SI16WA · WF
SW · SF · F

SEGA CIRCOLARE A LAMA INCLINABILE
CIRCULAR SAW WITH TILTING BLADE
SCIE CIRCULAIRE A LAME INCLINABLE
KREISSÄGE MIT SCHWENKBAREM SÄGEBLATT

USO E MANUTENZIONE
OPERATION AND MAINTENANCE
FONCTIONNEMENT ET ENTRETIEN
BETRIEBS- UND WARTUNGSANLEITUNG

scm

ENGLISH

This handbook gives you all informations required for the correct use of the machine, in this way you avoid damages to production and equipment.

SCM Service is always at your disposal not only for technical assistance but for any problem concerning the development of your business too.

SCM reserves the right to introduce, at any moment without obligation to timely update this Manual, modifications in the components or equipment supplied, as dictated by contingent requirements of a technical or commercial nature.

In addition, the parts added, such as the protections, accessories etc. can differ to conform to the laws and special requirements of the countries to which the machines are to be supplied.

The illustrations and the data contained in this manual are not binding.

EDITION 04/88 Print No. 0000502043H

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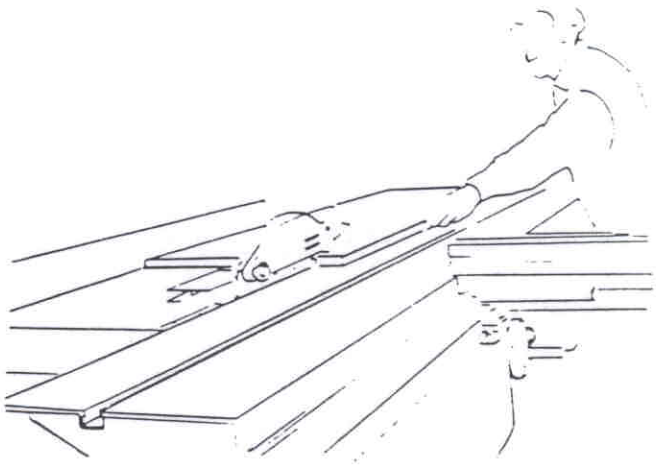
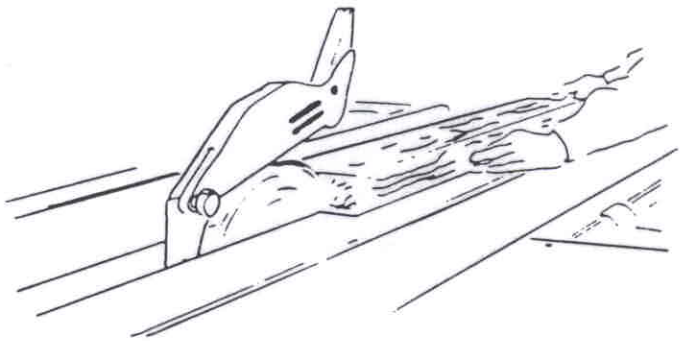
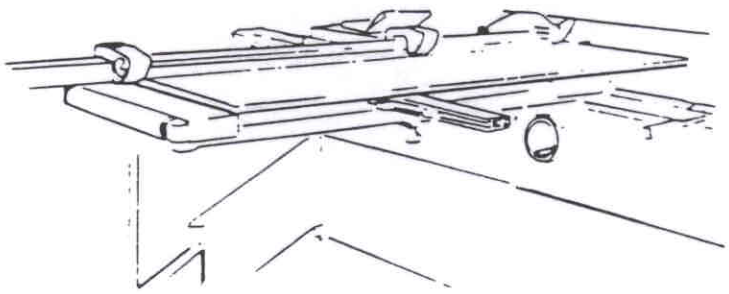
PANEL CUT TO SIZE



CUT TO OBTAIN LEDGES



PANEL SQUARING



GENERAL INFORMATION

MACHINE IDENTIFICATION

Model and serial number stamped on the metallic plate applied on machine frame

MACHINE CONTACT

In writing or telephoning to the selling dealer or to SCM on any matter relating to the machine, always include following information:

- Machine model
- Serial number
- Selling dealer
- Detalied description of failure
- Detailed information of particular working to carry out
- Working period number of working hours

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SAFETY WARNINGS

1. THIS IS A DANGEROUS MACHINE BE CAREFUL. Only skilled operators should use this machine or be within twenty feet when the machine is in operation
2. Read the Operations Manual carefully before operating.
   An Operations Manual should be attached to this machine.
   It contains important information and warnings concerning the use and operation of this machine.
   Improper use of this machine may result in serious injuries to persons and fires.
3. Never operate this machine without the safety shields and guards in their proper place.
   Operate this machine only when the doors and covers are in their proper protective position.
4. Before attempting oiling, cleaning, adjusting, maintenance or repair, turn off this machine and disconnect this machine from its power source.
   Failure to disconnect this machine from its power source could result in electrocution or other injury.
5. Keep all body parts away from the moving parts of this machine, whether it is an operation or at rest.
6. Be certain that this machine is properly grounded before operating it.
7. Do not place hands or fingers between the workpiece and the conveyor belt, near the feed rolls, or near the blades or cutters at any time. Always use a pusher device when undertaking close work.
8. Do not wear gloves or loose clothing (such as sweaters, jackets or jewelry) when operating or standing near an operating machine. Remove any loose clothing and all jewelry when feeding or working near a machine in operation.
9. Do not stand in line with work piece when feeding or unloading this machine
10. Always wear protective eye wear when operating or standing near an operating machine
11. Never overlap or double feed parts; always keep this machine properly adjusted for the work undertaken.
12. Do not run sparking materials (such as steel) with combustible materials (such as aluminium and magnesium dusts); a fire may be the result.
13. Always keep the area around this machine clean and uncluttered. Poor housekeeping could result in slips and falls or other injuries.
14. Concentrate at all times. Failure to pay attention to the task at hand is the cause of most accidents.
15. DO NOT REMOVE THESE WARNINGS. They are permanently affixed to this machine to warn you and all future users of the inherent dangers of this machine.
    Removal may result in injuries to you or to others for which you might be responsible.

GENERAL INFORMATION

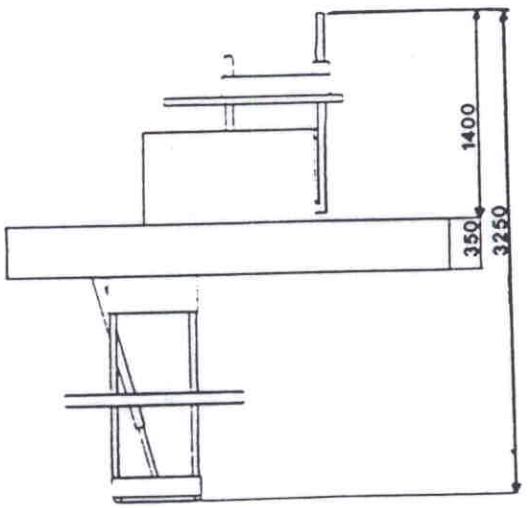
TECHNICAL DATA

SPECIFICATION FOR STANDARD MODEL

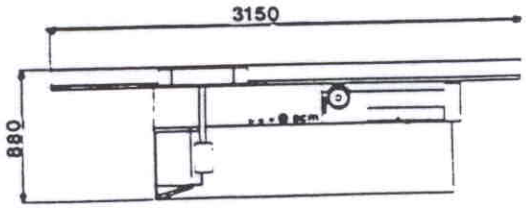
Working table height from floor	880 mm
Saw blade tilting	90°-45°
Max. cutting height (with standard saw blade) at 90°	110 mm
at 45°	75 mm
Saw blade speed	3200/4500/600 rpm
Scorer blade speed	9800 rpm
Cut width with parallel fence	1000 mm
Saw unit motor (standard)	4 kW (5.5HP)
Scorer motor	0.75 kW (1 HP)
Min. saw blade diameter	200 mm
Standard saw blade diameter	350 mm
Max. saw. blade diameter	400 mm
Scorer blade diameter	120 mm

FEATURES FOR DIFFERENT MODELS

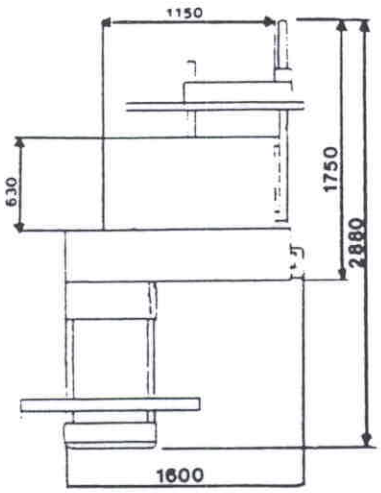
SI16WA-SI16WF



Rolling table stroke	3400 mm
Max. squaring length with scorer	3200 mm
Net weight SI16WA	960 kg
Net weight SI16WF	830 kg

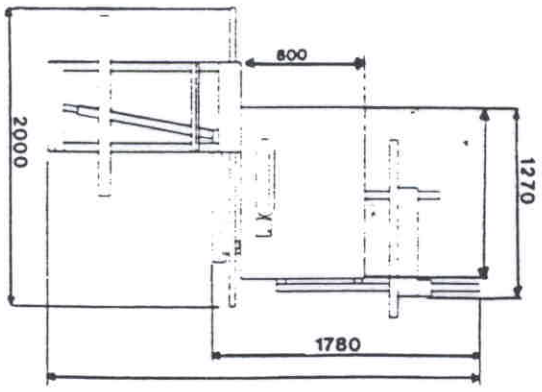


SI16SW



Rolling table stroke 2000 mm
Max. squaring lenght with scorer 1800 mm
Net weight 557 kg

SI16SF

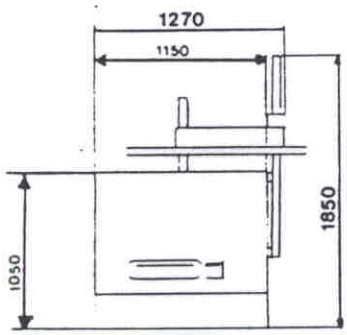


Squaring table stroke 1400 mm
Max. Squaring length with scorer 1230 mm
Net weight 574 kg

TECHNICAL DATA

SI16F

Net weight 585 kg



MAIN OPTIONALS

1) Independent scorer
2) Cut width with parallel fence up to 1500 mm
3) Reader for fence position
4) Only for SI16WA: pressure cylinders with centralized control
5) Only for SI16WA: second table sliding on rail
6) For all models but SI16F: Goniometric square with aluminium telescopic rule with 2 stops
7) Table extension
8) Saw motor up to 7.5 kW (10HP)
9) Hood behind the saw

CONTENTS

LIFTING AND UNLOADING MACHINE

Before unloading take off all parts rested on the machine for packing and shipping requirements.
Raise the machine using a crane or other lifting device as shown in **fig.1**: avoid sudden movements.

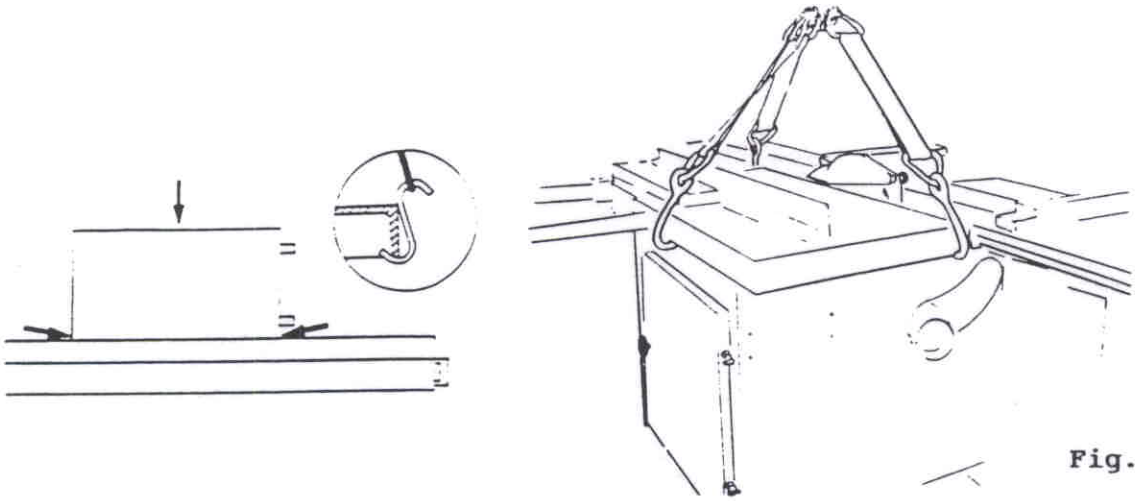


Fig.1

If the machine is equipped with socles or pallets it may be raised by a truck inserting the forks under the frame: see figure 2.

