

Book 1 of 3

OPERATOR'S MANUAL



SLIDING TABLE SAW MODEL: STS-16120CNC

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THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without a RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without a RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 30 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (e) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing, and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator's manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorneys' fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy.

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at: (920) 684-4990 or e-mail us at sales@baileighindustrial.com



INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

DANGER: Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING: Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION: Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE: Indicates a situation which, if not avoided, could result in property damage.

DANGER

WARNING

CAUTION

NOTICE

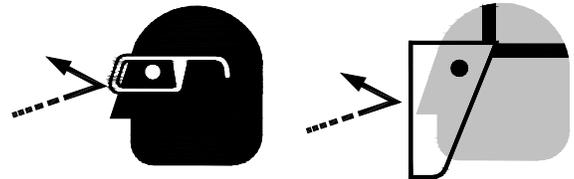


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



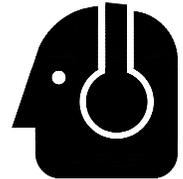
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



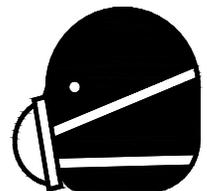
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



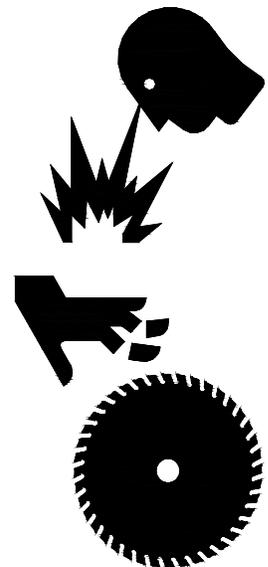
DUST HAZARD

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long term respiratory damage. Be aware of the dust hazards associated with all types of materials.



DUST PARTICLES AND IGNITION SOURCES

DO NOT operate the table saw in areas where explosion risks are high. Such areas include locations near pilot lights, open flames, or other ignition sources.



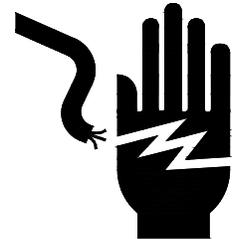
ROTATING BLADE HAZARD

Moving saw blade may result in loss of fingers or limb. **DO NOT** operate with guard removed. Follow lockout/tagout procedures before servicing.



HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off.
(FOLLOW PROPER LOCKOUT PROCEDURES)



EMERGENCY STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset.
Note: Resetting the E-Stop will not start the machine.



SAFETY PRECAUTIONS



Wood working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, push sticks, hold-downs, feather boards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

Dear Valued Customer:

- All Baileigh woodworking machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.



Please enjoy your Baileigh machine!Please enjoy it SAFELY!

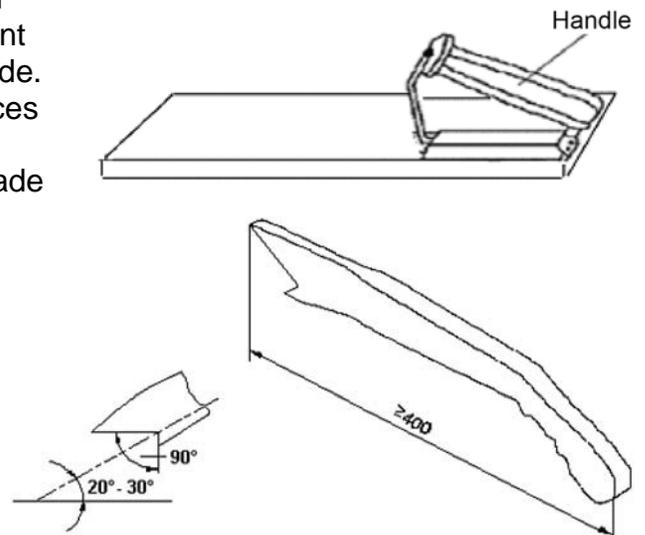
1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel should operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Kickback.** Kickback happens when the piece part is thrown back toward the operator at a high rate of speed. Before operating this saw, understand how kickback occurs, and how to prevent it.
5. **Reaching Over Saw Blade. NEVER** reach behind or over the blade with either hand while the saw is operating. If kickback of a piece part were to occur, you could amputate your hands, arms, or fingers.
6. **Blade Height.** Adjust the blade to the correct height above the piece part so it does not kickback toward the operator causing injury.
7. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
8. **Blade Guard / Riving Knife.** To reduce the risk of kickback, always use the riving knife and blade guard. Make sure they are properly installed during cutting operations.
9. **Dado and Rabbet Operations.** Dado and Rabbeting operations require that the blade guard be removed. Be aware of your personal safety while the guard is off, and replace the blade guard after these operations are completed.
10. **Keep work area clean.** Cluttered areas invite injuries.
11. **Push Sticks and Push Blocks.** When ripping narrow stock, there is a risk of your hands and fingers contacting the rotating blade, resulting in **serious personal injury.**
12. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
13. **Crosscutting Operations.** Remove the rip fence whenever using the miter gauge to crosscut a piece part.
14. **Operator Position.** If kickback occurs, the blade will eject the piece part into the path of the operator. **NEVER** stand in- line with the cutting path of the blade during operation.
15. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
16. **Awkward Positions.** Avoid awkward hand and body positions where a sudden slip could cause your hands or body to contact the spinning blade.
17. **Use eye and ear protection.** Always wear ISO approved impact safety goggles



18. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
19. **Damaged Saw Blades.** A damaged saw blade can cause kickback. If in doubt as to the condition of the blade, **DO NOT** use it.
20. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
21. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for binding of moving parts that may affect proper machine operation.
22. **Observe work area conditions.** **DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
23. **DO NOT** bypass or defeat any safety interlock systems.
24. Know the location of the **ON - OFF** switch and the “**E**”- **STOP** button.
25. **Removing Piece Parts.** Before removing cut-offs, always turn the saw **OFF**, and wait for the blade to stop turning, to avoid contact with a moving blade.
26. **Control of the Piece Part.** If the piece part should unexpectedly move or bind the blade, kickback could occur. Make sure the piece part is supported by either the rip fence or the crosscut fence. **NEVER** back a piece part out of a cut.
27. **Supporting Piece Part.** Provide adequate support to the sides and rear of the saw table for material that is extra wide and long.
28. Keep visitors a safe distance from the work area.
29. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
30. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
31. **DO NOT** touch live electrical components or parts.
32. **Be Sure** all equipment is properly installed and grounded according to national, state, and local codes. If machine is equipped with a three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.
33. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
34. **Maintain machine in top condition.** Keep clean for best and safest performance. Follow instructions for lubricating and changing accessories.



35. **Reduce the risk of unintentional starting.** Make sure switch is in “OFF” position before plugging in power cord.
36. **Never leave machine running unattended. TURN POWER OFF.** Don't leave machine until it comes to a complete stop.
37. **Make sure machine is disconnected from power supply** while motor is being mounted, connected or reconnected.
38. **Saw Appropriate Material.** Only use this saw for natural wood stock and wood stock products such as particle board, plastics, laminates, and medium-density fiber board (MDF). DO NOT try and cut metal, glass, ceramics, or products containing asbestos or lead paint. Some of these materials contain hazardous dust and can cause severe respiratory problems.
39. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use a wood dust collection system whenever possible.
40. A push block and/or a push stick must be used if the workpieces is less than 5” (127mm) to prevent your hands from getting too close to the saw blade. Push block must be used to cut narrow workpieces and, when necessary, to push the workpiece against the fence, a push block can be easily made by the operator.





MACHINE NOISE

DECLARED NOISE EMISSION VALUES in accordance with ISO 7960.		
	Idling	Operating
Declared A-weighted Sound Power Level Lward, in dB re 1 pW.	73	75
Declared A-weighted Emission Sound Pressure Level, IpAd, in dB re 20 µPa, at the operator's position.	60	62
Values determined according to specific test code ISO 3746.		

Noise Range

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include characteristics of the work room, the other sources of noise, etc. i.e. the number of machines and other adjacent processes.

Also the permissible exposure level can vary from country to country, this information; however, will enable the user of the machine to make a better evaluation of the hazard and risk.

If the environmental noise level exceeds the permissible value, the customer is requested to adopt addition noise control measures.

Noise Level

According to EN848-1/ISO3746 (The uncertainty K = 4 dB)

Sound pressure level: 83dB(A)

From the above measured results, this sliding table sawing machine present a little hearing or noise hazard to operator, the operator is required to wear ear protection whenever possible during operation and conform to the local safety regulations.

Noise Level

From the above measured results, this sawing machine present no sever hearing or noise hazard to operator, However, the operator is recommended to wear hearing protection whenever possible during operation and conform to the local safety regulations.



SPECIFICATIONS

Cast Iron Fixed Table Dimension	24.4" x 44.25" (620 x 1125mm)
Sliding Table Dimension	15" x 102.3" (380 x 2600mm)
Main Saw Blade Ø	10" - 16" (250 - 400mm) [12" (305mm) included]
Main Saw Bore	1" (25.4mm)
Max. Cutting Height With Bade At 90	4.9" (125mm)
Max. Cutting Height With Bade At 45	3.46" (88mm)
Supply Power	220V / 3ph / 60hz
Main Motor Power	7.5hp (5.5kw) 220V / 3ph / 60hz / 23A
Main Blade Speed	3000 / 4000 / 5000 / 6000 RPM
Scoring Saw Blade Ø	4.75" (120mm)
Scoring Saw Blade Bore Ø	.875" (22mm)
Scoring Motor Power	1hp (0.75kw) 220V / 3ph / 60hz / 5A
Scoring Blade Speed	8000 rpm
Cutting Width	39.3" (1000mm)
Cutting Width Adjustment	CNC Controlled
Saw Table Extension	15.75" (400mm)
Blade Titing Adjustment	CNC Controlled (0° ~ 45°)
Main Saw Height Adjustment	CNC Controlled
Scoring Saw Height Adjustment	Motor Driven
Scoring Saw +/- Direction Adjustment	Motor driven
Blade Titing Angle Show	Digital display
Main Blade Speed Show	LED exhibit
Overhead Saw Guard	Delux
Crosscut Fence Digital Display	Yes
Rip Fence Digital Display	Yes
Rapid Clamp	Optional
Tool Frame	Optional
Noise Level	78dB
Dust Collection System	Main channel 5", Delux 3" Guard



Note: Dust collector is optional and not included.



Cutting Depths

Saw Blade Diameter	10" (250mm)	12" (300mm)	14" (350mm)	16" (400mm)
Cutting Depths At 90°	0 ~ 2" (0 ~ 50mm)	0 ~ 2.95" (0 ~ 75mm)	0 ~ 4" (0 ~ 100mm)	1.1 ~ 4.92" (28 ~ 125mm)
Cutting Depths At 45°	0 ~ 1.38" (0 ~ 35mm)	0 ~ 2.1" (0 ~ 53mm)	0 ~ 2.76" (0 ~ 70mm)	0.8 ~ 3.5" (19.8 ~ 88mm)

Cutting Lengths

Sliding Table Cutting Lengths	With or Without Scoring Saw Blade
102.36" (2600mm)	98.53" (2500mm)

Machine Weight

Cutting Width	39.3" (1000mm)
Main Crate N/W	1675/1785lbs. (760/810kg)
Sliding Table Length	74.75" (1900mm)
N/W	227/337lbs. (103/153kg)

TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990, and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileighindustrial.com, Phone: 920.684.4990, or Fax: 920.684.3944.



Note: The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



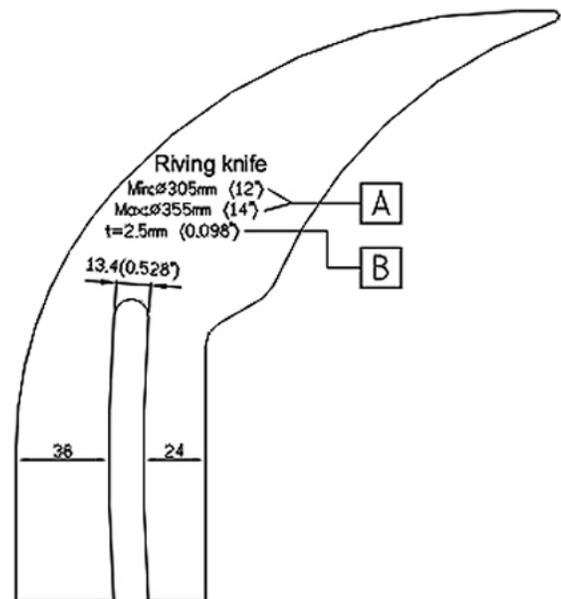
Note: The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.



RIVING KNIFE SPECIFICATION

⚠ WARNING: Before setting the riving knife, verify that it matches the saw blade diameter and body thickness. Always disconnect power at the mainpower switch prior to setting the riving knife to prevent unintended machine start up.

A: Main Saw Diameter Range.
B: Riving Knife Depth.



The machine is delivered as standard with the following riving knives.

- 305~355/2.5 specification: Saw blade diameter 305~355mm.
- Saw blade basic body thickness up to maximum: 2.5mm.

Diameter range and thickness are both engraved at the bottom end of the riving knife.

The thickness of the riving knife was selected so that they match the commercially available saw blade thickness in the respective diameter range.



TRANSPORTING AND LIFTING

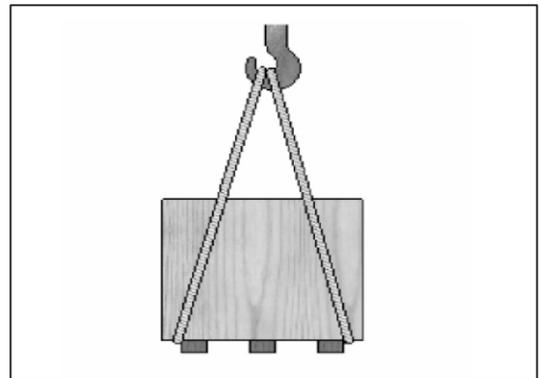
⚠ CAUTION: Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced. Choose a location that will keep the machine free from vibration and dust from other machinery. Keep in mind that having a large clearance area around the machine is important for safe and efficient working conditions.

Follow these guidelines when lifting:

- Always lift and carry the machine with straps on each end (fig. 1) for balance.
- Use a straps capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, and lower slowly until it touches the floor.

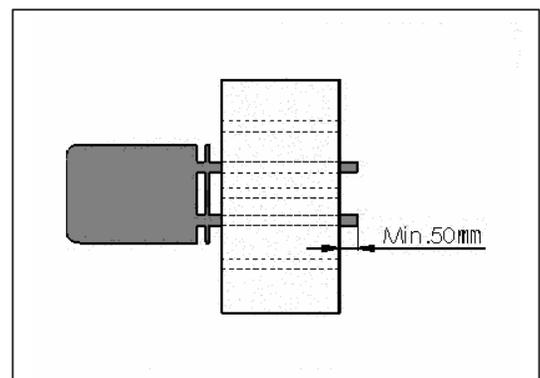
Use Crane To Move Wooden Crate

The crane's rope must be in good condition with no visible damage and be able to support the machine's full gross weight to prevent breakage.



Use Lift Truck To Move Woden Crate

Place the wooden crate in the middle of the forks and keep at least 2" (50.8mm) distance between the front of the forks and the wooden crate to avoid the case collapsing and secure safe transport.





Use Lift Truck To Transport Machine

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain at least 6 ft. (2m) safe clearance zone around the transport area.
- The machine is equipped with the slots that are specially designed for transport of lift truck and manual (electric) trolley.



Use Gantry Or Crane To Move Machine



Fig. 1

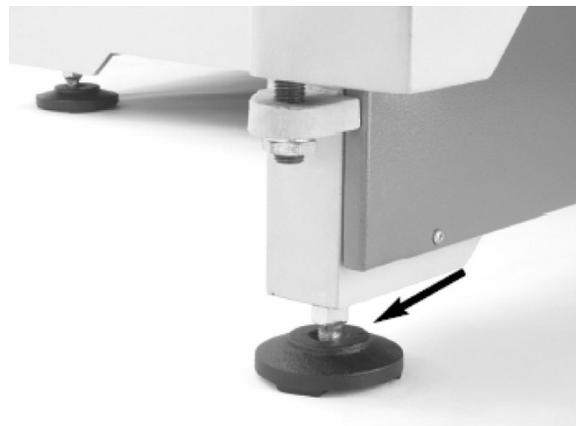


Fig. 2

- Before the machine is put on the floor, install level adjusting bases (as shown in Fig. 2) and adjust the level of the machine's working table to insure the sliding table's smooth movement and the machine's balanced operation.



