

Index

Index.....	1
Important instructions when ordering spare parts.....	2
Safety and maintenance instructions	2
Danger list.....	3
Operating instructions	3
Normal and prohibited use	4
REMAINING RISKS	4
Explanation of acoustic levels.....	5
General dimensions	6
Technical Data	7
Transportation and installation of the	8
Electrical connection (Fig.3)	8
Mounting the sliding table (Fig.4).....	9
Starting the machine (Fig.5-6)	10
Changing main sawblade (Fig.9)	10
Use and adjustment of the riving knife (Fig.10-11)	11
Lower sawblade cover	12
Adjusting the main sawblade	12
Adjusting the main sawblade M500EL	13
Blocking the sliding table (Fig.14).....	13
Mounting of the cross-cut table (Fig.17).....	14
Mounting of the cross-cut fence (Fig.18A-B).....	14
Use of the parallel fence (Fig.24A-B)	15
Calibration of the scale on the parallel fence (Fig.23-25).....	16
Cutting with mitre fence (Fig.24)	16
Using the saw guard (Fig.26A-26B-27)	17
Belt tension (Fig.28-29)	18
Adjusting the brake of the saw motor	18
Maintenance of the machine.....	19
Problems: causes and solutions	19

Important instructions when ordering spare parts

Always mention the following items on your order:

- Type and serial number of the machine
 - Serial number from manual
 - Part number and quantity
 - Your reference and correct delivery address.
-

Safety and maintenance instructions

- The risks associated with using woodworking machinery are high since they use high-speed sharp cutters to do the job and in many cases these are necessarily exposed to enable the machining process to take place. Also, because many machines are still hand-fed, woodworking is probably the main industry where the hands of the operator are constantly exposed to danger.
- As well as the high risk of injury from contact with the cutters, there is the risk of being injured by the ejection of the workpiece or cutters (or parts of them) from the machine. No two pieces of wood are the same; each piece behaves differently when machined or shaped during the production process. Knots and natural changes in the direction of the grain can give rise to snatching and kickback of the workpiece.
- Serious risks are related to the use of woodworking machinery, which are sharp, vibrant and noisy machines. The machine can only be used safely if the operator strictly follows the operating and safety instructions. It is essential to read this manual before using the machine so you know how to the machine works and what its limitations are.
- Provide sufficient space around the machine and a good lighting of the workshop.
- Always make sure that all safety devices are fitted to the machine and that the machine is connected to a dust extraction system.
- Keep dust levels down with good housekeeping. Keep the work area clean so you do not resuspend dust into the air while working. Never use compressed air to clean the work area or clothing, because it generates dust. Wood dust is harmful by inhalation and in contact with skin for all woods, but more or less according to the varieties of types (deciduous, conifers, exotic) and chemicals potentially associated (including formaldehyde in MDF).
- Exposure to wood dust and many chemicals (solvents, adhesives and varnishes...) generate a risk of allergic reactions, respiratory and sinus cancer.
- Use a dust mask and hearing protection when working with the machine. To avoid inhalation of wood dust many types of masks and filters are available. A good choice and application are important for proper operation.
- Carefully read the instructions for the cleaning of the machine.
- Do not remove by hand wood residues to a running engine. Do it only with a fully disabled machine. When changing tools or when doing a maintenance job, the machine must always be disconnected from its power supply.
- Knives and tools which are not correctly sharpened, or in a bad shape, not only diminish the quality of the work, but also increase the risk of accidents. Only use sharpened tools conform to EN 847-1:2017
- Always wear suitable clothing, loosen or torn clothing is dangerous.
- Keep children and non-trained personal away from the machine and out of the workshop.
- Always use templates during the machining of special parts.
- Be sure to use only blades corresponding to the dimensions indicated in the technical data and relevant to your work.

- Make sure that periodic maintenance be carried out in due time. Try out weekly the emergency stops. Read the instructions of maintenance and adjustment of the automatic brake of the motor. Check if the automatic braking of the motor time is less than 10 seconds, if the emergency stops functioning correctly.
- All guards need to be kept in a good working condition and need to be checked regularly to ensure that they move freely, are free from any defect and are capable of being adjusted over the full range of work for which they were designed.
- Maintenance work should only be carried out by people who have the combination of training, skills, experience and knowledge to do the work.
- Use only tools for manual use with a maximum width of 16 mm on the machine that is equipped with the "groove milling" option and which are manufactured according to EN 847-1: 2017 and are marked with "MAN".

Danger list

This list was based on C-norms EN ISO 19085-5.

Mechanical risks caused by, for example:

- the shape, the mass and the stability (potential energy of the elements), relative disposition, the mass and speed (kinetic energy of the elements), insufficient mechanical resistance, accumulation of potential energy of the elastic elements (springs), elements of the machine or machined pieces
- Risk of crushing
- Risk of cuts
- Risk of gasping, wrapping
- Risk of electric shock or pinching
- Ejection of elements (of the machine or of the processed part), electrical risks, caused by electrical contact (directly or indirectly)
- Risks caused by noise, materials or inhalation of toxic substances
- Risk of fire or explosion
- Combination of risks
- Risks caused by failure in the supply of energy, defect of elements of the machine and other functional disorders, for example all types of safety devices, safety equipment and start / stop equipment.
- Safety signals and pictograms and all types of information or equipment.

Operating instructions

The following recommendations for safe working procedures are given as an example, on top of all information characteristic of this machine.

- When working with the machine, safety equipment must be used.
- Nevertheless, the user must also follow the operating instructions to avoid accidents.

1 Training of machine users

It is absolutely essential that the panel saw user receives thorough training regarding operating and adjusting the machine.

In particular:

- a) the risks involved in working with the machine;
- b) the operating principles, the correct usage and adjustment of the machine;
- c) the correct choice of the tools for each operation;

- d) the safe handling of parts to be processed;
- e) the position of the hands in relation to the sawblade;
- f) storing the workpieces safely before and after sawing them.

2 Stability

In order to be able to use the machine safely, it is essential to place it stably on the ground or other stable surface.

3 Adjustment and installation

- a) Disconnect the machine from the power supply before every adjustment.
- b) The recommendations of the manufacturer must be followed when adjusting and installing the tools.
- c) The tools must be suited to the material being cut to assure safe and efficient sawing. The tools must be correctly sharpened and installed.

4 Handling of tools

In order to avoid severe cuts, safety measures must be taken when handling the sawblades.

