

# INTELLIGENT BANDSAW ALPHA A-15



C US



Revision A (2025-10-16)

## Contents

|                                                                |    |
|----------------------------------------------------------------|----|
| <b>1. Foreword</b>                                             | 1  |
| <b>2. Limited Warranty</b>                                     | 1  |
| <b>3. Safety Regulations</b>                                   | 2  |
| <b>4. Product Introduction</b>                                 | 7  |
| 4.1. Product Description                                       | 7  |
| 4.2. Product Components                                        | 7  |
| 4.3. Product Specifications                                    | 8  |
| 4.4. Power Requirements                                        | 9  |
| 4.5. Electrical Circuit Requirements                           | 9  |
| 4.6. Grounding Requirements                                    | 9  |
| 4.7. Extension Cord Guidelines                                 | 10 |
| 4.8. Dust Collection Requirements                              | 10 |
| 4.9. Electrical Circuit Requirements                           | 10 |
| 4.10. Cutting Capacity                                         | 10 |
| 4.11. Emergency Situations                                     | 10 |
| 4.12. Electrical Schematic                                     | 11 |
| <b>5. Packing List</b>                                         | 14 |
| <b>6. Installation</b>                                         | 16 |
| <b>7. Operation</b>                                            | 18 |
| 7.1 Installing the Display Assembly                            | 18 |
| 7.2 Power Supply                                               | 18 |
| 7.3 Control Panel                                              | 19 |
| 7.4 Table Tilt Angle Adjustment                                | 22 |
| 7.5 Table Tilt Angle Display Calibration                       | 22 |
| 7.6 Calibrating Table Tilt Angle Stops                         | 23 |
| <b>8. Blade Installation</b>                                   | 26 |
| 8.1 Blade Tensioning                                           | 26 |
| 8.2 Blade Tracking                                             | 27 |
| 8.3 Blade Guide Adjustment                                     | 27 |
| 8.4 Upper Blade Guide Position Calibration                     | 28 |
| 8.5 Lower Blade Guide Position Calibration                     | 29 |
| 8.6 Calibrating Blade-to-Table T-Slot Parallelism              | 29 |
| 8.7 Calibrating Blade-to-Table Squareness                      | 30 |
| 8.8 Attaching the Dust Cover                                   | 32 |
| 8.9 Attaching the Handle                                       | 32 |
| 8.10 Attaching the Tool Holder                                 | 32 |
| <b>9. Installing the Guide Rails</b>                           | 33 |
| 9.1 Front Guide Rail Installation Bolt Orientation (Important) | 33 |
| 9.2 Rear Guide Rail                                            | 34 |
| 9.3 Attaching the Scale Rulers                                 | 35 |
| <b>10. Installing the Fence Assembly</b>                       | 35 |
| 10.1 Adjusting the Fit Between the Slide Block and Guide Rail  | 35 |
| 10.2 Fence Locking                                             | 36 |

|                                                                 |           |
|-----------------------------------------------------------------|-----------|
| 10.3 Adjusting the Locking Force.....                           | 36        |
| 10.4 Fence Fine Adjustment.....                                 | 37        |
| 10.5 Adjusting Fence Vertical Positioning.....                  | 37        |
| 10.6 Use of High and Low Fence.....                             | 37        |
| 10.7 Use of Quick Positioning Flip Stops.....                   | 37        |
| 10.8 Calibrating Fence-to-Table Squareness and Parallelism..... | 38        |
| 10.9 Adjusting Scale Ruler Position.....                        | 38        |
| <b>11. Cutting Speed Adjustment / Belt Position Change.....</b> | <b>39</b> |
| <b>12. Belt Replacement.....</b>                                | <b>39</b> |
| <b>13. Installing the Dust Collection System.....</b>           | <b>40</b> |
| <b>14. Maintenance and Care.....</b>                            | <b>41</b> |
| 14.1 Daily Inspection.....                                      | 41        |
| 14.2 Cleaning and Maintenance.....                              | 41        |
| <b>15. Exploded View and Parts List.....</b>                    | <b>42</b> |

## 1. Foreword

Thank you for your purchase of the Harvey ALPHA A-15 Intelligent Bandsaw.

This manual provides essential information for qualified operators and outlines the standard use of this machine in a typical workshop environment. The A-15 is equipped with multiple safety features designed to protect the operator during use. However, no manual can anticipate every possible safety concern. Operators should have prior experience with machines of this type and are strongly advised to read the entire manual before operating the bandsaw. If any errors or omissions related to operation or installation are found in this manual, they will be corrected promptly.

## 2. Limited Warranty

### Warranty Period:

- Two (2) years from the date of retail purchase.

### Proof of Purchase:

- Please retain your dated sales receipt or invoice. It is required for warranty validation and service.

### Coverage:

- Harvey Industries warrants that the A-15 Intelligent Bandsaw is free from defects in materials and workmanship under normal use and service, for a period of two years from the original purchase date. This limited warranty applies only to the original retail purchaser and is non-transferable.

### Exclusions:

- This warranty does not cover damage or defects resulting from:
  - Misuse or abuse
  - Normal wear and tear
  - Negligence or accidents
  - Unauthorized repairs or modifications
  - Lack of proper maintenance
  - Use outside intended applications

### Limitations of Liability:

- Harvey shall not be liable for any incidental, special, or consequential damages, including but not limited to personal injury or property damage, arising from the use or misuse of this product.

### How to Obtain Service:

- To make a warranty claim, contact your local authorized distributor or Harvey customer service. After inspection and confirmation of a valid warranty issue, Harvey will repair or replace, at its discretion, any part found to be defective in materials or workmanship.



## WARNING

Notice to California Residents: This product can expose you to wood dust, which is known to the State of California to cause cancer. For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

### **3. Safety Regulations**

#### **3.1 General Safety Instructions**

##### **1.KNOW YOUR MACHINE.**

Read and understand the owner's manual and labels affixed to the machine. Learn its application and limitations as well as its specific potential hazards;

##### **2.GROUND THE MACHINE.**

In the event of an electrical short, grounding reduces the risk of electrical short;

##### **3.KEEP THE BLADE GUARDS IN PLACE.**

Keep in good working order, properly adjusted and aligned;

##### **4.REMOVE THE ADJUSTING TOOLS**

Form a habit of checking that the key and adjusting wrenches are removed from the machine before turning it on;

##### **5.KEEP THE WORK AREA CLEAN.**

Cluttered areas and benches invite accidents. Make sure the floor is clean and not slippery due to wax and sawdust build-up;

##### **6.AVOID A DANGEROUS ENVIRONMENT.**

Don't use machines in damp or wet locations or expose them to rain. Keep the work area well lit and provide adequate surrounding work space;

##### **7.KEEP CHILDREN AWAY.**

All visitors should be kept a safe distance from work area;

##### **8.SECURE YOUR WORKSHOP FROM UNAUTHORIZED USE.**

To prevent unintended use—especially by children—it is recommended to store the machine in a locked room or area when not in operation. Disconnect the power supply (e.g., unplug the machine or switch off the circuit breaker) and store any blades or accessories separately and out of reach;

##### **9.USE THE PROPER SPEED.**

A machine will do a better and safer job when operated at the proper speed;

##### **10. USE THE RIGHT MACHINE.**

Don't force the machine or the attachment to do a job for which it was not designed;

##### **11. WEAR THE PROPER APPAREL.**

Do not wear loose clothing, gloves, neckties or jewelry (rings, watch) because they could get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Roll up long sleeves above the elbows;

##### **12. MAINTAIN PROPER FOOTING.**

Keep proper footing and balance at all time. Do not over-reach to perform an operation;

##### **13. MAINTAIN THE MACHINE WITH CARE.**

Keep tools sharp and clean for the best and safest performance;

##### **14. DISCONNECT POWER BEFORE MAINTENANCE.**

Unplug the machine before performing any maintenance tasks, such as changing blades, accessories, or attachments. This helps prevent injury during servicing;

##### **15. PREVENT ACCIDENTAL START-UP.**

To avoid unintentional operation, always unplug the machine when it is not in use or before making setup changes (e.g., adjusting fence, guides, or workpiece positioning);

##### **16. USE RECOMMENDED ACCESSORIES.**

Consult the manual for recommended accessories. Follow the instructions that accompany the accessories. The use of improper accessories may cause hazards;

##### **17. NEVER STAND ON THE MACHINE.**

Serious injury could occur if the machine tips over. Do not store materials such that it is necessary to stand on the machine to reach them;

##### **18. CHECK FOR DAMAGED PARTS.**

Before further use of the machine, a guard or other parts that are damaged should be carefully checked to ensure that they will operate properly and perform their intended function. Check for alignment of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other parts that are damaged should be properly repaired or replaced;

### **19. NEVER LEAVE THE MACHINE RUNNING UNATTENDED.**

Always press the **OFF or Emergency STOP button** to stop the blade and wait until it comes to a complete stop before walking away. Do not leave the machine unattended while running. Use the Emergency Stop buttons to prevent accidental start-up if stepping away temporarily;

### **20. ADEQUATE LIGHT**

Ensure that adequate general or localized lighting is provided in work area;

## **3.2 Bandsaw Safety Instructions**

1. Maintain the machine regularly as instructed in the manual. Lubricate and replace damaged components promptly.
2. Never leave the machine unattended while the blade is in motion. Always maintain a line of sight with the blade until it has come to a complete stop. If you must step away, unplug the machine or activate the emergency stop to prevent accidental operation
3. Use only recommended accessories to prevent injuries resulting from incompatible or unsafe attachments (such as the Big Eye Fence, RG-2 Roller Guide, etc.).
4. Before starting the machine, ensure the fence, table, and blade guides are properly adjusted and securely locked. Check that the blade is properly tensioned and correctly aligned.
5. When cutting, adjust the upper blade guide so that the gap between its lower edge and the top of the workpiece is no more than 3/16" to 1/4" (approximately 4–6 mm).
6. Keep all parts of your body away from the cutting path of the blade at all times during operation.
7. Never reach across the blade, regardless of the reason.
8. Cutting can only be performed from the front or side of the machine
9. Do not operate the machine when fatigued or under the influence of alcohol or medication.
10. Always unplug the power cord before changing the blade, servicing the machine, or adjusting any components.
11. Provide sufficient support from the side or rear of the machine when cutting long or wide stock.
12. Avoid awkward body positions during operation to prevent accidental slips that may lead to hand contact with the moving blade.
13. Select blade speed based on material type:
  - Use low speed (2300 FPM) for cutting wet wood.
  - Use high speed (4300 FPM) for cutting dry wood.
14. The blade must be fully stopped before performing any action other than cutting.
15. The machine must be connected to an external dust extraction system. Always start the dust collector before cutting, as wood cutting generates airborne dust.
16. Never attempt to clear sawdust, chips, or offcuts while the machine is running.
17. Replace any damaged or missing warning labels or specification decals promptly.
18. Do not modify the drive system to increase blade speed beyond factory specifications. Also, avoid feeding material too aggressively—excessive feed rate can cause loss of control or poor cutting results.
19. Wood cutting generates flammable dust and may produce ignition sources. Keep the area around the machine free of flammable materials, open flames, and exposed electrical wiring.
20. The bandsaw blade is extremely sharp and hazardous. Improper handling can result in life-threatening injuries:
  - Coiled blades may uncoil suddenly with great force and fly unpredictably. Use extreme caution when uncoiling, including when removing blades from boxes or packaging. When installing blades, wear protective gloves, long protective pants, certified safety shoes (with anti-saw protection, steel toe caps, and slip-resistant soles), and certified close-fitting safety goggles.

- During blade installation, ensure all people and pets remain at least 20 feet (6 meters) away.
- Use proper handling equipment when transporting coiled blades.

### 3.3 Residual Risks

To ensure safe operation and reduce the risk of injury or exposure, please follow all guidelines below:

#### 1. Dust Exposure

Take precautions to minimize inhalation of harmful dust particles by wearing a properly fitted dust mask. Dust exposure levels can vary depending on several factors, including:

- The condition of the machine and its components
- The type of material being cut
- The setup and proximity of dust collection to the cutting area
- The alignment of dust collection fittings or blade guards
- Whether the machine is connected to an external dust extractor that meets the specifications listed in Section 8.14 of this manual

#### 2. Personal Protective Equipment (PPE)

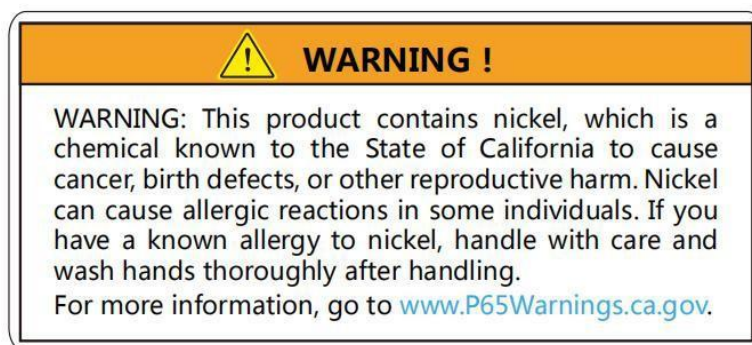
- Hearing Protection: Wear hearing protection to guard against potential hearing damage from prolonged exposure to machine noise.
- Eye Protection: Always wear safety goggles while operating the machine to prevent eye injuries from chips or dust.
- Blade Handling: Handle blades with extreme care during installation, removal, or cleaning to avoid cuts.

#### 3. Operating Safety

- Never clean sawdust or chips while the machine is running. Always wait until the blade has come to a complete stop.
- Before each use, verify that all guards and safety devices are properly installed and fully functional.
- In the event of a power failure, note that the blade may take longer to stop spinning. Remain at a safe distance until the blade has completely stopped moving.

### 3.4 Explanation of Machine Labels

#### ● Nickel Warning Label:



Some parts of this machine—including the table and flywheels—are coated with nickel plating. Nickel can cause allergic reactions in sensitive individuals, particularly with repeated or prolonged skin contact. If you have a known nickel allergy, wear protective gloves when operating the machine and wash your hands thoroughly afterward. Discontinue use and seek medical advice if you develop symptoms such as rash, itching, or swelling.

● **General Warning Label:**



● **High Voltage Warning Label (Lightning Symbol):**



This label indicates high voltage is present inside. Do not open the enclosure while the power is connected.

● **Cutting Hazard Label:**



This label marks areas where the blade passes through. Do not approach these areas while the power is on.

### 3.5 Safety Equipment

When cutting narrow workpieces, a Push Block must be used. Push the work piece against the fence if necessary. A push block can be either made by the operator or purchased separately as shown in Fig. 3-1.

If the workpiece is less than 4-3/4" (120 mm), you must use a suitable plastic or wooden push stick (not provided), as shown in Fig.3-2, to prevent your hands from getting too close to the saw blade during operation and avoid injury.

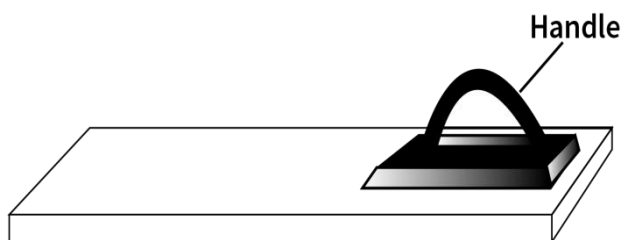


Fig. 3-1

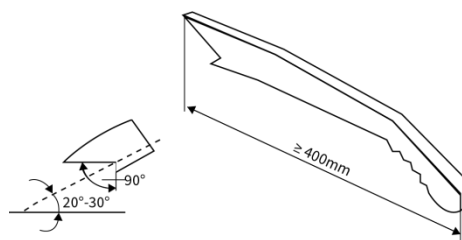


Fig. 3-2

#### Note:

All bandsaws pose a significant risk of severe cutting injuries or amputation. To minimize the risk of personal injury when using this product, it is essential to read and understand the instruction manual, and to follow all safety guidelines contained within before performing any operation.

#### Warning:

This machine generates wood chips and dust during operation. It must be connected to an external chip and dust extraction system during installation and use. Permanently installed external extraction systems must comply with the requirements of EN 12779.

For U.S. customers: While EN 12779 is a good safety guideline, it is not required in the U.S. For domestic safety, please follow OSHA rules for dust control, and check that your dust collection system meets any local or national codes—especially for controlling fine or combustible dust.

### 3.5 Noise Declaration

- Sound Power Level:  $\leq 67$  dB(A)
- Sound Pressure Level:  $\leq 57$  dB(A)
- Measurement Uncertainty: 4 dB(A)

The noise levels of this equipment have been measured in accordance with the test methods specified in ISO 3746:2010 and ISO 11202.

**\*Note:** These values represent emission levels measured under specific test conditions. They do not necessarily reflect safe exposure levels in actual working environments. Real exposure depends on factors such as room size, acoustics, other nearby machines, and duration of use. Always follow local noise regulations and it is recommended to use appropriate hearing protection when operating the machine.

## 4. Product Introduction

### 4.1 Product Description

The ALPHA A-15 Intelligent Bandsaw is a premium woodworking machine engineered for precision, versatility, and user-friendly operation. Designed with advanced features and a refined aesthetic, the A-15 delivers exceptional performance for discerning woodworkers.

#### Key Features:

- Intelligent Control System – Optimizes performance and enhances safety during operation
- Flexible Blade Tensioning Mechanism – Ensures proper tension for various blade types and cutting tasks
- Zero-Backlash Tilting Table – Provides accurate and smooth angle adjustments
- Finely Adjustable Blade Guide System – Promotes stability and clean, accurate cuts
- Big Eye Rip Fence System – Offers high visibility and precision fence alignment

Each component is built with meticulous attention to detail, ensuring smooth operation, exceptional cutting accuracy, and long-lasting performance.

**Note:** While all components are treated with anti-corrosion protection, the A-15 is intended for use in dry, indoor environments to maintain its optimal condition and longevity.

### 4.2 Product Components

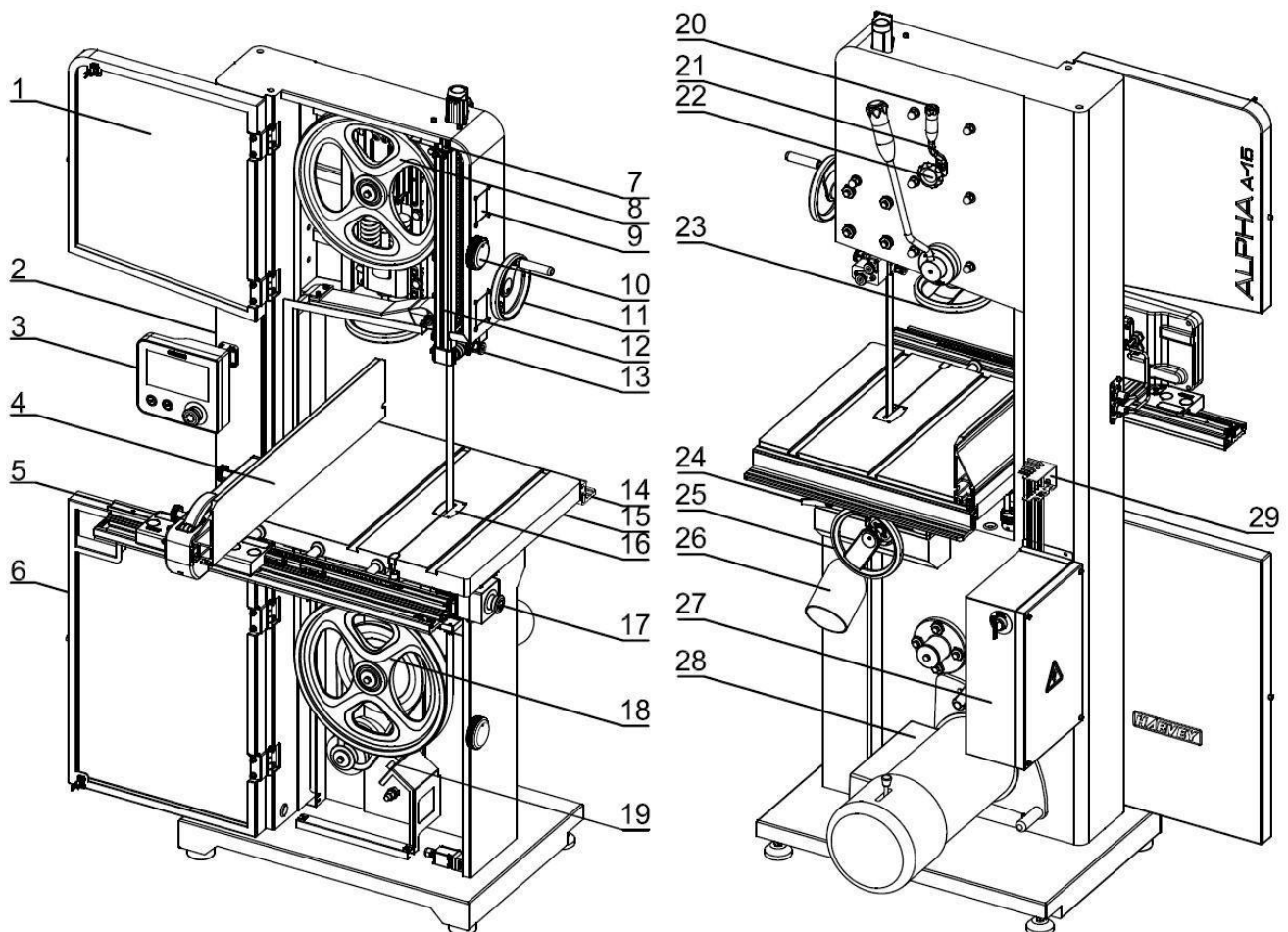


Fig. 4-1

|    |                             |    |                                 |
|----|-----------------------------|----|---------------------------------|
| 1  | Upper Cabinet Door          | 16 | Table insert                    |
| 2  | Frame                       | 17 | Secondary Emergency Stop Button |
| 3  | Control Panel               | 18 | Lower Flywheel                  |
| 4  | Fence                       | 19 | Speed Sensor                    |
| 5  | Front Guide Rail            | 20 | Adjustment Knob Locking Handle  |
| 6  | Lower Housing Door          | 21 | Tension Handle                  |
| 7  | Safety Shutoff Mechanism    | 22 | Adjustment Knob                 |
| 8  | Upper Flywheel              | 23 | Tension Handwheel               |
| 9  | Viewer                      | 24 | Worktable Lock Handle           |
| 10 | Door Lock                   | 25 | Worktable Tilt Handwheel        |
| 11 | Blade Guide Elevation Wheel | 26 | Dust Port                       |
| 12 | Upper Blade Guard           | 27 | Electrical Cabinet              |
| 13 | Upper Blade Guide           | 28 | Motor                           |
| 14 | Rear Guide Rail             | 29 | Tool Rack                       |
| 15 | Worktable                   |    |                                 |

### 4.3 Product Specifications

| Model                                        | US Version                                   |
|----------------------------------------------|----------------------------------------------|
| Net Weight                                   | 694lb (315Kg)                                |
| Gross Weight (Packaged)                      | 794lb (360Kg)                                |
| Length                                       | 34-7/8" (885mm)                              |
| Width                                        | 42-1/2" (1080mm)                             |
| Height                                       | 76-3/4" (1950mm)                             |
| Maximum Height                               | 78-3/4" (2000mm)                             |
| Base Dimensions                              | 28-3/4"X19-3/4" (730mmX500mm)                |
| Packaging Dimensions                         | 39-3/8"x37-3/8"x82-5/8"<br>(1000x950x2100mm) |
| Horsepower, Electric Phase, Voltage, Current | 3HP/1Ph/230V/14A                             |
| Frequency                                    | 60HZ                                         |
| Blade Width                                  | 1/8~1" (3~25mm)                              |
| Blade Length                                 | 143-3/4"±1/4" (3650±5mm)                     |
| Blade Tension Range                          | 0~6000N (0~6000N)                            |
| Flywheel Diameter                            | 15" (381mm)                                  |
| Maximum Cutting Height                       | 14-1/2" (368mm)                              |
| Throat Depth                                 | 14-1/4" (362mm)                              |
| Cutting Speed                                | 2300FPM&4300FPM<br>(700m/min&1300m/min)      |
| Table Size                                   | 21-5/8"X19-3/4" (550mmX500mm)                |
| Table Height from Ground                     | 38-1/2" (978mm)                              |
| T-Slot Dimensions                            | 1"X5/32"X3/4" (25.4X4.25mmX19.05mm)          |
| Table Tilt Angle                             | -5~45°                                       |
| Fence Size                                   | 1/2"&6"X29-3/4" (12.5mm&155mmX755mm)         |
| Dust Port Diameter                           | 4" (100mm)                                   |

#### 4.4 Power Requirements

| Specification           | Value        |
|-------------------------|--------------|
| Voltage                 | 230V         |
| Current                 | 14A          |
| Frequency               | 60Hz         |
| Phase                   | Single (1Ph) |
| Receptacle (N. America) | NEMA 6-20    |
| Circuit Breaker         | 20A          |

**Important Safety Note:**

All electrical setup—including initial installation, wiring, or any changes to the power connection—must be performed by a qualified electrician. This ensures compliance with safety standards and reduces the risk of electrical shock, fire, or serious injury.

Never adjust or repair the machine while it is connected to power. Always unplug the machine or shut off the power supply before performing any maintenance.

#### 4.5 Electrical Circuit Requirements

- This machine is pre-wired for operation on a 230V grounded circuit and must meet the following:
- Power Supply: 230V, 60Hz, Single Phase
- Current Rating: 14A
- Plug/Outlet: Must match the local electrical standard in your region

**Note:** If your existing outlet or circuit does not meet these specifications, contact a qualified electrician to ensure proper installation and full compliance with local electrical codes.

#### 4.6 Grounding Requirements

Proper grounding provides a low-resistance path to safely discharge electrical faults. This machine includes a grounding conductor and grounding plug as part of the power cord.

- **Connection:** Plug must be inserted into a properly installed and grounded outlet that complies with local codes.
- **Do Not Modify:** Never alter the provided plug. If it doesn't fit your outlet, have a qualified electrician install a matching outlet.
- **Grounding Wire:** Typically green or green with yellow stripes. Do not connect the grounding wire to a live terminal.
- **When in Doubt:** Consult a qualified electrician or service technician

## 4.7 Extension Cord Guidelines

- Use only properly rated NEMA 6-20 extension cords with a 2-pole, 3-wire grounding plug and receptacle (North America).
- Ensure the cord is of suitable gauge and length to supply sufficient current without voltage drop.
- Replace damaged or worn cords immediately.
- If unsure, consult a qualified electrician for proper selection and installation.

