

AXMINSTER
PROProfessional

AP3352B

Woodworking Bandsaw



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EU DECLARATION OF CONFORMITY

Cert No: HW615E Axminster Tool Centre Ltd Axminster Devon EX13 5PH UK axminstertools.com declares that the machinery described:- <table border="1"> <tr> <td>Type</td> <td>Bandsaw</td> </tr> <tr> <td>Model</td> <td>AP3352B</td> </tr> </table> Signed  Andrew Parkhouse Operations Director Date: 18/11/2019	Type	Bandsaw	Model	AP3352B	EU Declaration of Conformity This machine complies with the following directives: <table border="0"> <tr> <td>2006/42/EC</td> <td>EN 1807-1:2013</td> </tr> <tr> <td>EN 60204-1:2018</td> <td>EN 60204 -1:2006+A1+AC</td> </tr> <tr> <td>EN 1807-1:2013</td> <td></td> </tr> <tr> <td>06/42/EC - Annex I/05.2006</td> <td></td> </tr> </table> conforms to the machinery example for which the EC Type-Examination Certificate No BM 50273249 001, BM 50451848 has been issued by Harvey Industries Co., Ltd. at: 01 Building, No.68 Suyuan Road, Jiangning Economic & Technological Development Zone, Nanjing 211100 China (Mainland) and complies with the relevant essential health and safety requirements.	2006/42/EC	EN 1807-1:2013	EN 60204-1:2018	EN 60204 -1:2006+A1+AC	EN 1807-1:2013		06/42/EC - Annex I/05.2006	
Type	Bandsaw												
Model	AP3352B												
2006/42/EC	EN 1807-1:2013												
EN 60204-1:2018	EN 60204 -1:2006+A1+AC												
EN 1807-1:2013													
06/42/EC - Annex I/05.2006													

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



Fully read manual
and safety instructions
before use



Ear protection
should be worn



Eye protection
should be worn



Dust mask
should be worn



Two Man Assembly

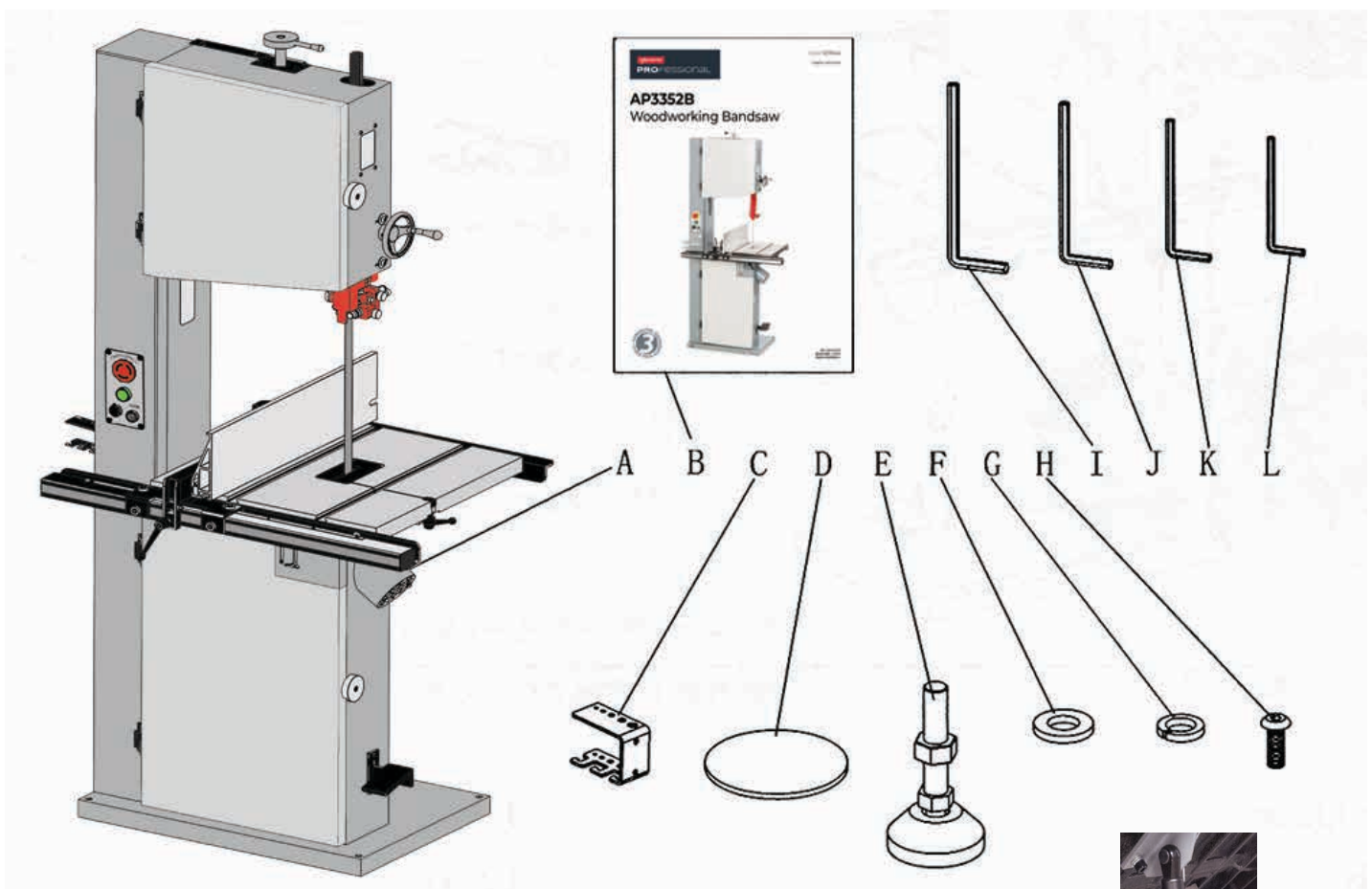


HAZARD

WHAT'S INCLUDED

Quantity	Item	Part	Model Number
			AP3352B
1	Bandsaw	A	
1	Instruction Manual	B	
1	Tool Storage Bracket	C	
1	Dust Extraction Cover	D	
4	Floor Mounting Feet 12x60	E	
2	Flat Washers	F	
2	Spring Washers	G	
2	Cap Screw 5x12	H	
1	Hex Key 5mm	I	
1	Hex Key 4mm	J	
1	Hex Key 3mm	K	
1	Hex Key 2mm	L	
1	Gas Strut with x2 Pins & Split Pins	M	
2	Gas Strut Brackets with Hex Screws, Washers/ Spring Washers	N	

Please Note: Before discarding any packaging material check to make sure all terms are accounted for.



Supplied with an 230V 3 pin 16 Amp plug



GENERAL INSTRUCTIONS FOR 230V MACHINES

The following will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.



WARNING!! KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN



KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.

Mains Powered Tools

- Tools are supplied with an attached 16 Amp plug.
- Inspect the cable and plug to ensure that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.
- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.

- Carry out a final check e.g. check the cutting tool is securely tightened in the machine and the correct speed and function set.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check cutters are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

SPECIFICATION

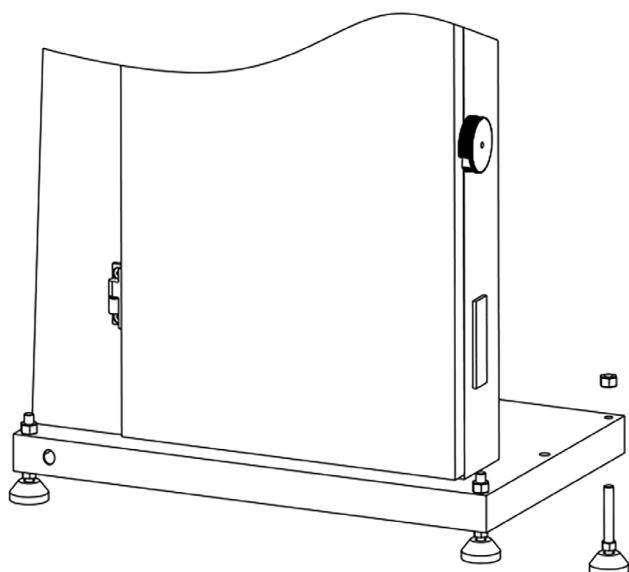
Code	107644
Model	AP3352B
Rating	Professional
Power	2.2kW 230V 1ph
Plug	3 pin 16 Amp
Blade Speed	950 m/min
Blade Length	3,352 mm (132")
Max Width of Cut	360 mm
Max Depth of Cut	350 mm
Max Width of Cut with Fence	315 mm
Airflow Required	1,200 m ³ /hr
Table Size	510 x 510 mm
Table Tilt	+15° to -45°
Table Height	870 mm
Wheel Diameter	380 mm
Noise Level	75dB (A)
Dust Extraction Outlet	2 x 100 mm
Overall L x W x H	750 x 495 x 1,720 mm
Weight	202 kg

Floor Mounting Feet

Remove the shipping pallet and place aside. Locate the four mounting feet (E) and with help mount them to each corner of the bandsaws base, see fig 01.

Manoeuvre the bandsaw to the required position with plenty of space around the unit. Adjust each foot in turn until the bandsaw is level.

Fig 01



Cast Iron Table

Remove the two clamping handles (A) from the underside of the table. Lower the table down so the steel threaded slot through the two holes on either side of the tilt quadrant and the trunnion (B) rests in the quadrants cradial. Replace the two clamping knobs (A) to secure the assembly, see fig 02.

Fig 02

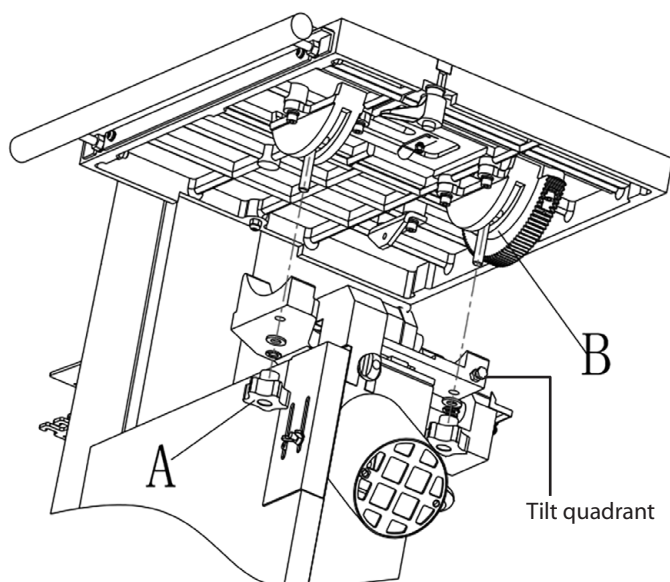
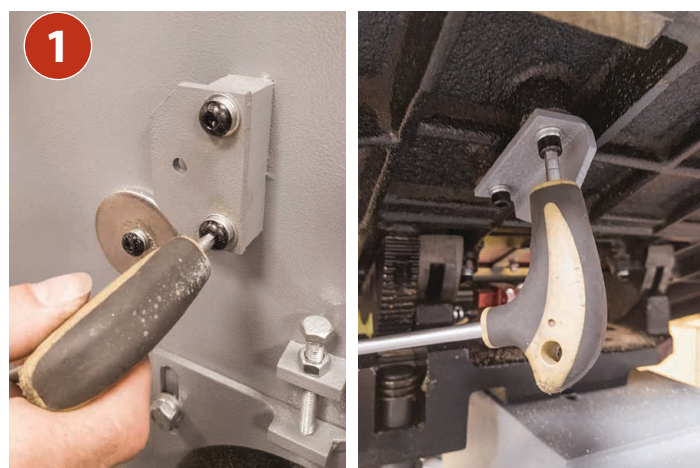
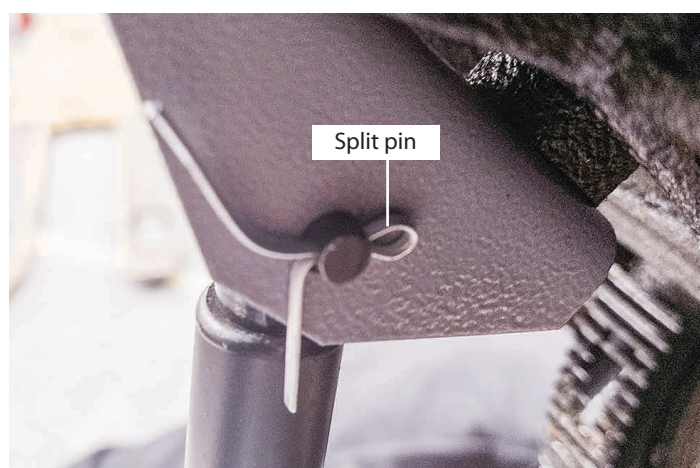
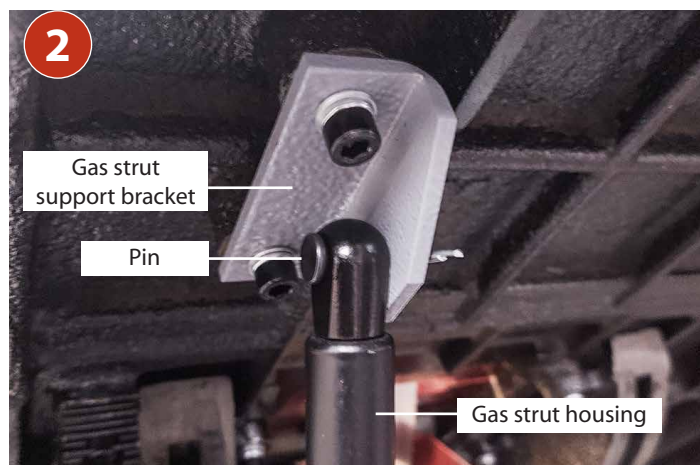


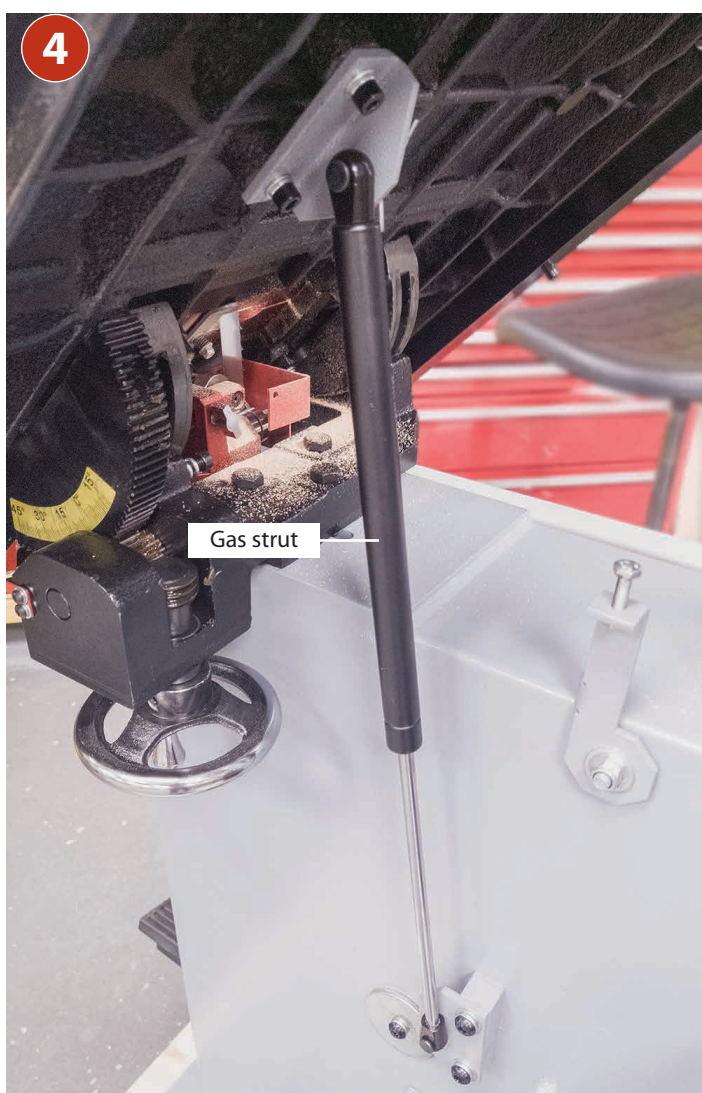
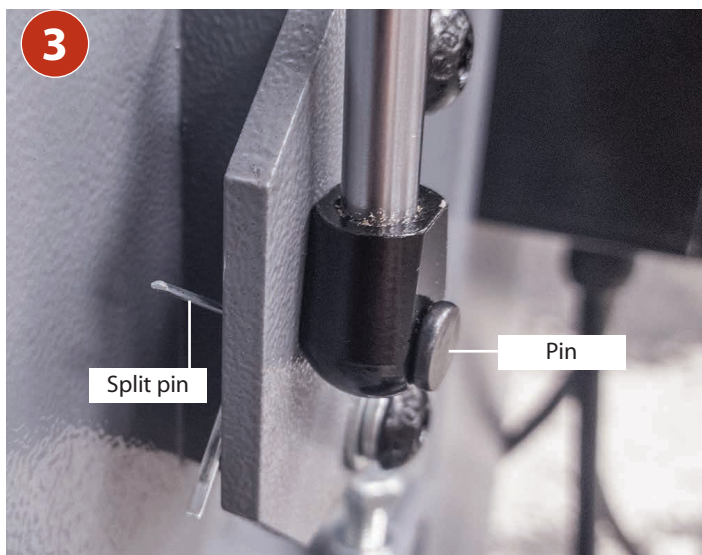
Table Support Gas Strut



1. Locate the two gas strut brackets, secure the first bracket using two Hex screws, washers/spring washers to the underside of the table. Repeat for the remaining bracket to the rear of the bandsaw, see picture 1.



