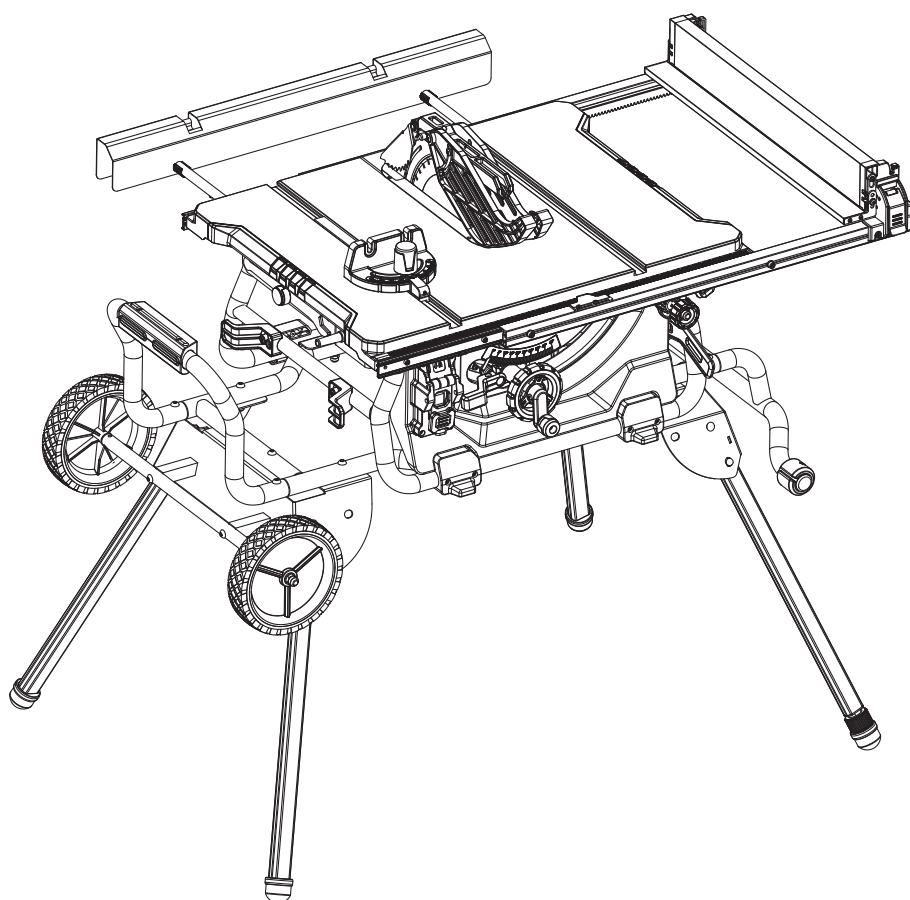


HiKOKI

Model **C 10RJ (X)**

Table Saw



SAFETY INSTRUCTIONS AND INSTRUCTION MANUAL

⚠ WARNING











IMPROPER OR UNSAFE use of this power tool can result in death or serious bodily injury!
This manual contains important information about product safety. Please read and understand this manual **BEFORE** operating the power tool. Please keep this manual available for other users and owners before they use the power tool. This manual should be stored in safe place.

CONTENTS

SECTION	PAGE
SYMBOLS	3
SAFETY INSTRUCTIONS	4
OVERVIEW	8
SPECIFICATIONS.....	10
LOOSE PARTS	11
ASSEMBLY	12
OPERATION	22
ADJUSTMENTS	29
MAINTENANCE	31
TROUBLESHOOTING	32
SELECTING ACCESSORIES	32
GUARANTEE	32

SYMBOLS

The following show symbols used for the machine. Be sure that you understand their meaning before use.

Symbol	Meaning
	C 10RJ (X): Table saw
	To reduce the risk of injury, user must read instruction manual.
	Always wear eye protection.
	Always wear hearing protection.
	Danger keep hands away from blade.
	Never operate the tool in a damp or wet environment.
	Lock / to tighten or secure.
	Unlock / to loosen.
V	Volts
Hz	Hertz
A	Amperes
n_0	No load speed
---/min	Revolutions per minute
W	Input power
kg	Kilogram
dB(A)	Decibel (A-rated)
~	Alternating current
	Class II Construction
	Caution, Warning or Danger.

SAFETY INSTRUCTIONS

General power tool safety warnings

⚠ WARNING: Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mainsoperated (corded) power tool or battery-operated (cordless) power tool.

1) Work area safety

- a) **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- b) **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- c) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

2) Electrical safety

- a) **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- c) **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- d) **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.
- e) **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduce the risk of electric shock.
- f) **If operating a power tool in a damp location is unavoidable, use a RESIDUAL CURRENT DEVICE (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.

3) Personal safety

- a) **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- b) **Use personal protective equipment. Always wear eye protection.** Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- c) **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- d) **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- e) **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- f) **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- g) **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related hazards.
- h) **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.

4) Power tool use and care

- a) **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- b) **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- c) **Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- d) **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- e) **Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- f) **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- g) **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.
- h) **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

5) Service

- a) **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This will ensure that the safety of the power tool is maintained.

Safety instructions for table saw

1) Guarding related warnings

- a) **Keep guards in place. Guards must be in working order and be properly mounted.** A guard that is loose, damaged, or is not functioning correctly must be repaired or replaced.
- b) **Always use saw blade guard, riving knife and anti-kickback pawls for every through-cutting operation.** For through-cutting operations where the saw blade cuts completely through the thickness of the workpiece, the guard and other safety devices help reduce the risk of injury.
- c) **Immediately reattach the guarding system after completing an operation (such as rabbeting) which requires removal of the guard, riving knife and/or anti-kickback pawls.** The guard, riving knife, and anti-kickback pawls help to reduce the risk of injury.
- d) **Make sure the saw blade is not contacting the guard, riving knife or the workpiece before the switch is turned on.** Inadvertent contact of these items with the saw blade could cause a hazardous condition.
- e) **Adjust the riving knife as described in this instruction manual.** Incorrect spacing, positioning and alignment can make the riving knife ineffective in reducing the likelihood of kickback.
- f) **For the riving knife and anti-kickback pawls to work, they must be engaged in the workpiece.** The riving knife and anti-kickback pawls are ineffective when cutting workpieces that are too short to be engaged with the riving knife and anti-kickback pawls. Under these conditions a kickback cannot be prevented by the riving knife and anti-kickback pawls.
- g) **Use the appropriate saw blade for the riving knife.** For the riving knife to function properly, the saw blade diameter must match the appropriate riving knife and the body of the saw blade must be thinner than the thickness of the riving knife and the cutting width of the saw blade must be wider than the thickness of the riving knife.

2. Safety instructions for sawing procedures

- a) **⚠DANGER: Never place your fingers or hands in the vicinity or in line with the saw blade.** A moment of inattention or a slip could direct your hand towards the saw blade and result in serious personal injury.
- b) **Feed the workpiece into the saw blade only against the direction of rotation.** Feeding the workpiece in the same direction that the saw blade is rotating above the table may result in the workpiece, and your hand, being pulled into the saw blade.
- c) **Never use the mitre gauge to feed the workpiece when ripping and do not use the rip fence as a length stop when cross cutting with the mitre gauge.** Guiding the workpiece with the rip fence and the mitre gauge at the same time increases the likelihood of saw blade binding and kickback.
- d) **When ripping, always apply the workpiece feeding force between the fence and the saw blade. Use a push stick when the distance between the fence and the saw blade is less than 150 mm, and use a push block when this distance is less than 50 mm.** Work helping" devices will keep your hand at a safe distance from the saw blade.
- e) **Use only the push stick provided by the manufacturer or constructed in accordance with the instructions.** The push stick provides sufficient distance of the hand from the saw blade.
- f) **Never use a damaged or cut push stick.** A damaged push stick may break causing your hand to slip into the saw blade.
- g) **Do not perform any operation "freehand". Always use either the rip fence or the mitre gauge to position and guide the workpiece.** "Freehand" means using your hands to support or guide the workpiece, in lieu of a rip fence or mitre gauge. Freehand sawing leads to misalignment, binding and kickback.
- h) **Never reach around or over a rotating saw blade.** Reaching for a workpiece may lead to accidental contact with the moving saw blade.
- i) **Provide auxiliary workpiece support to the rear and/or sides of the saw table for long and/or wide workpieces to keep them level.** A long and/or wide workpiece has a tendency to pivot on the table's edge, causing loss of control, saw blade binding and kickback.
- j) **Feed workpiece at an even pace. Do not bend or twist the workpiece. If jamming occurs, turn the tool off immediately, unplug the tool then clear the jam.** Jamming the saw blade by the workpiece can cause kickback or stall the motor.
- k) **Do not remove piece of cut-off material while the saw is running.** The material may become trapped between the fence or inside the saw blade guard and the saw blade pulling your fingers into the saw blade. Turn the saw off and wait until the saw blade stops before removing material.
- l) **Use an auxiliary fence in contact with the table top when ripping workpieces less than 2 mm thick.** A thin workpiece may wedge under the rip fence and create a kickback.

3. Kickback causes and related warnings

Kickback is a sudden reaction of the workpiece due to a pinched, jammed saw blade or misaligned line of cut in the workpiece with respect to the saw blade or when a part of the workpiece binds between the saw blade and the rip fence or other fixed object.

Most frequently during kickback, the workpiece is lifted from the table by the rear portion of the saw blade and is propelled towards the operator.

Kickback is the result of saw misuse and/or incorrect operating procedures or conditions and can be avoided by taking proper precautions as given below.

- a) **Never stand directly in line with the saw blade. Always position your body on the same side of the saw blade as the fence rail.** Kickback may propel the workpiece at high velocity towards anyone standing in front and in line with the saw blade.
- b) **Never reach over or in back of the saw blade to pull or to support the workpiece.** Accidental contact with the saw blade may occur or kickback may drag your fingers into the saw blade.
- c) **Never hold and press the workpiece that is being cut off against the rotating saw blade.** Pressing the workpiece being cut off against the saw blade will create a binding condition and kickback.
- d) **Align the fence to be parallel with the saw blade.** A misaligned fence will pinch the workpiece against the saw blade and create kickback.
- e) **Use a featherboard to guide the workpiece against the table and fence when making non-through cuts such as rabbeting.** A featherboard helps to control the workpiece in the event of a kickback.
- f) **Use extra caution when making a cut into blind areas of assembled workpieces.** The protruding saw blade may cut objects that can cause kickback.
- g) **Support large panels to minimise the risk of blade pinching and kickback.** Large panels tend to sag under their own weight. Support(s) must be placed under all portions of the panel overhanging the table top.
- h) **Use extra caution when cutting a workpiece that is twisted, knotted, warped or does not have a straight edge to guide it with a mitre gauge or along the fence.** A warped, knotted, or twisted workpiece is unstable and causes misalignment of the

kerf with the saw blade, binding and kickback.

- i) **Never cut more than one workpiece, stacked vertically or horizontally.** The saw blade could pick up one or more pieces and cause kickback.
 - j) **When restarting the saw with the saw blade in the workpiece, centre the saw blade in the kerf so that the saw teeth are not engaged in the material.** If the saw blade binds, it may lift up the workpiece and cause kickback when the saw is restarted.
 - k) **Keep saw blades clean, sharp, and with sufficient set. Never use warped saw blades or saw blades with cracked or broken teeth.** Sharp and properly set saw blades minimise binding, stalling and kickback.
- 4. Table saw operating procedure warnings**
- a) **Turn off the table saw and disconnect the power cord when removing the table insert, changing the saw blade or making adjustments to the riving knife, anti-kickback pawls or saw blade guard, and when the machine is left unattended.** Precautionary measures will avoid accidents.
 - b) **Never leave the table saw running unattended. Turn it off and don't leave the tool until it comes to a complete stop.** An unattended running saw is an uncontrolled hazard.
 - c) **Locate the table saw in a well lit and level area where you can maintain good footing and balance. It should be installed in an area that provides enough room to easily handle the size of the workpieces.** Cramped, dark areas, and uneven slippery floors invite accidents.
 - d) **Frequently clean and remove sawdust from under the saw table and/or the dust collection device.** Accumulated saw dust is combustible and may self ignite.
 - e) **The table saw must be secured.** A table saw that is not properly secured may move or tip over.
 - f) **Remove tools, wood scraps, etc. from the table before the table saw is turned on.** Distraction or a potential jam can be dangerous.
 - g) **Always use saw blades with correct size and shape (diamond versus round) of arbour holes.** Saw blades that do not match the mounting hardware of the saw will run off-centre, causing loss of control.
 - h) **Never use damaged or incorrect saw blade mounting means such as flanges, saw blade washers, bolts or nuts.** These mounting means were specially designed for your saw, for safe operation and optimum performance.
 - i) **Never stand on the table saw, do not use it as a stepping stool.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
 - j) **Make sure that the saw blade is installed to rotate in the proper direction. Do not use grinding wheels, wire brushes, or abrasive wheels on a table saw.** Improper saw blade installation or use of accessories not recommended may cause serious injury.
 - k) **Only use 10" saw blade with kerf width of 2.8mm and blade body thickness is 1.8 mm match the riving knife with thickness of 2.3 mm.**
 - l) **Always use only a saw blade diameter in accordance with the markings on the saw; Use only saw blades for which the maximum possible speed is not less than the maximum spindle speed of the product.**
 - m) **Do not use any blunt, cracked, deformed or damaged saw blades.**
- 5. Additional safety instructions**
- Please also observe the special safety instructions in the respective chapters.
 - Where applicable, follow the legal directives or regulations for the prevention of accidents pertaining to the use of table saws.
 - Avoid overheating of the saw teeth.
 - Do not attempt to stop the saw blade by pushing the workpiece against its side.
 - Store saw blade in such manner that nobody will get hurt.
 - Before making a cut, be sure all adjustments are secure.
 - Be sure blade path is free of nails. Inspect for and remove all nails from lumber before cutting.
 - Never touch blade or other moving parts during use.
 - Make sure the work area has ample lighting to see the work and that no obstructions will interfere with safe operation before performing any work using the table saw.
 - If this saw makes an unfamiliar noise or if it vibrates excessively, cease operating immediately, turn unit off and unplug the tool until the problem has been located and corrected. Contact a HiKOKI Authorized Service Center if the problem can not be found.

**SAVE THESE INSTRUCTIONS
AND
MAKE THEM AVAILABLE TO
OTHER USERS
AND
OWNERS OF THIS TOOL!**

GLOSSARY OF TERMS

The safe use of this product requires an understanding of the information on the tool and in this operator's manual as well as a knowledge of the project you are attempting. Before use of this product, familiarize yourself with all operating features and safety rules.