INSTALLATION

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.

It is important to maintain free area around the machine, which is required for the working place. If any long material is machined, it is necessary to have a sufficient room in front of the machine as well behind it in the places of material input and output.

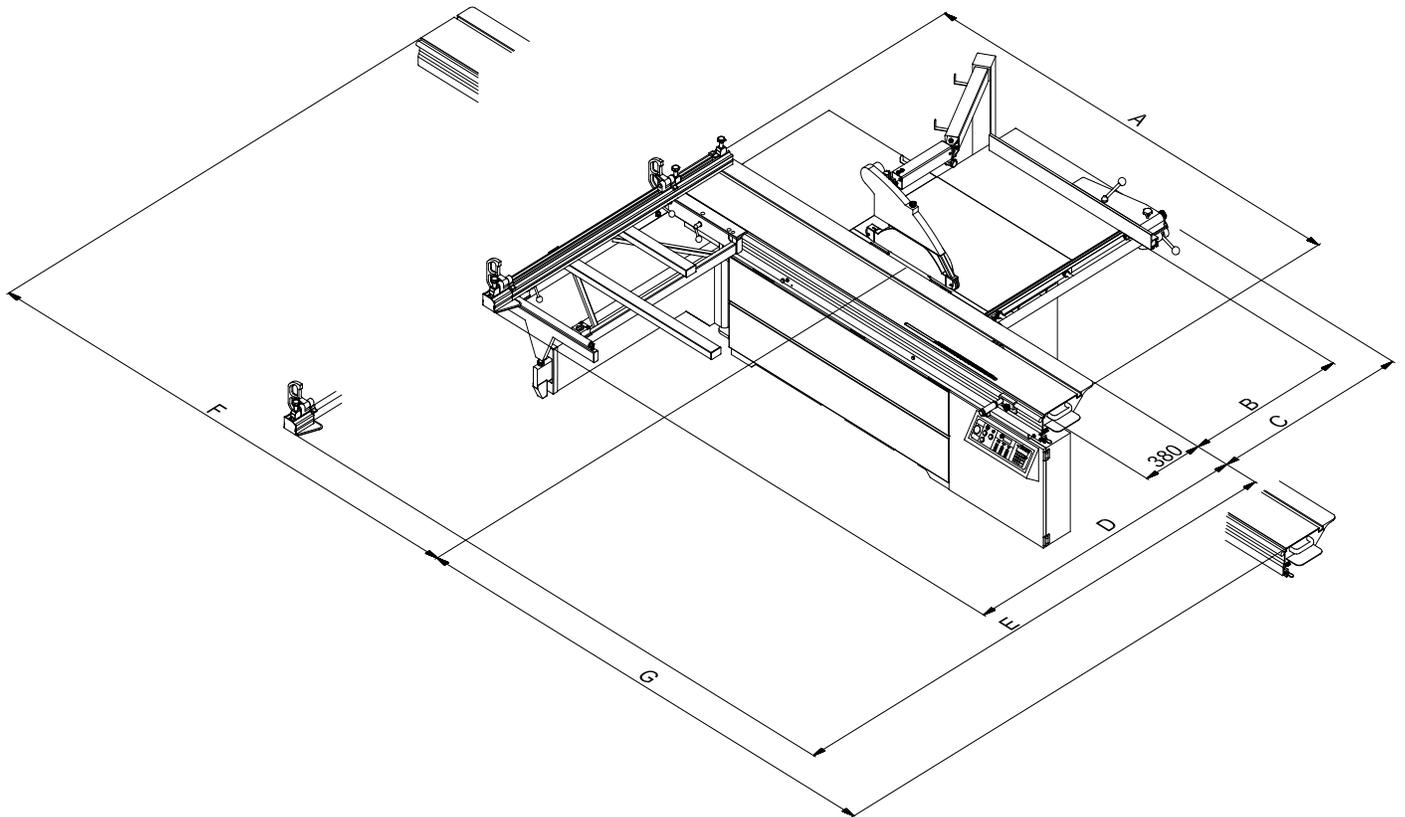
Before beginning assembly, take note of the following precautions and suggestions.

- The machine is bolted to the pallet. Before attempting any of the assembly procedures remove all of the loose parts and hardware from the inside of the machine and unbolt the machine from the pallet.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting both the weight of the machine and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **OUTLET PLACEMENT:** Outlets should be located close enough to the machine so that the power cord or extension cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

 **WARNING:** Before operating; make sure it is positioned firmly on a solid work surface. If it tips over on you, it could cause severe injury or death.



Clearance Dimensions



A	Sliding Table Length	102.36" (2600mm)
B	Cutting Width	51" (1300mm)
C	Cutting Width + 420mm	75.5" (1920mm)
D	Crosscut Fence	70.75" (1800mm)
E	Crosscut Fence Maximum	126.5" (3215mm)



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

⚠ WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.
If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

Cleaning

⚠ WARNING: DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

⚠ CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



Important: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.





INTENDED USE

Table saw and the workpiece guide equipment supplied with it are intended to be used exclusively for the following purposes:

- Laminated and unlaminated board materials (e.g. chipboard, coreboard, MDF board, ...)
- Solid wood
- Gypsum plasterboard, Cardboard, Veneer with a suitable clamping device.
- Dimensionally stable plastics (thermoset plastics, thermoplastics). Sawing these materials does not normally involve any risks in respect of dust, chips, and thermal degradation products.

OPERATIONAL INDICATION

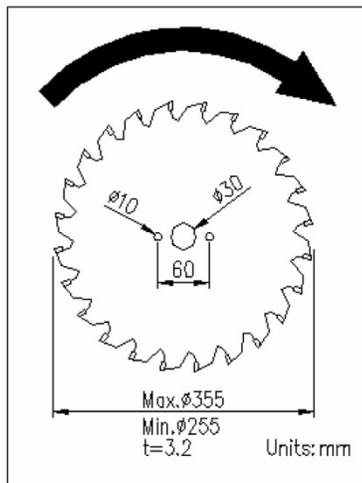


Fig.1

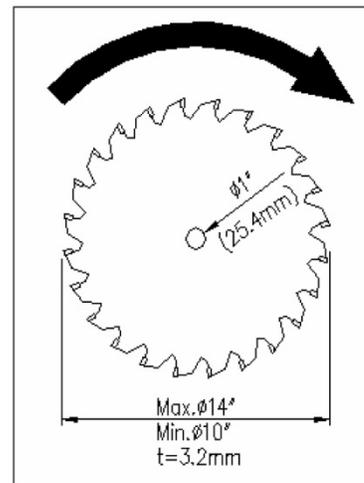


Fig.2

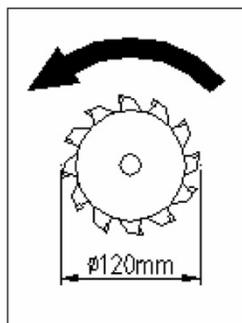


Fig.3

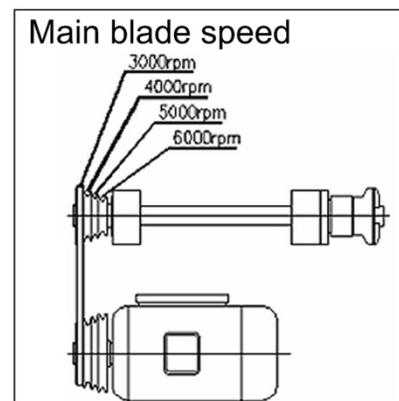


Fig.4

Fig. 1: the main saw's size and running direction.

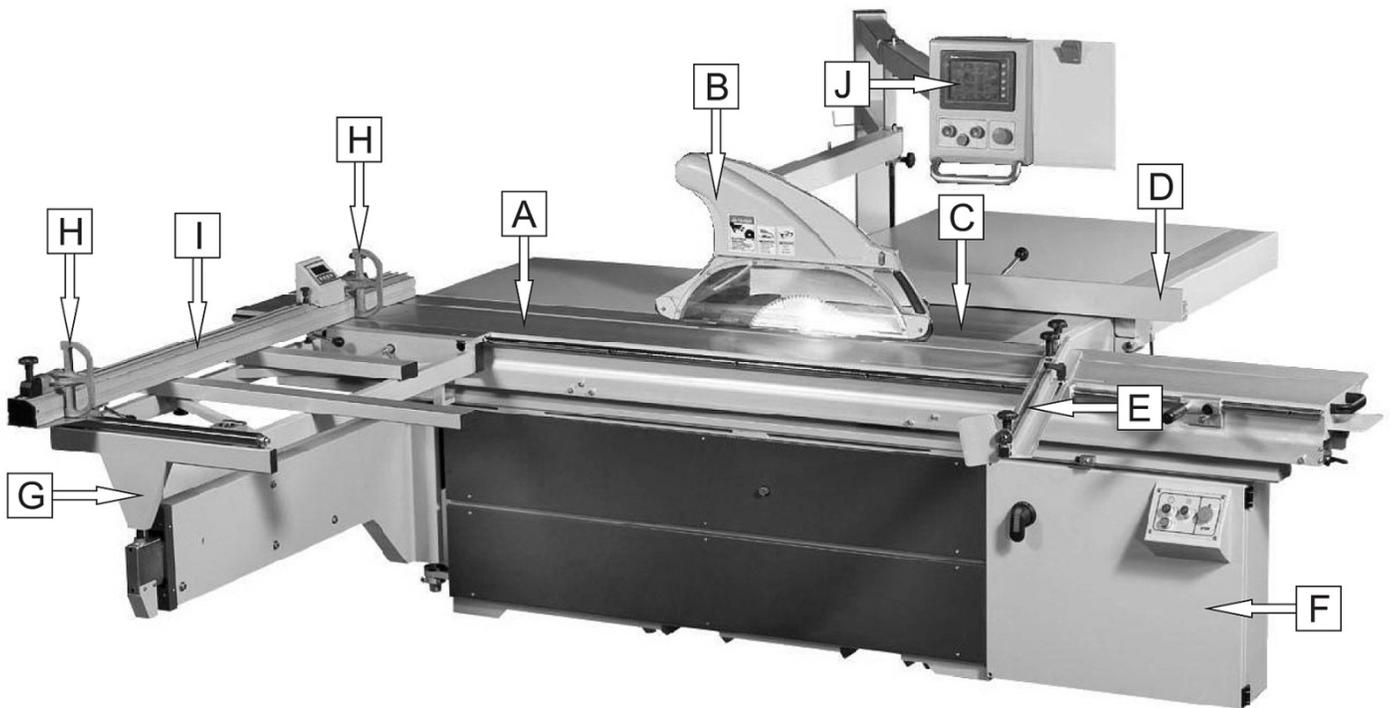
Fig. 2: the main saw's size and running direction.

Fig. 3: the scoring saw's size and running direction.

Fig. 4: Belt speed diagram.



GETTING TO KNOW YOUR MACHINE



A.	Scoring table	Table for main feeding while cutting.
B.	Dust guard	Not only reduce dust produced by chips while cutting, but also warning the operator where the saw-blade position.
C.	Main table	Main working table.
D.	Rip fence	Reference positioning while ripping.
E.	Miter fence	Reference positioning while 0 ~ ±45° cutting.
F.	Electric controlling box	The machine's main electric controlling box including power switch, emergency stop button.
G.	Cross cut table	Used to put the work piece while cross cutting.
H.	Movable positioning stops	To position while cross cutting.
I.	Cross cut scale fence	To position the size of the movable positioning board.
J.	Touch screen control panel	Control machine's running, display, stop, etc.



ASSEMBLY



WARNING: For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.



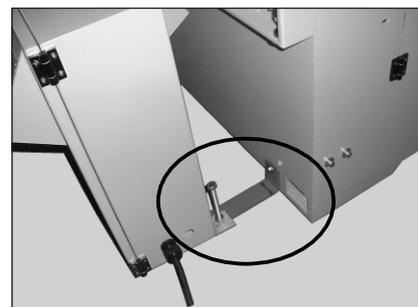
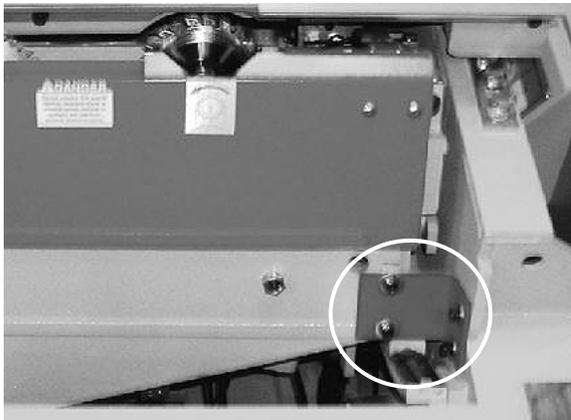
Note Due to the size and weight of many of the saws components, the assembly of the complete saw will require the use of from 4 – 6 assistants.



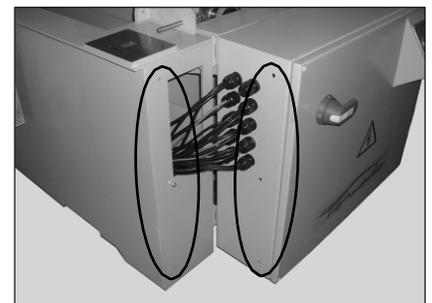
Note The saw was fully assembled, adjusted, and tested at the factory. Many of the fasteners have been installed into there mounting holes for shipping.

INITAIL INSTALLATION ASSEMBLY

1. Verify that the saw is positioned in the desired location.
2. Verify that the leveling feet are properly positioned under the leveling bolts and that the table is level.
3. Remove the 2 retaining brackets securing the saw blade assembly to the cabinet and the electrical enclosure to the cabinet.



4. Remove the 3 cap screws from the main cabinet and swing the electrical enclosure into its operating position.
5. Open the enclosure door and install and tighten the 3 cap screws through the enclosure and into the main cabinet.

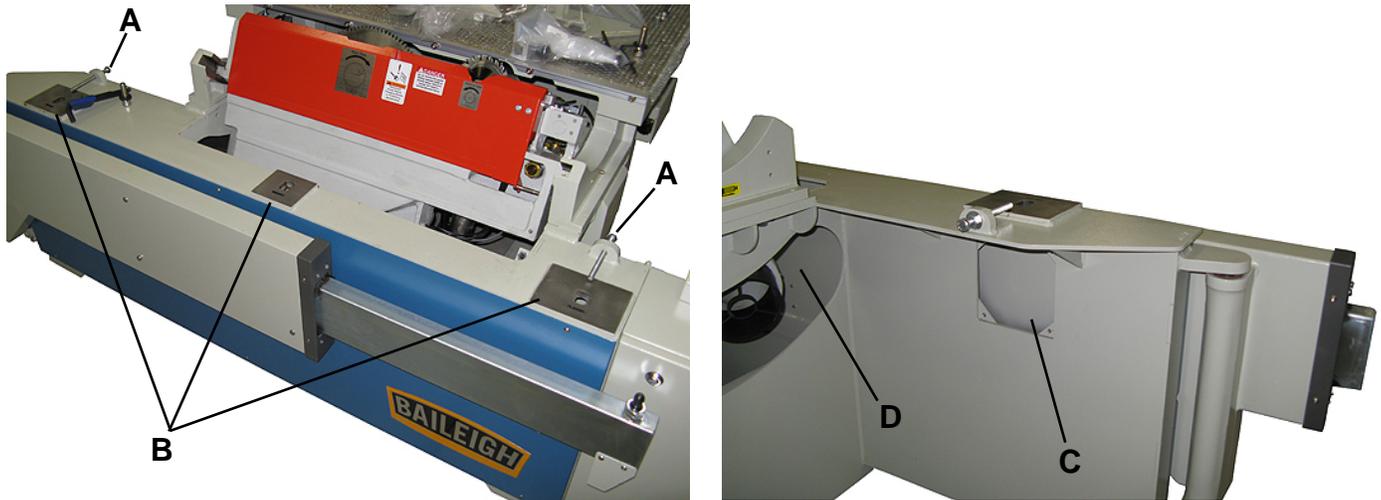




- Adjust the enclosure support bolt until it contacts the floor and then give 1/2 – 1 more turn to slightly lift the enclosure. DO NOT lower to the point of lifting the machine as this will be too much weight on the enclosure as well as affect the level setting of the table.

