

# **POWERMATIC®**

## **Operating Instructions and Parts Manual Horizontal Panel Saw Model HPS126**



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# Warranty and Service



WMH Tool Group, Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these WMH Tool Group Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your POWERMATIC® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

## MORE INFORMATION

WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit [powermatic.com](http://powermatic.com).

## WARRANTY

POWERMATIC products carry a limited warranty which varies in duration based upon the product.

	<b>Industrial Products</b> Horizontal Panel Saws Cut Off Saws Rip Saws Bandsaws Jointers Planers Oscillating Edge Sanders Belt Sanders Shapers Power Feeders Mortisers Dovetailers		<b>Non-Industrial Products</b> Tablesaws Vertical Panel Saws Bandsaws Jointers Planers Planer/Molder Dust Collection Disc Sanders Edge Sanders Drum Sanders Shapers Drill Press's Mortisers Dovetailers
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*Warranty reverts to 1 Year if above products are used for commercial, industrial or educational purposes*

## WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

## WHO IS COVERED?

This warranty covers only the initial purchaser of the product.

## WHAT IS THE PERIOD OF COVERAGE?

The general POWERMATIC warranty lasts for the time period specified in the product literature of each product.

## WHAT IS NOT COVERED?

The Five Year Warranty does not cover products used for commercial, industrial or educational purposes. Products with a Five Year Warranty that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

## HOW TO GET SERVICE

The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option.

We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the handling and shipping costs of the return.

## HOW STATE LAW APPLIES

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

## LIMITATIONS ON THIS WARRANTY

WMH TOOL GROUP LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WMH TOOL GROUP SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

WMH Tool Group sells through distributors only. The specifications in WMH catalogs are given as general information and are not binding. Members of WMH Tool Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

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# Warnings

As with all machines, there is a certain amount of hazard involved with the use of this panel saw. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.

1. Read and understand the entire owner's manual before attempting assembly or operation. Know the limitations and hazards associated with this machine.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This panel saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a panel saw, do not use until proper training and knowledge have been obtained.
5. Do not use this panel saw for other than its intended use. If used for other purposes, WMH Tool Group disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this panel saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this panel saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Protective type footwear should be used. Anti-skid floor strips are recommended. Do **not** wear gloves.
8. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations, use hearing protective devices.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
  - Lead from lead based paint.
  - Crystalline silica from bricks, cement and other masonry products.
  - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.
13. Disconnect machine from power source before performing any service or maintenance or when changing blades. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.
14. Remove adjusting keys, wrenches, scrap or cleaning rags. Form a habit of checking to see that all such items are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards before operating the machine.
16. Provide for adequate space surrounding work area and non-glare, overhead lighting.

# Warnings

17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for 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.
18. Keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Be sure the table is free of all scrap, foreign material and tools before starting to cut.
19. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Anti-skid floor strips are recommended on the floor area where the operator normally stands and each machine's work area should be marked off. Provide adequate work space around the machine.
20. Keep visitors a safe distance from the work area. **Keep children away.**
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
23. Maintain a balanced stance and keep your body under control at all times. Do not overreach or use excessive force to perform any machine operation. Do not stand in line with the saw blade or work piece and do not allow anyone else to do so.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
25. Maintain tools in top condition. Check the saw blade for cracks or missing teeth. Do not use a cracked or dull blade or one with missing teeth or improper set. Make sure the blade is securely locked on the arbor.
26. Turn off the machine before cleaning.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.
30. Keep hands clear of the blade area. Do not reach past the blade to clear parts or scrap with the saw blade running. Never saw free hand. Avoid awkward operations and hand positions where a sudden slip could cause your hand to contact the blade.
31. Saw blade rotation: Be sure the main saw blade rotates clockwise when viewed from the front (operator's side). The scoring blade should rotate counterclockwise when viewed from front.
32. Do not attempt to saw a board with loose knots or with nails or other foreign material, on its surface. Do not attempt to saw twisted, warped, bowed or "in wind" stock unless one edge has been jointed for guiding purposes prior to sawing.
33. If the operator leaves the machine area for any reason, he should turn "off" the power to the saw motor and wait until the saw blade comes to a complete stop before his departure. In addition, if the operation is complete, he should clean the saw and the work area. NEVER clean the saw with power "on" and never use the hands to clear sawdust and debris; use a brush or compressed air.
34. Use only Powermatic or factory authorized replacement parts and accessories; otherwise the warranty and guarantee is null and void.

**Familiarize yourself with the following safety notices used in this manual:**

**CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

**WARNING** This means that if precautions are not heeded, it may result in serious injury or possibly even death.

## Introduction

This manual is provided by WMH Tool Group, Inc. covering the safe operation and maintenance procedures for a Powermatic Model HPS126 Panel Saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or WMH Tool Group. WMH Tool Group can also be reached at our web site: [www.wmhtoolgroup.com](http://www.wmhtoolgroup.com).

## Specifications

Stock number .....	1791288K
Main motor .....	7.5 HP, 3Ph, 230V
Blade speed .....	3000, 4000, 5000 RPM
Blade size.....	12-16" (300-400 mm)
Arbor size.....	30 mm
Dado size (width x bore).....	13/16" x 5/8"
Cutting depth.....	5" (125 mm)
Scoring motor.....	3/4 HP
Scoring blade size .....	100 to 120 mm
Scoring blade arbor .....	20 mm
Scoring blade speed .....	7000 RPM
Sliding table carriage width .....	16-1/2" (420 mm)
Sliding table carriage stroke.....	126" (3200 mm)
Rip capacity.....	54" (1380 mm)
Main and scoring blade tilt .....	90 to 45 degrees
Main table size cast iron .....	27-1/2" x 35" (940 x 508 mm)
Right side extension table.....	31" x 18" (790 x 460 mm)
Rear extension table size.....	28" x 25" (710 x 635 mm)
Working table height.....	34" (860 mm)
Crosscut table size .....	57" x 21" (1450 x 530 mm)
Crosscut fence size with extension .....	117" (2970 mm)
Mitre Fence length with flip stop, clamp.....	47" (1200 mm)
Overall size .....	140" x 54" x 126" (3555 x 1370 x 3200 mm)
Dust collection ports (two).....	4" (100 mm)
Gross weight .....	2640 lbs. (1200 kg.)
Net weight .....	2530 lbs. (1150 kg.)
Noise emission (per ISO norm 7960) .....	91 dB (max. value 130 dB)

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, WMH Tool Group reserves the right to change specifications at any time and without prior notice, without incurring obligations.

# Dimensions and Features

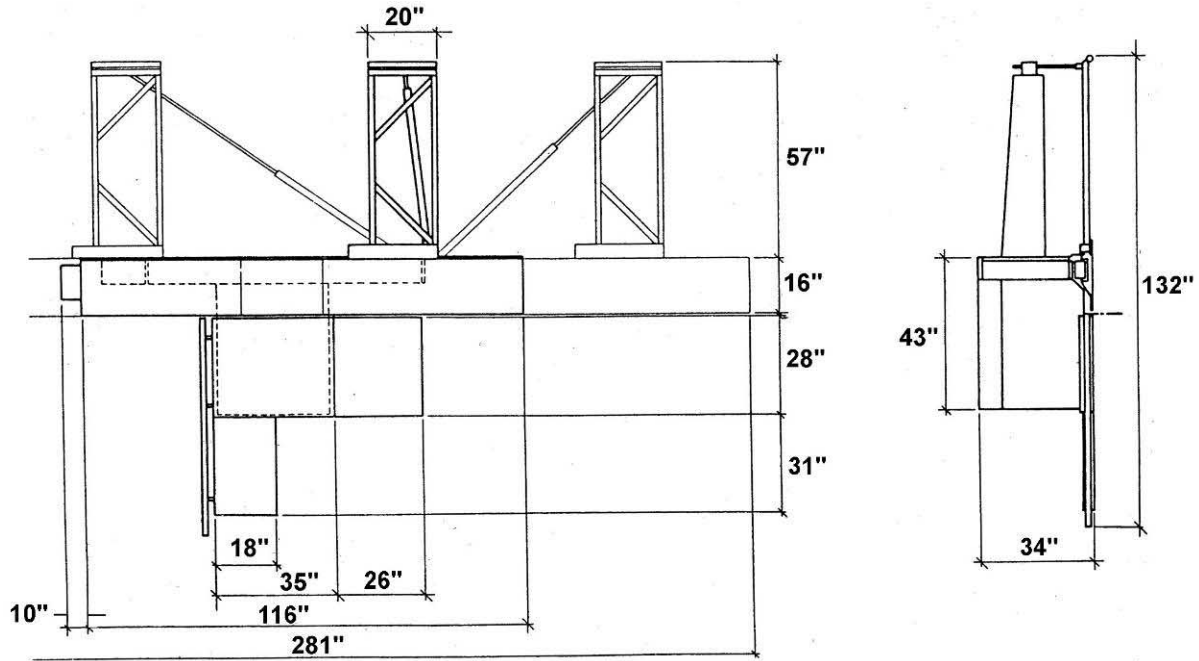


Figure 1

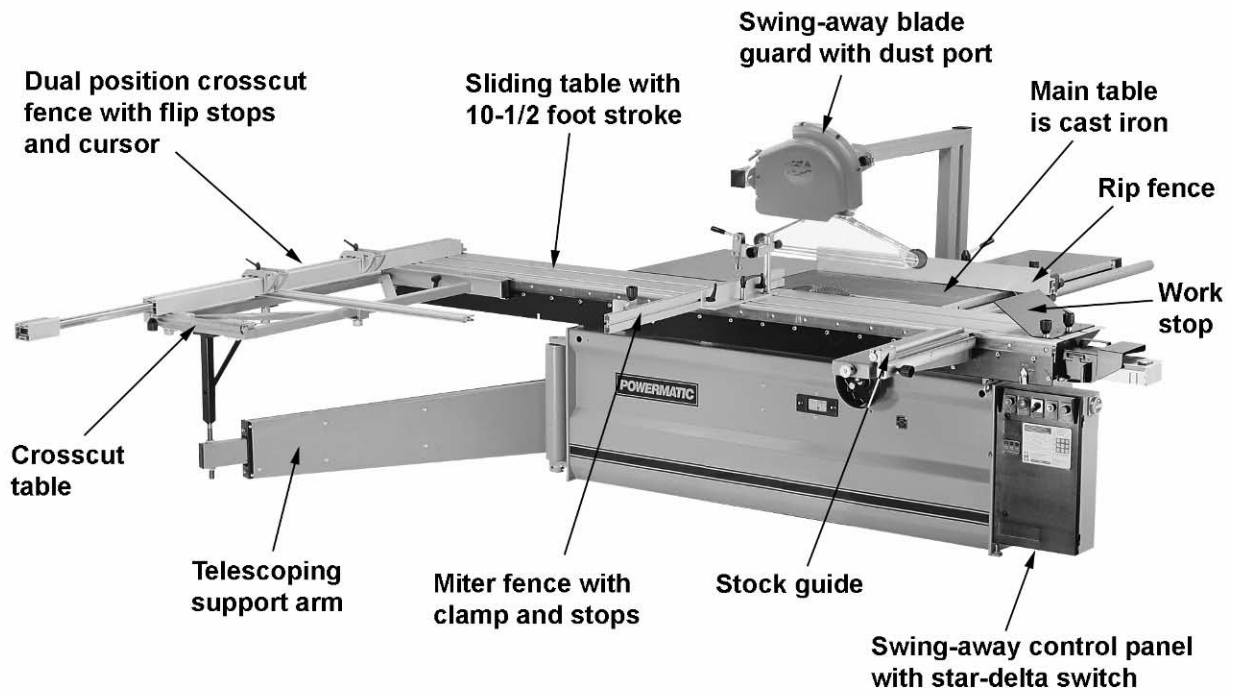


Figure 2

# Receiving

Remove crate from around machine and check for shipping damage and make sure all parts are intact. Report any damage immediately to your distributor and shipping agent. Read this instruction manual thoroughly for assembly, alignment, maintenance and safety instructions.

## Contents of crate:

### crate # 1:

- 1 saw body
- 1 warranty card
- 1 manual

### crate # 2:

- 1 sliding table
- 1 crosscut fence
- 1 crosscut table
- 1 overarm
- 1 guard assembly
- 1 rip fence assembly
- 1 large work stop
- 3 arbor wrenches
- 1 steel pin
- 1 miter fence assembly

Unpainted surfaces, such as the cast iron table, have been given a protective coating at the factory. This should be removed with a soft rag moistened with a good commercial solvent. Do not use acetone, lacquer thinner, gasoline or any flammable solvents. Do not use an abrasive pad.

# Installation and Assembly

## Tools required:

- forklift or hoist, with slings and steel rods
- 3 arbor wrenches (provided)
- 1 steel pin (provided)

1. Place steel rods (A, Figure 3) through the three holes in the machine frame. The machine can then be lifted off the pallet with hoist or forklift, by using slings passed under the rods. When the machine is sitting on the ground, it can be lifted by removing the bottom cover plate and sliding forks under the two openings (B, Figure 3).

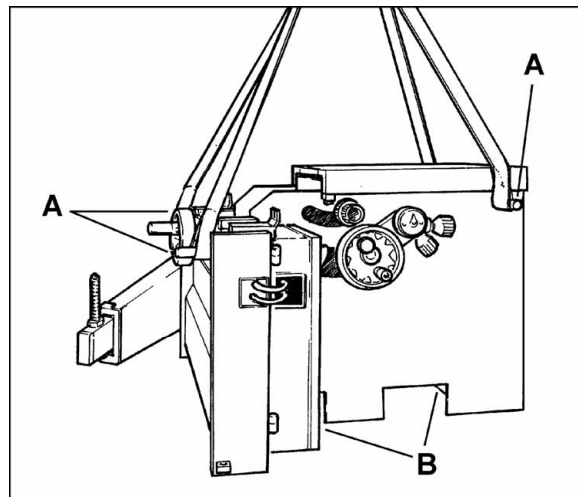


Figure 3



- When the machine has been placed in the intended location, it must be leveled in both directions to ensure smooth motion of the sliding table. Two leveling bolts must be inserted at the bottom of the frame before the machine is placed on the floor – one bolt under the pivot of the telescopic arm, and the other bolt under the electrical control panel. See Figure 4. These bolts must be positioned with bolt head upside down.

## Electrical Connections

**⚠WARNING** Electrical connections must be made by a qualified electrician in compliance with all relevant codes. The machine must be properly grounded to help prevent electrical shock and possible fatal injury.

- Make sure the voltage of the machine corresponds with the power supply voltage.
- Remove the electrical control panel cover with a hex wrench and introduce the cable, shown in Figure 5.
- Connect the three wires to the terminals L1, L2, L3. See Figure 6. If there is a neutral conductor (blue) it must be connected to the terminal N. Connect the ground wire (green) to the terminal marked with the ground symbol PE.
- Turn on the main saw motor (see "Starting the Machine" on page 14) and check that the blade arbor rotates clockwise (as viewed from front of machine). If rotation is wrong, turn motor off, disconnect from power source, and exchange wires L1 and L2.

## Installing Sliding Table

The position of the sliding table relative to the machine is factory set; after mounting it, the only adjustment will be making sure it is parallel with the saw blade.

- Disconnect machine from power source.
- Use a hoist or forklift with slings to lift the sliding table from its crate. Place the sliding table on to the frame with the two lateral adjustment bolts (A, Figure 7) in the two lugs placed at the front of the frame.
- Place the four socket head cap screws (B, Figure 7) into the lower section of the sliding table. NOTE: Prevent the table from flipping over when sliding away the upper section of the sliding table.
- Tighten firmly the four socket head cap screws (B, Figure 7).

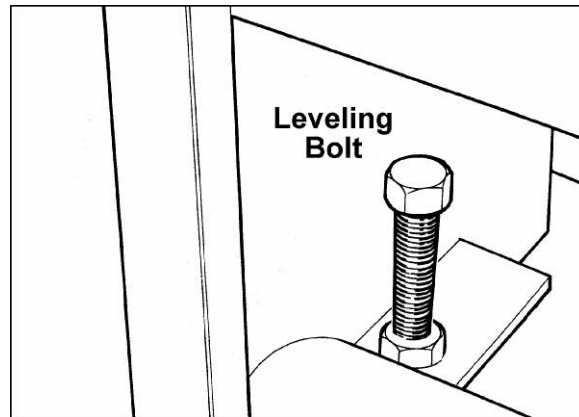


Figure 4

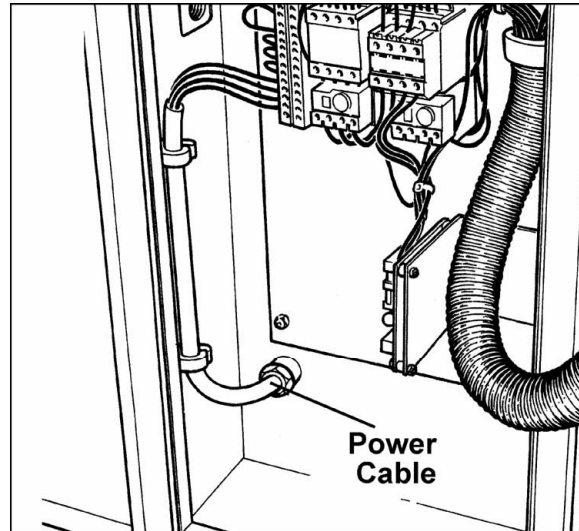


Figure 5

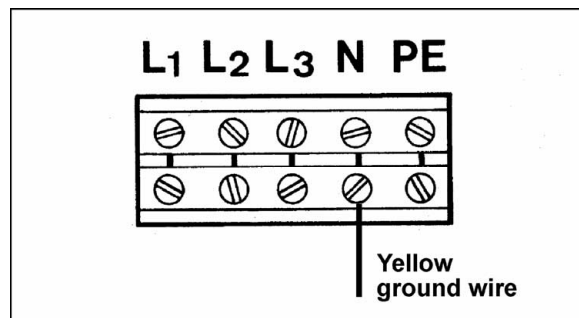


Figure 6

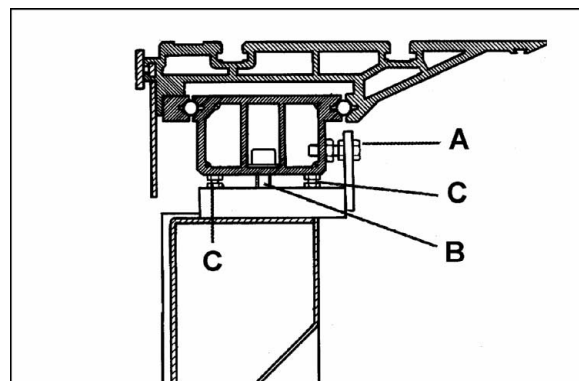


Figure 7

- The eight small height-adjustment bolts (C, Figure 7) are pre-set at the factory.

