



Stallion 14" XS Series Band Saw



Operations Manual

For your safety, please read this manual carefully before operation

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SPECIFICATION

Item	CWI-B1413-XS	CWI-B1413-RXS
Power	110V,1Ph,60Hz,3	220V, 1PH, 60Hz,2
Motor	/4/HP,1700rpm	.0HP, 1700rpm
Blade Length	117inch	
Blade Width	3/16-1 inch	
Blade Speed	50 ft/s	
Throat Capacity	13.6 inch	
Max Cutting height	13 inch	
Table Size	21x17 inch	
Table Tilt	0°~45°	
Dust outlet	4/2.48 inch	
N.W./G.W.	148/172Kg	
Packing Size	26.7x20.4x75.45inch	
Noise(unloading)	76dB	

NOTE: The above specifications and the constructions were current at the time this manual was published, but because of our policy of continuous improvement, we reserve the right to change specifications and the constructions without notice and without incurring obligations.

Fig A



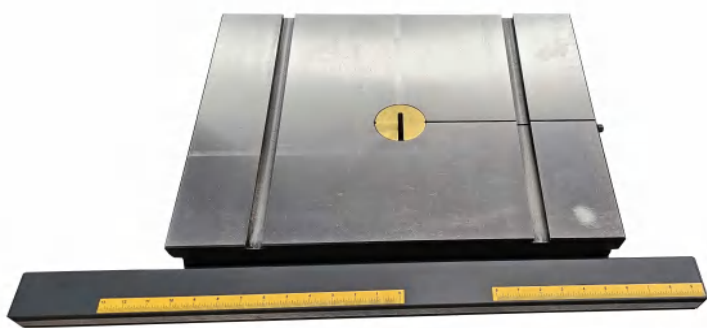
Push Stick, Push Stick Fixing Bolt and Mitre Fence

Fig B



Tools

Fig C



Cast Iron Table with Fence Rail and Extension Table

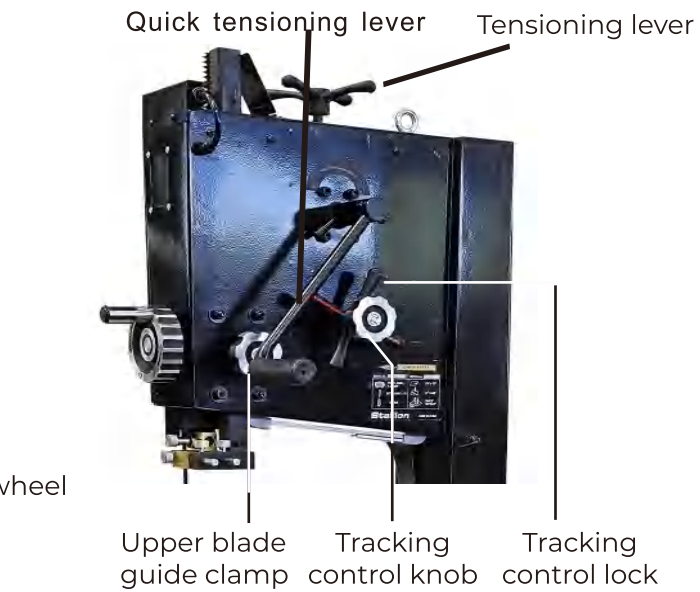
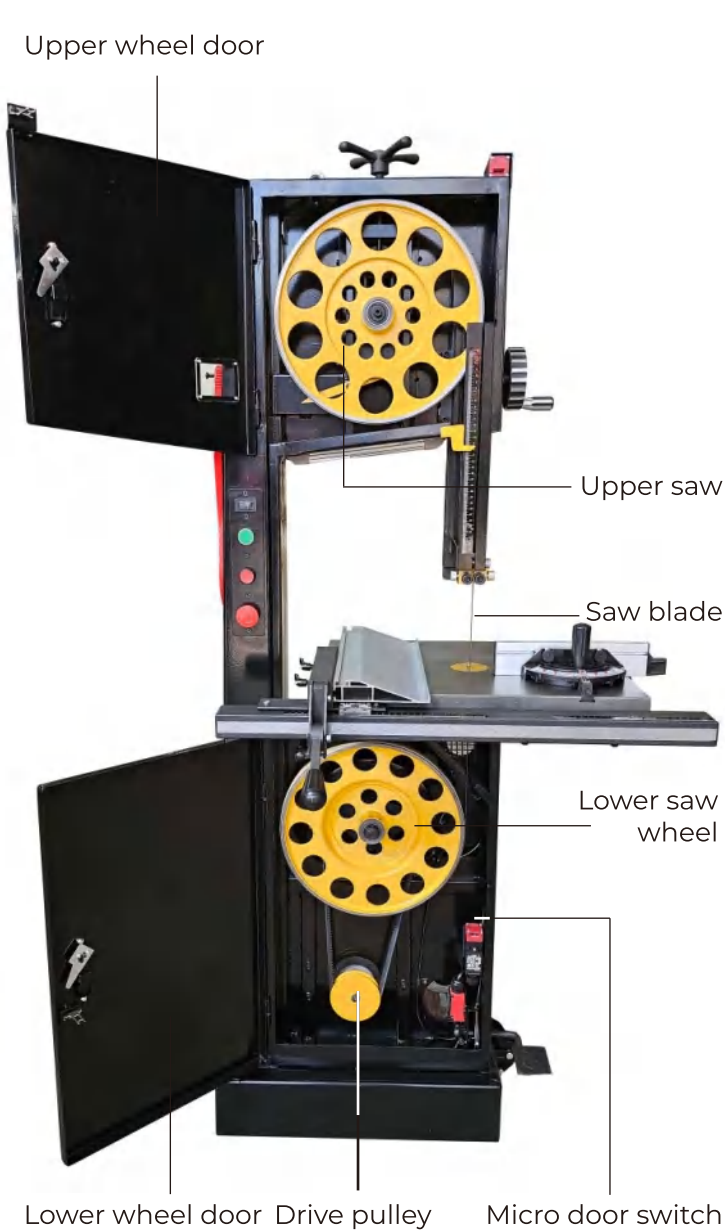
Fig D



Fence and Fence Lock Assembly

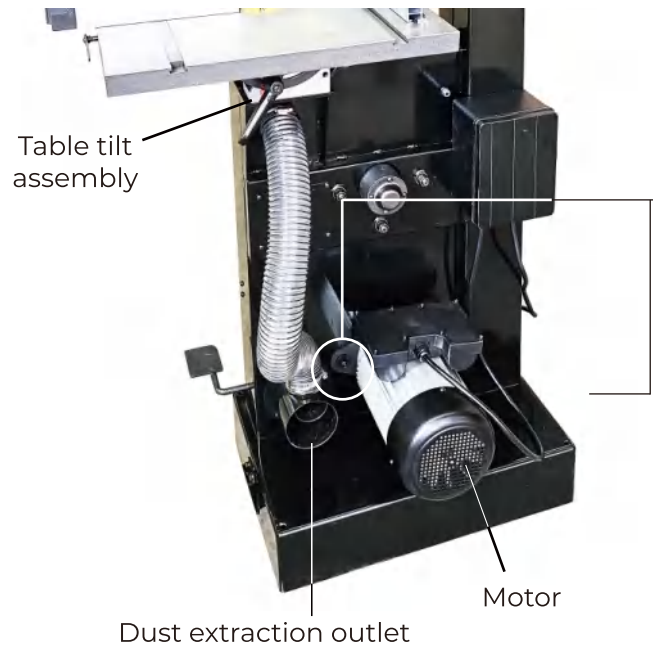
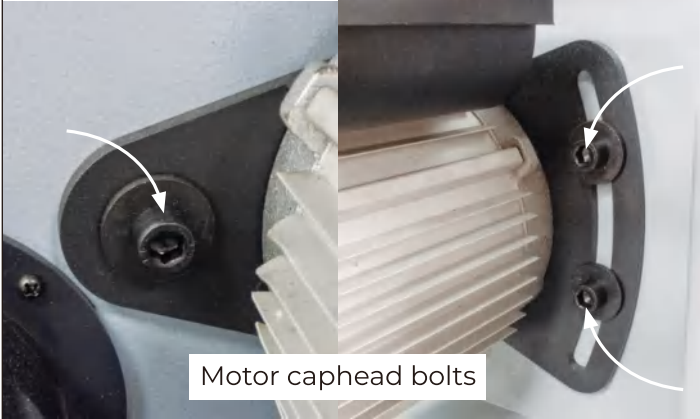
ANATOMY





Tension the Drive Belt

Loosen the three caphead bolts holding the motor, pivot the motor to increase or to decrease tension on the drive belt. **Note: Check the tension on the belt, there should be a 1/2 inch depression.**



SAFETY

The following is a list of safety precautions you must consider when using a bandsaw:



ALWAYS REMEMBER TO DISCONNECT THE POWER TO THE BANDSAW WHEN MAKING REPAIRS OR ADJUSTING BLADES AND GUARDS.