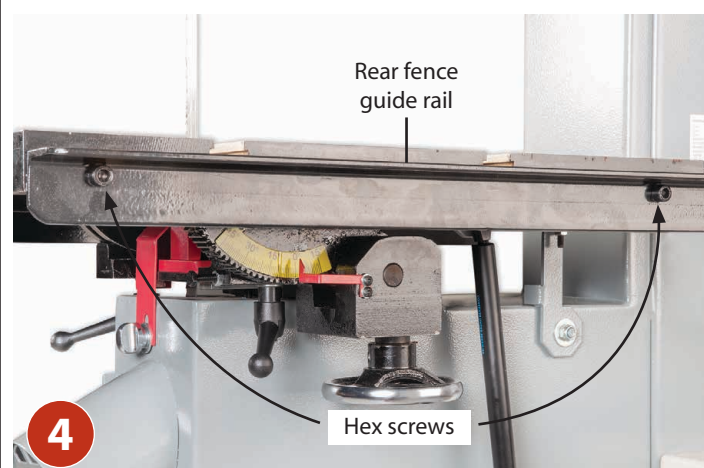
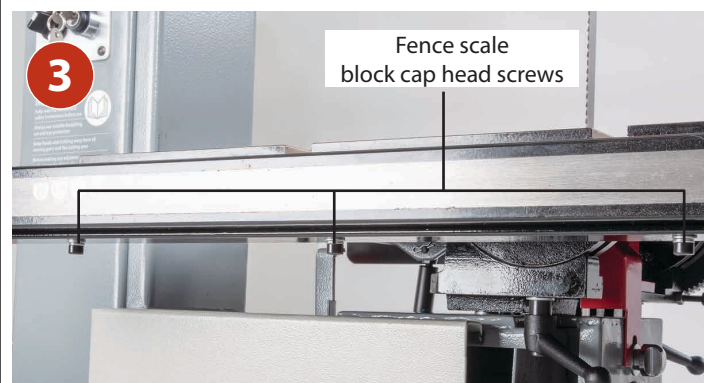
2. Locate the gas strut, the two pins and split pins. Lineup the mounting hole in the gas strut housing with the pre-drilled hole in the bracket, insert the pin through. Slot the split pin through the pin's hole and bend the split pin back to secure the strut in place, see picture 2. Repeat the process for the lower end of the gas strut, see picture 3 on page 6.

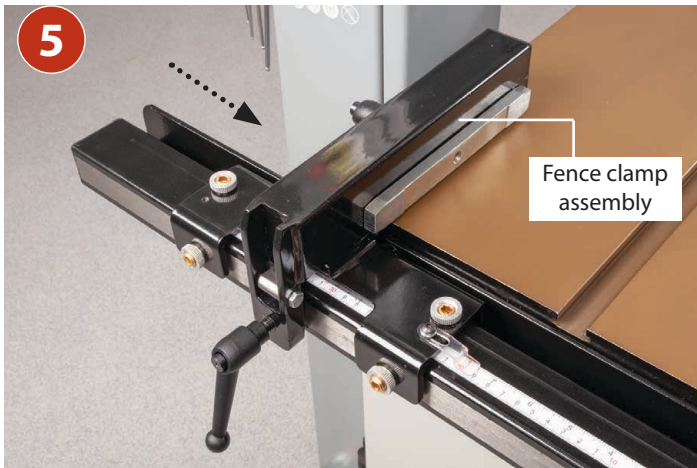


3. Table gas strut installed.

Rip-Fence Assembly

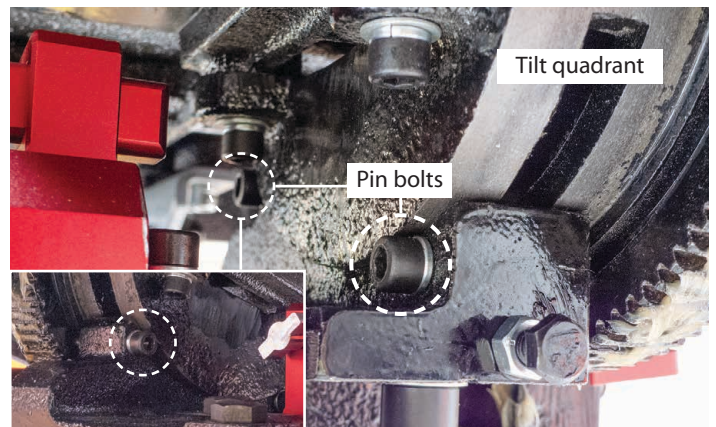
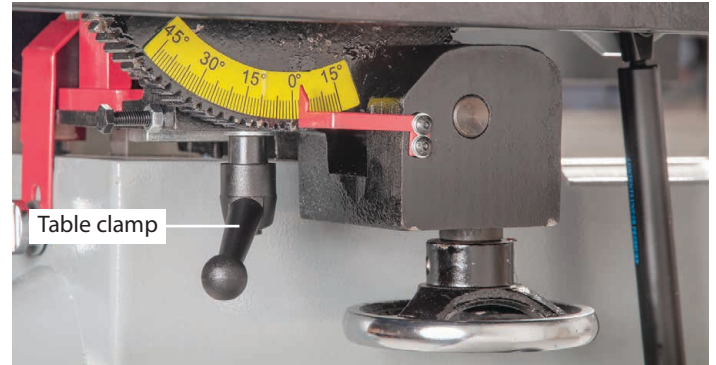
Follow the instructions below to assemble the fence.





Tilt Quadrant Slack Pin Bolts

Lower the table down and nip-up the two clamping handles to secure it in place. Using a Hex key, screw in the two caphead pin bolts into the tilt quadrant mechanism until there is no side play movement in the table, see the images below.



Tool Storage Bracket



Fit the tool storage bracket to the side of the bandsaw, below the NVR switch assembly.

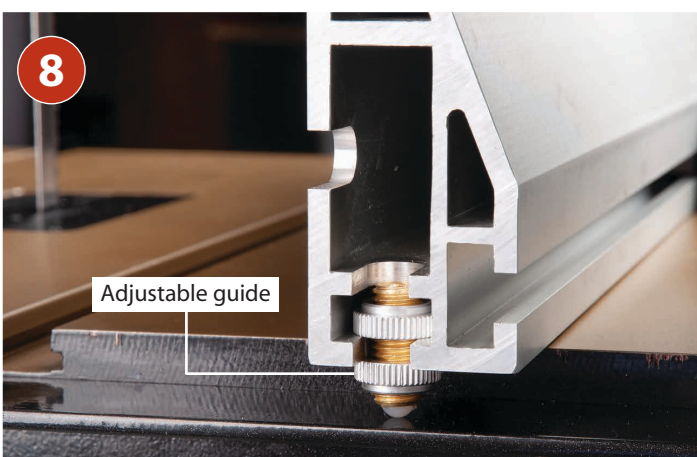
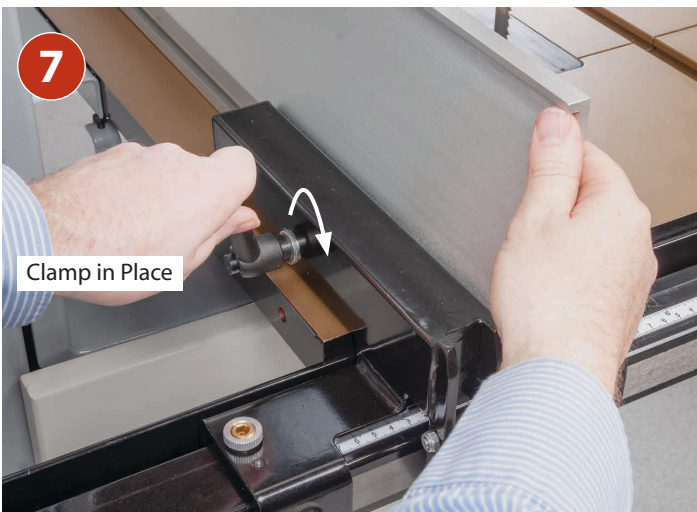
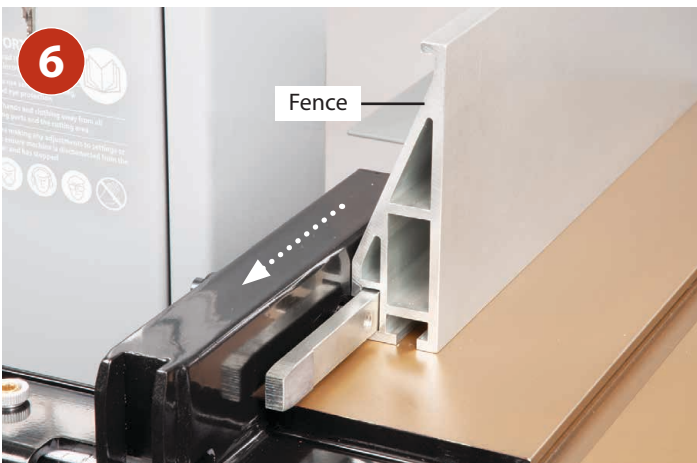
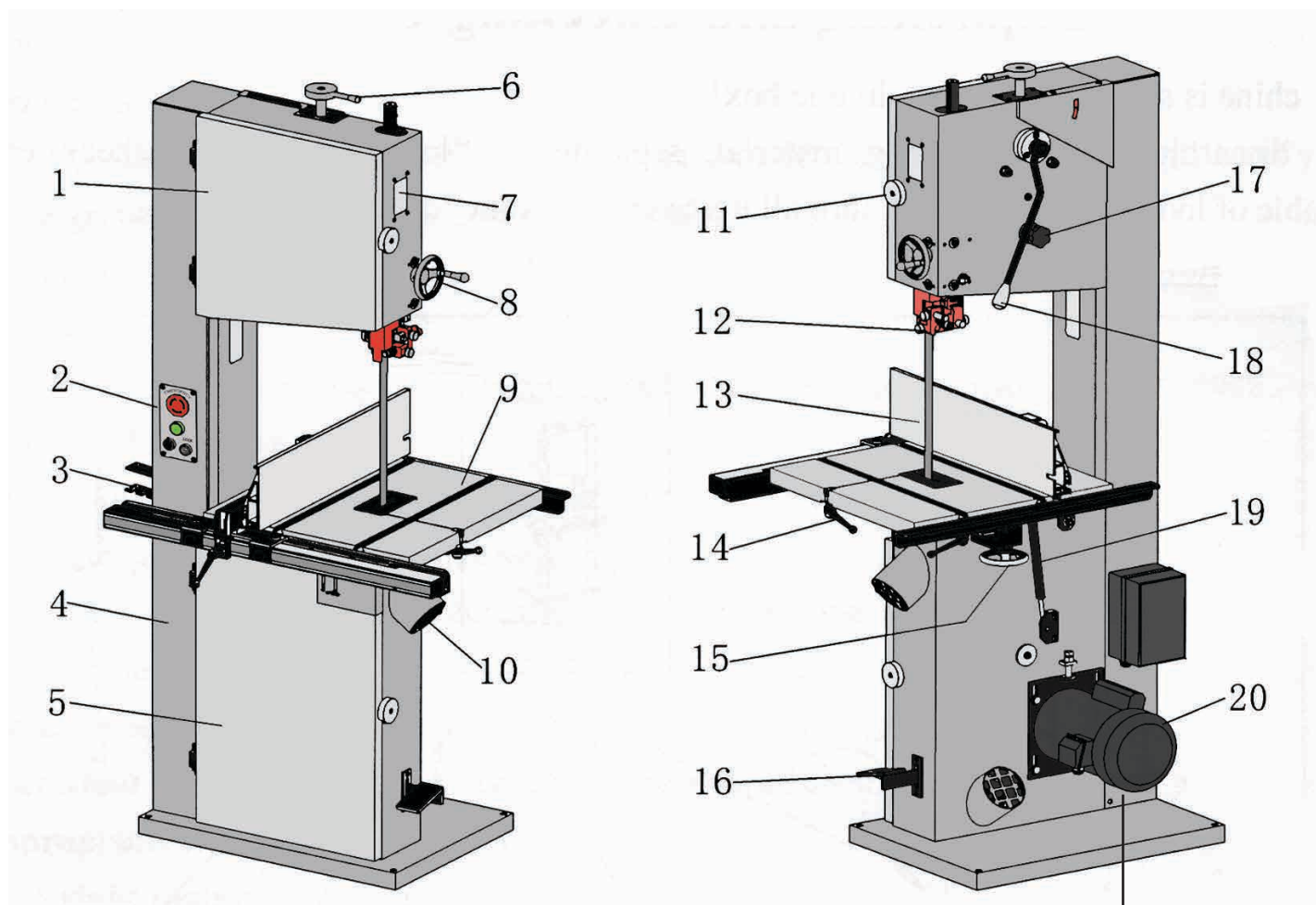


ILLUSTRATION & PARTS DESCRIPTION

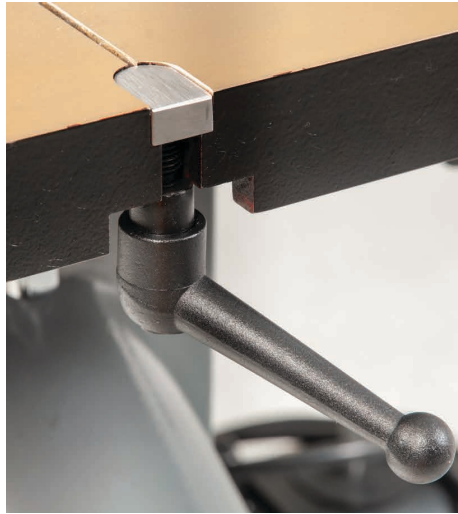
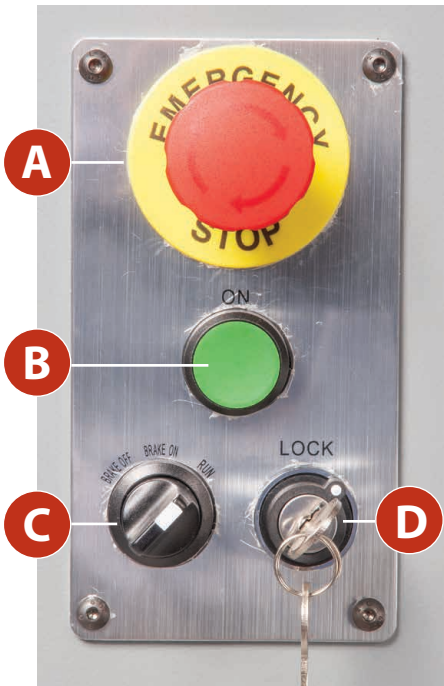


1	Upper Wheel Door
2	NVR Switch with isolating Key Lock
3	Tool Storage Bracket
4	Main Frame
5	Lower Wheel Door
6	Blade Tensioning Lever
7	Blade Tracking Window
8	Upper Blade Guide adjusting Wheel
9	Saw Table
10	Dust Extraction Outlet
11	Upper Door Lock Knob
12	Upper Blade Guide
13	Rip Fence Assembly
14	Table Alignment Handle
15	Table Tilt Operating Wheel
16	Corner Peddle Foot Brake Stop
17	Tracking Control Knob with Locking Wheel
18	Quick Release Tensioning Lever
19	Table Support Gas Strut
20	Motor with Electric Brake and Manual Operating Lever

Manual motor brake lever



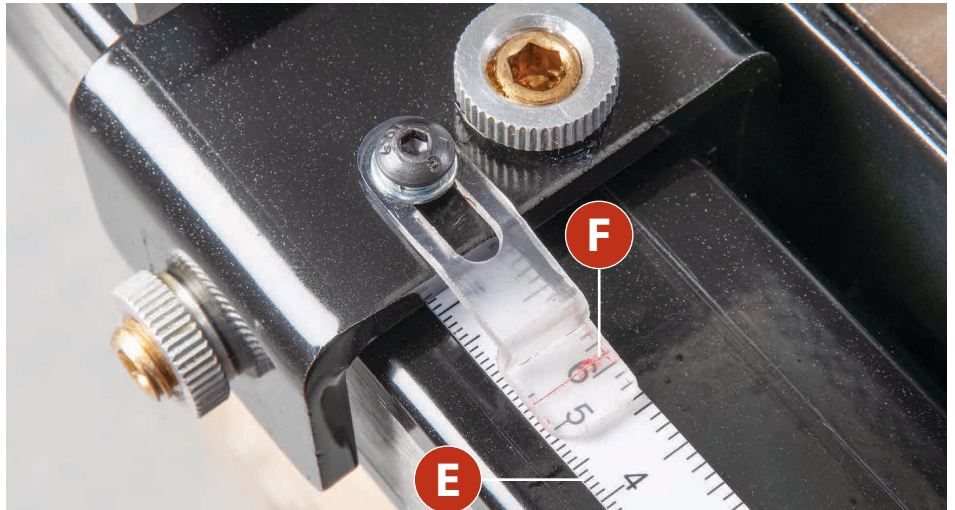
The electric motor brake is used to decelerate or hold motor loads when the power is cut intentionally or accidentally. **DO NOT REMOVE THE BRAKE LEVER!**



Dust extraction outlet



Emergency stop (A),
'ON' button (B), Selector switch (C),
Power isolating key lock (D)



Fence scale (E) and pointer (F)