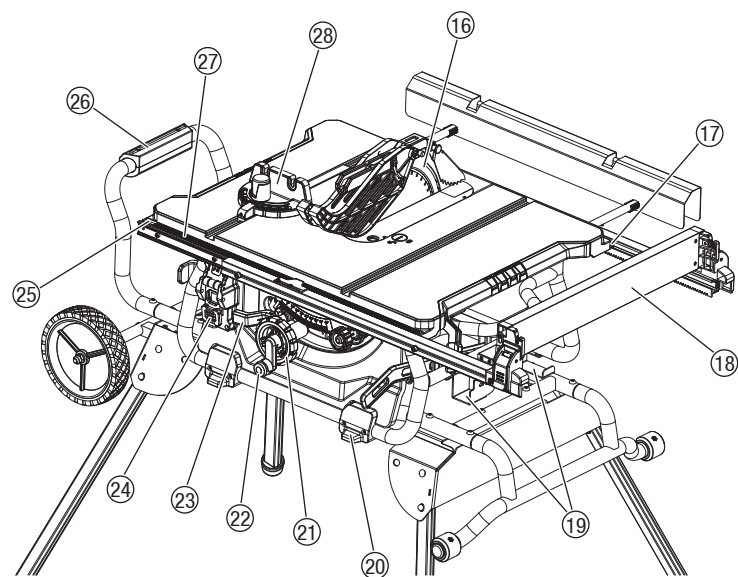
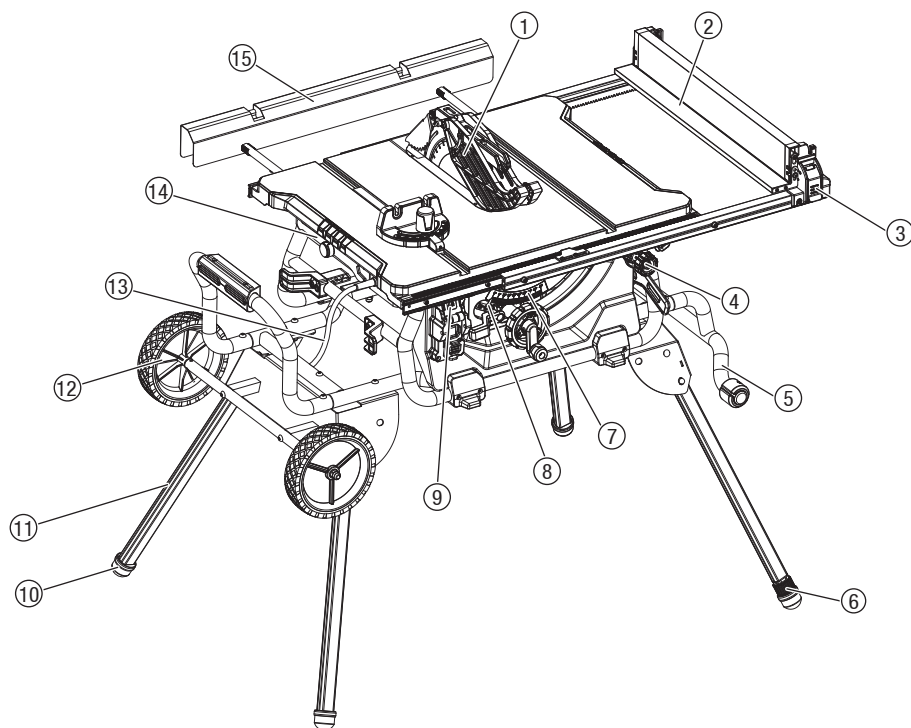
- **Anti-kickback Pawls:** Kickback is a hazard in which the workpiece is thrown back toward the operator. The teeth on the anti-kickback pawls point away from the workpiece. If the workpiece should be pulled back toward the operator, the teeth dig into the wood to help prevent or reduce the possibility of kickback.
- **Bevel Scale:** The easy-to-read scale on the front of the cabinet shows the exact blade angle.
- **Blade:** For maximum performance, it is recommended that you use the 40-tooth, 254 mm carbide tipped combination blade, provided with your saw. The blade is raised and lowered with the height/bevel adjusting handwheel. Bevel angles are locked with the bevel lock lever.

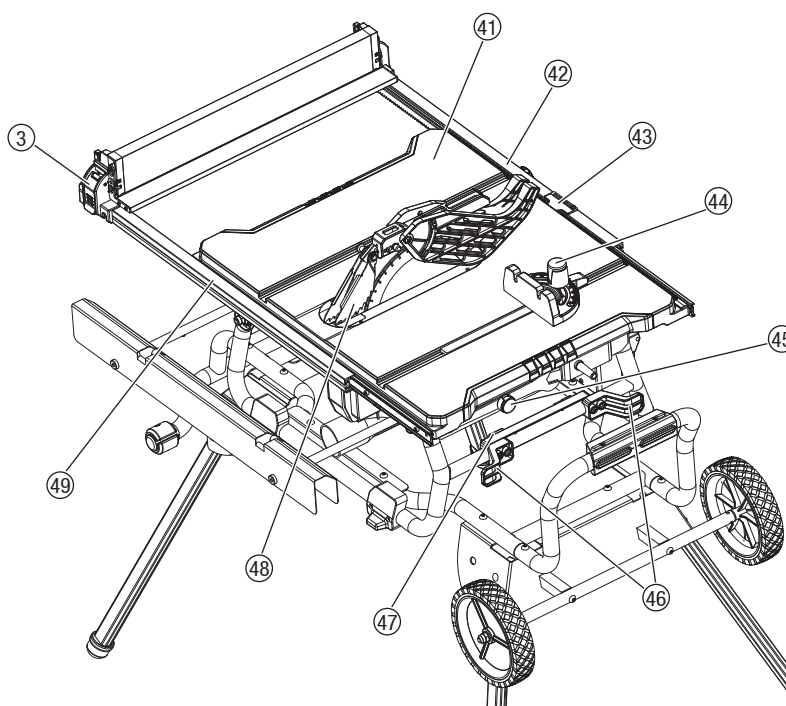
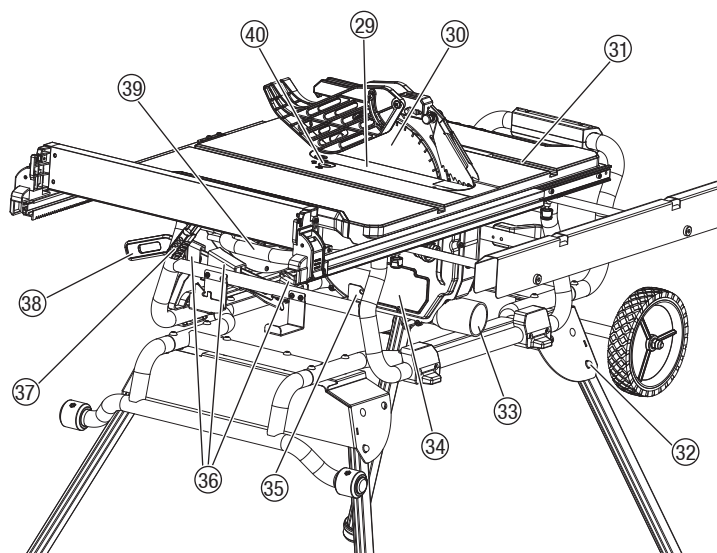
⚠ WARNING: Do not use blades rated less than the speed of this tool. Failure to heed this warning could result in personal injury.

⚠ WARNING: Be careful of your hand. Blade are sharp. Wear work gloves when removing or installing blades.

- **Blade Guard:** Always keep the guard down over the blade for through sawing cuts.
- **Bevel Lock Lever:** This lever under the working table surface on the front of the cabinet, locks the angle setting of the blade.
- **Height/Bevel Adjusting Handwheel:** Located on the front of the cabinet, this handwheel is used to lower and raise the blade for adjustments or blade replacement. The handwheel also makes the adjustment for bevel angles easy.
- **Fence Rails Lock Lever:** The lever under working table surface on the right of the saw releases the fence rails or locks it in place.
- **Adjusting Knob:** This knob is under the working table surface on the front of the saw. Turn it clockwise will slide the fence rails to right. Turn it counter-clockwise will slide fence rails to left.
- **Outfeed Support:** The outfeed support at the back of the tool gives the operator additional support when cutting long workpieces.
- **Mitre Gauge:** The mitre gauge aligns the wood for a cross cut. The easy-to-read indicator shows the exact angle for a mitre cut, with positive stops at 0°, 22.5° and 45°.
- **Mitre Gauge Grooves:** The mitre gauge rides in these grooves on either side of the blade.
- **Front Rail:** Front rail provides support for the front fence rail and rip fence.
- **Rip Fence with a Narrow Fence:** A sturdy metal fence guides the workpiece and It can be fixed on three positions of the fence rails with rip fence lock levers secure in place, the narrow fence can supports workpiece that extends beyond the working table.
- **Scale:** Located on the front rail, the easy-to-read scale provides precise measurements for rip cuts.
- **Riving Knife:** A metal piece, slightly thinner than the saw blade, which helps keep the kerf open and prevent kickback.
- **Arbor:** The shaft on which a blade or cutting tool is mounted.
- **Overload Reset Switch:** The saw is equipped with the overload reset switch to prevent the saw from overload damage. The saw will automatically shut off if the machine was with overloaded cutting or low voltage. Wait for the motor to cool down for at least five minutes. And press the overload reset switch button to resume the overload switch. After the motor has cooled down, press the green "I"-button on the ON/OFF switch to restart saw.
- **Working table:** Surface where the workpiece rests while performing a cutting operation.
- **Kerf:** The material removed by the blade in a through-cut, or the slot produced by the blade in a nonthrough or partial cut.
- **Push Stick:** A push stick should be used for narrow ripping operations when the fence is 150 mm or less from the blade. These aids help to keep the operator's hands well away from the blade.
- **Kickback:** A hazard that can occur when the blade binds or stalls, throwing the workpiece back toward the operator.
- **Ripping or Rip Cut:** A cutting operation along the length of the workpiece.
- **Bevel Cut:** A cutting operation made with the blade at any angle other than 90° to the table surface.
- **Compound Cut:** A crosscut made with both a mitre angle and a bevel angle.
- **Crosscut:** A cutting or shaping operation made across the grain or width of the workpiece.
- **Mitre Cut:** A cutting operation made with the workpiece at any angle other than 90° to the blade.
- **Non-Through Cut:** Any cutting operation where the blade does not extend completely through the thickness of the workpiece.
- **Through-sawing:** Any cutting operation where the blade extends completely through the thickness of the workpiece.
- **Freehand:** Performing a cut without the workpiece being guided by a fence, mitre gauge, or other aid Never perform any cut freehand with this saw.

OVERVIEW





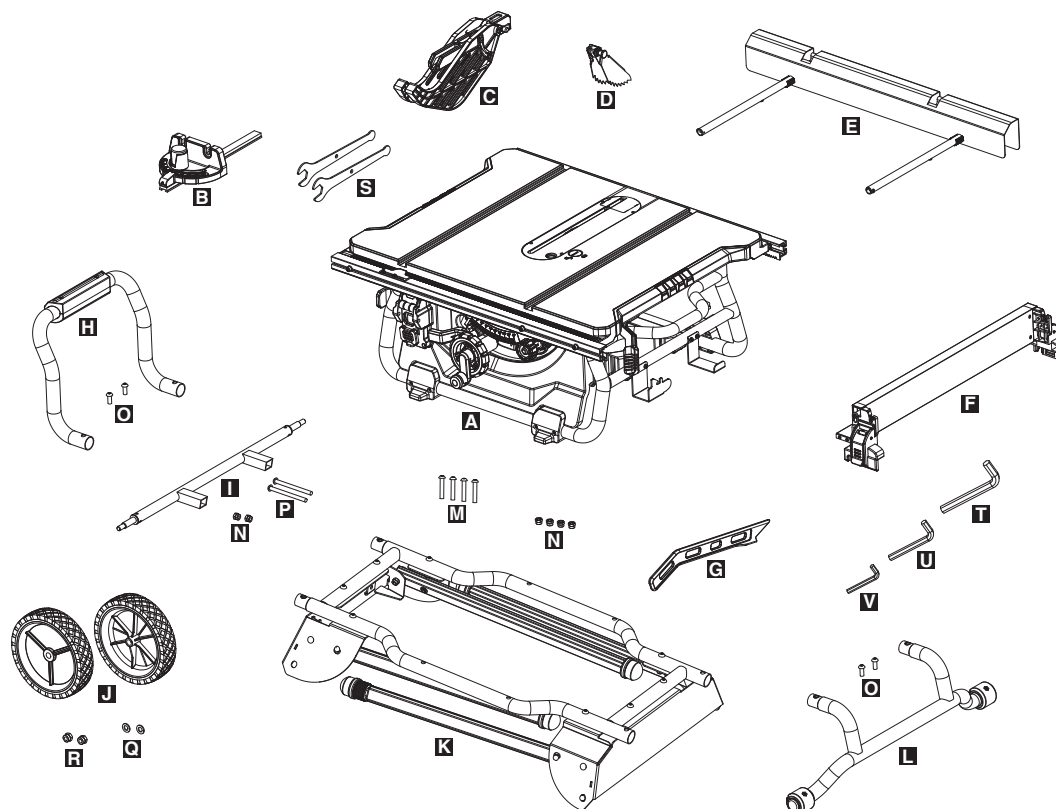
- | | | | |
|-------------------------|------------------------------------|-------------------------------|-----------------------------|
| ① Blade guard | ⑭ Blade wrench | ⑳ Stand support assembly | ㉔ Push stick |
| ② Narrow fence | ⑮ Outfeed support | ㉕ Scale | ㉕ Handle II |
| ③ Rip fence lock lever | ⑯ Riving knife | ㉖ Mitre gauge | ㉖ Lock knob |
| ④ Adjusting knob | ⑰ Rear rail | ㉗ Table insert | ㉗ Working table |
| ⑤ Handle I | ⑱ Rip fence | ㉘ Saw blade | ㉘ Front fence rail |
| ⑥ Adjustable foot | ㉑ Blade guard storage | ㉙ Mitre gauge groove | ㉙ Rip fence scale indicator |
| ⑦ Bevel scale | ㉒ Foot mat | ㉚ Lock pin | ㉚ Mitre gauge lock knob |
| ⑧ Bevel indicator | ㉓ Height/bevel adjusting handwheel | ㉛ Dust extraction port | ㉛ Blade wrench storage |
| ⑨ Overload reset switch | ㉔ Height adjusting knob | ㉜ Small baffle | ㉜ Power cord storage |
| ⑩ Foot | ㉕ Bevel lock lever | ㉝ Anti-kickback pawls storage | ㉝ Mitre gauge storage |
| ⑪ Stand leg | ㉖ Switch assembly | ㉞ Push stick storage | ㉞ Anti-kickback pawls |
| ⑫ Wheel | ㉗ Front rail | ㉟ Fence rails lock lever | ㉟ Rear fence rail |
| ⑬ Power cord | | | |

SPECIFICATIONS

Input Voltage	230-240V~, 50Hz
Power Input	1500W
No Load Speed n_0	4500/min
Blade Size	ø254mm × ø30mm × 2.8mm, 40T
Bevel Range	0°~45°
Working Table Size	730mm x 559mm
Outfeed Support Size	730mm x 50mm
Max. cutting depth at 0°	79mm
Max. cutting depth at 45°	57mm
Max. rip to left to blade	440mm
Max. rip to right to blade	880mm
Protection class	II/□
Weight	44kg

LOOSE PARTS

The following items are included with your table saw:



PART	DESCRIPTION	QUANTITY
A	Table saw assembly	1
B	Mitre gauge (in stored position)	1
C	Blade guard assembly (in stored position)	1
D	Anti-kickback pawls assembly (in stored position)	1
E	Outfeed support assembly	1
F	Rip fence assembly (in stored position)	1
G	Push stick (in stored position)	1
H	Stand support assembly	1
I	Wheel shaft	1
J	Wheels	2
K	Stand assembly	1
L	Handle I assembly	1
M	Flat round head screws M8 x 45	4
N	Lock nuts M8	6
O	Flat round head screws M8 x 10	4
P	Flat round head screws M8 x 100	2
Q	Big flat washers 10	2
R	Lock nuts M10	2
S	Blade wrenches	2
T	5mm Hex key	1
U	4mm Hex key	1
V	2.5mm Hex key	1

ASSEMBLY

UNPACKING YOUR TABLE SAW

This product requires assembly.