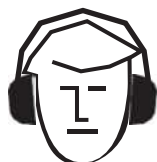
ALWAYS REMEMBER TO READ THROUGH THE MACHINE INSTRUCTIONS SUPPLIED.

- Eye and ear protection are required when operating a Bandsaw. Dust extraction and respiratory PPE are highly recommended.
 - Do not wear gloves, loose clothing, jewellery, or any dangling objects when operating a bandsaw.
- Do not allow children to operate the machine.
- All guards must be in place and fully operational. If a guard seems to be missing or damaged, adjust, replace or repair immediately.
- Disconnect the power to the bandsaw when making repairs or adjusting blades and guards.
- Remember to check the blade tension after a new blade has been 'working' for 30-60 minutes. The blade may 'stretch' slightly from new and the tension becomes slack.
- Hands and fingers must be kept clear of the blade, always use push blocks and push sticks when feeding small pieces into the blade.
- Use only the recommended blade size and type for the machine- see page 17-18 for recommendations.
- Ensure all blades are sharp and in good condition.
- The blade guard/guide set must be lowered to approximately $\frac{3}{4}$ " (20mm) above the workpiece.
- Check that the blade is tensioned and tracked correctly before turning the machine on.
- Never cut pieces smaller than the table insert size.
- Do not attempt to cross cut round timber free hand. Clamp to mitre fence or make a jig to keep the work piece stable.
- Long material should be supported at the same height as the saw table.
- To avoid contact with a coasting blade, do not reach into the cutting area until the blade comes to a full stop.
- Make sure the blade is not in contact with the material when you start the saw.
- Never leave the machine unattended when it is running.
- Keep the table top and surrounding work area free from excessive dust and debris to help prevent slipping or tripping.
- Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts.
- Do not overreach or use excessive force to perform any machine operation.

The symbols below advise the correct safety procedures when using this machine.



Fully read manual and safety instructions before use



Ear protection should be worn



Two Man Assembly



Eye protection should be worn



Dust mask should be worn



HAZARD

Aligning the fence to the blade

1. Ensure that the table aligning instruction has been followed on page 13 of the manual.

2. Place the fence on the machine & slide it over to the mitre fence slot. **FIG. 2**



FIG. 2



FIG. 3

3. To align the fence to the blade/mitre fence slot, the fence base has been fitted with 2 grub screws that can be located here. **FIG. 3-4**

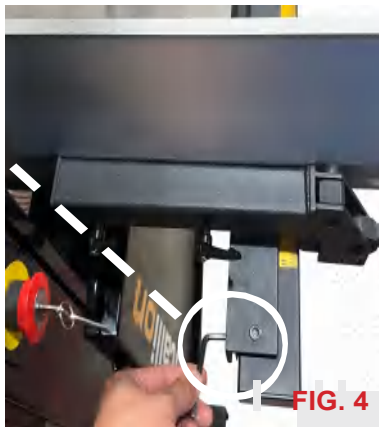


FIG. 4

4. Slide the fence over to the mitre fence slot and check for alignment, if the fence seems out of line to the slot, then adjustments can be made by winding either grub screw in or out. **FIG. 5**



FIG. 5



FIG. 1

Squaring the fence to the table

5. Ensure that the "squaring the table to the blade" instruction has been followed on page 16 of the manual."

Place the fence on the machine & slide it over then lock it off around 100 – 150mm from the blade, check for square with the fence in its high position. **FIG. 1**



FIG. 5

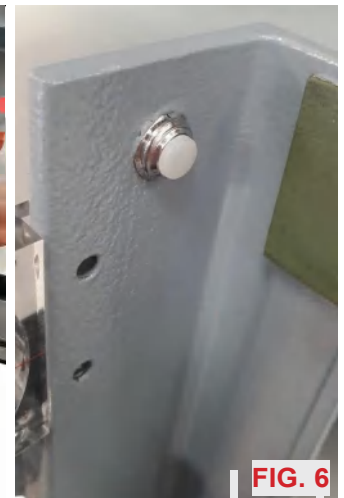


FIG. 6

6. If the fence seems out of square to the table, then adjustment can be made by firstly unlocking the fence then winding the 2 nylon grub screws in or out. Adjust, relock then recheck for square, adjust again if needed.

FIGS. 5 & 6



THE BANDSAW IS A HEAVY PIECE OF EQUIPMENT, IT IS ADVISABLE TO GET ASSISTANCE.



TWO MAN ASSEMBLY REQUIRED.

1. Line-up the holes to the underside of the cast iron table with the ones in the trunnions and secure in place with four button head Hex bolts/ washers, (fig 10-13).

Fig 10-13



- Loosen the lock lever.

- To tilt the table to the right (from the front or operator's side), turn the tilt handle clockwise and lift the table by hand, up to a maximum of 45°

- To tilt the table to the left, first loosen the lock lever . Slightly turn the tilt handle clockwise to release pressure from the 90° stop. Move the stop plate aside. Then turn the handle counterclockwise and lift the table by hand, up to a maximum of 15°. The exposed hole in the saw body allows the stop bolt to drop through, preserving the 90° setting.

- Tighten the lock lever to secure the position.

- The lock lever can be repositioned for easier access. Pull it straight out, rotate to the desired angle, and release to re-engage the pin.

3. Locate the table insert and place it into the centre of the table, (fig 14).

Fig 14



4. Find the fence locking assembly and slide it into position on the fence rail as shown, (fig 15).

Fig 15



ASSEMBLY

5. Loosen the two lift and shift handles on the fence locking assembly. Line-up the 'T' slot to the base of the fence and slide it over the mounting plate to the desired position. Nip-up the lift and shift handles to secure the fence, (fig 16-17).

Fig 16



Fig 17

6. Locate the Rise and Full handle wheel, loosen the two grub screws around the mounting boss. Line up the grubs crews with the machined flats on the drive shaft and slide the unit on. Nip-up the screws to secure in place, (fig 18-19).

Fig 18



Fig 19



7. Find the threaded hole to the side of the bandsaws column. Locate the push stick holding screw and screw it into the column, hook the pushstick over the screw, (fig 20-21).

Fig 20-21



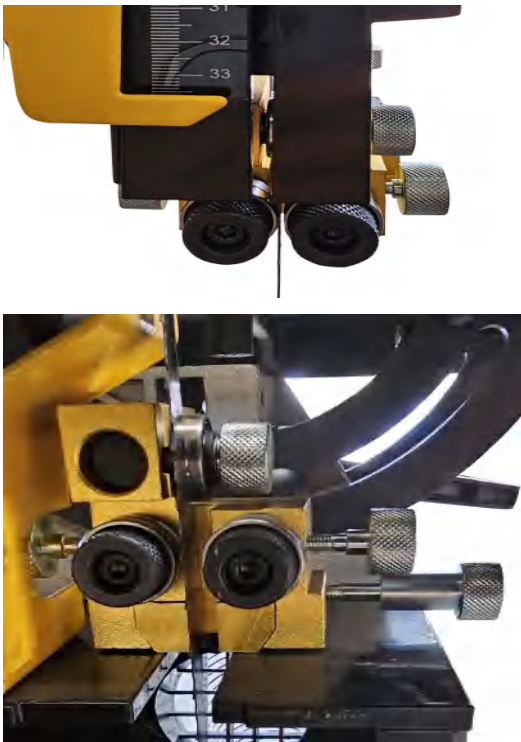
Blade Tension



DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

Ensure that all guide bearings are well clear of the blade!, (fig 22-23).