To disengage the electric motor brake manually, pull the lever back towards you

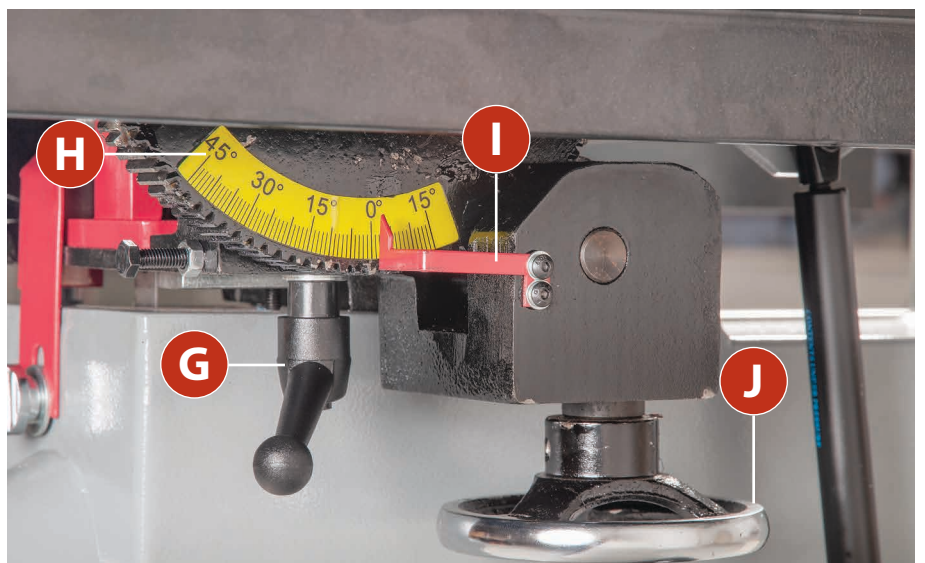
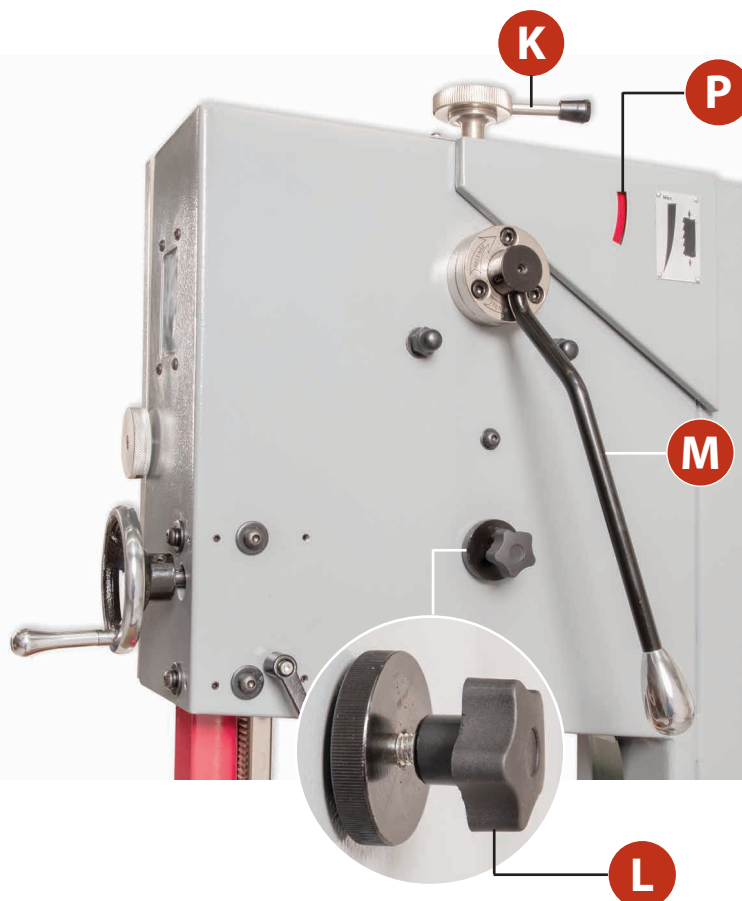
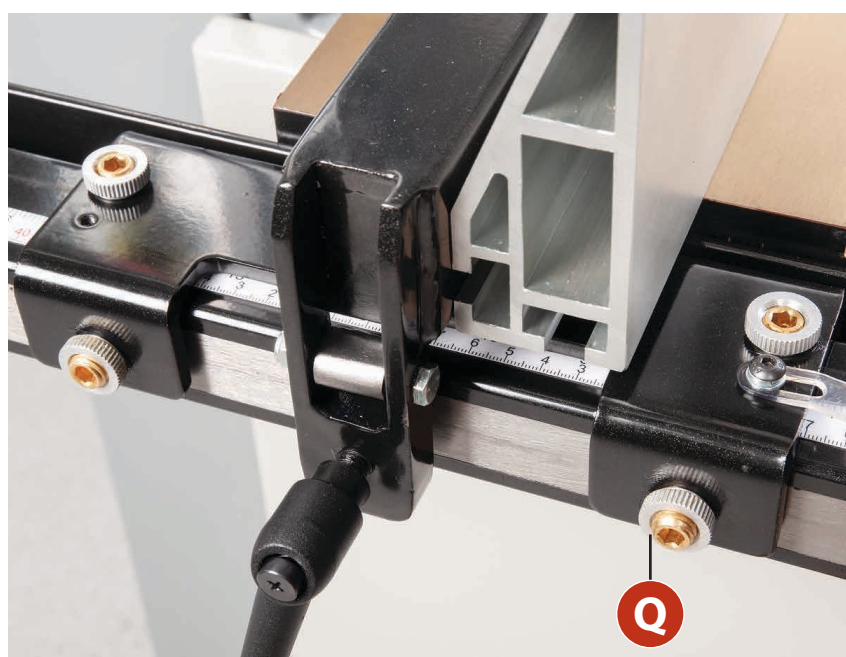
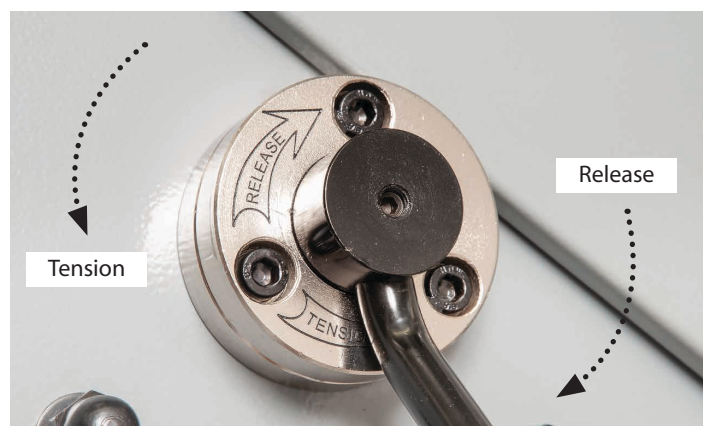
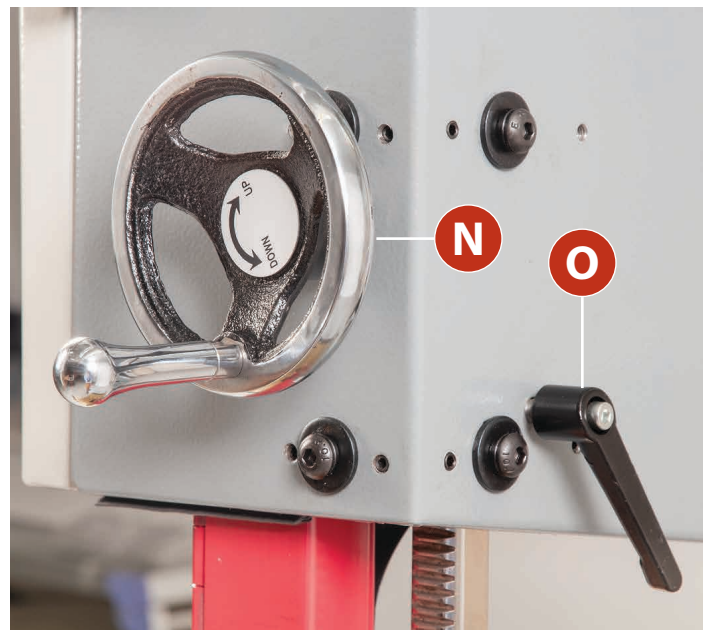


Table clamping handle (G), Table tilt scale (H),
Scale pointer (I), Table tilt operating wheel (J)

ILLUSTRATION & PARTS DESCRIPTION



Blade tensioning lever (K)
Tracking knob & locking wheel (L)
Quick release tensioning lever (M),
Upper guide adjusting wheel (N)
Upper guide locking handle (O)
Blade tension scale (P)

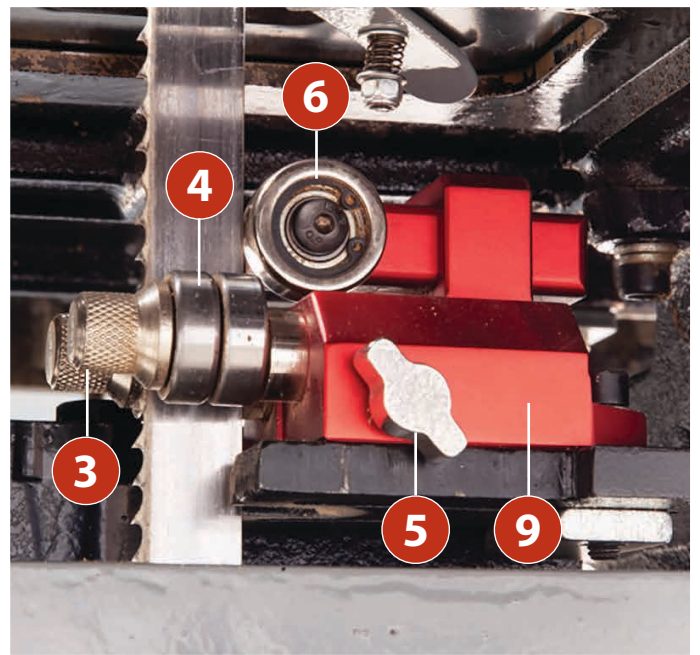
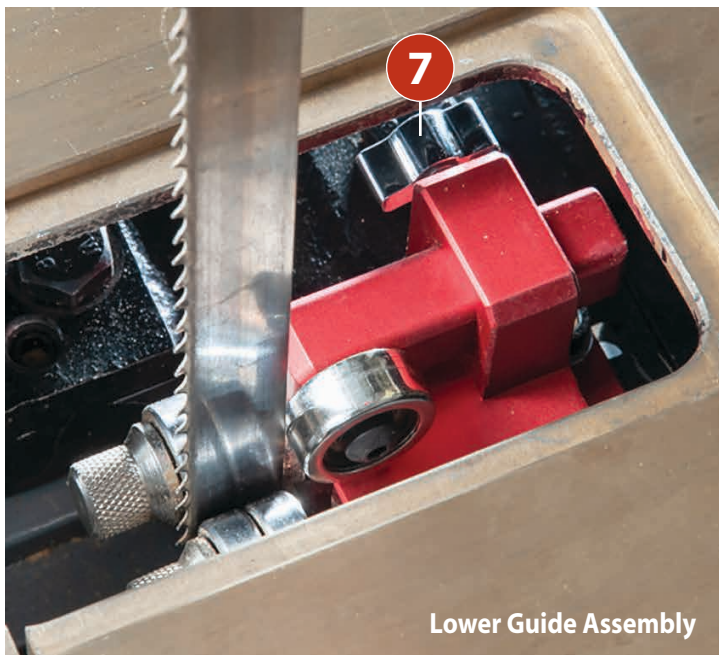
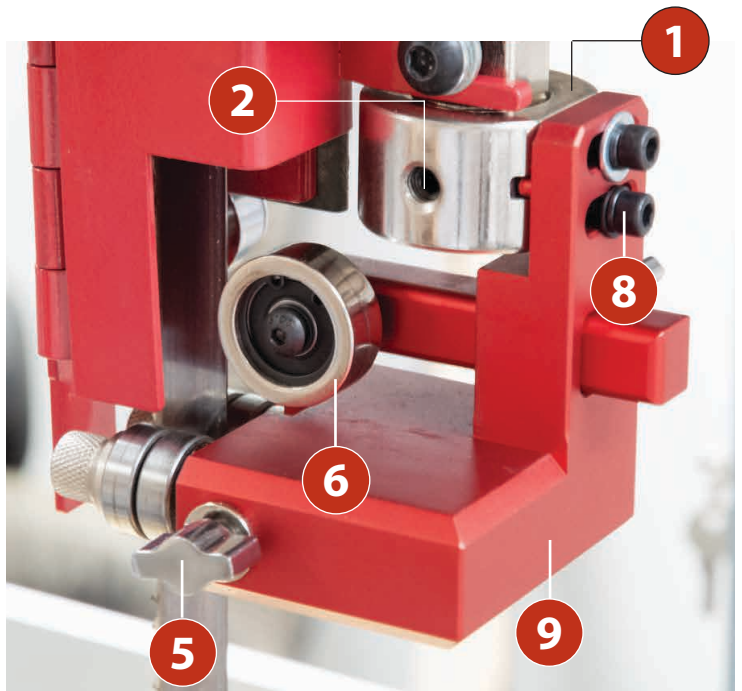


Four fence alignment Hex screws (Q) adjust each Hex screw until the fence is perpendicular with the blade and the table



Corner peddle foot brake stop
Press down to stop the bandsaw instantly

ILLUSTRATION & PARTS DESCRIPTION



	Blade Guide Description
1	Guide Holder
2	Guide Holder Cap head screw
3	Guide Bearing Adjusting knob
4	Guide Bearings
5	Guide Bearing Clamping knob
6	Thrust Bearing
7	Thrust Bearing Clamping Knob
8	Guide Assembly Cap head Screws
9	Guide Assembly



MOVE THE LOCK SWITCH (D) TO THE POWER ON POSITION, MOVE THE OTHER SWITCH TO THE 'BRAKE OFF' POSITION & PRESS THE GREEN BUTTON, SEE PAGE 9.

Tensioning and Tracking the Blade

Make sure both top and bottom blade guides are clear of the blade

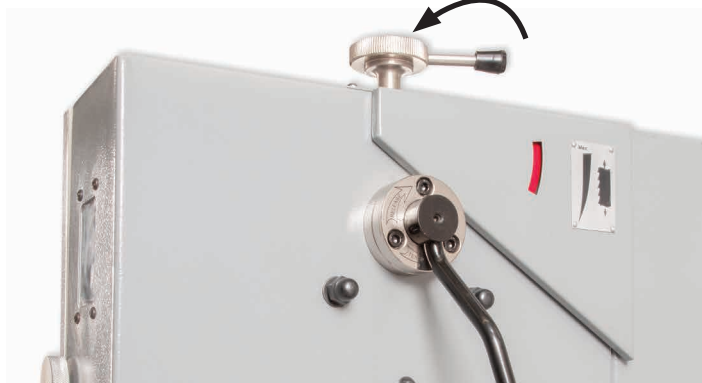
Open the upper and lower wheel doors, giving good access to the saw wheels. To tracking the blade first adjust all guide bearings so they are clear of the blade, see fig 03.

Fig 03



Check that the blade is sitting approximately in the middle of the wheel. Apply some tension to the blade by turning the tensioning wheel clockwise, see fig 04-05 spin the top wheel by hand and check that the blade remains centrally on the tyre.

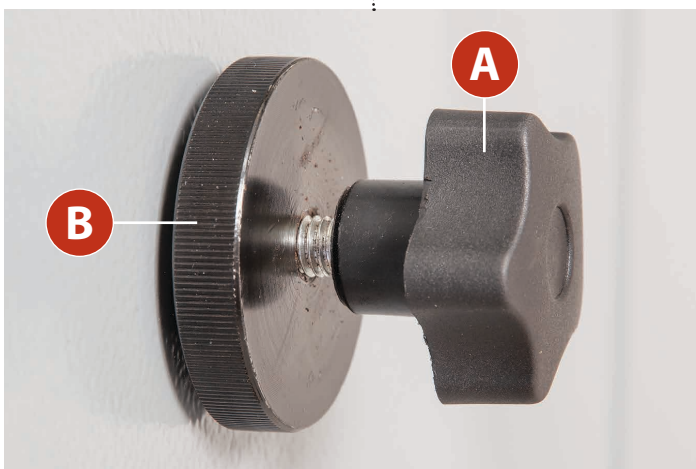
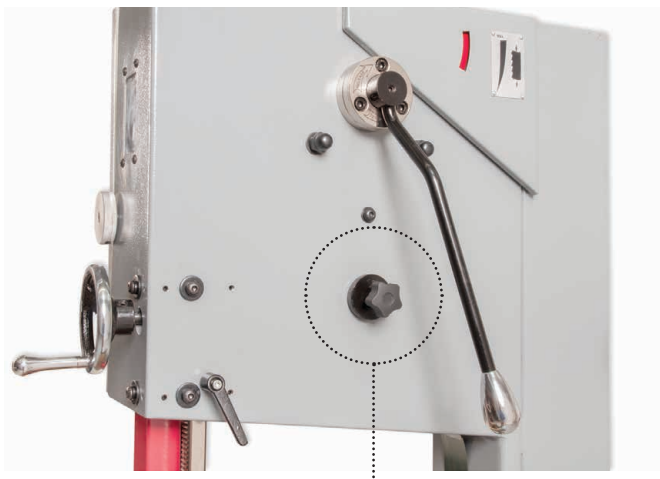
Fig 04



If it does not, adjust the tracking by turning the tracking control at the rear of the head box, see fig 05. Viewed directly onto the tracking control wheel, turning clockwise should cause the blade to track to the rear of the tyre; anti-clockwise to the front, (DO NOT make large adjustments). Spin the top wheel again. Continue until the blade tracks in the centre of the tyres with no appreciable to and fro movement.

Tighten the tracking control knob to lock the setting. Tension the blade fully. A sideways push of about 7-8 lbs (3+kgs) in the middle of the blade should allow a 1/4" (6.5mm) distension. Check the tracking again, adjust if necessary.

Fig 04-05



Tracking control knob (A) and locking wheel (B)

Check that the drive belt is tensioned correctly. If it is slack, apply 'take up' pressure to the belt by loosening the motor locking bolts (C) and turn the tensioning bolt (D) to press down the motor until the belt is under tension then re-tighten the bolts (C) to lock the motor in position, see fig 06.

Fig 06



Fig 07



Close the upper/lower doors, move the selector switch to the 'RUN' position and turn the 'LOCK' key to the power on position see fig 07. Stand clear and start the saw by pressing the 'GREEN' button. Check the saw is running smoothly, (no thumps, bumps, knocking or excessive vibration) and the blade appears to be tracking correctly (in one place). You can check this by holding a marker, e.g. a pencil, close to the back of the blade (approach from the back of the blade only) and check that the gap remains constant.

If further tracking is required, make very small adjustments and wait for the saw to react before you adjust again. Sometimes the reaction is not instantaneous. Once you are satisfied that the tracking is correct, switch the machine off by pressing 'RED' emergency off button. Allow it to come to a complete stop.



TURN THE KEY TO THE 'LOCK' POSITION TO ISOLATE THE POWER TO THE BANDSAW!

Checking the Table is Square

1. Loosen the two clamping handles beneath the table, clamping the tilt mechanism. Lower the table until its against the stop, see fig 07-08. The head of the bolt acts as a stop when it strikes the machine frame. Tighten the clamping knobs.

