

28/10/08

W872 FORSA-9 SCHEPPACH PANEL SAW

Hafco Setup Procedure to be used in conjunction with factory manuals supplied

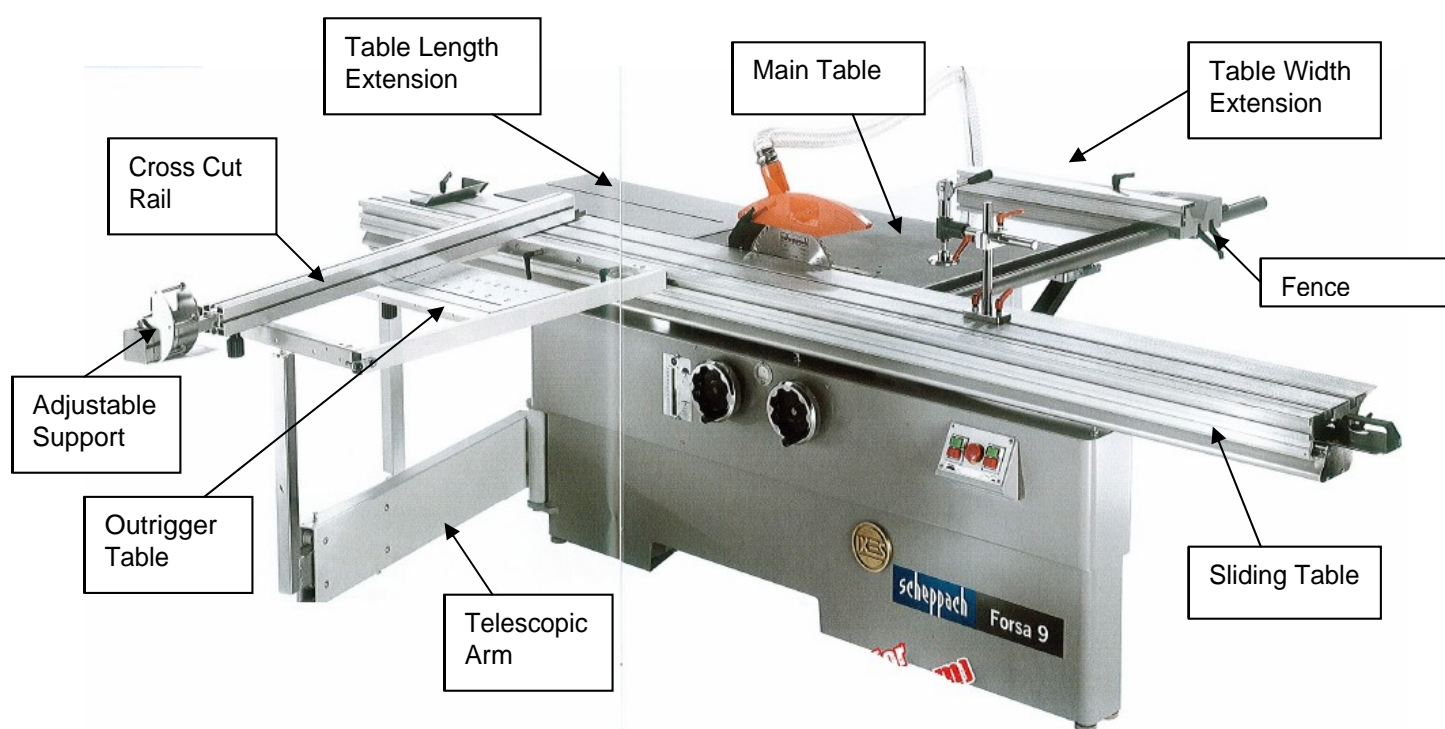


Table Stroke	3200mm
Max wide rip capacity	1320
Saw blade	315mm
Blade bore	30mm
Max depth of cut @ 90°	107mm
Max depth of cut @ 45°	75mm
Cutting speed	66m/sec
Tilt	90° - 45°
Scribe blade	120
Bore	20
Max height	4mm

There are five boxes containing the parts for the saw, the serial number should be on each box and they should all have the same number, because the machine is set in the factory and then dismantled and packed into boxes

