



5015 14" Cut Off Saw

Owner's Manual

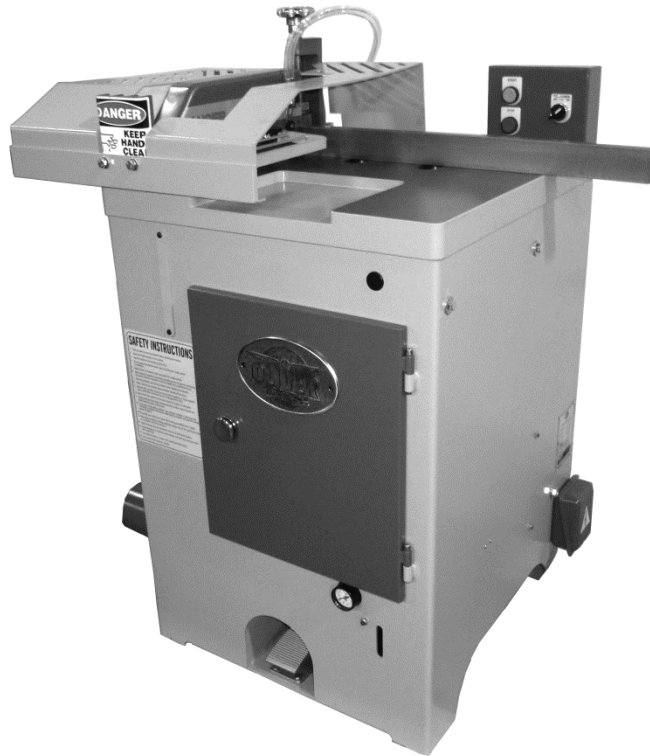


TABLE OF CONTENTS

I. GENERAL DESCRIPTIONS.....	01
II. SPECIFICATIONS.....	02
III. CUTTING CAPACITY DIAGRAM	02
IV. CAUTIONS BEFORE OPERATING	03
V. OPERATING PROCEDURES	04
VI. MAINTENANCE & SERVICE.....	04
VII. REMARKS	05
VIII.ADDITIONAL SAFETY RULES FOR THIS MACHINE (1) (2).....	06-07
IX. REPLACING THE SAWBLADE (1)(2)	08-09
X. ADJUSTING V-BELT TENSION (1)(2)	10-11
XI. DIAGRAMS AND PART LISTS	12-16

I. GENERAL DESCRIPTIONS

Much thanks for our honorable customers whom to select our products, 14” Auto Hi-speed Cut-Off Saw. We deep believe your intelligent selection which will make you feel easy and satisfactory.

In order to assist you realize the machinery character and how to operate, maintain the machinery etc., affairs. Therefore, we compile this manual for you to study and refer. Of course, the products which before to deliver to the endorsers our company has made the necessary testing, measuring & practical operations. But it is essential to the machinery performance which is based on the accurate maintenance and operations. Since we wish our honorable customers must practiced operating method and maintenance regularly. The manual is suggested to assist the user to understand the operating method much better and maintenance note precisely; moreover, to assure the supreme performance & long servicing life of machinery.

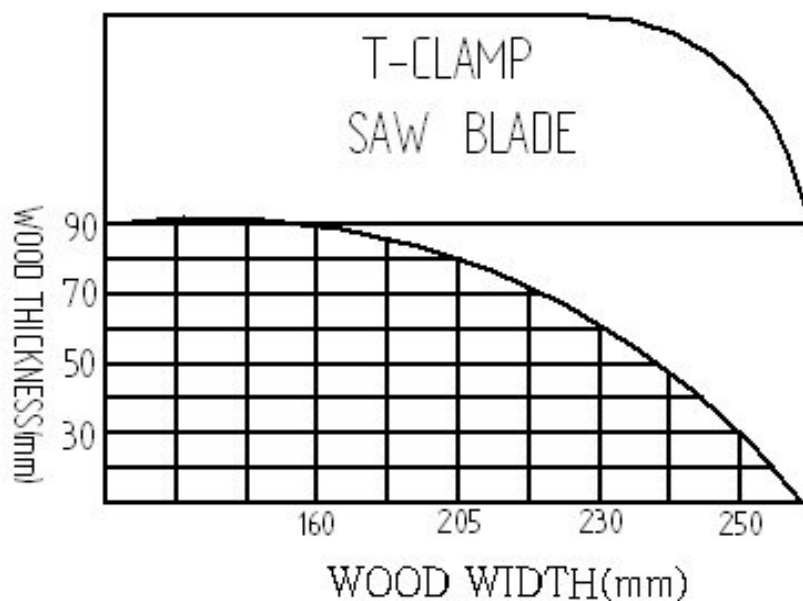
II. SPECIFICATIONS

14" CUT-OFF SAW

Cutting capacity (thickness x width)	1" x 10", 2" x 9", 3" x 8"
Cycle speed	95 strokes/min
Cycle operation	Air
Saw blade size (optional)	14"
Saw arbor diameter	1"
Saw blade speed	4100 RPM
Dust exhaust diameter	Ø4"
Motor	5 HP (7.5HP opt.)
Table size	630x 590 mm
Net weight	240 kgs
Gross weight	290 kgs
Packing dimensions (L x W x H)	770 x 760 x 1300 mm

*We reserve the right to modify design without prior notice.

