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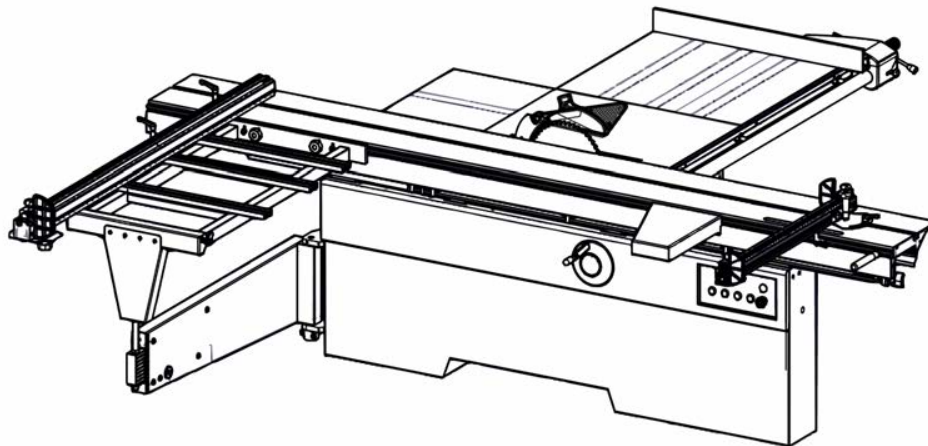
K 430

Sliding Table Panel Saw

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**Keep this manual to hand and in good condition for future reference.
Read this operating manual carefully before using the machine.**

Translation of the original operating instructions

Operating instructions

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1 Information about the manual

1.1 Explanation of symbols

Safety instructions

Safety instructions in this manual are indicated with symbols. The safety instructions are preceded by signal words that indicate the severity of the hazard.

Comply with safety instructions under all circumstances, and act with care in order to avoid accidents, personal injury, or material damage.



DANGER

... indicates a situation of immediate danger which will result in death or severe injuries if it is not avoided.



WARNING

... indicates a potentially dangerous situation which, if not avoided, could result in death or serious injury.



CAUTION

... indicates a potentially dangerous situation which, if not avoided, could result in minor or slight injuries.



NOTICE

... indicates a potentially dangerous situation which, if not avoided, could result in material damage.

Structure of a safety instruction based on the SAFE principle

Survey the workspace and environment

Uses the signal word and symbol to provide object description information regarding the level of risk to people and property (Attention / Warning / Danger).

Assess and eliminate hazards

Describes the cause of the hazard.

Follow operating instructions, and be aware of the consequences

Describes the consequences of failing to pay attention to the warnings.

Avoiding danger

Describes measures to prevent the hazard.

Example of a safety instruction:



WARNING

Breathing in dust

If inhaled, dust can cause respiratory diseases and lung damage. Certain types of dust, such as hardwood dust, can be carcinogenic.

- When working with carcinogenic dusts, wear respiratory protection with a particle filter offering $\geq 99.95\%$ filtration efficiency. e.g. P3 or N100 / P100
- Check that there are no other persons in the immediate vicinity of the machine.

Tips and recommendations



... emphasises useful tips and recommendations as well as information for efficient and trouble-free operation.

OK / NOK

Symbols	Description
	Result is okay.
	Result is not okay. Procedure when troubleshooting.

Safety instructions symbol

The following symbols may appear in the operating instructions.

Icon	Object description
	General warnings
	Warning of electrical voltage
	Warning of dangers due to charging batteries
	Warning of obstacles in the head area
	Warning of falling objects
	Warning about falling loads
	Warning of suspended loads
	Warning against crushing
	Warning of hand injuries due to crushing
	Warning of hand injuries due to cutting
	Warning of hot surfaces

The following symbols may appear in the description of operating equipment.

Icon	Object description
	Warning about hazardous substances
	Warning of environmentally hazardous substances
	Warning of flammable substances

1.2 Contents of the operating manual

- This operating manual describes the safe and proper use of the machine.
- All instructions in this manual must be strictly followed without exception.
- The operating manual is an integral part of the machine. It must therefore be kept in the direct vicinity of the machine and be accessible at all times.
- The operating manual must always accompany the machine.

1.3 Liability and warranty

- The contents and instructions in this manual have been compiled in consideration of current regulations and state-of-the-art technology as well as based on our know-how and experience acquired over many years.
- The manufacturer shall not be liable for damage and/or faults resulting from the disregard of instructions in the manual.
- The text and images do not necessarily represent the exact product that has been delivered. The images and graphics are not depicted on a 1:1 scale. The product that has been delivered, may have custom-built specifications, add-on options or recent technical modifications and may therefore deviate from the descriptions, instructions and images contained in the manual.
- We reserve the right to make technical changes to the product in order to improve the properties of use and further product development.
- The guarantee period is in accordance with national guidelines. Details may be found on our website, www.felder-group.com.
- Should any questions arise, please contact the manufacturer.

1.4 Copyright

- This manual should be treated as confidential. It is intended solely for those people who are to work on or with the machine.
- All descriptions, texts, drawings, photos and other depictions are protected by copyright and other commercial laws.
- Any unauthorised use is prohibited.
- This manual, in its entirety or parts thereof, may not be transferred to third parties or copied in any way or form, and its contents may not be used or otherwise communicated without the express written consent of the manufacturer. Infringement of these rights may lead to a claim for compensation. The right to further claims is reserved.
- We reserve all rights to exercise industrial property rights.

1.5 Training

- All those appointed to work on or with the machine must have fully read and understood the manual before commencing any work. This requirement must be met even if the appointed person is familiar with the operation of such a machine or a similar one, or has been trained by the manufacturer.
- Knowledge about the contents of this manual is a prerequisite for protecting personnel from hazards and avoiding mistakes so that the machine may be operated in a safe and trouble free manner.
- It is recommended that the operator requests proof from the personnel that the contents of the manual have been read and understood.

1.6 Contact Felder Group service centre

In the event of faults, problems and questions about your machine, please contact the local Felder Group service centre. You can find the contact details on our website: ➔ www.felder-group.com

2 Safety instructions

2.1 Personal protective equipment

2.1.1 Prohibitions

When working on or with the machine, the following must be strictly observed:

	Please note
	Long, loose hair is forbidden. A hair net must be worn with long hair and beards.
	It is prohibited to wear gloves whilst working with the machine. It is only allowed to wear gloves whilst carrying out tool changes and maintenance work.
	Wearing watches, rings and other jewellery is forbidden. Remove all jewellery, bracelets, watches and rings when operating the machine or carrying out maintenance work.

2.1.2 Mandatory safety equipment

Basic personal protective equipment

The personal protective equipment must comply with the applicable national regulations and standards. Personal protective equipment must be checked to ensure that it is in perfect condition before each use. Only personal protective equipment that is fully functional, undamaged and suitable for the intended use may be used.

When working on and with the machine, suitable personal protective equipment must be worn depending on the activity and hazard situation. As a rule, this includes:

	Please note
	Protective clothing: Sturdy, tight-fitting clothing (tear-resistant, no wide sleeves).
	Protective footwear: To protect feet from heavy falling objects and prevent from slipping on slippery floors.
	Ear protection: To protect against loss of hearing.
	Safety goggles: Protection to prevent damage to eyes.
	Respiratory mask: To protect from dust when carrying out cleaning and maintenance work. Use respiratory protection with particle filter ≥ 94 % filtration efficiency (e.g. filter class P2 according to EN 143 or N95 according to NIOSH). For potentially carcinogenic dusts, use respiratory protection with particle filter ≥ 99.95 % filtration efficiency (e.g. filter class P3 according to EN 143 or N100/P100 according to NIOSH).

Additional protective equipment required

The activity-specific personal protective equipment required in addition to the basic personal protective equipment is described in the respective chapters and sections of this manual.

The basic personal protective equipment is not mentioned again in the following chapters and sections.

2.2 Intended use

- The machine described in this manual is intended solely for the processing of wood, synthetic materials, and similar machinable materials. Operational safety is only guaranteed when the machine is used for the intended purposes.
- Any use, other than that of the machine's intended purpose shall be considered improper and is therefore not permitted. All claims regarding damage resulting from improper use that are made against the manufacturer and its authorised representatives will be rejected.
- The operator is solely liable for any damage that results from improper use of the machine.

- The term “proper use” also refers to correctly observing the operating conditions as well as the specifications and instructions in this manual. The machine may only be operated when using parts and accessories recommended by the manufacturer.

2.3 Making changes and modifications to the machine

In order to avoid potential hazards and to ensure optimum performance, no modifications, alterations or changes may be made to the machine that have not been explicitly approved by the manufacturer.

Unauthorised modifications, conversions and extensions to the machine

Modifications, conversions and extensions to the machine may jeopardise the functionality and operational safety of the machine. This can seriously injure or kill people.

- Modifications, conversions and extensions may only be carried out by an authorised specialist with the express permission of the manufacturer.

Deactivated or defective protective devices

The machine is equipped with diverse protective devices with safety function. When protective devices are decommissioned, the safety function is no longer ensured. Deactivated or defective protective devices can cause serious injuries.

- The safety equipment required for processing must be in good working conditions and properly maintained.
- Check all required safety devices to ensure good working condition.
- Do not switch off, bypass or disable protective and safety equipment.
- Do not deactivate protective devices.
- Do not intentionally trigger safety equipment.

Missing or illegible safety stickers

Pictograms, signs and labelling on the machine warn of hazards and misuse and are an important part of the safety equipment. Missing or illegible safety stickers increase the risk of serious and fatal injuries.

- Keep all pictograms, signs and labelling on the machine in a legible condition.
➔ Chapter 5.2 ‘Pictograms, signs and labels’ on page 25
- Damaged or illegible pictograms, signs and labelling must be replaced immediately.
- Label spare parts with the safety stickers provided.

2.4 Responsibilities of the operator

- The machine may only be operated if it is in proper working order and in safe condition.
- The machine must be inspected for visible defects and damage each time before it is switched on.
- Do not leave the machine running unattended.
- Secure the switched-off machine against unauthorised operation (padlock on the main switch, remove the key from the operating mode selector switch, block off the area around the machine, pull out the mains plug etc.).
- In addition to the safety advice and instructions specified in this operating manual, any local accident prevention regulations and general safety regulations applicable to the machine's area of use, as well as any applicable environmental protection regulations, must be observed and complied with.
- The operator and designated personnel are responsible for the trouble-free operation of the machine as well as for clearly establishing who is in charge of installing, servicing, maintaining and cleaning the machine. Keep children away from machines, tools and accessories.

2.5 Requirements of the personnel

- Only authorised and trained personnel may work on and with the machine. "Qualified personnel" is a term that refers to those who – due to their professional training, know-how, experience, and knowledge of relevant regulations – are in a position to assess delegated tasks and recognise potential risks.
- Personnel must be briefed about all potential dangers of the machine.
- Personnel must be familiar with the functions of the machine's guards and protective devices and their regular inspection.
- If the personnel lack the necessary knowledge for working on or with the machine, they must be trained. Responsibility for working with the machine (installation, service, maintenance, overhaul) must be clearly defined and strictly observed.
- Only those people who can be expected to carry out their work reliably may be given permission to work on or with the machine.
- Personnel must refrain from working in ways that could harm others, the environment or the machine itself.
- It is absolutely forbidden for anyone who is under the influence of drugs, alcohol or reaction-impairing medication to work on or with the machine.

- When appointing personnel to work on the machine, it is necessary to observe all local regulations regarding age and professional status.
- The machine may only be operated by an adult, that is without mental limitations or under the supervision of such a person.
- The operator must ensure that unauthorised persons maintain a sufficient safety distance from the machine.
- Personnel are obliged to immediately report any irregularities with the machine that might compromise safety to the operator.

2.6 Basic safety instructions

The machine has undergone a hazard analysis. The design and construction of the machine are based on the results of this analysis and correspond to state-of-the-art technology. The machine is considered operationally safe when used properly. Even if the safety measures are complied with, there are still certain associated risks that must be considered when working on the machine. This information should enable operators to better assess hazards and risks and avoid foreseeable misuse.

Generally applicable residual risks

- Crushing by being caught between moving parts.
 - Do not reach into the area of moving parts.
- Whilst processing, sparks can be created.
 - Carefully inspect workpieces for foreign matter (nails, screws) which might impair processing.
- Risk of damage to health from dust especially when processing hard woods.
 - Connect the dust extraction system in accordance with the instructions and make sure that it is working properly.
- Injury from flying workpieces and parts of the workpieces.
 - Wear personal protective equipment (protective work clothing and safety goggles)
- Cut or crush injuries, when changing the tools.
 - Wear protective gloves.
- Injury caused through being crushed, cut, caught or bumped into.
 - Pay particular attention when the machine is running.
- In the event of power supply failure, the machine will come to a stop without applying the brakes (no electric brake action).
 - It takes longer than normal for tools to come to a stop.
 - Do not reach into the area of the running tool.

Disregarding operating instructions

The operational safety of the machine is only guaranteed if the operating instructions are observed. People could be seriously injured or killed.

- Read and observe the operating instructions in full before commissioning.
- Only the equipment, tools and procedures specified in the operating instructions are safe.
- Do not operate the machine if, the operating instructions are not complete, or if it isn't available in the language of the country of operation.
- Keep the operating instructions with the machine and keep them available.

Incorrect work on the electrical units

Work on the electrical equipment may only be carried out by qualified personnel. People could be seriously injured or killed.

- Work on electrical equipment may only be carried out by qualified personnel and in strict observance of the safety instructions.
- Disconnect machine from power supply and secure against restarting before carrying out work on electrical equipment.

Does not comply with technical limits

If the technical limits of the machine are not complied with, people could be seriously injured or killed.

- Comply with limit values according to technical data. ➔ *Chapter 4 'Technical information' on page 19*
- Technical limit values include: speed, tool diameter, workpiece dimensions, load capacities, ambient temperature etc.

Noise / high sound level

Continuous work with the machine can cause damage to health due to noise.

- Use suitable hearing protection depending on ambient conditions, working hours, operating conditions and the materials to be processed.
- Take the sound pressure level into account. ➔ *'Noise emission values' on page 23*

- Sound level depends on the tool used. ➔ *Chapter 4.4 'Saw unit and tools' on page 21*
- Observe the operating and installation conditions, as a different work process can lead to higher noise emissions, for example.

Dust deposits

Dust build-ups can ignite when in contact with hot parts or cause an explosive atmosphere due to resuspension. Fire or explosion events can cause serious injuries.

- Clean production area as needed.
- Open fire, smoking and cleaning with compressed air forbidden.
- Only carry out spark-producing work and hot work after work release process.

Noise and dust exposure

Serious injuries

Factors that influence noise exposure:

- the selection of low-noise tools,
- choosing the right speed,
- the maintenance of the tools and the machine,
- the type of material to be processed,
- the use of all available covers and
- the use of hearing protection.

Factors that influence dust exposure:

- the quality of tool and machine maintenance,
- the material to be processed,
- local extraction (capture at the source),
- the correct setting of the extraction hoods/guiding elements/collection channels,
- connecting the machine to an external chip and dust extraction system.

Damage to electrical components or their insulation

Damaged electrical components or damage to their insulation cause deadly electric shocks.

- Work on electrical fittings may only be carried out by qualified personnel and in strict observance of the safety instructions.
- Disconnect machine from power supply and secure against restarting before carrying out work at electrical devices.

Standing on the machine

The covers or projecting components of the machine are not suitable for standing on them. Falling off the machine can result in serious injury.

- It is forbidden to climb onto the machine.

2.6.1 Transport, setup, installation and disposal

Incorrect setup and installation

The machine's operational safety is guaranteed only if it is set up and installed properly. People could be seriously injured or killed.

- Machine may only be set up by authorised, trained personnel who are familiar with how to operate the machine and are in strict observance of all safety instructions.
- Before assembling and installing the machine, check to make sure it is complete and in perfect working order.
- Only assemble and install the machine if the machine and all of the parts are complete and intact.
- Use safety equipment according to regulations and check proper functionality.
- Do not setup machine in areas with high electromagnetic fields.
- Do not setup machine in escape routes.
- Only place machine within buildings.
- Place the machine on a level, sufficiently stable, non-slip and vibration-free surface.
- The load-bearing capacity, coating and surface of the floor must remain constant in the long term.
- The floor around the machine must be level, well maintained, free of obstacles and free of debris such as chips and cut-off workpieces.
- The working area must be adequately lit.

Exceeding or falling below the permissible ambient temperature

If the permissible surrounding temperature is not complied with, malfunctions and unpredictable machine movements may occur. This can lead to serious personal injury and damage to property.

- Only operate machine within the listed temperature range.
- Follow operation and storage conditions in accordance with the technical information.
➔ Chapter 4 'Technical information' on page 19

Insufficient space available for force-guided workpieces.

If there is not sufficient distance between the machine and neighbouring machines, walls or other solid objects, the rail-guided workpieces pose a potential risk during the machining process.

The approximation of a workpiece to a fixed object or building structure can lead to severe crushing of limbs as well as the entire body.

- Observe minimum distances to spatial boundaries.
- Ensure that there is sufficient space to work around the machine.
- Keep sufficient distance from moving workpieces.
- Keep enough distance to adjacent machines or other static objects.

Insufficient lighting of the installation site

Tripping and falling due to inadequate lighting can lead to serious injuries.

- Illuminate installation site sufficiently.

Disorder at the workplace

Loose objects or objects that are lying around can cause severe injuries.

- Ensure that there is sufficient space to work around the machine.
- Remove loose objects and tools from the work area.
- Keep the work area orderly and clean.

Indirect touch with residual currents

If the power supply of the machine is not equipped with a residual current circuit breaker, this can lead to serious injury from electric shocks, particularly in the event of insulation faults or short circuits.

- Equip the machine's power supply with a fault-current circuit breaker.

Electrostatic charging of the extraction hoses

Burns or electric shock caused by unearthed, or low quality extraction hose.

- Always ensure continuous electrostatic earthing when connecting machines.
- Only use dust extraction hose approved by the manufacturer. ➔ Further information on page 105

Using unsuitable equipment

Equipment that does not meet the manufacturer's specifications may compromise the operational safety. People could be seriously injured or killed.

- Only use authorised, approved equipment approved by the manufacturer.
- Do not use any modified equipment.

Handling of equipment and auxiliary materials

Improper handling of equipment and auxiliary materials can cause serious injury or death.

- Observe the manufacturer's safety data sheets.
- Store equipment and auxiliary materials in a secure, locked area.
- Store equipment and auxiliary materials in their original containers.
- Wear personal protective equipment.
- Do not breathe in fumes.
- Avoid skin contact.
- Do not swallow equipment or auxiliary materials.
- Dispose of equipment and auxiliary materials in accordance with regulations.

2.6.2 Adjustments and tool changes, operation**Improper adjustment and setup**

The operational safety of the machine is only guaranteed if the settings and set-up work are carried out correctly. People could be seriously injured or killed.

- Adjustment and setup may only be carried out by authorised, trained personnel who are familiar with how to operate the machine and are in strict observance of all safety instructions.
- Before beginning any maintenance work on the machine, switch it off and secure it against accidentally being switched on again.
- Adjustments to or equipping of the machine may only be done once the machine is at a standstill.
- Before commencing any work with the machine, inspect it to ensure that it is complete and in technically good condition.
- Ensure that there is sufficient space to work around the machine.
- Mount safety equipment according to regulations and check proper functionality.

During operation

Serious injuries

- Offcuts or other parts of the workpiece must not be removed from the working area whilst the machine is still running.
- Injury from flying workpieces and parts of the workpieces (e.g. knots, offcuts).
- Do not lean over the working area.
- Only remove chips when the machine is at a standstill.

Residual risks applicable when working with the circular saw unit

- Injuries due to contact with the rotating circular saw blade and/or scoring blade.
 - The danger zone is the area 120 mm to the left, right, in front of and behind the saw blade.
 - Do not reach into the danger zone with your hand.
- Injuries caused by ejected tool bits (e.g. cutting edges).
 - Never stand directly in the cutting line of the machine whilst it is operating (in machining or idle mode).

Foreign objects in the workpiece

Serious injuries

- Carefully inspect workpieces for foreign matter (nails, screws) which might impair processing.

Processing unsuitable materials

Operational safety is only guaranteed when the machine is used for the intended purposes. People can be seriously injured or killed when working with unsuitable materials.

- Only process authorised, approved materials approved by the manufacturer.
- Comply with the intended use. ➔ Chapter 2.2 'Intended use' on page 9

Improper selection of saw blades and grooving tools

Permanent hearing impairment, serious injuries and property damage.

Sharp tools reduce the risk of kickback, especially when working with grooving tools.

Only use saw blades and grooving tools,

- which have an authorised speed higher than the speed of the saw arbour.
- that comply with EN 847-1 in the current version.
- which are marked with "MAN".
- that meet the requirements of these operating instructions.
- which are well sharpened and in good condition.

Only use grooving tools,

- which are suited to manual operation.
- that are suitable for woodworking.

Process large or small workpieces without assistance

Operational safety is only guaranteed when the machine is used for the intended purposes. People may suffer serious injury when working with unsuitable or unauthorised workpieces.

- Ensure that there is sufficient space to work around the machine.
Drive fed workpieces could be a hazard when processing. Keep sufficient distance from walls, machines and fixed objects.
- Support long workpieces with additional supports (e.g. table extensions, roller supports).
- Use auxiliary equipment for machining short and narrow workpieces (e.g. push grip, pushing stick, workpiece holder).
- Only process workpieces that can be safely placed on the machine and guided.

Process workpieces in the same direction as the rotation of the tool

When processing the workpieces in the same direction, the feed direction corresponds to the movement direction of the cutters in the area of contact. Serious injury caused through kickback of the workpiece could be the consequence.

- Always process workpieces in the direction opposite to the cutting direction.
- Pay attention to ensure the correct rotation direction of the tool.

Operate machine without saw blade guard or grooving tool cover and "saw boy" auxiliary stop

Operational safety is only guaranteed if a safety device is used above the circular saw blade or grooving tools. People could be seriously injured.

- Use a circular saw guard, circular saw top guard or grooving tool cover and "saw boy" auxiliary fence.

2.6.3 Maintenance and troubleshooting**Incorrect maintenance on the machine**

Maintenance work may only be carried out by qualified and trained personnel. Failure to follow the instructions may result in serious personal injury and material damage.

- Work on the machine may only be carried out by authorised, trained personnel who are familiar with how to operate the machine and are in strict observance of all safety instructions.
- If possible, only perform work when the machine is disconnected from all energy sources and an unintentional restart is prevented.
- The machine has to be switched off when carrying out any work on the machine.
- Disconnect machine from power supply before carrying out work on electrical devices.
- Disconnect the machine from the compressed air supply before working on pneumatic equipment.
- Do not deactivate or bypass protective devices.
- Maintenance personnel need to be fully aware of how the machine operates and moves, and they must be familiar with the exact operating sequence.
- Whilst maintenance work is being carried out, secure the area around the machine.
- Whilst maintenance work is being carried out, put up a sign that states "Machine under maintenance".
- To ensure quick and unmistakable communication, visual contact with the operators must be kept at all times.
- Operators should repeat and confirm instructions before they are carried out.
- Only start the machine when there is no one within the safety zone.
- Properly reinstall all components after the maintenance work and check functionality.
- As part of the machine maintenance, the whole machine, including the safety devices, must be checked regularly for damage.
- Keep a record of all maintenance work.

Exceeding the lifespan of protective devices that carry out a safety function

The safety devices have a lifespan of 20 years. If safety devices are used exceeding their lifespan, the proper function of the safety devices can not be guaranteed. Poorly maintained protective devices can cause serious injuries.

- Safety devices have to be replaced by expert personnel from Felder Group before the end of the lifespan.

Improper replacement or reparation of safety devices with safety function

Improper exchange or repair of safety devices can lead to malfunctions. People could be seriously injured or killed.

- Only let safety devices be replaced or repaired by expert personnel of the Felder Group.

Incorrect rectification of malfunctions

Incorrect rectification of malfunctions will impair operational safety. People could be seriously injured or killed.

- Wait for all moving parts to come to a standstill.
- Disconnect machine from all power sources and secure against restarting.

The use of incorrect or faulty spare parts

Spare parts that do not meet the manufacturer's requirements may impair safety-relevant functions and jeopardise the operational safety of the machine. People could be seriously injured or killed.

- Only use authorised, approved spare parts approved by the manufacturer.
- If in doubt, obtain authorisation from the dealer or manufacturer.
- Only use technically perfect spare parts.

- Safety-related spare parts may only be installed, exchanged and tested by authorised qualified personnel in accordance with the manufacturer's instructions.
- See spare parts list.

3 Declaration of Conformity

EU-Declaration of Conformity

	EU-Declaration of Conformity according to Machine Guidelines 2006/42/EC Note on the serial number: The serial number is printed on the cover sheet of the operating manual.
---	--

We hereby declare that the machine indicated below, which corresponds to the design and construction of the model we placed on the market, conforms with the health and safety requirements as stated by the EU guidelines (see table).

Manufacturer	FELDER KG KR-Felder-Straße 1 6060 Hall in Tirol, AUSTRIA
Product designation	Sliding Table Panel Saw
Brand	Hammer
Model type	K 430
The following EU guidelines were applied	2006/42/EC 2014/30/EC
The following harmonised norms were applied:	EN ISO 19085-1:2021 EN ISO 19085-5:2024

This EU-Declaration of Conformity is valid only if the CE label has been affixed to the machine. Modifying or altering the machine without the express written agreement of the manufacturer shall render the warranty null and void. The signatory of this statement is the appointed agent for the compilation of the technical information.

	Prof. h. c. Ing. Johann Georg Felder CEO FELDER KG KR-Felder-Straße 1, 6060 Hall in Tirol, AUSTRIA Date: 30.6.2026
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	Declaration of Conformity according to UK Directive S.I. 2008/1597 Note on the serial number: The serial number is printed on the cover sheet of the operating manual.
---	---

We hereby declare that the machine indicated below, which corresponds to the design and construction of the model we placed on the market, conforms with the health and safety requirements as required by the following UK guidelines (see table).

Manufacturer	FELDER KG KR-Felder-Straße 1 6060 Hall in Tirol, AUSTRIA
Product designation	Sliding Table Panel Saw
Brand	Hammer
Model type	K 430
The following UK guidelines were applied	S.I. 2008/1597 - Supply of Machinery (Safety) Regulations 2008 S.I. 2016/1091 - Electromagnetic Compatibility Regulations 2016
The following harmonised norms were applied:	EN ISO 19085-1:2021 EN ISO 19085-5:2024

This Declaration of Conformity is only valid if the UKCA label is affixed to the machine. Modifying or altering the machine without the express written agreement of the manufacturer shall render the warranty null and void. The signatory of this statement is the appointed agent for the compilation of the technical information.

	Prof. h. c. Ing. Johann Georg Felder CEO FELDER KG KR-Felder-Straße 1, 6060 Hall in Tirol, AUSTRIA Date: 30.6.2026
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4 Technical information

4.1 Dimensions and weight K 430

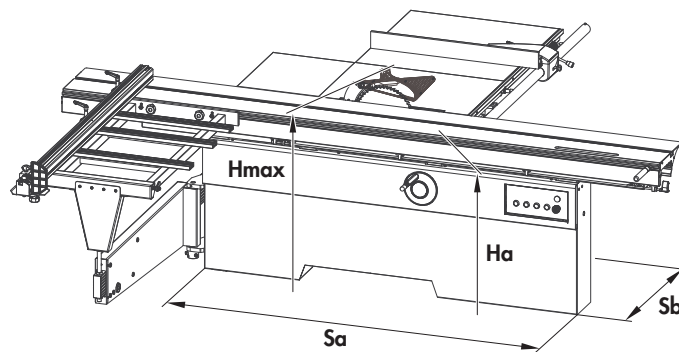


Fig. 1: Dimensions K430 - Basic machine

Basic machine

Data	Value	Unit
Space requirement Sa x Sb	2000 x 844	mm
Max. total height H	1332	mm
Working height Ha	874	mm
Net weight	490 *)	kg

*) with standard equipment

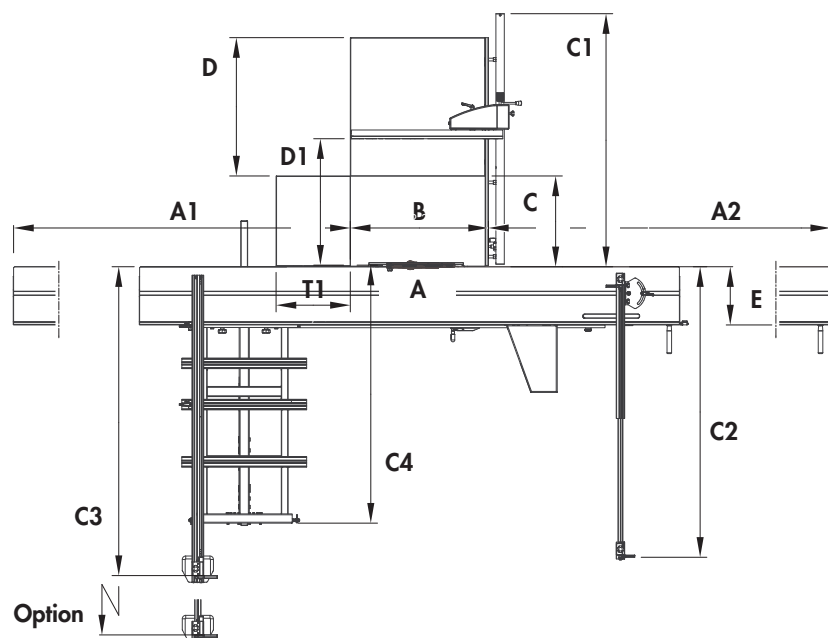


Fig. 2: Dimensions K430 - Cutting widths

Sliding table 3200

Data	Value	Unit
Sliding table length A	3200	mm
Sliding table travel distance A1	2855	mm
Sliding table travel distance A2	3016	mm
Total length A1 + B + A2	6690	mm
Sliding table width E	327	mm
Machine table length B	819	mm
Net weight *)	365	kg

*) only if the sliding table is packed separately

Machine table and cutting width

Data	Value	Unit
Machine table width C	534	mm
Table extension length T1	440	mm
Overall width C1	1500	mm
Cutting width max. D	820	mm
Average cutting width max. D1	1250	mm

Crosscut fence and outrigger table 1500

Data	Value	Unit
Cutting width max. C2	925 / 1716 *)	mm
Cutting width max. C3	1835 / 2600 *)	mm
Outrigger table width C4	1525	mm

*) with the telescopic extension option

Packaging dimensions (incl. pallet)

Width B = Open side of the pallet for the forklift

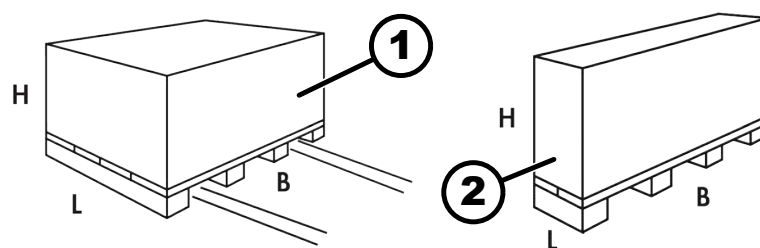


Fig. 3: Pallet info

- 1 Machine packaging
- 2 Sliding table packaging

Data	Value	Unit
Length x Width (machine)	1132 x 2247	mm
Length x Width (sliding table)	230 x 3390	mm
Overall height H (machine)	1090	mm
Overall height H (sliding table)	470	mm
Net weight (machine)	540	kg
Gross weight (sliding table)	125	kg

*) with standard equipment

4.2 Operation and storage conditions

Data	Value	Unit
Operating/room temperature	+10 - +40	°C
Storage temperature	-10 - +50	°C
Humidity (non-wetting)	90	%

4.3 Drive motor



See wiring diagram for electrical details.

The actual values of the components can be found on the data plate.

All data in the S6 operating mode = Load and intermittent operation.

Relative operating duration = 40%.

4.4 Saw unit and tools

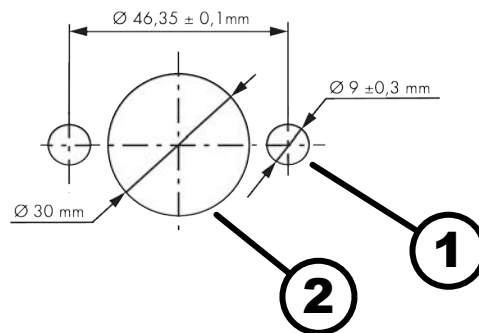


Fig. 4: Saw blade pin

- 1 Pin hole
- 2 Saw arbour hole

Only use saw blades and grooving tools,

- which have an authorised speed higher than the speed of the saw arbour.
- that comply with EN 847-1 in the current version.
- which are marked with "MAN".
- that meet the requirements of these operating instructions.
- which are well sharpened and in good condition.

Only use grooving tools,

- which are suited to manual operation.
- which are suitable to work with wood.



Note

We recommend you use manufacturer original Felder Group tools exclusively.

The processing of workpieces at the maximum cutting height indicated is only possible under certain conditions. Whether it is possible is in direct relation to the following factors:

- Type of wood (hardwood or softwood)
- Wood dampness
- Feed rate
- saw blades
- The motor power of your machine

Saw unit

Data	Value	Unit
Saw arbour diameter	30	mm
Rotation speed	4500	min ⁻¹
Tilt range	0° - 45°	
Saw table (length x width)	819 x 534	mm
Fence plate (length x width)	900 x 90	mm
Max. cutting height 90° *)	95	mm
Max. cutting height 45° *)	67	mm

*) with a 315 mm saw blade diameter

saw blades

Data	Value	Unit
Max. diameter	250 - 315	mm
Hole, with pin *)	30	mm

*) The circular saw flange is secured against rotation by the pin.

Scoring saw blade

Data	Value	Unit
Max. diameter *)	120	mm
Bore	20	mm
Rotation speed	8000	min ⁻¹
Max. cutting height	5	mm

*) in combination with a 315mm main saw blade

Groove cutters and slotting saws for use with circular saws

Data	Value	Unit
Max. diameter	315	mm
Max. width	6	mm

Data	Value	Unit
Felder Group	Art.-No. 03.0.030	
Diameter	300	mm
Cutting width	5	mm

Data	Value	Unit
Felder Group	Art.-No. 03.0.031	
Diameter	230	mm
Cutting width	4	mm

4.5 Dust extraction

- The machine has 2 separate extraction connections.
- Extract from both of the extraction connections (aggregate and saw guard) with a single extraction hose (ø 140 mm). ➔ Chapter 7.4 'Dust extraction' on page 43

Saw aggregate extraction

Data	Value	Unit
Connection diameter	120	mm

Data	Value	Unit
Min. air speed	20	m/s
Min. vacuum	1450	Pa
Min. volume flow (at 20 m/s)	814	m ³ /h

Saw guard extraction

Data	Value	Unit
Extraction connection diameter	50	mm
Min. air speed	20	m/s
Min. vacuum	953	Pa
Min. volume flow (at 20 m/s)	141	m ³ /h

4.6 Dust emission

The working areas of this machine are considered dust-minimised according to DGUV Information 209-044. The maximum concentration level of 2 mg/m³ of inhalable dust in the air will not be exceeded. This only applies if the conditions that are specified in the section "Extraction" are adhered to.

4.7 Noise emissions

Basic standards and measurement methods

If the stated noise emission values are to be checked, then the measurements must be taken following the same procedure and in the same operating and installation conditions as described.

The measurements are carried out in accordance with the following standards:

Measurement conditions / additional information EN ISO 19085-5:2017, Annex E

ISO 7960:1995, Annex A

with ISO 11202:2010 for the emission sound pressure at accuracy class 3

Note: It was not possible to measure the sound level L_p(A) with accuracy class 2 because background noise could not be reduced.

and ISO 3746:2010 for the sound power at accuracy class 3

Note: It was not possible to measure the sound level L_w(A) with accuracy class 2 because background noise could not be reduced.

WARNING: The noise emission values stated are only valid, when the same operating and installation conditions apply.

Other operation and installation conditions, e.g. a different work process, can lead to higher noise emission values with the danger of underestimation.

WARNING: The noise emission values stated are not exposure level values.

Although there is a correlation between emission and exposure levels, the emission values can not be used to reliably determine whether increased safety measures are required.

Factors that influence the actual degree of exposure are the actual work process, the exposure time, the characteristics of the workplace and other neighbouring noise sources in the workshop.