5 Intended use of the machine

The machine may only be used for processing all types of wood, panels and sheets with or without plastic coating. The processing of plastic sheets and plastic is permitted with adapted saws. The machining of ferrous and non-ferrous metals is strictly forbidden. In order to be able to maintain the indicated sound values, all protective caps and means provided on the machine must be used. This also applies to the dust emission and means that the machine must be connected to a dust extraction system, whose air flow rate measured at the extraction opening on the machine is at least 20 m³ / sec. amounts.

Normal and prohibited use

The panel saw is designed for the following work and is equipped with protective devices for these processes only. It is not designed to work materials such as ferrous or non-ferrous metals, work different from that stated below is prohibited.

- Ripping with the parallel saw fence with/without the sawblade tilted and the fence upright or in the low position.
- Right-angled or mitre cuts with the 90° fence mounted to the sliding table with tilted or vertical sawblade.
- Cross-cutting workpieces using the adjustable stop on the 90° fence. - Cutting panels or solid wood on the sliding table.

PROHIBITED USE

Following tasks are prohibited on the panel saw:

- submerged cuts by removing the riving knife and/or guard;
- all types of cuts without using the table saw fence, the 90° fence or sliding table; Cutting large workpieces that exceed the machine capacity without using aids such as roller supports.

REMAINING RISKS

The most important risks on the panel saw are:

- unintentional contact of the hand with the saw blade;

- contact with the saw blade during the stop time of the saw blade (10 sec). - recoil of the workpiece or recoil of parts within the workpiece - tilting of the workpiece due to insufficient support.
- Injuries due to tool breakage or parts that break off the tool.
- Injuries in the non-secured area between the machine table and the saw blade during sawing parts.
- Risk of pinching and crushing between the parallel fence and the sliding table
- Risk of pinching and crushing between the parallel fence and the saw blade, riving knife and saw blade.
- When moving the sliding table, there are risks for clamping, pinching and crushing. Only use the handle to move the sliding table.
- When cutting plastics, there is a risk of the release of harmful substances.
- Risks due to changes made to the machine by unauthorized personnel.
- Risks for the machine, tools and safety equipment when tilting the blade while the saw blade is rotating.
- Risks for the machine, tools and safety equipment when setting the parallel fence with rotating saw blade.

SOUND REDUCTION

- The type and condition of the saw blade is important to keep the noise level as low as possible.
- The material and the position of the safety devices are important for reducing the noise level. Using the correct speed of the saw blade for the type of material will reduce the noise level.
- The above does not mean that no additional protection measures such as hearing protection should be used.

Explanation of acoustic levels

The values given are the emission values and not necessarily the safe working levels. Although there is a relationship between the emission values and the level of exposure, this can not be reliably used to determine whether additional measures need to be taken.

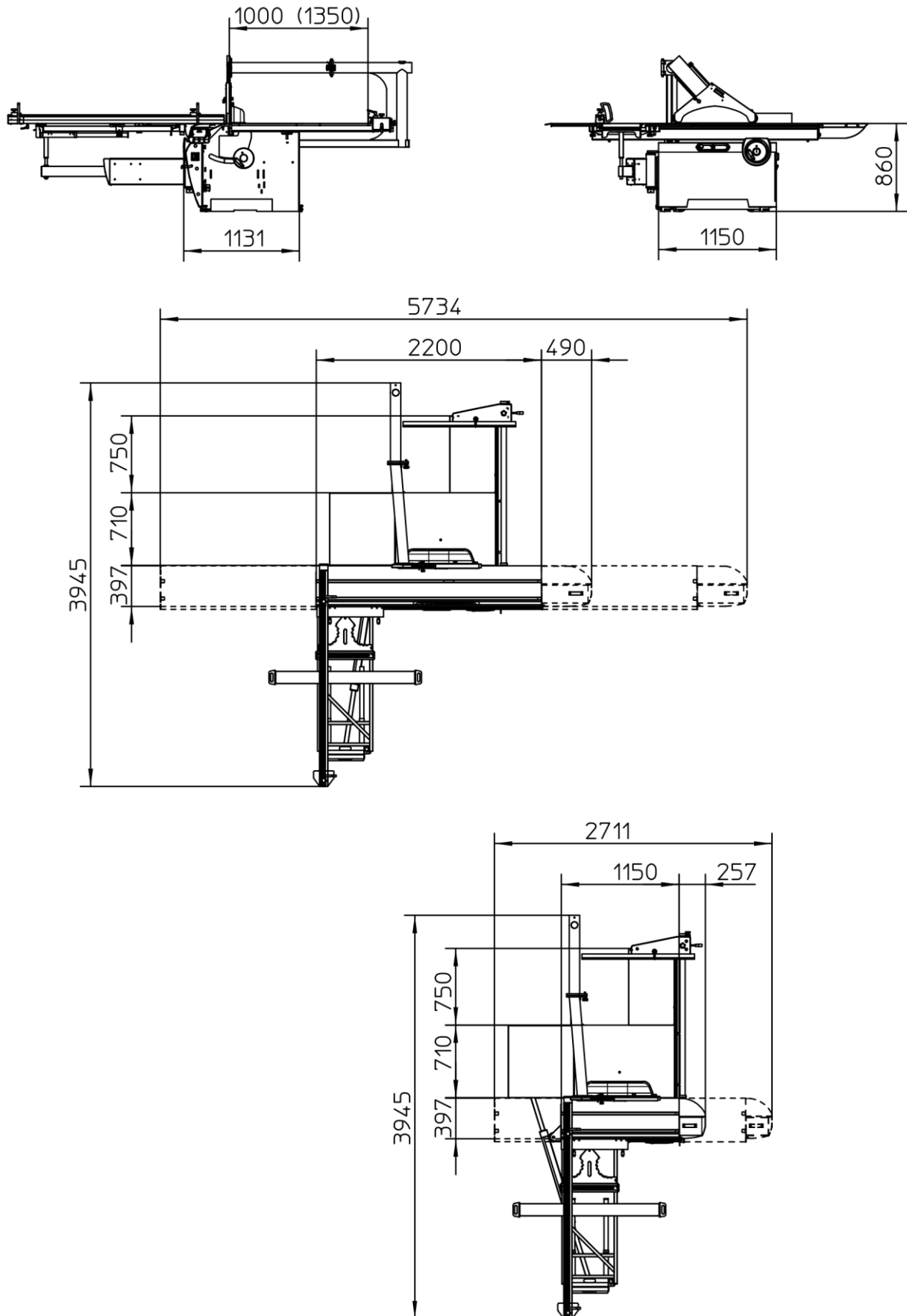
Measurements according: NBN EN ISO 3746 (2011)
NBN EN ISO 11202 (2010)

Measurements performed by: Vinçotte nv

A measurement uncertainty tolerance of K = 4 dB (A) applies to the indicated emission values.

