Panel saw

S3.0 / S2.5 / S1.6

INSTRUCTION MANUAL

DB&S MACHINES

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INTRODUCTION

Dear Client,

We are pleased, that you have chosen for one of our products.

This instruction manual is made exclusively for our clients.
This handbook can give you all needed directions for a use without defect, serving the machine, maintenance and supply of spare parts.

ATTENTION: It's allowed to the manufacturor to make improvements to the machine, so it can occur that changes, for instance improvements are not yet included in the instruction manual.
We will keep this instruction manual as much as possible up-to-date.

Please read this instruction manual carefully, before you use the machine.
This to avoid problems and damages caused by unskilled use.

Working without disturbances and professional use of the machine is only possible, when the machine is cleaned frequently and used with skill.

The manufacturor takes no responsability for damages, caused by not following the following recommendations and directions.

DB&S Machines

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1. Description of the machine

The machine is a panel saw for wood and wood-like materials.
This panel saw is, following the type, with different lenghts of sliding tables.
(Panel saw, part 5) equipped,

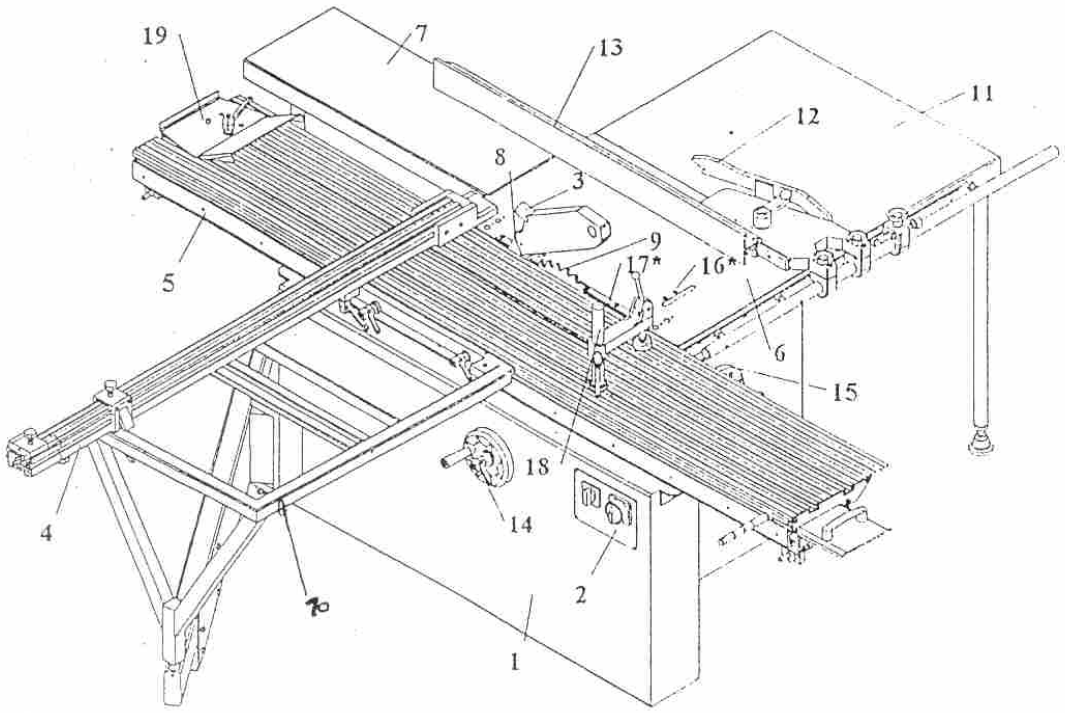
The saw blade (part 9) is adjustable in height and tiltable. As protections, there's a riving knife (part 8) and a covering (part 3) with a connection for the dustcollector.

For bigger panels is the machine equipped with an additional table, which is attached to the roller table and 2 fixed working surface enlargments (part 7 and part 11).

The machine is equipped with a parallel fence (part 13), without gradations, and a retearable degree fence for width and parallel cuts.

The machine can also be foreseen with a scoring unit, to avoid splintering.

Building parts of the machine (picture 1)



1) Main corps
2) Main switch
3) Saw blade protections with possibility for the dustextraction
4) Retearable degree fence
5) Roller table (format table)
6) Working surface
7) Working surface enlargment
8) Riving knife
9) Saw blade max. diameter 315 mm
10) Additional table
11) Working surface enlargment
12) Moving cane
13) Parallel fence
14) Handwheel for square adjustment of the saw blade
15) Handwheel for the height adjustment of the saw blade
16) Installation screws for the scoring unit
17) Scoring blade
18) Excentric clamp
19) Fence
20) Telescopic support
21) Square fence with measurement
22) Additional table for format table

1.1 Purpose of the machine

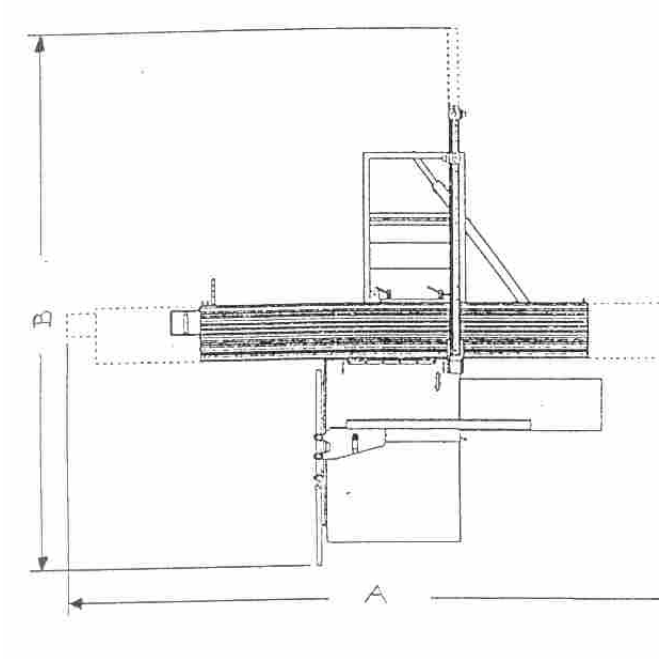
The machine is exclusifely meant to cut solid wood, fibre plates, panel plates or other wood-like materials.

ATTENTION: With this machine you can only work on wood or wood-like materials!
The machine may only be used with the prescribed protection devices.

2. Technical dates

Machine type	S1.6	S2.5	S3.0
Table dimension part 6	800 x 500 mm	800 x 500 mm	1100 x 600 mm
Roller table	1600 x 350 mm	2300 x 350 mm	3200 X 350 mm
Additional table for roller table part 10	900 x 610 mm	900 x 610 mm	1200x610 mm
Max. reach roller table	1600 mm	2500 mm	3000 mm
Add. worksurface part 7	850 x 320 mm	850 x 320 mm	900 x 400 mm
Addit. Worksurface part11	800 x 630 mm	800 x 630 mm	90 x 900 mm
Height workings surface	850 mm	850 mm	850 mm
Cutting width with parallel Fence and surface enlarg.t	800 mm	800 mm	1250 mm
Length carpenter's jqurare	1600 mm	1600 mm	2000 mm
Max. length degree fence	2800 mm	2800 mm	3320 mm
Max. diameter sawblade	315 mm	315 mm	315 mm
Min. diameter sawblade	250 mm	250 mm	250 mm
Shaftdiameter sawblade	30 mm	30 mm	30 mm
Max. cutting height 90°/45°			
With sawblade 315 mm	103/72 mm	103/72 mm	103/72 mm
With sawblade 250 mm	70/49 mm	70/49 mm	70/49 mm
Sawblade stop within	10 sec	10 sec	10 sec
Speed main sawblade	4000 rpm	4000 rpm	4000 rpm
Diameter dustextr.connect.	120 mm	120 mm	120 mm
Motor	5,5 Hp	5,5 Hp	5,5 Hp
Noise level			
Trial run	90 dB	90 dB	90 dB
Working	90 dB	90 dB	90 dB
Scoring unit (option)			
Speed scoring blade	8000 rpm	8000 rpm	8000 rpm
Diameter scoring blade	120-125 mm	120-125 mm	120-125 mm
Shafthole scoring blade	20 mm	20 mm	20 mm
Weight	420 kg	450 kg	480 kg

2.1 Building plan



	S1.6	S2.5	S3.0
A	4000 mm	5500 mm	7500 mm
B	4100 mm	4100 mm	5200 mm

ATTENTION: When building up the machine, pay attention that there is enough space for a safe working.

3. Security prescriptions

3.1 Security directions

Don’t work without the prescribed security devices.

Please follow the instruction manual carefully.

Tear out the electricity plug at all maintenance, equiping and cleaning operations and disturbances.
Test the security devices before working with the machine.