Noise emission values

Specification of noise emission values in two-number form according to ISO 4871:1996

Tab. 1: *Saw blade guard riving knife*

	Idle	Operation
A-weighted sound power level L _{WA} in dB	98	101
A-weighted emission sound pressure level L _{pA} in dB at workplace A	80	86
Uncertainty K _{WA} / K _{pA} in dB	4 / 4	

5 Machine overview

5.1 Overview

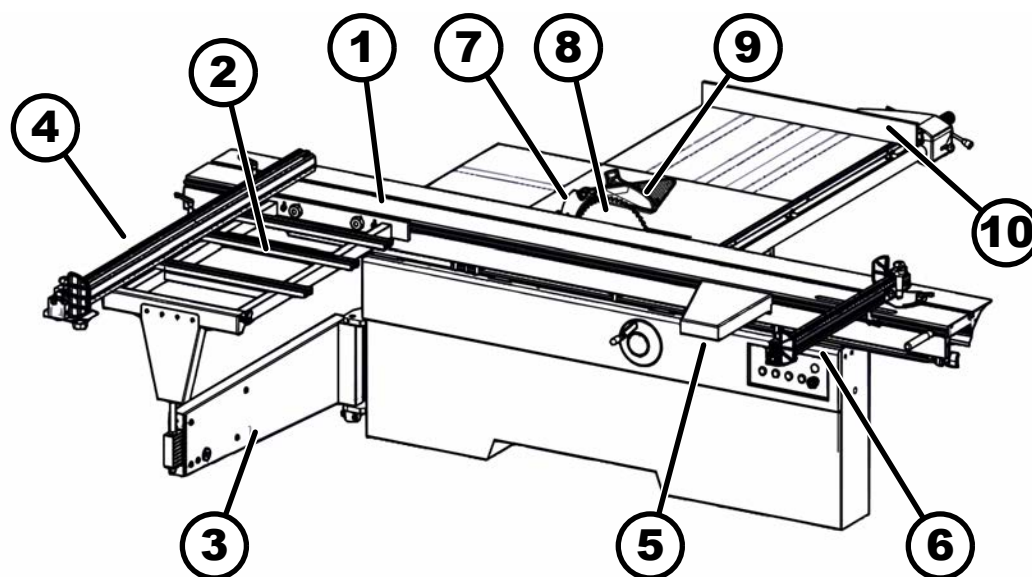


Fig. 5: Machine overview – front view

- | | |
|---|--|
| 1 Sliding table | 6 Crosscut fence on the sliding table (option) |
| 2 Outrigger table | 7 Riving knife |
| 3 Outrigger arm | 8 Saw blade |
| 4 Crosscut fence on the outrigger table | 9 Saw guard |
| 5 Table extension on the sliding table (option) | 10 Rip fence |

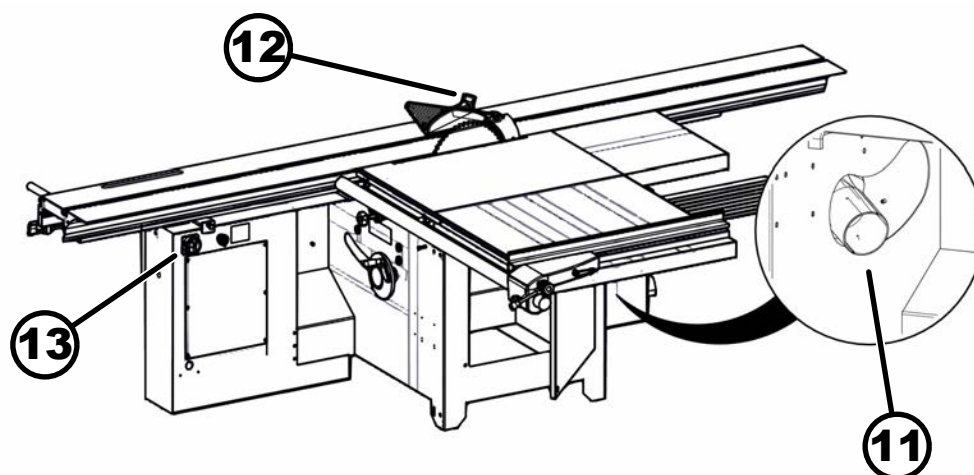


Fig. 6: Machine overview – rear side

- | |
|--|
| 11 Extraction connection diameter 120 mm |
| 12 Extraction connection diameter 50 mm |
| 13 Main switch |

5.2 Pictograms, signs and labels

All the pictograms, signs and labels affixed to the machine must be kept visible, readable and must not be removed.

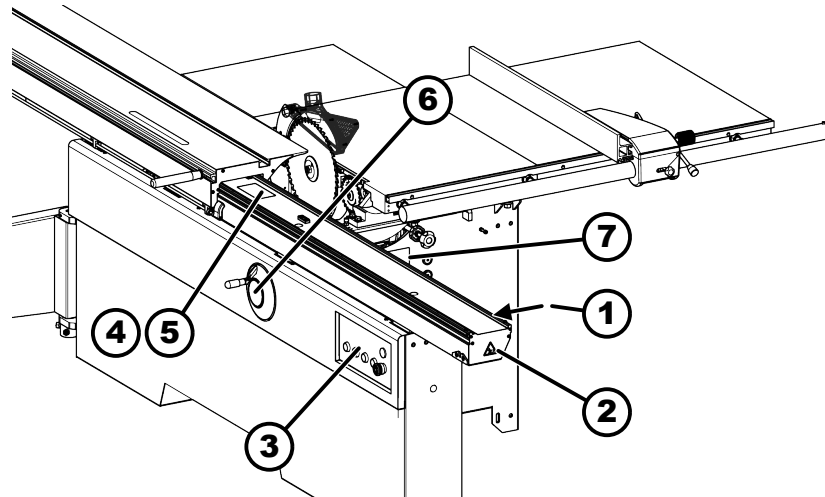


Fig. 7: Pictograms overview

- 1 Danger, electric current
- 2 Warning sticker - Hand injury
- 3 Control panel cover
- 4 Warning sticker - Cleaning without compressed air
- 5 Tool change - saw blade diameter
- 6 Scale - Circular saw angle information
- 7 Pictogram - Operating elements

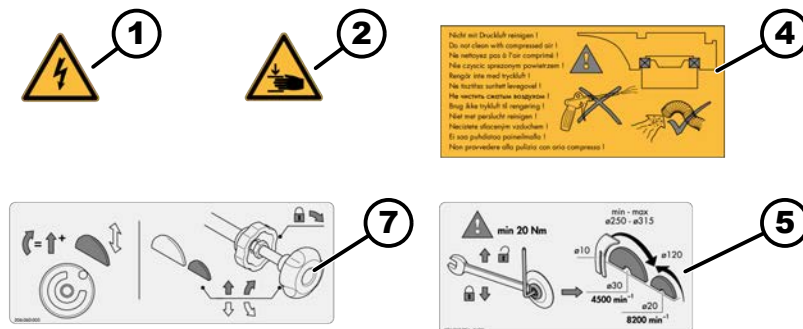


Fig. 8: Overview individual pictograms

5.3 Data plate

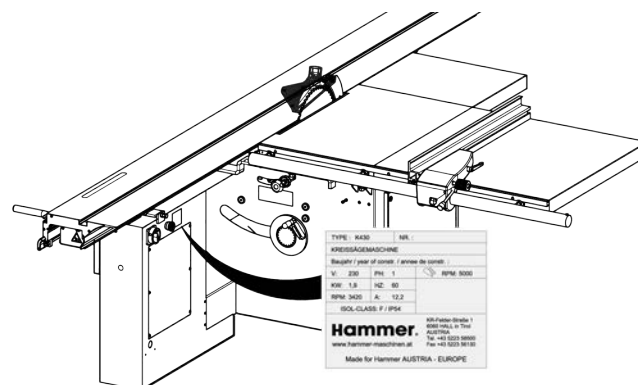


Fig. 9: Layout of the data plate

The data plate is mounted to the back of the machine.

Information on the machine data plate

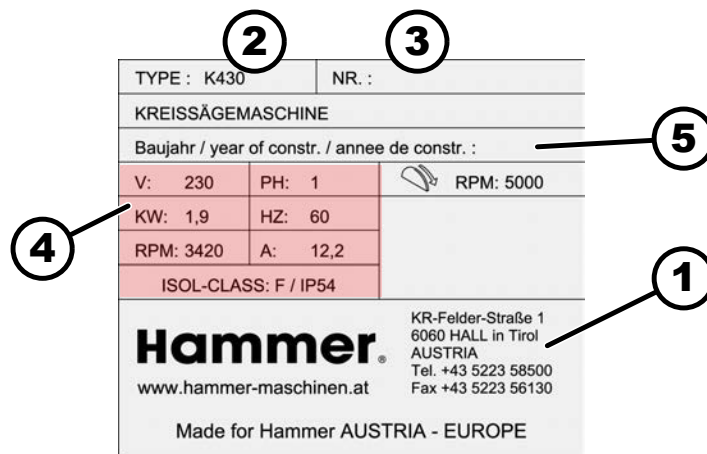


Fig. 10: Data plate

- 1 Manufacturer information
- 2 Model type
- 3 Serial number
- 4 Electrical connection
- 5 Year of construction

5.4 Accessories

**Note**

For further accessories and dust extraction equipment see the tools and accessories catalogue / Online-shop: www.felder-group.com.

Table extension and mitre guide

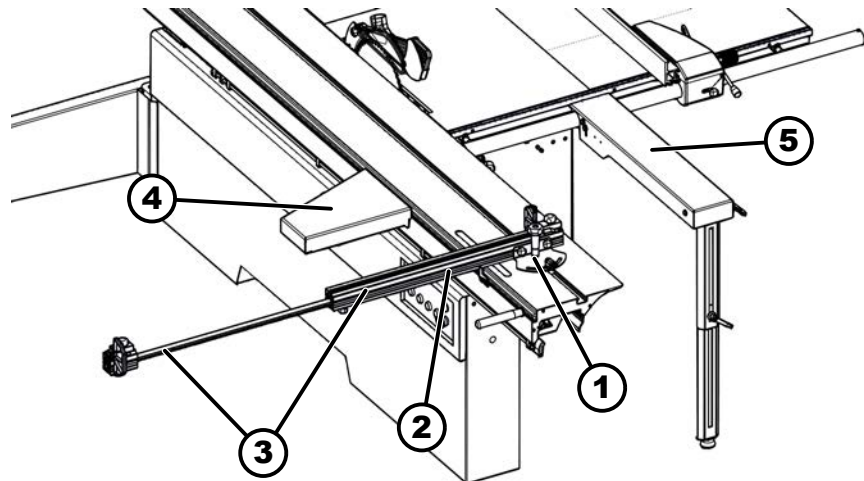


Fig. 11: Accessories overview

- 1 Coupling set for crosscut fence (Art. No. 503-136)
- 2 Crosscut stop, 900 mm (Art. No. 503-169)
- 3 Crosscut stop, 1300 mm (Art. No. 503-170)
- 4 Table extension for sliding table (Art. No. 503-137)
- 5 Table extension with support leg (Art. No. 503-156)

Table extension / Table extension

- Table extension with support leg that can be mounted on all machines with a round guiding bar.
- Table extension for format sliding table with ball-bearing guiding system.

Crosscut fence on the sliding table

- Coupling set for crosscut fence.
- Crosscut fence 900 mm / 1300 mm with 1 crosscut stop.

Trimming equipment and trimming shoe

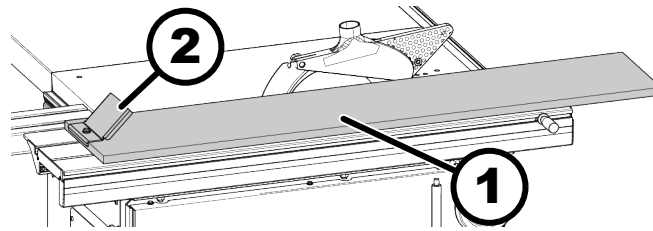


Fig. 12: Trimming equipment

1 Trimming equipment (Art. No. 500-110)

2 Trimming shoe (Art. No. 500-109)

- To correctly place the piece to be cut for long cuts.
- Table insert to be mounted on a panel for trimming wood on Hammer sliding tables.

Eccentric clamp and clamping set for sliding table

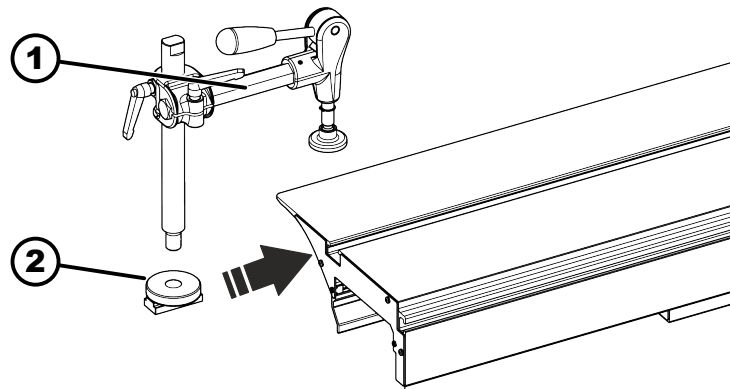


Fig. 13: Eccentric clamp

1 Eccentric clamp (Art.-no. 400-108)

2 Clamp set (Art. No. 01.0.036)

- Eccentric clamp to clamp workpieces securely to the sliding table.
- Clamping set for the mounting of the eccentric clamp on the sliding table.

5.5 Operation and display elements

5.5.1 Main switch

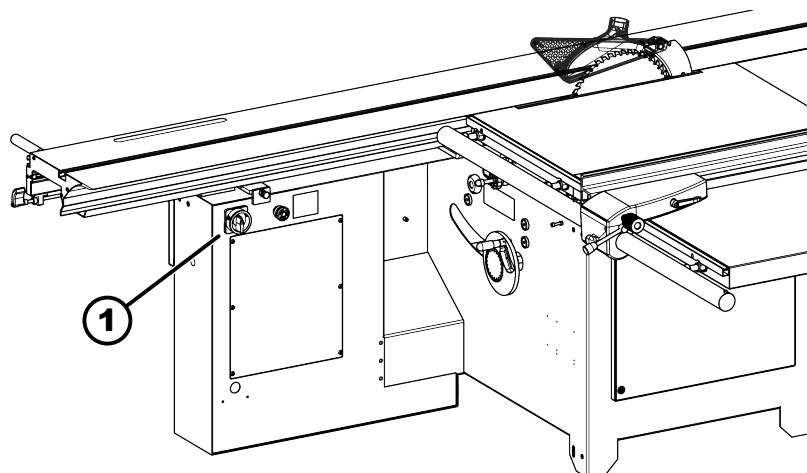


Fig. 14: Main switch

1 Main switch

The [main switch] is located on the rear or on the right-hand side of the machine.

- "O" / "OFF" position: Electrical supply OFF
- "I" / "ON" position: Electrical supply ON

If required, the main switch can be secured with padlocks in three different positions.

5.5.2 Emergency stop actuator

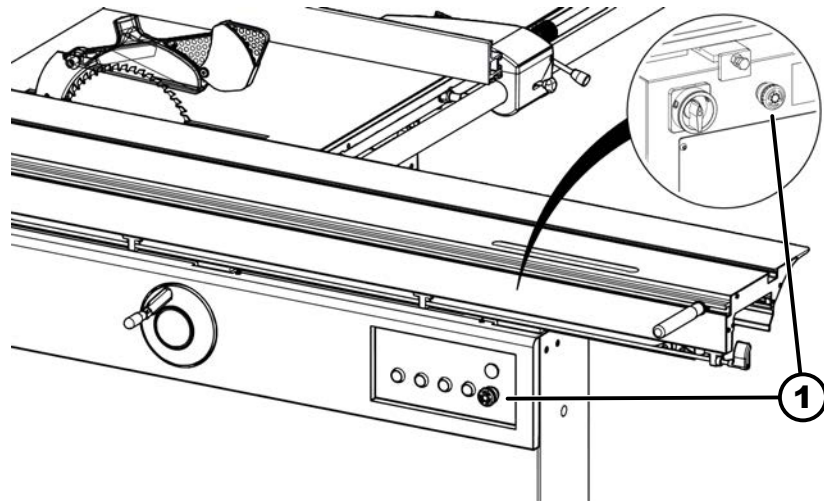


Fig. 15: Design - Emergency stop

1 Emergency stop actuator

The machine is equipped with [emergency stop] buttons which must be unlocked before the machine can be started.

- An [emergency stop] button is located on the right-hand side of the machine.
- A second [emergency stop] button is fitted next to the main switch.

The [emergency stop] button can be used to stop the machine in case of an emergency.

Unlock the [emergency stop] actuator by turning it.

5.5.3 Operation and display elements

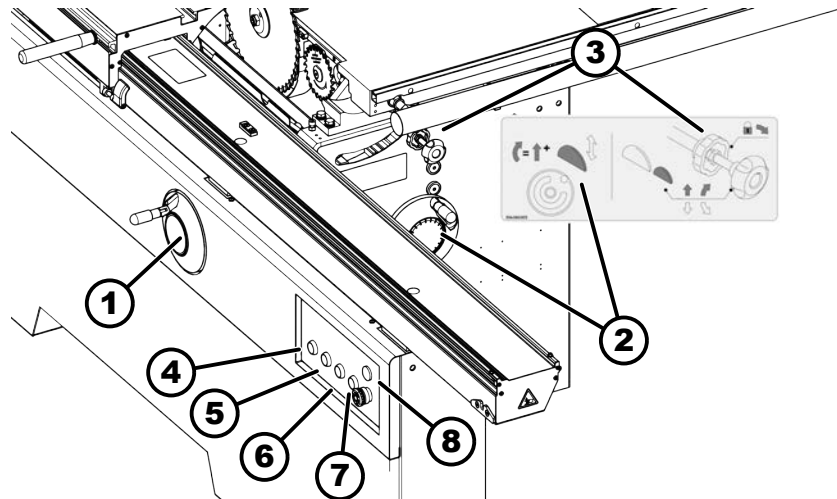


Fig. 16: Operation and display elements

- 1 Hand wheel - Saw blade angle adjustment
- 2 Hand wheel - circular saw height adjustment
- 3 Adjustment screw and clamp – height adjustment for the scoring unit
- 4 Green start button - Saw blade ON
- 5 Red stop button - Saw blade OFF
- 6 Green start button - Scoring blade ON
- 7 Red stop button - Scoring blade OFF
- 8 Indicator light – Mains power ON

5.6 Safety devices

5.6.1 Interlock switches and motor safety switches

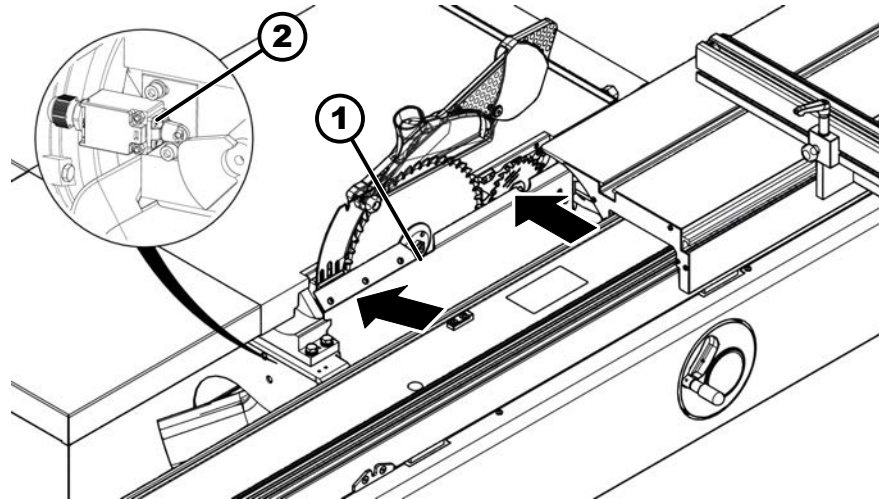


Fig. 17: Hinged cover is closed

- 1 Saw aggregate hinged cover
- 2 Safety switch

The machine is equipped with an interlock switch. The saw blade only runs when the safety switch in the inside of the machine body is actuated by the locking device (hinged cover closed).

- Ensure that the hinged cover locks in place correctly on the right and the left.

The machine is equipped with a motor protection device that switches the machine off in the event of an overload.

5.6.2 Saw guard

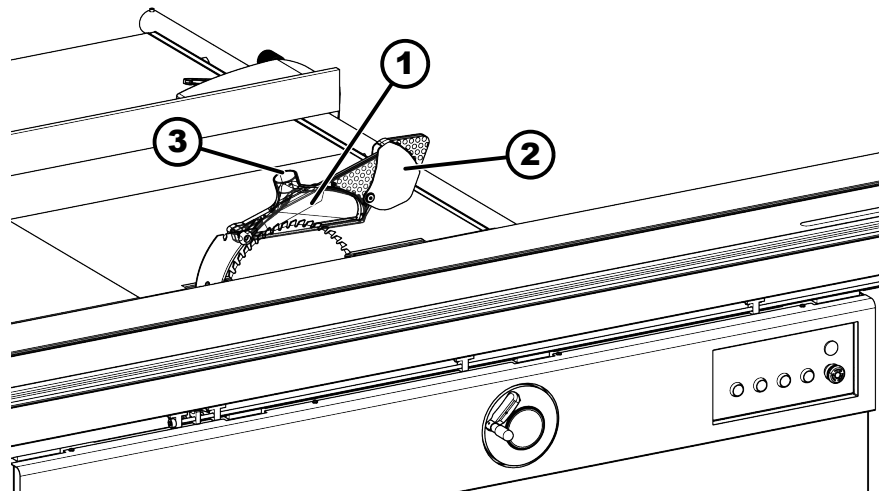


Fig. 18: Saw guard

- 1 Saw guard
- 2 Scoring unit cover hood (option)
- 3 Dust extraction connection (Ø 50 mm)

To prevent injuries when using the saw, the machine must be equipped with a protective hood which is positioned over the saw blade.

When using scoring saw blades, the additional scoring guard must be used (Art. No. 420-709).

- The saw guard has to be installed and adjusted correctly.
- Extraction must be connected to the saw guard.
- Extraction connection diameter = 50 mm.

6 Transporting, packing, storing

6.1 Transport inspection

1. → Upon arrival, inspect the shipment to ensure that it is complete and has not suffered any damage.
2. → If any transport damage is visible from the outside, do not accept the delivery or only accept it with reservation.
3. → Record the scope of the damage on the transport documents/hauliers delivery note.
4. → Initiate the complaint process.
5. → Any defects that are not discovered upon delivery, must be reported immediately once they have been identified as damage claims are only valid if claimed within the valid complaint period.

6.2 Packaging

If no agreement has been made with the supplier to take back the packaging materials, help to protect the environment by reusing the materials or separating them according to type and size for recycling.

When using overseas transport the machine must be tightly packed and protected from corrosion. Use desiccant.

Environmental protection

Packaging materials are valuable raw materials and in many cases they can be used again, reprocessed or recycled.



ENVIRONMENT

Dispose of the packaging in an environmentally friendly manner

- Dispose of packaging materials in an environmentally friendly manner and in accordance with the applicable local disposal regulations.
- Contract a recycling company.

6.3 Storage

Keep items sealed in their packaging until they are assembled/installed and be sure to observe the stacking and storage symbols on the outside of the packaging.

Storage conditions

- Do not store outdoors.
- Store in a dry and dust-free environment. Use desiccant if necessary.
- Pay attention to the storage conditions. ➔ Chapter 4.2 'Operation and storage conditions' on page 21
- Protect from direct sunlight.
- Avoid mechanical vibration.
- Avoid extreme temperature fluctuations (condensation build-up).
- Apply a coat of oil to all exposed machine parts (corrosion protection).
- Regularly check the general condition of all parts and the packaging during longer storage (> 3 months). If necessary, refresh or re-apply the coat of anti-corrosive agent.

6.4 Transport bracket

The machine is delivered partially assembled on a pallet.

The machine is attached to the pallet with several transport brackets. Only remove the transport bracket when the machine is to be lifted from the pallet.

Remove the saw aggregate transport bracket

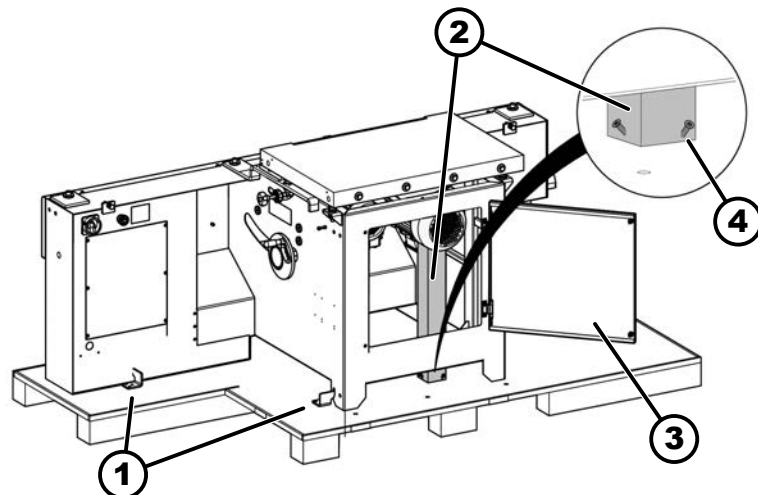


Fig. 19: Remove the transport bracket

- 1 Transport bracket
- 2 Saw aggregate transport bracket
- 3 Back cover
- 4 Lock screws

The saw aggregate is secured for transport to avoid misalignment.

Remove the transport bracket before adjusting the saw unit.

1. ➔ Open the cover at the rear of the machine.
 2. ➔ Remove the locking screws and the transport bracket.
- ➔ The saw unit can now be adjusted.

6.5 Information relating to transportation and unloading

**NOTICE****property damage**

Damage and possible complete write-off of the machine.

- Only lift the machine using the positions marked.
- Never lift the machine using the machine table or the additional support tables.
- Never lift the machine using the sliding table or the sliding table base.
- Only transport the machine using a forklift or a pallet truck.

6.6 Means of transportation

6.6.1 Unloading with a pallet truck

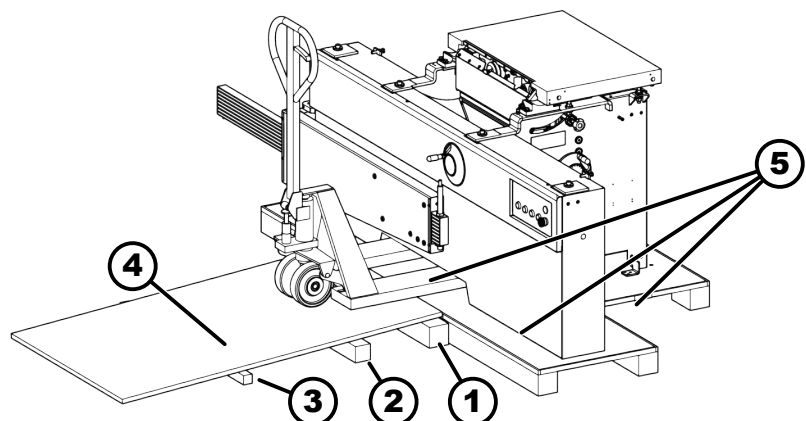


Fig. 20: Transport - Unloading with a pallet truck

- 1 Squared timber 90 x 90 mm
- 2 Squared timber 70 x 70 mm
- 3 Squared timber 40 x 40 mm
- 4 Panel 1500x1200x20 mm
- 5 Transport bracket

**WARNING****Tipping over of the machine**

Serious injury due to the high machine weight.

- Consider the machine weight and centre of gravity of the machine.
- Ensure that several additional assistants are on hand.

Personnel:

- Additional support assistants

Material:

- Solid construction timber (squared timber)
- Multi-layer glued wood panel (Multiplex)

Use a ramp as shown in the illustration for unloading from the pallet.

Use stable solid construction timber (squared timber) and a multi-layer glued laminated timber panel (multiplex panel) that is resistant to compression and bending.

1. ➔ Remove all transport brackets from the machine.
2. ➔ Screw the ramp panel on to the squared timber.
3. ➔ Attach the ramp to the machine pallet and ensure that it cannot slip.
4. ➔ Push the forks under the recess in the machine frame.
5. ➔ Unload the machine from the pallet with the pallet truck.

6.6.2 Transporting with a forklift

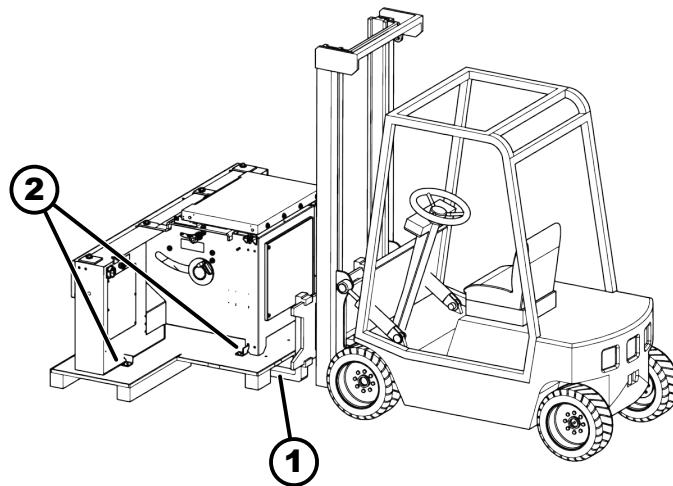


Fig. 21: Transport with a forklift truck

- 1 Recesses in the pallet
- 2 Do not remove the transport brackets

**WARNING****Tipping over of the machine**

Serious injury due to the high machine weight.

- Consider the centre of gravity of the machine.
- Depending on the equipment, two or three additional helpers are required when unloading.
- Lifting material (straps, chains and fork lifts) must be positioned as far apart away from the centre of gravity as possible.

Personnel:

- Forklift driver:in

1. ➔ Only remove the transport bracket when the machine is to be lifted from the pallet.
2. ➔ Move the forks of the forklift truck so they fit into the machine frame or pallet recesses.

7 Setup and installation

7.1 Floor space requirement

For operation and maintenance, setup the machine at least 500 mm away from a wall, parallel to the processing direction (dimension X).

Sufficient space must be available to be able to process workpieces and carry out maintenance and servicing of the sliding table unit (dimension Y).

Maintain a clearance of at least 2000 mm around the machine for operation and maintenance.

When installing the machine, ensure that there is sufficient space for the operators, also taking into account the necessary space for moving the workpieces (loading, processing, stacking).

The machine may only be used in dry rooms, free from frost and not outside in the open.

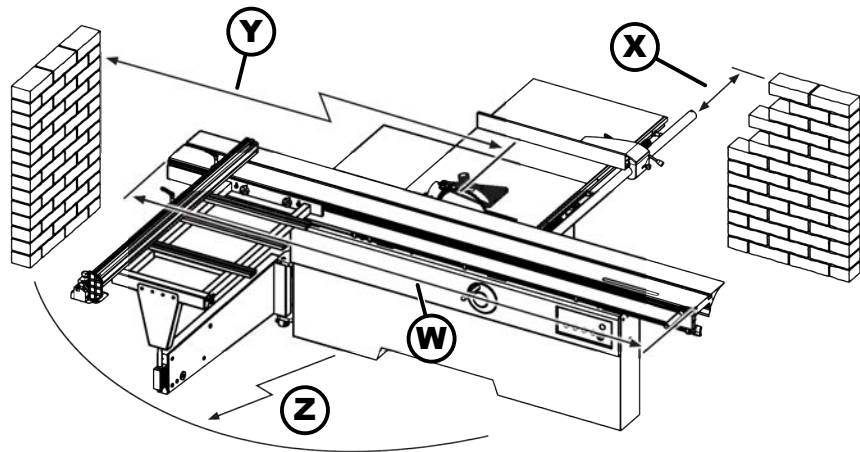


Fig. 22: Space requirement K430

- W Sliding table length
- X Distance from the wall
- Y Sliding table length + 500 mm
- Z Free space for operation

7.2 Setup and aligning the machine (levelling)

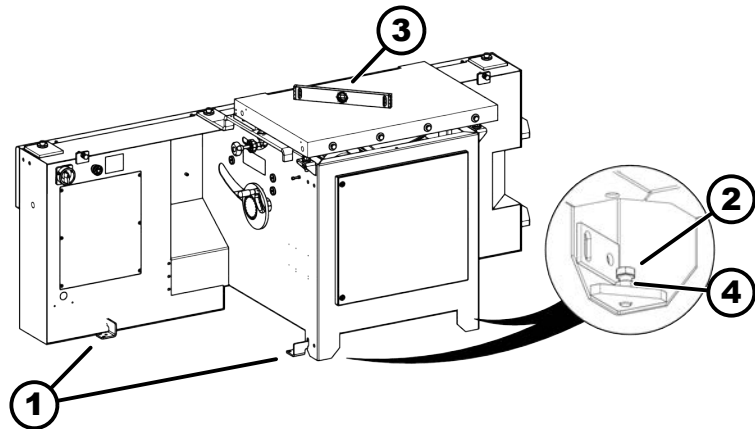


Fig. 23: Align the machine / Floor mounting

- 1 Transport bracket
- 2 Adjusting screws
- 3 Spirit level
- 4 Lock nut

Tool:

- Spirit level
- Ring spanner 17 mm

To ensure precise operation and smooth running of the machine, align it at the installation site using a spirit level.

1. → Compensate for uneven floors with the adjusting screws.
 1. → Loosen locking nut.
 2. → Turn the adjustment screw.
 3. → Tighten locking nut.
2. → If necessary, bolt the machine to the floor with transport brackets.
3. → Remove anti-corrosion agent from all exposed machine parts.

7.3 Install

7.3.1 Mounting the sliding table



WARNING

Sliding table with a high dead weight

Crushing due to falling load.

- Two to three additional helpers, depending on the cutting length, are required to mount the sliding table.

For logistical reasons, the sliding table is delivered in separate packaging.

Personnel:

- 3 additional assistants

Tool:

- Hex key 10 mm

1. → **Lift the sliding table onto the machine**
 1. → Slide the pre-assembled sliding table with the holes in the base onto the locking plates.
 2. → Move the sliding table forwards along the guide rail until the end position (fence screw) is reached.
 - ➔ The sliding table is automatically positioned correctly by the clamping plates.

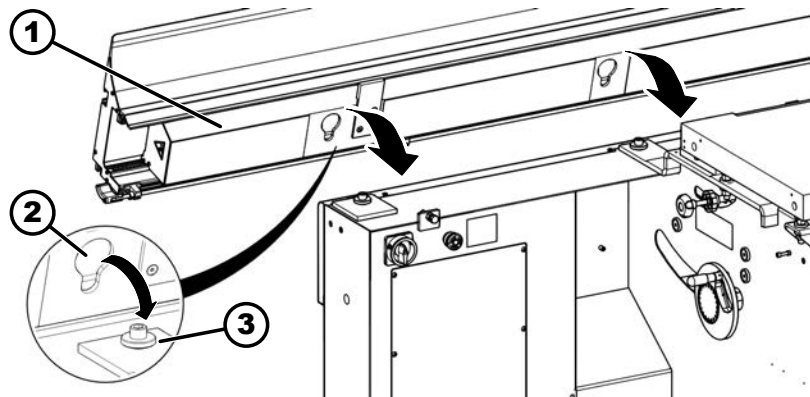


Fig. 24: Mounting the sliding table

- 1 Sliding table with base track
- 2 Holes in the base track
- 3 Locking plates

2. → **Screw the sliding table onto the right-hand side of the machine**
 1. → Remove sliding table transport bracket. ➔ Chapter 7.3.2 'Remove sliding table transport bracket' on page 37
 2. → Release the sliding table lock and slide the sliding table to the left. ➔ Chapter 8.1 'Lock the sliding table' on page 46
 3. → Remove the plugs from the base track.
 4. → Insert the Allen key through the base track into the clamping screw.
 5. → Press the base track against the fence screw.
 6. → Tighten both clamping screws slightly.

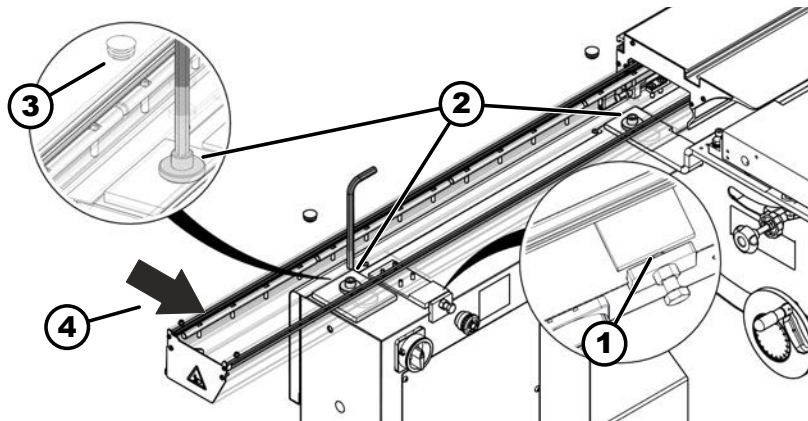


Fig. 25: Right-hand side of the machine

- 1 Fence screw
- 2 Clamping screws
- 3 Hole plug
- 4 Press the base track against the fence screw

3. → Screw the sliding table onto the left-hand side of the machine

- 1. → Move the sliding table to the right.
- 2. → Remove the plugs from the base track.
- 3. → Insert the Allen key through the base track into the clamping screw.
- 4. → Press the base track against the fence screw.
- 5. → Tighten both clamping screws slightly.