- Carefully lift saw from the carton and place it on a level work surface.
- Inspect the tool carefully to make sure that no breakage or damage occurred during shipping.
- Do not discard the packing material until you have carefully inspected and satisfactorily operated the tool.
- The saw is factory set for accurate cutting. After assembling it, check for accuracy. If shipping has influenced the settings, refer to specific procedures explained in this Operator's Manual.
- If any part is missing or damaged, do not attempt to assemble the table saw, plug in the power cord, or turn the switch ON until the missing or damaged part is obtained and is installed correctly.

⚠CAUTION: This tool is heavy. To avoid back injury, lift with your legs, not your back, and get help when needed.

⚠WARNING: Remove the protective polyfoam from between the saw's housing and the motor.

⚠WARNING: The use of attachments or accessories not listed in this manual might be hazardous and could cause serious personal injury.

⚠WARNING: Do not attempt to modify this tool or create accessories not recommended for use with this tool. Any such alteration or modification is misuse, and could result in a hazardous condition leading to possible serious personal injury.

⚠WARNING: Do not connect to the power supply until assembly is complete. Failure to comply could result in accidental starting and possible serious personal injury.

⚠WARNING: Always make sure the table saw is securely mounted to the stand. Failure to heed this warning can result in serious personal injury.

YOU WILL NEED

Items not supplied

- Flat head screwdriver
- Screwdriver
- 13mm wrench / Adjustment wrench
- Framing square
- Triangle square

Items supplied

- Blade wrench (2 pc)
- 2.5mm Hex key (1 pc)
- 4mm Hex key (1 pc)
- 5mm Hex key (1 pc)

⚠WARNING: To avoid injury, do not connect this table saw to a power source until it is completely assembled and adjusted and you have read and understood the operator's manual.

⚠CAUTION: Many of the illustrations in this manual show only portions of the table saw. This is intentional so that we can clearly show points being made in the illustrations. Never operate the saw without all guards securely in place and in good operating condition.

ASSEMBLE THE STAND (Fig. 1a-1e)

- Place cardboard or an old blanket on floor in order to protect the surface of the working table.
- Place the table saw assembly (50) upside down on the protective material.
- Attach the stand assembly (51) to the table saw assembly (50) with four flat round head screws M8 x 45 (52) and four lock nut M8 (53) (two holes on the side board of the stand assembly located on the blade wrench storage). (Fig. 1a)
- Attach the tubes of the stand support assembly (26) with the corresponding tubes (located on side of blade wrench storage (45)) on the stand assembly (51) and align the holes. Insert the flat round head screws M8 x 10 (54) into the hole and tighten with 5mm hex key. (Fig. 1b)

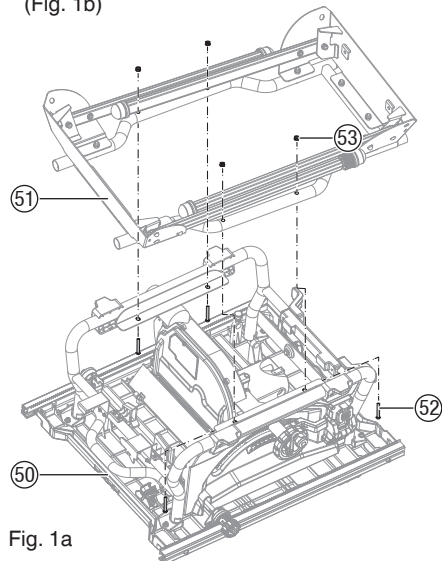


Fig. 1a

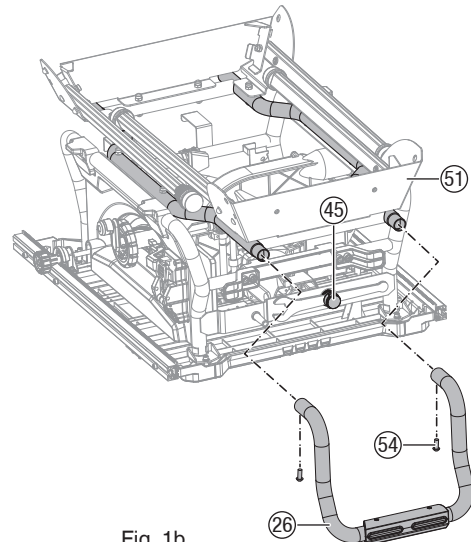


Fig. 1b

- Slide one wheel (12), one big flat washer 10 (55) and one lock nut M10 (56) onto the wheel shaft (57), secure wheel in place by tightening the lock nut M10. Repeat with the second wheel. (Fig. 1c)
- Attach the wheel assembly (58) to the stand assembly (51) with two flat round head screws M8 x 100 (59) and two lock nut M8 (53). (Fig. 1d)

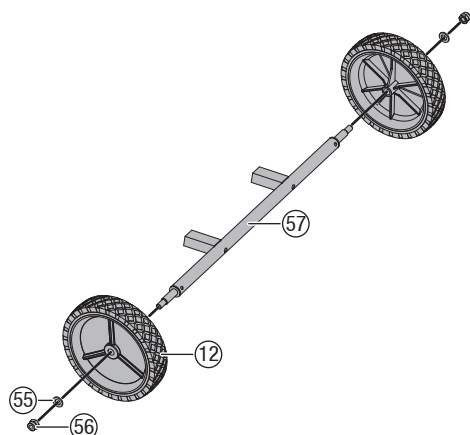


Fig. 1c

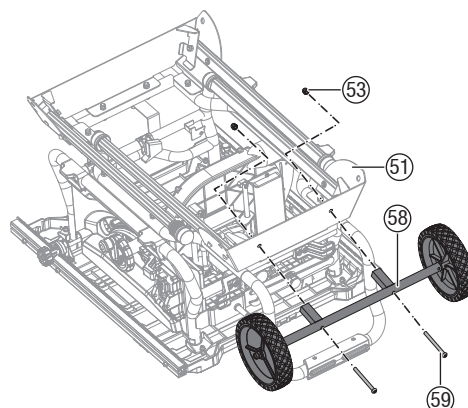


Fig. 1d

- Attach the tubes of the handle I assembly (5) with the corresponding tubes (located on side of blade guard storage) on the stand assembly (51) and align the holes. Insert the flat round head screws M8 x 10 (54) into the hole and tighten with 5 mm hex key. (Fig. 1e)

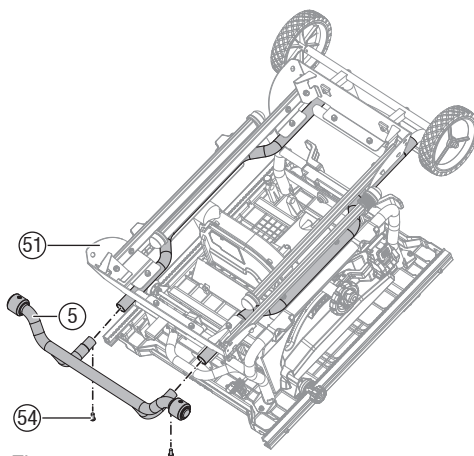


Fig. 1e

OPEN THE STAND (Fig. 2a-2d)

- Push the fence rails lock lever (37) toward the front of the saw to lock it. (Fig. 2a)
- Grasp the handle I (5) and tilt saw back onto wheels until the stand is balanced on the wheels (12) and stand support assembly (26). (Fig. 2a)
- Fold out two upper stand legs (11) (located on side of the handle I). To do this, push the lock pins (32) until they unlock the stand legs (11) from the holes, then swing the stand legs (11) upward until the stand legs (11) are locked with the lock pins (32) engage the holes. (Fig. 2a)

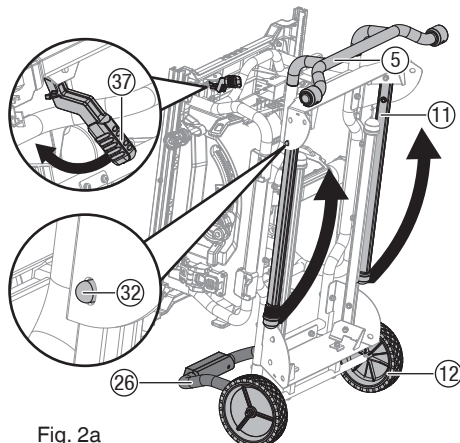


Fig. 2a

- Grasp the handle I (5) firmly and slowly tilt saw downward until the saw is balanced on the ground. (Fig. 2b-2c)
- Grasp the stand support assembly (26) and lift it up until two other stand legs (11) leaving off the ground, then fold out two stand legs (11). To do this, push the lock pins (32) until they unlock the stand legs (11) from the holes, then swing the stand legs (11) downward until the stand legs are locked with the lock pins (32) engage the holes. (Fig. 2c) Make sure the table saw is balanced with four leg stands stand on the floor.

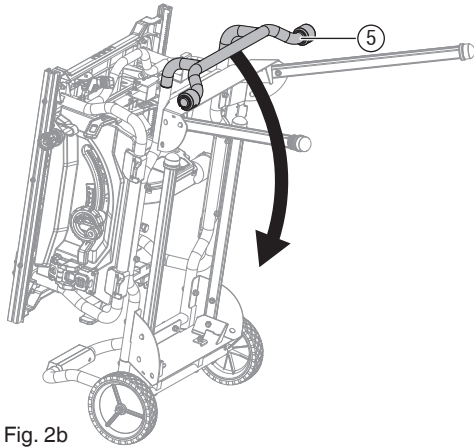


Fig. 2b

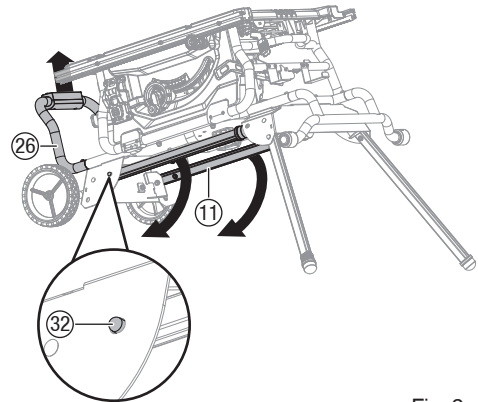


Fig. 2c

- Fig. 2d is the leg stand assembly in an open position.

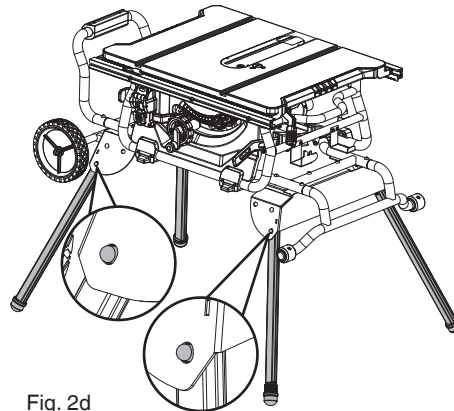


Fig. 2d

⚠ WARNING: Keep your fingers clear of the hinge points while opening the stand. Danger of fingers being crushed or contused.

TO SECURE/LEVEL THE STAND (Fig. 3)

With the stand open, resting on a level surface, the stand should not move or rock from side to side. If the stand rocks from side to side, the adjustable foot (6) need adjusting until the stand is balanced.

- Lift the stand slightly so that you may turn the adjustable foot (6) until the stand no longer rocks.
- Turning clockwise will lower the foot.
- Turning counter-clockwise will raise the foot.

⚠ WARNING: The table saw must be secured. A table saw that is not properly secured may move or tip over.

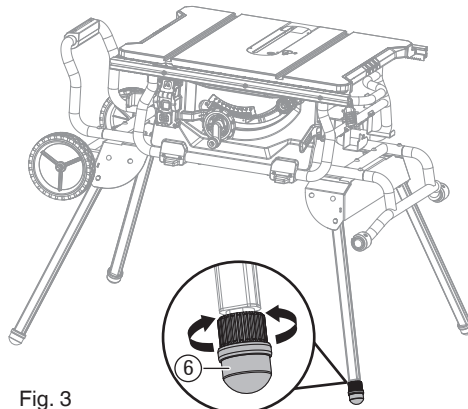


Fig. 3

TO REMOVE/REPLACE/ALIGN THE TABLE INSERT (Fig. 4a-4b)

⚠WARNING: The table insert must be level with the saw table. If the table insert is too high or too low, the workpiece can catch on the uneven edges, resulting in binding or kickback, which could result in serious personal injury.

⚠WARNING: Be care of your hands avoided to be striked with the saw blade which could result in serious personal injury when removing or reinstalling the table insert.

- Lower the blade all the way to down position by turning the height adjusting knob (22) counter-clockwise.
- Lock the blade by turning bevel lock lever (23) clockwise.
- **To remove the table insert:** Turn the lock knob (40) counter-clockwise to unlock the table insert (29). Place your index finger in the hole, pulling the table insert (29) out toward the front of the saw.
- **To reinstall the table insert:** Push the table insert (29) down, turn the lock knob (40) clockwise to lock the table insert in place. When the table insert is not level with the saw table, using a 2.5 mm hex key (supplied), adjust the four set screws (60) pre-assembled to the table located on the four holes of the table insert until the table insert is level with the working table.

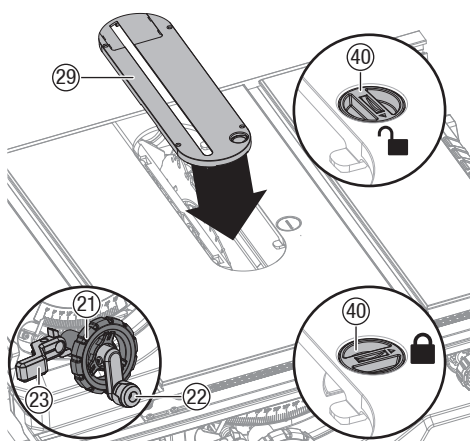


Fig. 4a

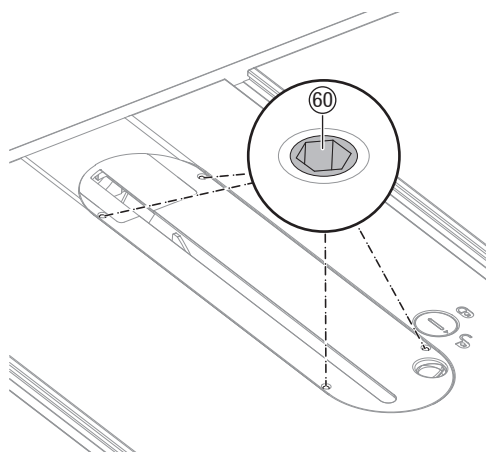


Fig. 4b

TO INSTALL THE RIVING KNIFE (Fig. 5a-5b)

⚠CAUTION: This saw is shipped with riving knife in "MIDDLE" position. Riving knife must be placed in uppermost position to attach anti-kickback pawls and blade guard for all through cut operations. The "MIDDLE" position is for non-through cuts (with blade guard and anti-kickback pawls removed).