## 4.8 Circuit Compatibility

- This tool is designed for use on 230V circuits only.
- It comes with a NEMA 6-20P plug (North America) for use with matching NEMA 6-20R receptacles.
- Do not use plug adapters.

If connecting to a different circuit type, modifications must be made by a licensed electrician and comply with all local electrical regulations.



## 4.9 Dust Collection Requirements

The use of a dust extractor is mandatory when operating this equipment. A 100 mm (4") dust port is located at the rear of the machine for connecting a corrugated dust hose, which must be properly grounded.

Dust extraction system specifications:

- Minimum airflow:  $\geq 650 \text{ m}^3/\text{h}$  ( $\text{CFM} \geq 367$ )
- Pressure drop per dust extraction outlet at recommended speed:  $\geq 1000 \text{ Pa}$
- Minimum air velocity in ducting:  $\geq 22 \text{ m/s}$
- Duct inner diameter: 100 mm

## 4.10 Cutting Capacity

This equipment is intended for cutting wood only.

The maximum cutting width is 362 mm, which refers to the maximum width of a workpiece positioned to the left of the blade.

The maximum cutting height is 368 mm, referring to the height of a workpiece either placed on the table or passing above it.

The minimum allowable workpiece width is  $\geq 10 \text{ mm}$ .

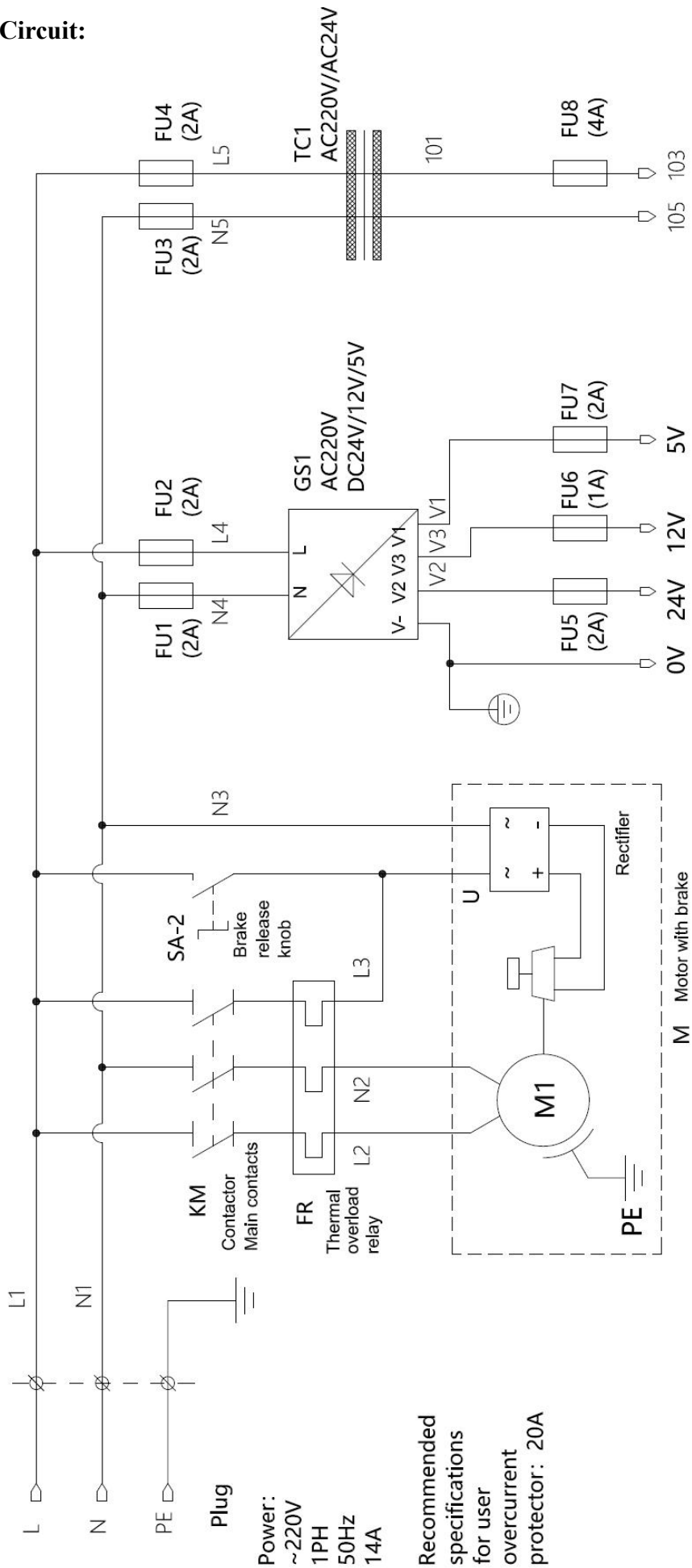
## 4.11 Emergency Situations

In case of emergencies such as machine damage, abnormal noise, blade breakage, or blade derailment, immediately press any Emergency Stop button and disconnect the power supply. Resume operation only after identifying and resolving the issue.

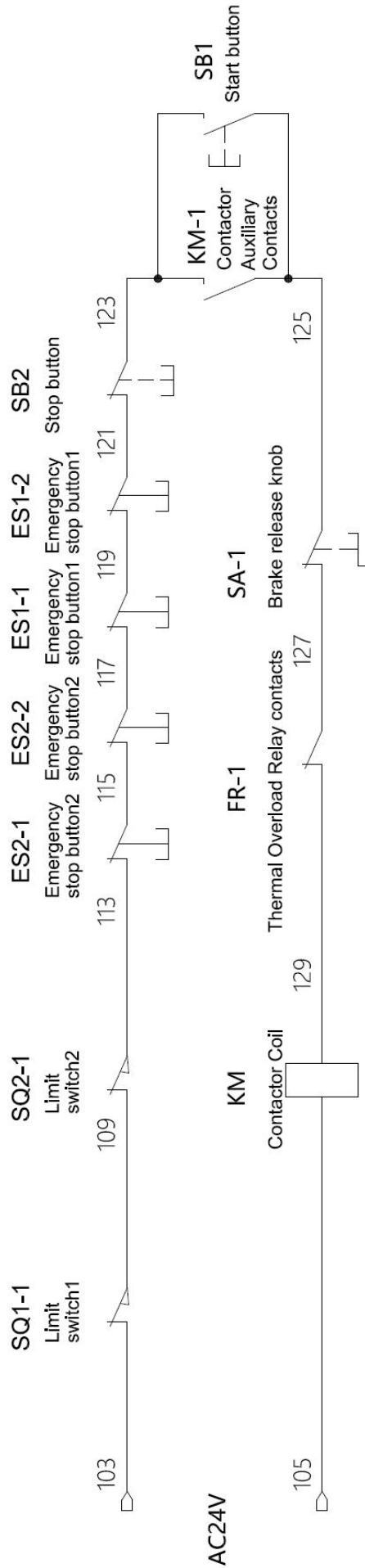
**Note: If the machine malfunctions but no alarm message appears on the screen, please contact the manufacturer immediately.**

4.12 Electrical Schematic

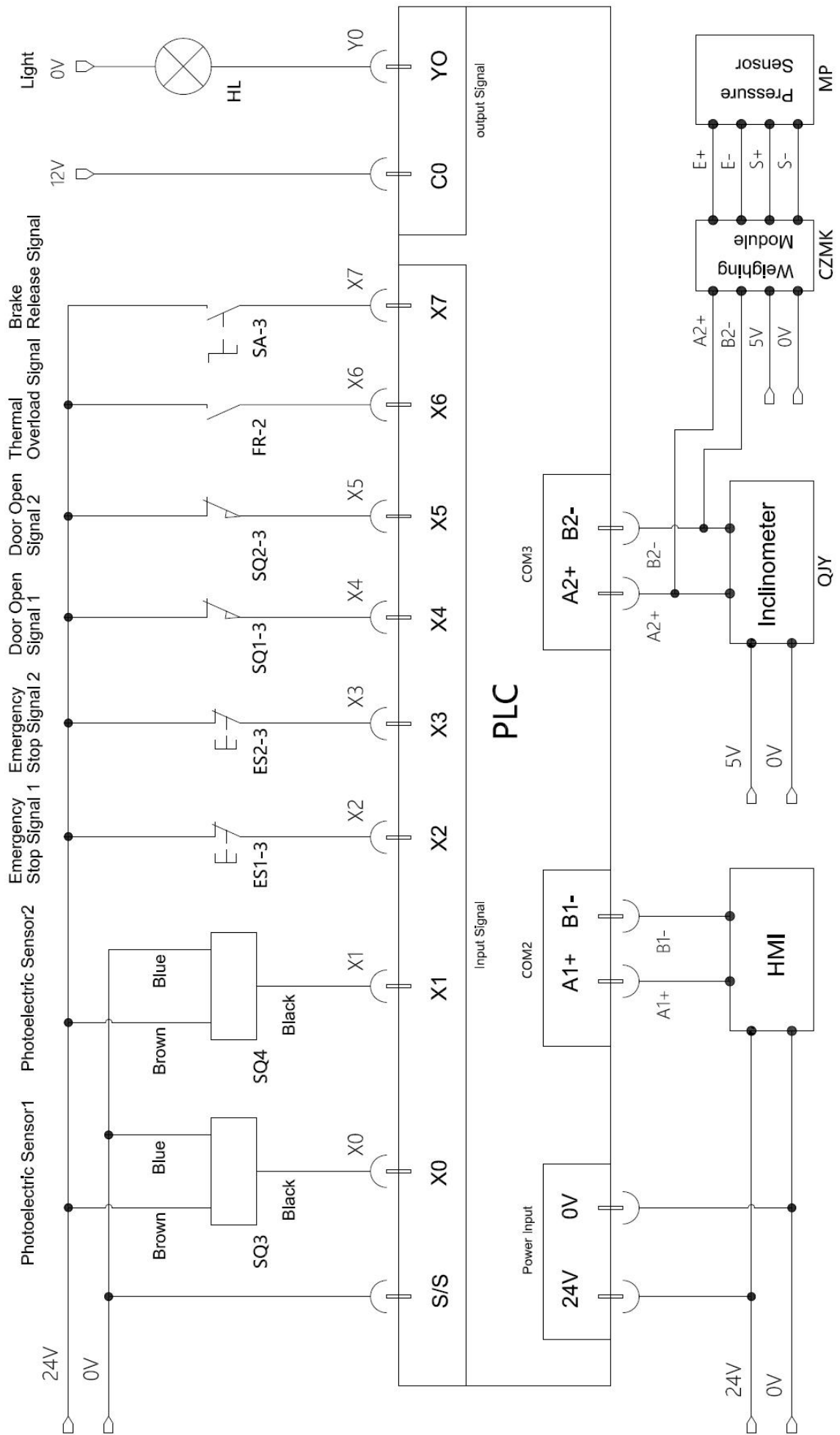
4.12.1 Main Circuit:



4.12.2 Control Circuit:



4.12.3 Detection Circuit:



## 5. Packing List

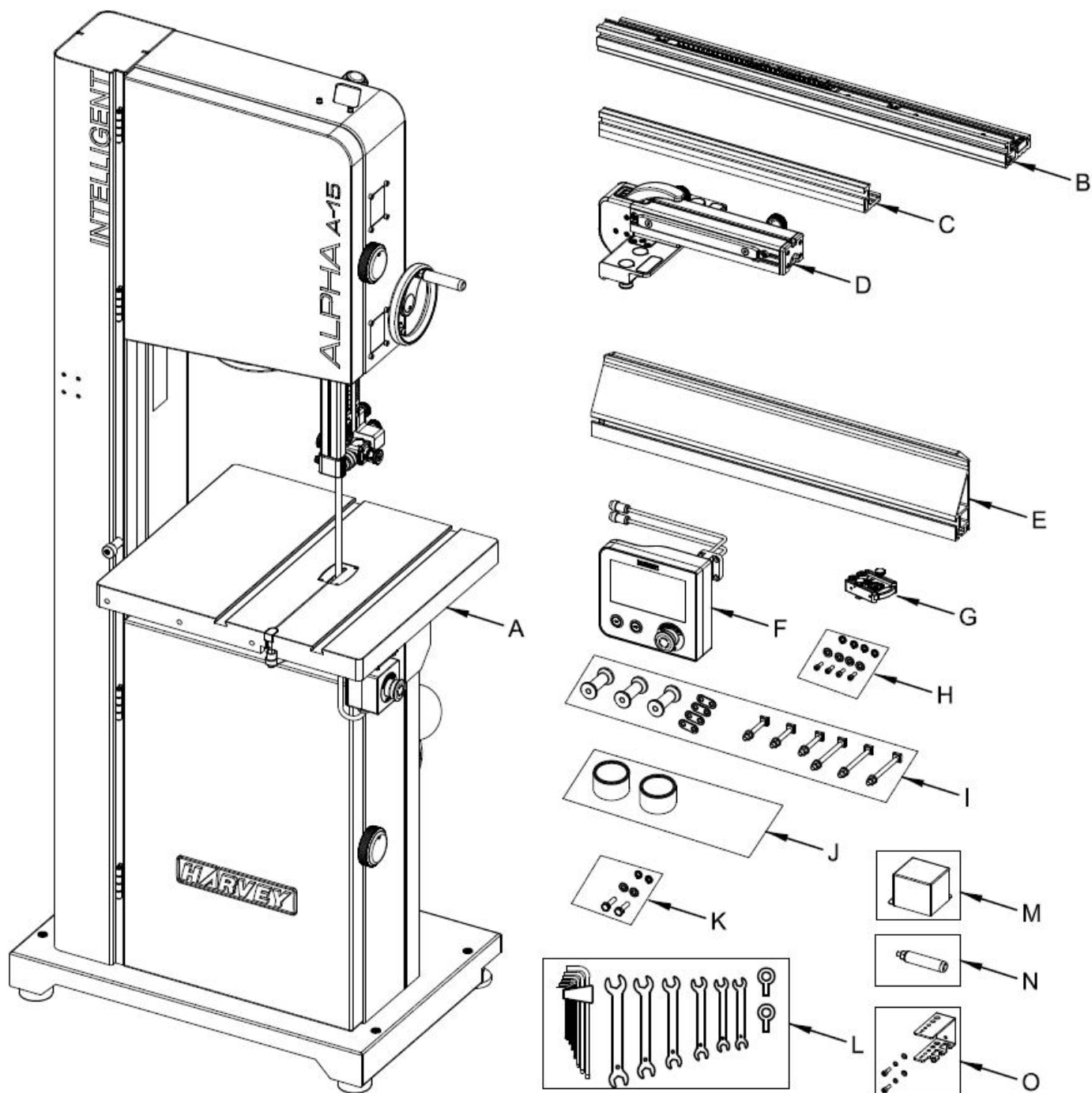


Fig. 5-1

The wooden crate contains one main unit and three accessory boxes (see Fig. 5-1). Use the figure and the parts list below to confirm that all items are present.

**Note:** If any parts appear missing during unpacking, first check their designated installation points and review all packaging materials to ensure nothing has been overlooked. If items are confirmed to be missing, please contact Harvey Customer Support.

|           |                                                        |   |
|-----------|--------------------------------------------------------|---|
| <b>A.</b> | Main Unit.....                                         | 1 |
| <b>B.</b> | Front Guide Rail Assembly.....                         | 1 |
| <b>C.</b> | Rear Guide Rail Assembly.....                          | 1 |
| <b>D.</b> | Fence Main Assembly.....                               | 1 |
| <b>E.</b> | Fence.....                                             | 1 |
| <b>F.</b> | Display Assembly.....                                  | 1 |
| <b>G.</b> | RG-2.....                                              | 1 |
| <b>H.</b> | Display Mounting Hardware                              |   |
|           | —Flat Washer 8mm.....                                  | 4 |
|           | —Spring Washer 8mm.....                                | 4 |
|           | —Hex Bolt M8.....                                      | 4 |
| <b>I.</b> | Guide Rail Mounting Hardware                           |   |
|           | —Eccentric Bolt M8 × 110mm.....                        | 3 |
|           | —Eccentric Bolt M8 × 45mm.....                         | 3 |
|           | —Rail Mounting Block.....                              | 3 |
|           | —Flat Washer 8mm.....                                  | 6 |
|           | —Spring Washer 8mm.....                                | 6 |
|           | —Hex Nut M8.....                                       | 6 |
|           | —Copper Shims.....                                     | 4 |
| <b>J.</b> | Scale Ruler                                            |   |
|           | —Rail Scale Ruler (Metric & Imperial, Set).....        | 1 |
|           | —Blade Guide Scale Ruler (Metric & Imperial, Set)..... | 1 |
| <b>K.</b> | Emergency Stop Box Mounting Hardware                   |   |
|           | —Flat Washer 5mm.....                                  | 2 |
|           | —Spring Washer 5mm.....                                | 2 |
|           | —Hex Bolt M5.....                                      | 2 |
| <b>L.</b> | Included Tools                                         |   |
|           | —Open Wrench 7.....                                    | 1 |
|           | —Open Wrench 8.....                                    | 1 |
|           | —Open Wrench 16.....                                   | 1 |
|           | —Open Wrench 18.....                                   | 1 |
|           | —Open Wrench 13-27.....                                | 1 |
|           | —Allen Key Set (2/2.5/3/4/5/6/8).....                  | 1 |
|           | —Eye Bolt.....                                         | 2 |
| <b>M.</b> | Dust cover                                             |   |
|           | —Dust cover.....                                       | 1 |
|           | —Flat Washer 5mm.....                                  | 4 |
|           | —Spring Washer 5mm.....                                | 4 |
|           | —Hex Bolt M5.....                                      | 4 |
| <b>N.</b> | Handle.....                                            | 1 |
| <b>O.</b> | Tool holder                                            |   |
|           | —Tool holder.....                                      | 1 |
|           | —Flat Washer 5mm.....                                  | 2 |
|           | —Spring Washer 5mm.....                                | 2 |
|           | —Hex Bolt M5.....                                      | 2 |

## 6. Installation

During transportation or handling, the machine must be operated by trained and qualified personnel, using appropriate lifting and transport equipment.

Ensure that the lifting capacity of the equipment meets the machine's weight requirements.

Due to the considerable weight of the machine, it is recommended to use a forklift or similar equipment, as shown in Figure below.

Do not damage the packaging during transport or storage. Do not expose the machine to rain or moisture.

Permissible environmental temperature for transport and storage: -25°C to 55°C.



### WARNING

It is recommended that two people cooperate during installation to avoid personal injury or equipment damage. Before assembling the equipment, carefully read and understand this manual, and ensure the power supply is disconnected.

#### 6.1 Removing the Pallet

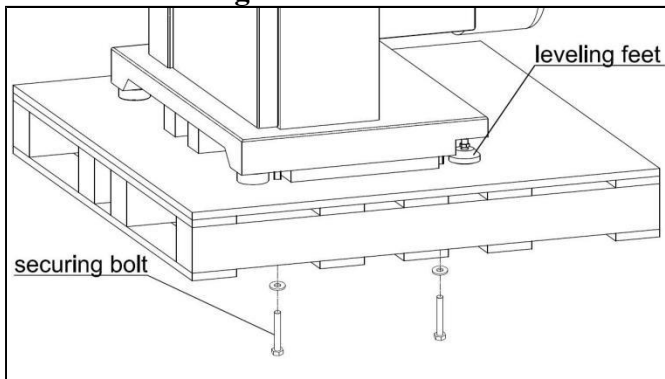


Fig. 6-1

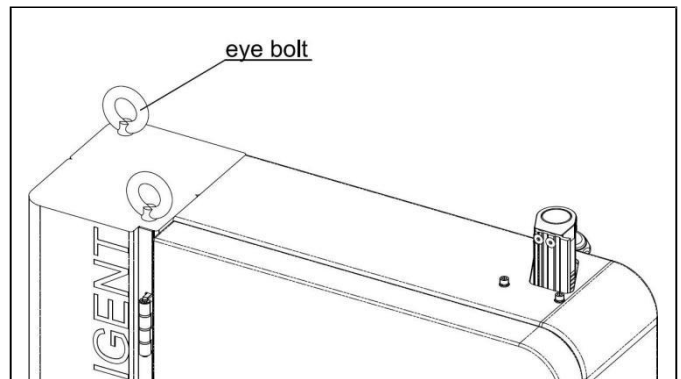


Fig. 6-2

#### ● Method 1:

1. As shown in Fig. 6-1, remove the four securing bolts from underneath the pallet.
2. Use a forklift to lift the machine from the open space beneath the base and remove it from the pallet.  
Place it in the designated working location.
3. Adjust the two rear leveling feet at the base of the machine to ensure it sits stably and evenly on the floor.  
Tighten the lock nuts on the leveling feet to secure them.

- **Method 2:**

1. As shown in Fig. 6-1, remove the four securing bolts from underneath the pallet.
2. As shown in Fig. 6-2, install the two supplied eye bolts into the mounting holes at the top of the column.  
Ensure they are securely fastened.
3. Prepare your own lifting accessories, such as ropes or chains, and attach them to the eye bolts.
4. Use a forklift or other suitable lifting equipment to hoist the machine off the pallet and move it to the designated position.
5. Adjust the two rear leveling feet at the base of the machine to ensure it sits stably and evenly on the floor.  
Tighten the lock nuts on the leveling feet to secure them.

- **Method 3:**

1. As shown in Fig. 6-1, remove the four mounting bolts from underneath the pallet.
2. With multiple people working together, lift the machine off the pallet and place it in the designated location.
3. Adjust the two adjustable leveling feet at the rear of the base to ensure the machine is stably positioned on the floor, then tighten the nuts on the adjustable leveling feet.

**Warning:** There is an eye bolt on the motor intended solely for removal or installation of the motor only. Do not use the eye bolt located on the motor body for lifting the machine as this could damage the motor. When lifting the machine via the eye bolts, only use the two eye bolt points located on top of the machine frame shown in Fig 6-2.

## 7. Operation Instructions

### 7.1 Installing the Display Assembly

1. As shown in Fig. 7-1, mount the Display Assembly onto the machine column using four M5×16 socket head screws then tighten these screws to secure the screen in place.

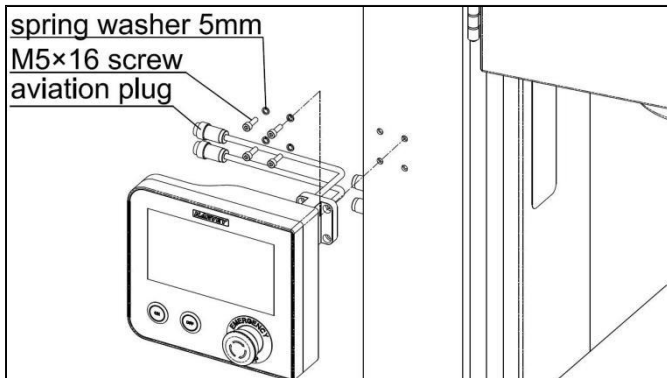


Fig. 7-1

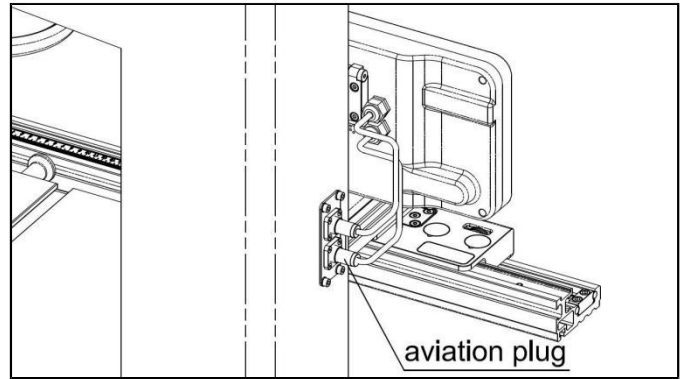


Fig. 7-2

2. As shown in Fig. 7-2, connect the two aviation plugs on the Display Assembly to the two matching sockets on the side of the machine column. Then tighten to secure them in place.

**Note:** The two aviation plugs have different pin configurations and can only be installed in one orientation. Before connecting, carefully check that each plug is correctly aligned with its corresponding socket.

### 7.2 Power Supply

- Input requirement: 230 V, 60 Hz.
- The machine has no built-in power switch; provide an external disconnect or switch at the plug location.
- The outlet or switch must carry an IP 44 rating (water- and dust-resistant).
- Install a properly rated circuit breaker in the supply circuit to protect the machine and operator.

