



**AGS400**  
**TILTING ARBOR**  
**SAWBENCH**

**INSTRUCTION MANUAL No 3002/1**



**Wadkin UltraCare Limited**  
Green Lane Road  
Leicester  
LE5 4PF

Tel: +44 (0)116 276 9111  
Fax: +44 (0)116 274 4567  
Website: www.wadkinultracare.com  
E-mail: info@wadkinultracare.com

**MANUFACTURERS E.C. DECLARATION  
OF CONFORMITY**

The following machine has undergone "Conformity Assessment" and has undergone Third Party Examination by a Notified Body in accordance with:-

Schedule IV of the Supply of Machinery (Safety) Regulations 1992  
and Amendment No. 2063

**COMPANY**

Wadkin Ultracare Limited  
Green Lane Road  
Leicester  
LE5 4PF

**RESPONSIBLE PERSON**

Mr J P Smith (Director)

**MACHINE DESCRIPTION**

**TYPE** Tilting Arbor Saw Bench

**MODEL** AGS 400/430

**DIRECTIVES COMPLIED WITH**

Supply of Machinery (Safety) Regulations 1992  
Amendment No. 2063 1994  
Draught Proposal CEN/TC 142  
ISO 9001 Part 1

**NOTIFIED BODY**

Lloyds Register  
Lloyds Register House  
29 Wellesley Road  
Croydon, CR0 2AJ

**SIGNED ON BEHALF OF WADKIN  
ULTRACARE LTD.**

**EC TYPE EXAMINATION  
CERTIFICATE NO.**



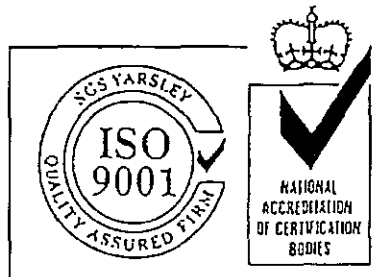
**EC95/00005**  
Registered in England 4177852  
Registered Office: 44 The Ropewalk, Nottingham NG1 5EL

**BE CAREFUL  
THIS MACHINE CAN BE DANGEROUS  
IF IMPROPERLY USED**

Always use guards.  
Keep clear until rotation has ceased.  
Always operate as instructed  
and in accordance with good practice.  
Read instruction manual before installing  
operating or maintaining machine.

Manufactured by :- WADKIN PLC  
Green Lane Road  
Leicester  
LE5 4PF  
England

phone no :-0116 2769111  
fax no :-0116 2742310



## **PREFACE**

### **IMPORTANT**

**IT IS OUR POLICY AND THAT OF OUR SUPPLIERS TO CONSTANTLY REVIEW THE DESIGN AND CAPACITY OF OUR PRODUCTS. WITH THIS IN MIND WE WOULD REMIND OUR CUSTOMERS THAT WHILE THE DIMENSIONS AND PERFORMANCE DATA CONTAINED HEREIN ARE CURRENT AT THE TIME OF GOING TO PRESS, IT IS POSSIBLE THAT DUE TO THE INCORPORATION OF THE LATEST DEVELOPMENTS TO ENHANCE PERFORMANCE, DIMENSIONS AND SUPPLIERS MAY VARY FROM THOSE ILLUSTRATED**

**THIS MANUAL IS WRITTEN AS A GENERAL GUIDE. A TYPICAL MACHINE IS SHOWN TO ILLUSTRATE THE MAIN FEATURES.**

**Failure to comply with instructions in this book may invalidate the guarantee**



## IMPORTANT

### SAFETY PROCEDURES AND CONSIDERATIONS

To ensure safe working conditions, persons operating and assisting with the operation of this machine must ensure that they read and fully understand the instructions given within this manual and have received sufficient training in the use of the machine and the safety aspects to be observed.

**Note:-** Persons under the age of 18 years must not operate the machine except during a course of training under the supervision of a trained operator.

#### A) POINTS TO NOTE BEFORE OPERATING OR ASSISTING WITH THE OPERATION OF THE MACHINE

- 1) You have read and understood the operation and safety aspects of the machine and have been checked out by a qualified supervisor.
- 2) The machine is supplied with full safeguarding. The machine shall not be operated unless the safeguardings are in position and functional.
- 3) Cutters/blades are the correct type, suitable for the machine and working conditions, rotate in the correct direction of cut, are sharp and correctly fitted.
- 4) Correct spindle and speeds are selected for the cutter equipment and working conditions.
- 5) Loose clothing is either removed or securely fastened back and jewellery removed.
- 6) Adequate working space and lighting is provided.
- 7) All dust extraction equipment is switched on, properly adjusted and working adequately.
- 8) The machine is securely installed (refer to installation section within this manual).
- 9) The machine should only be used for cutting wood or materials with physical and technological characteristics similar to wood, and for which the chip or particle removal process is similar.



**B) DURING MACHINING:-**

- 1) Wear suitable protective clothing e.g., approved eye protection, ear defenders and dust mask. Gloves shall be worn when handling sharp edged saws.
- 2) Stop the machine using the emergency stop or at the mains isolator before making adjustments, cleaning or carrying out maintenance.
- 3) Keep the floor area around the machine clean and free from wood refuse. Do not allow the floor around the machine to become slippery.
- 4) Stop the machine and report immediately to a person in authority any actual or potential malfunction or operator hazard. Do not attempt to repair or rectify the machine unless qualified and authorised to do so.
- 5) The operator must not leave the machine running whilst unattended.
- 6) Never by pass interlocks.
- 7) A push stick or handled push block must be used to feed the trailing end of a workpiece past the cutting head.
- 8) When ripping never stand directly behind the material.

**WARNING:-**

Failure to observe correct operating procedures prior to and during operation of this machine can result in severe injury.

**DO NOT** attempt to operate the machine while under the influence of anything that reduces your alertness.

1.0	<b>INDEX</b>	Pages 1/1
2.0	<b>SAFETY</b>	Pages 2/1 to 2/2
2.1	Health & Safety Statement	Page 2/1
2.2	Safety Instructions	Page 2/2
3.0	<b>SPECIFICATIONS</b>	Pages 3/1
4.0	<b>ASSEMBLY INSTRUCTIONS</b>	Pages 4/1 to 4/8
4.1	Standard Items Despatched with Machine	Page 4/4
4.2	Slinging	Page 4/4
4.3	Foundation	Page 4/4
4.4	Cleaning & Re-assembly	Page 4/4
4.4.1	Cleaning	Page 4/4
4.4.2	Re-assembly of Rip Fence - Export Only	Page 4/4
4.4.3	Re-assembly of Riving Knife and Sawguard	Page 4/7
4.5	Electrical	Page 4/7
4.5.1	Wiring Connection	Page 4/7
4.5.2	Fuse Lists	Page 4/7
4.5.3	Wiring Diagrams	Page 4/8
4.6	Dust Extraction Details	Page 4/8
4.6.1	Main Extraction	Page 4/8
4.6.2	Crown Guard Extraction - Extra	Page 4/8
5.0	<b>CONTROLS</b>	Pages 5/1 to 5/6
5.1	Table Rise & Fall	Page 5/1
5.2	Canting	Page 5/1
5.3	Sawguard and Riving Knife Adjustment	Page 5/1
5.4	Rip Fence	Page 5/1
5.4.1	Rapid Fence Adjustment	Page 5/1
5.4.2	Micro Fence Adjustment	Page 5/3
5.5	Electrical Controls	Page 5/3
5.6	Fitting Tooling	Page 5/3
5.6.1	Main Sawblade	Page 5/3
6.0	<b>USE OF MACHINE</b>	Pages 6/1 to 6/3
6.1	Ripping	Page 6/1
6.2	Mitre Fence	Page 6/1
7.0	<b>MAINTENANCE</b>	Pages 7/1 to 7/6
7.1	Lubrication	Page 7/1
7.2	General	Page 7/1
7.3	Setting Main Table in Line with Saw	Page 7/1
7.4	Setting Rip Fence	Page 7/1
7.5	Setting Saw to Riving Knife	Page 7/3
7.6	Belt Changing	Page 7/5
8.0	<b>SPARES</b>	Pages 8/1
8.1	Instruction for Ordering Spare Parts	Page 8/1
8.2	Sawblades	Page 8/1

## 2.1

## HEALTH &amp; SAFETY

## SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

Wadkin plc supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the users responsibility to see that the following rules are complied with to ensure safety at work:

- 1) The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.
- 2) Safe methods of working only should be adopted as given in BS.6854 Part 1, "Safeguarding Woodworking Machines" and subsequent parts for specific machines (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin plc.
- 3) Only personnel trained in the safe use of a machine should operate it.
- 4) Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.
- 5) All tools and cutters must be securely fixed and the speed selected must be appropriate for the following.

Safety is our watchword, but the user must comply with the above rules in his own interest. We would be pleased to advise on the safe use of our products.

**Wadkin Leicester**

Green Lane Works, Leicester LE5 4PF, England.  
Telephone: 0533 769111 Telex: 34646 Wadkin G.  
Fax: 0533 742310



## 2.2 SAFETY INSTRUCTIONS

Carefully read instruction manual with particular reference to the following instructions:-

- a) Slinging, ie, safe lifting limits for slings, etc.
- b) Installation and foundation, ie, safe working area of machine, bolt positions, etc.
- c) Wiring details, ie, connection of machine to mains supply, fuse details, etc.
- d) Machine controls and operating instructions.

Ensure tooling is of the correct type for use with the machine and cutters are securely fixed in position.

Select correct spindle speed and feed rate relevant to the tooling being used.

Set all guards correctly and ensure they are securely fixed in accordance with the current regulations.

Use suitable jigs, fixtures and feeding devices etc., (push stick, etc.,) where appropriate.

Refer to BS.6854, Part 1, "Safeguarding Woodworking Machines" and subsequent parts for specific machines for safe working practices.

### During Machining

Wear suitable protective equipment, where necessary, eg, goggles, ear defenders and dust mask.

Ensure all moving parts of the machine are stationary before setting, cleaning or making any adjustments.

Report immediately to a person in authority any machine malfunction or operator hazard. Do not attempt to repair the machine unless authorised to do so.

Ensure machine is electrically isolated before any maintenance/cleaning work commences.

### NOISE LEVELS

This machine, under certain conditions, will emit noise levels in excess of 85dB(a).

Noise levels will be affected by the environment in which the machine operates, the timber being machined, tooling, machine setting and dust extraction.

Further information available from Wadkin

As a manufacturer it is Wadkin's policy to reduce the noise level as far as is practicable.

3.0

**SPECIFICATION - AGS 400**

Size of main table	1190 x 1100mm	47 x 39 in
Maximum distance saw to rip fence	914mm	36 in
Maximum dia of saw	400mm	16 in
Saw projection with 400mm saw	50-125mm	2-5 in
Saw projection with 300mm saw	0- 75mm	0-3 in
Power of motor	- standard - optional	7.5 hp 10 hp
Spindle speed	3000rpm	
Spindle dia	30mm	
Approximate floor space	1650 x 1250mm	65 x 49 in
Approximate net weight	440kg	968 lbs
Approximate gross weight - poly packed	450kg	990 lbs
Approximate gross weight - fully boxed	550kg	1100 lbs
Shipping dimensions - boxed	1.31 x 1.10 x 1.07m	49¼ x 41 x 35 in