III. CUTTING CAPACITY DIAGRAM



IV. CAUTIONS BEFORE OPERATING

- 1.** After the machine is transported to the installed site which must be cared to take off the exporting case and the install site must be flatten and rugged. If there are not flatten which can be inserted the shim at the bottom of the machine, so that there are not swung.
- 2.** After the installed process is completed and then, which can be connected the power wire. Meanwhile, to inspect the rotating direction of circular saw is same as indicated or not. Check if there are not which must exchange the connecting terminal.
- 3.** We can employed the kerosene to clean the anti-rust oil which brushed on the sliding portion of machinery and then, to wipe new lubricating oil or grease on the sliding way or transmitting portion.
- 4.** Before operating, firstly inspecting safety appurtenance, guard of saw blade- - - etc. and other safety device locked tightly or not.
- 5.** To check and inspect if the air piping is connected with the R.F.L unit, if the oil cup is poured oil, and if there is any leakage on the piping system or not. Especially, to correct the error and then to solve the problem. After that, to connect the dust chute with the dust collector.

V. OPERATING PROCEDURES:

1. Adjust the angle between guide fence and circular saw which s corresponded to the being cutting angle.
2. Turn selecting switch of air inlet to the ON position.
3. Start the electric power on.
4. Pedaling on the foot pedal switch and then, the cutting process can be processed.
5. To inspect if the dimensions & profile of the first products meet the requirement or not, therefore to adjust the assorted portion again.

VI. MAINTENANCE & SETVICE

1. Each week, the SPINDLE OIL NOZZLE must be lubricated with grease on the circular saw shaft periodically. (Shell #3 or same grade grease)
2. Poured the lubricating oil in the R.F.L unit periodically and drained out the water which stored in the filtering cup.
3. Each day, after the work is over, clean the wood chips on the machine sot that to assure the operation to be processed continuously.

VII. REMARKS

- 1.** When operating, if the workpiece is clogged or any portion of the machine must be adjusted, beware: turn off the electric power and then handle again.
- 2.** During operating, the operator must be far from the range of circular saw processing which can avoid the breakage fly out. Especially, do not approach your hands to the circular saw.
- 3.** During operating, if the effect of cutting process is not good enough, check if the V belt is loose or the circular saw is blunt.

VIII. ADDITIONAL SAFETY RULES FOR THIS MACHINE (1)

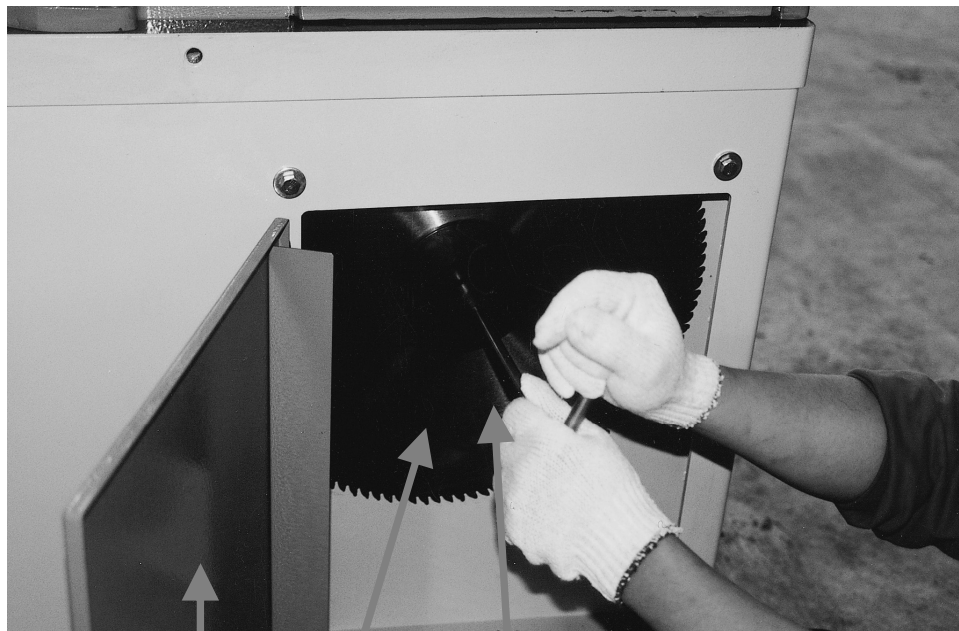
1. As with all machine, there is a certain amount of hazard involved with the use of this machine. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.
2. **LIMITED WARRANTY** This warranty does not apply to personal injury and defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-end tear, repair or alterations outside our faculties, or to a lack of maintenance.
3. **IF YOU ARE NOT** thoroughly familiar with the operation of this machine, obtain advice from your suspensor, instructor or other qualified person. Or please contact the company who sold the machine to you, and request for the correct instruction of operating. When you are not sure what the correct operation is, please do not use this machine.
4. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES** performing the intended operation, stop using the machine! Then contact the distributor's service department or ask a qualified expert how the operation should be performed.
5. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.
6. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.
7. **MAKE** all adjustments with the power "OFF"

