



Assembly Instructions and Parts Manual

XACTA[®] Commercial Fence & Rails (50" Rip)

for JTAS-12-DX Table Saw



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1.0 Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

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

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

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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3.0 Safety warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. The table saw on which this fence is used, is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a table saw, do not use until proper training and knowledge have been obtained.
5. Do not use the table saw for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using the table saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating the table saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Always use the blade guard on all "through-sawing" operations. A through-sawing operation is one in which the blade cuts completely through the workpiece.
9. Kickback occurs when the workpiece is thrown towards the operator at a high rate of speed. If you do not have a clear understanding of kickback and how it occurs, DO NOT operate the table saw!
10. Wear ear protectors (plugs or muffs) during extended periods of operation.
11. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
12. Make certain switch is in OFF position before connecting the machine to the power supply.
13. Make certain the machine is properly grounded.
14. Make all machine adjustments or maintenance with the machine unplugged from the power source.
15. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
16. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. Keep children away.
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall into the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep saw blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
28. Do not stand on the machine. Serious injury could occur if the machine tips over.

29. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
30. Remove loose items and unnecessary work pieces from the area before starting the machine.
31. Keep hands out of the line of saw blade.
32. Use a push-stick when required.
33. Pay particular attention to instructions on reducing risk of kickback.
34. Do not perform any operation freehand.
35. Never reach around or over saw blade.
36. Don't use in dangerous environment. Don't use power tools in damp or wet location, or expose them to rain. Keep work area well lighted.

 **WARNING:** This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

 **WARNING:** Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection.

Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

4.0 About this manual

This manual is provided by JET covering the assembly and adjustment procedures for a JET XACTA® Fence system for the JTAS-12-DX Table Saw. This manual contains instructions on installation, safety precautions, and parts breakdown. Your fence has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Retain this manual for future reference. If the fence transfers ownership, the manual should accompany it.

 WARNING Read and understand the entire contents of the table saw manual before attempting operation of the rip fence. Failure to comply may cause serious injury.

5.0 Specifications

XACTA Fence:

Stock number	708955Z
Fence body length.....	40-1/2" (1029 mm)
Side plate length	42" (1067 mm)
Side plate thickness	19/32" (15 mm)
Side plate material	polyethylene
Fence width.....	4-1/4" (108 mm)
Fence height	2-1/2" (64 mm)
Head length.....	16" (406 mm)
Net weight (fence only)	23 lb (10.4 kg)
Paint finish	powder coat

Rail Assembly:

Stock number	708956Z
Maximum rip to right of blade.....	50" (1270 mm)
Maximum rip to left of blade	14" (356 mm)
Guide tube dimensions	84-3/8"L x 3"W x 2"H (2143 x 76 x 51 mm)
Front rail dimensions	72"L x 2-1/2"W x 2-1/2"H (1830 x 64 x 64 mm)
Rear rail dimensions	72" x 1-1/2"W x 1-1/2"H (1830 x 38 x 38 mm)
Paint finish	powder coat

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

6.0 Setup and assembly

Open shipping cartons and check that all parts are intact. Report any damage immediately to your distributor. Read the instruction manual thoroughly for assembly, alignment, and maintenance instructions.

6.1 Tools required

- 1 #3 cross point screwdriver
- 1 7/16" wrench
- 1 1/2" wrench
- 1 Combination square & straight edge
- 1 1/4" hex key
- 1 3/16" hex key

6.2 Shipping contents

- 1 XACTA Fence II
- 1 Front rail
- 1 Back rail
- 1 Guide tube
- 3 Black plastic end covers
- 1 Owner's manual
- 1 Warranty registration card
- 1 Hardware package (p/n XF12DX-HP)* contains:
 - 7 Flat head screws, 1/4 x 1-1/2 (HP-1)
 - 5 Hex cap screws, 1/4 x 1-1/2 (HP-2)
 - 7 Hex cap screws, 1/4 x 3/4 (HP-3)
 - 2 Hex cap screws, 5/16 x 3/4 (HP-4)
 - 2 Flat washers, 5/16 (HP-5)
 - 24 Flat washers, 1/4 (HP-6)
 - 19 Lock washers 1/4 (HP-7)
 - 12 Hex nuts 1/4 (HP-8)

* Hardware package is shipped inside guide tube. Contents are shown full scale in Figure 1.