### 7.3 Control Panel

As shown in Fig. 7-3a and 7-3b, the functions of the control panel are as follows:

- |   |                           |    |                            |
|---|---------------------------|----|----------------------------|
| 1 | System Settings Button    | 8  | Tension Self-Test Button   |
| 2 | Blade Tension Display     | 9  | Emergency Stop Button      |
| 3 | Table Tilt Angle Display  | 10 | Blade Spec. Setting Button |
| 4 | Blade Speed Display       | 11 | Off Button                 |
| 5 | Machine Alarm Information | 12 | On Button                  |
| 6 | Calibration Button        | 13 | Microphone                 |
| 7 | Lighting Switch           | 14 | Speaker                    |

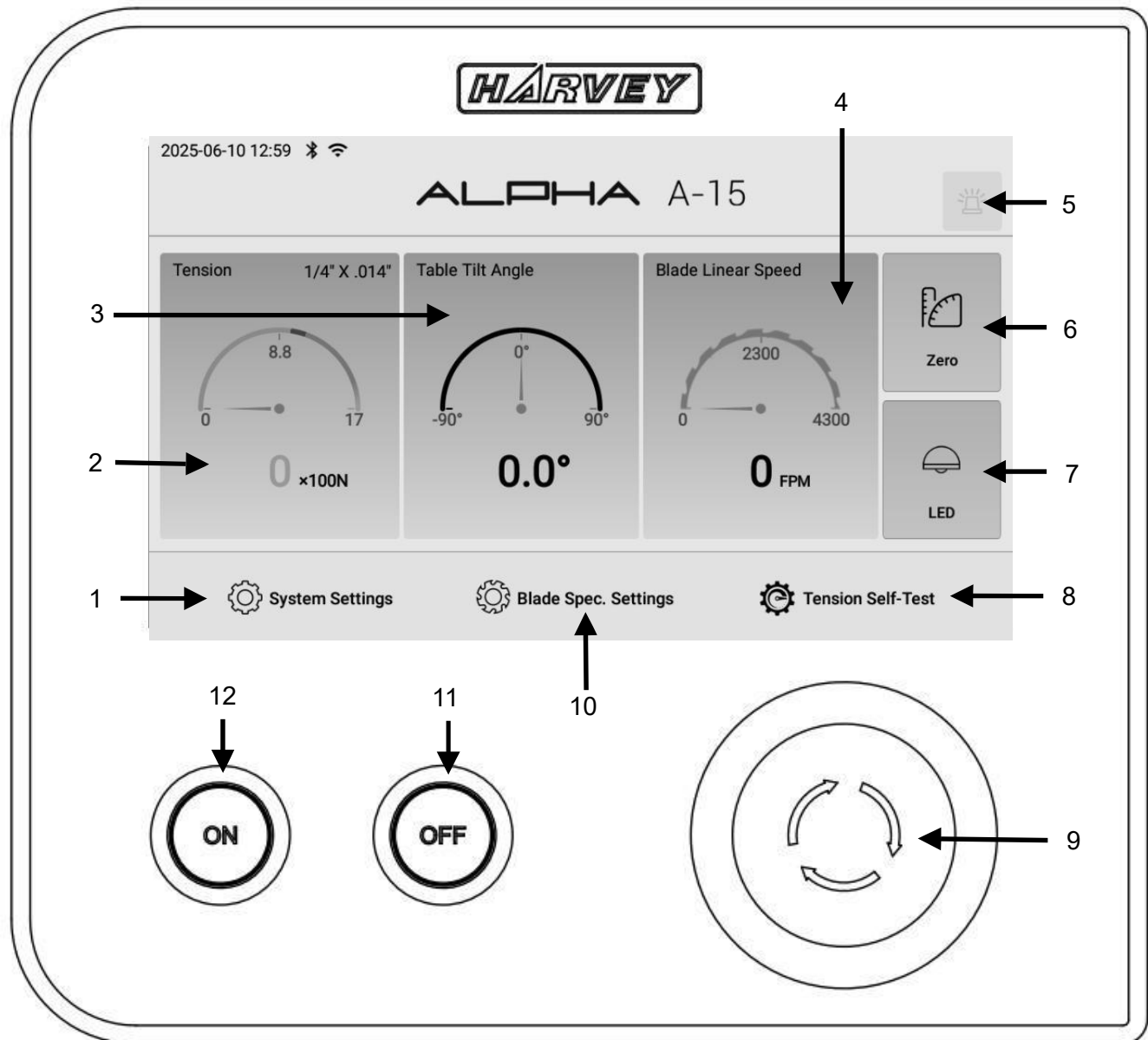
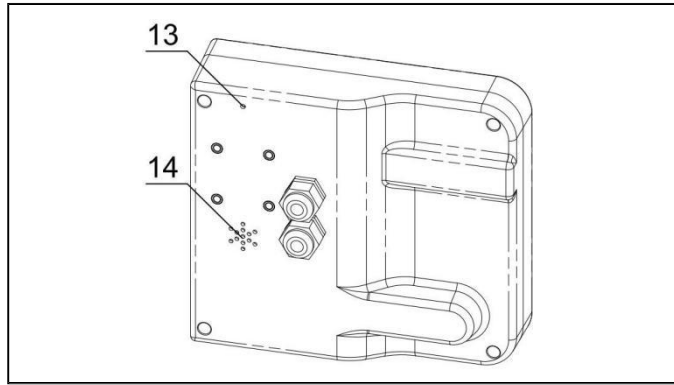


Fig. 7-3a

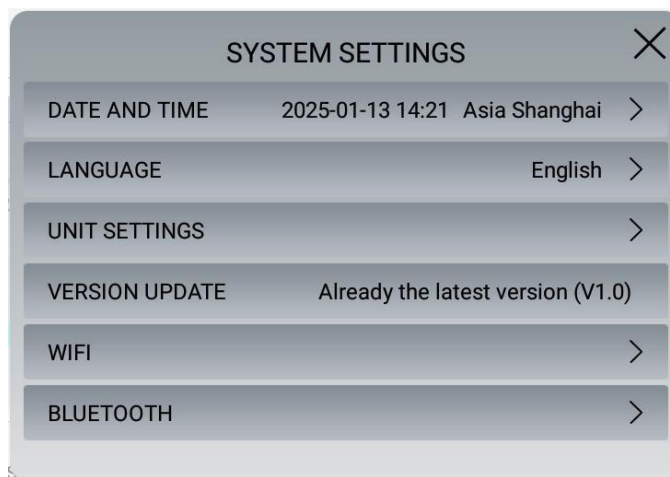


**Fig. 7-3b**

### 7.3.1 System Settings

As shown in Fig. 7-3a, tap the “System Settings” button to enter the settings page shown in Fig. 7-4.

This page allows configuration of date & time, language, unit system, system updates, and connections to Wi-Fi and Bluetooth.



**Fig. 7-4**



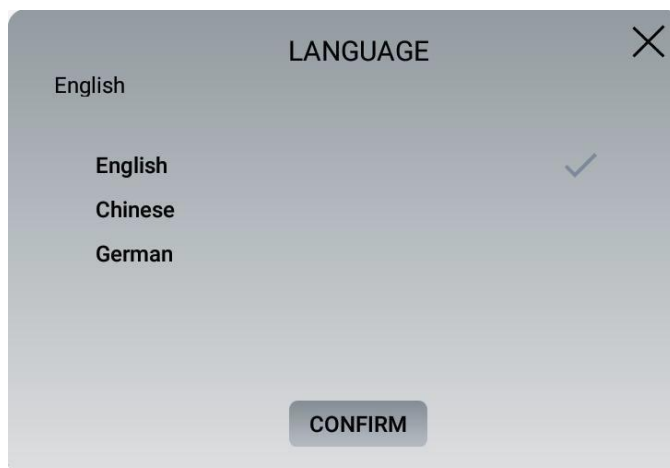
**Fig. 7-5**

- **Date and Time**

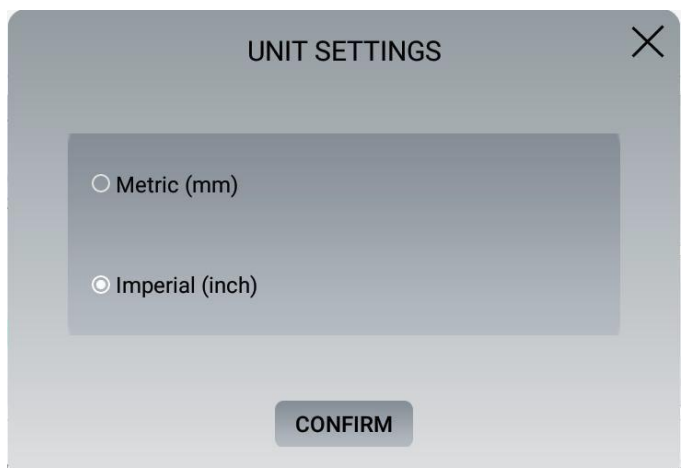
As shown in Fig. 7-4, tap “DATE AND TIME” in the settings menu to set the time zone and adjust the system date and time in the “DATE AND TIME” screen, (see Fig. 7-5).

- **Language**

As shown in Fig. 7-4, tap “LANGUAGE” to enter the “LANGUAGE” screen and switch the system language between Chinese, English, and German, (see Fig. 7-6).



**Fig. 7-6**



**Fig. 7-7**

● **Unit System**

As shown in Fig. 7-4, tap “UNIT SETTINGS” to enter the “UNIT SETTINGS” screen to switch between metric (mm) and imperial (inch) display units, (see Fig. 7-7).

● **Wifi**

As shown in Fig. 7-4, tap “Wi-Fi” to enter the “Wi-Fi” menu and connect the machine to a wireless network, (see Fig. 7-8).

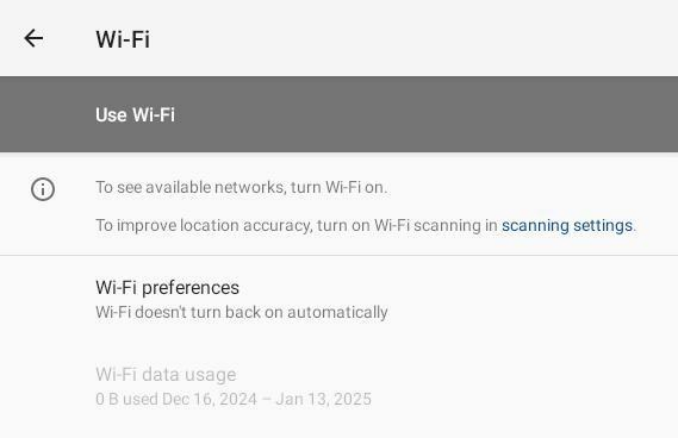


Fig. 7-8

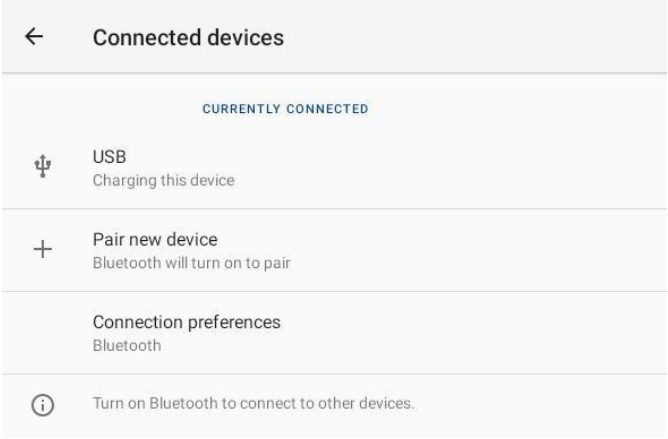


Fig. 7-9

● **Bluetooth**

As shown in Fig. 7-4, tap “Bluetooth” to enter the “Connected Devices” menu Fig. 7-9 to connect compatible Bluetooth devices.

● **Software Update**

As shown in Fig. 7-4, tap “Version Update” in the settings menu to check for and install software updates.

- 1.Connect to Wi-Fi (required).
- 2.Tap the "SYSTEM SETTINGS" button (see Fig. 7-3a).
- 3.As shown in Fig. 7-10, tap "VERSION UPDATE", and wait for the installation to complete.

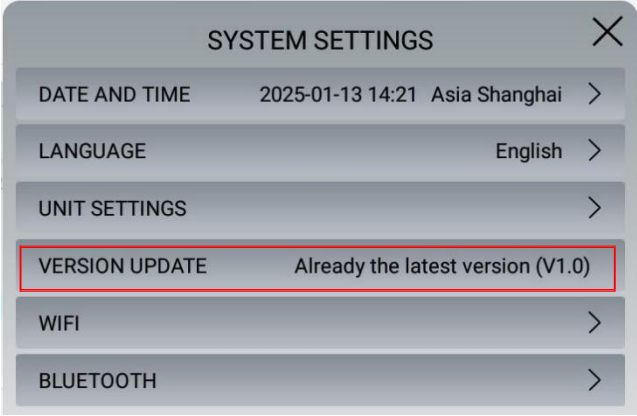


Fig. 7-10

**7.3.2 Blade Tension Display Area**

This area displays the blade specification, recommended tension, and actual tension in real time. Before operating the machine, ensure that the selected blade type is correct, and the tension value is within the recommended range.

**Note:** The values 8.8 and 17 in this area are fixed and serve as position indicators; they are not related to actual blade tension. After installing the blade and inputting the blade specification settings, a tension range will be displayed with the “GREEN” range indicating proper tension and “RED” for under or over tension ranges. Adjust the blade tension higher or lower as needed until it falls within the “GREEN” range.

### 7.3.3 Table Tilt Angle Display Area

This area shows the current tilt angle of the table relative to the machine's reference plane, in real time.

### 7.3.4 Blade Speed Display Area

This area displays the current linear speed setting of the blade based on the position of the belt on the motor pulley. If the value shown is "0", it may indicate a sensor malfunction or an improperly installed belt.

### 7.3.5 Machine Alarm Indicator

When the machine meets the startup conditions, this icon is invisible. If the machine fails to meet the startup conditions, the icon will flash. Tap the icon to view all conditions preventing the machine from starting.

## 7.4 Table Tilt Angle Adjustment

As shown in Fig. 7-11, loosen the table locking handle, then turn the table tilt handwheel until the table reaches the desired angle. Tighten the locking handle to secure the table. The current table angle can be viewed on the main display screen.

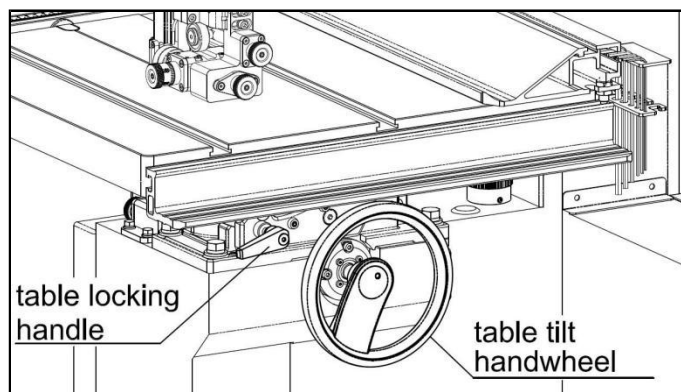


Fig. 7-11

**Note:** To tilt the table within the  $-5^{\circ}$  to  $0^{\circ}$  range, first rotate the limiting block (see Fig. 7-13), to the  $-5^{\circ}$  limit position. To tilt within the  $0^{\circ}$  to  $45^{\circ}$  range, rotate the limiting block to the  $0^{\circ}$  limit position first.

## 7.5 Table Tilt Angle Display Calibration

1. Tap the "ZERO" button (see Fig. 7-3a) to enter the table angle calibration page (see Fig. 7-12).
2. Rotate the table tilt handwheel to set the table to the  $0^{\circ}$  position.
3. Check the confirmation box in the interface shown in Fig. 7-12, then tap "Confirm" to save the calibration.

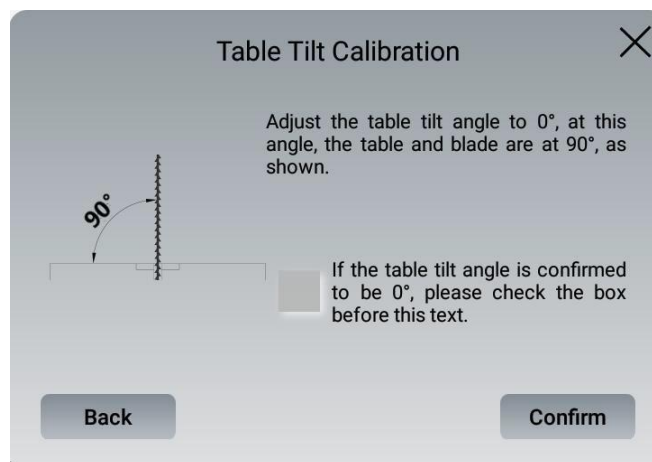


Fig. 7-12

## 7.6 Calibrating Table Tilt Angle Stops

The table tilt angle stops are factory-calibrated before shipment. If recalibration is required, follow the procedures below:

### 7.6.1 0° Stop Calibration

1. As shown in Fig. 7-13, rotate the table stop block until the 0° stop bolt is positioned beneath the table skirt.

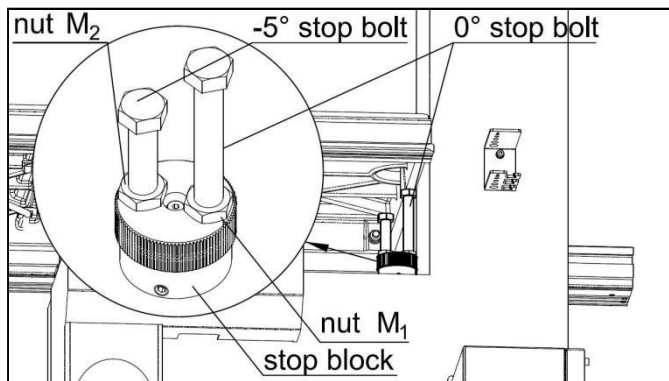


Fig. 7-13

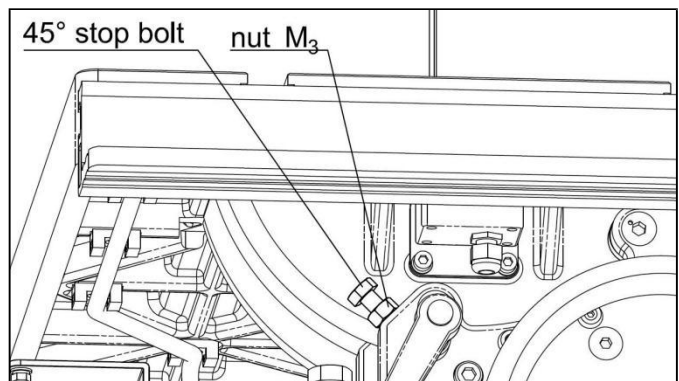


Fig. 7-14

2. Loosen nut M1, and rotate the 0° stop bolt clockwise until it no longer obstructs the table from returning to the 0° position.
3. Loosen the table locking handle, and rotate the table tilt handwheel until the angle between the table surface and the blade side is exactly 90° (this indicates the table is at 0°). Then re-tighten the table locking handle.
4. Rotate the 0° stop bolt counterclockwise until it makes contact with the bottom of the table skirt, then tighten nut M1.

### 7.6.2 -5° Stop Calibration

1. As shown in Fig. 7-13, rotate the stop block until the -5° stop bolt is positioned beneath the table skirt (the same position previously occupied by the 0° bolt).
2. Loosen nut M2, and rotate the -5° stop bolt clockwise until it no longer obstructs the table from tilting to -5°.
3. Loosen the table locking handle, and rotate the table tilt handwheel until the angle between the table surface and the blade side near the column is 95° (this indicates the table is at -5°). Then re-tighten the table locking handle.
4. Rotate the -5° stop bolt counterclockwise until it makes contact with the bottom of the table skirt, then tighten nut M2.

### 7.6.3 45° Stop Calibration

1. As shown in Fig. 7-14, loosen nut M3.
2. Rotate the 45° stop bolt clockwise until it no longer obstructs the table from tilting to 45°.
3. Loosen the table locking handle, and rotate the table tilt handwheel until the angle between the table surface and the blade side near the column is 45°. Then re-tighten the table locking handle.
4. Rotate the 45° stop bolt counterclockwise until it contacts the bottom of the table, then tighten nut M3.

### 7.6.4 LED Light Switch

Tap the “LED” button on the display to turn the work light on or off.

### 7.6.5 TENSION SELF-TEST

As shown in Fig. 7-3a, tap the "TENSION SELF-TEST" button to enter the tension calibration page (see Fig. 7-15). On this page, you can verify whether the tension sensor is functioning properly and displaying the correct tension value.

**Note:** This operation should be performed only when the blade is completely released.

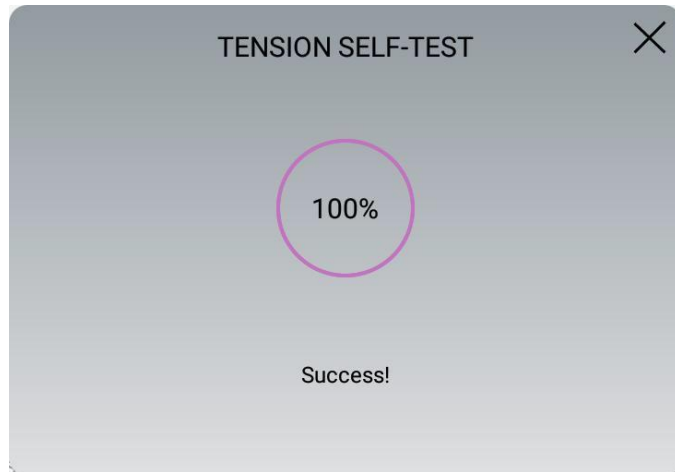


Fig. 7-15

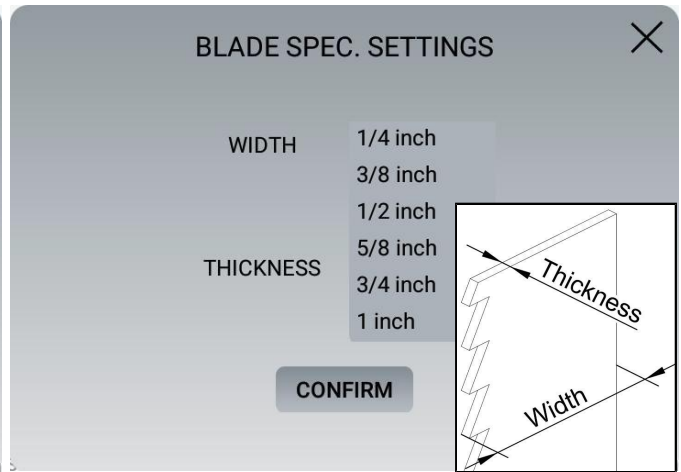


Fig. 7-16

### 7.6.6 Blade Specification Settings

As shown in Fig. 7-3a, tap the "BLADE SPEC. SETTINGS" button on the display to enter the blade specification setting page (see Fig. 7-16). On this page, you can select the preset blade width and thickness. The system will then recommend a suitable tension range based on the selected blade specifications, which will be displayed in the Blade Tension Display Area.

**Note:** The blade width and thickness are standard presets for user selection and cannot be entered manually. If the exact size is not available among the presets, choose the value that most closely matches the actual dimensions.

### 7.6.7 Start

After connecting the power supply, press the “ON” button (see Fig. 7-3a) to start the machine.

To ensure operator safety, the machine will only start when the following conditions are met (any unmet conditions will be shown on the screen as alarm messages):

- The upper and lower cabinet doors must be fully closed and locked.
- Both emergency stop buttons must be released.
- The motor brake must not be in the released state.

**Note:** The screen serves only as a supplementary system! Regardless of whether the screen is functioning normally, the ON/OFF buttons will still operate once the machine is powered on. Always proceed with caution when starting the machine.

### 7.6.8 Stop

Press the “OFF” button on the display (see Fig. 7-3a) to stop the machine.

### 7.6.9 Emergency Stop

Press the Emergency Stop Button (see Fig. 7-3a) to immediately halt machine operation. The machine cannot be restarted until the emergency stop has been released.

(An additional emergency stop button is located on the side of the table (see Fig. 4-1.)

## WARNING

In the event of abnormal operation or an emergency, at least one emergency stop button should be pressed immediately!

### 7.6.10 Voice Control

This machine features voice interaction capability. To use voice control, begin with the wake word: "Hi Harvey" or "Hey Harvey".

When the language is set to English, the following voice commands are supported: "Turn

on the light" → Turns the LED work light on.

"Turn off the light" → Turns the LED work

light off. "Enable network" → Enables the Wi-Fi

connection. "Disable network " → Disables the

Wi-Fi connection. "Enable Bluetooth" →

Enables Bluetooth.

"Disable Bluetooth" → Disables Bluetooth.

"Switch to Chinese" → Switches system language to Chinese.

"Switch to German" → Switches system language to German.

## 8. Blade Installation

1. As shown in Fig. 8-1, pull the tensioning lever to the “FULL RELEASE” position, and rotate the tensioning handwheel.

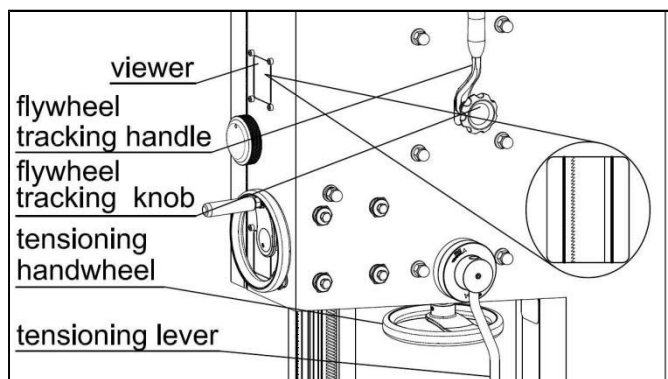


Fig. 8-1

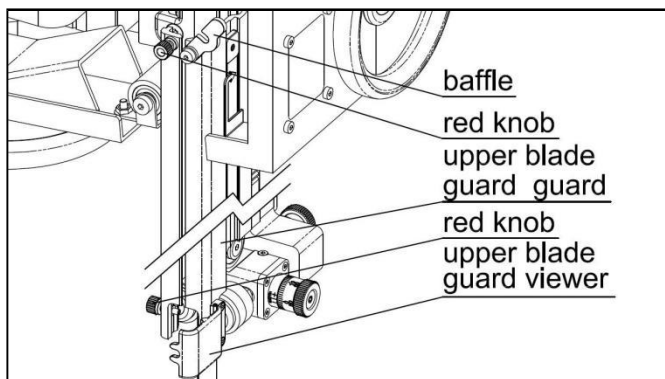


Fig. 8-2

### 2. TENSION SELF-TEST (Optional Calibration)

- 2.1. Tap the "TENSION SELF-TEST" button to enter the tension calibration page (see Fig. 7-3a, 8-3).
- 2.2. On this page, you can verify whether the tension sensor is functioning properly and displaying the correct tension value prior to blade installation for convenience.

**Note:** If a blade has already been installed, this operation should be performed only when the blade is completely released.

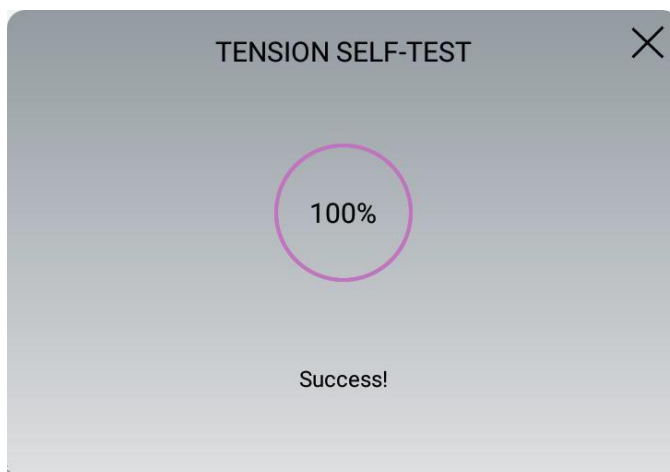


Fig 8-3

1. After confirming that the Tension Self Test is successfully calibrated, turn the brake release knob to the "Activate the Brake" position and engage both Emergency Stop buttons for added safety when installing the blade.
2. Open the upper and lower cabinet doors and the lower blade guard. Loosen the two red knobs on the upper blade guard, and open the top baffle and the upper blade guard viewer (see Fig. 8-2).
3. Install a new blade onto the upper and lower flywheels with the blade centered on the flywheel tires.
4. If replacing a blade, first remove the installed blade before installing the new blade.
5. Tension the blade (refer to section 8.1 Blade Tensioning).