To ensure a clean and straight cut, the sliding table must be set parallel to the blade. Proceed as follows:

- Unlock the four socket head cap screws (B, Figure 7) and adjust with one of the two parallel adjustment bolts (A, Figure 7).
- Tighten the four cap screws (B, Figure 7) with a torque of 60 foot pounds (80Nm).

### Installing/Replacing Main Blade

**CAUTION** Use care when working with and around sharp saw blades. Use only carbide tip saw blades, not high speed steel blades.

*NOTE: A blade is not included with the panel saw.*

- Disconnect machine from power source.
- Move the sliding table completely to the left, out of the way of the blade area.
- Release the two latches on the blade cover, shown in Figure 8, and open blade cover.
- Raise main blade arbor to its highest position and place wrench (C, Figure 9) over the arbor nut (A, Figure 9).
- Insert the steel pin (B, Figure 9) into the hole in the cast iron table. Turn the arbor with the wrench until the steel pin (B, Figure 9) engages the hole in the arbor pulley.
- Remove the nut (NOTE: Left hand threads – loosen by turning clockwise) and flange.
- Ensure new blade and flanges are clean, then mount new blade and flange, and tighten arbor nut securely. The blade and flange must slip over the two pins (Figure 10). This provides positive drive to the blade, and prevents the hex nut from loosening when the arbor rotation is halted by the motor brake.

**WARNING** All main saw blades used on this panel saw must have two additional holes in the blade body to accommodate the pins.

- Remove steel pin (B, Figure 9). Close cover and secure both latches (Figure 8).

**SAFETY TIP:** Tape a red rag on to the locking pin and drape it over the blade while pin is inserted. This will remind you to remove the pin before starting the saw.

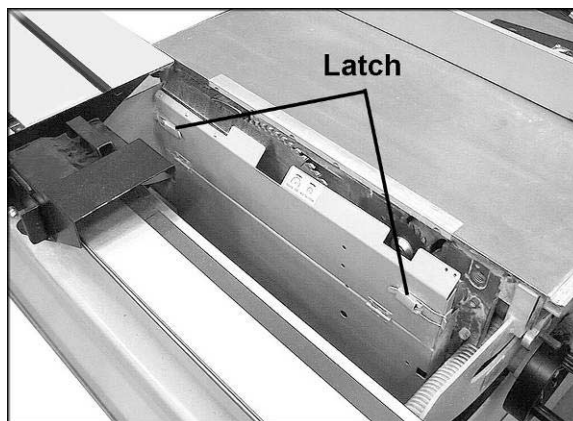


Figure 8

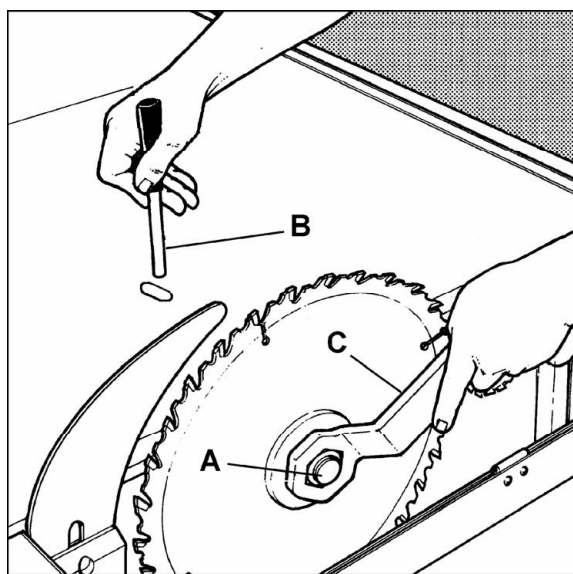


Figure 9

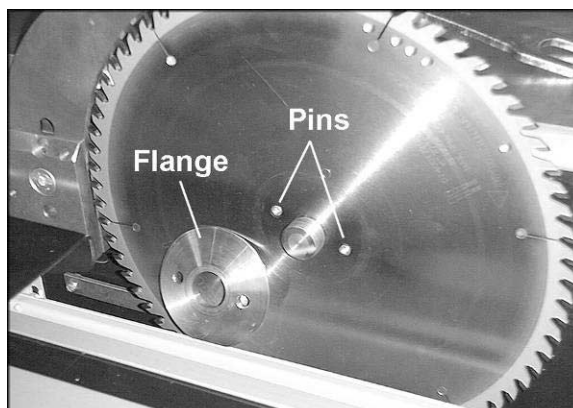


Figure 10

## Installing/Replacing Scoring Blade

1. Disconnect machine from power source.
2. Tilt scoring blade arbor to the left, and place open end flat wrench (A, Figure 11) on the flat of the arbor.
3. Remove socket head cap screw with the hex wrench (B, Figure 11). NOTE: Left hand threads – turn clockwise to loosen.
4. Mount scoring blade and re-tighten screw while holding arbor with the flat wrench.

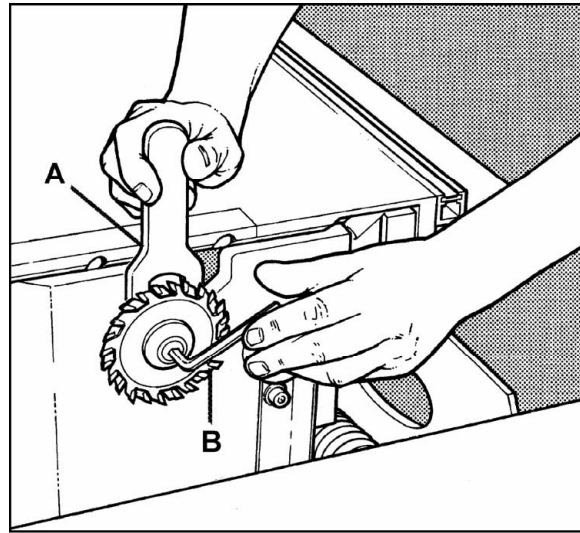


Figure 11

## Riving Knife

The panel saw is equipped with a riving knife for use with saw blades from 250 to 300mm and 350 to 400mm diameter. The riving knife (or "splitter") helps guide the cut, keeps the kerf from closing, and prevents the workpiece from being pinched by the upward running teeth at the back of the blade, thus greatly reducing the possibility of kickback.

**⚠WARNING** Do not remove the riving knife for saw operations.

The riving knife (A, Figure 12) can be adjusted in both a vertical and horizontal direction. The highest point of the riving knife must never be more than 3mm above the highest saw tooth in the wood.

The gap between blade and knife must be a minimum of 0.3 mm and maximum of 0.8 mm evenly across the blade.

Loosen the central bolt (B, Figure 12) and use the three adjustment screws (C, Figure 12) for precise setting of the knife. After adjustment, always tighten the central bolt (B, Figure 12).

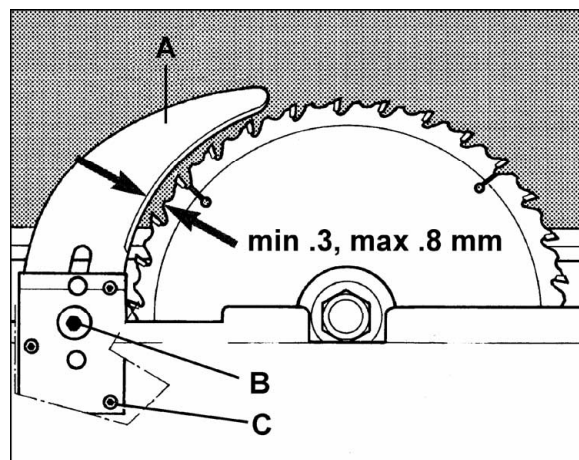


Figure 12

## Installing Over-Arm

Mount the over-arm with four socket head cap screws to the holes on the side of the frame. Tighten screws securely.

## Installing Blade Guard

Mount the upper guard assembly (Figure 13) to the over arm with two M10x80 socket head cap screws, two M10 flat washers, and an M10 hex nut (A, Figure 13).

Install the blade guard using the bolt (B, Figure 13).

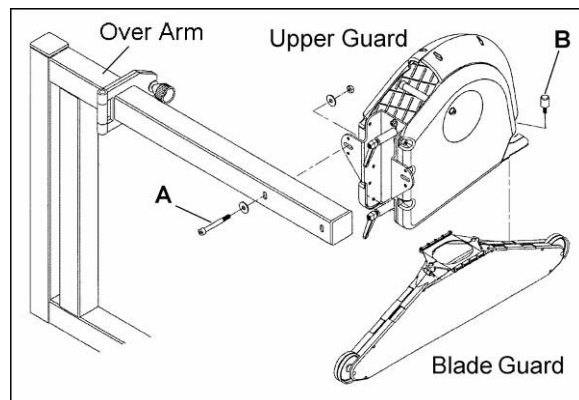


Figure 13

## Crosscut Table

The crosscut table can be slid from the left to the center of the sliding table via the flat bar on the side of the sliding table. NOTE: The crosscut table can only move to the center of the sliding table – the telescoping support arm is too short to allow it to be set at the right of the sliding table.

Both telescoping support arm and cross-cut table are factory set and require no adjustment.

To install the crosscut table:

1. Place the crosscut table on to the edge of the sliding table as shown in Figure 14.
2. Position the two brackets so that the crosscut table will move easily along the sliding table.
3. Lock the position of the crosscut table by tightening the handle.

NOTE: The black handles are adjustable. Simply pull up on the handle, rotate it on the pin, then release, making sure the handle re-seats itself on the pin.

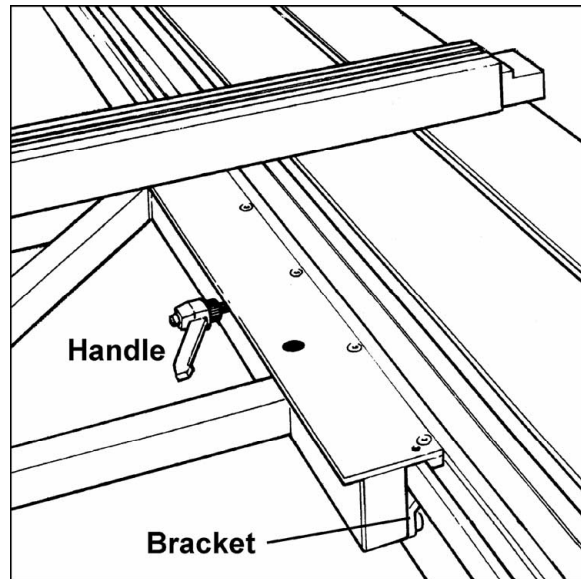


Figure 14

## Crosscut Fence

1. The crosscut table has four holes allowing the fence to be placed in two positions: at the left or right of the crosscut table. Place the fence on to the crosscut table as shown in Figure 15, and lock it in position with the two serrated handles.
2. Before operating, the scale on the crosscut fence must be calibrated. See "Crosscut Fence Calibration", pages 17-18.

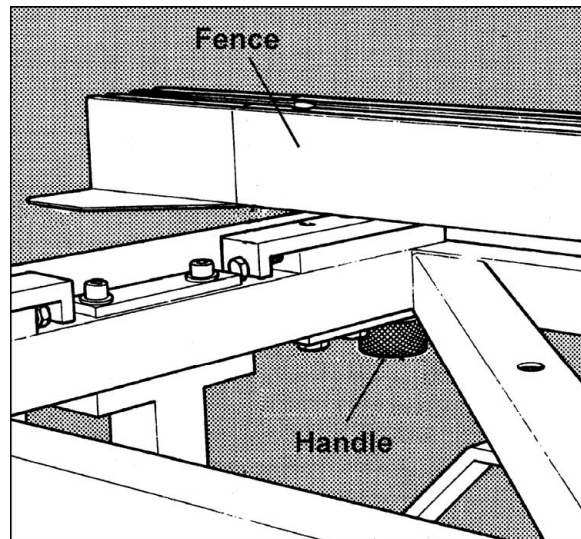


Figure 15

## Roller Support

1. Mount the hinge plate (A, Figure 16) of the roller support to the frame using the two bolts (B, Figure 16).
2. The roller must be adjusted to the height of the saw table by loosening the knob (C, Figure 16).
3. The entire support can be swung aside by loosening lower knob (D, Figure 16)
4. To remove the roller support, simply lift it off its hinges.

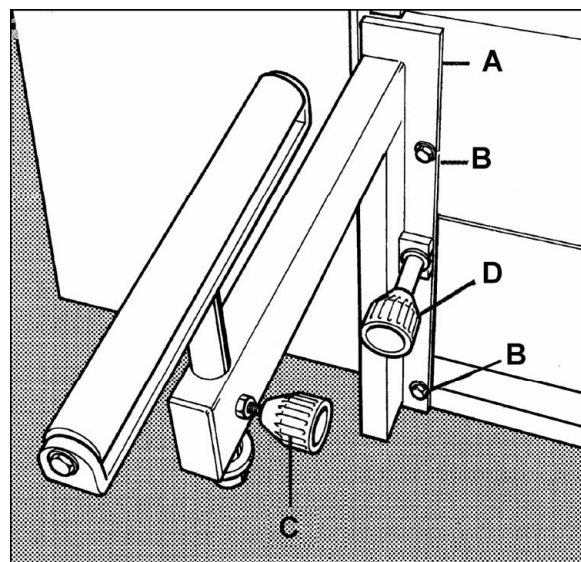


Figure 16

## Guide Bar

1. Mount the scale (Figure 17) to the edge of the cast iron table with six M6 x 16 socket head cap screws and six square nuts.
2. Mount the cylindrical steel guide bar to the edge of the cast iron table, using four M12 hex nuts and flat washers.
3. The outside edge of the guide bar along its entire length should be approximately 2-1/2" from the table, to allow for smooth movement of the fence.

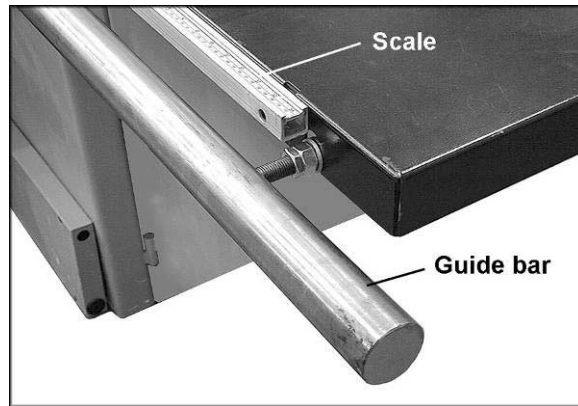


Figure 17

## Rip Fence

The rip fence assembly (Figure 18) has a cast iron body with a sliding aluminum fence. Mount the body by sliding it on to the end of the guide bar while lifting the handle. Loosen the fence lock and slide the aluminum fence on to the body as shown.

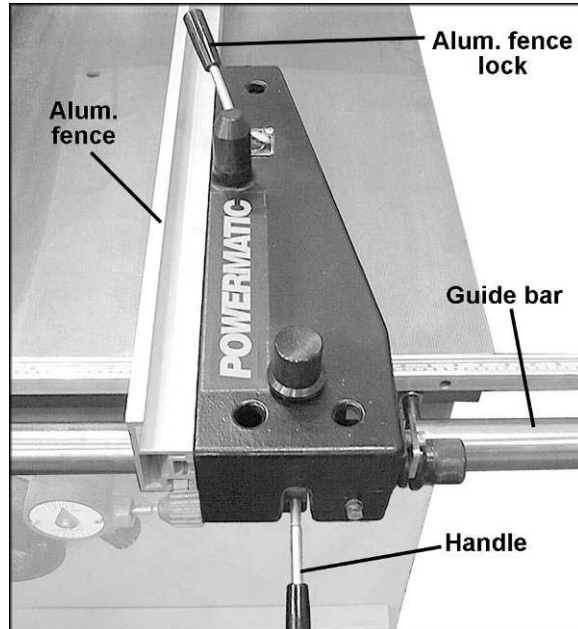


Figure 18

## Work Stop

Mount the work stop to the two T-nuts in the channel of the sliding table, as shown in Figure 19. The work stop can be slid to any spot on the table and secured by tightening the two knobs.

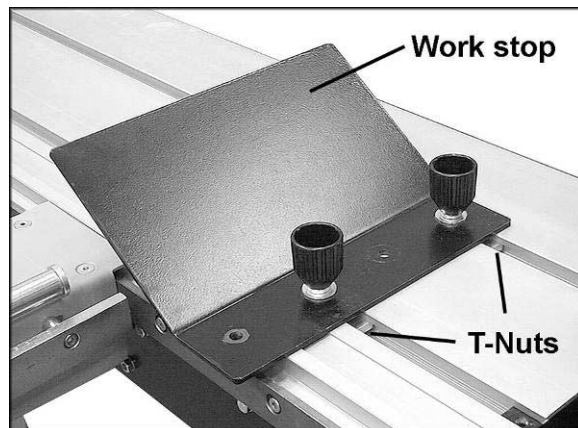


Figure 19

## Guide Table

Mount the guide table (Figure 20) onto the edge of the sliding table and secure it in place with the knurled nut.

The adjustable stock guide can be moved along the rail and secured by tightening the knob.

## Starting the Machine

NOTE: The machine will not start if the blade cover or the rear door is open.