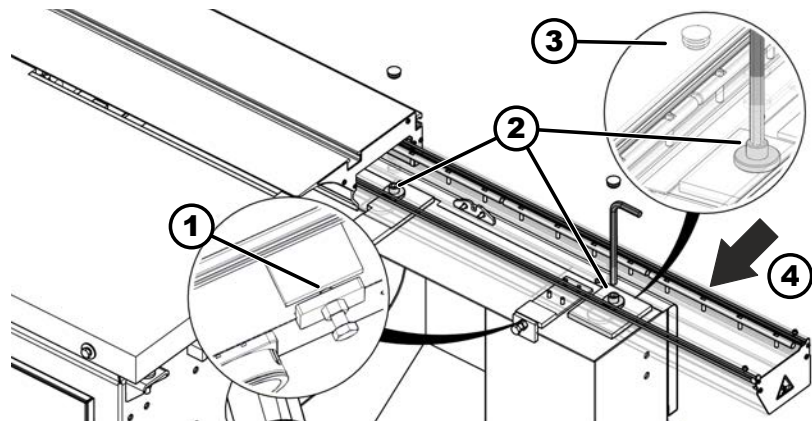


Fig. 26: Left-hand side of the machine

- 1 Fence screw
- 2 Clamping screws
- 3 Hole plug
- 4 Press the base track against the fence screw

4. → Check the distance to the machine table

- 1. → Measure the distance X between the edge of the sliding table and the machine table on the left and right-hand sides.
 - Distance from the machine table $X1 = X2 = \text{max. } 12 \text{ mm}$
- 2. → If necessary, adjust the distance using the left or right fence screw.
 - Loosen the lock nut – turn the fence screw – tighten the lock nut.
 - The sliding table moves parallel to the machine table.

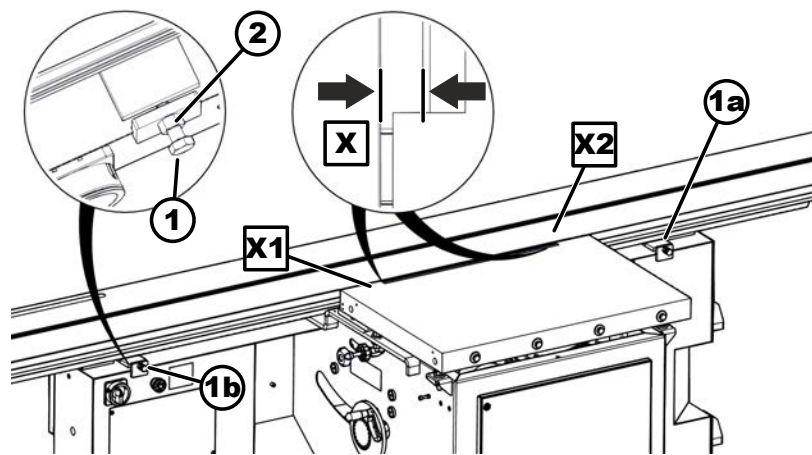


Fig. 27: Position the sliding table

- 1 Fence screw
- 1a Fence screw, left-hand side of the machine
- 1b Fence screw, right-hand side of the machine
- 2 Lock nut
- X Distance from the machine table
- X1 Distance from the right-hand side of the machine
- X2 Distance from the left-hand side of the machine

5. Tighten all four clamping screws securely.
6. Seal all four holes in the base track with plugs.

Fit the mounting kit for the crosscut stop on the sliding table (Option)

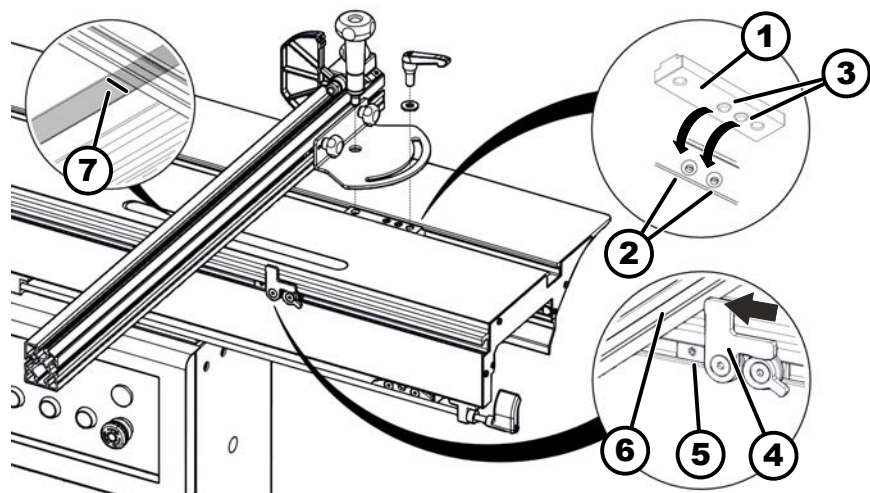


Fig. 28: Mount the crosscut stop to the sliding table

- 1 Clamping device
- 2 Positioning holes
- 3 Grub screws
- 4 0° stop plate
- 5 Clamping screws
- 6 Fence plate
- 7 Scale (0° position)



Set the 0° cutting angle (readjust)

Adjust the 0° position on the 0° stop plate. ➔ Chapter 11.7 'Adjusting the 0° angle of the crosscut stop on the sliding table' on page 100

Tool:

- Hex key 3 mm
- Hex key 5 mm

1. Position the clamping part of the crosscut stop in the groove of the sliding table.
 - ➔ Both threaded pins are positioned directly above the positioning holes.
2. Clamp the clamping piece in place using the threaded pins in the positioning hole.
3. Fit the crosscut stop, complete with fence support bar and clamping lever to the sliding table. ➔ Chapter 8.2 'Crosscut fence on the sliding table (Option)' on page 46
4. Set the crosscut fence to a cutting angle of 0°.

5. → Mark the 0° cutting angle in the recess in the sliding table with a pencil.
6. → Position the pre-assembled 0° stop plate in the front groove of the sliding table.
 ➡ The 0° stop plate is positioned against the fence plate.
7. → Tighten the clamping screw.
8. → Stick the scale into the recess in the sliding table.
 1. → Swivel the crosscut stop to the side.
 2. → Stick the scale, with the 0° mark, onto the mark in the recess.
 3. → Slide the crosscut fence back again, until it sits against the 0° stop plate.
 ➡ The fence edge is positioned exactly above the 0° mark on the scale.

7.3.2 Remove sliding table transport bracket

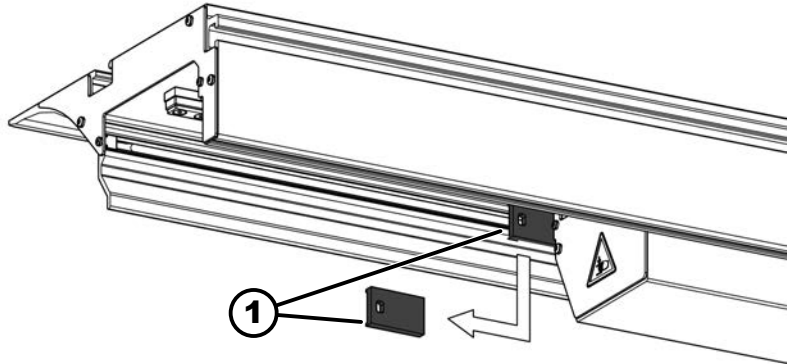


Fig. 29: Sliding table transport locking device

1 Transport bracket

- Remove the transport bracket between the base track and sliding table on both sides.

7.3.3 Sliding table handle

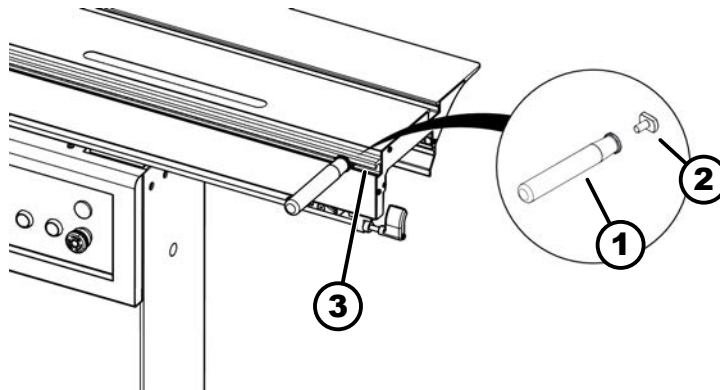


Fig. 30: Handle on the sliding table

1 Hand grip
 2 Clamping piece
 3 Sliding table groove

1. → Thread the handle with the clamping piece into the groove in the sliding table.
2. → Clamp it in the desired position.

7.3.4 Mounting the sliding tube in the outrigger arm

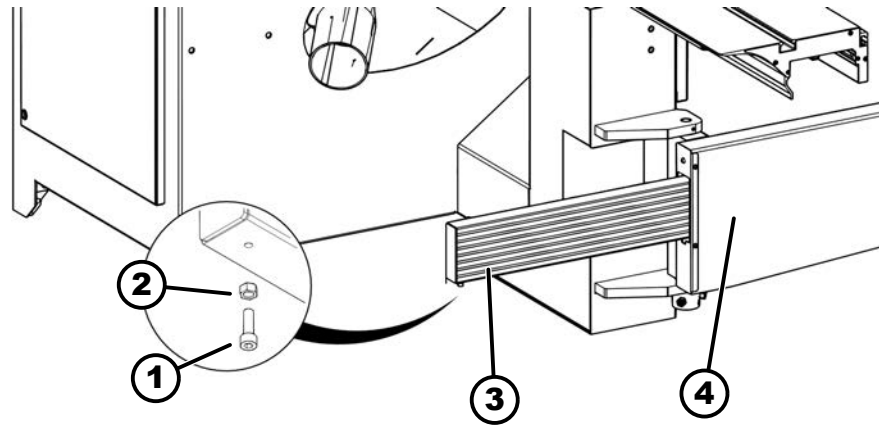


Fig. 31: Mounting the sliding tube in the outrigger arm

- 1 Screws
- 2 Lock nuts
- 3 Sliding tube
- 4 Outrigger arm

Tool:

- Ring spanner 10 mm

The screw serves as a stop.

The sliding tube cannot slip out of the outrigger arm when the screw is fitted.

1. ➔ Remove the bolt and lock nuts from the sliding tube.
 2. ➔ Push the assembled sliding tube into the outrigger arm until it comes out of the other side.
 3. ➔ Refit the bolt and lock nuts to the sliding tube.
 4. ➔ Hook the outrigger table onto the sliding table, place it on the support shaft and secure it with the knurled screws.
- See chapter "Making adjustments and preparations"

7.3.5 Mounting the fence support bar

Mount the fence support bar to the machine table

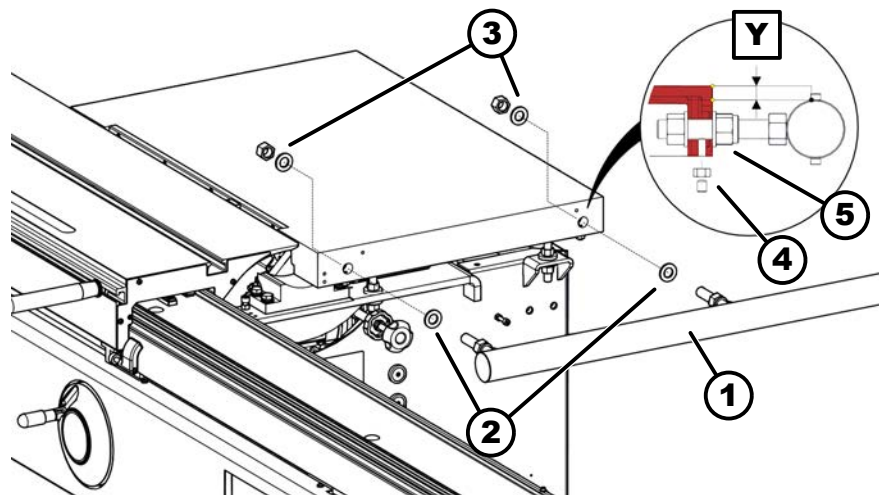


Fig. 32: Mounting the fence support bar

- 1 Fence support bar
- 2 Washers
- 3 Locking nuts and washers
- 4 Adjustment screw and locking nut
- 5 Safety hexagon nut
- Y Distance fence support bar to the table level

Tool:

- Callipers
- Bracket

The rear safety hexagon nuts are preset and must not be adjusted.

These nuts define the angle between the rip fence and the circular saw blade (free cut).

1. → Remove the lock nuts and serrated washers from the threaded pins.
2. → Position bar on machine table using the threaded screws.
3. → Loosely secure the bar with washers and locking nuts on the rear side of the machine.
4. → Adjust the distance to the table level exactly.
 - ➡ Check $Y1 = 12.0$ mm with calipers and stop angle.

Check distance from fence support bar to machine table

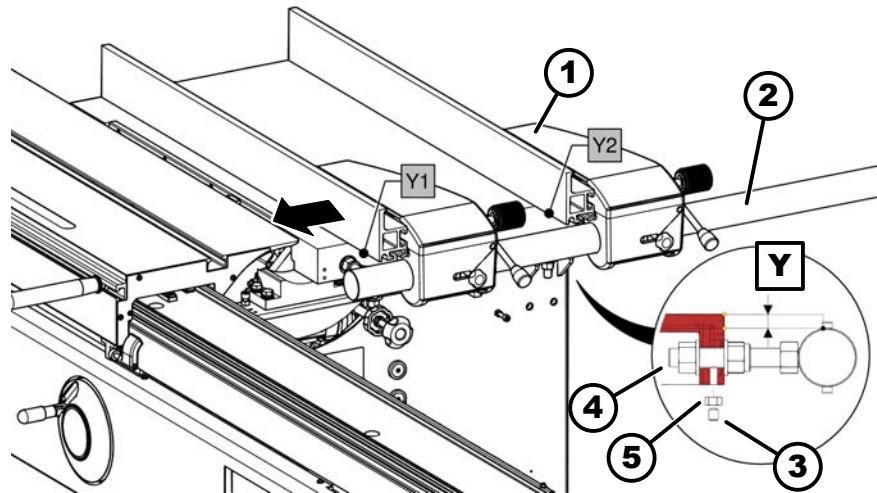


Fig. 33: Fence support bar - Check

- 1 Rip fence
- 2 Fence support bar
- 3 Adjusting screw
- 4 Locking nut (fence support bar)
- 5 Locking nut (adjustment screw)
- Y Distance fence support bar to the table level

Tool:

- Callipers
- Bracket
- Hex key 4 mm
- Ring spanner 13 mm
- Ring spanner 24 mm

1. → Push the rip fence onto the bar from behind.
2. → Adjusting the distance at the front of the bar to the table:
 1. → Move the rip fence to the front.
 2. → Adjust the distance to the table level exactly using the adjusting screw.
 - ➡ $Y1 = 12.0$ mm.
 3. → Lightly tighten the front locking nut.
3. → Adjusting the distance at the rear of the bar to the table:
 1. → Move the rip fence back.
 2. → Adjust the distance to the table level exactly using the adjusting screw.
 - ➡ $Y2 = 12.0$ mm.
 3. → Lightly tighten the rear locking nut.
4. → Check the setting in several positions and readjust if necessary.
 - ➡ Distance to the table level $Y1 = Y2 = 12.0$ mm.
5. → Tighten both of the locking nuts tightly.

7.3.6 Mount table extension

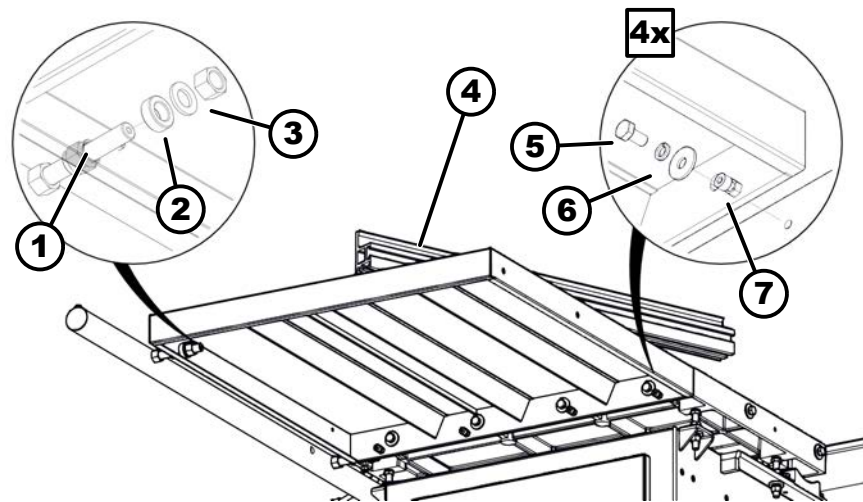


Fig. 34: Mount table extension

- 1 Grub screws fence support bar
- 2 Spacer washer
- 3 Serrated washers and lock nuts
- 4 Fence plate
- 5 Clamping screw M10x20
- 6 Spring washer and serrated washers
- 7 Adjustment screw / lock nut (tilt)

Tool:

- Hex key 6 mm
- Ring spanner 10 mm
- Ring spanner 17 mm
- Ring spanner 24 mm

The table extension is mounted to the rear side of the machine.

1. Remove the lock nuts and serrated washers from the grub screw of the fence support bar.
2. Position a washer on the grub screws (fence support bar).
3. Position the table extension on the grub screws (fence support bar) and on the machine table.
4. Loosely secure the table extension to the machine table using M10x20 clamping screws, spring washers and serrated washers (4x).
5. Loosely secure the spacer, serrated washers and lock nut to the threaded pin on the fence support bar to extend the cut.
6. Adjust the vertical position of the table extension:

Set the vertical position

1. Place the fence plate on the machine table.
2. Slide the table extension upwards to the fence plate.
 - ➡ The upper edge of the table extension is at the same level as the machine table.

Set the angle

1. Place the fence plate on the machine table.
2. Adjust the angle of the table extension precisely using the adjustment screws.
 - ➡ The surface of the table extension is on the same level as the machine table.

7. Tighten the clamping screws.
8. Tighten the lock nut firmly onto the threaded pin.
9. Check the vertical position and angle of the table extension using the fence plate and, if necessary, repeat the adjustment procedure.

7.3.6.1 Mounting the scale track

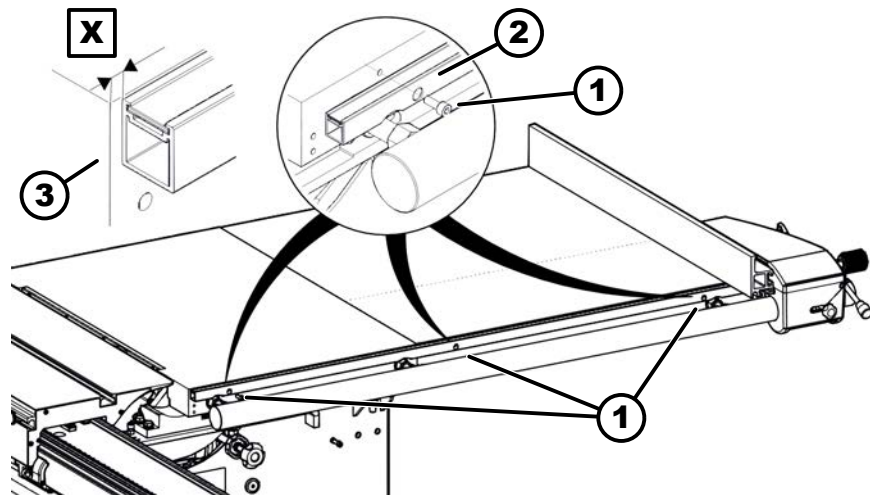


Fig. 35: Mounting the scale track

- 1 Hex screws M6 x 16 (3x)
- 2 scale track
- 3 Machine table
- X Distance between the scale track and the edge of the table

Tool:

- Hex key 5 mm
- Callipers

1. → Position the scale track on the machine table.
Note the installation position: The scale must be mounted rising from left to right.
2. → Screw the M6 x 14 socket head cap screws into the machine table slightly.
3. → Set the distance from the edge of the table precisely: X dimension = 4.0 mm.
4. → Tighten allen screws securely.

7.3.7 Fitting and adjusting the table extension to the machine table

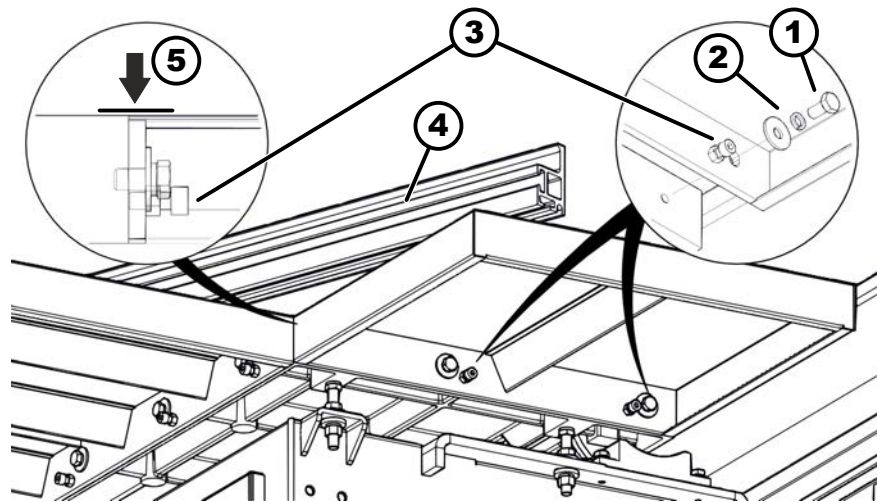


Fig. 36: Mount table extension

- 1 Clamping screw M10x20
- 2 Spring washer and serrated washers
- 3 Adjustment screw / lock nut (tilt)
- 4 Fence plate
- 5 Check height and evenness

Tool:

- Hex key 6 mm
- Ring spanner 10 mm
- Ring spanner 17 mm
- Ring spanner 24 mm

The table extension is attached to the narrow side of the machine table.

1. → If the table extension has been disassembled for transport reasons:
 1. → Position the table extension on the machine table as shown in the illustration.
 2. → Loosely secure the table extension to the machine table using M10x20 clamping screws, spring washers and serrated washers (2x).
2. → Setting the vertical position and angle of the table extension:

Set the vertical position

 1. → Loosen the clamping screws.
 2. → Place the fence plate on the machine table.
 3. → Push the table extension upwards until it reaches the fence plate.
 - ➡ The upper edge of the table extension must be at the same level as the machine table.
 4. → Tighten the clamping screws slightly.

Set the angle

 1. → Loosen the clamping screws.
 2. → Place the fence plate on the machine table.
 3. → Set the angle of the table extension precisely using the adjustment screws.
 - ➡ The surface of the table extension must be at the same level as the machine table.
 4. → Tighten the clamping screws slightly.
3. → Check the vertical position and angle of the table extension using the fence plate and, if necessary, repeat the adjustment procedure.
4. → Tighten the clamping screws.

7.3.8 Setting the hand wheel and display clock

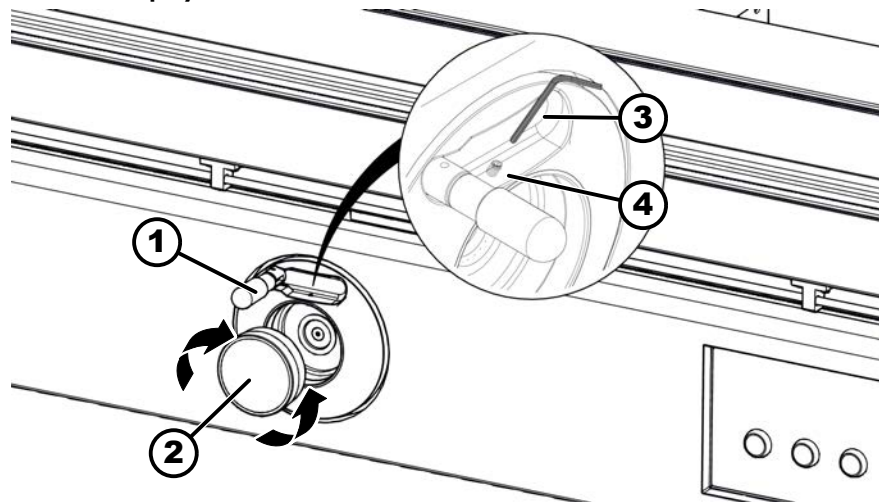


Fig. 37: Setting the display clock

- | | |
|---|-------------------------------|
| 1 | hand wheel |
| 2 | Display clock (cutting angle) |
| 3 | Hex key |
| 4 | Clamping screws |

Set the display clock accurately after transport

Tool:

- Allen key 2.5 mm
- Angle gauge

The display clocks may need readjusting after transportation.

For precise setting (calibration), the display clock in the handwheel must be turned.

1. → Preparing the machine for a tool change.
2. → Attach the circular saw blade.
3. → Prepare the machine for operation.
4. → Move the saw blade into the 90° position (cutting angle 0°).
 - ➡ Check with digital inclinometer or digital protractor.
5. → Loosen the clamping screw.
6. → Continue to rotate the handwheel until the cutting angle shows 0° cutting angle.
7. → Carefully tighten the clamping screw.

7.4 Dust extraction

Dust extraction system requirements

Every machine that uses an extraction system shall be extracted in accordance with EN 12779:2015 or EN 16770:2018.

- The extraction performance must be sufficient to achieve the negative pressure and air speed required at the connection point (see technical data or layout).
- Check extraction power before initial start-up and after significant changes (to the machine and / or extraction system).
- Before the machine is put into operation for the first time the dust extraction setup must be checked. Check for obvious defects on a daily basis and the efficiency on a monthly basis.
- Depending on the equipment, the dust extractor can be connected to the machine in such a way that it runs in unison with the machine (potential-free contact).
- On machines without extraction system control, switch on the extraction system before starting processing.
- The dust extraction hose must be electroconductive and grounded to prevent electrostatic build up.
- Only use flame-retardant extraction hoses.
- Use extraction with reduced dust emission to clean dust from the machine.

Connection to the extractor

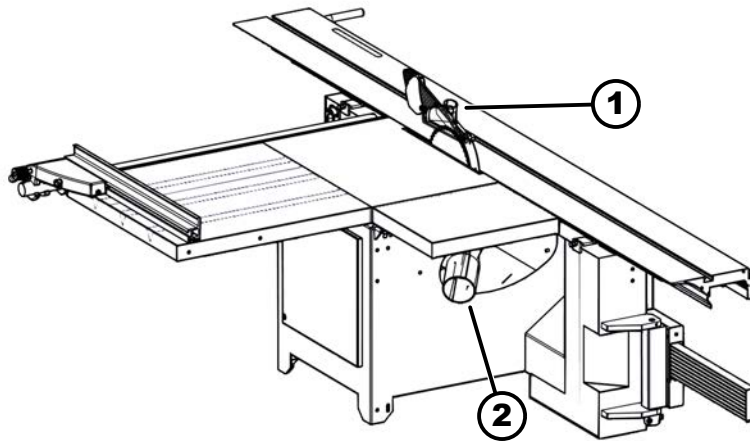


Fig. 38: Extraction connection

- 1 Circular saw guard Ø 50 mm
- 2 Saw aggregate Ø 120 mm



CAUTION

Electrostatic charging

Burns or electric shock caused by unearthed, or poor quality extraction hose.

- Only use dust extraction hose approved by the manufacturer.
- Always ensure continuous electrostatic earthing when connecting machines.
- The dust extraction hose must be flame resistant and electroconductive. For this reason we recommend that you only use Felder Group dust extraction hose!

1. → Attach the extraction hose to the extraction connection on the overhead saw guard or saw guard with a hose clamp.
2. → Fasten the extraction hose to the saw aggregate extraction port using a quick connector or hose clamp.
3. → Extract from both of the extraction connections (aggregate and saw guard) with a single extraction hose. → Chapter 4.5 'Dust extraction' on page 22

7.5 Connect electrics

7.5.1 Safety instructions - Connect electrics



NOTICE

Electric current

Damage due to incorrect power supply.

- The electrical connection of the machine must be carried out by a licensed electrician on the day of installation.
- Before connecting the machine to the power supply, compare the information on the nameplate with that of the power supply. Only connect the machine if the two sets of data correspond to each other.
- It is forbidden to open or to tamper with the electrical box on the machine without the express authorisation from Felder Group service centre. Violating this stipulation will invalidate any guarantee claims.

Electrical connection requirements:

- The machine must be earthed with electrical conductors.
- Pay attention to the technical data relating to the electrical components of the machine.
- The on-site electric cabinet must be fitted with a circuit breaker (DIN VDE 0641). There must be a separate switch contact for each live phase.
- The unit must only be used in TN-Systems (neutral connected to earth).
- For permissible voltage fluctuation, fuse protection and connection cable, see wiring diagram.
- The power supply cable must be protected against damage (e.g. armoured conduit).
- The power supply cable must be laid in such a way so that it does not bend or chafe and that there is no risk of tripping over it.
- The power cable should be inspected regularly for signs of damage or ageing. The machine must not be used if the power cable is not in perfect condition.
- Only connect the power plug once the machine is positioned in its operating location. Connect to CEE outlet (e.g. wall outlet).

7.5.2 Connect the machine plug

Connect power supply cable

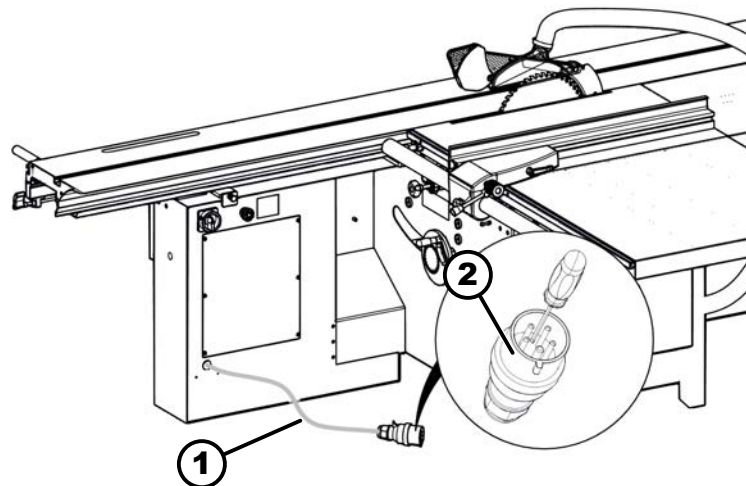


Fig. 39: Electrical connection cable

- 1 Power supply cable
- 2 CEE outlet, phase inverter (optional)



DANGER

High electrical voltage in the connection cable

Serious injury or death when touching live cables.

- Changes to the connection cable can only be carried out by a trained electrician.

Personnel:

- Qualified electrician

The machine's power cable is delivered with an open cable end, i.e. without a plug. The electrical outlet must have the appropriate socket (for a three-phase alternating current motor, CEE).

1. Fit the machine's power cable with a suitable plug and ensure that it is in accordance with country specific regulations.

2. → To protect against electric shock, the machine must be equipped with a protective device (residual current circuit breaker and/or an overcurrent protection device).
3. → Check the loop impedance and the suitability of the overcurrent protective device at the machine's installation site.

Check the rotation direction of the saw arbour

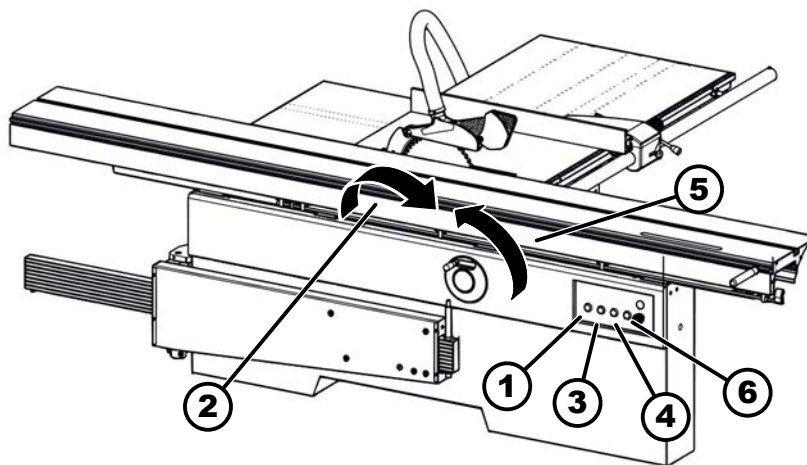


Fig. 40: Motor rotation direction

- 1 Green start button – saw motor ON
- 2 Rotation direction of the saw shaft
- 3 Red stop button – saw motor OFF
- 4 Green start button - Scoring blade ON
- 5 Rotation direction of the scoring shaft
- 6 Red stop button - Scoring blade OFF

Personnel:

- Qualified electrician

1. → Connect the plug to the power supply.
2. → If available: unlock the [main switch] and switch on (position "I" / "ON").
3. → Attach the circular saw blade. → Chapter 8.9.1 'Change the saw blade' on page 58
4. → Depending on the machine configuration: Fit the scoring saw blade. → Chapter 8.10.1 'Installing the scoring saw blade' on page 61
5. → Prepare the machine for operation. → Chapter 8.8.3 'Prepare the machine for operation' on page 57
6. → Switch the machine on, let it run briefly and switch it off again.
7. → As the motor is slowing down, check the rotational direction of the saw arbour.

OK

The rotation direction of the saw arbour is in the opposite direction to the processing direction of the workpiece.

NOK

The rotation direction of the saw arbour is in the same direction to the processing direction of the workpiece.

→ Swap two phases on the machine's supply cable.

8. → Check the rotation direction of the scoring shaft at the motor outlet.

OK

The rotation direction of the scoring shaft is opposite to that of the saw shaft.

NOK

The rotation direction of the scoring shaft is the same as that of the saw shaft.

Error in the electrical connection.

→ Contact Felder Group service centre.

8 Adjustments and tool changes

8.1 Lock the sliding table

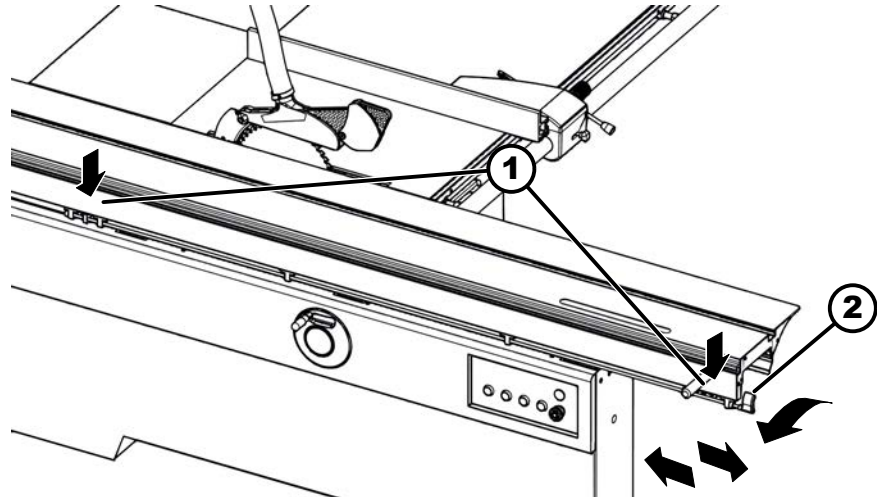


Fig. 41: Lock the sliding table

- 1 Locking positions
- 2 Lever

The sliding table can be locked in two positions using the lever.

1. Slide the sliding table into the desired locking position (arrow).
2. Shift the lever to the back. Slide the sliding table to and fro so that it locks into position.
3. To unlock move the lever upwards.