### 8.1 Blade Tensioning

1. Tap the “BLADE SPEC. SETTINGS” button on the display screen (see Fig. 7-3a) to enter the blade preset interface (Fig. 8-4).
2. Select the specifications of the installed blade and tap “Confirm” to return to the main interface.
3. Pull the tensioning lever to the “FULL TENSION” position (see Fig. 8-1).
4. Rotate the tensioning handwheel until the blade tension value shown on the main display falls within the recommended range.

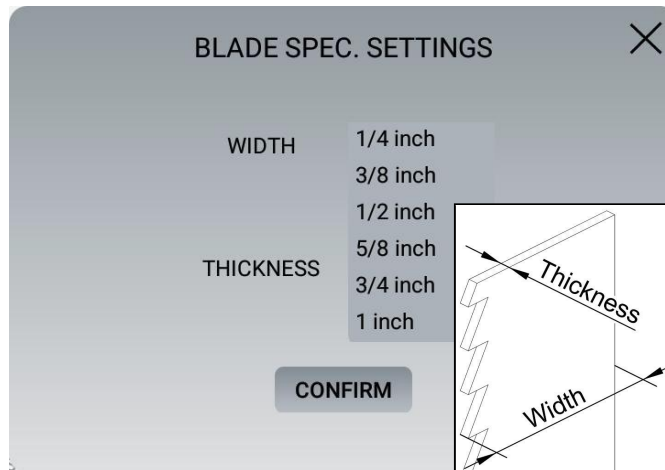


Fig. 8-4

## 8.2 Blade Tracking

1. Turn the Brake Release knob to the released position to allow manual rotation of the flywheel.
2. Turn the flywheel tracking handle counterclockwise, then rotate the flywheel tracking knob to adjust the blade's front-to-back position (see Fig. 8-1).
  - Turn the flywheel tracking knob counterclockwise and rotate the flywheel to move the blade backward.
  - Turn the knob clockwise and rotate the flywheel to move the blade forward.
3. Once the blade appears to be centered on the flywheel, turn the flywheel tracking handle clockwise to lock it. For blades  $\frac{1}{8}$ "- $\frac{1}{2}$ " aligning the deepest part of the blade gullet centered on the wheel may provide a better contact surface. For blades  $\frac{3}{4}$ "-1", center the blade tooth to spine on the tire.
4. Close the guard viewer and baffle, and tighten the two red knobs. Close the lower blade guard and the cabinet doors.
5. Adjust the upper and lower blade guides to the correct positions (see Section 8.3).

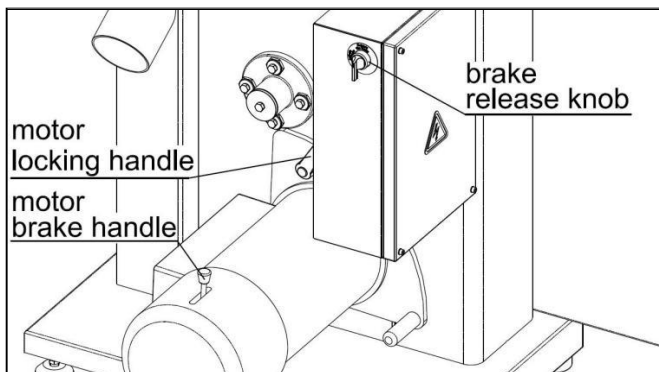


Fig. 8-5

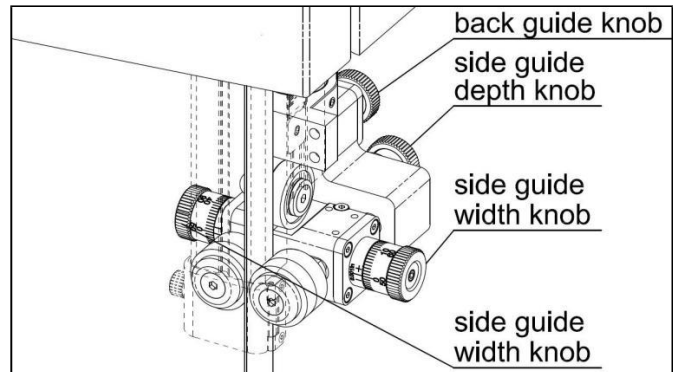
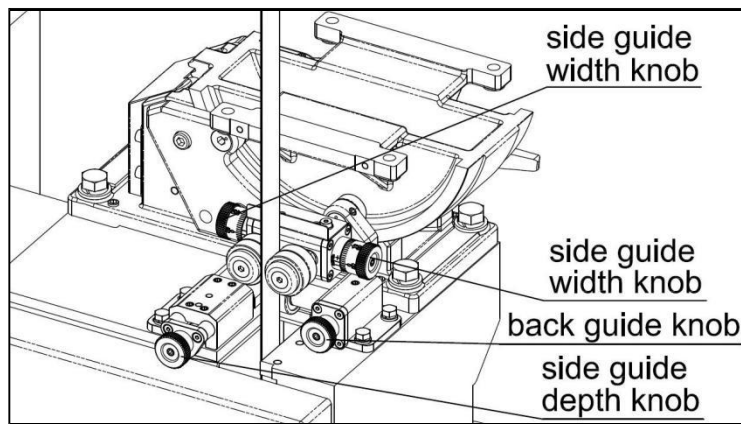


Fig. 8-6

**Note:** If the brake release knob is malfunctioning or damaged, the motor brake handle at the end of the motor can be used instead (see Fig. 8-5). Pull it as far back toward the rear of the motor as possible and maintain it in that position to allow manual rotation of the flywheel.

## 8.3 Blade Guide Adjustment

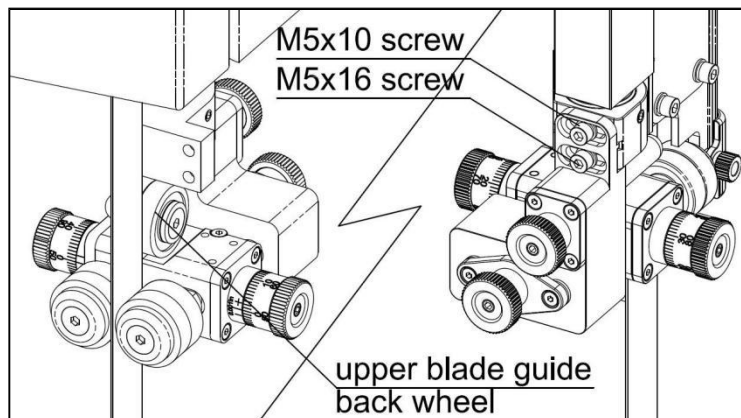
1. As shown in Fig. 8-6, rotate the side guide depth knob so that the side guide rollers are offset from the blade teeth with the guides behind the gullets of the blade.
2. Rotate the side guide width knob counterclockwise until the side guide rollers just touch the blade, then rotate one tick clockwise (approximately 0.001" or 0.02 mm) so that the side guide rollers are not contacting the blade.
3. Rotate the back guide knob counterclockwise until the back guide roller just touches the blade and then rotate clockwise until there is a gap of approximately  $\frac{1}{32}$ " or 0.79mm so it doesn't spin at idle and only starts turning when stock is fed.
4. As shown in Fig. 8-7, adjust the lower blade guide in the same manner.



**Fig. 8-7**

#### **8.4 Upper Blade Guide Position Calibration**

- 1.** Install the blade correctly and tension it.
- 2.** As shown in Fig. 8-8, loosen the two M5 screws located at the rear of the upper blade guide.
- 3.** Slide the upper blade guide assembly laterally until the blade is centered on the upper blade guide back wheel.
- 4.** Tighten the two M5 screws to secure the position.



**Fig. 8-8**

## 8.5 Lower Blade Guide Position Calibration

### 8.5.1 Lower Blade Guide Side Wheel Calibration

1. Install the blade correctly and tension it.
2. As shown in Fig. 8-9, rotate both side wheel adjustment knobs (located on either side of the lower blade guide) clockwise until they stop.
3. Loosen the two M6 bolts on the side wheel assembly, then move the lower blade guide side wheel assembly until both left and right guide wheels are symmetrically aligned with the blade.
4. Tighten the two M6 bolts.

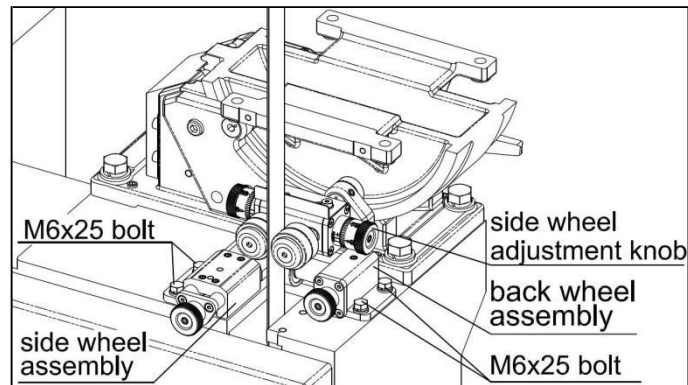


Fig. 8-9

### 8.5.2 Lower Blade Guide Back Wheel Calibration

1. As shown in Fig. 8-9, loosen the two M6 bolts on the back wheel assembly.
2. Adjust the back wheel assembly so the blade is centered on the back wheel.
3. Tighten the two M6 bolts.

## 8.6 Calibrating Blade-to-Table T-Slot Parallelism

The alignment between the table's T-slot and the blade is properly set at the factory. To verify the Blade-To-Table T-slot parallelism perform the following steps:

1. Disconnect the band saw from the power source.
2. Place a long straightedge ruler flush against the blade, making sure it contacts both the front and back of the blade.
3. Use another ruler to carefully measure the distance from the miter slot to the straight edge. Take measurements at both the front and back of the table – if the measurement at both the front and the back of the table are the same the blade is parallel with the T-slot.

If realignment is needed, follow the steps below:

1. As shown in Figs. 8-10 and 8-11, loosen the four M12 bolts securing the table assembly.
2. Rotate the table horizontally until the T-slot is parallel to the blade.
3. Re-tighten the four M12 bolts to secure the table in position.

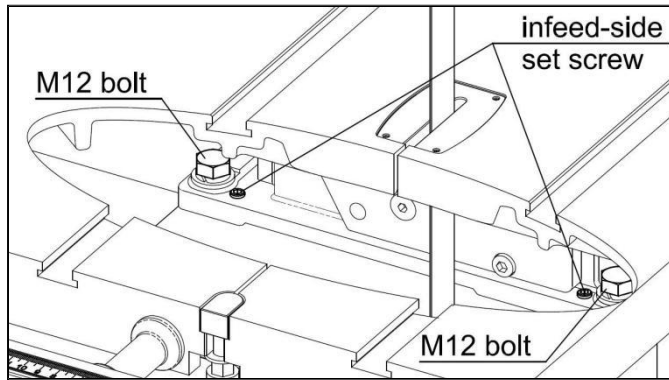
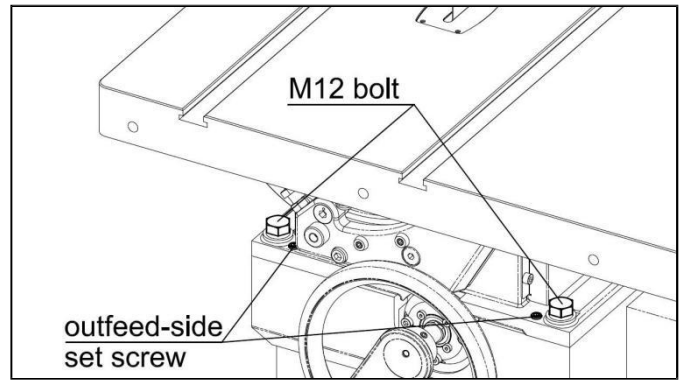


Fig. 8-10



8-11

## 8.7 Calibrating Blade-to-Table Squareness

The perpendicularity between the blade and the table surface is factory-calibrated. To verify blade-to-table squareness there are multiple methods that can be used.

**Option 1:** Use a calibrated square positioned against the table and the blade to check both sides and the back or spine of the blade in relation to the table to verify that all three form a 90-degree angle with the table.

**Option 2:** Use a piece of wood that is no wider than the table and jointed square on the bottom edge.

1. Lower the upper guides to approximately 1/4" above the workpiece and then make a shallow 1/16" deep groove cut into the face of the workpiece.
2. Remove the workpiece and rotate it 180-degrees maintaining the same jointed side down on the table and position the cut groove to align with the spine of the blade.

If the blade sits into the groove cut (Option 2: Step 1) and is vertically even, then the blade is confirmed to be square to the table.

**If recalibration is necessary, proceed as follows:**

1. As shown in Figs. 8-10 and 8-11, loosen the four M12 bolts.
2. Refer to Fig. 8-12, if the angle between the back of the blade and the table surface is less than 90°, rotate the two infeed-side set screws (M8) clockwise by the same number of turns (or rotate the outfeed-side screws counterclockwise).
3. If the angle is greater than 90°, rotate the two outfeed-side set screws (M8) clockwise by the same number of turns (or rotate the infeed-side screws counterclockwise).
4. Continue adjustment until the angle between the back of the blade and the table equals exactly 90°.
5. Re-tighten the four M12 bolts to secure the table.

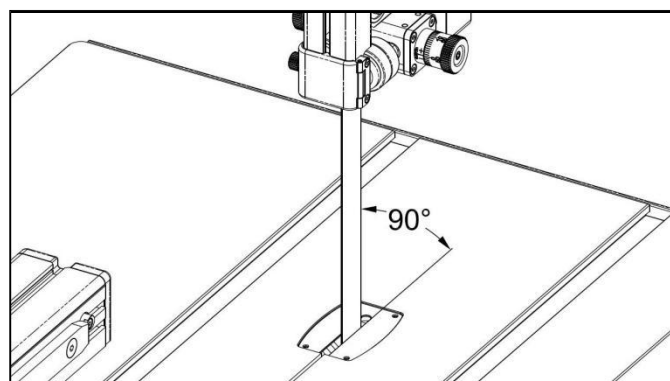


Fig. 8-12

### 8.7.1 Attaching the Blade Guide Scale

This product includes a set of metric and imperial blade guide scale rulers, with scales arranged top to bottom. Users may apply the ruler to the mounting base according to their preference.

1. As shown in Fig. 8-13, loosen the set screw on the upper scale stop block, then slide both the stop block and the scale base upward out of the T-slot of the upper blade guard. Align the height scale with the base, ensuring it is flush and centered in width before applying it.
2. Reinstall the scale base and the scale stop block.
3. Move the upper blade guard assembly until the viewer lightly touches the table surface. Loosen the set screw on the lower scale stop block, adjust the scale base so that the arrow points to the "0" mark, and then tighten the set screws on both scale stop blocks.

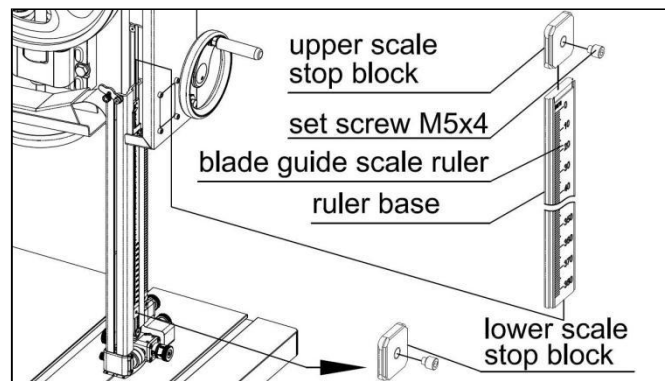


Fig. 8-13

**Note:** The ruler must be applied smoothly and firmly. Edges should be flat with no lifting to avoid wear or obstruction in the viewing area.

### 8.7.2 Blade Guide Scale Adjustment

As shown in Fig. 8-14, the side of the upper blade guard is equipped with a height scale ruler, with limit blocks on both ends.

This ruler indicates the distance from the bottom of the blade guide to the intersection point of the blade and table surface (i.e., the vertical distance from the blade guide base to the table when the table is perpendicular to the blade).

Before use, the scale must be calibrated as follows:

1. Tilt the table to the 0° position.
2. Rotate the blade guide elevation handwheel until the lower edge of the upper guard viewer just touches the table surface.
3. Loosen the screws on the upper and lower limit blocks, align the scale's arrow pointer to the "0" mark, then tighten the set screws on the limit blocks.

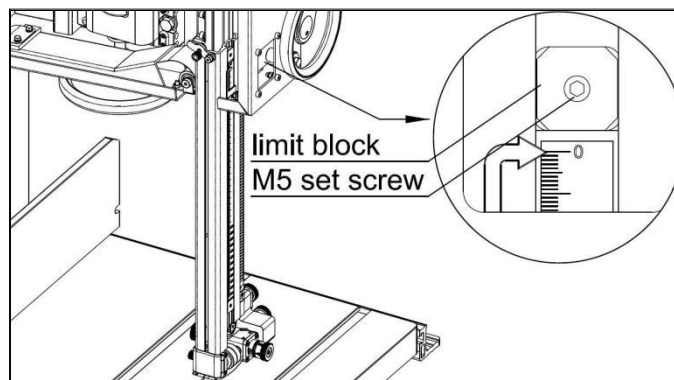


Fig. 8-14

## 8.8 Attaching the Dust Cover

Unpack the Dust Cover M and the corresponding screws from the package. Install the cover on the top of the machine as shown in Fig. 8-15, and securely tighten the four screws.

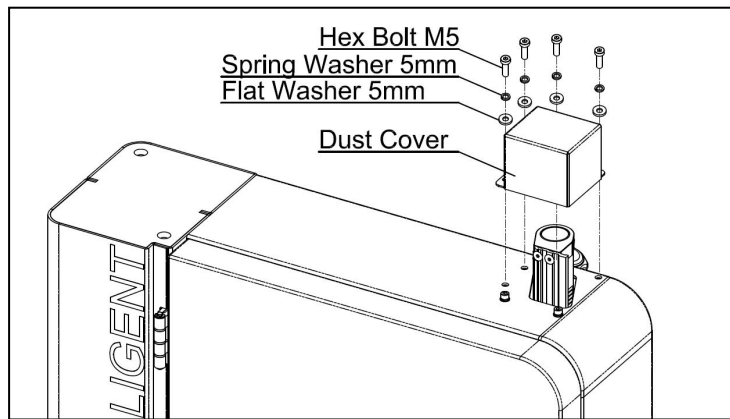


Fig. 8-15

## 8.9 Attaching the Handle

Unpack the Handle N from the package. Install the handle onto the handwheel in the direction shown in Fig. 8-16, and tighten it firmly using an open-end wrench.

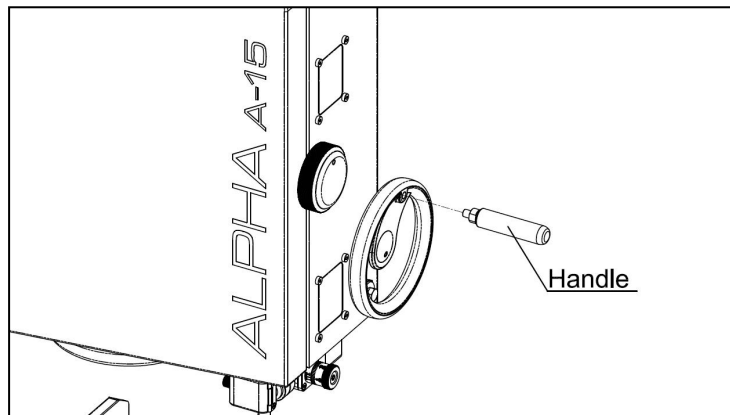


Fig. 8-16

## 8.10 Attaching the Tool Holder

Unpack the Tool Rack O and the corresponding screws from the package. Install the tool rack on the rear side of the machine column as shown in Fig. 8-17, and securely tighten the two screws.

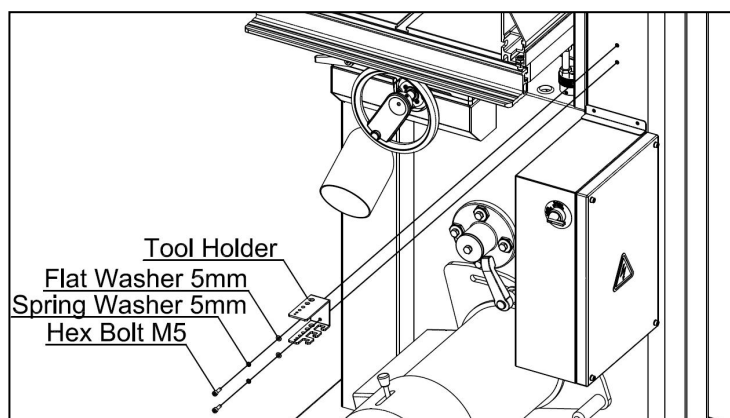


Fig.8-17

## 9. Installing the Guide Rails

### 9.1 Front Guide Rail Installation Bolt Orientation (Important):

Each eccentric bolt has a threaded shaft that is offset from the center of the bolt head—this offset creates a cam-like effect when rotated. To ensure proper alignment and locking force, orient all three eccentric bolts with the offset side of the threaded section (the "cam lobe") facing downward during insertion.

This means when viewed from the side, the threaded shaft should be positioned at the lowest point relative to the bolt head.

The flat sides of the bolt head may help identify the orientation visually—align all heads the same way for consistency.

#### 1. Insert Eccentric Bolts:

Start by sliding three M8 × 110 eccentric bolts into the T-slot of Front Guide Rail Assembly B, as illustrated in Fig. 9-1.

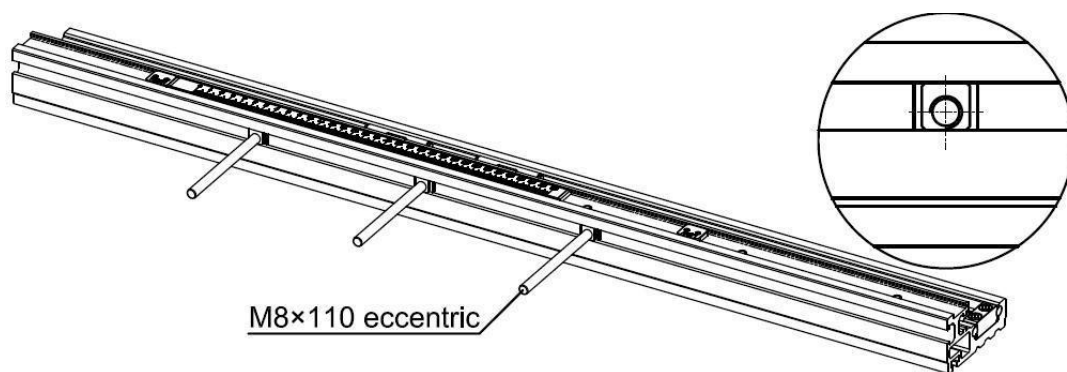


Fig. 9-1

#### 2. Install the Rail Mounting Blocks:

As shown in Fig. 9-2, mount the rail mounting blocks onto the M8×110 eccentric bolts.

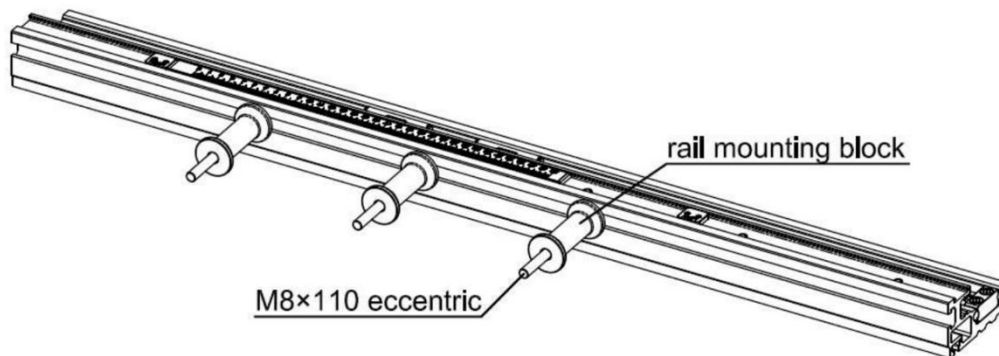


Fig. 9-2

#### 3. Install the Front Guide Rail:

As shown in Fig. 9-3, install the front guide rail assembly and pre-tighten the nuts. Secure the rail only after confirming the following:

- The front guide rail is parallel to the working surface of the table.
- The top surface of the guide rail is 11.5 mm below the top surface of the table. This ensures that the guide rail is positioned below the T-slots on the table.
- The right end of the guide rail is retracted 5–10 mm inward from the right edge of the table.

**IMPORTANT NOTE:** The right end of the guide rail must be recessed approximately 5–10 mm inward from the right edge of the table. This will allow enough clearance on the left side of the rail for the high & low fence feature.