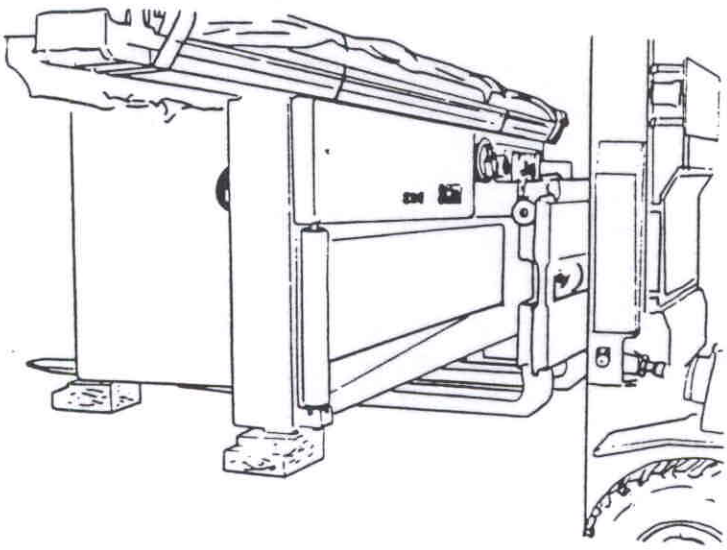


Fig.2

If no lifting device is available, let the machine slide on strong boards supported by stands **(fig.3):** check the machine sliding by ropes stretched by the motor vehicule table.

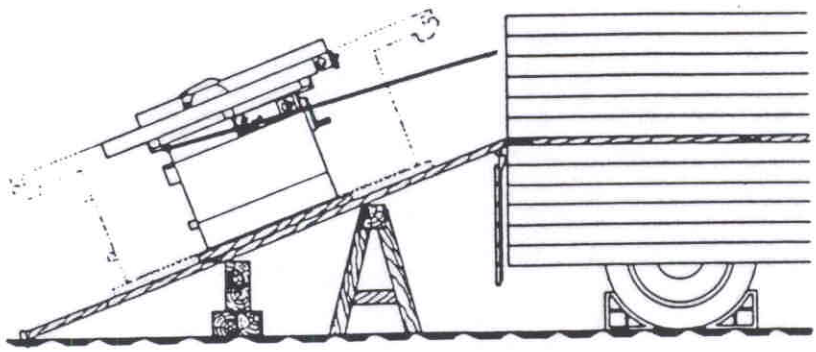


Fig.3

INSTALLATION

ELECTRIC CONNECTION AND GROUNDING

Before connecting the machine make sure the motor rating agrees with the electric system and the mains voltage corresponds to the machine's one.
Connect the 3 cables to terminals **(L1-L2-L3 fig.4)**, the earth cable (yellow-green) to terminal **(PE or ⏚ fig,4)** and the neutral cable to terminal **N**.

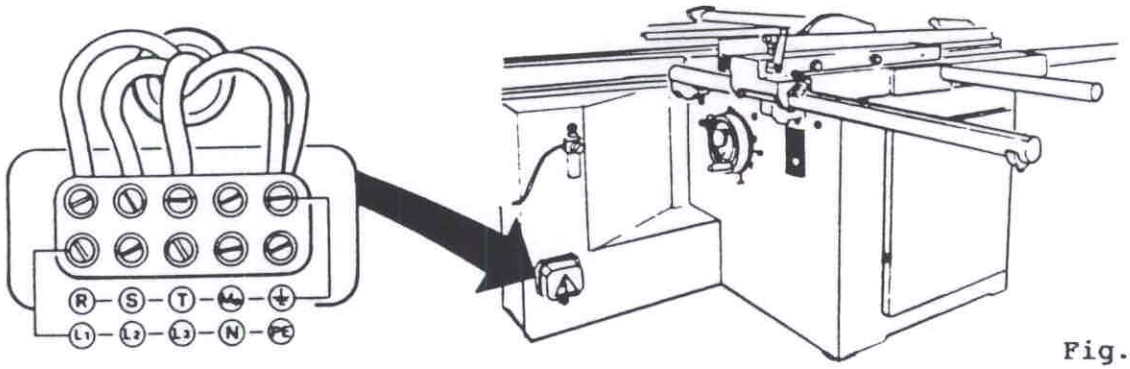


Fig.4

Check the direction of spindle rotation: the saw blade shall rotate in the direction opposite the workpiece feed: for this purpose start the machine as indicated on page 36.
If the saw blade rotation is not right:1

1) Cut out the voltage
2) Reverse two phases in the terminal board

CONNECTION TO THE SUCTION SYSTEM

Connect the exhaust hood to the suction system with a hose: external diameter of the hood 120 mm **(fig.5)**.

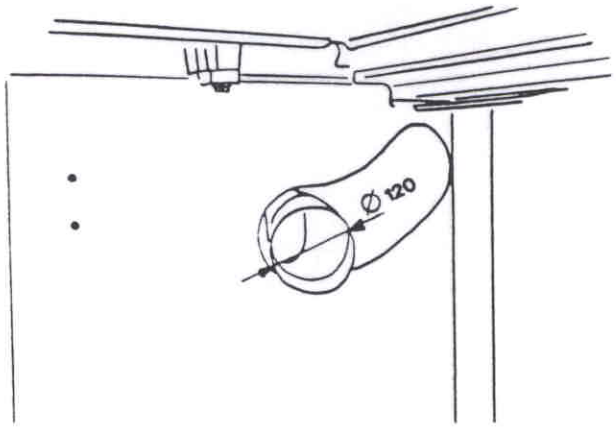
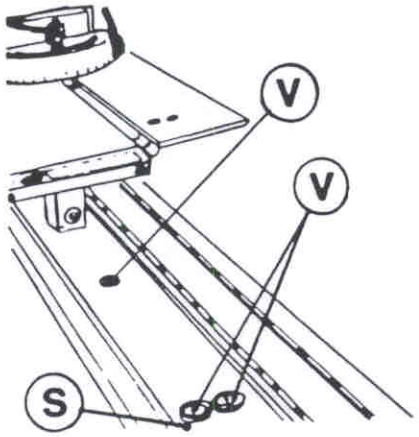


Fig.5

FITTING ROLLING TABLE AND SQUARING TABLE (SI16WA - SI16SW - SI16WF)

1) Insert pins **(S fig.6)**
2) Tighten screws **(V fig.6)** for SI16WA and SI16SW models, close the hole with plug **(T)**
3) With SI16WA and SI16SW models remove plugs **(Z)**

SI16WF



SI16WA

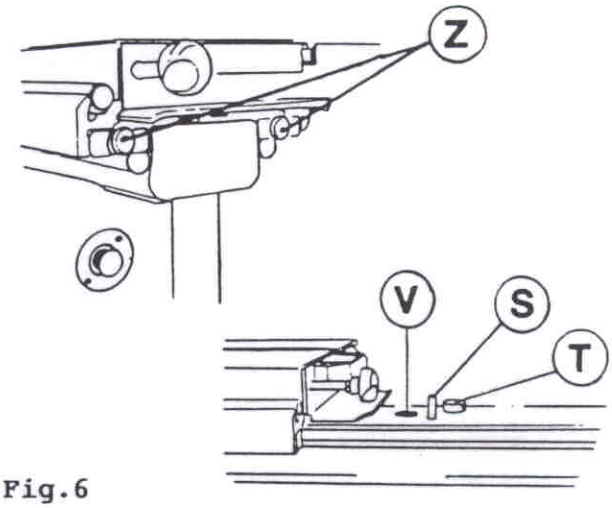


Fig.6

Pivoting support **(B fig.7)** is fastened to frame by means of square support **(A)** and screw **(V)**.

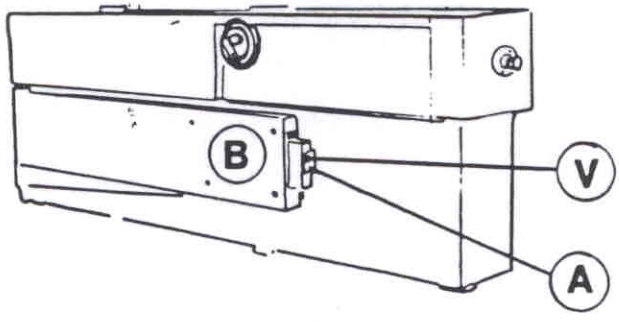


Fig.7

INSTALLATION

Fit the squaring table on rule (R) and lock it in position with knob (P fig.8)
Insert pivot (S fig.9) into the pivoting support end, then rest the frame on it.

SI16WF **SI16WA**

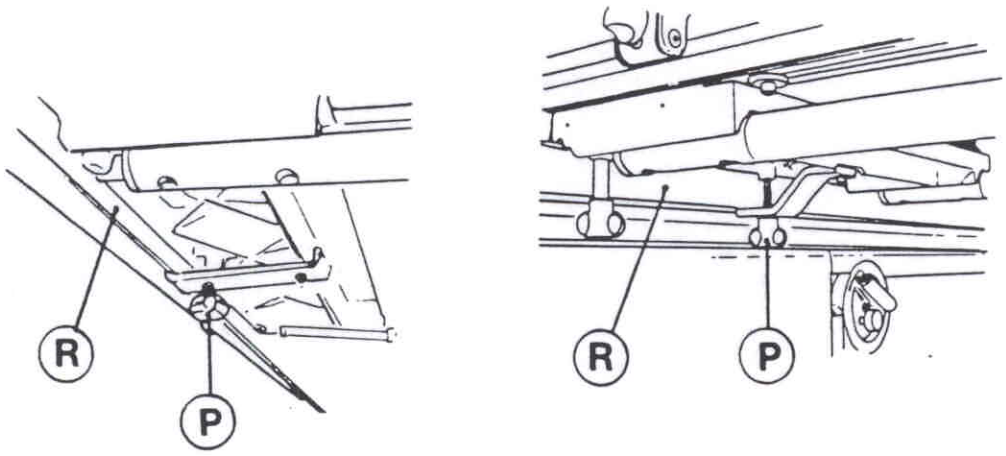


Fig. 8

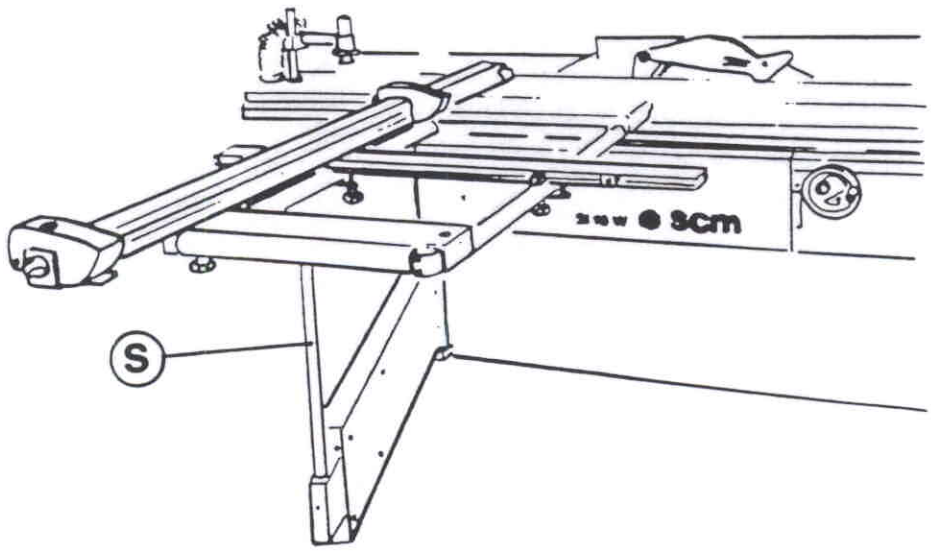


Fig.9

FITTING RESTING RULE

1) Insert pivots **(P and P1)** into holes **(F and F1)**
2) Lock the fence on the table by inserting the 2 knobs **(S)** into the bottom table part, then screw the knobs into the inside threading of pivots **(P and P1)**
3) Fit stops **(B and B1 fig.10)**

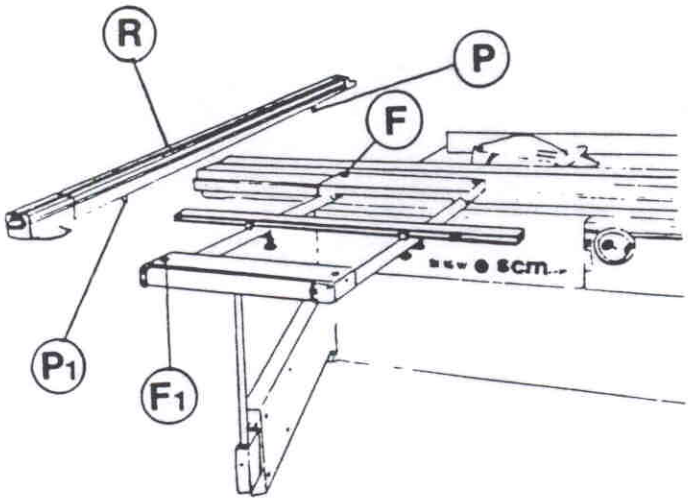
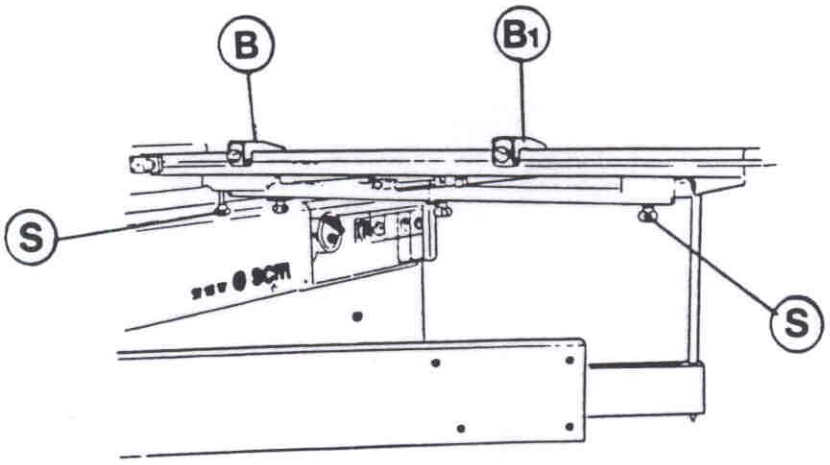


Fig.10



INSTALLATION

FITTING FENCE FOR PARALLEL CUTS

Fasten toothed rod **(D)** to parts **(A)** with the two screws **(V)**
Fit rear rod **(B)** so that its cylindrical surface is flush with the worktable.