Workstation	Level acoustic load dB (A)	Level acoustic power dB (A)
Sawing	92.1	100.1

General dimensions



Technical Data

Voltage	230V / 400V
Motor power	9,2 kW (S6) (12,5pk)
Weight	550kg
Saw	
Diameter saw and bore	300 - 500 x 30 mm
Cutting depth at 90° / 45°	175 mm / 122 mm
RPM	3000 / 4000 / 5000
Sawblade tilting	90° - 45°
Cutting width parallel fence	1000/1350mm
Dimensions table	985 x 710 mm
Dimensions sliding table	1150x 420 (optie 2200) mm
dimensions cross-cut table	mm
Diameter aspiration tubes	120 + 100 mm
Motorized rise and fall of the saw	M500 EL
Motorised tilting of saw aggregate	M500 EL
Preparation groove cutter	Option M500 EL
Mitre fence on sliding table	Option
Extra support table with rip fence	option
Eccentric clamp	standard
Digital read out of tilt of the saw aggregate	Option
Digital read out of height of saw blade	option M500 EL
Digital read out on parallel fence	option M500

Transportation and installation of the machine (Fig.1-2)

Depending on the transport or shipping method you will receive the machine either in a box or not packaged. The packaging itself, made of sturdy fibre boards and the wooden beams, can easily be reused. You can lift the machine with a crane or forklift truck and bring it to the ground. On the front of the frame there are two openings with which you can move the machine with a hand pallet truck. (2) Ensure that the machine is well balanced in the lifting belts when moving. Secure the belts against lateral shearing.

ATTENTION:

Always check if the payload of your hoist is large enough.

After unpacking, check that the machine has not been damaged during transport or during unloading. Place the machine stably on a solid surface and provide sufficient space around the machine to work in a safe manner. The machine must be levelled in both directions. There are 6 adjusting bolts on the machine, see fig.2

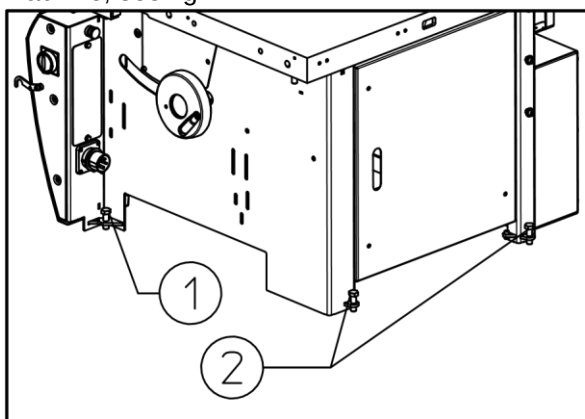


Fig.1

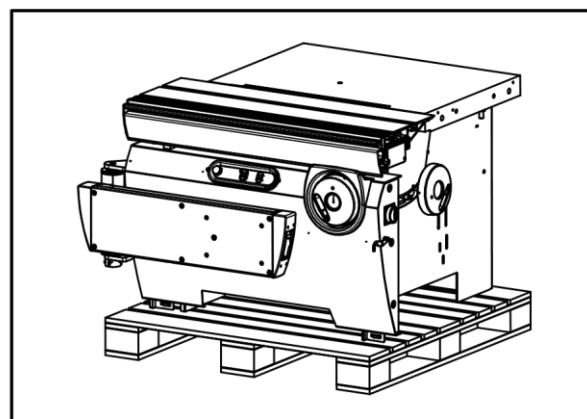


Fig.2

Electrical connection (Fig.3)

The electrical connection must be carried out by a qualified electrician who is able to calculate exactly the required wire cross-section and capacity of the workshop fuses.

Check that the main voltage of the machine corresponds with the voltage supply to your workshop. Now open the electrical switch panel and introduce the cable. Connect the 3 phases to the terminals on the connection block marked L1, L2, L3. If there is a neutral conductor it must be connected to the terminal N.

Connect the earth wire (green-yellow) to the terminal marked with the earth symbol PE.

ATTENTION:

- Check first if the saw spindle runs freely and if all safety devices are fitted before starting the machine.
- If the direction of rotation of the sawblade is not correct, the wires L1 and L2 must be exchanged (clockwise direction of the spindle is correct).
- For safety reasons this must only be done without the sawblade on the spindle !

THERMAL OVERLOADS

The machine has overload protections on both saw and scoring motors. Should the motor be shut-off by one of these protectors, it is necessary to wait a few minutes until the overload has cooled down.

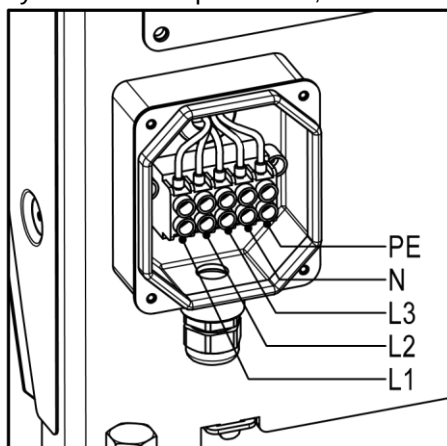


Fig.3

Mounting the sliding table (Fig.4)

To obtain a good arrangement and function of the sliding table; it is vital that the machine is put on a right level in both directions, with the help of a level, before putting the sliding table on the machine. All the adjustments and arrangements are done in the factory. Simply put the table onto the frame with the two lateral adjustment bolts (1) into the two lugs of the frame. Be sure that the girder rests well in the height adjustment bolts. Now place the 4 big Allen bolts (3) and tighten well. In order to obtain a good movement of the wood or the sliding table, the sliding table is set near to 2 mm above the sawing table. The parallelism between the principal blade and the sliding table, can be corrected by using 2 bolts. After the adjustment, the 4 bolts need to be tightened well with a Torque wrench with a value of 7 kg (70 Nm). The adjustment in height of the sliding table can be done by using 8 bolts (2) but always with the big bolts closed.