Fig 23-23



Position the tension lever down in full tension position, (see fig 24).

Fig 24



- Before altering blade tension ensure that the blade is roughly positioned in the middle of the wheel, you will need to lower the top wheel slightly by using the tension lever to do this, (fig 25).
- Turn the blade tension knob clockwise to tension the blade whilst rotating the top wheel slowly at first by hand. A gauge at the front of the upper wheel shows either tension on or tension off, (fig 26).
- The best place to check blade tension is on the left hand side of the bandsaw. Around 1cm of blade movement is recommended, (fig 27).
- Changes in blade width will have an effect on blade tension. Keep in mind that too little blade tension can cause blade breakage.
- After a period of use it is recommended to recheck the blade tension and possibly readjust as bandsaw blades can stretch slightly in use.

TIP: If the bandsaw is to sit idle for a period of time, place the tension lever in partial tension position; this will help prevent blade fatigue and tyre deformation, and save wear on bearings and band wheels.

Fig 25



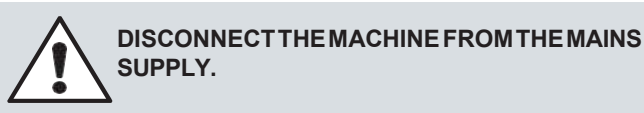
Fig 26



Fig 27



Blade Tracking

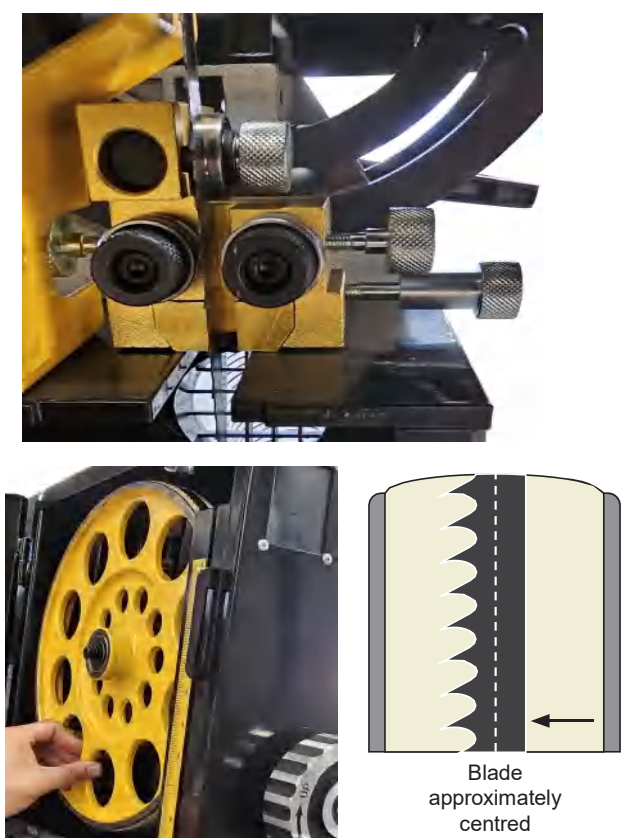


- Do not adjust blade tracking with the machine running. “Tracking” refers to how the blade is positioned on the wheels whilst running.
- The blade should track approximately in the centre of both wheels, as shown in (fig 28) Tracking on the Bandsaw should be checked periodically, included as part of every blade change.
- The blade must be properly tensioned before adjusting blade tracking. Make sure blade guides bearings are opened up, backed off and are well clear of the blade, (fig 29)
- Open the upper door and rotate the upper wheel slowly at first clockwise by hand. Observe the position of the blade on the wheel - it should be in the centre, (fig 30-31).

Fig 28



Fig 29-30-31



- If the blade tends to shift to one side or the other of the wheel, slight adjustment will need to be made, start by loosening the locking knob, (fig 32).
- If the blade is tracking toward the front edge of the wheel, rotate the tracking knob clockwise – the upper wheel will tilt toward the back and the blade will move to the centre of the wheel. If the blade is tracking toward the back edge of the wheel, rotate the tracking knob counterclockwise: the upper wheel will tilt toward the front and the blade will move toward the centre of the wheel, (fig 33).

Fig 32

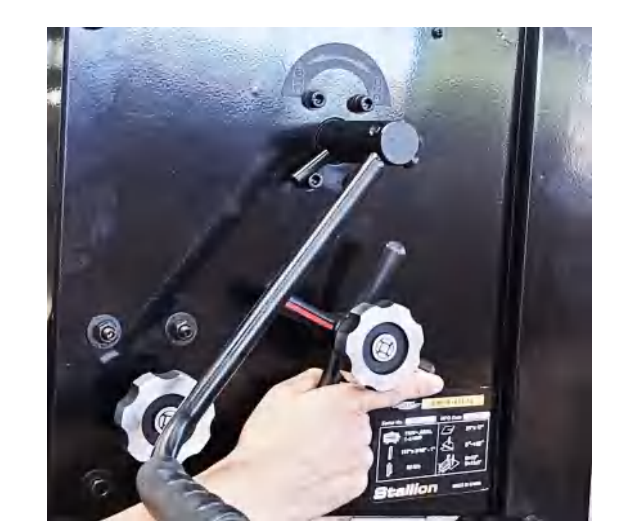


Fig 33



• **IMPORTANT:** This adjustment is sensitive; perform it in small increments and give the blade time to react to the changes, as you continue to rotate the wheel.

• When the blade is tracking properly at the centre of the wheel, re-tighten the locking knob, (fig 34).

• Turn on the saw and verify proper tracking while the machine is running.

• If further tracking adjustments are needed, disconnect from power, and repeat instructions above.

Fig 34



Setting Upper and Lower Blade Guides

Both top and bottom bearing blade guides will be set in exactly the same position.

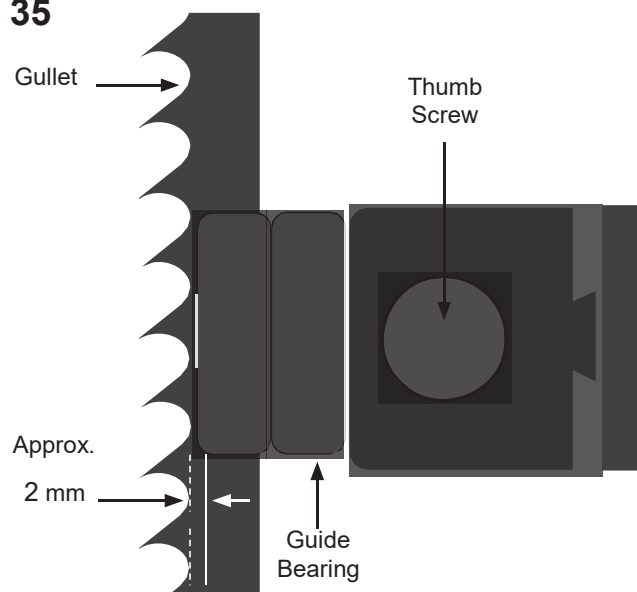


DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

• Blade must be tensioned and tracked properly.

• Loosen thumb screw and move guide block by turning the knob so that the front face of the guide bearings are approximately 2mm behind the gullet (curved area at base of tooth) of the blade, tighten thumb screw, (fig 35).

