the hex head bolt B. (Pivot the motor down)
6. Tighten the hex head bolt A and B until the belts deflect between a 1/4" and a 1/2" when pressed firmly in the center of each V-belt.
7. Close and secure the motor cabinet door.

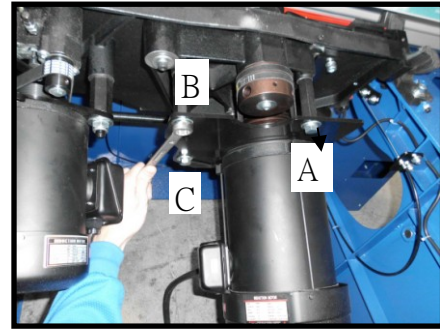


Fig. 64

### To change flat belt for the scoring motor (Option)

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade and scoring blade set up.
3. Open the motor cabinet door.
4. Push the scoring blade motor and remove the flat belt.
5. Place the flat belt on the scoring blade arbor, lift the scoring motor and slide the lat flat over the scoring motor pulley. (Fig. 65)
6. Close and secure the motor cabinet door.

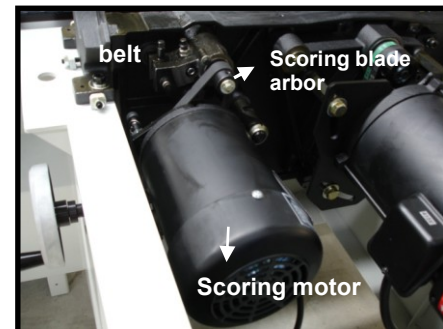


Fig. 65

### (9) Blade Tilt

1. Disconnect the saw from the power source.
2. Move the blade tilt to 90° according to the gauge, and raise the main blade.
3. Place a machinist's square between the teeth on the blade and on the table surface and inspect for gaps between the blade and the square.
4. If a gap exists at either the top or bottom of the square, loosen the 90 tilt stop bolt (Fig. 65-1)
5. Turn the hand wheel until the blade and square are flush from top to bottom.
6. Snug the adjustment screw against the underside of the table and tighten the lock nut.
7. Recheck the blade with the square to ensure the screw has not been over-tightened.
8. Adjust the blade angle until you hit the 45" positive stop. Check the bevel with an adjustable square set to 45°.
9. If aviators exist, adjust the 45° tilt stop bolt until the blade and square match. (Fig. 66)
10. Tighten the lock nut and recheck the bevel by adjusting the blade back to 90° then back to 45°.

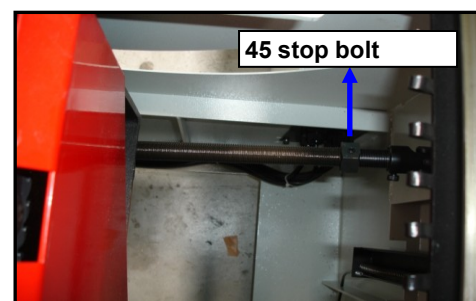
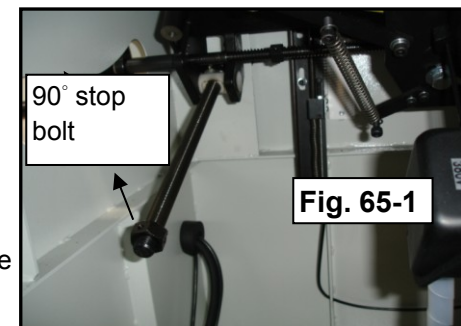


Fig. 66

### (10) Sliding Table Parallel Adjustment

The table is calibrated at the factory and please adjust if it changes during the transportation.

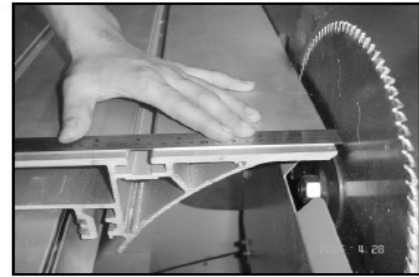


Fig. 67

To adjust the sliding table parallel with the main blade :

1. Disconnect the saw from the power source.
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade and scoring blade set up.
3. Mark the center of the blade with a felt tip pen, this will allow you to take your measurements from the exact same place on the blade.
4. move the sliding table all the way to one end, and using a precision ruler, measure the gap between the edge of the table and you mark on the blade. (Fig. 67)
5. Move the other end of the sliding table in front of the blade and measure the gap.
6. Open the cover plates under each end of table and loosen the table mounting bolts. (Fig. 68)
7. Move the end of the sliding table that needs to be adjusted in front of the blade.
8. Using the ruler, watch the gap measurement and have your assistant slowly make the adjustment to the parallelism adjustment bolts (Fig. 69) until the gap size is equal to the other side. (Fig. 69-1)
9. Repeat steps 7-8 until the gap between your mark on the blade and the edge of the sliding table is even at both ends.
10. Tighten the jam nuts on the parallel adjustment bolts to secure them in place.
11. Tighten the table mounting bolts and replace the access plates.

Cover

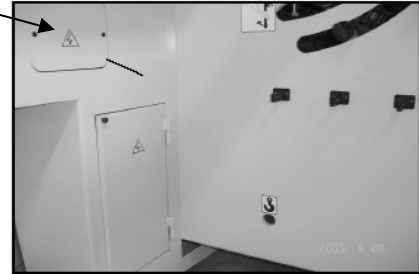


Fig. 68

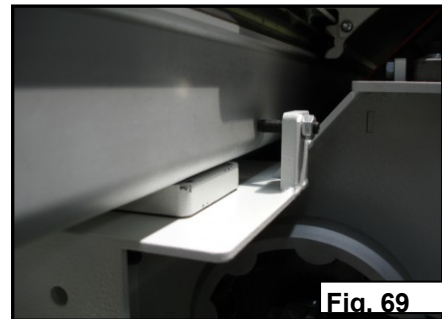


Fig. 69

### (11) Squaring Crosscut Fence to Blade

1. Make sure the blade is parallel with the sliding table.
  2. Prepare the scrap test piece by cutting it to 32" x 32" and number all four sides of the test piece.
  3. Using the crosscut fence, cut 1/2" off of each side of the test piece.
  4. Measure the test piece diagonally from corner to corner, at all four corners are same size. **Fig. 69-1**
- Note : If both measurements are not within 1/16" then the crosscut fence needs to be adjusted.
5. Loosen the set screw and rotate the cairn to square the crosscut fence.
  6. Tighten the set screw and repeat 3-6.

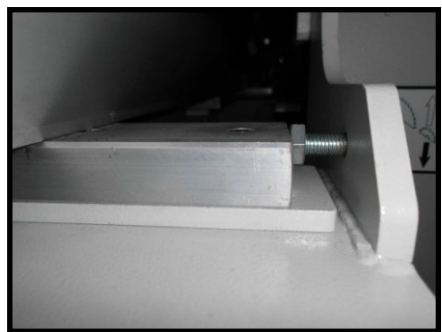


Fig. 69-1



## Troubleshooting

### WARNING

Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury or death.

### Saw will not start

1. Check the switch is being depressed fully.
2. Check the electrical power cord is plugged into the power outlet.
3. Check the electrical supply is on (reset)
4. With the power disconnected from the machine, check that the wiring in the plug is correct. Check that the rubber insulation is stripped enough and is not causing a bad connection. Check that all screws are tight.
5. With the machine power disconnected from the machine, check that the wiring in the plug is correct. Check that the rubber insulation is stripped enough and is not causing a bad connection. Check that all screws are tight.
6. Check that you have correct power.
7. Check that the ground wire is wired correctly.

### Motor will no start

1. Emergency stop button is depressed.
2. Start capacitor is at fault.
3. Motor is at fault.
4. With the power disconnected from the machine, try to turn the blade by hand.  
If the blade will not turn, check the reason for jamming, typical reason is wood jamming the blade.

If any trouble you cannot solve it from above solutions, please call your senior engineer or contact the agent which you ordered this machine.

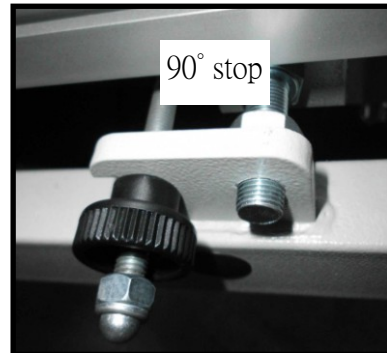
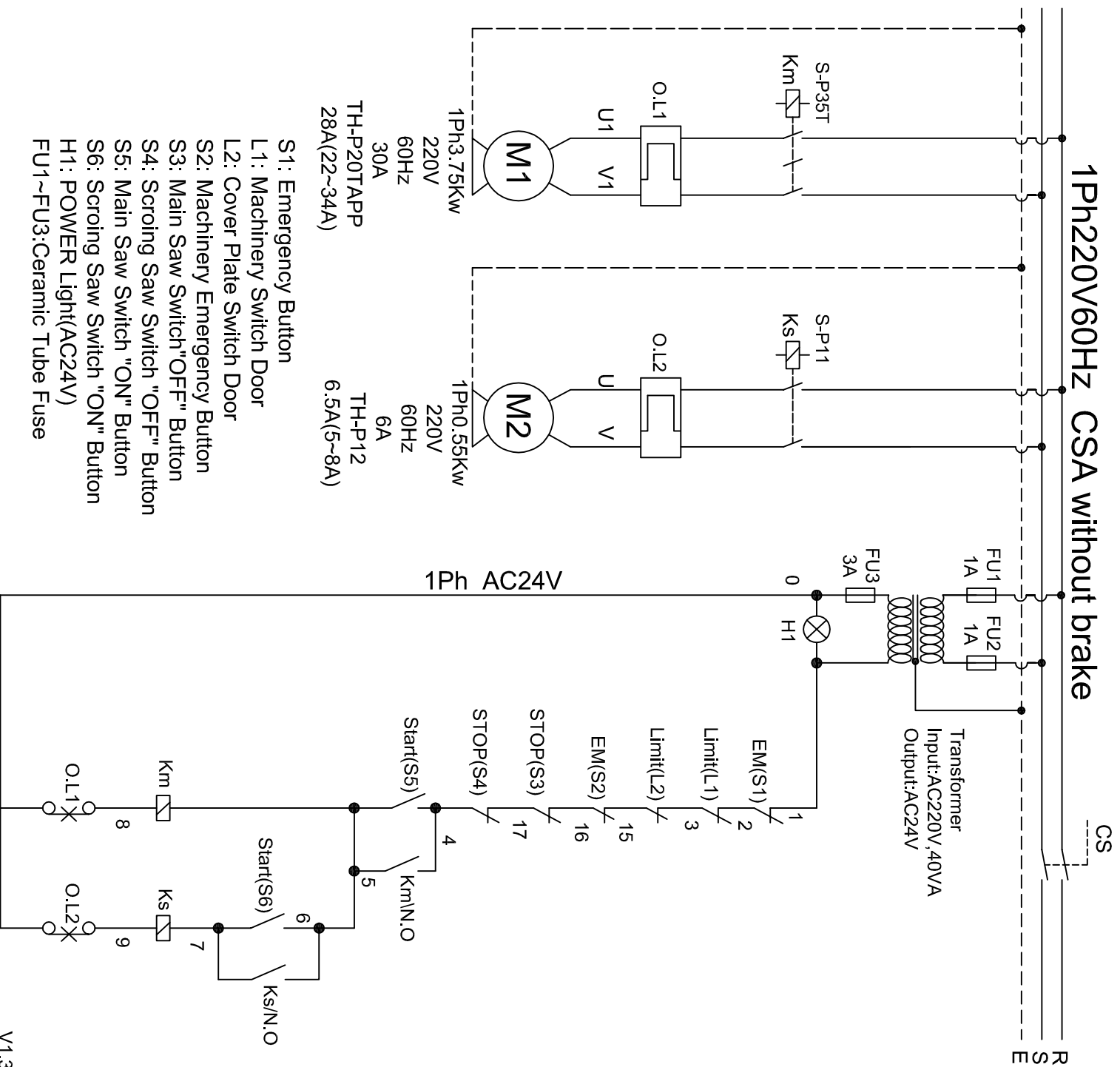
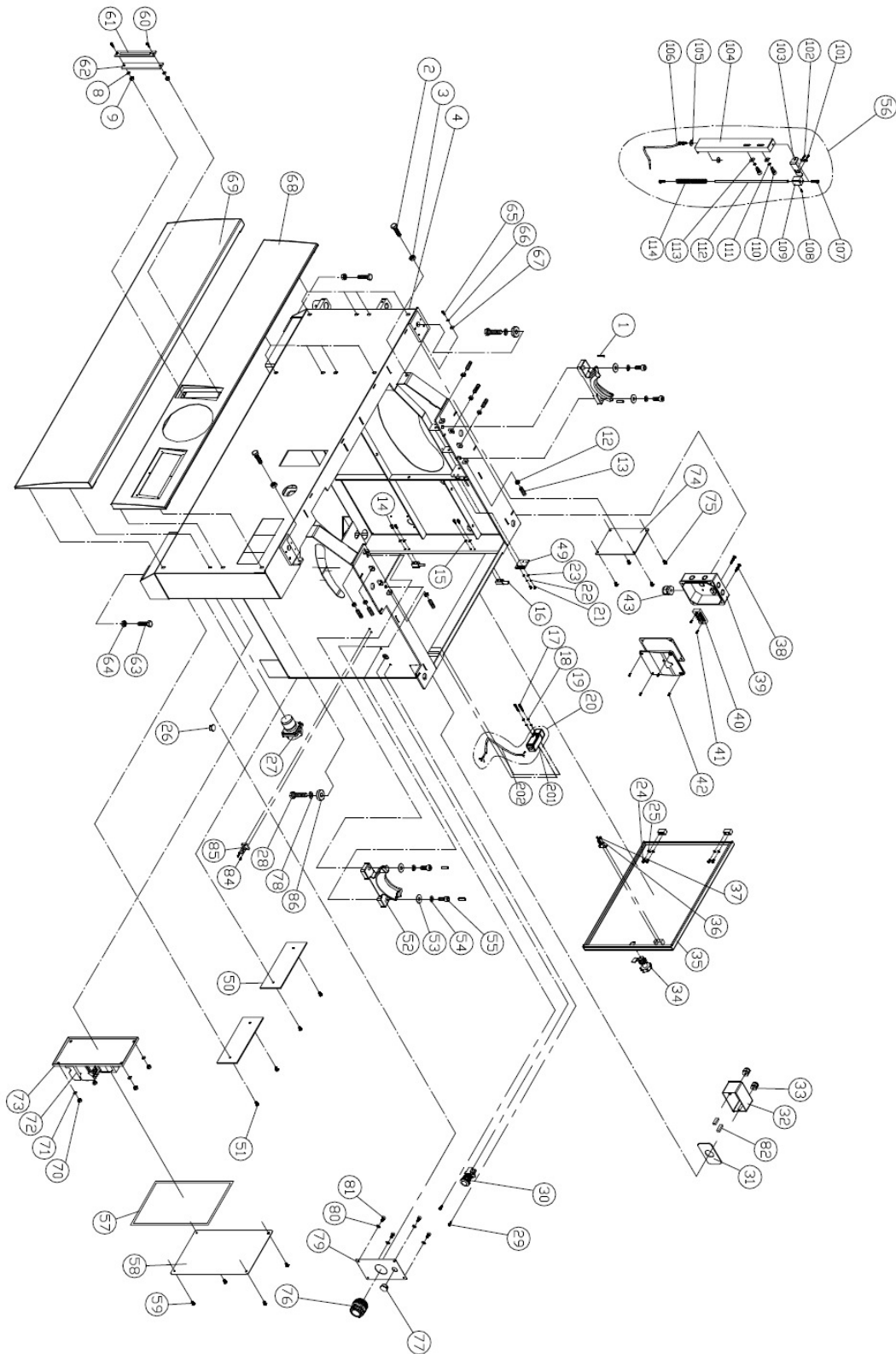