www.DaltonsWadkin.com

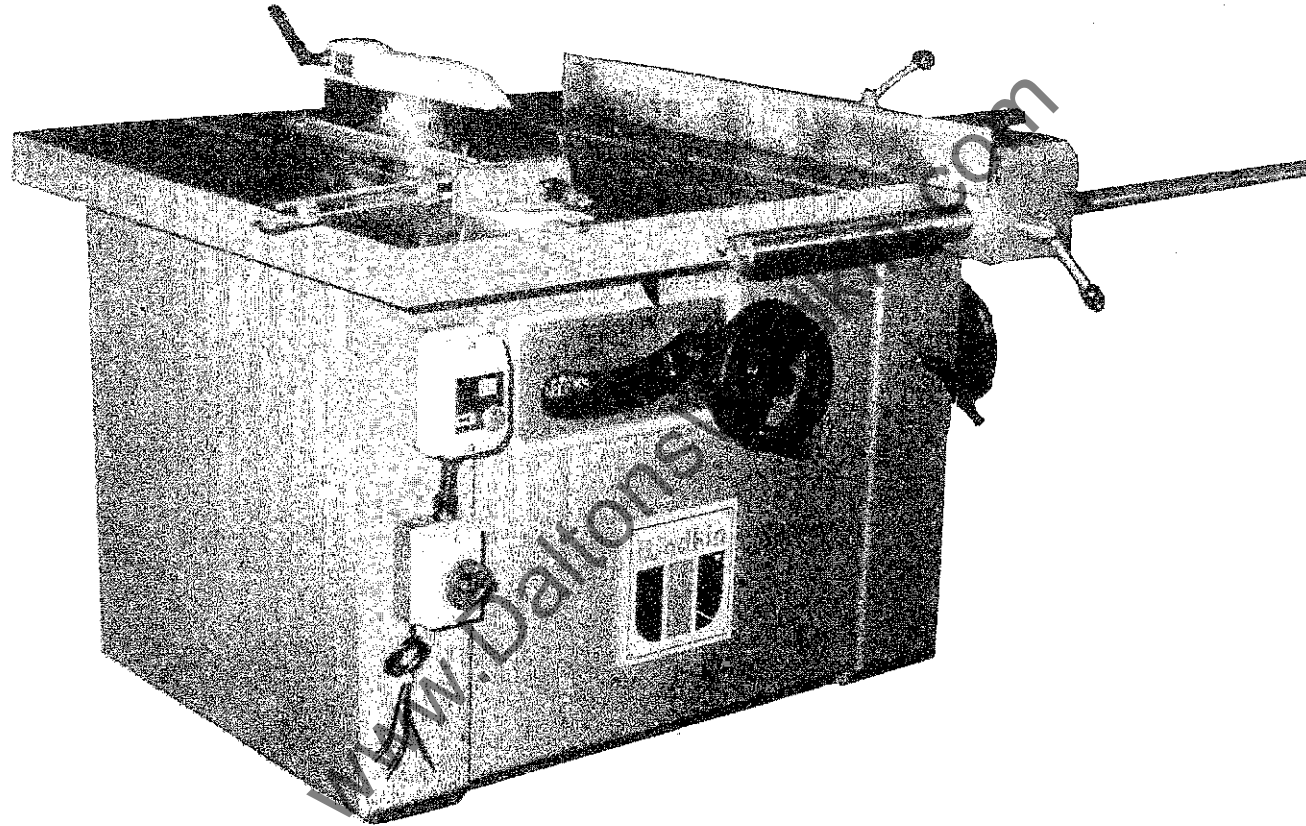


FIG. 1

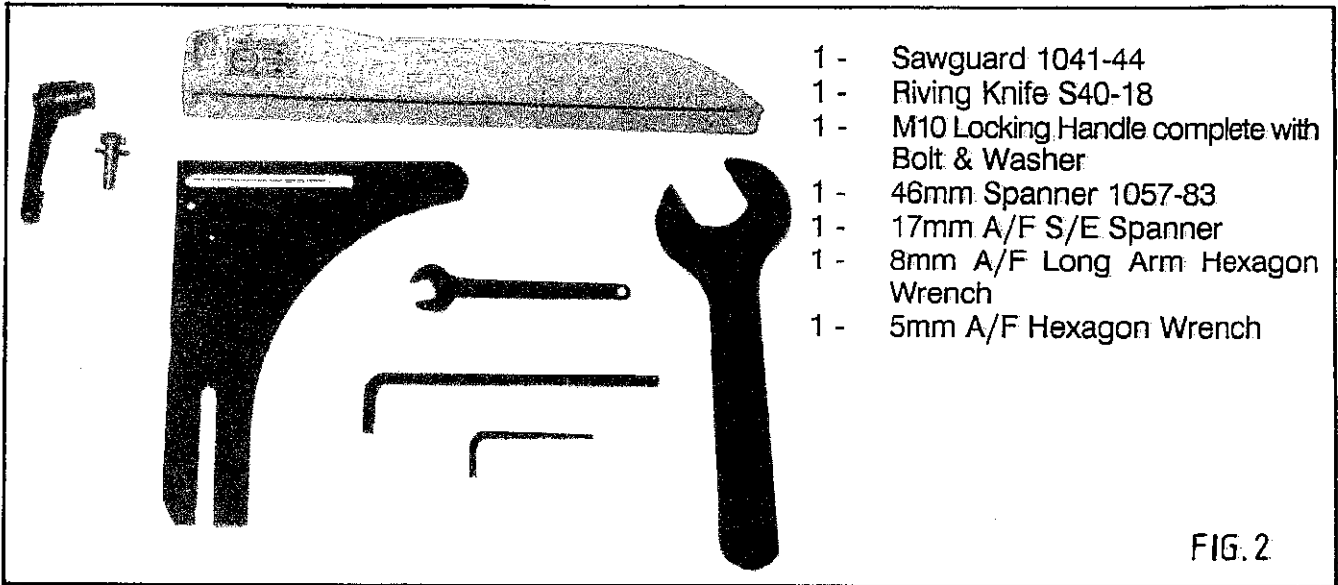


FIG.2

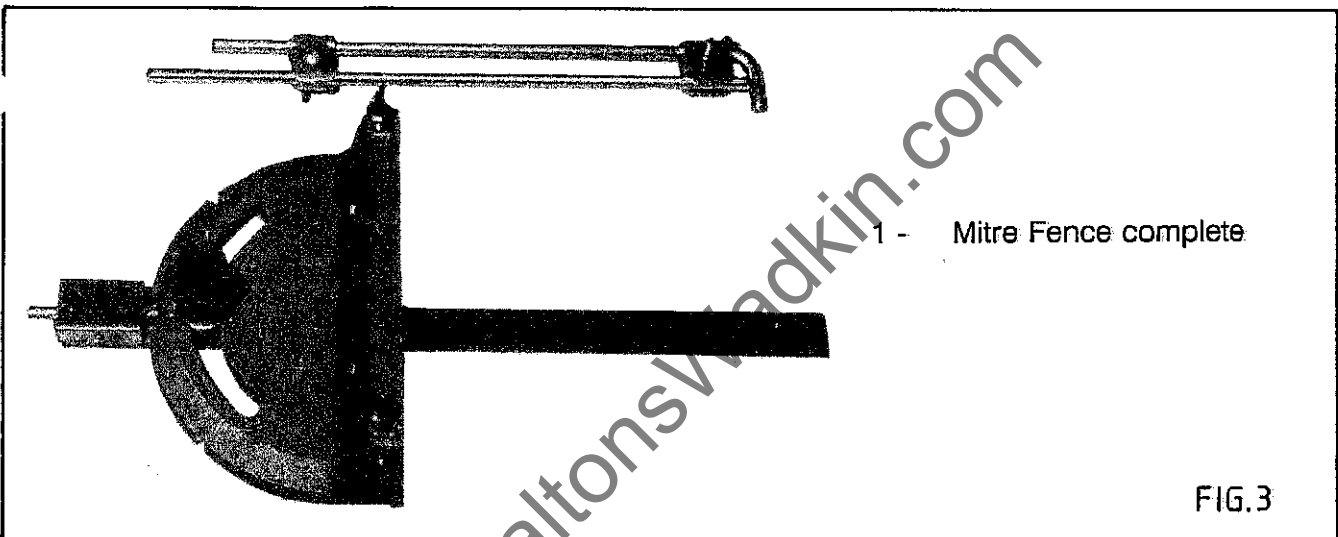


FIG.3

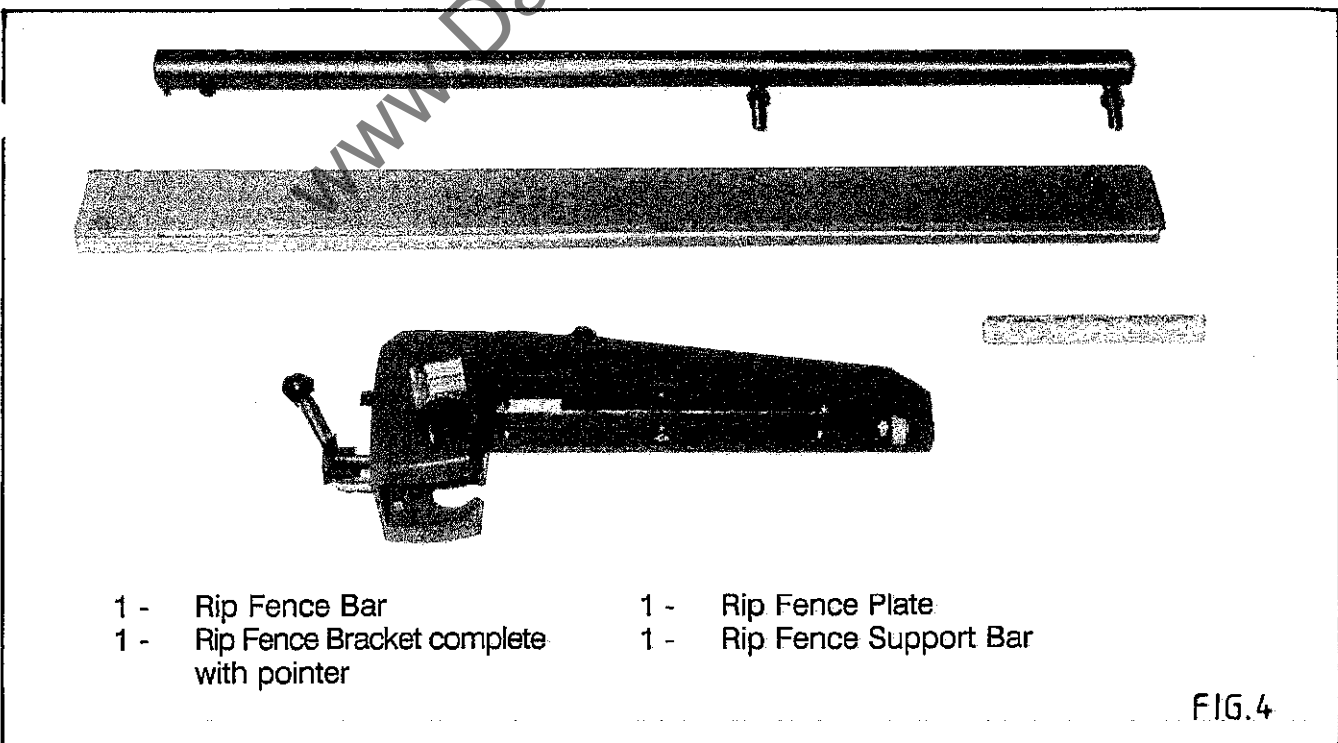
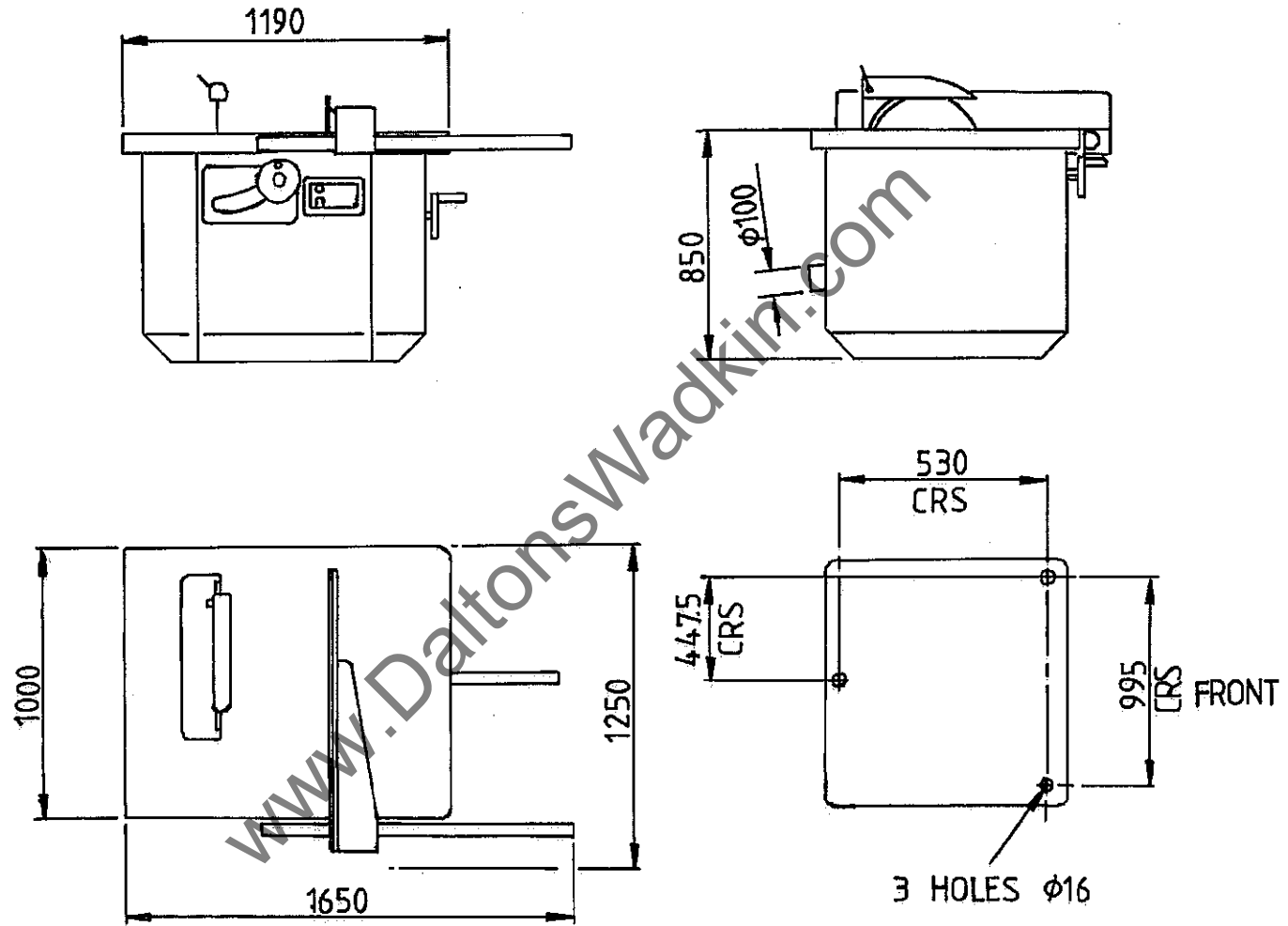


FIG.4



FOUNDATION PLAN

FIG. 5

## 4.0 ASSEMBLY INSTRUCTIONS

### 4.1 Standard Items Despatched with Machine

A set of operational spanners and mitre fence are despatched with the machine, see FIGS.2 & 3 for details. In addition certain parts are removed, see FIG.4 for details.

### 4.2 Slinging

Always use a sling within safe working load of machine weight.

Approximate net weight of machine	-	440 KG
Approximate gross weight of machine - poly packed	-	450 KG
Approximate gross weight of machine - fully boxed	-	550 KG

Attached slings to machine as shown in FIG.6, ensuring damage will not be caused to machine during slinging operations.