Never work with handgloves.

Keep the workplace and the machine always clean.

Pay attention to a good enlightning, without dark spots, in the workplace.

Don’t ever let the machine run unsupervised.

Before working, remove all unneeded pieces from the machine.

Before working, pay attention that the electrical connection is done skillfully.

Use the machine only for what it’s meant.

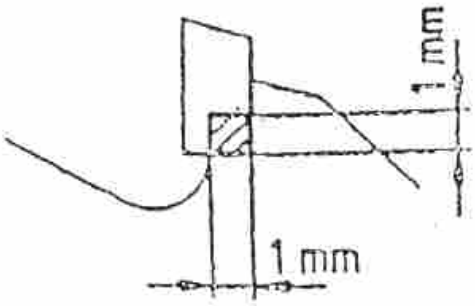
Pay attention to the max. speed of the used sawblade.

Only use a sawblade, when it’s well sharpened and without defects.
Stump sawblades overcharge the machine, give a bad working result and enheighten the back-slash danger.

Let sharpen the tools only by skilled personnel.

Never use carved, deformed, for instance repaired sawblades, please throw these away immediatly.

At a repairing, for instance the installation of a saw blade in connected execution (outblowing newer cutting plates) the construction must stay the same (form ot the teeth, teeth width).



Connected tools
(Saw blade with solded cutting plates)

Don’t work in humid rooms and don’t expose the machine to rain or low temperatures.

Don’t work with loose clothing, loose hair, sjawls, etc..
Take off your rings, chains, wristwatches and other, before working.

Always work with the prescribed protection devices (for instance hearing protection, ...)

Keep children away from the machine and make sure that children and unauthorised persons can’t start the machine.

Youngsters under 16, may only use the machine under supervision of a skilled adult.

Pay attention that the machine is only served by persons who are familiar with the working and the possible dangers, and who have full physical and mental capacities.

If it’s necessary to have auditif communication with other working or communication devices, this devices must be completed with optical signs.

4. Security devices

The security devices of this machine is according to the safety prescriptions of all EC-countries.

The machine is equipped with the following safety devices:

a) Electronic motor brake
   Thiss stops the shaft, when pushing the OUT- or EMERGENCY-button, within 10 seconds.
b) Endswitch
   Is activated when the roller table is in the end-position, needed to change the sawblade, or when flipping over of the sidewise sawblade protections, and avoids the starting of the machine when replacing a sawblade.
c) Clamp
   To clamp smaller workpieces.
d) Riving knife
   Possible to install for the main blade of 250 to 315 mm diameter.
e) Sawblade covering with possibility for dustextraction
f) Possibility for dustextraction form down below
g) Several little aids (for instance a pushing cane).
h) Outlining fence

5. Delivery prescription

Instruction manual
List sparts parts
4 feet for under the machine
Serving tools for equiping operations
1 excentric clamp
1 pushing cane
1 riving knife
1 sawblade covering with possiblilty for dustextraction
1 parallel fence with fine installation
1 degree fence, retearable
2 additional layers for working table enlargment
1 additional table for the roller table
1 outlining fence

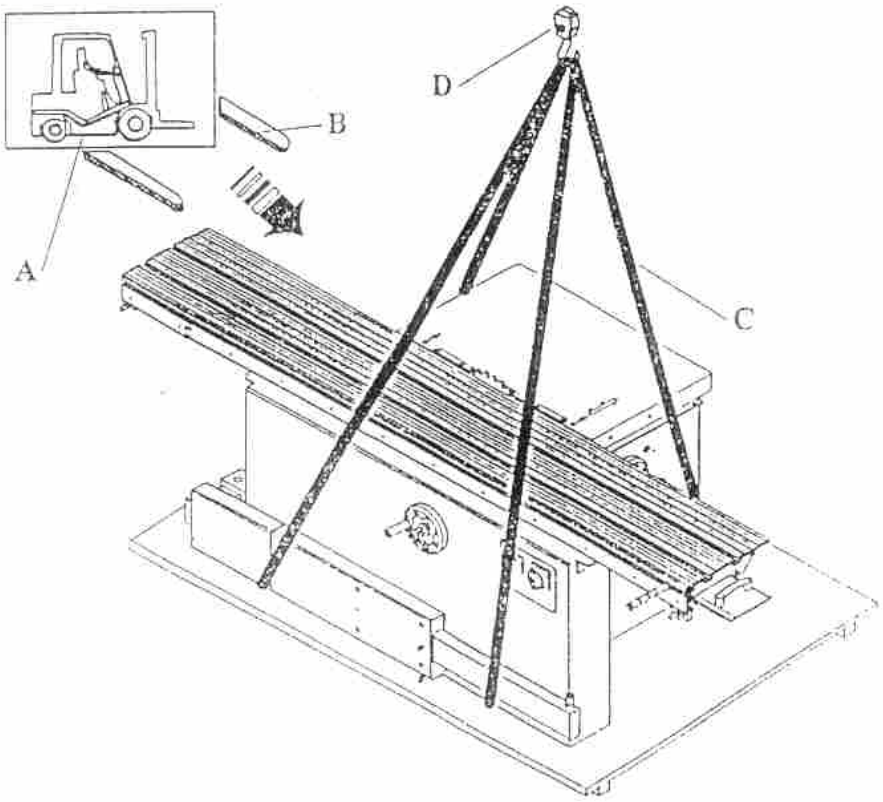
6. Transport prescriptions

Only transport the machine, when it's screwed to the pallet.

To lift the pallet or to move the machine with belts or girdles, you must lift the machine only at the therefor foreseen places.

When moving with a forklift, always use long forks and lift the pallet from the length direction.

ATTENTION: Lift and lower the machine without shocks!
Be sure that the machine is levelled!



7. Preparing the machine for first use

7.1 Cleaning

All shining parts, which were protected against rust for transport, must be cleaned with petrol or another degreasing products.

ATTENTION: Don't ever use nitrothinning products or other solving products!
Don't ever use water!

7.2 Building up

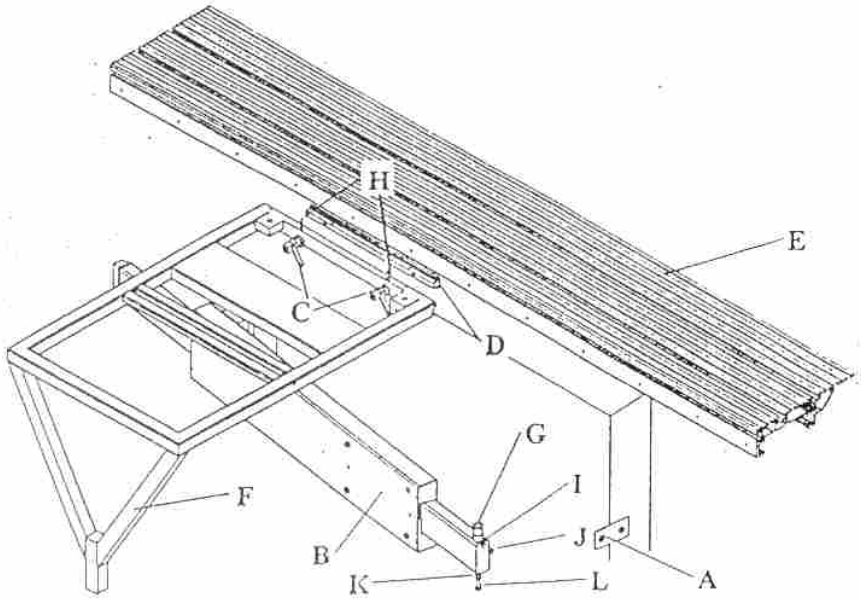
The machine must be levelled with all 4 installation feet, on a flat surface with a sufficient bearing power.

The levelling operation of the machine can be done by turning the installation screws on the feet of the machine.

Pay attention to have enough space around the machine.
This makes working more easy and lowers the danger level.