6.3 Front rail installation

1. Identify the front rail (A, Figure 2), which is 2-1/2" x 2-1/2" with notches on one side and countersunk mounting holes on the other side.
2. Lightly secure front rail (A) to table with seven 1/4 x 1-1/2 screws, flat washers, lock washers and hex nuts (HP-1/6/7/8). Tighten just enough to hold rail next to table but loose enough to allow height adjustment.

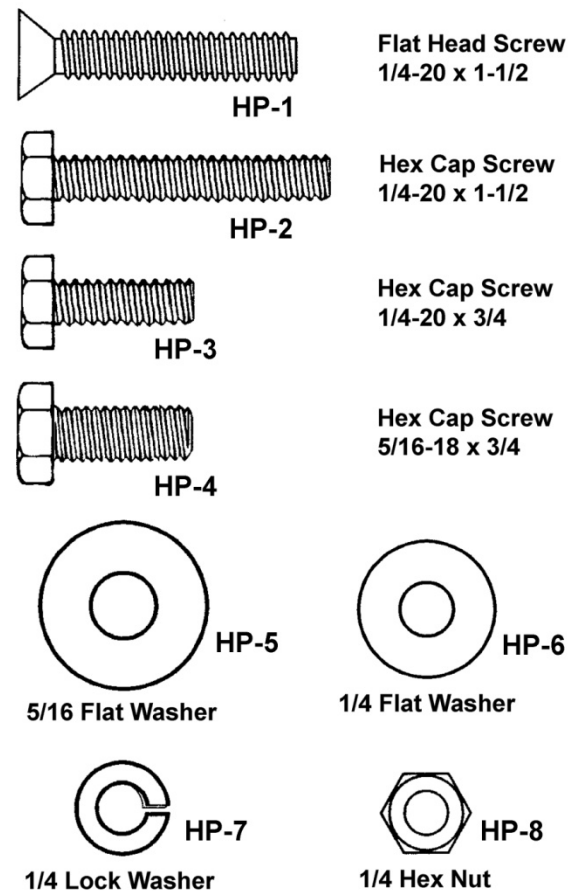


Figure 1

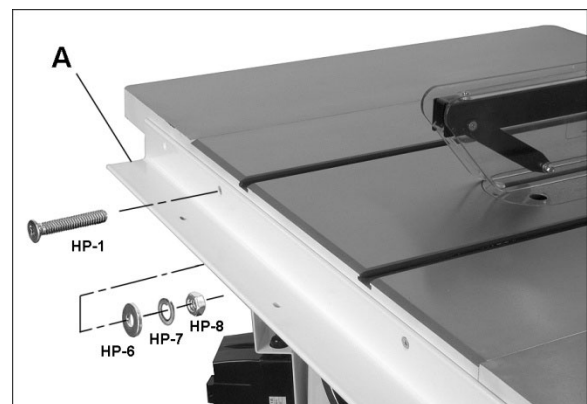


Figure 2

The front rail must be low enough to clear the miter gauge slot, and parallel to the table top:

1. Place an adjustable square on the table as shown in Figure 3.
37. Check height of front rail at several locations along the surface of the saw table. The front rail **must** be parallel with table top.
38. When front rail has been correctly positioned, use a screwdriver and 7/16" wrench to tighten nuts securely. However, do not tighten hardware for the farthest left hole; it should remain loose to accommodate switch installation (below).