**IMPORTANT:** DO NOT WALK OR STAND UNDER MACHINE DURING SLINGING OPERATION.

### 4.3 Foundation

The machine should be so placed that the traffic of men and materials to and from it fits smoothly into the general scheme of traffic. It should also not be necessary for the operator to stand in or near an aisle so as to cause a hazard. The minimum clearance on each working side of the machine should be at least 1 metre greater than the largest material worked on the machine.

Ensure floor is level, then mark to suit 3 - M12 rawlbolts, refer to foundation plan FIG.5. Drill floor to suit rawlbolts. These bolts are not supplied with the machine, but can be supplied at an additional charge.

### 4.4 Cleaning & Re-assembly

#### 4.4.1 Cleaning

Remove protective coating from bright parts by applying a cloth soaked in paraffin or other solvents.

#### 4.4.2 Re-assembly of Rip Fence - Export Only

- a) Locate stud "A" FIG.7 into holes in front of main table. Set fence bar parallel to table top and lock in position with nuts provided.

**NOTE:** Do not disturb locknuts as these are set in factory to give correct fence alignment.

- b) Assemble fence and lock stop screw in end of fence bar. Fit fence support "B" to table edge and ensure support is set level to table top.

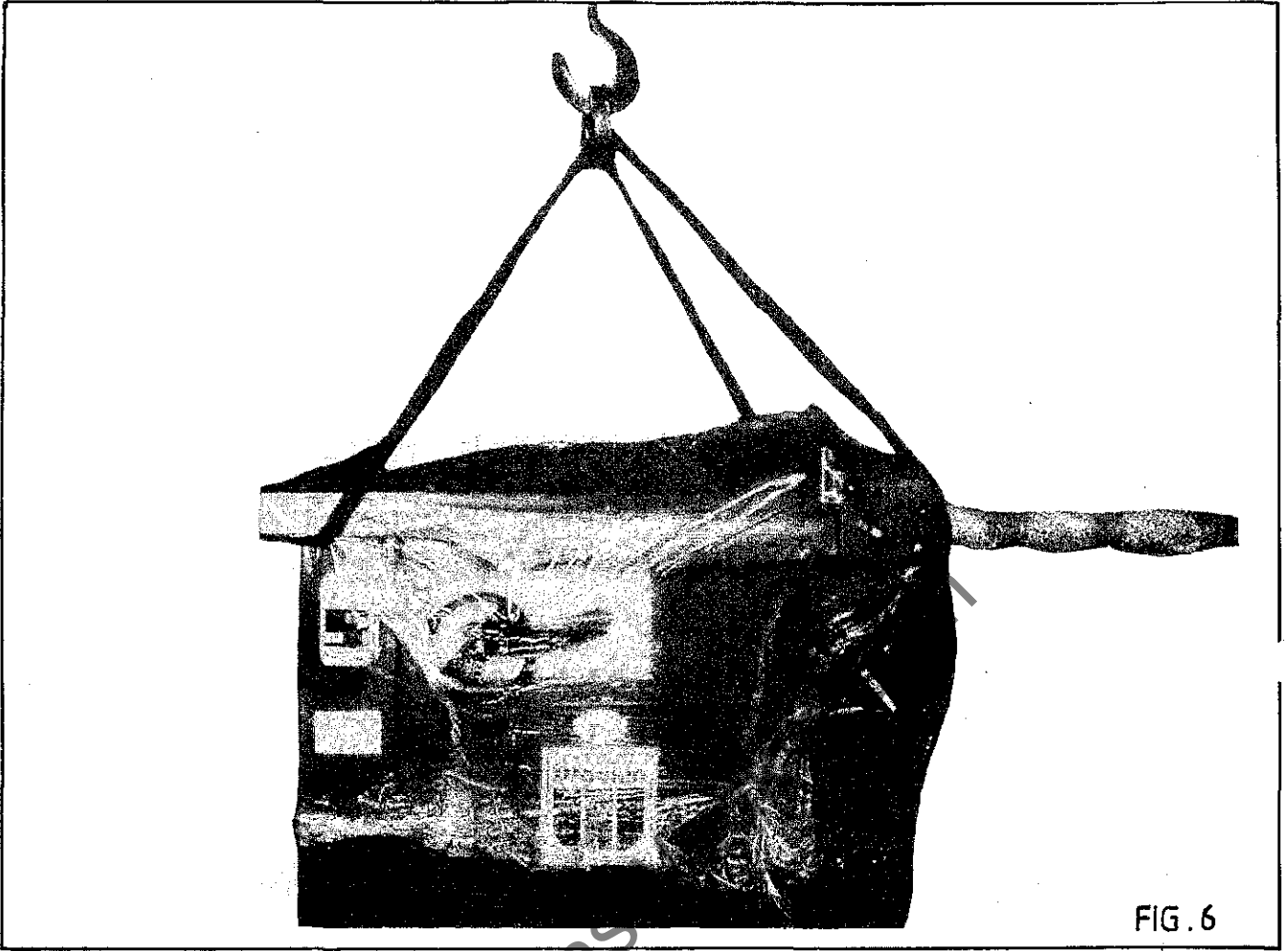


FIG. 6

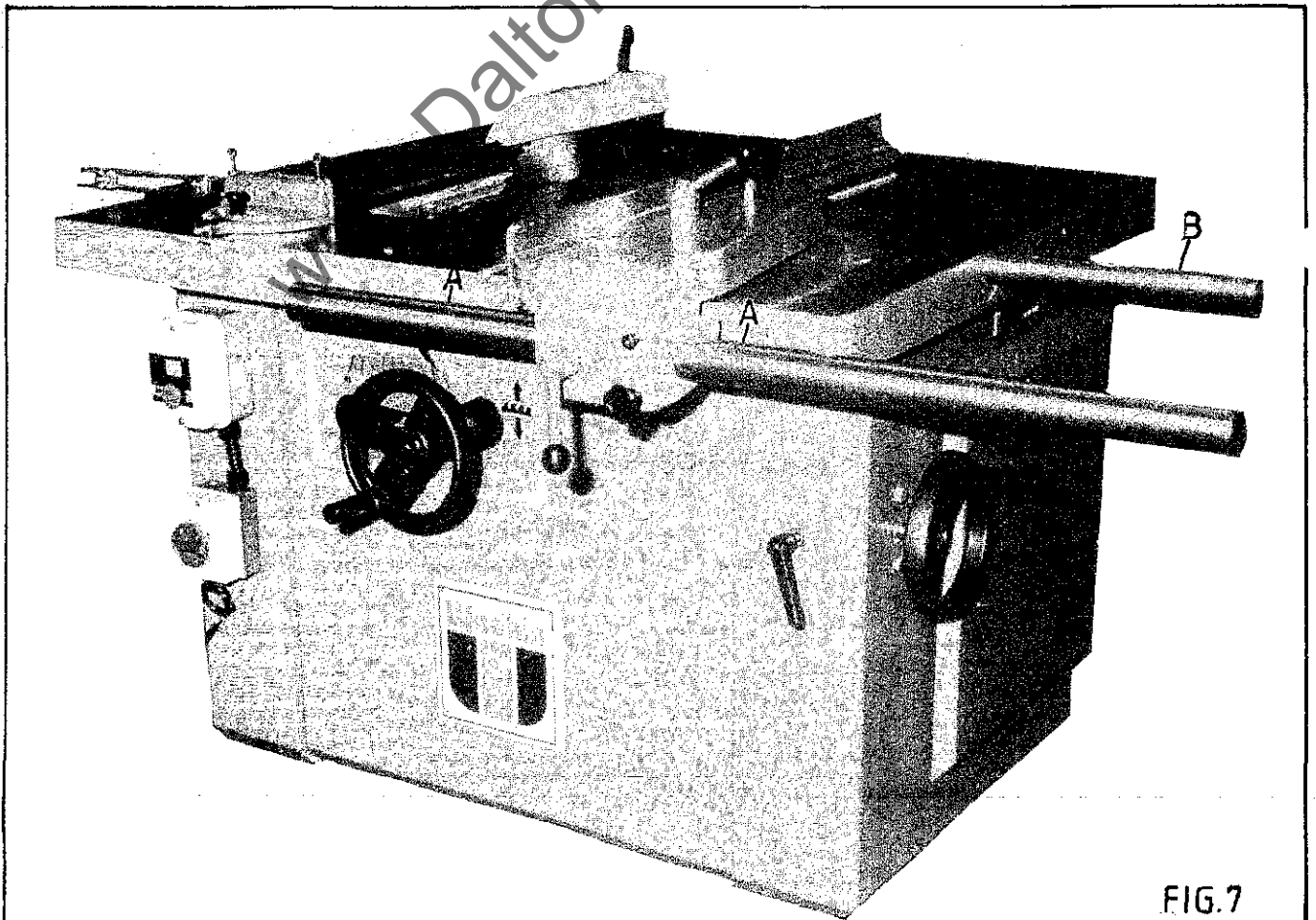


FIG. 7

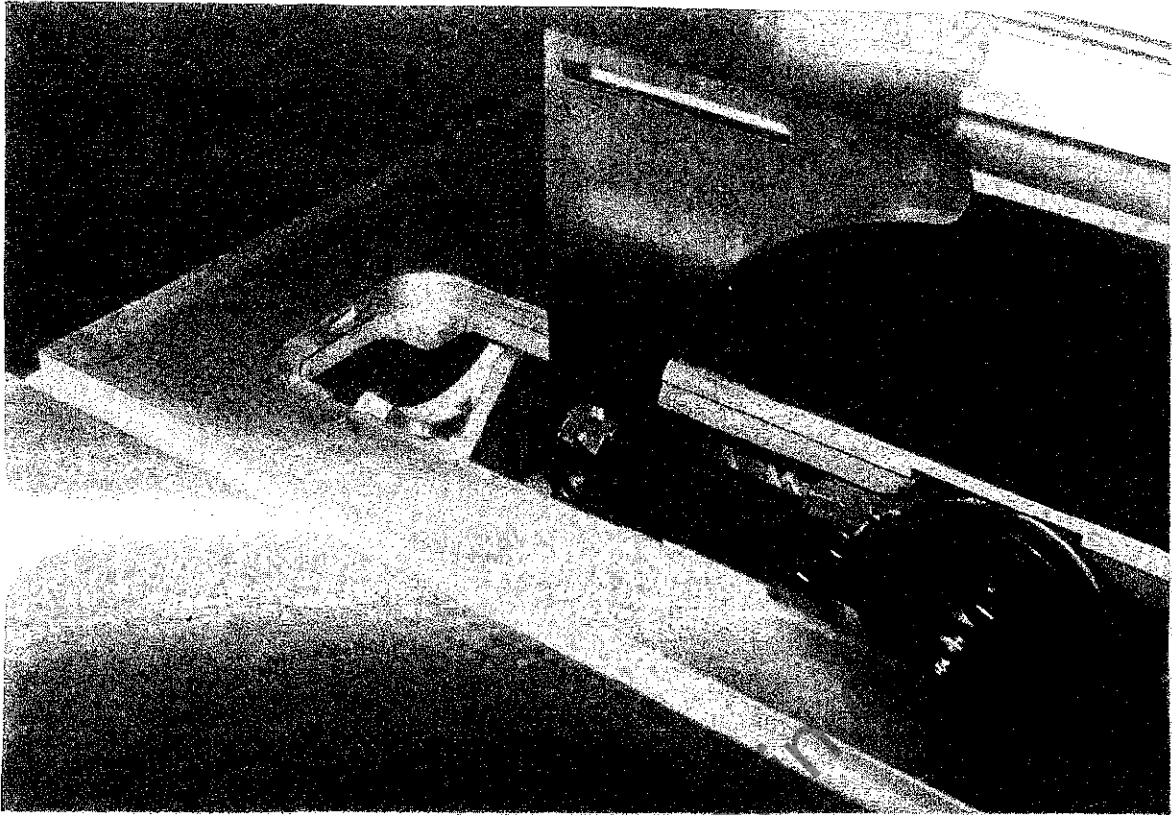


FIG. 8

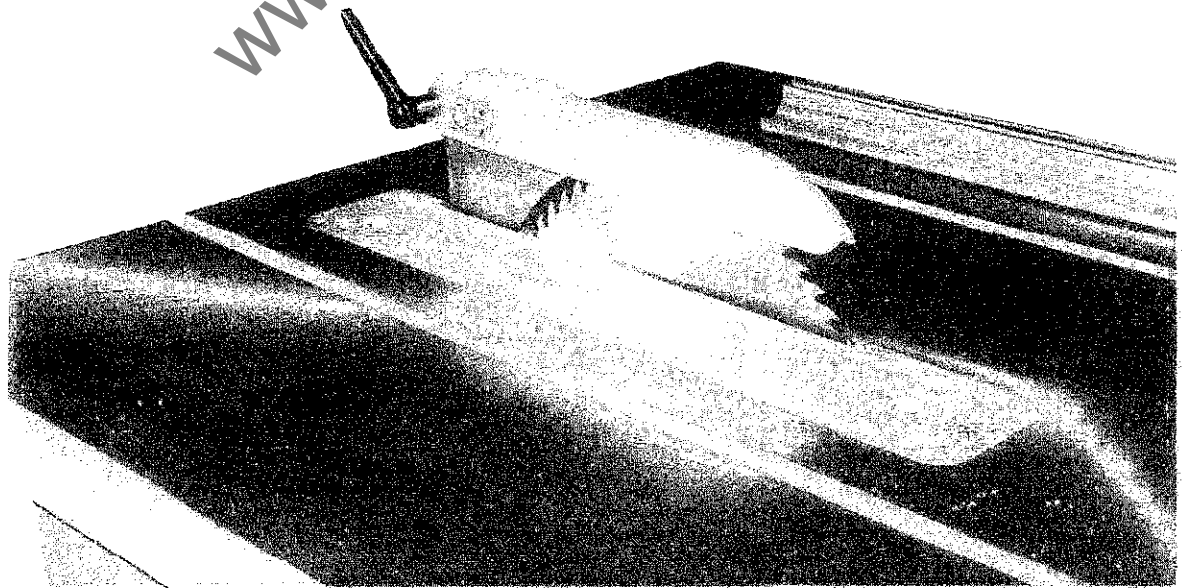


FIG. 9



#### 4.4.3 Re-assembly of Riving Knife and Sawguard

- a) Remove table insert.
- b) Loosen M16 locking screw and position riving knife between pressure plate and guide plate FIG.8.
- c) Tighten securely M16 locking screw.
- d) Replace table insert.
- c) Fit sawguard as shown in FIG.9.