Fig 07

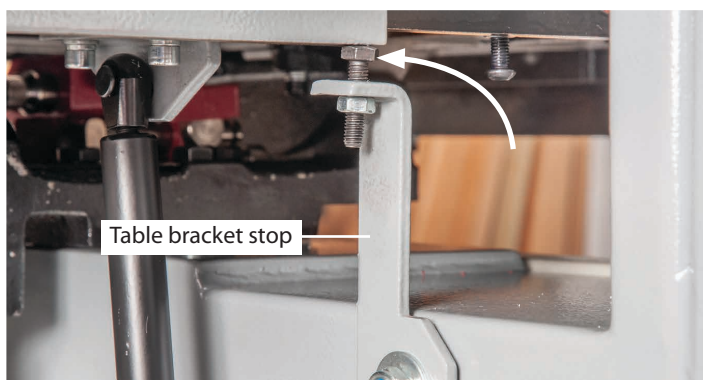
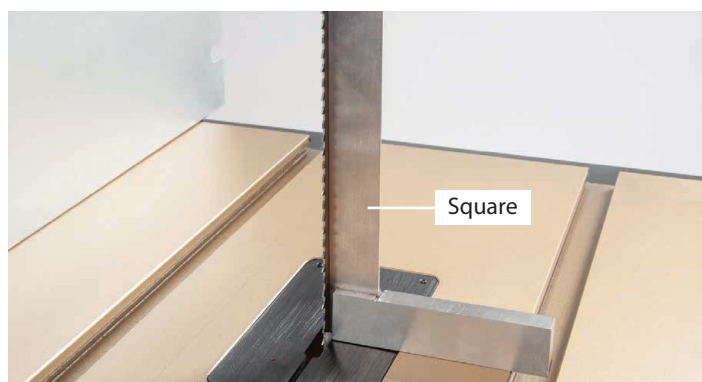
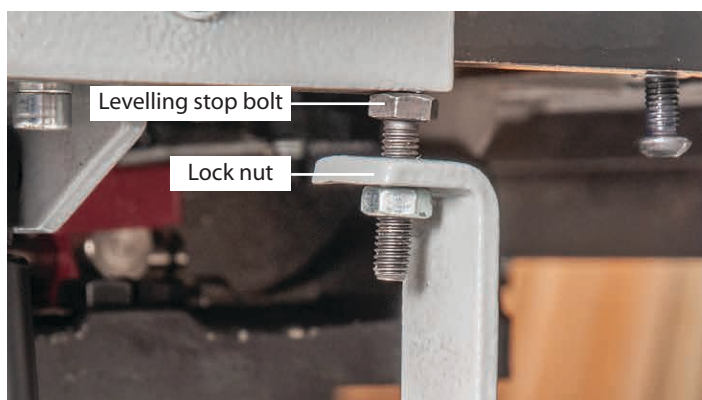


Fig 09

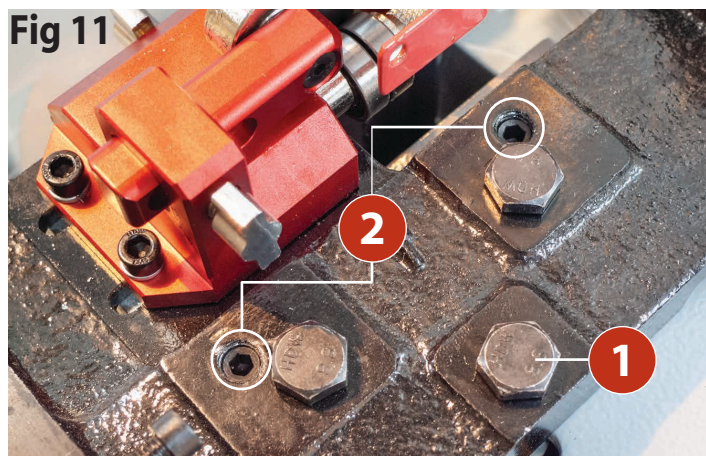


2. Make sure the upper blade guide is raised as high as possible. Place a square on the table and move it up against the blade (behind the teeth), see fig 09. Check that the blade is perpendicular to the table. If it is not, try resetting the table. If it is still not correct, loosen the table locking handles and adjust the table stop bolt until this is achieved, see fig 10. Tighten the lock nut and then re-check.

Fig 10

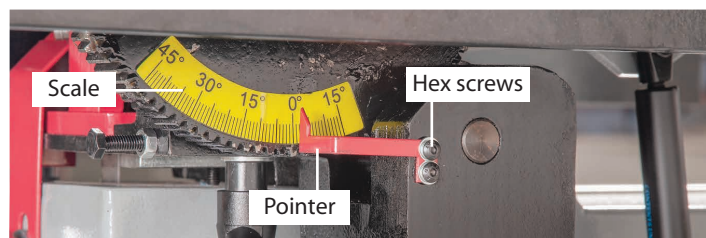


3. The tilt quadrant can also be adjusted by loosening the three bolts (1) on the tilt quadrant housing, see fig 11 on page 14. Using a Hex key adjust the two grub screws (2) to tilt the quadrant forward or back. NOTE: Make small adjustments and lower the table back down, place a square against the blade and check again. Continue until the blade is perpendicular to the table. Nip-up the three bolts (1) to secure the quadrant in place.



When you are satisfied that the table is set correctly, check that the pointer of the tilt scale reads zero, see fig 12.

Fig 12

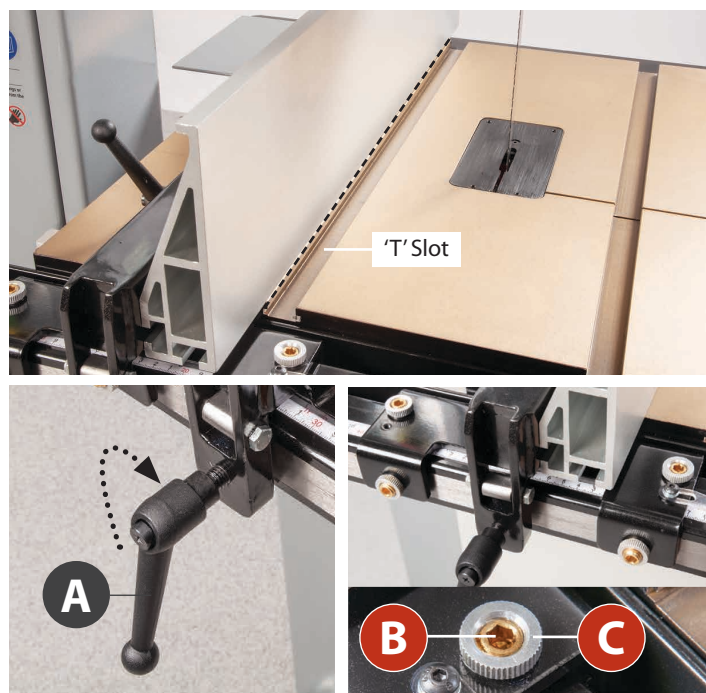


Setting the Fence

To make sure the guide fence is at 90° to the table, line up the guide fence with the edge of the table's 'T' slot, see fig 13. If you find that the fence is out of alignment follow the step below.

1. Secure the fence with the locking handle (A).
2. Loosen the four Hex screws (B) on the fence camp assembly and adjust until correct. Tighten the locking rings (C) to secure the setting, see fig 14.

Fig 13-14



MOVE THE SELECTOR SWITCH TO 'BRAKE OFF' POSITION

Upper Blade Guides

Open the blade guide access door (1). Loosen the locking knobs (2), adjust the fore and aft position of the guide bearings so they are approximately 2mm behind the gullets of the saw blade, see fig 15-16-17. Tighten the knobs (2).

Fig 15-16-17

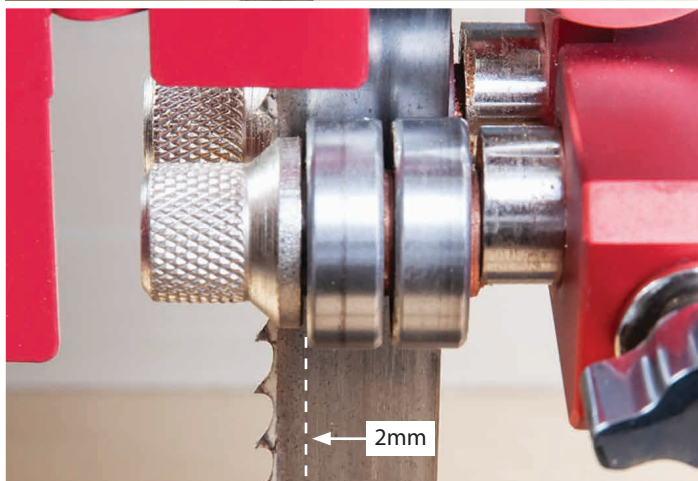
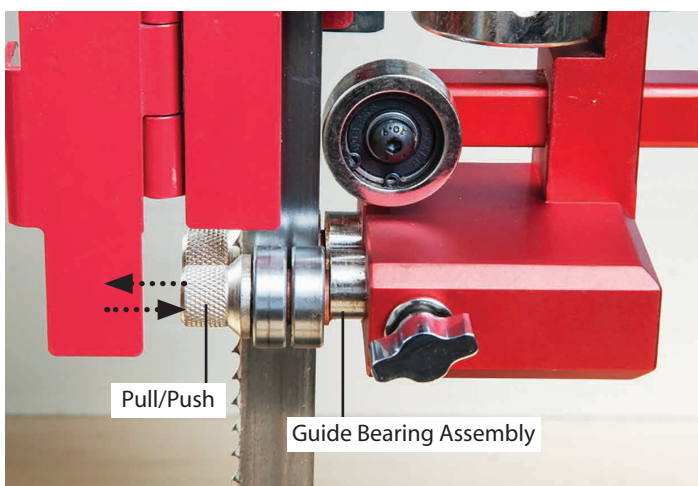
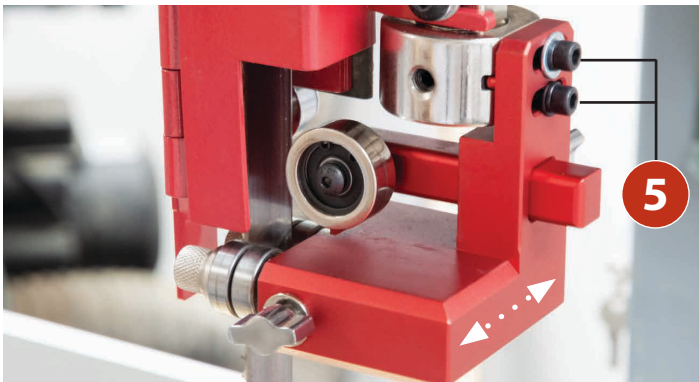
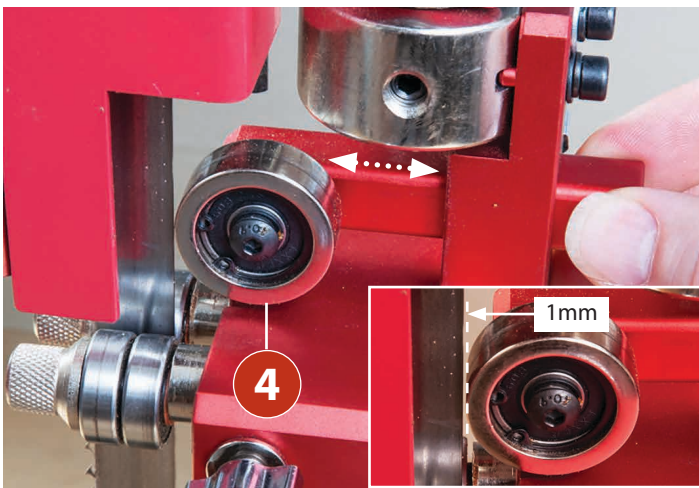
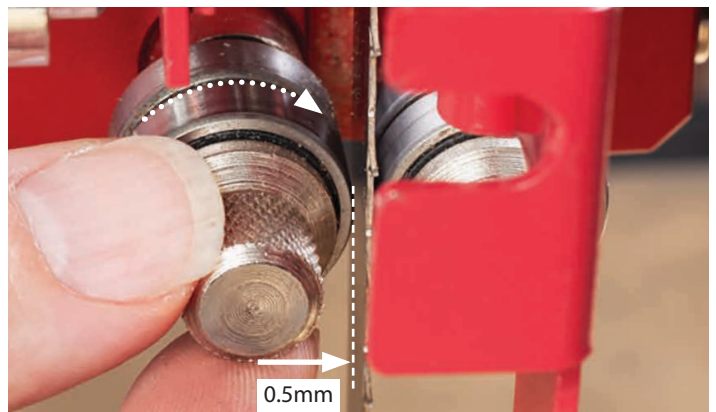
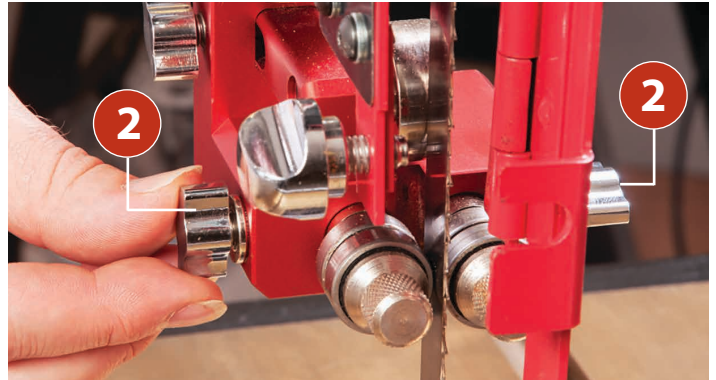


Fig 18-19-20-21



Loosen the locking knob (3), position the thrust bearing (4) 1mm behind the blade. Note: loosen the two cap head screws (5) to the rear of the guide assembly and adjust, so the thrust bearing is centred with the back of the blade, see fig see fig 18-19-20-21. Tighten the knob (3) to secure the setting.

Fig 22-23



Loosen the clamping knobs (2) and adjust the guide bearings so they are approximately 0.5mm to the blade, see fig 22-23.

NOTE: A sheet of A4 of photocopy paper is approximately 0.5mm thick. Re-tighten knobs (2). Close the blade guide access door (1).

Lower Blade Guides

Remove the table insert, see fig 24-25.

Fig 24-25

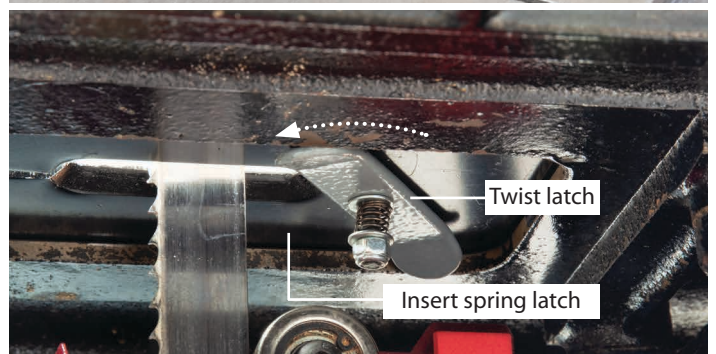
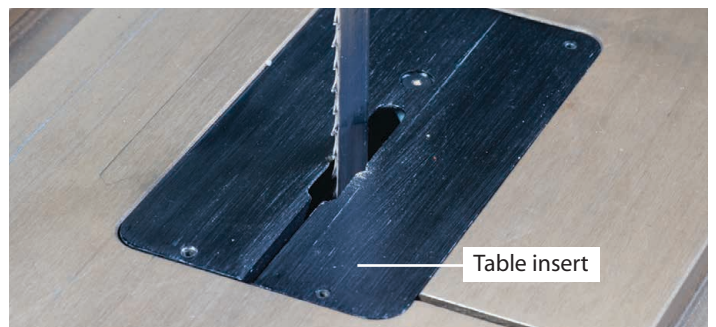
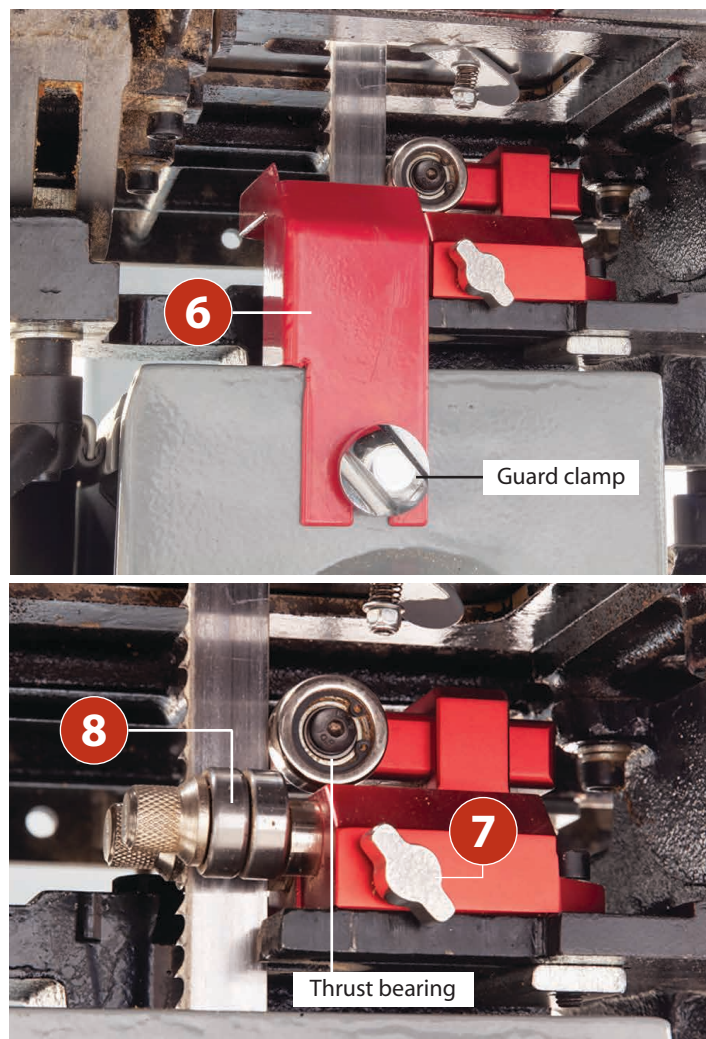


Fig 26-27-28-29



Remove the lower blade guard (6). Loosen the clamping knob (7) and adjust the lower guide bearings (8), so they are 2mm behind the gullets of the saw. Check the thrust bearing is centred with the back of the blade. If not, loosen the two Hex screws (10) to the rear of the assembly & carefully move the unit until centred. Tighten the Hex screws (10).



Adjust the guide bearings with a clearance of 0.5mm between the blade and nip-up the the clamping knobs (7). Next loosen the thrust bearing clamping knob (9) and manoeuvre, so there's a 1mm clearance behind the blade. Secure the clamping knob (9). Replace the lower blade guard (6) and table insert, see fig 26-27-28-29.