Through cutting riving knife installation

- Unplug the saw.
- Remove the table insert.
- Set the saw blade angle to 0°.
- Raise the saw blade to the uppermost position by turning the height adjusting knob (22) clockwise.
- Lock the blade by turning bevel lock lever (23) clockwise.
- Unlock riving knife lock knob (61) by turning it clockwise.
- Grasp the riving knife (16) and pull toward right side of saw to release it from spring-loaded lock pin.
- Position the riving knife in the uppermost position with springloaded lock pin is re-engaged.
- Lock the riving knife lock knob (61) by turning it counter-clockwise.
- Reinstall the table insert.

⚠WARNING: Be extremely careful when adjust the riving knife position. Do not allow hands to contact blade.

To place riving knife in middle position, refer to the above procedure.

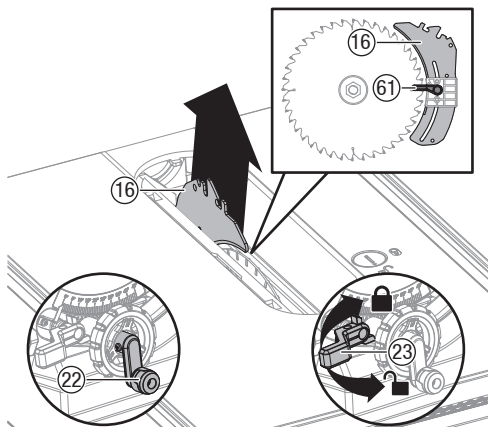


Fig. 5a

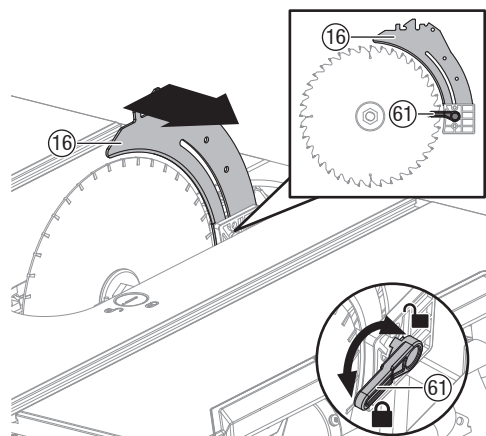


Fig. 5b

REMOVING AND INSTALLING THE BLADE (Fig. 6a-6b)

⚠CAUTION: Check the arbor hole diameter of the blade before installing the blade. Always use the correct ring for the arbor hole of the blade you intend to use.

⚠CAUTION: To work properly, the saw blade teeth must point down toward the front of the saw. Failure to heed this instruction could cause damage to the saw blade, the saw or the workpiece.

⚠WARNING: Make sure that the saw blade is installed to rotate in the proper direction. Do not use grinding wheels, wire brushes, or abrasive wheels on a table saw. Improper saw blade installation or use of accessories not recommended may cause serious injury.

⚠WARNING: Only use a 254 mm diameter blade. To avoid injury from an accidental start, make sure the switch is in the OFF position and the plug is not connected to the power source outlet.

⚠WARNING: Be extremely careful when loosening arbor nut. Keep firm grasp on both wrenches. Do not allow hands to slip and contact blade.

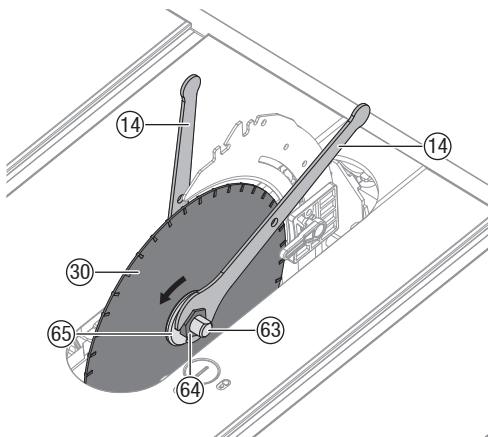


Fig. 6a

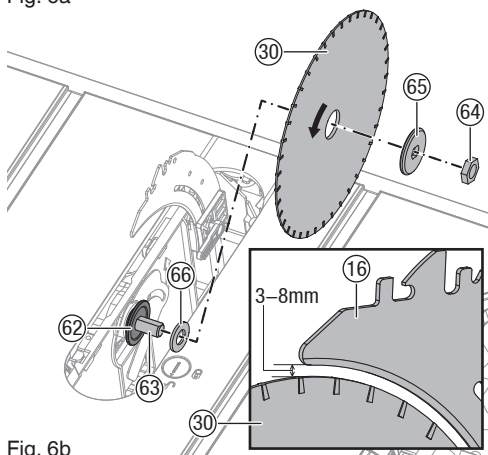


Fig. 6b

- Unplug the saw.
- Turn height adjustment knob clockwise to raise blade to maximum height.
- Remove the table insert.
- Set the saw blade angle to 0° and raise the saw blade to the uppermost position.
- Remove the blade wrenches from storage area.

Remove the blade:

- Using one opened-ended blade wrench (14), place the flat open end on the flats on the inner blade flange (62).
- Using the other opened-ended blade wrench (14), place the flat open end on the flats on the arbor nut (64). Holding both wrenches firmly, pull the opened-ended blade wrench on the arbor nut (64) forward to the front of the machine.
- Remove arbor nut (64), outer blade flange (65), saw blade (30) and ring (66).

⚠WARNING: Be extremely careful when loosening arbor nut. Keep firm grasp on both wrenches. Do not allow hands to slip and contact blade.

Install the blade:

- Place the ring (66) and one new blade on arbor (63). Make sure saw blade teeth point down at the front side of saw table. Place outer blade flange (65) and arbor nut (64) on arbor and use blade wrenches to tighten nut securely. **DO NOT** over tighten.

⚠CAUTION: The ring 30 mm in outer diameter is factory-installed onto the arbor.

⚠WARNING: The large, flat surface of the outer blade flange faces the saw blade and the saw blade (30) is firmly seated against the inner blade flange (62).

⚠WARNING: The saw blade (30) should be aligned with the riving knife (16) and ensuring there is a gap of 3 to 8 mm between the blade teeth and the riving knife (16).

- Lower the saw blade to lowest position and replace table insert.

⚠WARNING: If the inner blade flange has been removed, reinstall it before placing the saw blade on arbor. Failure to do so could cause an accident.

ANTI-KICKBACK PAWLS INSTALLATION (Fig. 7a-7b)

Anti-kickback pawls should only be installed for through cuts.

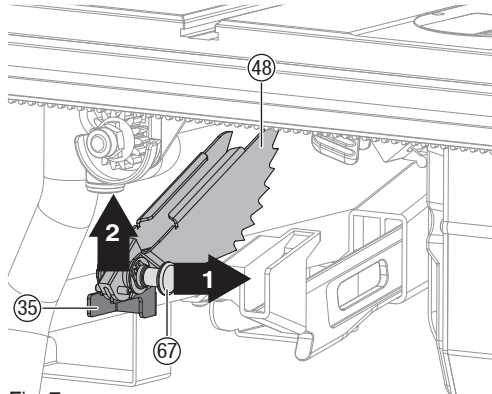


Fig. 7a

⚠WARNING: Make sure the anti-kickback pawls are reinstalled immediately after finishing any non-through cut operations which require their removal.

⚠WARNING: Replace dull or damaged anti-kickback pawls. Dull or damaged anti-kickback pawls may not stop a kickback, increasing the risk of serious personal injury.

- Unplug the saw.
- Set the blade angle to 0°.
- Raise the saw blade to maximum height by turning height adjusting knob clockwise.
- Lock the blade by turning bevel lock lever clockwise.
- Place the riving knife in the highest position.
- Pull out and hold knob (67) and push anti-kickback pawls up, remove it from the anti-kickback pawls storage (35) located on inside of the left side of saw. (Fig. 7a)

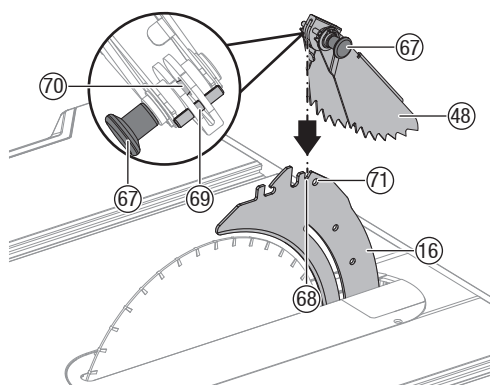


Fig. 7b

- Pull out and hold knob (67). Align slot in anti-kickback pawls (48) over the slot A (68) indicated on riving knife (16). Place the spring pin (69) on the anti-kickback pawls (48) into the slot (A) (68) indicated on the riving knife (16).
- Press anti-kickback pawls (48) down until it snaps into place and release knob (67) to insert the pin (70) into hole (71) indicated on the riving knife (16).

⚠ CAUTION: Pull up on anti-kickback pawl assembly to make sure it is secured to riving knife.

⚠ WARNING: Gently pull up the anti-kickback pawls to ensure it is locked into place. Make sure that the anti-kickback pawls move freely and are not stuck in the table insert slot.

⚠ WARNING: Use extra caution when cutting wood products having slippery surface as the anti-kickback pawls may not always be effective.

BLADE GUARD INSTALLATION (Fig. 8a-8c)

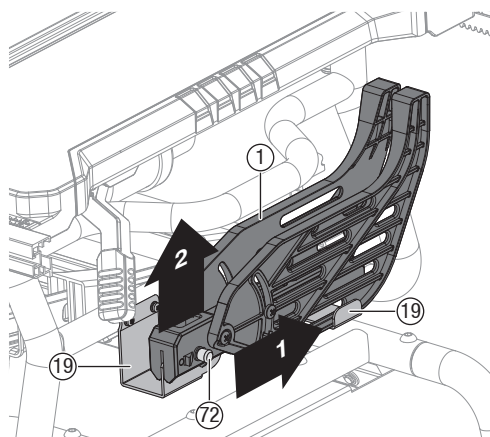


Fig. 8a

⚠ WARNING: KEEP GUARDS IN PLACE and in good working order for all through cut operations. Reinstall the blade guard immediately after finishing any non-through cut operations which require removal of the blade guard. Failure to heed this instruction could result in serious personal injury.

- Unplug the saw.
- Hold the knobs (72) (one on either side of the blade guard) and push the knobs forward to the front of the blade guard and up until the pin comes out from the slot in the mounting bracket (blade guard storage) (19) at bottom front right side of the saw, then remove the blade guard from the U-bracket (blade guard storage) (19) at bottom middle right side of the saw (Fig. 8a).
- Hold and push knobs (72) forward to the front of the blade guard. Place the pins (73, 74) on the blade guard (1) into the slot B (75) and slot C (76) indicated on the riving knife (16). (Fig. 8b)
- Pull blade guard fully back onto riving knife. Push pin and release it to lock guard into position.
- If blade guard is not parallel to table when riving knife is in uppermost position (through cuts), adjust the set screw (77) as necessary. (Fig. 8c)

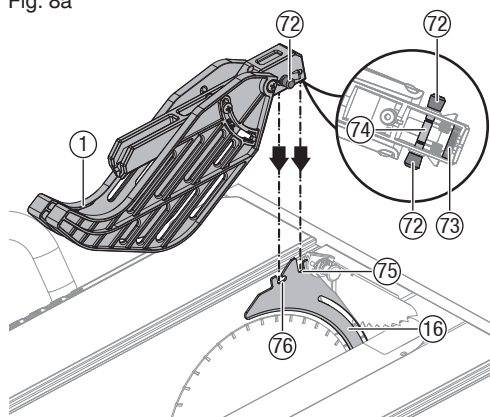


Fig. 8b

⚠ WARNING: After the installation, check the blade guard to ensure that it is properly placed and workable before operation the saw.

⚠ WARNING: When using the blade guard, lift the left and right blade guard and make sure that they move independently and contact the table surface. The blade guard can be raised to adjust the cut line, but must be lowered to contact the table surface before starting the saw.

⚠ WARNING: Make sure blade guard and anti-kickback pawls move freely before starting the saw. Ensure the direction of rotation by checking blade teeth point down at the front side of saw table.

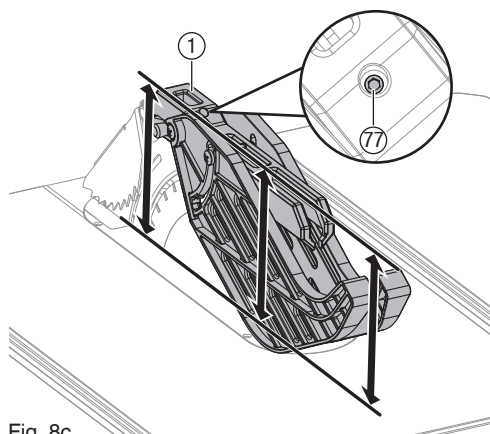


Fig. 8c

OUTFEED SUPPORT ASSEMBLY INSTALLATION (Fig. 9a-9b)

- Loosen and remove two stop screws (78) on the extension poles (79) of the outfeed support (15).
- Loosen the locking knobs (80) under the working table counterclockwise.
- Insert the rear extension poles (79) into the two holes in the rear of the working table and into the extension tube brackets that are located under the working table.
- Position the outfeed support (15).
- Thread the locking knobs (80) into the holes under the working table and tighten them.
- Thread the two stop screws (78) into the holes located on ends of the extension poles (79) and tighten them.

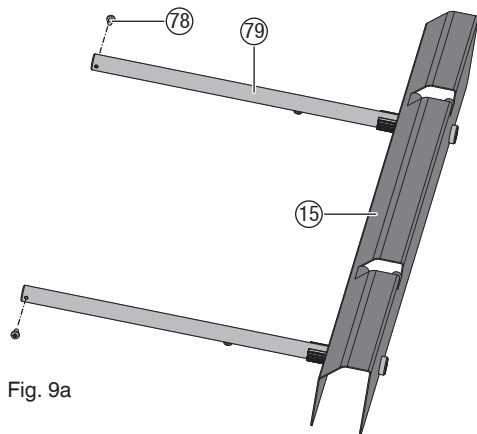


Fig. 9a

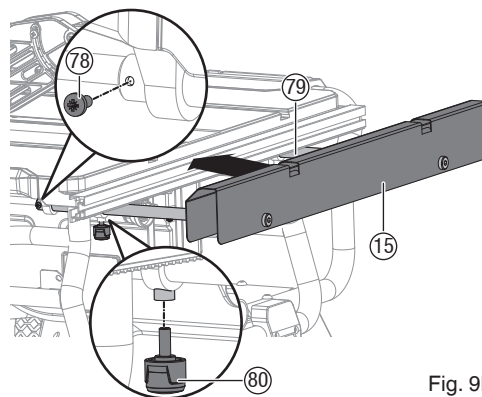


Fig. 9b

RIP FENCE INSTALLATION (Fig. 10a-10c)

- Push down the fence rails lock lever (37) toward the rear of the saw to unlock it.
- Open the rip fence lock levers (3) located on two ends of the rip fence (18), then remove the rip fence (18) from the front and rear fence rails (42, 49).