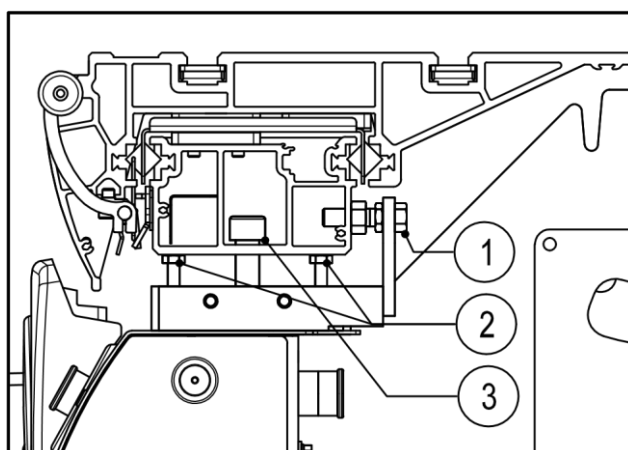


Fig.4

Starting the machine (Fig.5-6)

Set main switch (1) to "1" to energize the machine (fig. 6.1).

For model M500 fig (5A) and model M500 EL fig (5B). Start the main engine (white button) and stop (black button) with the button (3).

The upper white button starts the engine, the lower black button stops the engine.

When the emergency stop (1) is pressed, both motors are switched off. The main saw motor is equipped with an automatic brake which slows down the motor within 10 seconds as soon as the machine is shut off.

ATTENTION:

When the machine access door is open, the saw blade cover is open, or one of the emergency stops is pushed in, the machine cannot be started.

All fuses are located inside the electrical panel and each time this panel is opened the machine has to be disconnected from its power supply.

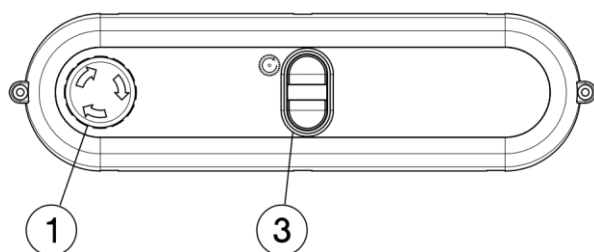


Fig.5A

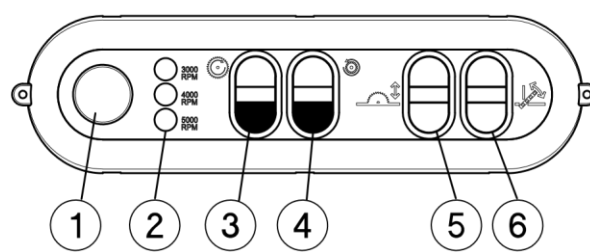


Fig.5B

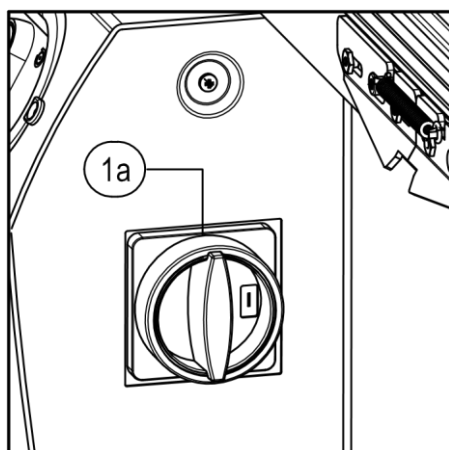


Fig.6

Changing main sawblade (Fig.9)

Warning: Before changing sawblades always turn off the main switch. Handle sawblades with care, to avoid serious cuts and injuries.

Push the sliding table to the rear and open the saw cover. Raise the main sawblade to its highest position and put the key(2) into the saw spindle nut.

Put the locking pin in the opening of the saw table and turn the spindle with the key (3) until the locking pin (2) engages in the hole in the saw spindle pulley.

Now unlock the nut (1). Before fitting the new sawblade ensure the blade and flanges are clean. This prevents wobbling of the sawblade.

Never forget, after the saw spindle nut has been tightened, to remove the locking pin from the pulley before starting up the motor.

ATTENTION:

Only saw blades with a diameter of 300 to 400 mm may be placed on the machine.

The use of HSS saw blades is strongly prohibited, as well as the use of deformed or cracked saw blades. Only use saw blades in carbide!

Also make sure that the saw blades are always sharp and cut according to the manufacturer's specifications.

WARNING:

All main sawblades which are used on the panel saw must have two additional holes in the sawblade body, to prevent the sawblade from loosening when the rotation of the saw spindle is stopped by the brake on the motor.

The two little bolts in the fixed saw spindle flange prevent the saw from coming off and may under no circumstance be removed.

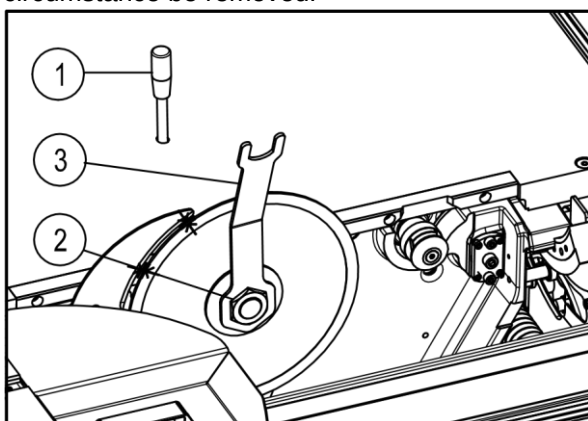


Fig.9

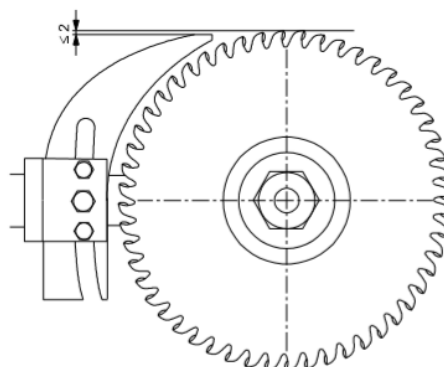
Use and adjustment of the riving knife (Fig.10-11)

The machine is equipped with two riving knives for the use of sawblades from 300 to 500 mm. The riving knife has to be adjusted in such a way that over its entire length the gap between sawblade and riving knife does not exceed min.3 mm and max.8 mm.

The riving knife can be adjusted in both vertical and horizontal direction.

In the upper range, the riving knife must be adjusted so that the top is between 0 mm and 2 mm below the highest tooth of the saw blade.