8.2 Crosscut fence on the sliding table (Option)

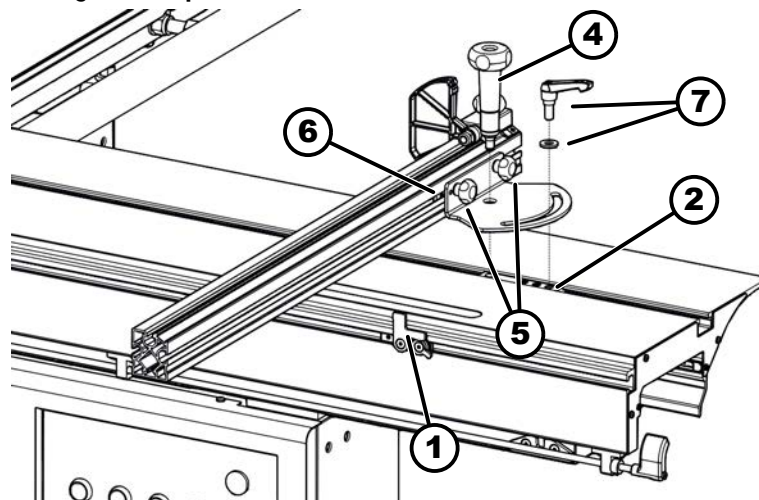


Fig. 42: Mount the crosscut fence to the sliding table

- 1 0° stop plate
- 2 Clamping device
- 4 Hold-down shaft
- 5 Thumb screws
- 6 Fence screw (fence plate)
- 7 Clamping lever with serrated washers



NOTICE

Collision between crosscut fence and saw blade

Damage could be caused if set incorrectly.

- The fence plate must not protrude beyond the edge of the sliding table.

Mount the crosscut fence to the sliding table

The machine can be optionally equipped with a crosscut fence on the sliding table.

Install the mounting set for the crosscut fence on the sliding table (see separate installation guide). ➔ Chapter 7.3.1 'Mounting the sliding table' on page 34

1. Turn away the 0° stop plate in order to slide the crosscut fence over it.
2. Lightly fix the crosscut stop to the clamping piece using the hold-down shaft.
3. Screw the clamping lever, together with the serrated washers, into the clamping piece.

4. → Calibrate the scale of the crosscut fence by pushing the stop profile forwards to the 0° position.
 1. → Loosen the thumb screws.
 2. → Push the fence forwards as far as the fence screw (in the groove).
 3. → Tighten the thumb screws.
5. → Tighten the hold-down shaft and clamping lever.

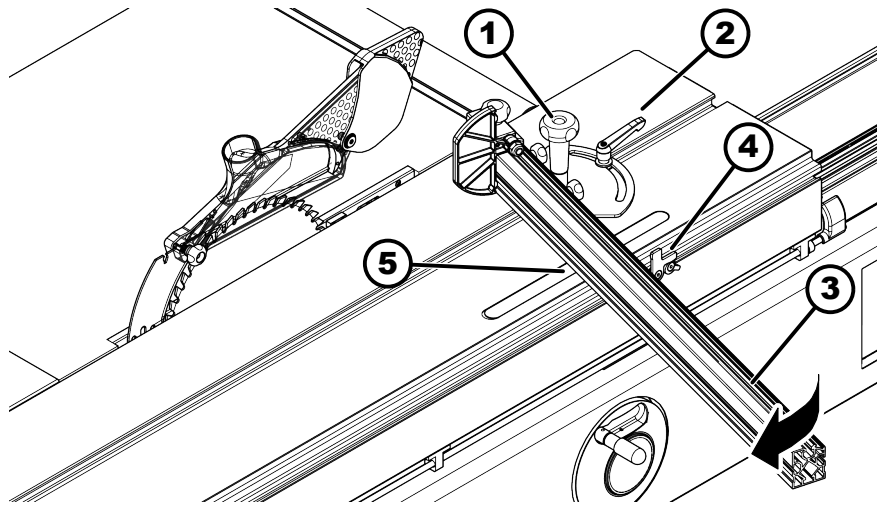


Fig. 43: Tilt the crosscut fence

- 1 Hold-down shaft
- 2 Clamping lever
- 3 Crosscut fence
- 4 0° stop plate
- 5 Scale

**NOTICE****Collision between crosscut fence and saw blade**

Damage could be caused if set incorrectly.

- The fence plate must not protrude beyond the edge of the sliding table.

Swing the crosscut fence into the desired position

1. → Loosen hold-down shaft and clamping lever.
2. → Adjust scale (-45° to +45°) to desired cutting angle.
If necessary, turn the 0° stop plate downwards to be able to slide the crosscut fence over it.
3. → Scale length compensation when the fence is at an angle towards +45°:
 1. → Loosen the thumb screws.
 2. → Move (retract) the stop profile.
 3. → Re-tighten the thumb screws.
4. → Set the crosscut fence to a cutting angle of 0°.
 1. → Move the 0° stop plate back up (position vertically).
 2. → Slide the crosscut fence back again, until it sits against the 0° stop plate.
 3. → Loosen the thumb screws.
 4. → Push the fence forwards as far as the fence screw (in the groove).
 5. → Re-tighten the thumb screws.
5. → Tighten the hold-down shaft and clamping lever.

**Set the 0° cutting angle (readjust)**

Adjust the 0° position on the 0° stop plate. → Chapter 11.7 'Adjusting the 0° angle of the crosscut stop on the sliding table' on page 100

8.3 Mounting/removing the outrigger table

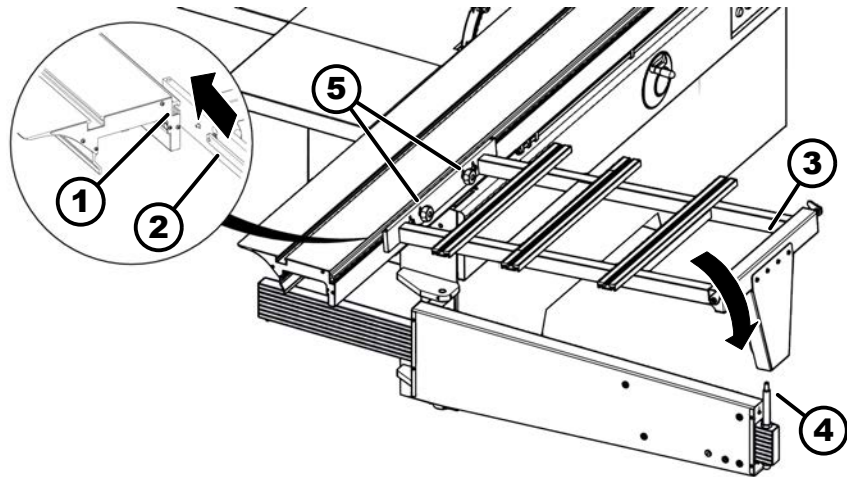


Fig. 44: Mounting the outrigger table

- 1 Groove
- 2 Clamping strip
- 3 Outrigger table
- 4 Support arbour
- 5 Thumb screws

Mount the outrigger table:

1. Lock the sliding table.
2. Loosen the thumb screws.
3. Slide the outrigger table with the clamping strip into the groove on the sliding table.
4. Slide forward until the adjusting screw just rests in the sliding table groove.
To achieve the maximum travel of the sliding table, move the outrigger table to the position shown in the illustration.

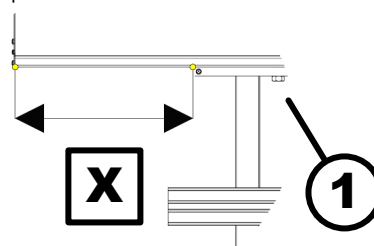


Fig. 45: Detail - Outrigger table mounting position

- 1 Adjusting screw
- X Distance to the edge of the sliding table approx. 290 mm
- 5. Place the outrigger table onto the support arbour.
- 6. Tighten the thumb screws.

Removing the outrigger table:

1. Lock the sliding table.
2. Removing the crosscut fence from the outrigger. ➔ Chapter 8.4 'Crosscut fence on the 1100 mm outrigger' on page 49
3. Loosen the thumb screws.
4. Unhook the outrigger table from the support shaft.
5. Pull the outrigger table sideways out of the sliding table groove.
➔ Do not tilt the outrigger table when pulling it out.

8.4 Crosscut fence on the 1100 mm outrigger

Mounting / removing the crosscut fence from the rear side of the outrigger

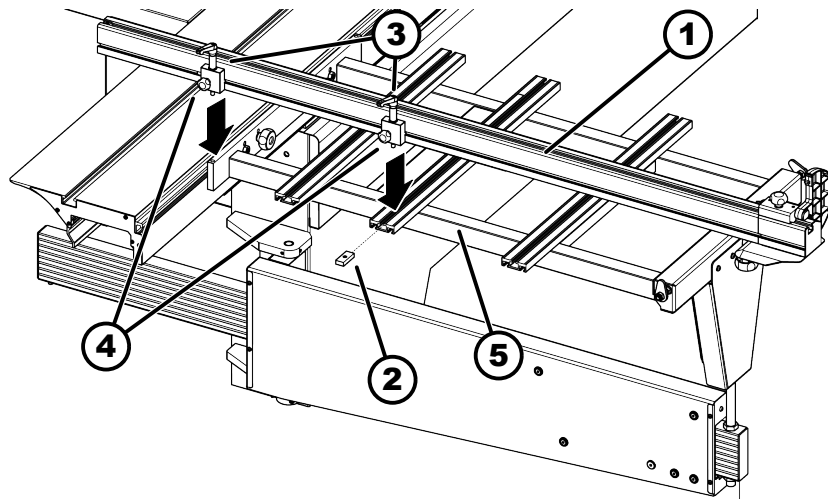


Fig. 46: Mounting the crosscut fence

- 1 Crosscut fence
- 2 Locking plate
- 3 Clamping lever
- 4 Thumb screws
- 5 Outrigger table

The crosscut fence can be mounted on the pull and push side of the outrigger table.

1. Thread the clamping plate into the support rail of the outrigger table.
2. Loosen the thumb screws and position the crosscut fence on the outrigger.
3. Clamp the crosscut fence on the outrigger with the clamping lever.
4. Tighten the thumb screws.
5. Remove by carrying out in reverse order.

Mount the crosscut fence on the outrigger on the front side

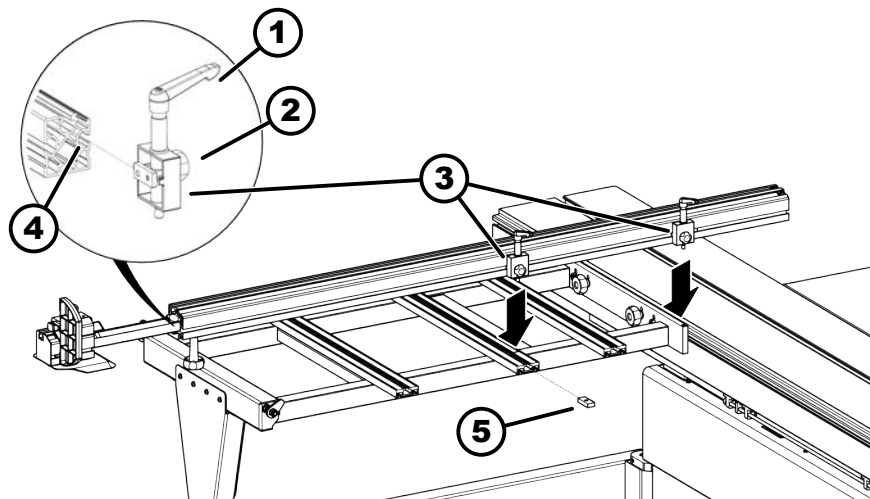


Fig. 47: Mount the crosscut fence on the front side

- 1 Clamping lever
 - 2 Thumb screws
 - 3 Swivel jaws
 - 4 Groove
 - 5 Locking plate
1. Release the clamping lever and remove the crosscut fence.
 2. Loosen the thumb screws.
 3. Slide both of the swivel jaws out of the groove of the fence profile.
 4. Thread both swivel jaws back into the groove on the opposite side.
 5. Move the clamping plate in the rail of the outrigger.
 6. Position the crosscut fence on the push side of the outrigger.
 7. Clamp the crosscut fence on the outrigger with the clamping lever.

Swing the crosscut fence into the desired position

**NOTICE****Collision between crosscut fence and saw blade**

Damage could be caused if set incorrectly.

- The fence plate must not protrude beyond the edge of the sliding table.

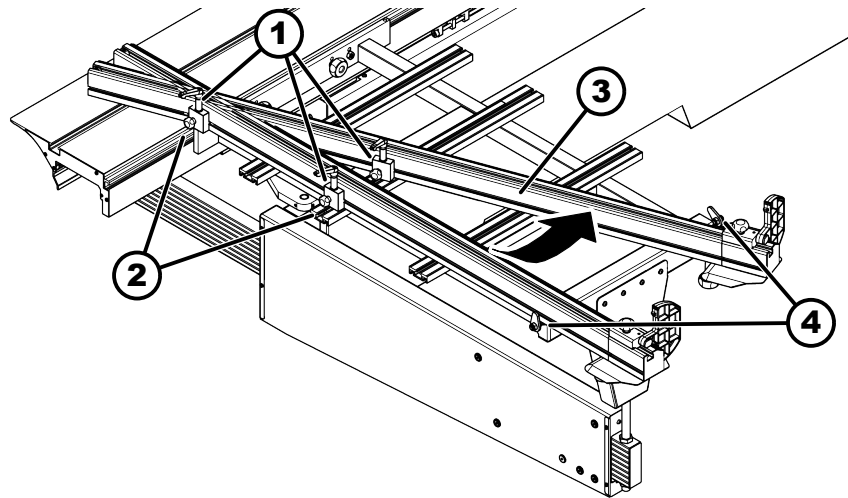


Fig. 48: Tilt the crosscut fence

- 1 Clamping lever
- 2 Thumb screws
- 3 Crosscut fence
- 4 0° stop plate

The crosscut fence scale must be adjusted to the angle set (length compensation).

1. Loosen the clamping lever and thumb screws.
2. Swing the crosscut fence to the desired position. If necessary, fold down the stop plate to slide the crosscut fence over it.
3. Clamp the clamping lever in place and tighten the thumb screws.
4. Scale length compensation when the fence is at an angle:
 1. Loosen the thumb screws.
 2. Move the fence profile.
 3. Re-tighten the thumb screws.

Swing the crosscut fence into the 0° position

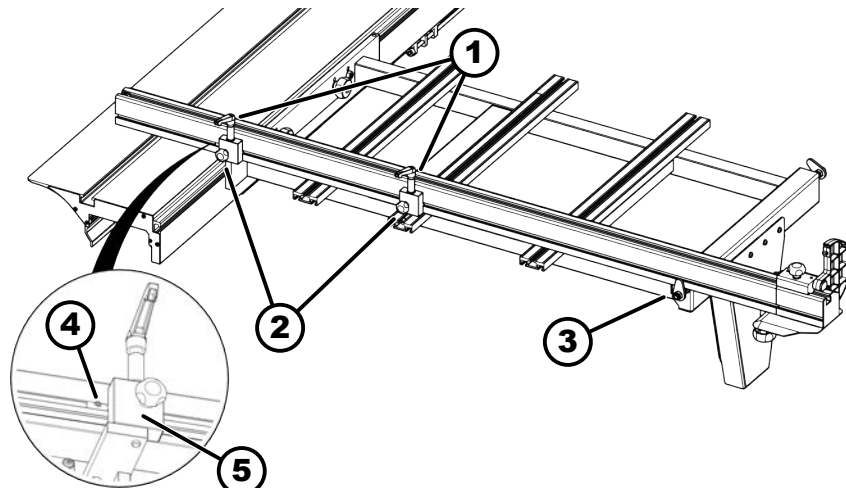


Fig. 49: Crosscut fence in the 0° position

- 1 Clamping lever
- 2 Thumb screws
- 3 0° stop plate
- 4 0° calibration position (scale)

1. Loosen the clamping lever and thumb screws.
2. Move the 0° stop plate back up (position vertically).
3. Slide the crosscut fence back again, until it sits against the 0° stop plate.

4. → Calibrate the scale of the crosscut fence by turning the stop plate back to the 0° position.
5. → Clamp the clamping lever in place and tighten the thumb screws.



0° angle adjustment (readjust)

The 0° position can be corrected on the stop plate using the lock nuts.
 ➔ Chapter 11.8 'Correct the 0° angle of the crosscut fence on the out-rigger angle' on page 101

8.5 Crosscut fence - extension and crosscut fence

Crosscut stop on the crosscut fence (standard)

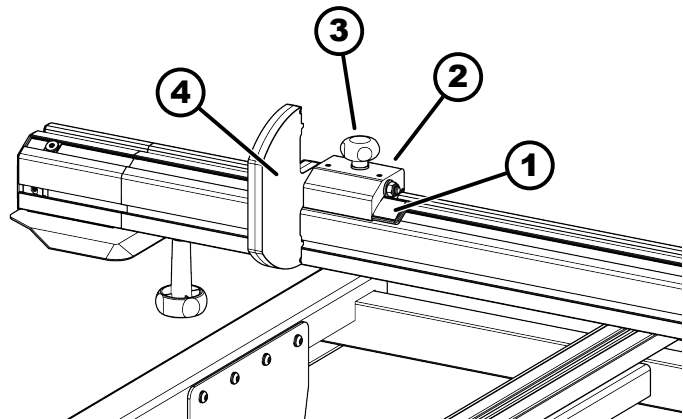


Fig. 50: Crosscut stop standard

- 1 Magnifying glass
- 2 Crosscut fence
- 3 Thumb screws
- 4 Fence stop

The crosscut fence can be positioned freely along the fence.

If required, the end stop can be folded back.

1. → Loosen the thumb screw.
2. → Move the crosscut fence to the desired position.
 ➔ Read off the measurement (cutting width) using the magnifying glass.
3. → Tighten the thumb screw.

Crosscut fence - Extension

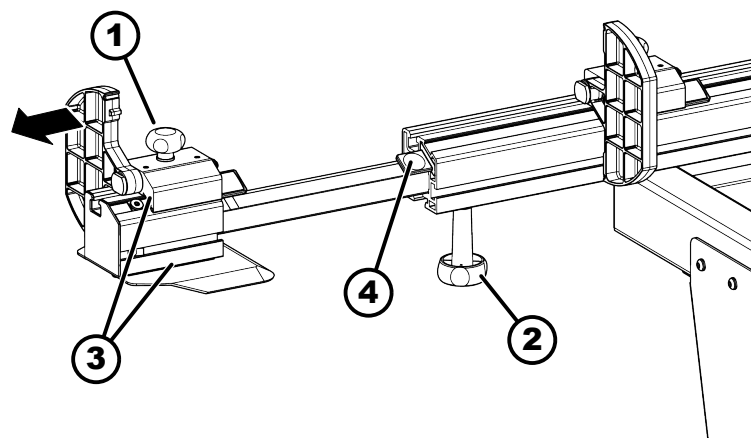


Fig. 51: Crosscut fence - Extension

- 1 Thumb screw 1 (crosscut stop)
- 2 Thumb screw 2 (extension)
- 3 Crosscut fence and extension
- 4 Magnifying glass


Remove transport lock

Depending on the equipment, the crosscut fence extension is secured against movement with a locking screw on delivery.

Remove the locking screw and replace it with the thumb screw from the bag.

The crosscut fence is equipped with an extension.

1. ➔ Loosen the thumb screw 1.
2. ➔ Push the crosscut fence onto the extension as far as it will go.
3. ➔ Tighten the thumb screw 1.
4. ➔ Loosen the thumb screw 2.
5. ➔ Move the crosscut fence extension to the desired position.
 - ➔ Read off the measurement (cutting width) using the magnifying glass.
6. ➔ Tighten the thumb screw 2.

8.6 Rip fence

8.6.1 Setting the rip fence

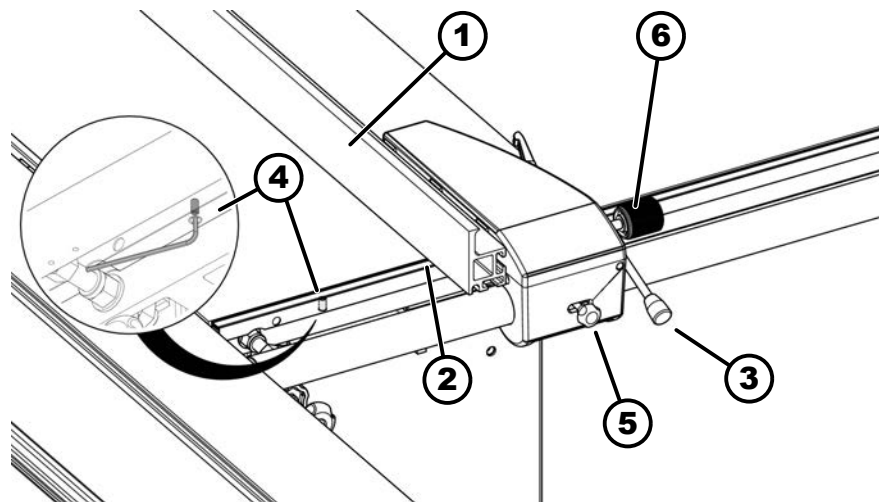


Fig. 52: Standard parallel fence

- | | |
|---|---------------------------------------|
| 1 | Fence plate |
| 2 | Scale |
| 3 | Clamping lever |
| 4 | Clamping screw (adjust scale) |
| 5 | Knurled screw (fine adjustment clamp) |
| 6 | Adjustment wheel fine adjustment |

Set the rip fence to the cutting dimension

Tool:

- Hex key 3 mm

1. ➔ Switch off the machine.
2. ➔ Loosen the clamping lever.
3. ➔ Read the measurement set from the scale on the front edge of the fence plate.
4. ➔ Adapt scale to different circular saw blade thicknesses:
 1. ➔ Loosen the clamping screw.
 2. ➔ Move the scale by the missing dimension.
 3. ➔ Tighten the clamping screw.
5. ➔ Clamp the clamping lever.

Rip fence with fine adjustment


Note

To compensate for thread play, always make the fine adjustment towards the saw blade.

1. ➔ Switch off the machine.
2. ➔ Release the clamping lever and lock the knurled screw in place.

3. → Turn the adjusting wheel clockwise for fine adjustment.
 ➤ Adjustment in the direction of the saw blade.
4. → If fine adjustment is no longer possible, first move the adjustable jaw to their original position.
 → Turn the adjusting wheel counter clockwise as far as it will go.
5. → Tighten the clamping lever, then loosen the knurled screw.

8.6.2 Convert fence plate to narrow fence edge

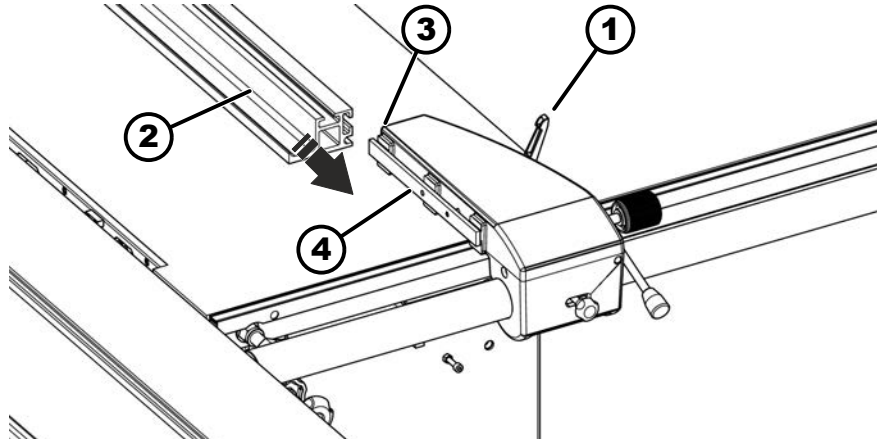


Fig. 53: Mount the guide in a flat position

- 1 Clamping the fence plate (clamping lever)
- 2 Fence plate
- 3 Front edge of the rip fence
- 4 Clamping rail

To cut narrow workpieces, convert the fence plate to the narrow fence edge.

If the fence plate is installed horizontally, the distance to the saw blade changes. Take account of the changed cutting width on the scale.

1. → Switch off the machine.
2. → Release the fence plate clamping.
3. → Pull the fence plate out to the rear.
4. → Turn the fence plate (lay it flat on the table) and thread it onto the clamping rail with the corresponding groove.
5. → **WARNING!** Wedging of the fence plate on the rip fence.
 Serious injuries due to kickback if the workpiece jams and jams during processing.
 ► Pull the fence plate back as far as the front edge of the rip fence.

Tighten the clamp on the fence plate.

8.6.3 Remove rip fence

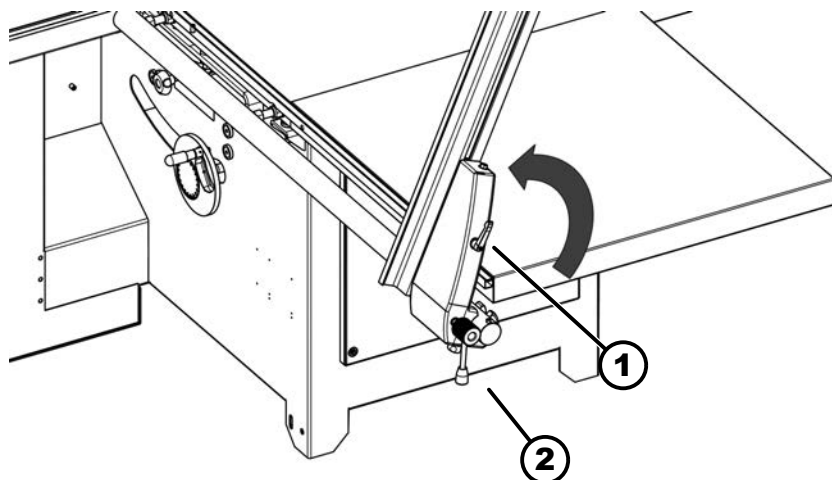


Fig. 54: Remove rip fence

- 1 Clamping lever 1 (fence plate)
- 2 Clamping lever 2 (rip fence)

**WARNING****Uncontrolled movement of the workpiece**

Serious injuries due to kickback if the workpiece slips and tilts during processing.

- Always use a cross fence or rip fence to guide the workpiece.

When processing large panels or when carrying out maintenance work it may be necessary to remove the rip fence.

1. Switch off the machine.
2. Lock clamping lever 1 (fence plate).
3. Release clamping lever 2 (rip fence).
4. Push the rip fence right to the back.
5. Lift the rip fence and pull it backwards off the fence support bar.

8.6.4 Swing the rip fence away – standard fence

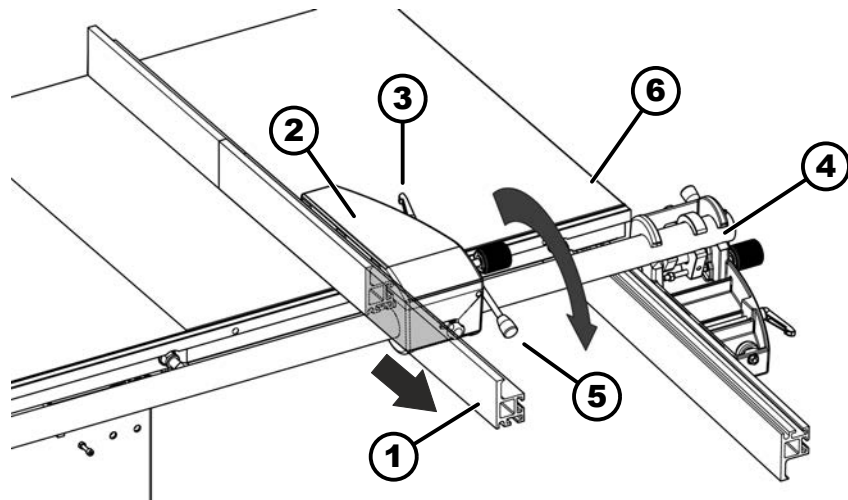


Fig. 55: Swing the rip fence away

- 1 Fence plate
- 2 Rip fence
- 3 Clamping lever 1 (fence plate)
- 4 Fence support bar
- 5 Clamping lever 2 (rip fence)
- 6 Table extension

When processing large panels the rip fence can be swung away underneath the table level.

1. Switch off the machine.
2. Loosen the clamping lever 1.
3. Place the fence plate in the centre.
4. Lock clamping lever 1.
5. Loosen the clamping lever 2.
6. Move the rip fence right up to the end of the bar.
7. Tilt the rip fence away and let it rest with the crosscut fence against the underside of the table extension.

8.6.5 Mounting the "Sägeboy" auxiliary fence on the rip fence

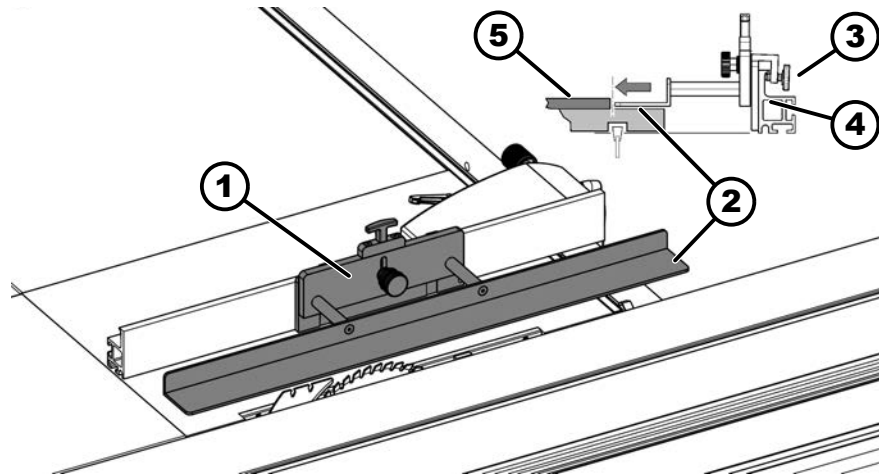


Fig. 56: Mount the auxiliary fence "Sägeboy"

- 1 Auxiliary Fence "Sägeboy" (Art.-No. 01.0.022)
- 2 Guide rail
- 3 Thumb screws
- 4 Fence plate
- 5 Template (mounted to the workpiece)



Grooving tool cover and auxiliary fence "Sägeboy"

On machines without overhead saw guard, covered cuts and grooving work may be carried out if the auxiliary fence "Sägeboy" is placed over the saw blade.

Assembly, operation and adjustment: See own operating instructions.

The auxiliary fence "Sägeboy" is an additional, anodised aluminium fence and is mounted to the saw rip fence.

The Sägeboy guide rail also serves as a fence for sawing with templates.

1. → Clamp the Sägeboy auxiliary fence to the fence plate with thumb screws.
2. → Adjust the rip fence so that the tool is covered by the Sägeboy guide rail.
3. → For settings on the Sägeboy auxiliary fence, see specific operation instructions.

8.7 Adjusting the cutting height / cutting angle

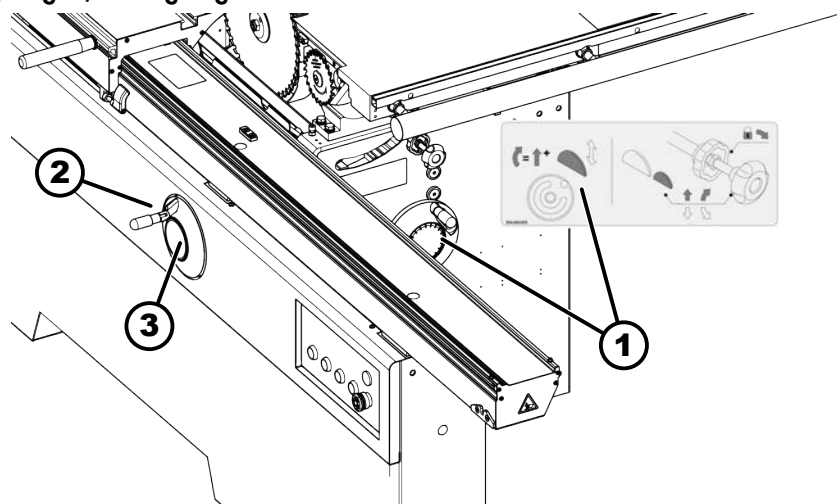


Fig. 57: Adjusting the cutting height / cutting angle

- 1 Hand wheel - circular saw height adjustment
- 2 Hand wheel - Saw blade angle adjustment
- 3 Display clock - cutting angle

Adjusting the cutting height

Only adjust the cutting height to the height actually required.

1. → Set the cutting height using the height adjustment hand wheel on the side.
 - Clockwise: higher
 - Anti-clockwise: lower
2. → Check the cutting height that has been set with a measuring device on the saw blade.

**NOTICE****Collision between the saw blade and the fence plate or workpieces**

Property damage may result from incorrect setting of the cutting angle.

- When tilting beware of any possible collisions between fences, workpieces etc.
- Keep objects clear of the saw blade's tilt range.

Adjusting the cutting angle

When tilting beware of any possible collisions between fences, workpieces etc.

1. → Move the rip fence away from the saw blade to prevent a collision when tilting.
→ Chapter 8.6.1 'Setting the rip fence' on page 52
2. → Set the cutting angle using the angle adjustment hand wheel.
 - Anti-clockwise: towards 45°
 - Clockwise: towards 0°
3. → Read the set cutting angle from the display clock.

8.8 Tool change**8.8.1 General information relating to saw blades and grooving tools****NOTICE****Collision between machine components**

Material damage when swivelling the saw unit.

- Do not adjust the 0° angle when operating with grooving tooling.
- Only use grooving tools with a width of less than 6 mm.

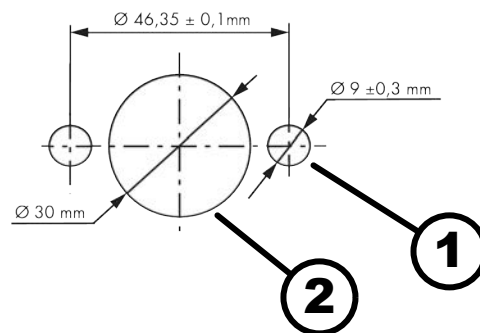


Fig. 58: Saw blade pin

- 1 Pin hole
2 Saw arbour hole

Only use saw blades and grooving tools,

- which have an authorised speed higher than the speed of the saw arbour.
- that comply with EN 847-1 in the current version.
- which are marked with "MAN".
- that meet the requirements of these operating instructions.
- which are well sharpened and in good condition.

Only use grooving tools,

- which are suited to manual operation.
- which are suitable to work with wood.

**Note**

We recommend you use manufacturer original Felder Group tools exclusively.

The processing of workpieces at the maximum cutting height indicated is only possible under certain conditions. Whether it is possible is in direct relation to the following factors:

- Type of wood (hardwood or softwood)
- Wood dampness
- Feed rate
- saw blades
- The motor power of your machine

8.8.2 Prepare to change tooling

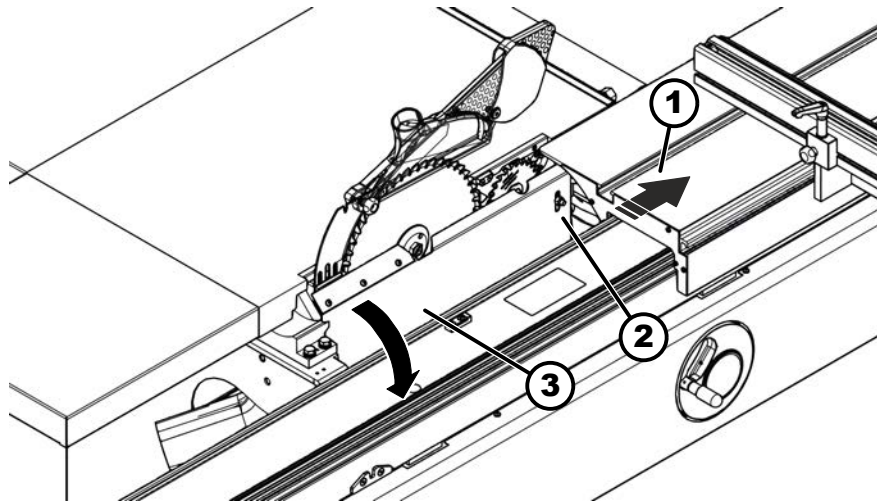


Fig. 59: Prepare to change tooling

- 1 Move the sliding table as far to the right as possible
 - 2 Hinged cover lock
 - 3 Hinged cover
1. → Position the saw aggregate in the 90° position (cutting angle 0°) and move to the uppermost position.
 2. → Switch off the machine and secure it from being switched on again.
 3. → Release the sliding table catch. → Chapter 8.1 'Lock the sliding table' on page 46
 4. → Slide the sliding table to the right until it reaches the end stop.
 5. → Release the lock (push upwards).
 6. → Pull the hinged cover to the front.