SLIDING TABLE INSTALLATION

- The sliding table was installed and adjusted for parallelism at the factory. DO NOT change or damage the the adjusting bolts (A) during installation of the sliding table.
- Clean the rust preventative off of the contact surfaces (B) for the main cabinet and the sliding table (Total 3 contact surfaces).



- Remove the access covers (C) from behind the 2 outer mounting points. The center mount is accessed through the clearance slot (D) for tilting the blade.



Note Use care when placing the sliding table on the contact surfaces so as not to damage the surfaces. The sliding table may require from 4~ 6 workers to lift safely.

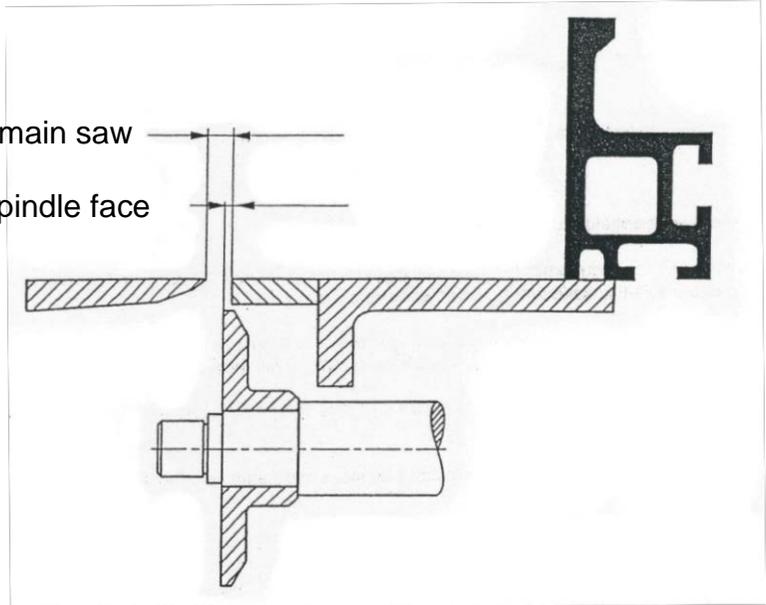
- Using the assistants, lift the sliding table onto the machine taking care not to damage the contact spots. Looking closely at the edge of the sliding table base, you should be able to see the spots where the adjusting bolts have contacted the sliding table. Use these marks to help align the bolt holes.
- Install the 3 mounting bolts hand tight.
- Verify that the sliding table base is tight against the adjusting bolts and slightly tighten the 3 mounting bolts.



7. Check the parallelism of the sliding table to the main table.

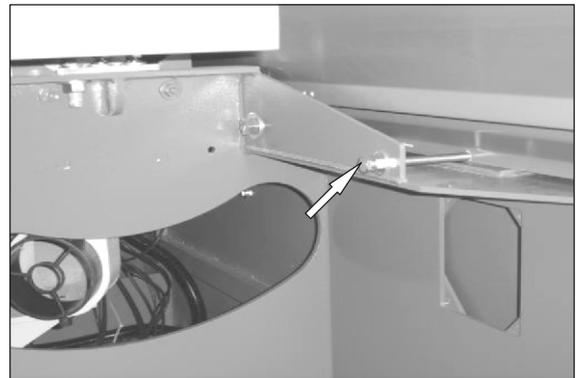
If the sliding table is parallel to the main table and has a maximum gap of 12mm between the tables and 3mm to the spindle face, final tighten the 3 mounting bolts verifying that the table does not move.

Maximum 12mm to main saw
Maximum 3mm to spindle face



If the sliding table is either not parallel, or within the clearance limits:

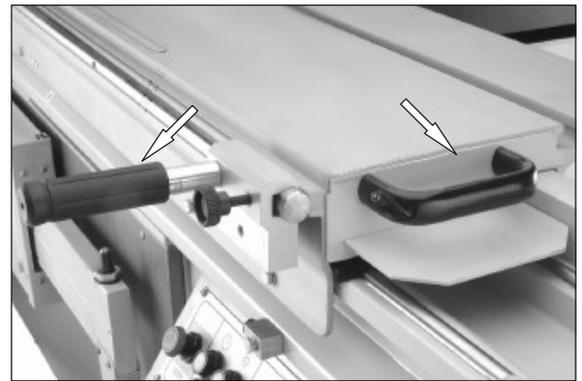
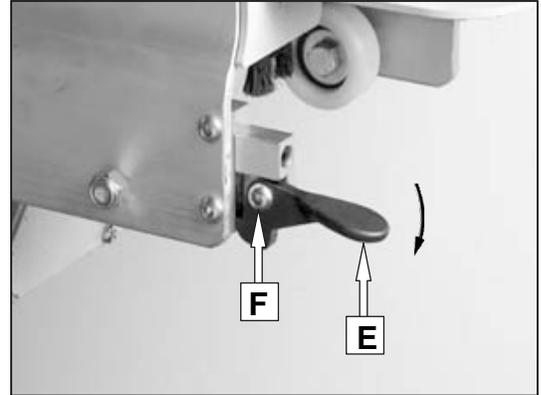
8. Loosen the 3 screws holding the sliding table to the machine just enough to allow movement for adjustment.
9. Use the 2 adjusting screws at the ends of the main cabinet to make the sliding table parallel to the saw blade and keep the gap within its limits.
10. Hold in position and fully tighten the 3 mounting bolts.



Note The sliding table must be 0.3mm higher than the working table (The height has been set at the factory. Do not adjust this height without verified measurement and approval from the factory. This is considered an unauthorized change and will void the warranty.

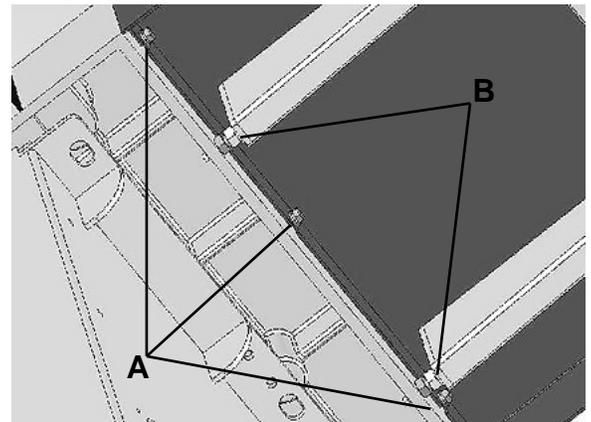


11. Install the table lock (E) onto the right end of the sliding table using the M6 x 20 screw, washer, and M6 nut (F).
12. The lock can fasten the sliding table in the middle and the end positions.
13. Before the sliding table is moved, make sure the safety lock is unlocked.
14. Lifting the handle will lock the table.
15. Pressing down on the handle will unlock the table.
16. The front handle is moveable on the front rail of the slide table. Install the front handle over the rail and position near the end. Tighten the hand screw to hold in position. This handle may be position along the rail as desired or removed as needed.
17. Install the end caps on the ends of the slide table. Remove the bolts from the slide table and insert the bolts through the end cap brackets and tighten. The end cap with the handle go on the right end of the sliding table.



LENGTH EXTENSION TABLE INSTALLATION

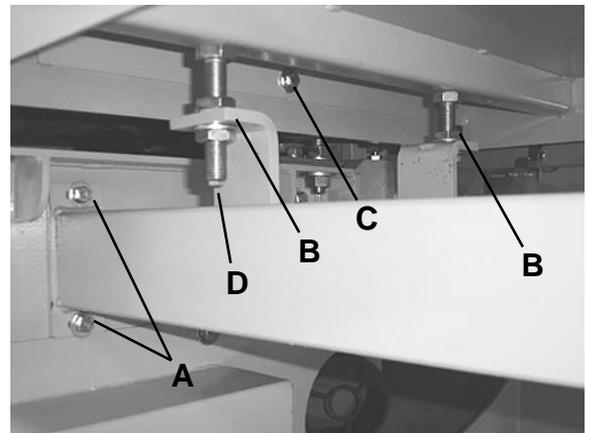
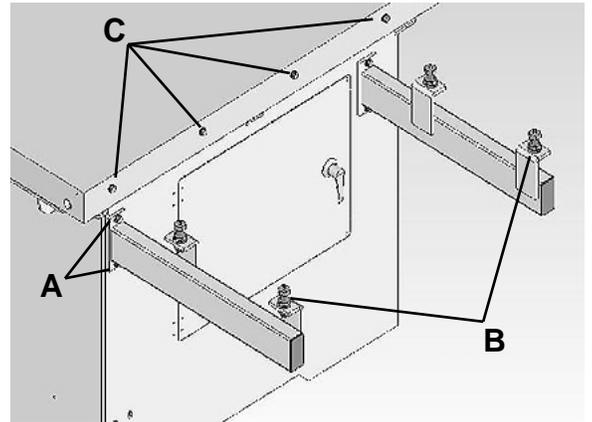
1. Loosen the 3 extension table mounting bolts (A) on the main table just enough to slide the extension table onto them.
2. Slide the extension table onto the mounting bolts so that the extension is tight to the main table and the washers and bolt heads (A) are to the inside of the extension table.
3. Place a level across the extension table and the main table.
4. Adjust the leveling bolts (B) to level the extension table to the main table.
5. When the extension table is level to the main table, tighten the mounting bolts (A) keeping the extension table level and flush to the main table.





WIDTH CUTTING EXTENSION TABLE INSTALLATION

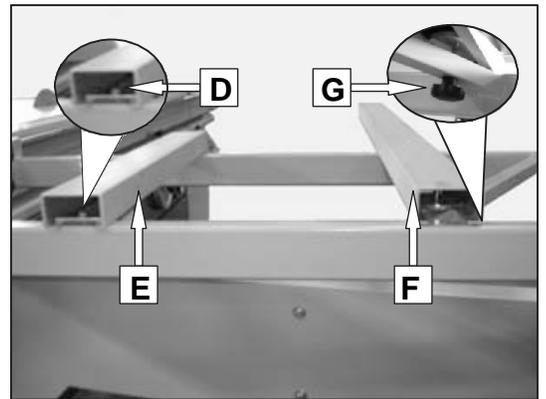
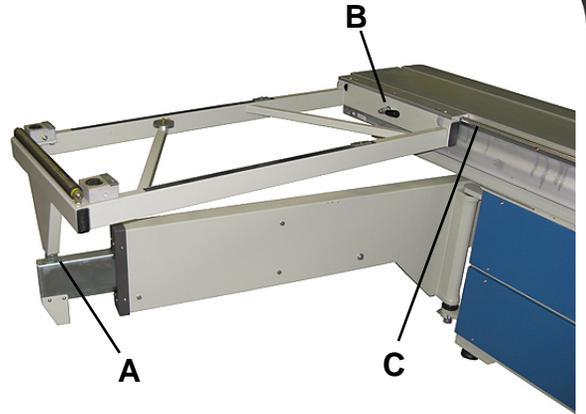
1. Locate the two extension table supports.
2. Remove the 4 cabinet mounting bolts (A) from the back of the main cabinet and install the supports with the leveling bolt (B) up and the adjustment opening toward the outside.
3. Tighten the cabinet mounting bolts (A) enough to hold the supports stable but allow a little movement for alignment of the leveling bolt locating bolts (D) to the extension table.
4. Loosen the 4 extension table mounting bolts (C) on the back of the main table just enough to slide the extension table onto them.
5. Slide the extension table onto the mounting bolts so that the extension is tight to the main table and the washers and bolt heads (C) are to the inside of the extension table.
6. Install the leveling bolt locating bolts (D) into the extension table 3 – 4 turns.
7. Align the extension table supports and final tighten the mounting bolts (A).
8. Place a level across the extension table and the main table.
9. Adjust the leveling bolts (B) on the supports to level the extension table to the main table.
10. When the extension table is level to the main table, secure the table starting with the 4 bolts (C) securing the extension to the main table keeping the table level and flush to the main table.
11. Fine tune the extension table level as needed and then tighten the upper and lower leveling bolt (B) jam nuts.
12. Tighten the leveling bolt locating bolts (D).





CROSSCUT TABLE ASSEMBLY

1. Lubricate the pivot pin (A) with light grease and place the stand end of the crosscut table onto the pivot pin.
2. Lift and hold the lock handle (B) so that it is pointing straight up.
3. Place the slide end of the crosscut table on the on the slide rod (C) of the sliding table. Verify that the locking bar of the crosscut table is positioned under the slide rod.
4. Tighten the handle (B) to fasten the crosscut table.
5. Place the two C-shaped aluminum channels across the crosscut table.
6. Loosen the bolts on the 2 bar clamps (D) and center the shorter aluminum channel (E) on the crosscut table with the bar clamp positioned to clamp the channel in place.
7. Tighten the bar clamp bolts (D) to secure the channel.
8. The longer channel (F) is a movable channel. Loosen the hand bolt enough to allow the channel to slide over the plate clamp (G).
9. Slide the channel over the plate clamp at least 1" and hand tighten the bolt to secure the channel in place. This channel may be repositioned as needed to support the work material as needed.
10. Using a soft mallet, install the end caps into the channels.
11. Place a straight edge across the crosscut table channels and onto the sliding table to check if the surface is flat.
12. Adjust the pivot pin (A) nuts as needed to level the crosscut table to the sliding table.





CROSSCUT FENCE ASSEMBLY

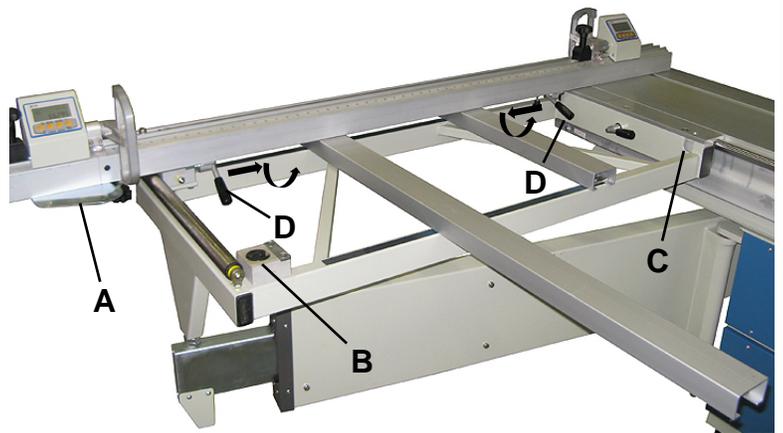
The crosscut fence may be mounted in either the near or far set of mounting points on the crosscut table, or it may be removed from the table.

This instruction specifically installs the crosscut fence in the far set of mounting points and uses the near set as indicators.



Note *If the crosscut fence is removed, or moved to the opposite mounting point, check and adjust (if needed) the perpendicularity of fence to the saw blade before use.*

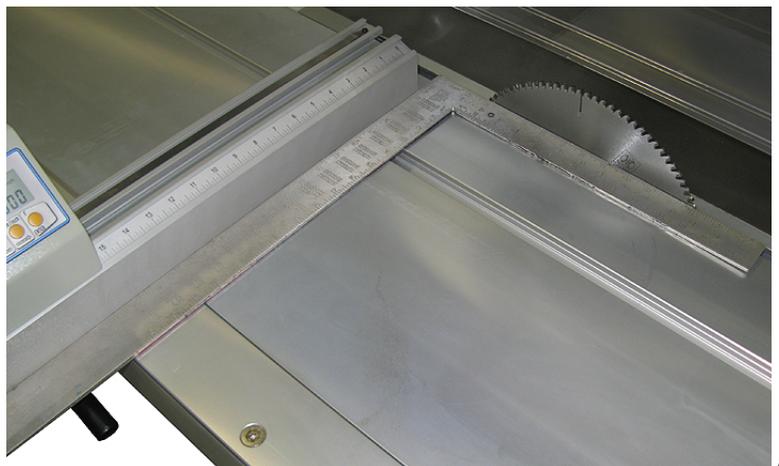
1. Place the crosscut fence onto the crosscut table so that the triangular support (A) is away from the main table and the locating pins into the positioning points (B) and (C) of the crosscut table.
2. Lift the lock handles (D) and slide them inward to the fully unlocked position.
3. Set the locating pins of the crosscut fence into the locating holes and slide the lock handles outward and rotate them down to lock the crosscut fence to the crosscut table.
4. After the machine is completely set-up and assembled, Check and adjust the perpendicularity of the crosscut fence to the saw blade.