Fig. 70

# 1Ph220V60Hz CSA without brake



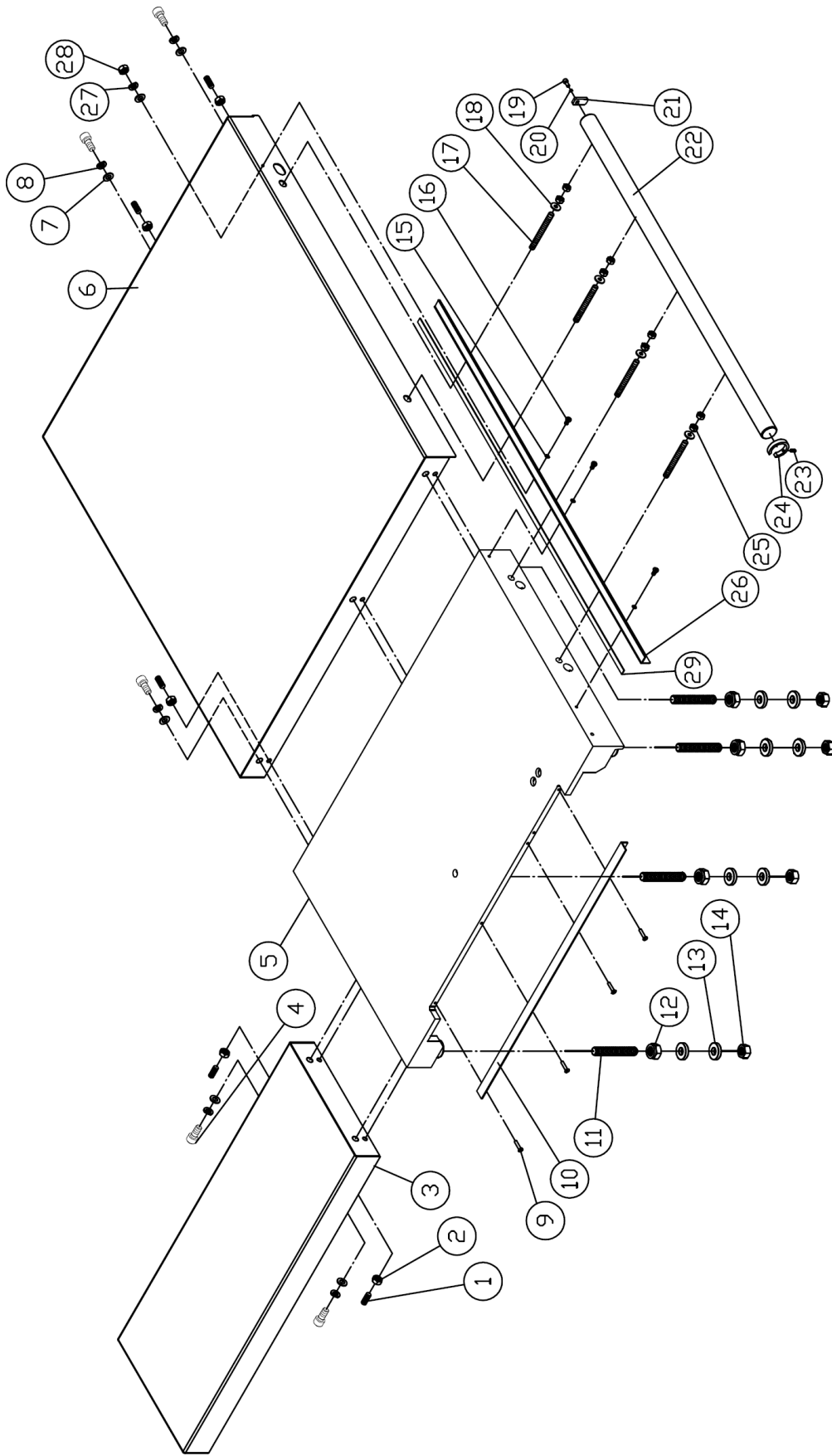
- S1: Emergency Button
- L1: Machinery Switch Door
- L2: Cover Plate Switch Door
- S2: Machinery Emergency Button
- S3: Main Saw Switch "OFF" Button
- S4: Scroing Saw Switch "OFF" Button
- S5: Main Saw Switch "ON" Button
- S6: Scroing Saw Switch "ON" Button
- H1: POWER Light(AC24V)
- FU1~FU3: Ceramic Tube Fuse



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	PS062500	Spring Pin	ψ6x25	4	
2	SH100800	Hex Head Bolt	M10x40	2	
3	NH101700	Hex Nut	M10	2	
4	206605	Machine frame		1	T9
8	WF040808	Washer	M4xψ8	2	
9	NF040700	Hex Nut	M4	2	
12	NH081300	Hex Nut	M8	8	
13	SS080500	Setscrew	M8x25	8	
14	SR050100	Cap Screw	M5x5	4	
15	WS050000	Lock Washer	M5	4	
16	203412	Block		2	
17	SP040600	Pan Head Screw	M4x30	2	
18	WS040000	Lock Washer	M4	2	
19	WF040808	Washer	M4xxψ8	2	
20	AB136458	Door Safety Switch ASM		1	
201	136457	Door Safety Switch	AZD-S11	1	
202	IC201413	STOP CORD	0.75x2Cx40CMx2Y2.E	1	
21	SR069300	Cap Screw	M6x12	2	
22	WS060000	Lock Washer	M6	2	
23	WF061310	Washer	M6x13	2	
24	SR059200	Cap Screw	M5x8	4	
25	WS050000	Lock Washer	M5	4	
26	206442	Hole Plugs	HP-38	1	
27	994809	Power Switch	ZH-HD-2	1	
28	SH121000	Hex Head Bolt	M12x50	2	
29	ST050400	Tap Screw	M5x20	2	
30	994808	Emergency Stop Button	R2PNR4-1B-R	1	
31	150956	Pad		1	
32	605408	Switch Box		1	
33	998621	Strain Relief		2	
34	203430	Lock		1	
35	205259	Door		1	
36	WS040000	Lock Washer	M4	2	
37	SP040500	Pan Head Screw	M4x25	2	
38	SJ060400	Button Head Screw	M6x20	2	
39	201105	Power Box		1	CE
	201105A	Power Box		1	CSA
40	994805	Terminal	PB2504 4P	0	CE
	994805	Terminal	PB2504 4P	1	CSA
41	SP059200	Pan Head Screw	M5x8	2	
42	SJ059300	Button Head Screw	M5x12	4	
43	709421	Strain Relief	PG20	2	

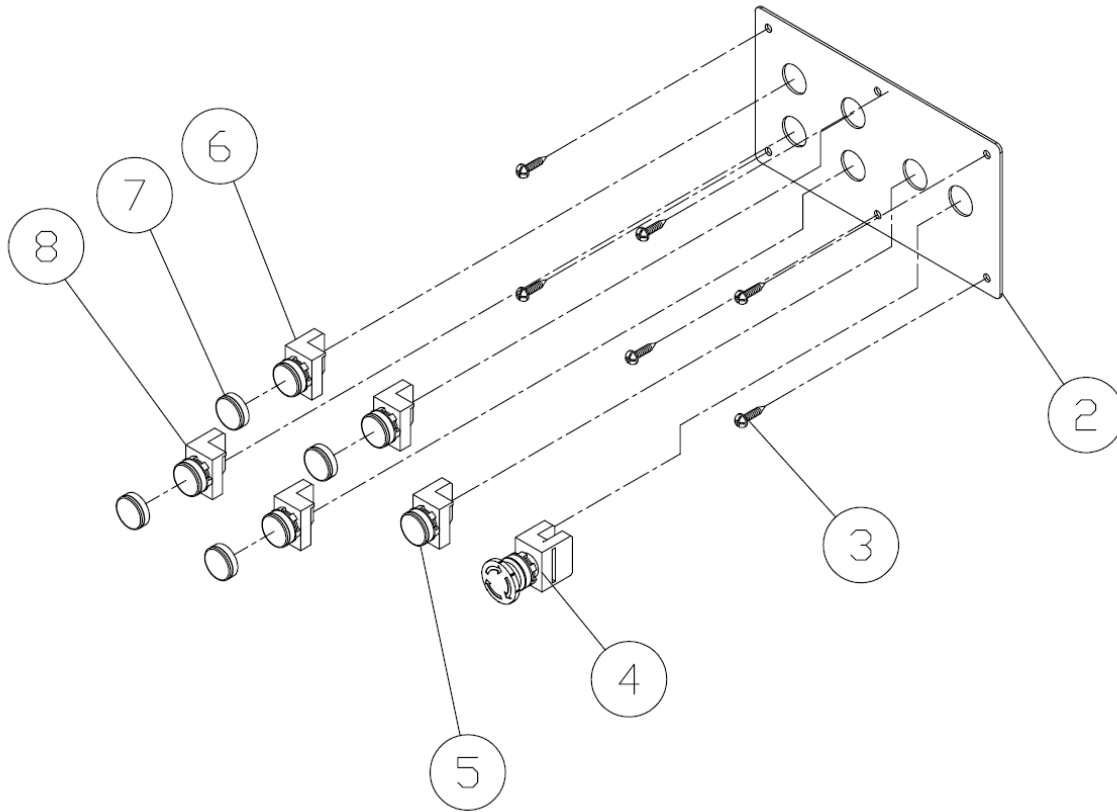
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
49	206342	Plate		1	
50	206345-32	Plate		2	T9
51	SF060200	Pan Head Screw(+)/W	M6x10	4	
52	207540	Base		2	X2
53	WF102030	Washer	M10x $\psi$ 20	4	
54	WS100000	Lock Washer	M10	4	
55	SR100700	Cap Screw	M10x35	4	
56	AB207399	Steel Wire ASM		1	
101	WF051210	Washer	M5x12	2	
102	SP050200	Pan Head Screw	M5x10	2	
103	200840	Pointer		1	
104	200841	Fix Plate		1	
105	WF061310	Washer	M6x13	2	
106	207399	Steel Wire		1	
107	SR050200	Cap Screw	M5x10	2	
108	SS050200	Setscrew	M5x10	1	
109	200843	Indicator Block		1	
110	SR069300	Cap Screw	M6x12	2	
111	WS060000	Lock Washer	M6	2	
112	200842	Shaft		1	
113	WF061310	Washer	M6x13	2	
114	200993	Spring		1	
57	150527	Pad	2x300x7.5(M/M)	4	
58	201893	Plate		1	T9
59	SJ060200	Button Head Screw	M6x10	4	
60	SP040400	Pan Head Screw/W	M4x20	2	
61	LM001076	Tilt Scale		1	
62	201785	Plate		1	
63	SH161000	Hex Head Bolt	M16x50	4	
64	NH162400	Hex Nut	M16	4	
65	SR069300	Cap Screw	M6x12	12	
66	WS060000	Lock Washer	M6	12	
67	WF061310	Washer	M6x $\psi$ 13	12	
68	206616	Front Cover		1	
69	206617	Front Cover		1	T9
70	NF061000	Hex Flange Nut	M6	4	
71	WF061310	Washer	M6x13	4	
72	200867	Electric.Panel	400V 3~	1	
73	200867A-1	Plate		1	
74	207128	Plate		1	T9
75	SJ069300	Button Head Screw	M6x12	4	

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
76	207318	Strain Relief	MGB40-25B	1	
77	201458	Hole Plugs	HP-22	1	
78	WS120000	Lock Washer	M12	2	
79	207080	Plate		1	
80	WS060000	Lock Washer	M6	4	
81	SR069300	Cap Screw	M6x12	4	
82	136019	Cord Connetor	224-201	2	
84	ST049300	Tap Screw		2	
85	170736	Hanger		1	
86	203410	Ring		2	