8.8.3 Prepare the machine for operation

Operational readiness when using saw blades

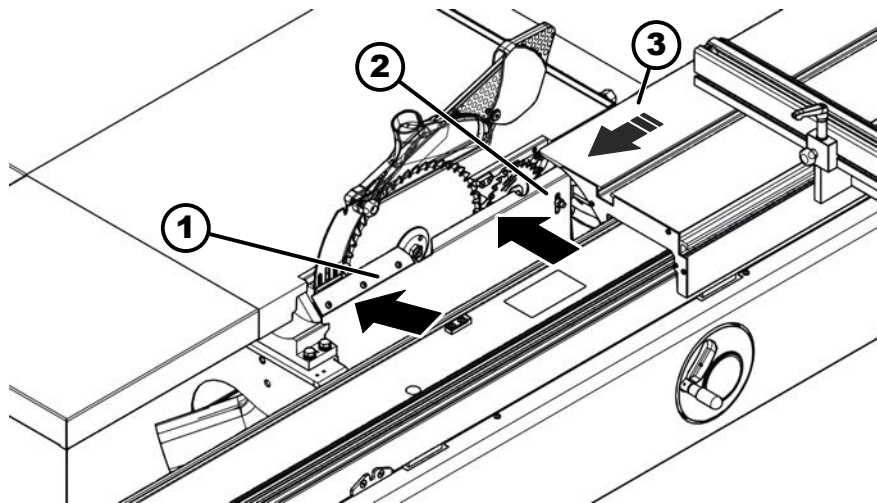


Fig. 60: Prepare the machine for operation

- 1 Saw aggregate hinged cover
- 2 Hinged cover lock
- 3 Place the sliding table in the centre position



Note

The saw blade only runs when the safety switch in the inside of the machine body is actuated by the locking device (hinged cover closed).

- Ensure that the hinged cover locks in place correctly on the right and the left.
- Ensure that the lock engages correctly.

1. → Close the hinged cover.
2. → Lift the latch and let it click into place.
3. → Place the saw guard on the riving knife from above and check the settings. → Chapter 8.11 'Fitting and adjusting the circular saw guard' on page 65

4. → Slide the sliding table to the centre.
 ➡ The machine is ready to use.

Operational readiness when using grooving tools

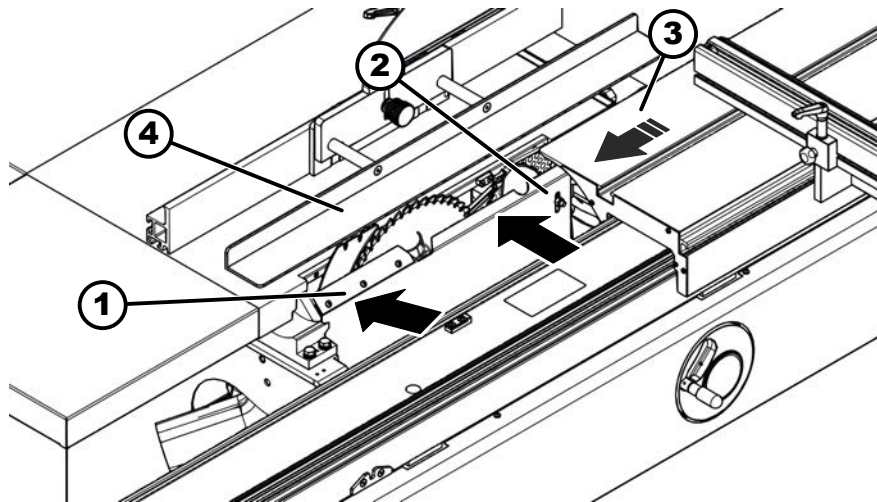


Fig. 61: Operational readiness - grooving tool

1. → Close the hinged cover.
2. → Lift the latch and let it click into place.
3. → Mounting the "Sägeboy" auxiliary fence on the rip fence. ➡ Chapter 8.6.5 'Mounting the "Sägeboy" auxiliary fence on the rip fence' on page 55
 Adjust the rip fence so that the tool is covered by the Sägeboy guide rail.
4. → Slide the sliding table to the centre.
 ➡ The machine is ready to use.

8.9 Changing the saw blade

8.9.1 Change the saw blade



Note

For precision cuts, we recommend using the smallest possible saw blade.
 See technical data for authorised saw blades.

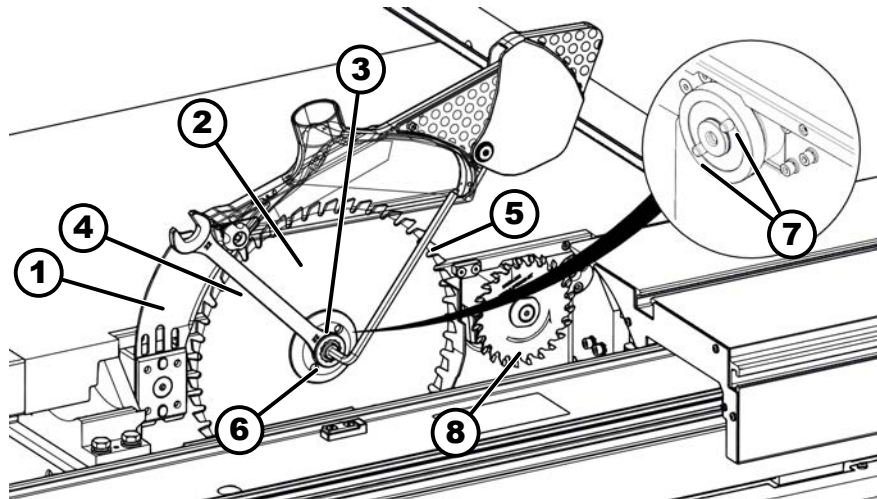


Fig. 62: Change the saw blade



WARNING

Sharp and hot tool cutting edges

Cuts and burns due to sharp and hot tools.

- Wear protective gloves.
- Adjustments to the machine or changing the tools may only be done once the machine has stopped.

Tool:

- Hex key 8 mm
- Ring spanner 22 mm

1. Prepare to change tooling. → Chapter 8.8.2 'Prepare to change tooling' on page 57
2. Hold the saw flange with a spanner.
3. Loosen the clamping screw with an Allen key.
Left screw thread, loosen by turning clockwise.
4. Remove the clamping screw and saw flange.
5. If a larger saw blade is to be fitted, loosen the riving knife. → Chapter 8.9.2 'Loosen / adjust riving knife' on page 59
6. Remove the existing saw blade and place the new saw blade on the shaft.
7. Replace the flange (take note of the assembling position).
► Place the flange onto both of the pins by aligning the holes.
8. Hold the saw flange with a spanner.
9. **WARNING!** Ejected parts
Severe injuries and damage to property.
► Observe the minimum tightening torque.

Tighten the clamping screw with a minimum tightening torque of 20 Nm.
Left screw thread, tighten by turning counter clockwise.
10. Has a larger or smaller circular saw blade been installed:
 - Adjust the riving knife.
 - Adapt the saw guard (on the riving knife) to the saw blade diameter.
11. Prepare the machine for operation.
→ Chapter 8.8.3 'Prepare the machine for operation' on page 57

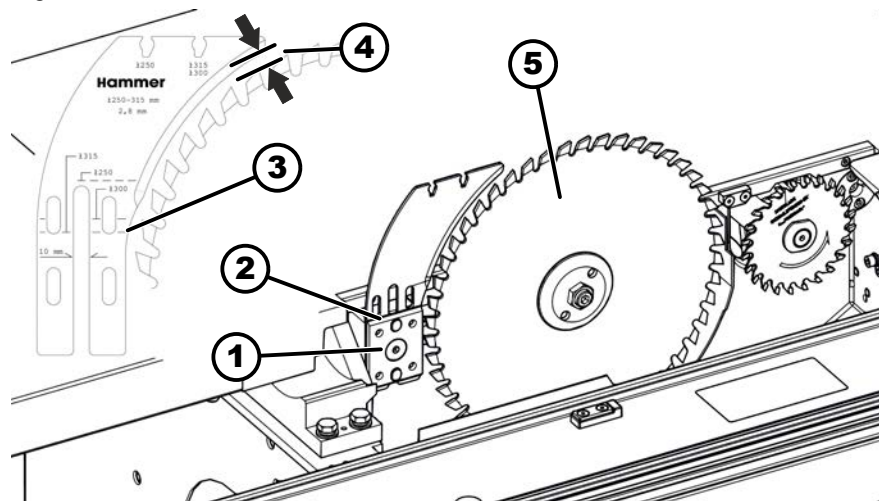
8.9.2 Loosen / adjust riving knife

Fig. 63: Adjust the riving knife

- 1 Clamping screws
- 2 Upper edge of the riving knife holder
- 3 Marking on the riving knife
- 4 Distance
- 5 Saw blade

**NOTICE****Incorrectly adjusted distance between the saw blade and riving knife**

Material damage and possible malfunction with covered cuts.

- Set the riving knife so that the distance to the saw blade is between 3 and 8 mm.
- When making concealed cuts, position the riving knife so that its highest point is 0 to 2 mm below the highest point of the saw blade.

Tool:

- Hex key 6 mm

1. Preparing the machine for a tool change. → Chapter 8.8.2 'Prepare to change tooling' on page 57
2. Loosen the clamping screw.
3. Move the riving knife so that there is, at any given point, a distance of 3 to 8 mm between the saw blade and the riving knife.

4. → The marking on the riving knife must match the top edge of the riving knife holder.
When carrying out covered cuts, the highest point of the riving knife must be 0-2 mm below the highest point of the saw blade.
5. → **WARNING!** Ejected parts
Severe injuries and damage to property.
► Observe the minimum tightening torque.
- Tighten the clamping screw with a minimum tightening torque of 25 Nm.

8.9.3 Fit /change the riving knife

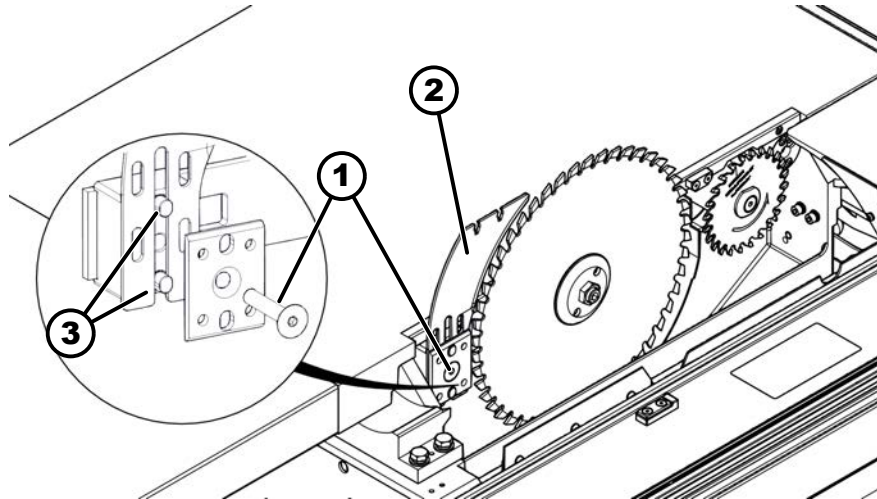


Fig. 64: Fit the riving knife

- 1 Clamping screws
2 Riving knife
3 bolts

Tool:

- Hex key 6 mm

1. → Loosen the clamping screw.
2. → Remove the riving knife if required.
3. → Insert the riving knife into the holder.
► The riving knife holder bolt must sit in the riving knife groove.
4. → Move the riving knife into the correct position. → Chapter 8.9.2 'Loosen / adjust riving knife' on page 59
5. → **WARNING!** Ejected parts
Severe injuries and damage to property.
► Observe the minimum tightening torque.

Tighten the clamping screw with a minimum tightening torque of 25 Nm.

Correct selection of the riving knife

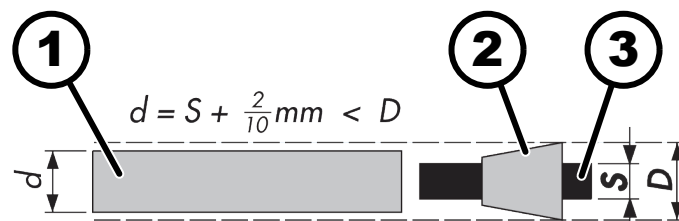


Fig. 65: Suitable riving knife for the saw blade

- 1 Riving knife thickness (d)
2 Saw tooth width (D)
3 Saw blade body (S)

The riving knife has to be adapted to the thickness of the saw blade. The thickness of the riving knife must be between that of the saw blade body and the width of the saw tooth.
The riving knife must be adapted to the saw blade diameter. Observe the markings on the riving knife.

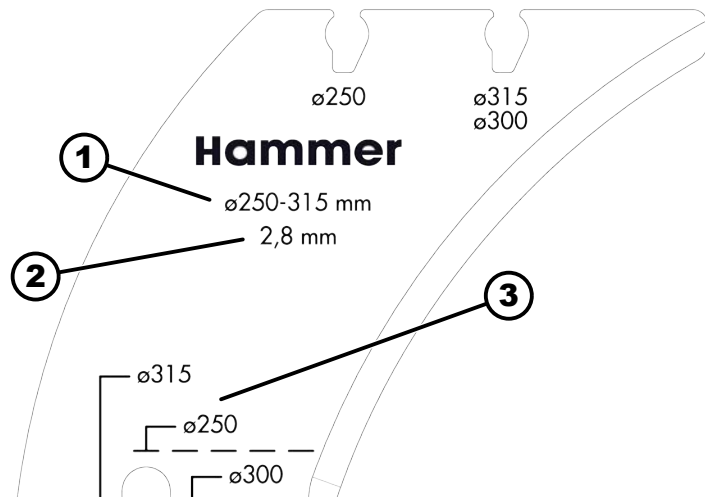


Fig. 66: Riving knife markings

- 1 Saw blade diameter
- 2 Riving knife thickness
- 3 Saw blade diameter markings

8.10 Scoring blade

8.10.1 Installing the scoring saw blade

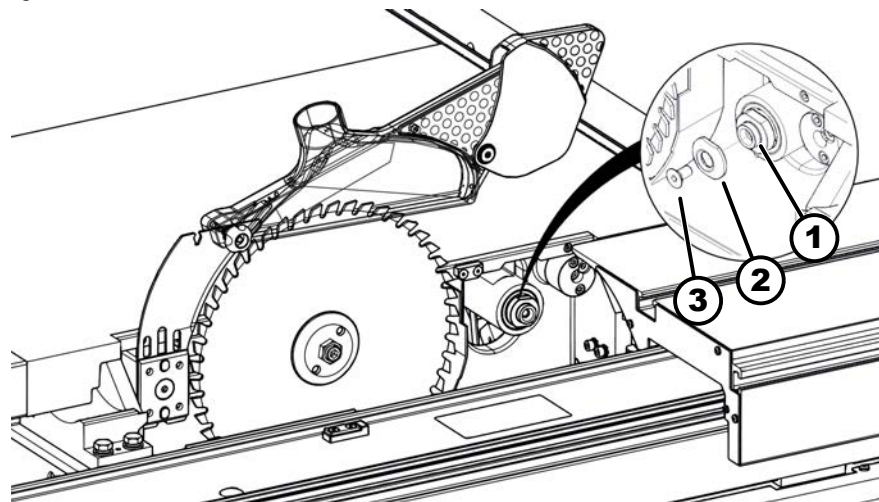


Fig. 67: Installing the scoring saw blade

- 1 Scoring unit shaft
- 2 Scoring flange
- 3 Clamping screws



WARNING

Sharp and hot tool cutting edges

Cuts and burns due to sharp and hot tools.

- Wear protective gloves.
- Adjustments to the machine or changing the tools may only be done once the machine has stopped.

Prepare to install the scoring saw blade:

1. → Preparing the machine for a tool change. → Chapter 8.8.2 'Prepare to change tooling' on page 57
2. → Remove the clamping screw and the scoring flange.
3. → Clean the scoring arbour thoroughly.

Insert conical scoring saw blade

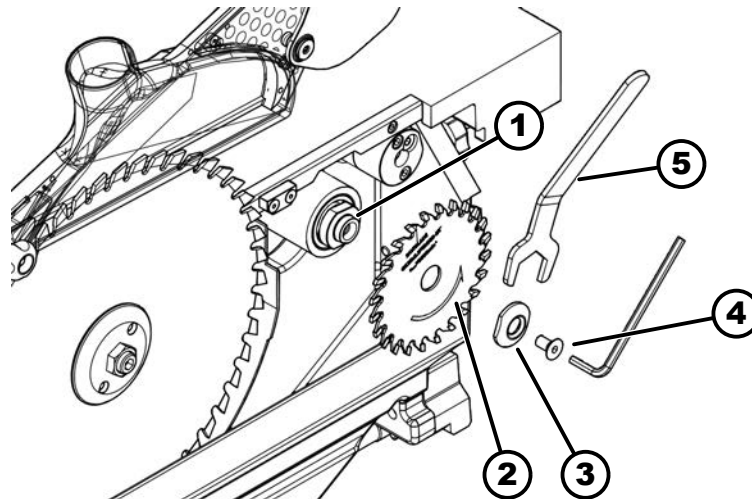


Fig. 68: Conical scoring saw blade

- 1 Scoring unit shaft
- 2 Scoring saw blade
- 3 Scoring flange
- 4 Clamping screws
- 5 Special spanner

Tool:

- Hex key 5 mm
- Special spanner

The one-piece scoring saw blade is fitted with tapered alternating teeth.

After setting the height, the scoring blade can be adjusted to the relevant thickness of the main saw blade.

1. → Fit the scoring saw blade onto the scoring shaft.
Check the installation position: That the tool rotates in the opposite direction to the main saw blade.

2. → Place the scoring flange onto the scoring shaft.

3. → Screw the clamping screw into the scoring shaft.

4. → **WARNING!** Ejected parts
Severe injuries and damage to property.
► Observe the minimum tightening torque.

Hold the scoring flange in place with a special spanner and apply an Allen key to the clamping screw.

Tighten the clamping screw clockwise with a minimum tightening torque of 20 Nm.

5. → Prepare the machine for operation. ➔ Chapter 8.8.3 'Prepare the machine for operation' on page 57

Installing the Classic scoring saw blade

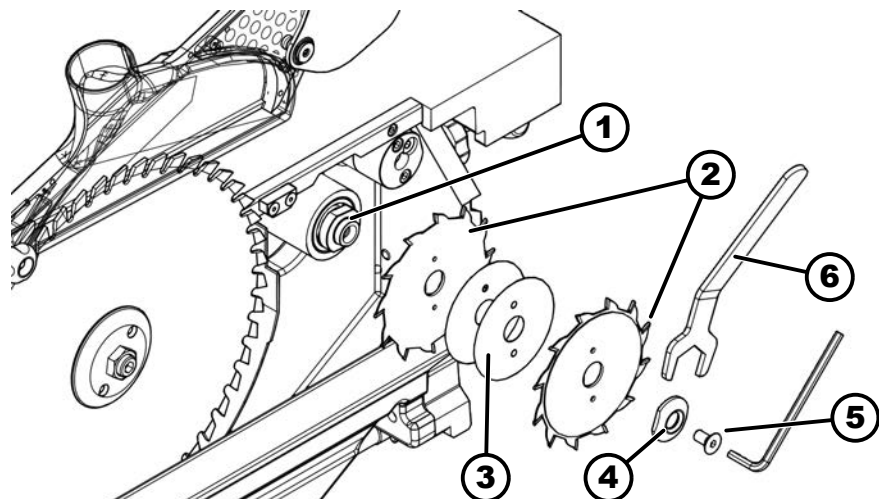


Fig. 69: Classic scoring blade

- 1 Scoring unit shaft
- 2 Scoring saw blade
- 3 Spacing discs

- 4 Scoring flange
- 5 Clamping screws
- 6 Special spanner

Tool:

- Hex key 5 mm
- Special spanner

The scoring saw blade consists of two saw blade halves and several spacer discs.

Use as many spacer washers as necessary in order to attain the required width.

The scoring saw blade should be 0.1 to 0.2 mm wider than the main saw blade.

1. → Fit the scoring saw blade onto the scoring shaft.
Check the installation position: That the tool rotates in the opposite direction to the main saw blade.
 2. → Place the scoring flange onto the scoring shaft.
 3. → Screw the clamping screw into the scoring shaft.
 4. → **WARNING!** Ejected parts
Severe injuries and damage to property.
► Observe the minimum tightening torque.
- Hold the scoring flange in place with a special spanner and apply an Allen key to the clamping screw.
- Tighten the clamping screw clockwise with a minimum tightening torque of 20 Nm.
5. → Prepare the machine for operation. ➔ Chapter 8.8.3 'Prepare the machine for operation' on page 57

8.10.2 Removing the scoring saw blade

Remove the conical scoring saw blade

**WARNING****Sharp and hot tool cutting edges**

Cuts and burns due to sharp and hot tools.

- Wear protective gloves.
- Adjustments to the machine or changing the tools may only be done once the machine has stopped.

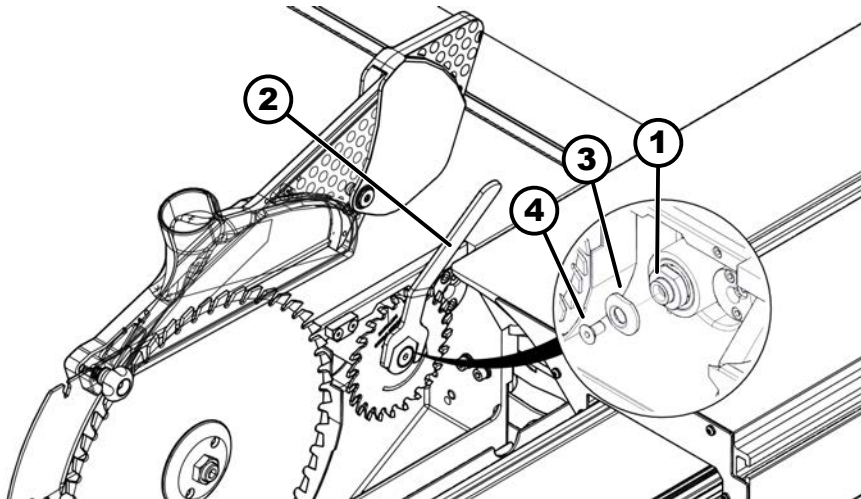


Fig. 70: Removing the scoring saw blade

- 1 Scoring unit shaft
 - 2 Special spanner
 - 3 Scoring flange
 - 4 Clamping screws
1. → Preparing the machine for a tool change. ➔ Chapter 8.8.2 'Prepare to change tooling' on page 57
 2. → Hold the scoring flange with a special spanner and loosen the clamping screw with an Allen key counter clockwise.
 3. → **WARNING!** Ejected parts
Serious injuries and property damage caused by loose components.
► When working without a scoring blade, leave the clamping screw and the scoring flange removed.
- Remove the clamping screw and scoring flange.
4. → Remove the scoring saw blade from the scoring shaft.

8.10.3 Scoring saw blade height and side adjustment

**WARNING****Moving machine components and tools**

Serious injury due to moving parts.

- Adjustments to the machine or changing the tools may only be done once the machine has stopped.
- Switch off the machine and secure it against being switched on again.

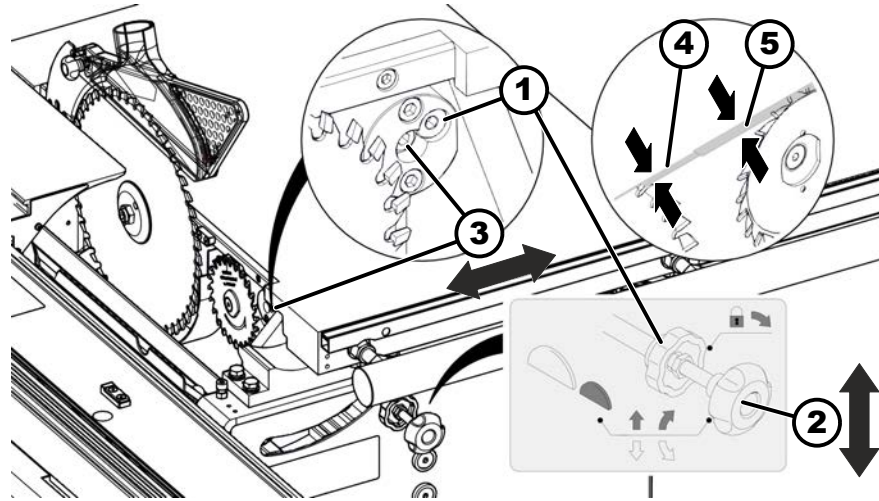


Fig. 71: Height-side adjustment

- 1 Clamping - height adjustment
- 2 Knurled screw - height adjustment
- 3 Adjustment screw - side adjustment
- 4 Cutting gap saw blade
- 5 Cutting line scoring saw blade

Tool:

- Hex key 5 mm

The scoring unit is necessary when processing laminated panels as it produces clean edges.

1. ➔ Switch off the machine and secure it from being switched on again.

2. ➔ Adjust the height using the knurled screw on the side. (Pos. 1)

1. ➔ Release the height adjustment lock.

- 2.** ➔ Turn the knurled screw:
- Clockwise: higher
 - Anti-clockwise: lower

3. ➔ Check that the height adjustment is locked in place.

3. ➔ Adjust the side alignment using the front adjustment screw. (Pos. 2)

Set the scoring blade so that it is aligned with the saw blade.

- clockwise: away from the sliding table
- counter clockwise: towards the sliding table

4. ➔ Check the setting by making a sample cut.

- ➔ A perfectly adjusted scoring saw blade cuts the workpiece at the same width on the underside to the left and right of the circular saw blade.

8.10.4 Width adjustment of scoring saw blade

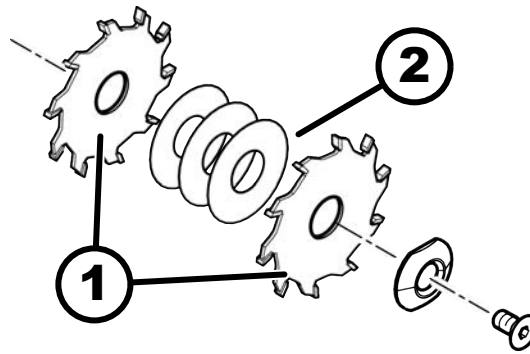


Fig. 72: Scoring blade

- 1 Saw blade halves
- 2 Spacing discs

The scoring saw blade consists of two saw blade halves and several spacer discs.

Adjust the width of the scoring saw blade just enough, that the saw teeth still cover both halves of the saw blade (cutting width max. 3.6 mm).

1. Use as many spacer discs as are needed, to ensure that the scoring saw blade is 0.1 to 0.2 mm wider than the circular saw blade.
2. Set the scoring blade so that it is centered to the saw blade. → Chapter 8.10.3 'Scoring saw blade height and side adjustment' on page 64
3. Check the setting by making a sample cut.

8.11 Fitting and adjusting the circular saw guard

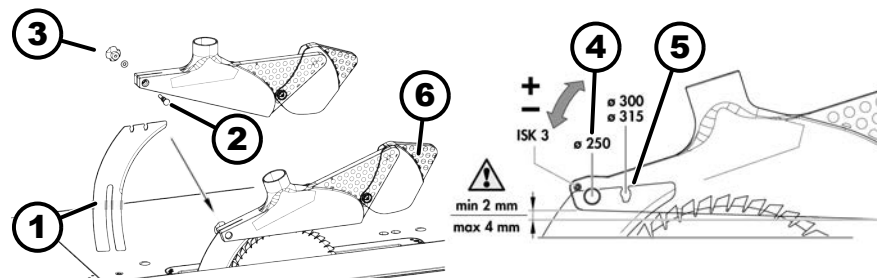


Fig. 73: Overhead saw guard

- 1 Riving knife
- 2 Hood bolt
- 3 Thumb nut
- 4 Recess for saw blades from 250 mm
- 5 Recess for saw blades from 300 to 315 mm
- 6 Option: Protective hood scoring saw blade

To prevent injuries when using the circular saw, the machine must be equipped with a protective hood which is positioned over the saw blade.

The saw guard may only be used with saw blades with a diameter of 250 to 315 mm.

To utilise the maximum cutting height when the saw blade is swivelled, the hood bolt can also be mounted from the rear of the circular saw guard.

Adjust the saw guard to the saw blade size:

1. Switch off the machine and secure it from being switched on again.
2. Loosen the thumb nut.
3. Press the hood stud forwards with the thumb nut.
4. Remove the saw guard from above and insert it into the other recess.
 - Make sure that the cover bolts sit correctly in the slot of the riving knife.
5. Secure the thumb nut.

Adjust the inclination of the circular saw guard:

Tool:

- Hex key 3 mm

1. Switch off the machine and secure it from being switched on again.
2. Loosen the thumb nut.
3. Adjust the inclination of the saw guard with the adjusting screw.
 - Pay attention to setting value of the distance in the graphic.
4. Secure the thumb nut.

9 Operate

9.1 Auxiliary aids for safe operation



Note

When using appropriate auxiliary equipment and observing the safety distances to the surroundings, there are no limits to the workpiece dimensions.

- Support long workpieces with additional supports (e.g. table extensions, roller supports).
- Keep tools for processing short and narrow workpieces close at hand (e.g. push grip, push stick, workpiece holder).

9.2 Switch on / switch off / shutdown due to an emergency stop



WARNING

Insufficient preparation

Severe injuries and damage to property

- Do not start the machine until all prerequisites have been met and all preparatory work has been completed.
- Read the instructions for setup, adjustment and operation before turning on the machine.



NOTICE

Operating/room temperature

Damages due to storage, material damage

- The machine may only be operated in dry and frost-free rooms at temperatures between +5 and +40 °C.

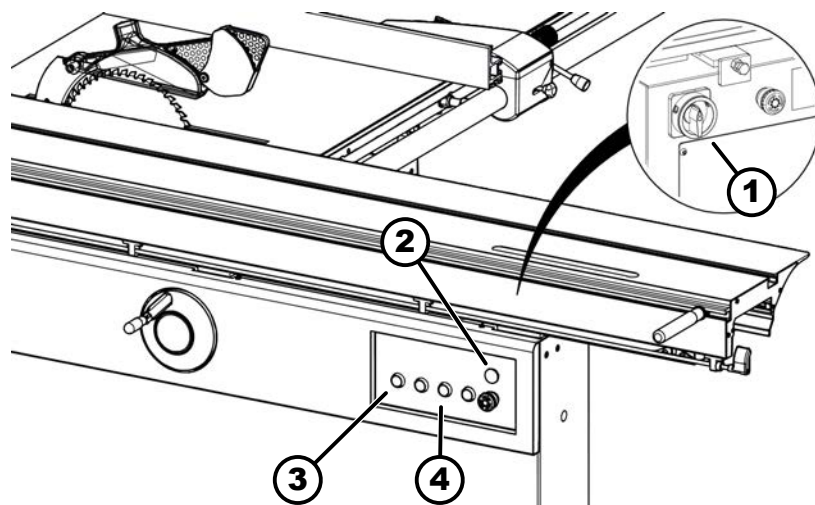


Fig. 74: Switch on

- 1 Main switch (on the back)
- 2 Indicator light – Mains power ON
- 3 Green start button - Saw blade ON
- 4 Green start button - Scoring blade ON

Switch on

The scoring saw blade and the main saw blade are switched on separately using their respective green *[start]* buttons.

1. ➔ Connect the plug to the power supply.
2. ➔ Unlock the *[Main switch]* and turn on (position "I" / "ON").
➔ The *Mains power ON* indicator light is on.
3. ➔ Press the green *[Start]* button on the control panel and release.

9.3 Switch on / switch off / shutdown due to an emergency stop

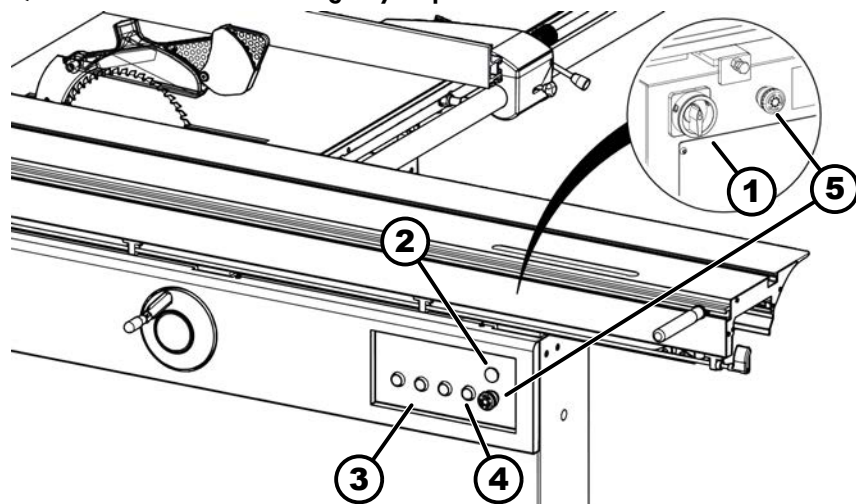


Fig. 75: Switch off / Emergency stop

- 1 Main switch (on the back)
- 2 Indicator light – Mains power ON
- 3 Red stop button - Saw blade OFF
- 4 Red stop button - Scoring blade OFF
- 5 Emergency stop actuator

Switch off

The scoring saw blade and the main saw blade are switched off separately using their respective red *[stop]* buttons.

1. → Press the red *[stop]* button.
2. → Switch off *[Main switch]* (position "O" / "OFF") and lock.
 - ➡ The 'Mains Power ON' indicator light goes out.
3. → Disconnect the machine from the main power supply.

Switching off in an emergency

The machine is equipped with either one or several *[emergency stop]* buttons, depending on the configuration.

1. → Press the *[emergency stop]* or the red *[stop]* button.
 - ➡ The machine stops immediately.
2. → Unlock the *[emergency stop]* actuator by turning it.

9.4 Moving the sliding table

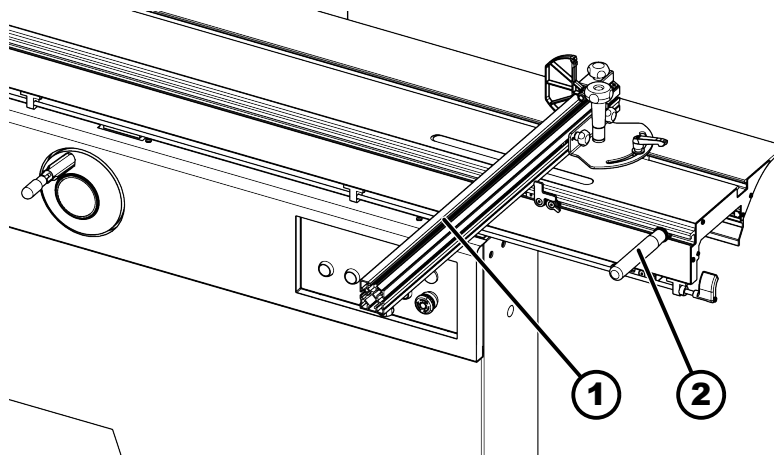


Fig. 76: Moving the sliding table

- 1 Crosscut fence
- 2 Hand grip

Move sliding table using the crosscut fence or handle.

9.5 Working techniques

9.5.1 Working positions



WARNING

Ejected workpieces / tool parts

Injuries caused by ejected workpieces and workpiece parts (e.g. branches, offcuts, blade parts).

Injury due to kickback from cut workpiece parts.

- Never stand directly in the cutting line of the saw blade whilst it is operating (when machining or in idle).
- Assume the correct working position.

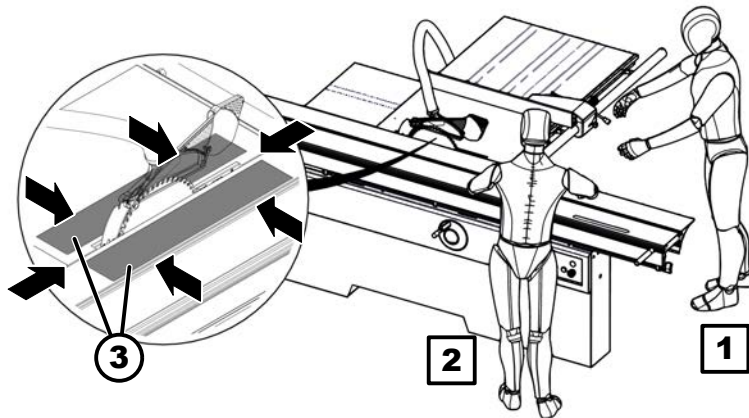


Fig. 77: Working positions

- 1 Working position when operating with the rip fence
- 2 Main working position for all other operations
- 3 Danger zone - 120 mm

The danger zone is the area 120 mm to the left, right, in front of and behind the saw blade.

Do not reach into the danger zone with your hand.

Never place your hands on the workpiece in the danger zone.

9.5.2 Permitted working methods

Only the following working techniques are allowed with the panel saw:

- Trimming, only when using the trimming shoe.
- Crosscutting, with parallel or crosscut fence.
- Longitudinal cut 90° to 45°, with a parallel cutting fence and locked sliding table.
- Longitudinal cut 90° to 45°, with a crosscut fence and sliding table.
- Splitting of large-format panels.

Only the following work techniques are allowed using the panel saw without a scoring unit:

- Covered cuts / rebate on the parallel cutting fence.