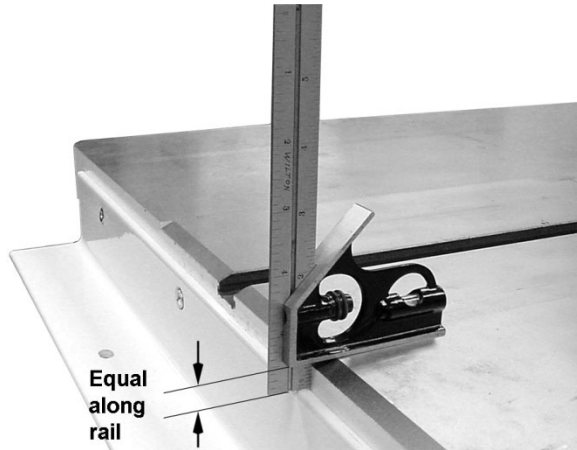


Figure 3

6.4 Switch installation

At this time refer to your JTAS-12DX Table Saw manual and mount the switch as described in the *Installing Switch* section. The switch should be mounted before the guide tube installation described later in this manual.

6.5 Back rail installation

1. Locate the back rail which is 2" x 2" with holes running along one side only. Height of back rail when attached to the saw is not critical.
39. Align holes in back rail to holes in table top.
40. Secure back rail to pre-tapped holes in saw table with two 5/16 screws and flat washers (**HP-4/5**), as shown in Figure 4. Tighten screws securely with 1/2" wrench.
41. Secure remainder of back rail with 1/4 screws, flat washers, lock washers, and hex nuts (**HP-2/6/7/8**) as shown in Figure 5.
42. Tighten all nuts.

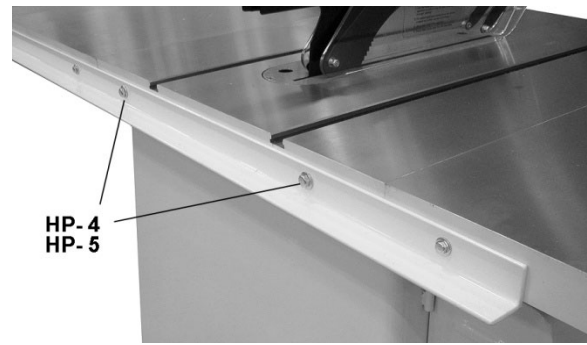


Figure 4

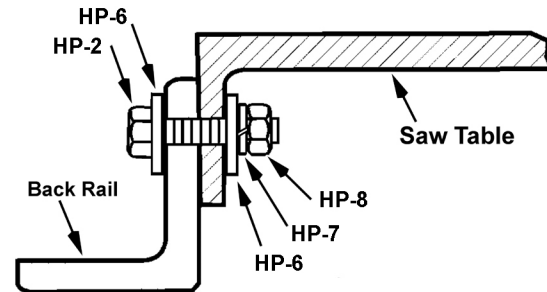


Figure 5

6.6 Guide tube

Important: Before proceeding with guide tube installation, the table saw switch should already be installed. If not, refer to the Switch Installation section in your JTAS-12-DX Saw manual.

Referring to Figure 6:

The guide tube (A) is placed on top of front rail (B) and is mounted with scale facing toward operator.

1. Align holes in bottom of guide tube with holes in front rail. When properly positioned, the guide tube should extend beyond the front rail about 6" in both directions.
43. Fasten guide tube (A) to front rail (B) from beneath, with seven 1/4" screws, lock washers, and flat washers (**HP-3/6/7**). Finger-tighten only until all screws are inserted.
44. Tighten all screws with a 7/16" wrench.

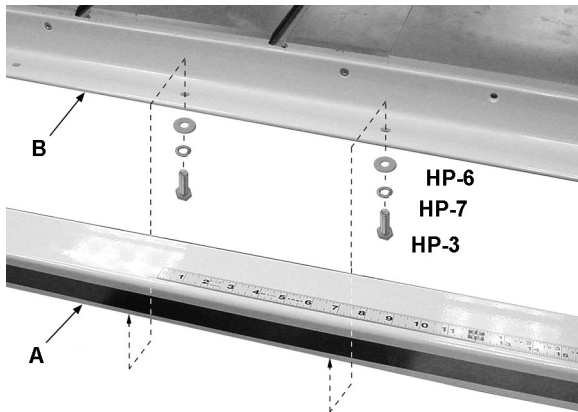


Figure 6

6.7 XACTA Fence

Screw knob into threaded handle on fence, as shown in Figure 7.