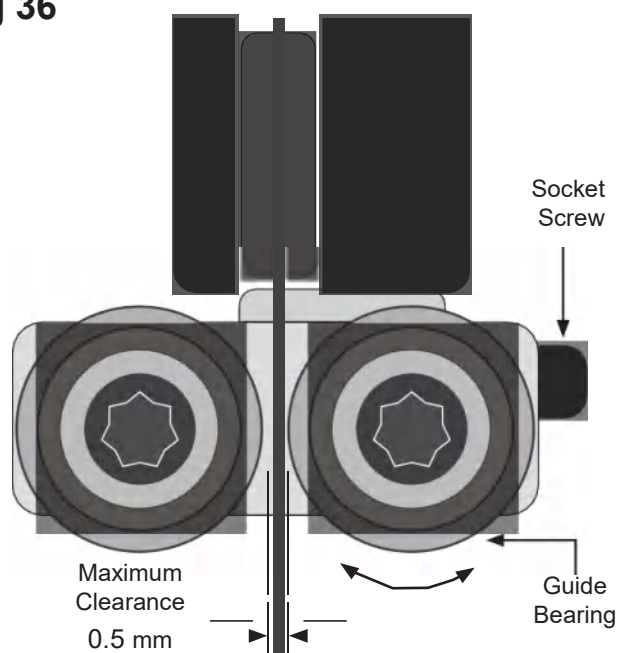
Fig 35



• Loosen the socket screw and position each guide bearing so that it is no more than 0.5mm away from the blade, very close but not quite touching the blade. A quick way to set this distance is to use a piece of breakfast cereal packet cardboard between the blade and bearing, which is approximately 0.3mm thick, (fig 36).

• Tighten socket screw when adjustment is satisfactory.

Fig 36



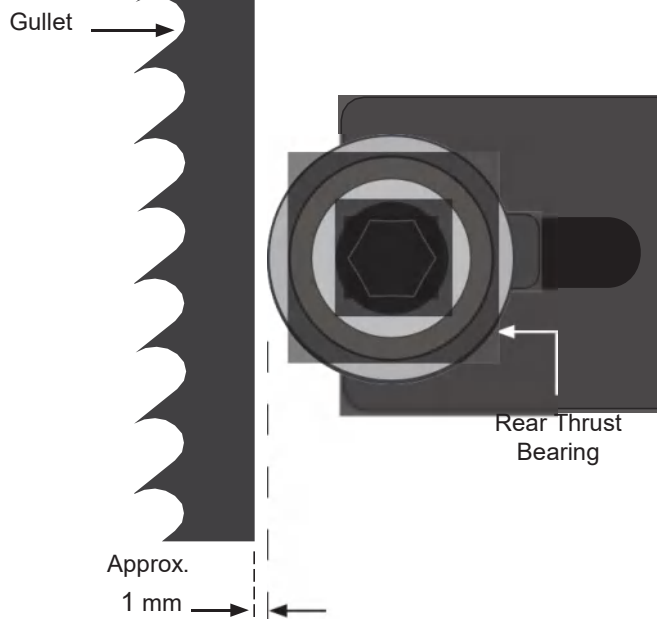
Thrust Bearing, Upper and Lower

The thrust bearing supports the back edge of the blade during operation, and is set so that the blade will contact it only when the blade is under pressure during a cut.

SET UP

- Loosen thumb screw and turn knob to move the thrust bearing in or out until the bearing is approximately 1mm behind the blade, tighten thumb screw, (fig 37).

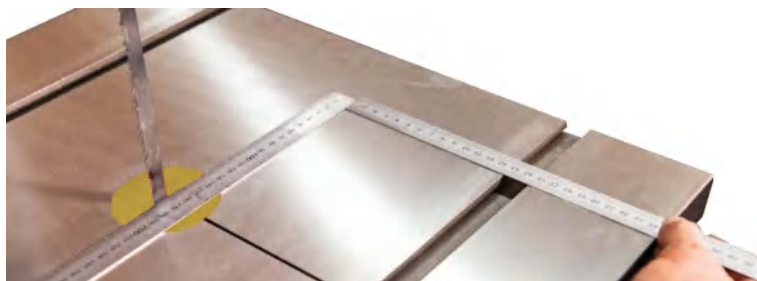
Fig 37



Aligning the Table to the Blade

- Place a straight edge along the side of the blade ($\frac{1}{2}$ " width blade or wider), with very light pressure (do not deflect the blade). The straightedge should contact both the front and back of the blade but sit between the teeth, (fig 38).
- Measure carefully with a fine rule from the straightedge to the edge of the mitre slot, do this at the front and back of the table; the distance should be the same, (fig 39).

Fig 38-39



- If the mitre slot is not aligned with the blade, slightly loosen the four screws holding the trunnions to the table, (fig 40).
- Nudge the table as needed, until the mitre slot is aligned with blade (distances are the same front to back), (fig 41).
- Tighten trunnion screws. (**NOTE: After this adjustment, the alignment of fence to blade may need to be re-checked. See "Aligning Fence to Blade" section**)

Fig 40-41



Squaring the Table to the Blade



DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

- Loosen table locking knobs and tilt table to the left (down flat) until it rests against the table stop screw (fig 42).
- Use a square placed on the table and against the left hand side of the blade (fig 43) verify that the table is 90 degrees to the blade. Make sure the table insert is level with the table surface or removed to ensure an accurate reading.
- If an adjustment is necessary, tilt the table and tighten the table locking knobs.
- Loosen the lock nut and turn the table stop screw left or right to raise or lower the stop, raising or lowering the table height when in the down position, tighten lock nut down against the trunnion/table to hold table stop screw in place, (fig 44).
- Unlock the table and tilt it back on to the table stop screw to confirm the table is 90 degrees to the blade. Repeat this process as necessary until the table is at 90 degrees to the blade.
- Adjust the pointer indicates zero, (fig 45).

Fig 42-43-44-45



Aligning the Fence to the Blade

- Line up the fence with the edge of the tables mitre fence slot and press down the locking handle, (fig 46).
- Adjust the fence until its in alignment with the mitre fence slot, retighten the Hexscrews, (fig 48).

Fig 46-47-48



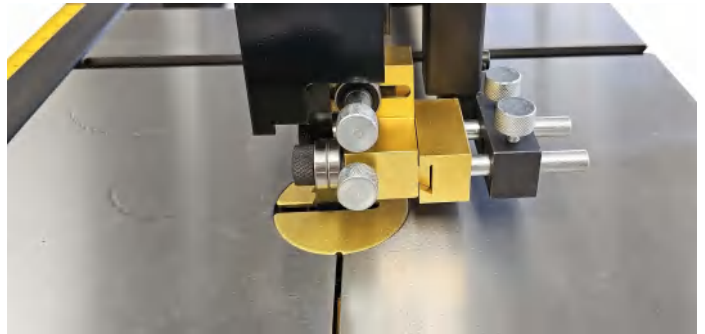
General use / operation

The following section contains basic information, and is not intended to cover all possible applications or techniques using the Bandsaw. Consult published sources of information, acquire formal training, and/or talk to experienced Bandsaw users to gain understanding and knowledge of bandsaw operations.

Firstly ensure that you have the right blade fitted for the intended cut - see the blade selection guide on pages 17-18.

- Make sure the blade is adjusted correctly tensioned and tracking, and that upper and lower guide bearings and thrust bearings are set in proper relation to the blade. Adjust guide post so that the guide bearings are just above the workpiece, about $\frac{3}{4}$ " (20mm) allowing minimum exposure to the blade but maximum support during the cut,(fig 59).
- If using the fence, move it into position and lock it to the fence rail. If you are using the mitre gauge for a crosscut, the rip fence would usually be moved safely out of the way, (fig 60-61).

Fig 59-60-61



GENERAL USE / OPERATION

- Turn on the bandsaw and allow a few seconds for the machine to reach fullspeed.
- Whenever possible, use a push stick, hold-down, jig, or similar device while feeding timber, to prevent your hands getting too close to the blade, (fig 62-63).

Fig 62-63



- Place the straightest edge of the workpiece against the fence for a rip cut; or against the mitre gauge for a crosscut. Push the workpiece slowly into the blade, while also keeping it pressed against the fence or held against the mitre gauge. Do not force the workpiece into the blade, always feed through at a slow and steady pace, (fig 64-65).