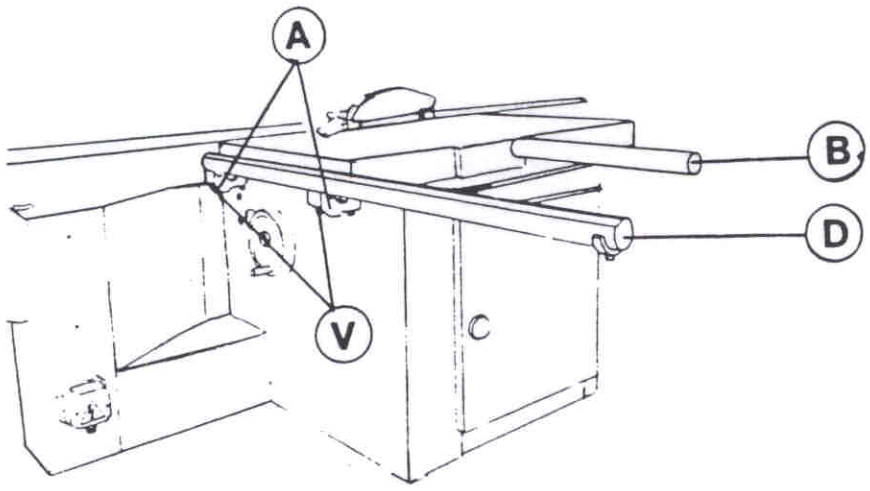


Fig.11

- Fit support **(S)** to rod **(D fig.12)**
- Fit fence **(G)**, adjust the length, then fasten it by two grips **(M fig.12)**

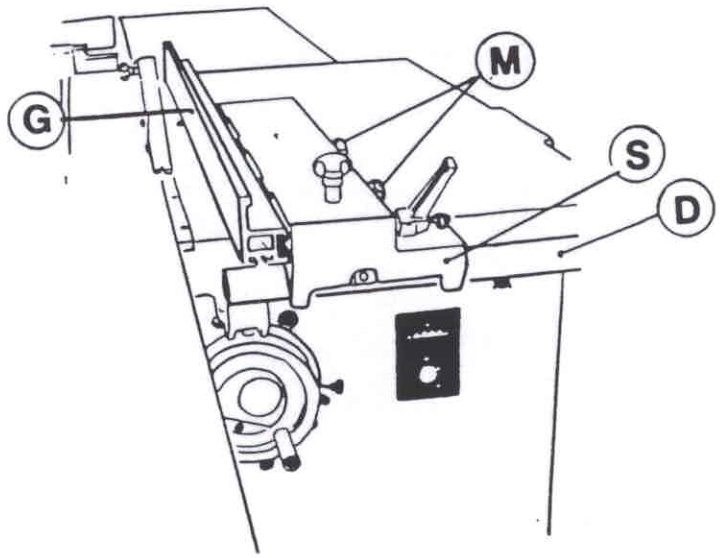


Fig.12

FITTING SQUARING TABLE (SI16SF)

Fasten rod **(B)** to table with screws **(V fig.13)**
Fit table **(T)** to rod **(B)** by holding it overturned to avoid the contact with screws **(V fig.13)**.
Set it in normal position see **fig.14**, then fit pivot **(P)** into one of the holes at the table ends.

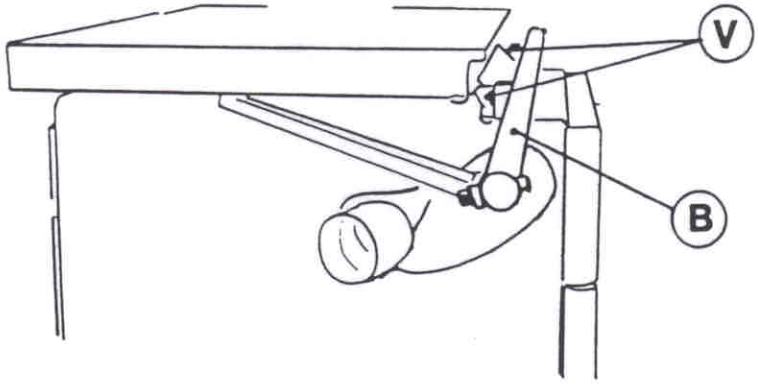


Fig.13

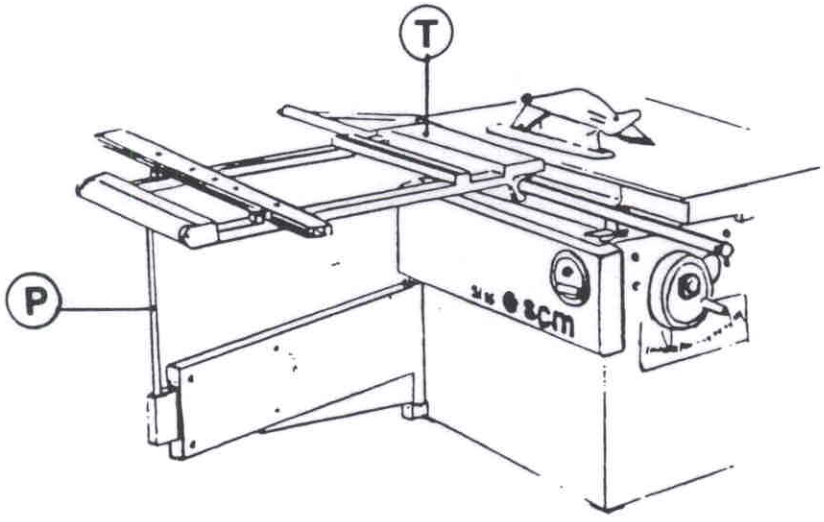


Fig.14

For fitting the resting rule and the fence proceed in the same way described for other models.

INSTALLATION

FITTING THE MITRE GAUGE (SI16F)

Fit mitre gauge **(S)** into the table groove, then fasten it by screw **(C)**.

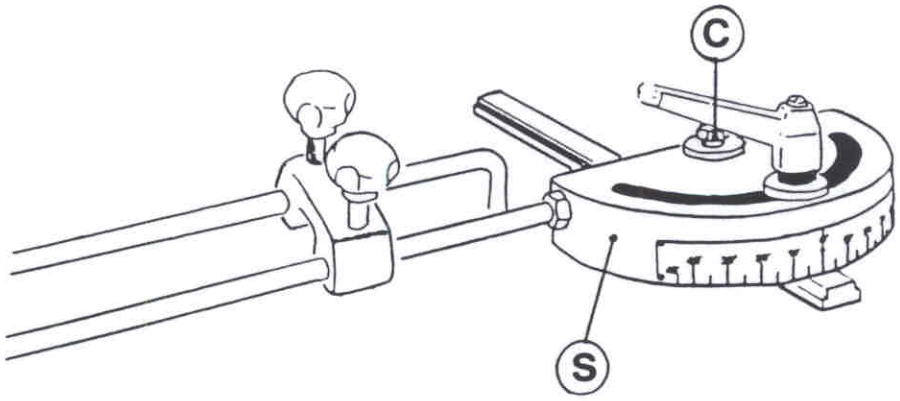


Fig.15

FITTING SAW BLADE AND GUARD

To fit or to replace the saw blade lift saw spindle to extreme position by handwheel **(V fig.16)**

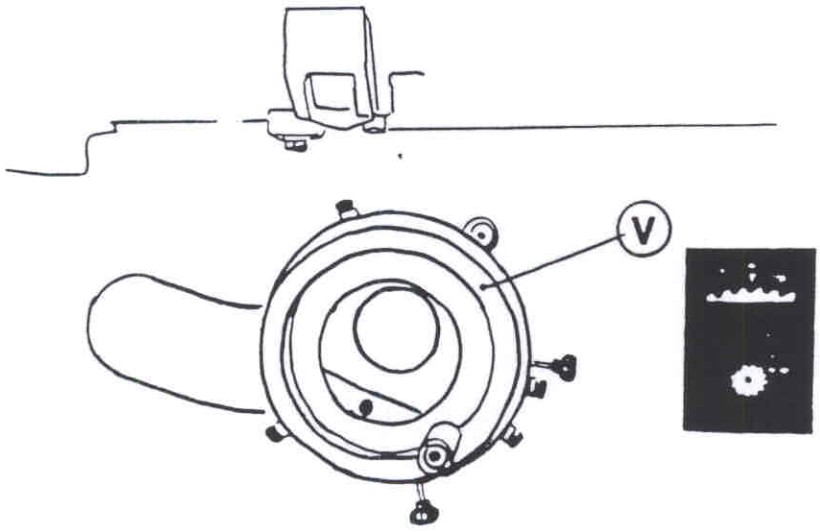


Fig.16

Push the button **(A fig.17)** from table hole and turn spindle at the same time in order to lock it.
To unscrew the screw which tightens the saw blade, turn it clockwise.

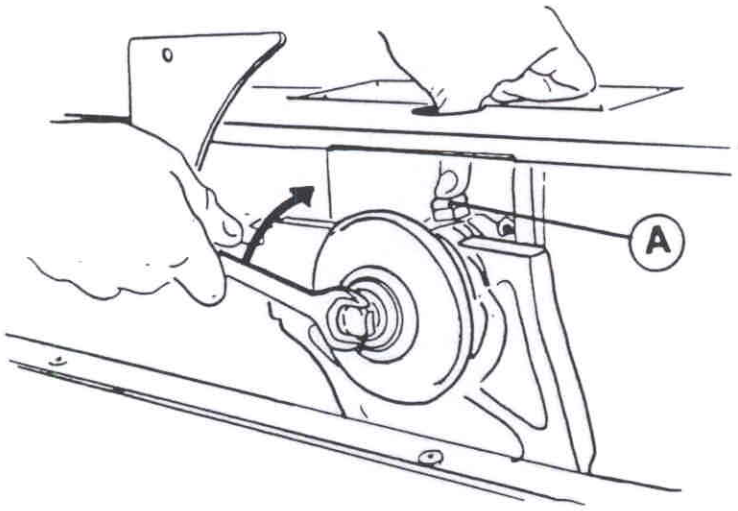


Fig.17

Unscrew screw **(E fig.8)**, take off washer **(R)** and flange **(F)**.
Check that the 2 flanges **(F)** are clean.