CAUTION: There are three position screws (81) (position A, B, C) on the each front and rear fence rails (42, 49) to attach rip fence. Position screws (81) (position A and B) use for rip fence on the right of saw blade. Position screws (81) (position C) use for rip fence on the left of saw blade. (Fig. 10b)

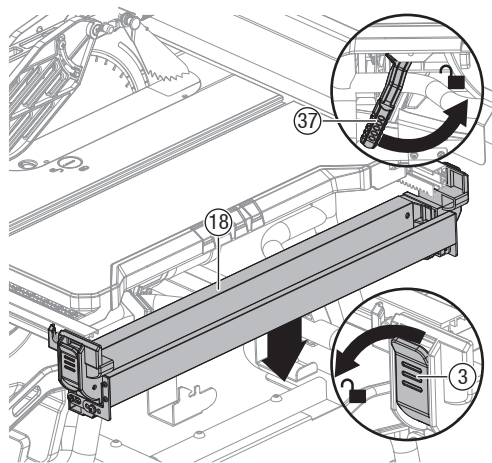


Fig. 10a

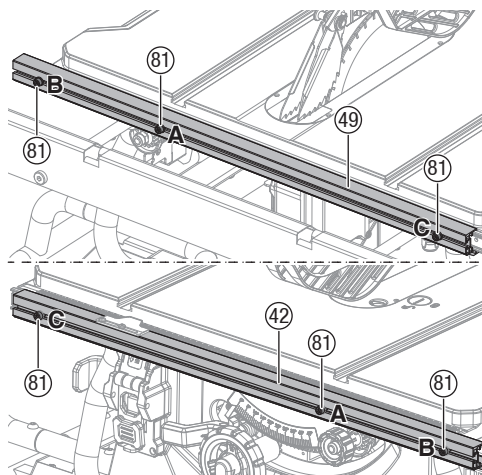


Fig. 10b

- Align the fence slots (82) with the position screws (front and back) on the fence rails.
- Push the slots (82) down onto the position screws and secure the rip fence in place by pushing the rip fence lock levers (3) down.
- Lock the fence rails lock lever (37).

CAUTION: The rip fence should be parallel to the saw blade. If not, refer to the section “Aligning rip fence to blade” (Page 29).

CAUTION: Three position screws (81) (position A, B, C) apply to three different scales:

- Position screw (Position A): Begin with 0 to 680 mm end. (Rip fence located on the right of the blade)
- Position screw (Position B): Begin with 200 mm to 880 mm end. (Rip fence located on the right of the blade)
- Position screw (Position C): Begin with 0 to 440 mm end. (Rip fence located on the left of the blade)

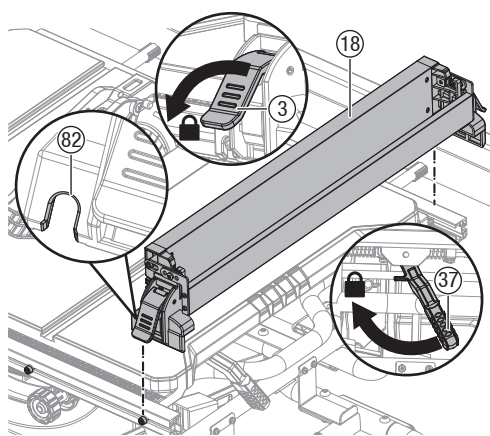
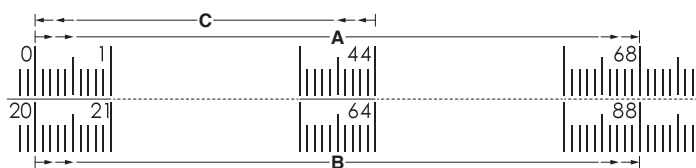


Fig. 10c



MITRE GAUGE INSTALLATION (Fig. 11a-11b)

The mitre gauge (28) can be installed on each mitre gauge groove (31) on either side of blade.

- Remove the mitre gauge (28) from mitre gauge storage (47) located on inside of the right side of saw.
- Slide the guide rail (83) of the mitre gauge (28) into one of the guide grooves (31) of the saw table intended for this purpose.

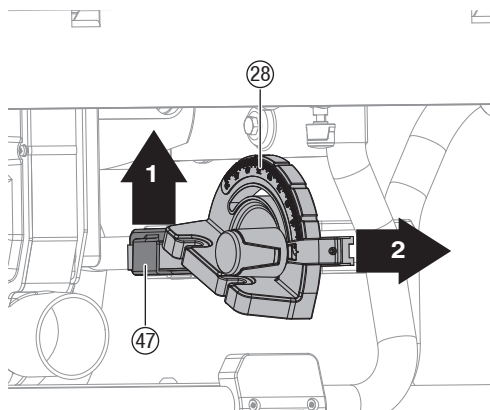


Fig. 11a

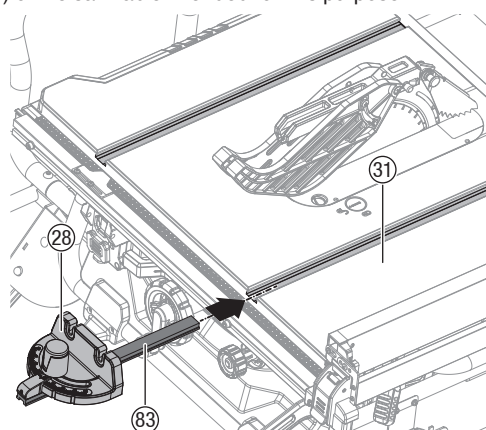


Fig. 11b

TO STORE THE TABLE SAW ACCESSORIES (Fig. 12a-12c)

- The table saw has two convenient storage areas (one on either side and back of the saw) specifically designed for the saw's accessories: rip fence (18), blade guard (1), push stick (38), blade wrenches (14), power cord (13), anti-kickback pawls (48) and mitre gauge (28).
- When not in use, store accessories securely.

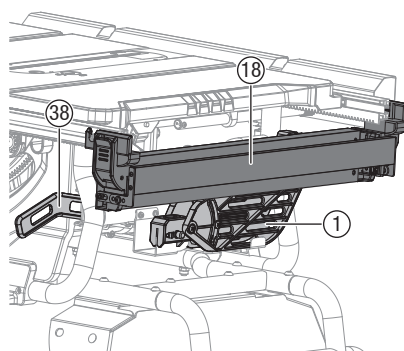


Fig. 12a

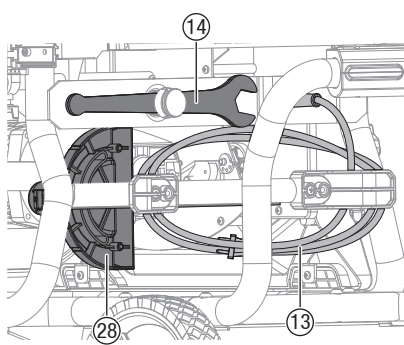


Fig. 12b

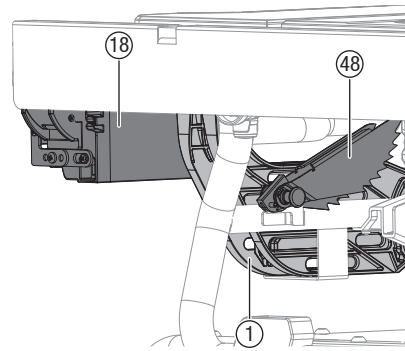


Fig. 12c

FOLDING THE STAND (Fig. 13a-13f)

- To fold the stand for moving, return fence rails and lock the fence rails lock lever and return outfeed support to inner position. Store the accessories securely.
- Grasp the stand support assembly (26) and lift it up until two stand legs (11) (located on side of the wheel) leaving off the ground, then fold in two stand legs (11). To do this, push the lock pins (32) until they unlock the stand legs (11) from the holes, then swing the stand legs (11) upward until the stand legs are locked with the lock pins (32) engage the holes.

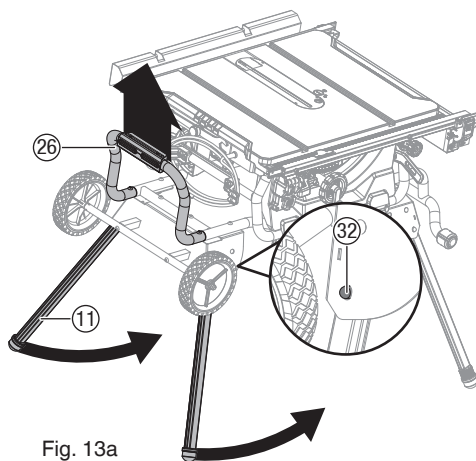


Fig. 13a

- Grasp the handle I (5) and tilt saw back onto wheels until the stand is balanced on the wheels (12) and stand support assembly (26). (Fig. 13b-13c)

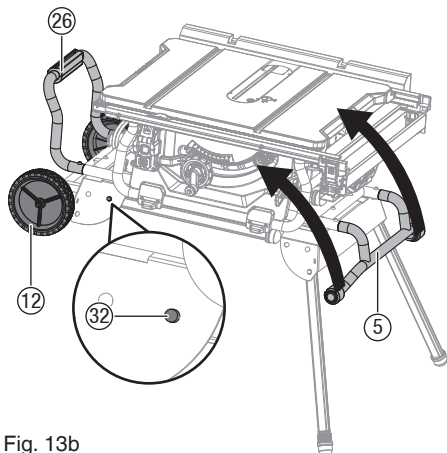


Fig. 13b

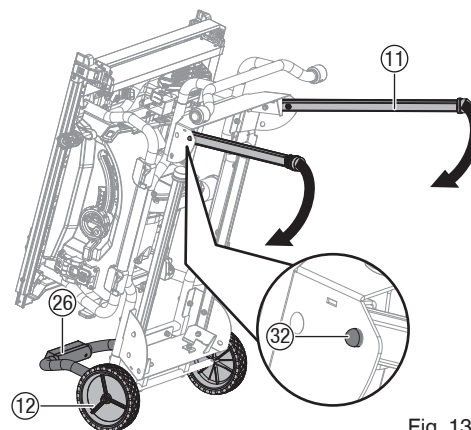


Fig. 13c

- Fold in other two stand legs (11). To do this, push the lock pins (32) until they unlock the stand legs (11) from holes, then swing the stand legs downward until the stand legs are locked with the lock pins (32) engage the holes.
- Grasp the handle I (5) firmly and tilt saw to you, push the saw to the desired location (Fig. 13e) then either open the stand or store the saw (Fig. 13d & 13f) in a dry environment.

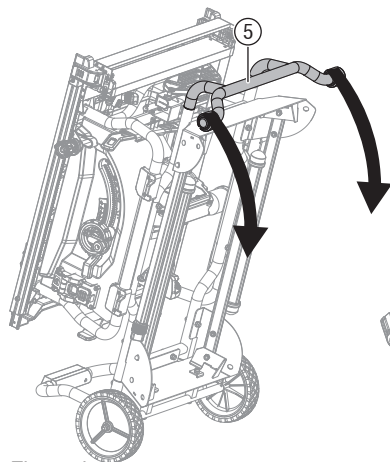


Fig. 13d

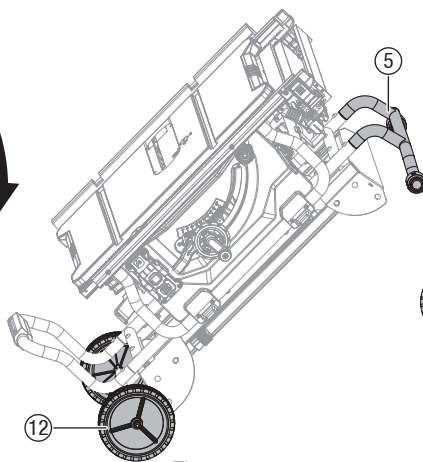


Fig. 13e

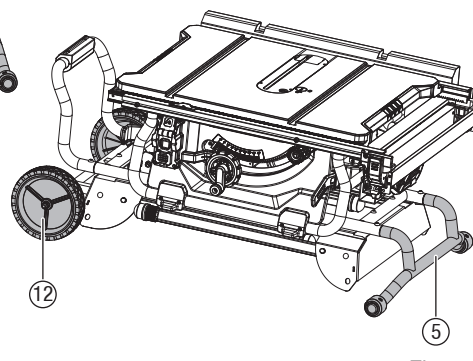


Fig. 13f

⚠WARNING: Keep your fingers clear of the hinge points while folding the stand. Danger of fingers being crushed or contused.

CONNECT TO A DUST COLLECTION SYSTEM (Fig. 14)

The dust extraction port (33) with 63.5 mm size is located on the back of the table saw. This port can be connected directly to a dust collection system by connecting the pick up end of the dust collection hose to the dust port.

⚠ WARNING: ALWAYS connect to a dust collection system and the table saw must be regularly checked for dust built up and cleaned frequently, otherwise there is a risk of heat built up and potential fire.

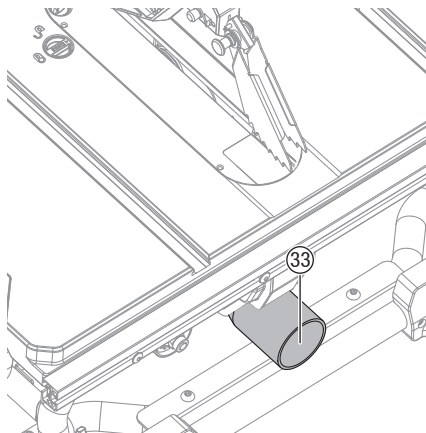


Fig. 14

OPERATION

⚠ WARNING: To reduce the risk of serious personal injury, turn unit off and unplug the tool before making any adjustments or removing/installing attachments or accessories. An accidental start-up can cause injury.

⚠ WARNING: Before using the saw, verify the following each and every time:

- ALWAYS wear proper eye, hearing and respiratory equipment.
- Blade is securely tightened.
- Bevel angle and fence rails lock lever is locked.
- If ripping, ensure that rip fence lock lever is locked and that the fence is parallel to the blade.
- If crosscutting, mitre gauge lock knob is securely tightened.
- The blade guard assembly is properly attached and the anti-kickback pawls assembly is functioning.

⚠ WARNING: To reduce the risk of serious personal injury, if the distance between the rip fence and saw blade is less than 150 mm, the push stick must be used.

⚠ WARNING: Feed the workpiece into the saw blade only against the direction of rotation. Feeding the workpiece in the same direction that the saw blade is rotating above the working table may result in the workpiece, and your hand, being pulled into the saw blade.

⚠ WARNING: In the event of a power failure or when the tool is not in use, turn the switch OFF. This action will prevent the tool from accidentally starting when power returns.

⚠ WARNING: ALWAYS make sure your workpiece is not in contact with the blade before operating the switch to start the saw. Blade contact could result in kickback or thrown workpiece.

⚠ WARNING: To reduce the risk of accidental starting, ALWAYS make sure the switch is in the OFF position before plugging saw into the power source.

⚠ WARNING: DO NOT use blades rated less than the speed of this tool. Failure to heed this warning could result in serious personal injury.

⚠ WARNING: The operation of any power tool can result in foreign objects being thrown into the eyes, which can result in severe eye damage. Always wear eye protection before commencing power tool operation.