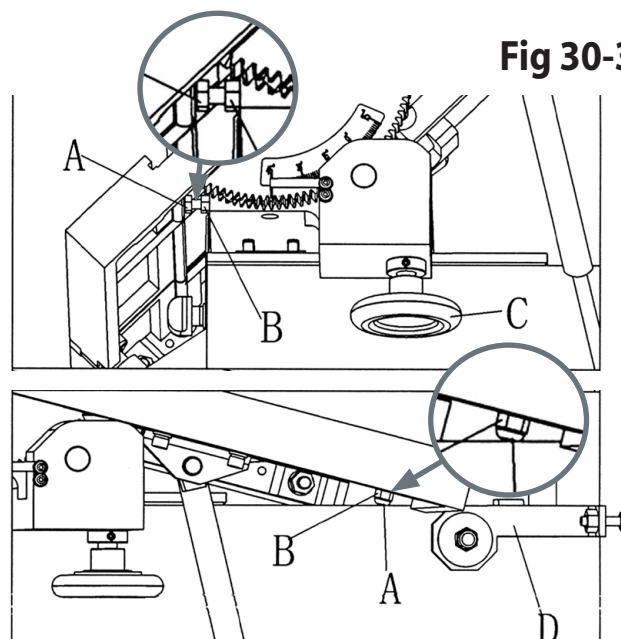
Table Positioning Stops

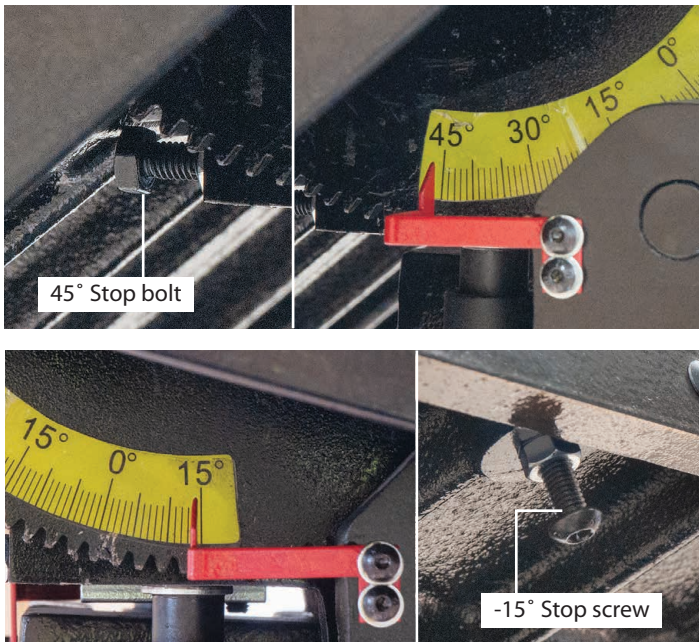
Beneath the table there are two positioning stop to accurately set the table at 45° or -15° degrees.

1. Rotate the table at 45° with the hand wheel (C). Adjust bolt (A) until the bolt rests against the table casting and lock in place with the nut (B), see fig 30.

2. Lower the 90° table stop bracket (D). Rotate the table to -15 degrees on the scale and adjust stop screw (A) so it rests against the saw frame and tighten the nut (B), see fig 31.

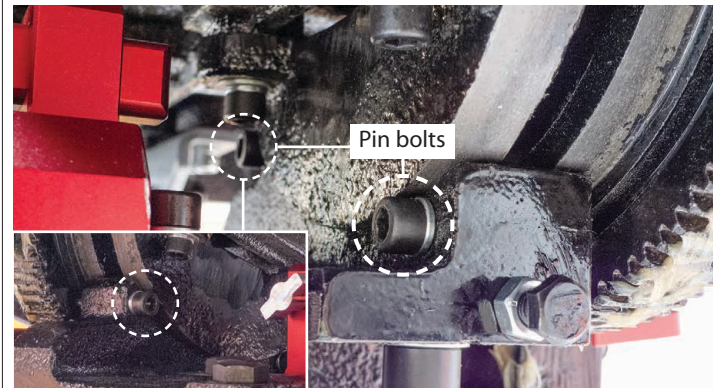
Fig 30-31





Tilt Quadrant Slack Pin Bolts

Lower the table down and lock in place. There are two caphead pins bolt, forward and aft on the tilt quadrant mechanism. Adjust each bolt clockwise to take up the slack this will remove any side play movement from the table, see image below.



OPERATING INSTRUCTIONS

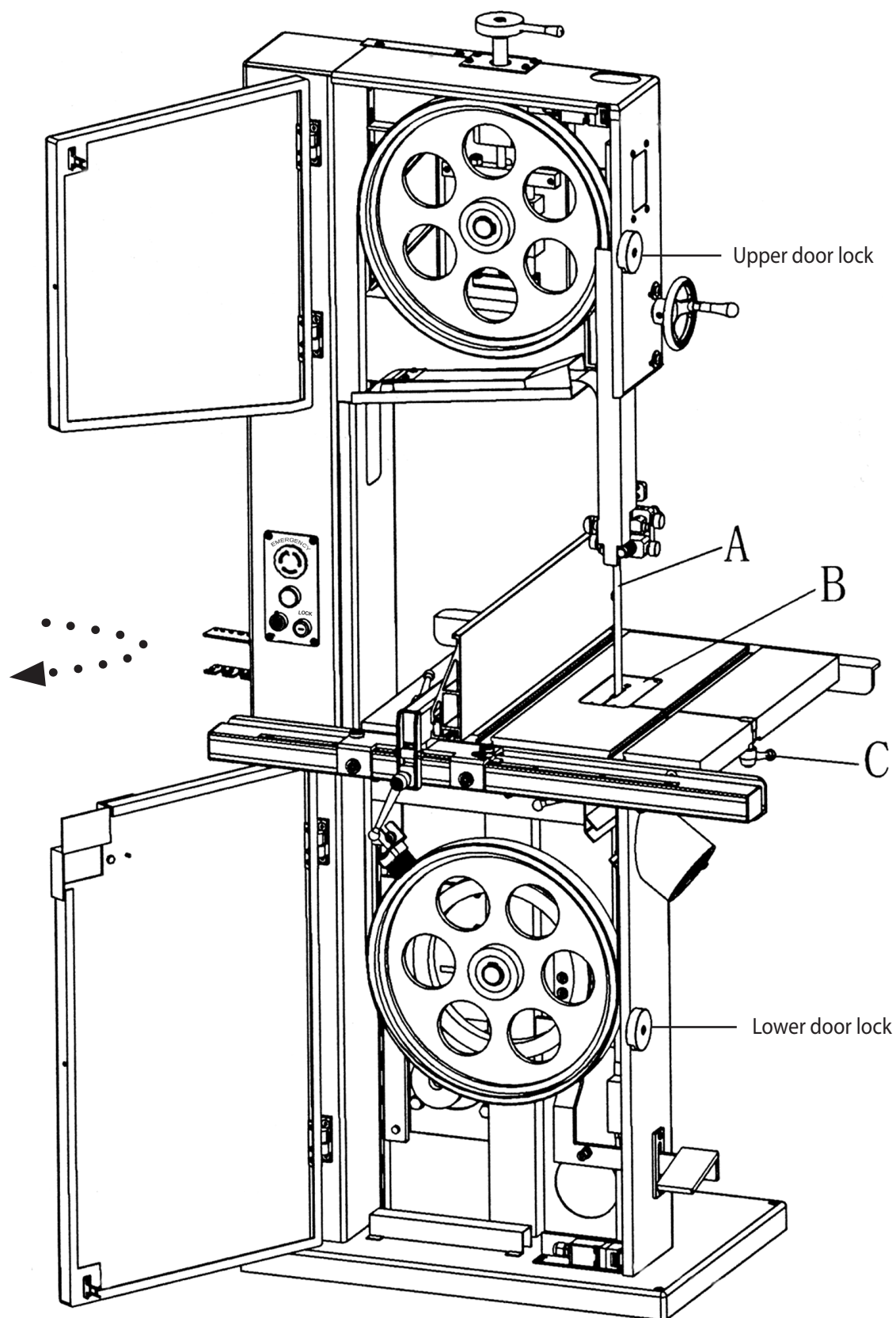
1. Make sure you have read and fully understood the general instructions and safety precautions in the preceding pages of this manual.
2. Before connecting the machine to the supply; check the machine for obvious signs of damage, paying particular attention to the plug and the power cable. Check that the blade you are using is the correct one for the job in hand. Change the blade if necessary. Check the blade is not damaged; is clean, sharp, tracks properly and is correctly tensioned.
3. Set the upper blade guide to approximately 12mm (1/2") above the height of the work piece.
4. Check there are no foreign objects e.g. old nails, screws, small stones etc embedded in the material you are about to cut.
5. Remove all accessories, tools etc., that have been used to set the machine.
6. Ensure the machine is switched off. Plug the power cable into a correctly rated switched socket outlet. If extension leads are being used, check these for damage, do not use if damaged. Switch on. Allow the saw to run up to speed.
7. Make sure that the material you are about to cut is within the machine's capacity, and the cut you are about to make is within the blades' capabilities, e.g. do not try to cut a 1" radius curve using a 5/8" blade.
8. Make sure the blade is not in contact with the material when you start the saw. Do not try to cut too quickly; the correct cutting speed, would never see the blade pushed back against the thrust bearing, the saw would cut and clear the saw line at the rate the work piece was fed into it. If you notice that you require more and more pressure to effect the cut, the blade is probably becoming blunt. Check and change if necessary.
9. **DO NOT** let go of the work piece, if you have to change your grip, make sure one hand is holding the material at all times.
10. If you are cutting long pieces of material think about sawing cutouts (i.e. a saw cut from the edge of the material to the saw line) along the saw line so that you can discard the off cuts as you progress down the saw line.
11. Observe the old woodworkers' adage of never allowing your hand/fingers within one handbreadth of the blade.
12. If you have to cut pieces of material of less than 20mm long, use a push stick.
13. Remember to check the blade tension after a new blade has been 'working' for 30-60 mins. The blade will 'stretch' slightly when new.
14. **DO NOT** release the tension on the saw blade when work is complete. The blades and the main saw frame do not respond kindly to constant changes in stress and tension. Only release the tension to change the blade or once work has finished for the day, using the release lever.



**WARNING! IF THE SAW JAMS
SWITCH OFF IMMEDIATELY.**

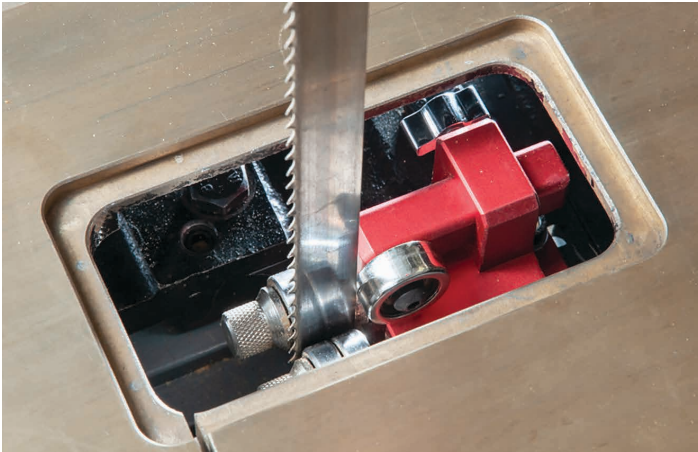
The blade in tension over a long period of non-use will cause the tyres to develop 'flat' spots.

CHANGING THE SAW BLADE



**MOVE THE SELECTOR SWITCH
TO 'BRAKE OFF' POSITION**

Fig 31



Set the upper blade guide assembly approximately midway in the throat. Open the top and bottom covering doors and remove the table insert (B), see fig 31.

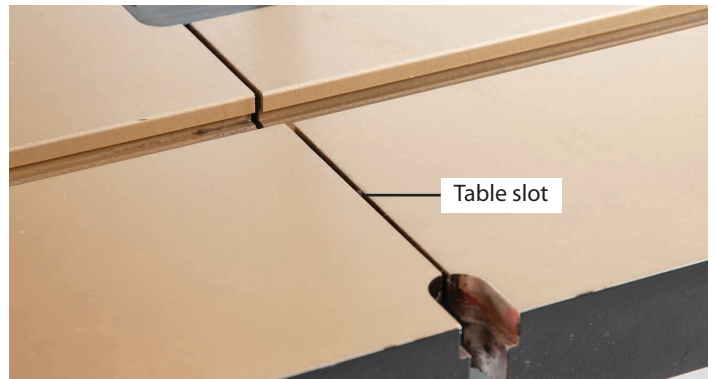
Remove the table stabilising bolt (C) and release the blade tension by pushing the quick release lever up, see fig 32.

Fig 32-33



Remove the lower blade guard (8), see fig 26 open the upper guard door (1), see fig 34. Slip the blade (A) off the wheels, carefully 'wiggle' it clear of the upper blade guard and clear of the lower blade guides and out through the slot in the table, see fig 35.

Fig 34-35



Clean the interior of the machine; remove the impacted 'crud' from the tyres, apply a little light oil to the screw threads of the blade and drive belt tensioners and the tracking control. The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the drive belt tensioner (in its slot) could likewise be lightly oiled.

Check the new blade for signs of damage.



WARNING! BE VERY CAUTIOUS WHEN YOU 'UNFOLD' THE BLADE; IT TENDS TO 'SPRING' OPEN.

Throw the blade away from you and check the blade did not "unfold" inside out.



MAKE SURE THE BLADE TEETH ARE POINTING DOWN!

Open up all blade guides so that they are clear of the blade. Hold the blade (A) approximately midway on either side of the loop and feed it into the table slot. 'Wriggle' the right hand side of the blade through the slot in the lower bearing guide guards and through the guard on the upper blade guide assembly.

Ease the blade over the wheels and locate the blade in the blade guides. Check that the blade is sitting approximately in the middle of the wheels and re-tension the blade by pulling the quick release lever down, see fig 33.

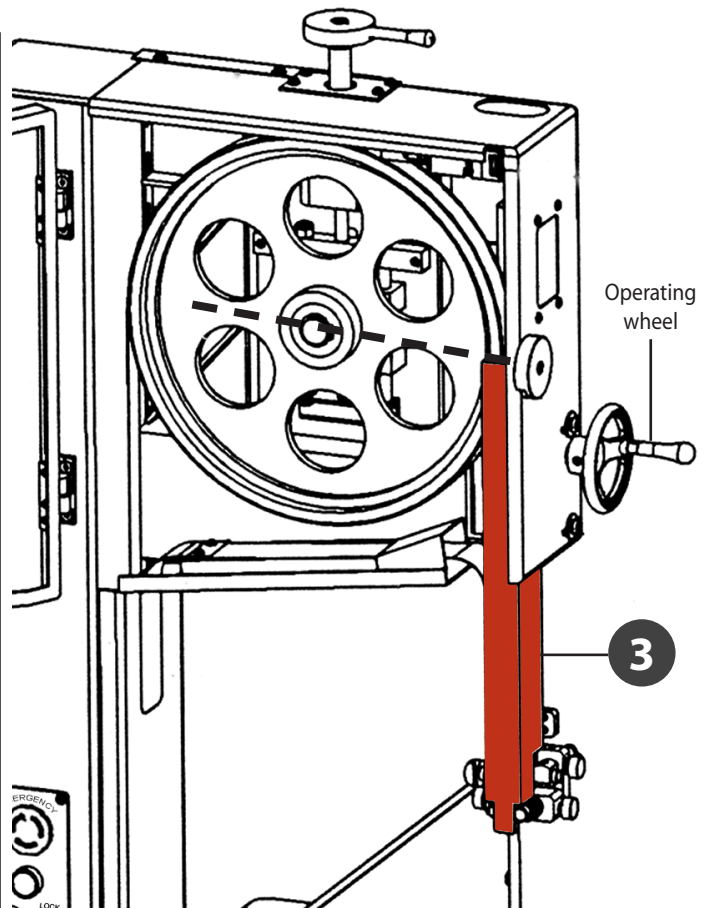
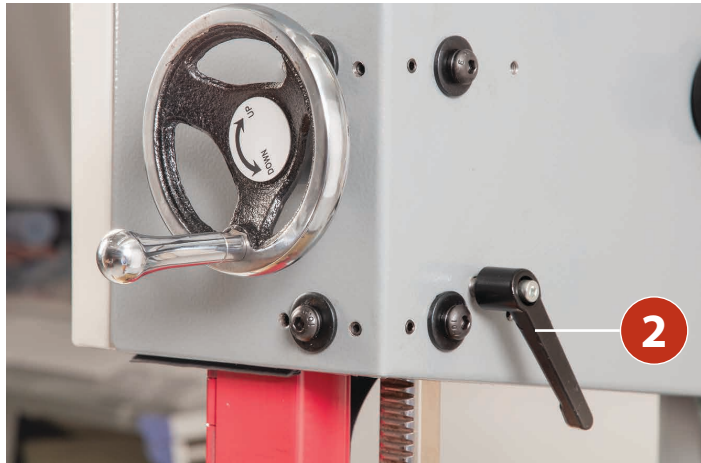
CHANGING THE SAW BLADE

Turn the top wheel by hand to ensure the blade will not skip off the wheels and the blade is travelling in the blade guides. Re-fit the table stabilising bolt and table insert.

Loosen the upper guide clamp (2) and position the assembly (3) so that the top of the blade guide is level with the centre of the top drive wheel, see fig 36-37. Re-tighten the clamp (2).

Now carry out the procedures as detailed in 'Setup/Adjustment'.

Fig 36-37



MAINTENANCE



TURN THE KEY TO THE 'LOCK' POSITION TO ISOLATE THE POWER TO THE BANDSAW!



MOVE THE SELECTOR SWITCH TO 'BRAKE OFF' POSITION

Daily

- Keep the machine clean.
- Check the saw blade for missing teeth and cracks (B).
- Spray Axcaliber Dry lubricant on the bare metal surfaces.