9.5.3 Prohibited working techniques

The following work techniques are strictly forbidden when using the circular saw:

- All techniques without the use of a rip fence, cross section, trimming shoe or outrigger.
- Cutting of round workpieces (in the longitudinal direction).
- Removing the riving knife for insert cuts *).
- Covered cuts *).

*) The following deviations apply to the scope of the Holz-Berufsgenossenschaft (BG) in the Federal Republic of Germany: Insertion cuts and covered cuts are permitted if the operating regulations corresponding to the Employer's Liability Insurance Association (BG) are observed (BG No. 96.18).

9.5.4 General procedures for authorised working techniques



CAUTION

Cutting circular work-pieces

Injuries due to ejected workpieces and workpiece parts or twisting of the workpiece.

- Secure round workpiece against turning by using a template or holding device.
- Work with the crosscut fence especially with round workpieces.
- Use a suitable saw blade for cross sections.

Carry out all adjustment work and preparations for cutting only when the saw blade is stationary.

1. Ensure there are sufficient support surfaces (accessories).
2. Keep handling accessories at hand:
 - Push stick, push grip
 - Deflector with Holding Magnets
3. If required: Set the cutting height, cutting angle and if necessary scoring blade.
4. With machines that have an overhead saw guard:
 1. For angle cuts, convert the overhead saw guard to the wide guard.
 2. Lower the protective hood to the workpiece height.
5. Before cutting check the collision zone between crosscut fence and saw blade.
6. Before switching on the machine, always check to make sure that there are no other people in the immediate vicinity of the machine.
7. On machines without automatic extraction system control, switch on the extraction system.
8. Only switch the machine on once the workpiece has been placed in the correct position.
9. Place your hands flat on the workpiece with your fingers closed.
 1. Never place your hands on the workpiece in the danger zone.
 2. Place the left hand only up to a maximum of 120 mm from the front edge of the guard for lateral guidance of the workpiece.
 3. Place the left hand on the machine table or sliding table for further processing.
10. Guide the workpiece evenly through the saw blade.
11. Use the push stick once you are at the end of the cut.
12. Once the cut is finished, switch the machine off.

9.5.5 Longitudinal cut / cutting of strips

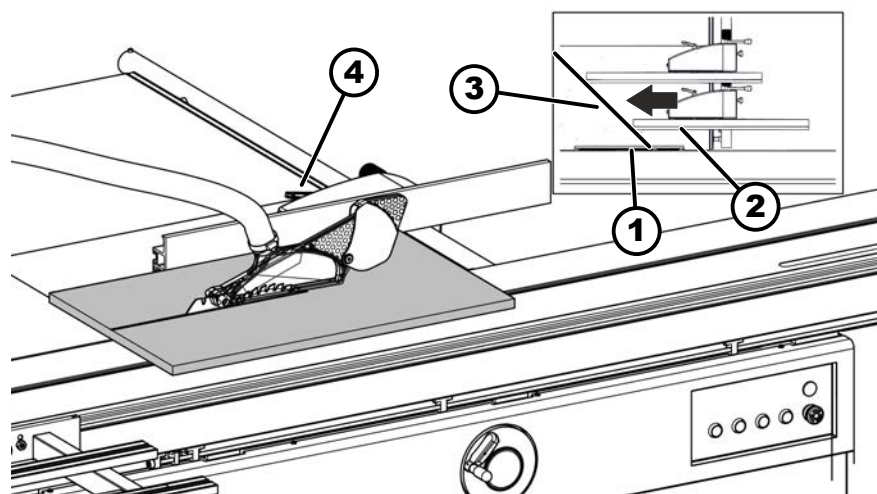


Fig. 78: Rip cut

- 1 Saw blade
- 2 Fence plate
- 3 imaginary 45° line
- 4 Clamping the fence plate (clamping lever)

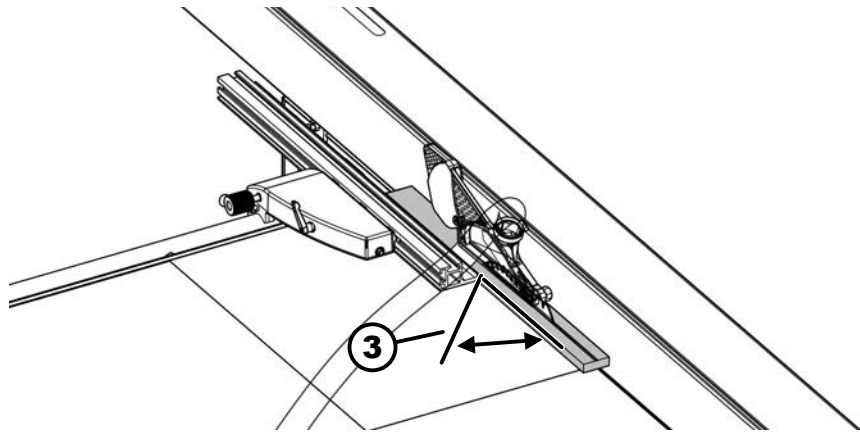


Fig. 79: Cutting strips

**WARNING****Rotating saw blade**

Severe injury caused by contact with a rotating saw blade.

- Never place your hands on the workpiece in the danger zone.
- Push the workpiece past the saw blade with the push stick.

1. Take note of general procedures for permitted working methods.
2. If required and only when cutting strips:
Convert the fence plate on the rip fence to a narrow fence edge.
3. Adjust the rip fence to the desired position.
4. **WARNING!** Securing the workpiece in place whilst processing.
Serious injuries due to kickback if the workpiece jams and jams during processing.
 - Set the fence plate to match the cutting width.
1. Release the fence plate clamping.
2. Move the fence plate forward until it is flush with an imaginary line (see illustration).
 - The end of the fence plate abuts an imaginary line that starts at the front edge of the saw blade and runs backwards at 45° across the machine table.
3. Clamp the fence plate in place.
 - This prevents the workpiece from becoming trapped between the fence plate and the saw blade.
5. Lock the sliding table into a centre position.
6. Remove the crosscut fence.
 - A collision with the crosscut fence is prevented when working with long workpieces.
7. Place the workpiece against the rip fence.
8. Switch the saw blade on.
9. Place your hands flat on the workpiece with your fingers closed.
 1. Place the left hand only up to a maximum of 120 mm from the front edge of the guard for lateral guidance of the workpiece.
 2. Place the left hand on the machine table or sliding table for further processing.
10. Guide the workpiece evenly through the saw blade.

9.5.6 Trimming

**WARNING****Uncontrolled movement of the workpiece**

Serious injuries due to kickback if the workpiece slips and tilts during processing.

- Always use a trimming shoe or trimming device for trimming unfinished boards.

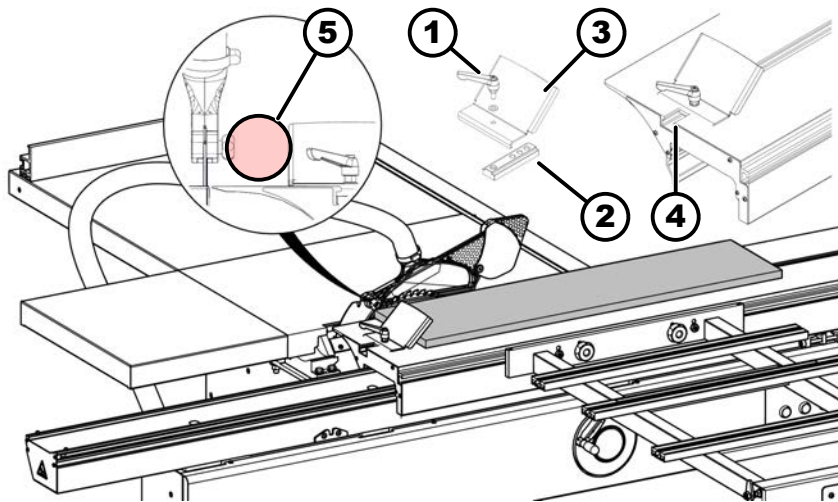


Fig. 80: Trimming

- 1 Clamping lever
- 2 Locking plate
- 3 Trimming shoe
- 4 Groove
- 5 Collision zone

Using the trimming shoe (mounted on the sliding table):

1. Take note of general procedures for permitted working methods.
2. Remove the crosscut fence.
3. Assembling the trimming shoe:
 1. Insert the trimming shoe with the clamping plate into the groove in the sliding table.
 2. Clamp the trimming shoe with the clamping lever onto the sliding table.
 3. Check the clearance between the trimming shoe and the saw guard.
4. Loosen the sliding table lock and pull the sliding table back completely.
5. Place the unfinished plank, with the hollow side facing downwards, onto the sliding table and clamp in the trimming shoe.
6. Switch the saw blade on.
7. Place your hands flat on the workpiece with your fingers closed.
 1. Place the left hand only up to a maximum of 120 mm from the front edge of the guard for lateral guidance of the workpiece.
 2. Place the left hand on the machine table or sliding table for further processing.
8. Guide the workpiece evenly through the saw blade.

9.5.7 Cutting short, narrower workpieces

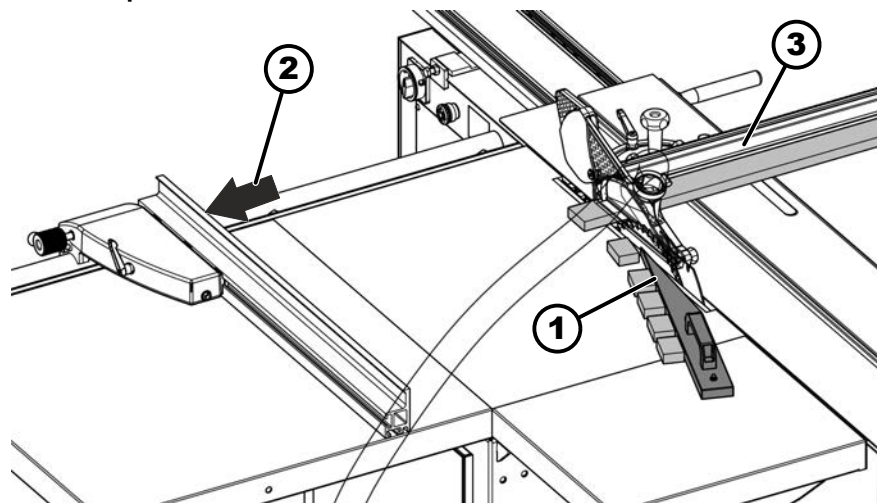


Fig. 81: Cutting short, narrower workpieces

- 1 Guard with holding magnets (art. no. 420-260)
- 2 Move the rip fence away
- 3 Crosscut fence

Tool:

- Guard with holding magnets (art. no. 420-260)

1. ➤ Take note of general procedures for permitted working methods.
2. ➤ Move the rip fence as far away as possible from the saw blade.
3. ➤ Attach the off-cut deflector to the machine in such a way that the sawed off pieces do not collide with the rising part of the saw blade.
4. ➤ Release the sliding table catch.
5. ➤ Place the workpiece against the crosscut fence.
6. ➤ Switch the saw blade on.
7. ➤ Press the workpiece hard against the crosscut fence using both hands.
 - Never place your hands on the workpiece in the danger zone.
8. ➤ Guide the workpiece evenly through the saw blade.
9. ➤ Pull the workpiece a few millimetres away from the saw blade and move the sliding table into the initial position.

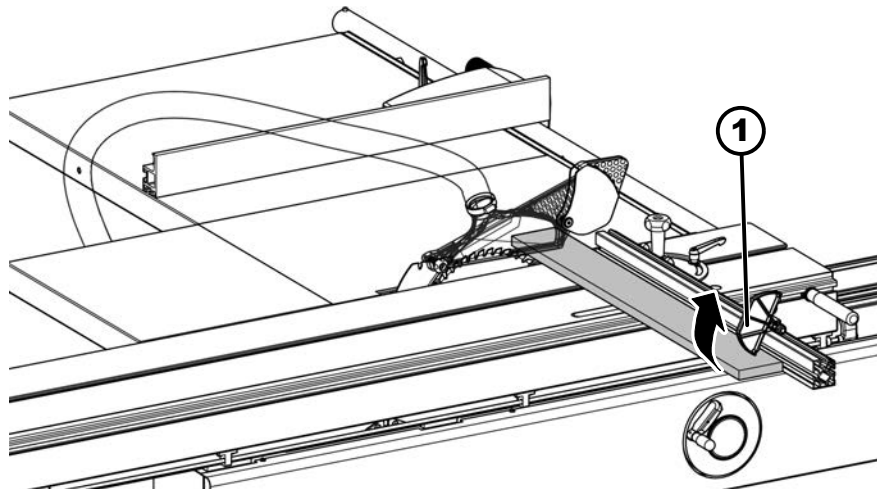
9.5.8 Cross-cutting using the crosscut fence (sliding table)

Fig. 82: Rough cut

1 Fence stop folded up (on the workpiece)

Rough cut:

1. ➤ Take note of general procedures for permitted working methods.
2. ➤ Move the rip fence as far away as possible from the saw blade.
3. ➤ Set the crosscut stop to the desired position.
4. ➤ Release the sliding table catch.
5. ➤ Place the workpiece against the crosscut fence.
6. ➤ Lift the crosscut stop up and place it onto the workpiece (illustration).
7. ➤ Press the workpiece hard against the crosscut fence using both hands.
 - Never place your hands on the workpiece in the danger zone.
8. ➤ Switch the saw blade on.
9. ➤ Guide the workpiece evenly through the saw blade.
10. ➤ Pull the workpiece a few millimetres away from the saw blade and move the sliding table into the initial position.

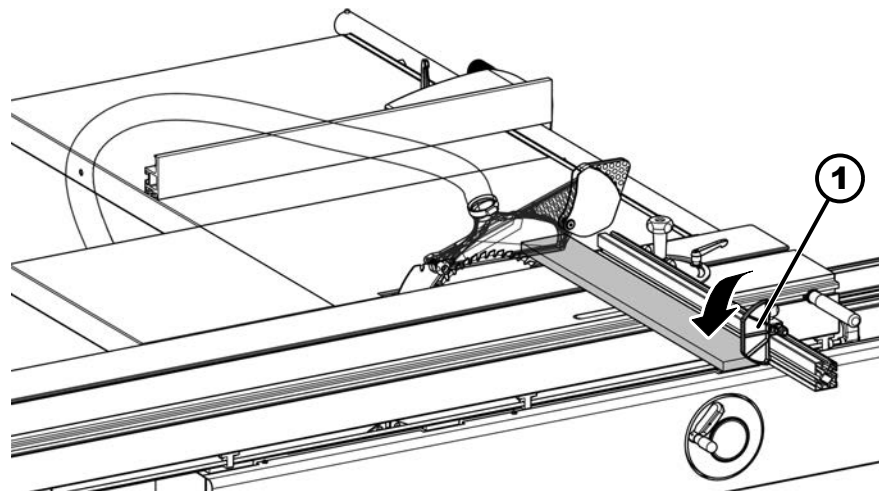


Fig. 83: Precise cut

1 Fence stop as workpiece stop

Precise cut:

1. Lower the end stop.
2. Place the workpiece against the crosscut fence and the crosscut stop.
3. Press the workpiece hard against the crosscut fence using both hands.
 - Never place your hands on the workpiece in the danger zone.
4. Guide the workpiece evenly through the saw blade.

9.5.9 Crosscutting with the crosscut and rip fence

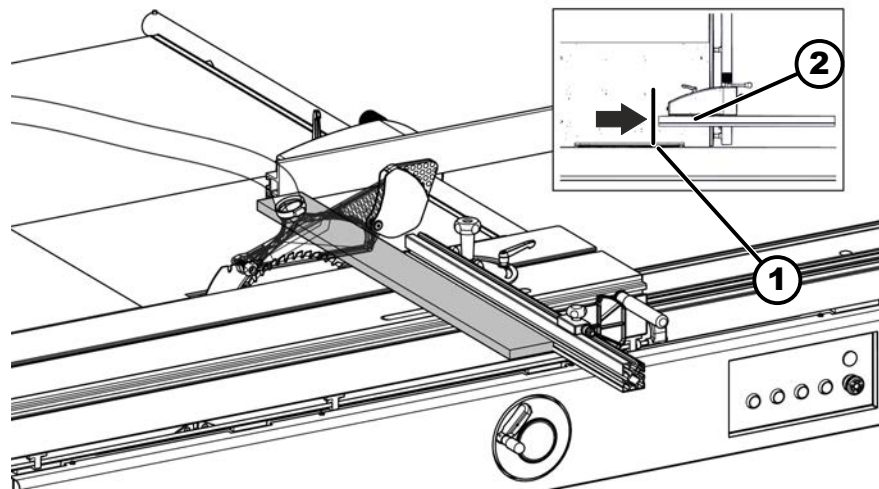


Fig. 84: Crosscutting using the rip fence

- 1 Saw blade front edge
2 Fence plate

1. Take note of general procedures for permitted working methods.
2. Adjust the rip fence to the desired position.
3. **WARNING!** Wedging of the fence plate on the rip fence. Serious injuries due to kickback if the workpiece jams and jams during processing.
 - Pull the fence plate back as far as the front edge of the rip fence.
1. Release the fence plate clamping.
2. Pull the fence plate back to the front edge of the rip fence.
 - The end of the fence plate abuts an imaginary line that starts in front of the front edge of the saw blade and runs backwards at 90° across the machine table.
3. Clamp the fence plate in place.
 - This prevents the workpiece from becoming jammed between the fence plate and the saw blade.
4. Clamp the fence plate in place.
5. Release the sliding table catch.
6. Place the workpiece against the crosscut fence.
7. Switch the saw blade on.

8. ➔ Advance the workpiece to the parallel stop rail (ruler).
9. ➔ Press the workpiece hard against the crosscut fence using both hands.
 - ◆ Never place your hands on the workpiece in the danger zone.
10. ➔ Guide the workpiece evenly through the saw blade.
11. ➔ Pull the workpiece a few millimetres away from the saw blade and pull the crosscut fence back into the starting position.

9.5.10 Cutting with an outrigger

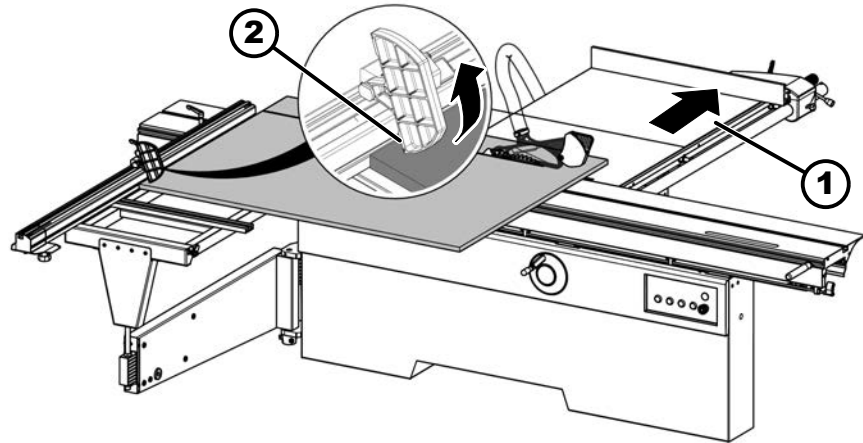


Fig. 85: Rough cut

- 1 Move the rip fence away
- 2 Fence stop: Position on workpiece



WARNING

Tilting or tipping of the workpiece

Serious injuries due to kickback if the workpiece tilts and jams during processing.

- Be sure to leave large and heavy workpieces on the outrigger.

Rough cut:

1. ➔ Take note of general procedures for permitted working methods.
2. ➔ Move the rip fence as far away as possible from the saw blade.
3. ➔ Set the crosscut stop to the desired position.
4. ➔ Release the sliding table catch.
5. ➔ Place the workpiece against the crosscut fence.
6. ➔ Lift the crosscut stop up and place it onto the workpiece (illustration).
7. ➔ Press the workpiece against the crosscut fence.
8. ➔ Switch the saw blade on.
9. ➔ Place your hands flat on the workpiece with your fingers closed.
 - ◆ Never place your hands on the workpiece in the danger zone.
10. ➔ Guide the workpiece evenly through the saw blade.
11. ➔ Pull the workpiece a few millimetres away from the saw blade and move the sliding table into the initial position.

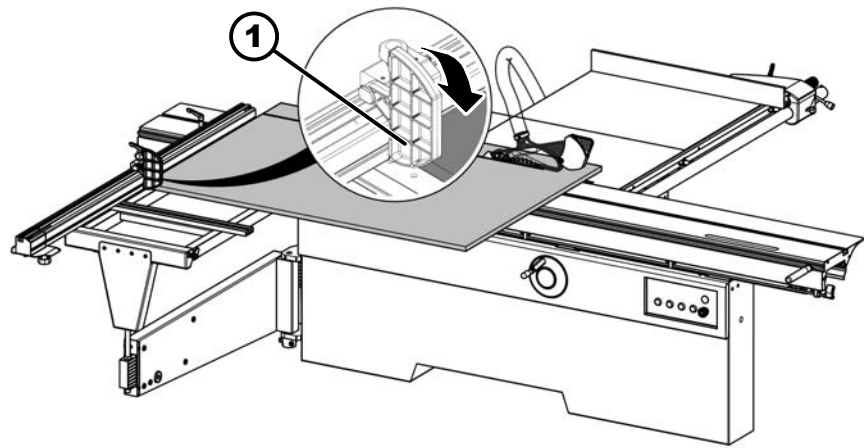


Fig. 86: Precise cut

1 Fence stop: position of exact cut

Precise cut:

1. Lower the end stop.
2. Place the workpiece against the crosscut fence and the crosscut stop.
3. Press the workpiece against the crosscut fence.
4. Place your hands flat on the workpiece with your fingers closed.
 - Never place your hands on the workpiece in the danger zone.
5. Guide the workpiece evenly through the saw blade.

9.5.11 Covered cuts ("Sägeboy" auxiliary fence)**WARNING****Rotating saw blade without safety devices**

Serious injuries may result from contact with the rotating saw blade without safety devices.

- Use the auxiliary fence "Sägeboy" (Art.-No. 01.0.022).
- Never place your hands on the workpiece in the danger zone.
- Do not remove the riving knife.

The offcut strip falls off on the right side of the saw blade. Because of the high risk of kickback, use a push stick to push the workpiece forward or use the crosscut fence.

1. Take note of general procedures for permitted working methods.
2. Remove circular saw guards.
3. Adjust riving knife: When carrying out covered cuts, the highest point of the riving knife must be 0-2 mm below the highest point of the saw blade.
4. Adjusting the rip fence: The front edge of the saw blade must be flush with the Sägeboy guide rail.

Carry out covered cuts with help of templates

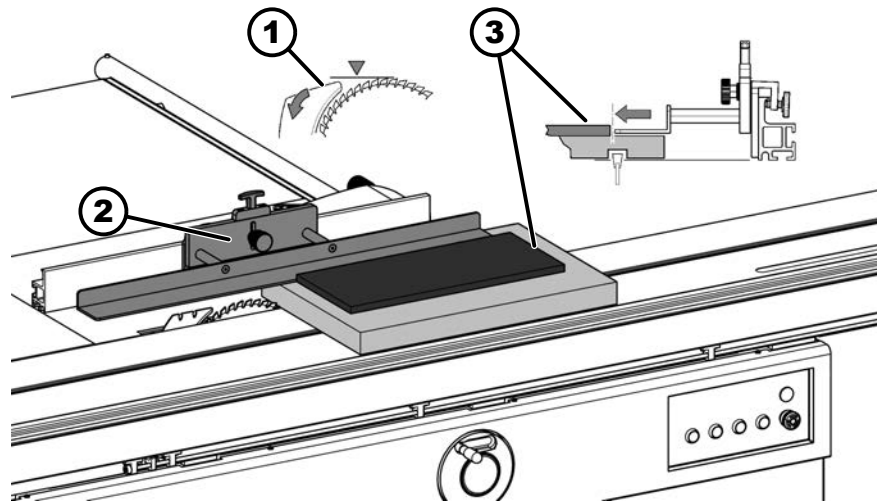


Fig. 87: Covered cut with template

- 1 Adjust the riving knife
- 2 Auxiliary fence "Sägeboy" (accessory)
- 3 Template (mounted to the workpiece)

1. On machines with sliding table:

1. Lock the sliding table into a centre position.
2. Remove the crosscut fence.
 - ➡ A collision with the crosscut fence is prevented for long cuts.

2. Mount the template to the workpiece.

3. Place the workpiece with the template on to the Sägeboy guiding plate.

4. Use a push stick to move small workpieces forward.

Carry out covered cuts with the help of a crosscut fence

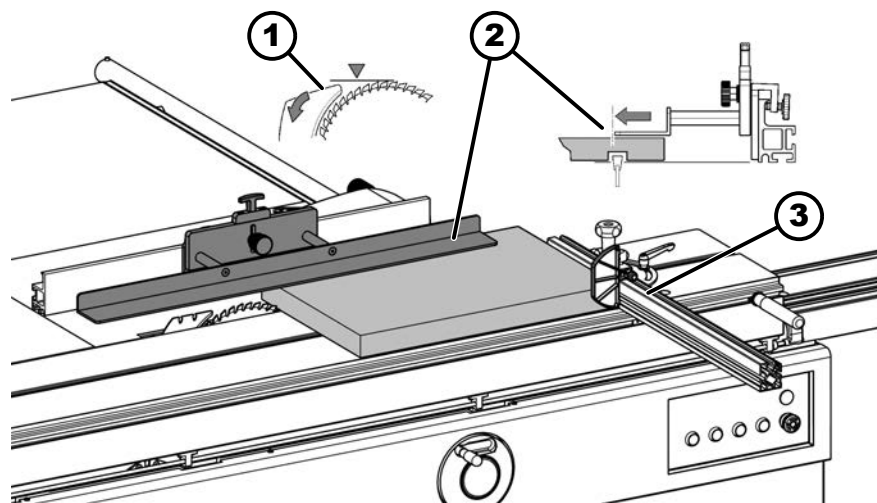


Fig. 88: Covered cuts with crosscut fence

- 1 Adjust the riving knife
- 2 Sägeboy guiding plate
- 3 Crosscut fence

1. On machines with sliding table:

1. Mount the crosscut fence to the sliding table.
2. Release the sliding table catch.

2. Place the workpiece against the crosscut fence.

3. Press the workpiece hard against the crosscut fence using both hands.

- ➡ Never place your hands on the workpiece in the danger zone.

4. Guide the workpiece evenly through the saw blade.

10 Maintenance

10.1 Maintenance plan

The following maintenance work must be performed at the prescribed intervals.

Chap.	Task to execute	Every 8 operating hours	Every 160 operating hours	Monthly	Twice a year	If required	Page
10.4.1	Clean machine thoroughly	X					78
10.4.3	Cleaning the guide tracks (sliding table / base)			X			79
10.4.4	Cleaning / changing the dust brush of the outrigger arm				X		80
10.4.5	Check dust extractor for any damage	X					81
10.4.5	Check the effectiveness of the dust extractor		X				81
10.4.5	Check extraction hose and pipe		X			X	81
10.4.6	Check safety devices (emergency stop)			X			81
10.4.7	Check that the safety device (safety switch) is working properly			X			82
10.4.8	Lubricate the swivel segments and the height adjustment mechanism				X		83
10.4.9	Lubricating the height adjustment spindles				X		84
10.4.10	Lubricating the tilting spindle				X		85
10.5.2	Renewing the sliding table scraper blade (ball cage)					X	87
10.5.4	Align the sliding table ball cage					X	90
10.6.1	Check belt tension and belt condition				X		91

10.2 Preparations for maintenance work / Open the cover

Instructions to maintenance technicians

If the maintenance technician has to check whether they have carried out their work correctly or troubleshoot whilst the machine is running, the following instructions must be followed:

- To ensure quick and unmistakable communication, visual contact between the operators must be kept at all times.
- Operators should repeat and confirm instructions before they are carried out.
- Wait for all the moving parts to come to a standstill.
- Only start the machine when there is no one within the safety zone.
- Maintenance technicians need to be fully aware of how the machine operates and moves, and they must be familiar with the exact operating sequence.
- Keep a record of all maintenance work.

Open/close the covers on the rear of the machine for maintenance purposes

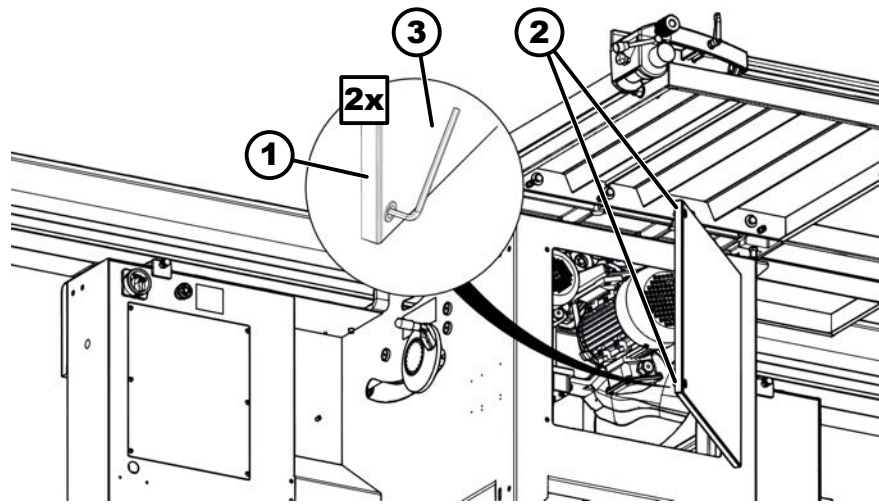


Fig. 89: Open the rear cover

- 1 Cover (rear)
- 2 Socket screws
- 3 Hex key 5 mm

Tool:

- Hex key 5 mm

The cover on the back must be opened for the following maintenance work.

1. ➔ Switch off the machine and secure it from being switched on again.
2. ➔ Disconnect the machine from the mains power supply.
3. ➔ Open the cover at the back:
 1. ➔ Release the hex screws (2x).
 2. ➔ Swing the cover open.
4. ➔ Close the cover again after the maintenance work.
Screw both hexagon socket screws in fully.
➔ The cover rests against the machine frame at the top and bottom.

10.3 Cleaning and lubricating

- Do not use compressed air to clean, as this will blow dust and shavings into the various ball bearings and guides.
- Only use low dust emission vacuum to remove dust deposits.
- Carry out cleaning when required, after each workday or at the very latest after 8 hours of operation.



NOTICE

Caustic or abrasive cleaning detergents

Damage to the surface of the machine

- Never use caustic or abrasive cleaning detergents.



Note

Cleaning and care products are available as accessories (see: Tools and accessories catalogue / Online shop: www.felder-group.com).

10.4 General maintenance procedures

10.4.1 Clean machine thoroughly



CAUTION

Sharp tools

Cutting damage

- Use tools carefully.
- Wear gloves.
- Use safety equipment.

Personnel:

- Trained machine operator

Tool:

- Cleaning cloths
- Vacuum cleaner

1. Switch off the machine and secure it from being switched on again.
2. Clean the machine of dust, shavings, waste material and other contaminants.
3. Cleaning the table surface and the guide tracks. Remove any resin residue.
4. Clean the rip fence, including the guide shaft and overhead saw guard and saw guard, and check that it is functioning correctly.
5. For machines with outrigger table:
Remove any dust, chips and resin residue from the outrigger arm rollers and pipe.
6. Perform a visual inspection of all machine parts.
 - ➔ If any damage is identified on the machine or of the components, then these are to be fixed immediately.

10.4.2 Belt tension**NOTICE****Drive belt tension is too high**

Bearing damage to the saw shaft or motor

- Stop turning the belt-tensioning screw once the drive belt is tensioned sufficiently, enabling it to transmit power effectively.
- Check the drive belt using a frequency measurement device.

The belt tension is factory set to the ideal value.

The drive belt of the scoring unit is spring-tensioned and therefore maintenance-free.

As the drive belt of the circular saw shaft can stretch over time, the power transmission will also decrease. In this case, the drive belt must be retightened. ➔ Chapter 10.6.4 'Retensioning the drive belt' on page 93

10.4.3 Cleaning the guide tracks (sliding table / base)**NOTICE****Sliding table - Do not grease or oil the guides**

Premature sticking / dirtying of the guide tracks.

- Cleaning the guide tracks with Ballistol Universal Oil (Art. No.: 10.2.007).

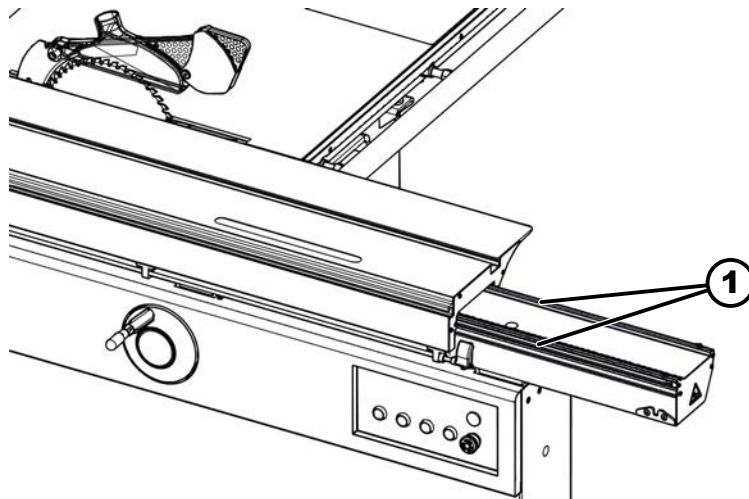


Fig. 90: Cleaning the guide tracks

1 guide tracks

Tool:

- Paper or microfibre cloth

Material:

- Ballistol Universal Oil (Art. No.: 10.2.007)

1. Switch the machine off and ensure that it cannot be switched on again.
2. Move the sliding table all the way to the left.
3. Clean the guiding tracks on the base and the sliding table from any dust and chips. To do this, apply Ballistol Universal Oil (Art. No.: 10.2.007) with paper or a micro-fibre cloth.
 - ➔ Do not wipe the guide surfaces dry.

4. → Move the sliding table all the way to the far right and repeat the process.
5. → Move the sliding table several times to the furthest point in both directions.

10.4.4 Cleaning / changing the dust brush of the outrigger arm

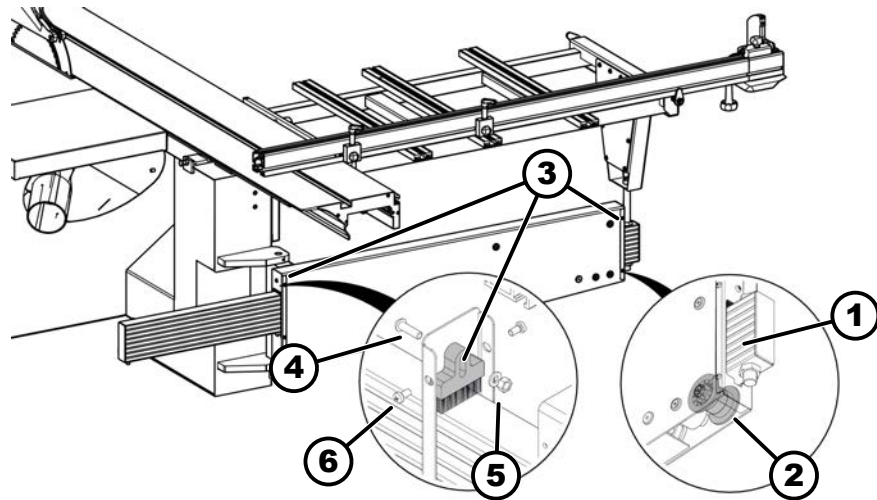


Fig. 91: Outrigger arm dust brush

- 1 Sliding tube
- 2 Roller
- 3 Brush strip
- 4 Screw (brush strip)
- 5 Washers and nut
- 6 Screws (cover)

Clean the sliding tube in the outrigger arm

Tool:

- Paper or microfibre cloth

1. → Thoroughly clean the rollers and the sliding tube.
2. → Clean the dust brush and check if in good condition.
3. → Adjust or renew the dust brush if the outer slider is no longer cleaned.

Adjusting or exchanging the brush strip:

Tool:

- Hex key 4 mm
- Ring spanner 10 mm
- Phillips head screwdriver

1. → Loosen the screws (4) and slide the cover to one side.
2. → Loosen the screw on the brush holder.
3. → Exchange the brush strip (if necessary):
 1. → Loosen and remove the screw on the brush holder.
 2. → Fit the new brush strip using a screw, serrated washers and nut.
4. → Adjust the dust brush:
 1. → Set the dust brush as low as required so as to clean the outer slider once again.
 2. → Tighten the screw.
5. → Refit the cover.

OK

- The brush strip makes even contact across the entire width of the sliding tube.
- Chips and dust are cleaned off the sliding tube by the brush.