Fig 64-65



Tips:

- Make relief cuts whenever possible. A relief cut is an extra cut made through the waste portion of a workpiece up to the layout line. When that intersection is reached by the blade while following the layout line, the waste portion comes free. This helps prevent pinching of the back edge of the blade in the cut, (fig 66).
- When cutting, do not overfeed the blade; overfeeding will reduce blade life, and may cause the blade to break.
- Stand at the corner of the machine when making rip or re-saw cuts using the rip fence, this will help ensure that the timber stays in contact with the fence for the full cut, (fig 67).
- When cutting long timber, the operator should use roller stands, support tables, or an assistant to help stabilise the workpiece, (fig 68).

Fig 66

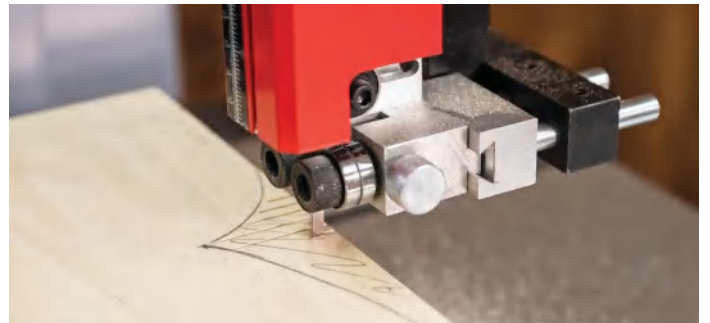


Fig 67

Fig 68



GENERAL USE / OPERATION

- Turn on the bandsaw and allow a few seconds for the machine to reach fullspeed.
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Fig 66

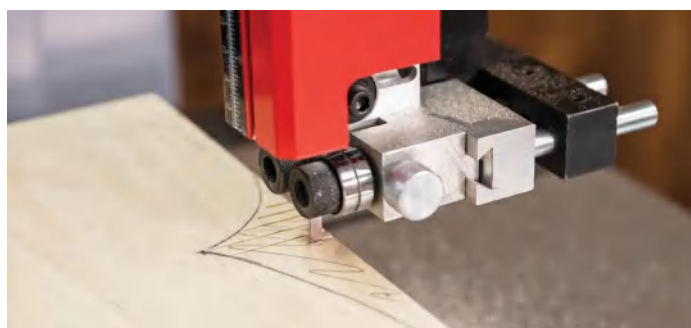


Fig 67

Fig 68



Ripping cuts

Ripping is cutting lengthwise down the workpiece, and with the grain. Always use a push stick or similar safety device when ripping narrow pieces. Rip cuts can also be made “freehand” following a pencil line but you will find far more accurate results if a fence is used, (fig 69).

Fig 69



Resawing

- Resawing is the process of slicing timber to reduce its thickness, or to produce boards that are thinner than the original timber, such as veneers and book matching. The ideal blade for resawing is the widest one the machine can handle, as the wider the blade the better it can hold a straight line, a fairly coarse tooth (3-4 TPI) is recommended for this cut, (fig 70).

- Resawing is always performed using the rip fence, use a push stick and often a feather board to ensure straight safe cuts. Keeping your hands away from the blade, (fig 71).

Fig 70-71



Crosscutting

- Crosscutting is cutting across the grain of the timber, usually whilst using the mitre gauge to feed the timber into the blade. The right hand should hold the workpiece steady against the mitre gauge, while the left hand pushes the mitre gauge past the blade. Cross cuts can also be made “freehand” following a pencil line but you will find far more accurate results if a mitre fence is used (fig 72).

Fig 72



Freehand Curve Cutting

- Curve cutting is something all bandsaws do very well in both shallow and deep timber with the correct blade installed. An ideal curve cutting blade is a $\frac{1}{4}$ " x 6 TPI - the narrower the blade the tighter curve it can cut.

- No fences are used making these cuts and usually no push sticks either so it is very important to ensure that your hands remain as far away from the blade as possible. If the timber is too small or the curve too tight then the cut is better made on a Scroll saw, (fig 73).

Fig 73





DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

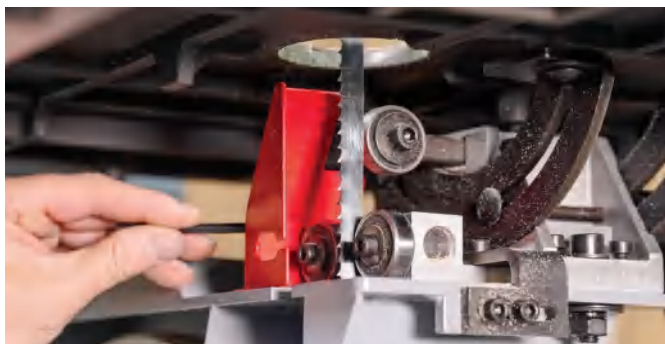
Removing Blade

- Open the doors
- Adjust the upper blade guide set so that it is around half way down, (fig 74).
- Remove the lower blade guards and open up/back off all blade guides so that they are clear of the blade, (fig 75-76).

Fig 74



Fig 75-76



- Remove the table insert, table alignment pin and wooden plate, (fig 77-78).
- Use the tension lever to de-tension the blade, (fig 79).

Fig 77-78



Fig 79



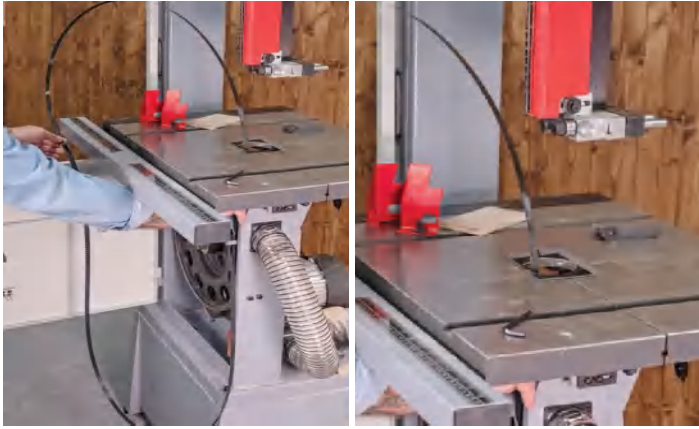
- Slide the blade forward clear of both wheels and through the right hand guard slot (fig 80). Bring the left hand side of the blade through the slot and around towards the right hand side of the machine then guide the blade through the table slot, (fig 81-82).

Fig 80



BLADE CHANGE

Fig 81-82



- Clean crud from the tyres and remove any small off cuts that may be around the bottom blade guide set, (fig 83-84).

- Use the blade selection guide on pages 17-18 to ensure that you have the right blade for the job!

Fig 83-84



Fitting the new Blade

- Slide the new blade through the table slot taking care not to twist or distort the blade, then guide the left hand side of the blade around toward the machine and through the slot at the spine of the machine, (fig 85-86-87).