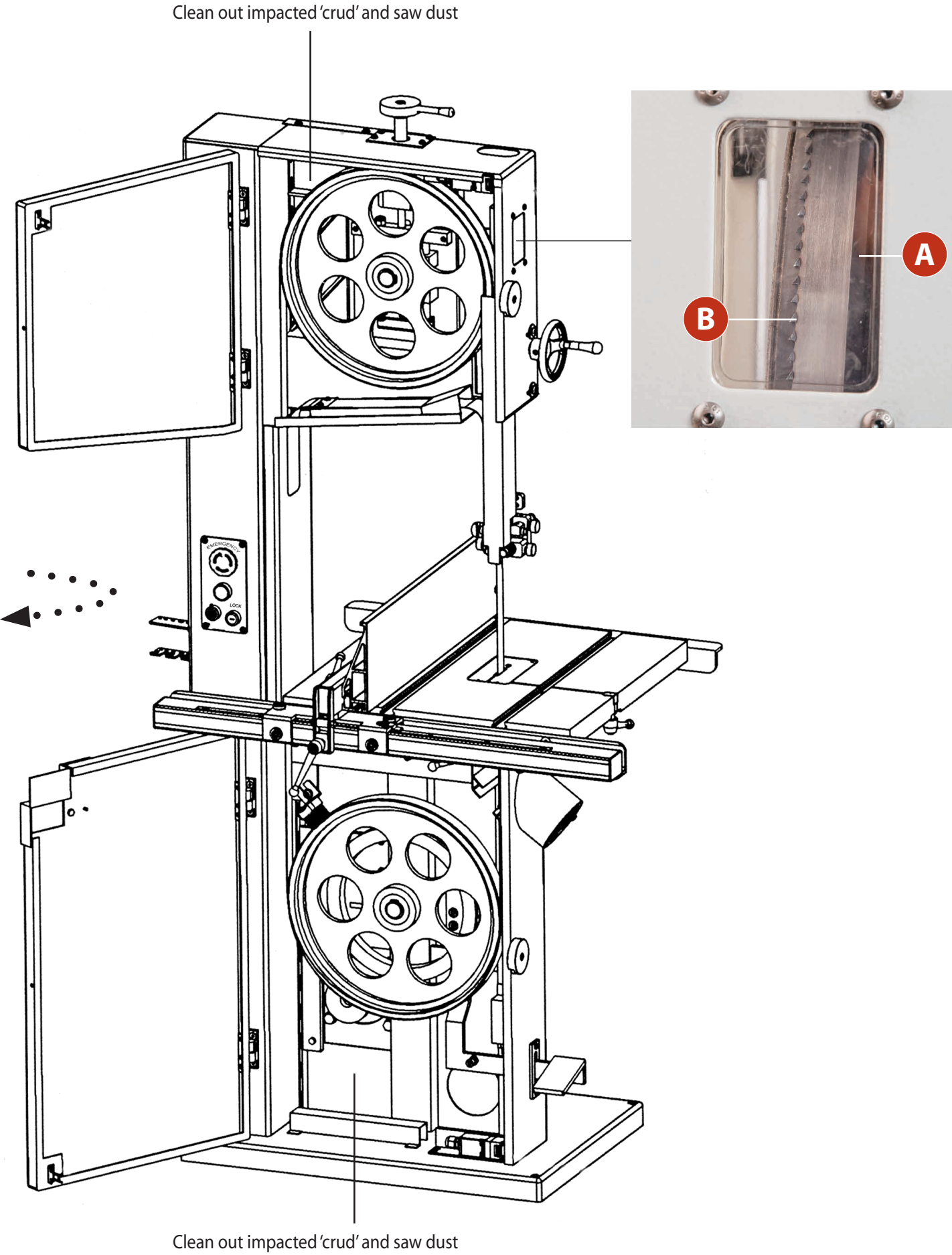
Weekly

- Open the top and bottom wheel covers and clean out all saw dust using an 'M Class' Vacuum cleaner.

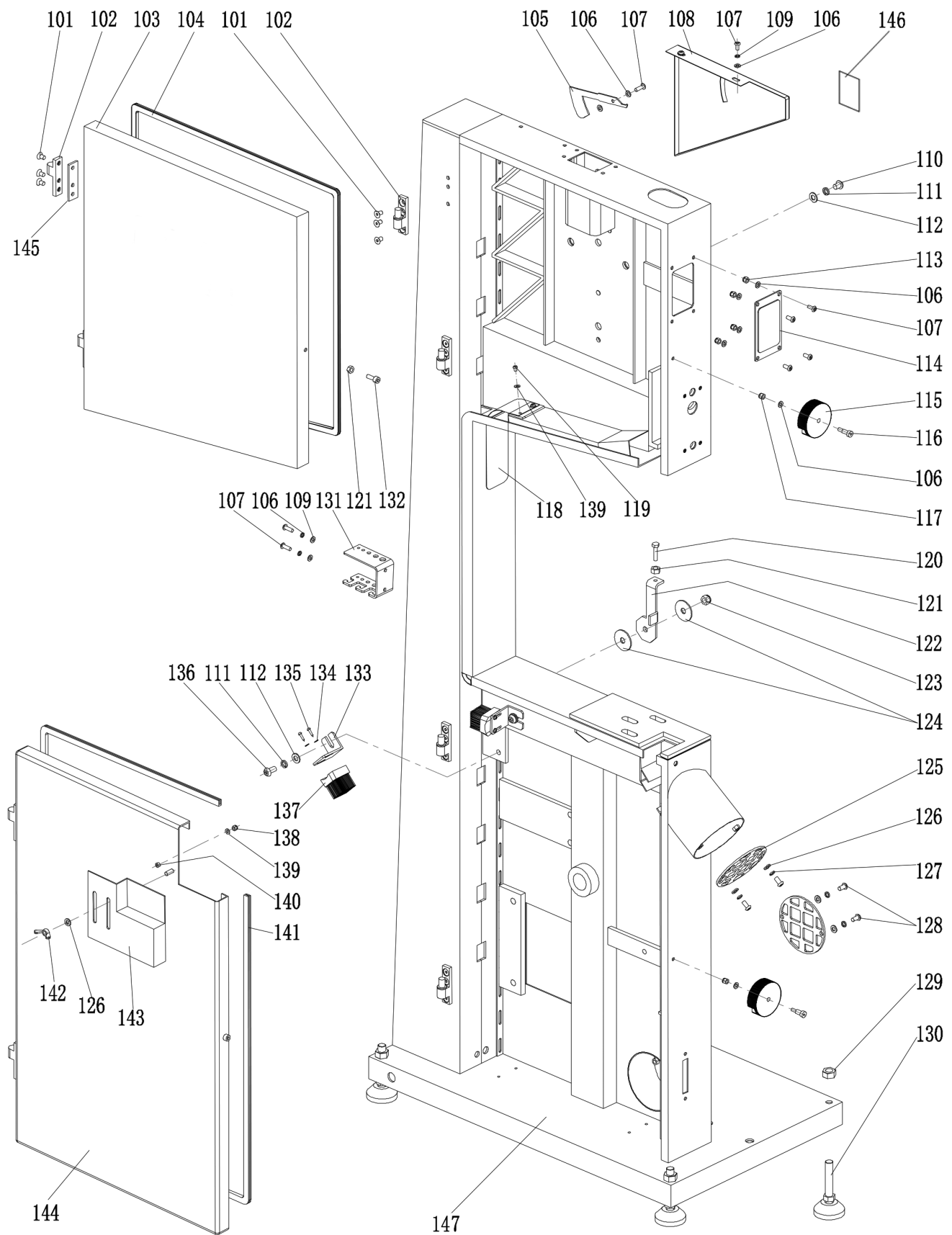
Monthly

- Open the lower and upper door and check the condition of the tyres and the drive belt. Clean out all saw dust and impacted 'crud' from the wheels and compartment area.
- Apply a little oil to the screw threads of the blade and drive belt tensioners. **DO NOT TO GET ANY OIL ON THE TYRES AND DRIVE BELT.**
- Check the condition of the tyres (A)
- Check the blade for missing teeth and cracks (B)
- Check the condition of the upper/lower blade guides and thrust bearings and clean using a soft brush, spray dry lubricant, (Axcaliber Dry Lubricant) on the bearing to prevent resin build up.
- Using an 'M Class' Vacuum cleaner, clean the motor vents and casing.





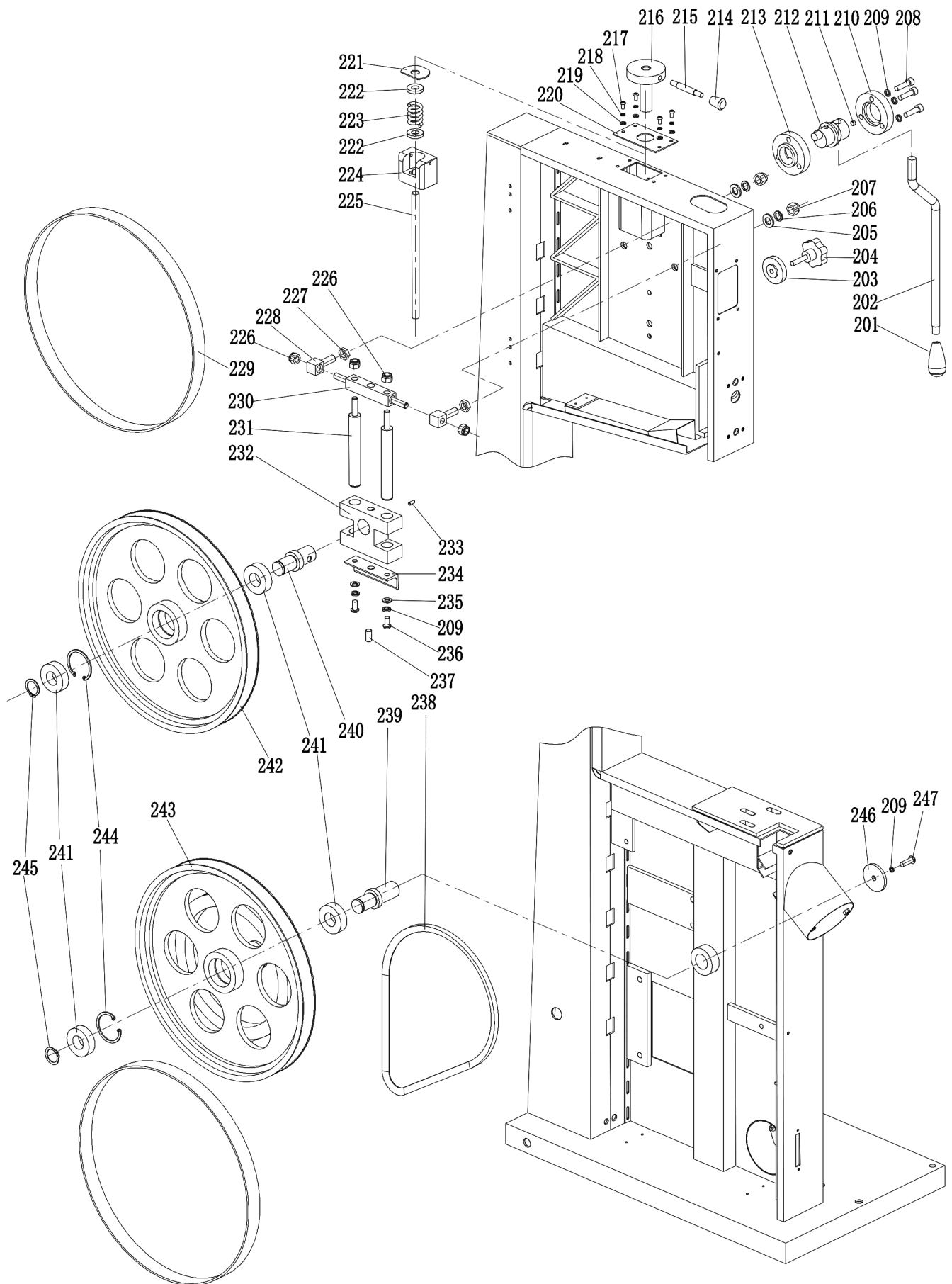
Frame Assembly Exploded View



No	Name	Description	Qty
101	Hex Socket Cap Screw	GB/T70.1 M6 X 12	24
102	Hinge	HW616-01-73	4
103	Door	HW615-01-90	1
104	Shockproof Soft Article	1.9 m	1
105	Position Indicator	HW615-04-05	1
106	Flat Washer	GB/T97.1 5	12
107	Cap Screw	GB/T70.2 M5 X 12	9
108	Tension Indicator Piece	HW615-04-26	1
109	Spring Washer	GB/T 93 5	4
110	Cap Screw	GB/T70.2 M8 X 10	1
111	Spring Washer	GB/T 93 8	3
112	Flat Washer	GB/T97.1 8	3
113	Lock Nut	GB/T923-1988 M5	4
114	Sight Glass	HW616-01-73	1
115	Lock Button	HW616-01-74	2
116	Cap Screw	GB/T 5281 6.5 X 12	2
117	Lock Nut	GB/T889.1 M5	2
118	Guide Plate	HW615-05-34	1
119	Cap Screw	GB/T70.2 M4 X 5	2
120	Cap Screw	GB/T 5783 M6 X 25	1
121	Lock Nut	GB/T 6170 M6	3
122	Washer	HW616-03-20	1
123	Lock Nut	GB/T889.1 M8	1
124	Washer	HW616-03-21	2

125	Dust Guard	HW616-01-76	2
126	Flat Washer	GB/T97.1 6	5
127	Spring Washer	GB/T 93 6	4
128	Cap Screw	GB/T70.2 M6 X 16	4
129	Lock Nut	GB/T 6170 M12	4
130	Anchor Bolt	M12 X 60	4
131	Tool Bracket	HW616-01-85B	1
132	Cap Screw	GB/T70.1 M6 X 12	2
133	Brush Plate	HW616-01-83	2
134	Flat washer	GB/T97.1 3	2
135	Screw	GB/T845 ST 2.9 X 13	2
136	Cap Screw	GB/T70.2 M8 X 16	1
137	Brush	HW616-01-84	2
138	Lock Nut	GB/T889.1 M4	1
139	Flat Washer	GB/T97.1 4	3
140	Flat Washer	GB/T70.1 M4 X 10	1
141	Shockproof Soft Article	2.3 m	1
142	Lock Nut	GB/T62 M6	1
143	Cover	HW615-01-80	1
144	Door	HW615-01-91	1
145	Stator		1
146	Tension Label		1
147	Saw Frame	HW615-01-00SJ	1

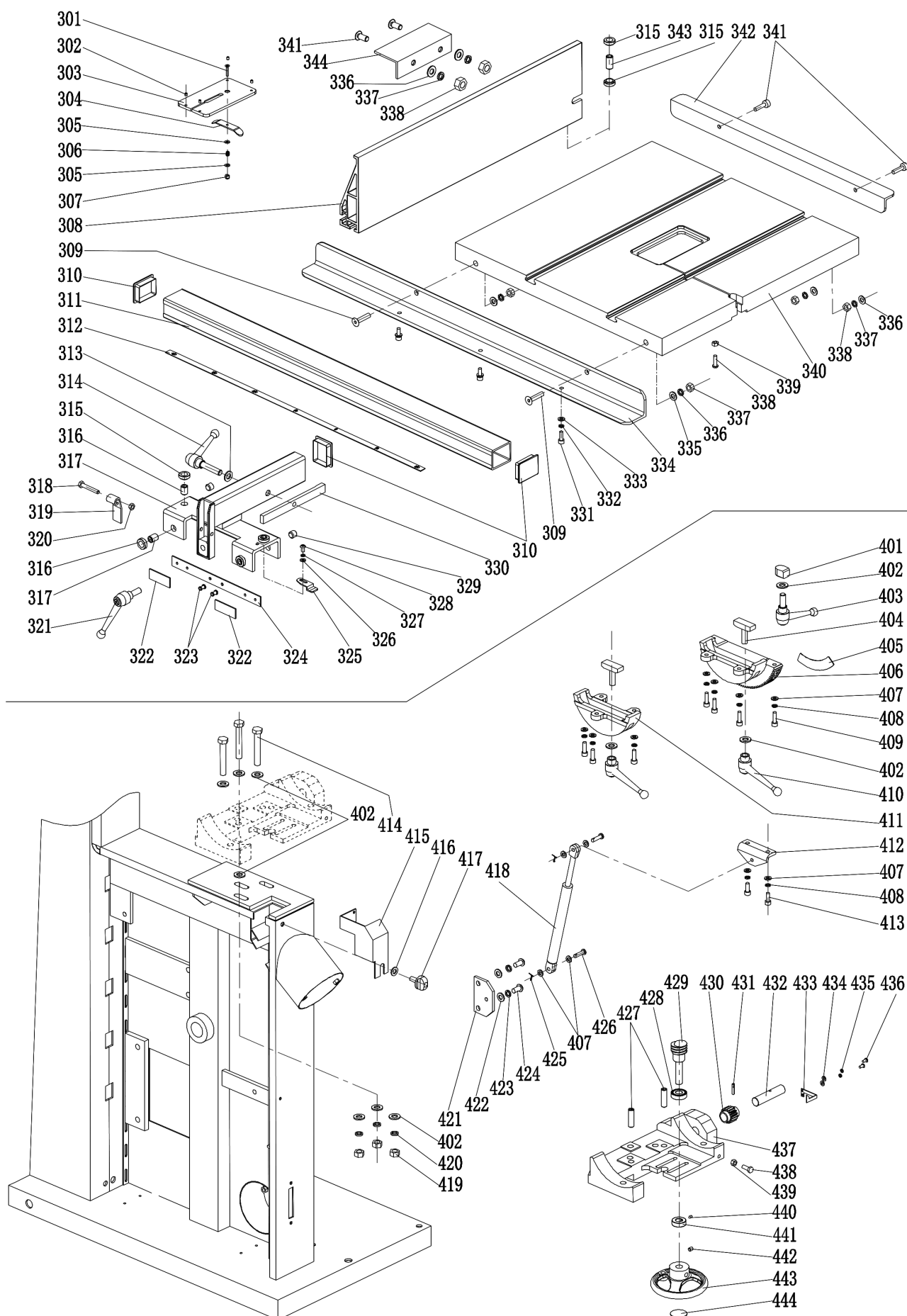
Wheels and Blade Tension Level Assembly



No	Name	Description	Qty
201	Knob	HW615-04-40	1
202	Handle	HW615-04-08	1
203	Adjusting Nut	HW616-04-23	1
204	Knob	M8X35	1
205	Flat Washer	GB/T97.1 12	2
206	Spring Washer	GB/T93 12	2
207	Lock Nut	GB/T97.1 12	2
208	Cap Screw	GB/T70.1 M8 X 30	3
209	Spring Washer	GB/T 93 8	6
210	Gasket	HW615-04-30	1
211	Set Screw	GB/T78 M8 X 10	1
212	Cam Shaft	HW616-04-10	1
213	Support Gasket	HW616-04-09	1
214	Handle Cover	GB4141.11 A-M8 X 25	1
215	Adjusting Extension Handle	HW616-04-24	1
216	Adjusting Handle	HW615-04-01	1
217	Cap Screw	GB/T70.2 M5 X 16	4
218	Spring Washer	GB/T 93 5	4
219	Flat Washer	GB/T97.1 5	4
220	Top Plate	HW616-01-71	1
221	Tensioning Washer	HW615-04-06	1
222	Tensioning Washer	HW616-04-07	2
223	Tighten Spring	d=5, D=21, ni=5.5, Ho =42	1