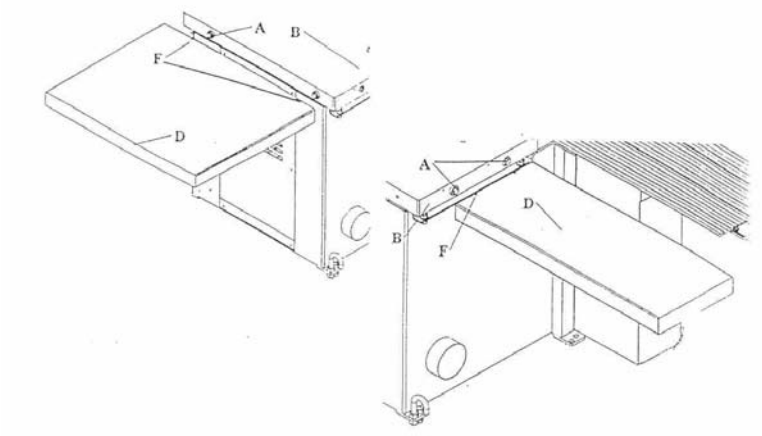
7.3 Preparation before working

7.3.1 Mounting the additional table F (picture 5)



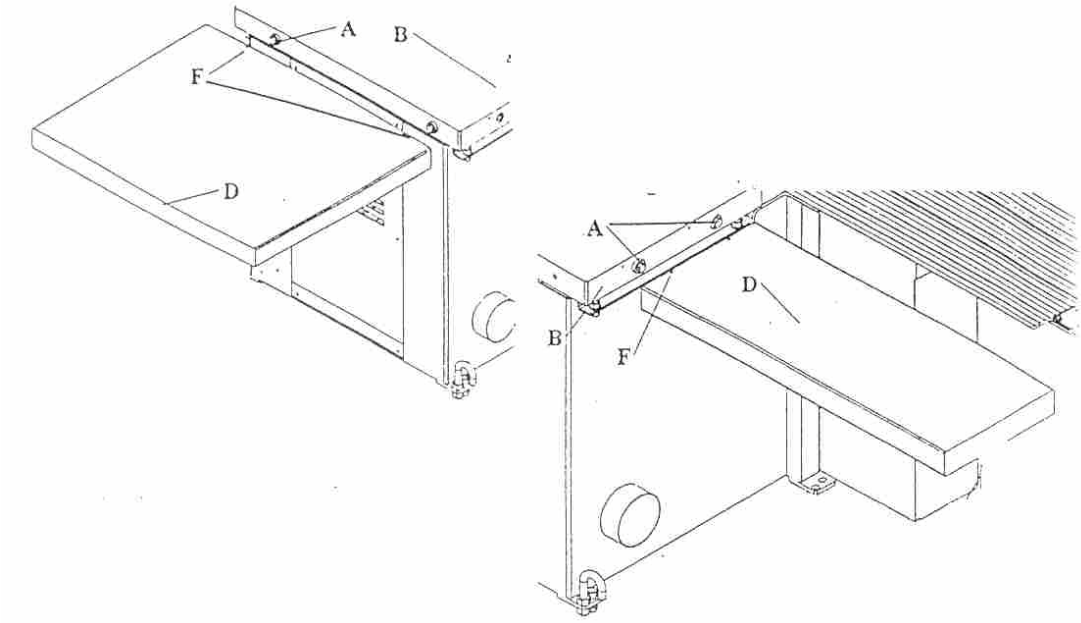
a) Loosen the transport security A from the telescopic support B.
b) Move the groove core D in the T-groove at the roller table.
c) Short screw the screw C with the add-ins to the thread D.
d) Place the additional table F on the bolts G and the screws C.
e) Test, if the onlay surfaces of both tables are parallel to each other and or on equal heights.
   When needes, you can change the installation with installation screws H und L.

7.3.2 Mounting the working surface enlargments D (picture 6)



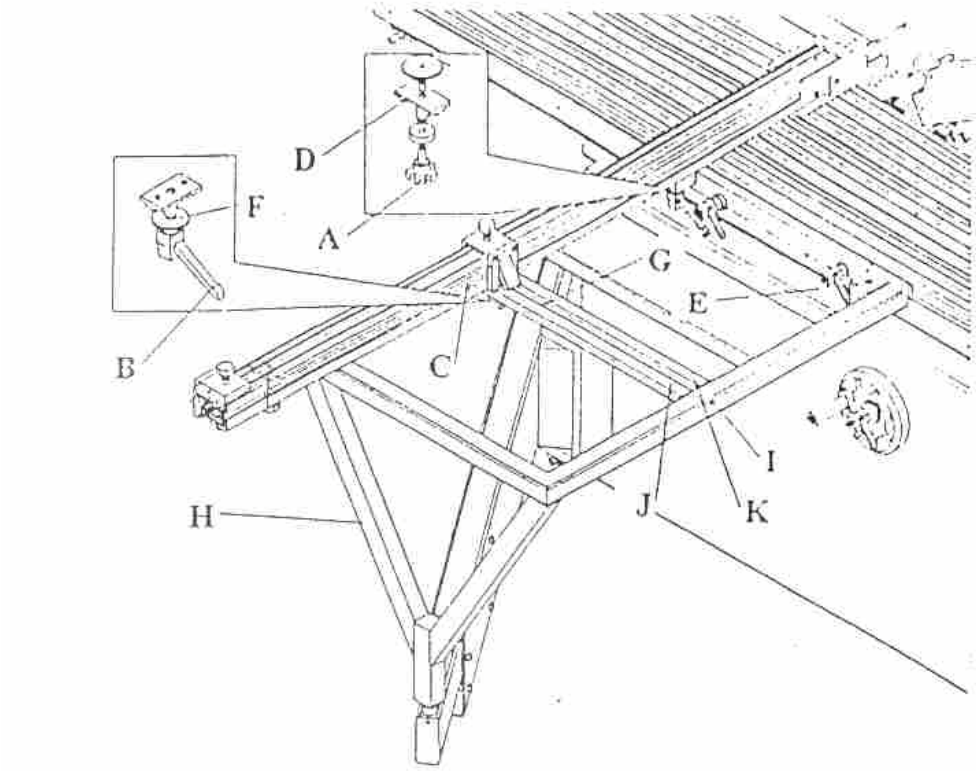
a) Loosen attachment screws A.
b) Screw supports C to layer D.
c) Place layer D on the attachment screws A.
d) Check if the table enlargments are flat and parallel with the table.
If needed, you can change this with the installation screws G and F.

7.3.3 Mounting the retearable degree fence C (picture 8)



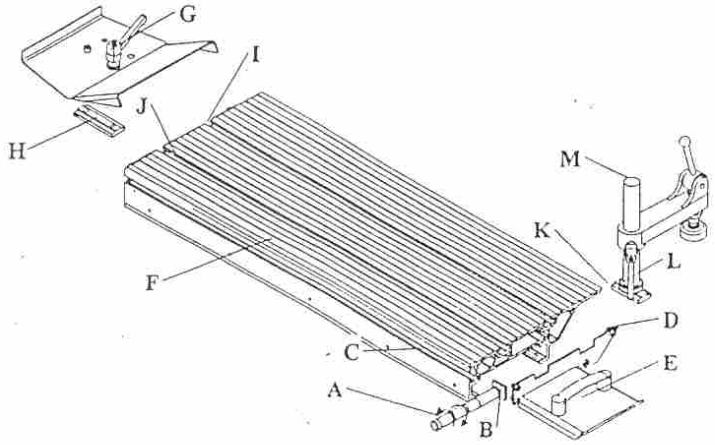
a) Place the take-up-cane of fence C in one of the two drillings E on the additional table H.
b) Screw the fence with both screws A and B.
c) Test if the installation of the fence is 90° to the sawblade, if needed you can adjust this with the installation screws.

7.3.4 Mounting the parallel fence (picture 9)



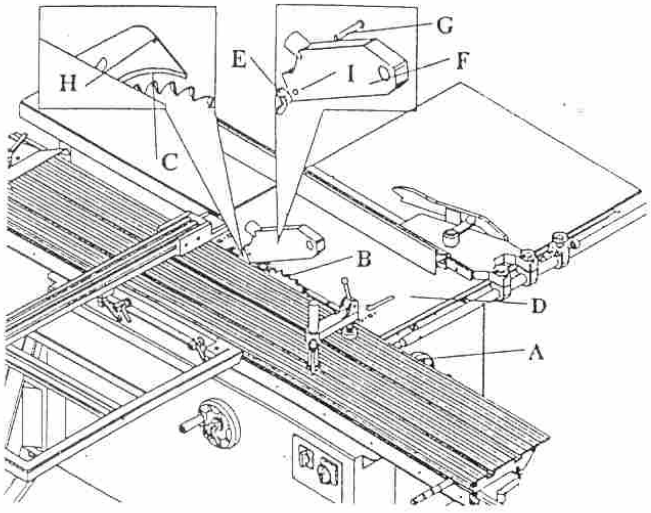
a) Mount the degree L with measurement to the side of the working surface G and H.
   The measurement start must flee with the teeth widht of the sawblade.
   The installation is done by moving of the degree parts.
b) Fasten the bar F on the side of the working surface with the cane screw and bolt D.
c) Move bar J on bar f.
d) Fasten fence I on bar J.
e) Install the fence lineals parallel to the sawblade by adjusting the propulsion bars with the attachment bolt.