VIII. ADDITIONAL SAFETY RULES FOR THIS MACHINE (2)

8. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. DO NOT** leave tool until it comes to a complete stop.
9. **MAKE SURE** wiring codes and recommended electrical connection instructions are followed, and that the machine is properly grounded.
10. **DISCONNECT** machine from power source when make repairs.
11. **KEEP** knives sharp and free of all rust and pitch.
12. **DO NOT** operate this machine when the guard is removed.
13. **KEEP** fingers and hands away from the cutting area.
14. **NEVER** start the machine, with the workpiece in contact with the cutterhead.
15. **CHECK MATERIAL** for loose knots and other defects before operating.
16. **MAKE SURE** the workpiece is free from nails and other foreign objects which could cause injury or damage to the knives.
17. **MAKE SURE** the knives are properly secured to the machine, as explained in the instruction manual, before turning on power.
18. **REMOVE SHAVINGS** only with the power “OFF”.
19. **KEEP HANDS** away from the top surface of the board near the feed rollers.
20. **BEFORE LEAVING** the machine, make sure the work area is clean.
21. **SHOULD** any part of your machine be missing, damaged or fail in any way, or any electrical component fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged or failed parts before resuming operation.
22. **ATTENTION!!** Before installation & operation, please make sure the worker have been trained and be effected insurance on. Also, for the dangerous machine, the seller in local has to insure “Product Liability Insurance”.

IX. REPLACING THE SAWBLADE (1)

1. Disconnect the machine from the power source.
2. Open the left side door. Use the supplied door handle to turn the door latch for opening the door.
3. Loosen the sawblade lock screw by using the supplied "T" wrench.



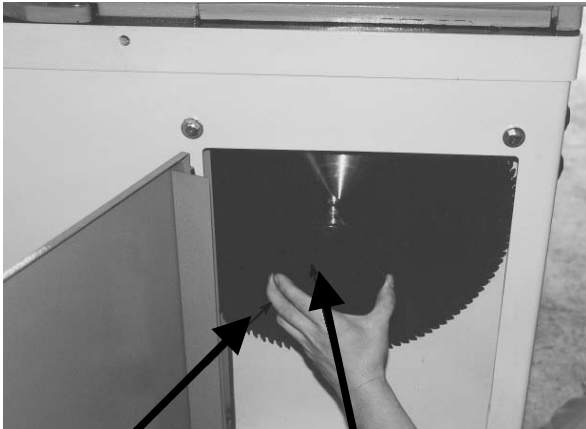
LEFT SIDE DOOR

BLADE LOCK
SCREW

"T" WRENCH

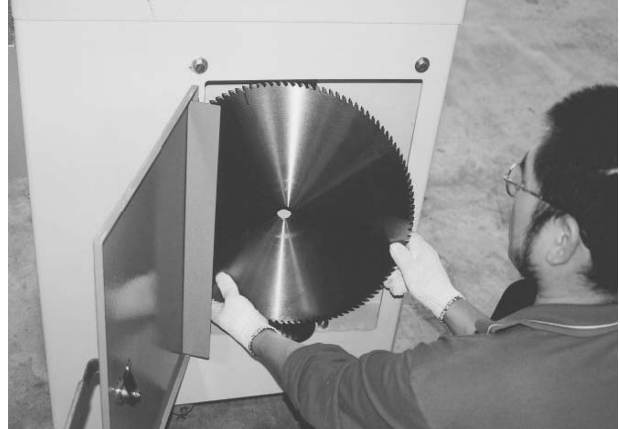
IX. REPLACING THE SAWBLADE (2)