224	Spring Bracket	HW616-04-03B	1
225	Shaft	HW616-04-02	1
226	Lock Nut	GB/T889.1 M10	4
227	Lock Nut	GB/T6172.1 M12	2
228	Square Screw	HW616-04-16B	2
229	Rubber Belt	HW615-02-06	2
230	Square Shaft	HW616-04-20C	1
231	Guide Bar	HW616-04-19	2
232	Shaft Bracket	HW616-04-21	1
233	Set Screw	GB/T77 M6 X 12	1
234	Bracket	HW616-04-22	1
235	Flat Washer	GB/T97.1 8	2
236	Cap Screw	GB/T70.2 M8 X 16	2
237	Set Screw	GB/T78 M10 X 20	1
238	Triangle Belt	HM-39 9.5 X 990 La	1
239	Driving Shaft	HW615-02-03	1
240	Driving Shaft	HW615-02-04	1
241	Bearing	6205DU	4
242	Upper Fly-Wheel	HW615-02-02	1
243	Lower Fly-Wheel	HW615-02-01	1
244	Circlip For Hole	GB/T893.1 52	2
245	Circlip for Shaft	GB/T894.1 25	2
246	Plain Thick Washer	HW616-02-07	1
247	Cap Screw	GB/T70.2 M8 X 25	1

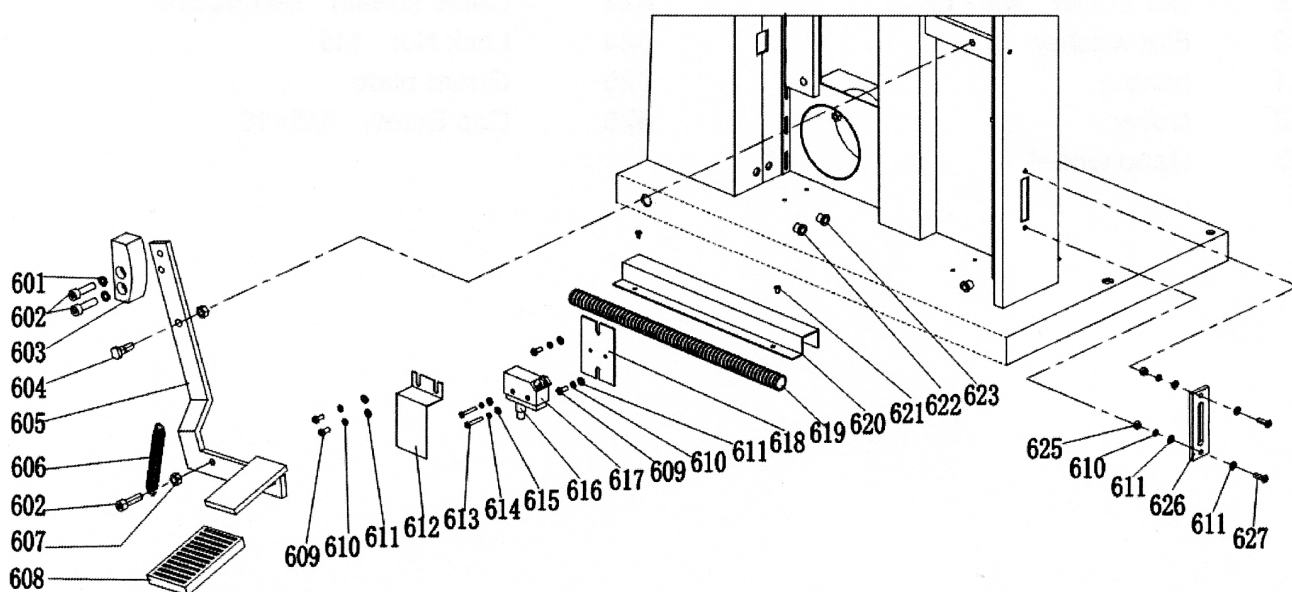
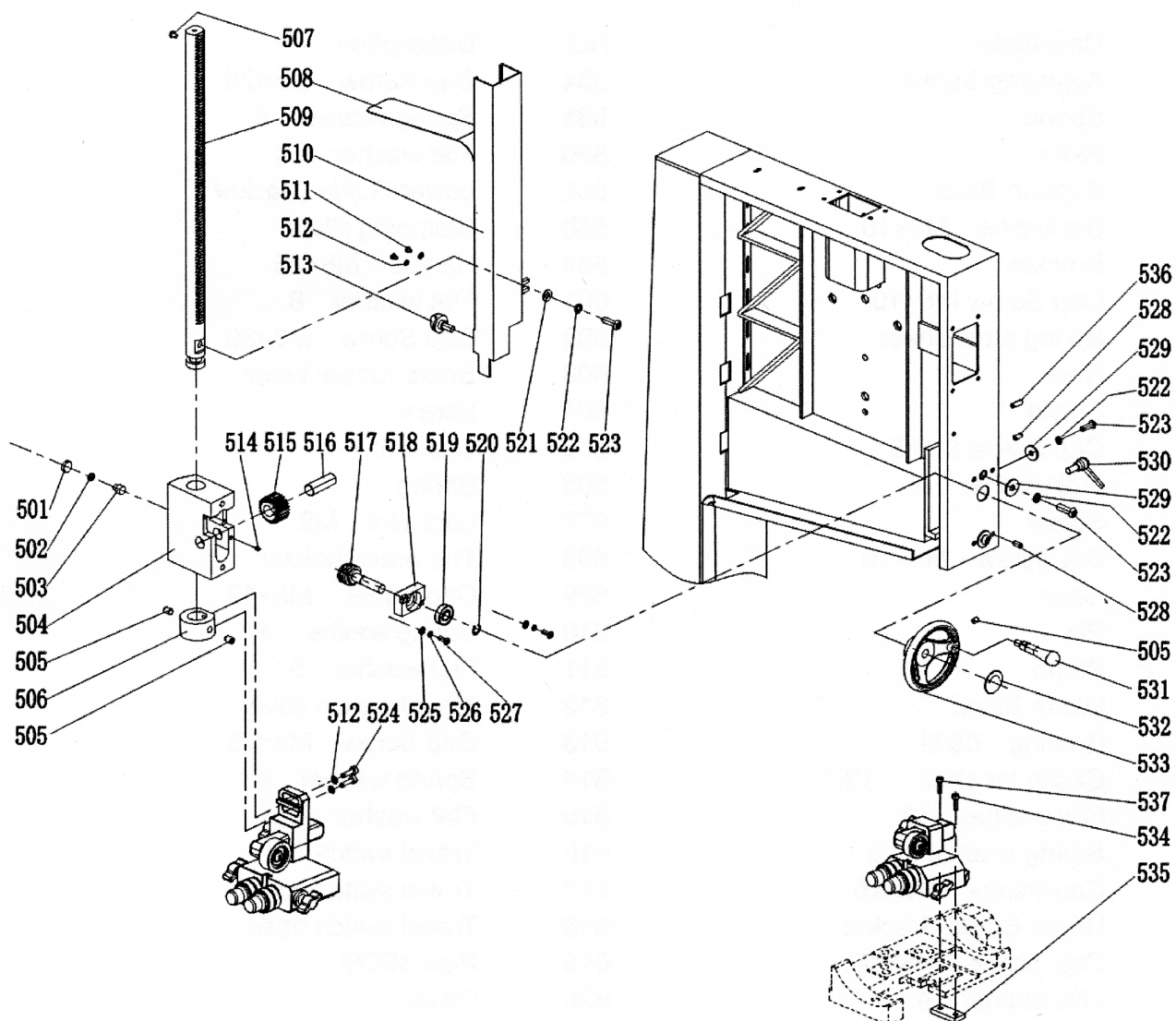
Table, Fence and Trunnion Assembly



No	Name	Description	Qty
301	Hex Socket Cap Screw	GB/T70.3 M4 X 20	1
302	Set Screw	GB/T77 M4 X 5	4
303	Insert	HW616-03-07	1
304	Spring Sheet	HW616-03-08	1
305	Flat Washer	GB/T97.1 4	2
306	Spring	d=0.5, D=6.5, ni=7.5, H=20	2
307	Lock Nut	GB/T889.1 M4	1
308	Aluminum Guide Plate	HW615-07-30	1
309	Hex Socket Cap Screw	GB/T70.1 M8 X 35	2
310	End Cap	40 X 50	3
311	Guide Tube	HW615-07-12	1
312	Ruler	HW618-07-09	1
313	Flat Washer	GB/T97.1 10	1
314	Handle	M10 X 55	1
315	Lock Nut	HW110-14-23	6
316	Set Screw	M12 X15	4
317	Fence Body	HW615-07-10	1
318	Cap Screw	GB/T5783 M6 X 45	1
319	Plate Lock	HW615-07-14	1
320	Lock Nut	GB/T889.1 M6	1
321	Handle	M10 X 25	1
322	Glide Pad	HW110-14-04 sc	2
323	Rivet	GB/T12618 5 X 16	2
324	Sliding Vane	HW615-07-13	1
325	Ruler X-Ray Film	HW615-07-18	1
326	Flat Washer	GB/T97.1 5	1
327	Spring Washer	GB/T 93 5	1
328	Cap Screw	GB/T70.2 M5 X 10	1
329	Set Screw	HW110-14-11 M12X10 (P=I)	2
330	Locking Plate	HW615-07-16	1
331	Cap Screw	GB/T70.1 M6 X16	3
332	Spring Washer	GB/T 93 6	3
333	Flat Washer	GB/T97.1 6	3
334	Front Rail	HW615-07-11	1
335	Flat Washer	GB/T97.1 8	8
336	Spring Washer	GB/T 93 8	8
337	Lock Nut	GB/T6170 M8	6
338	Cap Screw	GB/T70.2 M6 X 25	1
339	Lock Nut	GB/T6170 M6	1
340	Work Table	HW618-03-01	1
341	Cap Screw	GB/T70.2 M8 X 35	4
342	Rear Rail	HW615-07-15	1
343	Set Screw	M12 X 30	1
344	Extra Table		1

No	Name	Description	Qty
401	Lock Nut	HWJ14-03-06	1
402	Flat Washer	GB/T97.1 10	1
403	Handle	M10 X 25	1
404	Locking Screw	HW616-03-05B	2
405	Degree Indicator	HW616-03-19	1
406	Cam Trunion	HW616-03-03	1
407	Flat Washer	GB/T97.1 6	13
408	Spring Washer	GB/T 93 6	9
409	Cap Screw	GB/T70.1 M6 X 20	7
410	Handle	M10	2
411	Trunion Body	HW616-03-02	1
412	Gas Strut Bracket 1	HW616-03-14	1
413	Cap Screw	GB/T70.1 M6 X 16	2
414	Hex Cap Bolt	GB/T5783 M10 X 60	3
415	Shield	HW616-05-23	1
416	Cap Screw	GB/T96 8	1
417	Handle	HW616-05-30-2	1
418	Gas Strut	HW616-03-16	1
419	Lock Nut	GB/T6170 M10	3
420	Spring Washer	GB/T 93 10	3
421	Gas Strut Bracket 2	HW616-03-15	1
422	Flat Washer	GB/T97.1 8	2
423	Spring Washer	GB/T 93 8	2
424	Cap Screw	GB/T70.2 M8 X 16	2
425	R Pin	GB/T91 1.5 X 6.5 X 23	2
426	Pin	GB/T882 6 X 22	2
427	Set Screw	GB/T77 M10 X 30	2
428	Bearing	6001	1
429	Worm	HW616-05-31	1
430	Gear Shaft	HW616-03-06	1
431	Pin	GB/T879.2 4 X 20	1
432	Gear Shaft	HW616-03-09CE	1
433	Indicator	HW616-03-13	1
434	Flat Washer	GB/T97.1 4	2
435	Spring Washer	GB/T 93 4	2
436	Cap Screw	GB/T70.2 M4 X 8	2
437	Support Frame	HW616-03-04CE	1
438	Cap Screw	GB/T5783 M6 X 25	1
439	Lock Nut	GB/T6170 M6	1
440	Set Screw	GB/T78 M5 X 8	1
441	Limit Sleeve	HW616-05-32	1
442	Set Screw	GB/T77 M6 X 8	1
443	Hand Wheel	HWT40-02-06	1
444	Block Slice	HW615-04-32	1

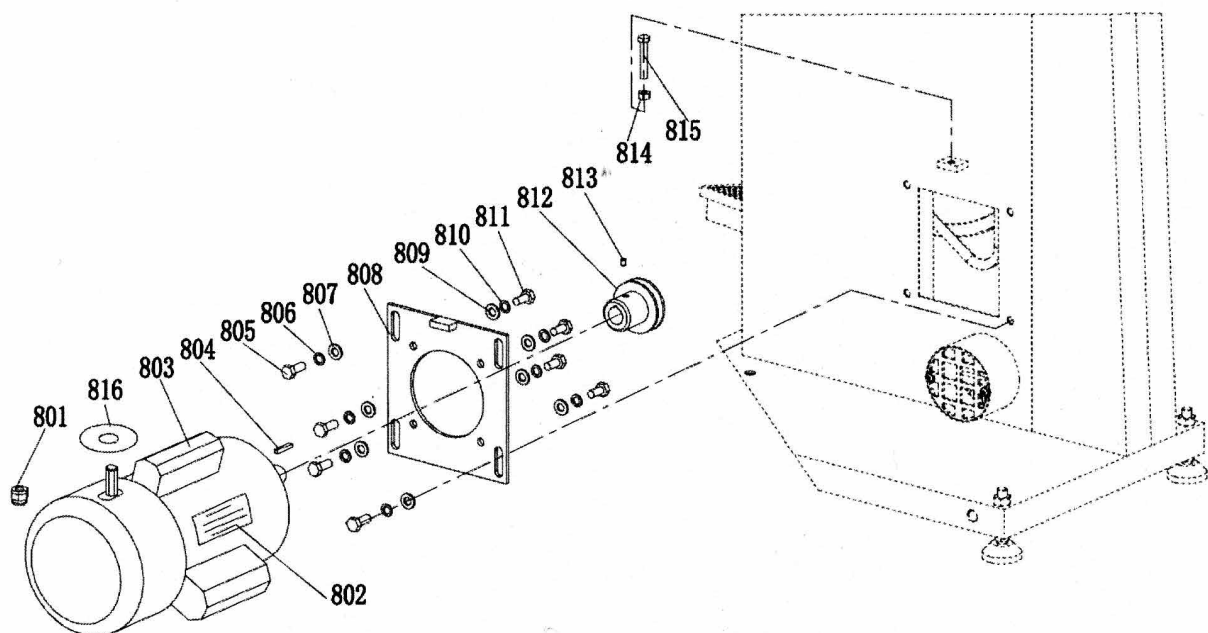
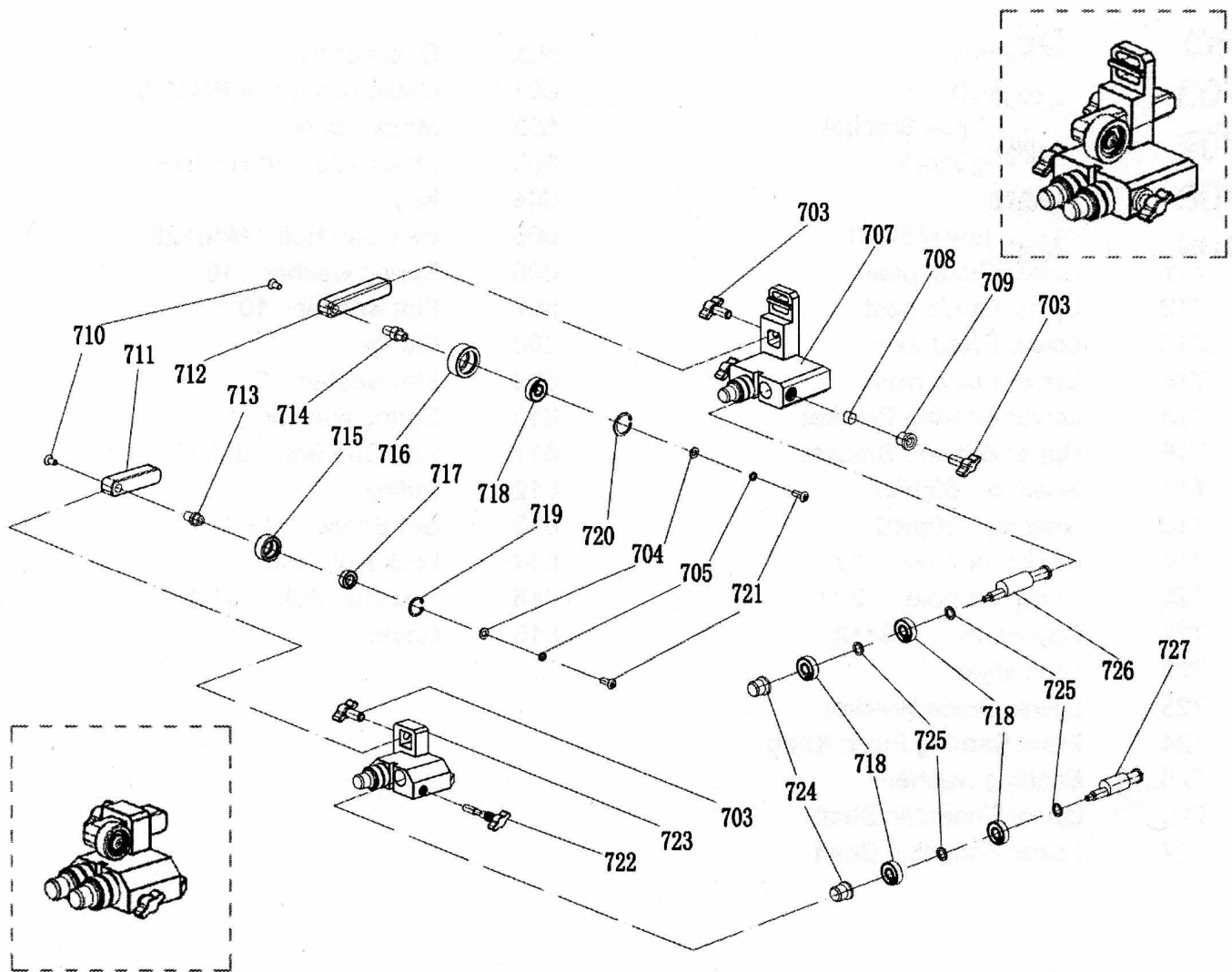
Upper/Lower Blade Guide and Brake Pedal Assembly