Crosscut Fence Adjustment

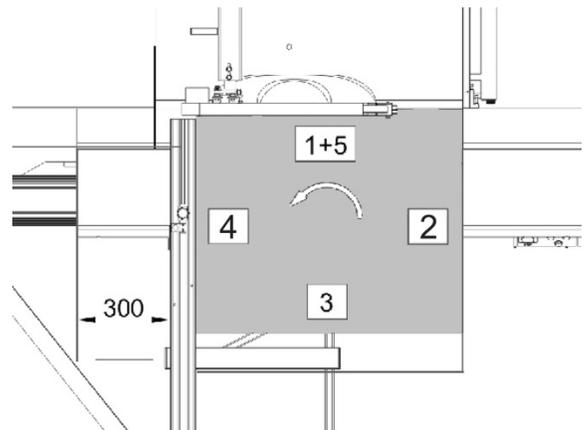
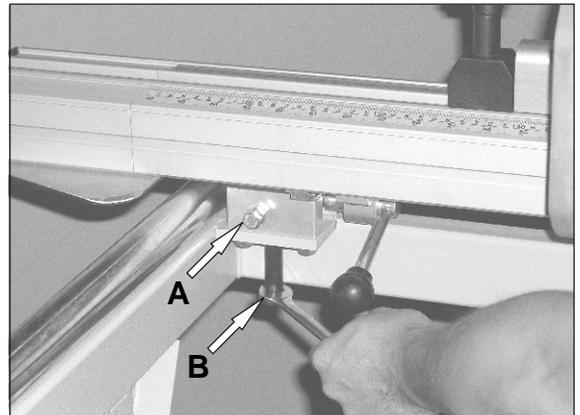
1. Raise the main blade to full height.
2. Disconnect and lockout power to the saw!
3. Place a carpenter's square across the face of the blade and carefully slide it against the crosscut fence.

There should be no gap between the square and the crosscut fence.



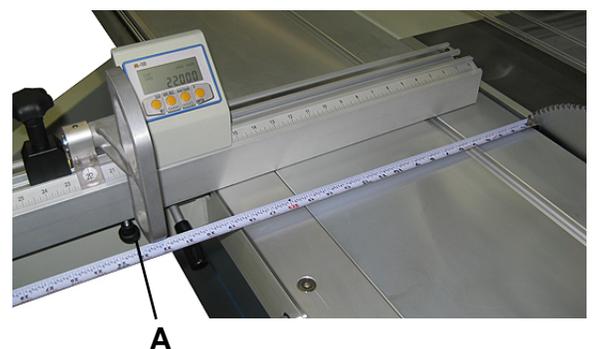


4. If there is a gap at any point, adjust the outboard crosscut fence mounting cam to square the fence to the blade.
5. Loosen the two retaining set screws (A) and adjust the cam adjustment bolt (B) to square the fence.
6. When the fence is square, hold the cam in position and evenly tighten the two retaining set screws and lock in place with the jam nuts.
7. To verify the perpendicularity of the crosscut fence, cut a piece of wood using the following steps.
8. Position the crosscut table 11-7/8" (300mm) in from the of the sliding table.
9. Use a 14" x 0.125" x 100T (355mm/3.2t/100T) blade at 5000 rpm speed and wood board 40" x 40" x 3/4" (1016 x 1016 x 19mm) for test cut.
10. Make 5 cuts on the board in the sequence shown, cutting from NO.1 ~ 5.
11. Measure diagonally across the the board to check if the board is square. If the board is not square, adjust the crosscut fence cam as noted in steps 5 and 6.



Crosscut Fence Scale Adjustment

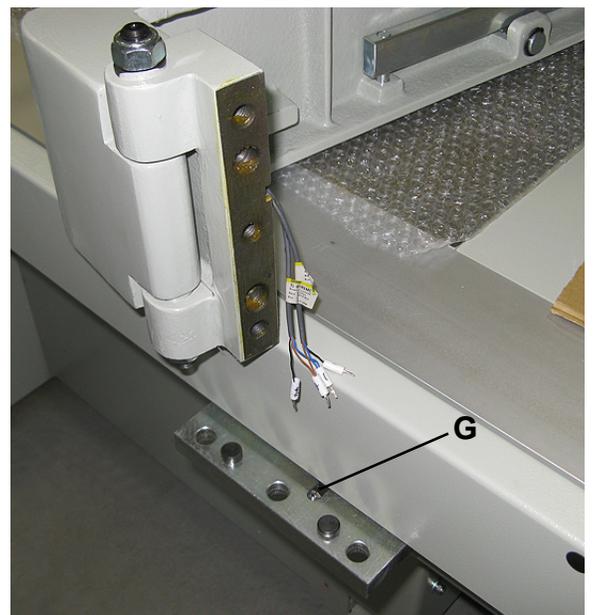
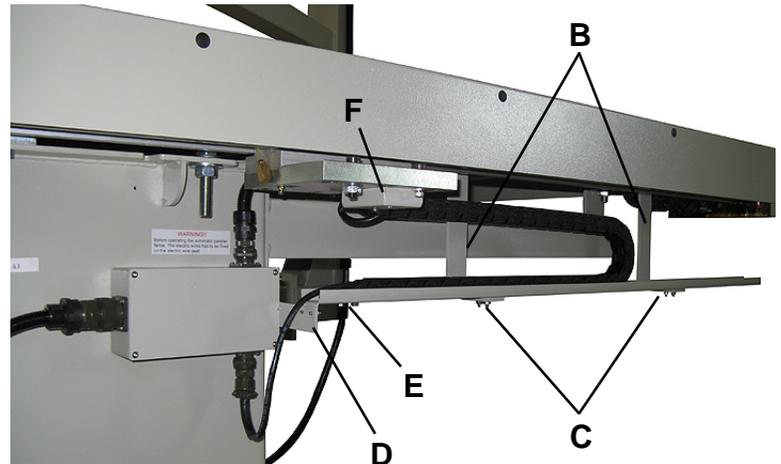
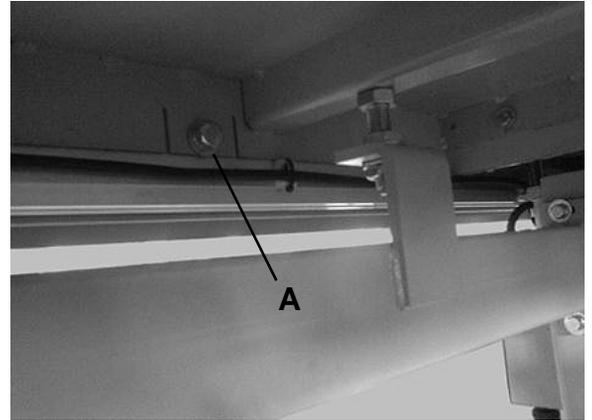
1. Raise the main blade to full height.
2. Disconnect and lockout power to the saw!
3. Loosen the inboard fence stop and set the stop to 22" using the DRO.
4. Measure the distance from the saw blade teeth to the blade side of the fence stop. This measurement should be exactly 22". If the measurement is different, follow the M-10 Calibration to correct the DRO.
5. Read the scale measurement dimension. If it is also exactly 22", the scale is set correctly.
6. If adjustment is needed, loosen the thumb screw (A) on the bottom of the fence and slide the scale until the setting is exactly 22".
7. Hold the scale firmly in place and tighten the thumb screw.





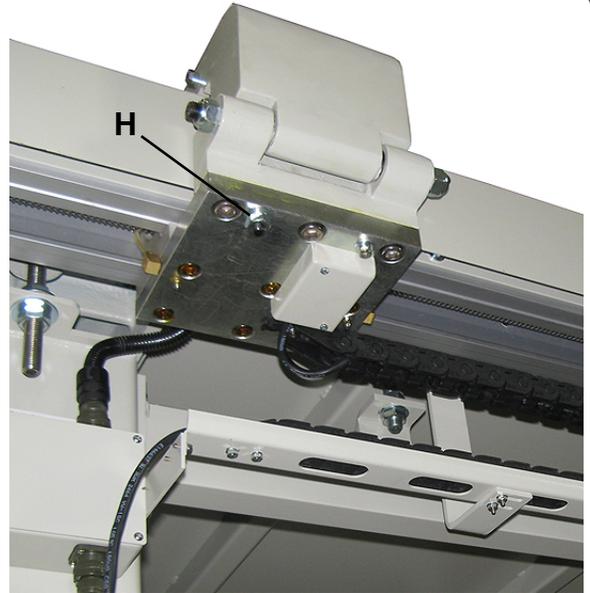
ELECTRIC RIP FENCE ASSEMBLY

1. Remove the 4 bolts installed in the rip fence drive rail. Note the size difference of the 2 bolts that mount in the main table and the 2 bolts that mount in the extension table.
2. Position the drive rail against the tables and install the 4 bolts. ([A] Extension table bolts shown.)
3. Adjust the drive rail so that it's surface is 0 - .004" (0 - 0.1mm) below the surface of the main table and tighten the 4 bolts.
4. Install the cable track hangers (B) to the underside of the extension table. The mounting holes are drilled and tapped.
5. Set the cable track support on the hangers and loosely install the 4 screws (C).
6. Install the stand off (D) between the track support and the electrical connector box.
7. Align the standoff to the cable track support and the track hangers and tighten all 8 fasteners.
8. Install and secure the cable track to the track support (E).
9. Connect the 3 plug connectors into the electrical connector box as shown. Route the cables as needed to provide enough length to make the connection.
10. Remove the connector cover (F).
11. Remove the hole plug and route the rip fence signal wires through the access hole (G) to the terminal block on the bottom of the mounting plate.
12. Install the rip fence on the dowel pins while routing the wires.
13. Install the 3 bolts and secure the rip fence.





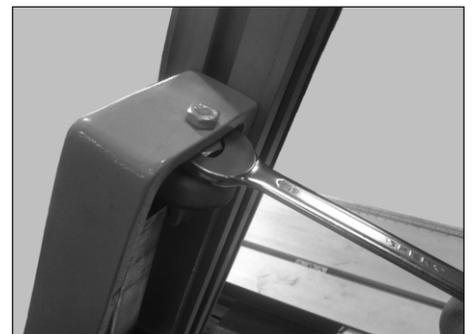
14. Connect the signal wires on the terminal block matching the markings on the wires. The markings are: Wire 44 to 44, wire 43 to 43, wire + to +, and wire - to -.
15. Install the terminal block cover.
16. Use the open 8mm wrench to adjust the screw (H) to make the fence parallel to main saw blade.



17. Measure from each end of the rip fence to the front of the main table. These measurements must be within 0 - .004" (0 - 0.1mm) of each other. Adjust the screw (H) until the setting is within tolerance.

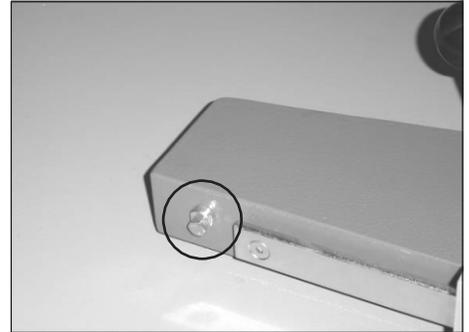


18. Adjust the eccentric wheel at the front end of the rip fence base to make the fence base parallel to the work table.





19. Adjust the eccentric wheel on the side of the fence base to make aluminum fence parallel to the work table.



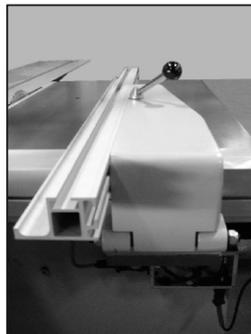
The aluminum rip fence may be mounted in either of two positions.

Use the high side position when when the cutting angle is at 0~45 degree.



Use the low side position when when the cutting angle is at 90 degree.

When the angle cut (wide) safety guard is used, the aluminum fence must be put at low position.





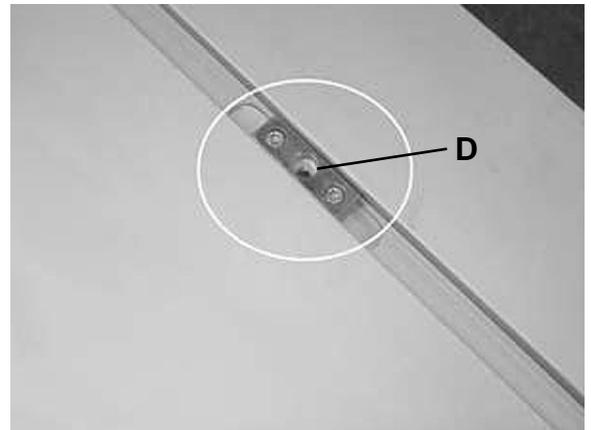
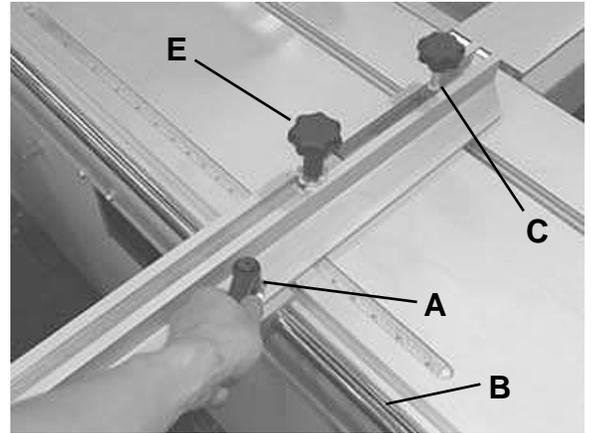
MITER FENCE ASSEMBLE

1. Loosen the miter fence slide block clamp handle (A) a few turns.
2. From the right end of the slide table, place the miter fence slide block over the round slide rod (B) on the front of the sliding table and slide it onto the table until it is over the angle scale.
3. Install the pivot bolt (C) into the pivot block (D) in the sliding table slot and tighten until the miter fence is snug but will rotate on the pivot bolt.
4. Swing the miter fence to the desired angle and tighten the clamp handle (A).



Note *Swing the miter fence slowly and smoothly as the slide block may bind slightly when the fence is moved, especially at the extreme angles.*

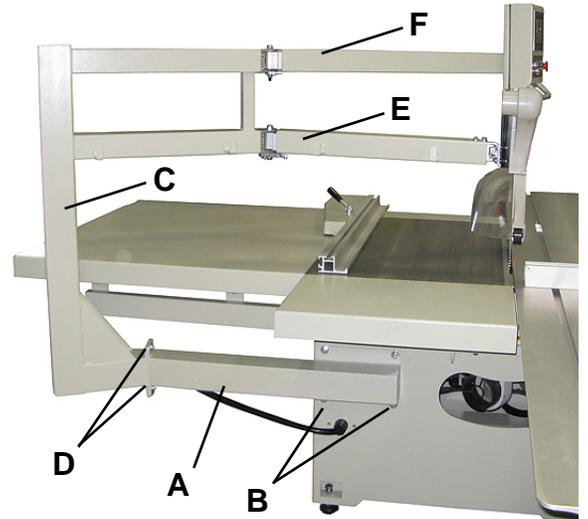
5. Loosen knob (E) and push outwards to extend the miter fence stops.