1. Place the main table in position and level using the four jacking bolts



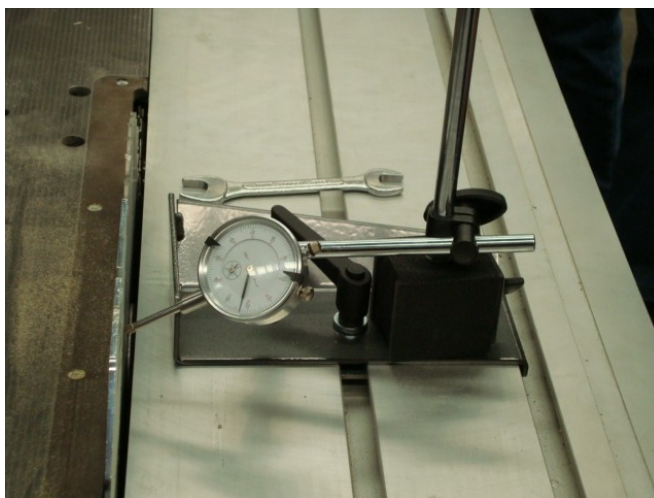
2. Mount the sliding table to the main table by lowering it over the six mounting studs, the nyloc nuts should be factory set to the correct height, Adjust the height of the sliding table so that it is 0.3mm above the main table, this is to stop the material dragging on the main table as it passes through the blade
3. Do not tighten the main bolts at this stage, nip them up until the sliding table is squared up



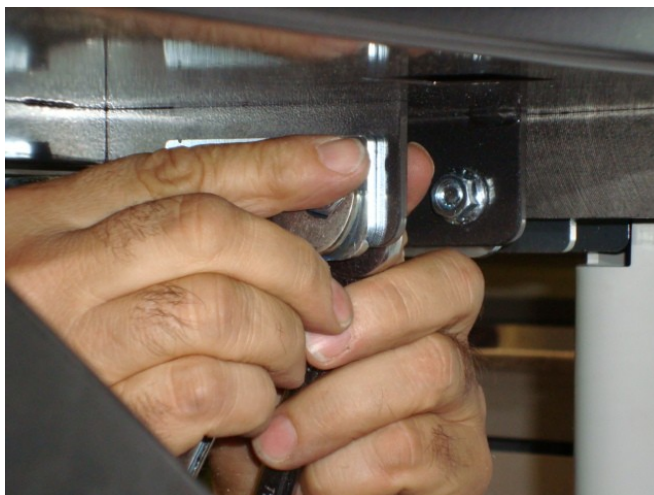
4. Before tightening the main bolts pull the table towards the main table tight against the two adjusting bolts



5. Mount a dial indicator as shown and traverse it along the blade then adjust the sliding table if necessary by using adjusting screws.
6. The sliding table should be square to the blade to a tolerance of $\pm 0.1\text{mm}$
7. Tightened main bolts



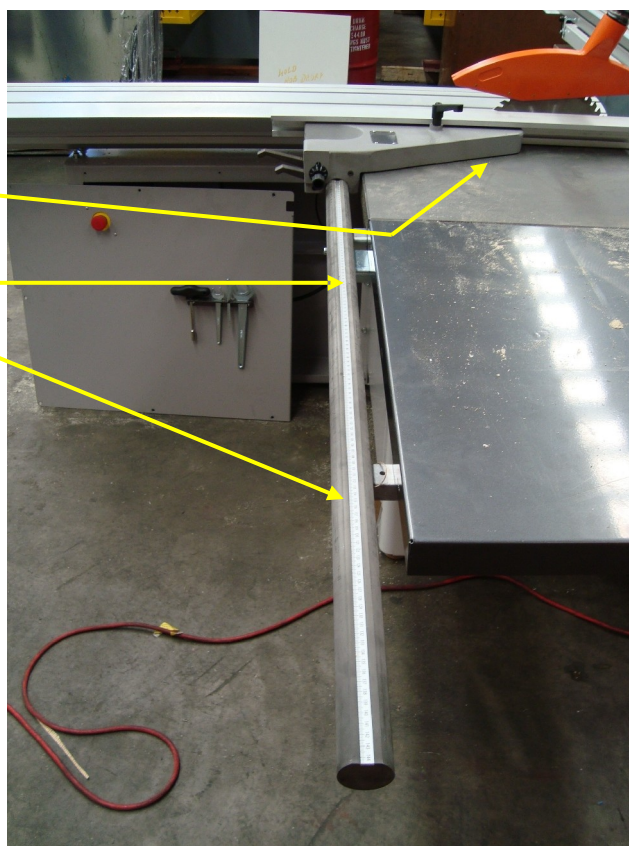
8. Fix the mounting brackets to the table width extension, then fit the extension to the main table, adjust so that the side extension table is flush with the main table



9. Outer end of the table width extension table can be levelled using the two adjusting bolts



10. Fit the fence rail to the table and nip the bolts up
11. Fit the fence to the rail and slide up to the blade and lock in position
12. Adjust the rail until the fence is square to the blade and tighten bolts
13. With the fence against the blade adjust the indicator to zero by loosening the plastic indicator holding screws and repositioning the indicator