NOK

- The brush strip is not straight or is set too high.
 - Chips and dust are not scraped off the sliding tube.
- Readjust the position of the brush strip.

10.4.5 Check dust extractor

Check dust extractor for any damage

1. → Switch off the machine and extraction systems.
2. → Carry out a visual inspection of all suction hoses, extraction pipes and connecting parts.
3. → Check that the entire dust extractor is in perfect condition.
4. → For machines with effectively connected potential-free contact to the extraction system control:
 1. → Switch machine on.
 2. → Check whether the dust extractor starts up with the machine.
5. → On machines without extraction system control:
 1. → Switch on the dust extractor.
 2. → Switch machine on.
6. → Perform a visual inspection of all machine parts.
 - ➔ If any damage is identified on the machine or of the components, then these are to be fixed immediately.

Check the effectiveness of the dust extractor

1. → Measure air flow and air speed.
2. → The extraction performance must be sufficient to achieve the negative pressure and air speed required at the connection point (see technical data or layout).

Check extraction hose and pipe

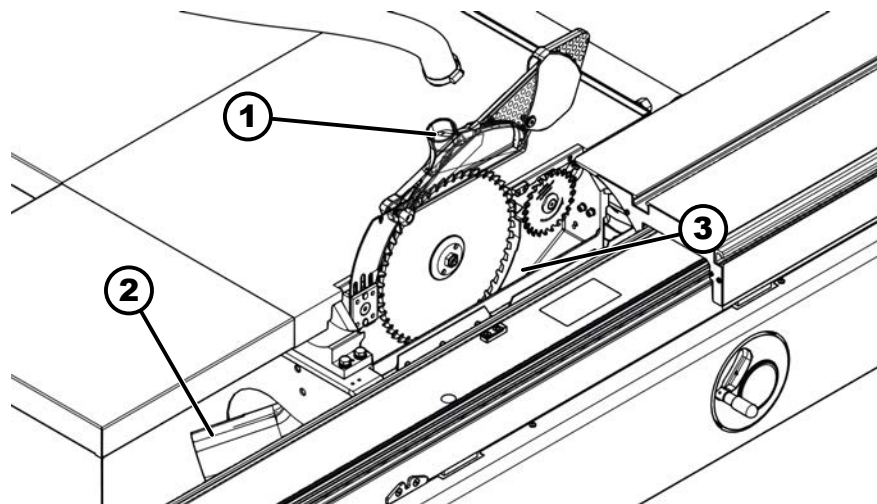


Fig. 92: Clean the extraction

- 1 Extraction connection (saw guard)
- 2 Extraction connection (saw unit)
- 3 Extraction funnel

1. → Preparing the machine for a tool change. ➔ Chapter 8.8.2 'Prepare to change tooling' on page 57
2. → Remove the dust extraction hose from the extraction connector.
3. → Remove any chips, dust and material cuttings from the extraction hose and extraction funnel.
4. → Attach the extraction hose to the extraction connection.
5. → Prepare the machine for operation. ➔ Chapter 8.8.3 'Prepare the machine for operation' on page 57

10.4.6 Check safety devices (emergency stop)

Safety devices [emergency stop] buttons must be checked monthly.

The following also applies to machinery bearing the CE mark:

The saw shaft with a tool clamped and fitted, must come to a standstill within 10 seconds.

Check the emergency stop

Carry out emergency stop test with all red [Emergency stop] buttons on the machine.

1. → Prepare the machine for operation.
2. → Switch the machine on and briefly let it run.

3. → Push the *[Emergency stop]*.

OK

Machine stops immediately.

→ Continue with next step.

NOK

Machine does not stop immediately.

1. → If present: Switch off *[Main switch]* (position "O" / "OFF").**2.** → Disconnect the machine from the mains power supply.**3.** → Contact Felder Group service centre.

4. → Switch the machine on using the green *[start]* button with the *[emergency stop]* button locked.

OK

Machine does not start.

1. → Unlock the *[emergency stop]* actuator by turning it.**2.** → Repeat with all *[Emergency Stop]* buttons on the machine.

NOK

Machine can be started.

1. → Press the red *[stop]* button.**2.** → If available: Turn the *[main switch]* off (position "O" / "OFF") and secure it.**3.** → Contact Felder Group service centre.

Check the time it takes for the machine to come to a stop

Configuration of the machine with a DC motor brake:

The machine is equipped with an automatic brake. The brake is a maintenance-free DC brake. All necessary adjustments are done in the factory.

Configuration of the machine without a motor brake:

The machine is not equipped with a motor brake. After the machine has been switched off, the saw shaft continues to run to a halt without braking.

Required only for machines bearing the CE mark.

1. → Prepare the machine for operation.**2.** → Switch the machine on and briefly let it run.**3.** → Switch machine off with the red *[Stop]* button.

The saw shaft must come to a standstill within 10 seconds with the tools clamped.

OK

Machine comes to a standstill within 10 seconds.

→ Checking the time for the machine to come to a stop completed.

NOK

Machine takes longer than 10 seconds to come to a standstill.

1. → If present: Switch off *[Main switch]* (position "O" / "OFF").**2.** → Disconnect the machine from the mains power supply.**3.** → Contact Felder Group service centre.

➡ The time in which the machine requires to come to a standstill is checked.

10.4.7 Check that the safety device (safety switch) is working properly

Safety devices (safety switches) must be checked monthly. The machine can only be started if the limit switch inside the machine is not actuated by the locking device. The hinged cover must be closed.

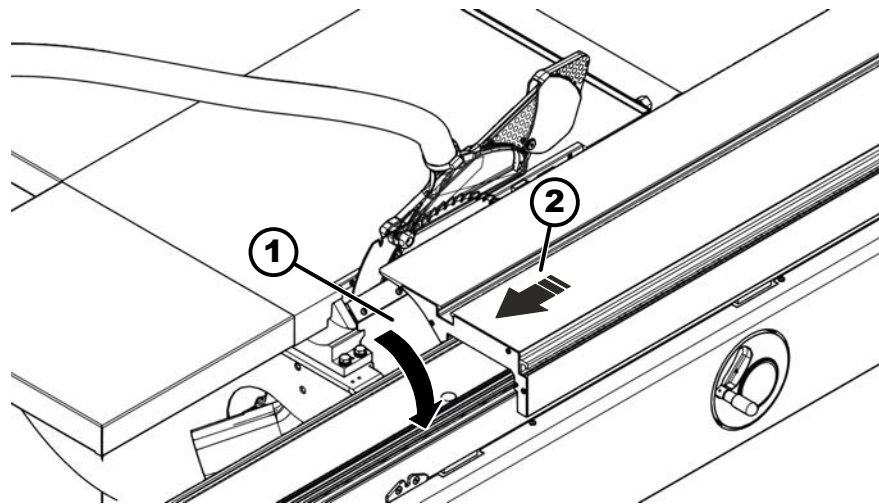


Fig. 93: Check limit switch hinged cover

- 1 Hinged cover
- 2 Move the sliding table to the left

Check limit switch hinged cover for functions

1. → Place the saw blade in the lowest position.
2. → Switch off the machine and secure it from being switched on again.
3. → Pull the hinged cover to the front. → Chapter 8.8.2 'Prepare to change tooling' on page 57
4. → Push the sliding table to the left so that the saw blade is covered.
5. → Press the green [Start]-button on the control panel.



Machine does not start.

→ Prepare the machine for operation. → Chapter 8.8.3 'Prepare the machine for operation' on page 57



Machine can be started.

1. → Press the red [stop] button.
2. → Switch off [Main switch](position "O" / "OFF") and lock.
3. → Contact Felder Group service centre.

➔ The safety switch has been tested.

10.4.8 Lubricate the swivel segments and the height adjustment mechanism

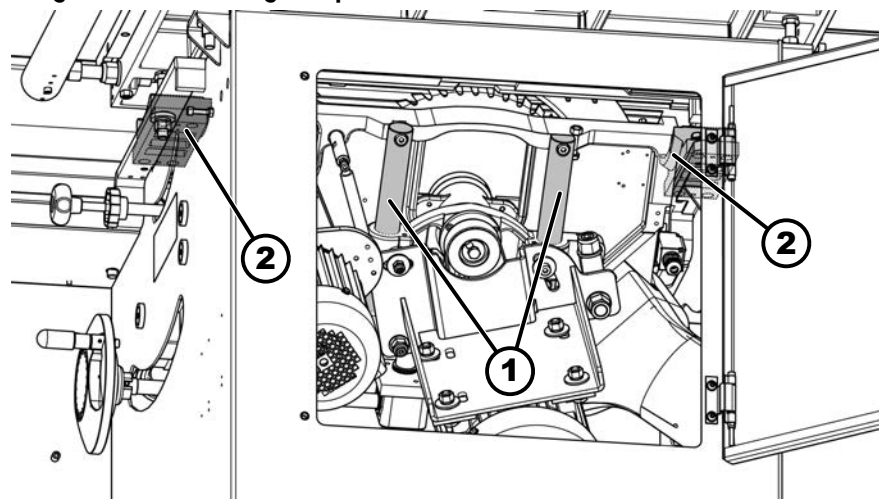


Fig. 94: Height guide and tilt segments

- 1 Height guide
- 2 Swivel segment

Tool:

- Brush

Material:

- Machine Grease
- Machine oil

1. → Switch off the machine and secure it from being switched on again.
2. → Remove the saw guard.

3. ➤ Set the saw unit to the 45° position and move it all the way down.
4. ➤ Disconnect the machine from the mains power supply.
5. ➤ Open the cover at the back. ➡ Chapter 10.2 'Preparations for maintenance work / Open the cover' on page 77
6. ➤ Thoroughly clean the height guide and tilt segments from chips, dust and grease residues.
7. ➤ Lightly lubricate the height guide with standard machine grease or machine oil.
8. ➤ Lubricate both tilt segments with a few drops of machine oil each.
9. ➤ Move the saw unit to the lowest position and then back to the highest position.
10. ➤ Close the cover at the back again.
Screw both hexagon socket screws in fully.
➡ The cover rests against the machine frame at the top and bottom.

10.4.9 Lubricating the height adjustment spindles

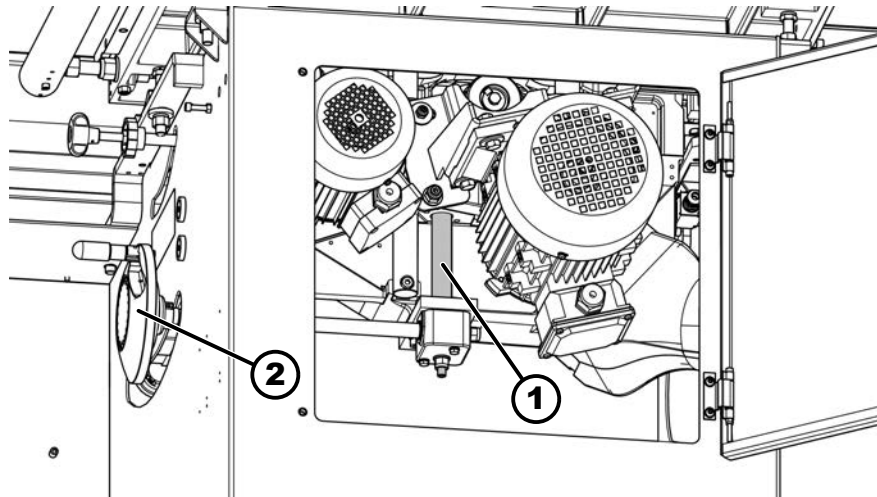


Fig. 95: Lubricate the spindle

- 1 Height spindle
2 Hand wheel - circular saw height adjustment

Tool:

- Brush

Material:

- Machine Grease

1. ➤ Switch off the machine and secure it from being switched on again.
2. ➤ Remove the saw guard.
3. ➤ Set the circular saw unit to the 90° position and all the way to the top.
4. ➤ Disconnect the machine from the mains power supply.
5. ➤ Open the cover at the back. ➡ Chapter 10.2 'Preparations for maintenance work / Open the cover' on page 77
6. ➤ Thoroughly clean the height spindle of any chips, dust and grease residue.
7. ➤ Lubricate the height spindle with standard machine grease using a brush.
8. ➤ Move the saw unit to the lowest position and then back to the highest position.
9. ➤ Close the cover at the back again.
Screw both hexagon socket screws in fully.
➡ The cover rests against the machine frame at the top and bottom.

10.4.10 Lubricating the tilting spindle

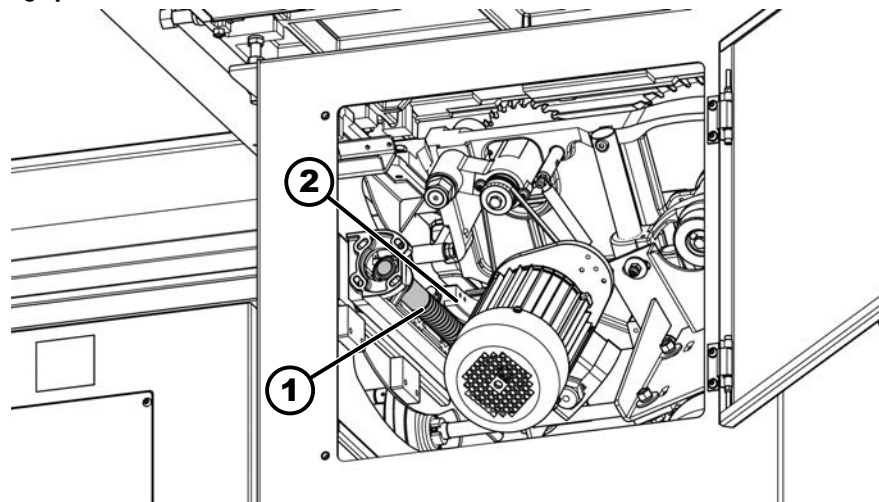


Fig. 96: Lubricating the tilting spindle

- 1 tilting spindle
- 2 Gear rack (angle adjustment)

Tool:

- Brush

Material:

- Machine Grease

1. ➔ Switch off the machine and secure it from being switched on again.
2. ➔ Remove the saw guard.
3. ➔ Set the saw unit to the 45° position and move it all the way down.
4. ➔ Disconnect the machine from the mains power supply.
5. ➔ Open the cover at the back. ➔ Chapter 10.2 'Preparations for maintenance work / Open the cover' on page 77
6. ➔ Thoroughly clean the tilting spindle and gear rack of any chips, dust and grease residue.
7. ➔ Lubricate the tilting spindle with standard machine grease using a brush.
8. ➔ Tilt the saw unit to the 90° position and then back to the 45° position.
9. ➔ Close the cover at the back again.
Screw both hexagon socket screws in fully.
➔ The cover rests against the machine frame at the top and bottom.

10.5 Renewing the sliding table scraper (roller cage)

10.5.1 Dismantling the sliding table



Note

Two to three additional helpers, depending on the cutting length, are required for removal and reassembly.

The following work is intended for people who have a very good technical knowledge. We recommend this work to be performed by Felder Group service.

Preparing the machine to remove the sliding table

1. ➔ Switch off the machine and secure it from being switched on again.
2. ➔ If present, remove any fitted accessories from the sliding table.
 1. ➔ Remove the crosscut stop from the sliding table.
 2. ➔ Removing the outrigger table.
➔ Chapter 8.3 'Mounting/removing the outrigger table' on page 48

Prepare the base ready to remove the sliding table

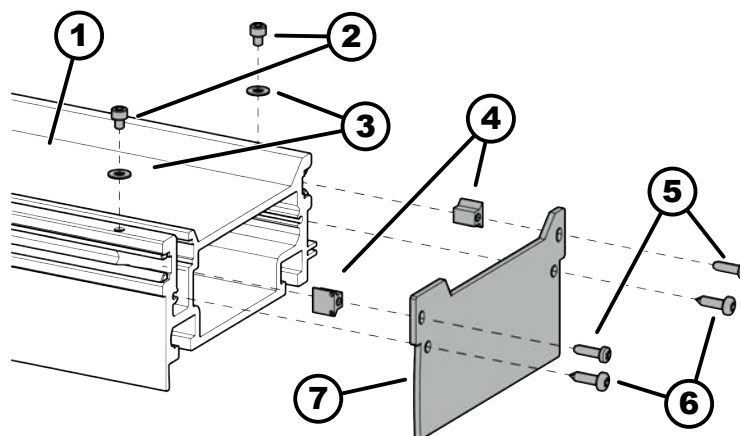


Fig. 97: Base track cover

- 1 Base track
- 2 Socket screws
- 3 Washers
- 4 Clamping jaws
- 5 PT screws (4.0x14)
- 6 Fillister head screws (4.2x16)
- 7 Base track cover

Tool:

- Hexagon socket screwdriver
- Hex key

On that side of the base, from which the sliding table should be removed:

1. ➔ Remove the hexagon socket screws and washers.
2. ➔ Loosen the PT screws and remove the clamping jaws.
3. ➔ Loosen the fillister head screws and the base cover.

Preparing the sliding table for dismantling

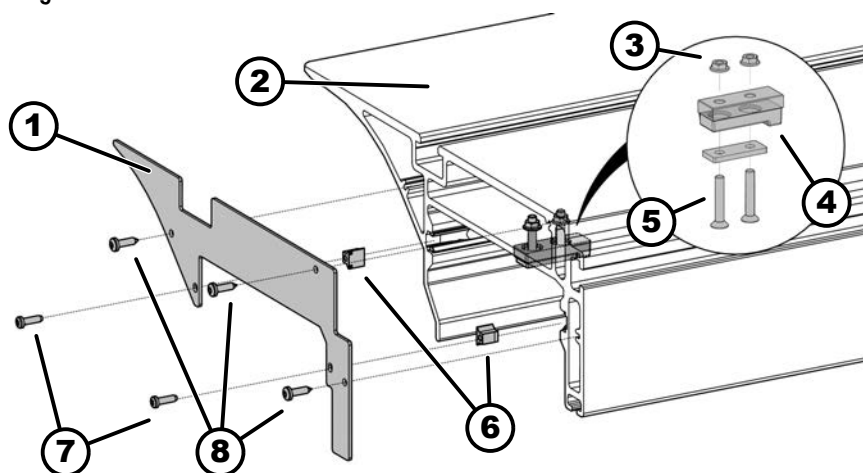


Fig. 98: Sliding table cover and stop blocks

- 1 Sliding table cover
- 2 Sliding table
- 3 Hexagon nut
- 4 Stop blocks (note the installation position)
- 5 Countersunk screw
- 6 Clamping jaws
- 7 PT screws (4.0x14)
- 8 Fillister head screws (4.2x16)

Tool:

- Hexagon socket screwdriver
- Hex key
- Ring spanner

Remove the sliding table cover on the opposite side of the removed base track cover:

1. ➔ Loosen the PT screws and remove the clamping jaws.

2. ➔ Loosen the fillister head screws and remove the sliding table cover.
3. ➔ Hold the hexagon nut in place and loosen the flat head screw.
4. ➔ Remove the hex nut, countersunk screw and stop blocks.

Pull the sliding table from the base

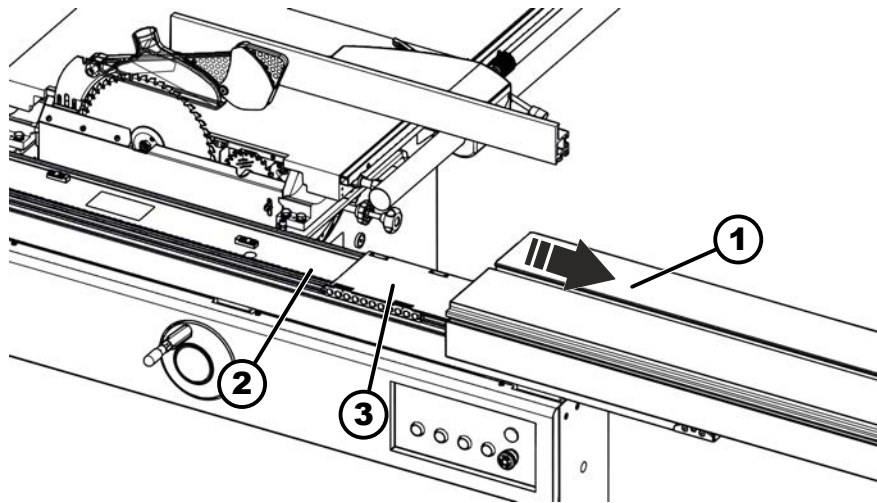


Fig. 99: Dismantling the sliding table

- 1 Sliding table
- 2 Base track
- 3 Ball cage



WARNING

Dropping the sliding table when dismantling from the machine

Serious injury due to its high weight.

- Depending on the cutting length, at least two additional helpers are required for safe installation.

On that side of the base, from which the sliding table should be removed:

1. ➔ Slowly pull the sliding table from the base.
Do not tilt the sliding table, support it from below with help from others.
2. ➔ Hold the ball cage by the base track and secure it against falling.

10.5.2 Renewing the sliding table scraper blade (ball cage)



Note

The scrapers on the ball cages are subject to a certain amount of wear. If the scrapers no longer function properly, they must be exchanged.

To do this, the sliding table must be removed from the machine. ➔ Chapter 10.5.1 'Dismantling the sliding table' on page 85

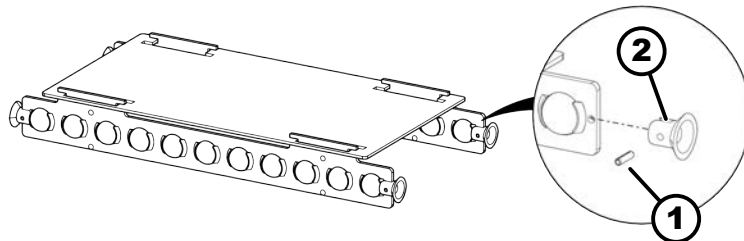


Fig. 100: Ball cage - scraper

- 1 bolts
- 2 scraper

Tool:

- Counterpunch (splint driver) - 1.5 mm
- Pliers

1. ➔ Switch off the machine and secure it from being switched on again.
2. ➔ Disassemble the sliding table.
3. ➔ Remove the wheel bolts and worn scrapers.

4. → Mount the new scrapers and tighten with the wheel bolts.
5. → Mounting the sliding table.

10.5.3 Mounting the sliding table

Place the cage plate with the ball cages on the base track

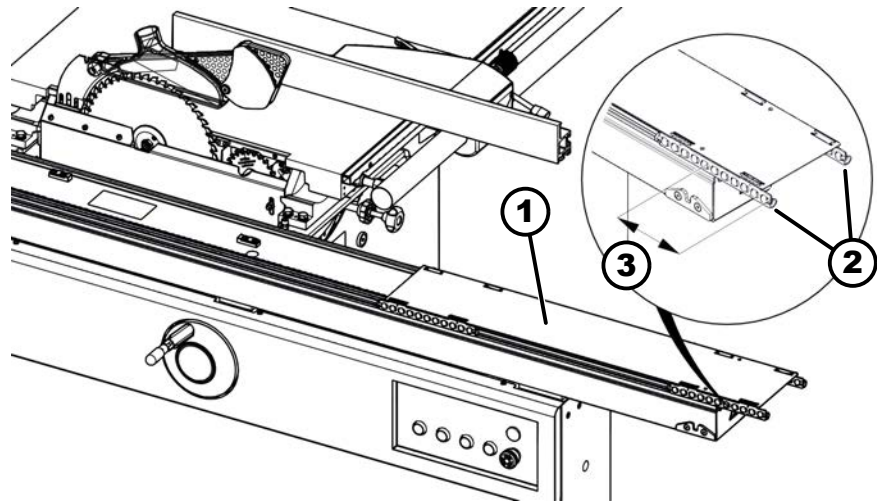


Fig. 101: Ball cage base

- 1 Cage plate
- 2 Ball cages
- 3 Half on the base track

1. → Ensure that the ball cage scrapers sit tightly.
2. → Ensure that there are no balls missing in the ball cages.
3. → Slide the first half of the cage plate with the ball cages on to the guides of the base.

Slide the sliding table completely onto the base

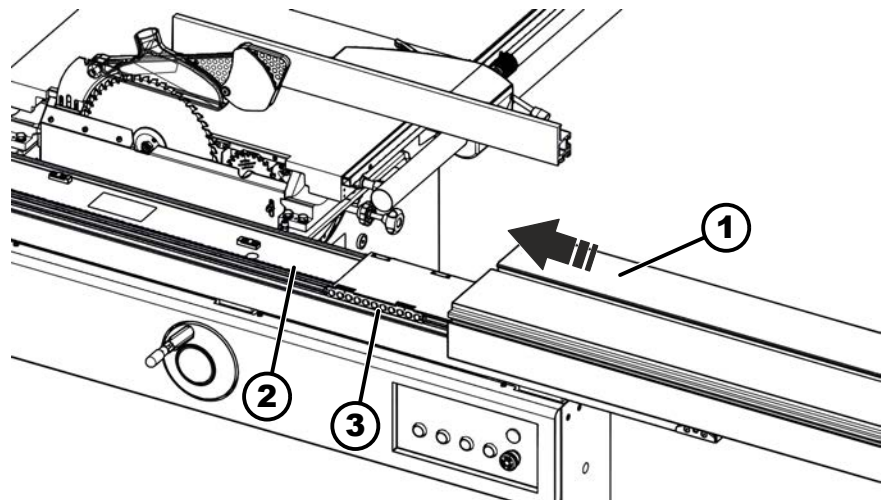


Fig. 102: Mounting the sliding table

- 1 Sliding table
- 2 Base track
- 3 Ball cage

1. → Thread the sliding table onto the ball cages.
2. → Slide the sliding table a few centimetres over the guidings of the base.
3. → Push the sliding table further onto the base; make sure that the following ball cages are threaded cleanly between the base and the sliding table.
4. → Slide the sliding table completely onto the base.

Fitting the base track cover and sliding table cover

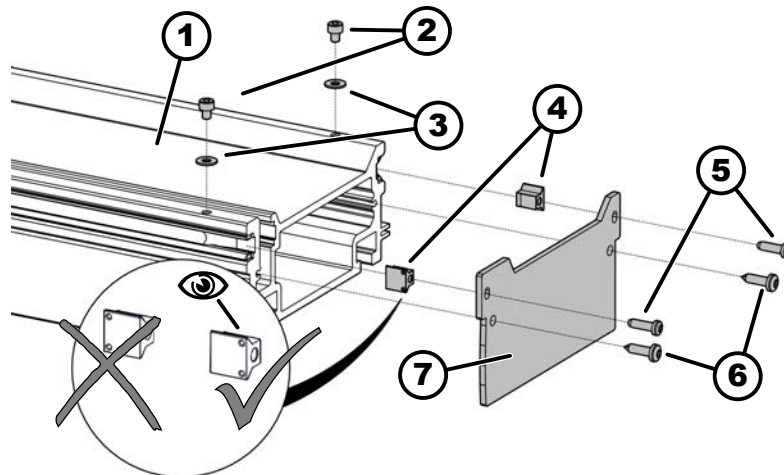


Fig. 103: Base track cover

- 1 Base track
- 2 Socket screws
- 3 Washers
- 4 Clamping jaws
- 5 PT screws (4.0x14)
- 6 Fillister head screws (4.2x16)
- 7 Base track cover

Tool:

- Hexagon socket screwdriver
- Hex key

On the base:

1. → Screw in the hexagon socket screw with the washers.
2. → Screw the base cover on with fillister head screws.
3. → Insert the clamping jaws. Ensure correct installation position: The two points must face outwards.
4. → Screw the PT screws into the clamping jaws.

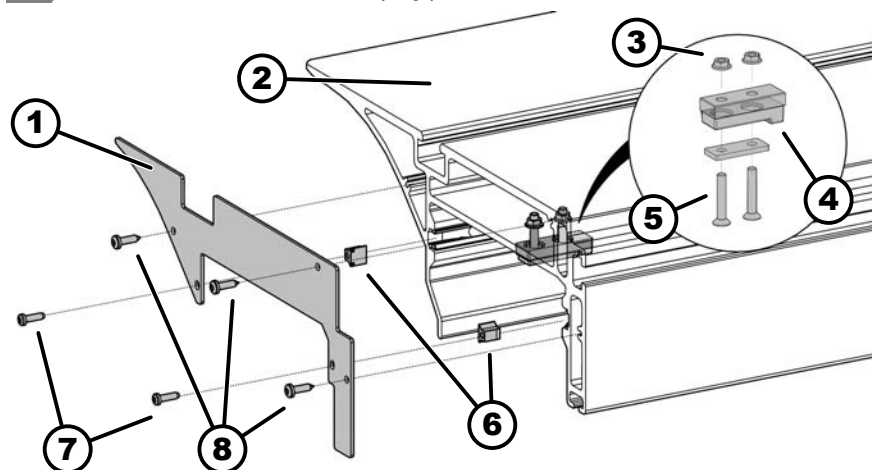


Fig. 104: Sliding table cover and stop blocks

- 1 Sliding table cover
- 2 Sliding table
- 3 Hexagon nut
- 4 Stop blocks (note the installation position)
- 5 Countersunk screw
- 6 Clamping jaws
- 7 PT screws (4.0x14)
- 8 Fillister head screws (4.2x16)

Tool:

- Hexagon socket screwdriver
- Hex key
- Ring spanner

On the opposite side on the sliding table:

1. → Screw on the clamping jaws using a countersunk screw and a hex nut.
Ensure it is fitted in the correct position: the thick side of the rubber stop must face towards the centre of the sliding table.
2. → Screw the sliding table cover on with fillister head screws.
3. → Insert the clamping jaws. Ensure correct installation position: The two points must face outwards.
4. → Screw the PT screws into the clamping jaws.

10.5.4 Align the sliding table ball cage

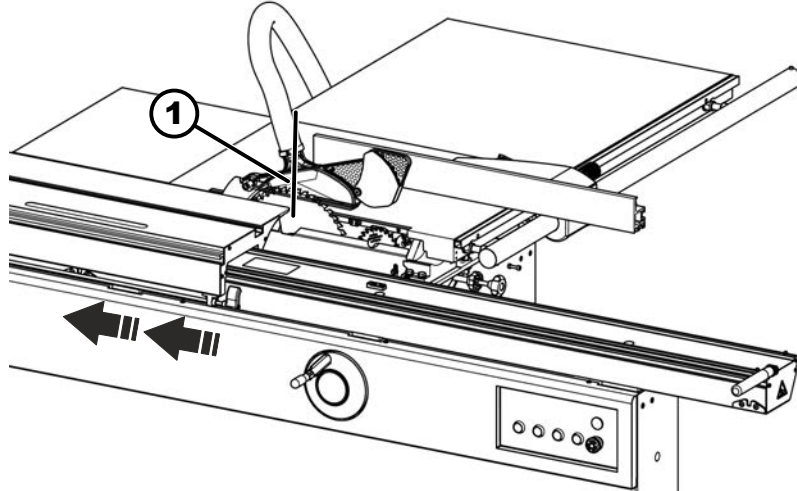


Fig. 105: Align the sliding table ball cage

1 Centre saw blade



Note

The ball cage will, over time, run untrue due to small sliding table strokes between the sliding table and the base.

The full cutting length will as such, not be achieved.

The cage plate with the rolling cages must be correctly positioned after assembly.

1. → Move the sliding table past the resistance to the end position and up to the stop.
2. → Then push the sliding table quickly to the right until it reaches the reference stop.
➡ The cage plate with the ball cages will now be correctly positioned.
3. → Push the sliding table back to the left until it reaches the end stop.

OK

The end edge of the sliding table extends at least to the centre of the saw blade.

NOK

The required cutting length is not achieved.

→ Align the sliding table roller cages again.

10.6 Checking/changing the circular saw drive belt

10.6.1 Check belt tension and belt condition

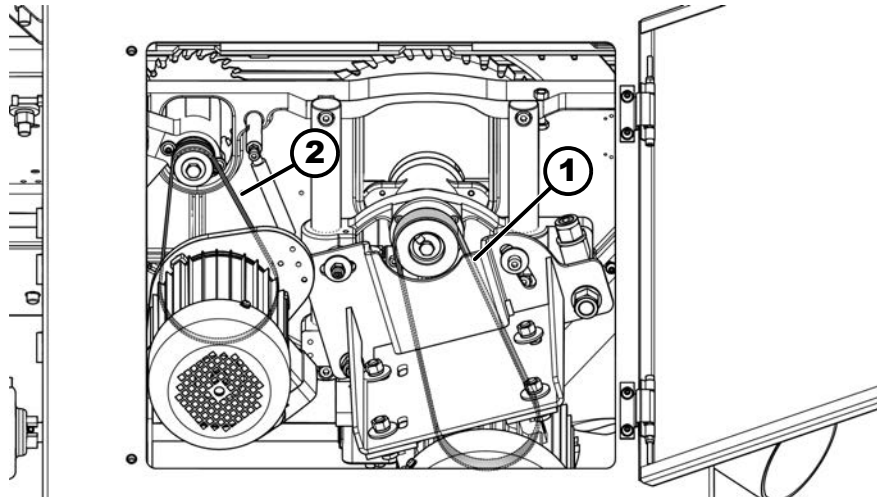


Fig. 106: Check the drive belt

- 1 Drive belt for the saw shaft (frequency 140–160 Hz)
 - 2 Drive belt for the scoring unit (spring-tensioned)
 - The belt tension is factory set to the ideal value.
 - The belt tension is specified as an oscillation frequency in hertz (Hz).
 - The correct belt tension can only be checked with a measuring device.
1. → Switch off the machine and secure it from being switched on again.
 2. → Remove the saw guard.
 3. → Set the saw unit to the 45° position and move it all the way down.
 4. → Disconnect the machine from the mains power supply.
 5. → Open the cover at the back. ➔ Chapter 10.2 'Preparations for maintenance work / Open the cover' on page 77
 6. → Check the condition of the entire belt with a few manual turns.

OK

No damage, cracks or lateral tears.
→ Continue with next step.

NOK

Cracks on the back of the belt, lateral tears or brittle areas.
→ Replace the drive belt. ➔ Chapter 10.6.2 'Replace the drive belt' on page 92
 7. → Check the belt tension with a measuring device.

OK

Drive belt tension 140 - 160 Hz

NOK

Vibration frequency in Hertz (Hz) is not within the specified range.
→ Re-tensioning the drive belt. ➔ Chapter 10.6.4 'Re-tensioning the drive belt' on page 93
 8. → Close the cover at the back again.
Screw both hexagon socket screws in fully.
 - ➔ The cover rests against the machine frame at the top and bottom.

10.6.2 Replace the drive belt

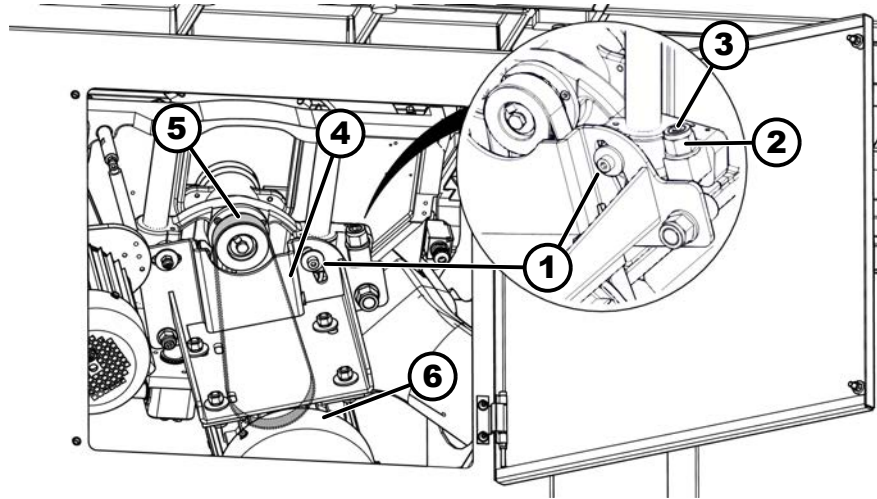


Fig. 107: Replace the drive belt

- 1 Clamping screws
- 2 Lock nut
- 3 Belt-tensioning screw
- 4 Drive belt (tension 140 - 160 Hz)
- 5 Saw spindle
- 6 Drive motor

Tool:

- Hex key 6 mm
- Hex key 8 mm
- Ring spanner 24 mm

1. → Preparations for maintenance work on the machine.
2. → Remove the saw guard.
3. → Set the saw unit to the 45° position and move it all the way down.
4. → Slacken the old drive belt and remove:
 1. → Loosen the clamping screw.
 2. → Hold the lock nut in place.
 3. → Loosen the belt-tensioning screw.
5. → Hook the new drive belt into place:
 1. → First hook onto the saw shaft.
 2. → Pull the drive motor upwards.
 3. → Hook the drive belt on the drive motor.
6. → Ensure that the belt is seated properly by carrying out a couple of manual turns.
7. → Tension drive belt. → Chapter 10.6.4 'Re-tensioning the drive belt' on page 93.