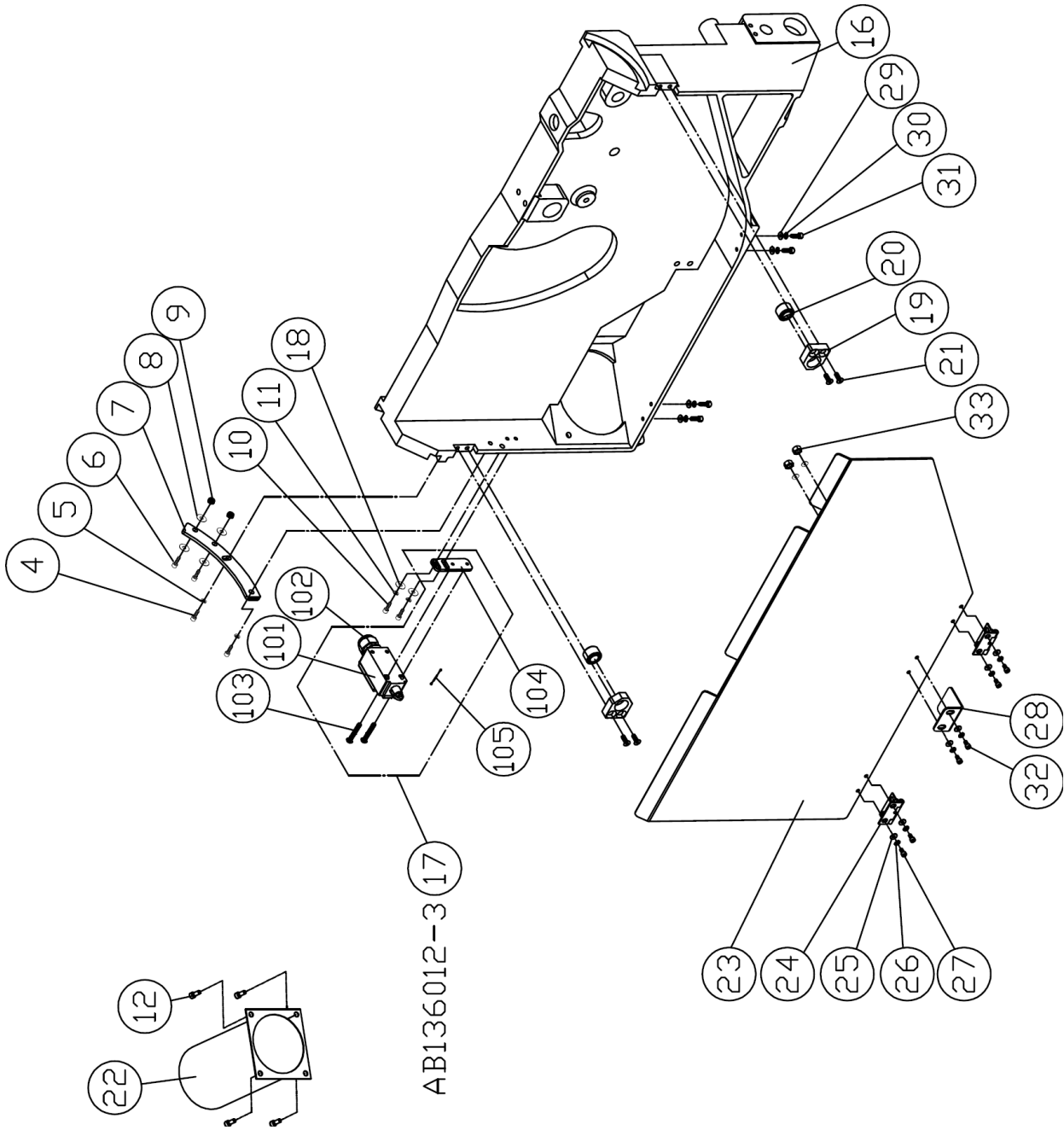


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	SS100400	Set Screw	M10*20	5	
2	NH101700	Hex Nut	M10	5	
3	207077	Left Ext. Plate	S	1	
	207151	Left Ext. Plate	OPT	1	optional
4	SR100500	Cap Screw	M10*25	5	
5	206332	Table		1	
6	207078	Ext. Plate	BIG	1	
7	WF102030	Washer	M10* $\psi$ 20	5	
8	WS100000	Lock Washer	M10	5	
9	SJ069300	Button Head Screw	M6*12	4	
10	206354	Table Insert		1	
11	SS162000	Set Screw	M16*100	4	
12	NL162400	Lock Nut	M16	4	
13	205016	Washer		8	
14	NH162400	Hex Nut	M16	4	
15	WF061620	Washer	M6*16	4	
16	SJ069300	Button Head Screw	M6*16	3	
17	200881	Screw	M12 $\times$ 1.75p $\times$ 115L	4	
18	WF132225	Washer	M13 $\times$ 22	4	
19	SR089300	Cap Screw	M8 $\times$ 16	1	
20	WS080000	Lock Washer	M8	1	
21	206437	End Washer		1	
22	201004	Round Rail		1	
23	SS060200	Setscrew	M6 $\times$ 10	1	
24	200957	Ring Stop		1	
25	NH121900	Hex Nut	M12	8	
26	207984	Measuring Rule Rail		1	
27	WS060000	Lock Washer	M6	1	
28	NH061000	Hex Nut	M6	1	
29	LM206306	Ruler		1	Metric
	LM001042	Ruler		1	optional

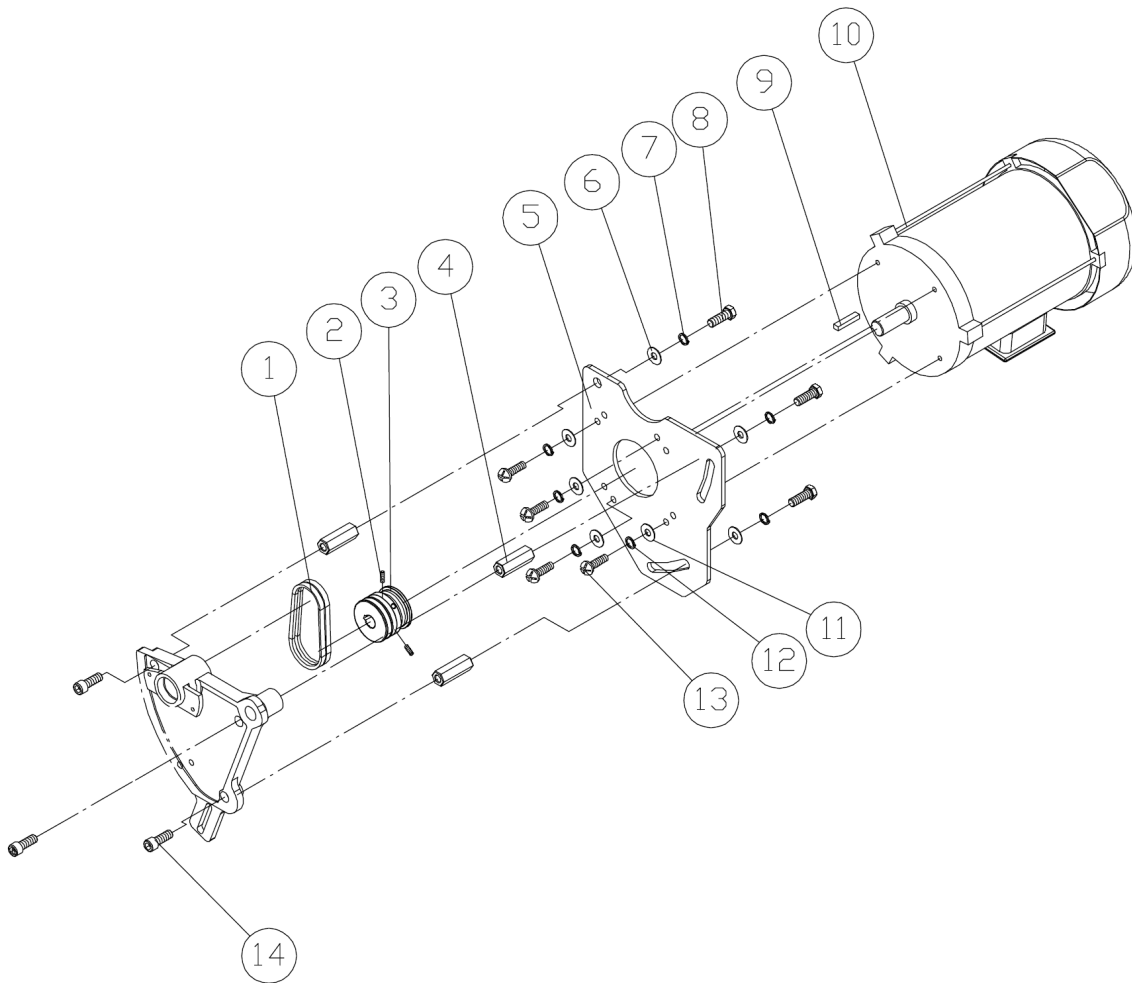




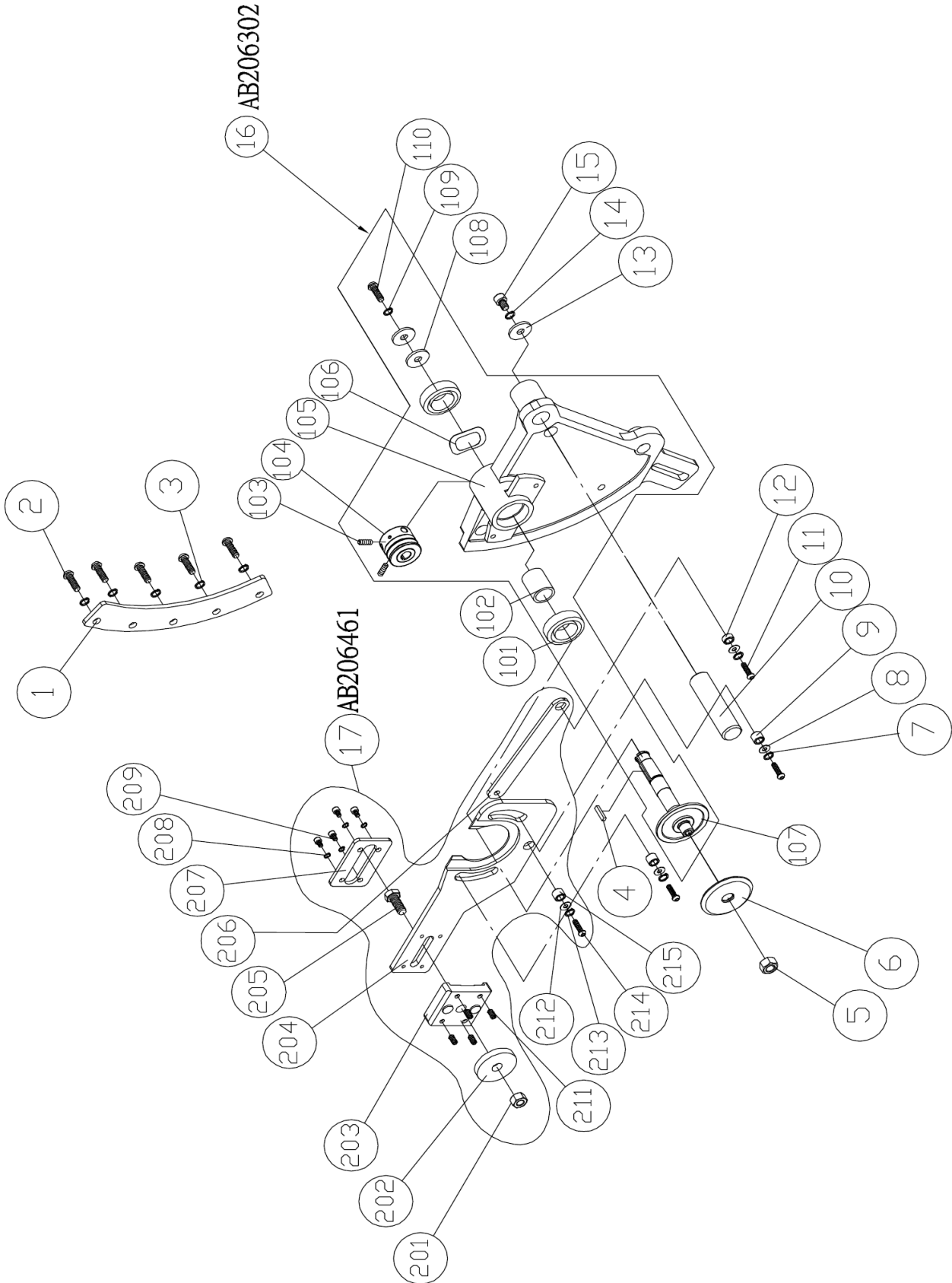
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
2	206407	Panel		1	
3	SJ050200	Button Head Screw	M5x10	6	
4	994808	Emergency Stop Button		1	
5	996002	Pilot Lamp	YK.24V $\phi$ 22 (W)	1	
6	994855	Switch Button-ON	R2 PNF-1A-G	2	
7	994855A	Dust Cove	R2 PRCF	4	
8	994856	Switch Button-OFF	R2 PNF-1B-R	2	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
4	SR069300	Cap Screw	M6x12	2	
5	WS060000	Lock Washer	M6	2	
6	SR059400	Cap Screw	M5x16	2	
7	206337	Fix Plate		1	
8	WF051010	Washer	M5x10	4	
9	NL050800	Lock Nut	M5	2	
10	SR059300	Cap Screw	M5x12	2	
11	WS050000	Lock Washer	M5	2	
12	SF089300	Hex Head Bolt(+)/W	M8x12	4	
16	206301	Channel Base		1	
17	AB136012-3	Door Safety Switch Assembly		1	
101	136012	Door Safety Switch		1	
102	709411	Strain Relief	PG11	1	
103	SP040700	Pan Head Plate	M4x35	2	
104	206341	Fix Plate		1	
105	IC200807	STOP CORD		1	optional
	IC206301	STOP CORD		1	optional
18	WF051010	Washer	M5x10	2	
19	206359	Plate		2	
20	203249	Magnetic Iron(assembly)		2SETS	
	203249-1	Magnetic Iron		1	
	203249-3	Screw		1	
21	SM060400	Sunkhead Socket Screw	M6x20	4	
22	206118	Dust Port		1	
23	206324	Cover		1	F1L
24	207940	Hinge		2	
25	WF051010	Washer	M5x10	8	
26	WS050000	Lock Washer	M5	6	
27	SR059200	Cap Screw	M5x8	4	
28	207152	Plate		1	
29	WF051010	Washer	M5x10	4	
30	WS050000	Lock Washer	M5	4	
31	SR050200	Cap Screw	M5x10	4	
32	SR059400	Cap Screw	M5x16	2	
33	NH050800	Hex Nut	M5	2	