Figure 21 shows the control panel and the function of the buttons. Follow this procedure to start up the panel saw in Star-Delta operation:

- 1 – Turn main switch to position "1".
- 2 – Put star-delta switch into "Y" position.
- 3 – Push main motor start switch.
- 4 – After five seconds, switch star-delta to "Δ" position. (The five second delay is necessary to let the motor reach full speed before switching over to delta.)
- 5 – Start scoring motor (main motor must be running).
- 6 – Push emergency stop to halt both main and scoring blades. Or push scoring motor stop button to halt only scoring motor.

**CAUTION** If you forget to switch over from "Y" to "Δ", the motor will reach full speed but will have no power, and will be damaged during operations.

The main motor is equipped with an automatic brake which stops the motor within 10 seconds as soon as the machine is shut off.

An additional emergency stop button is located on the right side of the frame (in the rip fence area). It halts both main and scoring motors.

Fuses are located inside the electrical control panel. The machine must be disconnected from power supply when opening this panel.

This machine has overload protection on both main and scoring motors. Should the motor be shut off by one of these protectors, wait a few minutes until the overload has cooled down before restarting.

The entire control panel can be pivoted for convenience. Simply open the panel cover and release the screws securing it to the machine frame. It will now swing upon the hinges.

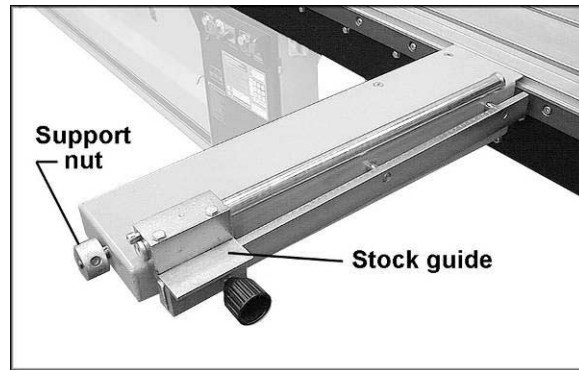


Figure 20

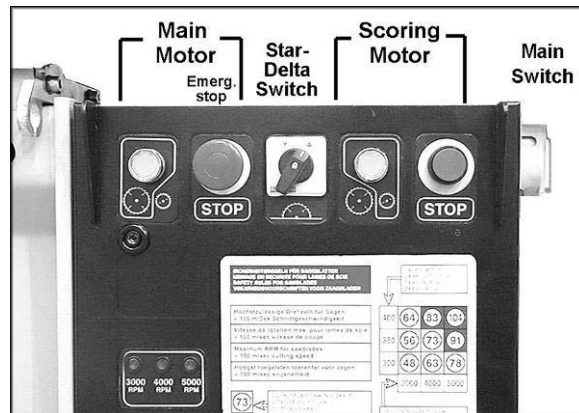


Figure 21

## Dust Collection

It is strongly recommended that a dust collection system be connected to the HPS126. The dust collector should have sufficient capacity for this size machine. Both the outlet on the blade guard (3" diameter outlet) and on the machine base (4" diameter outlet) should be connected to the dust collection system.

## Adjustments

### Setting Main Blade

The controls for blade setting are shown in Figures 22 and 23.

1. Adjust the height of the main blade with the handwheel on the side of the machine (Figure 22). One rotation of the handwheel raises or lowers the blade by 3/16".
2. The blade is tilted by using handwheel on front of machine (Figure 23). The blade can be tilted at any angle between 90 and 45 degrees. After setting, lock the blade in this position with the lock knob. The angle can be read on the indicator.

NOTE: The 90 and 45 degree stops are pre-set at the factory and should require no adjustment. Whenever the main blade has been set at the desired cutting angle, the cutting depth of the scoring blade must be re-set.

### Setting Scoring Blade

(Figures 22 & 23)

1. Turn the scoring blade height knob. One turn raises or lowers the scoring blade by 3mm.
2. Each time the main saw blade is replaced by a new one, or the current blade has been resharpened, the scoring blade must be adjusted to match the width of the main blade teeth. This must be done to ensure a clean cut free of splintering. Lateral movement is obtained by turning the lateral adjustment knob, then locking it at the desired setting.
3. After lateral adjustment, the indicator should be set to "0".

Figures 24 and 25 show the different possibilities for scoring blade setting:

- 1 – Without the use of a scoring blade
- 2 – Correct alignment of blade but too deep
- 3 – Too much to the right side
- 4 – Correct setting of the scoring blade

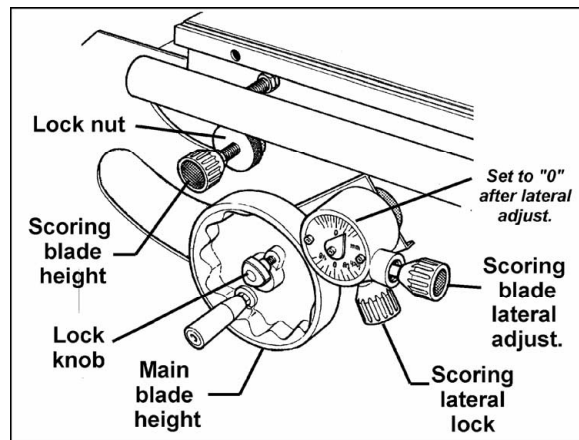


Figure 22

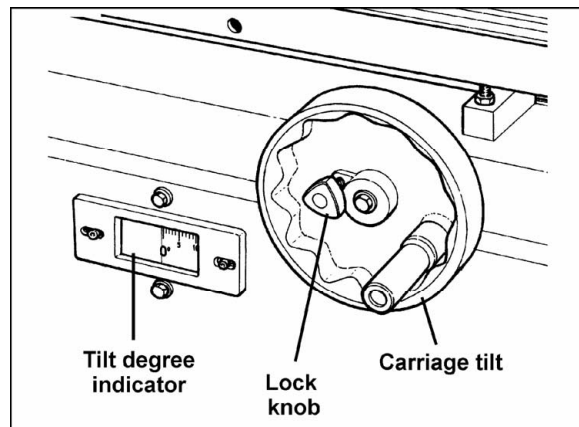


Figure 23

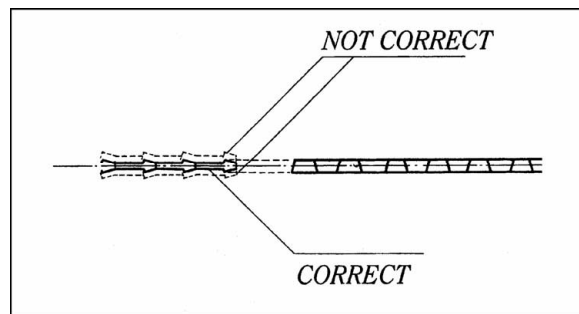


Figure 24

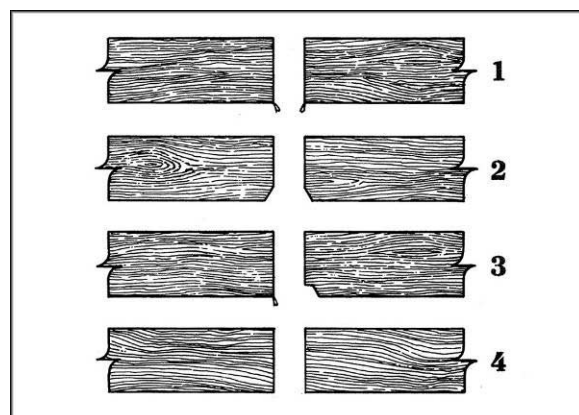


Figure 25

## Setting Blade Guard

The two handles (Figure 26) are for setting the guard height limits. Loosen a handle and slide the bracket as needed. Both handles on the guard should be tightened securely before operating the panel saw.

When the arbor is tilted for a bevel cut, mount the alternate lower guard with the convex back (Figure 26).

**⚠WARNING** When bevel cutting, make sure the appropriate blade guard has been mounted before operating the saw.

## Sliding Table Lock

When loading panels and when cutting using the rip fence, the sliding table should be locked. There are two different systems to achieve this:

When loading a panel onto the sliding table, to prevent the table from sliding away from the operator:

1. Turn the indicator (Figure 27) to "B". Slide the table to the right and it will automatically lock in this position.
2. To unlock the table, pull the handle toward the right and turn indicator to "A".

If the sliding table refuses to lock properly via the indicator, it may need adjusting:

1. Behind the indicator, on the underside of the table, use a 4mm hex wrench to loosen the set screw on the collar. Compress the spring approximately one inch so it will not interfere with the indicator cam.
2. Pull sliding table all the way to the right until the sliding table locks.
3. Loosen the hex nut (Figure 27) and slowly tighten it toward the edge of the table; as the hex nut turns it pulls the locking rod. Tighten the hex nut until the table unlocks.
4. Hold indicator to position "A" and loosen the set screw on the collar so that the collar once again rests against the indicator cam. Tighten set screw.
5. Move hex nut back toward the lock handle and tighten it.

To secure the sliding table while cutting with the rip fence:

1. Pull the lock lever (Figure 28) and engage it in one of the three slots on the edge of the sliding table.
2. To unlock the table, push in the lever.

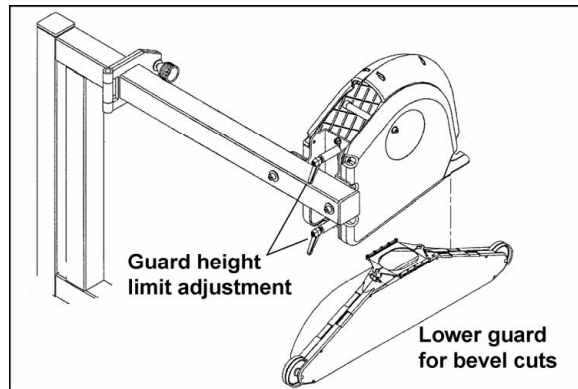


Figure 26

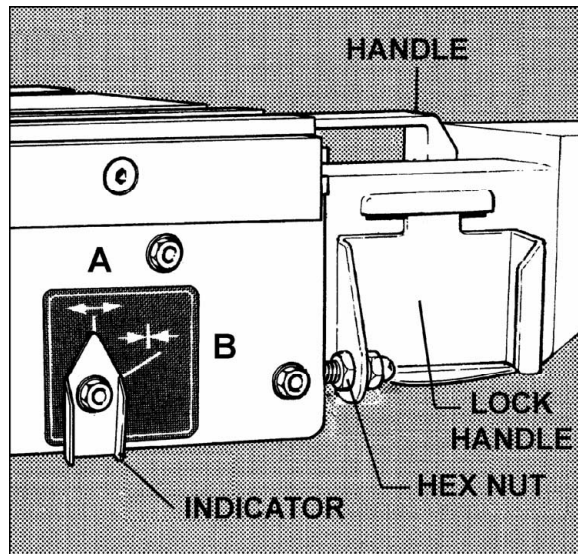


Figure 27



Figure 28



Over a long period of time, if many short movements of the sliding table are made (e.g. crosscutting solid wood) it is possible that the ball carrier between the upper and lower part of the sliding table will move. This means it will no longer be correctly positioned to allow the sliding table to slide through its full course. The operator will feel resistance in the sliding table motion and the full stroke will not be achieved.

This effect can be corrected simply by pushing the table with a few short, light pushes against the buffer stop at the end, until the position of the ball carrier is adjusted and the table can be moved again along its full stroke.

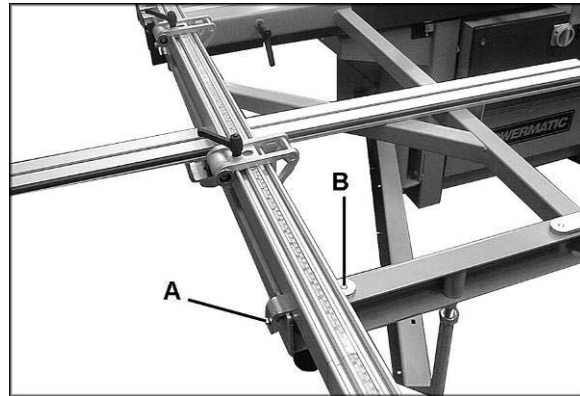


Figure 29

### Crosscut Fence Calibration

The 90-degree angle of the fence is factory set. However, should adjustment ever be needed, proceed as follows:

1. Loosen the two bolts (A, Figure 29).
2. Turn bolt (B, Figure 29) to open or close the angle of the fence in relation to the saw blade.
3. Re-tighten bolts (A, Figure 29).

Before using the first time, and each time a new blade is installed, the scales must be calibrated. Proceed as follows:

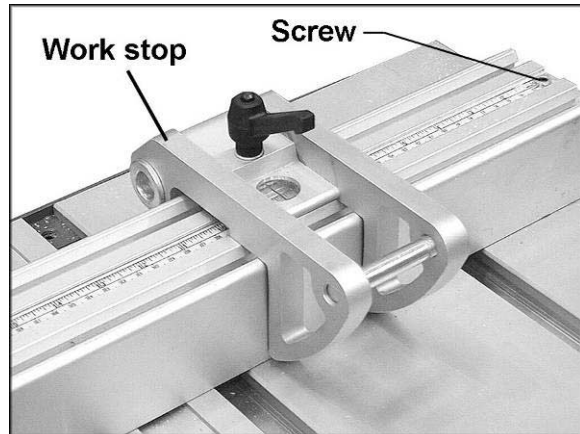


Figure 30

1. Put the work stop (Figure 30) at a certain measure and cut off a sample.
2. Measure the exact length of the sample. Loosen the screw (Figure 30) which holds the scale and move the scale until the measurement corresponds to the length of the previously cut sample. The main part of the fence is now calibrated to the saw blade.
3. The scale on the telescopic extension of the fence should now be checked and adjusted. Move the other stop to the outermost edge of the extension fence until the edge of the stop is flush with the edge of the fence (Figure 31). Lock the stop in position by tightening the handle.

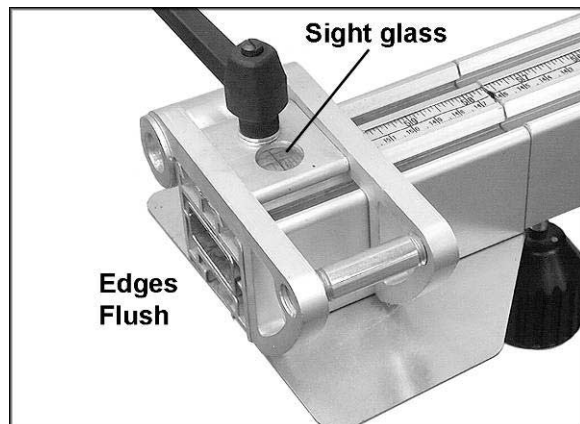


Figure 31

NOTE: DO NOT loosen the stop until the adjustment procedure has been completed.

4. Record the measurement in the sight glass of the work stop.
5. Add 2" to this measurement and slide out the extension until the new measurement is read at the end of the fixed fence (Figure 32). NOTE: Be careful to set this correctly, because the scale on the sliding fence reads opposite the scale on the fixed fence.

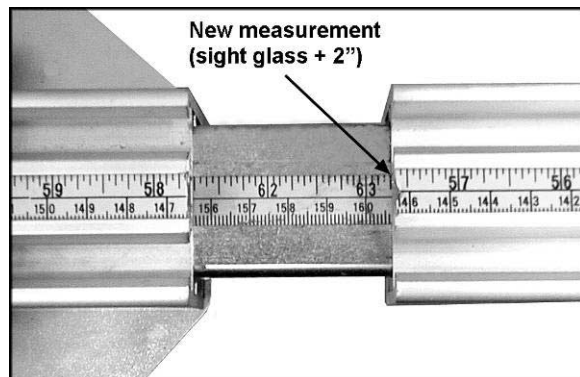


Figure 32

6. Lock the extension fence to this new measurement by tightening the knob underneath.
7. With a 3mm hex wrench, loosen the set screws underneath the short movable fence extrusion (Figure 33), and slide the extrusion to 2" of the fixed fence (Figure 34). Tighten the set screws.
8. When using the telescopic extension, make sure the stop is positioned flush with the end of the movable extrusion.
9. The best way to check if all scales correspond is to make several test cuts on the different scales.

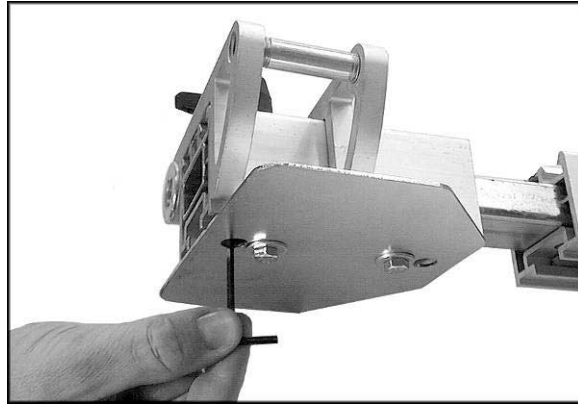


Figure 33

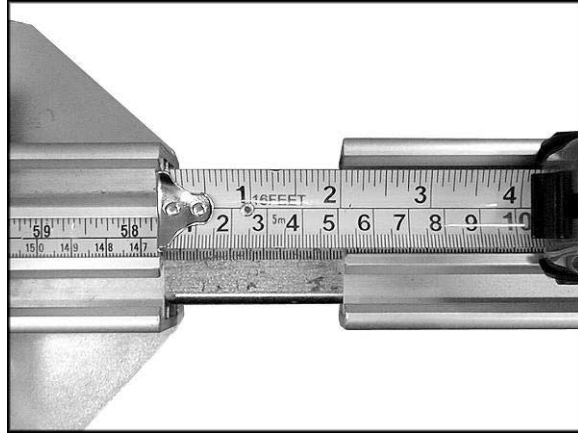


Figure 34

### Wood Cap

After a period of use, if the wood protection cap at the end of the crosscut fence is cut away, a new one must be made. See Figure 35 for the correct dimensions.