No	Name	Description	Qty
501	Adjusting Screw	HW616-05-03	1
502	Spring	d=1, D=10, m=6.5, Ho=20	1
503	Block	HW616-05-02	1
504	Support Block	HW615-05-30	1
505	Set Screw M8 x 10	GB/T77 M8X10	3
506	Bracket	HWB14-05-30	1
507	Cap Screw M5 x 10	GB/T70.2 M5X10	1
508	Spring Steel Sheet	HW615-05-37	1
509	Rack	HW615-05-11	1
510	Shield	HW616-05-29	1
511	Cap Screw M5 x 8	GB/T70.2 M5 X 8	2
512	Flat Washer 5	GB/T97.1 5	4
513	Screw	HW616-05-30-1	1
514	Set Screw M5 x 10	GB/T77 M5 X 10	1
515	Gear	HW615-05-10	1
516	Pin	HW615-05-31	1
517	Worm	HW615-05-35	1
518	Worm Block	HW615-05-33	1
519	Bearing 6001	6001	1
520	Cir-clip for Shaft 12	GB/T894.1 12	1
521	Flat washer 8	GB/T97.1 8	1
522	Spring washer 8	GB/T 93 8	5
523	Cap Screw M8 x 25	GB/T70.2 M8 X 25	5
524	Cap Screw M5 x 16	GB/T70.1 M5 X 16	2
525	Flat Washer 4	GB/T97.1 4	2
526	Spring Washer 4	GB/T 93 4	2
527	Cap Screw	GB/T70.2 M4 X 20	2
528	Set Screw	GB/T77 M6 X 12	6
529	Flat Washer 8	GB/T96 8	4
530	Handle	M8 X 25	1
531	Handle	HWT40-02-07	1

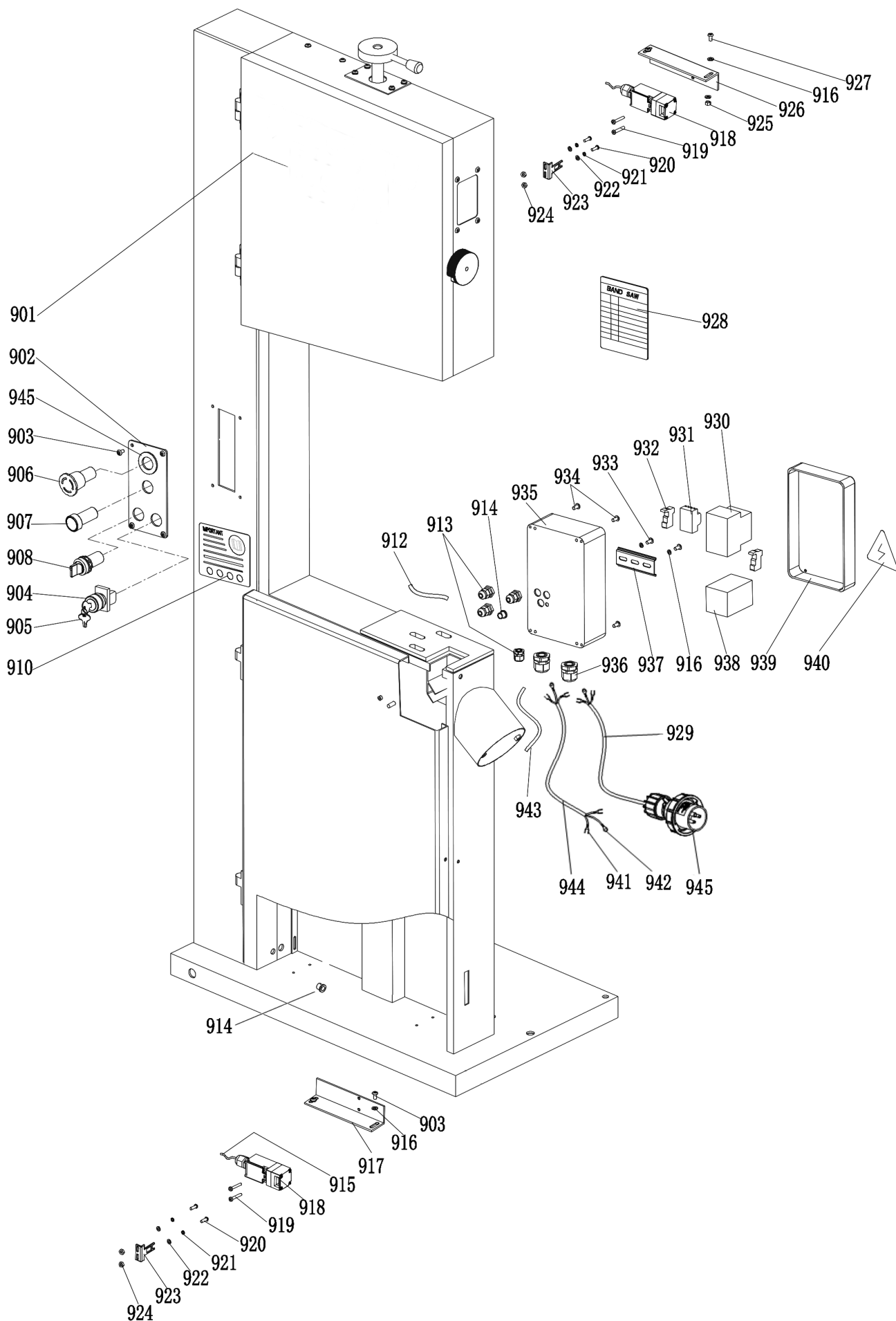
532	Cover	HW615-04-31	1
533	Hand Wheel	HWT40-02-06	1
534	Cap Screw M6 x 25	GB/T70.1 M6 X 25	1
535	Clamping Plate	HW616-05-18	1
536	Set Screw	GB/T77 M6 X 12	2
537	Cap Screw M6 x 20	GB/T70.1 M6 X 20	1
601	Flat washer 8	GB/T97.1 8	2
602	Cap Screw M8 x 30	GB/T70.1 M8 X 30	2
603	Brake Rubber Block	HW616-06-03	1
604	Screw	HW616-06-05	1
605	Brake Rod	HW616-06-01	1
606	Spring	d=2, D=12, m=30, Ho=95	1
607	Lock Nut M8	GB/T6170 M8	2
608	The Brake Holster		1
609	Cap Screw M5 x 12	GB/T70.2 M5 X 12	4
610	Spring Washer 5	GB/T 93 5	6
611	Flat Washer 5	GB/T97.1 5	8
612	Travel Switch Cover	HW616-06-08	1
613	Cap Screw M4 x 25	GB/T70.2 M4 X 25	2
614	Spring washer 4	GB/T 93 4	2
615	Flat washer 4	GB/T97.1 4	2
616	Travel Switch	AZ1037	1
617	Travel Switch Cover		1
618	Travel Switch Base	HW616-06-06	1
619	Pipe	35CM	1
620	Cover	HW615-09-20	1
621	Cap Screw	M4 x 8	2
622	Cable Sheath	0811	1
623	Cable Sheath	0813/0814	1
625	Lock Nut	GB/T6170 M5	2
626	Guard Plate	HW616-06-04	1
627	Cap Screw	GB/T70.2 M5 x 16	2

Upper/Lower Blade Guide and Motor Assembly



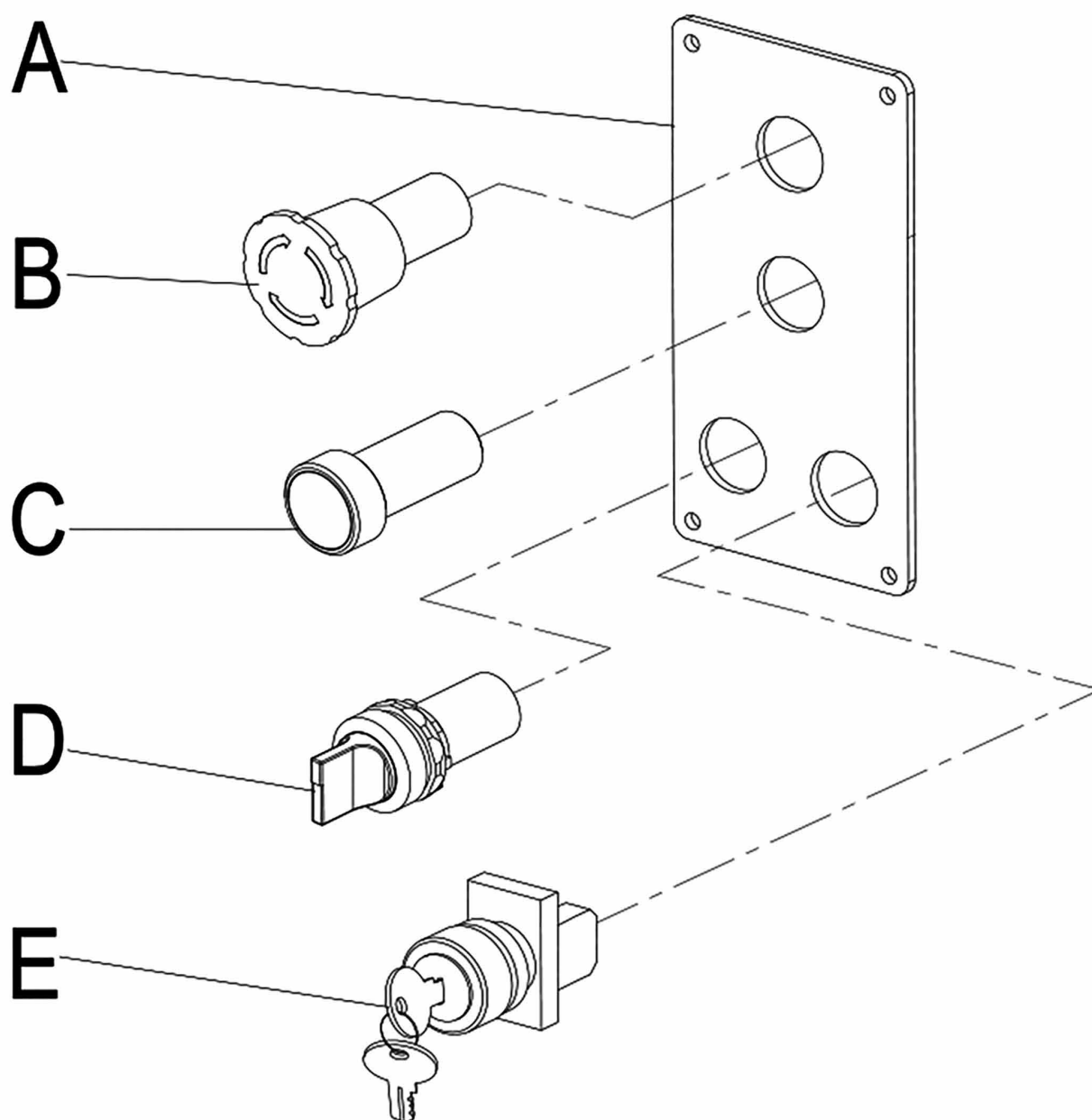
No	Name	Description	Qty
703	Lock Knob		3
707	Upper Guide Bracket		1
708	Damping Block		1
709	Nut set		1
710	Cap Screw	M5 x 10	2
711	Lower Guide Post		1
712	Upper Guide Post		1
713	Lower Fixed Axis		1
714	Upper Fixed Axis		1
715	Lower Bearing Bracket		1
716	Upper Bearing Bracket		1
717	Bearing 689RS	689RS	1
718	Bearing 608RS	608RS	1
719	Cir-clip for Hole 17		1
720	Cir-clip for Hole 22		1
721	Cap Screw	M5 x 12	2
722	Lock Shaft		1
723	Lower Guide Bracket		1
724	Front Bearing Fixed Knob		2

725	Bushing Washer		2
726	Upper Eccentric Shaft		1
727	Lower Eccentric Shaft		1
801	Cable Connector	PG13.5	2
802	Motor Label		1
803	Motor	230V 50 Hz 3HP 1PH	1
804	Key		1
805	Hex Cap Bolt	GB/T5783 M10 X 25	4
806	Spring Washer	GB/T93 10	4
807	Flat Washer	GB/T97.1 10	4
808	Flange	HW615-09-02	1
809	Flat Washer 8	GB/T97.1 8	4
810	Spring Washer	GB/T 93 8	4
811	Hex Cap Bolt	3/8-16—3/4	4
812	Pulley	HW615-02-05	1
813	Set Screw	GB/T77 M6 X 8	1
814	Lock Nut	GB/T6170 M8	1
815	Hex Cap Bolt	GB/T5783 M8 X 50	1
816	Circular Rubber Cover		1



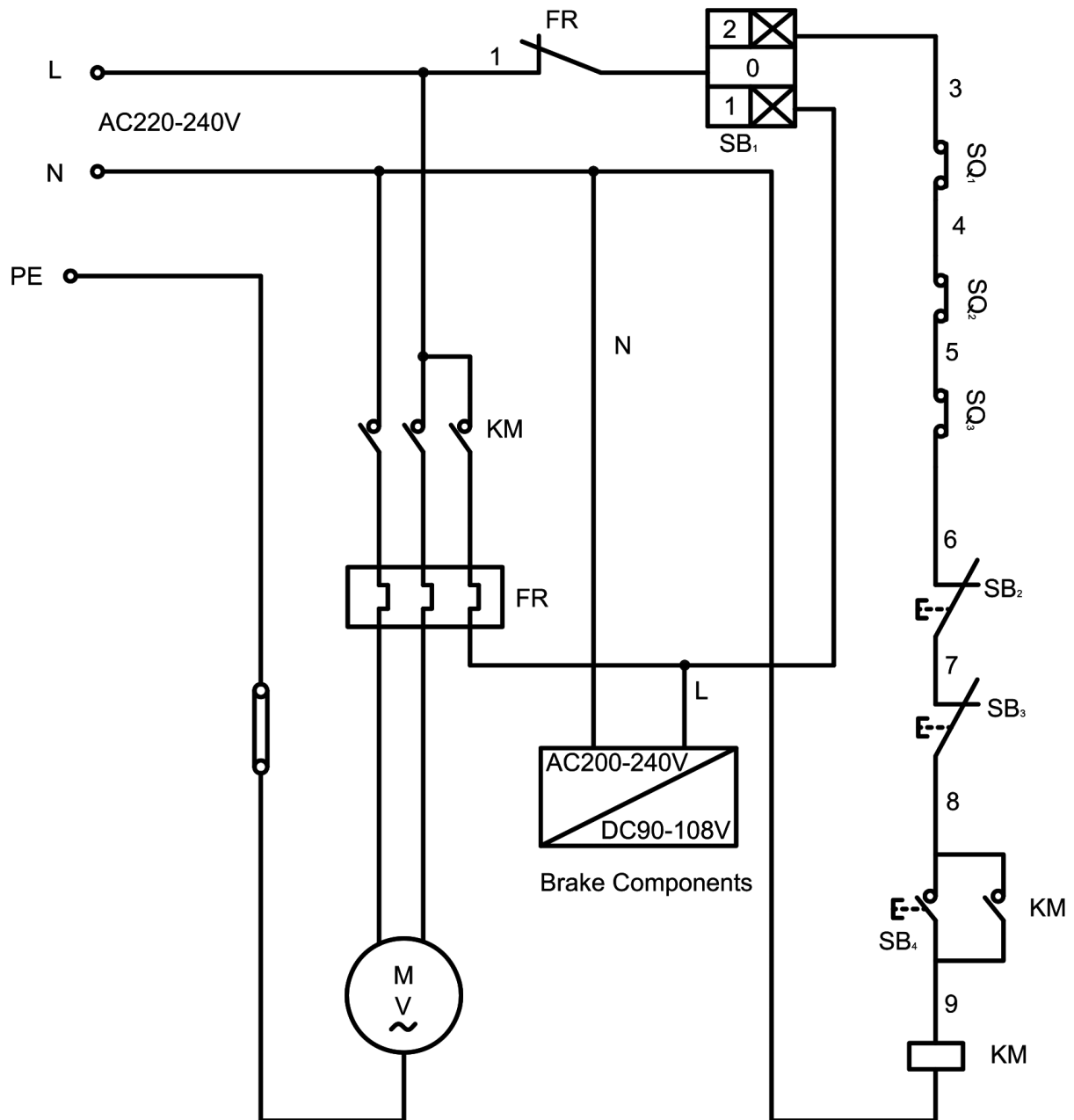
No	Name	Description	Qty
901	LOGO		1
902	Switch Panel	HW615-09-25	1
903	Cap Screw	GB/T70.2 M5 X 12	8
904	Switch Lock	ZB2-BG2C	1
905	Key		2
906	Emergency Stop Button	MPET4-10R-01	1
907	Start Button	CPI-10G-10,Typec,5A	1
908	Select Switch	C3SS1-10B-20	1
910	Warning Label		1
912	Control Line	7C(VDE) 0.75 mm2 1.4m	1
913	Cable Connector	PG9	4
914	Cable Sheath	0811	2
915	Limit Switch Line	2C (VDE) 1.5mm2, 2.3m 1.3m	1
916	Flat Washer	GB/T97.1 5	6
917	Lower Limit Switch Plate	HW616-09-13	1
918	Limit Switch	QKS8	2
919	Cap Screw	GB/T70.2 M4 X 25	4
920	Cap Screw	GB/T70.2 M4 X 12	4
921	Spring Washer	GB/T 93 4	4
922	Flat Washer	GB/T97.1 4	4
923	Limit Switch Key	CNTD-	2

924	Lock Nut	GB/T889.1 M4	4
925	Lock Nut	GB/T889.1 M5	2
926	Upper Limit Switch Plate	HW616-09-14	1
927	Cap Screw	GB/T70.2 M5 X 16	2
928	Warning Label		1
929	Input Cable		1
930	AC Contractor	A16-30-10, 230V, 17A	1
931	Grounding Terminals	MA2.5/5 M4-6.P	1
932	Wire Terminal	BAM2	2
933	Cap Screw	GB/T70.2 M5 X 8	2
934	Cap Screw	GB/T818 M4 X 8	4
935	Electrical Box	HW616-09-11	1
936	Cable Connector	PG13.5	2
937	Bracket		1
938	Thermal Overload Relay	TA25DU,13-19A	1
939	Electrical Box	HW615-09-10	1
940	Electric Shock Warning Label	60 x 60	1
941	Crimping Terminal 2.5		1
942	Circular Crimping Terminal 2.5		1
943	Control Line	2C (VDE) 1.5mm2, 1.2m	1
944	Output Cable		1
945	Waterproof Plug		1



No	Name	Description	Qty
A	Switch Panel	HW615-09-25	1
B	Emergency Stop Button	MPET4-10R-01	1
C	Start Button	CPI-10G-10,Typec,5A	1
D	Select Switch	C3SS1-10B-20	1
E	Key Switch	ZB2-BG2C	1

Electrical Connections Diagram



Remarks: FR Thermorelay
 SQ₁ Upper Door Opening Switch
 SQ₂ Lower Door Opening Switch
 SQ₃ Footbrake Switch
 KM Contactor

SB₁ Terminal Switch
 SB₂ Key Switch
 SB₃ Emergency Stop Switch
 SB₄ Start Button

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