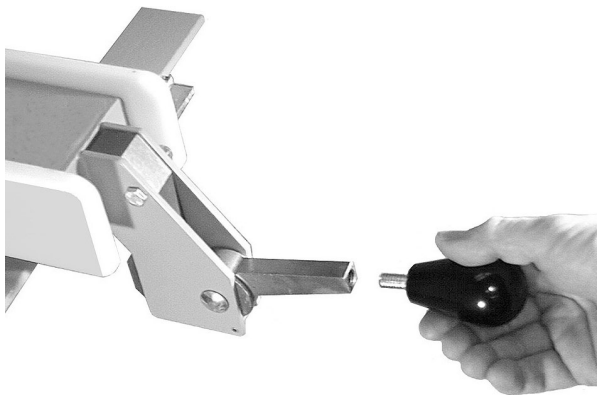


Figure 7

The lock lever has three functional positions as shown in Figure 8:

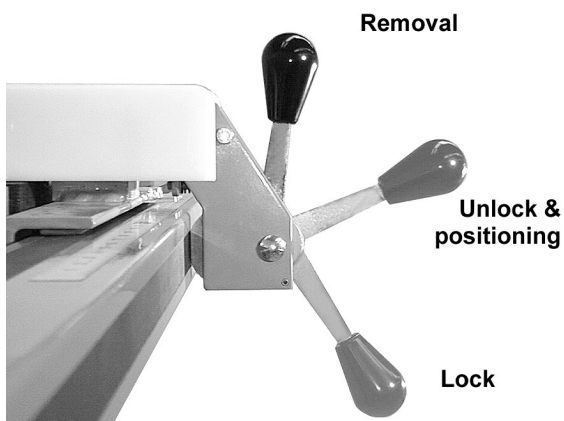


Figure 8

1. Upright position permits mounting and removal of fence from saw.
2. Unlock position permits easy fence positioning.
3. Lower position locks fence to guide tube. The cam handle should be pushed down firmly against the pin.

6.8 Leveling fence to saw table

Place fence on table and lock it.

1. View the fence from left side of saw (Figure 9). Look for the space *between the table and the fence bottom* to be equal along entire length of fence (A, B, Figure 9).

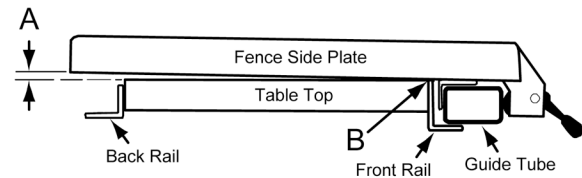


Figure 9

If adjustment is necessary:

45. Unlock fence.
46. Raise or lower two nylon adjustment screws (D, Figure 10) *the same number of turns* until the space between bottom of fence and table is the same. Care must be taken to raise or lower fence on each side equally or the fence may not be 90° to the table after the height adjustment is performed.

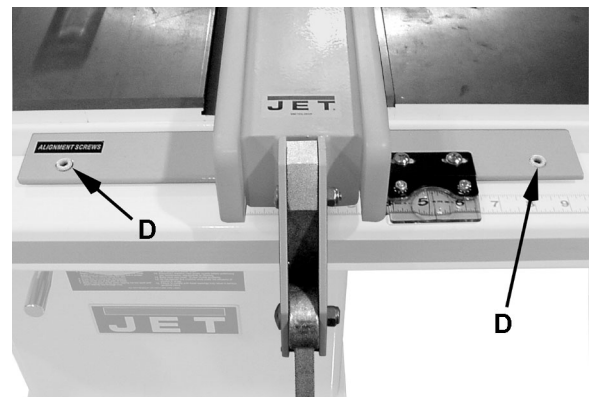


Figure 10

6.9 Adjusting fence parallel to miter slot

1. Place fence next to outside edge of right miter slot and lock it.
2. Fence should be even with miter slot from front to back.
47. If fence is not even along length of miter slot, unlock fence, remove it and turn it upside down.
48. Adjust one of two setscrews (A, Figure 11) until fence is even with miter slot edge along its entire length when locked.