4. Remove sawblade lock screw and flange. Take out the old sawblade.



SAWBLADE

FLANGE



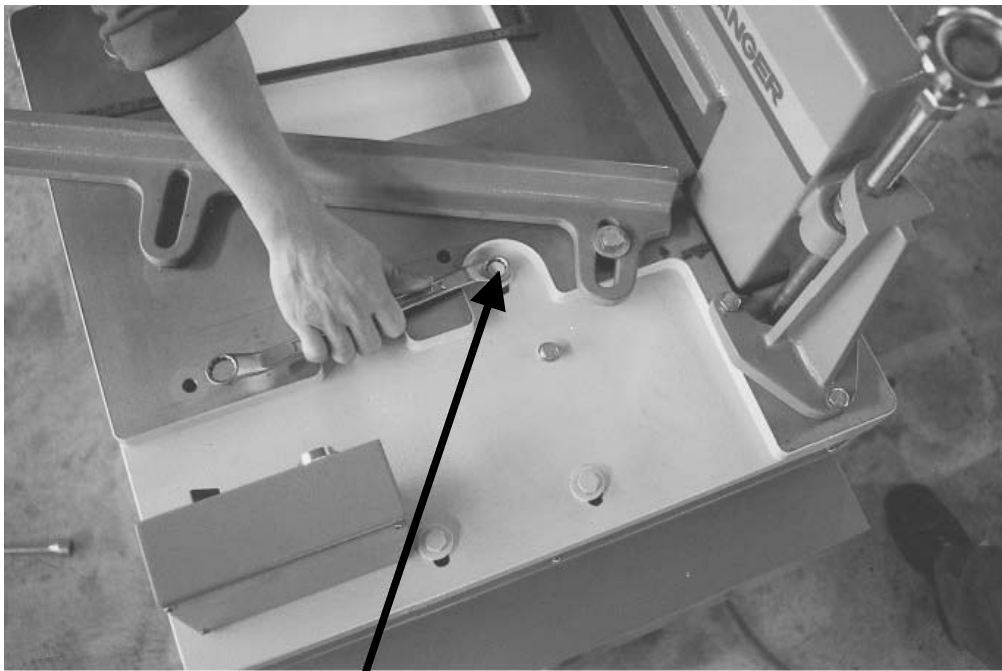
5. Fit a sawblade onto the arbor. Ensure that the arbor and flange are clean of dust and debris before fitting the saw blade.
6. Be sure the saw blade teeth point toward its running direction.
7. Tighten the sawblade securely by using the supplied "T" wrench.
8. Reverse above procedures to return the machine to its original condition.

X. ADJUSTING V-BELT TENSION (1)

After the machine has been operated for a long period, the V-belt tension may loosen gradually. At this time you need to adjust the V-belt tension.

Inadequate tension in the V-belt will cause the belt to slip from the pulley. To adjust V-belt tension:

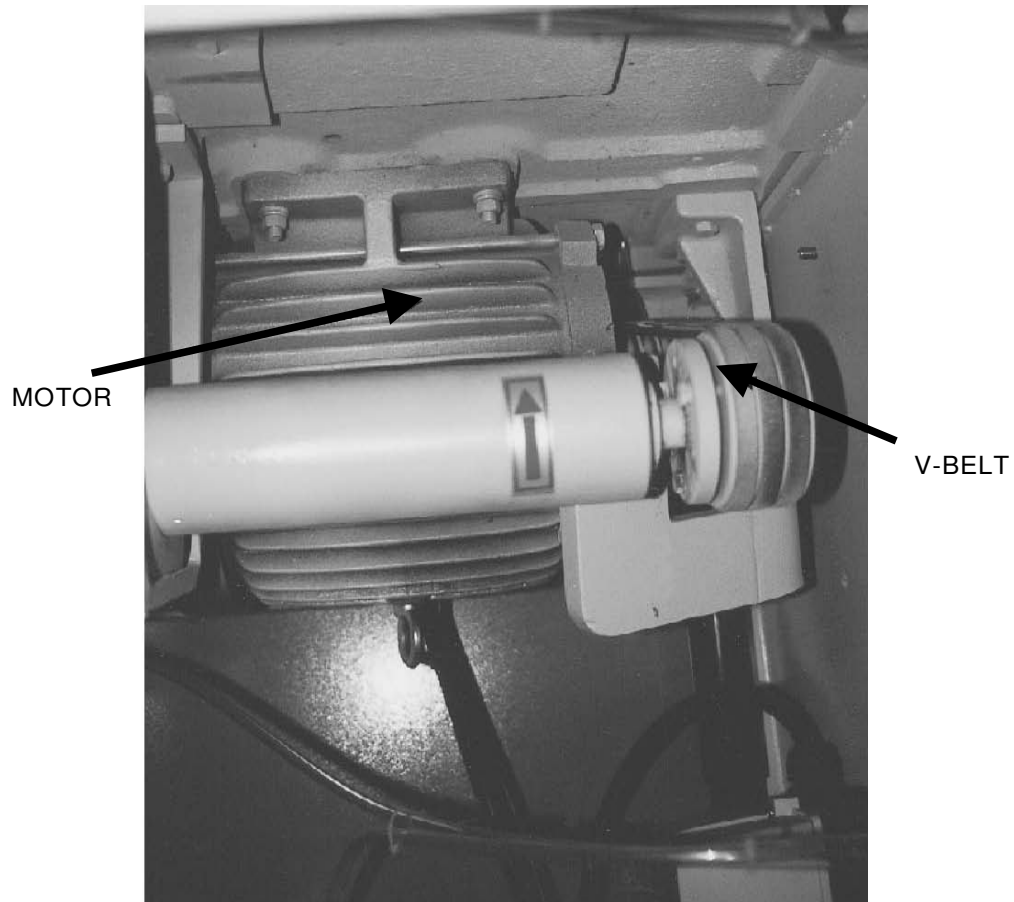
- 1.** Disconnect the machine from the power source.
- 2.** Slightly loosen the 4 screws on the table.