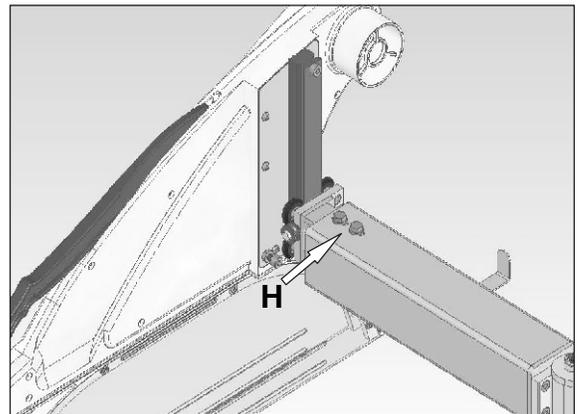
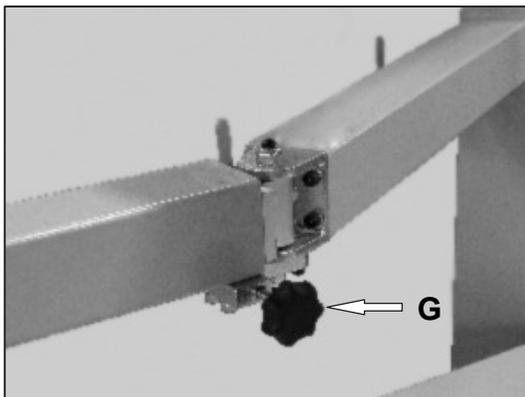
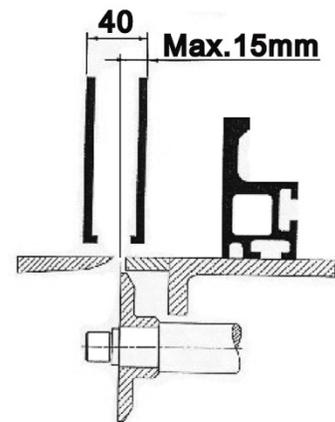


CONTROL/GUARD SUPPORT ASSEMBLY

1. Install the lower support arm (A) using the 4 bolts and washers removed from the mounting holes.
2. Hold the lower support arm level and tighten the 4 bolts (B).
3. Align the upper support arm (C) to the lower arm and secure with two bolts (D).
4. Mount the saw guard arm (E) assembly to the upper support arm and secure with the four cap screws.
5. Mount the control arm (F) to the upper support arm and secure with the four cap screws.

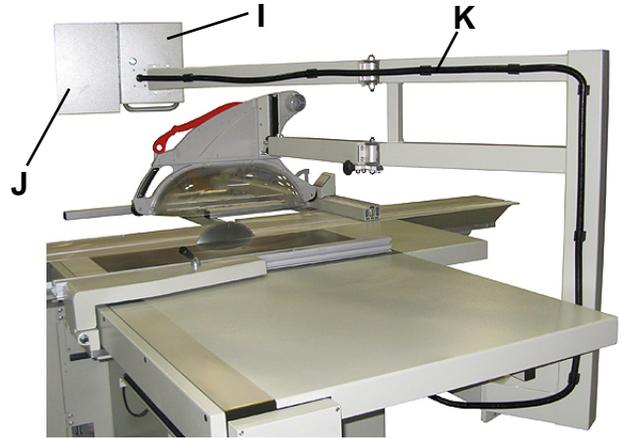


6. Position the saw guard and the saw blade as shown to avoid the saw blade and the guard from contacting each other.
7. With the saw guard over the blade, adjust the guard to be parallel to the blade by loosening the hand knob (G) and the two screws (H).
8. Adjust the saw guard arm for the coarse adjustment and the saw guard mounting bolts for the finish adjustment.
9. When the blade guard is parallel to the saw blade tighten the knob and the screws.



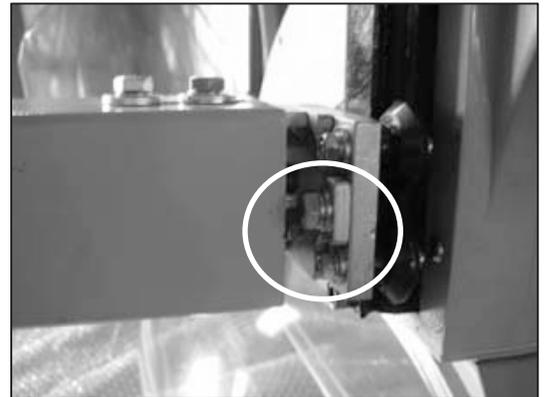


10. Unpack the control box (I) from the carton and route it and the cord up to the top support arm.
11. Using the cabinet key, unlocked the door and open the cabinet.
12. Mount the cabinet on the end of the upper support arm and secure in position.
13. Mount the clip board plate (J) to the side of the control box.
14. Route the cable (K) back down to the cabinet on the inside of the support arm assembly snapping the cable into the cable supports. Leave enough space at the pivot point for the cable to flex when the control panel is moved from side to side.



ADJUST SAFETY GUARD

1. Move the saw guard up or down slightly by hand.
2. Adjust how tight the up/down movement of the saw guard in by adjusting the bolt shown.
3. This adjustment will loosen over time and must be adjusted at least tight enough to prevent the saw guard from moving when unintended.



SAFETY BAR INSTALLATION

1. Remove the switch cover.
2. Remove the pivot bolts and install the safety bar so that the return tab contacts the switch roller.
3. Tighten the bolts enough to allow the safety bar to pivot and the weight of the safety bar to depress the switch plunger.





DUST-COLLECTING CONNECTIONS

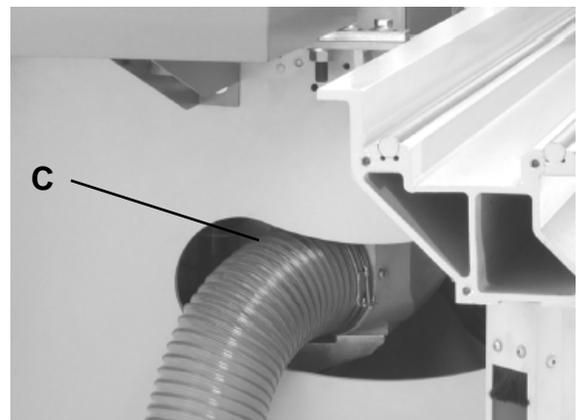
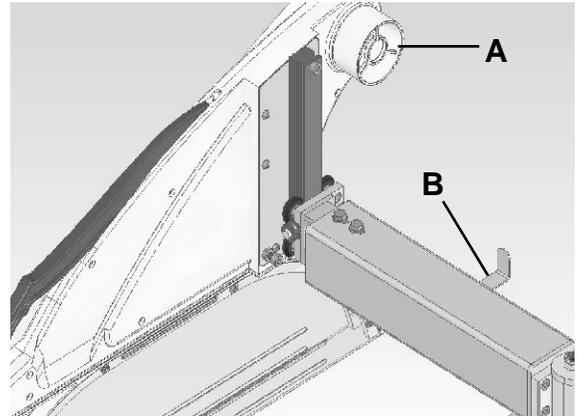
Before the machine is used to cut workpiece, make sure the dust collector work as designed.



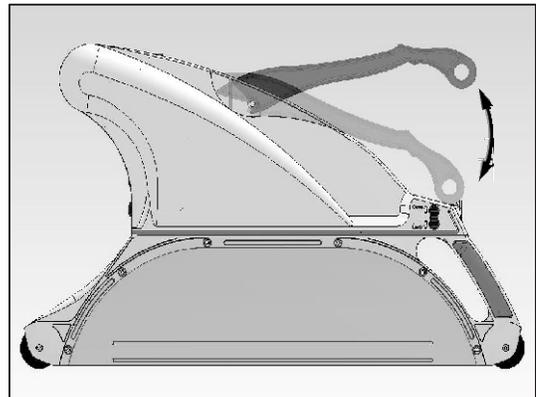
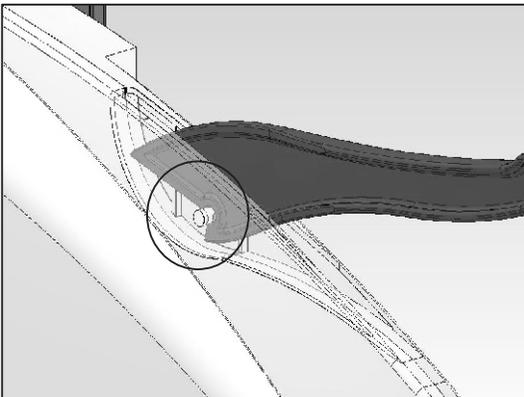
Note: The required air speed at the end of flexible tube is 30 ~ 34m/sec. The required air volume of the machine is 1220 ~ 1390 m³/hr. (43,000~49,000 cu. ft./hr.). Use antistatic and electrically conductive hoses only.

Two dust-collecting outlets are available on the machine to assist with dust removal. The saw guard has a 3" diameter connection port and the saw blade has a 5" diameter connection port on the left side of the machine. They can be connected to the dust collector by one flexible hose in proper diameter.

1. Install the dust collection hose into the dust collection hole (A) at the back of the guard. Diameter of hose at the back of guard is 3".
2. Route and secure the hose onto the support brackets (B).
3. Install the dust collection hose into the dust collection hole (C) on the left side of the saw blade housing. Diameter of hose is 5".



PUSH STICK INSTALLATION



1. Install the pushing stick on the holder at degree 45.
2. Lightly press down on the push stick until the push stick is latched in place.



CHANGE SAFETY GUARD

1. Disconnect and lockout power to the saw!
2. Lower the saw blade fully under the saw table.
3. Push up on the saw guard lock button to loosen the saw blade shield and move backward to remove.

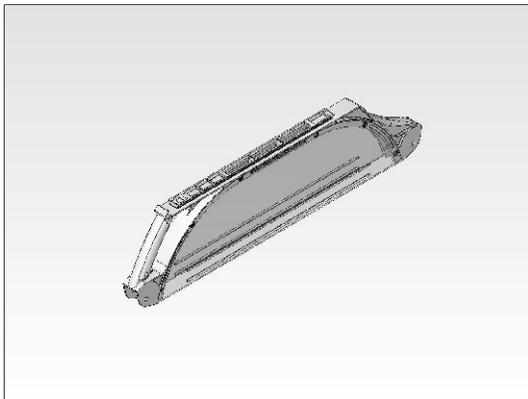
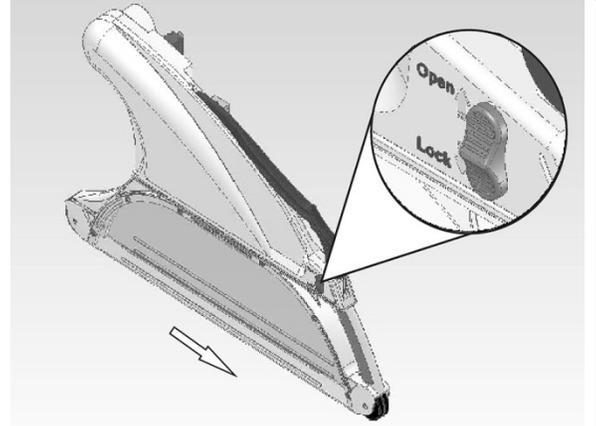


Fig. 1

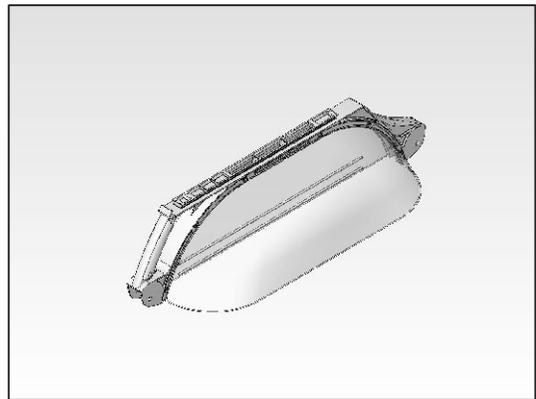


Fig.2



Note: While cutting workpiece:

At 90° cutting, 90° special safety guard must be used as Fig. 1.

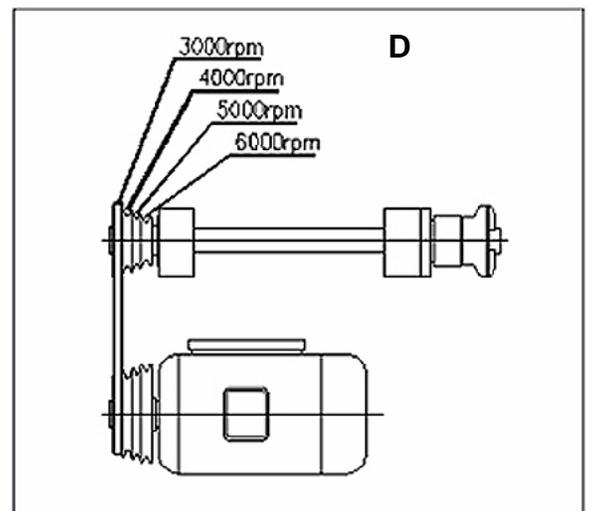
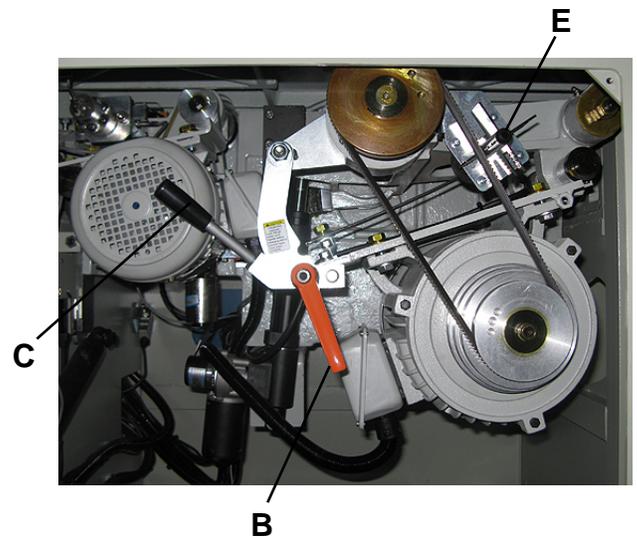
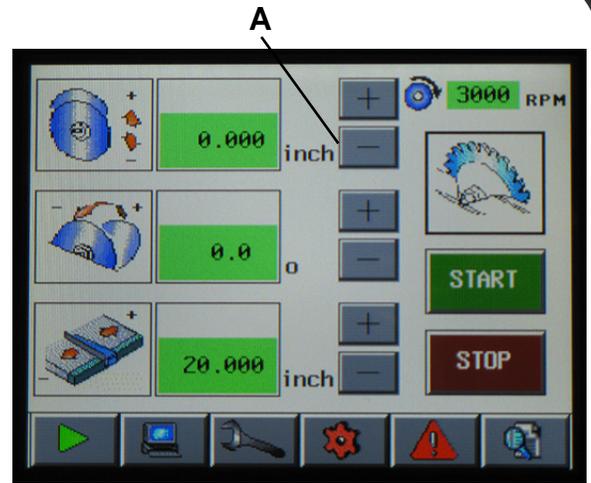
At angular cutting, special angular safety guard must be used as Fig. 2.



CHANGE SPINDLE ROTATING SPEED

Belt tension of main motor is set at about 220kg.cm. The steps of changing main motor's rotating speed as follows:

1. Using the control panel, lower the saw blade to the lowest position.
2. Disconnect and lockout power to the saw!
3. Remove the two screw and open the access door at the back of the machine.
4. Loosen the adjustable handle (B).
5. Press down the handle (C) to lift the motor board to loosen the belt.
6. Place the belt in the grooves that match the desired speed setting (D).
7. Turn the rotating speed positioning knob (E) to your required rotating speed.
8. Make sure the belt has completely entered the grooves of the pulley and then turn & check if the rotating speed positioning knob is at the correct rotating speed position.
9. Lift the handle (C) to lower the motor board to pull tightly the belt and lock the adjustable handle (B).

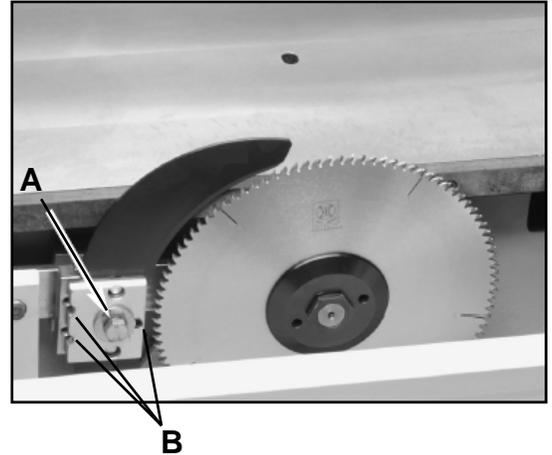


The machine has the rotating speed 3000, 4000, 5000, 6000r.p.m. available for change.