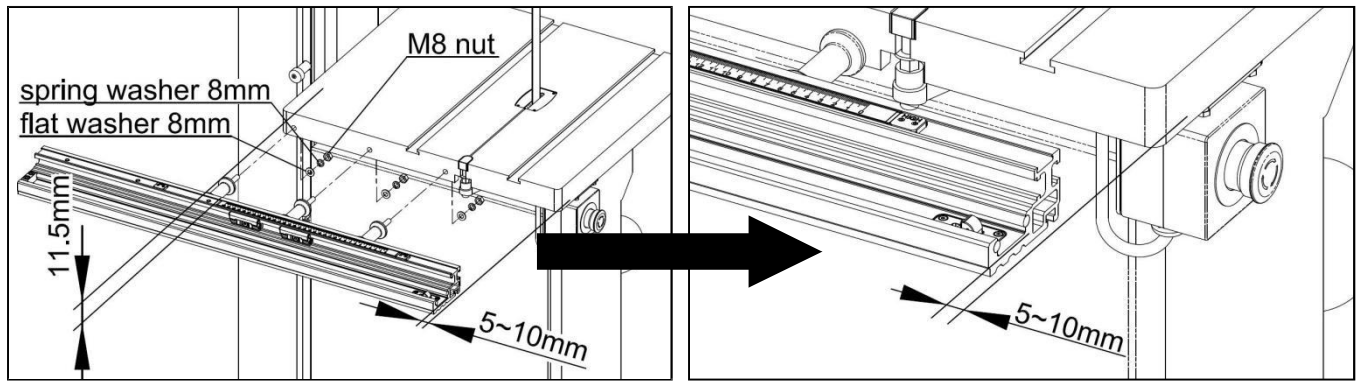


Fig. 9-3

## 9.2 Rear Guide Rail

1. Insert three M8×45 eccentric bolts into the T-slot of the Rear Guide Rail C, as shown in Fig. 9-4.

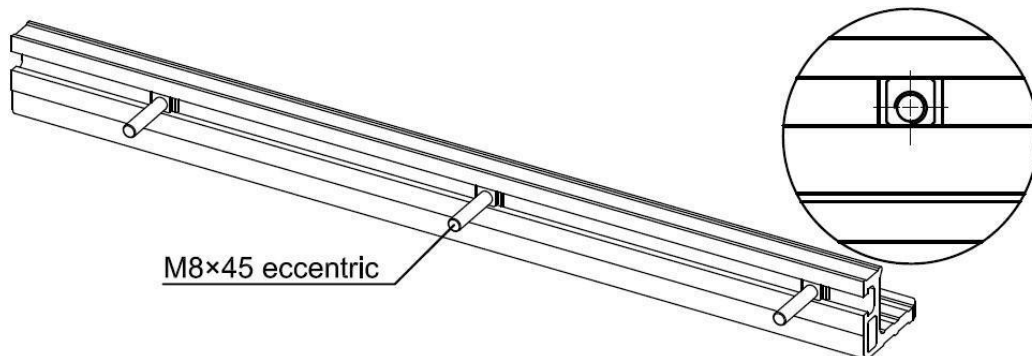


Fig. 9-4

**Note:** Ensure all eccentric bolts are oriented the same way, with the eccentric offset facing downward.

2. As shown in Fig. 9-5, install the rear guide rail and pre-tighten the nuts onto the eccentric bolts.

**Note:** To make installation of the washers and nut onto the middle eccentric bolt more accessible, the tilt handwheel can be removed temporarily. To remove the tilt handwheel:

3. Loosen the two set screws that secure the tilt handwheel to the keyed shaft and pull it off of the shaft.
4. Push the cabling on the underside of the table so it sits above the bolt, then install the spring and flat washers with the bolt only partially pushed through the hole, leaving enough room to install the nut onto the end of the bolt before tightening the nut with an open end wrench.
5. Re-install the tilt handwheel, ensuring the key is seated into the slot on the tilt shaft and aligning the key slot on the handwheel to match before pressing the tilt wheel back onto the shaft and fastening the two set screws.

Fully tighten the nuts onto the eccentric bolts only after ensuring:

- The top surface of the rear guide rail is 11.5 mm below the top surface of the table.
- The end face of the rear guide rail is flush with the side surface of the table.

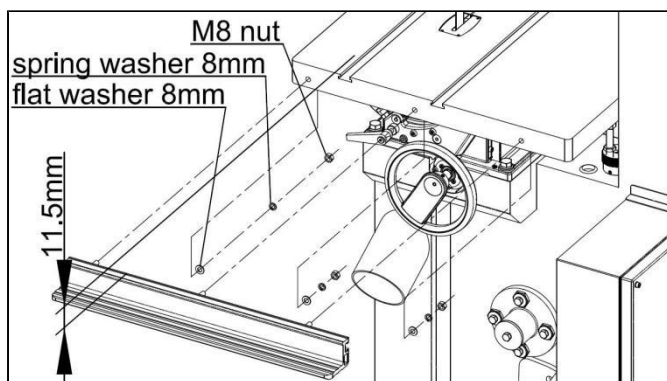


Fig. 9-5

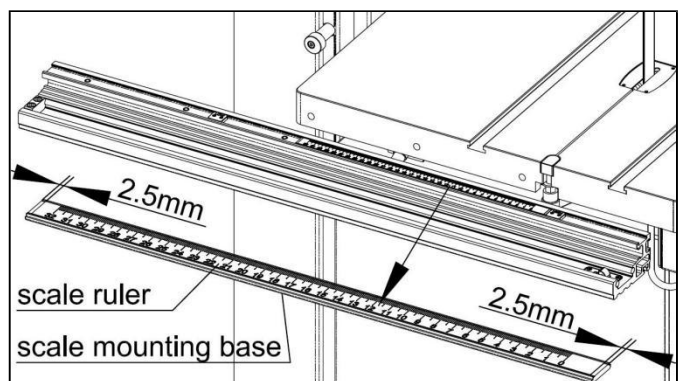


Fig. 9-6

### 9.3 Attaching the Scale Rulers

This product includes a set of metric and imperial scale rulers for the guide rail. The scales are arranged from right to left. Users can attach the rulers to the scale ruler mounting base as needed.

As shown in Fig. 9-6, during installation:

- Align the inner edge of the ruler to be 2.5 mm inward from the inner edge of the mounting base.
- Center the ruler along its width.

**Note: The ruler must be applied smoothly and firmly. Do not allow edges to lift, as this could cause abrasion to the viewer.**

## 10. Installing the Fence Assembly

As shown in Fig. 10-1, slide the Fence Main Assembly D into the front guide rail.

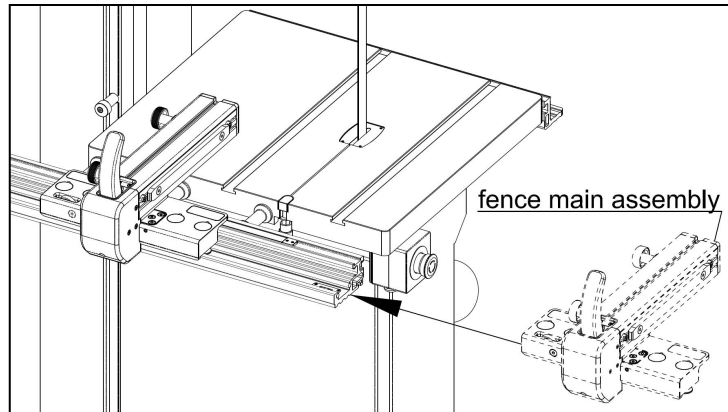


Fig. 10-1

**Important:**

- ① The Fence Main Assembly D must be inserted in a parallel motion to avoid damaging the viewer.
- ② Before installation, press down the safety limit block on the guide rail (see Fig. 10-2). After installation, release the safety block to prevent the fence from sliding off the rail (see Fig. 10-3).

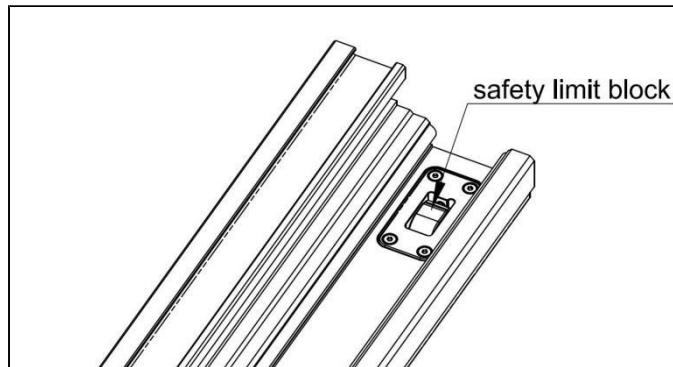


Fig. 10-2

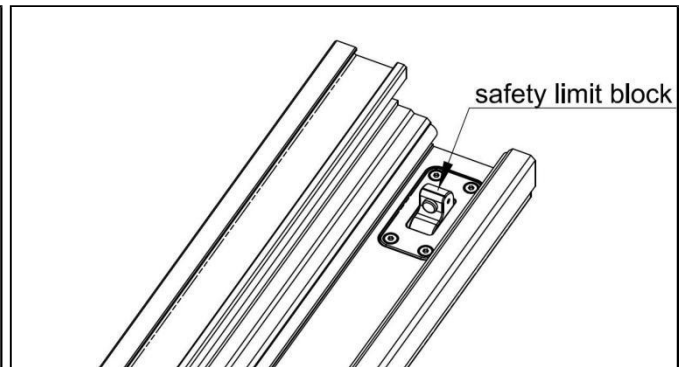


Fig. 10-3

### 10.1 Adjusting the Fit Between the Slide Block and Guide Rail:

The fit between the slide block and guide rail is factory-calibrated. However, if the fence assembly feels difficult to move or wobbly during use, adjust as follows:

1. As shown in Fig. 10-4, remove the magnetic dust cover from the slide block.
2. Loosen the three set screws on the eccentric nut, then use an 8 mm Allen wrench to rotate the eccentric nut until the lower roller contacts the guide rail. Re-tighten the three set screws on the eccentric nut.
3. Repeat the adjustment for all four eccentric nuts. If the fence assembly moves smoothly without play, the adjustment is complete. Reinstall the dust cover.

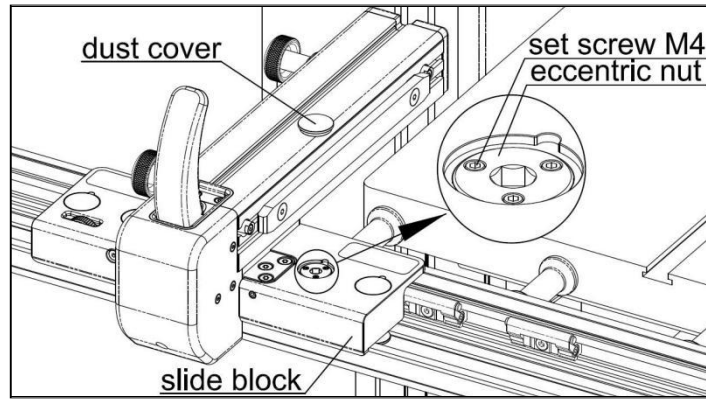


Fig. 10-4

## 10.2 Fence Locking

As shown in Fig. 10-5, press down the locking hand to lock the fence. Pull up the lever to release the fence.

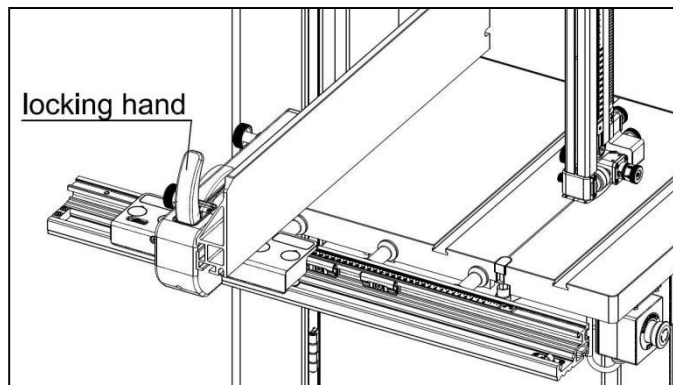


Fig. 10-5

## 10.3 Adjusting the Locking Force

As shown in Fig. 10-6, lift the locking handle and use a 6 mm Allen wrench to adjust the internal screw inside the housing.

1. First, turn the screw counterclockwise until fully loosened.
2. Then, turn it clockwise until significant resistance is felt—stop at that point.
3. Finally, turn the wrench backward (counterclockwise) by approximately 60°. The adjustment is now complete.

**Note: The Locking Force at this position has been tested and optimized. Do not overtighten or leave it too loose during use, as improper adjustment may affect performance.**

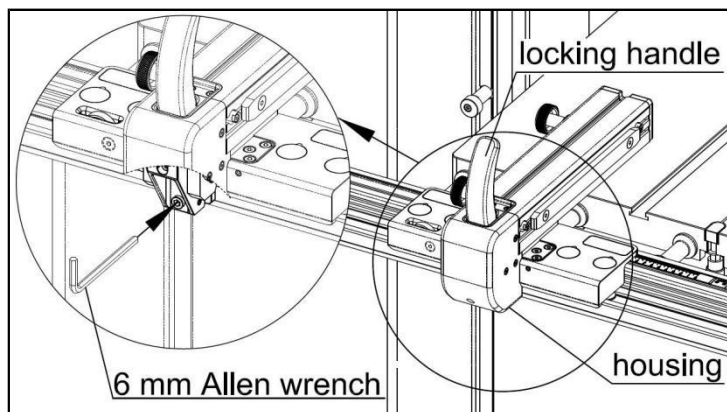


Fig. 10-6

## 10.4 Fence Fine Adjustment

The fence is equipped with a fine adjustment knob that allows for precise positioning. To adjust, press and gently roll the fine adjustment wheel with your fingers to move the fence incrementally.

**Note:** The fine adjustment mechanism has no preload, so the knob must be pressed down firmly while turning. If slipping occurs, the fine adjustment assembly should be replaced promptly.

## 10.5 Adjusting Fence Vertical Positioning

There are two eccentric positioning blocks on the right side of the Fence Main Assembly, which can be adjusted to fine-tune the distance between the fence and the table. Proceed as follows:

- ① As shown in Fig. 10-7, use a 2.5 mm Allen wrench to loosen the screws on the two fence positioning blocks. Adjust the eccentric angle of the blocks as needed, then retighten the screws.
- ② As shown in Fig. 10-8, loosen the fence locking knob, and install Fence E onto the Fence Main Assembly in the indicated direction. Then tighten the locking knob to secure the fence.

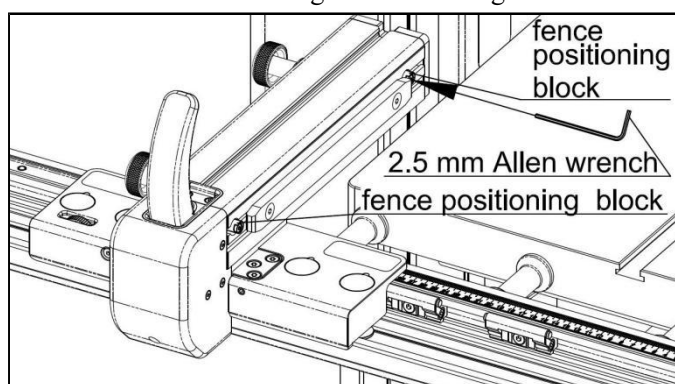


Fig. 10-7

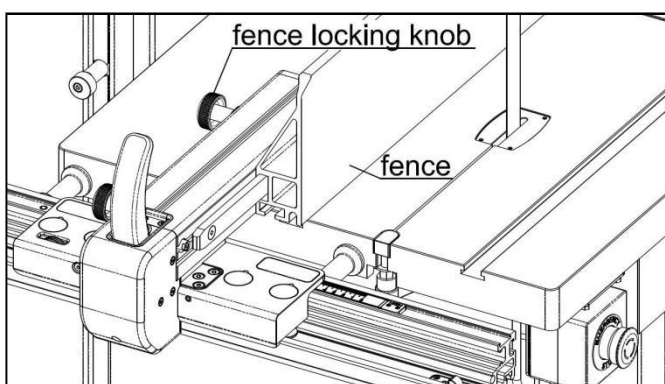


Fig. 10-8

## 10.6 Use of High and Low Fence

As shown in Fig. 10-9, loosen the fence locking knob to remove the fence and switch between high and low fence configurations as needed.

**Note:** When changing the high/low fence orientation, ensure the orientation of the nylon tipped support screw at the end of the fence is also repositioned to support the fence above the table and prevent friction damage to the table or fence.

## 10.7 Use of Quick Positioning Flip Stops

The machine comes with two quick positioning flip stops for rapid fence positioning (see Fig. 10-10). Each positioning stop has two states:

- Pressed down: Stop is engaged and prevents the fence from sliding past.
- Pulled up: Stop is disengaged and allows the fence to slide past.

To adjust the positioning stop: Use a 4 mm hex wrench to loosen the M6 screw on the stop, move it to the desired position, and then tighten the screw.

**Note:** Avoid forceful impact or collision with the positioning stops during use.

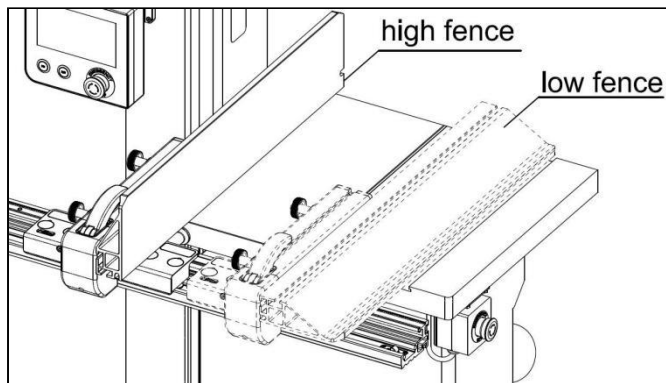


Fig. 10-9

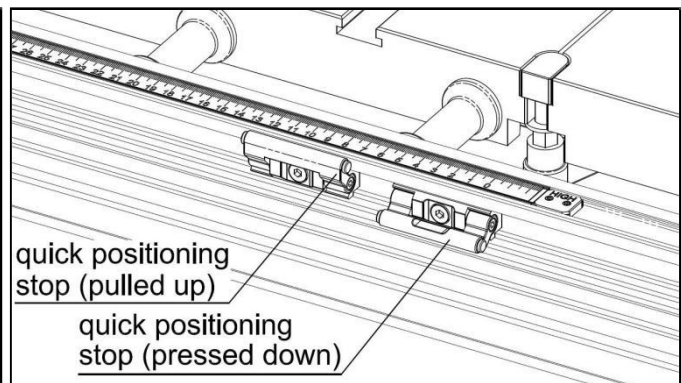


Fig. 10-10

## 10.8 Calibrating Fence-to-Table Squareness and Parallelism

The fence must be calibrated before use, and the squareness must be adjusted before parallelism.

### Check Fence-to-Table Squareness:

- If there is a large squareness error, first verify that the front and rear guide rails are installed correctly (i.e., the top surface of the rail is 11.5 mm below the table surface). If the guide rail position is inaccurate, adjust it first.
- If only a minor deviation in squareness exists, use shims to correct it. Follow these steps:
  1. As shown in Fig. 10-11, lift the locking handle, then use a hex wrench to remove the six M6×20 screws, and loosen the two M6×8 set screws by two turns. Then remove the Fence Main Assembly.
  2. Place copper shims on the left or right side of the groove in the slide block to adjust the squareness. Each set includes four 0.05 mm-thick shims; stackable. One layer adjusts squareness by approx. 0.05 mm (see Fig. 10-12).
  3. Reinstall the Fence Main Assembly, tighten the six M6×20 screws, and check the squareness. If squareness is not within acceptable limits, add or remove shims as needed until correct. Then slightly loosen the six screws, leaving them in a pre-tightened state and continue to adjust the parallelism before tightening.

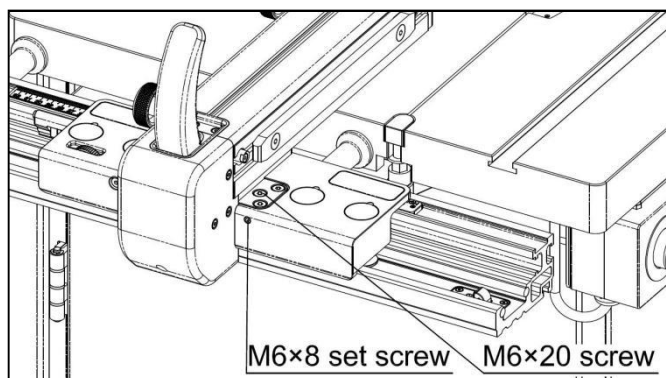


Fig. 10-11

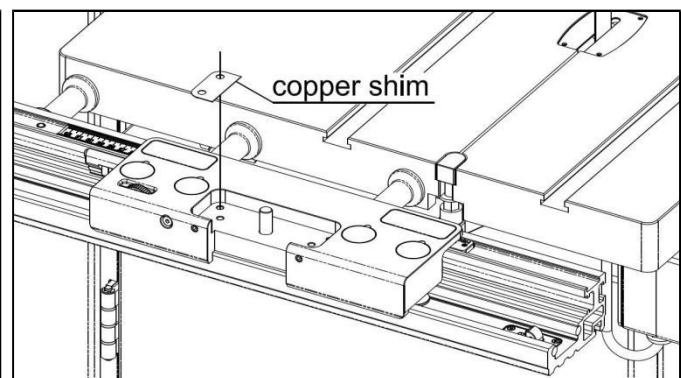


Fig. 10-12

### Adjust Fence-to-Table Parallelism:

Rotate the two M6×8 set screws clockwise to shift the fence and adjust parallelism: Rotating the left screw moves the fence clockwise. Rotating the right screw moves the fence counterclockwise

After parallelism is correctly adjusted: First tighten the six M6×20 screws, then tighten the two M6×8 set screws.

## 10.9 Adjusting Scale Ruler Position

As shown in Fig. 10-13, the scale ruler is equipped with limit blocks at both ends. When using the high fence, move the ruler so it aligns with the limit block marked "HIGH". When using the low fence, move the ruler so it aligns with the block marked "LOW".

Before use, the ruler limit blocks must be calibrated as follows:

1. Use a 2 mm Allen wrench to loosen the two M4 set screws on each limit block. Slide both blocks away from the ruler, then re-tighten the screws.

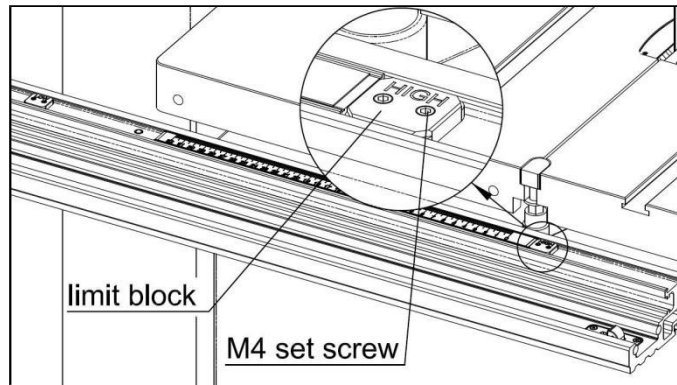


Fig. 10-13

**Note:** Do not move the fence assembly while the M4 set screws are loose, as this may damage the viewer.

**2.** Set the fence to the high fence position, then slide the ruler. When the red alignment mark in the slider viewer matches the actual cutting width, loosen the screws on the "HIGH" limit block, move it to contact the ruler edge, and tighten the screws.

**3.** Switch to the low fence position, then slide the ruler again. When the red alignment mark in the viewer matches the cutting width, loosen the screws on the "LOW" limit block, adjust it against the ruler, and tighten it.

**Note:** When the fence is mounted to the left side of the blade, we recommend using the left-side scale window. In the low position, the fence body may obstruct the view of the right window, making it difficult to read.

## 11. Cutting Speed Adjustment / Belt Position Change

**1.** As shown in Fig. 11-1, loosen the motor locking handle.

**2.** Lift the motor and move the belt to the desired pulley groove. Press down on the motor to tension the belt, and tighten the motor locking handle.

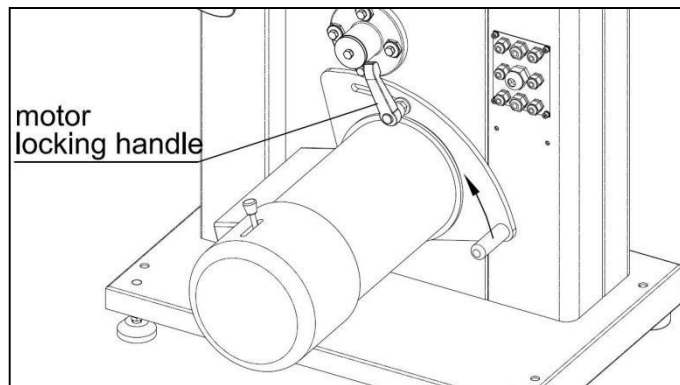


Fig. 11-1

## 12. Belt Replacement

**1.** Remove the blade.

**2.** As shown in Fig. 11-1, loosen the motor locking handle.

**3.** As shown in Fig. 12-1, remove the belt from the small pulley.

**4.** Use a 6 mm hex wrench to remove the M8 bolts from the lower flywheel and take off the flywheel.

**5.** Remove the old belt and place the new belt into the V-groove behind the lower flywheel.

**6.** Reinstall the lower flywheel and tighten the M8 bolts.

**7.** Lift the motor and install the new belt into the appropriate pulley position. Press down the motor to tension the belt and tighten the motor locking handle.

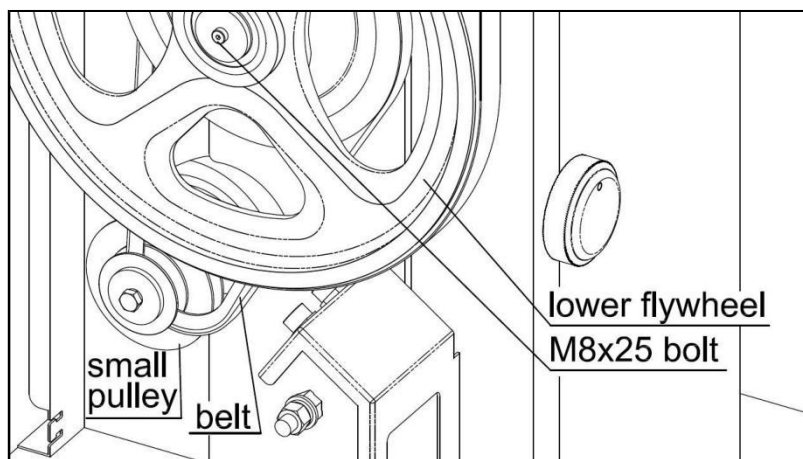


Fig. 12-1

### 13. Installing the Dust Collection System

#### **⚠ NOTICE**

Users must use a dust collection device, and it must be turned on before starting the band saw. The machine includes a dust port located at the rear of the unit, with an outer diameter of 100 mm (see Fig. 22-1).