LOCK SCREW

X. ADJUSTING V-BELT TENSION (2)

3. Open the front door by using the supplied door handle.
4. Move the motor forward to increase the belt tension.



5. After V-belt tension is adjusted tighten the 4 lock screws on the table.

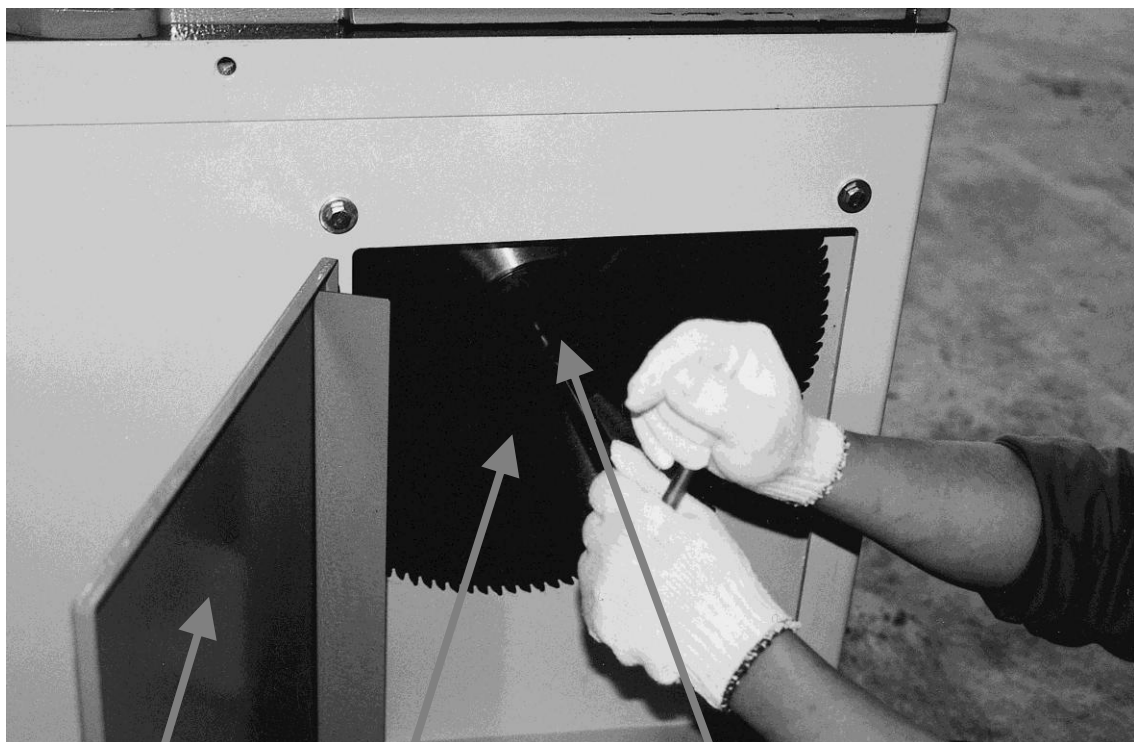
REPLACING THE SAWBLADE (1)



WARNING

Disconnect the machine from power source before replacing the saw blade.

1. Disconnect the machine from the power source.
2. Open the left side door. Use the supplied door handle to turn the door latch for opening the door.
3. Loosen the sawblade lock screw by using the supplied "T" wrench.