7.3.5 Completing the roller table (picture 10)



a) Mount the grip and move groove core B in the T-groove C of table F and srew groove piece A in the thread of the groove core B.
The position of the grip on the working table can be chosen freely.
b) Screw covering E to the front side.
c) Mount the fence:
Move groove core H in T-groove J or I, put the fence on it.
Fasten screws G.
d) Mount the excentric clamp:
Move groove core K in T-groove J or I, screw column M and excenter arm with screw L.

7.3.6 Mounting the sawblade covering (picture 11)



Lift the saw-unit with handwheel A.
Place the sawblade covering on RIVING KNIFE C.
Fasten winged nut E in drilling H.

ATTENTION: Sawblade B must be lowered under working surface D to unmount sawblade covering I.

7.4 Electrical connection

The electrical connection may only be done by an electro-specialist.
The turning direction of the sawblade can be tested with short activiations.
When the turning directions isn't right, let an electro-specialist correct it.
The 0 and protection-supply must be available.

ATTENTION: The switching off of the machine may only be done with the foreseen switch, and certainly not by tearing out the electricity plug.

8. Serving the machine

ATTENTION: Check before you start to work, if the machine runs normally!
When you notice vibrations, check the sawblade on defects and swinging, on hard-metal sawblades you must look for defect teeth.
If there's a defect, you must take out the sawblade.
The covering must be mounted so that the sawblade is fully covered.
When the sawblade is lowered under the working surface, you must unmount the sawblade covering (part 3).

8.1 Adjusting the sawblade

Height adjustment:
Loosen screw H, put the sawblade in the desired height by turning handwheel D, fix screw H.

Adjusting the degree:
Loosen screw J, achieve the desired grade with handwheel I, fasten with screw J.
The adjustment can be read on the scale in the reach of handwheel G on the right side of the machine.

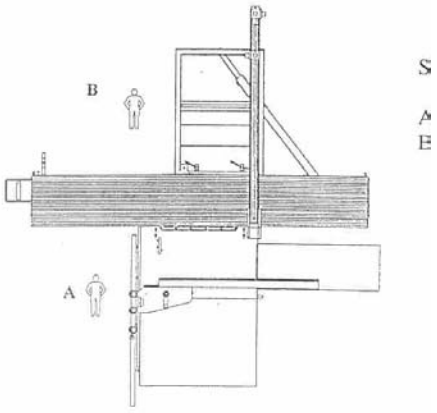
When the sawblade is lowered under the working surface, you must remove the sawblade protection.

8.2 Roller table

The roller table is stopped in the middle position by nut C.
Loosening the clamping screw B and fastening the bolts again, sets the table free.

8.3 Working positions

Serving the machine is only for one person.



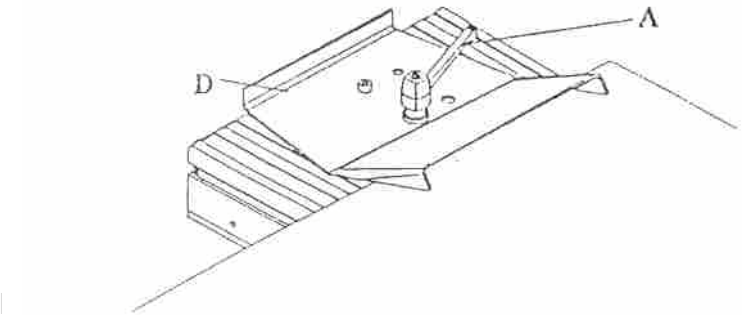
Working position of the workman

A. Working with the parallel fence
B. Working with the roller table

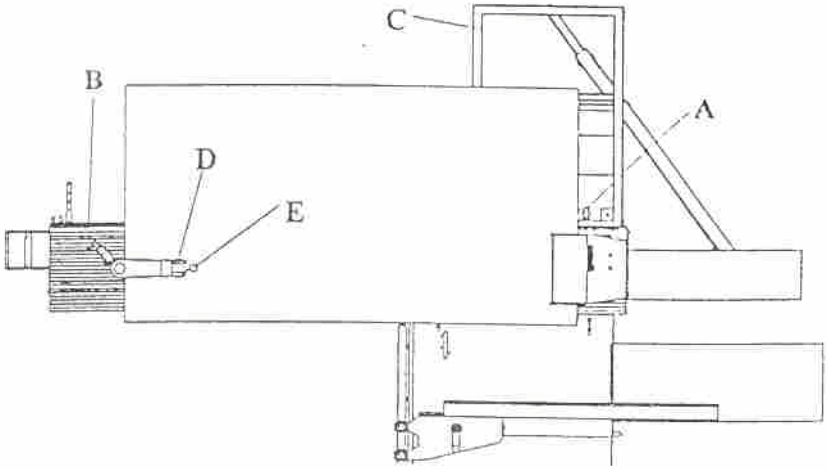
8.4 Working directions

You must use the roller table to cut longuer pieces!

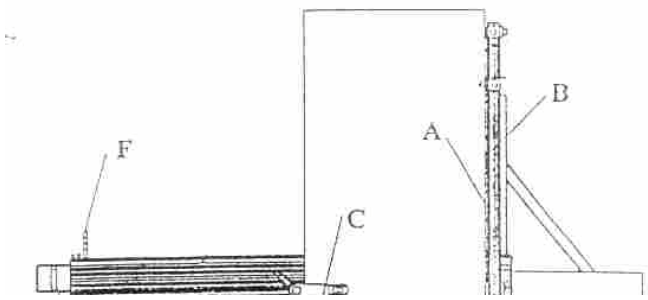
Cutting with fence (picture 34 and 35)



Mount fence D on table B, push the plate or piece against the fence and fix with excentric clamp D, like this, both ends are pushed below.

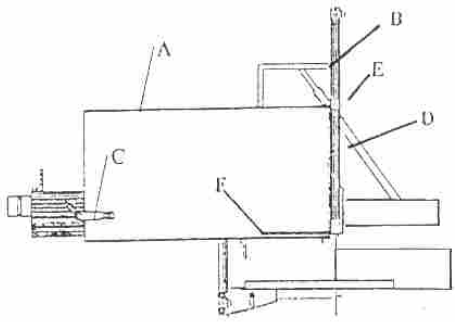


Cutting with retearable degree without sidefence (picture 36)

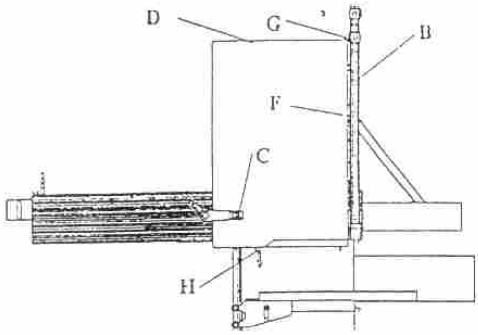


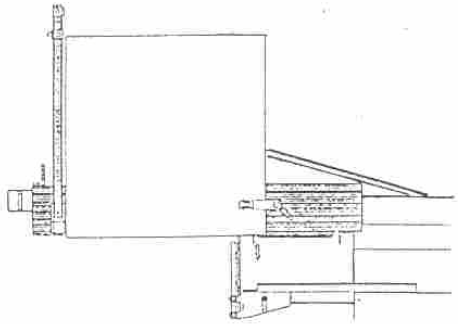
Lay the workpiece against the fence ons the desired measurement and fix with the excentric clamp.

Cutting with the retearable degree and sidefence (picture 37 and 38)

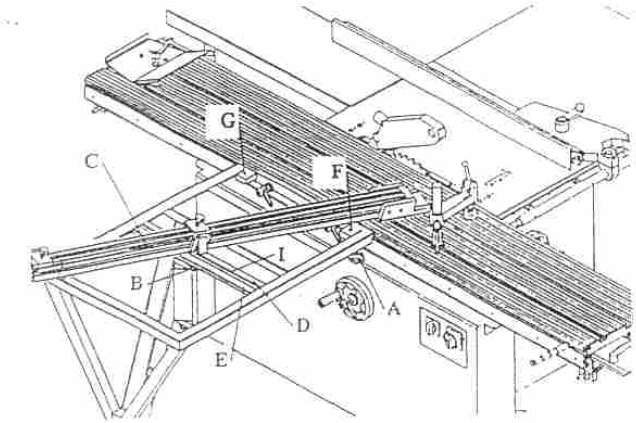


Install fence E on the desired cutting length, lay workpiece A against the installed fence and fix with excentric clamp D. Dependable ot the size of the workpiece, you can tear out the telescopic part of the fence and so prolong it.