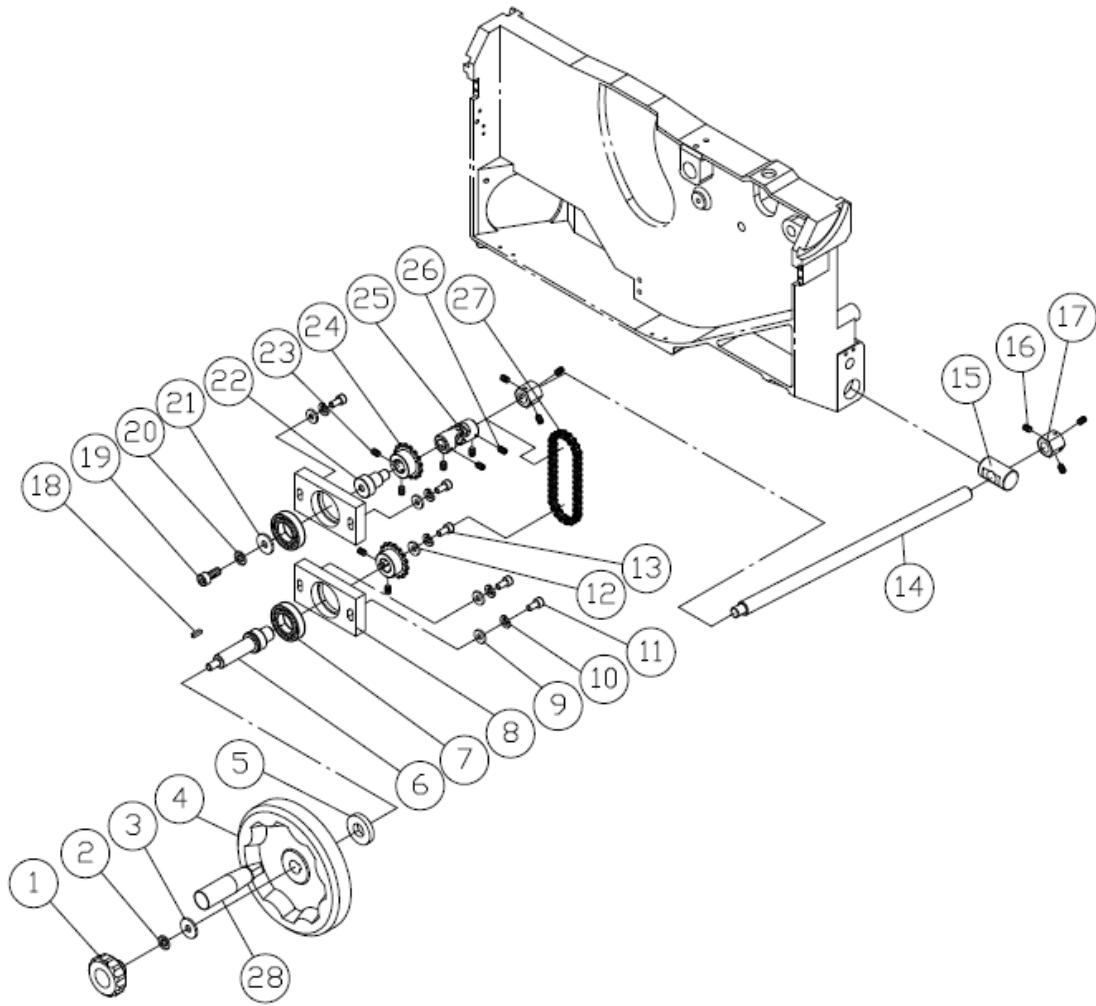


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	208044	Belt (50hz)	3VX-265	2	optional
	206399	Belt (60hz)	3VX-250	2	optional
2	SS080200	Setscrew	M8×10	3	
3	208043	Belt Pulley (CE)	50Hz	1	optional
	208042	Belt Pulley (CSA)	60Hz	1	optional
4	201333	Shaft		3	
5	206396	Main Motor Plate		1	
6	WF132225	Washer	M13×ψ22	3	
7	WS120000	Lock Washer	M12	3	
8	SH120600	Hex Head Bolt	M12×30	3	
9	KD080745	Key	8x7x45	1	
10	MH204006	Main Motor	5HP(220V/440V)	1	optional
11	WF081818	Washer	M8×ψ18	4	
12	WS080000	Lock Washer	M8	4	
13	SJ080400	Hex Head Bolt	M8×20	4	
14	SR120600	Cap Screw	M12×30	3	



ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	206304	Gip Plate		1	
2	SJ100500	Button Head Screw	M10x25	5	
3	WS100000	Spring Washer	M10	5	
4	KD050520	Key	5x5x20	1	

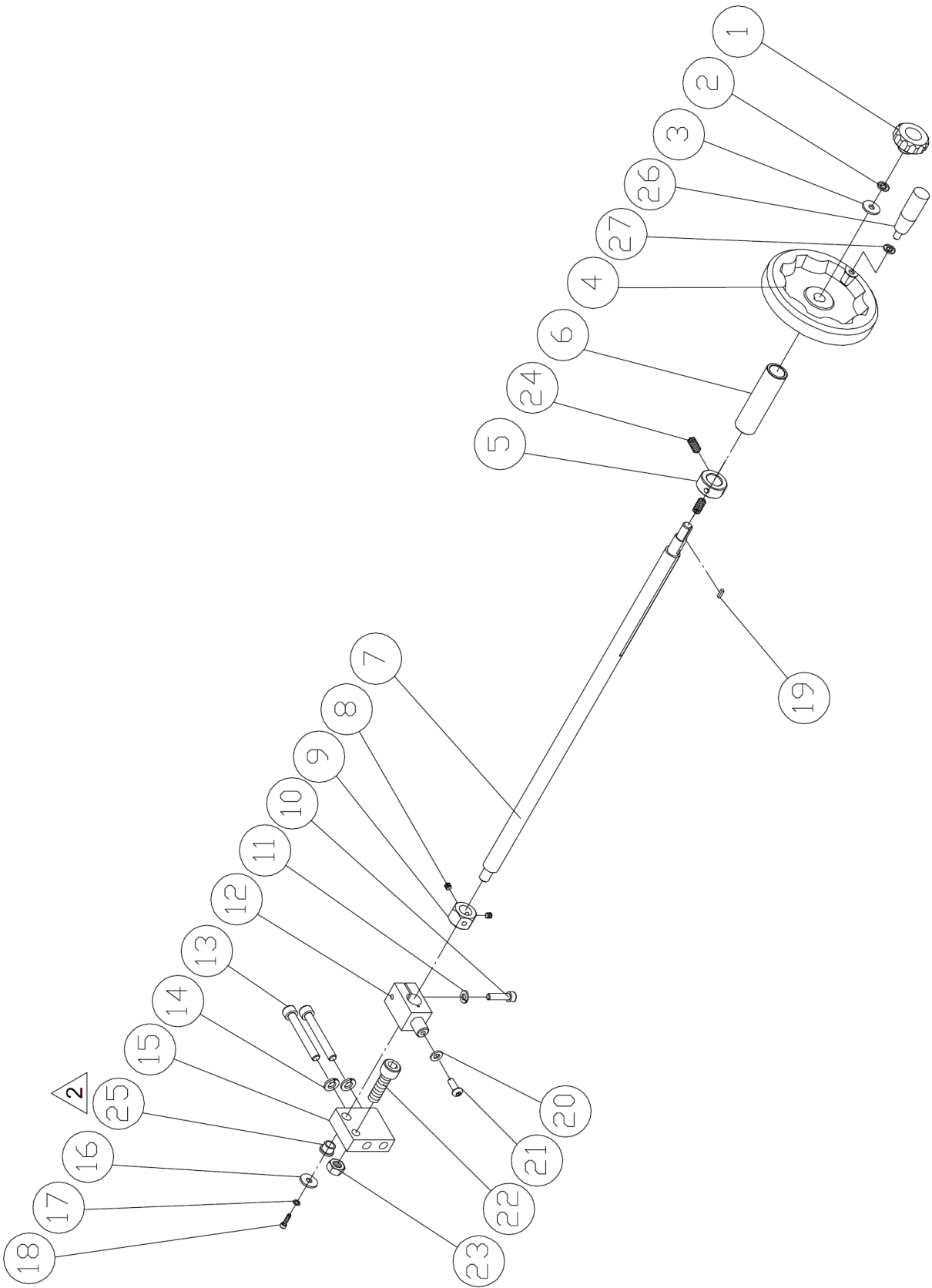
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
5	201822	Nut	M16x2.0	1	
6	206350	Arbor Flange	ψ25.4	1	optional
	206380	Arbor Flange	ψ30	1	
7	WS080000	Lock Washer	M8	3	
8	WF083030	Washer	M8×ψ30	3	
9	200964	Bushing		3	
10	201205	Shaft		1	
11	SJ080400	Button Head Screw	M8×20	3	
12	201346	Bushing		1	
13	WF083030	Washer	M8×ψ30	1	
14	WS080000	Lock Washer	M8	1	
15	SR080400	Cap Screw	M8×20	1	
16	AB206302-3		SS-D30P2 D305P2	1	
	AB206302-4		SS-D30P2 D305P2	1	optional
	AB206302-5		SS-D30P2 D305P2	1	optional
101	BB620604	Bearing	6206LLB	2	
102	206311	Spacer		1	
103	SS050200	Setscrew	M5×10	3	
104	208041	Pulley		1	
105	206302	Rotate Plate		1	
106	WW476004	Wave Washer	ψ47×ψ60	2	
107	206357	Main Arbor	ψ30	1	
	206310	Main Arbor	ψ25.4	1	optional
108	WF083030	Washer	M8×ψ30	2	
109	WS080000	Lock Washer	M8	1	
110	SJ080400	Button Head Screw	M8×20	1	
17	AB206461	Fix Block ASM		1	
201	NH101704	Hex Nut	M10	1	
202	WF104040	Washer	M10×ψ40	1	
203	206461	Fix Block		1	
204	206309	Locate Plate		1	
205	SH100600	Hex Head Bolt	M10×30	1	
206	206360	Link Plate		1	
207	201881	plate		1	
208	WS050000	Lock Washer	M5	4	
209	SJ050200	Button Head Screw	M5×10	4	
211	SS050200	Setscrew	M5x10	4	
212	WF083030	Washer	M8×ψ30	1	
213	WS080000	Lock Washer	M8	1	
214	SJ080400	Button Head Screw	M8×20	1	
215	200964	Bushing		1	



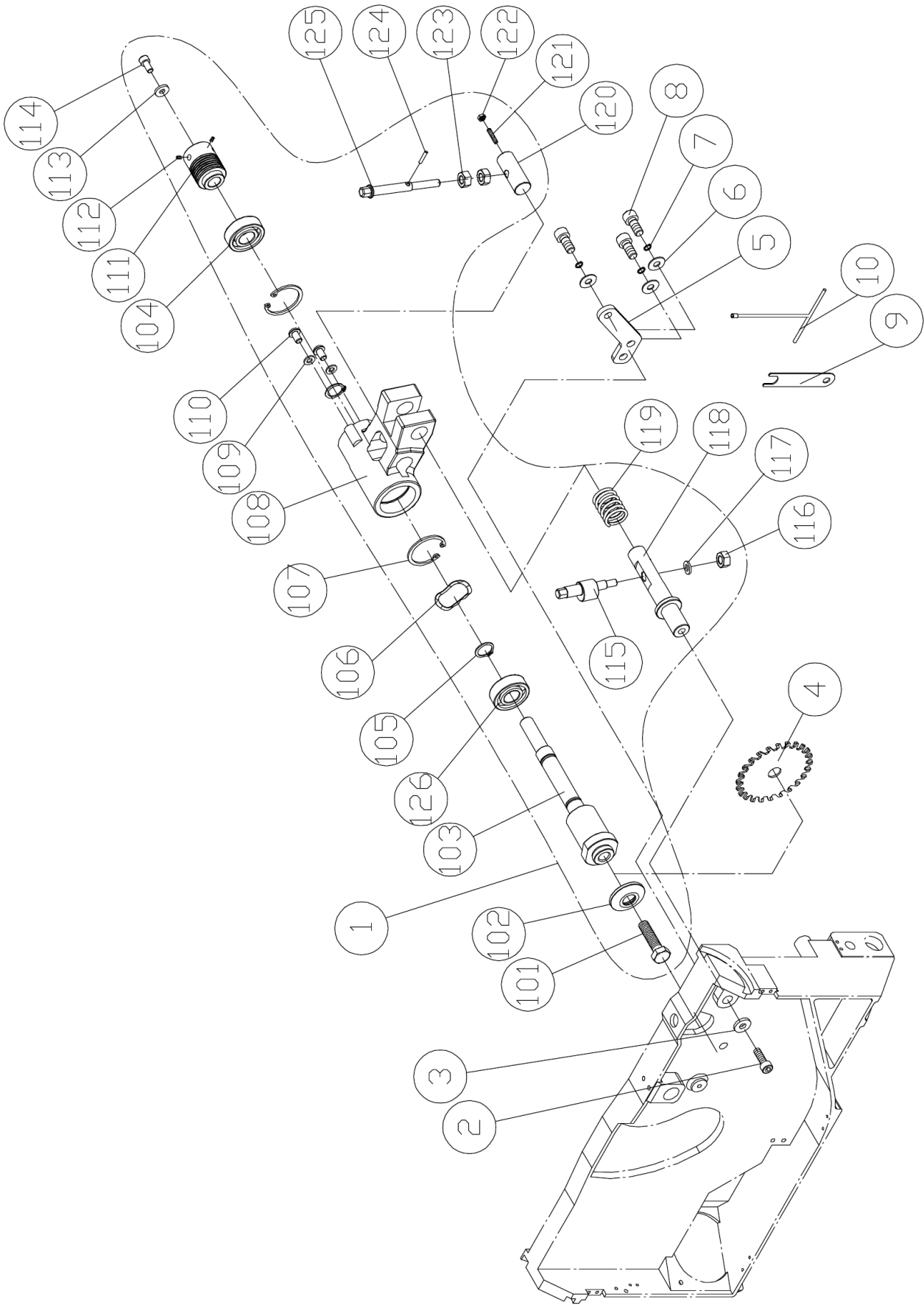
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	100203	Lock Knob	M10	1	
2	204263	Washer	$\psi 10 \times \psi 20$	1	
3	WF102730	Washer	8"	1	
4	206434A	hand wheel		1	
5	201567	Washer		1	
6	206444	Shaft	6006ZZ	1	
7	BB600602A	Bearing		2	
8	206409	Locate Plate		2	
9	WF081818	Lock Washer	M8 $\times\psi 18$	4	
10	WS080000	Lock Washer	M8	5	
11	SR080700	Cap Screw	M8 $\times 35$	4	
12	WF083030	Lock Washer	M8 $\times\psi 30$	1	
13	SR080400	Cap Screw	M8 $\times 20$	1	
14	207176	Screw		1	
15	206328	Shaft		1	

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
16	SS069100	Set Screw	M6x6	6	
17	206379	Set Nut		2	
18	KS070720	Key	7x7x20	1	
19	SR100400	Cap Screw	M10x20	1	
20	WS100000	Lock Washer	M10	1	
21	WF104030	Washer	M10xψ40	1	
22	206410	Shaft		1	
23	SS060200	Set Screw	M6x10	4	
24	207115	Sprocket		2	
25	207461	Free Joint	ψ14	1	
26	SS069100	Set Screw	M6x6	4	
27	206441	Chain		1	
28	200866-1			1	