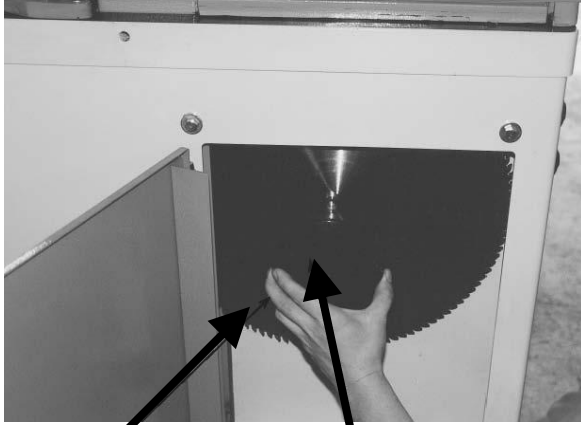
LEFT SIDE DOOR

BLADE LOCK
SCREW

"T" WRENCH

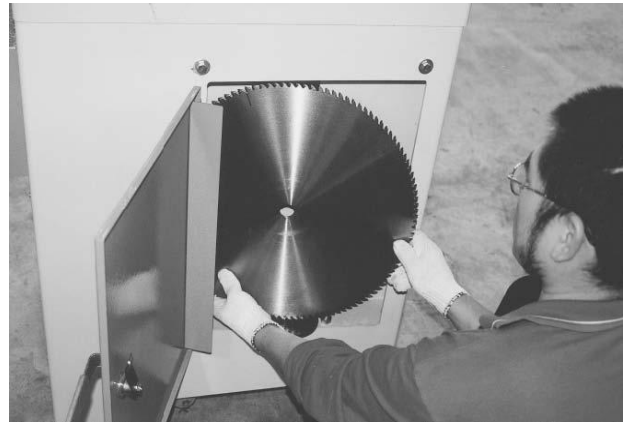
REPLACING THE SAWBLADE (2)