Note: You may need to re-adjust the clamping pressure after aligning the fence.



Figure 11

6.10 Clamping Pressure

The XACTA Fence has been adjusted by the manufacturer to lock securely when lock handle is pushed down. If adjustment is needed:

1. Unlock fence.
49. Remove fence from guide tube and turn it over.
50. Adjust each of two setscrews (A, Figure 11) exactly the same number of rotations until the fence is held securely when lock handle is pushed down.

6.11 Checking 90° to Table

1. Place fence on saw table and lock it.
51. Place a square (A, Figure 12) on table next to fence. The fence should be 90° to the table.
52. If adjustment is necessary, unlock fence and turn one of two nylon adjustment screws (B, Figure 12) until fence is 90° to table.
53. Lock fence and check the adjustment again.

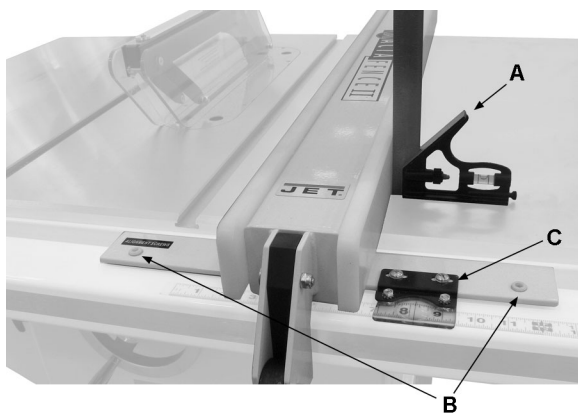


Figure 12

6.12 Cursor Adjustment

1. Disconnect saw from power source.
54. Raise blade above table top.
55. Unlock fence and slide it to approximately four inches from blade.
56. Lock the fence.
57. Measure distance between saw blade and inside of fence.
58. Adjust cursor (C, Figure 12) to read the distance just measured, and tighten cursor assembly to fence.
59. Make a test cut and confirm the adjustment is correct.

Note: If the cursor does not have enough travel to give the correct measurement, loosen guide rail and adjust as needed. If you still do not get the correct measurement, loosen front rail and adjust as needed. If you have to adjust front rail you will need to go through the front rail assembly instructions again.