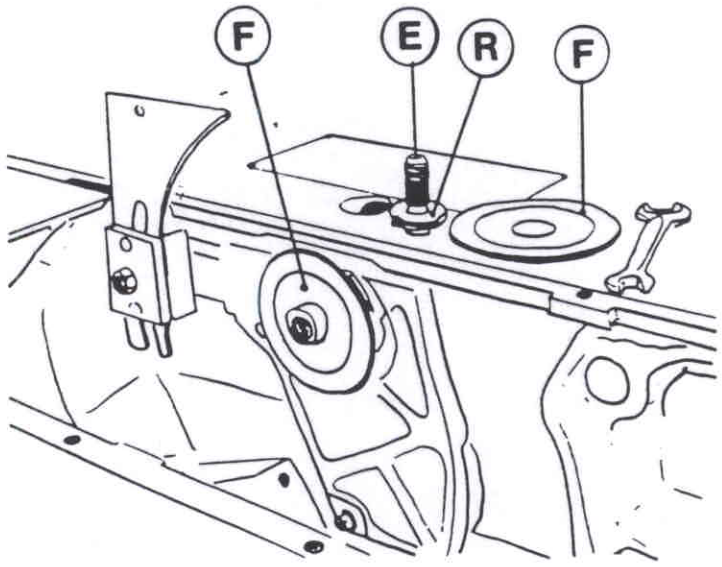


Fig.18

Press button **(A)** again then tighten screw as shown in **fig.19**

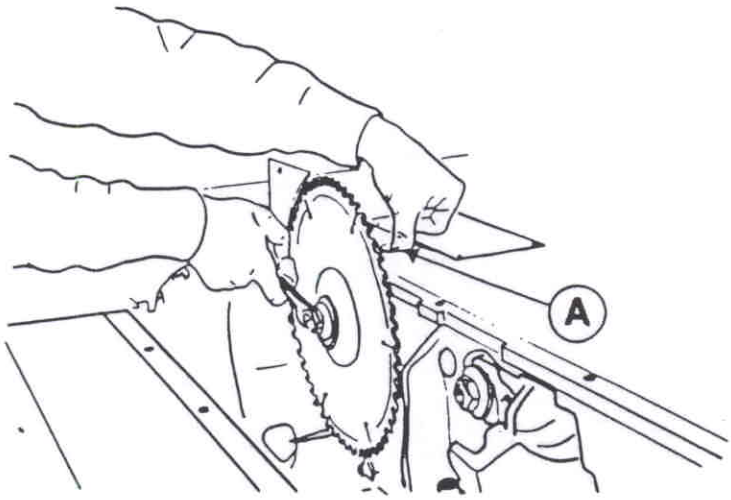


Fig.19

After fitting the saw blade, fit hood **(B fig.20)** and bottom cover (C)

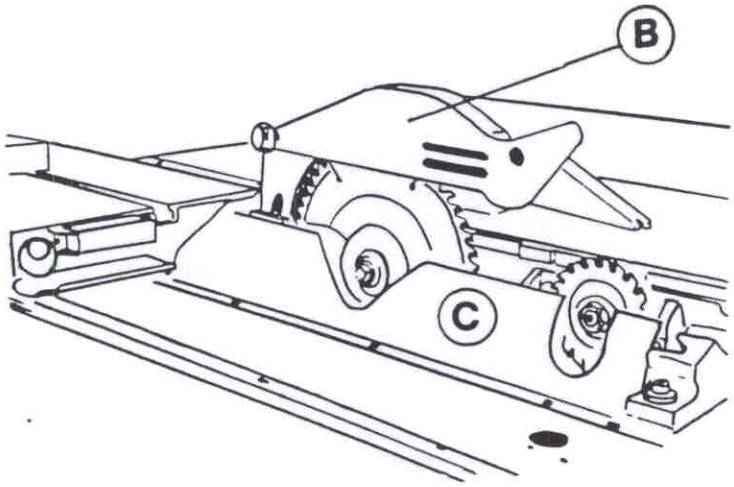


Fig.20

Fig.21 shows another guard type

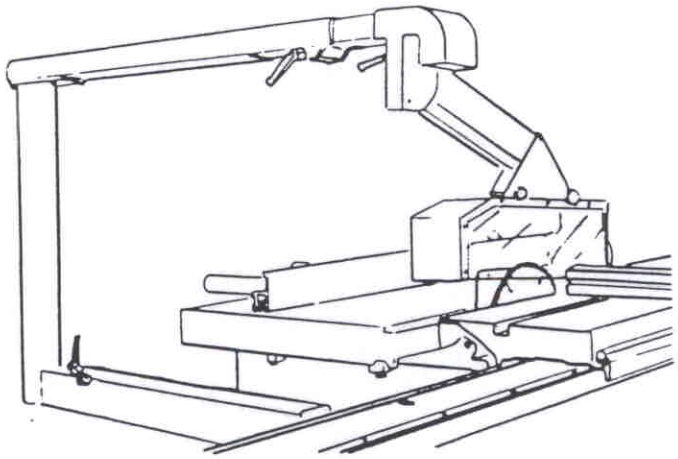


Fig.21

NOTE: The riving knife with a 3 mm thickness fits well in the case of 250 mm blades.
If you use blades of different diameter, you have to replace the riving knife.

FITTING SCORING BLADE

- Lock spindle by means of 8 mm Allen wrench (C fig.22)
- Loosen nut (D): right-hand thread

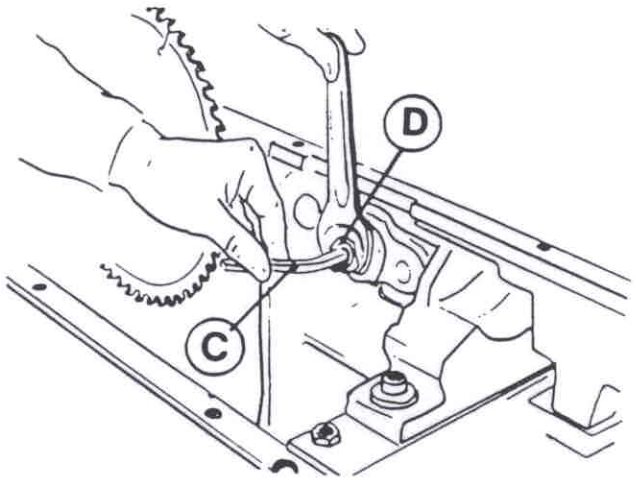


Fig.22

Take off nut (D fig.23) and one flange (F): check that flange (F) as well as scoring blade are clean.

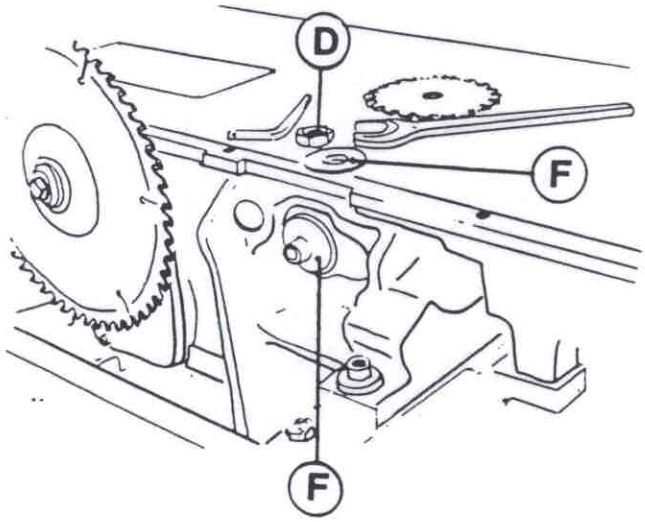


Fig.23

Fit the blade, the flange and the nut, then after locking the spindle as described previously tighten nut **(D fig.24)**

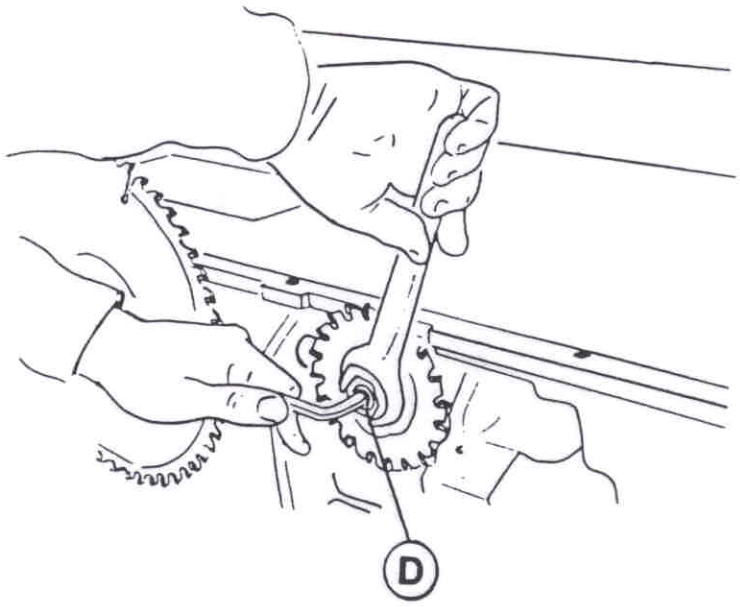


Fig.24

CONTENTS

CONTROL BOARD

It depends on the machine version as well as the regulations of the different countries.

A- Padlockable main switch
B- **O-Y-△** change over switch for starting the saw blade
C- Push buttons **ON -OFF** of thermomagnetic protection (saw motor)
D- Push buttons **ON-OFF** of thermomagnetic protection (scorer motor)
E- Display for saw and scorer speed
F- Selector to lock and release the saw motor brake
- turn selector to the left →(•)← to reach the working position
- turn selector to the right ←(•)→ to loosen the brake

G- Pilot lamp: it shows the brake is released
H- Knob to reach the fuses housing

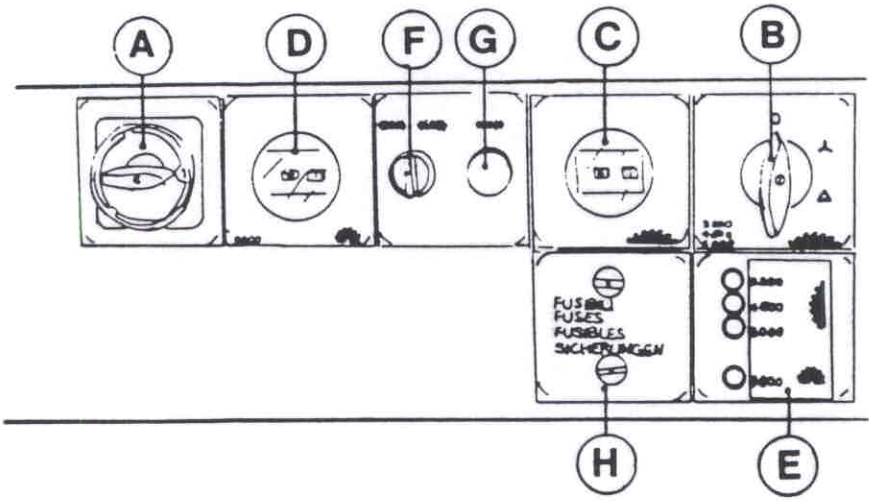


Fig.25

MACHINE START

1) Turn main switch **(A)** to position **1**
2) Press button **ON (C)**
3) Turn change-over switch **(B)** to position **Y** until the spindle reaches the right speed, then turn selector to position △
4) Press button **ON (D)** to start the scorer (if the machine is not equipped with thermomagnetic protection the scorer start occurs by means of commutator 0-1)

LIFTING AND TILTING THE SAW BLADE

Turn handwheel **(V)** clockwise to raise the blade: the saw blade height is right when it exceeds the workpiece thickness 1-1.5 cm. After the adjustment, lock handwheel **(V)** by knob **(G fig.26)**

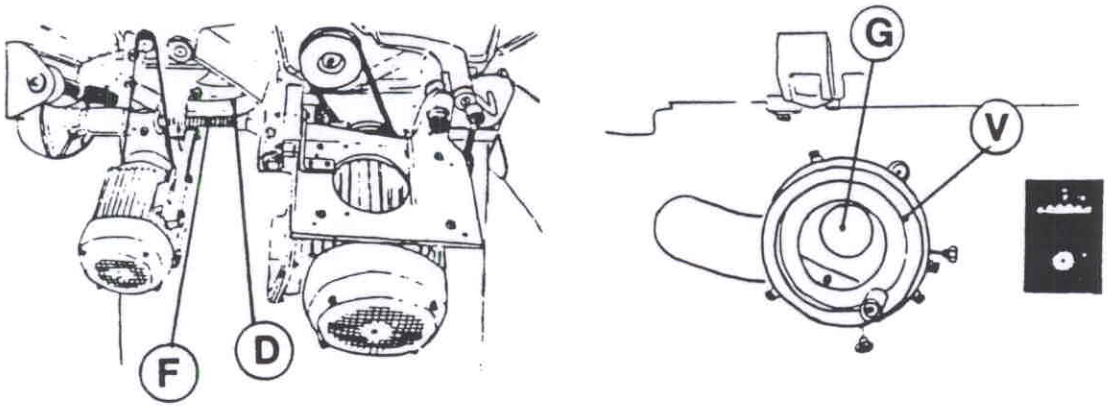


Fig.26

By means of handwheel **(L)** the blade may be tilted up to **45°**: a complete turn corresponds to a **2°** tilting.
Read the tilting angle on plate **(T)**, then lock with knob **(B)**.

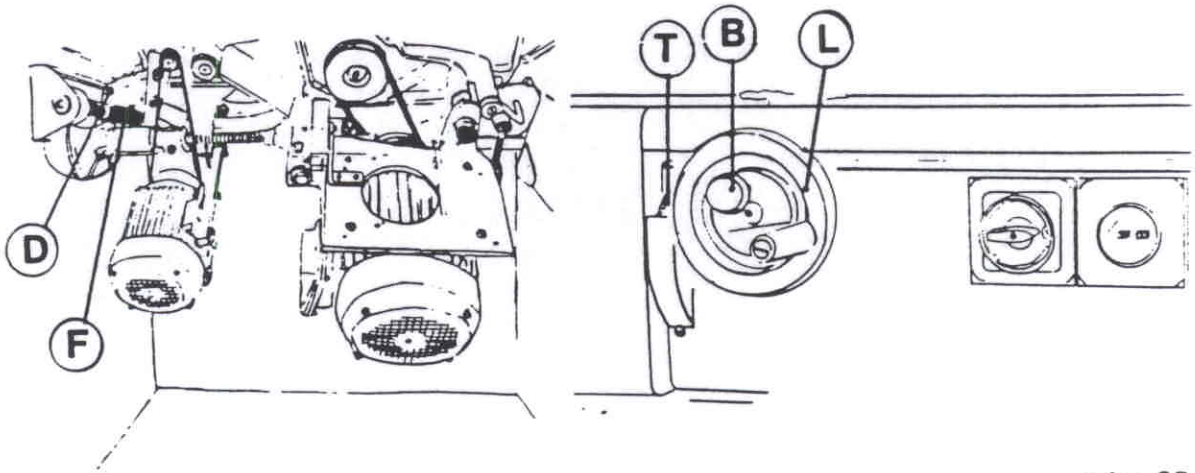


Fig.27

SETTING UP AND USE

SCORER USE

If both edges of the panel are to be finished, you have to use one of the following tools:

1) Scoring blade with the thickness equal to the saw blade's one **(fig.28)**
2) Double cutter by inserting shims between the two elements **(fig.29)**
3) Conic scoring blade which enables the alignement with blades of different thickness or to obtain on the two edges of the panel two chamfers **(fig.30)**
   If the panels are very long and not perfectly straight the chamfers may be not uniform.