4. Remove sawblade lock screw and flange. Take out the old sawblade.



SAWBLADE

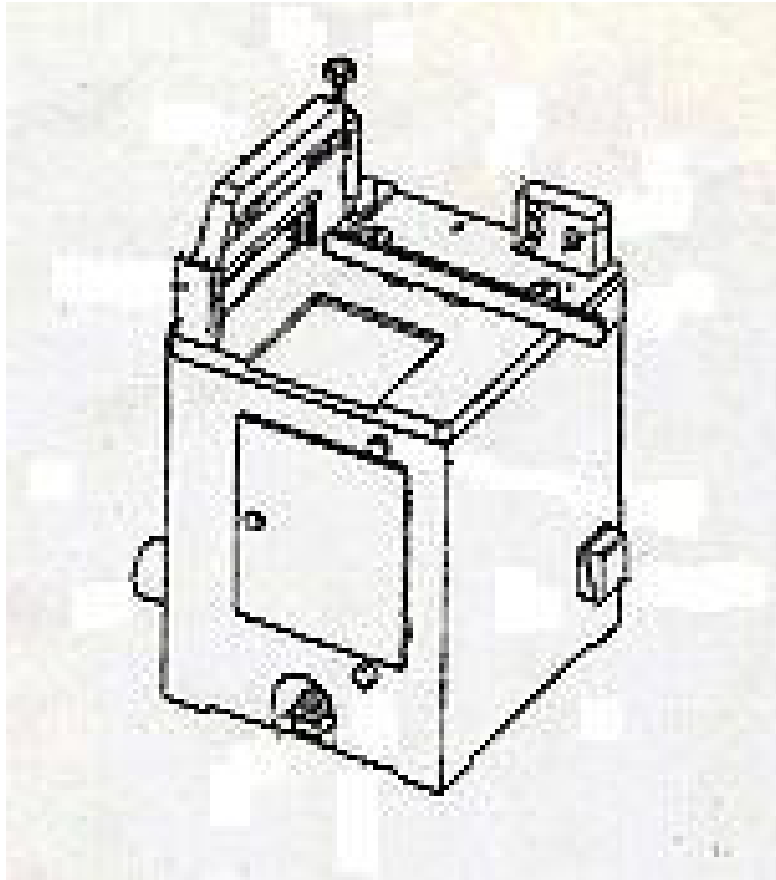
FLANGE

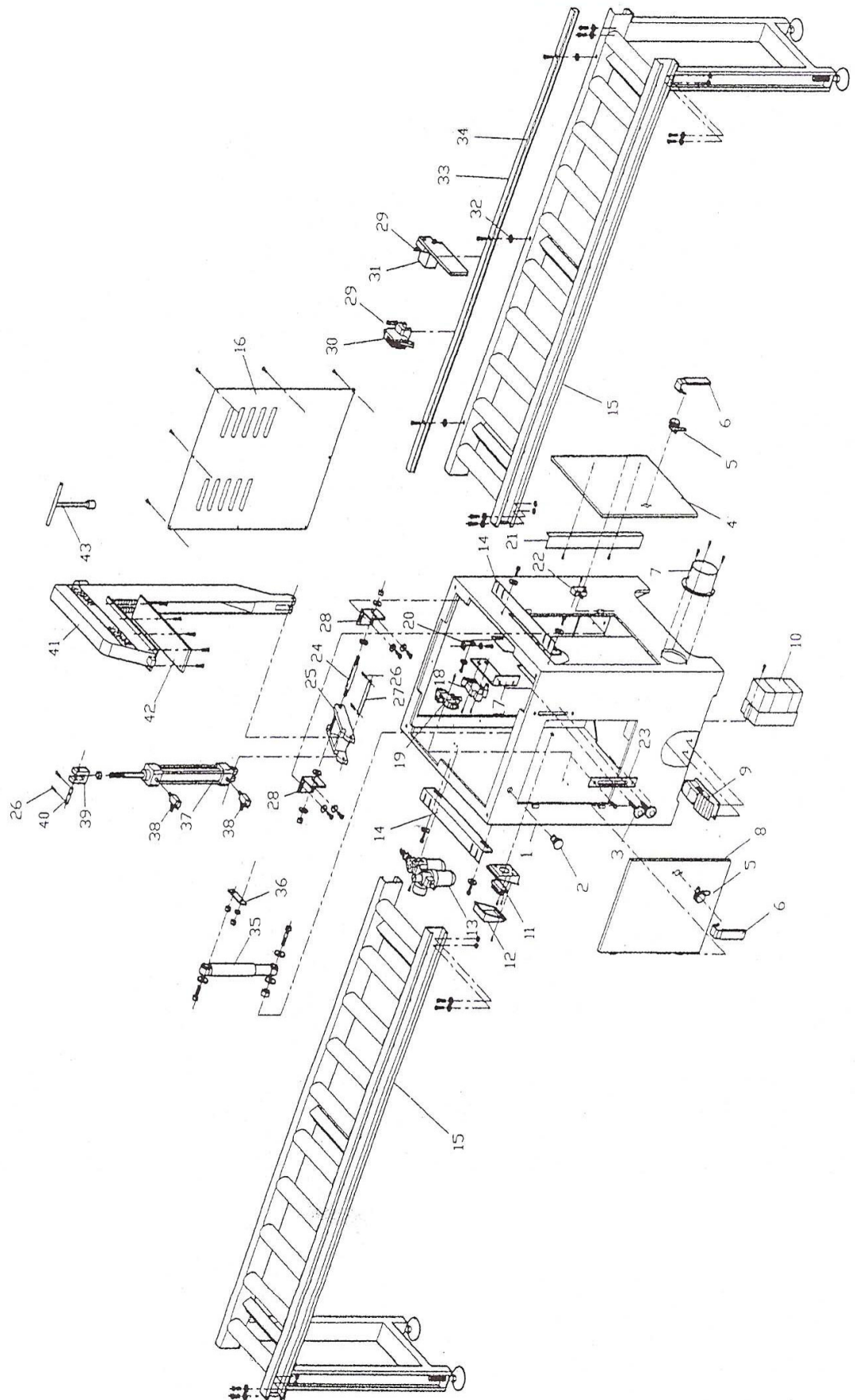


5. Fit a sawblade onto the arbor. Ensure that the arbor and flange are clean of dust and debris before fitting the saw blade.
6. Be sure the saw blade teeth point toward its running direction.
7. Tighten the sawblade securely by using the supplied "T" wrench.
8. Reverse above procedures to return the machine to its original condition.