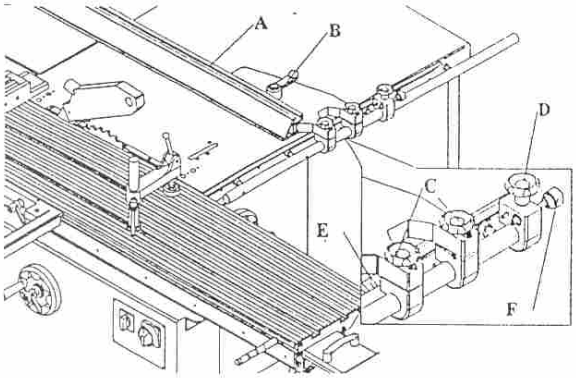
When necessary, you also place the fence for other works from the front side G to the back side F (picture 39). The workpiece is then moved from the fence (mostly to cut lighter plates).



Installing the degree (picture 40).

Installing the degree of fence C is done by loosening the clamp screw B and installing the desired position by turning the fence C around point F.
The degreescales can be found on E and D.

Working with the parallel fence (picture 30)

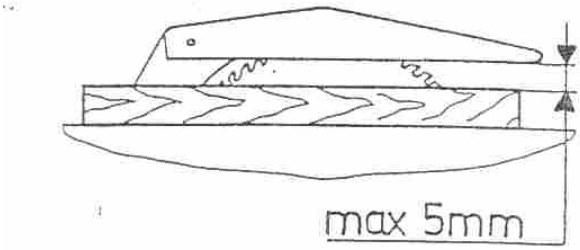


Use this for workpieces with two parallel moving sides. The parallel fence is fixed on the working surface and can be moved without gradations. The installed measurement can be viewed on scale E.

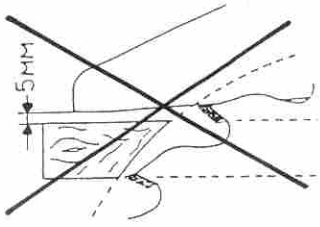
For thin workpieces, fence A can be turned 90° and converted. For that, the clamping of the fence is loosened by turning handle B, the fence is taken off the bar and turned 90°, moved back in the bar and fixed.

ATTENTION: When cutting smaller pieces, work with the moving cane or with the other aids!

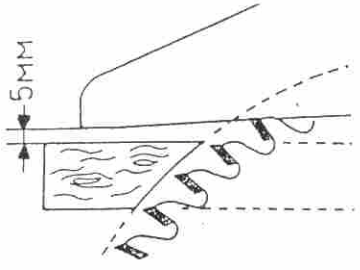
Installing the sawblade



Always look to the sawblade that all the teeth are covered with the awblade covering. The distance to the protection hood can't exceed 5 mm.

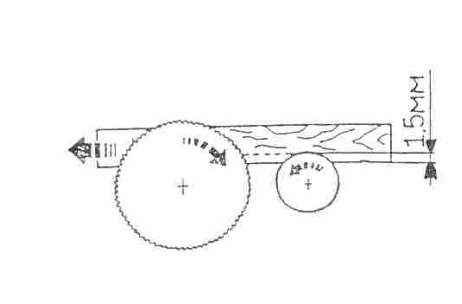


To improve the cutting quality and to avoid that the workpiece slashes back, you must install the sawblade so that at least 2 teeth cut the workpiece simultanously.



When this isn't possible, you must use a sawblade with finer teeth.
When cutting, move the workpiece without chocs, but move equally.

Install the height and degree of the sawblade only when the machine is turned off.
When cutting layered plates, you must use the scoring unit.

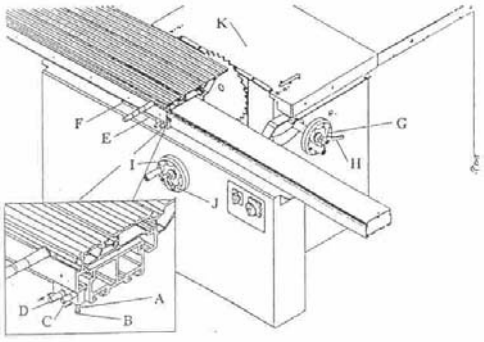


The cutting depth of the scoring blade must be approx. 1,5 mm.

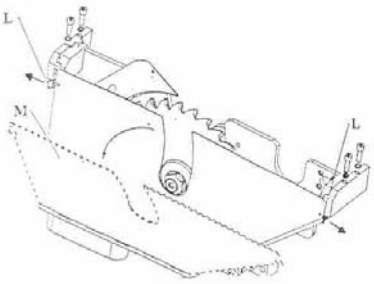
Harded sawblades must be cleaned
with an appropriate liquid, certainly not with a metal brush.

8.5 Taking out the sawblade

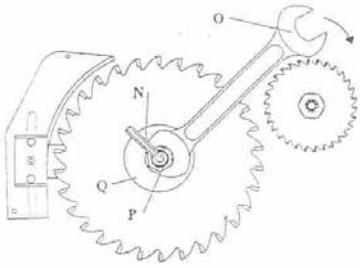
- Before you take out the sawblade, you must make sure the machine can't be started. TAKE OUT THE ELECTRICITY PLUG!!!



Bring the saw-unit with handwheel G to the highest position. Move the roller table as much as possible to the front, over the fence, so that the fence pen D is teared out (picture 14).



Deregulate protection plate M (picture 15) by pushing from the side on surface spring L and flip it over.



Unscrew the fixing nut P to the right (picture 16) with key Q (SW32) and hold it with key N (SW10) (Left rhreaded).

Take off the fixing flang and take off the sawblade.

8.6 Placing the sawblade

Move the new sawblade on the shaft.

ATTENTION: Pay attention to the direction of the teeth.

Move the clamping flange on the shaft, paying attention that the flange lays against the sawblade, if necessary turn it untill it moves on it (turning security).
Turn on the fixing nut by turning it to the left (holding it with a thorn or an imbuskey).

Test the turning by hand, if the sawblade turns around freely.
Flip down the protection plate.

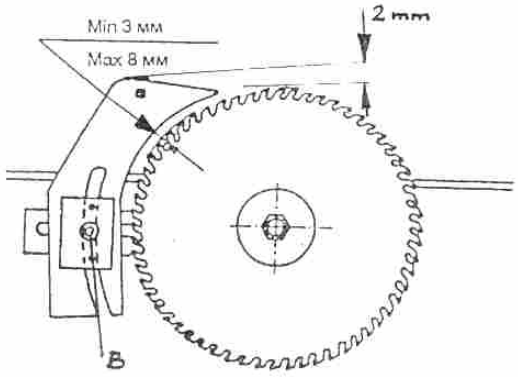
Retear the roller table from the most far position.

Shortly activate the machine to be sure that the sawblade turns without defects.

ATTENTION: When a sawblade with another diameter is installed, you must re-install the riving knife!

Installing the riving knife

Loosen nut B , adust the riving knife to the sawblade.
Refasten nut B.



ATTENTION: The distance from the riving knife to the sawblade must be min. 3 mm and max. 8 mm.
The upper side of the riving knife must be min. 2 mm above the height of the teeth.

8.7 Scoring unit

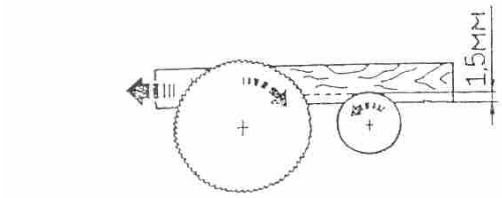
8.7.1 Installing and taking out of the scoring blade.

The installation or taking out of the scoring blade is done like by the main sawblade, you must also take the same safety measurements **(tear out the electricity plug).**

Pay attention to the following differences:

The fixing nut of the scoring blade is right-threaded, so you must loosen it by turning to the left.

The position of the teeth of the scoring blade is installed in opposite of the teeth of the main blade, because the turning direction of both blades is in opposite to each other (picture 16).

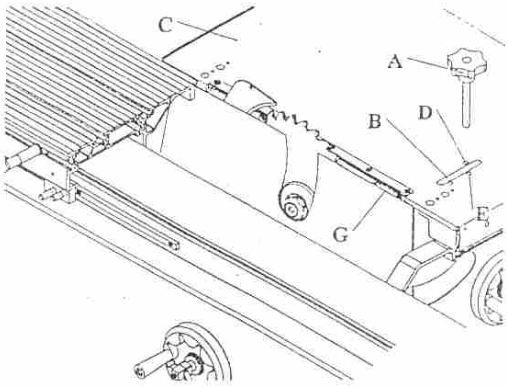


The scoring blade must be installed so that the max. cutting depth is 15 mm (picture 25).

8.7.2 Adjusting the scoring blade

Height-adjustment

Put key A in the drilling B on the square and by turning you adjust the height.



Tilting-adjustment

Put key A in the drilling E on the square and by turning, you obtain the desired tilting.

This adjustment is a fine adjustment, which is almost more viewable, because the main installations are already done when mounting the machine.