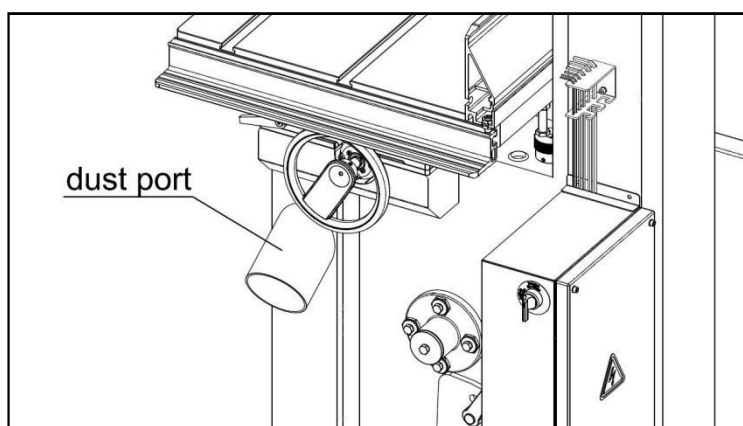


Fig. 22-1

**Installation and calibrations are complete.**

## 14. Maintenance and Care

### 14.1 Daily Inspection:

- Check the saw blade for any signs of rust, damage, or deformation. If any issues are found, remove the rust or replace the blade promptly.
- Ensure the blade is centered on the flywheel. If off-center, adjust it to the middle position, refer to Section 8.2 “Blade Tracking” Step 2 for details.
- Check the effectiveness of the brush. If worn, reposition or replace the brush.
- Inspect the flywheel rim for sawdust or debris. Clean thoroughly before use.
- Verify door Safety Shutoff function. If the machine does not properly alarm or can still start with the door open, replace the limit switch.
- Test the emergency stop buttons. If the machine can start after pressing, or fails to stop when pressed, replace the emergency stop switch.
- Check the brake function. If braking time exceeds 2 seconds after pressing the stop button, repair or replace the brake. **Note: Motor replacement requires rewiring. It is recommended to have this done by after-sales service personnel.**
- Inspect the power cable for corrosion, damage, or exposed wires. If found, repair or replace immediately (see section 4.8 for specifications).
- Check bearings on the locking handles for rust or damage. If rusted or damaged, clean or replace as needed.
- Check the fence movement for smoothness or wobbling. If wobbling occurs, inspect the roller tightness and adjust as described in section 10.1.
- Check locking effectiveness. If locking is abnormal, adjust according to section 10.2 and 10.3.
- Frequently run the “ Tension Self-Test ” (see section 7.6.5) to verify whether the pressure sensor is functioning properly. If the self-test shows failure, replace the sensor.

### 14.2 Cleaning and Maintenance:

- When the machine is not in use, move the tension handle to the “FULL RELEASE” position to prevent blade fatigue.
- Clean the brush regularly.
- Clean the flywheels regularly.
- As shown in Fig. 14-2, regularly clean the trunnion and apply grease to its lubrication surface.
- Frequently blow off sawdust using an air gun and wipe dust from the front rail with a clean cloth. This is essential for smooth fence movement.
- Do not let exposed bearings come into contact with water or sweat. Apply anti-rust spray in a timely manner (see Fig. 14-1).

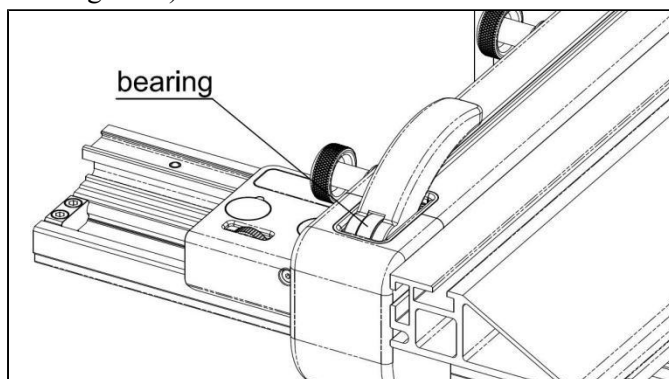


Fig. 14-1

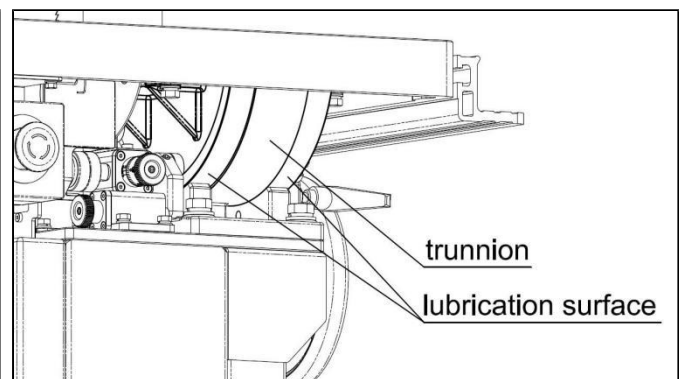


Fig. 14-2

- Replacing the Bearing:

If the bearing is damaged or rusted and no longer functional, please follow the steps below to replace it:

1. Prepare a new bearing model 6003-2Z (GB/T 276).
2. Remove the fence main body assembly according to the procedure described in section 10.8 (1), as shown in Fig. 14-3.
3. As shown in Fig. 14-4, remove the rear cover and the spring.

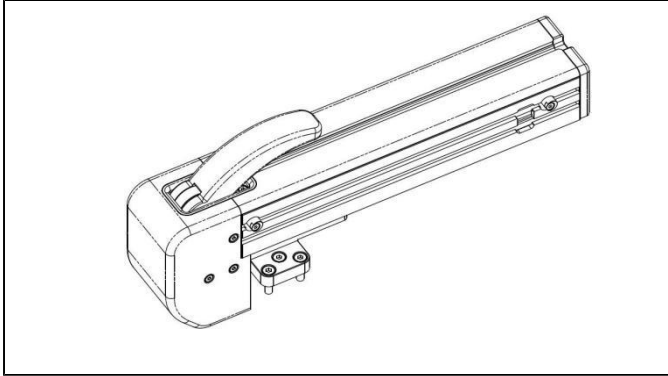


Fig. 14-3

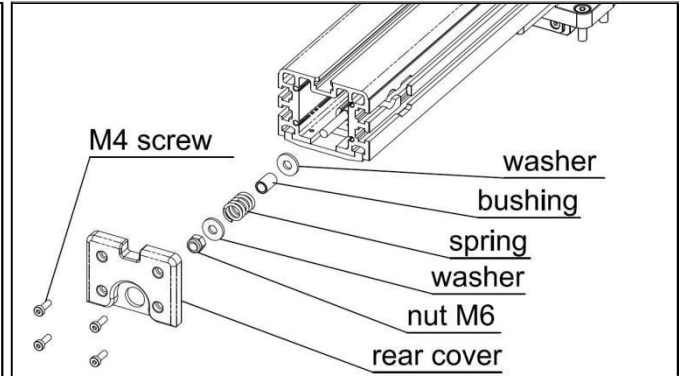


Fig. 14-4

4. As shown in Fig. 14-5, remove the six M4 screws on both sides of the housing and take off the housing cover.
5. As shown in Fig. 14-6, remove the two shoulder screws and take off the front locking block bracket, then pull out the locking swing arm.

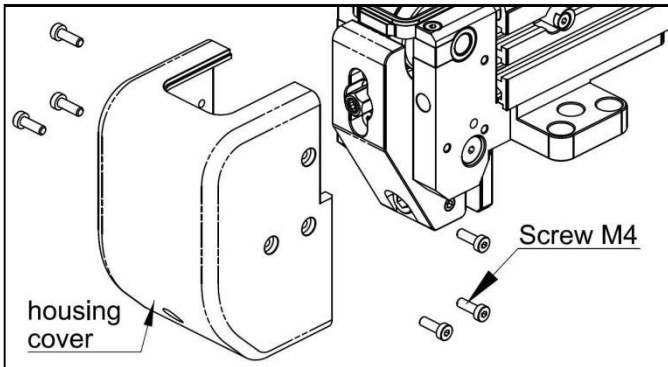


Fig. 14-5

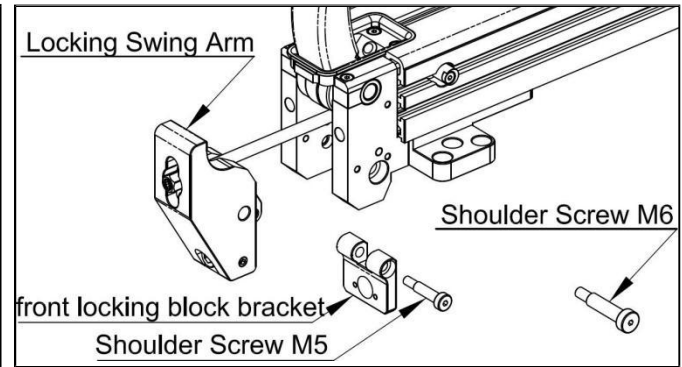


Fig. 14-6

6. As shown in Fig. 14-7, remove two M4 screws, two locking bracket spacers, and two copper bushings.
7. As shown in Fig. 14-8, remove the two screws in front of the locking handle and take out the upper limit block of the handle.

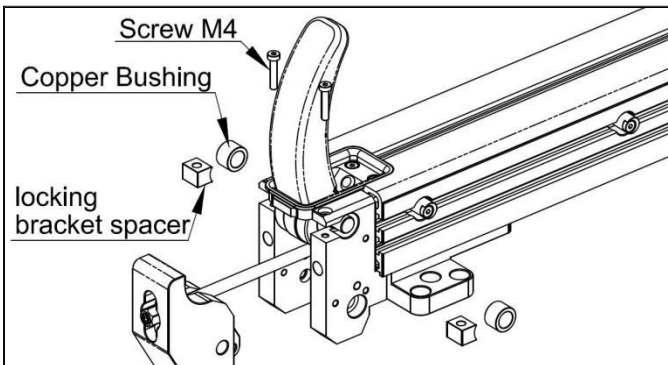


Fig. 14-7

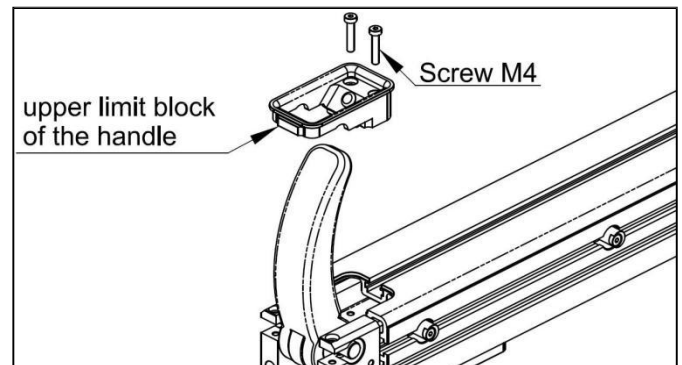
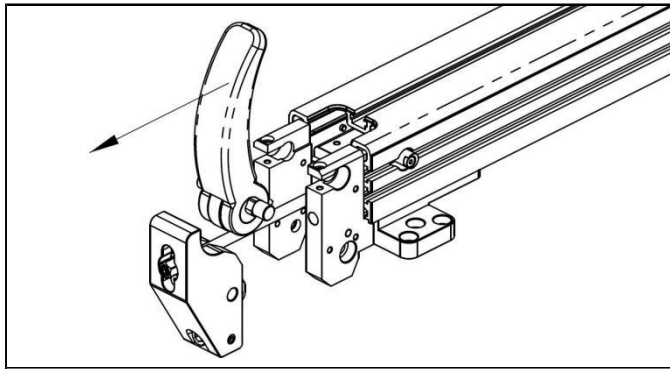


Fig. 14-8

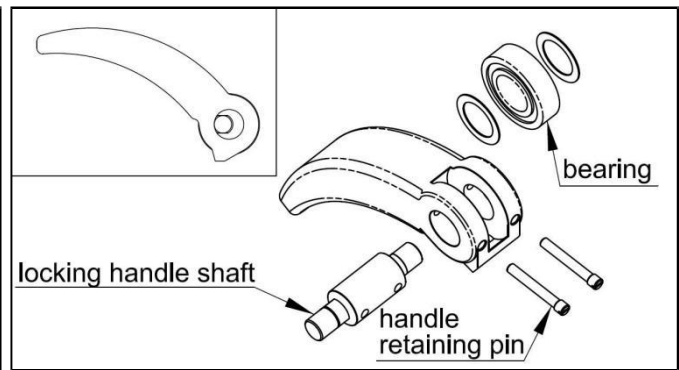
8. As shown in Fig. 14-9, remove the handle assembly.

9. As shown in Fig. 14-10, use a flathead screwdriver to remove the two handle retaining pins, then pull out the locking handle shaft and remove the bearing.

**Note: Make sure to confirm the orientation of the locking handle shaft during reinstallation. Take a photo before disassembly if necessary.**



**Fig. 14-9**



**Fig. 14-10**

10. Clean the locking handle and related components. Install the new bearing, then reassemble in reverse order following the disassembly steps. The replacement is now complete.

### ● Replacing the Viewer

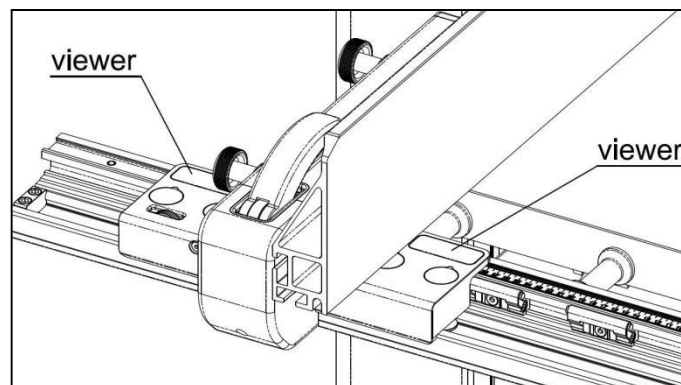
If the viewer is damaged, follow the steps below to replace it:

1. Prepare a new viewer and wipe it clean using anhydrous ethanol.
2. Use a heat gun to heat the edge of the damaged viewer. Once the adhesive loses its stickiness, remove the viewer.

**Warning: Parts may become extremely hot after heating. Handle with care to avoid burns.**

3. As shown in Fig. 14-11, clean the installation area on the slider with anhydrous ethanol.
4. Apply UV adhesive to the mounting area and affix the new viewer.

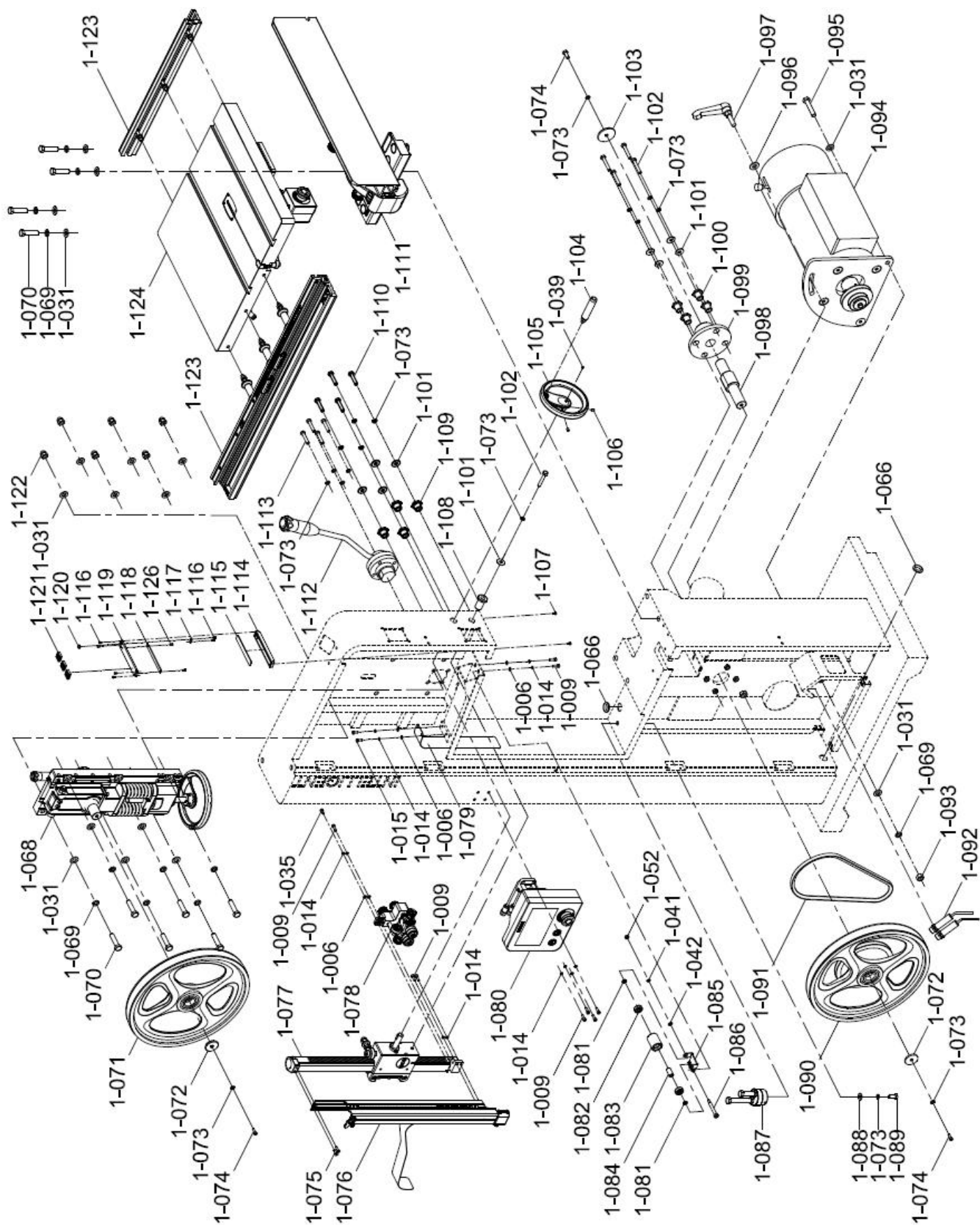
**Note: Use the UV adhesive in accordance with the manufacturer's instructions provided with the adhesive.**



**Fig. 14-11**

## Main Body





## List

### REF DESCRIPTION

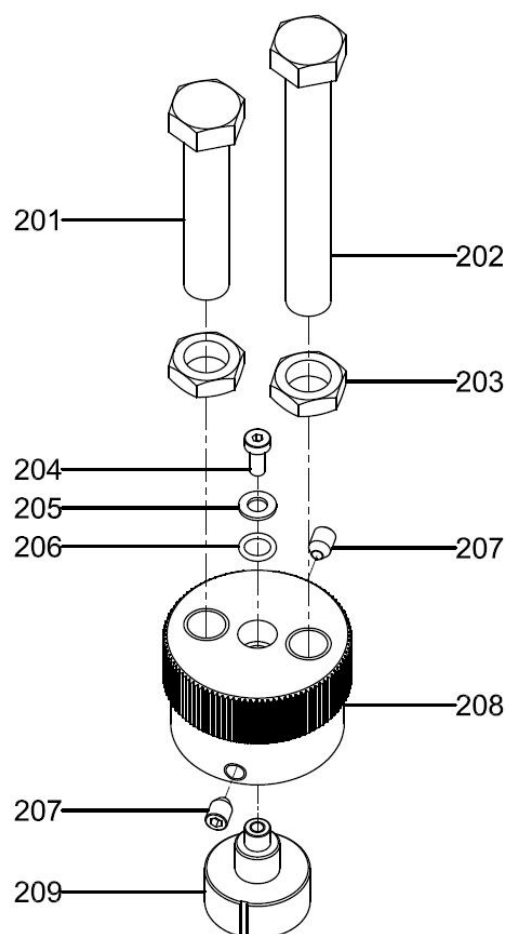
1-001 Installation board  
 1-002 Travel switch  
 1-003 Hex Screw M4x35  
 1-004 Stick strips  
 1-005 Cap nut M5  
 1-006 Flat Washer 5  
 1-007 Window  
 1-008 Rack  
 1-009 Hex Screw M5x16  
 1-010 Waterproof connector  
 1-011 Installation board  
 1-012 Adjusting base  
 1-013 Eccentric wheel  
 1-014 Spring Washer 5  
 1-015 Hex Bolt M5X12  
 1-016 Flat Washer 3  
 1-017 Brush  
 1-018 Installation board  
 1-019 Installation block  
 1-020 Nut M6  
 1-021 Big Flat Washer 6  
 1-022 Nylon Washer  
 1-023 Pointer  
 1-024 Installation board  
 1-025 Tapping screw ST2.9x9.5  
 1-026 Nut M4  
 1-027 Spring Washer 4  
 1-028 Installation board  
 1-029 Flat Washer 4  
 1-030 Rubber pad  
 1-031 Flat Washer 12  
 1-032 Hex Screw M12x30  
 1-033 Foundation  
 1-034 Thin Nut M12  
 1-035 Hex Screw M5x16  
 1-036 Nylon Washer  
 1-037 Set Screw M6x30  
 1-038 Door lock  
 1-039 Decorative Block  
 1-040 Hex Screw M6x25  
 1-041 Spring Washer 6  
 1-042 Flat Washer 6  
 1-043 Hinge A  
 1-044 Countersunk Screw M6x16  
 1-045 Nylon Washer  
 1-046 Hinge B  
 1-047 Axle  
 1-048 Snap ring  
 1-049 Lower door  
 1-099 Lower wheel base

### REF DESCRIPTION

1-050 Right baffle  
 1-051 Hex Bolt M6X20  
 1-052 Nut M6  
 1-053 Lower saw card assembly-A  
 1-054 Lower saw card assembly-B  
 1-055 Hex Screw M6x12  
 1-056 Upper door  
 1-057 Hex Screw M4X12  
 1-058 Electrical box components  
 1-059 Shelf  
 1-060 Window  
 1-061 Window bracket  
 1-062  
 1-063 Nut M4  
 1-064 Hinge  
 1-065 Left baffle  
 1-066 Sheath  
 1-067 Hex Screw M5x12  
 1-068 Wheel base assembly  
 1-069 Spring Washer 12  
 1-070 Hex Bolt M12X50  
 1-071 Upper wheel assembly  
 1-072 Wheel Washer  
 1-073 Spring Washer 8  
 1-074 Hex Screw M8x20  
 1-075 Countersunk Screw M5x10  
 1-076 Shield assembly  
 1-077 Lifting assembly  
 1-078 Upper saw card assembly  
 1-079 Reed  
 1-080 Operation panel assembly  
 1-081 Bush  
 1-082 Bearing  
 1-083 Roller  
 1-084 Bush  
 1-085 Installation board  
 1-086 Shoulder Screw D8x50-M6  
 1-087 Limit assembly  
 1-088 Flat Washer 8  
 1-089 Hex Bolt M8X20  
 1-090 Lower wheel assembly  
 1-091 V belt  
 1-092 Photoelectric switch  
 1-093 Nut M12  
 1-094 Motor assembly  
 1-095 Hex Bolt M12X60  
 1-096 Big Flat Washer 12  
 1-097 Adjustable locking handle M12  
 1-098 Axle  
 1-100 Adjusting nut

|                                  |                              |
|----------------------------------|------------------------------|
| 1-101 Big Flat Washer 8          | 1-114 Lampshade              |
| 1-102 Hex Bolt M8X60             | 1-115 Transparent board      |
| 1-103 Wheel Washer               | 1-116 Hex Screw M3x6         |
| 1-104 Handle                     | 1-117 Tension disc           |
| 1-105 Handwheel                  | 1-118 Light                  |
| 1-106 Set Screw M6x8             | 1-119 Lamp base              |
| 1-107 Hex Screw M4x6             | 1-120 Sheath                 |
| 1-108 Adjusting nut              | 1-121 Fin                    |
| 1-109 Adjusting nut              | 1-122 Cap nut M12            |
| 1-110 Hex Bolt M8X35             | 1-123 Rail Assembly          |
| 1-111 Fence Assembly             | 1-124 Table Assembly         |
| 1-112 Tensioning handle assembly | 1-125 Bin-Screw M5x16        |
| 1-113 Hex Bolt M8X40             | 1-126 Hex Screw M3x6 (Nylon) |

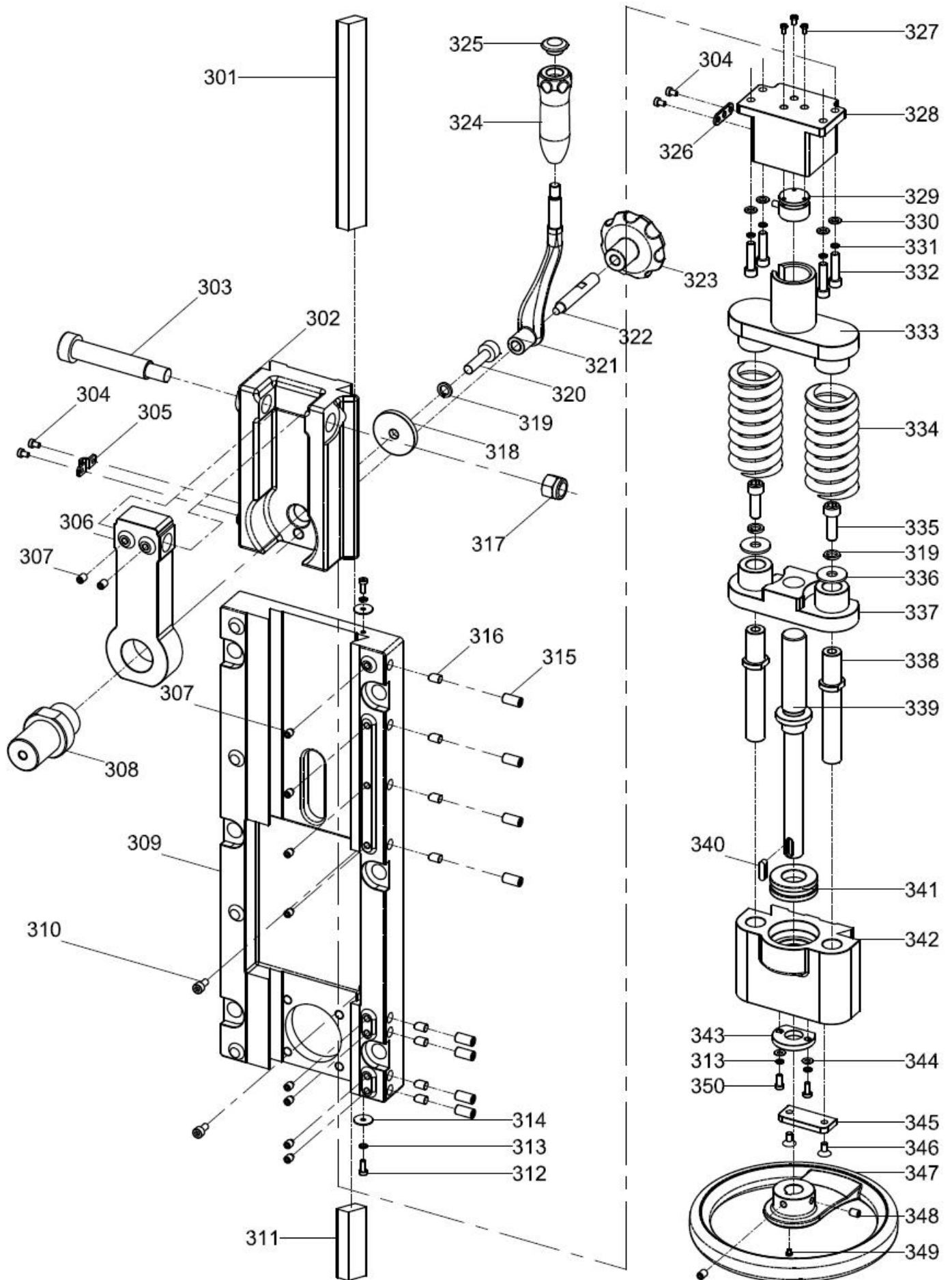
## Limit Assembly



## List

| REF | DESCRIPTION     | REF | DESCRIPTION     |
|-----|-----------------|-----|-----------------|
| 201 | Hex Bolt M12X60 | 206 | O-rings         |
| 202 | Hex Bolt M12X90 | 207 | Ball screw M6x8 |
| 203 | Thin Nut M12    | 208 | Limit knob      |
| 204 | Hex Screw M4x10 | 209 | Limit base      |
| 205 | Flat Washer 5   |     |                 |