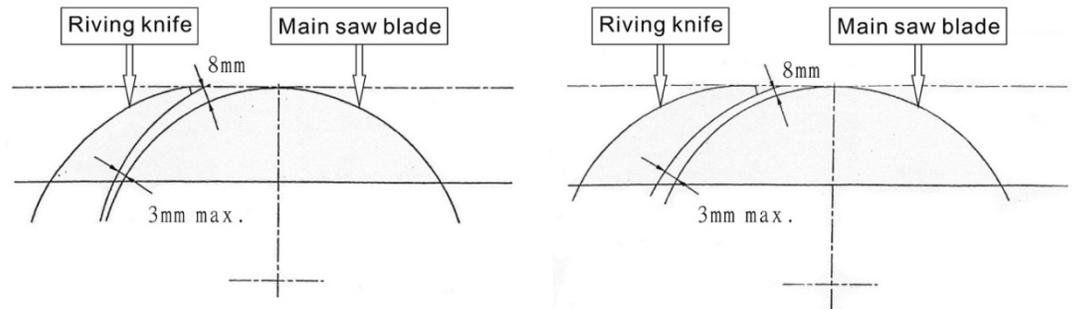


RIVING KNIFE ADJUSTMENT

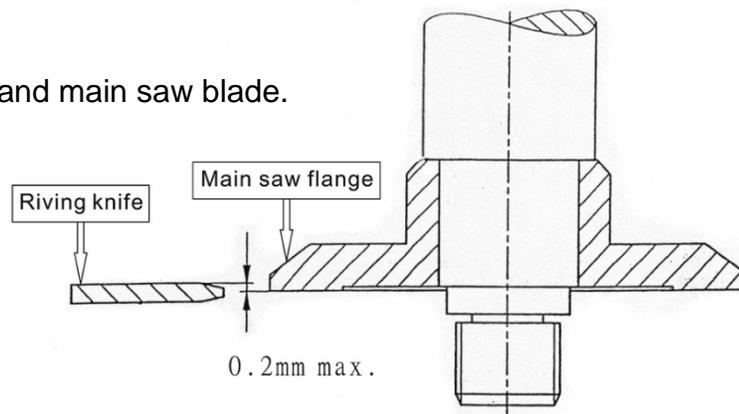
1. Disconnect and lockout power to the saw!
2. Open the saw blade guard.
3. Loosen the retaining screw (A) on the riving knife base just enough to allow the riving knife to move.
4. Adjust the 3 set screws (B) at the sides of the retaining screws as the projected place shown in the above drawing.
5. Measure the relative size of the riving knife and saw blade.



After adjustment of the riving knife is completed, please make sure to tighten the fixing screw on the riving knife base.



Relative size of the riving knife and main saw blade.





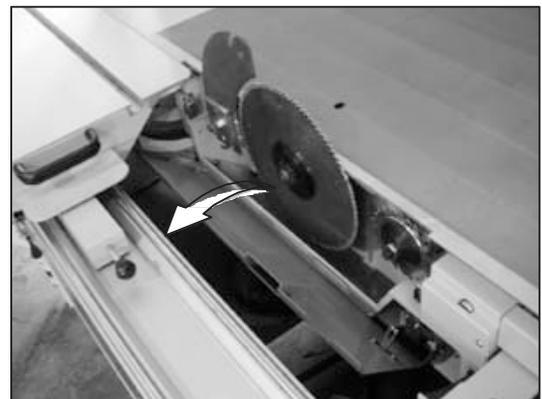
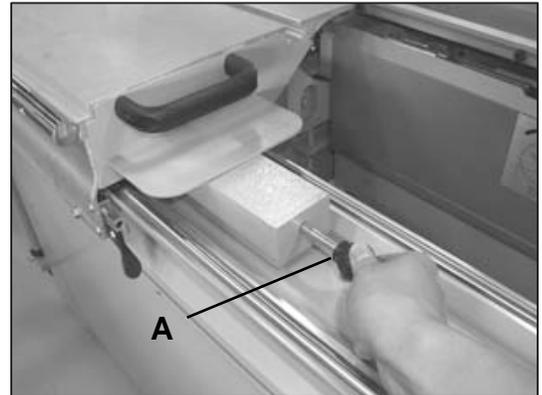
CHANGE MAIN SAW BLADE

⚠ WARNING: Blades are dangerously sharp. Use extreme caution when working with or around the blade. Wear proper safety protection such as heavy gloves.

⚠ WARNING: Turn the power switch "OFF" and unplug the power cord from its power source when changing the saw blade.

When replacing blades, check the thickness stamped onto the riving knife. You must select a blade with a kerf width larger than the thickness of the riving knife. Thinner blades may cause the workpiece to bind during cutting.

1. Raise the saw blade to the full up position and set the saw blade tilt to 0°.
2. Disconnect and lockout power to the saw!
3. Push the sliding table to the left until the travel release rod (A) is exposed.
4. When the release rod is seen, push the ball on the rod inwards to release the sliding table to allow it to over travel the bed and expose the blade housing.
5. Pull forward on the saw blade guard to open the guard.





6. Rotate the saw blade until the lock pin (B) engages into the spindle lock hole.
7. The arbor nut is left hand thread. Turn the nut clockwise remove the nut and flange.
8. Make sure the new saw and flange are clean.
9. Install the new saw blade and torque the nut to 21.7 lb/ft (300kg/cm) to tighten the arbor nut.
10. Remove the lock pin.
11. Close the saw cover.
12. Move the slide table back to the right to engage the travel limit rod.



Important: The main saw blade flange nut must be torqued to 21.7 lb/ft (300kg/cm).

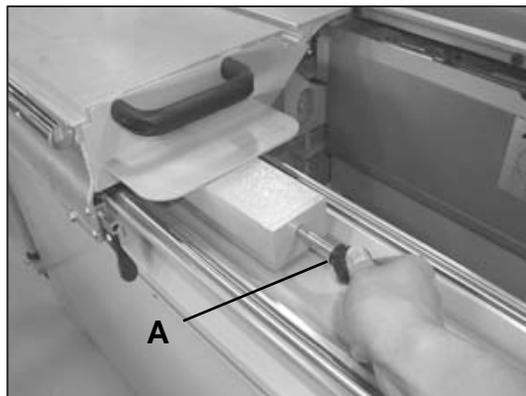
⚠ CAUTION: After changing a saw blade, always check that the Riving knife and Blade Guard are set correctly!

CHANGE SCORING SAW BLADE

⚠ WARNING: Blades are dangerously sharp. Use extreme caution when working with or around the blade. Wear proper safety protection such as heavy gloves.

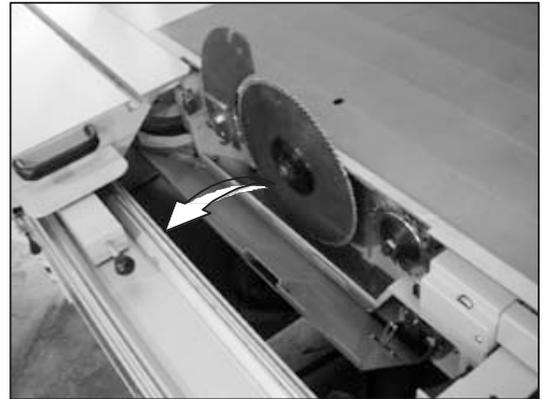
Turn the power switch “OFF” and unplug the power cord from its power source when changing the saw blade.

1. Lower the scoring saw and the main saw blades to the lowest position and set the main saw blade tilt to 0°.
2. Disconnect and lockout power to the saw!
3. Push the sliding table to the left until the travel release rod (A) is exposed.
4. When the release rod is seen, push the ball on the rod inwards to release the sliding table to allow it to over travel the bed and expose the blade housing.





5. Pull forward on the saw blade guard to open the guard.



6. Use the wrench provided to hold the arbor and remove the flange nut.

7. Make sure the new saw and flange are clean.

8. Install the new saw blade and torque the nut to 20 lb/ft (250kg/cm) to tighten the arbor nut.

9. Close the saw cover.

10. Move the slide table back to the right to engage the travel limit rod.

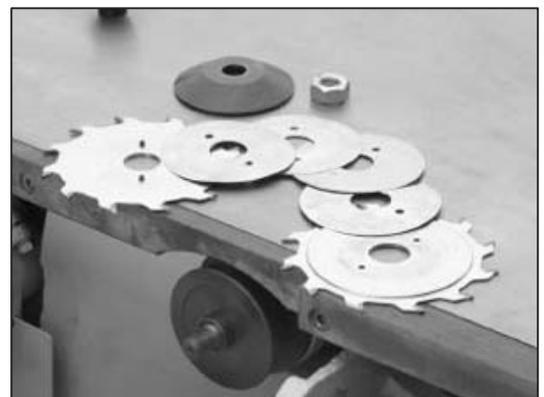


Important: The scoring saw blade flange nut must be torqued to 20 lb/ft (250kg/cm).

The shims are used to adjust the cutting width of the scoring saw to allow it to be wider than the cutting width of the main saw blade to make the cutting workpiece look nicer.

- Thickness of the scoring saw is 2.8mm. Adding shims in combination will increase the thickness of the scoring saw blade up to 4.3mm.
- Shim size & quantity:

0.1mm	1pcs.
0.2mm	1pcs.
0.3mm	4pcs.





ELECTRICAL

⚠ WARNING: Baileigh Industrial is not responsible for any damage caused by wiring up to an alternative 3-phase power source other than direct 3-phase. If you are using an alternate power source, consult a certified electrician or contact Baileigh Industrial prior to energizing the machine.

⚠ CAUTION: HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!
Check if the available power supply is the same as listed on the machine nameplate.

⚠ WARNING: Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

Power Specifications

Your tool is wired for 220 volts, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your tools. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

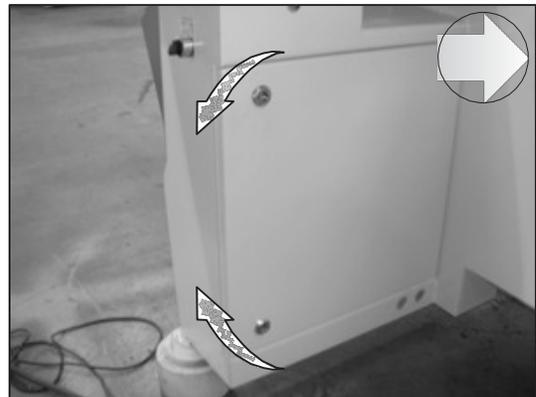


⚠ WARNING: In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Repair or replace damaged or worn cord immediately.

Electrical Enclosure

1. Disconnect and lockout power to the saw!



2. Use the specific key tool enclosed to unlock the electrical enclosure door.

Notes for wiring:

1. Power input: AC5V and AC12V / 50~60HZ.
2. Signal input: Standard proximity sensor or encoder A, B phase signal (DC12V).
3. Unit of measurement: Degrees.
4. Don't connect the shielded cable of the induction unit to circuit 0V or GND.
5. Sensor shielded cables please direct connection to the controller.
6. For reducing controller interference. Use separate signal wire and power wire.
7. The programmable controller is intended of use in Zone B typical industrial environment.

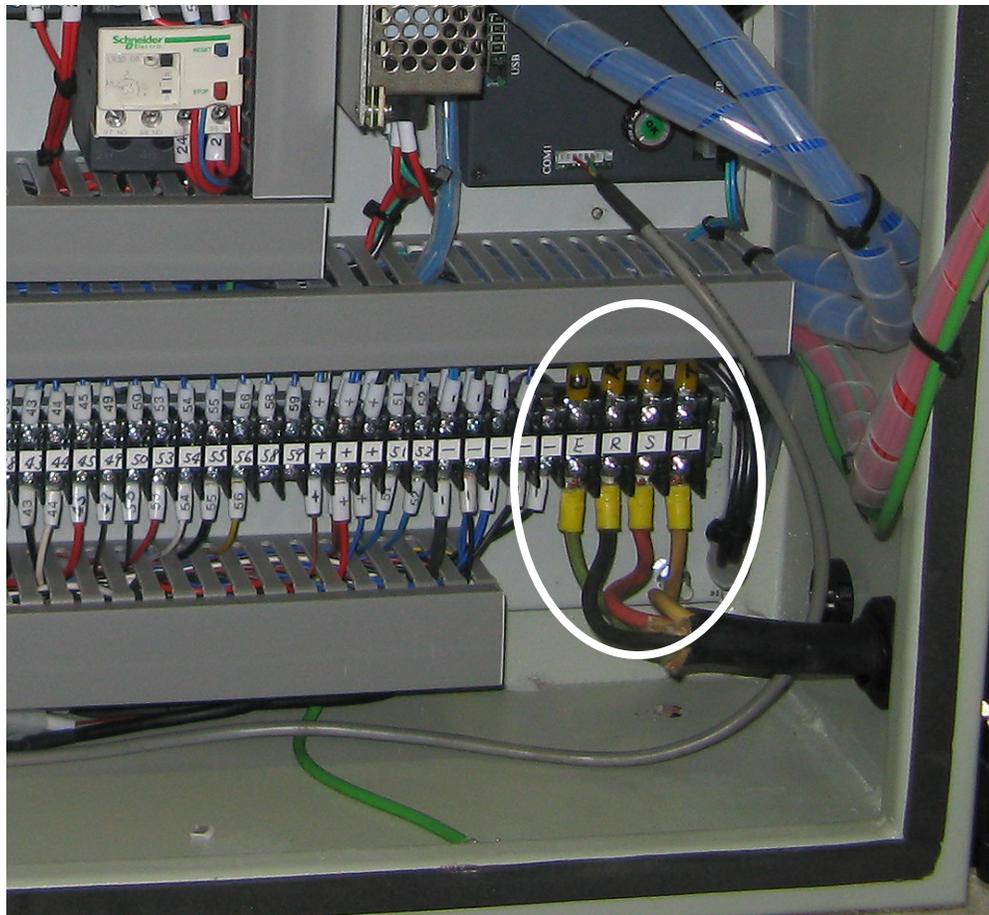


Important:

- The fuse in the signal circuit cannot exceed 3A. Customer supplied.
- Electrical technician and operator must obey above-mentioned items. Changing internal wiring or circuit protection may cause controller burnt out other mechanical damage, this will void the warranty.

Power Supply Connection

1. Verify that the voltage of the machine conforms to the incoming power supply.
2. Use the specific key tool to open the electrical enclosure to connect power.
3. Connect three power wires to terminal L1(R), L2(S), L3(T). Connect the earth wire (green-yellow) to PE terminal.
4. Start motor to check if the rotating direction of the main saw blade and the scoring saw is as shown in "Operational Indications".
5. If the saw blade rotates in reverse direction, stop the blade and disconnect power, exchange terminal L1 position for L2 position and check again.





OPERATION OVERVIEW

Safety Precautions Before Operations

The operation of power tools involves a certain amount of hazard for the operator. Before attempting regular work we recommend you get the feel of operations using scrap lumber to check settings. Read entire instructions before you start to cut workpiece.

Always pay attention to safety precautions to avoid personal injury.

 **WARNING:** Never operate the saw with any guards or covers removed missing or damaged. It could cause severe injury or death.

 **CAUTION:** Always wear proper eye protection with side shields or a face shield, safety footwear, dust mask, and possibly heavy gloves to protect from, chips, dust, burrs, and splinters.

 **WARNING:** Check that saw blade clamping system is tight before operating the machine.

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls and components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is not intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

To complete a typical operation, the operator will:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the blade tilt, if necessary, to the correct angle of the desired cut.
3. Adjusts the blade height to no more than 1/4" higher than the thickness of the workpiece.
4. Adjusts the fence to the desired width of cut then lock it in place.
5. Checks the outfeed side of the machine for proper support and to make sure the workpiece can safely pass all the way through the blade without interference.
6. Puts on safety glasses and a respirator.
7. Locates push sticks/blocks if needed.
8. Starts the saw.



9. Feed the workpiece all the way through the blade while maintaining firm pressure on the workpiece against the table and fence, and keeping hands and fingers out of the blade path and away from the blade.
10. Stops the saw immediately after the cut is complete.

OPERATIONAL SAFETY CHECK



IMPORTANT: Perform these safety checks at least twice every week to ensure proper and secure emergency and interlock switch function.

Emergency Stop Switch Check

1. Connect to power, start the main saw blade and the scoring saw to make the machine run.
2. Push each emergency stop of machine and check if the saw blade and the scoring saw completely stop within 7 seconds.
3. With the emergency stop switch depressed, operate the machine to see if it starts.
 - If the machine does not start the system is operating normally.
 - If the machine starts, the emergency stop is not operating properly, immediately stop operation. Have someone trained in electrical circuits inspect and test the system and possibly replace the emergency stop switch.