Fig 85



Fig 86

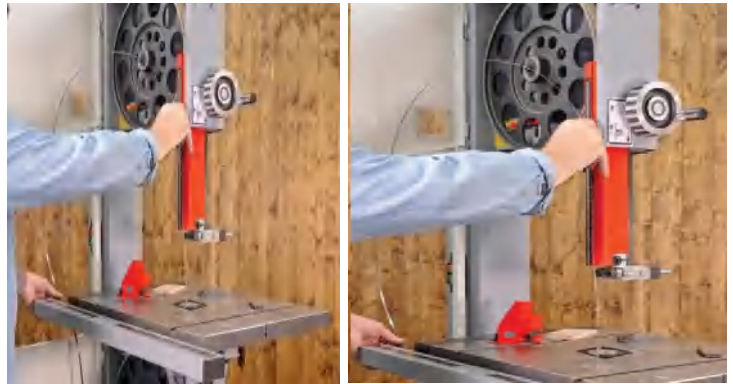
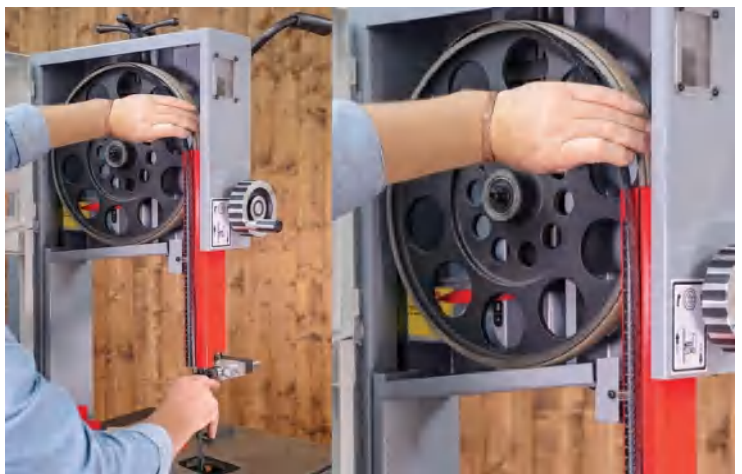


Fig 87



- Guide the blade through the upper blade guard and both the top and bottom blade guides positioning the blade approximately in the middle of firstly the top and then the bottom of the wheel, (fig 88).

Fig 88



- Apply blade tension using the tension lever then fine tune using the tension / tracking guide on pages 08-09-10.

- Reattached the table insert, the table alignment pin and wooden plate then close the doors.

Bandsaws are relatively simple machines and with all machinery regular servicing (preventative maintenance) is essential to get the best from your saw.

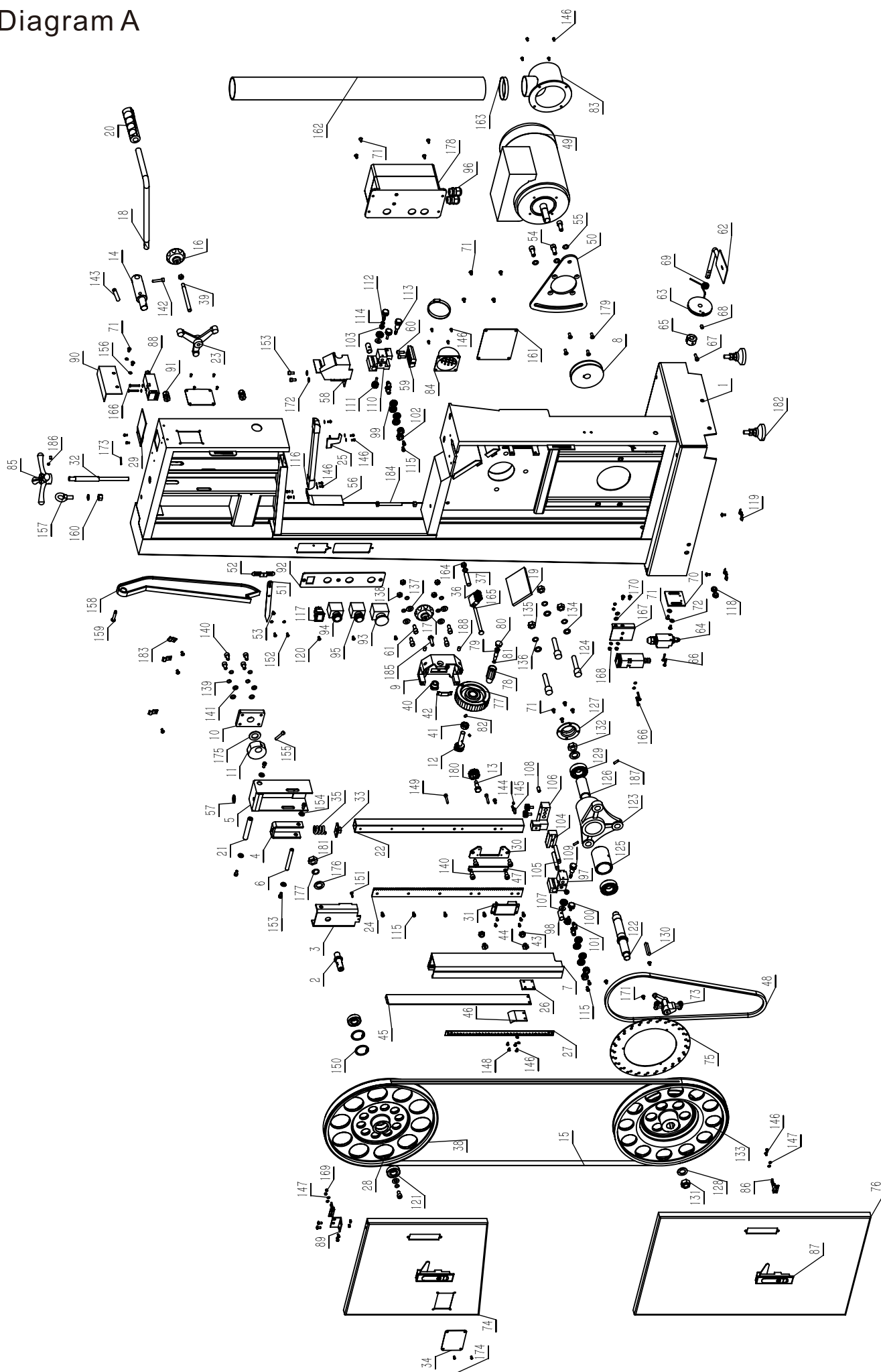
	‘My bandsaw won’t cut straight’		“My bandsaw slows down when cutting”
●	This is the most common question that you will get from bandsaw users. Usually the answer lies within the blade; poor quality blades with uneven set, the blade is blunt or damaged often only on one side, the tooth count is far too high for the material being cut -remember 2 teeth minimum and 10 teeth maximum in the work piece.	●	Check drive belt is tensioned correctly, see page 5.
●	The fence is out of line with the blade.	●	If cutting hard or wet material, slow your feed rate down.
●	Increase blade tension	●	Check blade is sharp and not too fine.
●		●	Make sure that when curve cutting a narrow blade is used- pages 17-18 blade and cutter types.
	“My bandsaw vibrates”		“Can I cut steel on my bandsaw?”
●	Clean machine wheels.	●	No , most woodcutting bandsaws run far too fast to cut steel, even if a metal cutting blade is fitted.
●	Check blade is running correctly on wheels.		
●	Check blade weld – is it in line?		
●	Check machine is not on an uneven floor.		
			“Getting blade breakage?”
		●	Blade tension too slack.
		●	Blade guides misaligned.
		●	Feeding timber too quickly.

MAINTENANCE

Daily -	
●	Keep the machine clean. Use extraction.
●	Check blade condition keeping a close eye out for missing teeth and small fatigue cracks.
Weekly -	Carry out the above checks, plus
●	Open the top and bottom wheel covers and clean out all saw dust.
●	Add in wax cast iron tables.
●	Clean impacted ‘crud’ from the tyres, NOTE: Do not use solvents around tires. If signs of wear or deformation occur, replace the tires.
Monthly -	Carry out the above checks, plus
●	Check drive belt condition and tension.
●	Ensure that all guide bearings are moving freely.
●	Check fence for alignment and squareness to blade.