⚠ WARNING: Never operate the saw with the blade guard removed except for non-through cuts, failure to heed this instruction could result in serious personal injury.

APPLICATIONS

You can use this tool for the purposes listed below:

- Straight-line cutting operations, such as cross cut, rip cut, mitre cut, and compound cut.
- Cabinet making and woodworking.

NOTE: This table saw is designed to cut wood and wood composition products only. Never cut metals, cement board, or masonry.

OPERATING COMPONENTS

- The upper portion of the blade projects up through the table and is surrounded by an insert called the table insert. The height of the blade is set with a height adjusting handle on the height/bevel adjusting handwheel. Detailed instructions are provided in this manual for the basic cut: cross cuts, mitre cuts, bevel cuts, and compound cuts.
- The rip fence is used to position workpiece for lengthwise cuts and used for outfeed support for large workpiece cuts.
- It's very important to use the riving knife, anti-kickback pawls and blade guard assembly for all through cut sawing operations.

CAUSES OF KICKBACK

Kickback can occur when the blade stalls or binds, causing the workpiece to be kicked back toward the operator with great force and speed. If your hands are near the saw blade, they may be jerked loose from the workpiece and come into contact with the blade. Obviously, kickback can cause serious injury, and it is well worth using precautions to avoid the risks. Kickback can be caused by any action that pinches the blade in the wood, such as the following:

- Making a cut with incorrect blade depth.
- Sawing into knots or nails in the work piece.
- Twisting the wood while making a cut.
- Failing to support the workpiece.
- Forcing a cut.
- Cutting warped or wet lumber.
- Using the wrong blade for the type of cut.
- Not following correct operating procedures.
- Misusing the saw.
- Failing to use the anti-kickback pawls.
- Cutting with a dull, gummed-up, or improperly set blade.

PRECAUTIONS OF KICKBACK

NOTE: Kickback can be avoided by taking following proper precautions:

- Never stand directly in line with the saw blade. Always position your body on the same side of the saw blade as the fence.

Kickback may propel the workpiece at high velocity towards anyone standing in front and in line with the saw blade.

- Never reach over or in back of the saw blade to pull or to support the workpiece. Accidental contact with the saw blade may occur or kickback may drag your fingers into the saw blade.
- Never hold and press the workpiece that is being cut off against the rotating saw blade. Pressing the workpiece being cut off against the saw blade will create a binding condition and kickback.
- Align the fence to be parallel with the saw blade. A misaligned fence will pinch the workpiece against the saw blade and create kickback.
- Use extra caution when making a cut into blind areas of assembled workpieces. The protruding saw blade may cut objects that can cause kickback.
- Support large panels to minimise the risk of saw blade pinching and kickback. Large panels tend to sag under their own weight. Support(s) must be placed under all portions of the panel overhanging the table top.
- Use extra caution when cutting a workpiece that is twisted, knotted, warped or does not have a straight edge to guide it with a mitre gauge or along the fence. A warped, knotted, or twisted workpiece is unstable and causes misalignment of the kerf with the saw blade, binding and kickback.
- Never cut more than one workpiece, stacked vertically or horizontally. The saw blade could pick up one or more pieces and cause kickback.
- When restarting the saw with the saw blade in the workpiece, center the saw blade in the kerf so that the saw teeth are not engaged in the material. If the saw blade binds, it may lift up the workpiece and cause kickback when the saw is restarted.
- Keep saw blades clean, sharp, and with sufficient set. Never use warped saw blades or saw blades with cracked or broken teeth. Sharp and properly set saw blades minimise binding, stalling and kickback.

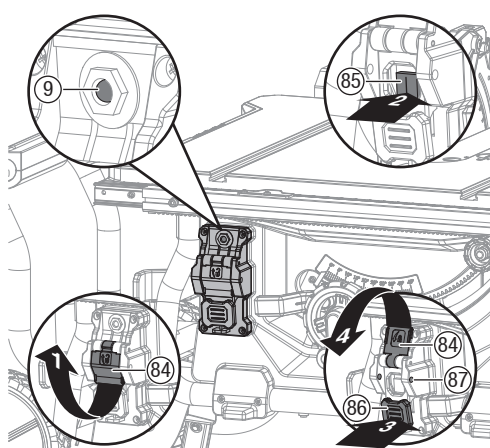


Fig. 15

SWITCH ASSEMBLY (Fig. 15)

⚠ WARNING: To reduce the risk of injury, be sure switch is in the OFF position before plugging machine in.

To turn saw on and off:

- Flip the switch cover (84) upward.
- Press the switch I (85) to turn on the saw.
- Press the switch paddle (86) to turn off the saw.

To lock saw:

- Flip the switch cover (84) downward.
- The holes (87) is provided in the switch for insertion of a padlock with a removable shank to lock the saw off.

NOTE: A conventional padlock will not fit.

OVERLOAD PROTECTION (Fig. 15)

The saw is equipped with an overload switch (9) to prevent the saw from overload damage. The saw will automatically shut off if the machine was with overloaded cutting or low voltage. Wait for the motor to cool down at least five minutes. And press the overload reset switch button to resume the overload switch. After the motor has cooled down, press the green "I"-button on the ON/OFF switch to restart saw.

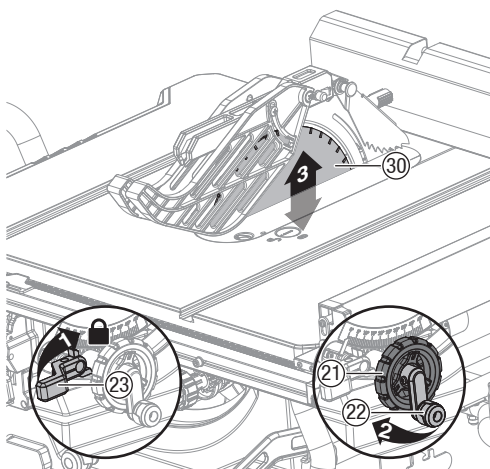


Fig. 16

CHANGING BLADE DEPTH (Fig. 16)

Blade depth should be set so that outer points of blade are higher than workpiece by approximately 3 mm to 6 mm and bottom of gullets are below top surface of workpiece.

- Turn the bevel lock lever (23) clockwise to tighten it securely.
- Raise blade (30) by turning height adjusting knob (22) on the height/bevel adjusting handwheel (21) clockwise. Lower blade by turning height adjusting knob (22) counterclockwise.
- Make sure blade (30) is at proper height.

⚠ WARNING: Make sure the blade guard is in place after adjusting the blade depth. Failure to heed this instruction could result in serious personal injury.

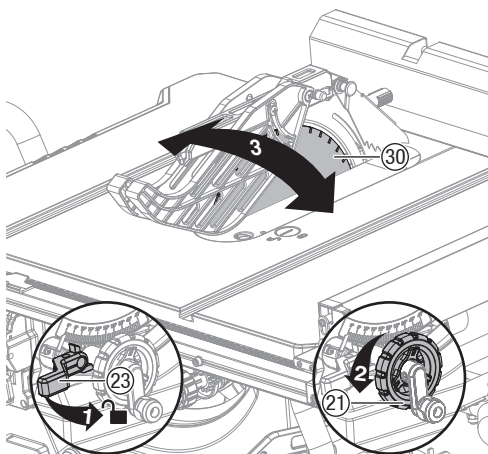


Fig. 17

CHANGING BLADE ANGLE (BEVEL) (Fig. 17)

⚠ CAUTION: A 90° cut has a 0° bevel and a 45° cut has a 45° bevel.

⚠ CAUTION: If bevel indicator is not at zero when saw blade is at 0°, see the section “Adjusting bevel indicator” (Page 30).

- Loosen the bevel lock lever (23) counter-clockwise.
- Adjust bevel angle by first pushing height/bevel adjusting handwheel (21) all the way to the left.
- Holding height/bevel adjusting handwheel, slide bevel indicator to the right to increase angle of blade (30) (bringing it closer to 45° from the tabletop). Holding height/bevel adjusting handwheel, slide bevel indicator to the left to decrease the angle (bringing blade closer to 90° from the table top).
- Make sure blade (30) is at desired angle. Tighten bevel lock lever (23) clockwise.

⚠ WARNING: Make sure the blade guard is in place after adjusting blade angle. Failure to heed this instruction could result in serious personal injury.

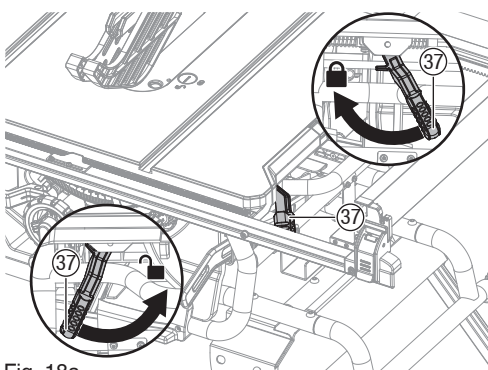


Fig. 18a

RIP FENCE (Fig. 18a-18c)

⚠ WARNING: To reduce the risk of injury, always make sure the rip fence is parallel to the blade before beginning any operation.

Fence rails lock lever (Fig. 18a)

The fence rails lock lever locks the rip fence in place preventing movement during cutting.

- To lock the fence rails lock lever (37), push it up and toward the front of the saw.
- To unlock the fence rails lock lever (37), push it down and toward the rear of the saw.

⚠ CAUTION: When ripping, always lock the fence rails lock lever.

Narrow fence (Fig. 18b)

- When using the narrow fence (2) to support a workpiece that extends beyond the working table, rotate the narrow fence (2) as shown in (Fig. 18b) and secure it in the lowest position A for both the front and back slots.
- When using the narrow fence (2) to cut a narrow workpiece, rotate the narrow fence (2) as shown in (Fig. 18b) and secure it in the upper position B for both the front and back slots.

⚠ CAUTION: Always use the auxiliary fence (not the narrow fence) when ripping material 3 mm or thinner to prevent stock from slipping under the fence.

NOTE: If the narrow fence is not required, always place it in the position C as shown (Fig. 18b).

NOTE: The narrow fence (2) for cutting a narrow workpiece can provide more space for a push stick without removing the blade guard.

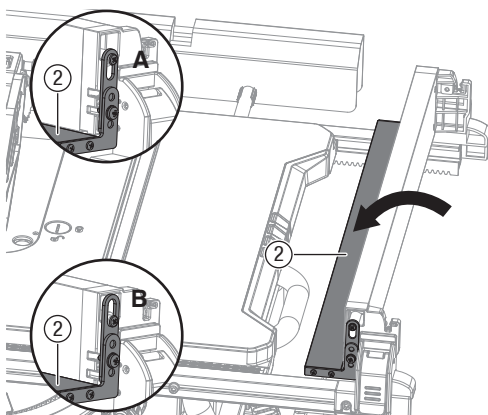


Fig. 18b

Adjusting knob (Fig. 18c)

The adjusting knob allows smaller adjustments when setting the rip fence.

- Unlock the fence rails lock lever (37).
- Slide the rip fence (18) close to the desired position.
- Slowly turn the adjusting knob (4) to set the rip fence (18) to desired position. Turn the adjusting knob (4) clockwise will extend the fence rails to right. Turn the adjusting knob (4) counter-clockwise will extend the fence rails to left.
- Lock the fence rails lock lever (37).

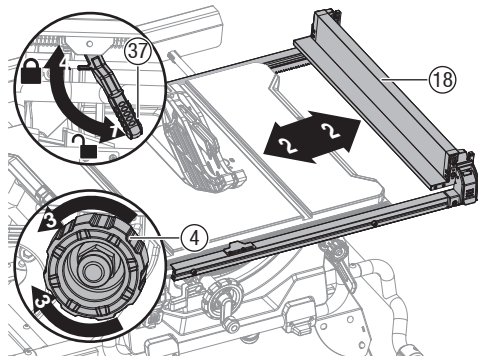


Fig. 18c

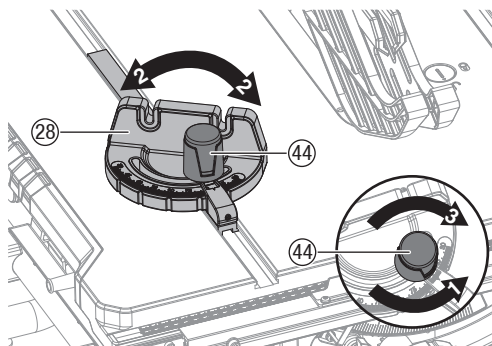


Fig. 19

MITRE GAUGE (Fig. 19)

The mitre gauge (28) provides accuracy in angled cuts. For very close tolerances, test cut are recommended. There are two mitre gauge grooves, one on either side of blade. When making a 90° cross cut, use either mitre gauge groove. When making a beveled cross cut (blade tilted in relation to working table, mitre gauge should be located in groove on right so that blade is tilted away from mitre gauge and hands.

Using mitre gauge

- Loosen mitre gauge lock knob (44) turning it counterclockwise.
- With mitre gauge in mitre gauge groove, rotate gauge until desired angle on scale is reached.
- Retighten mitre gauge lock knob (44) turning it clockwise.

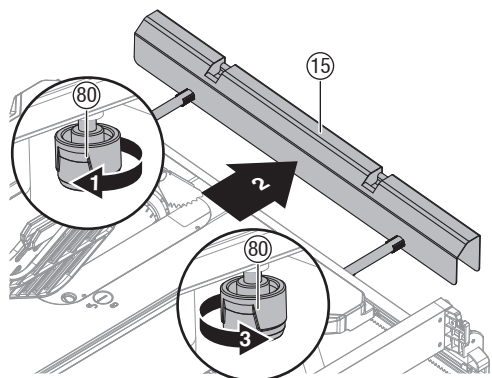


Fig. 20

OUTFEED SUPPORT (Fig. 20)

The outfeed support slides to give operator additional support for cutting long workpieces.

- Unplug the saw.
- Loosen the lock knobs (80) under the working table counter-clockwise.
- Stand behind saw. Grasp outfeed support (15) with both hands and pull until it is fully extended.
- Tighten the lock knobs (80) clockwise.

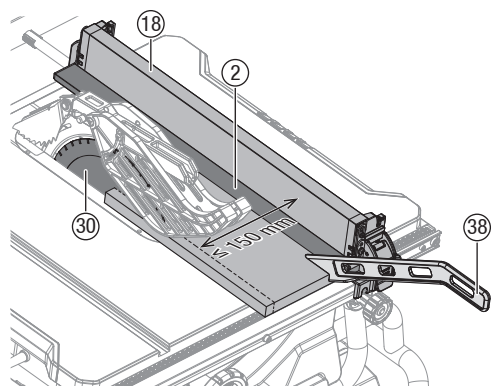


Fig. 21

PUSH STICK (Fig. 21)

Push stick (38) is a device used for safely pushing a work piece through the blade instead of using your hands. A push stick is included with your saw, but it can be made from scrap wood in various sizes and shapes to be used in a specific project. The stick must be narrower than the work piece, with a 90° notch in one end and shaped for a grip on the other end.

Push stick should be used in place of the user's hand to guide the material between the fence and blade. When using a push stick, the trailing end of the board must be square.