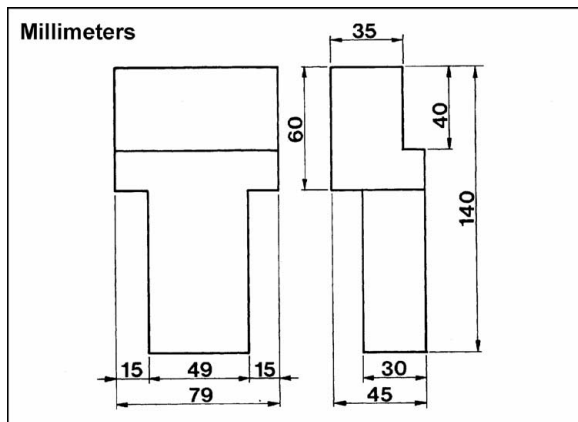


Figure 35

### Miter Fence

**IMPORTANT:** The flat T-nut, which is in the groove of the sliding table and which holds the vertical rod of the clamp, is factory set and must remain in its position to make the angle scale correspond.

1. To set the required angle, unlock the rod of the clamp (A, Figure 36) with the provided tool, and loosen the handle (B, Figure 36).
2. To slide the fence (C, Figure 36) toward or away from the saw blade, loosen the two smaller handles (D, Figure 36).
3. Reading the angle is done at the edge of the aluminum bracket. An adjustable stop can be mounted to the miter fence as shown in Figure 36, for making multiple cuts of the same length.
4. Re-tighten all handles before operating.

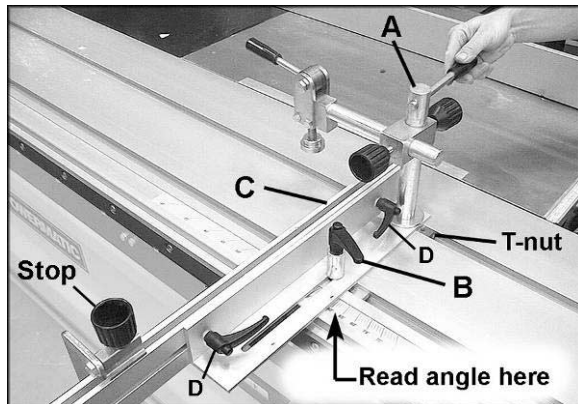


Figure 36

## Rip Fence

1. To move the rip fence, shown in Figure 37, turn the micro adjust gear counterclockwise, and lift the handle. The fence should slide freely on the guide bar.
2. To lock the fence in position, push the handle down and tighten the micro-adjust gear by turning it clockwise.
3. Micro-adjustment is achieved by locking the micro adjust gear, by holding the handle in the upright position, and by turning the micro-adjust knob.
4. After adjustment, push handle down to lock the fence in place.

NOTE: When cutting small workpieces with the saw blade tilted at 45 degrees, the aluminum rip fence should be used in the low position:

1. Loosen the aluminum fence lock, slide the fence off and slide it back on in the low position, as shown in Figure 38.
2. Tighten the aluminum fence lock.

When cutting solid wood using the rip fence, to avoid the wood getting stuck between the fence and riving knife (which can result in a dangerous kickback) re-position the aluminum fence so its end protrudes just past the end of the riving knife.

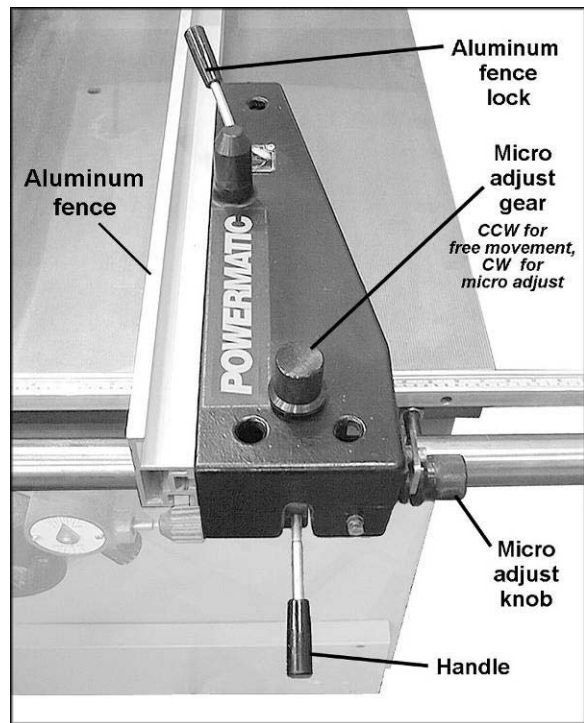


Figure 37

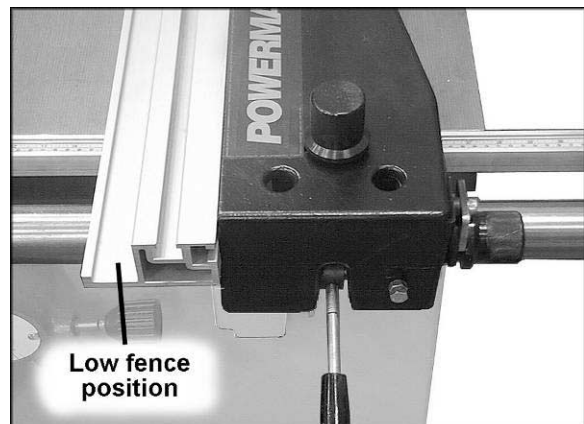


Figure 38

## Rip Fence Scale Calibration

Each time a new blade is mounted, the rip fence scale has to be calibrated to the new blade.

1. Cut a sample and measure its exact length.
2. Loosen the screw on the scale, shown in Figure 39. To avoid the fence contacting the rotating saw blade, the stop ring has to be adjusted.
3. Slide the fence to about 10 mm from the saw blade.
4. Slide the stop ring across the round guide bar until it comes up against the casting of the fence. Tighten the set screw on the stop ring.

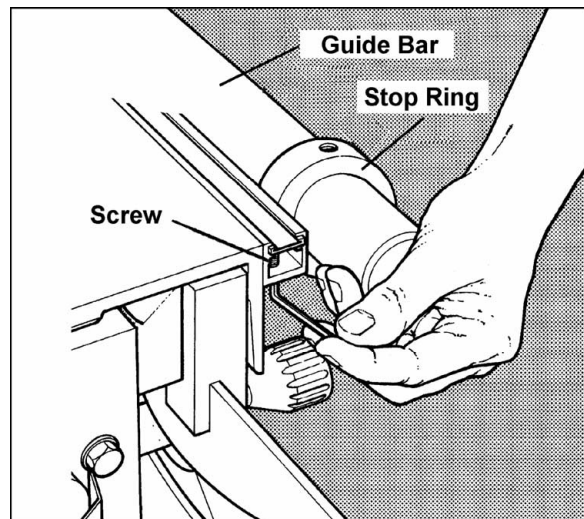


Figure 39

## Belt Tension and Speed Change

To tighten the belt on the main motor:

1. Pull and turn handle (A, Figure 40) to the left to loosen the belt. Slip the belt into the appropriate pulley groove. Check the indicator (C, Figure 40) for correct position.
2. Make sure the belt is positioned well into the pulley's groove.
3. Adjust the tension by pulling and turning handle (A, Figure 40) to the right, and engaging it into the serrated span sector (B, Figure 40).

**CAUTION** Make sure the belt is not over-tensioned as this may lead to damage to the saw arbor and belt.

To tighten the belt on the scoring motor:

1. Loosen the two nuts (D-Fig. 41) which hold the scoring motor, and push the motor down.
2. While pushing the motor down, tighten the two nuts.
3. If the belt needs replacing, make sure the new belt is fully seated in the grooves of both pulleys.

## Precision Tuning Your Panel Saw

Your HPS126 is a precision machine designed to give accurate performance over many years. But like all fine equipment, it can only meet the tight tolerances required if it is tuned correctly.

Your machine has been so designed that all the major parameters which influence the quality of cut can be adjusted by non-technical staff.

These tuning procedures should be carried out in the proper order, as later adjustments depend upon the earlier being correct.

The four steps of the procedure are:

1. Free Cut from blade to sliding table
2. Free Cut from blade to rip fence
3. Square Cut
4. Scoring Blade

### Free Cut (Blade to Sliding Table)

The sliding table does not run exactly parallel to the saw blade. It runs away from the back teeth by a fraction of a millimeter. This is called "free cut."

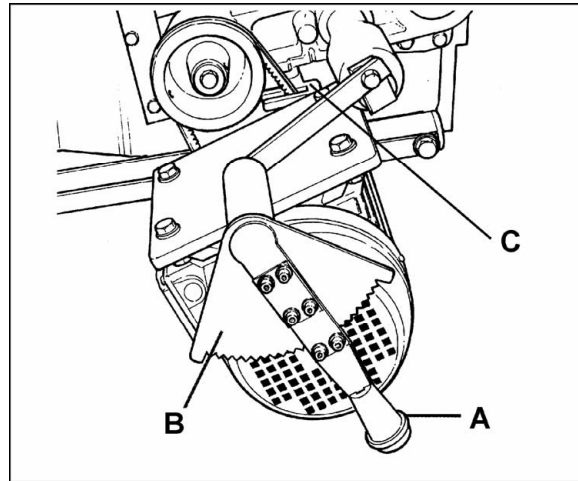


Figure 40

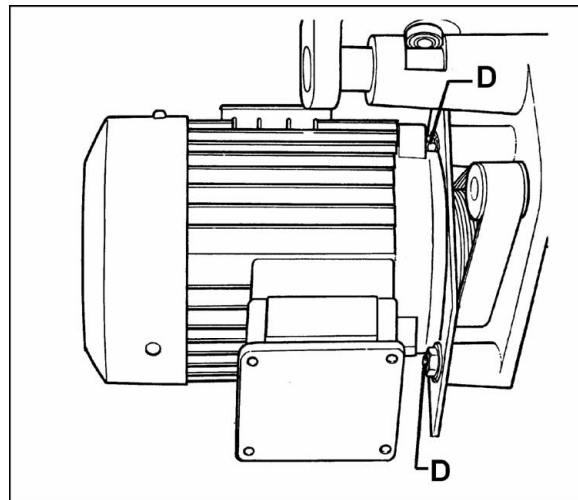


Figure 41

A very slight amount of free cut is desirable to avoid the problems of back cutting due to saw blade flutter. All saw blades vibrate to some extent. They flutter less at the front, where the cutting teeth are held stable by the material, than at the back.

If the table were set absolutely parallel to the saw blade, the back teeth could contact the material and spoil the clean cut achieved by the front teeth. As the back teeth are ascending, they could cause chip out on the top surface of laminated boards.

The free cut required is less than 0.05 mm over one meter of travel.

A dial indicator is not required. You can use your ears to compare the noise of the front teeth with that of the back teeth. To do this will require a workpiece shorter than the distance between front and back teeth. The saw blade should be raised to its maximum height to achieve the most contrast.

1. Lay the workpiece against the crosscut fence and make a cut.
2. Hold the workpiece firmly after the front teeth have cut and push it on past the back teeth. As you pass the back teeth you should feel rather than hear a slight tingling or whisper. If there is no sound from the back teeth, you probably have too much ("positive") free cut. If the noise from the back teeth is similar to that of the front teeth, there is too little ("negative") free cut and the table is running in towards the back of the blade.
3. Having passed the back teeth, stop level with the riving knife and cut backwards. The back teeth will make a noise as they are now cutting the material.

**⚠WARNING** The workpiece must be held down firmly when making this backward cut.

4. As you continue past the front teeth, the noise from the front teeth should be equal to or slightly less than the noise from the back teeth. Slight back cutting on the backstroke equals slight free cut on the forward stroke.
5. If the front teeth make more noise than the back, the free cut is positive; if they make no noise, the free cut is negative. If the noise relationship front teeth to back teeth on the forward stroke is the same as the noise relationship back teeth to front teeth on the back stroke (on a scale of 100, 100/30 in each case), the sliding table is running exactly parallel to the blade (zero free cut).

To correct the free cut, one end of the sliding table must be moved outward or inward. It doesn't matter whether you move the left or the right end. The only consideration is that there is enough clearance between the sliding table and the fixed cast iron table at the end you are moving.

1. At the end you have decided to move, loosen the hex nut (A, Figure 42) holding the sliding table to the frame.

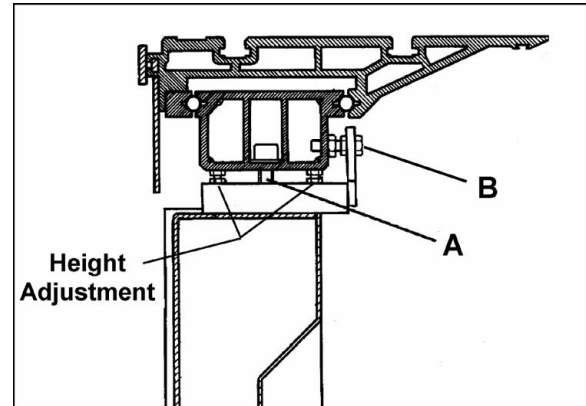


Figure 42

2. Loosen the other two hex nuts in the middle of the sliding table so that the table will pivot at the remaining fixed end.
3. Move the table end in or out as needed, then re-tighten the table mounting nuts.
4. Check again to confirm the free cut is satisfactory. Repeat the process if needed.

NOTE: The sliding table should be approximately 0.3 mm higher than the fixed cast iron table (thickness of a piece of paper). This is pre-set at the factory, but if adjustment should ever be needed, use the four height adjustment bolts (Figure 42) on each end of the table.

### Trouble-shooting Free Cut (Blade to Sliding Table):

#### Symptoms of positive free cut:

Back cutting on rip fence side. Workpiece on cast iron table pulled into back of sawblade.

Chip out on top.

Machine cutting out of square. Workpiece moves slightly on sliding table due to pressure of saw blade, without operator noticing.

Scoring saw correctly aligned for sliding table is out of alignment on rip fence side, and vice-versa.

Chip out on the bottom as alignment of scoring saw with main blade inconsistent due to movement of workpiece.

#### **Symptoms of negative free cut:**

Back cutting on sliding table side. Workpiece runs into back of saw blade. Chip out on top.

Machine cutting out of square. Workpiece moves slightly on sliding table due to pressure of saw blade, without operator noticing.

Chip out on the bottom as alignment of scoring saw with main blade inconsistent due to movement of workpiece.

NOTE: The above test depends upon the riving knife being properly in line with the blade.

#### **Free Cut (Blade to Rip Fence)**

If the free cut on the rip fence side is negative, the symptoms are fairly obvious. The workpiece gets stuck between the back teeth and the fence and, in the worst case gets kicked back.

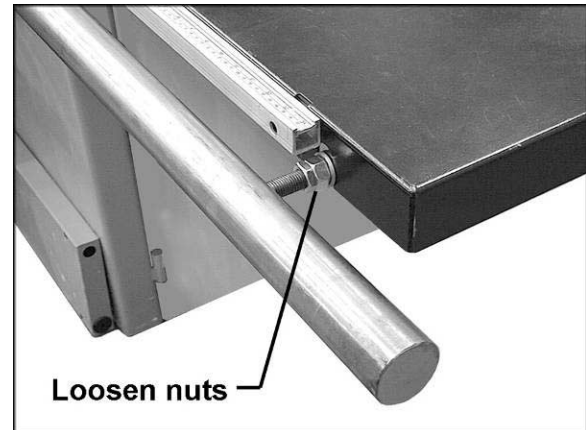
If the free cut is positive, other problems arise which are not so easily recognized, as for example, an incorrect rip fence setting. The following procedure will help you compare the distance between front teeth and rip fence with the distance between back teeth and rip fence:

1. Lower scoring blade all the way down, and out of the way.
2. Raise main blade to its highest position.
3. Take a workpiece of convenient size (e.g. 12" x 18") and edge one long side using the sliding table.
4. Set the rip fence slightly narrower than the workpiece, and cut the opposite long side of the workpiece using the fence.
5. Stop the workpiece when the trailing edge is level with the riving knife (i.e. has passed the back teeth.)
6. Using the rip fence micro adjustment, move the rip fence 1/4 turn inward, and pull workpiece backward almost to sawblade middle. The back teeth will then cut, and where they have cut, the workpiece width will correspond to the distance between the back teeth and the rip fence.
7. Remove workpiece in normal cutting direction.
8. Flip the workpiece over so that the trailing edge becomes the leading edge and feed into the saw blade for half the direction which the back teeth just cut. The width here will correspond to the distance between the front teeth and the fence.

Between the teeth marks from the back teeth and front teeth there will be a small ridge. The height of this ridge is the free cut over the length of the saw blade. This ridge should hardly be visible, but just possible to feel.

#### **To correct the free cut:**

Loosen the nuts on the outside (third) bolt holding the guide bar on which the rip fence slides. See Figure 43.



*Figure 43*

Move the bar, and therefore the fence, in or out by pivoting it upon the second bolt.

When corrected, tighten outside (third) bolt.

#### **Trouble-shooting Free Cut (Blade to Rip Fence)**

##### **Symptoms of negative free cut:**

Workpiece gets jammed between fence and back of saw blade, danger of kickback.

Backcutting, top chip out to the right of blade.

##### **Symptoms of positive free cut:**

Backcutting to the left of saw blade. Workpiece on left is pulled into back teeth. Chip out on top.

Scoring saw, while correctly aligned on sliding table side, is out of alignment for ripping.

When the rip fence section is in a pulled back position, the actual width cut is less than that shown on the scale.

NOTE: The above check depends on the riving knife being in line with the blade, not bent, narrower than the tooth kerf and wider than the body of the blade.

## Square Cut

1. Take a panel approximately 40" and cut five times round, always turning the cut edge up against the crosscut fence (counter-clockwise with crosscut fence in normal position). The fifth cut cuts the same edge as the first.
2. The last offcut strip (whose left side was the last cut and whose right side was the first cut) must be the same width at both ends if every corner was precisely 90 degrees. Any error in the squareness has been multiplied four times.
3. Break the strip and lay the ends side by side and check the difference. (Break the strip in such a way that you know afterward which was front and which was back; e.g. front bit short, back bit long).

Unlike other methods of checking for squareness, this system tells you which way to move the fence should adjustment be necessary. It depends upon the shape of the fifth offcut strip:

If front thick, back thin – move fence counter-clockwise.

If front thin, back thick – move fence clockwise.