After height adjustment always lock the central bolt (3) at a torque of 60 Nm. The 4 adjustment screws (2) are used for the exact setting of the riving knife in line with the sawblade.



Never remove this riving knife. Kickbacks are severe and very dangerous !!

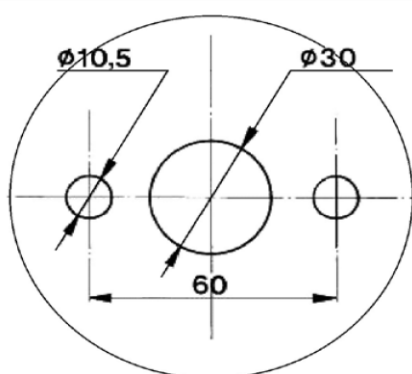


Fig.10

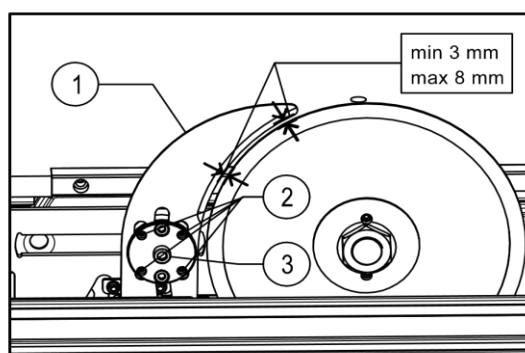


Fig.11

Lower sawblade cover

In the event of a saw blade change, the sliding table must be pushed fully to the rear in order to be able to open the saw blade cover.

The sawblade cover is held by 2 magnets.

If the cover is open, the saw cannot be started.

Adjusting the main sawblade

M500 (Fig.12A-B)

The main saw blade can be adjusted vertically with the handwheel (1) and the handle (2)

The height adjustment of the scoring saw is done with the adjusting knob (5). (fig 12A)

Lock the setting with the serrated nut (4). (fig 12A)

The desired cutting angle can be set with the handwheel (1) and the handle (2)(Fig 12B). The angle setting can be read on the clock (4) in the handwheel. The angle of the scorer blade is automatically adjusted according to the angle setting of the main saw blade. The sawing unit can be adjusted to angles between 45 ° and 90°. Mechanical stops have been adjusted from the factory to the end points.

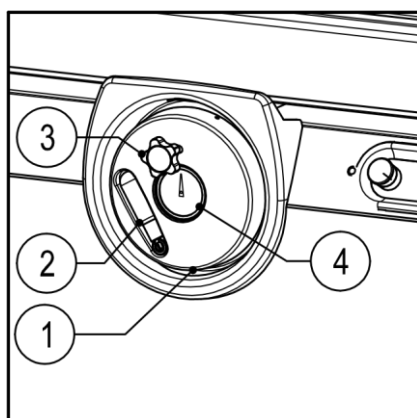


Fig.12A

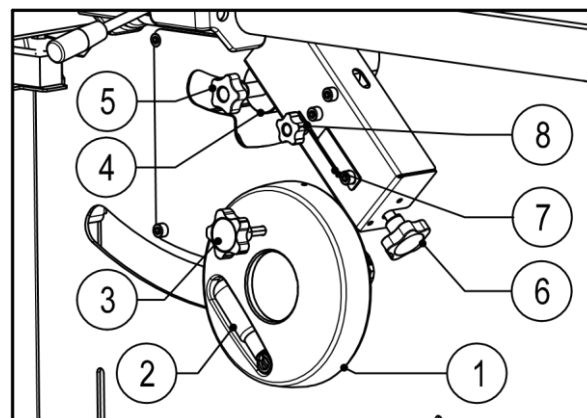


Fig.12B

Adjusting the main sawblade M500EL

Adjusting height (Fig.5B and 5C)

Changing the height of the main sawblade can be done with the help of push buttons.(4 and 5). To recover the backlash of the transmission; always adjust the height of the blade in <<up>> mode.

Adjusting the inclination of the saw unit (Fig. 5B and 5C)

The inclination of the main sawblade can be done with help of push buttons.(6) The inclination of the saw unit is visualized on the indicator or on the digital screen (9) for the machines equipped with this part. The saw unit can be inclined in angles of 45 and 90° and at those two points, there are mechanical stops provided by the factory.

Blocking the sliding table (Fig.14)

- The sliding table can be blocked in two positions and with one block-system. This is vital for example by loading of the boards or cutting along the parallel guide. The system is located on the front-side of the sliding table. Pull the button (1) in your direction and turn to the right to liberate the table. Pull the sliding table till end, the table will be blocked automatically when arriving in the exact position. Continue this way to start working.
- When several movements are repeated consecutively, it is possible that the bearing cage between the two profiles moves a little bit. We can note this as well by a reducing travelling distance of the sliding table. To proceed and achieve the normal travelling distance of the sliding table, you can adapt the position of the bearing cage: simply push the table with a few short, light pushes against the buffer stop at the end of the sliding table until the position of the ball carrier is adjusted and the table can be moved again along its full stroke.

Attention: cleaning and maintenance of the sliding table

It is vital to regularly blow away the saw- and other dust, collected between the sliding table and the bearing cage. Push the sliding table to the end, to get a better reach towards the rails, the bearing cage and gliding tracks. Oil serves to lubricate the sliding rails and is an extra guarantee of good use and function.
Always use the handle to move the sliding table!

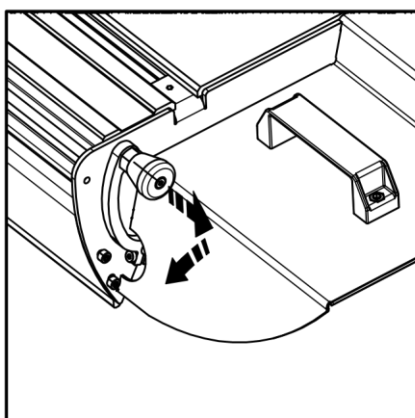


Fig.14A

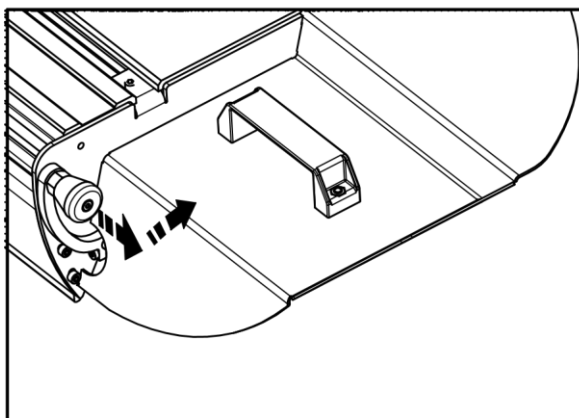


Fig.14B

Mounting of the cross-cut table (Fig.17)

The cross-cut table can be mounted on the sliding table as follows: make sure that both mounting brackets are well placed in the lateral groove of the sliding table.