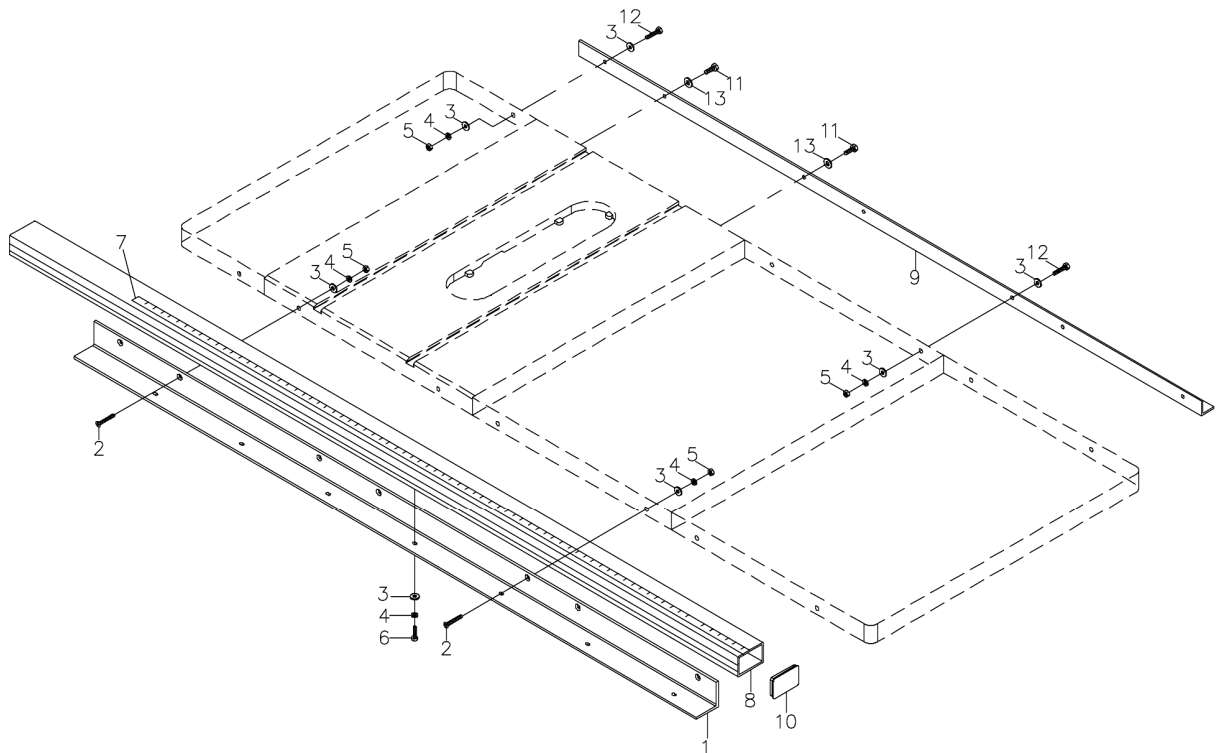
Cursor accuracy should be checked whenever a different blade is installed.

After installing the XACTA Fence, press the black plastic end covers into the openings of the guide rail. There is also an end cover for the fence that may already be installed.

7.0 Replacement Parts

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

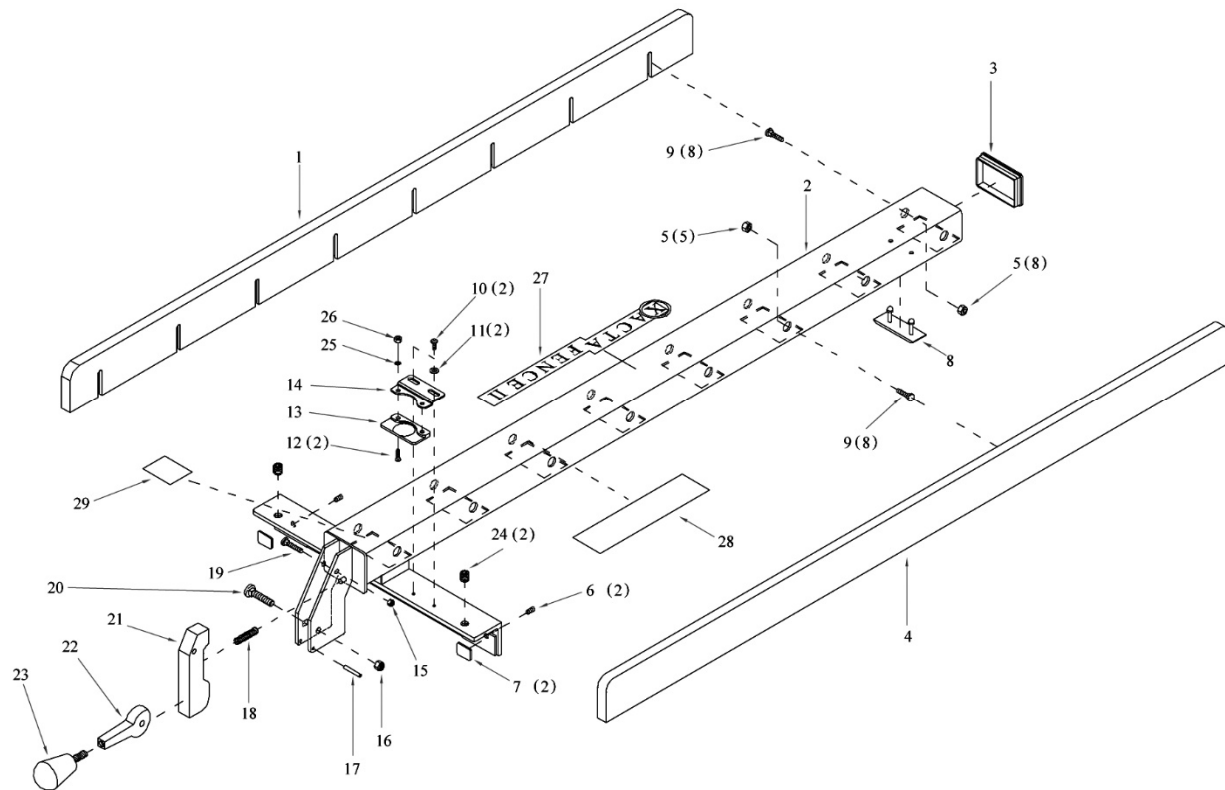
7.1.1 XACTA Fence Rail Assembly – Exploded View