A push stick against an uneven end could slip off or push the work piece away from the fence, which may cause kickback resulting in serious personal injury. The push stick can be stored in the push stick storage (36).

⚠ WARNING: Always use the push stick with the narrow fence (2) whenever the fence is 150 mm or less from the blade.

⚠ WARNING: When the push stick is not in use, always it must be stored in the push stick storage.

THROUGH CUTS

⚠ WARNING: Always make sure the blade guard and anti-kickback pawls are in place and working properly when making these cuts to avoid possible injury.

⚠ WARNING: Use extra caution when cutting wood products having slippery surface as the anti-kickback pawls may not always be effective.

⚠ WARNING: DO NOT use blades rated less than the speed of this tool. Failure to heed this warning could result in personal injury.

⚠ WARNING: To avoid kickback, make sure one side of the workpiece is securely against the rip fence during any rip cut, and hold the workpiece firmly against the mitre gauge during any mitre cut.

⚠ WARNING: DO NOT attempt compound mitre cuts, with blade beveled and mitre fence angled, until you are thoroughly familiar with the basic cuts and understand how to avoid kickback.

⚠ WARNING: DO NOT attempt to make any cuts not covered here.

⚠ WARNING: Using rip fence as a cutoff gauge when cross cutting will result in kickback which can cause serious personal injury.

⚠ WARNING: NEVER make freehand cuts (cuts without mitre gauge or rip fence). Unguided workpieces can result in serious injury.

⚠ WARNING: Never make through cuts without the blade guard in place. Failure to heed this instruction could result in serious personal injury.

CUTTING TIPS

- The kerf (the cut made by the blade in the wood) will be wider than the blade to avoid overheating or binding. Make allowance for the kerf when measuring wood.
- Make sure the kerf is made on the waste side of the measuring line.
- Cut the wood with the finish side up.
- Knock out loose knots before making cut.
- Always provide proper support for wood as it comes out of saw.

MAKING CUTS

- Stand slightly to the side of blade path to reduce the chance of injury should kickback occur.
- Use mitre gauge when making cross, mitre, bevel and compound mitre cuts. To secure angle, lock mitre gauge in place by twisting lock knob clockwise. ALWAYS tighten lock knob securely in place before use.

⚠WARNING: Never use the fence and mitre gauge together. This may cause a kickback condition and injury to the operator.

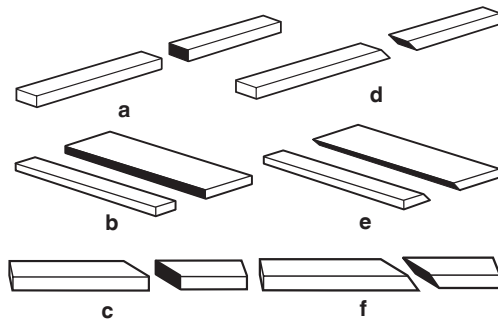


Fig. 22

TYPES OF CUTS (Fig. 22)

There are six basic cuts: a) the cross cut, b) the rip cut, c) the mitre cut, d) the bevel cross cut, e) the bevel rip cut, and f) the compound (bevel) mitre cut.

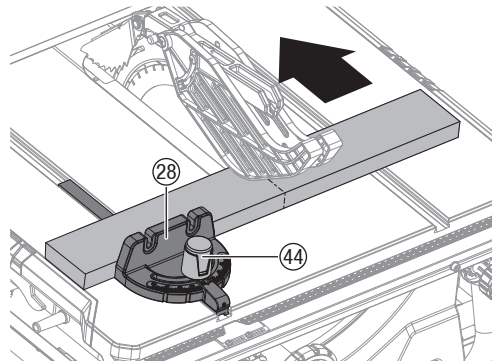


Fig. 23

MAKING A CROSS CUT (Fig. 23)

- Remove rip fence.
- Set blade to correct depth for workpiece.
- Set mitre gauge (28) to 0° and tighten lock knob (44).
- Make sure wood is clear of blade before turning on saw.
- To turn saw on, press switch button.
- Let blade build up to full speed before moving workpiece into blade.
- Hand closest to blade should be placed on mitre gauge lock knob and hand farthest from blade should be placed on workpiece. Feed workpiece into blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

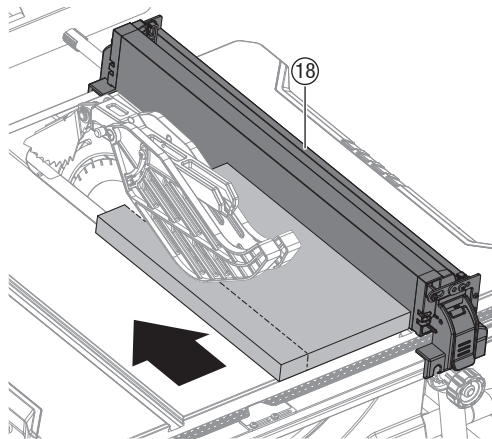


Fig. 24

MAKING A RIP CUT (Fig. 24)

- Set blade to correct depth for workpiece.
- Unlock the fence rail lock lever and slide rip fence (18) to desired distance from blade for cut.
- Lock the fence rail lock lever.
- Make sure wood is clear of blade before turning on saw.
- When ripping a long workpiece, slide the outfeed support to fully extend.
- To turn saw on, press switch button.
- Position workpiece flat on table with edge flush against rip fence (18). Let blade build up to full speed before feeding workpiece into blade.
- Once blade has made contact with workpiece, use hand closest to rip fence for guidance. Make sure edge of workpiece remains in solid contact with both rip fence and surface of table. If ripping a narrow piece, use push stick and/or push blocks to move piece through cut and past blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

⚠WARNING: When ripping, always apply the workpiece feeding force between the fence and the saw blade. Use a push stick when the distance between the fence and the saw blade is less than 150 mm, and use a push block when this distance is less than 50 mm. Cutting aids will keep your hand at a safe distance from the saw blade.

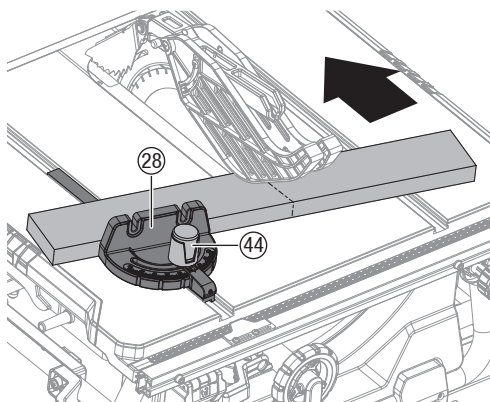


Fig. 25

MAKING A MITRE CUT (Fig. 25)

- Remove rip fence.
- Set blade to correct depth for workpiece.
- Set mitre gauge (28) to the desired angle and tighten lock knob (44).
- Make sure the wood is clear of the blade before turning on the saw.
- Turn the saw on.
- Let the blade build up to full speed before moving the workpiece into the blade.
- Hand closest to blade should be placed on mitre gauge lock knob and hand farthest from blade should be placed on workpiece. Feed workpiece into blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

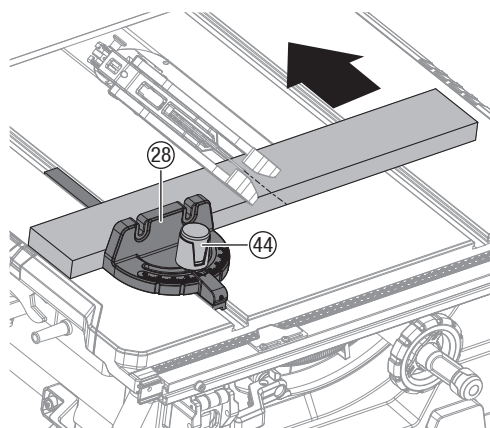


Fig. 26

MAKING A BEVEL CROSS CUT (Fig. 26)

- Remove rip fence.
- Unlock bevel lock lever.
- Adjust bevel angle to desired setting.
- Lock bevel lock lever.
- Set blade to correct depth for workpiece.
- Set mitre gauge (28) to 0° and tighten lock knob (44).
- Make sure wood is clear of blade before turning on saw.
- Turn saw on.
- Let blade build up to full speed before moving workpiece into blade.
- Hand closest to blade should be placed on mitre gauge lock knob and hand farthest from blade should be placed on workpiece. Feed workpiece into blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

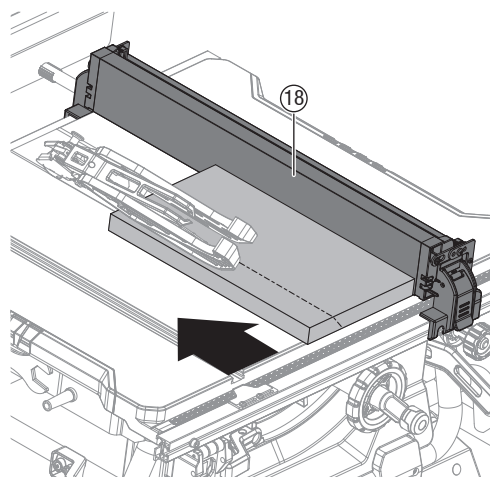


Fig. 27

MAKING A BEVEL RIP CUT (Fig. 27)

⚠WARNING: Make sure that the rip fence is on the right side of the blade to avoid trapping the wood and causing kickback. Kickback and serious personal injury will result if the rip fence is placed to the left of the blade.

- Remove mitre gauge.
- Unlock bevel lock lever.
- Adjust bevel angle to desired setting.
- Lock bevel lock lever.
- Set blade to correct depth for workpiece.
- Unlock the fence rails lock lever and slide rip fence (18) to desired distance from blade for cut.
- Lock the fence rails lock lever.
- Make sure wood is clear of blade before turning on saw.
- When ripping a long workpiece, slide the outfeed support to fully extend.
- Turn saw on.
- Position workpiece flat on table with edge push against rip fence (18).
- Let blade build up to full speed before moving workpiece into blade.
- Once blade has made contact with workpiece, use hand closest to rip fence for guidance. Make sure edge of workpiece remains in solid contact with both rip fence and surface of table. If ripping a narrow piece, use push stick to move piece through cut and past blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

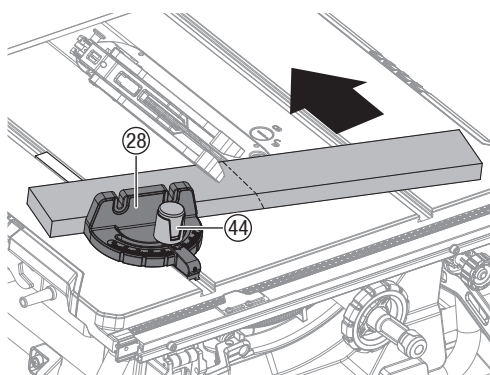


Fig. 28

MAKING A COMPOUND (BEVEL) MITRE CUT (Fig. 28)

- Remove rip fence.
- Unlock bevel lock lever.
- Adjust bevel angle to desired setting.
- Lock bevel lock lever.
- Set blade to correct depth for workpiece.
- Set mitre gauge (28) to desired angle and tighten lock knob (44).
- Make sure wood is clear of blade before turning on saw.
- Turn the saw on.
- Let the blade build up to full speed before moving the workpiece into the blade.
- Hand closest to blade should be placed on mitre gauge lock knob and hand farthest from blade should be placed on workpiece. Feed workpiece into blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

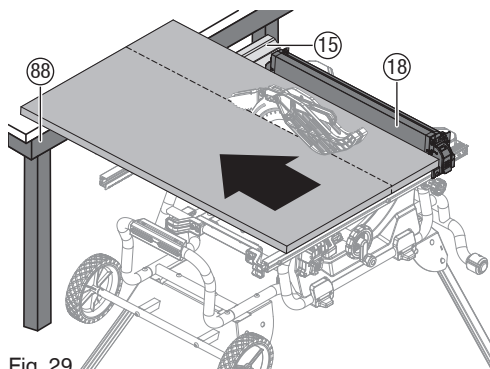


Fig. 29

MAKING A LARGE PANEL CUT (Fig. 29)

- Slide the outfeed support (15) to fully extend, and place a support (88) the same height as top of working table behind saw for cut and add supports to sides as needed.
- Depending on shape of panel, use rip fence or mitre gauge. If panel is too large to use either rip fence or mitre gauge, it is too large for this saw.
- Make sure wood does not touch blade before saw is turned on.
- Turn the saw on.
- Position workpiece flat on table with edge flush against rip fence. Let blade build up to full speed before feeding workpiece into blade.
- Use push stick to move piece through cut and past blade.
- When cut is complete, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

MAKING A NON-THROUGH CUT

The use of a non-through cut is essential to cutting grooves and rabbets. Non-through cuts can be made using a standard blade having a diameter of 254 mm. Non-through cuts are the only type of cuts that should be made without the blade guard assembly and anti-kickback pawls installed. Make sure the blade guard assembly and anti-kickback pawls are reinstalled upon completion of this type of cut.

⚠ WARNING: To reduce the risk of serious injury when making nonthrough cuts, follow all applicable warnings and instructions listed below in addition to those listed above for the relevant through cut.

⚠ WARNING: When making a non-through cut, blade is covered by workpiece during most of cut. Be alert to exposed blade at start and finish of every cut to avoid the risk of personal injury.

⚠ WARNING: Never feed wood with hands when making any non-through cuts such as rabbets. To avoid personal injury, always use push blocks, push sticks, and/or featherboards.

⚠ WARNING: Read the appropriate section which describes the type of cut in addition to this section on non-through cuts. For example, if your non-through cut is a straight cross cut, read and understand the section on straight cross cuts before proceeding.

⚠ WARNING: Once non-through cuts are completed, unplug saw and reinstall riving knife in uppermost position. Install antikickback pawls and blade guard.

- Unplug saw.
- Unlock release lever.
- Adjust bevel angle to 0°.
- Lock release lever.
- Remove blade guard (1) and anti-kickback pawls (48).
- Set the riving knife (16) in "MIDDLE" position and lock the riving knife lock knob (61).
- Plug saw into power source and turn saw on.
- Let blade build up to full speed before moving workpiece into blade.
- Always use push blocks, push sticks, and/or featherboard when making non-through cuts to reduce the risk of serious injury.
- When cut is made, turn saw off. Wait for blade to come to a complete stop before removing workpiece.

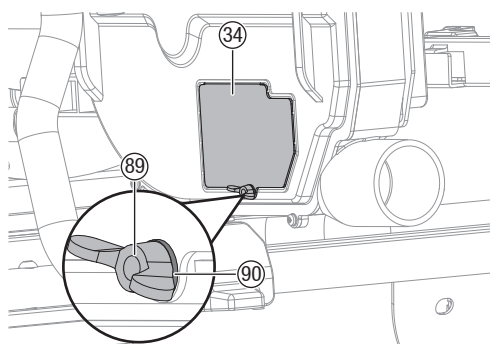


Fig. 30

DUST COLLECTION (Fig. 30)

This table saw is equipped with a dustshroud and dust collection port. For best results, connect a vacuum to the port at the rear of the saw. After extended use, the saw's dust collection system may become clogged.

To clear the dust collection system:

- Unplug the saw.
- Loosen and remove the thumb screw (89) and flat washer (90), then open the small baffle (34).
- Clean out the excess dust, and push the small baffle in place, replace the flat washer and screw.