#### 4.5 Electrical

##### 4.5.1 Wiring Connections

The motor and control gear have been wired in before despatch, all that is required is to connect the power supply to the starter or isolating switch when fitted.

Points to note when connecting power supply:-

- a) Check the voltage, phase and frequency correspond to those on the motor plate.
- b) It is important that the correct cable is used to give the correct voltage to the starters, as running on low voltage will damage the motors.
- c) Check the main line fuses are of the correct capacity. See fuse list. (Refer to 4.5.2)
- d) Connect the line leads to the appropriate terminals. See wiring diagrams. (Refer to 4.5.3).
- e) Check all connections are sound.
- f) Check rotation of all motors for the correct direction. If these are incorrect, reverse any two of the incoming mains leads connections.

##### 4.5.2 Fuse List

###### Direct on Line

<u>Voltage</u>	<u>Phase</u>	<u>KW</u>	<u>SWG Tinned Copper Wire</u>	<u>Amps per Phase</u>
220	3	5.5	13	120
380	3	5.5	15	70
415	3	5.5	18	47

Star Delta

<u>Voltage</u>	<u>Phase</u>	<u>KW</u>	<u>SWG Tinned Copper Wire</u>	<u>Amps per Phase</u>
380	3	5.5	21	29
415	3	5.5	23	18

4.5.3 Wiring Diagrams

See wiring diagrams in rear of instruction manual.

4.6 Dust Extraction Details4.6.1 Main Extraction

The extraction outlet is situated at the rear of the machine. The outlet size is 100mm dia and should be connected to a flexible extraction hose from the main plant. The volume of air to be extracted is 206 LPS (436 CFM) with a velocity of 26 MPS (5,000 ft per min).

4.6.2 Crown Guard Extraction (Extra)

The extraction outlet on crown guard 100mm dia and should be connected to a flexible extraction hose from the main plant. The volume of air to be extracted is 206LPS (436CFM) with a velocity of 26 MPS (5,000 ft per min).

## 5.0 **CONTROLS**

### 5.1 **Rise & Fall**

- a) Release locking handle "A" FIG.10 and raise or lower the saw arbor by the handwheel "B" FIG. 10 to the required position, then relock locking handle "A".

### 5.2 **Canting**

The saw cant 45° to the right with positive stops at 90° and 45°.

- a) Release locking handle "C" FIG.10 and turn handwheel "D" working in conjunction with the canting scale indicated by the pointer "E" to required saw position. Relock locking handle "C".

### 5.3 **Sawguard and Riving Knife Adjustment**

The riving knife and sawguard rise and fall with the saw. The riving knife should be adjusted to the closest practicable distance from the saw.

- a) Isolate machine electrically.
- b) Remove table insert.
- c) Loosen M16 locking screw "F" FIG.11 and move riving knife "G" to correct position.
- d) Tighten securely locking screw "F".
- e) Replace table insert.

**NOTE:** The sawguard should then be adjusted to cover as much of the saw as possible.

### 5.4 **Rip Fence**

The rip fence slides on a round bar fitted to the front of the table. Rapid fence adjustment and micro-adjustment are provided with an effective lock.

#### 5.4.1 **Rapid Fence Adjustment**

- a) Loosen locking handle "J" FIG.10.
- b) Position fence where required then turn locking handle "J" to lock fence in position. A ripping capacity scale on fence slide bar "K" is indicated by an adjustable pointer "L" located in the fence body and secured by socket capscrew "M".
- c) Relock locking handle "J".

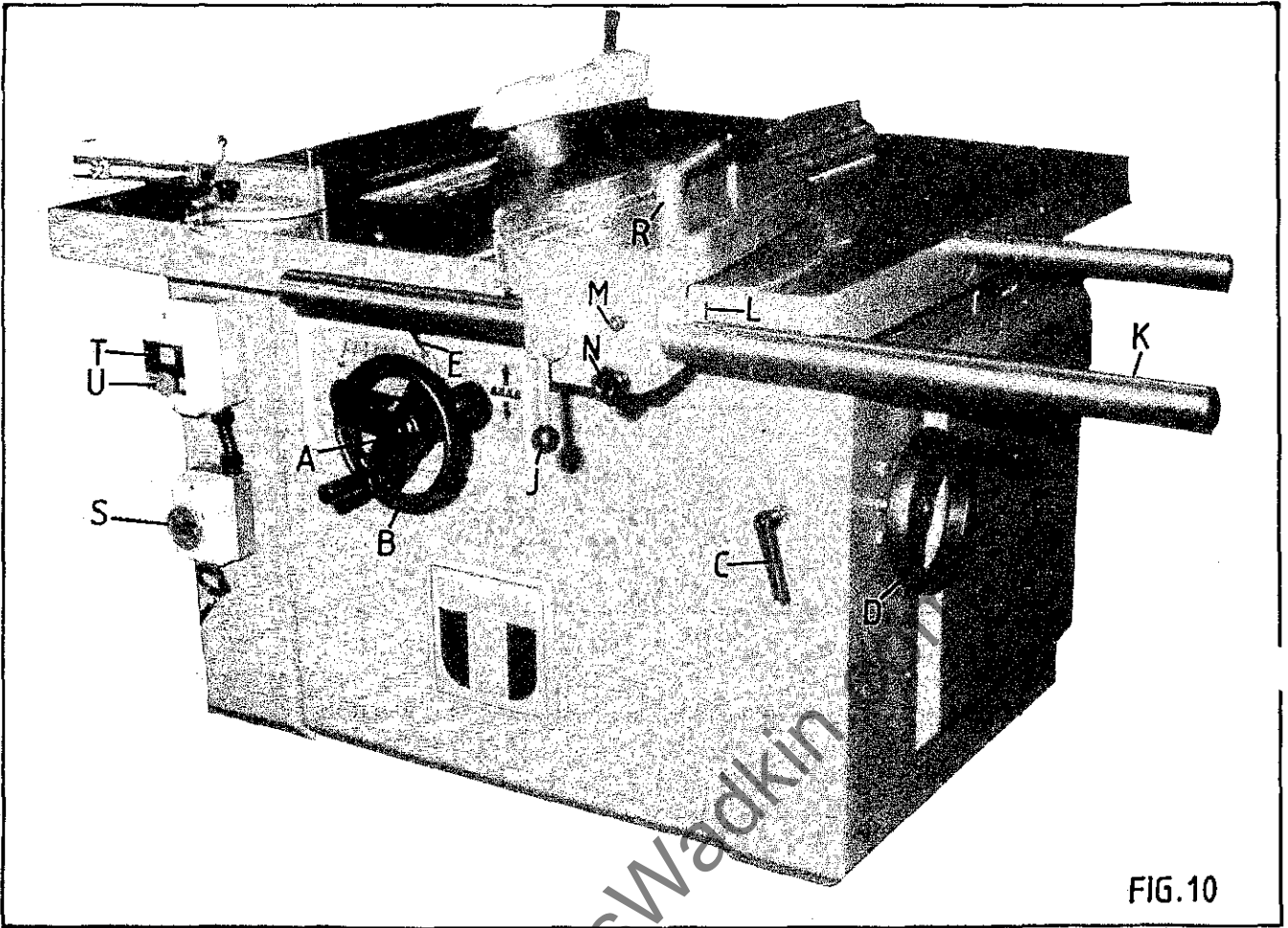


FIG.10

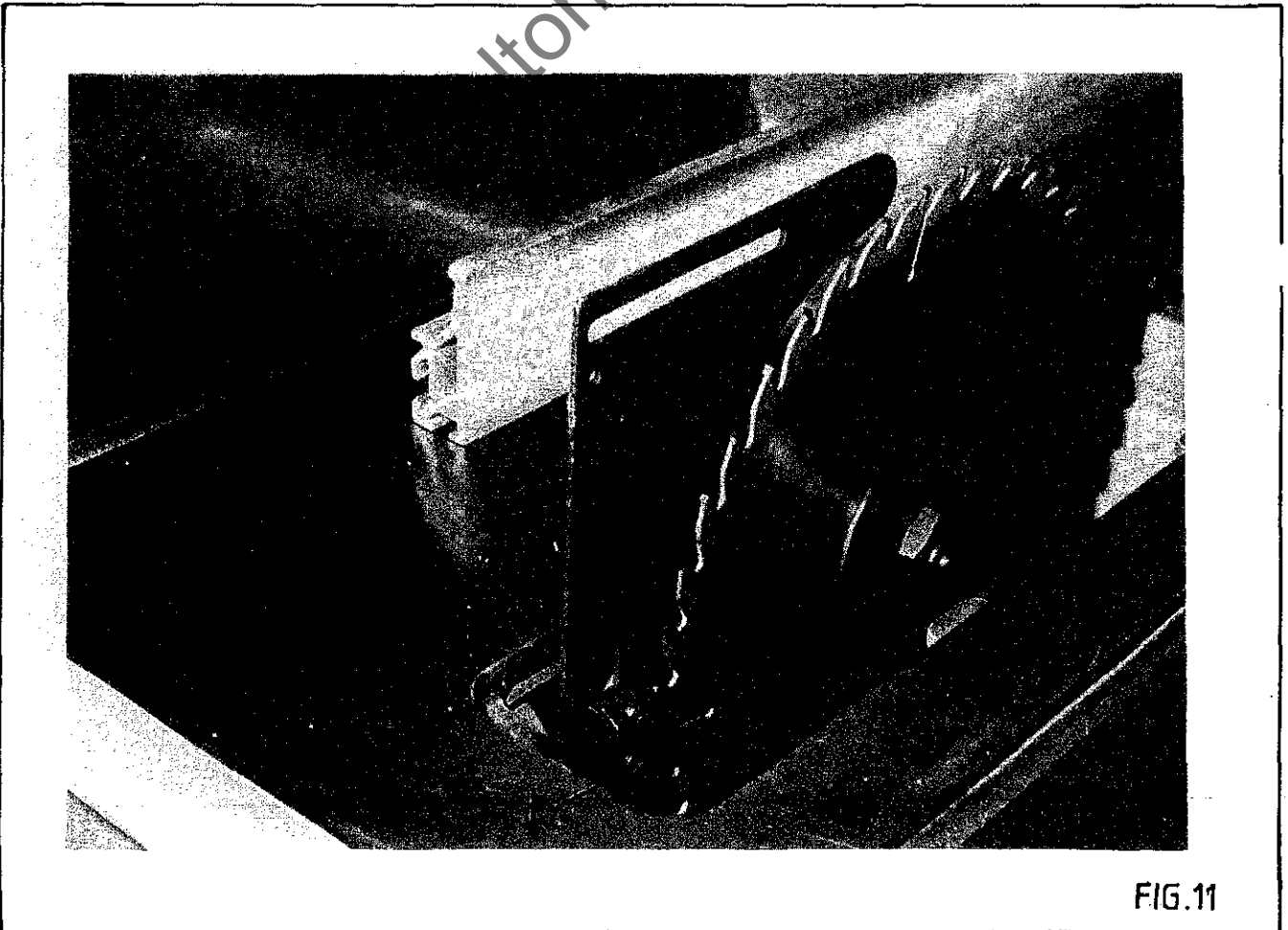


FIG.11

#### 5.4.2 Micro Fence Adjustment

- a) Loosen locking handle "J".
- b) Engage spring loaded handwheel "N" in the racked fence slide bar "K".
- c) Relock locking handle "J".

#### 5.4.3 Fence Plate Positions

The fence plate "P" FIG.10 has two positions. Position shown in FIG.10 is for use with deep stock, fence can be moved longitudinally to facilitate this. Position shown in FIG.12 is for use with faced panels, melamine, veneer, etc.

- a) To change fence plate position, loosen locking handle "R" FIG.10, then slide fence plate from fence body.
- b) Slide fence plate over the locking plate to position shown FIG.12, relock locking handle "R".

**NOTE:** When the fence plate position has been changed as previously described, the pointer "L" FIG.10, must be reset.

- c) To reset pointer, loosen locking handle "J" FIG.10, then move fence to a position which would allow a reasonable cut to be taken, relock locking handle "J".
- d) Start machine, then feed a piece of timber past the sawblade keeping timber firmly up against the fence. Stop machine.
- e) Accurately measure the width of timber, then loosen socket capscrew "M" and set rule pointer "L" accordingly. Relock socket capscrew "M".

#### 5.5 Electrical Controls

The control panel is shown in FIG.10. When isolator "S" FIG. is fitted, ensure it is in the 'ON' position before operating.

The saw is controlled by start and stop buttons "T" and "U" FIG.10.

#### 5.6 Fitting Tooling

##### 5.6.1 Main Sawblade

- a) Isolate machine electrically.
- b) Remove table insert.
- c) Raise saw spindle to uppermost position (Refer to 5.1).
- d) Lift and move forward undertable guard.
- e) Locate 8mm allen key (supplied) in main saw spindle as shown FIG.13, then remove spindle nut (left hand thread) with spanner (supplied) and front saw flange.