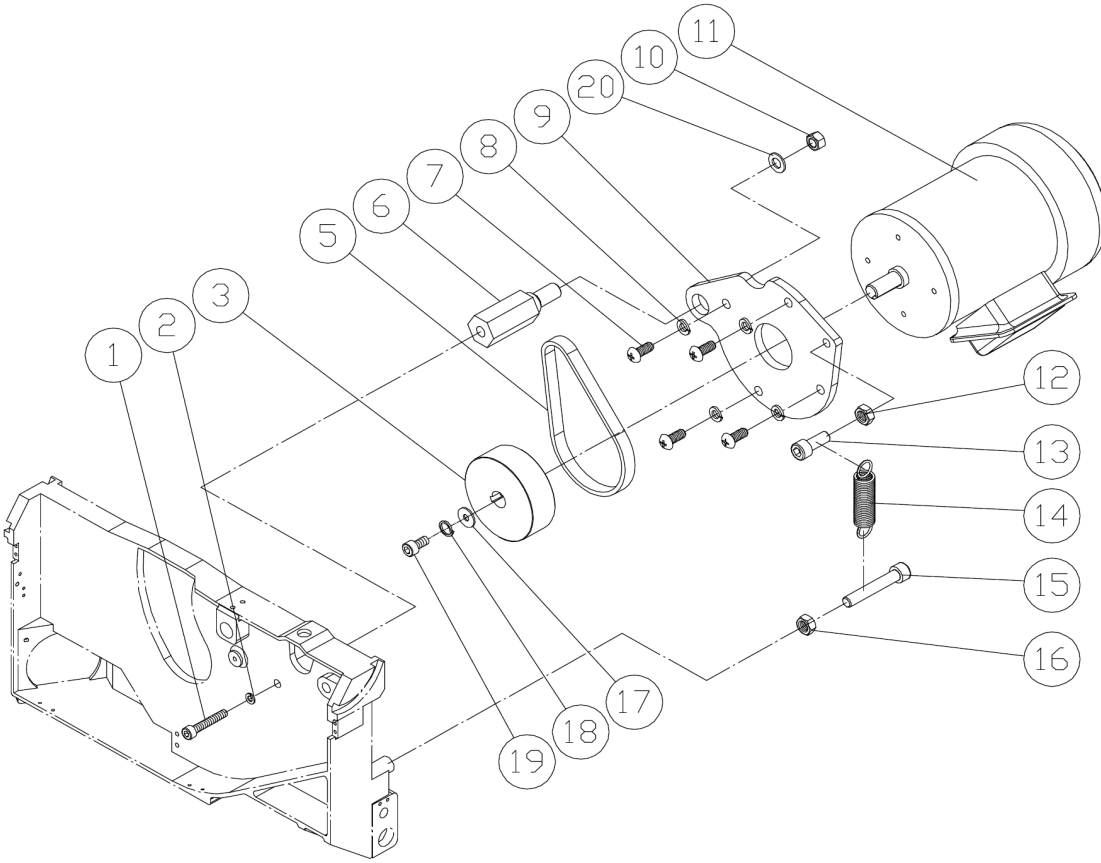




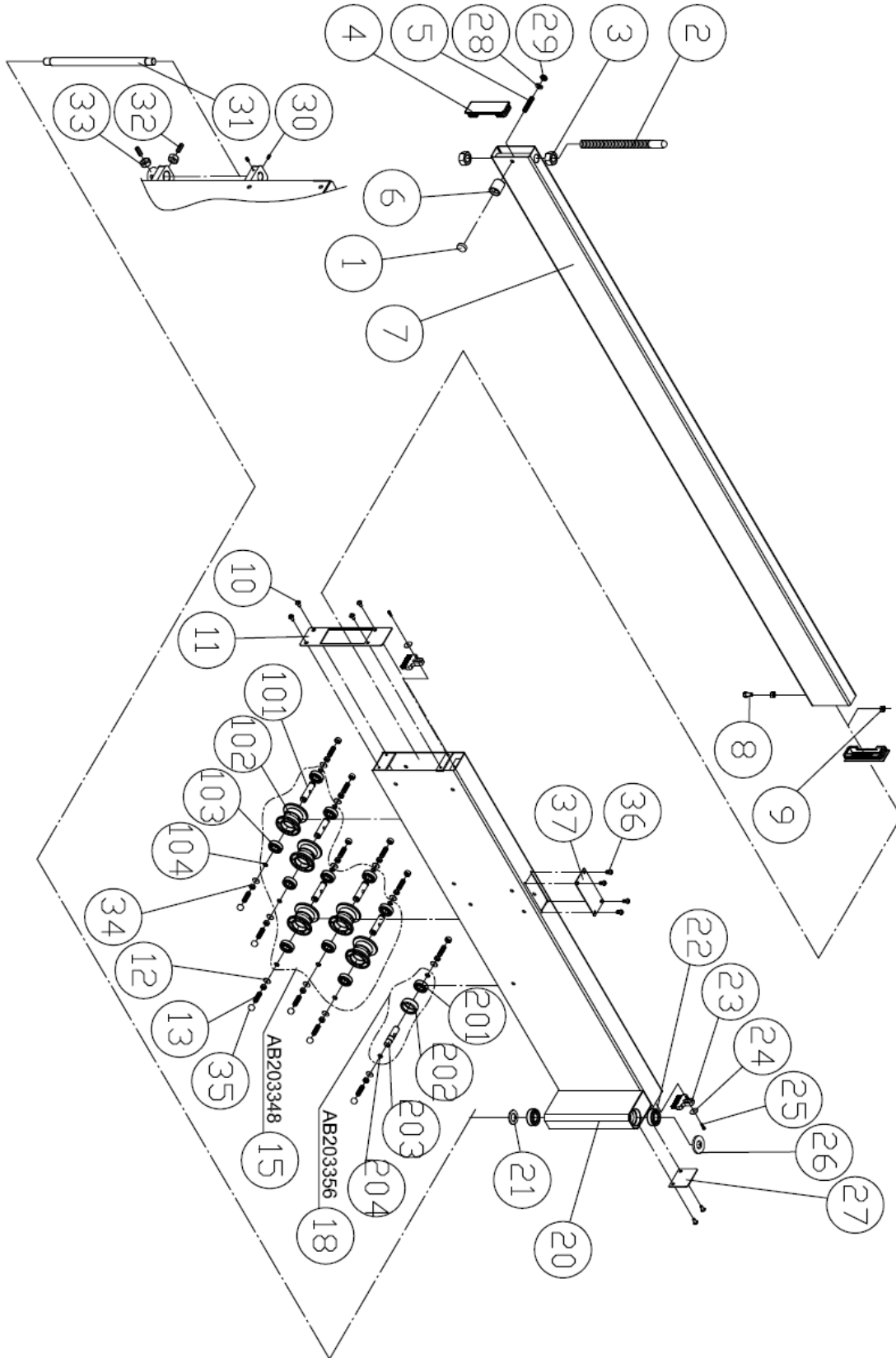
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	100203	Lock Knob	M10	1	
2	204263	Washer	$\psi 10 \times \psi 20$	1	
3	WF103030	Washer	M10 $\times\psi 30$	1	
4	204289B	Hand Wheel		1	optional
	204176A	Hand Wheel		1	optional
5	200855	Bushing		1	
6	206385	Sleeve		1	
7	206327	Screw		1	
8	SS069100	Setscrew	M6 $\times 6$	3	
9	206379	Set Nut		1	
10	SR060600	Cap Screw	M6 $\times 30$	1	
11	WS060000	Lock Washer	M6	2	
12	206326	Hex Nut		1	
13	SR081200	Cap Screw	M8 $\times 60$	2	
14	WS080000	Lock Washer	M8	2	
15	206325	Locate Block		1	
16	WF061310	Washer	M6 $\times 13$	1	
17	WS060000	Lock Washer	M6	1	
18	SR069300	Cap Screw	M6 $\times 12$	1	
19	KS050520	Key	5*5*20	1	
20	WF061620	Washer	M6 $\times\psi 16$	1	
21	SJ060200	Cap Screw	M6 $\times 10$	1	
22	SS100700	Setscrew	M10 $\times 35$	1	
23	NH101700	Hex Nut	M10	1	
24	SS080200	Setscrew	M8 $\times 10$	2	
25	017177	Bushing		1	
26	206460	Handle	M10 7"	1	
27	WF101608	Washer	M10 $\times\psi 16 \times t 0.8$	1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	AB206315-1	Pulley ASM		1	
101	SH120440	Hex Head Bolt	M12x20	1	
102	206320	Flange		1	
103	206321	Shaft		1	
104	BB620204	Ball Bearing	6202LLB	1	
105	RS150000	Int. Retaining Ring	S15	2	
106	WW263403	Wave Washer	$\psi 26 \times \psi 34 \ t=0.3 \ ( \ 6202 \ )$	2	
107	RR350000	Int. Retaining Ring	R35	2	
108	206303	Shaft		1	
109	WF061310	Washer	M6x13	2	
110	SJ069400	Button Head Screw	M6*16	2	
111	206315	Pulley		1	
112	SS069100	Set Screw	M6x6	3	
113	WF061620	Washer	M6x16	1	
114	SH069402	Hex Head Bolt	M6x16(L.H)	1	
115	206316	Shaft		1	
116	NL061000	Lock Nut	M6	1	
117	206395	Spring	$\psi 15 \times \psi 6.2 \times 0.5t$	1	
118	206318	Shaft		1	
119	206323	Spring		1	
120	206319	Shaft		1	
121	206386	Set Screw	M6x25	1	
122	NH061000	Hex Nut	M6	1	
123	203239	Hex Nut	M8	2	
124	PS031200	Spring Pin	$\psi 3 \times 12$	1	
125	206317	Screw		1	
126	BB600304	Ball Bearing	6003LLB	1	
2	SR080400	Cap Screw	M8x20	1	
3	WF083030	Washer	M8x $\psi 30$	1	
4	200973	Scoring Saw Blade	$\phi 20$	1	
5	206365	Fix Plate		1	
6	WF061310	Washer	M6x13	3	
7	WS060000	Lock Washer	M6	3	
8	SR069400	Cap Screw	M6x16	3	
9	206366	Wrench		1	
10	206369	Wrench	8mm	1	

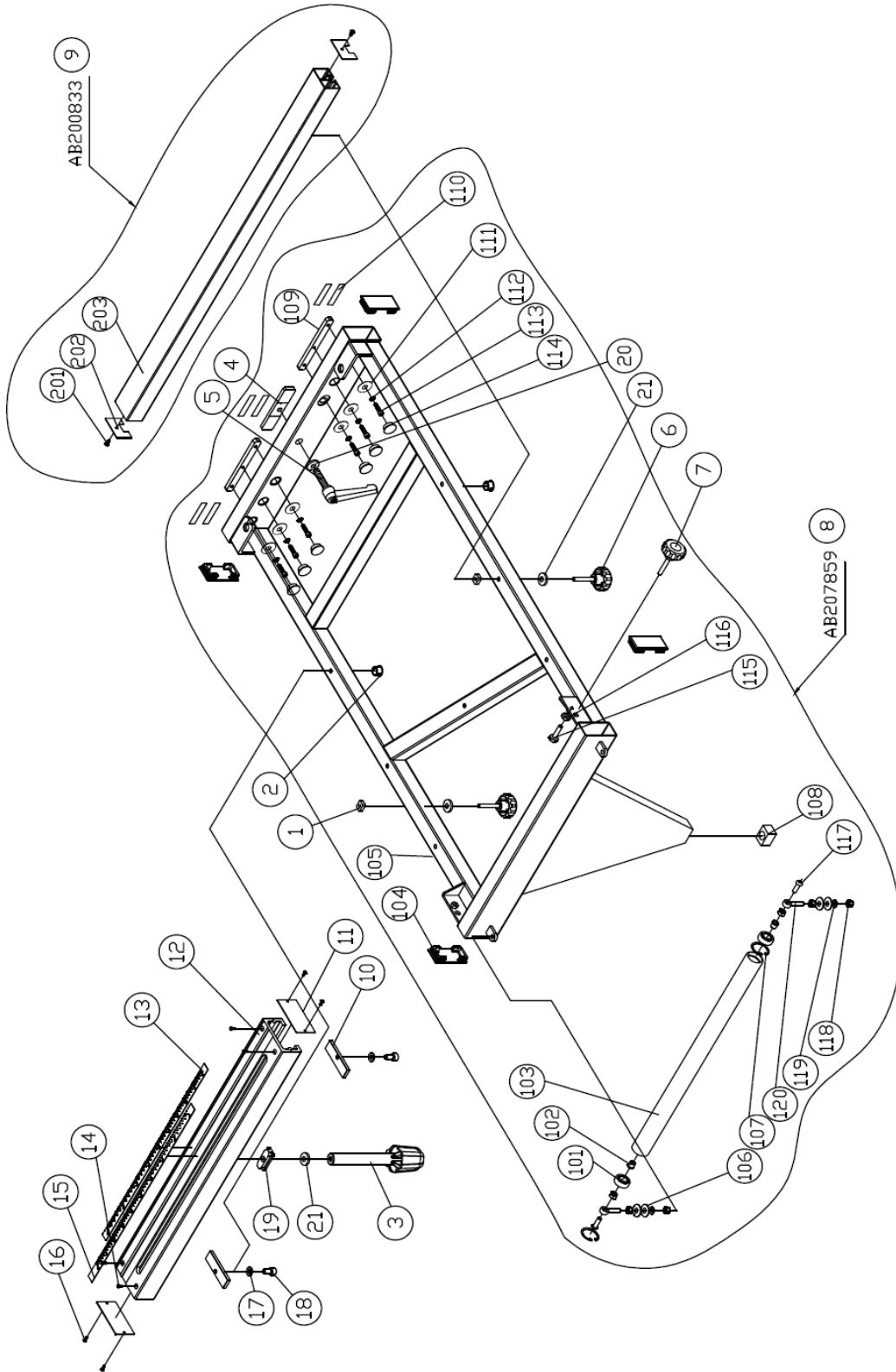


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	SR122000	Cap Screw	M12x100	1	
2	WS120000	Lock Washer	M12	1	
3	206314	Pully (50hz)		1	optional
	206336	Pully (60hz)		1	optional
5	LJ014070	Belt (60hz)	140J7	1	optional
	LJ015070	Belt (50hz)	150J7	1	optional
6	206313	Shaft		1	
7	SJ080400	Button Head Screw	M8x20	4	
8	WS080000	Lock Washer	M8	4	
9	206331	Plate		1	
10	NL142200	Lock Nut	M14	1	
11	MH206301	Scoring Motor	0.75P (M20P)	1	
12	NH101700	Hex Nut	M10	1	
13	SR100400	Cap Screw	M10x20	1	
14	201275	Expansion Spring		1	
15	SR101000	Cap Screw	M10x50	1	
16	NH101700	Hex Nut	M10	1	
17	WF063030	Washer	M6xψ30	1	
18	WS060000	Lock Washer	M6	1	
19	SR069400	Cap Screw	M6x16	1	
20	WF143530	Washer	M14xψ35	1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	200934-2	Magnet		1	
2	203416	Screw Threads	For sliding table E	1	Optional
	205505A	Screw Threads	For sliding table D	1	Optional