1. The crosscut fence position is adjusted at the outer attachment point only. Loosen the clamping device on the bottom of the crosscut fence.
2. Loosen and adjust the cross cut fence bracket on the top surface of the table.
3. Re-tighten the cross cut fence clamp device.
4. Perform another test to check the setting.

NOTE: An incorrect free cut on the sliding table can affect the squaring; see "Free Cut (Blade to Rip Fence)"

## Scoring Blade

The scoring blade should penetrate the material about 2mm.

Problems with the alignment of the scoring blade can normally be traced back to too much free cut. For this reason, the free cut must be checked for correctness before the scoring saw is adjusted.

For example, when the main blade is tilted to 45 degrees, the scoring blade may need to be readjusted sideways.

The tilt axis is independent of the free cut on the sliding table rip fence. The scorer alignment at 90 degrees takes the free cut into account.

Thus, the scorer and the main blade are slightly out of alignment with regard to the tilt axis.

As the blades are tilted to 45 degrees, this misalignment in the horizontal plane also becomes a misalignment in the vertical plane.

The scorer must, therefore, be "raised" (moved to the left) or "lowered" (moved to the right) depending on whether the free cut on the sliding table, or the rip fence, needs to be compensated for.

The free cut can influence the scoring cut; it is essential to carry out the first two free-cut tests mentioned above before adjusting the scoring blade.

## Operation

The panel saw is designed for the following work and is equipped with safety devices for these particular procedures. It is not designed to work materials such as ferrous or non-ferrous metals.

Available procedures:

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

The machine has overload protection on both main 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 before restarting.

## Maintenance

The sliding table should be cleaned once a week, and all sawdust and chips removed.

From both sides of the sliding table, blow out the dust which has accumulated between the two sections and on the ball carrier. This can be done more efficiently when the upper part of the sliding table is slid to the rear. Then repeat the process when the upper part is slid to the front end.

Remove any resin deposits on sliding table and other surfaces.

After blowing out the dust, spray a thin oil onto the steel rods (Figure 44) on both the upper and lower part of the sliding table. Never use a thick oil or grease!

Lubricate all moving parts with a light coating of oil.

NOTE: All bearings in the machine are self-sealed and require no lubrication.

Blow sawdust out of the cooling fan and motor.

The cast iron table surface must be kept clean and free of rust for best results. Apply a coating of paste wax as needed.

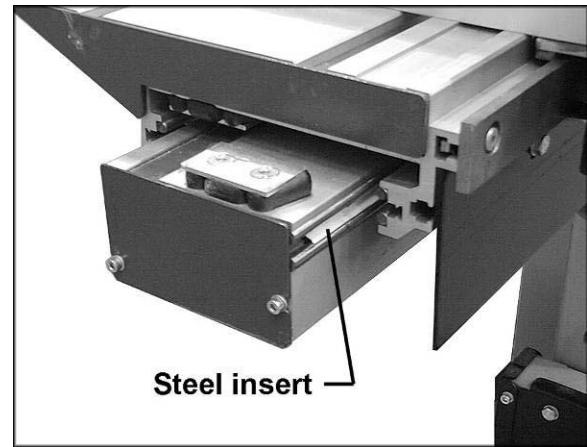


Figure 44

## Troubleshooting

Trouble	Probable Cause	Remedy
Machine will not start when start button is pushed.	Rear door or blade cover is open.	Close door and/or blade cover.
	No power; possible shortage.	Check power source.
	Star-delta switch in wrong position.	Switch must be on "Y" position for starting.
	Main switch is off.	Turn main switch to "1".
Excessive vibration.	Tilt or raising lock knobs not tight.	Tighten knobs.
	Blade out of balance.	Have blade balanced or replaced.
	Worn or damaged belt.	Replace belt.
	Motor malfunction.	Replace motor.
Cuts out-of-square when crosscutting.	Fence misaligned.	Reset fence angle (see page 17).
	Table not aligned with blade arbor.	Realign table (pages 9-10).
Motor stalls or workpiece binds or burns.	Excessive feed.	Reduce feed.
	Dull or incorrect blade.	Replace blade.
	Motor malfunction.	Replace motor.
	Fence misaligned.	Realign fence.
Blade tilt or saw raising handwheels difficult to turn.	Lock knob not released.	Loosen lock knob.
	Worm and worm gear segment caked with sawdust and pitch.	Clean and re-grease.
	Worm and worm gear segment out of alignment.	Realign worm and worm gear segment.
After starting, arbor won't turn and motor makes straining noises.	Pin not removed from arbor hole after changing blade.	Remove pin.



<b>Trouble</b>	<b>Probable Cause</b>	<b>Remedy</b>
Motor overheats.	Motor overloaded.	Correct overload condition, such as by reducing feed rate.
	Improper cooling of motor.	Clean sawdust from fan and duct areas of motor.
Thermal overload.	Overload not set on automatic reset, or overload is faulty.	Contact service technician.
Motor starts slowly or fails to come up to full speed.	Low voltage.	Request voltage check from power company and correct low voltage condition.
	Start switch malfunction.	Replace switch.
	Motor malfunction.	Replace motor.
Reduction of speed during cutting.	Belt tension incorrect.	Properly tension belt.
	Motor overload due to incorrect feed rate.	Reduce feed rate.
	Dull blade(s).	Resharpen or replace.
Motor fails to develop full power.	Power line overloaded.	Correct overload condition.
	Undersize wires in supply system.	Increase supply wire size.
	Low voltage.	Request voltage check from power company and correct condition.
	Motor malfunction.	Replace motor.

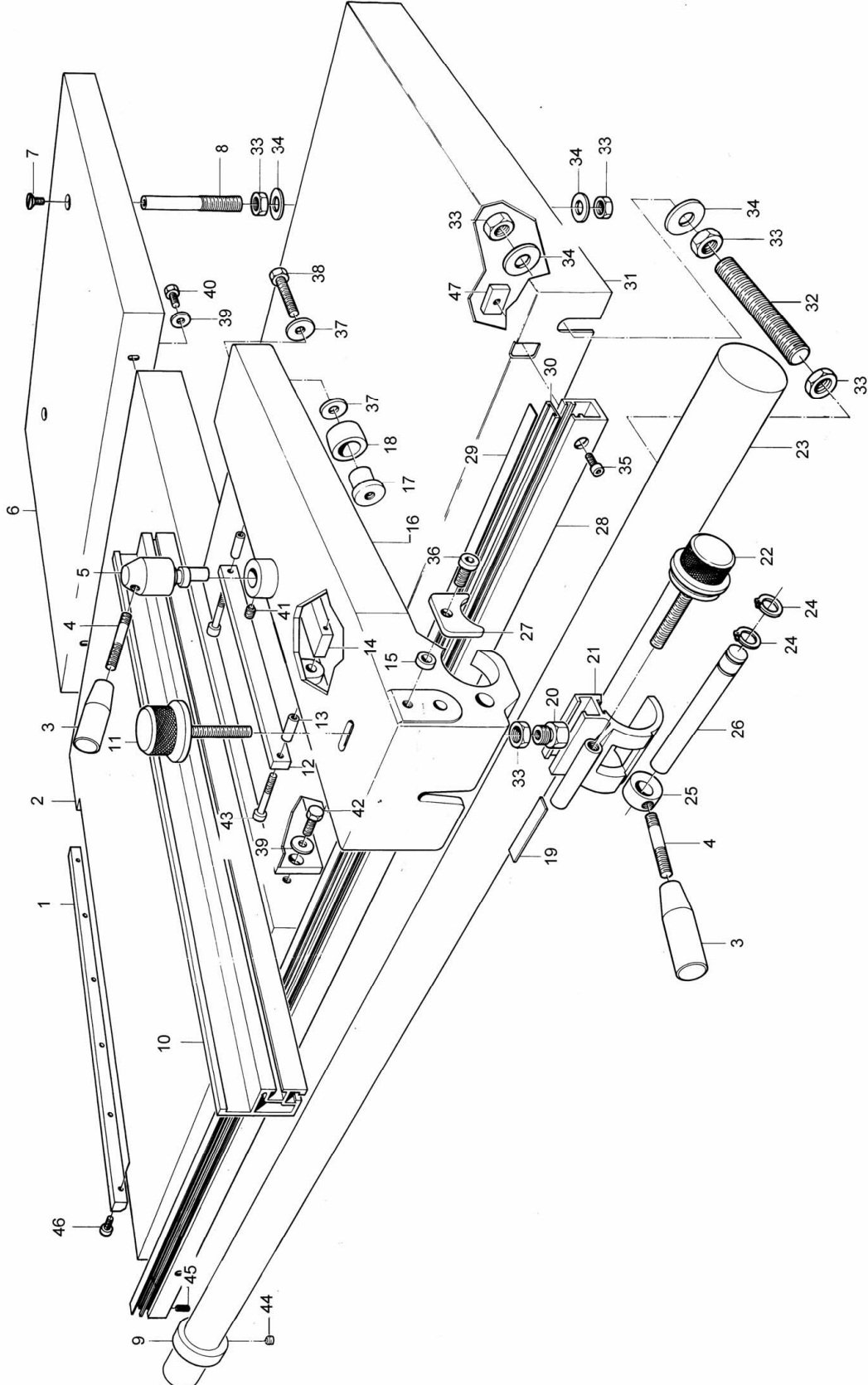
## Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 on Monday through Friday during normal business hours. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

## Parts List: Rip Fence Assembly

Index No.	Part No.	Description	Size	Qty
1	HPS126-701	Wood Inlay		1
2	HPS126-702	Table		1
3	HPS67-445	Handle		2
4	HPS67-448	Handle Rod		2
5	HPS67-703	Lock Bushing		1
6	HPS126-706	Table Extension		1
7	HPS126-707	Machine Screw		2
8	HPS126-708	Shaft		1
9	HPS126-709	Stop Collar		1
10	HPS126-710	Fence Guide		1
11	HPS126-711	Adjustment Screw		1
12	HPS126-712	Mount Plate		1
13	HPS126-713	Bushing		2
14	HPS126-714	Lock Plate		1
15	HPS67-723	Bushing		1
16	HPS126-716	Body		1
17	HPS126-717	Bushing		1
18	HPS126-718	Wheel		1
19	HPS126-719	Lock Plate		1
20	HPS126-720	Lock Plate		1
21	HPS126-721	Lock Housing		1
22	HPS126-722	Adjustment Screw		1
23	HPS126-723	Guide Bar		1
24	HPS67-729	Retainer Ring		2
25	HPS67-731	Lock Collar		1
26	HPS126-726	Shaft		1
27	HPS67-727	Handle Plate		1
28	HPS126-728	Scale Base		1
29	HPS126-729	Scale		1
30	HPS126-730	Scale Plate		1
31	HPS67-305	Extension Saw Table Right Z		1
32	HPS126-732	Stud	M16	1
33	TS-2311161	Full Hex Nut	M16	6
34	TS-155010	Flat Washer	M16	4
35	TS-1503041	Socket Head Cap Screw	M6 x 16	6
36	TS-1504041	Socket Head Cap Screw	M8 x 20	1
37	TS-1550071	Flat Washer	M10	2
38	TS-1491041	Hex Cap Screw	M10 x 30	1
39	TS-1550061	Flat Washer	M8	2
40	TS-1490021	Hex Cap Screw	M8 x 12	1
41	TS-1524031	Socket Set Screw	M8 x 8	1
42	TS-1490041	Hex Cap Screw	M8 x 25	1
43	TS-1503131	Socket Head Cap Screw	M6 x 60	1
44	TS-1524011	Socket Set Screw	M8 x 8	1
45	TS-1522061	Socket Set Screw	M5 x 20	1
46	TS-1504061	Socket Head Cap Screw	M8 x 30	6
47	HPS126-747	Nut		1

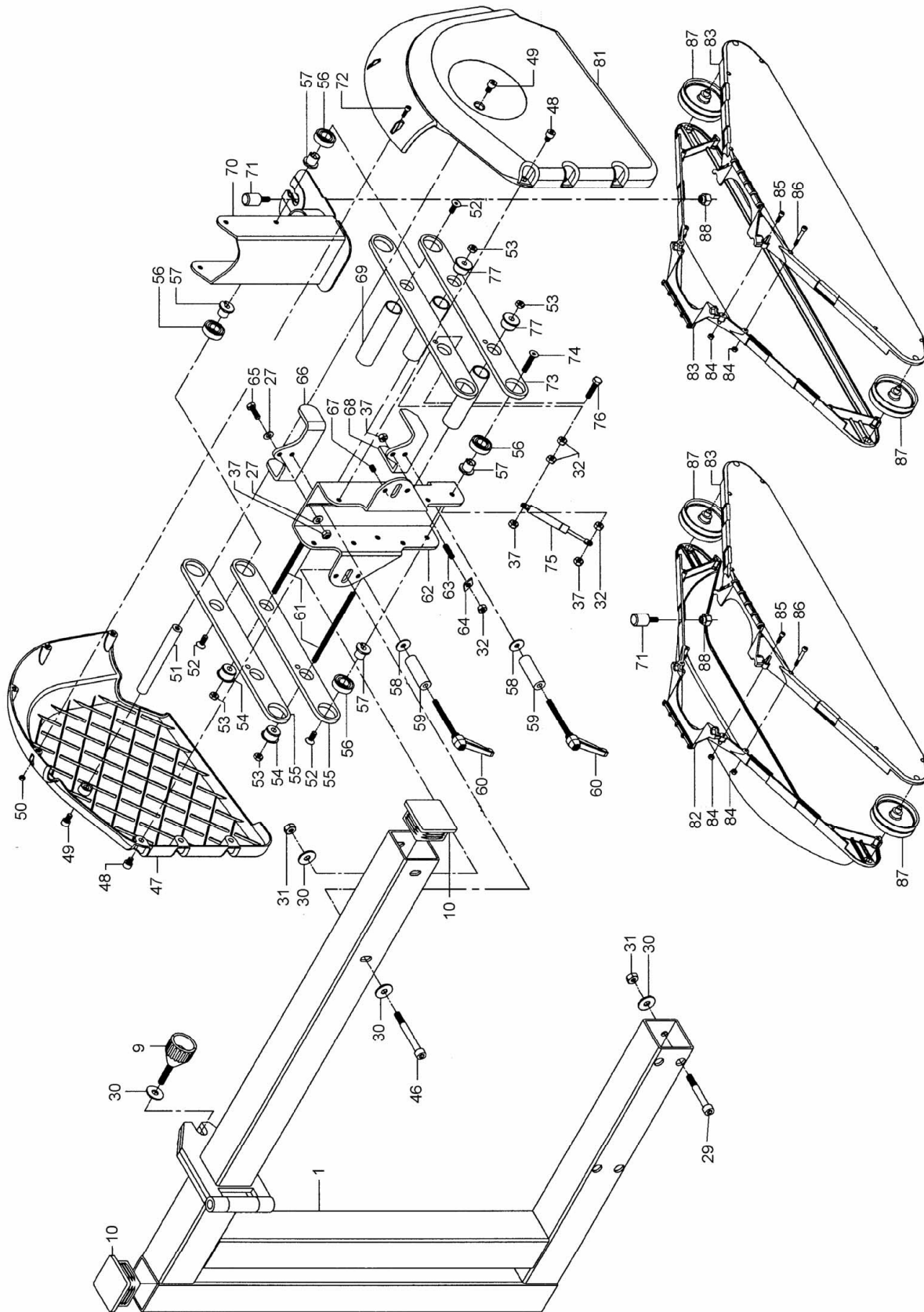
# Rip Fence Assembly



## Parts List: Over Arm Guard Assembly

Index No.	Part No.	Description	Size	Qty
1	HPS126-901	Frame		1
9	HPS67-909	Hand Knob		1
10	HPS67-910	End Cap		2
27	TS-1550061	Flat Washer	M8	12
29	TS-1505041	Socket Head Cap Screw	M10 x 30	4
30	TS-1550071	Flat Washer	M10	8
31	TS-2311101	Hex Nut	M10	5
32	TS-2311081	Hex Nut	M8	4
37	TS-1541031	Nylon Lock Hex Nut	M8	4
46	TS-1505131	Socket Head Cap Screw	M10 x 80	2
47	HPS67-947	Upper Guard (LH)		1
48	TS-1504011	Socket Head Cap Screw	M8 x 10	6
49	TS-1504031	Socket Head Cap Screw	M8 x 16	2
50	TS-1540031	Hex Nut	M5	1
51	HPS67-951	Stand Off		1
52	TS-1515031	Socket Head Flat Screw	M8 x 25	3
53	TS-2311081	Hex Nut	M8	4
54	HPS67-954	Bushing		2
55	HPS67-955	Link Bar		2
56	HPS67-956	Ball Bearing	6003-2RS	4
57	HPS67-957	Bushing		4
58	TS-1550061	Flat Washer	M8	2
59	HPS67-959	Spacer		2
60	HPS67-960	Handle		2
61	HPS67-961	Threaded Rod		1
62	HPS67-962	Guard Column (LH)		1
63	HPS67-963	Socket Set Screw	M8 x 30	1
64	HPS67-964	Pointer		1
65	TS-1490041	Hex Cap Screw	M8 x 25	1
66	HPS67-966	Upper Bracket		1
67	TS-1524021	Socket Set Screw	M8 x 10	4
68	HPS67-968	Lower Bracket		1
69	HPS67-969	Support Shaft		4
70	HPS67-970	Guard Column (RH)		1
71	HPS67-971	Bolt		1
72	TS-1502041	Socket Head Cap Screw	M5 x 16	
73	HPS67-973	Link Bar		2
74	HPS67-974	Socket Head Flat Screw	M8 x 45	1
75	HPS67-975	Cylinder		1
76	TS-149006	Hex Cap Screw	M8 x 35	1
77	HPS67-977	Bushing		2
81	HPS67-981	Upper Guard (RH)		1
	HPS67-982A	Blade Guard Assembly (tilted arbor) (items 71, 82 thru 88)		1
82	HPS67-982	Blade Guard (tilted arbor)		1
	HPS67-983A	Blade Guard Assembly (items 71, 83 thru 88)		1
83	HPS67-983	Blade Guard		3
84	TS-1540021	Hex Nut	M4	4
85	TS-1501051	Socket Head Cap Screw	M4 x 16	4
86	TS-1501091	Socket Head Cap Screw	M4 x 35	4
87	HPS67-987	Roller		4
88	HPS67-988	Lock Nut		1