# Wheel Base Assembly



## List

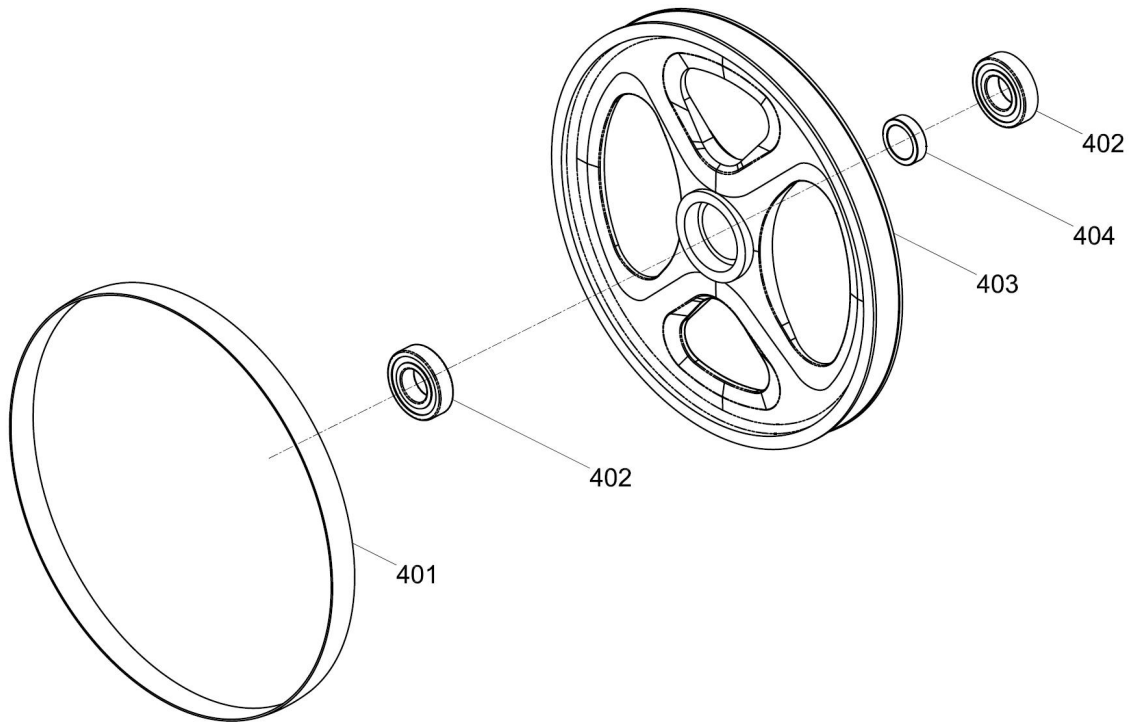
### REF DESCRIPTION

|     |                           |
|-----|---------------------------|
| 301 | Panel                     |
| 302 | Swing base                |
| 303 | Shoulder Screw D16x85-M12 |
| 304 | Hex Screw M4x6            |
| 305 | Line Card                 |
| 306 | Swing block               |
| 307 | Set Screw M6x6            |
| 308 | Wheel shaft               |
| 309 | Guide base                |
| 310 | Hex Screw M5x10           |
| 311 | Panel                     |
| 312 | Hex Screw M4x10           |
| 313 | Spring Washer 4           |
| 314 | Flat Washer 4             |
| 315 | Set Screw M8x16           |
| 316 | Briquette                 |
| 317 | Nut M12                   |
| 318 | Thick Flat Washer 8       |
| 319 | Spring Washer 8           |
| 320 | Hex Screw M8x20           |
| 321 | Locking rod               |
| 322 | Adjusting screw           |
| 323 | Adjusting knob            |
| 324 | Locking handle            |
| 325 | Decorative Block          |

### REF DESCRIPTION

|     |                         |
|-----|-------------------------|
| 326 | Line Card               |
| 327 | Hex Screw M3x6          |
| 328 | Sensor base             |
| 329 | Sensor                  |
| 330 | Flat Washer 6           |
| 331 | Spring Washer 6         |
| 332 | Hex Screw M6x25         |
| 333 | Sensor guide block      |
| 334 | Spring                  |
| 335 | Hex Screw M8x25         |
| 336 | Flat Washer 8           |
| 337 | Guide nut               |
| 338 | Guide rod               |
| 339 | Guide screw             |
| 340 | Key                     |
| 341 | Bearing                 |
| 342 | Tension base            |
| 343 | Stop block              |
| 344 | Flat Washer 4           |
| 345 | Anti wear pad           |
| 346 | Countersunk Screw M5x10 |
| 347 | Handwheel               |
| 348 | Set Screw M6x8          |
| 349 | Decorative Block        |
| 350 | Hex Screw M4x12         |

## Upper wheel Assembly



### List

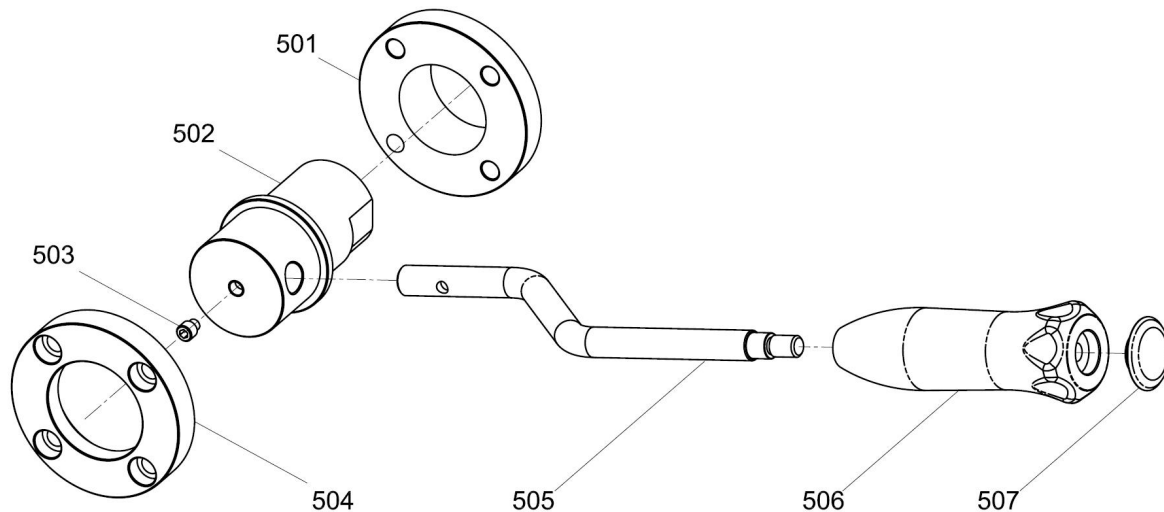
#### REF DESCRIPTION

- 401 Crash Pad
- 402 Bearing

#### REF DESCRIPTION

- 403 Wheel
- 404 Bush

## Tensioning handle assembly



### List

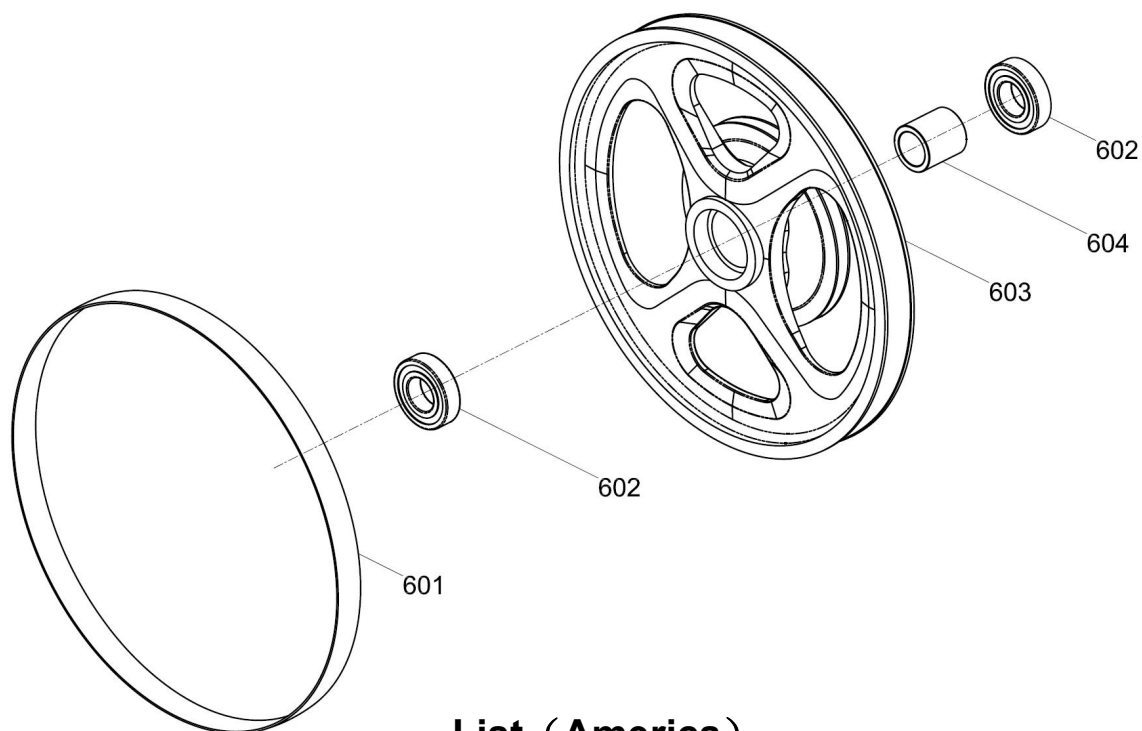
#### REF DESCRIPTION

- 501 Positioning seat
- 502 Axle
- 503 Set Screw M6x8
- 504 Locking seat

#### REF DESCRIPTION

- 505 Tension rod
- 506 Tension handle
- 507 Decorative Block

## Lower wheel Assembly



### List (America)

#### REF DESCRIPTION

601 Crash Pad  
602 Bearing

#### NUM

#### REF DESCRIPTION

603 Wheel (60Hz)  
604 Bush

### List (Europe)

#### REF DESCRIPTION

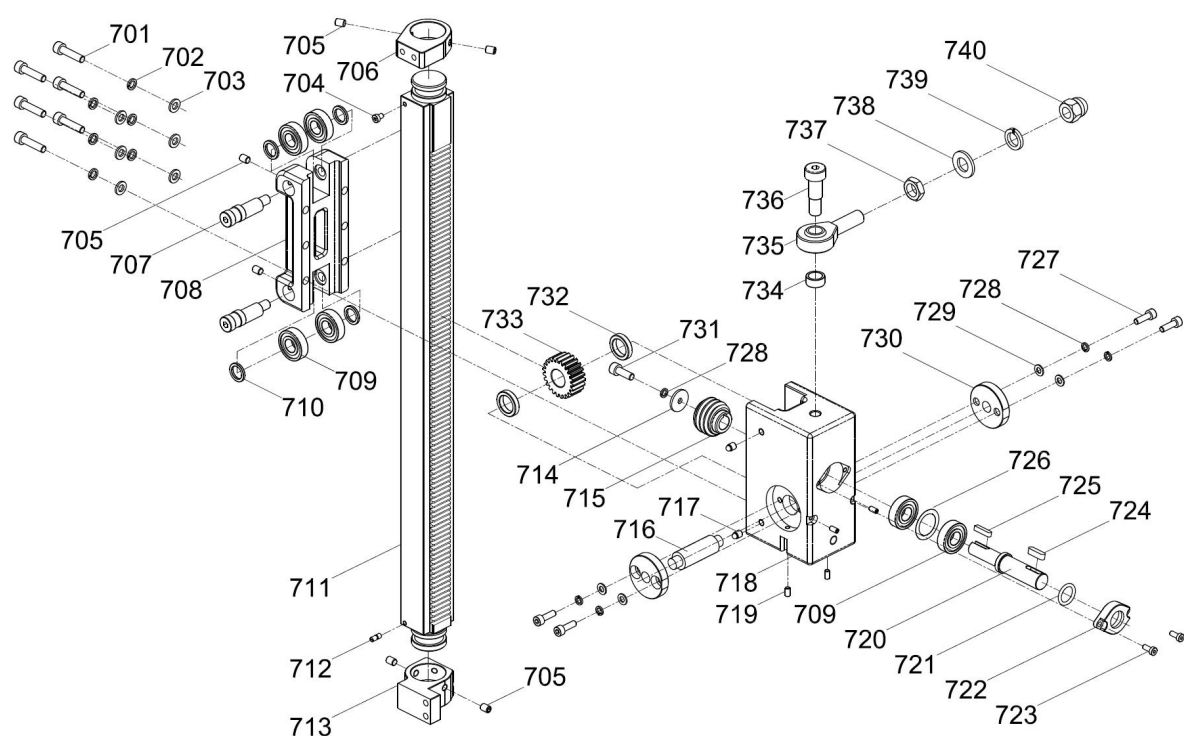
601 Crash Pad  
602 Bearing

#### NUM

#### REF DESCRIPTION

603 Wheel (50Hz)  
604 Bush

## Lifting Assembly



### List

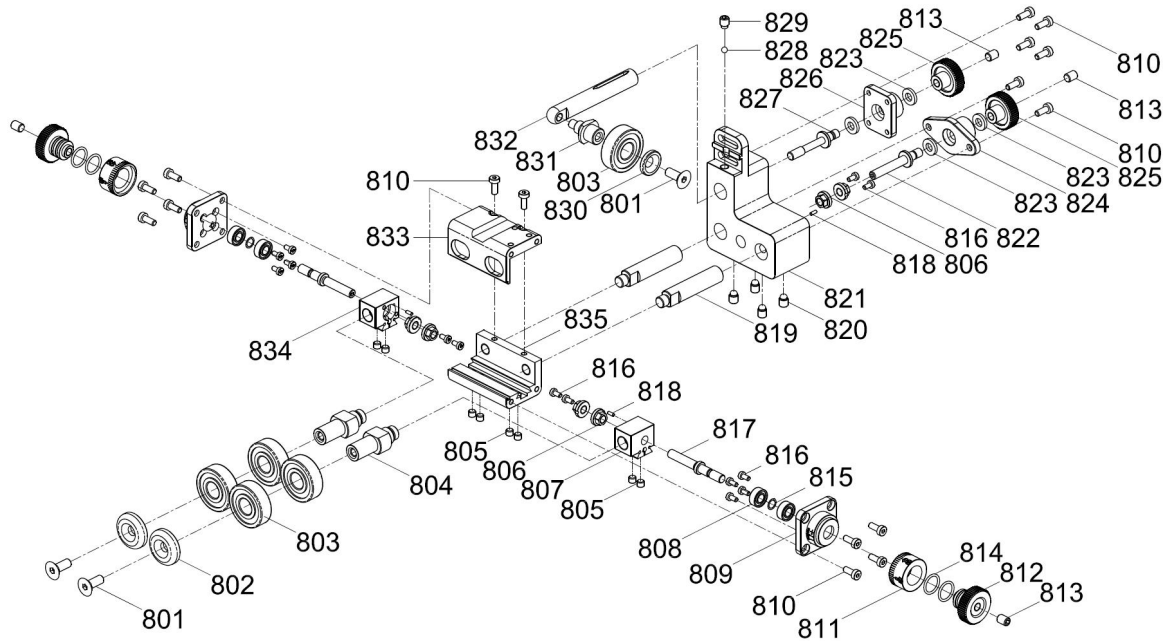
#### REF DESCRIPTION

|     |                 |
|-----|-----------------|
| 701 | Hex Screw M6x25 |
| 702 | Spring Washer 6 |
| 703 | Flat Washer 6   |
| 704 | Hex Screw M4x6  |
| 705 | Set Screw M6x8  |
| 706 | Up fixed seat   |
| 707 | Eccentric shaft |
| 708 | Lift mount      |
| 709 | Bearing         |
| 710 | Bush            |
| 711 | Rack            |
| 712 | Pin screw M4x10 |
| 713 | Down fixed seat |
| 714 | Big Washer 5    |
| 715 | Worm            |
| 716 | Shaft           |
| 717 | Set Screw M6x6  |
| 718 | Right mount     |
| 719 | Set Screw M4x8  |
| 720 | Shaft           |

#### REF DESCRIPTION

|     |                           |
|-----|---------------------------|
| 721 | O-rings                   |
| 722 | Fixed block               |
| 723 | Hex Screw M4x10           |
| 724 | Key                       |
| 725 | Key                       |
| 726 | Shim                      |
| 727 | Hex Screw M5x10           |
| 728 | Spring Washer 5           |
| 729 | Flat Washer 5             |
| 730 | Adjusting base            |
| 731 | Hex Screw M5x12           |
| 732 | Bush                      |
| 733 | Gear                      |
| 734 | Bush                      |
| 735 | Spherical bearing         |
| 736 | Shoulder screw D12x20-M10 |
| 737 | Thin Nut M12              |
| 738 | Flat Washer 12            |
| 739 | Spring Washer 12          |
| 740 | Cap nut M12               |

## Upper saw card Assembly



### List

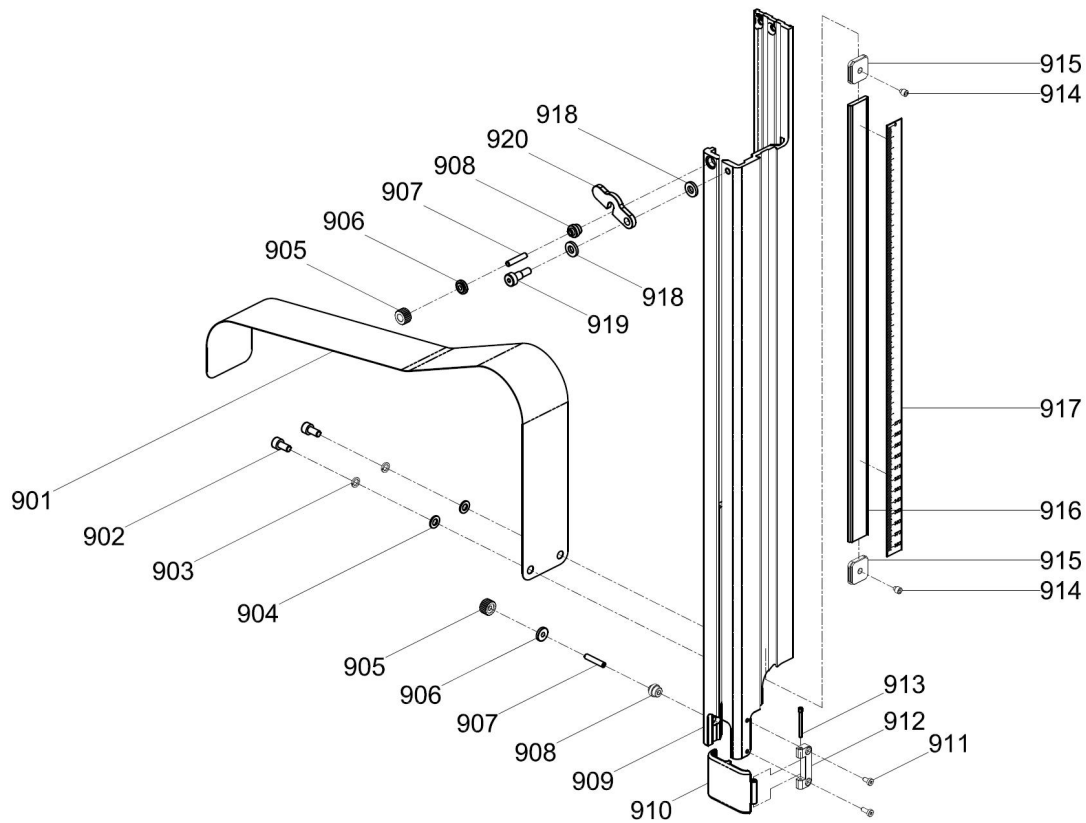
#### REF DESCRIPTION

|     |                         |
|-----|-------------------------|
| 801 | Countersunk Screw M6x16 |
| 802 | Limit washer            |
| 803 | Bearing                 |
| 804 | Axle                    |
| 805 | Set Screw M5x4          |
| 806 | Adjusting nut           |
| 807 | Lift slider             |
| 808 | Bearing                 |
| 809 | Flange                  |
| 810 | Hex Screw M4x10         |
| 811 | Scale ring              |
| 812 | Knob                    |
| 813 | Set Screw M6x8          |
| 814 | O-rings                 |
| 815 | Shim                    |
| 816 | Hex Screw M3x6          |
| 817 | Axle                    |
| 818 | Pin 2x5                 |

#### REF DESCRIPTION

|     |                |
|-----|----------------|
| 819 | Guide rod      |
| 820 | Set Screw M6x6 |
| 821 | Base           |
| 822 | Axle           |
| 823 | Nylon Washer   |
| 824 | Flange         |
| 825 | Knob           |
| 826 | Flange         |
| 827 | Axle           |
| 828 | Steel ball     |
| 829 | Set Screw M6x6 |
| 830 | Limit washer   |
| 831 | Axle           |
| 832 | Guide rod      |
| 833 | Cover          |
| 834 | Right slider   |
| 835 | Guide base     |

## Shield Assembly



### List

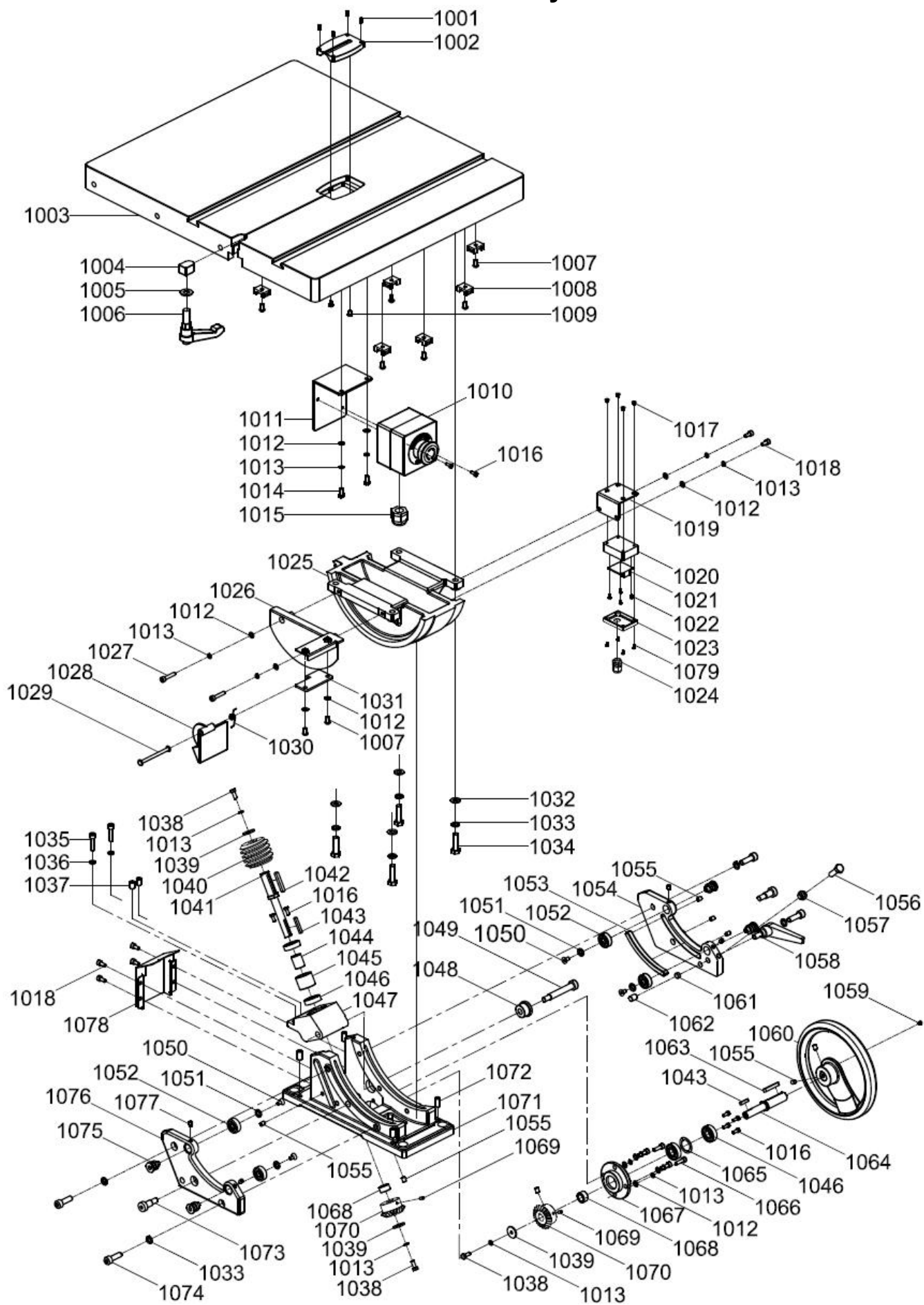
#### REF DESCRIPTION

|     |                        |
|-----|------------------------|
| 901 | Reed                   |
| 902 | Hex Screw M5x10        |
| 903 | Spring Washer 5        |
| 904 | Flat Washer 5          |
| 905 | Knob                   |
| 906 | Nylon Washer           |
| 907 | Set Screw M4x20        |
| 908 | Inlaid nut             |
| 909 | Upper protective cover |
| 910 | Window                 |

#### REF DESCRIPTION

|     |                           |
|-----|---------------------------|
| 911 | Hex Screw M3x6            |
| 912 | Hinge seat                |
| 913 | Hinge                     |
| 914 | Set Screw-Nylon head M5x4 |
| 915 | Limit nut                 |
| 916 | Ruler holder              |
| 917 | Ruler                     |
| 918 | Nylon Washer              |
| 919 | Shoulder screw D6x8-M5    |
| 920 | Locking plate             |