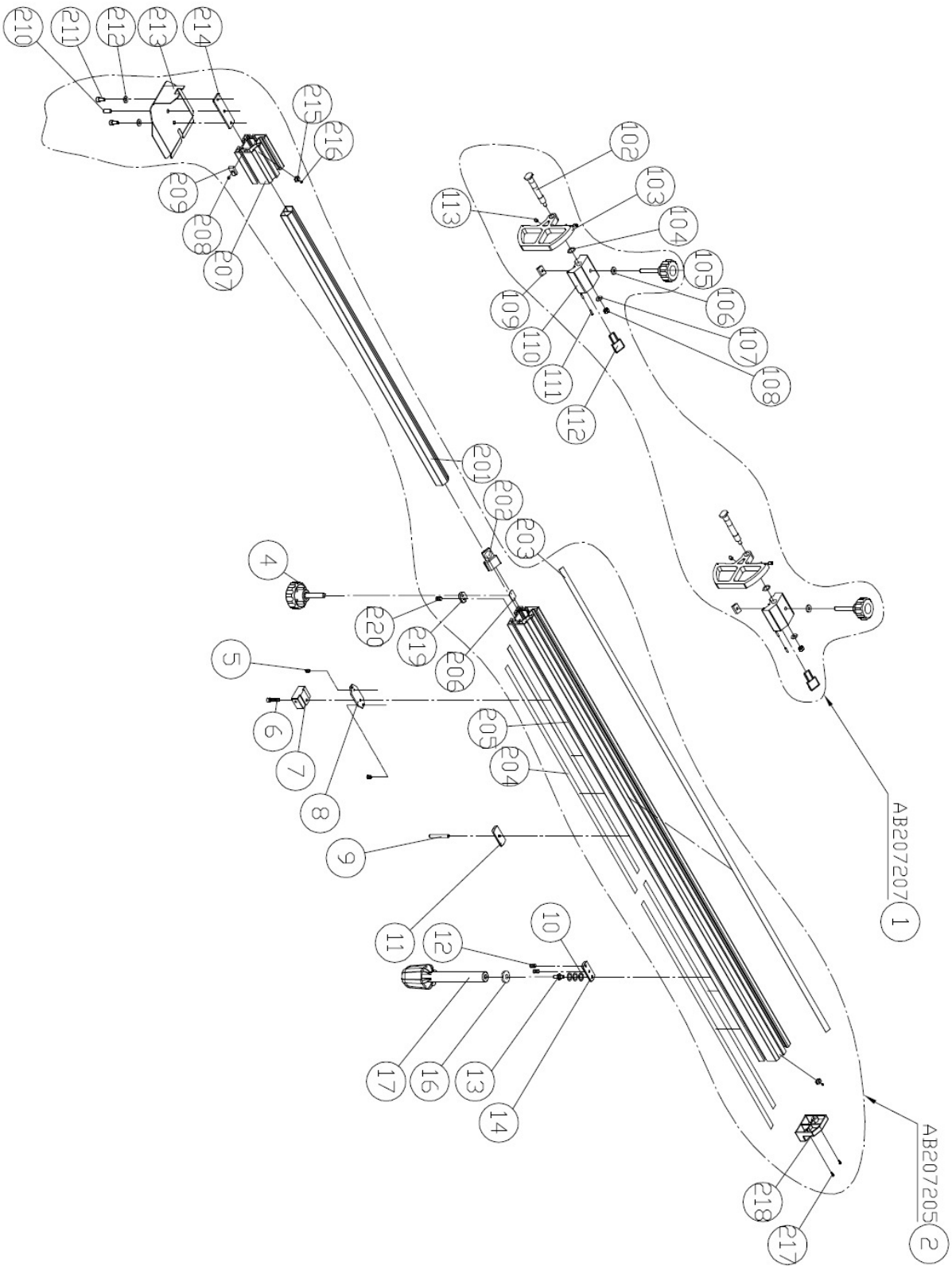
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
3	NH203000	Hex Nut	M20x2.5p	2	
4	203470	Plug	40x120	2	
5	SS080700	Set Screw	M8x35	1	
6	201146-1	Magnetic Bracket		1	
7	207856	Sliding Tube	2200MM	1	Optional
	205208	Sliding Tube	3200MM	1	Optional
	205395	Sliding Tube	3800MM	1	Optional
8	SH080400	Hex Head Screw	M8x20	1	
9	NH081300	Hex Nut	M8	2	
10	SJ060200	Button Head Screw	M6x10	6	
11	207085	Cover		1	
12	WF081818	Washer	M8x $\psi$ 18	8	
13	SS080500	Setscrew	M8x25	8	
15	AB203348	Roller Assembly		5	
101	203349	Shaft		1	
102	203348	Roller		1	
103	BB620202	Bearing	6202ZZ	2	
104	RS150000	Ext. Retaining Ring	S15	2	
18	AB203356	Ring Assembly		1	
201	BB620202	Bearing	6202ZZ	1	
202	203356	Ring		1	
203	203357	Shaft		1	
204	RS150000	Ext. Retaining Ring	S15	2	
20	206421	Swing Arm		1	
21	WF203730	Washer	M20x $\psi$ 37	1	
22	BB600402A	Bearing	6004ZZ	2	
23	135051-A	Brush		2	
24	WF061310	Washer	M6x13	2	
25	SR060400	Cap Screw	M6x20	2	
26	WF203730	Washer	M20x $\psi$ 37	1	
27	207084	Plate		1	
28	WS080000	Spring Washer	M8	1	
29	203239	Hex Nut	M8x1.25P	1	
30	SS100200	Setscrew	M10x10	3	
31	207081	Shaft		1	
32	SS100400	Setscrew	M10x20	4	
33	NH101700	Hex Nut	M10	4	
34	NH081300	Hex Nut	M8	8	
35	207582	Cover	13mm	8	
36	SJ059200	Button Head Screw	M5x8	4	
37	207528	Plate		1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	201103	T-Nut	M8x1.25p	2	
2	203230	Plug	HP-16	2	
3	203128	Handle		1	

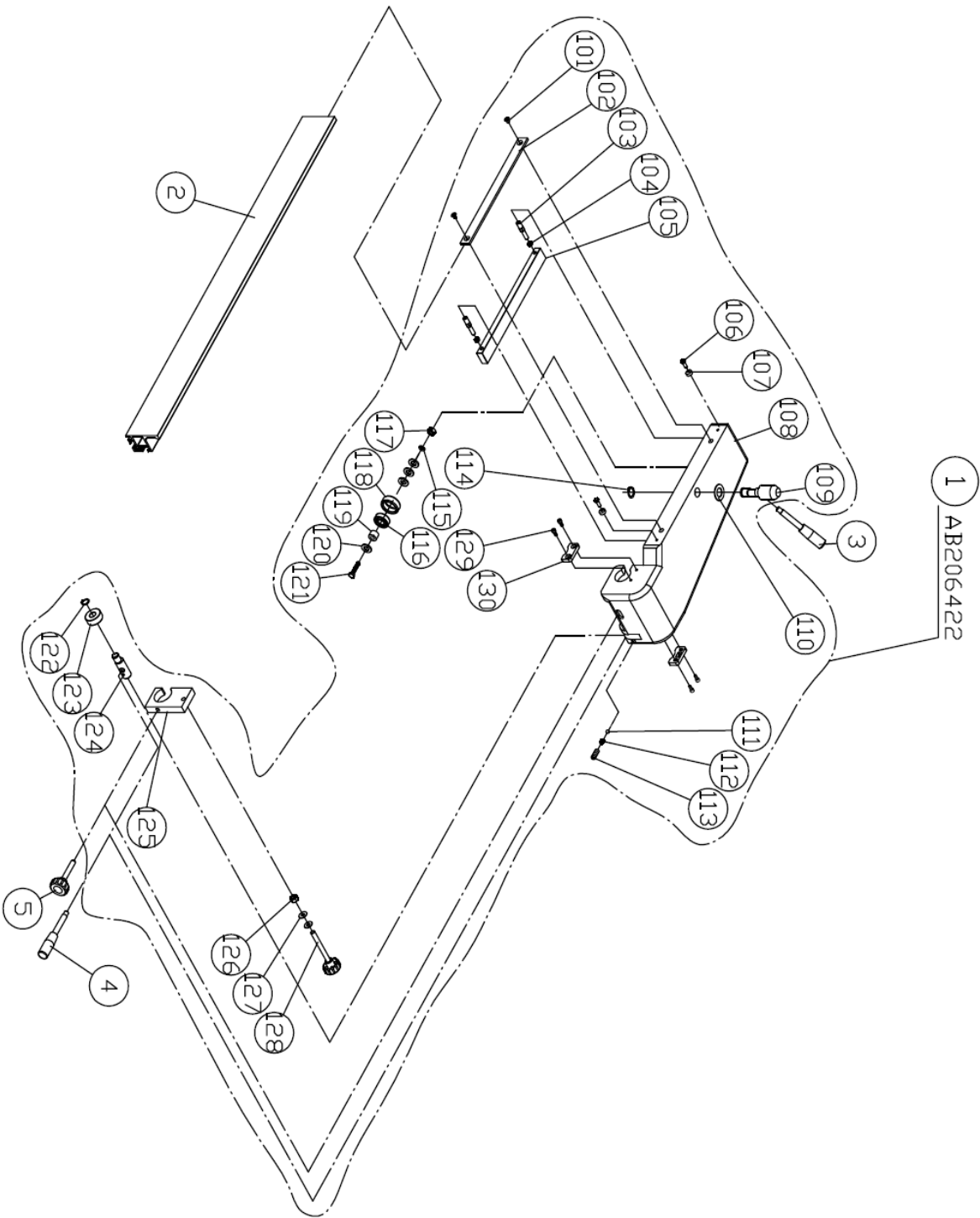


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
4	201456	T-Block		1	
5	200815	Adjust Handle	M12x1.75px57L	1	
6	200954	Knob Screw	M8x50	2	
7	200954	Knob Screw	M8x50	1	
8	AB207996R	Support Frame ASM		1	
101	BB620102A	Bearing	6201ZZ	2	
102	017058	Bearing		2	
103	203302	Roller		1	
104	200910	Plug	80x40	4	
105	207996	Support Frame		1	
106	WF081818	Washer	M8x18	4	
107	RR320000	Int. Retaining Ring	R32	2	
108	203094	Plug		1	
109	201452	Plate		2	
110	201038	Pad	55mm	6	
111	WF061620	Washer	M6x16	6	
112	WS060000	Lock Washer	M6	6	
113	SJ069400	Button Head Screw	M6x16	6	
114	201458	Plug		6	
115	SH080600	Hex Head Screw	M8x30	2	
116	NH081300	Hex Nut	M8	2	
117	SJ080500	Button Head Screw	M8x25	2	
118	NH081300	Hex Nut	M8	6	
119	WS080000	Lock Washer	M8	2	
120	201542	Eye Bolts	M8x40	2	
9	AB200833	Square Brace		1	
201	ST040200	Tap Screw	#8x3/8"	2	
202	200955	Cover		2	
203	200833	Square Brace		1	
10	203121	Fixed Block		2	
11	203856	Plate		2	
12	203855	Pipe		1	X7
13	LM205638-2	Ruler		1	
14	SS050250	Setscrew	M5x10	1	
15	LM205638-1	Ruler		1	
16	BR000041		3.2X6/6.4	4	
17	WS080000	Lock Washer	M8	2	
18	SR080500	Cap Screw	M8x25	2	
19	203122	Block		1	
20	WF123030	Washer	M12	1	
21	WF083030	Washer	M8	3	

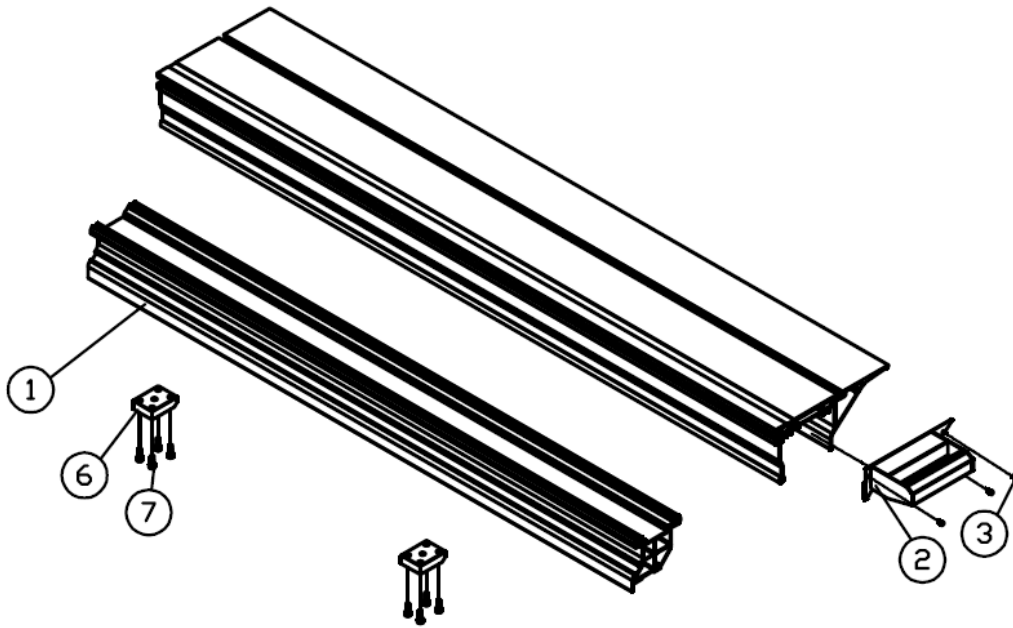


ITEM	PART NO	PARTS NAME	SIZE	Q`TY	
1	AB207207	Flip Stop Assembly		2	
102	207203	Shaft		1	
103	207207	Flip Stop		1	
104	207208	Washer		1	
105	207263	Knob	M8x1.25px42L	1	
106	200472	Washer	M8x20x1	1	
107	WF081818	Washer	M8x18	1	
108	207235	Nut	M8	1	
109	207200	Nut		1	
110	207201	Stop Bracket		1	
111	207223	Pipe		2	
112	207202	Magnifier		1	
113	203286	Set Screw	M8*10	2	
2	AB207205	Ext. Fence Assembly		1	
201	207212	Extended Tube		1	
202	207213	Magnifier		1	
203	207216	Rule		1	
204	205544	Wearing Tape	875x15	4	
205	207205-1	Ext. Fence		1	
206	207884	Sheet		1	
207	207205-2	Ext. Fence		1	
208	SS069100	Setscrew	M6x6	1	
209	207211	Stop Block		1	
210	SS080500	Setscrew	M8x25	1	
211	SR089400	Cap Screw	M8x16	2	
212	WF081818	Washer	M8x18	2	
213	207210	Locate Plate		1	
214	207209	Plate		1	
215	207204	Nut		2	
216	SS050100	Setscrew	M5x5	2	
217	ST049200	Tap Screw	M4x8	2	
218	207851	Rotate Block		1	
219	207222	Fixed Block		1	
220	SS089300	Setscrew	M8*12	2	
4	200827	Knob	M8x1.25px40L	1	
5	SS069100	Setscrew	M6x6	2	
6	SR060500	Cap Screw	M6x25	1	
7	207221	Fixed Block		1	
8	207220	Plate		1	
9	SS081300	Setscrew	M8x65	1	
10	200069	Fiber Washer	10x18	3	
11	207218	Fixed Block		1	