# Over Arm Guard Assembly



## Parts List: Motor and Arbor Assembly

(Exploded view on page 33)

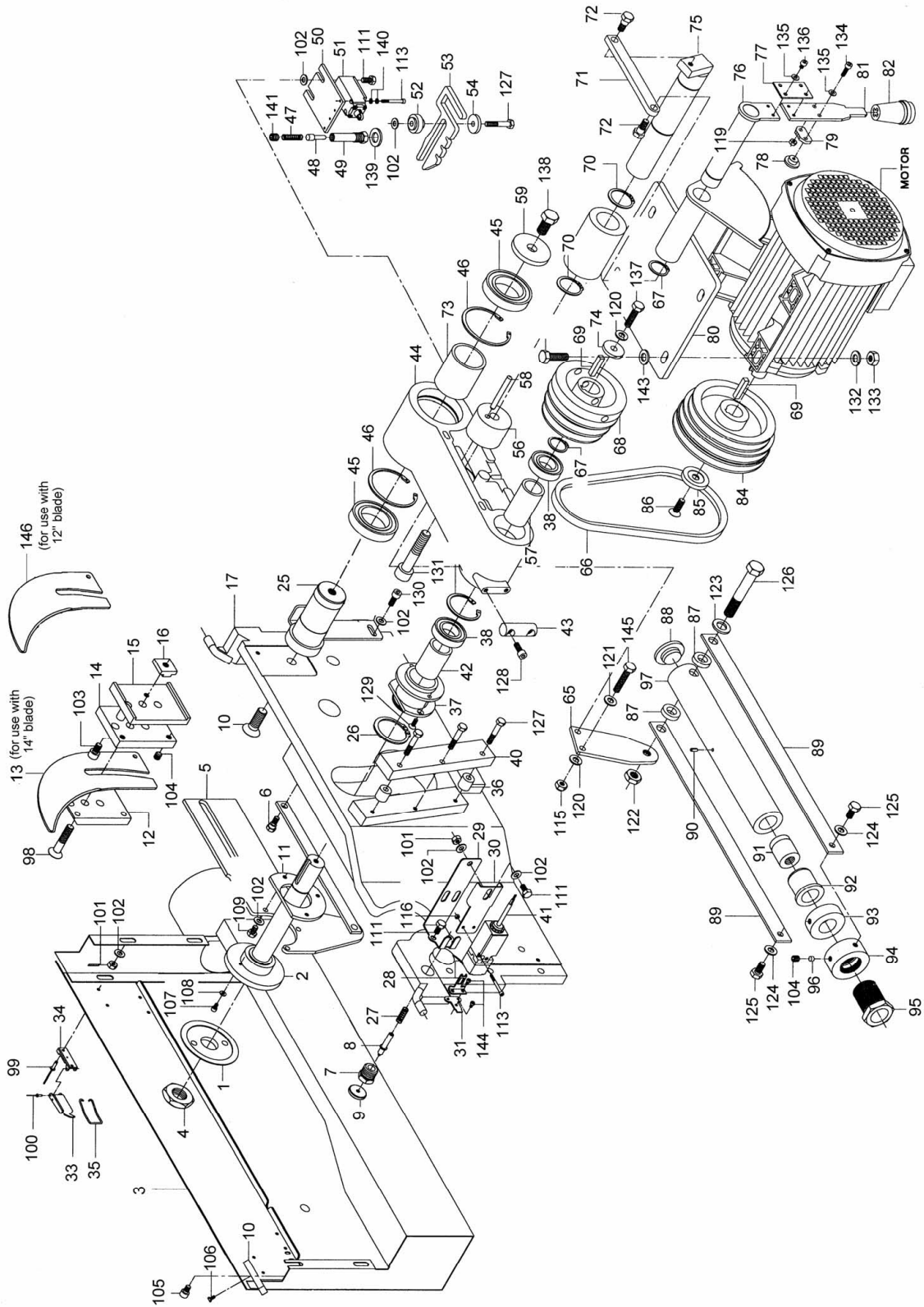
Index No.	Part No.	Description	Size	Qty
1	HPS126-101	Flange Collar		1
2	HPS126-102	Arbor Shaft		1
3	HPS126-103	Cover		1
4	HPS126-104	Arbor Nut		1
5	HPS126-105	Riving Knife		1
6	HPS126-106	Bolt		2
7	HPS126-107	Hub		1
8	HPS126-108	Shaft		1
9	HPS126-109	Nut		1
10	HPS126-110	Cam		1
11	HPS126-111	Flange		1
12	HPS126-112	Locking Plate		1
13	HPS126-113	Riving Knife (for use with 14" blade)		1
14	HPS126-114	Adjustment Block		1
15	HPS126-115	Plate		1
16	HPS126-116	Nut		1
17	HPS126-117	Cradle		1
25	HPS126-125	Pivot Unit		1
26	HPS126-126	Retainer Ring	N471-55	1
27	HPS126-127	Spring		1
28	HPS126-128	Micro Switch		1
29	HPS126-129	Bracket		1
30	HPS126-130	Bracket		1
31	HPS126-131	Bracket		1
33	HPS126-133	Bracket		1
34	HPS126-134	Bracket		1
35	HPS126-135	Spring		1
36	HPS126-136	Glide Bushing		2
37	HPS126-137	Flanged Riving Knife		1
38	BB-6006-ZZ	Ball Bearing	6006-ZZ	2
39	HPS126-139	Retainer Ring	N472-55	1
40	HPS126-140	Bracket		1
41	HPS126-141	Switch		1
42	HPS126-142	Flange Bushing		1
43	HPS126-143	Sliding Pin		1
44	HPS126-144	Body		1
45	BB-6010VV	Ball Bearing	6060VV	2
46	HPS126-146	Retainer Ring	N472-80	2
47	HPS126-147	Spring		1
48	HPS126-148	Pin		1
49	HPS126-149	Holder		1
50	HPS126-150	Bracket		1
51	HPS126-151	Micro Switch		1
52	HPS126-152	Bushing		1
53	HPS126-153	Fork		1
54	HPS126-154	Washer		1
56	HPS126-156	Bushing		1
57	HPS126-157	Bushing Saw Arbor		1
58	HPS126-158	Pin	8mm dia. x 70mm	1
59	HPS126-159	Flange		1
65	HPS126-165	Connection Plate		1
66	HPS126-166	V-Belt		1
67	HPS126-167	Retainer Ring	N471-30	2
68	HPS126-168	Arbor Pulley		1
69	HPS126-169	Key		2

70	HPS126-170	Retainer Ring	N471-40	1
71	HPS126-171	Tensioner Strap		1
72	HPS126-172	Tensioner Bolt		2
73	HPS126-173	Pivot Bushing		1
74	HPS126-174	Washer		1
75	HPS126-175	Belt Spanner		1
76	HPS126-176	Belt Spanner		1
77	HPS126-177	Handle Plate		1
78	HPS126-178	Handle Nut		1
79	HPS126-179	Segment Gear		1
80	HPS126-180	Motor Base		1
81	HPS126-181	Handle Plate		1
82	HPS126-182	Handle		1
83	HPS126-183	Motor	7-1/2HP, 230V, 3Ph	1
84	HPS126-184	Motor Pulley		1
85	HPS126-185	Washer		1
86	HPS126-186	Screw		1
87	HPS126-187	Medium Washer		2
88	HPS126-188	Plug		1
89	HPS126-189	Strap Bracket		1
90	HPS126-190	Pin	5mm dia. x 12mm	1
91	HPS126-191	Nut		1
92	HPS126-192	Stop Bushing		1
93	HPS126-193	Height Stop Collar		1
94	HPS126-194	Height Adjustment Collar		1
95	HPS126-195	Height Adjustment Bushing		1
96	HPS126-196	Insert Pad		2
97	HPS126-197	Adjustment Shaft		1
98	TS-224A601	Flat Head Socket Cap Screw	M12 x 60	1
99	HPS126-199	Screw	M4 x 6	1
100	HPS126-200	Screw	2.4 x 6	1
101	TS-2311081	Hex Nut	M8	2
102	TS-1550061	Flat Washer	M8	4
103	TS-1505011	Socket Head Cap Screw	M10 x 16	4
104	TS-1525011	Socket Set Screw	M10 x 10	4
105	TS-1504021	Socket Head Cap Screw	M8 x 12	1
106	TS-1481021	Hex Cap Screw	M5 x 10	1
107	TS-1502011	Socket Head Cap Screw	M5 x 8	2
108	TS-1550031	Flat Washer	M5	1
109	TS-1490011	Hex Cap Screw	M8 x 12	3
110	HPS126-201	Flat Head Socket Cap Screw	M16 x 45	1
111	TS-1490021	Hex Cap Screw	M8 x 16	6
113	TS-1501081	Socket Head Cap Screw	M4 x 30	1
115	TS-2342101	Nylon Lock Hex Nut	M10	2
116	TS-1540021	Hex Nut	M4	1
120	TS-2361101	Lock Washer	M10	1
121	TS-1550071	Flat Washer	M10	1
122	TS-2311161	Full Hex Nut	M16	1
123	TS-155010	Flat Washer	M16	1
124	TS-1550071	Flat Washer	M10	1
125	TS-2210161	Hex Cap Screw	M10 x 16	2
126	TS-149B16	Hex Cap Screw	M16 x 100	1
127	TS-1490081	Hex Cap Screw	M8 x 45	3
128	TS-1504041	Socket Head Cap Screw	M8 x 20	2
129	TS-1514021	Socket Head Flat Screw	M6 x 16	1
130	TS-1504041	Socket Head Cap Screw	M8 x 20	2
131	TS-223C801	Socket Head Cap Screw	M16 x 80	1
132	TS-2361121	Lock Washer	M12	4
133	TS-1540081	Hex Nut	M12	4
134	TS-1503041	Socket Head Cap Screw	M6 x 16	4
135	TS-1550041	Flat Washer	M6	4

136	TS-1503011	Socket Head Cap Screw	M6 x 8	4
137	TS-1491061	Hex Head Cap Screw	M10 x 40	1
138	TS-222C301	Hex Cap Screw	M16 x 30	1
139	TS-155010	Flat Washer	M16	1
140	HPS126-203	Washer	M4	2
141	TS-1526011	Socket Set Screw	M12 x 12	1
144	TS-1501011	Socket Head Cap Screw	M4 x 6	2
145	TS-1491081	Hex Cap Screw	M10 x 50	2
146	HPS126-118	Riving Knife (for use with 12" blade)		1



# Motor and Arbor Assembly



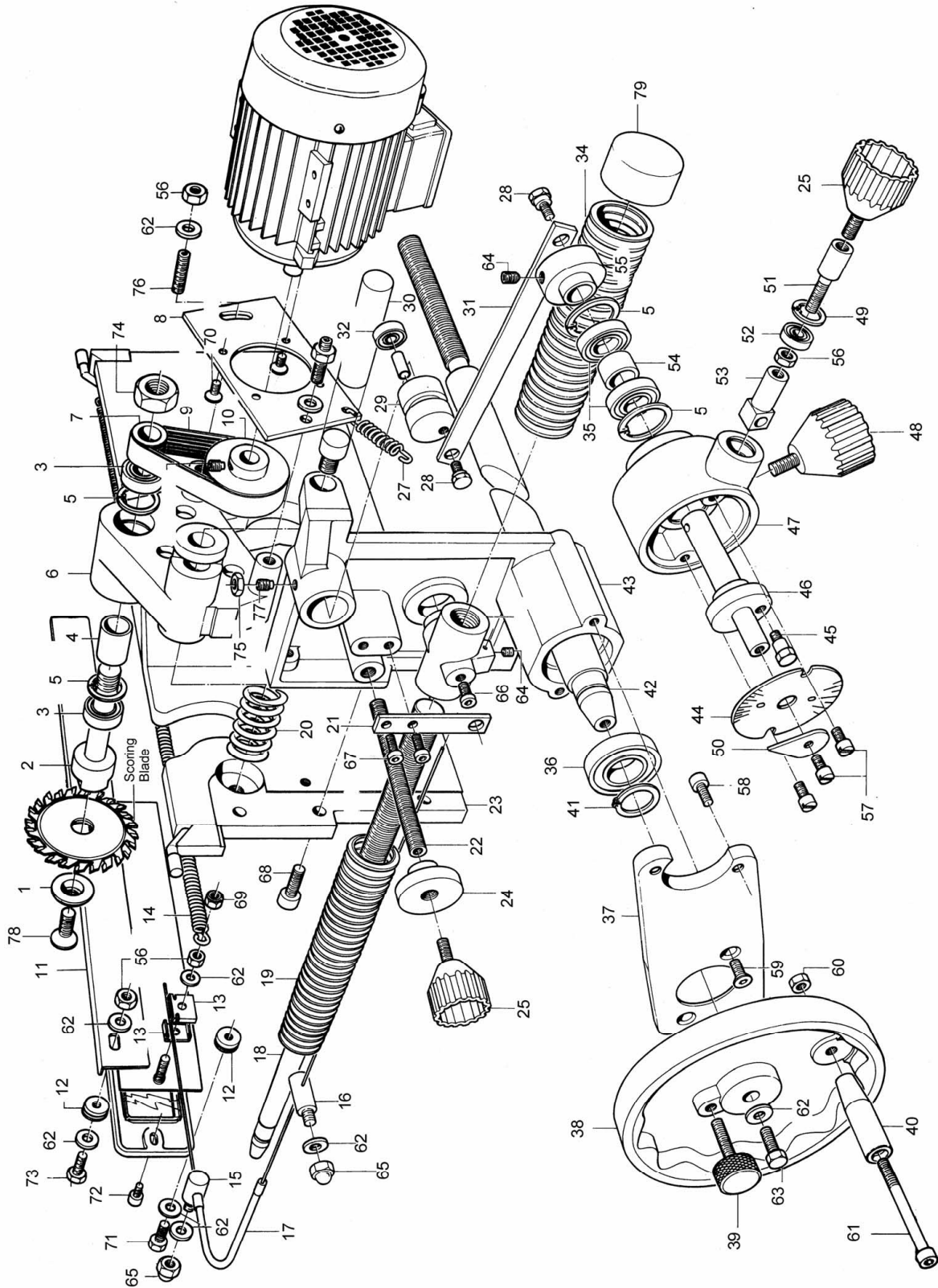
## Parts List: Scoring Motor and Arbor Assembly

(Exploded view on page 36)

Index No.	Part No.	Description	Size	Qty
1	HPS67-201	Flange Collar	1	1
2	HPS67-203	Arbor Shaft		1
3	BB-6003ZZ	Ball Bearing		2
4	HPS126-204	Bushing		1
5	HPS126-205	Retainer Ring	N472-35	1
6	HPS126-206	Bearing Housing		1
7	HPS67-207	Arbor Pulley		1
8	HPS126-208	Motor Mount		1
9	HPS126-209	V-Belt		1
10	HPS67-226	Motor Pulley		1
11	HPS126-211	Corner Plate		1
12	HPS126-212	Guide		2
13	HPS126-213	Cable Clamp		2
14	HPS126-214	Spring		1
15	HPS126-215	Cable Guide		1
16	HPS126-216	Cable Guide		1
17	HPS126-217	Cable Sleeve		1
18	HPS126-218	Threaded Rod		1
19	HPS67-145	Cover Tube		1
20	HPS67-225	Spring		1
21	HPS126-221	Strap Bracket		1
22	HPS126-222	Threaded Rod		1
23	HPS126-117	Cradle		1
24	HPS126-224	Locking Knob		1
25	HPS126-225	Hand Knob		2
26	HPS126-226	Threaded Rod Housing		1
27	HPS126-227	Spring		1
28	HPS126-106	Bolt		2
29	HPS126-229	Bushing		1
30	HPS126-230	Pivot Shaft		1
31	HPS126-231	Strap Bracket		1
32	BB-608ZZ	Ball Bearing	608ZZ	1
33	HPS67-233	Scoring Motor	3/4HP, 230V (.55 kw)	1
34	HPS126-232	Hose		1
35	BB-6003ZZ	Ball Bearing	6003ZZ	2
36	BB-6304ZZ	Ball Bearing		1
37	HPS126-237	Support Plate		1
38	HPS126-238	Handwheel		1
39	HPS126-239	Locking Knob		1
40	HPS126-240	Handle		1
41	HPS126-241	Retainer Ring	N471-25	1
42	HPS126-242	Height Setting Shaft		1
43	HPS126-243	Shaft Housing		1
44	HPS126-244	Dial Plate		1
45	HPS126-245	Adjustment Bolt		1
46	HPS126-246	Adjustment Shaft		1
47	HPS126-247	Gear Housing		1
48	HPS126-248	Hand Knob		1
49	HPS126-249	Retainer Ring	N472-22	1
50	HPS126-250	Pointer		1
51	HPS126-251	Adjustment Rod		1
52	HPS126-252	Bearing		1
53	HPS126-253	Adjustment Rod		1
54	HPS126-254	Bushing		1
55	HPS126-255	Adjustment Plate		1
56	TS-2311081	Hex Nut	M8	2