ADJUSTMENTS

⚠ WARNING: Before performing any adjustment, make sure tool is unplugged from power supply and switch is in off position. Failure to do so could result in serious personal injury.

⚠ WARNING: Make sure the blade guard is reinstalled immediately after making any adjustment which requires it to be removed. Failure to heed this instruction could result in serious personal injury.

The table saw has been adjusted at the factory for making very accurate cuts. However, some components might have been jarred out of alignment during shipping. Also, over a period of time, readjustment will probably become necessary due to wear.

Carefully check alignment with a framing square before beginning adjustments to confirm whether they are necessary. Use test cuts after completing adjustments to avoid damaging workpiece.

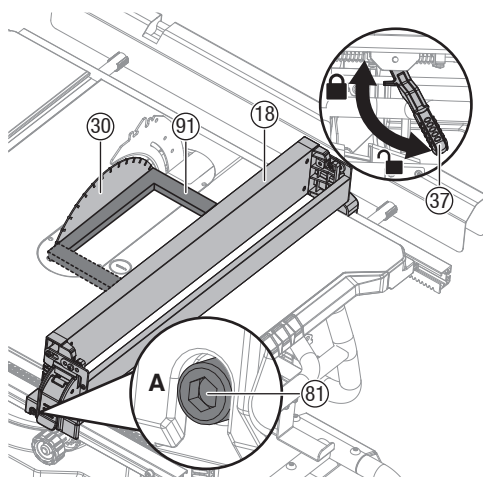


Fig. 31

ALIGNING RIP FENCE TO BLADE (Fig. 31)

Rip fence and blade alignment is set at factory and in most cases will not need to be adjusted. However, the alignment should always be checked after installing blade or before making cuts, and can be adjusted if necessary. If rip fence is out of alignment with blade, adjustment is needed.

⚠ WARNING: Rip fence must be aligned to blade so that wood does not bind, resulting in kickback. Failure to do so could result in serious personal injury.

DO NOT loosen any position screws for this adjustment until alignment has been checked with a square to be sure adjustment are necessary. Once screws are loosened, items must be reset.

⚠ WARNING: Unplug saw. Remove blade guard and anti-kickback pawls. Raise the blade by turning height adjusting knob.

To check/adjust

- Place the framing square (91) beside the blade (30), and unlock the fence rails lock lever (37) to move the rip fence (18) up to the square.
- Lock the fence rails lock lever (37) and note the measurement on the rip scale.
- Move the fence back and rotate the framing square (91) 180° to check the other side.
- If the two measurements are not the same, loosen the position screws (81) on the extension poles and then align it.
- Retighten the position screws with 5 mm hex key (supplied). Recheck alignment after position screws are retightened.
- Reinstall the blade guard and anti-kickback pawls.
- Make two or three test cuts using scrap wood. If the cuts are not true, repeat the process.

⚠ WARNING: The adjustment must be correct. If it is not, kickback could result in a serious injury and inability to make accurate cuts.

⚠ WARNING: Make sure the blade guard is reinstalled immediately after making any adjustment which requires it to be removed. Failure to heed this instruction could result in serious personal injury.

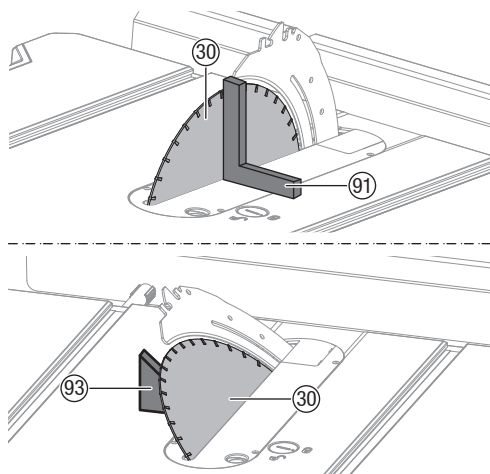


Fig. 32a

BEVEL ADJUSTMENT (Fig. 32a-32b)

This saw has positive stops that will quickly position the saw blade at 90° (0°) or 45° to the table. Angle settings of saw have been set at the factory and, unless damaged in shipping, should not require setting during assembly. After extensive use, they may need to be checked.

To check 90° (0°) bevel

- Unplug the saw.
- Raise the blade to the maximum height by turning the height adjusting knob clockwise.
- Remove the anti-kickback pawls and blade guard.
- Using a framing square (91), set the blade (30) to exactly 90°.
- If the blade stops bevelling before it gets to 90°, loosen the 90° stop set screw (92) (located at the left of the bevel track on the front), and then adjust it to 90°.
- With the blade set at 90°, slowly turn the 90° stop set screw (92) until you feel resistance. Bevel the blade away from 90° a little, and then back to the stop.
- Re-measure the angle and repeat the stop adjustment as necessary until the blade stops at 90°.

To check 45° bevel

- Unplug the saw.
- Raise the blade to the maximum height by turning the height adjusting knob clockwise.

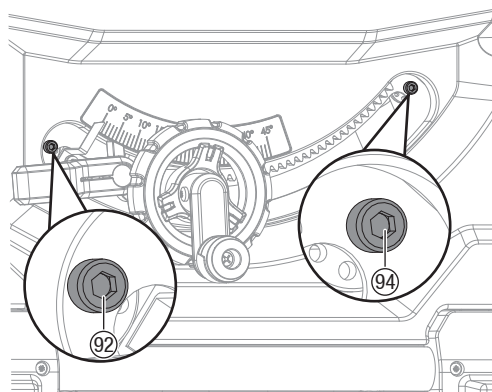


Fig. 32b

- Remove the anti-kickback pawls and blade guard.
- Using a triangle square (93), set the blade (30) to exactly 45°.
- If the blade stops bevelling before it gets to 45°, loosen the 45° stop set screw (93) (located at the right of the bevel track on the front), and then adjust it to 45°.
- With the blade set at 45°, slowly turn the 45° stop set screw (93) until you feel resistance. Bevel the blade away from 45° a little, and then back to the stop.
- Re-measure the angle and repeat the stop adjustment as necessary until the blade stops at 45°.

⚠ WARNING: For easy of use, bevel adjust should stop at 45° and 90°.

⚠ WARNING: Make sure the blade guard and anti-kickback pawls are reinstalled immediately after making any adjustment which requires it to be removed. Failure to heed this instruction could result in serious personal injury.

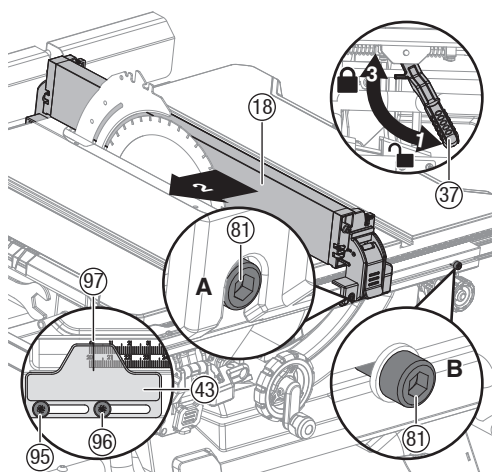


Fig. 33

ADJUSTING RIP FENCE SCALE INDICATOR (Fig. 33)

- Remove the anti-kickback pawls and blade guard.
- Unlock the fence rails lock lever (37).
- Mount the rip fence in position A. Adjust the blade to bevel 0° and then allow the left side of the rip fence (18) to touch the blade.
- Lock the lock lever (37) of the fence rails.
- Loosen the screws (95, 96) of the rip fence scale indicator (43) and set the red pointer (97) on the rip fence scale indicator (43) to be aligned with the zero point.
- Retighten the screws (95, 96) of the rip fence scale indicator (43).

NOTE: When the rip fence (18) is mounted on the right side of the blade, there are two positions. In position A, please read the top rip scale; It will be from 0 to 680 mm. In position B, please read the bottom scale; It will be from 200 mm to 880 mm.

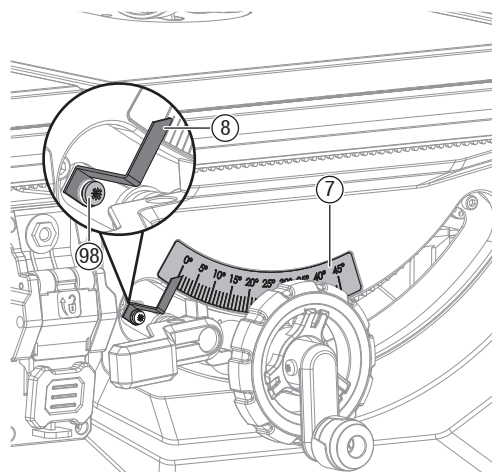


Fig. 34

ADJUSTING BEVEL INDICATOR (Fig. 34)

Adjust the red line on the bevel indicator if it is not aligned with zero when the blade is perpendicular to the table.

- With blade perpendicular to table, loosen screw (98).
- Set the bevel indicator (8) to align with 0° on bevel scale (7).
- Retighten screw (98).

MAINTENANCE

- ⚠ WARNING:** When servicing, use only identical replacement parts. Use of any other part may create a hazard or cause product damage.
- ⚠ WARNING:** Always wear eye protection during power tool operation or when blowing dust. If operation is dusty, also wear a dust mask.
- ⚠ WARNING:** Before performing any maintenance, make sure the tool is unplugged from the power supply and switch is in the off position.
- ⚠ WARNING:** DO NOT at any time let brake fluids, gasoline, petroleum-based products, penetrating oils, etc., come in contact with plastics parts. Chemicals can damage, weaken, or destroy plastic.
- ⚠ WARNING:** Make sure the blade guard is reinstalled immediately after finishing any maintenance which requires it to be removed. Failure to heed this instruction could result in serious personal injury.

GENERAL MAINTENANCE

- Avoid using solvents when cleaning plastic parts. Most plastics are susceptible to damage from various types of commercial solvents and may be damaged by their use. Use clean cloths to remove dirt, dust, oil, grease, etc.
- Periodically check all clamps, nuts, bolts, and screws for tightness and condition. Make sure the table insert is in good condition and level with the working table.
- Check the blade guard assembly after performing maintenance to make sure it is installed correctly and functioning properly.
- Clean plastic part only with a soft damp cloth. DO NOT use any aerosol or petroleum solvents.

LUBRICATION

All of the bearings in this tool are lubricated with a sufficient amount of high grade lubricant for the life of the unit under normal operating conditions. Therefore, no further lubrication is required.

SERVICE AND REPAIRS

All quality power tools will eventually require servicing or replacement of parts because of wear from normal use. To assure that only authorized replacement parts will be used and that the double insulation system will be protected, all service (other than routine maintenance) must be performed by an HiKOKI Authorized Service Center ONLY.

NOTE: Specifications are subject to change without any obligation on the part of HiKOKI.

STORAGE

After operation of the tool has been completed, check that the following has been performed:

- Switch is in OFF position.
- Power plug has been removed from the receptacle.

When the tool is not use, keep it stored in a dry place out of the reach of children.

TROUBLESHOOTING

⚠ WARNING: To avoid injury from an accidental start, turn the switch OFF and always remove the plug from the power source before making any adjustments.
All electrical or mechanical repairs should be done only by qualified service technicians. Contact HiKOKI Authorized Service Center.
Consult HiKOKI Authorized Service Center if for any reason the motor will not run.

PROBLEM	PROBLEM CAUSE	CORRECTIVE ACTION
Saw will not start.	<ul style="list-style-type: none"> ○ Overload tripped. ○ Saw is not plugged in. ○ Fuse blown or circuit breaker tripped. ○ Cord is damaged. 	<ul style="list-style-type: none"> ○ Allow motor to cool and reset by pushing overload reset switch. ○ Plug in saw. ○ Replace fuse or reset circuit breaker. ○ Have the cord replaced by an Authorized Service Center.
Does not make 45° and 90° rip cuts.	<ul style="list-style-type: none"> ○ Positive stop not adjusted correctly. ○ Bevel angle pointer not set accurately. ○ Rip fence not properly aligned. 	<ul style="list-style-type: none"> ○ See section "Bevel adjustment". ○ See section "Adjusting bevel indicator". ○ See section "Aligning rip fence to blade".
Material pinches blade when ripping.	<ul style="list-style-type: none"> ○ Rip fence not aligned with blade. ○ Warped wood, edge against fence is not straight. 	<ul style="list-style-type: none"> ○ See section "Aligning rip fence to blade". ○ Select another piece of wood.
Material binds on riving knife.	<ul style="list-style-type: none"> ○ Riving knife not aligned correctly with blade. 	<ul style="list-style-type: none"> ○ Align riving knife with blade.
Saw makes unsatisfactory cuts.	<ul style="list-style-type: none"> ○ Dull blade. ○ Blade mounted backwards. ○ Gum or pitch on blade. ○ Incorrect blade for work being done. ○ Gum or pitch on blade causing erratic feed. 	<ul style="list-style-type: none"> ○ Replace with the specified blade. ○ Turn the blade around. ○ Remove the blade and clean with turpentine and coarse steel wool. ○ Change the blade. ○ Clean table with turpentine and steel wool.
Material kicked back from blade.	<ul style="list-style-type: none"> ○ Riving knife not aligned correctly with blade. ○ Feeding stock without rip fence. ○ Riving knife not in place. ○ Dull blade. ○ The operator letting go of material before it is past saw blade. ○ Mitre gauge lock knob is not tightened. 	<ul style="list-style-type: none"> ○ Align riving knife with blade. ○ Install and use rip fence. ○ Install and use riving knife (with guard). ○ Replace with the specified blade. ○ Push material all the way past saw blade before releasing work. ○ Tighten lock knob.
Blade does not raise or bevel freely.	<ul style="list-style-type: none"> ○ Sawdust and dirt in elevation/beveling mechanisms. 	<ul style="list-style-type: none"> ○ Brush or blow out loose dust and dirt.
Blade does not come up to speed or reset trips too easily.	<ul style="list-style-type: none"> ○ Extension cord too light or too long. ○ Low house voltage. 	<ul style="list-style-type: none"> ○ Replace with adequate size cord. ○ Contact your electric company.
Machine vibrates excessively.	<ul style="list-style-type: none"> ○ The saw is not mounted securely to the stand. ○ Stand is on uneven floor. ○ Workbench is moving. ○ Damaged saw blade. 	<ul style="list-style-type: none"> ○ Tighten all mounting hardware. ○ Reposition on flat, level surface. ○ Securely the workbench to floor. ○ Replace blade.

SELECTING ACCESSORIES

The accessories of this machine are listed on page 11 (Refer to "LOOSE PARTS" chapter).

⚠ CAUTION: Repair, modification and inspection of HiKOKI Power Tools must be carried out by a HiKOKI Authorized Service Center.
In the operation and maintenance of power tools, the safety regulations and standards prescribed in Australia must be observed.

GUARANTEE

We guarantee HiKOKI Power Tools in accordance with statutory/country specific regulation. This guarantee does not cover defects or damage due to misuse, abuse, or normal wear and tear. In case of complaint, please send the Power Tool, undismantled, with the GUARANTEE CERTIFICATE found at the end of this Handling instruction, to a HiKOKI Authorized Service Center.

NOTE: Due to HiKOKI's continuing program of research and development the specifications herein are subject to change without prior notice.

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