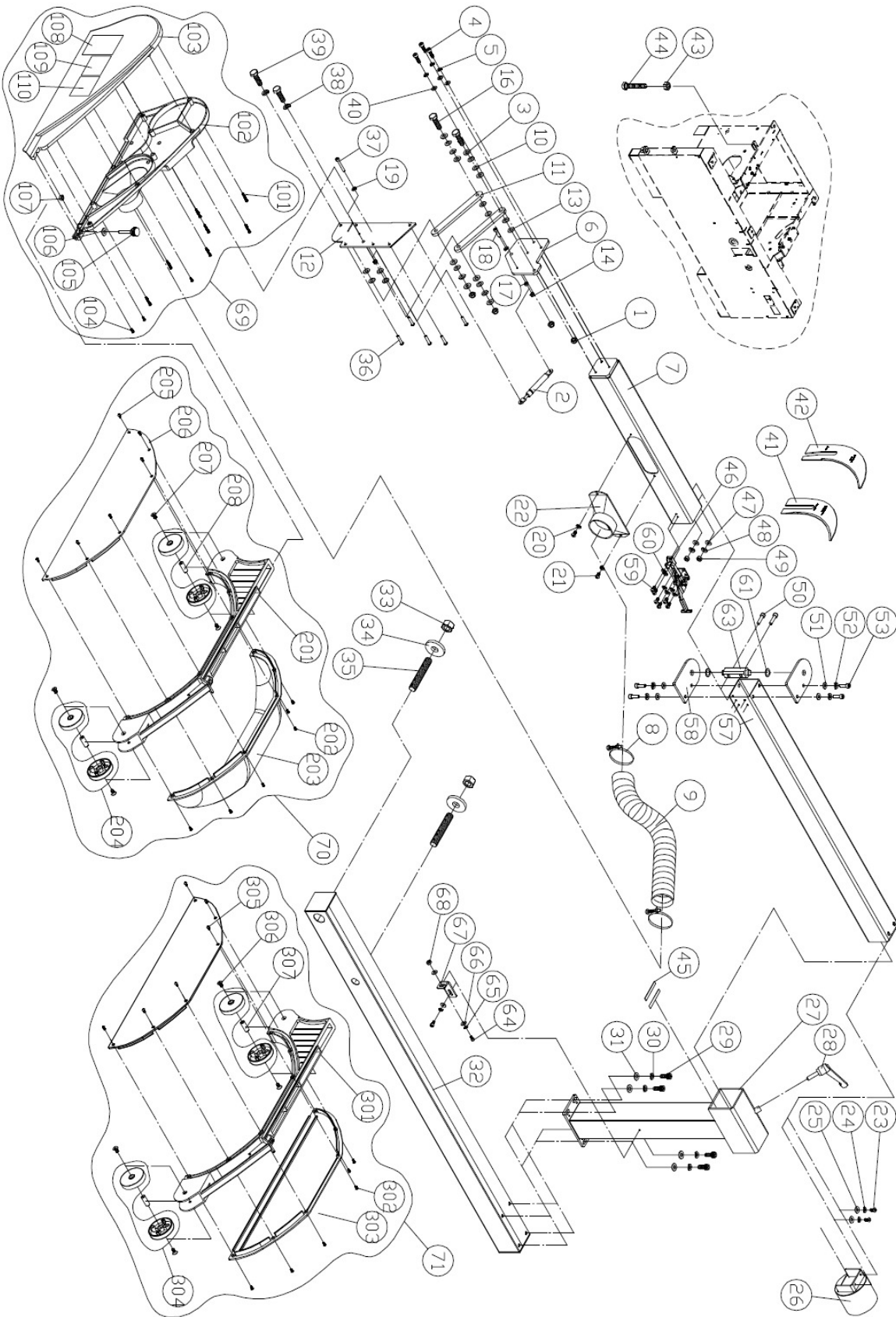
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	
12	SS089300	Setscrew	M8x12	2	
13	206633	Rotate Shaft		1	
14	207737	Fixed Block		1	
16	WF083030	Washer	M8x30	1	
17	203128	Handle		1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	AB206422	Rip Fence Housing Assembly		1	
101	SI069400	Counter Sunk Screw	M6x16	2	
102	206433	Fixed Plate		1	
103	203193	Shafts		2	
104	NL081000	Lock Nut	M8	2	
105	200875	Plate		1	
106	SH069400	Hex Head Bolt	M6x16	2	
107	203179	Eccentric Ring		2	
108	206422	Seat		1	
109	203213	Eccentric Shaft		1	
110	WF203630	Washer	ψ20xψ36	1	
111	994181	Steel Ball	ψ8	1	
112	150099	Spring		1	
113	SS100200	Set Screw	M10x10	1	
114	RS200000	Retaining Ring	S20	1	
115	WS080000	Lock Washer	M8	1	
116	BB620202	Ball Bearing	6202ZZ	1	
117	NA081300	Hex Nut	M8	1	
118	203356	Ring		1	
119	206435	Ring		1	
120	WF083030	Washer	M8xψ30	4	
121	SH080700	Hex Head Bolt	M8x35	1	
122	RS150000	Retaining Ring	S15	1	
123	203649	Ring		1	
124	203650	Shaft		1	
125	206428	Fixed Block		1	
126	NL101700	Lock Nut	M10	1	
127	200069	Washer	M10	2	
128	205114	Adjust Knob	M10x110	1	
129	SR060200	Cap Screw	M6x10	4	
130	205822	Scraper	ψ40	2	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	2375160M	Table	375x1600mm	1	
2	2375320M-1	Hander		1	T3
3	SJ060200	Hex Head Bolt	M6x10	3	
6	206581	Fixed Block		2	
7	SR080500	Cap Screw	M8x25	8	

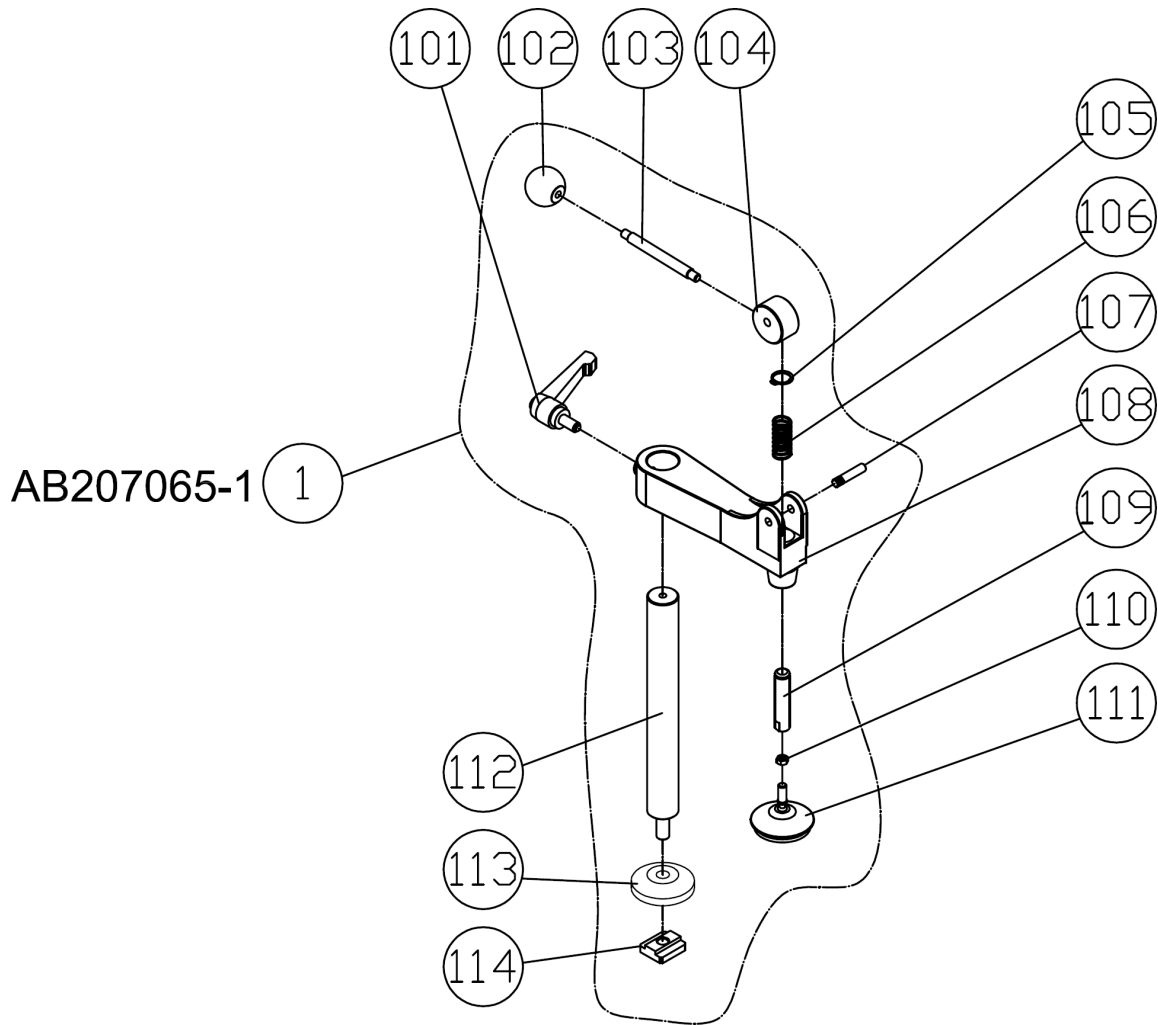




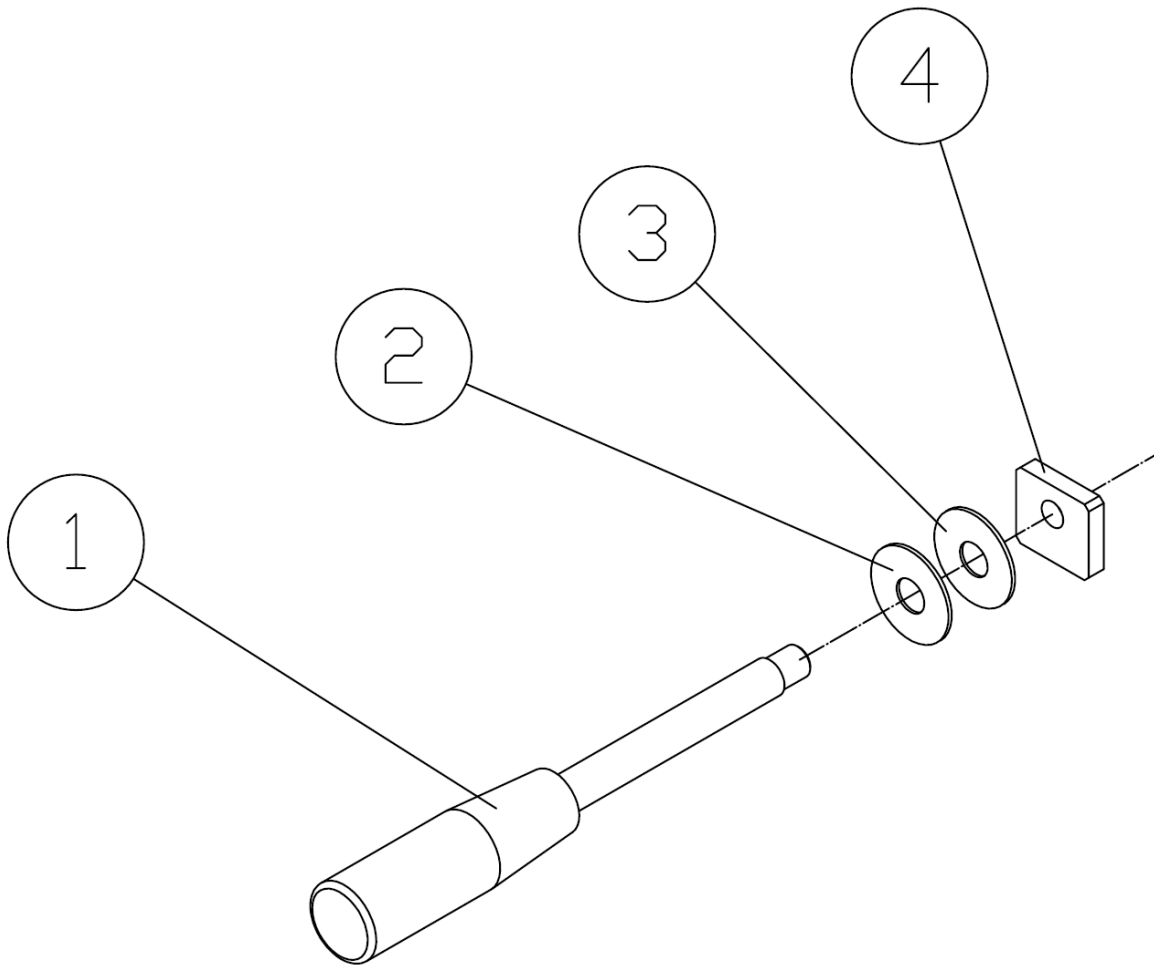
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	NL101700	Lock Nut	M10	4	
2	205004	Gas Expansion Cylinder		1	
3	WF102020	Washer	M10xψ20	8	
4	SR060400	Cap Screw	M6x20	3	
5	WS060000	Lock Washer	M6	3	
6	207987	Fixed Plate		1	
7	207970	Arm		1	
8	204158	Hose Clamp	3-1/4"	2	
9	HS330004	Hose	ψ3"x42cm	1	
10	204263	Washer	ψ10×ψ20	8	
11	207981	Link		2	
12	207985	Fixed Plate		1	
13	992609	Copper Washer	ψ20×ψ10×0.5t	8	
14	NL061000	Lock Nut	M6	2	
16	SH100700	Hex Head Bolt	M10x35	2	
17	NH061000	Hex Nut	M6	1	
18	SR060500	Cap Screw	M6x25	1	
19	WS060000	Lock Washer	M6	2	
20	WS060000	Lock Washer	M6	2	
21	SJ069300	Cap Screw	M6x12	2	
22	204061	Dust Port		1	
23	SJ069300	Cap Screw	M6x12	2	
24	WS060000	Lock Washer	M6	2	
25	WF061920	Washer	M6xψ19	2	
26	206390	Dust Port		1	
27	206388	Fixed Bracket		1	
28	201109	Fasten Handle	M10x35	1	
29	SR080500	Cap Screw	M8x25	4	
30	WS080000	Lock Washer	M8	4	
31	WF081818	Washer	M8x18	4	
32	206391	Fixed Bracket		1	
33	NH203000	Hex Nut	M20	2	
34	203338	Washer	ψ22xψ60xt8	2	
35	205116	Screw	M20x130	2	
36	SJ060600	Button Head Screw	M6x30	5	
37	SR060900	Cap Screw	M6x45	1	
38	WS100000	Lock Washer	M10	2	
39	SH100700	Hex Head Bolt	M10x35	2	
40	WF061920	Washer	M6xψ19	3	
41	205073	Plate	φ300~350	1	
42	205032	Plate	φ350~400	1	optional

ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
43	NH121900	Hex Nut	M12	1	
44	SH121400	Hex Head Bolt	M12X70	1	
45	201039	Pad		8	
46	205358	Elbow Type Clamp		1	
47	WF081818	Washer	M8x18	2	
48	WS080000	Lock Washer	M8	2	
49	NH081300	Hex Nut	M8	2	
50	SR080600	Cap Screw	M8x30	2	
51	WF081818	Washer	M8x18	4	
52	WS080000	Lock Washer	M8	4	
53	SR080500	Cap Screw	M8x25	4	
57	207971	Square Tube		1	
58	207973	Plate		2	
59	SJ060200	Cap Screw	M6x10	6	
60	WS060000	Lock Washer	M6	6	
61	992627	Copper Washer	ψ24xψ16x0.3t	2	
63	207975	Shaft		1	
64	SR060400	Cap Screw	M6*20	2	
65	WS060000	Lock Washer	M6	2	
66	WF061620	Washer	M6×ψ16	3	
67	207776	Fixed Plate		1	
68	NH061000	Hex Nut	M6	1	
69	AB207866	Rear Cover ASM		1	
101	ST030500	Tap Screw	M3.5x25	7	
102	207866	Rear Cover		1	
103	207865	Front Cover		1	
104	ST040200	Tap Screw	M4x10	3	
105	207882	Knob		1	
106	WF081818	Washer	M8x18	1	
107	NH081300	Hex Nut	M8	1	
108	LM207031	Warning Label		1	
109	LM207032	Warning Label		1	
110	LM207033	Warning Label		1	
70	AB205355	Protection Hood ASM		1	
201	207867	Guard		1	
202	SP040200	Pan Head Screw	M4x10	6	
203	205355	Protection Hood		1	
204	AB207868	Roller ASM		2	
205	SP040200	Pan Head Screw	M4x10	6	
206	205356	Protection Hood		1	
207	SI060200	Counter Sunk Screw	M6x10	4	

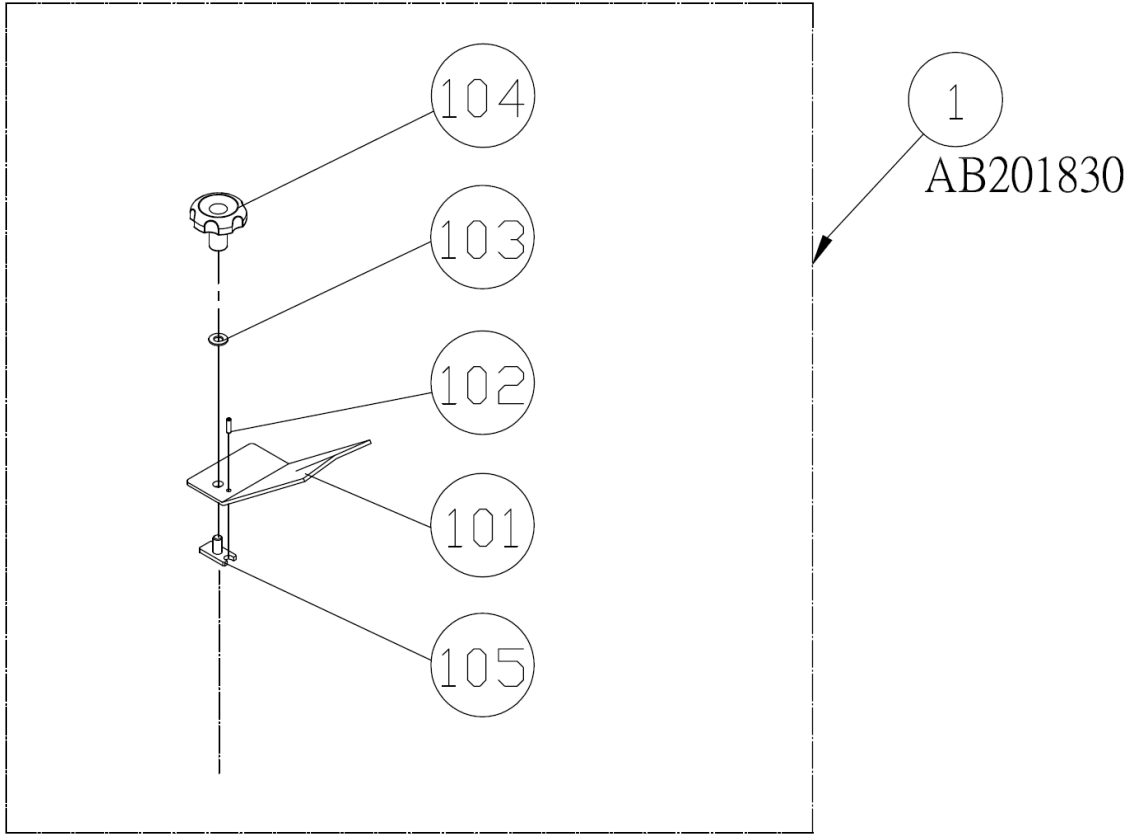
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
208	207883	Shaft		2	
71	AB205356	Protection Hood ASM		1	optional
301	207867	Guard		1	
302	SP040200	Pan Head Screw	M4x10	6	
303	205356	Protection Hood		2	
304	AB207868	Roller ASM		2	
305	SP040200	Pan Head Screw	M4x10	6	
306	SI060200	Counter Sunk Screw	M6x10	4	
307	207883	Shaft		2	



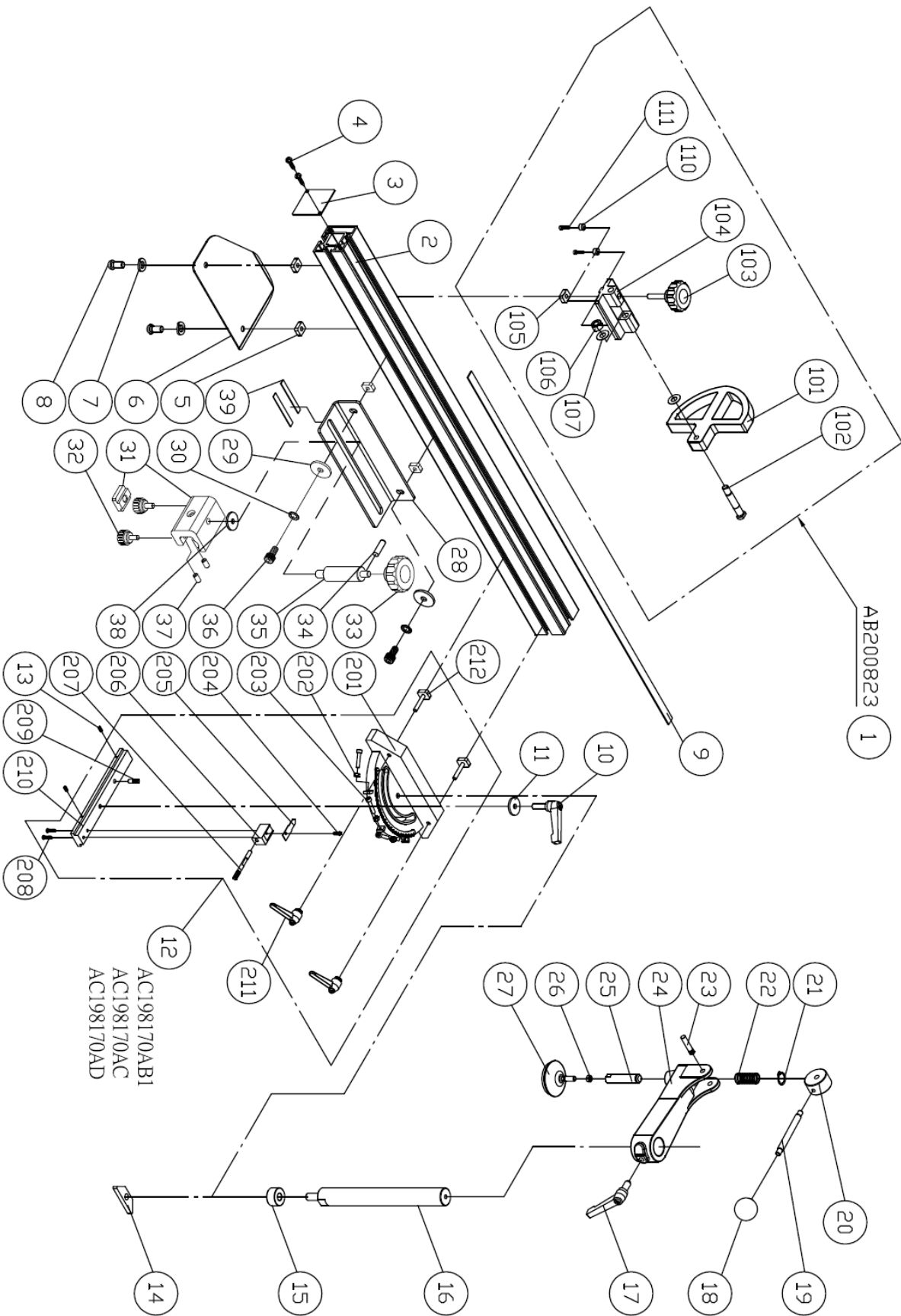
ITEM	PART NO	PARTS MA,E	SIZE	Q`TY	NOTE
1	AB207065-1	Down Press ASM		1	
101	207143	Adjust Handle		1	
102	100271	Ball Knob	M8×P1.25	1	
103	207070	Handle Bar		1	
104	207067	Cam		1	
105	RS140000	Ext. Retaining Ring	S14	1	
106	207069	Spring		1	
107	207145	Pin		1	
108	207065	Down Press		1	
109	207068	Shaft		1	
110	NH602300	Hex Nut	5/16	1	
111	200807	Large Washer		1	
112	205253	Shaft		1	
113	200809	Washer		1	
114	201855	T-Nut		1	S, B
	205830	Block		1	S, D



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	200939	Handle		1	
2	WF123030	Washer	M12x30	1	
3	992496	Plastic Washer	φ13xφ25	1	t=2
4	201849	T-Nut	M12x1.75p	1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	AB201830	Edge Shoe Plate Assembly		1	
101	201830	Edge Shoe Plate		1	
102	PS051800	Spint Pin	φ5xφ18	1	
103	WF102025	Washer	M10x25	1	
104	203718	Knob	M10	1	
105	201829	T-Nut	M10x1.5p	1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	AB200823	Flip Stop Assembly	No.101~111	1	
101	200823	Flip Stop		1	
102	200824	Rotation Shaft		1	
103	200827	Knob	M8x1.25px40L	1	
104	200826	Stop Bracket		1	
105	201103	T-Nut	M8x1.25p	1	
106	NL101700	Lock Nut	M10	1	
107	992610	Copper Washer	ψ11*ψ18*0.5t	2	
110	201170	Ring		2	
111	SR039400	Cup Screw	M3x12	2	
2	205758	Square Fence		1	
3	200830	Cover		1	
4	ST040200	Tap Screw	M4x10	2	
5	201103	T-Nut	M8x1.25p	4	
6	205715	Locate Plate		1	
7	WS080000	Lock Washer	M8	2	
8	SJ089400	Button Head Screw	M8x16	2	
9	LM200143	Rule	R 0~1000(MM/")	1	Standard
	LM200149	Rule	R 0~1000(MM)	1	Optional
10	200814	Fasten Handle		1	
11	WF083030	Flat Washer	M8×ψ30	1	
12	AC198170AB1	Miter Gauge Assembly	For B1,F type	1	Optional
	AC198170AC	Miter Gauge Assembly	For C type	1	Optional
	AC198170AD	Miter Gauge Assembly	For D type	1	Optional
201	198170A	Miter Gauge Body		1	
202	NH050800	Hex Nut	M5	3	
203	SR050500	Cap Screw	M5×25	3	
204	SP049300	Pan Head Bolt	M4×12	1	
205	201366	Pointer		1	
206	201365	Fixed Block		1	
207	201367	Stop Bar		1	
208	SP049400	Pan Head Bolt	M4×16	2	
209	198174	Shaft		1	
210	201364B1	Fixed Base	For B1,F type	1	Optional
	205721	Fixed Base	For C type	1	Optional
	205829	Fixed Base	For D type	1	Optional
211	017003	Adjust Handle		2	
212	207667	T-Bolt		2	
13	201632	Spring plungers with ball	M4×9	2	
14	207666	Locate Plate		1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
15	207668	Ring		1	
16	205253	Shaft		1	
17	207143	Adjust Handle		1	
18	100271	Ball Knob	M8×P1.25	1	
19	207070	Handle Bar		1	
20	207067	Cam		1	
21	RS140000	Ext. Retaining Ring	S14	1	
22	207069	Spring		1	
23	207145	Pin		1	
24	207065	Down Press		1	
25	207068	Shaft		1	
26	NH602300	Hex Nut	5/16	1	
27	200807	Large Washer		1	
28	205810	Locate Plate		1	Optional-D
	205811	Locate Plate		1	Optional-E
29	WF083030	Washer	M8X30	2	
30	WS080000	Lock Washer	M8	2	
31	205760	Block		1	Optional-D
	201855	T-Nut		1	Optional-E
32	203720	Knob	M8×16	2	Optional-D
33	100203	Lock Knob	M10	1	
34	PP052000	Pin	ψ5×20	1	
35	205757	Shaft		1	
36	SR089400	Cap Screw	M8×20	2	
37	203286	Set Screw	M8×16	2	Optional-D
38	WF123025	Washer	M12X30X2.5t	1	Optional-D
39	201039	Pad		2	Optional-E

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