57.....	TS-1503011 .....	Socket Head Cap Screw.....	M6 x 8 .....	1
58.....	TS-1504021 .....	Socket Head Cap Screw.....	M8 x 12 .....	1
59.....	TS-1515031 .....	Flat Head Socket Cap Screw.....	M8 x 25 .....	1
60.....	TS-2311081 .....	Hex Nut.....	M8.....	4
61.....	TS-1505141 .....	Socket Head Cap Screw.....	M10 x 90 .....	1
62.....	TS-1550061 .....	Flat Washer.....	M8.....	8
63.....	TS-1490021 .....	Hex Head Cap Screw .....	M8 x 16 .....	1
64.....	TS-1524011 .....	Socket Set Screw .....	M8 x 8 .....	2
65.....	TS-2331081 .....	Cap Nut.....	M8.....	2
66.....	TS-1503031 .....	Socket Head Cap Screw.....	M6 x 12 .....	1
67.....	TS-1504041 .....	Socket Head Cap Screw.....	M8 x 20 .....	1
68.....	TS-1505041 .....	Socket Head Cap Screw.....	M10 x 30 .....	1
69.....	TS-1541031 .....	Nylon Lock Hex Nut.....	M8.....	1
70.....	TS-1514011 .....	Socket Head Flat Screw .....	M6 x 12 .....	1
71.....	TS-1490021 .....	Hex Head Cap Screw .....	M8 x 16 .....	1
72.....	TS-1503021 .....	Socket Head Cap Screw.....	M6 x 10 .....	1
73.....	TS-1490041 .....	Hex Cap Screw .....	M8 x 25 .....	1
74.....	TS-2310162 .....	Full Hex Nut .....	M16-1.5P .....	1
75.....	TS-2312101 .....	Jam Nut.....	M10.....	1
76.....	TS-29-198.....	Socket Set Screw .....	M8 x 50 .....	2
77.....	HPS126-277 .....	Half Dog Point Socket Set Screw.....	M10 x 20 .....	1
78.....	TS-1515021 .....	Flat Head Socket Set Screw .....	M8 x 20 .....	1
79.....	HPS126-279 .....	End Cap.....	.....	1

# Scoring Motor and Arbor Assembly



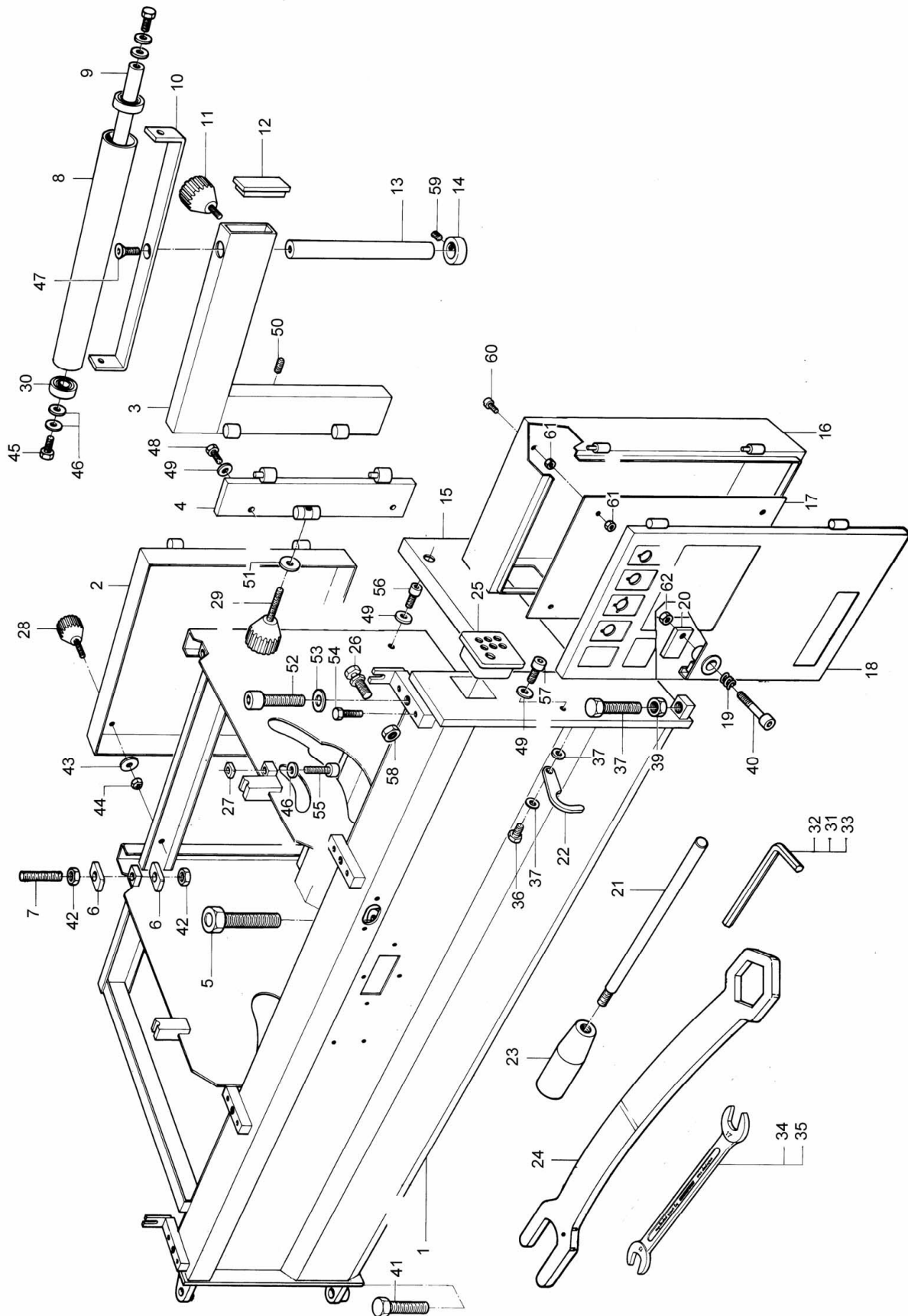
## Parts List: Stand Assembly

(Exploded view on page 39)

Index No.	Part No.	Description	Size	Qty
1	HPS126-301	Stand		1
2	HPS126-302	Door		1
3	HPS126-303	Support Arm		1
4	HPS126-304	Support Plate		1
5	HPS126-305	Adjustment Screw		1
6	HPS126-306	Washer		2
7	HPS67-312	Threaded Rod		1
8	HPS126-308	Pivot Roll Support		1
9	HPS126-309	Pivot Roll Shaft		1
10	HPS126-310	Roll Support Bracket		1
11	HPS67-409	Adjustment Knob		1
12	HPS126-312	End Cap		1
13	HPS126-313	Support Shaft		1
14	HPS126-314	Collar		1
15	HPS126-315	Cover Plate		1
16	HPS126-316	Electrical Cabinet		1
17	HPS126-317	Mount Plate		1
18	HPS126-318	Door		1
19	HPS67-324	Spring		1
20	HPS126-320	Lock Plate		1
21	HPS126-321	Lock Pin		1
22	HPS67-311	Hook		1
23	HPS67-445	Handle		1
24	HPS126-324	Wrench		1
25	HPS126-325	Stop Block		1
26	HPS126-326	Adjustment Block		1
27	HPS126-327	Ring		1
28	HPS126-248	Hand Knob		1
29	HPS126-329	Hand Knob		1
30	BB-6003ZZ	Ball Bearing	6003ZZ	2
31	TS-152707	Hex Key	6mm Short	1
32	TS-227D081	Hex Ke	8mm Short	1
33	TS-227D061	Hex Key	5mm Short	1
34	HPS126-334	Wrench	19mm x 22mm	1
35	HPS67-328	Wrench	13mm x 17mm	1
36	TS-1490021	Hex Head Cap Screw	M8 x 16	1
37	TS-1550061	Flat Washer	M8	2
38	TS-2213401	Hex Cap Screw	M16 x 40	1
39	TS-2311161	Full Hex Nut	M16	1
40	TS-1504071	Socket Head Cap Screw	M8 x 35	1
41	TS-2215901	Hex Cap Screw	M20 x 90	2
42	TS-154010	Hex Nut	M16	2
43	TS-2361081	Lock Washer	M8	1
44	TS-1541031	Nylon Lock Hex Nut	M8	1
45	TS-1491021	Hex Cap Screw	M10 x 20	2
46	TS-1550071	Flat Washer	M10	2
47	TS-1516021	Socket Flat Head Cap Screw	M10 x 25	1
48	TS-1490071	Hex Cap Screw	M8 x 40	1
49	TS-1550061	Flat Washer	M8	2
50	HPS67-51	Stud	M8 x 20	6
51	TS-1550071	Flat Washer	M10	2
52	TS-223C501	Socket Head Cap Screw	M16 x 50	1
53	TS-155010	Flat Washer	M16	1
54	TS-1490061	Hex Head Cap	M8 x 35	1
55	TS-2239451	Socket Head Cap Screw	M10 x 45	1
56	TS-1504021	Socket Head Cap Screw	M8 x 12	1

57.....	TS-1504031 .....	Socket Head Cap Screw.....	M8 x 16 .....	4
58.....	TS-1540081 .....	Hex Nut.....	M12.....	1
59.....	TS-1525011 .....	Socket Set Screw .....	M10 x 10 .....	1
60.....	TS-1503071 .....	Socket Head Cap Screw.....	M8 x 16 .....	4
61.....	TS-2311061 .....	Hex Nut.....	M6.....	4
62.....	TS-2311081 .....	Hex Nut .....	M8.....	4

# Stand Assembly



## Parts List: Sliding Table Assembly

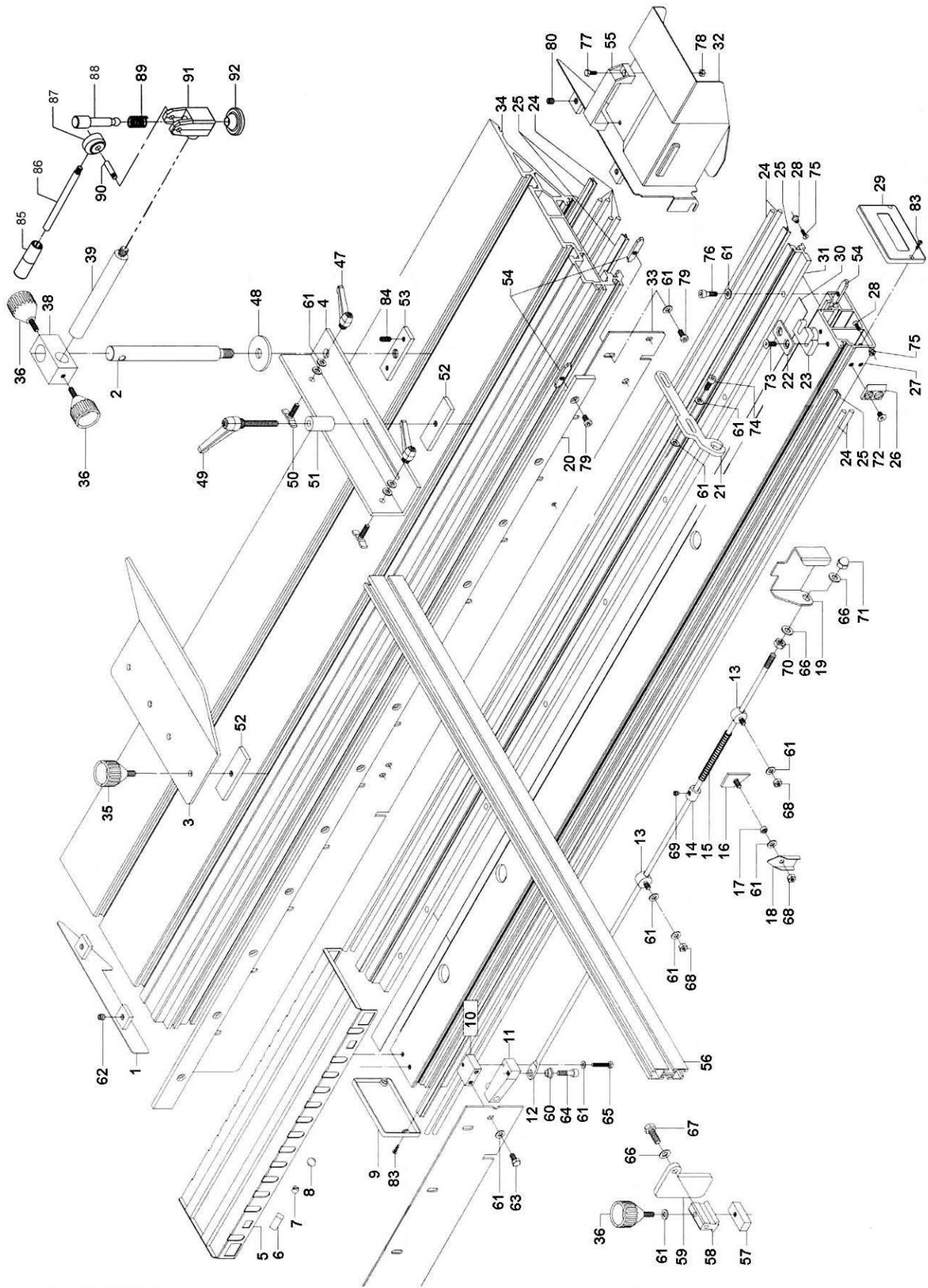
(Exploded view on page 42)

Index No.	Part No.	Description	Size	Qty
1	HPS126-401	Plate		1
2	HPS126-402	Clamp Rod		1
3	HPS126-403	Stop Plate		1
4	HPS126-404	Bracket		1
5	HPS126-405	Mount Plate		1
6	HPS126-406	Wiper		4
7	HPS126-407	Plug		2
8	HPS126-408	Steel Ball		11
9	HPS126-409	Cover Plate		1
10	HPS126-410	Block		1
11	HPS126-411	Bracket		1
12	HPS126-412	Rod		1
13	HPS126-413	Coupling		2
14	HPS126-414	Coupling		1
15	HPS126-415	Spring		1
16	HPS126-416	Plate		1
17	HPS126-417	Bushing		1
18	HPS126-418	Position Indicator		1
19	HPS126-419	Bracket		1
20	HPS126-420	Mount Plate		1
21	HPS126-421	Lock Plate		1
22	HPS126-422	Stop Plate		2
23	HPS126-423	Stop Block		2
24	HPS126-424	Rod		10
25	HPS126-425	Guide		3
26	HPS126-426	Plate		1
27	HPS126-427	Support		1
28	HPS126-428	Nut		2
29	HPS126-429	Cover Plate		1
30	HPS126-430	Plate		1
31	HPS126-431	Guide		1
32	HPS126-432	Bracket		1
33	HPS126-433	Plate		1
34	HPS126-434	Support Table		1
35	HPS126-435	Adjustment Knob		1
36	HPS67-409	Adjustment Knob		1
38	HPS67-442	Post Block		1
39	HPS67-443	Rod		1
47	HPS67-430	Handle		2
48	HPS67-453	Washer		1
49	HPS67-440	Handle		1
50	HPS67-438	Handle Bolt		2
51	HPS67-439	Bushing		1
52	HPS67-434	Nut Plate		2
53	HPS67-435	Clamp		2
54	HPS67-429	Nut Plate		14
55	HPS67-415	Handle		1
56	HPS67-413	Profile Tube		1
57	HPS67-411	Lock Plate		1
58	HPS67-410	Adjustment Block		1
59	HPS67-412	Mitre Guide Stop		1
60	HPS67-906	Bushing		1
61	TS-1550061	Flat Washer	M8	30
62	TS-1525011	Socket Set Screw	M10 x 10	2
63	TS-1490021	Hex Head Cap Screw	M8 x 16	4
64	TS-1504061	Socket Head Cap Screw	M8 x 30	1



65	TS-1482081	Hex Head Cap Screw	M6 x 40	2
66	TS-1550071	Flat Washer	M10	10
67	TS-1491041	Hex Head Cap Screw	M10 x 30	1
68	TS-2311081	Hex Nut	M8	5
69	TS-1524011	Socket Set Screw	M8 x 8	1
70	TS-2311101	Hex Nut	M10	1
71	TS-2331101	Cap Nut	M10	2
72	TS-2248121	Flat Head Socket Cap Screw	M8 x 20	4
73	TS-1515021	Flat Head Socket Cap Screw	M8 x 20	2
74	TS-1504041	Socket Head Cap Screw	M8 x 20	1
75	TS-1513031	Flat Head Socket Cap Screw	M5 x 16	2
76	TS-1504051	Socket Head Cap Screw	M8 x 25	2
77	TS-1482031	Hex Head Cap Screw	M6 x 16	2
78	TS-2311061	Hex Nut	M6	2
79	TS-2288202	Phillips Pan Head Machine Screw	M8 x 20	24
80	TS-1525011	Socket Set Screw	M10 x 10	1
83	HPS126-436	Self Tapping Screw	4,8-19	4
84	HPS67-451	Stud	M8 x 20	2
85	HPS67-480	Handle		1
86	HPS67-481	Handle Shaft		1
87	HPS67-482	Cam		1
88	HPS67-483	Clamp Pin		1
89	HPS67-484	Spring		1
90	HPS67-485	Pin		1
91	HPS67-486	Clamp Block		1
92	HPS67-487	Clamp		1