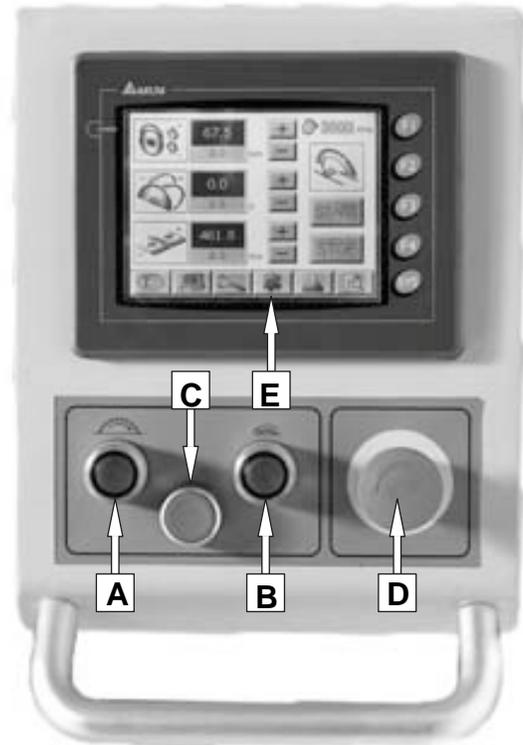
Safety Connection Switch Check

1. Connect to power to the saw. Open the safety door (i.e. saw blade's guard and service door) at the back of the machine.
2. Operate the machine. The machine should not operate.
3. Close the safety door and operate the machine again. The machine should operate.
 - If machine works as described, the safety connection switch is normal.
 - If machine does not work as described, the safety connection switch or wiring has failed and need immediate repair or replacement.



TOUCH SCREEN CONTROL OPERATION

- A. Main Saw Blade On Button
Starts the main saw blade.
- B. Scoring Saw Blade On Button
Starts the scoring saw blade.
- C. Saw Blade Off Button
Stop the main saw blade and scoring saw blade.
- D. Emergence Stop
Disconnects power to all motors in the motor cabinet.
- E. Touch screen
Control for all the axis movement.



Self-Learning Model

Before placing the saw into operation, perform the SELF LEARNING procedure on the AUTO RIP FENCE.

Step 1. For 8 points in same distance from 150mm to 1250 mm.

Move the rip fence in 100mm increments starting at 150mm.

Move from 150mm->250mm, 250mm->350mm, 350mm->450mm, 450mm->550mm, 550mm->650mm, 650mm->750mm, 750mm->850mm, 850mm->950mm, 950mm->1050mm, 1150mm->1250mm

Step 2. For 8 points in same distance from 1250mm to 150 mm.

Move the rip fence back starting from 1250mm.

Move from 1250mm->1150mm, 1150mm->1050mm, 1050mm->950mm, 950mm->850mm, 850mm->750mm, 750mm->650mm, 650mm->550mm, 550mm->450mm, 450mm->350mm, 350mm->250mm. 250mm->150mm

Step 3. For 8 points in 5mm distance only.

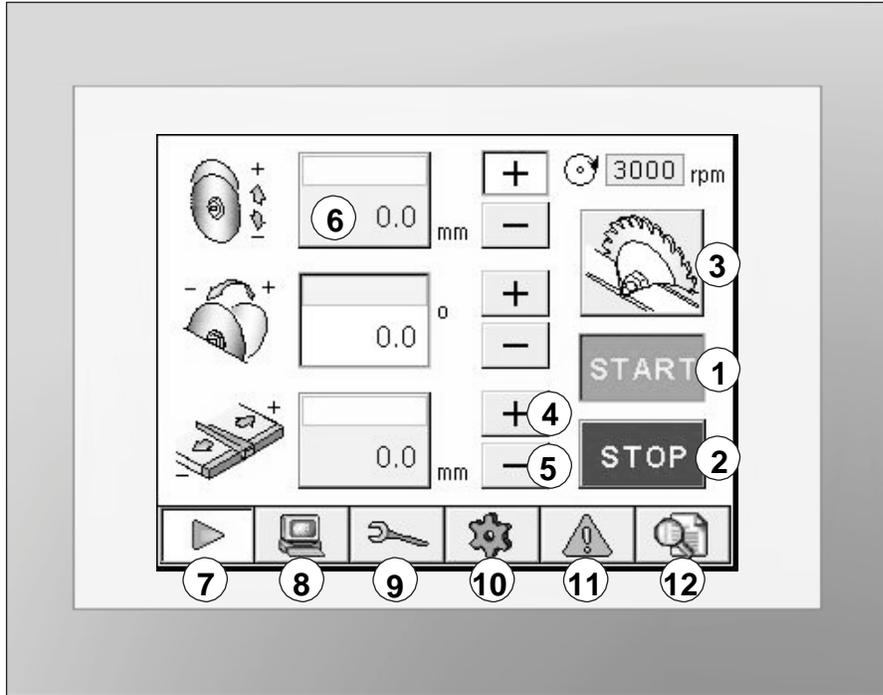
105mm->110mm, 110mm->115mm, 115mm->120mm, 120mm->125mm, 125mm->130mm, 130mm->135mm, 135mm->140mm, 140mm->145mm, 145mm->150mm, 150mm->155mm

Step 4. For 8 points in 5mm distance only.

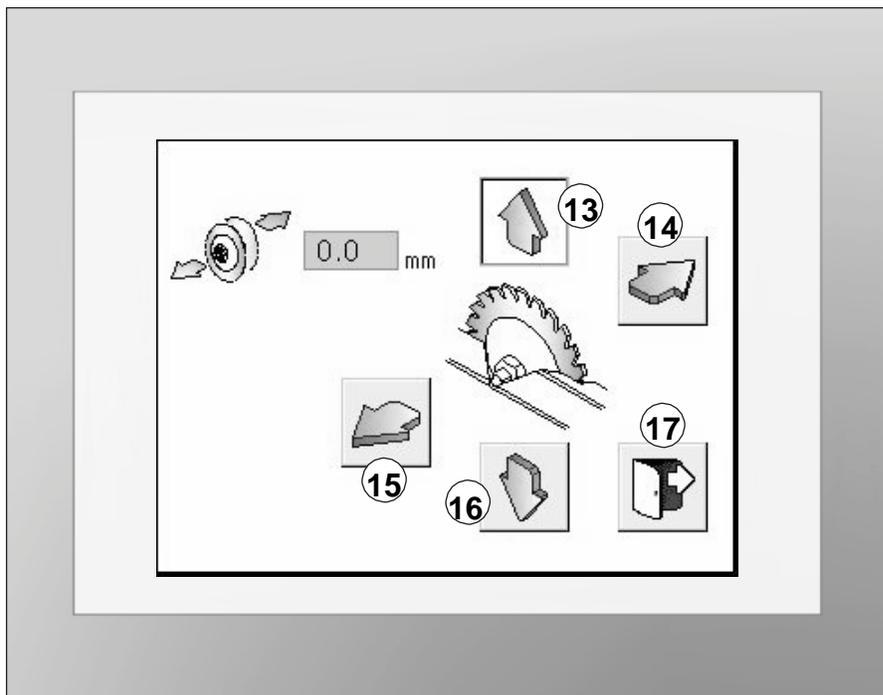
155mm->150mm, 150mm->145mm, 145mm->140mm, 140mm->135mm, 135mm->130mm, 130mm->125mm, 125mm->120mm, 120mm->115mm, 115mm->110mm, 110mm->105mm