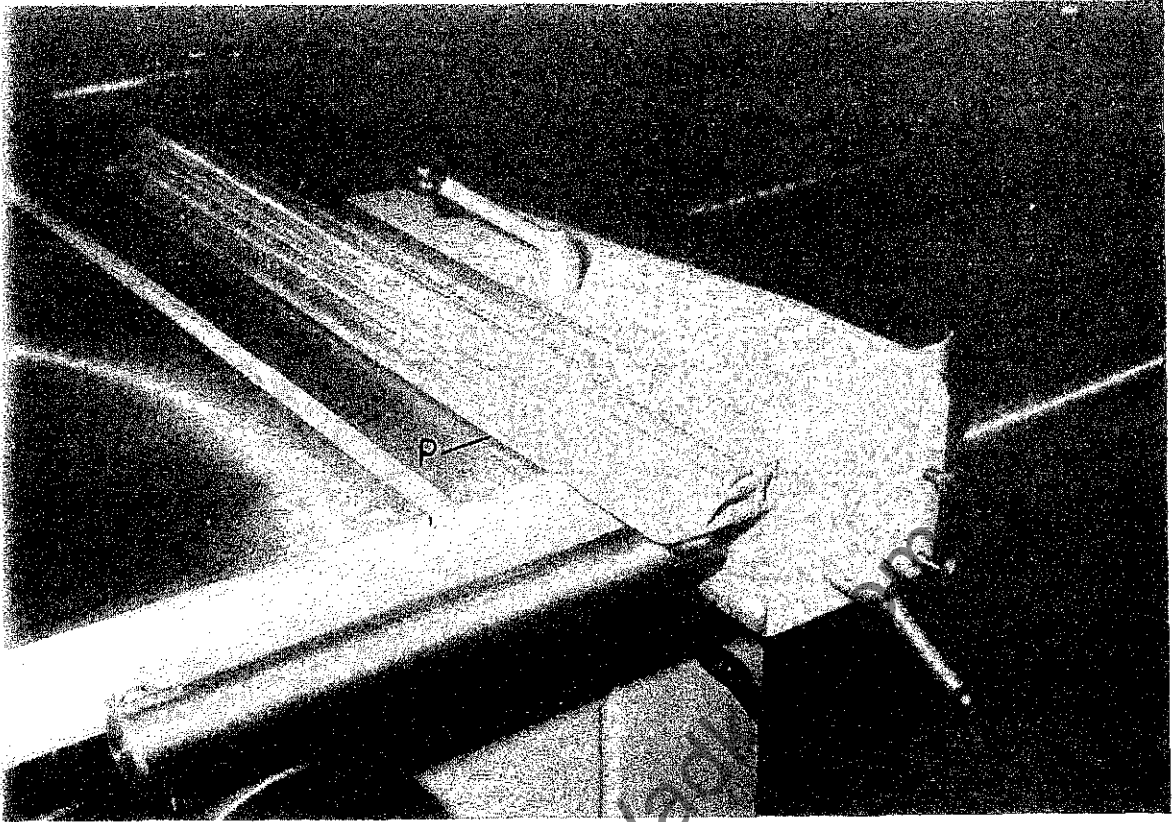


FIG.12

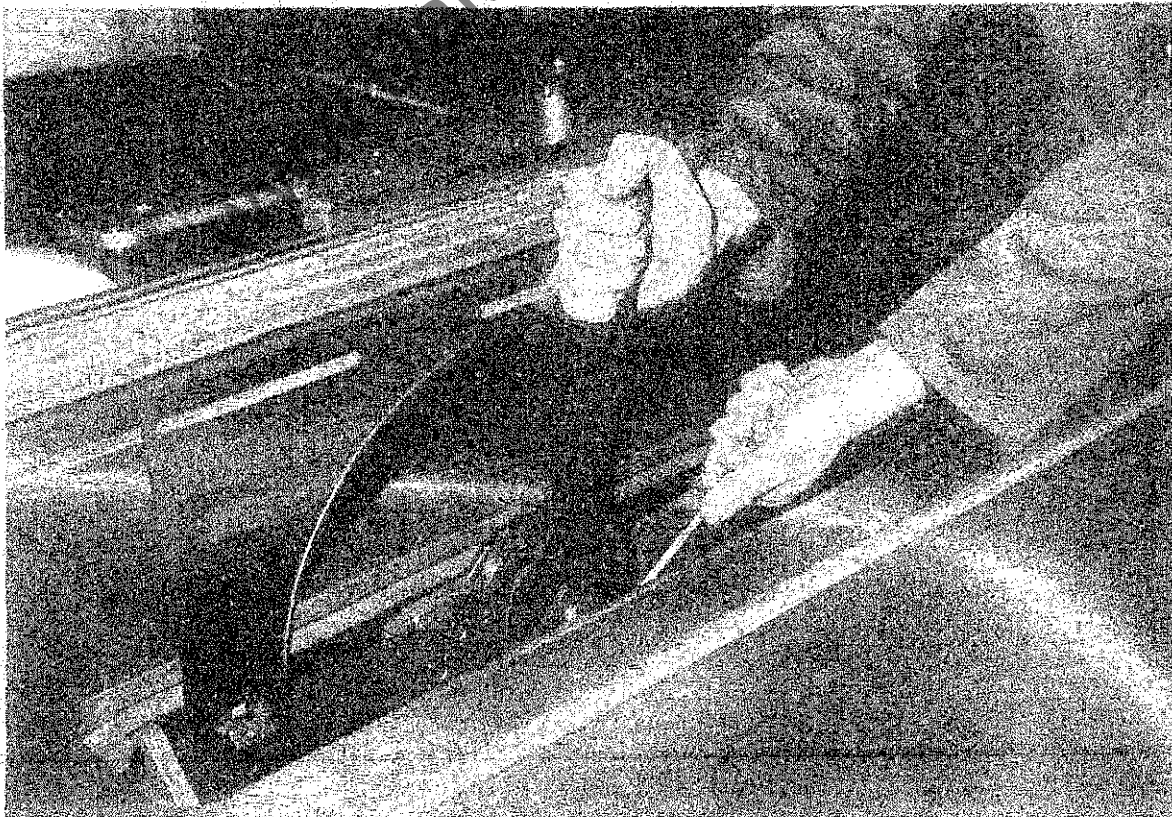


FIG.13

### 5.6.1 Main Sawblade (Continued)

- f) Select required blade and check blade is free from dirt, gum or sawdust, especially where it will be gripped by saw flanges. Check rear saw flange is clean and fit sawblade on spindle.

**NOTE:** Saw teeth must point towards front of machine.

- g) Check front saw flange is clean and fit on spindle.

**NOTE:** If flanges and saw are not clean, the saw will run out of true, causing vibration.

- h) Lock saw securely in position with spindle nut (left hand thread) as shown in FIG.14.

- i) Replace table insert.

- j) Position sawguard depending on thickness of timber to be worked.

**IMPORTANT:** Sawguard must cover as much as is practicable. Clearance between sawguard and timber should never exceed 12mm FIG.15 (Woodworking Machine Regulations 1974 16(3)).

www.DaltonsWadkin.com

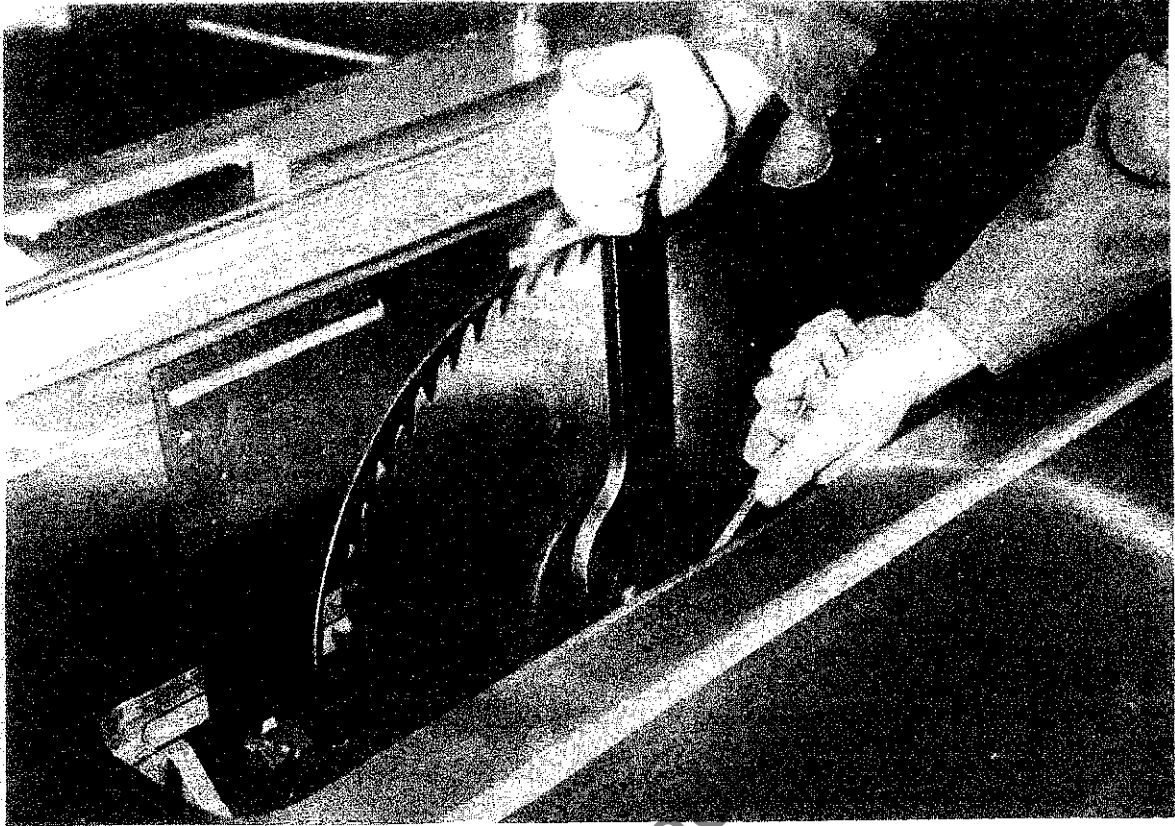


FIG.14

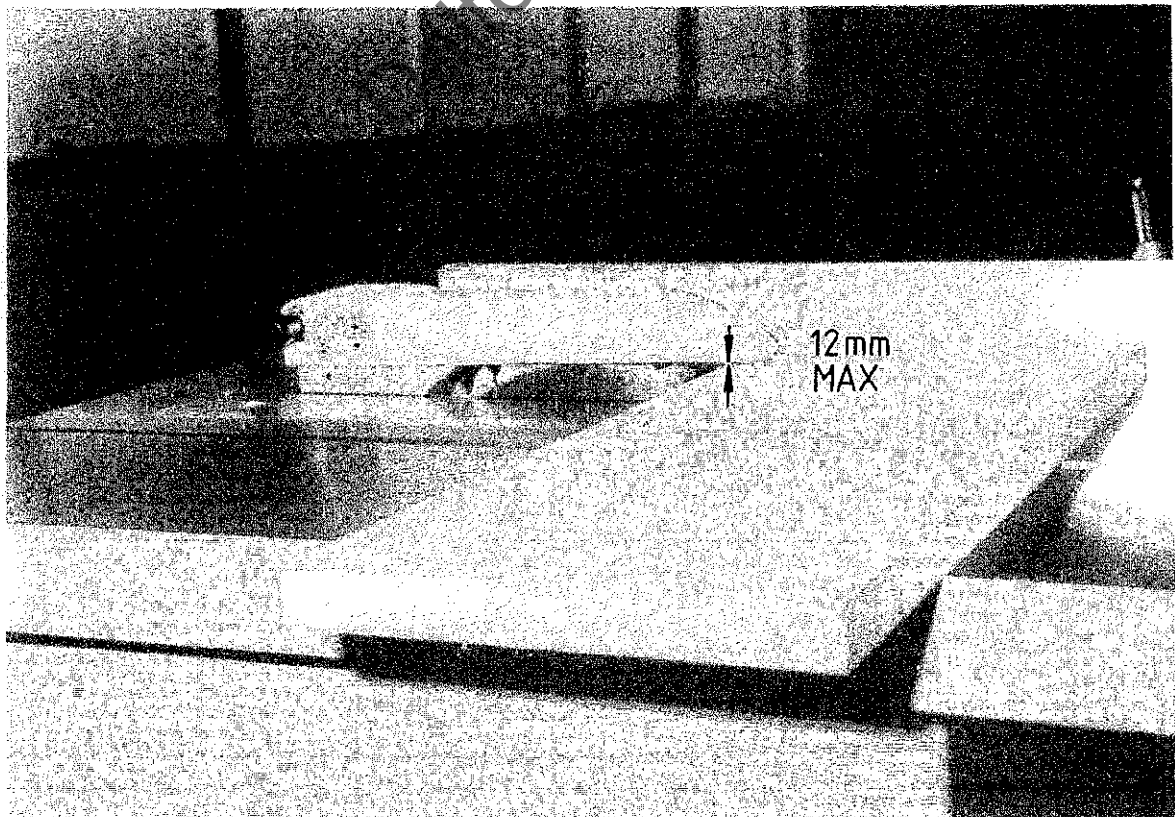


FIG.15



6/1

## 6.0 USE OF MACHINE

### 6.1 Ripping

- a) Slide rip fence to cutting width required (Refer to 5.4).
- b) Ensure sawguard, riving knife and saw are correctly adjusted (Refer to 5.3 and 5.6.1).

**NOTE:** Use correct sawblade when ripping (Refer to 8.2).

- c) Use a wood push stick FIG.16 (Refer to 2.1 and 2.2) as much as practicable when feeding timber to avoid accidents.

### 6.2 Mitre Fence

The mitre fence "A" FIG.17 slides in either of two table slots and can be used at either side of the sawblade. Two stop rods "B" are held together by two clamps "C" and wingnuts "D". The stop rods are secured to the fence body by either of the two thumbscrews "E" depending on which side of fence body the rods are used.