Fig.28

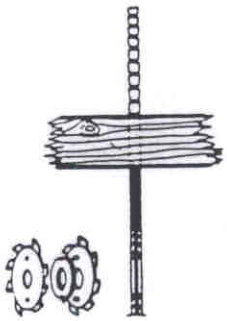


Fig. 29

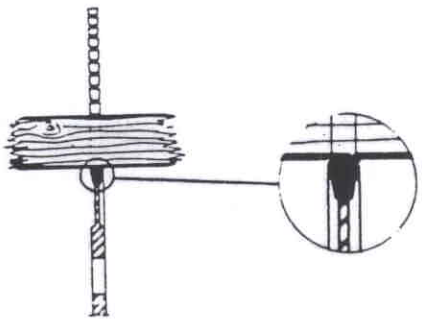


Fig. 30

SCORER ADJUSTMENT

Scorer height adjustment

- Loosen handle **(M fig.31)** and turn it counterclockwise to sto
  (B)
- Stop **(B)** may be positioned round disk **(D)** by loosening its kno

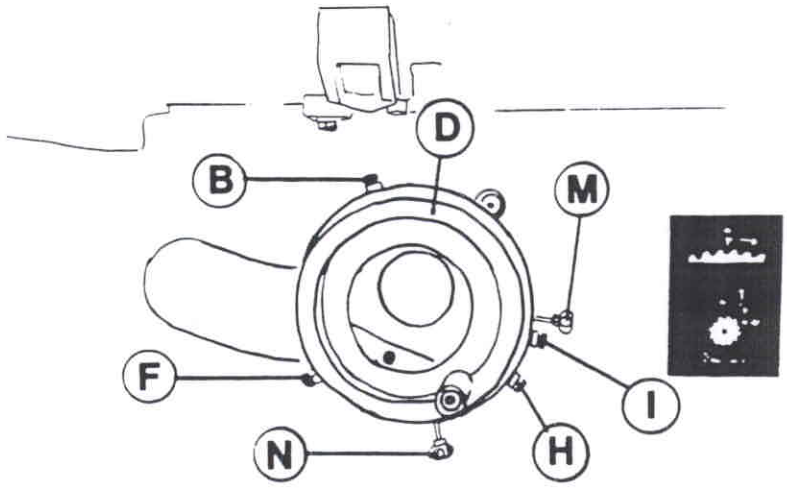


Fig.3

Alignement with the main saw

- Loosen handle **(N)** and turn it until the scorer is aligned wit
  main saw: try with cutting test
- Lock handle **(N)** and position end stop **(Fig.31)** against it
  End stops **(B,F,H,I)** are reference stops to obtain the bes
  working conditions when you have to fit the scorer again
  The two fixed end stops on disc **(D)** limit the movement o
  handle **(N)**: in this way the scorer does not come in contac
  with the worktable or with the rolling table.

GUARD ADJUSTMENT

Guard **(fig.32)** is fitted to riving knive by means of knob **(B)**. Never take off the guard and position it so that the saw blade is completely covered.

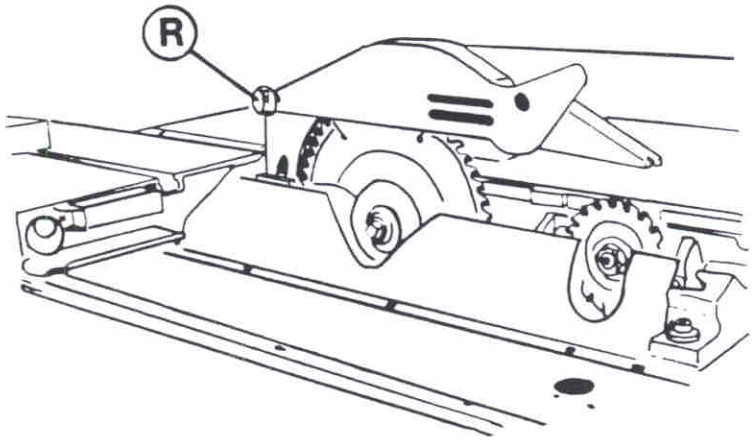


Fig.32

The machine may be equipped with a special guard (1000 or 1500 mm arm),

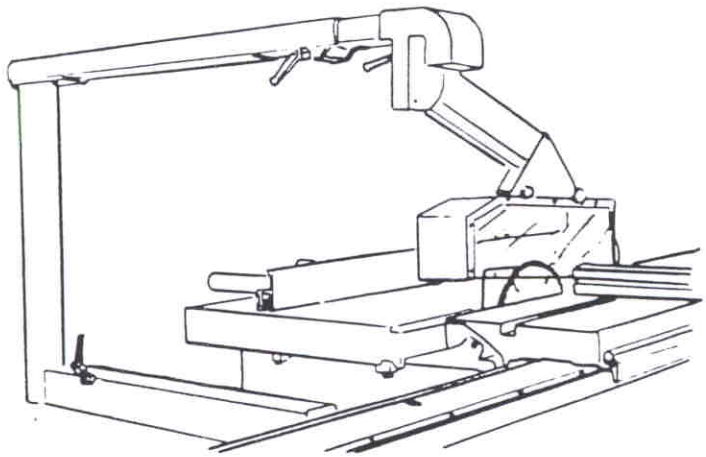


Fig.33

SETTING TO ZERO THE REST RULE

- Lock stop **(B)** on the rule by knob **(P)** in any position (f.e 25 mm)
- Rest a mason's rule against a saw tooth and move the rest rule so that the distance from the left side of stop **(B)** to saw blade is equal to the value selected (i.e 25 mm).
- Lock the rest rule on the squaring table by knobs **(S)**

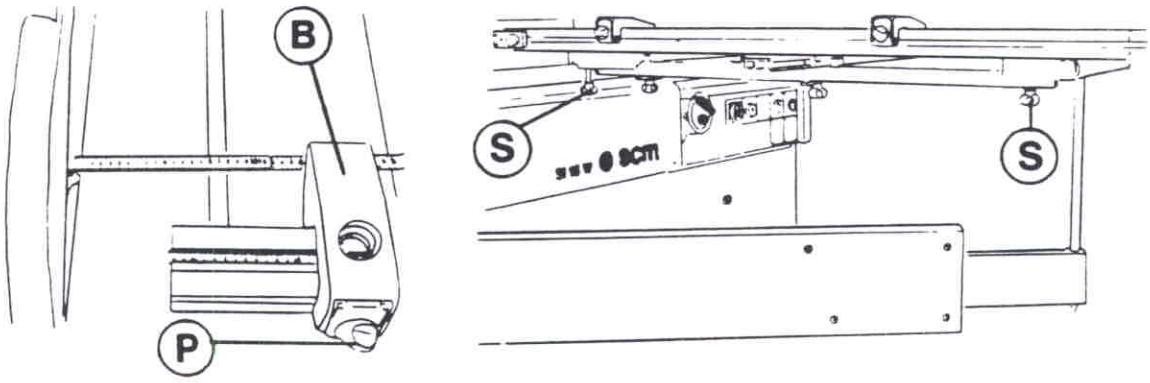


Fig.34

- Trim a panel so that the side are perfectly perpendicular each to other
- Lock stop **(B)** on the rule in any position
- Carry out a cut: one trimmed side of the panel is against the rule, the other against stp **(B)**
- Read the cutting measure **(L)**

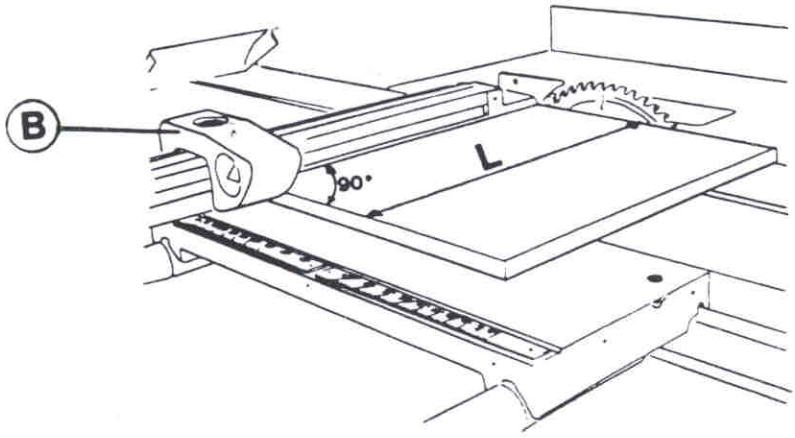


Fig.35

- Keep the position of stop **(B fig.35)**
- Loosen millimeter rule **(M fig.36)** by turning screw (F)
- Move rule **(M)** until the line corresponding to measure **(L fig.35)** coincides with the reference line of the lens of stop **(B)**
- Lock rule **(M)** by means of screw **(F fig.36)**

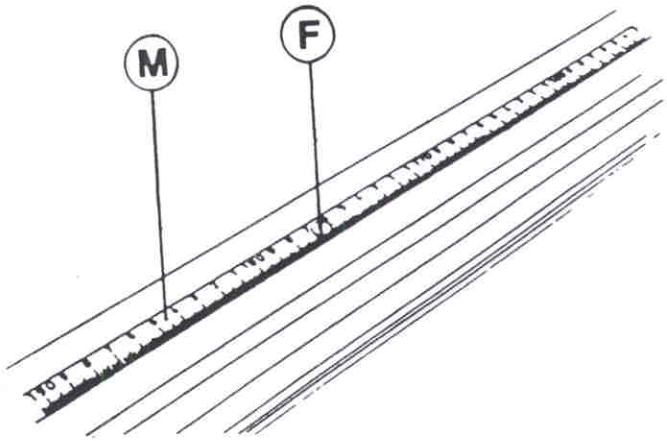


Fig.36

After setting to zero the rule don't move the saw transversally; if necessary to move it carry out the setting to zero.

NOTE: The lens pointer of the stop is composed of a reference line in the bottom part and of a point on the top: when reading a measure the point shall be perfectly superposed to the line.

SETTING TO ZERO THE FENCE FOR PARALLEL CUTS

- Remove the saw guard
- Move parallel fence so that section (**A fig.**37) touches the saw blade then lock the fence by handle.
- Loosen knob (**P**) and position the lens with reference line (**L**) on rule (**T**) to zero, then tighten knob (**P**).

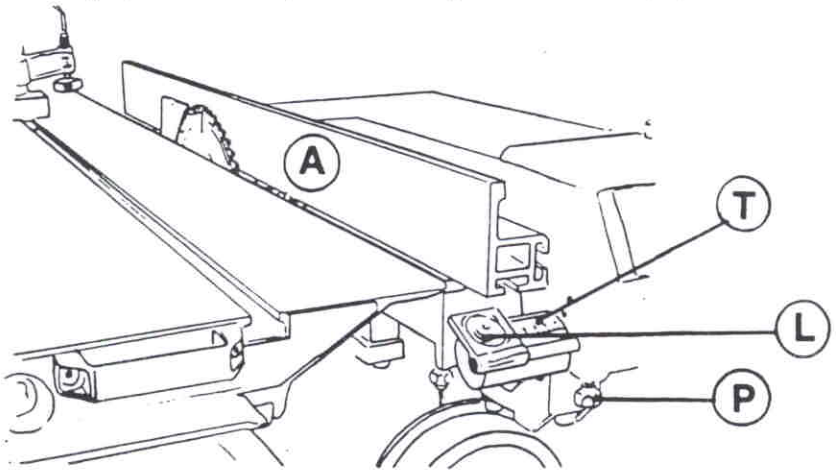


Fig.37

- Loosen the fence and move away it from the saw blade
- Fit the saw guard
- Carry out a cutting test on a panel first on one side then on the parallel one.
- Read the cutting measure
- Check that the measure you have read is equal to the measure indicated by pointer
- In the affermative case the setting is okey, otherwise loosen the pointer and position it on the measure read by holding the rolling table locked.

NOTE: The 2 rings with grub screw (**G fig.38**) may be used as a reference stop to move pointer.