The locking itself is done with the two locking handles (1). Make sure the cross-cut table rests well on the vertical post of the telescopic arm. The machine serves only to put the cross-cut table at the back of the sliding table, with a maximum at the centre.

The cross-cut table and fence are factory set at 90° to the saw blade but if for some reason this is not the case and not exact anymore, the 90° angle setting adjustment is done by loosening the 4 bolts (2) and shifting the complete cross-cut table. Make sure these 4 bolts are well tightened after the adjustment is done. The cross-cut table can only be mounted at the end of the sliding table. To put it more forwards (max. in the middle), use the optional longer telescopic tube.

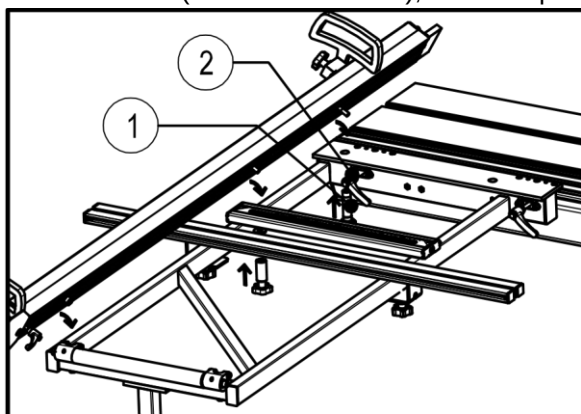


Abb.17

Mounting of the cross-cut fence (Fig.18A-B)

To place the cross-cut fence on the cross-cut table, place the fence with the right hinge pin (1) in the fastening hole on the front of the table (fig. 18B). Now place the clamping screw (2). Slide the fence backwards until the stop bolt (3) is securely in the rear support point (4) and the stop bolt (5) in the support point. These support points also serve as a 90° stop. The support point (4) is set fixed but can be adjusted if desired, but it does not serve to adjust the squareness of the fence, this is done with 4 adjusting bolts (fig 17, 2), but to adjust the rear fastening point without play. The fence can be used in 2 positions at the front or the rear, and at an angle. All attachment points are factory-set.

There is an optional index system for the fence. This allows you to cut accurately at an angle and have a correct length reading on the fence. Loosen the 3 clamping screws loosely, push the stop beam forward so that it is free from the support point (4). Now the fence can be moved at an angle. The angle can be read on the measuring scale (7). Now pull the fence backwards until the stop (5) falls into one of the notches on the index plate (8). Now you are sure of angle and length. Now the clamping screws (2 and 6) can be fixed again.

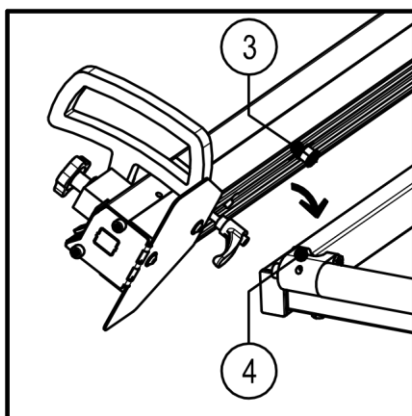


Fig. 18A

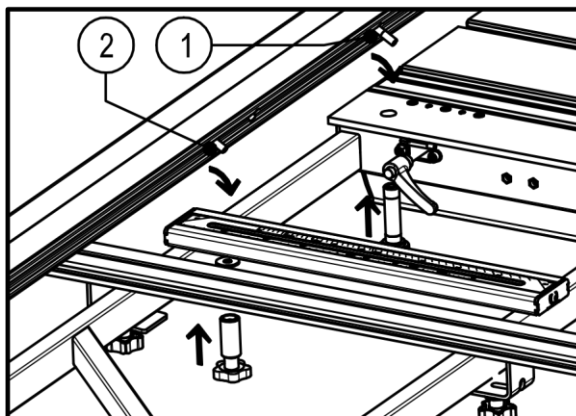


Fig. 18B

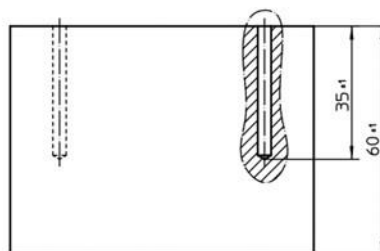
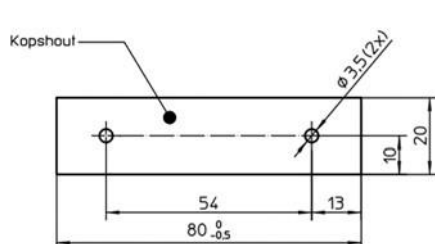


Abb.21

Use of the parallel fence (Fig.24A-B)

When the serrated knob (3) is unlocked and the handle (1) is lifted up, the complete parallel fence can be moved. To lock the fence in position push the handle (1) down.

The micrometric adjustment is achieved by locking the knob (3), by holding the handle (1) in the upright position and by turning the serrated knob (2).

After the adjustment, push handle (1) down to lock the fence in place. When cutting small workpieces with the saw unit inclined at 45°, the fence should be used in the low position.

Simply unlock the eccentric clamping handle (4), slide off the fence and slide it back on in the low position. Lock the fence with the eccentric clamping handle (4).

When cutting solid wood using the parallel fence, to avoid the wood getting stuck between the fence and the riving knife (resulting in a highly dangerous kickback) it is recommended to reposition the fence so that its end protrudes just past the end of the riving knife.