# Sliding Table Assembly



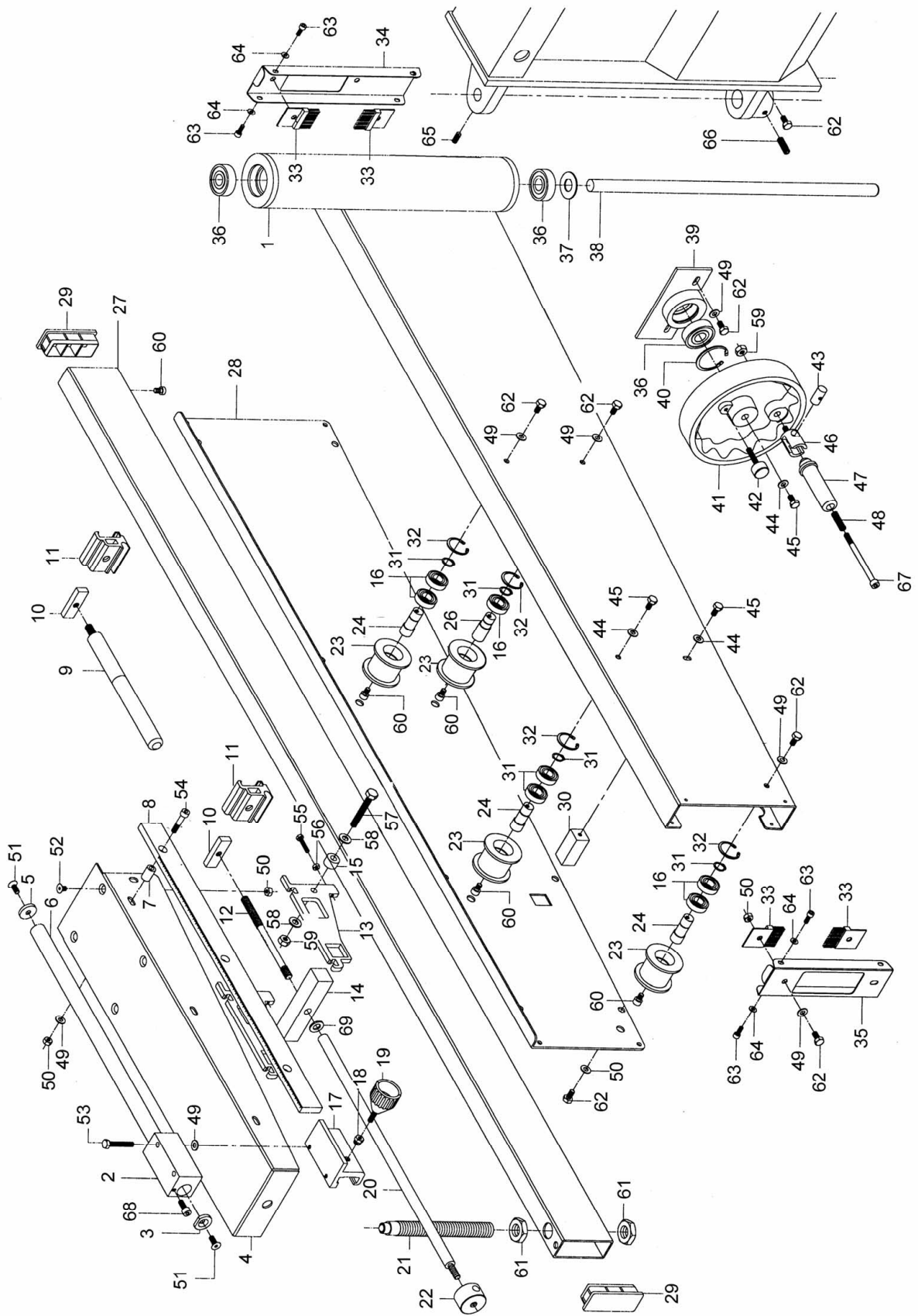
## Parts List: Support Arm Assembly

(Exploded view on page 45)

Index No.	Part No.	Description	Size	Qty
1	HPS126-501	Support Arm		1
2	HPS126-502	Stop Block		1
3	HPS126-503	Washer		1
4	HPS126-504	Table		1
5	HPS126-505	Washer		1
6	HPS126-506	Stop Shaft		1
7	HPS126-507	Bushing		1
8	HPS126-508	Scale Plate		1
9	HPS126-509	Handle		1
10	HPS126-510	Support Nut		2
11	HPS126-511	Lock Block		2
12	HPS126-512	Threaded Rod		1
13	HPS126-513	Fixed Plate		2
14	HPS126-514	Guide Block		1
15	HPS126-515	Idle Bushing		1
16	BB-6003ZZ	Ball Bearing		7
17	HPS126-517	Guide Block		1
18	HPS126-518	Bushing		1
19	HPS67-613	Hand Knob		1
20	HPS126-520	Pivot Shaft		1
21	HPS126-521	Threaded Rod		1
22	HPS126-522	Support Nut		1
23	HPS126-523	Spool Cylinder		4
24	HPS126-524	Shaft		3
26	HPS126-526	Shaft		1
27	HPS126-527	Arm Tube		1
28	HPS126-528	Side Plate		1
29	HPS126-312	End Cap		2
30	HPS126-530	Arm Stop		1
31	HPS67-516	Retainer Ring		4
32	HPS126-205	Retainer Ring	N472-35	4
33	HPS126-533	Brush		4
34	HPS126-534	Cover		1
35	HPS126-535	Cover		1
36	BB-6304ZZ	Ball Bearing		3
37	HPS126-537	Washer		1
38	HPS126-538	Pivot Shaft		1
39	HPS126-539	Bearing Housing		1
40	HPS126-540	Retainer Ring	N472-52	1
41	HPS126-541	Handwheel		1
42	HPS126-239	Locking Knob		1
43	HPS126-543	Nut		1
44	HPS126-544	Washer		4
45	HPS126-545	Bolt		4
46	HPS126-546	Bushing		1
47	HPS126-547	Handle		1
48	HPS126-548	Spring		1
49	TS-1550061	Flat Washer	M8	8
50	TS-2311081	Hex Nut	M8	2
51	TS-1515021	Flat Head Socket Cap Screw	M8 x 20	2
52	TS-2248121	Flat Head Socket Cap Screw	M8 x 20	4
53	TS-1490101	Hex Cap Screw	M8 x 55	2
54	TS-1504081	Socket Head Cap Screw	M8 x 40	3
55	TS-1482061	Hex Cap Screw	M6 x 30	2
56	TS-2311101	Hex Nut	M10	2
57	TS-1491121	Hex Cap Screw	M10 x 70	1

58.....	TS-1550071 .....	Flat Washer.....	M10.....	2
59.....	TS-2311101 .....	Hex Nut.....	M10.....	2
60.....	TS-1504021 .....	Socket Head Cap Screw.....	M8 x 12 .....	6
61.....	TS-2312241 .....	Hex Jam Nut .....	M24.....	2
62.....	TS-1490021 .....	Hex Cap Screw .....	M8 x 16 .....	10
63.....	TS-1503041 .....	Socket Head Cap Screw.....	M6 x 16 .....	6
64.....	TS-1550041 .....	Flat Washer.....	M6.....	6
65.....	TS-1524051 .....	Socket Set Screw .....	M8 x 20 .....	1
66.....	TS-2279351 .....	Socket Set Screw .....	M10 x 35 .....	2
67.....	TS-2239911 .....	Socket Head Cap Screw.....	M10 x 100 .....	1
68.....	TS-1504041 .....	Socket Head Cap Screw.....	M8 x 20 .....	1
69.....	TS-2360121 .....	Flat Washer.....	M12.....	1

# Support Arm Assembly



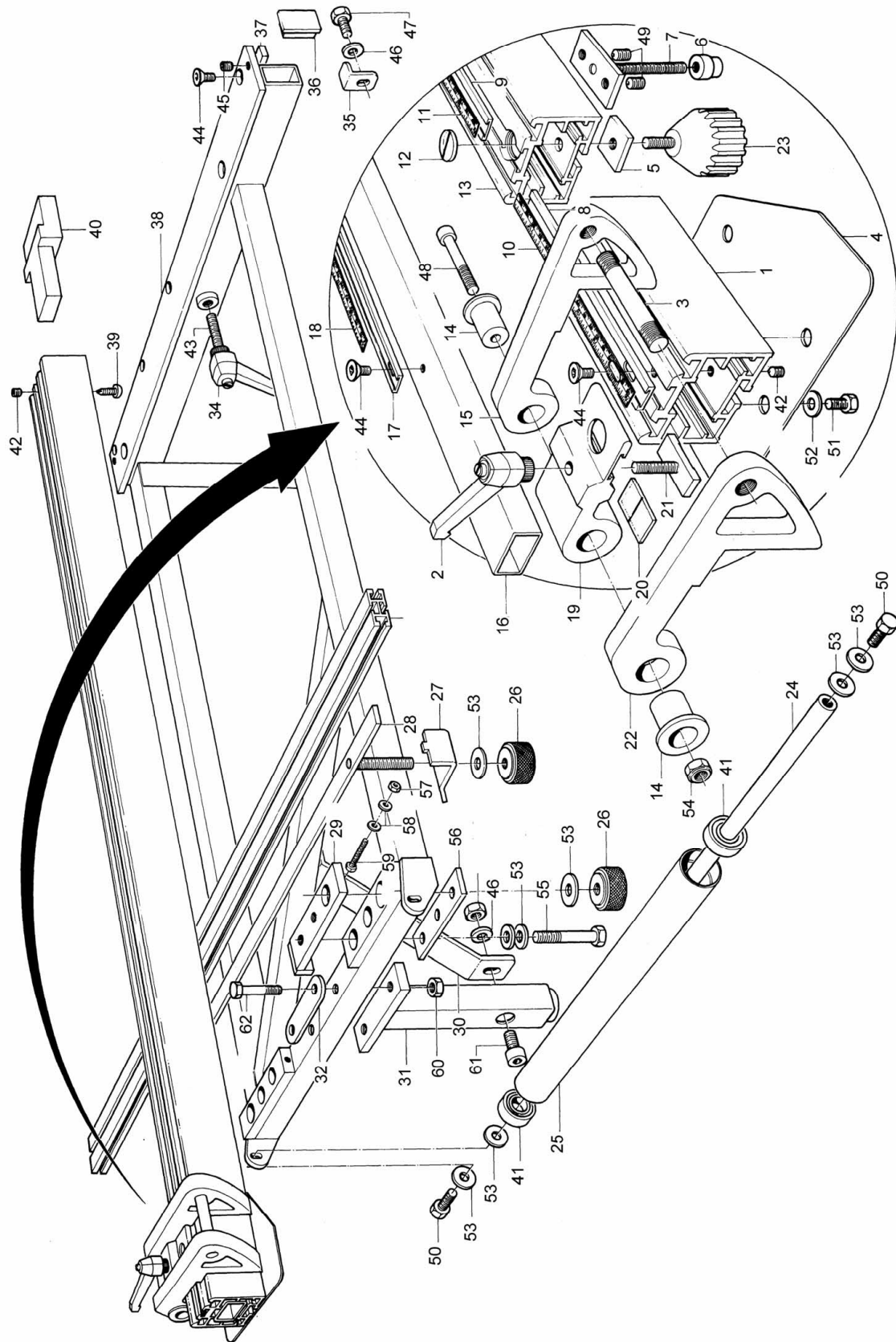
## Parts List: Crosscut Fence Assembly

(Exploded view on page 48)

Index No.	Part No.	Description	Size	Qty
1	HPS126-601	Cross Cut Fence (Short)		1
2	HPS67-430	Handle		1
3	HPS126-603	Shaft		1
4	HPS126-604	Support Guide		1
5	HPS67-614	Square Nut		1
6	HPS126-606	Bushing		1
7	HPS126-607	T-Bolt		1
8	HPS126-608	Scale Plate (Short)		1
9	HPS126-609	Scale Plate (Long)		1
10	HPS126-610	Scale (Short)		1
11	HPS126-611	Scale (Long)		1
12	HPS126-612	Lens		1
13	HPS126-613	Cross Cut Fence (Long)		1
14	HPS126-614	Bushing		2
15	HPS126-615	Left Stop		1
16	HPS126-616	Guide Tube		1
17	HPS126-617	Scale Plate		1
18	HPS126-618	Scale		1
19	HPS126-619	Bracket		1
20	HPS126-620	Lens		1
21	HPS67-609	T-Bolt		1
22	HPS126-622	Right Stop		1
23	HPS126-248	Hand Knob		1
24	HPS126-624	Roll Shaft		1
25	HPS126-625	Roller		1
26	HPS67-619	Lock Knob		1
27	HPS67-620	Clamp		1
28	HPS126-628	Strap		1
29	HPS126-629	Bracket		1
30	HPS126-630	Bracket		1
31	HPS126-631	Support		1
32	HPS126-632	Plate		1
33	HPS67-627	Cross Tube		1
34	HPS126-419	Handle		1
35	HPS126-635	Table Bracket		1
36	HPS126-636	End Cap		2
37	HPS126-637	Strap Bracket		1
38	HPS126-638	Support Plate		1
39	HPS126-639	Self Tapping Screw	10 x 3/4	1
40	HPS126-640	Bracket		1
41	BB-6003ZZ	Ball Bearing		2
42	TS-2276081	Socket Set Screw	M6 x 8	1
43	HPS126-643	Stud	M10 x 80	1
44	TS-1514011	Socket Head Flat Screw	M6 x 12	12
45	TS-1524011	Socket Set Screw	M8 x 8	2
46	TS-1550061	Flat Washer	M8	8
47	TS-1490021	Hex Cap Screw	M8 x 16	1
48	TS-1504121	Socket Head Cap Screw	M8 x 60	2
49	TS-1525011	Socket Set Screw	M10 x 10	2
50	TS-1491021	Hex Cap Screw	M10 x 20	2
51	TS-1503021	Hex Cap Screw	M6 x 10	4
52	TS-1550041	Flat Washer	M6	4
53	TS-1550071	Flat Washer	M10	10
54	TS-1541031	Nylon Lock Hex Nut	M8	1
55	TS-1491121	Hex Cap Screw	M10 x 70	3
56	HPS126-656	Support Bracket		1

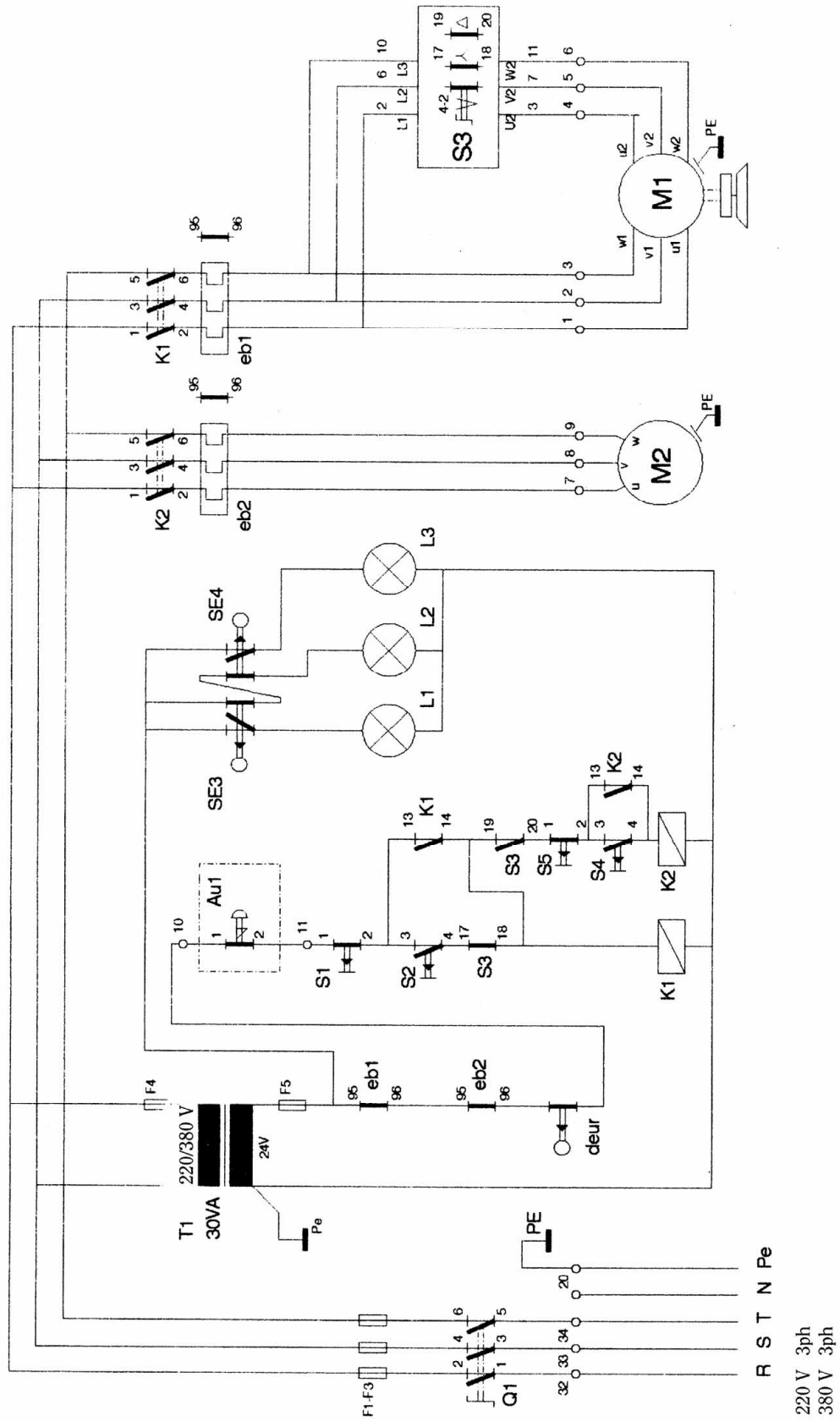
57.....	TS-2311061 .....	Hex Nut.....	M6.....	2
58.....	TS-1550041 .....	Flat Washer.....	M6.....	2
59.....	TS-1482081 .....	Hex Cap Screw .....	M6 x 40 .....	2
60.....	TS-2311081 .....	Hex Nut.....	M8.....	2
61.....	TS-1504041 .....	Socket Head Cap Screw.....	M8 x 20 .....	2
62.....	TS-1490101 .....	Hex Cap Screw .....	M8 x 55 .....	2

# Crosscut Fence Assembly





# Electrical Wiring



## Parts List: Electrical Components Spare Parts

(see diagram on page 49)

Index No.	Part No.	Description	Size	Qty
HPS67-801		Main Switch		1
HPS126-801		Main Fuse	25A	3
HPS126-802		Primary Transformer Fuse	0.5A, 6 x 20mm	1
HPS126-803		Secondary Transformer Fuse	2A, 6 x 20mm	1
HPS126-804		Fuse Holder		1
HPS126-805		Thermal Overload Main Motor	16-22A	1
HPS126-806		Thermal Overload Scoring Motor	2.8-4.4A	1
HPS126-807		Micro Switch (for Door)		1
HPS67-808		Transformer	230-400-24V 40VA	1
HPS126-808		Emergency Stop Switch	AU1	1
HPS126-809		Magnetic Starter Main Motor		1
HPS126-810		Magnetic Starter Scoring Motor		1
HPS126-811		Micro Switch (RPM Indicator)		1
HPS126-812		Micro Switch (Saw Blade Cover)		1
HPS126-813		RPM Indicator Lights	24V	1
HPS67-811		Emergency Stop Switch	AU2	1
HPS67-812		Emergency Stop Electrical Cabinet		1
HPS67-814		Start (Saw Motor)		1
HPS67-815		Start (Scoring Motor)		1
HPS67-816		Star-Delta Switch	3.7 kW	1



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