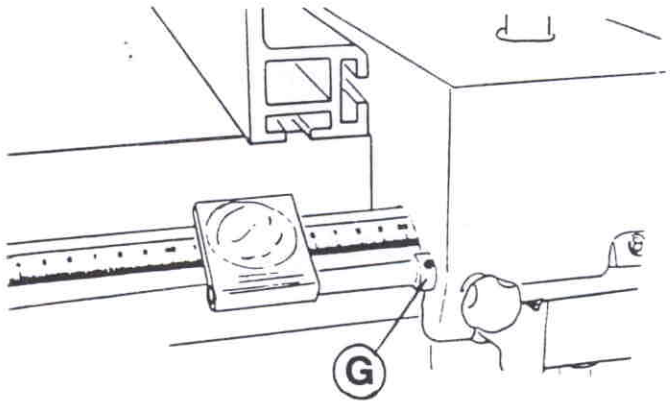


Fig.38

SETTING TO ZERO THE FENCE FOR PARALLEL CUT WITH DIGITAL READER

Follow the same instructions previously indicated and proceed as follows:

- When section **(A fig.37)** touches the saw blade by pressing button **(R fig.39)** the reader is set to zero
- After the cutting test if the measure indicated by the reader is different from the one obtained by measuring the panel, with buttons + or - you correct the value until it coincides with the measure noted on the panel.

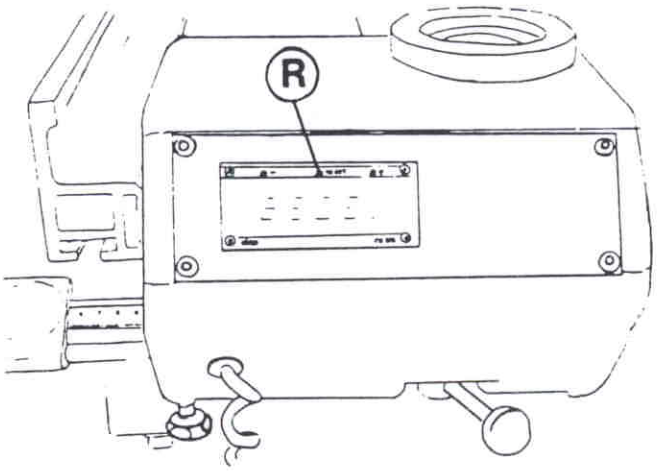


Fig.39

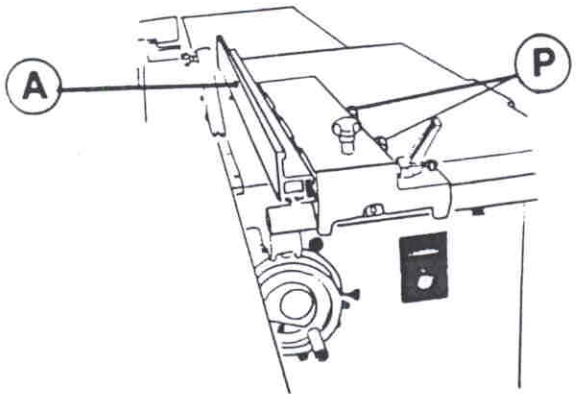
ATTENTION: when the machine is cut out do not move the fence for parallel cut because when you switch on the machine you have to set the fence to zero again.

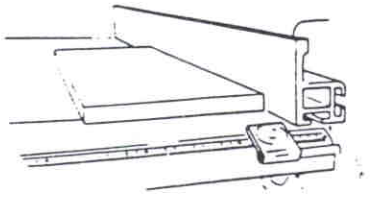
USE OF FENCE FOR PARALLEL CUT WIDTH UP TO 1500 mm

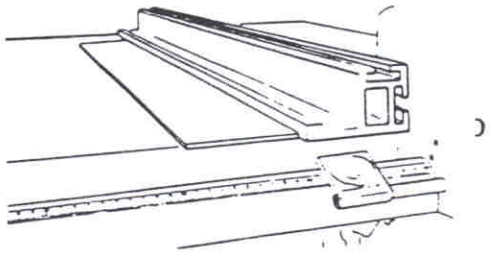
The aluminium fence **(A)** may be moved and locked by knobs **(P)**: two positions are possible:

1) Horizontal position **(O)** to cut thin workpieces
   in this case you shall use a push block

2) Vertical position **(V)** for longitudinal cuts
   For traverse cuts by using the fence as a length stop position it longitudinally so that its outlet end is at the height of the saw blade center







Posizione "V" **Fig.40** **Posizione "O"**

USE OF THE ROLLING TABLE AND SQUARING TABLE

Example for carrying out the squaring:

- Carry out the first longitudinal cut by resting the panel against the stop **(L)** and fastening it by clamp **(S)**

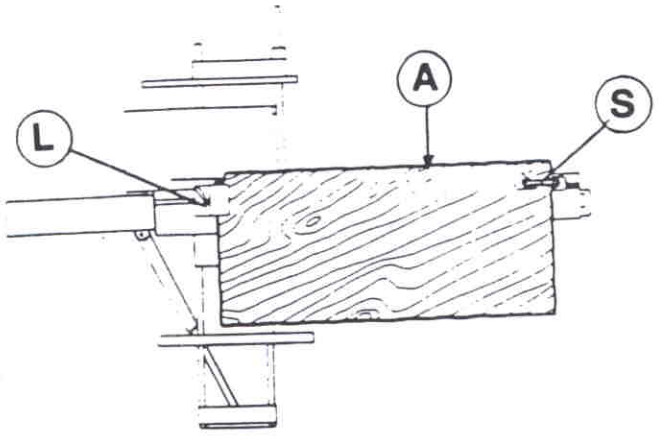


Fig.41

- Turn panel **90°** so that the trimmed side **(A fig.42)** rests against the aluminium fence, then carry out cut **(B)**.
- Turn panel **90°** and rest side **(B fig.43)** you have now trimmed against the aluminium fence and side **(A)** against stop **(T)** positioned according to cutting measure, then carry out cut **(C)**
- Turn panel **90°** again: rest side **(C fig.44)** against aluminium fence and side **(B)** against stop **(T)** set according to cutting measure, then carry out cut **(D)**.

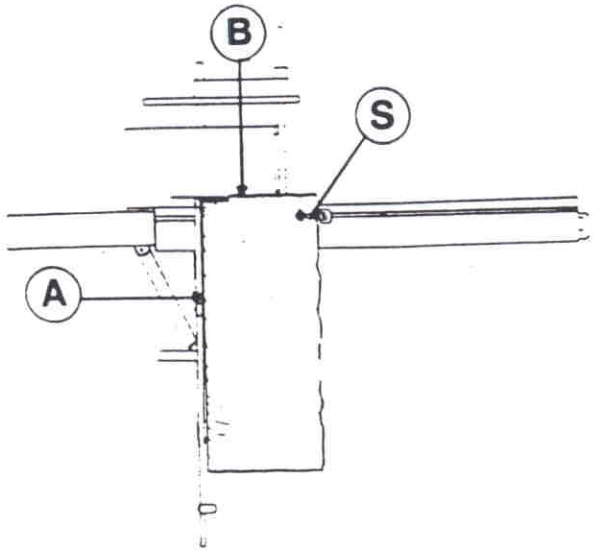


Fig.42

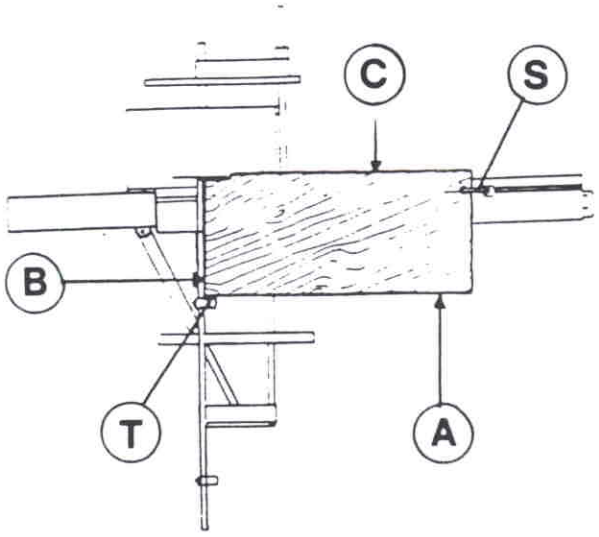


Fig.43

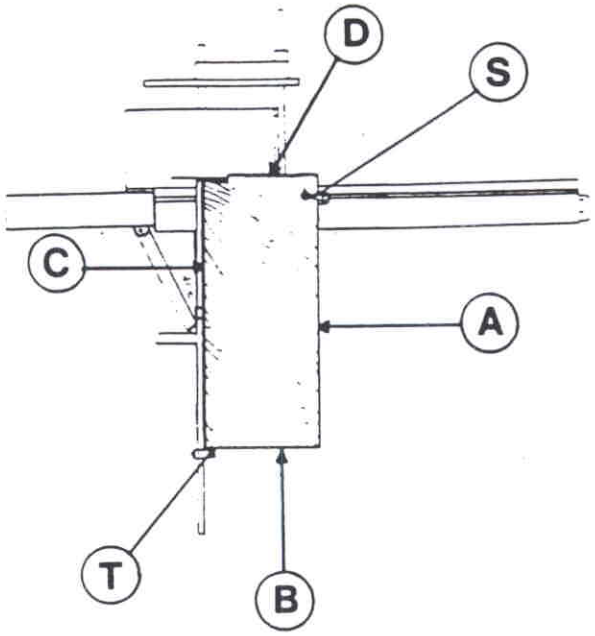


Fig.44

Another system to carry out the squaring is the following:

- Carry out the trimming cut as previously described
- Rest side (G) you have now trimmed against aluminium fence positioned according to the measure required, then cut.

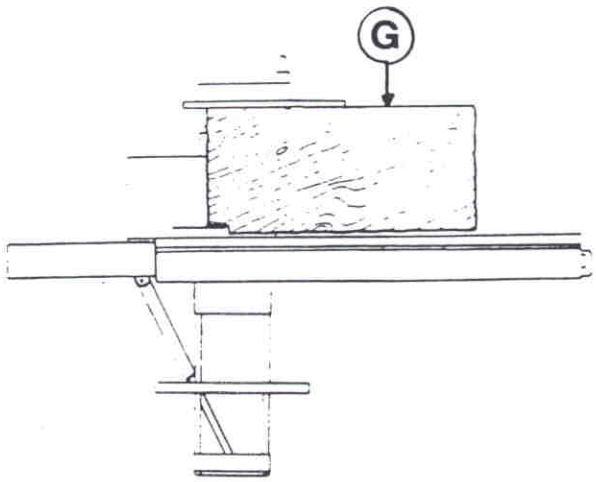


Fig.45

The first cutting-off is carried out by resting the panel against the fence

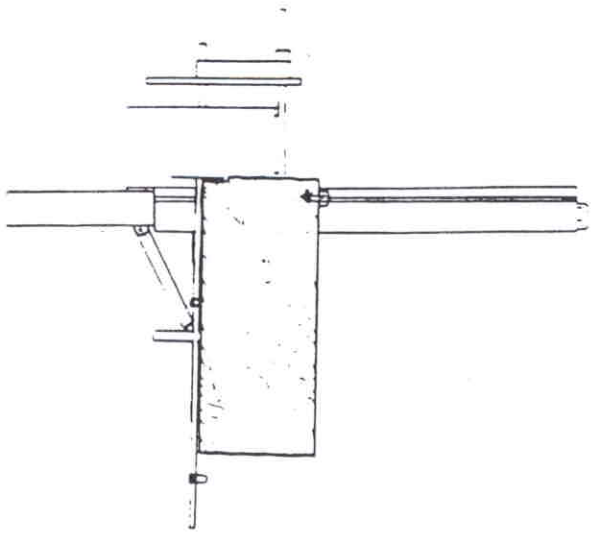


Fig.46

Now cut-off by resting the panel always against the aluminium fence but by using stop **(F)**

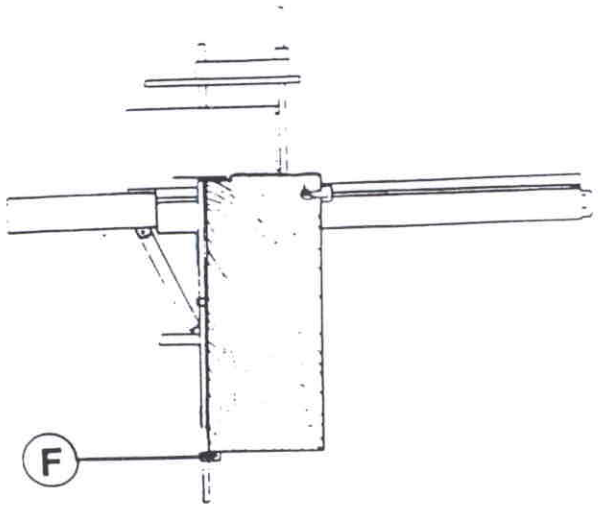


Fig.47

For the entire stroke of the rolling table loosen the table and move it along the rolling table (when this one is at the end of stroke); lock the frame by knob **(P)**, then move the rolling table: total stroke.