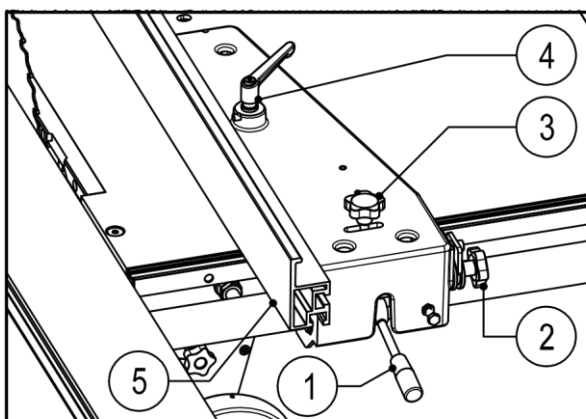


Fig.24A

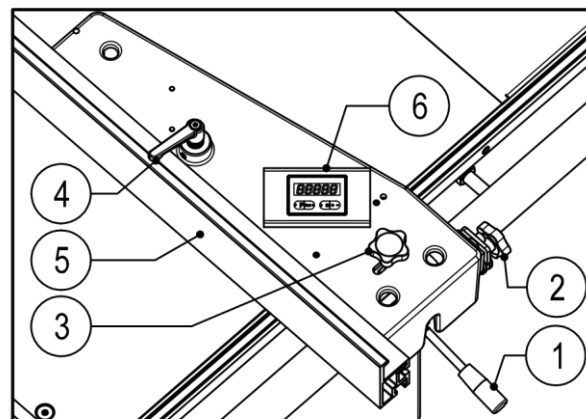


Fig.24B

Calibration of the scale on the parallel fence (Fig.23-25)

Each time a new sawblade is fitted the parallel fence scale has to be calibrated to the new sawblade. By cutting a sample and measuring its exact length, the scale can be adjusted so that the exact measure corresponds with the front side of the fence.

After the screw (1) has been loosened the scale can be adjusted. To avoid the fence contacting the sawblade while it is revolving, the stop ring (2) has to be adjusted. Slide the fence to about 10 mm from the sawblade. Now slide the stop ring (2) across the round guide bar (3) until it comes up against the casting of the fence. Tighten the lock screw on the stop ring.

For a digital reading: Move the parallel fence against the saw blade, and then simultaneously press the "F" and "SET" buttons. The value on the digital reading jumps to "0".

Then shift the locking ring (fig. 25.3) onto the saw guide (2) until the cutting width is limited to 2 mm. This prevents inadvertent contact with the saw blade.

If the size display is not correct when the digital display is read, check the distance between the sensor (Fig. 23.2) and the digital measuring tape (Fig. 23.1). This may be max 0.2 mm. If necessary, adjust this with the adjusting bolts (fig. 23.3).

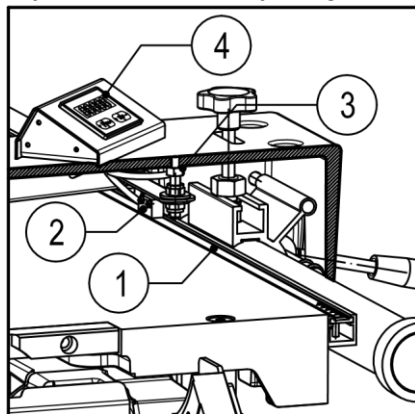


Fig.23

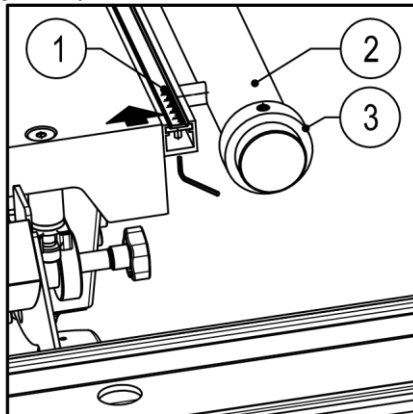


Fig.25

Cutting with mitre fence (Fig.24)

The nut for receiving the wood clamp shaft (1) is set from the factory and must not be moved. The set angle can be read at the rear of the large angle bracket (4). The angle is changed by unloading the shaft (1) and releasing the clamping lever (2). The stop profile (5) itself can be moved by releasing the 2 clamping levers (3).

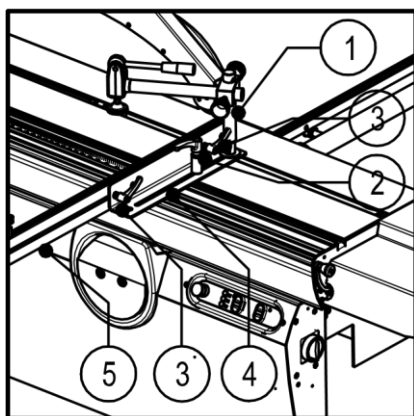


Fig. 24

Using the saw guard (Fig. 26A-26B-27)

For safety and health reasons, the saw cover must be connected to a dust extraction system. This must have a flow rate of min 1200m³ / h at 20 m / s.

The connection at the bottom of the saw unit has a diameter of 120 mm, on the saw guard (via the support pipe) with a diameter of 100 mm. The saw guard itself must be set so that the saw blade and the scoring blade are protected and the piece to be machined can be moved just under the cover. The height adjustment of the hood is done by pulling back the pin (fig. 27, 2). With normal use pull the pin (fig. 27, 2) backwards and lower the saw blade onto the work table. The saw cover will automatically raise when entering workpieces up to a certain thickness. For workpieces where a larger cutting height is required: grasp the saw blade on the handle (4), pull the pin (2) back and place the saw blade in the desired position. Push the clamping pin 2 forward again and the saw blade is fixed. The saw cover can no longer lower, but will go up if a higher workpiece is inserted. To lock the saw blade in both directions, screw in the clamp pin (fig. 27, 1). To set a maximum cutting height, place the ring (3) in the desired position.

The saw blade has a narrow cover for sawing under 90 °. To place it, slide the plate (fig 26A, 1) down into the key holes and attach the 2 clamp screws (26A, 2).

The wide hood serves for cutting under 45 °. This is also fixed with 2 clamping screws (fig 26B, 2) and also slides into 2 key holes.