Home page

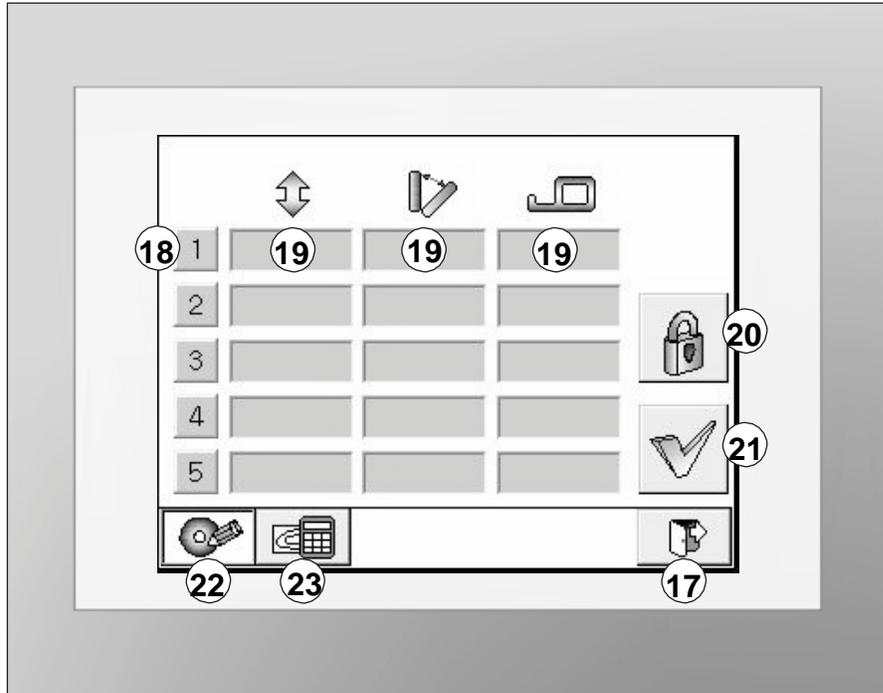


Operation Page of Scoring Saw

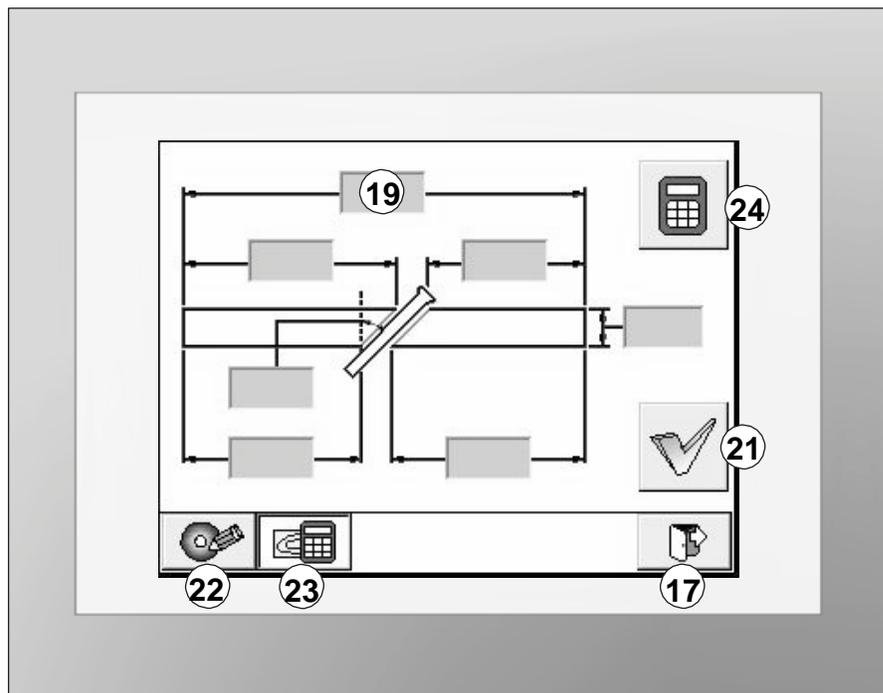




Functional Operation Page
Processing Editing Page

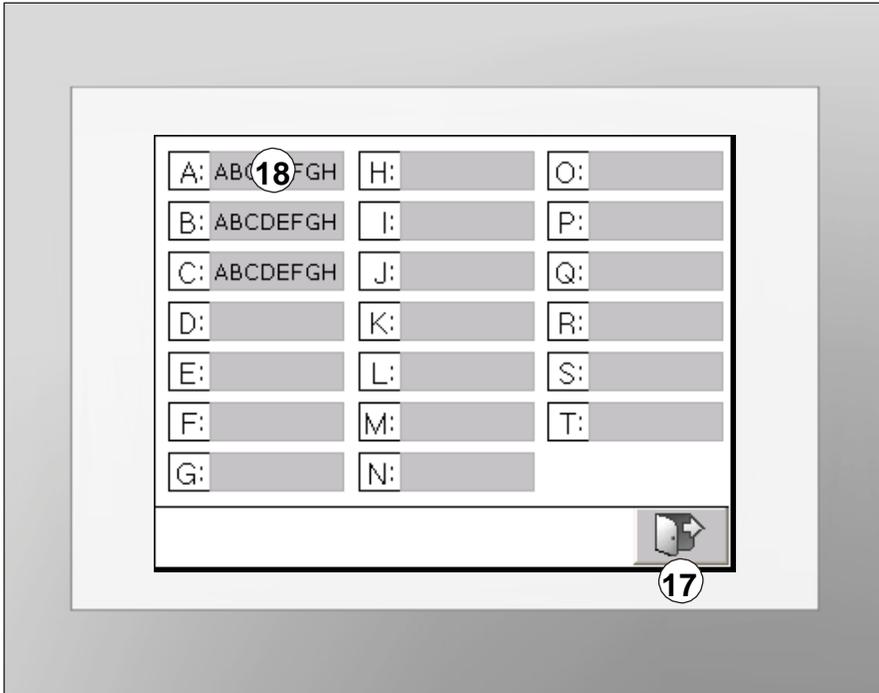


Dimension Calculating Page

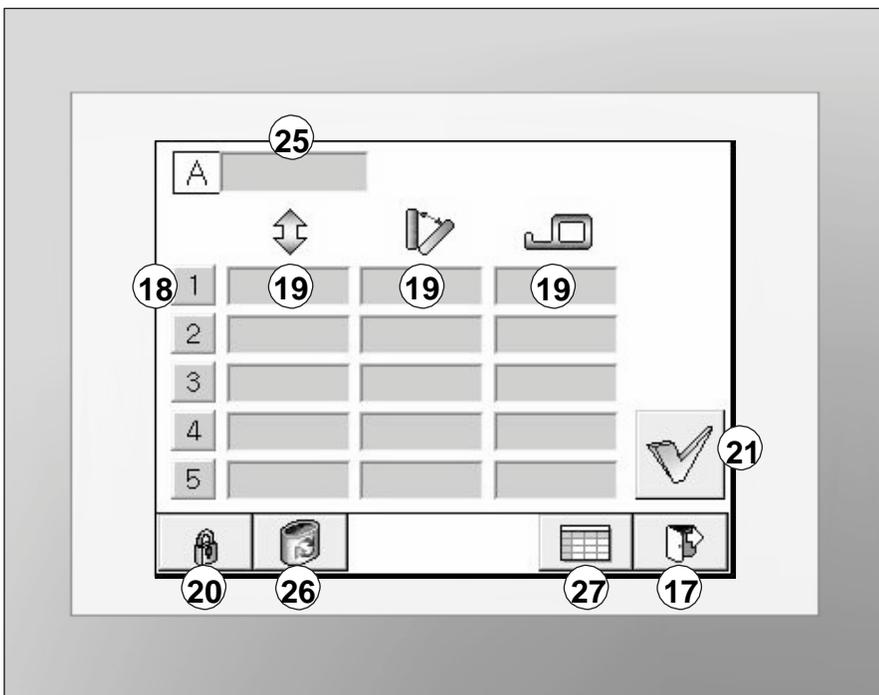




Program Operation Page
Group Selection Page

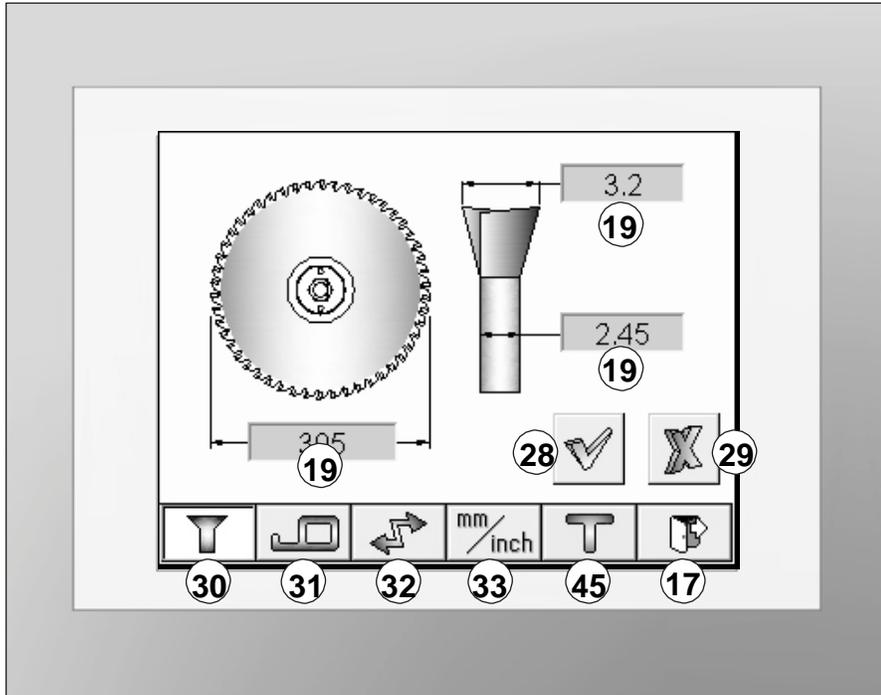


Program Editing Page

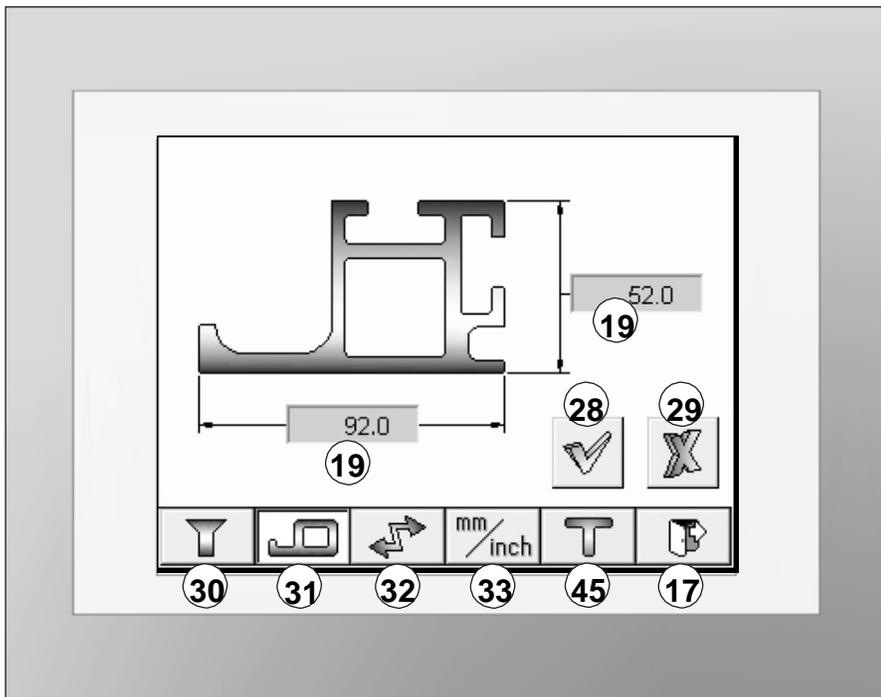




Setting Operation Page
Saw Blade Specification Page

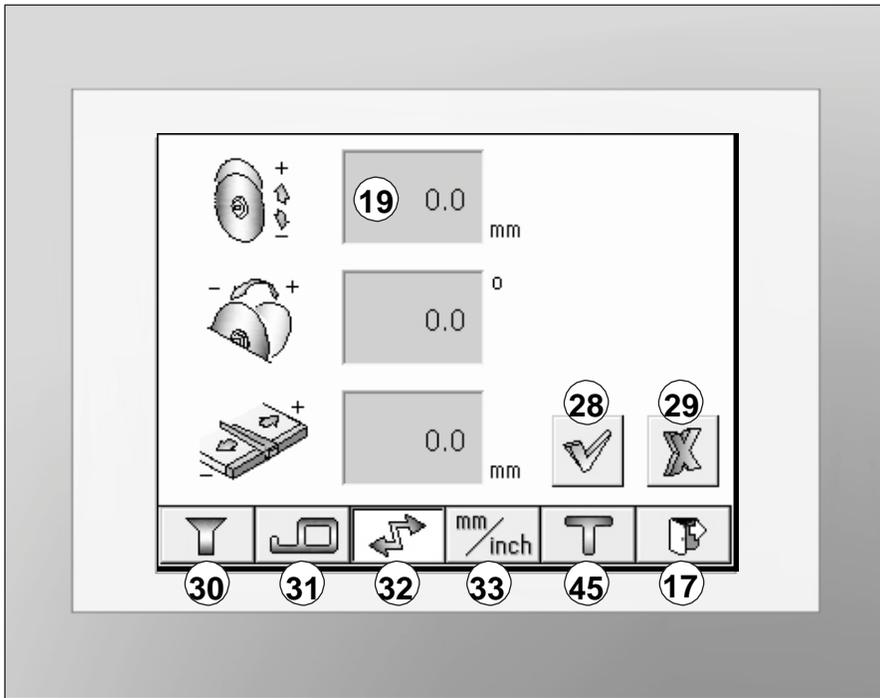


Fence Size Page

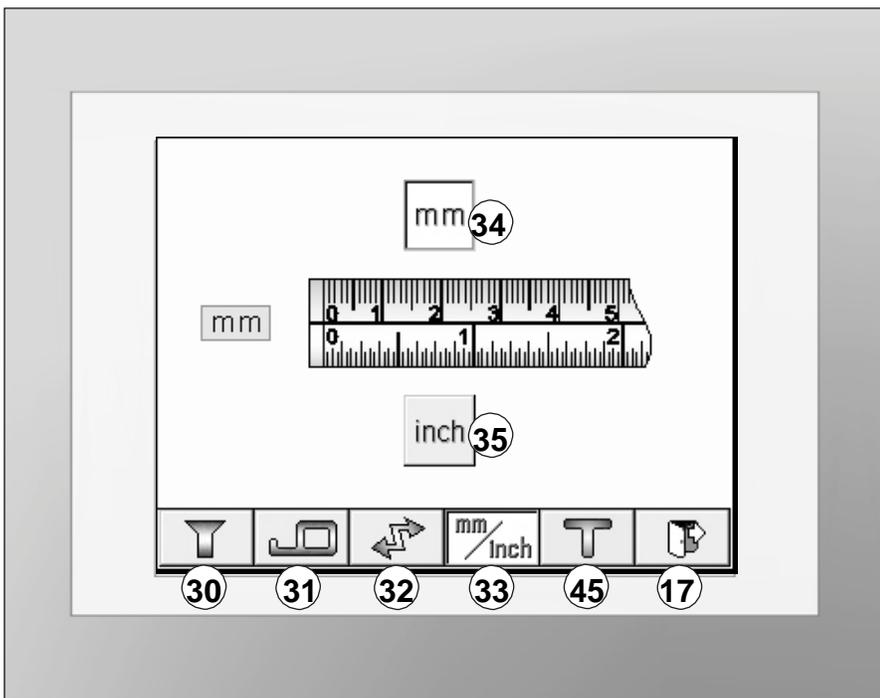




Position Correction Page

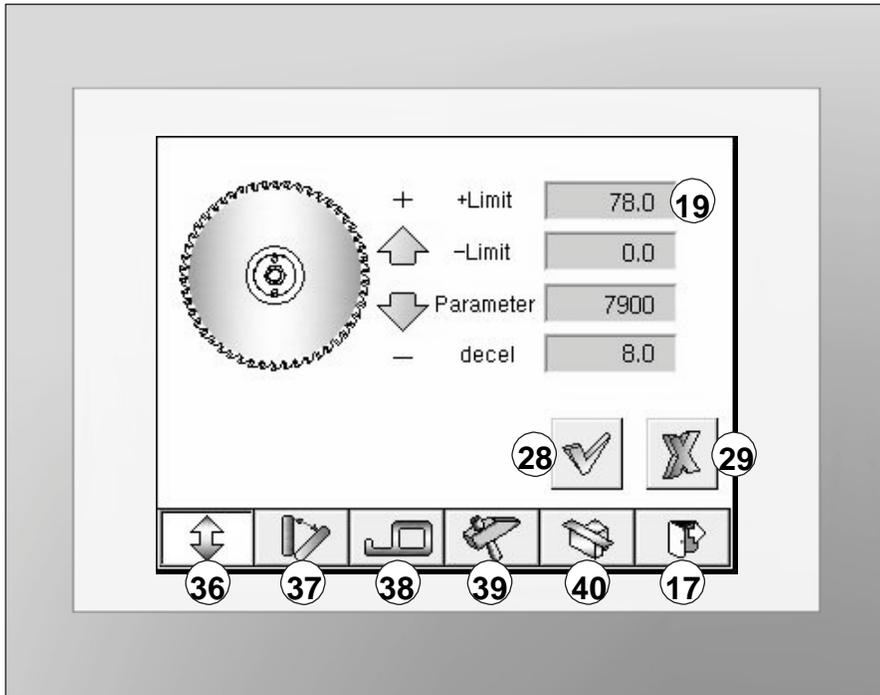


Unit Change Page

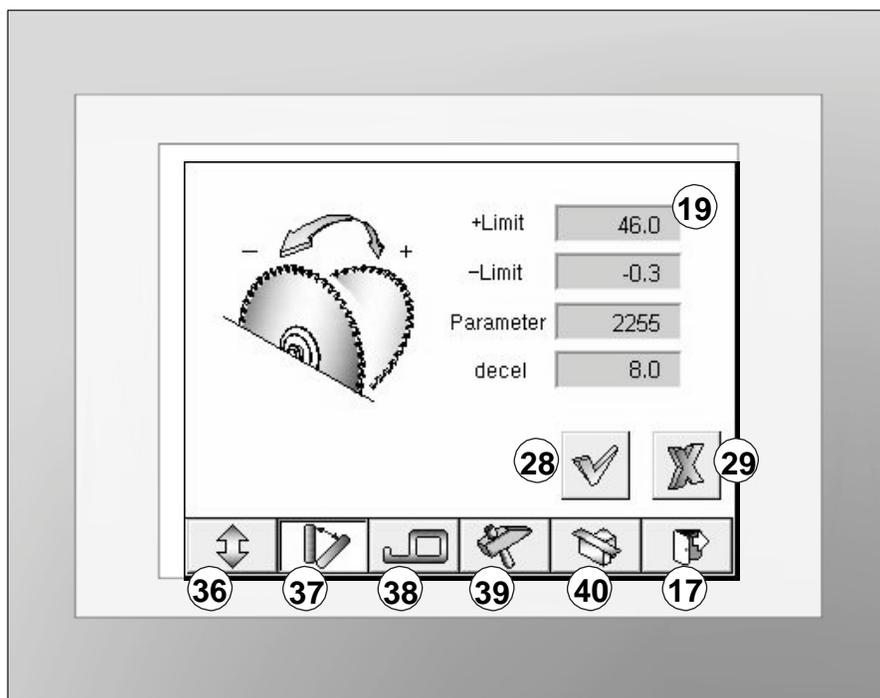




System Operation Page
UP/DOWN Parameter Page



Tilting Parameter Page





Rip Cut Fence Parameter Page

The screenshot shows a control panel for the Rip Cut Fence Parameter Page. On the left is a 3D diagram of a fence assembly with a '+' sign above and a '-' sign below. To the right of the diagram are five input fields: '+Limit' (1325.0), '-Limit' (10.0), 'Parameter' (1251), 'decel' (100.0), and 'Backlash' (0.28). Below these fields is a 'Safety area' field (200.0). To the right of the 'Safety area' field are two buttons: a checkmark (28) and an 'X' (29). At the bottom is a row of six icons: a double-headed vertical arrow (36), a saw blade (37), a fence section (38), a hand holding a tool (39), a fence section (40), and a document (17).

Main Saw Blade tilting Rotary Center Correction

The screenshot shows a control panel for the Main Saw Blade tilting Rotary Center Correction. On the left is a 2D diagram of a saw blade tilted at 45° and 30° relative to a vertical axis. To the right of the diagram are three input fields: 28.6, 49.9, and 50.0. Below these fields are two buttons: a checkmark (28) and an 'X' (29). At the bottom is a row of six icons: a double-headed vertical arrow (36), a saw blade (37), a fence section (38), a hand holding a tool (39), a fence section (40), and a document (17).



Machine's Data Page

Model:	*****	
Date of production:	*****	
System password:	###	<input checked="" type="checkbox"/>
Reconfirmed the (system) password:	###	<input checked="" type="checkbox"/>
Observing password:	###	<input checked="" type="checkbox"/>
Observing password re-confirmed:	###	<input checked="" type="checkbox"/>
Timer of motor braked:	#. #	
Software version:	1234	
PLC error message:	1234	

Navigation icons: 36, 37, 38, 39, 40, 17

Error Data Page

Alarm message

000

Navigation icon: 17



Monitor Data Page
Input Data Page

A port for Main Saw blade tilted

B port for Main Saw blade tilted

A port for Main Saw blade elevated

A port for Rip fence position

B port for Rip fence position

B port for Main Saw blade elevated

Scoring saw advance index switch

Main saw blade rise protective switch

Main saw blade down protective switch

Main saw blade tilt increase protective switch

INPUT OUTPUT

41 42 43 44 17

Output Data Page

Scoring saw blade move up TEST

Scoring saw blade move down TEST

Scoring saw blade move on TEST

Scoring saw blade move back TEST

Main saw blade move up TEST

Main saw blade move down TEST

Main saw blade elevator in low speed TEST

Main saw blade tilt increase TEST

Main saw blade tilt decrease TEST

INPUT OUTPUT

41 42 43 44 17



Functional Explanation of Keys

1.	START:	A key for starting running such as main saw blade up/down movement, tilting angle, etc.
	 running.	Note: The START is only for controlling movement excluding saw blade's running.
2.	STOP:	A key for stopping running such as main saw blade up/down movement, tilting angle, etc.
	 stop.	Note: The STOP is only for controlling movement excluding saw blade's stop.
3.	Scoring Saw Setting key:	A key for setting scoring saw forward/backward and up/down.
4.	Increase (+) key:	A key for slightly increasing movement.
5.	Decrease (-) key:	A key for slightly decreasing movement.
6.	Numerical Value Display Setting key:	A key for showing present value and setting value movement
7.	Function key:	A key for entering functional operation page.
8.	Program key:	A key for entering program operation page.
9.	Setting key:	A key for entering setting operation page.
10.	System key:	A key for entering system operation page.
11.	Error key:	A key for entering error data.
12.	Monitor key:	A key for entering monitor operation page.
13.	Movement key:	A key for scoring saw movement.
14.	Movement key:	A key for scoring saw movement.
15.	Movement key:	A key for scoring saw movement.
16.	Movement key:	A key for scoring saw movement.
17.	Exit key:	A key for departing and returning to home page.
18.	Group key:	A key for selecting the processing group.
19.	Numerical Value Editing key:	A key for editing input, parameter, etc.
20.	Lock/Release key:	A key for locking and releasing.
21.	Confirmation key:	A key for confirming present selection, value, parameter, etc.
22.	Processing Editing key:	A key for entering the processing editing page.
23.	Dimension Calculating key:	A key for entering the dimension calculating page.
24.	Calculation key:	A key for calculating dimension.
25.	Data editing key:	A key for editing the shown data.



26.	Delete key:	A key for deleting the selected group.
27.	Group Listing key:	A key for showing all groups.
28.	Save key:	A key for saving input.
29.	Cancel key:	A key for canceling input.
30.	Saw Blade Specification key:	A key for entering saw blade specification page.
31.	Fence Size key:	A key for entering fence size page.
32.	Position Correction key:	A key for entering position correction page.
33.	Unit Change key:	A key for entering unit change page.
34.	Metric Unit key:	A key for changing to metric unit.
35.	Inch Unit key:	A key for changing to inch unit.
36.	UP/DOWN Parameter key:	A key for entering UP/DOWN parameter page.
37.	Tilting Parameter key:	A key for entering the tilting parameter page.
38.	Rip Fence Parameter key:	A key for entering rip fence parameter page.
39.	Parameter Correction key:	A key for entering parameter correction page.
40.	Machine Data key:	A key for entering machine data page.
41.	Input Data key:	A key for entering input data page.
42.	Output Data key:	A key for entering output data page.
43.	Page up key:	A key for page up.
44.	Page down key:	A key for page down.
45.	Language Change key	A key for entering language change page.

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