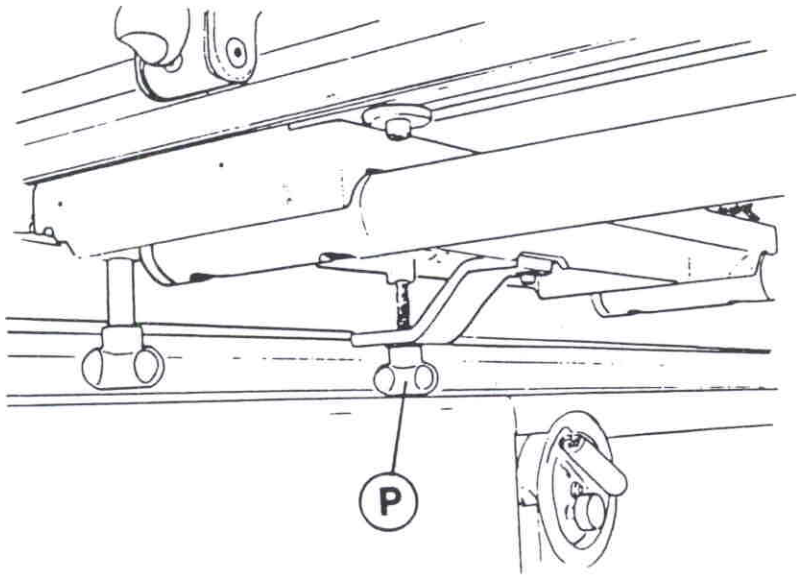


Fig.48

It is advisable to work with the fence following the workpiece only in case of small pieces

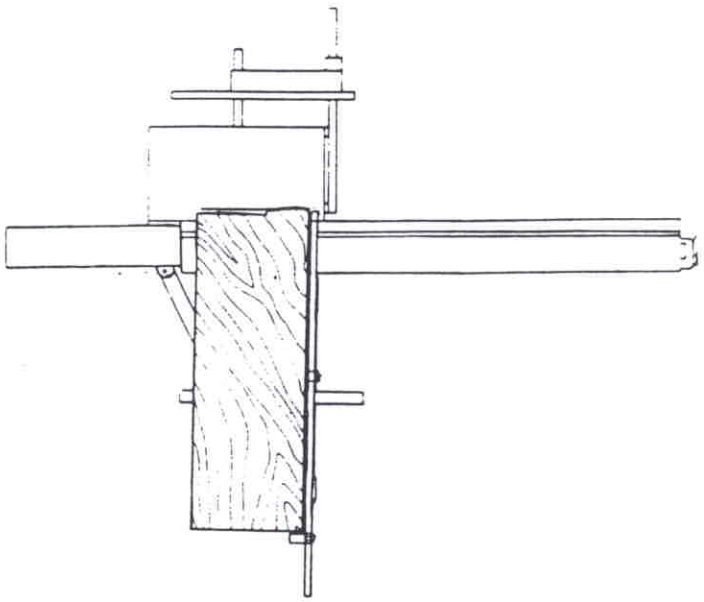


Fig.49

PNEUMATIC PRESSERS (UPON REQUEST FOR SI16WA)

Position the pressure cylinders in order to lock the panel: if you press knobs **(A)** the panel is clamped, if you pull knobs **(A)** the panel is unlocked.

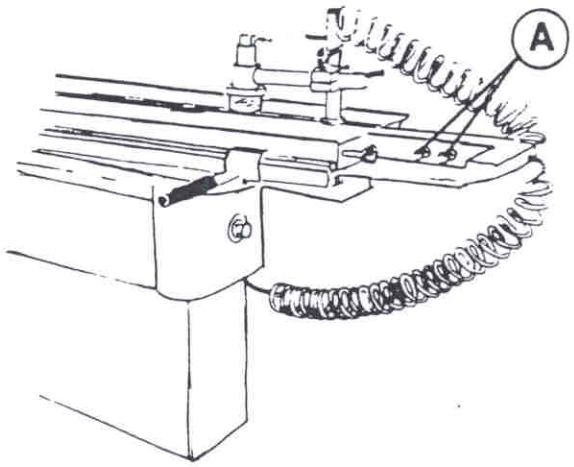


Fig.50

Adjust the pressure of the compressed air by means of grip **(R)**: read the value on pressure gauge **(M)**, then turn grip **(R)** to the initial position.

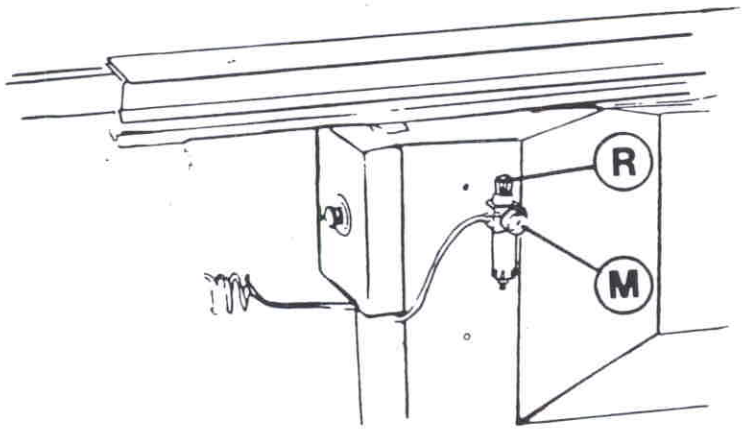


Fig.51

OBLIQUE CUT ON SQUARING UNIT

Rule **(M)** is equipped with two reference stops **(H)** and **(I)**; the holes correspond to the angles: **15°**, **22°30'**, **30°** and **45°**
To carry out the cut proceed as follows:

- Rest rule **(M)** with stop **(I)** against stop **(L)**, then loosen rule by means of the proper knobs.

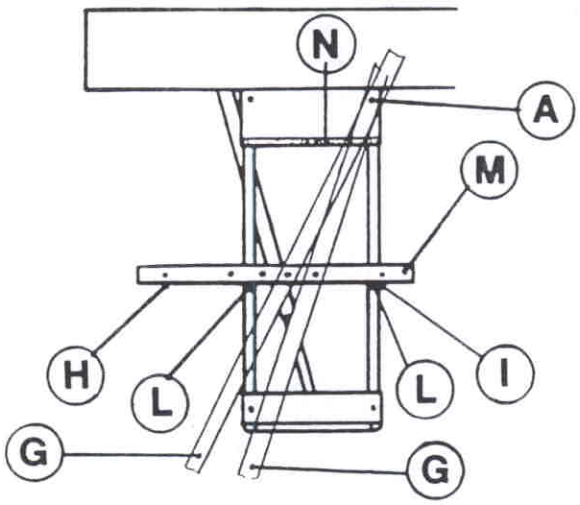


Fig.52

Make sure that the rule rests against stops **(L)**, fit pivot of fence **(G)** into hole **(A)** and the second pivot into the hole corresponding to the angle required on rule **(M)**: read the angle on plate **(N)**.
Lock fence **(G)** by knobs.
Fence **(M)** may be rested against stops **(L)** also with stop **(H)** by letting it move; in that case the fulcrum hole of fence **(G)** is **(C)**.

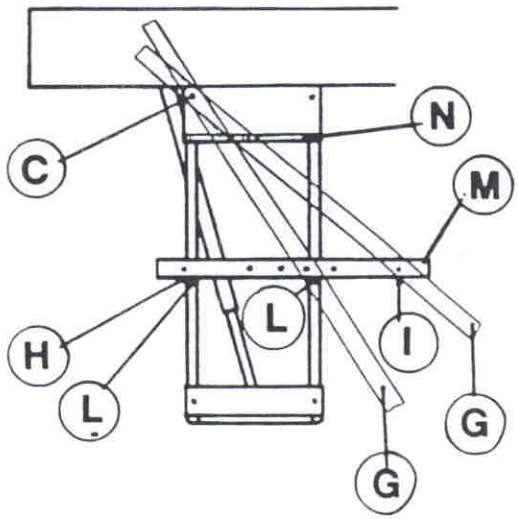


Fig.53

SAW BLADE SPEED CHANGE (SI16WA-SI16WF-SI16SW)

- Position the saw unit at the half stroke
- Remove cover **(C)**

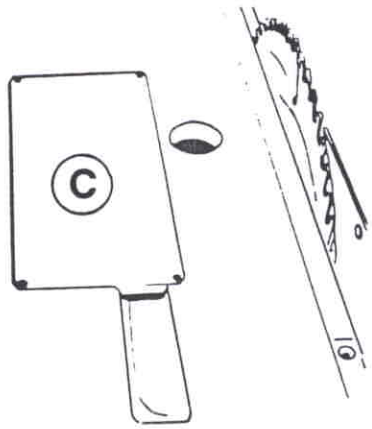


Fig.54

- Loosen knob **(A fig.55)**
- Turn lever **(B)** upwards to the end stop: the belt is slack and hands are free
- Fit the belt into the race required
- Turn lever **(B)** to the initial position to stretch the belt
- Lock knob **(A)**

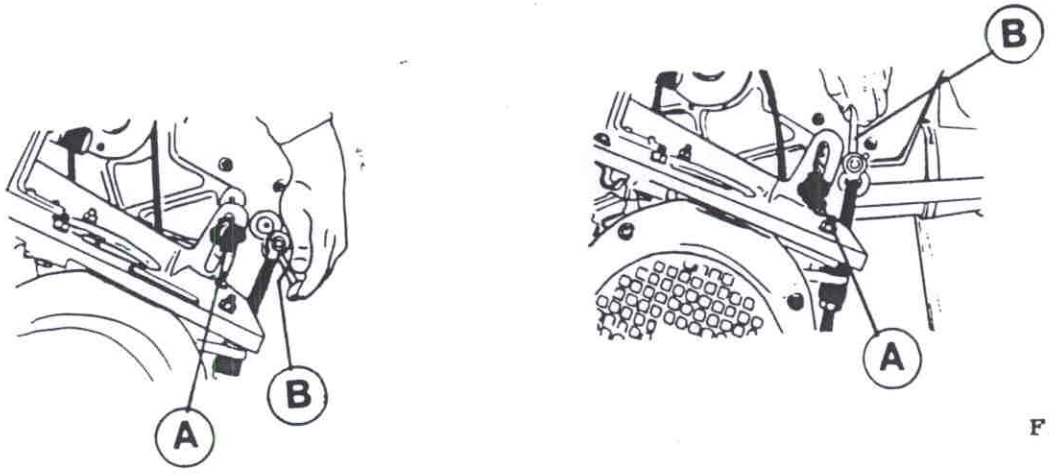
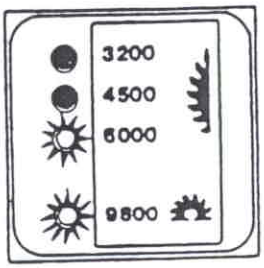


Fig.55

If the machine is equipped with speed display move the fork to the new position of belt by means of knob (P).
The pilot lamp corresponding to the speed selected lights up.



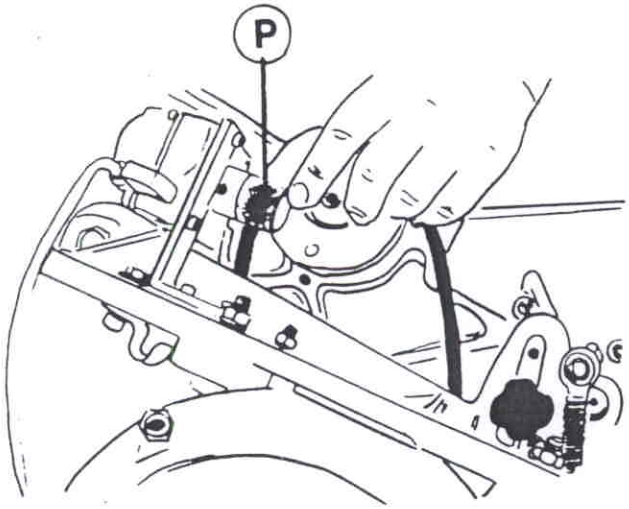


Fig.56

SAW BLADE SPEED CHANGE (SI16SF-F)

- Loosen handle **(M fig.57)**
- Loosen the belt by pulling lever **(L)** upwards, then lock handle **(M)**: the belt is slack and both hands are free
- Fit the belt into the proper race
- Loosen handle **(M)**
- Turn lever **(L)** down to stretch the belt, then tighten handle **(M)**.

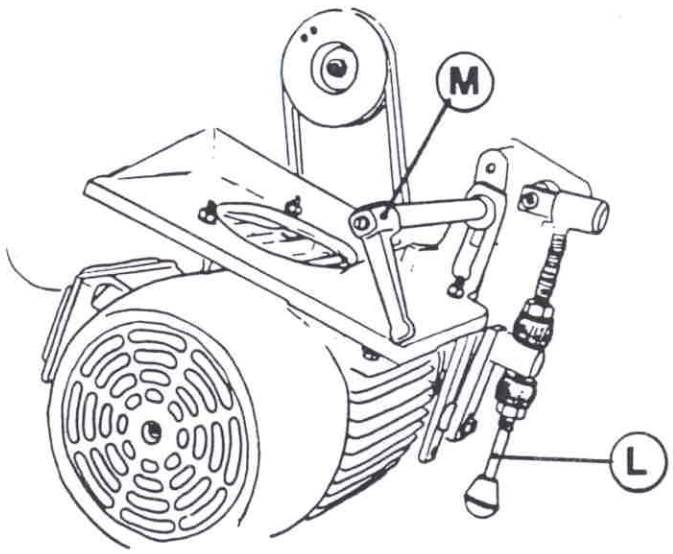


Fig.57

CONTENTS

MAINTENANCE

MACHINE CLEANING

An accurate cleaning of the machine ensures longer machine life and it is an important safety precaution.