21

Diagram A



Parts list (Diagram A)

No.	Description
A-1	Saw Body
A-2	Upper Wheel Shaft
A-3	Upper Wheel Axis Seat
A-4	U-Bracke
A-5	Guide Plate
A-6	Shaft
A-7	Blade Guard
A-8	Motor Pulley
A-9	Upper Guide Moun
A-10	Eccentric Base
A-11	Eccentric Shaft
A-12	Worm
A-13	Gear Shaft
A-14	Shaft
A-15	Saw blade
A-16	Adjusting Knob
A-17	Lock Knob
A-18	Tension Handle
A-19	Wood Inser
A-20	Tension Handle sleeve
A-21	Shaft
A-22	Upper Guide Square Tube
A-23	Handle
A-24	Upper Guide Rack
A-25	Guide Pointer
A-26	Plate
A-27	Cutting Height Scale
A-28	Upper Wheel
A-29	Hinge Plate
A-30	Plate for Gear Box
A-31	Gear Box Cover
A-32	Blade Tension Shaft
A-33	Connector Nut
A-34	Sight Glass
A-35	Spring
A-36	Brush
A-37	Spacer Bushing
A-38	Tire
A-39	Lock Handle
A-40	Thread Tube
A-41	Collar
A-42	Upper Guide Insert
A-43	Washer A
A-44	Washer B
A-45	Plate
A-46	Spring Plate
A-47	Cover A
A-48	Motor Belt
A-49	Motor

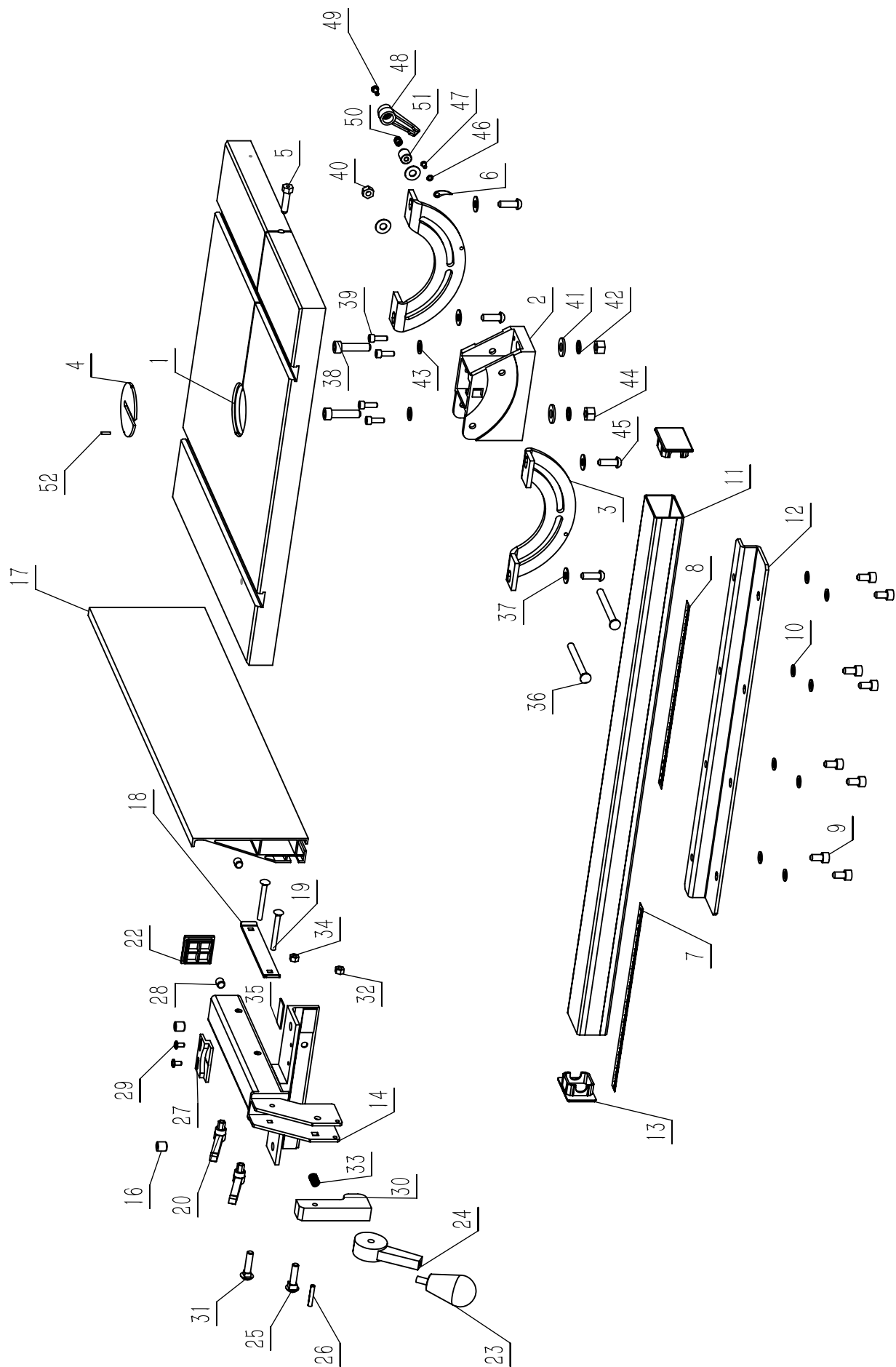
No.	Description
A-50	Motor Plate
A-51	Tension Pointer
A-52	Tension Indicator Plate
A-53	Slotted Head Screw
A-54	Socket Head Cap Screw M10x30
A-55	Flat Washer 10mm
A-56	Protective Bending Plate
A-57	Large Flat Washer 10mm
A-58	Lower Guide Guard
A-59	Wedge Way Guide , Lower Guide
A-60	Socket Head Cap Screw M6x16
A-61	Adjust Screw
A-62	Brake Pedal
A-63	Brake Disc A
A-64	Travel Switch
A-65	Travel Switch Base
A-66	Pan Head Machine Screw M4X25
A-67	Socket Head Cap Screw M6X20
A-68	Socket Set Screw M8X10
A-69	Spring
A-70	Plate for Travel Switch
A-71	Pan Head Machine Screw M5X10
A-72	Large Flat Washer 5mm
A-73	Brake Assembly Kit
A-74	Upper Door
A-75	Brake Disc
A-76	Lower Door
A-77	Hand Wheel
A-78	Handwheel Knob
A-79	Screw,Handwheel Knob
A-80	End Cap,Knob
A-81	"O" Ring
A-82	Socket Set Screw M6X8
A-83	Dust collect Tube Joint
A-84	Dust Chute
A-85	Adjusting Handle
A-86	Key, Micro switch
A-87	Lock
A-88	Micro switch D4NS-4BF
A-89	Micro switch Base
A-90	Limit Switch Guard
A-91	Strain Relief M12
A-92	Mounting plate,switch
A-93	Emergency Stop
A-94	Start button
A-95	Stop button
A-96	Strain Relief M20
A-97	Guide Base, Upper Guide
A-98	Nut, Bearing

Parts list (Diagram A)

A-99	Bearing 61900
A-100	Lock Nut
A-101	Eccentric Shaft
A-102	Bush, Bearing
A-103	Sleeve
A-104	Wedge Way Guide , Upper Guide
A-105	Shaft,Upper Guide
A-106	Mount, Upper Guide
A-107	Large Flat Washer 6mm
A-108	Socket Set Screw M8X16
A-109	Knurled Lock Knob A
A-110	Guide Base, Lower Guide
A-111	Knurled Lock Knob B
A-112	UKnurled Lock Knob C
A-113	Knurled Lock Knob D
A-114	Spring Washer 6mm
A-115	Socket Head Cap Screw M5X10
A-116	Light
A-117	Switch, Light
A-118	wire sleeve
A-119	Cord Clip
A-120	Flat Head Cap Screw M5X10
A-121	Bearing 6203
A-122	Lower Wheel Shaft
A-123	Bracket, Lower Wheel
A-124	Bolt
A-125	Sleeve A
A-126	Sleeve B
A-127	Cover
A-128	Flat Washer 18mm
A-129	Bearing 6205
A-130	Flat Key 8X50
A-131	Hex Nut, Nylon Lock M18X1.5 L
A-132	Hex Nut M18X1.5
A-133	Lower Wheel
A-134	Flat Washer 12mm
A-135	Hex Nut M12
A-136	Spring Washer 12mm
A-137	Large Flat Washer 8mm
A-138	Hex Nut M8
A-139	Spring Washer 8mm
A-140	Socket Head Cap Screw M8X16
A-141	Flat Washer 8mm
A-142	Socket Head Cap Screw M6X30
A-143	Socket Set Screw, CPP