**NOTE:** Always ensure the stop rods are set clear of the sawblade or serious damage will result when machine is operated.

The mitre fence can be rotated through 90° with positive stops at 90° and 45°.

To position mitre fence at required angle, loosen handwheel "F" FIG.17, then pull plunger "G" from location, position fence as required using scale "H", then relock handwheel "F".

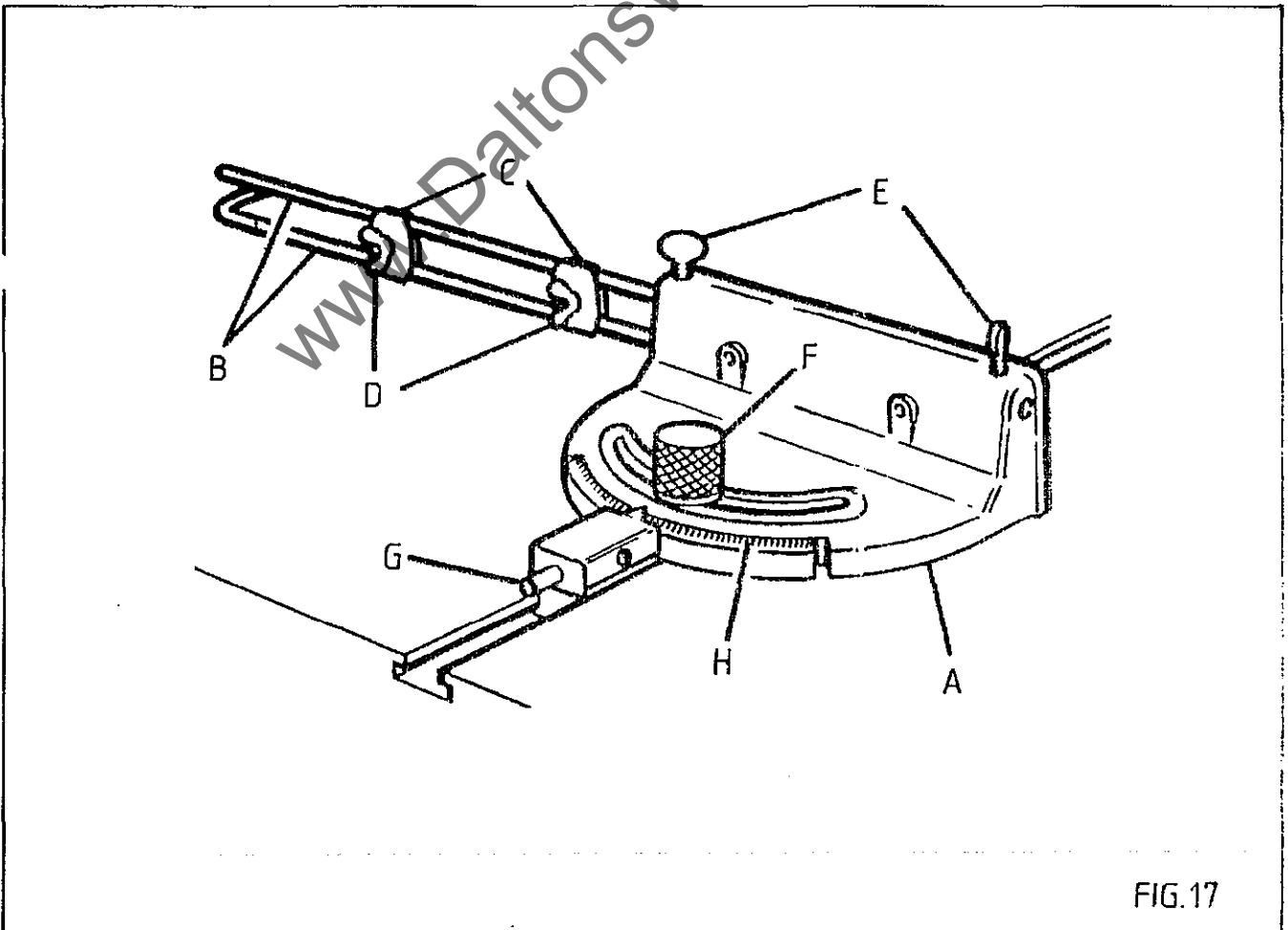
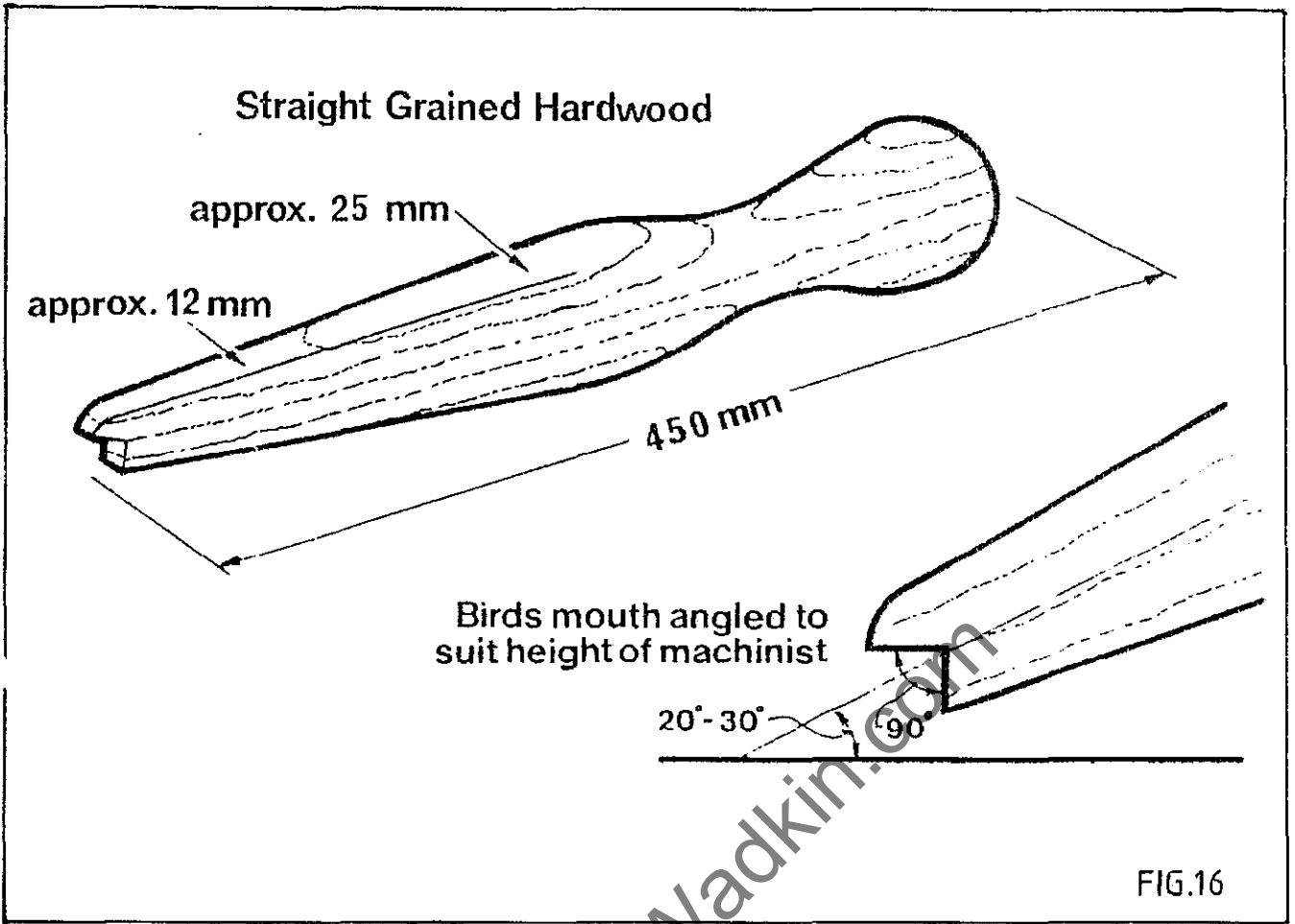
**NOTE:** Always ensure table slot is clean when using mitre fence.

#### Use of Mitre Fence Stop Rods

Accurate repetitive cutting can be made using the stop rods, see FIG.18.

The rods are held in the fence by thumbscrews "E" FIG.17 and the stop rods held together by the two clamps "C". See FIG.18 for several positions in which the stop rods can be used.

**NOTE:** Take care that the stop rods are always clear of the saw or serious damage will result.



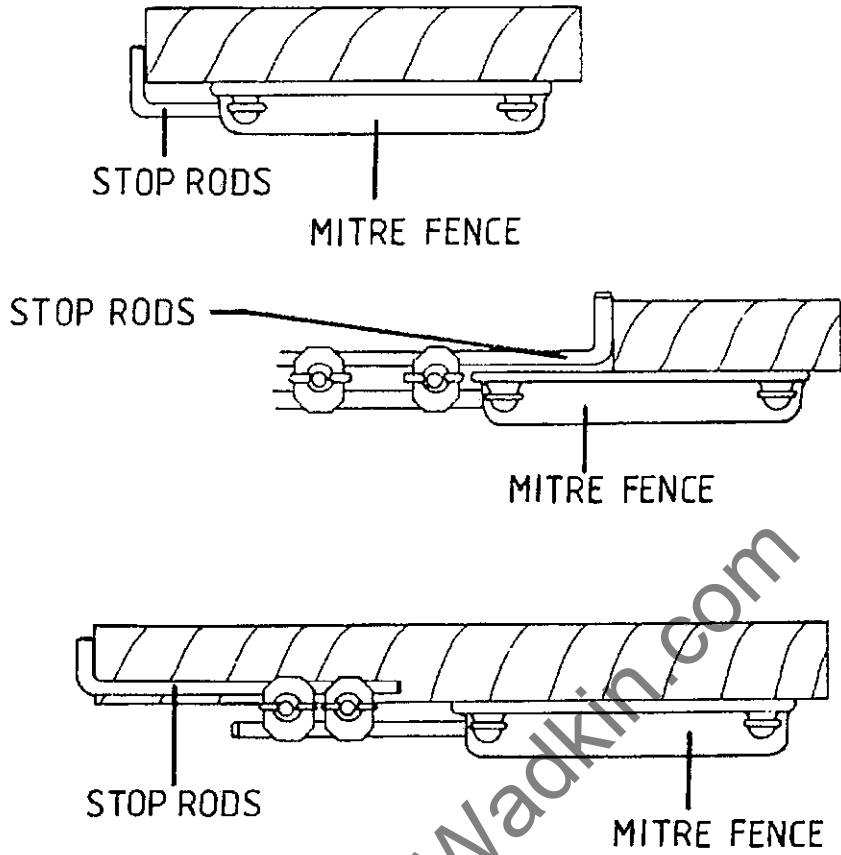


FIG.18

www.DaltonsWadkin.com

## 7.0 MAINTENANCE

### 7.1 Lubrication

The majority of machine working parts are designed to require no lubrication.

- a) Oil rise and fall screw, canting screw and slides on a weekly basis.
- b) From time to time clean saw spindle with a resin solvent and lightly oil. It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

For approved lubricants, see page 7/6.

### 7.2 General

Regularly clear chips and dust from inside the machine.

### 7.3 Setting Main Table in Line with Saw

The table grooves are preset at works, if for any reason the table has been disturbed, the undermentioned procedure should be followed:

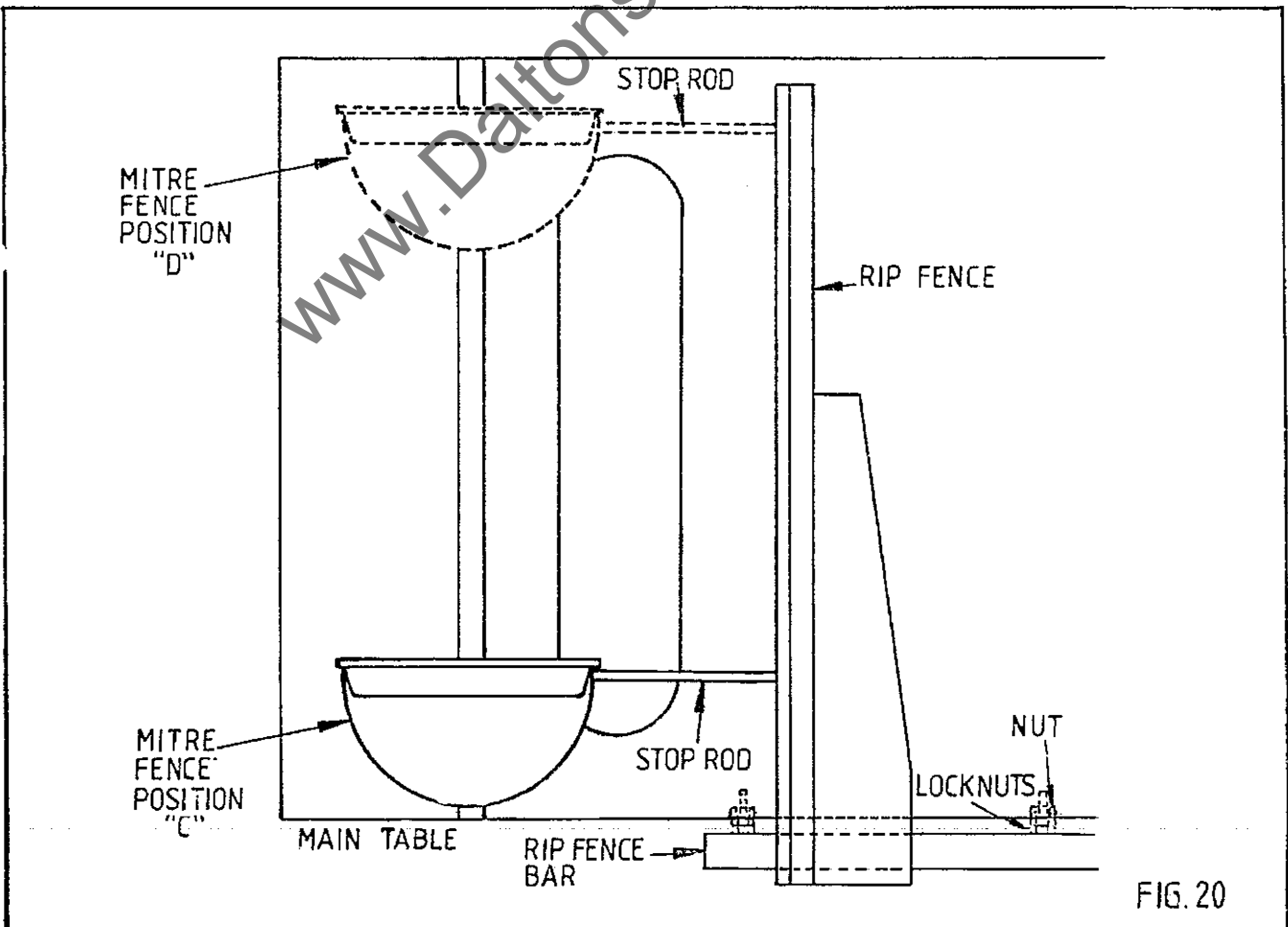
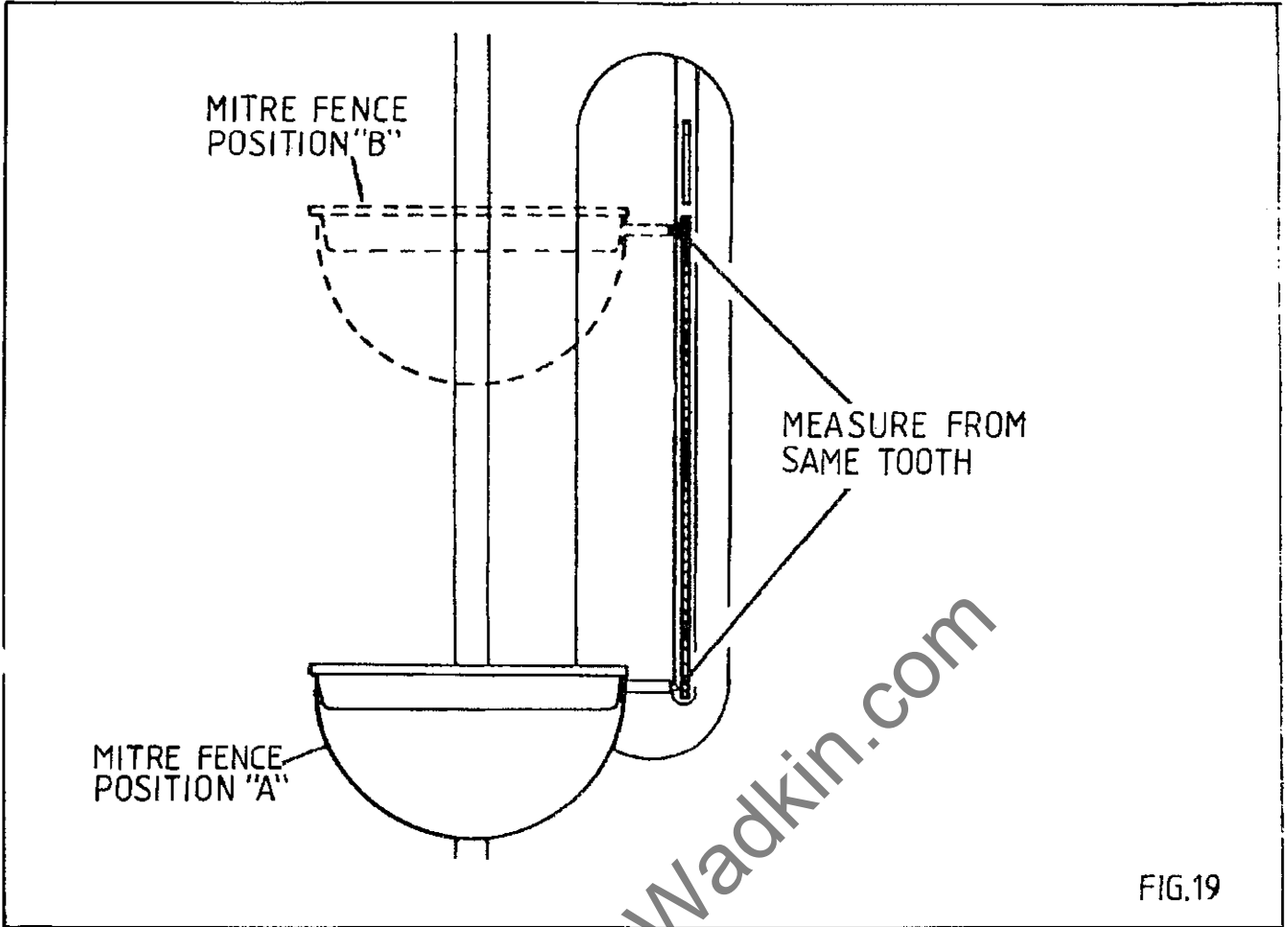
- a) Isolate machine electrically.
- b) Loosen the 4 - M10 nuts securing the main table to the base.
- c) With the saw fitted to the arbor (refer to 5.6.1), select a tooth and position straight stop rod of mitre fence (refer to 6.2), so that it touches saw in position "A" FIG.19.
- d) Slide mitre fence to rear position 'B' of the saw, swing tooth of saw which was mentioned in item c) above. Check whether stop rod touches the tooth.
- e) If stop rod is touching, position table until a lead off of .002"/.004" from position 'B'.
- f) The correct position of saw in relation to the table insert slot is 25.4mm (1") from the right hand side. This will ensure clearance on table insert when the saw is canting.
- g) When set, retighten 4 - M10 nuts.
- h) To check this alignment, cut several pieces of wood using the mitre fence to ensure there is no back cut as the stock is passed through the sawblade.

### 7.4 Setting Rip Fence

The rip fence is preset at works, if for any reason the rip fence has been disturbed, the undermentioned procedure should be followed.

**NOTE:** Ensure saw is parallel to table slot (refer to 7.3)

- a) Isolate machine electrically.
- b) Remove sawguard, riving knife and saw (ref to 4.4.3 and 5.6.1).



7.4 Setting Rip Fence (Continued)

- c) Slide rip fence towards table insert (refer to 5.4).
- d) Position straight stop rod of mitre fence so that it touches rip fence plate in position "C" FIG.20.
- e) Slide mitre fence to rear position "D". Check whether the stop rod touches the rip fence plate.
- f) If stop rod is touching, loosen locknuts on the two bolts holding the rip fence bar.
- g) Reset rip fence until a lead off of .004"/.006" from position "D".
- h) When set retighten locknuts in new position and retighten nut behind main table.

7.5 Setting Saw to Riving Knife

The saw spindle is preset at works and requires no adjusting unless saw is cutting out of line.

- a) Isolate machine electrically.
- b) Cant saw to 45° (refer to 5.2).
- c) Open access door.
- d) Loosen hexagon head bolt "E" FIG.21 and tap spindle (with hide face hammer) as required, taking care not to damage the threads on spindle ends.
- e) Cant the saw to 90°.
- f) Place a steel rule along both sides of riving knife to check saw is central.
- g) When set, retighten the hexagon head bolt "E".
- h) Close access door.
- i) To check this setting, feed a short piece of timber from the rear, along both sides of the riving knife. If riving knife is set correctly, the blade will cut equal shoulders as shown in FIG.22A and when set incorrectly, unequal shoulders as shown in FIG.22B.