7.1.2 XACTA Fence Rail Assembly – Parts List

Index No	Part No	Description	Size	Qty
.....	708956Z	XACTA Rail Assembly 50" (index # 1-13).....		1
1	XF12DX-201	Front Rail		1
2	TS-081F081	Flat Head Screw	1/4"-20 × 1-1/2"	7
3	TS-0680021	Flat Washer	1/4"	24
4	TS-0720071	Lock Washer	1/4"	19
5	TS-0561011	Hex Nut.....	1/4"-20	12
6	TS-0050031	Hex Cap Screw.....	1/4"-20 × 3/4"	7
7	XF2-207	Scale.....	50"	1
8	XF2-208	Guide Rail.....	50"	1
9	XF12DX-209	Rear Rail.....	50"	1
10	XF2-210	Guide Cover		2
11	TS-0081031	Hex Cap Screw.....	5/16"-18 × 3/4"	2
12	TS-0050071	Hex Cap Screw.....	1/4"-20 × 1-1/2"	5
13	TS-0680031	Flat Washer	5/16"	2
.....	XF12DX-HP	Hardware Package (index # 2-6 and 11-13).....		

7.2.1 XACTA Fence Assembly – Exploded View



7.2.2 XACTA Fence Assembly – Parts List

Index No	Part No	Description	Size	Qty
.....	708955Z	XACTA Commercial Fence 40" (index # 1-29)		1
1	XF12DX-101N	Left Side Plate		1
2	XF12DX-102	Fence Body Assembly		1
3	XF2-103	Tube Cover		1
4	XF12DX-104N	Right Side Plate		1
5	TS-0640071	Lock Nut	1/4" × 20	16
6	TS-0271031	Socket Set Screw	3/8"-16 × 3/8"	2
7	3575081	Fluoroway Pad		2
8	XF-8A	Pad		1
9	XF2-9	T-Square Bolt	1/4"-20 × 3/4"	16
10	TS-081D022	Pan Head Machine Screw	10-32 × 3/8"	2
11	TS-0680021	Flat Washer	1/4"	2
12	TS-081D021	Flat Head Machine Screw	10-32 × 3/8"	2
13	800708950D	Cursor		1
14	800708950C	Cursor Bracket		1
15	TS-0640071	Lock Nut	1/4" × 20	1
16	TS-0640081	Lock Nut	5/16"-18	1
17	XF2-117	Spring Pin	4 × 28mm	1
18	6813042	Compression Spring		1
19	TS-0151041	Carriage Bolt	1/4"-20 × 1-1/2"	1
20	TS-0152031	Carriage Bolt	5/16"-18 × 1-1/2"	1
21	3215301	Foot Cam		1
22	3076232	Lock Cam		1
23	6430055	Knob w/stud		1
24	XF-5	Nylon Adjustment Screw	1/2" × W12	2
25	TS-0680021	Flat Washer	1/4"	2
26	TS-0560081	Hex Nut	10-32	2
27	XF-27	XACTA Fence II Label		1
29	XF-29	JET Label		1