8.8 Safety directions

When installing a sawblade, you must pay attention that the shaft diameter of the blade is equal to the shaft diameter of the machine.

Don’t ever mount a blade with a bigger shaft diameter.

Defect or deformed sawblades may not be repaired.
You must throw them away immediatly.

Stump sawblades may only be sharpened by skilled people.

At a repairment, for instance setting right a layered sawblade (welding new cutting plates), the construction must stay the same (form of the teeth, for instance the width).

Layered tools (sawblades with welded cutting plates) may only be slitted to a max. diameter of 1 mm.

9. Maintenance of the machine

ATTENTION: Before starting maintenance works, you must be sure that the machine can't be started, so you must always tear out the electricity plug!!!

You must test the cutting plates of the sawblades (stump or broken teeth, defects...) and when necessary replace the sawblade.

9.1 Cleaning the machine

The machine must be cleaned frequently and profoundly of all dust and splinters.

9.2 Greasing the machine

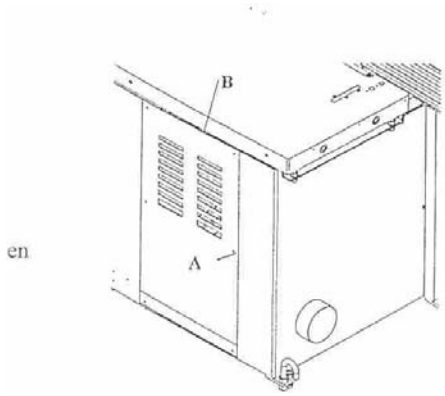
The roller bearings of the roller table and the parallel fence must be greased frequently slightly with an oilspray.

9.3 Testing the belts

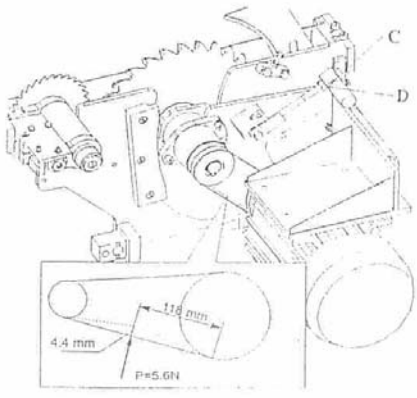
You must test the belts after the first 10 hours of working and if necessary, tighten them, later on you must check them frequently and tighten them if necessary.

Tightening the belts

Unscrew the back covering B (picture 41).



Test the tension of the belts by pressing, when the tension is too low, loosen 6-sided-nut D and fasten 6-sided-nut C untill the belts are inbetween the discs and it can be pressed approx.. 4 or 5 mm (picture 42).



ATTENTION: Don't tighten the belts too much, otherwise you may damage the roller bearings.

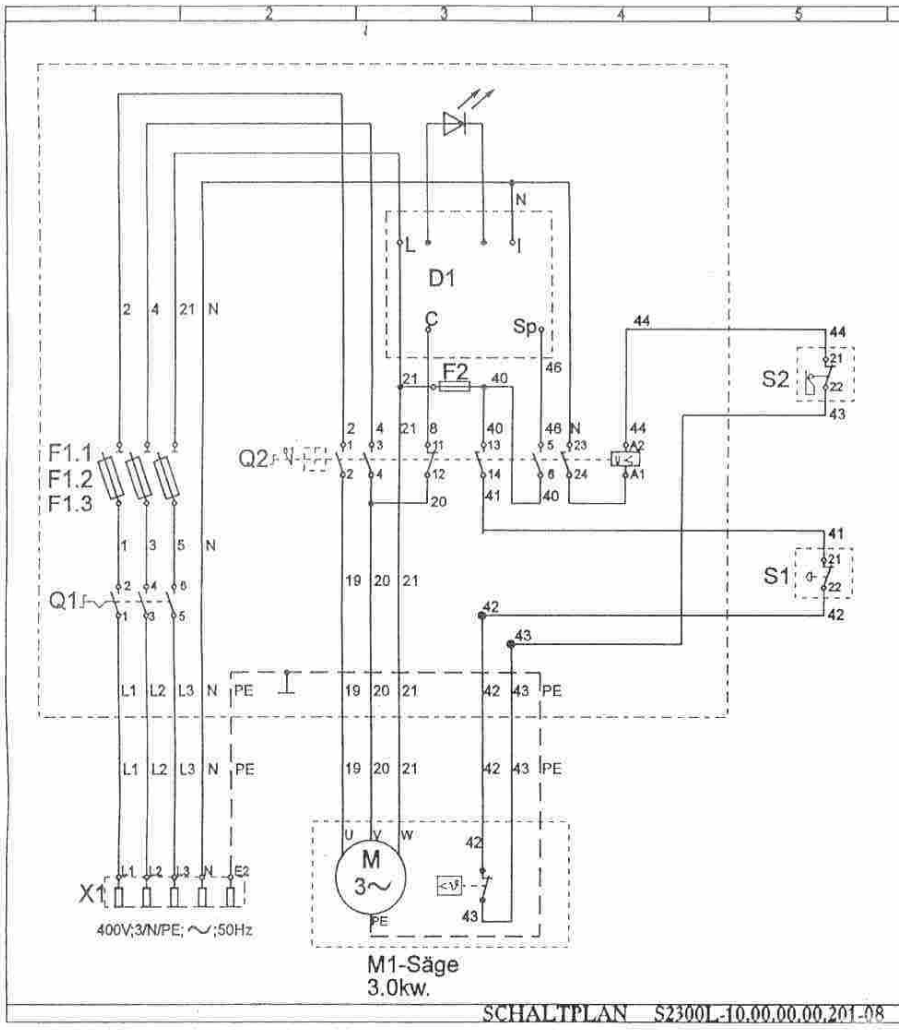
9.4 Testing the motorbrakes

The machine is equiped with an electronic motorbrake.
The period from shutiing down the machine untill complete stop may not exceed 10 sec..
You must test the brakes monthly.

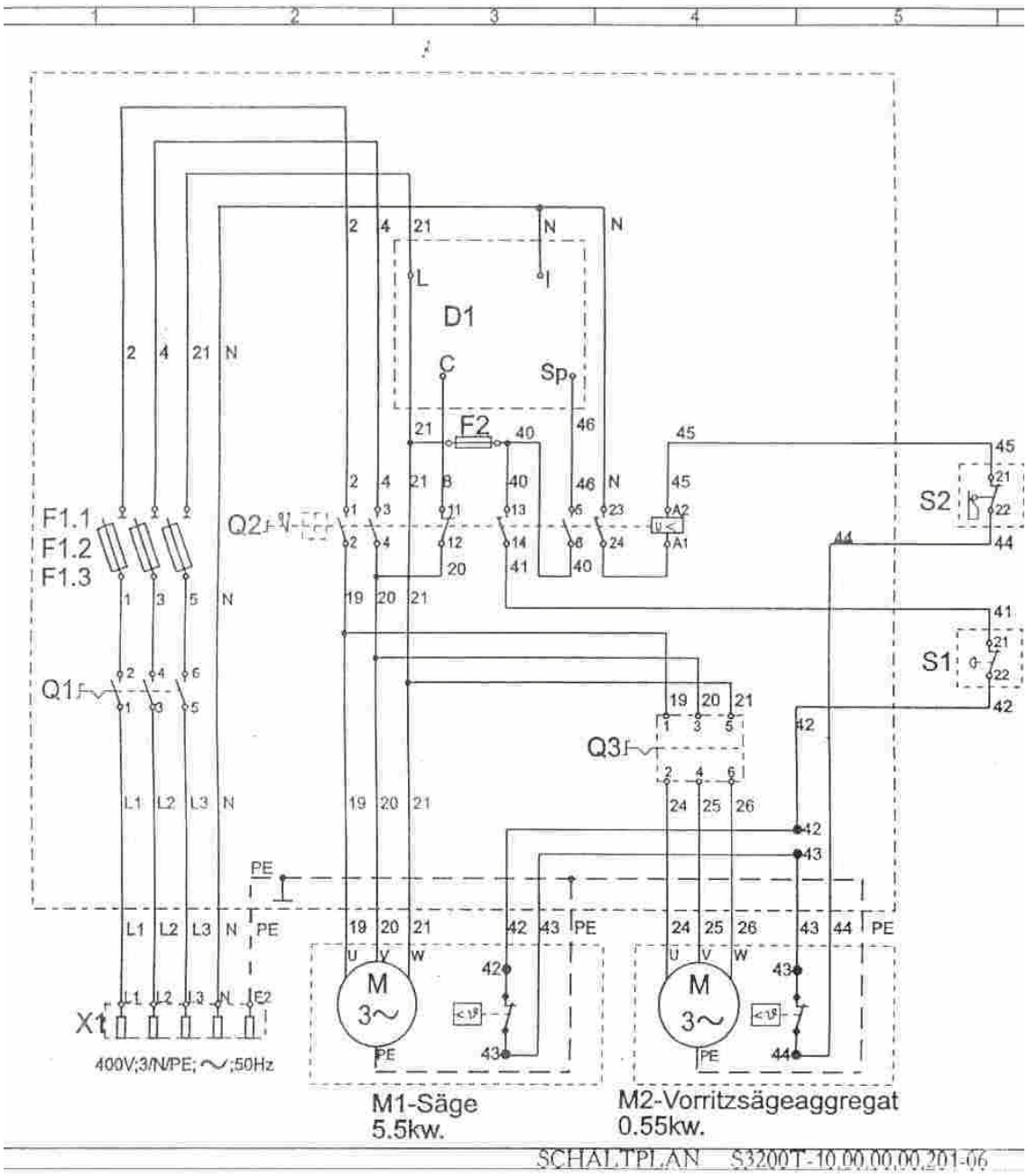
It the braking period is longuer than 10 sec., you must let test the motorbrake by a skilled technician and replace it if necessary.