10.6.3 Replacing the scoring belt

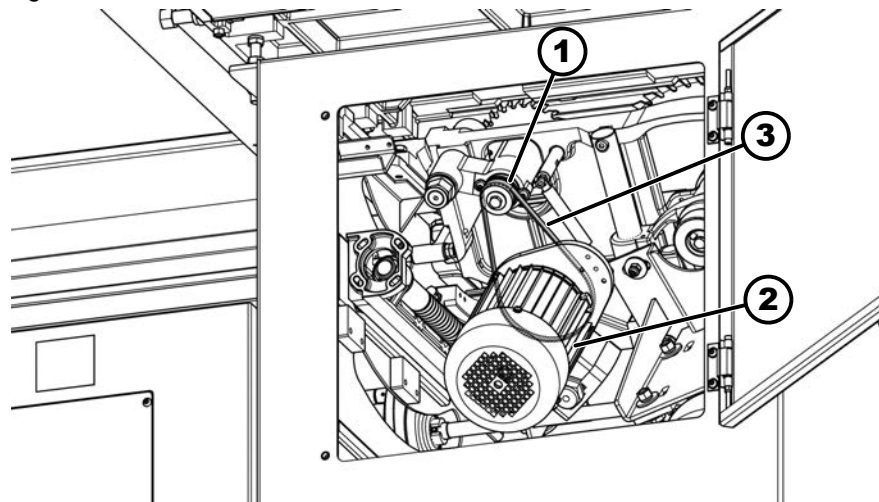


Fig. 108: Replacing the scoring belt

- 1 Saw spindle
- 2 Drive motor
- 3 Drive belt for the scoring unit (spring-tensioned)

1. → Preparations for maintenance work on the machine.
2. → Remove the saw guard.
3. → Set the saw unit to the 45° position and move it all the way down.
4. → Pull the drive motor upwards.
5. → Remove the old drive belt.
6. → Hook the new drive belt into place:
 1. → First hook onto the saw shaft.
 2. → Pull the drive motor upwards.
 3. → Hook the drive belt on the drive motor.
7. → Ensure that the belt is seated properly by carrying out a couple of manual turns.
8. → The drive belt is spring-tensioned and does not need to be retensioned.
9. → Close the cover at the back again.
Screw both hexagon socket screws in fully.
➡ The cover rests against the machine frame at the top and bottom.

10.6.4 Re-tensioning the drive belt

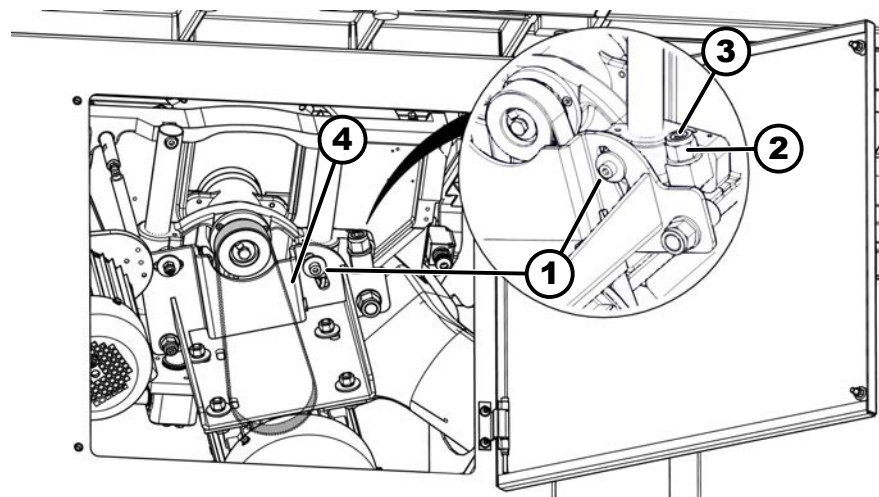


Fig. 109: Replace the drive belt

- 1 Clamping screws
- 2 Lock nut
- 3 Belt-tensioning screw
- 4 Drive belt (tension 140 - 160 Hz)

**NOTICE****Drive belt tension is too high**

Bearing damage to the saw shaft or motor

- Stop turning the belt-tensioning screw once the drive belt is tensioned sufficiently, enabling it to transmit power effectively.
- Check the drive belt using a frequency measurement device.

Tool:

- Hex key 6 mm
- Hex key 8 mm
- Ring spanner 24 mm

- 1.** → Preparations for maintenance work on the machine.
- 2.** → Remove the saw guard.
- 3.** → Set the saw unit to the 45° position and move it all the way down.
- 4.** → Tension the drive belt with the belt tensioning screw.

- 1.** → Loosen the clamping screw.
- 2.** → Hold the lock nut in place.
- 3.** → Tighten belt-tensioning screw.
- 4.** → Tighten the clamping screw.

- 5.** → Close the cover at the back again.
Screw both hexagon socket screws in fully.
➡ The cover rests against the machine frame at the top and bottom.

11 Troubleshooting

11.1 What to do in the event of malfunction



WARNING

Improper troubleshooting

Severe injuries and damage to property

- Troubleshooting may only be carried out by authorised, trained personnel who are familiar with how to operate the machine and are in strict observance of all safety instructions.

Report faults and errors on the machine, including separating safety devices and tools, as soon as they are detected.

In the event of faults involving immediate danger to persons, property or operational safety:

1. → Stop the machine immediately pressing either the *[Emergency Stop]* or the red *[Stop]* button.
2. → Disconnect the machine from the mains and ensure it cannot be switched on again.
3. → Contact Felder Group service centre and solve the fault.

11.2 What to do after rectifying the fault

1. → Check, whether the malfunction and cause of the malfunction have been professionally remedied.
2. → Check, whether all safety equipment has been installed in accordance with regulations and are technically and functionally in perfect condition.
3. → Ensure whether, there are no individuals located within the danger area of the machine.

11.3 Faults, causes and repairs

The following examples highlight possible undesired conditions of the machine. This list makes no claim to completeness.

This information is designed to help operators recognise faults when operating the machine and to rectify them.

Fault on the machine - saw unit

Fault description	Cause	Remedy
The <i>[Emergency stop]</i> button will not stop the machine immediately.	Fault in the electrical system / <i>[Emergency stop]</i> - command chain.	1. → Switch off <i>[Main switch]</i>(position "O" / "OFF"). 2. → Disconnect the machine from the mains power supply. 3. → Contact Felder Group service centre.
Machine can be started despite the <i>[emergency stop]</i> being activated.	<i>[Emergency stop]</i> button faulty.	1. → Press the red <i>[stop]</i> button. 2. → Switch off <i>[Main switch]</i>(position "O" / "OFF") and lock. 3. → Contact Felder Group service centre.
The red <i>[Stop]</i> button will not stop the machine immediately.	Fault in the electrical system.	1. → If present: Switch off <i>[Main switch]</i> (position "O" / "OFF"). 2. → Disconnect the machine from the mains power supply. 3. → Contact Felder Group service centre.
Safety switch without function.	Fault in the electrical system.	1. → If present: Switch off <i>[Main switch]</i> (position "O" / "OFF"). 2. → Disconnect the machine from the mains power supply. 3. → Contact Felder Group service centre.
Machine cannot be switched off.	Fault in the electrical system / <i>[Emergency stop]</i> - command chain.	1. → Switch off <i>[Main switch]</i>(position "O" / "OFF"). 2. → Disconnect the machine from the mains power supply. 3. → Contact Felder Group service centre.
Machine is not functioning.	<i>[Main switch]</i> is off (position "O" / "OFF").	→ Switch on the main switch(position "I" / "ON").

Fault description	Cause	Remedy
Machine is not functioning.	Error in the electrical connection.	→ Check the electrical connection (power cable, fuses).
Circular saw shaft doesn't start.	[Emergency stop] is pressed.	→ Unlock the [emergency stop] actuator by turning it.
	Hinged cover open / limit switch actuated.	→ Prepare the machine for operation.
	[Motor safety switch] has been triggered.	1. → Switch off the main switch and allow the motor to cool down. 2. → Restart the machine.
The motor is running but the saw blade is not rotating.	The drive belt is torn.	→ Replace the drive belt.
The belts squeal when switched on or started.	The belt tension is too slack.	→ Check belt tension, retighten if necessary.
	The drive belt is worn out.	→ Replace the drive belt.
Saw blade does not come to a stop within 10 seconds.	Fault in the electrical system / brake.	→ Contact Felder Group service centre.

Fault on the machine - mechanical

Fault description	Cause	Remedy
Height of rip fence above the machine table not correct.	The height adjustment is misadjusted.	→ Adjust the height of the fence plate.
Angle of rip fence not correct.	The angle adjustment is misadjusted.	→ Adjust / correct the angle of the parallel fence.
0° - angle crosscut fence not correct.	The angle adjustment is misadjusted.	1. → Correct the 0° angle on the crosscut fence. 2. → Check the setting by making a 5-sided sample cut.
Unsatisfactory cuts.	Saw blade is blunt or incorrectly selected for the workpiece.	→ Changing the saw blade.
	Cutting height is set too high.	→ Only set the cutting height to the height actually required.
The full cutting length of the sliding table is not achieved.	The sliding table roller cages are misaligned.	→ Align the sliding table ball cage.
The outrigger table/outrigger arm are not moving smoothly.	Dirt and deposits on the sliding tube.	→ Thoroughly clean the rollers and the sliding tube.

11.4 Adjust the height of the rip fence above the machine table

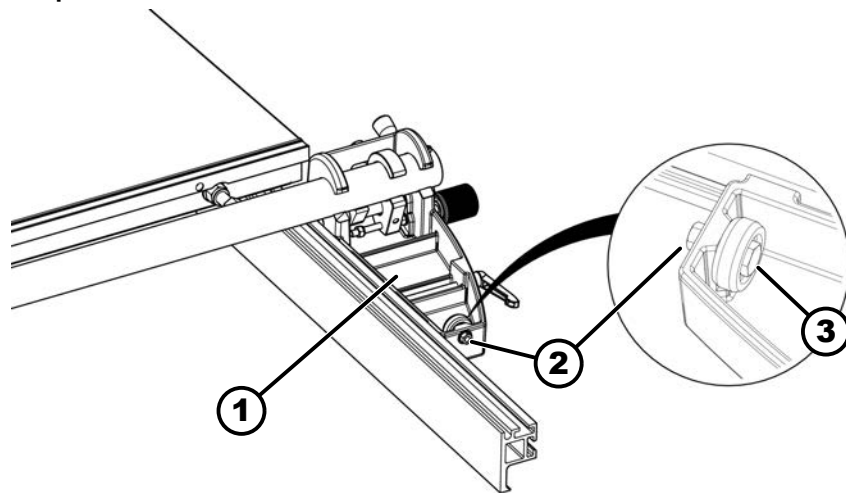


Fig. 110: Readjusting the rip fence height

- 1 Rip fence
- 2 Lock nut
- 3 Eccentric adjustment screw

Tool:

- Ring spanner 13 mm
- Ring spanner 16 mm

The fence plate should be parallel to the machine table. This setting is important when working with the "Sägeboy" auxiliary fence on the rip fence.

1. ➔ Switch off the machine and secure it from being switched on again.
2. ➔ Move the rip fence to the end of the bar and outwards.
3. ➔ Secure the eccentric adjustment screw against rotation using a combination spanner.
4. ➔ Loosen locking nut.
5. ➔ Adjust the height of the fence with the eccentric adjustment screws.
6. ➔ Tighten the lock nut again.
7. ➔ Swing the rip fence to the rear.
8. ➔ Check the height setting.

OK

Fence plate with an even distance parallel to the machine table.

NOK

Fence plate not parallel to the machine table.

➔ Adjust the height of the rip fence with the adjustment screw.

11.5 Readjust the rip fence fine adjustment

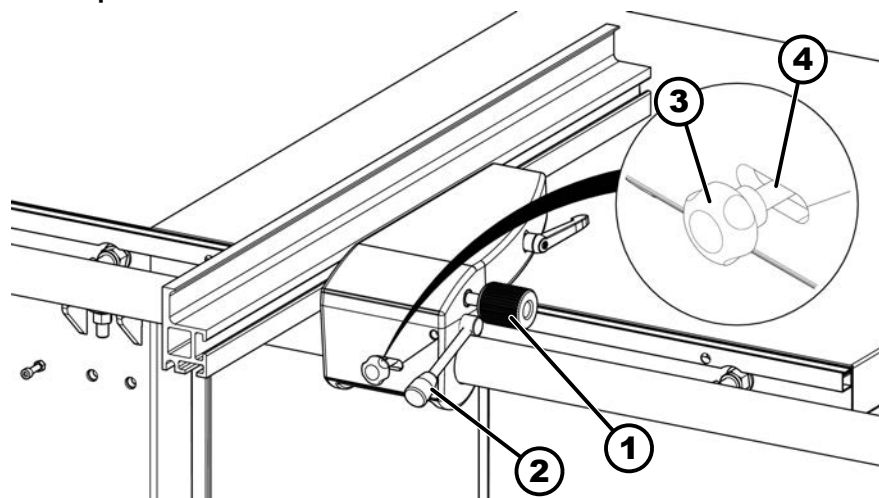


Fig. 111: Rip fence fine adjustment

- 1 Knurled handle
- 2 Clamping lever
- 3 Thumb screws
- 4 Threaded rod / slotted hole

1. ➔ Switch off the machine.

2. ➔ Tighten the thumb screw.
3. ➔ Loosen the clamping lever.
4. ➔ Turn the knurled handle until the threaded rod is located in the centre of the mortise.
5. ➔ Lock the clamping lever.
6. ➔ Loosen the thumb screw.

11.6 Correcting the rip fence angle (adjust free cut)

The angle between the fence plate and the machine table or saw blade cutting line is also called the free cut.

A correctly adjusted clearance cut is important so that the workpiece is not burnt or damaged by the rising part of the saw blade during rip cutting.

If the free cut is set correctly, very little dust will be produced during processing.

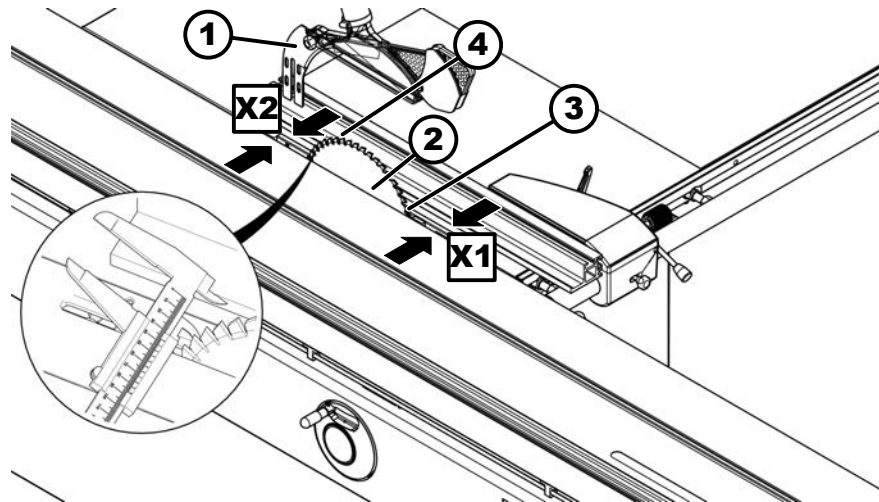


Fig. 112: Free cut preparation

- 1 Riving knife and saw guard
- 2 Saw blade ø315 mm
- 3 cutting saw teeth
- 4 high running saw teeth
- X1 Rip fence setting
- X2 Free cut adjustment

Prepare the machine for adjustment

The free cut dimension is measured between the saw tooth and the fence plate on the rip fence.

1. ➔ Switch off the machine and secure it from being switched on again.
2. ➔ Disconnect the machine from the mains power supply.
3. ➔ Remove riving knife and saw guard.
4. ➔ Insert a ø315mm saw blade.
5. ➔ Tilt the saw aggregate in the 90° position (cutting angle 0°) and move to the uppermost position.
6. ➔ Convert fence plate to narrow fence edge.
7. ➔ Set the rip fence to an even measurement and fix in place (for example 30 mm).
 - ➔ Check dimension X1 = 30.0 mm with digital calliper.
8. ➔ Check the free cut dimension between the saw tooth and the fence plate on the rip fence using the digital caliper.
 - ➔ X2 dimension = X1 dimension + 0.07 mm.

Correcting the rip fence angle (adjust free cut)

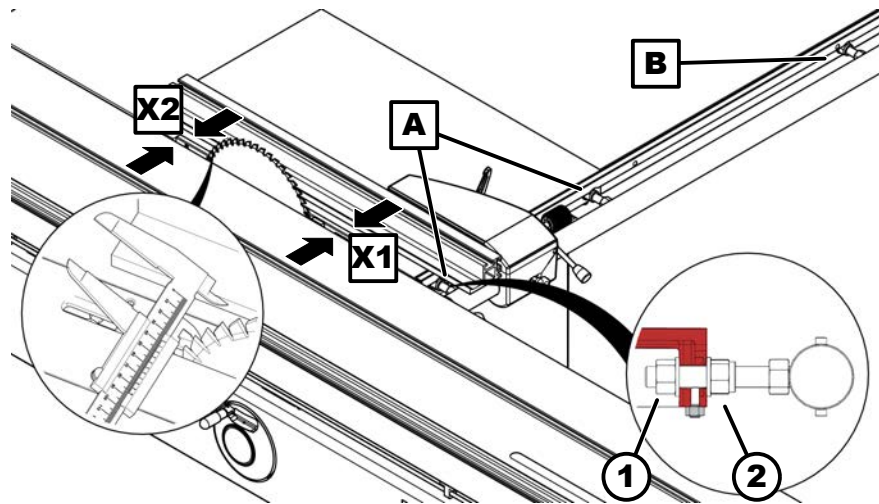


Fig. 113: Adjust free cut

- 1 Lock nut
- 2 front adjusting nut
- A Adjustment point (machine table)
- B Adjustment point (table extension)
- X1 Rip fence setting
- X2 Free cut adjustment

Tool:

- Ring spanner 17 mm
- Callipers

Material:

- MDF-panel

The free cut dimension is measured between the saw tooth and the fence plate on the rip fence.

1. Loosen the lock nuts at the adjustment points "A" and "B".
2. On setting point "A" (machine table, 2x):
 1. Adjust the free cut accurately using the front adjustment nut.
 - ➔ $X2 \text{ dimension} = X1 \text{ dimension} + 0.07 \text{ mm}$.
 2. Lightly tighten the locking nut.
3. At set point "B" (cutting extension):
 1. Turn the adjusting nut by hand on the cutting extension.
 2. Lightly tighten the locking nut.
4. Tighten the lock nuts firmly at the adjustment points "A" and "B".
5. Prepare the machine for operation. ➔ Chapter 8.8.3 'Prepare the machine for operation' on page 57
6. Check settings with a sample cut using an MDF panel.

OK

Very little dust is produced during processing

NOK

Workpiece is burnt or damaged by the rising part of the saw blade.

➔ Correcting the rip fence angle (adjust free cut).

11.7 Adjusting the 0° angle of the crosscut stop on the sliding table

0°-angle adjustment (readjust)

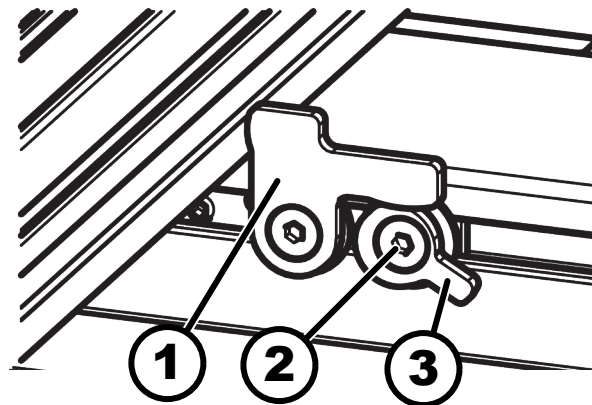


Fig. 114: Adjusting the crosscut end stop

- 1 End stop
- 2 Clamping screw
- 3 Eccentric lever

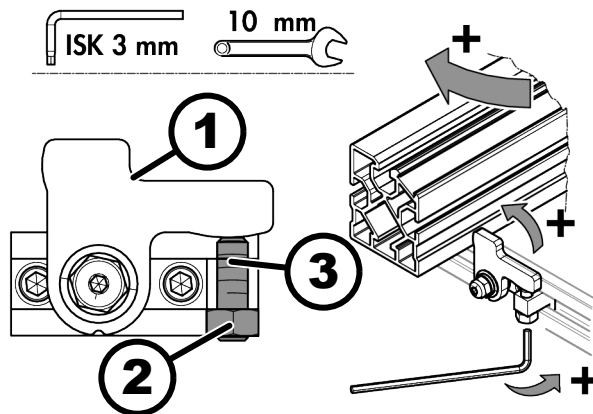


Fig. 115: Adjusting the crosscut end stop

- 1 End stop
- 2 Lock nut
- 3 Adjustment screw

Tool:

- Hex key set
- Ring spanner set

1. → Flip the end stop back.
2. → Loosen the clamp down lever and position the fence against the stop.
3. → Depending on the configuration: Loosen the clamping screws or clamping nuts.
4. → Depending on the configuration: Turn the setscrew as well as eccentric clamp to the 0° angle.
 - ➡ Fence edge is positioned over the scale at 0°.
5. → Depending on the configuration: Tighten the clamping screws or clamping nuts.

Check the setting by making a 2-sided sample cut

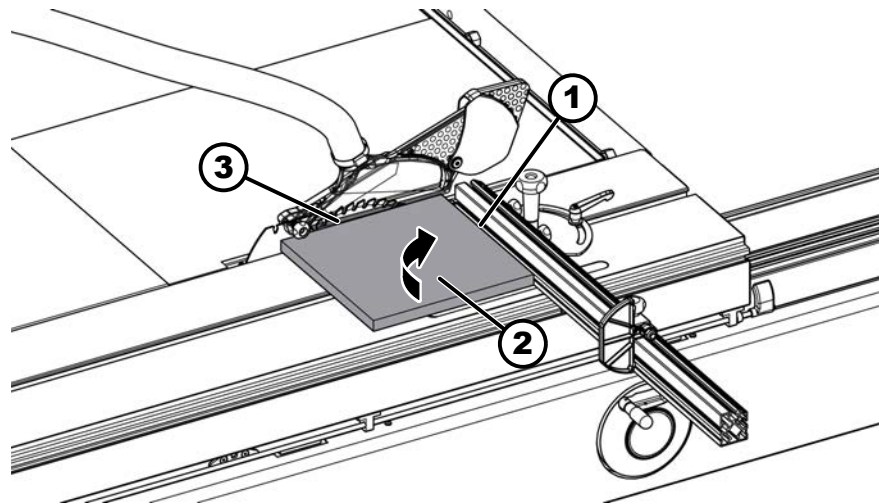


Fig. 116: Sample cut - Crosscut fence angle

- 1 First cut (reference cut)
- 2 Rotate the workpiece in a clockwise direction
- 3 Second cut (control cut)

Tool:

- Precision bevelled steel square

Material:

- Test workpiece (panel material)

1. Set saw cutting angle and crosscut fence to 0°.
2. Carry out sample cut (reference cut).
3. Turn the test workpiece 90° in a clockwise direction.
 - ➡ Let the workpiece rest with the cut side against the stop.
4. Carry out a sample cut again (control cut).
5. Check the result with a precision hair angle.
 - ➡ Allow the precision hair angle to rest against the two cut surfaces.

11.8 Correct the 0° angle of the crosscut fence on the outrigger angle

Crosscut fence on the outrigger table 1100

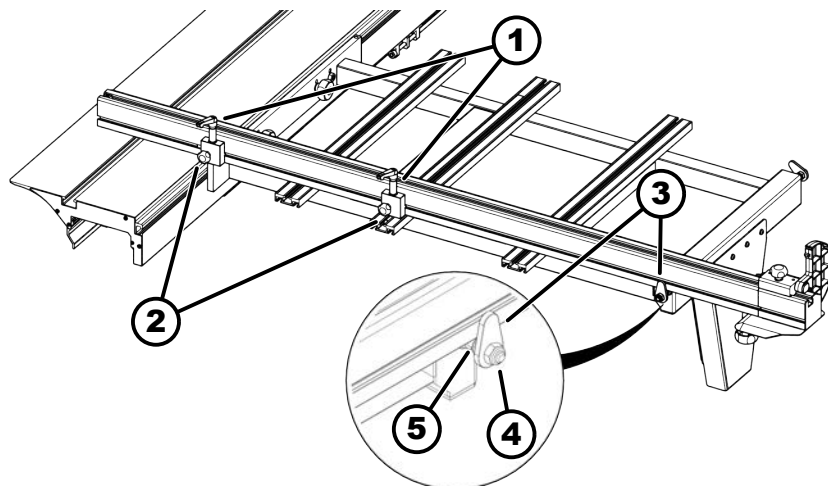


Fig. 117: Correct the 0° angle on the crosscut fence

- 1 Clamping lever
- 2 Thumb screws
- 3 Stop plate
- 4 Front lock nut
- 5 Rear lock nut

0° angle adjustment (readjust)

Tool:

- Ring spanner 17 mm

1. Loosen the clamping lever and the thumb screw.
2. Move the stop plate back up.
3. Secure the rear lock nut with an open-end spanner to prevent it from turning.

4. ➔ Release the front lock nut.
5. ➔ Adjust the position of the stop plate with the two lock nuts.

OK The stop plate must be free of play but must be able to rotate freely.

NOK Stop plate has play or can be turned too tightly.
➔ Loosen or tighten the front lock nut.

6. ➔ Slide the crosscut fence back again, until it sits against the stop plate.
➔ Fence edge is exactly over the scale at 0°
7. ➔ Clamp the clamping lever in place and tighten the thumb screws.
8. ➔ Check settings with a test workpiece.

11.8.1 Check the setting by making a 5-sided sample cut

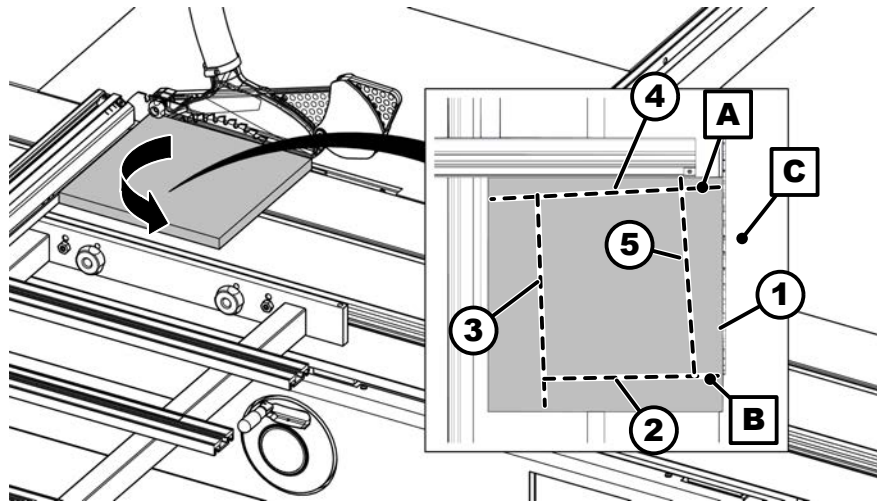


Fig. 118: Test cut - 5-sided cut

- 1 Cut 1 (reference cut)
- 2 Cut 2
- 3 Cut 3
- 4 Cut 4
- 5 Cut 5 (last cut)
- A Dimension A (cutting error)
- B Dimension B (cutting error)
- C Dimension C (length of measuring strip)

Tool:

- Callipers

Material:

- Test workpiece (panel material)

The test workpiece must have at least one straight cut surface. Label this side with 4. Label the remaining sides with 1 to 3.

1. ➔ Set saw cutting angle and crosscut fence to 0°.
2. ➔ Place the workpiece with the straight side 4 against the reference stop.
3. ➔ Carry out reference cut.
➔ Narrow waste strips - Cut 1
4. ➔ Rotate the test workpiece by 90°.
➔ Lay the workpiece against the stop with the side that has just been cut.
5. ➔ Carry out a new reference cut.
➔ Narrow waste strips - Cut 2
6. ➔ Make a reference cut 2 more times followed by a rotation.
➔ Narrow waste strip - section 3 and 4
7. ➔ Cut off a 2 cm wide strip from the last reference cut.
➔ Measuring strip - section 5

8. → The absolute cutting error can be determined as follows: Dimension "A" minus dimension "B" divided by 4.

EXAMPLE:

- Dimension A = 32.0 mm, dimension B = 20.0 mm
- Cutting error with 4 cuts (dimension A - dimension B) = 12.0 mm
- Absolute cutting error per cut = 3.0 mm
- Length of the measuring strip (dimension C) = 173.5 mm
- Cutting error per metre = 3.0 mm / 173.5 × 1000 mm = 17.3 mm
- Angular error = $\tan^{-1}(17.3 \text{ mm} / 1000 \text{ mm}) = 0.99^\circ$

11.9 Correct crosscut fence length

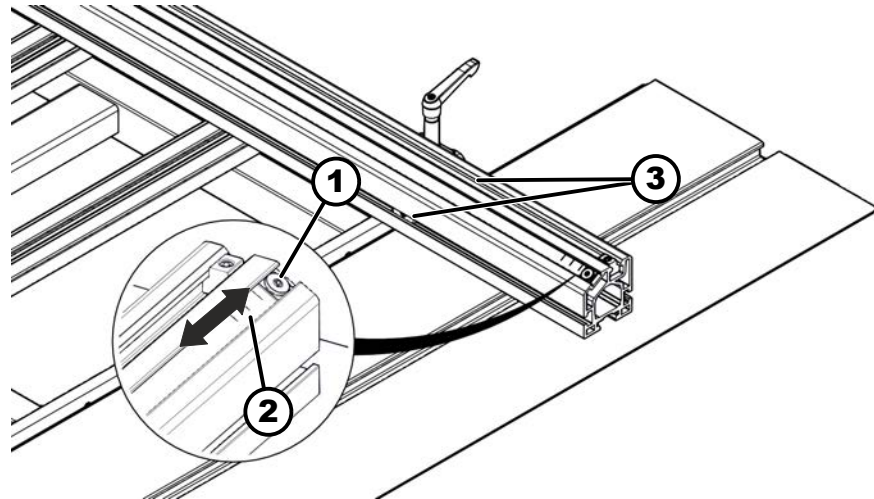


Fig. 119: Scale crosscut stop

- 1 Clamping screws
- 2 Scale
- 3 Sliding block with grub screw

Changing the saw blade on a crosscut fence with a scale (standard)

Tool:

- Allen key 2.5 mm

Adjust until the scale is calibrated to the saw blade.

A slotted nut in the stop profile serves as a stop point for the crosscut stop in the 0° position.

1. → Loosen the clamping screw.
2. → Move the scale to compensate for the saw blade width.
3. → Tighten the clamping screw.

Changing the saw blade on the crosscut fence with digital display (option)

Correction applies only to the digital display; the scale is not valid.

→ Calibrate position display / adjust current value.

Correction when converting from the push side to the pull side on a standard crosscut stop

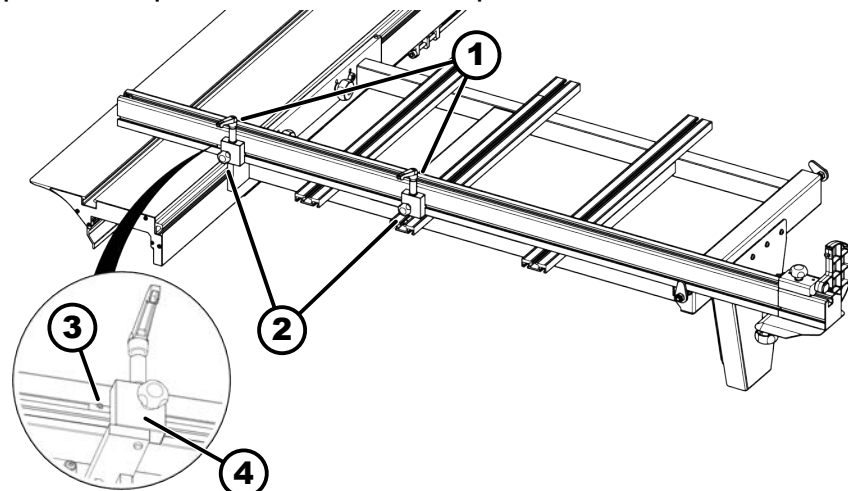


Fig. 120: Crosscut fence in the 0° position

- 1 Clamping lever
- 2 Thumb screws
- 3 Sliding block with grub screw
- 4 Pivot jaws

When converting from push to pull side and vice versa, ensure that the calibration position of the scale is set correctly.

One slotted nut on each side of the stop profile (on the push and pull sides) serves as a stop point for the crosscut stop in the 0° position.

1. ➞ Convert the crosscut fence to the push or pull side.
2. ➞ Calibrate the scale of the crosscut fence by turning the stop plate back to the 0° position.
3. ➞ Clamp the clamping lever in place and tighten the thumb screws.
4. ➞ Perform a test cut and measure the workpiece.
5. ➞ Compare the scale on the crosscut stop with the measured value.

OK

The scale on the crosscut fence matches that on the test workpiece.

NOK

Crosscut fence with scale not calibrated.

1. ➞ Loosen the grub screw of the sliding block.
2. ➞ Loosen the thumb screws.
3. ➞ Move the crosscut fence with scale according to the measured value.
4. ➞ Tighten the knurled screws.
5. ➞ Adjust the sliding block to the pivot jaws and fix it with the grub screw.

12 Attachment

12.1 Information relating to spare parts

The use of incorrect or faulty spare parts

Spare parts that do not meet the manufacturer's requirements may impair safety-relevant functions and jeopardise the operational safety of the machine. People could be seriously injured or killed.

- Only use authorised, approved spare parts approved by the manufacturer.
- If in doubt, obtain authorisation from the dealer or manufacturer.
- Only use technically perfect spare parts.
- Safety-related spare parts may only be installed, exchanged and tested by authorised qualified personnel in accordance with the manufacturer's instructions.
- See spare parts list.

If unauthorised spare parts are fitted into the machine, all warranty, service, compensation and liability claims against the manufacturer and their contractors, dealers and representatives will be rejected.



Use original spare parts

The original spare parts that have been authorised for use are listed in a separate spare parts catalogue, enclosed in the documentation package supplied with the machine.

Spare part orders

Pos.	Teilenummer	Teilebezeichnung
1	418EJ	SKT SCHRAUBE M10X80 SCHWARZ
2	414E	SCHEIBE M10
3	401F	SKT MUTTER M10 VERZINKT
4	214AO	KUGELPFANNEN UNTERTEIL LT. Z. 75-07-136
5	214AN	KUGELPFANNEN OBERTEIL LT. Z. 75-07-135
6	402K	SKT MUTTER M10 FLACH

Feldner KG KR-Valder-Straße 1, A-606 HALL in Tirol feldner-group.com, info@feldner-group.com +43 5223 58500, Fax +43 5223 56130			
TYPE: XXXXXXXX		Code: XXXX	
NR.: XXXXX.XXX.XX		CE UK CA	
V: XXX	PH: X	HZ: XX	A: X.X
KW: X.X SX-XX%		XXX (machine type)	
Baujahr / year of construction / ANNEE DE CONSTR.: 20xx			

Fig. 121: Spare parts list / data plate

- 1 Model type
- 2 Serial number
- 3 Article number
- 4 Article description

The following information is required when ordering spare parts:

- Type description and serial number as per identification plate
- Article number, article description and required quantity
- Shipping address
- Shipping mode (mail, freight, sea, air, express)

Orders for spare parts, which do not include the required details, will not be processed. Unless specific dispatch instructions are given, the manufacturer / supplier standards shall apply.

12.2 Disposal



ENVIRONMENT

Disposal of machine components

Used electrical materials, electronic components, lubricants and other auxiliary substances must be treated as special waste and may only be disposed of by specialised, licensed firms.

The machine consists of many different materials for which different disposal conditions may apply depending on national legislation.

1. Separate all machine components into material groups.
2. When disposing, pay attention to international regulations, standards and environmental protection norms.

**ENVIRONMENT****Disposing of batteries**

Batteries are subject to special waste treatment regulations and must be disposed of in accordance with locally enforced regulations.

The improper handling of batteries, can due to their potentially dangerous substances, have a negative environmental effect and consequences for human health.

For this reason, follow the advice relating to batteries exactly:

- do not open or short circuit
- do not throw them into fire or expose them to high temperatures
- protect from getting wet and do not place them in water
- do not store them together with electroconductive items (e.g. chains, screws, metal waste etc.)

Hammer®

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