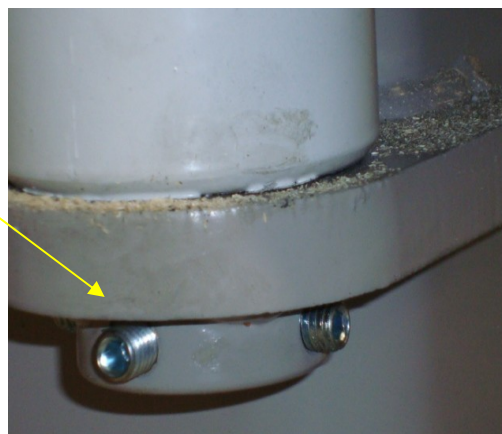
14. Fit the table length extension and adjust so that it sits just below the surface of the main table
15. This can be adjusted by the mounting bolts for the hinge pins
16. The outer end is adjusted by the stabilising leg



17. Place fence across the sliding table and measure from the fence to the top of the telescopic arm, do this measurement at the further most forward point of the telescopic arm travel and then again at the rear most point of travel



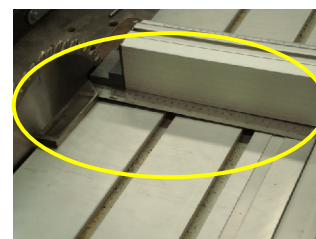
18. Adjust the pivot pin until both readings are the same



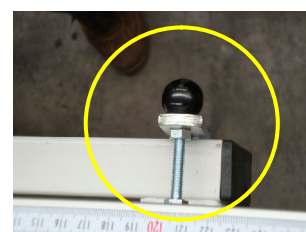
19. Fit the outrigger table to the sliding table so that both surfaces are flush

20. Fit crosscut rail to the sliding table and fit the adjustable stop to
21. the crosscut rail and lock it in position at the 100mm mark

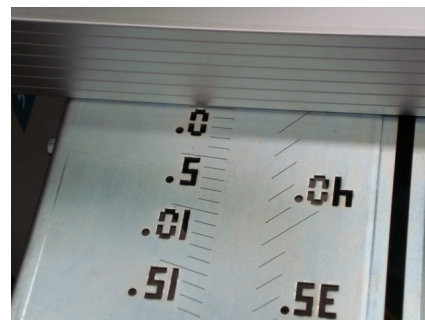
22. Adjust the whole crosscut rail until the face of the stop is 100mm
a. from the blade



23. Place a set square against the blade and square the crosscut rail
to the blade with the adjusting screw

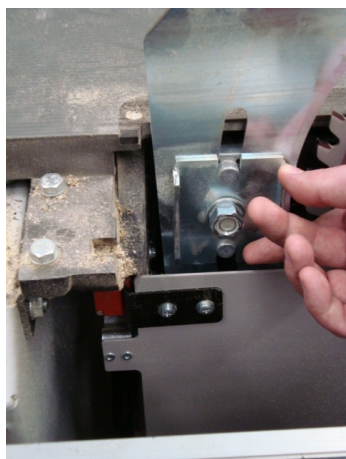


24. The crosscut rail scale can also be adjusted to zero by loosening the whole plate and sliding until the zero mark lines up with the fence

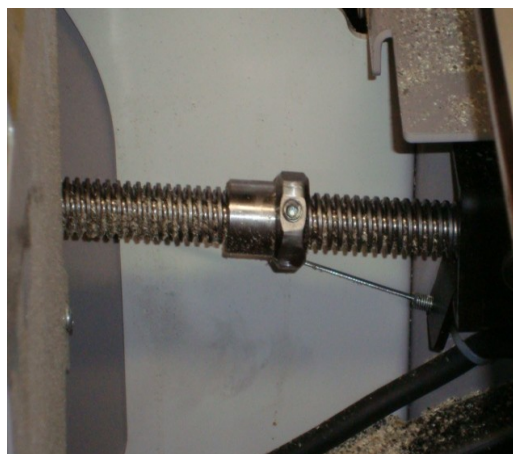


MAIN SPINDLE

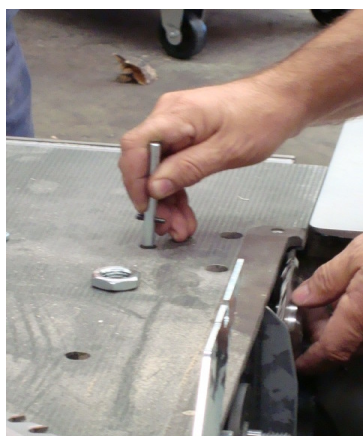
The blade cover has a micro switch so the cover must be shut for the saw to operate



The riving knife can be adjusted to suit different blades



The maximum blade angle can be set by this nut



Fit pin into spindle to loosen blade nut, both blades



Front bolt adjusts blade up or down
Rear bolt adjusts blade from side to side

To adjust scribe blade position

MAINTENANCE

At the end of each day wipe off sawdust and wipe down sliding surfaces with a rag wet with WD40