ATTENTION: Switchfrequence max. 10 times/hour.

10. Electric drawing



Sign	Name	Art. Nr.
Q1	Switch	M220-61199-033M1
Q2	Switch	KB-S-30; Uc=220V; 50Hz
D1	Electro motorbrake	TES 71 10/230
S1	Emergency-stop button	XAL-J01 / ZA2-BT4
S2	Endswitch	FX-515
F1.1	Security	V/099-004116
F1.2	automat	
F1.3		
F2	Fuse	UK4-TG / ST-SI-UK4 / PP-20.250V.0.2A
X1	CEE-plug	515-6;3P+PE
M1	Motor	T90LB-2D;B3;3.0kW;400V;50Hz;11.1/6.4A;dY;2860/min.

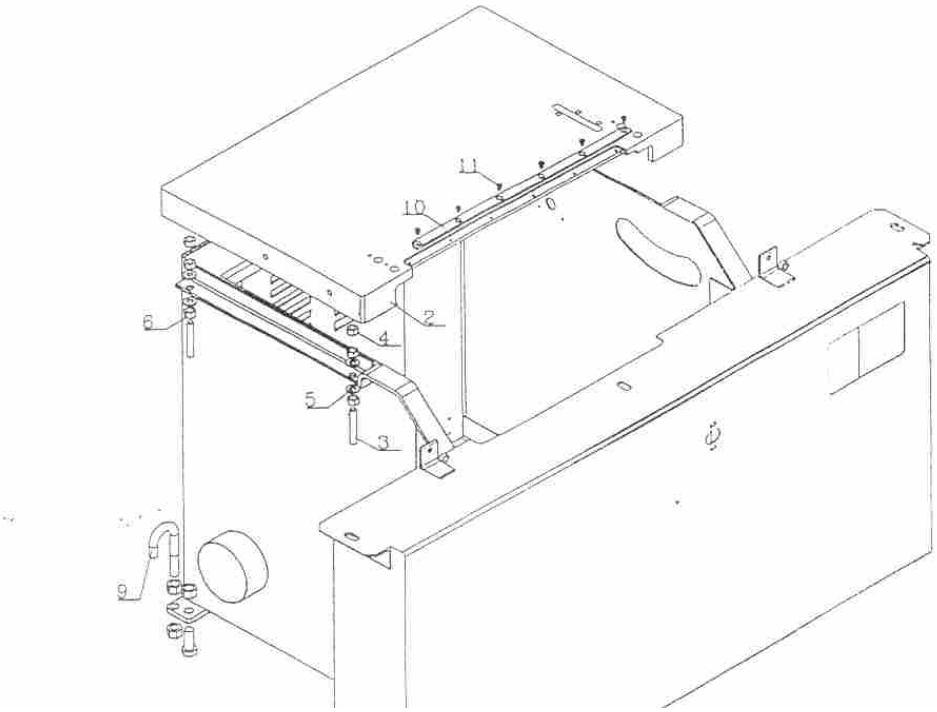


Sign	Name	Art.Nr.
Q1	Switch	M220-61199-033M1
Q2	Switch	KB-S-30. Uc=220V;50Hz
Q3	Switch	T212-61003-003M1
D1	Electro motor brake	No:4082.05;250V;16A
S1	Emergency-stop button	XAL-J01 / ZA2-BT4 / ZA2-BZ102
S2	Endswitch	FX-515
F1.1	Security	V/099-004125
F1.2	automat	
F1.3		
F2	Fuse	UK4-TG / ST-SI-UK4 PP-20;250V.0.2A
X1	CEE-plug	515-6;3P+N+PE
M1	Motor	T112MB-2;B3;5.5kW;230/400V;50Hz;11.6A;dY;2860/min.
M2	Motor	MO71B/2D;B14;F115;0.55kW;230/400V 50Hz;2.42/1.4A;dY;2760/min.

11. List of the spare parts

S2300.01.00.00.00 Machine main corps

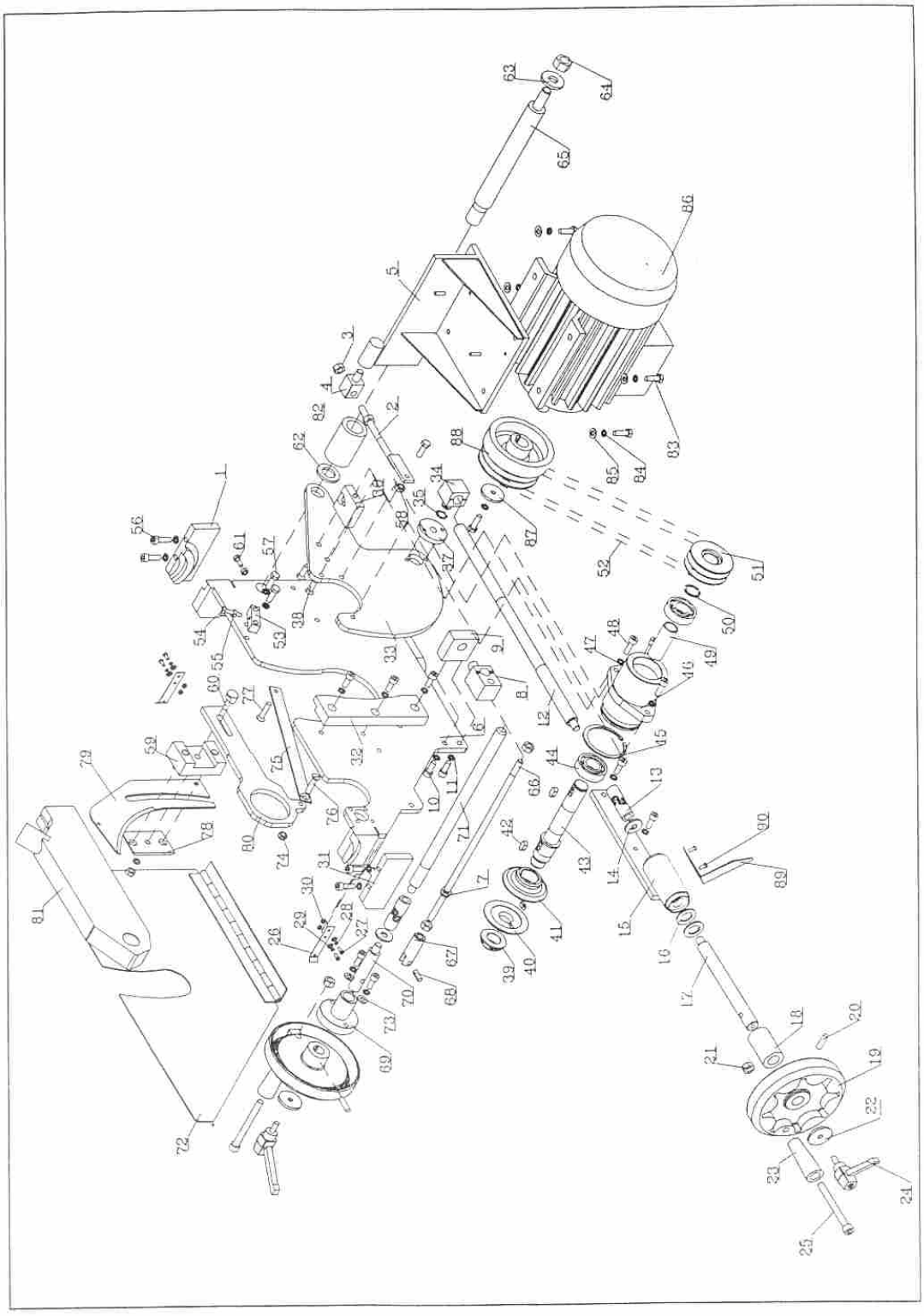
Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.01.01.00.00	Unterteil	1
2.	S2300.01.00.02.01	Arbeitsplatte	1
3.	S2300.01.00.10.03	Stiftschraube M12x78	4
4.	DIN 985-6	Sechskantmutter M12	4
5.	S2300.01.00.00.05	Beilage	8
6.	BDS 744-83	Sechskantmutter M12	8
7.	BDS 744-83	Sechskantmutter M16	14
8.	BDS 1232-86	Sechskantschraube M16x40	6
9.	S2300.01.00.00.09	Transporthaken	4
10.	S2300.01.00.02.02	Kunststoffleiste	1
11.	DIN 7991	Imbusschraube M5x10	6