A-144	Socket Set Screw M5X6
A-145	Socket Head Cap Screw M6X12
A-146	Flat Head Cap Screw M4X8
A-147	Flat Washer 4mm
A-148	Flat Head Cap Screw M4X8
A-149	Socket Head Cap Screw M5X30
A-150	Retaining Rings 40mm
A-151	Flat Head Cap Screw M4X16
A-152	Flat Head Cap Screw M4X12
A-153	Socket Head Cap Screw M6X12
A-154	Large Flat Washer 6mm
A-155	Socket Head Cap Screw M6X30
A-156	Flat Washer 5mm
A-157	Lifting Ring M10
A-158	Push Stick
A-159	Holder,Push Stick
A-160	Hex Nut M10
A-161	Cover
A-162	Dust Collect Tube
A-163	neck chain
A-164	Hex Nut, Nylon Lock M8
A-165	Carriage Bolt M8X85
A-166	Flat Head Cap Screw M4X30
A-167	Plat for micro switch
A-168	Hex Nut M5
A-169	Hex Nut M4
A-170	Large Flat Washer 4mm
A-171	Socket Head Button Screw M5X8
A-172	Flat Washer 6mm
A-173	Cotter Pin 2.5X18
A-174	Rivet 4X8
A-175	Large Flat Washer 20mm
A-176	Flat Washer 16mm
A-177	Spring Washer 16mm
A-178	Switch Box
A-179	Socket Head Flat Screw M6X16
A-180	Gear
A-181	Hex Nut M16
A-182	Leveling Foot
A-183	Cover Clip
A-184	Hex Bolt M8X75
A-185	Hex Bolt M8X30
A-186	Socket Set Screw M6X10
A-187	Pin 6X16
A-188	Set Screw

Diagram B

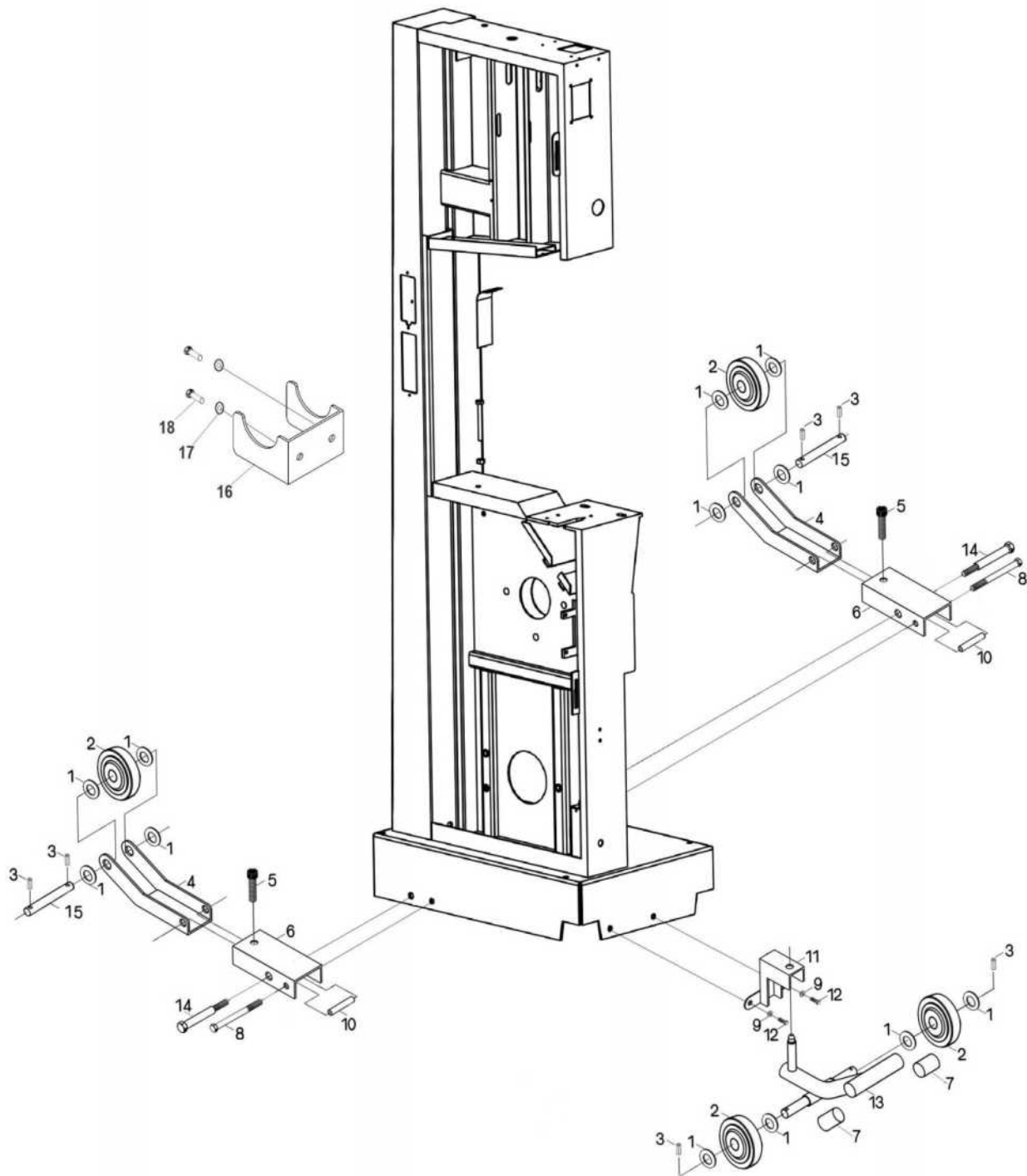


Parts list (Diagram B)

No.	Description
B-1	Table
B-2	Table Trunnion, Lower
B-3	Table Trunnion, Upper
B-4	Insert
B-5	Table Pin
B-6	Pointer
B-7	Scale A
B-8	Scale B
B-9	Socket Head Cap Screw M8X16
B-10	Flat Washer 8mm
B-11	Fence Rail Extrusion
B-12	Fence Rail Base
B-13	Cap for Fence Rail
B-14	Fence Base
B-15	Friction Plate
B-16	Socket Set Screw
B-17	Fence
B-18	Lock Bar
B-19	Carriage Bolt M6X55
B-20	Adjustable Handle
B-21	Large Flat Washer 6mm
B-22	Cap for Fence Base
B-23	Knob
B-24	Eccentric Wheel
B-25	Carriage Bolt M8×35
B-26	Pin 5X30

No.	Description
B-27	Pointer
B-28	Socket Set Screw M10X10
B-29	Pan Head Machine Screw M5X10
B-30	Lock Plate
B-31	Carriage Bolt M6×35
B-32	Nylon Lock Hex Nut M8
B-33	Spring
B-34	Nylon Lock Hex Nut M6
B-35	Washer
B-36	Carriage Bolt M8X85
B-37	Large Flat Washer 8mm
B-38	Socket Head Cap Screw M10X40
B-39	Socket Head Cap Screw M6X20
B-40	Nylon Lock Hex Nut M8
B-41	Large Flat Washer 10mm
B-42	Spring Washer 10MM
B-43	Flat Washer 10mm
B-44	Hex Nut M10
B-45	Socket Head Button Screw M8X20
B-46	Flat Washer 4mm
B-47	Socket Head Button Screw M4X8
B-48	Lock Handle
B-49	Screw
B-50	Spring
B-51	Gear
B-52	Pin 3X10

Diagram C



Parts list (Diagram C)

No.	Description
C-1	Flat Washer 16mm
C-2	Foot Wheel
C-3	Split Pin 4×30
C-4	Support for foot wheel
C-5	Socket Head Cap Screw M12×50
C-6	Adjustable frame
C-7	sleeve
C-8	Hex Cap Screw M10×80
C-9	Flat Washer 10mm

No.	Description
C-10	Bush for Adjustable frame
C-11	90° steel frame
C-12	Hex Cap Screw M10×20
C-13	Handle for foot wheel
C-14	Stop axle screw
C-15	Single foot wheel shaft
C-16	Hook
C-17	Hex Cap Screw M6×16
C-18	Flat Washer 6mm



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