1) Make sure that inside the motor housing there are no chips
2) Every week clean all moving parts especially those which are subject to resin and dust using turpentine or proper solvent.
3) Take particularly care of: slideways, the rod of fence and the groove where the squares and presser slide.

IMPORTANT

Periodically clean the rolling table slideways (SI16WA-SI16SW) with naphta or other solvent.

LUBRICATION

Every week grease:

1) Screws **(V fig.58)** as well as sectors **(S)**
2) Sleeves **(C)** and rods **(A)** of the scoring unit with a light grease film after cleaning them with a jet of compressed air.

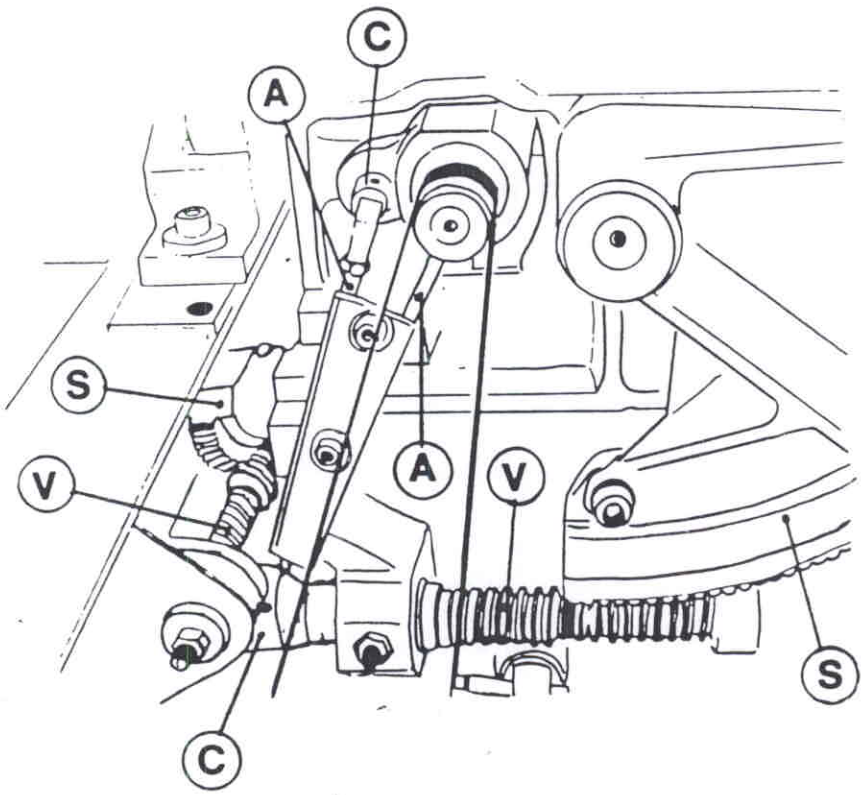


Fig.58

MAINTENANCE

Every week oil:

1) Slideways **(A fig.59)** for saw blade tilting

2) Surfaces **(B)** and pivot **(C)** for saw blade lifting

3) Joints **(D fig.60)** of riving knife

4) Supports **(F fig.61)** of the parallel fence

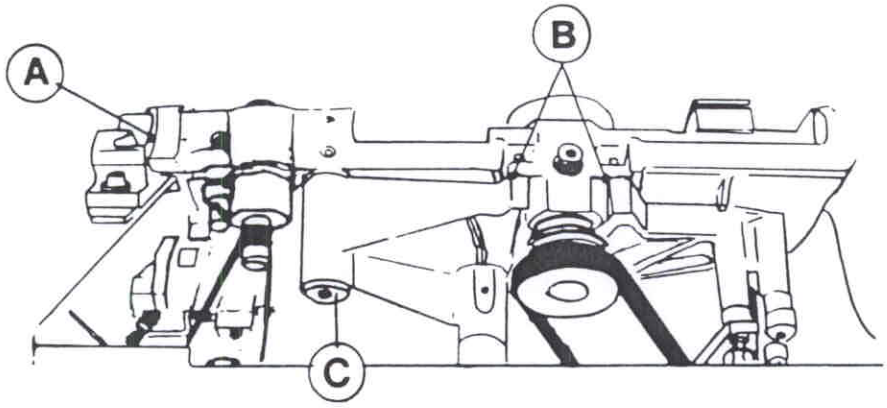


Fig.59

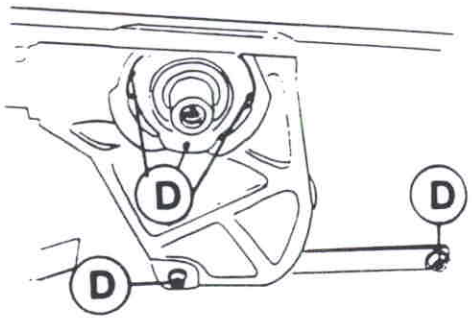


Fig.60

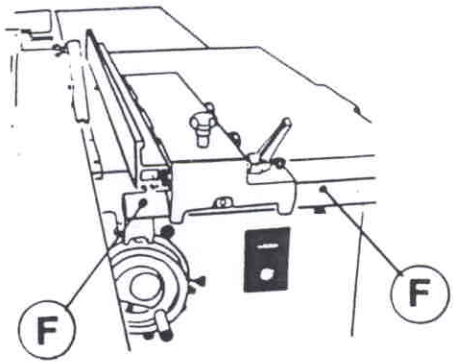


Fig.61

IMPORTANT

All bearings are lubricated for life and proof: therefore they don't require any lubrication.

BELT TENSION ADJUSTMENT

If it necessary to stretch the belts loosen nut **(D)** and screw down nut **(D1)**. The belt tension is right when applying a force (approx. 3kg) you get an elastic deflection of 5 mm

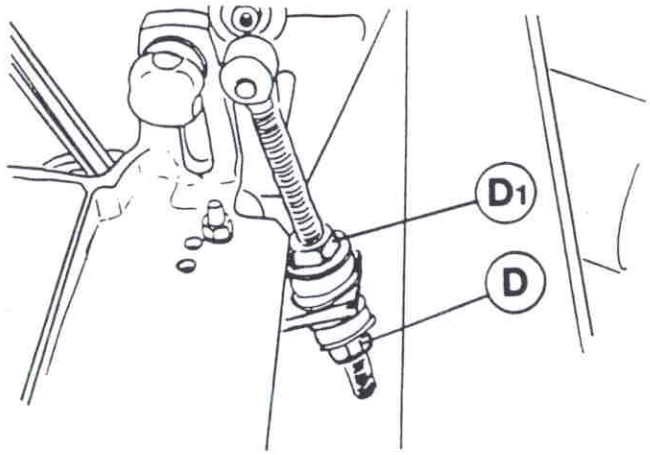


Fig.62

BELTS REPLACEMENT

Proceed in the same way indicated for SAW BLADE SPEED CHANGE page 43 use belts:

- SCM 0000603366F, that is V-Belt 3V 335 9.5x8 length: 850 for 50 Hz motor
- SCM 0000603365D, that is V-Belt 3V 315 9.5x8 length: 800 for 60 Hz motor

For the scorer use flat belt SCM 0000604007F, that is Belt 900x20 MEGADYNE 150

SELF BRAKING MOTOR (UPON REQUEST)

To carry otu the working turn selector **(G fig.63)** to the left.
When you turn the switch for saw control to position **0**, the motor automatically brakes.
For changing blade the spindle must rotate freely; in this case turn selector **(G)** to the right; pilot lamp **(H)** lights up.
The motor may be started only if selector (G) is turned to the left.

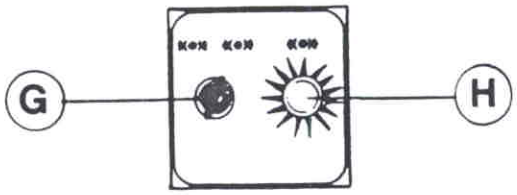


Fig.63

Periodically check and if necessary adjust the braking electromagnetic device **(See fig.64)**

CUT OUT MACHINE BY TURNING MAIN SWITCH TO POSITION O WHEN MAKING ADJUSTMENTS.

Electromagnet brake clearance

Distance **(A fig.64)** between electromagnet **(B)** and mobile core **(C)** is called "air gap" and is adjusted during device contruction.
Adjustment is required only in case of replacement of mobile core **(C)** having glued to its surface a brake disk of friction material being subject to wear **(F)**.
Wear limit of friction disk is 3 mm.
Replacement must be carried out only by technician of your local dealer.

Adjustment of braking unit

Braking efficacy reduction can be noticed by increasing of time required to completely stop spindle.
Best braking torque is obtained as follows:
- remove protection cover **(P)**
- insert an Allen wrench into seat **(G)** foreseen at spindle end, thus avoiding rotation of same.
- screw progressively nut **(D)** till joining mobile elements and eliminating distance **(A)** (brake clearance)
- unscrew nut **(D)** of half a turn
- fit protection cover
- start and stop motor a few times to check correct running.

NOTE

Mechanical brake release is obtained withdrawing nut **(D)** more than 1 mm.

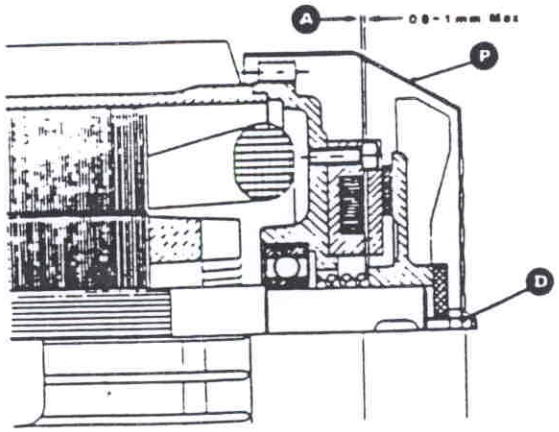


Fig.64

MAINTENANCE

TROUBLE	CAUSE	WHAT TO DO
The machine does not start	Lack of power supply on one phase or more phases	Make sure that all three phases receive power supply
	Start switches disconnected	Make sure that the switches receive power supply Replace switches
	Thermal cut-out disconnected	Reset the thermal cut-out
	Door for motor access open	Shut door so that it is in contact with microswitch
	Emergency button on	Switch off the button by turning it
	Fuses of the auxiliary circuits switched off; or caps of fuses loose	Tighten caps; if the machine does not start 1- unscrew caps 2- check fuses, if necessary replace them
	Main switch in position 0	Turn switch to position 1

TROUBLES	CAUSE	WHAT TO DO
The machine stops during the working	Lack of power supply on one phase or more phases	Make sure that all phases receive current
	Fuses of auxiliary circuit switched off or caps of fuses loose	Tighten caps; if the machine does not start 1- unscrew caps 2- check fuses, if necessary replace them
	Excessive electrical input due to many hours of continuous working	Await until the thermal cutout on control board is cold Switch it on after some minutes.
	Too heavy work for the motor power	Reset the thermal cut-out and machine only pieces which don't require higher motor power
The motor rotates but the saw blade stops when it is in contact with the workpiece	Belts between motor pulley and saw pulley are slack	Stretch belts as described at page 51
The cut measure on panel does not correspond to the measure read on the rest rule	The rest rule has moved The millimeter rule has moved	Set rule to zero as described at page 31

MAINTENANCE

TROUBLES	CAUSE	WHAT TO DO
The cut measure on panel does not correspond to the measure read on the pointer of the fence for parallel cut	Fence position to saw blade not right	With the machine standstill rest the aluminium fence against the saw blade if the saw teeth rest on the fence before and behind or only behind, you have to adjust the parallel fence: 1) loosen the screws which lock the supports of the toothed round rod 2) turn the unit steps by steps until the aluminium fence touches only the front teeth: that is a 0.10 mm clearance between the aluminium fence and the rear teeth 3) Lock the table supports and carry out a test cut
The cut is not parallel	Fence not well adjusted	The fence shall be parallel to saw blade it is required a 0.10 mm clearance at the outlet side. To adjsut the parallelism proceed as already described

TROUBLES	CAUSE	WHAT TO DO
Square cuts not precise	Aluminium fence not adjusted	To adjust the position of holes **(B-D fig.65)** proceed as follows - unscrew grub screw **(E)** - turn bush **(B)** by means of a screw-driver - tighten grub screw **(E)** - carry out a test cut then check the squareness

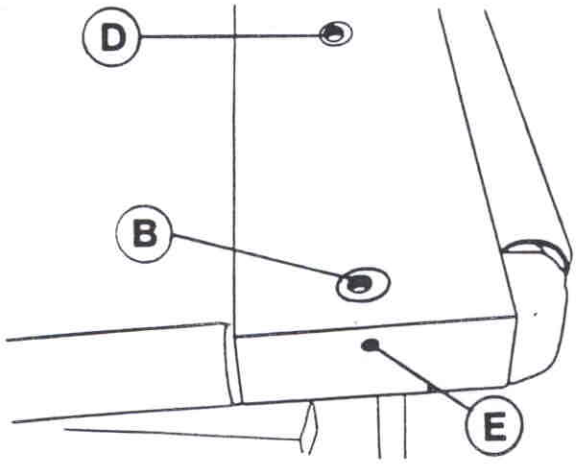


Fig.65