## Table Assembly



## List

### REF DESCRIPTION

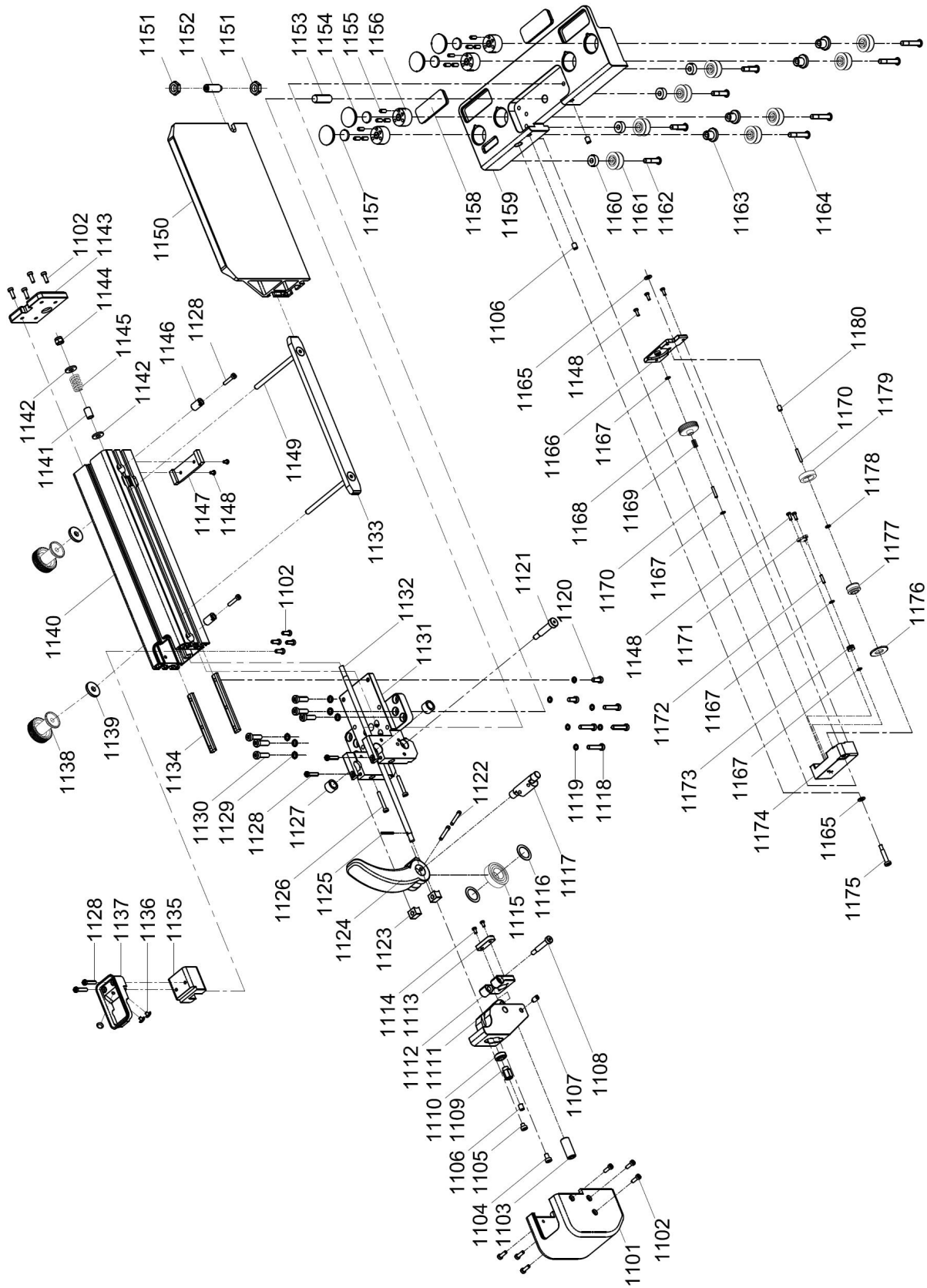
1001 Set Screw M4x8  
 1002 Protective board  
 1003 Table  
 1004 Locking block  
 1005 Flat Washer 10  
 1006 Adjustable locking handle M10  
 1007 Hex Screw M5x6  
 1008 Line Card  
 1009 Hex Screw M4x6  
 1010 Button box  
 1011 Installation board  
 1012 Flat Washer 5  
 1013 Spring Washer 5  
 1014 Hex Bolt M5X12  
 1015 Waterproof connector  
 1016 Hex Screw M4x10  
 1017 Countersunk Screw M3x5  
 1018 Hex Screw M5x16  
 1019 Installation board  
 1020 Sensor box  
 1021 Sensor  
 1022 Cross screw M2x5  
 1023 Cover  
 1024 Waterproof connector  
 1025 Rotating block  
 1026 Back side baffle  
 1027 Hex Screw M5x25  
 1028 Centering block  
 1029 Hinge  
 1030 Torsional spring  
 1031 Installation board  
 1032 Flat Washer 8  
 1033 Spring Washer 8  
 1034 Hex Bolt M8X30  
 1035 Hex Screw M6x25  
 1036 Spring Washer 6  
 1037 Set Screw M8x16  
 1038 Hex Screw M5x12  
 1039 Big Washer 5

### REF DESCRIPTION

1040 Worm  
 1041 Axle  
 1042 Key  
 1043 Key  
 1044 Bush  
 1045 Bush  
 1046 Bearing  
 1047 Worm base  
 1048 Positioning block  
 1049 Shoulder screw D10x75-M8  
 1050 Countersunk Screw M5x10  
 1051 Limit washer  
 1052 Bearing  
 1053 Panel  
 1054 Outer vertical panel  
 1055 Set Screw M6x8  
 1056 Hex Bolt M8X20  
 1057 Nut M8  
 1058 Adjustable locking handle M8  
 1059 Decorative Block  
 1060 Handwheel  
 1061 Locking pad  
 1062 locking block  
 1063 Key  
 1064 Axle  
 1065 Shim  
 1066 Hex Screw M5x16  
 1067 Gear base  
 1068 Bush  
 1069 Set Screw M4x8  
 1070 Bevel gear  
 1071 Base  
 1072 Set Screw M8x16  
 1073 Shoulder screw D10x15-M8  
 1074 Hex Screw M8x25  
 1075 Eccentric shaft  
 1076 Inner vertical board  
 1077 Set Screw M6x6  
 1078 Cover  
 1079 Cross screw M3x8

1022

# Fence Assembly



## List

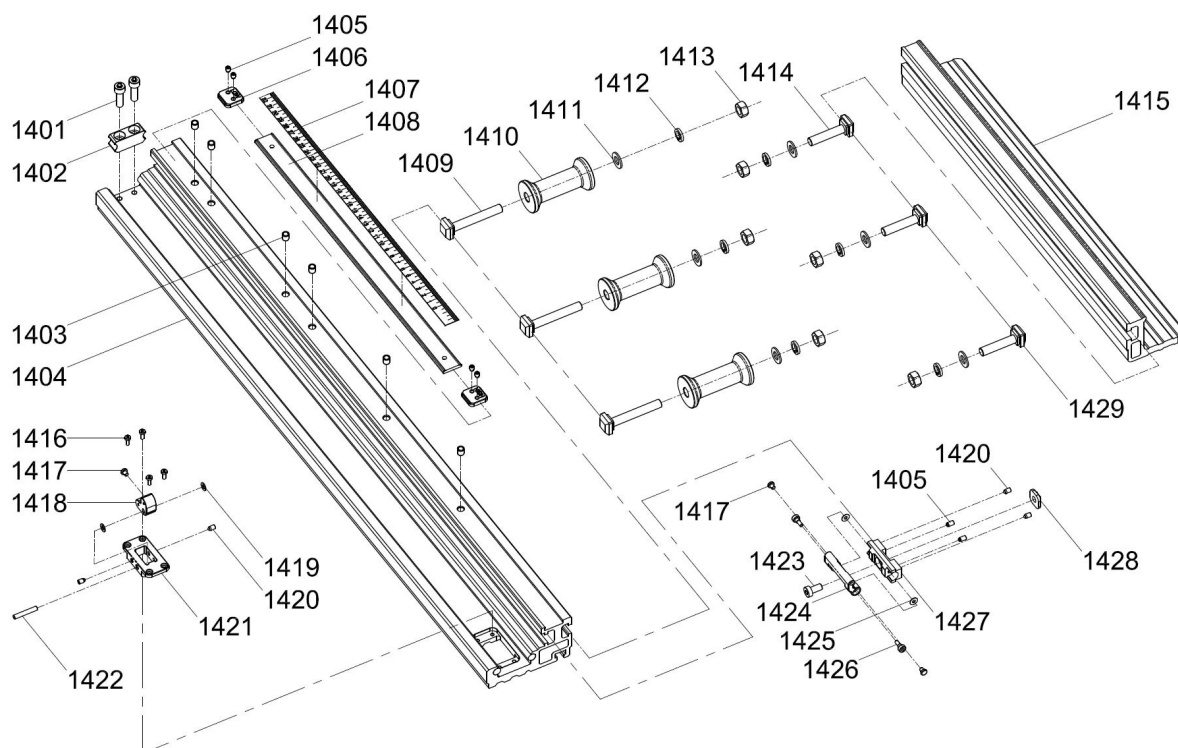
### REF DESCRIPTION

1101 Outer Shell  
 1102 Hex Screw M4x12  
 1103 Adjusting Screw  
 1104 Hex Screw M5x8  
 1105 Hex Screw M5x5  
 1106 Set Screw M6x8  
 1107 Set Screw M6x6  
 1108 Shoulder Screw D6x25-M5  
 1109 Pull Rod Lock Nut  
 1110 Spherical Plain Bearing GE8C  
 1111 Locking Swing Arm  
 1112 Locking Block Seat  
 1113 Locking Block  
 1114 Hex Screw M4x6  
 1115 Bearing 6003  
 1116 Thin Flat Washer  
 1117 Handle Shaft  
 1118 Hex Screw M5x25  
 1119 Spring Washer 5  
 1120 Hex Screw M5x12  
 1121 Shoulder Screw D8x40-M6  
 1122 Handle Pin  
 1123 Support Block  
 1124 Locking Handle  
 1125 Pin 2x12  
 1126 Hex Screw M4x40  
 1127 Copper Bush  
 1128 Hex Screw M4x20  
 1129 Hex Screw M6x20  
 1130 Spring Washer 6  
 1131 Bracket  
 1132 Locking Rod  
 1133 Fence Locking Block  
 1134 Bracket Locking Block  
 1135 Lower Block of Handle  
 1136 Rubber Limit Block  
 1137 Upper Block of Handle  
 1138 Fence Locking Knob  
 1139 Teflon Flat Washer  
 1140 Fence Body

### REF DESCRIPTION

1141 Bush  
 1142 Flat Washer 6  
 1143 End Cap  
 1144 Nut M6  
 1145 Spring  
 1146 Fence Position Block  
 1147 Sliding pad  
 1148 Hex Screw M3x8  
 1149 Countersunk Screw M6x100  
 1150 Fence  
 1151 Thin Nut M10  
 1152 Set Screw M10x25  
 1153 Pin 10x30  
 1154 Sealing Cover  
 1155 Set Screw M4x10  
 1156 Eccentric Nut  
 1157 Magnet  
 1158 Window  
 1159 Slider  
 1160 Fixed wheel cushion block  
 1161 Roller  
 1162 Roller Shaft(short)  
 1163 Moving wheel cushion block  
 1164 Roller Shaft(long)  
 1165 Nylon Washer  
 1166 Cover  
 1167 Thin Flat Washer  
 1168 Roller  
 1169 Gear  
 1170 Pin 2x25  
 1171 Fixed plate  
 1172 Pin 2x12  
 1173 Gear  
 1174 Base  
 1175 Shoulder Screw D5x25-M4  
 1176 Gear  
 1177 Roller core  
 1178 Nylon Washer  
 1179 Roller rubber  
 1180 Bush

## Rail Assembly



## List

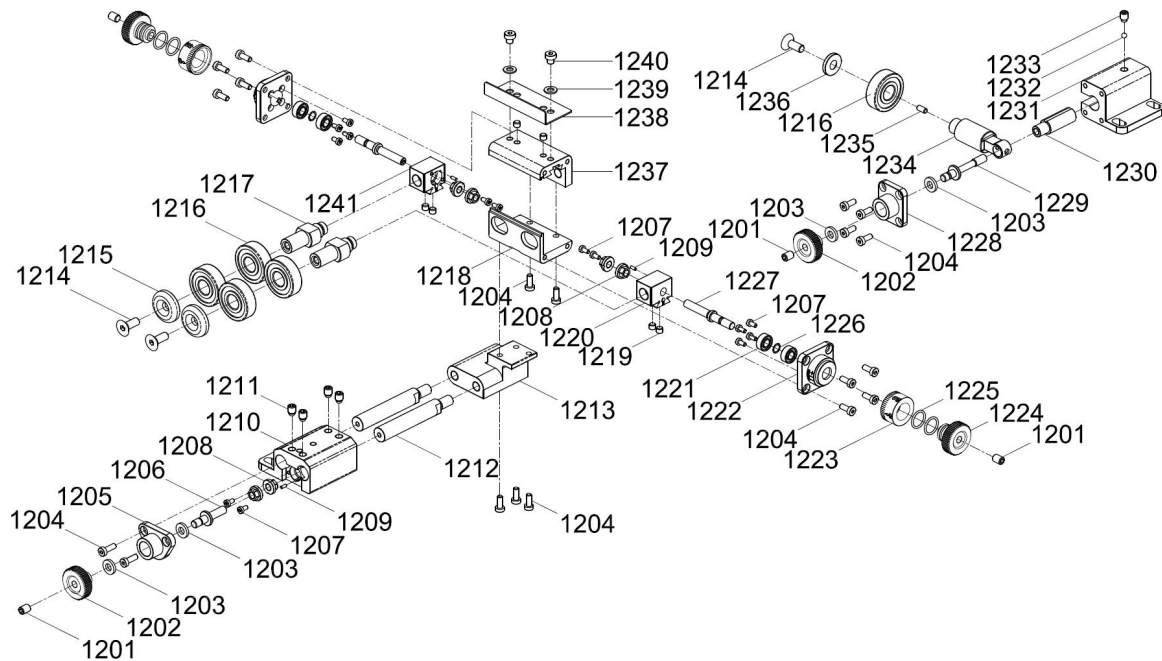
### REF DESCRIPTION

|      |                                |
|------|--------------------------------|
| 1401 | Hex Screw M6x20                |
| 1402 | Stop block                     |
| 1403 | Ball plunger $\phi 6 \times 7$ |
| 1404 | Front guide rail               |
| 1405 | Set Screw M4x4                 |
| 1406 | Scale Stop                     |
| 1407 | Ruler                          |
| 1408 | Ruler holder                   |
| 1409 | Set Screw M8x110               |
| 1410 | Installation block             |
| 1411 | Flat Washer 8                  |
| 1412 | Spring Washer 8                |
| 1413 | Nut M8                         |
| 1414 | Set Screw M8x45                |
| 1415 | Rear Rail                      |

### REF DESCRIPTION

|      |                           |
|------|---------------------------|
| 1416 | Hex Screw M3x8            |
| 1417 | Nylon limit block         |
| 1418 | Safety Stop               |
| 1419 | Copper Washer 4           |
| 1420 | Ball screw M4x6           |
| 1421 | Safety Stop Locking Block |
| 1422 | Pin 4x20                  |
| 1423 | Hex Screw M6x12           |
| 1424 | Flip Position Stop        |
| 1425 | Copper Washer 3           |
| 1426 | Shoulder Screw M4x8       |
| 1427 | Flip Position Stop Block  |
| 1428 | Square Nut                |
| 1429 | Eccentric Square Nut      |

## Lower saw card Assembly



### List

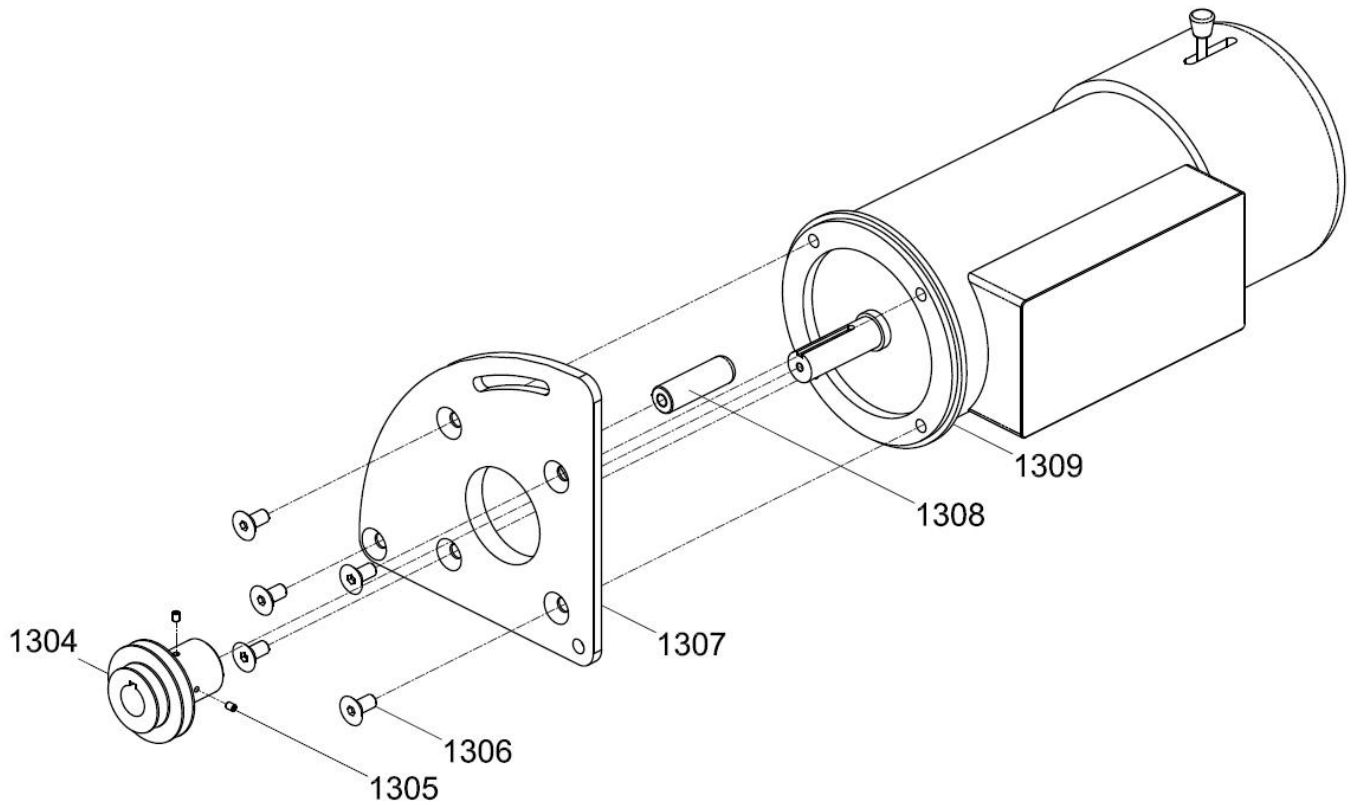
#### REF DESCRIPTION

|      |                         |
|------|-------------------------|
| 1201 | Set Screw M6x8          |
| 1202 | Knob                    |
| 1203 | Nylon Washer            |
| 1204 | Hex Screw M4x10         |
| 1205 | Flange                  |
| 1206 | Axle                    |
| 1207 | Hex Screw M3x6          |
| 1208 | Adjusting nut           |
| 1209 | Pin 2x5                 |
| 1210 | Base                    |
| 1211 | Set Screw M6x6          |
| 1212 | Guide rod               |
| 1213 | Installation block      |
| 1214 | Countersunk Screw M6x16 |
| 1215 | Limit washer            |
| 1216 | Bearing                 |
| 1217 | Axle                    |
| 1218 | Cover                   |
| 1219 | Set Screw M5x4          |
| 1220 | Lift slider             |

#### REF DESCRIPTION

|      |                           |
|------|---------------------------|
| 1221 | Bearing                   |
| 1222 | Flange                    |
| 1223 | Scale ring                |
| 1224 | Knob                      |
| 1225 | O-rings                   |
| 1226 | Shim                      |
| 1227 | Axle                      |
| 1228 | Flange                    |
| 1229 | Axle                      |
| 1230 | Guide rod                 |
| 1231 | Base                      |
| 1232 | Steel ball                |
| 1233 | Set Screw-Nylon head M6x6 |
| 1234 | Axle                      |
| 1235 | Set Screw M4x8            |
| 1236 | Limit washer              |
| 1237 | Guide base                |
| 1238 | Back side baffle          |
| 1239 | Flat Washer 5             |
| 1240 | Hex Screw M5x5            |
| 1241 | Lift slider               |

## Motor Assembly



### List(America)

#### REF DESCRIPTION

1301  
1302  
1303  
1304 Belt pulley(60Hz)  
1305 Set Screw M6x8

#### REF DESCRIPTION

1306 Countersunk Screw M12x25  
1307 Mount  
1308 Handle  
1309 Electrical machinery

### List(Europe)

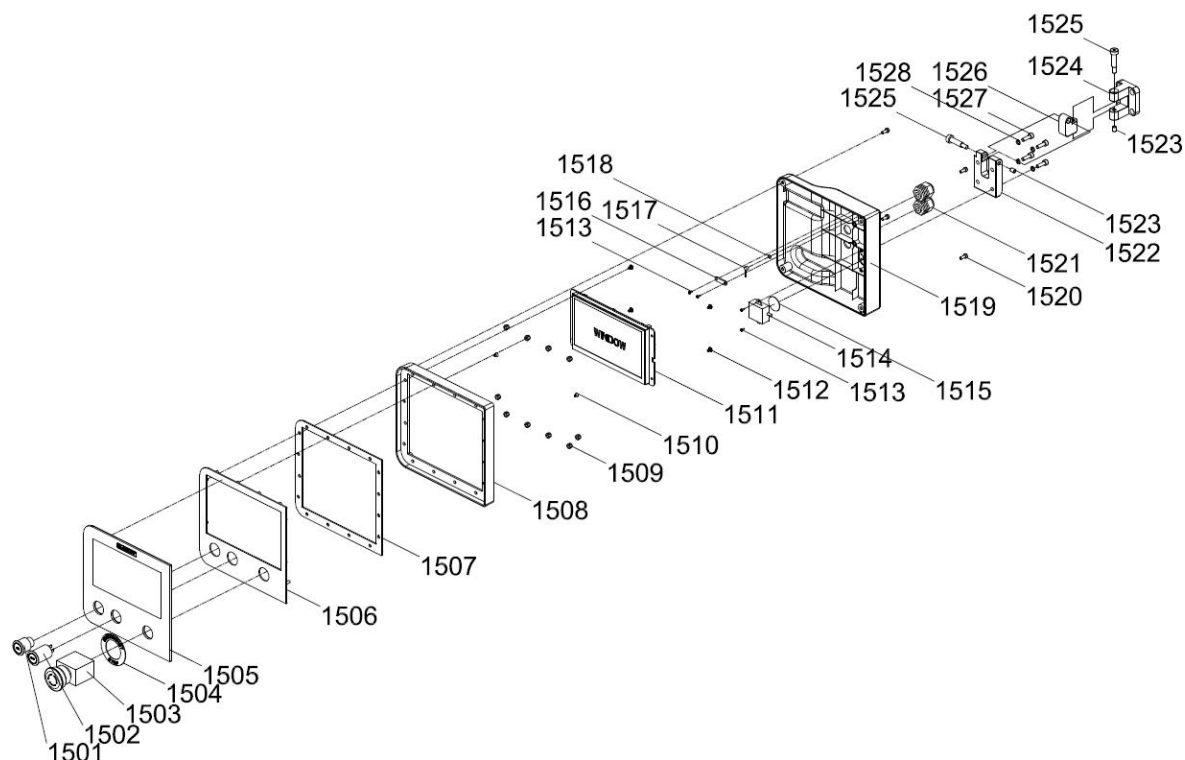
#### REF DESCRIPTION

1301 Hex Bolt M8X20  
1302 Spring Washer 8  
1303 Flat Washer 8  
1304 Belt pulley(50Hz)  
1305 Set Screw M6x8

#### REF DESCRIPTION

1306 Countersunk Screw M12x25  
1307 Mount  
1308 Handle  
1309 Electrical machinery

## Operation panel assembly



## List

### REF DESCRIPTION

- 1501 Start button
- 1502 Stop button
- 1503 Emergency stop button
- 1504 Emergency label
- 1505 Glass panel
- 1506 support
- 1507 gasket
- 1508 Front shell
- 1509 Nut M4
- 1510 Countersunk Screw M3x5
- 1511 Display screen
- 1512 Cross groove flange screw
- 1513 Cross recessed screw M2X6
- 1514 Speaker

### REF DESCRIPTION

- 1515 Waterproof membrane 25
- 1516 Line card
- 1517 mic
- 1518 Waterproof membrane 6
- 1519 Rear case
- 1520 Hex Screw M4x12
- 1521 connector
- 1522 Hinge C
- 1523 Set Screw M6x8
- 1524 Hinge A
- 1525 Shoulder screw D8x25-M6
- 1526 Hinge B
- 1527 Hex Screw M5x16
- 1528 Spring Washer 5



Good Enough Is Not Enough

[www.harveywoodworking.com](http://www.harveywoodworking.com) (North American Online Shop)

[www.harveywoodworking.ca](http://www.harveywoodworking.ca) (Canadian Online Shop)

[www.harveywoodworking.de](http://www.harveywoodworking.de) (European Online Shop)

### ***HARVEY INDUSTRIES CO., LTD.***

68-10 Suyuan Avenue, Jiangning District, Nanjing 211100, China



#### **Harvey Industries International Inc.**

📍 10832 Ada Ave. Montclair, CA. 91763, United States

☎ 1-888-211-0397

✉ [info@harveywoodworking.com](mailto:info@harveywoodworking.com)



#### **Harvey Industries Europe GmbH**

📍 Ludwigstraße 16.35315 Hornberg (Ohm) Germany

☎ 49-6633-9110396

✉ [info@harveywoodworking.de](mailto:info@harveywoodworking.de)  
[info@bridgecitytools.de](mailto:info@bridgecitytools.de)



#### **Canada Fulfillment Center**

📍 1422 Pemberton Avenue, North Vancouver  
British Columbia V7P 2S1, Canada

☎ 1-888-211-0397

✉ [info@harveywoodworking.com](mailto:info@harveywoodworking.com)



#### **南京海威机械有限公司**

📍 中国南京江宁经济开发区苏源大道68-10.

☎ 025-86668165

✉ [shane@harvey.cn](mailto:shane@harvey.cn)