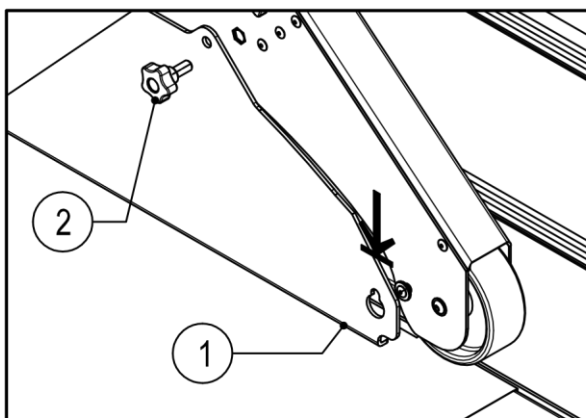


Fig. 26A

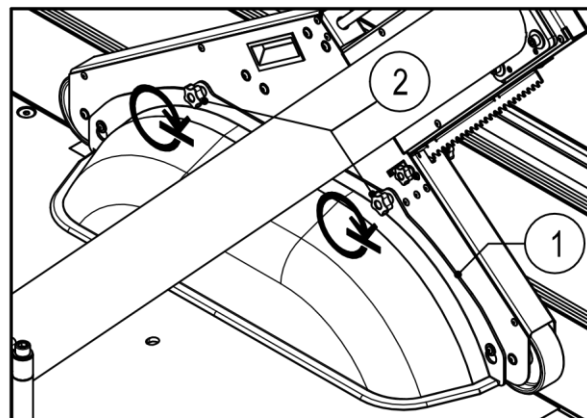


Fig. 26B

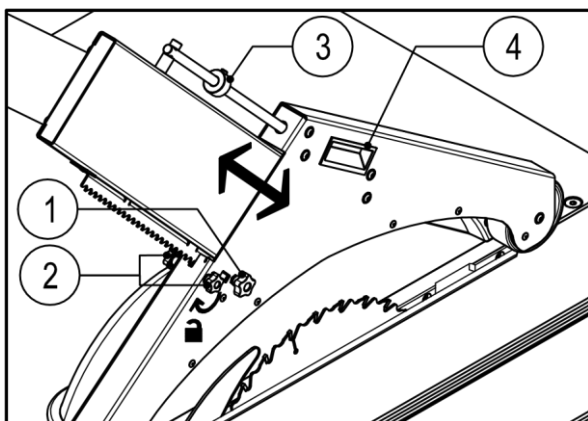


Fig.27

Belt tension (Fig.28-29)

Raise the motor via the handle (29.2). Now the belt can be placed in the desired slots (fig. 28). Lower the motor until the belt has the correct tension. A properly tensioned belt can be pressed in the middle under slight pressure over approximately the thickness of the belt. A belt that is too tight leads to damage to bearings and premature wearing of the belt.

Check the condition of the belt regularly and change if necessary (order number: NXPA800). Only use Robland replacement parts.

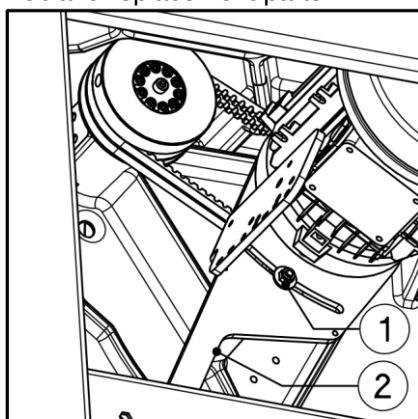
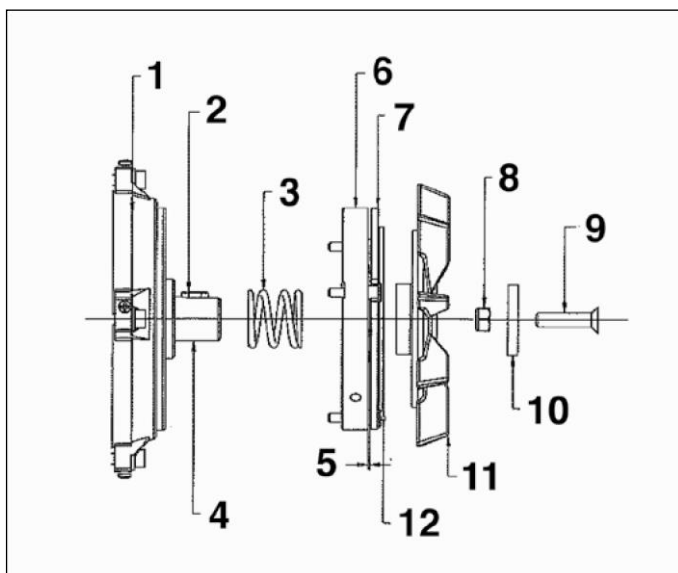


Fig.28

Adjusting the brake of the saw motor

If the run down time of the saw motor exceeds 10 seconds, then the brake will need to be readjusted. This is done as follows: without removing the motor cowling, turn the bolt holding the ventilator fan on the motor axle one 1/16th of a turn clockwise and make a brake test. When needed adjust the brake furthermore until it does not exceed 10 seconds.

The air gap between ventilator fan (brake disk) and brake liner (Ferrodo) is factory set at 0,25 mm, this under normal conditions.



- 1 Motor frame
- 2 Key
- 3 Spring
- 4 Motor axle
- 5 Air gap
- 6 Electromagnet
- 7 Mobile disk
- 8 Locking nut
- 9 Adjustment bolt
- 10 Washer
- 11 Braking disk cast iron
- 12 Brake liner (Ferrodo)

Maintenance of the machine

All maintenance and cleaning work may only be carried out with the main switch set to "O". The machine must have been switched off from the mains.

In order to guarantee the life of your machine and also to optimize the quality of your delivered work, we strongly recommend cleaning the machine once a week and remove all dust and chips that have accumulated on different parts of the machine.

Especially the carriage must be well maintained. To do this, slide the trolley to the rear and carefully blow all dust and dirt from between the two profiles and ball cage. Afterwards the steel carriages of the car must be lubricated with a simple lubricant in spray such as WD40 or other means.

All ball bearings used in the machine are dust-tight and require no lubrication.

Remove any resin deposits on the machine and regularly lubricate the steel axle of the parallel fence.

Caution: when using solvents, be very careful about the risk of fire. !! Do not smoke and keep the products away from heat sources !!

Problems: causes and solutions

- 1 The machine does not start when the start button is activated:**
 - access door is still open: close the door correctly
 - main fuse is switched off: power cut, power shortage or motor overload
- 2 Reduction of speed when working:**
 - belt tension not correct: tension the belt
 - motor overload due to incorrect feed rate: reduce the feed rate - blunt tools: sharpen tools
- 3 Vibration of the sawblade or spindle:**
 - unbalanced tool: replace or have the tool balanced - worn or damaged belt: replace the belt

- 4 Thermal overload does not re-arm automatically after shut-off and cooling down period:**
- overload is not set on automatic reset or the overload is faulty

If you cannot solve the problem yourself or you do not find your problem in this list, please contact your Robland dealer.
land-Händler.