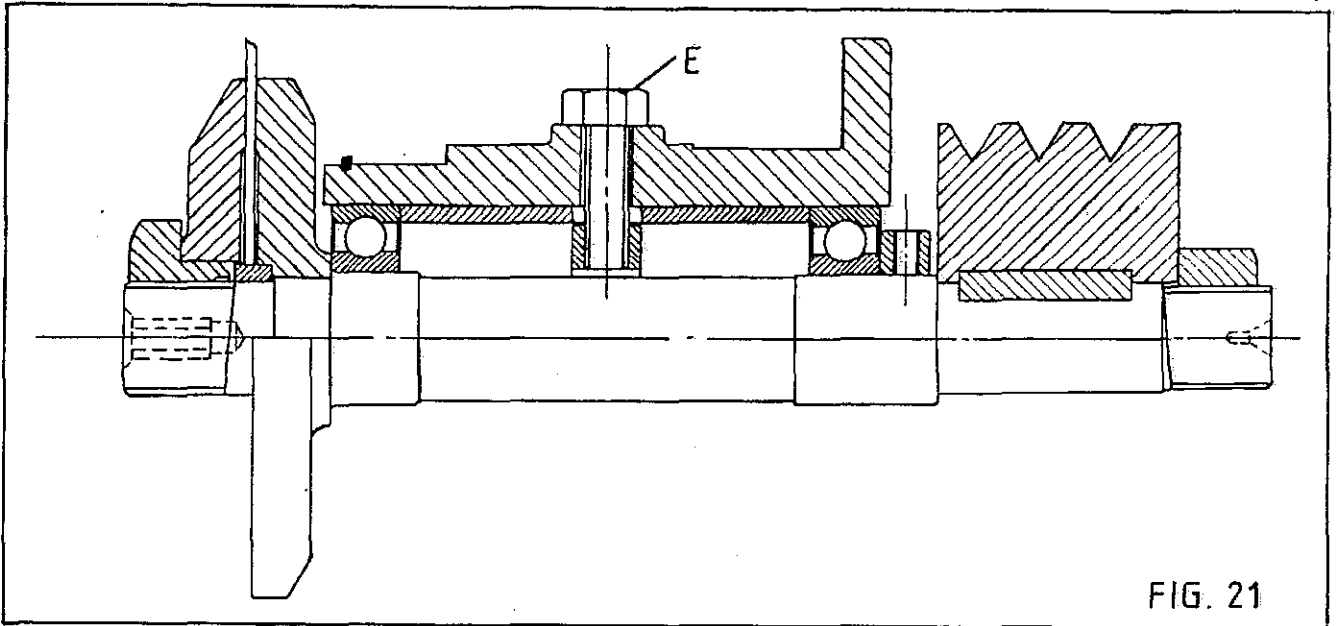


FIG. 21

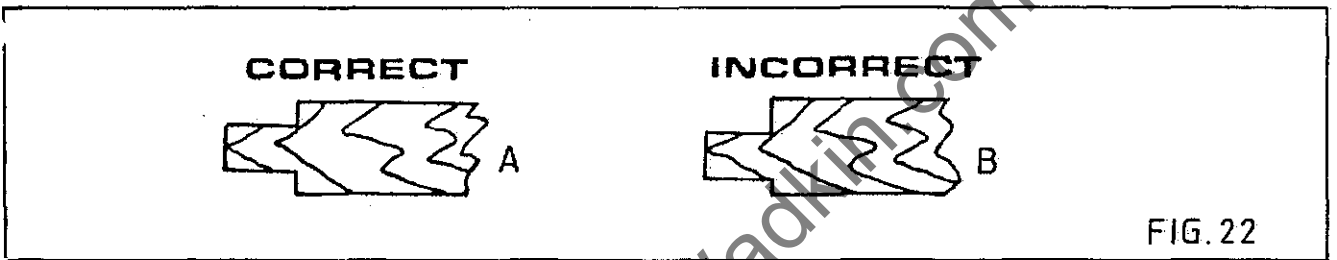


FIG. 22

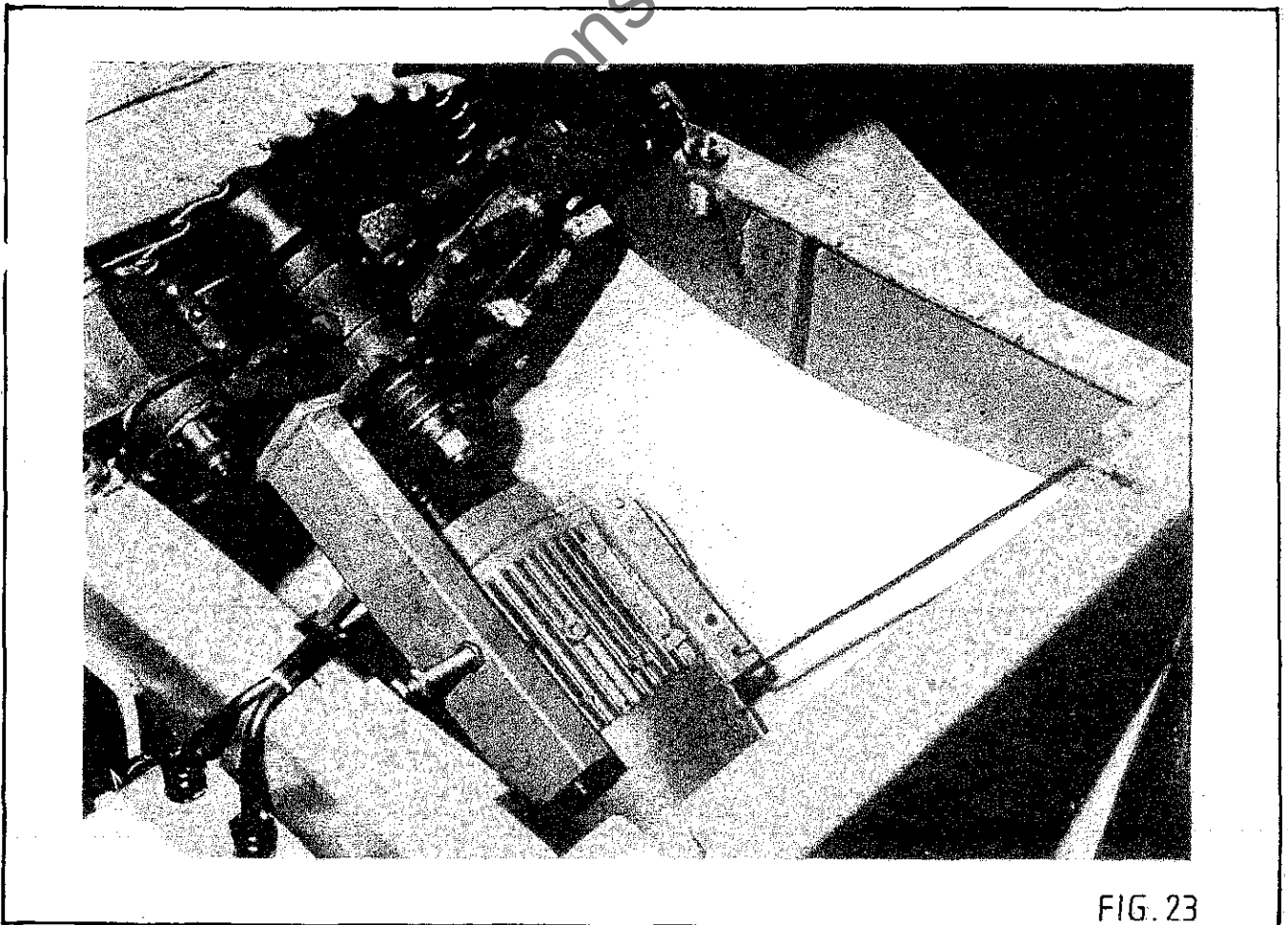


FIG. 23

7/5

## 7.6 Belt Changing

The saw spindle is driven by 3 Vee belt from a 5.5 kw or 7.5 kw motor, giving a speed of 3000 rpm.

To change belts, proceed as follows:-

- a) Isolate machine electrically.
- b) Lower saw spindle approximately to mid position (refer to 5.1).
- c) Open access door.
- d) Cant saw spindle to approximately  $45^{\circ}$  (refer to 5.2).
- e) Position tension stay FIG.23 into hole on motor foot.
- f) Continue canting saw spindle until tension on belts is released. Change belts.
- g) Reverse above procedure.

**NOTE:** Main table is removed for photographic purposes only.

www.DaltonsWadkin.com



Application	APPROVED LUBRICANTS					
	Castrol	B.P.	Shell	Esso	Texaco/Caltex	Wadkin
Worm Boxes	ZN220	Energol CS320	Vitrea 320	Spartan EP220	Regal Oil 320	L2
General Lubrication	Magna 68	Energol HP68	Vitrea 68	Nuray	Ursa Oil P68	L4
Pneumatic Lubricators	Hvsprin AWS32	Energol HL32	Tellus 37	Nuto H32	Rando Oil HD32	
Grease	Spheerol AP3	Energol L53	Alvania R3	Beacon 3	Regal Starfalk Premium 3	L6
Brake Cables	Brake Cable Grease	Energol L21M	Alvania R3	Esso Multi-Purpose Grease		

**8.0 SPARES**

**8.1 Instructions When Ordering Spare/Replacement Parts**

The undermentioned information should be given with all orders requesting spare/replacement parts.

- a) Machine type.
- b) Machine serial number.
- c) Part number of required parts, as stated in the instruction manual.
- d) If no manual available, as full a description as possible of the required part, including location within the machine.
- e) Order number and full company name and address.
- f) Company account number, with **Wadkin**, if known.
- g) All telephone orders must be followed by an official order, clearly marked "Confirmation Order".

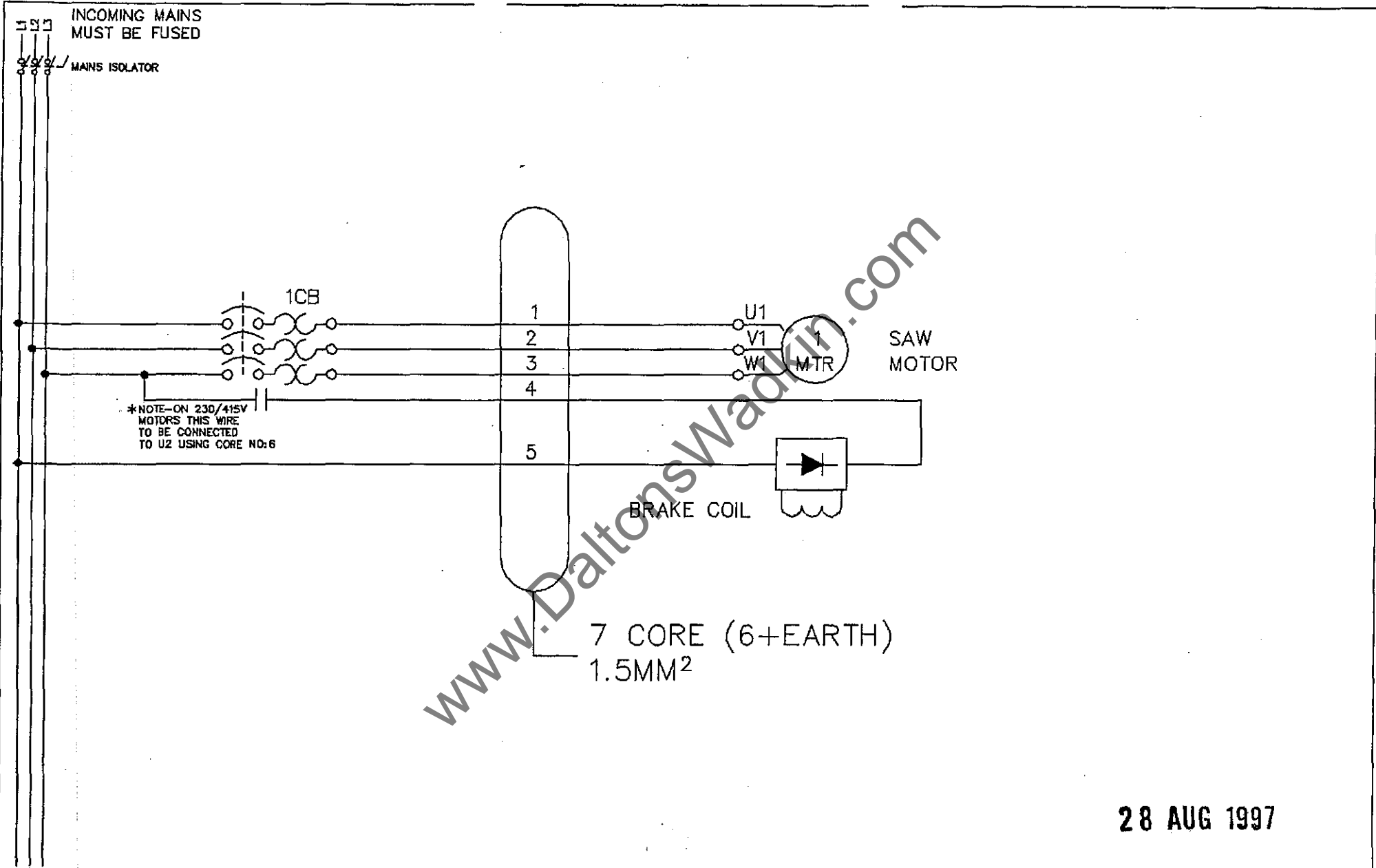
**NOTE:** The company operate a 'Minimum Order Charge' on all spare/replacement part orders.

**8.2 Sawblades**


For best results, we recommend the purchase of sawblades from Wadkin Durham.

400mm dia x 30mm bore alloy rip sawblade	B-S-239
400mm dia x 30mm bore TCT rip sawblade	B-S-382
400mm dia x 30mm bore alloy crosscut sawblade	B-S-240
300mm dia x 30mm bore alloy rip sawblade	B-S-383
300mm dia x 30mm bore TCT rip sawblade	B-S-384
300mm dia x 30mm bore TCT crosscut sawblade	B-S-305

**NOTE:** When using 300 diameter sawblade, standard riving S40-18 must be replaced by riving knife P32-353 (which can be obtained at an additional charge).



28 AUG 1997

 <p>LEICESTER WOODWORKING DIVISION</p>	Data	Sig.	C	Date	Sig.	B	Date 28/8/97	Sig. KM	A	Description	Drawn K.MOBBS	Drawing No.	
							*NOTE-ADDED			AGS/SP WITH BRAKE	Aprd.R.PATEL	D6974	
										CAD Location N:\ACAD\DR\ELECT00\ELECSTD\ESTD1857	W.O. No	Date 31/01/97	SHEET 01

Date: 28/10/98

Time: 13:59:07

PART NO. ENQUIRY

Pgm: FN001R

User: ACOWLES

105 AGS C

250/300 CE 3HP 380/415

EA

BO

CLEL03

Part No Explosion

<u>D</u>	<u>Part Number</u>	<u>Description</u>	<u>IGC</u>	<u>C</u>	<u>Qty</u>	<u>FL</u>	<u>Gen Arr</u>	<u>P/N</u>	<u>RM</u>
Z	K1225808	TELE 4-6.3AMP C/B GV2	BO		1.000				
Z	K1225814	TELE SIDE AUX 1NC/1NO GV2	BO		1.000				
Z	K1225818	TEL U/V TRIP 380-415V/50	BO		1.000				
Z	K1225820	MUSHROOM HEAD LATCH GV-2	BO		1.000				
Z	K1225821	GV2 ENCLOSURE MC01	BO		1.000				
Z	X5117241	KM P1-25/1/SVB LOCKABLE I	BO		1.000				

<-END->

+

105 AGS C

4-©

2 Sess-1

199.5.83.158

MW

DOC

24/33

Date: 18/11/98	PART NO. ENQUIRY		Pgm: PNO01R
Time: 14:01:09	105 AGS M	250/300 CE 3HP 380/415	User: ACOWLES
		Part No Explosion	EA SEC
<u>D Part Number</u>	<u>Description</u>	<u>IGC C</u>	<u>Qty</u> <u>FL</u> <u>Gen Arr</u> <u>P/N RM</u>
Z K5115128	10AGS/3/2.2/220/380/50BRK BO		1.000
<-END->			
†			
4-©	2 Sess-1	105 AGS M 199.5.83.158	MW DOC 24/33

Date: 28/10/98 Pgm: PN001R  
 Time: 13:59:17 PART NO. ENQUIRY User: ACOWLES  
 106 AGS C 250/300 5.5HP CE 380/415 EA BO

Part No Explosion

D Part Number	Description	IGC C	Qty	FL	Gen Arr	P/N RM
Z K1225809	TELE 6-10AMP C/B GV2	BO	1.000			
Z K1225814	TELE SIDE AUX 1NC/1NO GV2	BO	1.000			
Z K1225818	TEL U/V TRIP 380-415V/50	BO	1.000			
Z K1225820	MUSHROOM HEAD LATCH GV-2	BO	1.000			
Z K1225821	GV2 ENCLOSURE MC01	BO	1.000			
Z K5117241	KM PI-25/I/SVB LOCKABLE I	BO	1.000			

<-END->

+

Date: 18/11/98  
Time: 14:01:37  
106 AGS M 250/300 5.5HP CE 380/415 EA SEC  
PART NO. ENQUIRY  
User: ACOWLES  
Pgm: PNO01R  
Part No Explosion

<u>D Part Number</u>	<u>Description</u>	<u>IGC</u>	<u>C</u>	<u>Qty</u>	<u>FL</u>	<u>Gen Arr</u>	<u>P/N</u>	<u>RM</u>
Z K5115188	BEL 4KW 380/415 BRK MTR S BO			1.000				

<-END->

Date: 28/10/98

Time: 13:58:44

PART NO. ENQUIRY

Pgm: PN001R

User: ACOWLES

108 AGS C

AGS400 7.5HP CE UK

EA

BO

CLEL04

Part No Explosion

<u>D</u>	<u>Part Number</u>	<u>Description</u>	<u>IGC</u>	<u>C</u>	<u>Qty</u>	<u>FL</u>	<u>Gen Arr</u>	<u>P/N RM</u>
Z	K1225809	TELE 6-10AMP C/B GV2	BO		1.000			
Z	K1225814	TELE SIDE AUX 1NC/1NO GV2	BO		1.000			
Z	K1225818	TEL U/V TRIP 380-415V/50	BO		1.000			
Z	K1225820	MUSHROOM HEAD LATCH GV-2	BO		1.000			
Z	K1225821	GV2 ENCLOSURE MC01	BO		1.000			
Z	K5117241	KM P1-25/I/SVB LOCKABLE I	BO		1.000			

<-END->

108 AGS C

4-©

2 Sess-1

199.5.83.158

MW

DOC

24/33



Date:	18/11/98								
Time:	14:01:20	<u>PART NO. ENQUIRY</u>					Pgm:	PN001R	
	108 AGS M	AGS400	7.5HP	CE	UK	EA	User:	ACOWLES	
		<u>Part No Explosion</u>						SEC	
<u>D</u>	<u>Part Number</u>	<u>Description</u>	<u>IGC</u>	<u>C</u>	<u>Qty</u>	<u>FL</u>	<u>Gen Arr</u>	<u>P/N</u>	<u>RM</u>
Z	K5115189	BCC 5.5KW 380/415/3/50 BR	BO		1.000				
	<-END-->								
									+
			108	AGS	M				
4-©	2	Sess-1	199.5.83.158			MW		DOC	24/33