DIAGRAMS AND PART LISTS

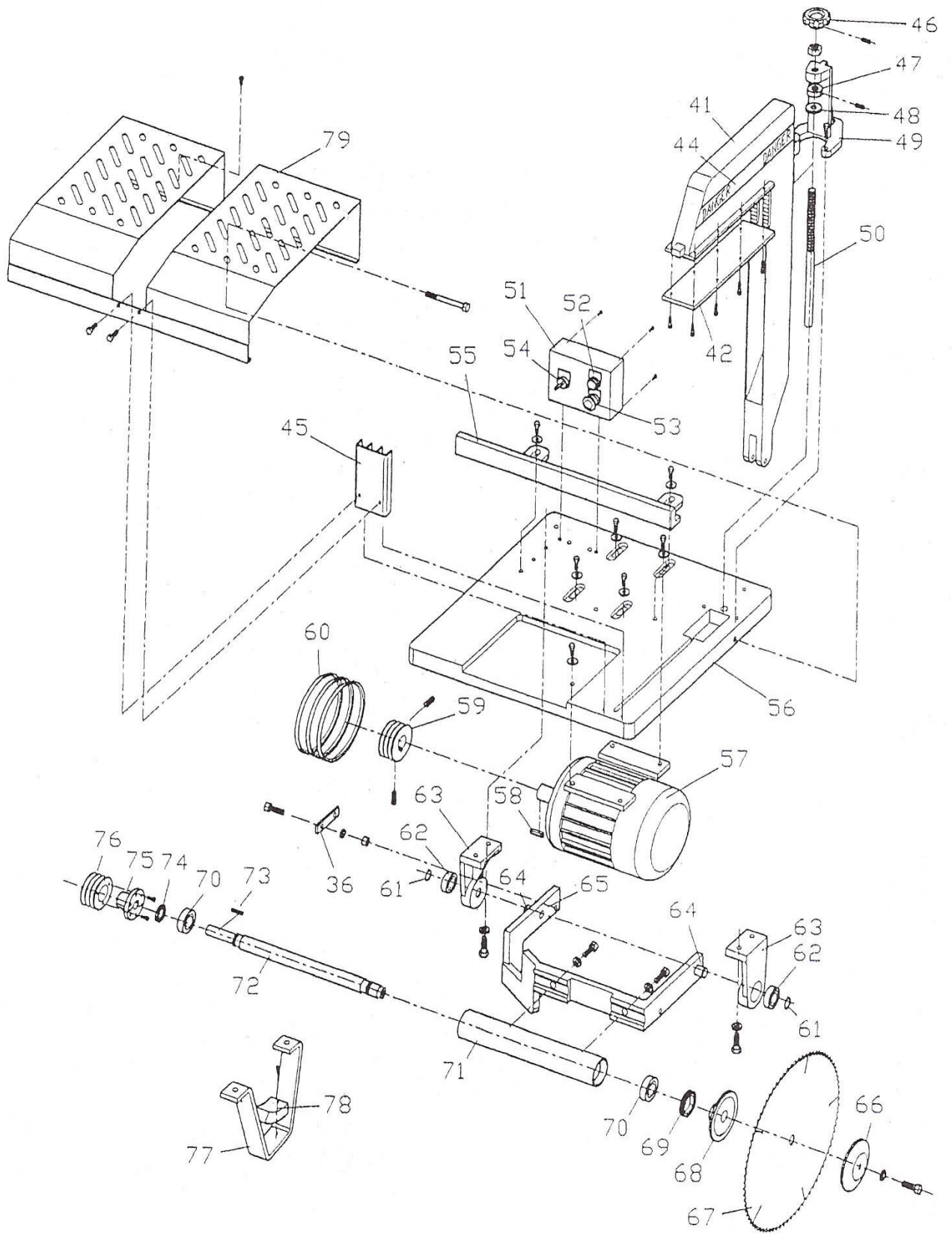
14" CUT-OFF SAW





PART LIST

14" CUT-OFF SAW					
REF	DESCRIPTION	Q'TY	REF	DESCRIPTION	Q'TY
1	Cabinet	1	21	Limit Switch Stop	1
2	Emergency stop S.W.	1	22	Limit Switch	1
3	Lobe knob with 3/8" threaded stud	2	23	Metal Pad	1
4	Side Door	1	24	Stud Bolt	1
5	Door Lock	2	25	Support Frame	1
6	Lock Handle	2	26	Split Pin	4
7	Dust Port	1	27	Coupling Pin	1
8	Front Door	1	28	Support Angle Steel	2
9	Pedal	1	29	Lock Handle 8mm	1
10	Magnetic Switch	1	30	Equal Stop	1
11	Wire Connecting Plate	1	31	Big Stop	1
12	Electrical Box	1	32	Square Washer	3
13	Air Filter-Pressure Regulator – Oil Feeder	1	33	Square Rail	1
14	Connecting plate	2	34	Scale	1
15	Roller Conveyor	2	35	Cushion	1
16	Back Door	1	36	Connecting Link	1
17	Limit Switch Bracket	1	37	Air Cylinder	1
18	Limit Switch	1	38	Pressure Regulating Valve	2
19	Solenoid Valve	1	39	Toggle	1
20	Bracket	1	40	Coupling Pin 1/2" x2"	1
			41	T-clamp	1
			42	Gasket	1
			43	Socket Wrench 19mm	1



PART LIST

14" CUT-OFF SAW					
REF	DESCRIPTION	Q'TY	REF	DESCRIPTION	Q'TY
41	T-clamp	1	61	C-Ring	2
42	Gasket	1	62	Bearing 6205zz	2
43	Socket Wrench 19mm	1	63	Bracket	2
44	Danger Label	2	64	Shaft	2
45	Safety Appurtenance	1	65	Suspension Bran	1
46	Lobe Knob	1	66	Flange Washer	1
47	Lock Nut	1	67	Saw Blade	1
48	Rubber Ring	1	68	Inside Flange	1
49	Adjustable Seat	1	69	Locknut	1
50	Guide Screw	1	70	Bearing 6206zz	2
51	Switch Box	1	71	Quill	1
52	On Button	1	72	Main Spindle	1
53	Stop Button	1	73	Key	1
54	Air Inlet Switch	1	74	Locknut-Left	1
55	Fence	1	75	Tapper Flange	1
56	Table	1	76	Drive Pulley	1
57	Motor	1	77	Lower Bracket	1
58	Key	1	78	Lower Damper	1
59	Motor Pulley	1	79	COOLANT TANK	1
60	V-belt MF1300	3			