S2300.02.00.00.00 Sawunit

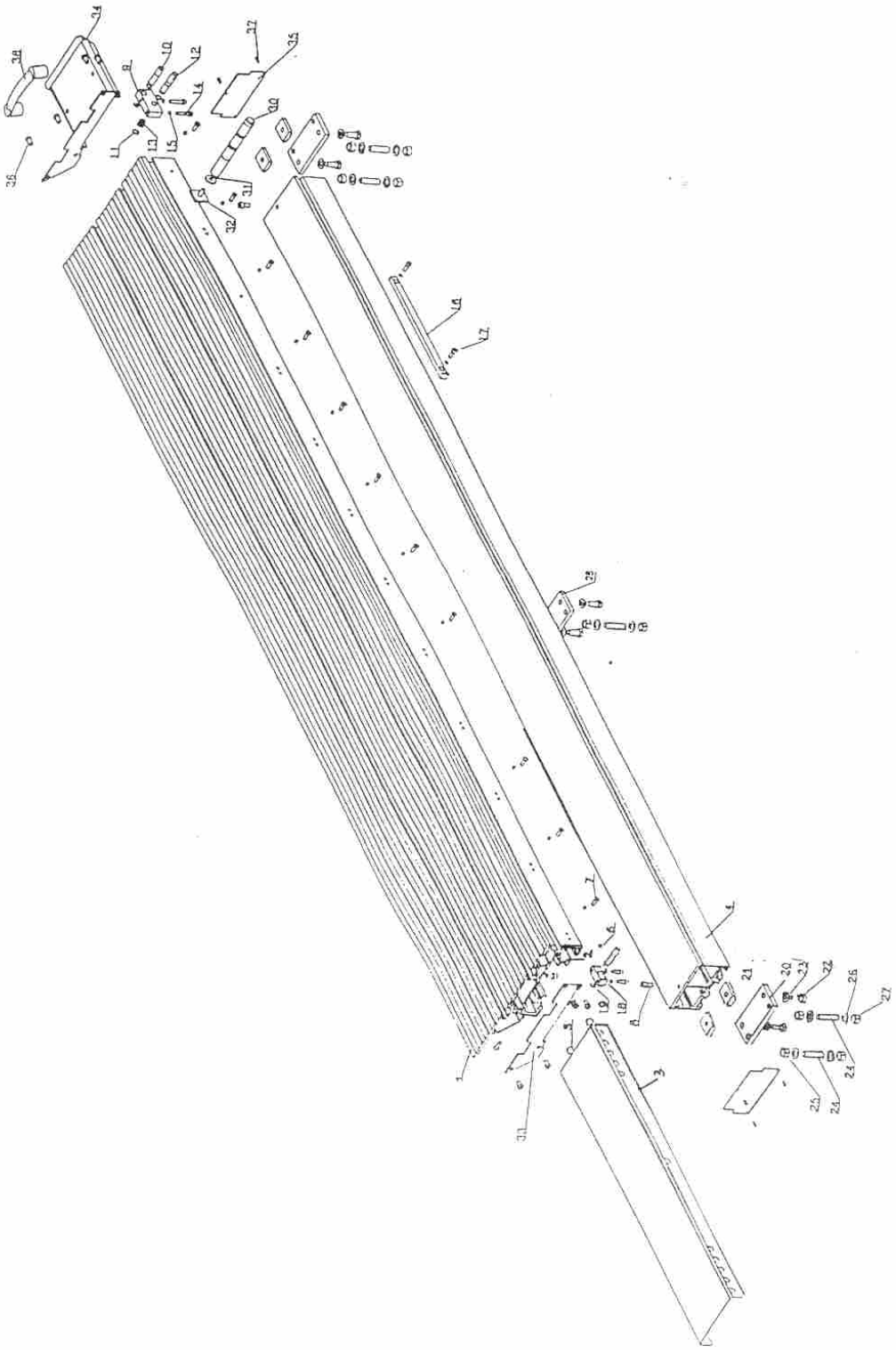
Pos.	Artikelnummer	Benennung	Stk.
1.	S2300.02.00.00.01	Führung	1
2.	S2300.02.00.20.00	Spannschraube	1
3.	BDS 744-83	Sechskantmutter M10	3
4.	S2300.02.00.00.04	Gegenlager	1
5.	S2300.02.10.10.00	Konsole	1
6.	S2300.02.00.10.00	Konsole (Seitenteil)	1
7.	DIN 985	Sechskantmutter M10	2
8.	S2300.02.00.00.10	Spindelmutter	1
9.	S2300.02.00.00.11	Gegenlager	1
10.	BDS 2171-83	Imbusschraube M8x20	9
11.	BDS 833-82	Federring Ø8,5	15
12.	S2300.02.00.00.14	Gewindespindel	1
13.	CKE	Gelenk	2
14.	KK-315.05.00.07	Scheibe	2
15.	S2300.02.20.00.00	Nabe	1
16.	S2300.02.00.00.19	Distanzscheibe 35x∅20x2.8	4
17.	S2300.02.00.00.20	Welle	1
18.	S2300.02.00.00.21	Hülse	1
19.	KPMAЩ .11.01	Handrad Ø160	2
20.	KPMAЩ .11.07	Stift	2
21.	BDS 744-83	Sechskantmutter M10	2
22.	KPMAЩ .11.02	Scheibe 40xØ8x4	2
23	400B/MP MP8/10	Kurbelgriff	2
24.	KP55 M8x20	Kurbelschraube	2
25.	BDS 2171-83	Imbusschraube M10X100	2
26.	S2300.02.00.00.23	Flachfeder	2
27.	BDS 832-83	Zylinderkopfschraube M4x10	8
28.	BDS 833-82	Federring Ø4	8
29.	BDS 206-83	Beilagscheibe Ø4	8
30.	BDS 744-83	Mutter M4	8
31.	S2300.02.00.00.28	Führung, links	1
32.	S2300.02.00.00.30	Leiste	1
33.	S2300.02.00.60.01	Wange	1
34.	S2300.02.00.60.02	Spindelmutter	1
35.	BDS 2170-77	Wellensicherung	1
36.	S2300.02.00.06.06	Distanzring	1
37.	S2300.02.00.06.07	Scheibe	1
38.	BDS 1359-83	Sechskantschraube M8x20	2
39	S2300.02.30.00.01	Mutter	1
40.	S2300.02.30.10.00	Scheibe mit Verdrehsicherung	1
41.	S2300.02.30.00.02	Scheibe	1
42.	BDS 3389-78	Einlagefeder 8x7x18	2

43.	S2300.02.30.00.07	Welle	1
44.	FAG	Rillenkugellager 6205-2Z.P53	2
45.	BDS 2170-77	Sicherungsring B70 DIN 471	1
46.	S2300.02.30.00.08	Lagerkörper	1
47.	BDS 833-82	Federring Ø8,5	3
48.	BDS 2171-83	Sechskantschraube M8x25	3
49.	S2300.02.30.00.10	Distanzhülse	1
50.	BDS 2170-77	Wellensicherung B25 DIN 471	1
51.	S2300.02.30.00.10	Keilriemenscheibe	1
52.	BDS 8717-79	Keilriemen 710x10	1
53.	S2300.02.00.00.34	Anschlag	1
54.	BDS 1230-85	Sechskantschraube M6x30	1
55.	BDS 744-83	Sechskantmutter M6	2
56.	BDS 2171-83	Imbusschraube M8x25	4
57.	BDS 1230-85	Sechskantschraube M8x25	3
58.	BDS 744-83	Sechskantmutter M8	1
59.	S2300.02.00.40.00	Führung	1
60.	S2300.02.00.00.40	Führungsbolzen	1
61.	BDS 1230-85	Sechskantschraube M6x16	1
62.	S2300.02.00.00.43	Distanzscheibe Ø40xØ24x4	1
63.	S2300.02.00.00.44	Distanzscheibe Ø40xØ16,5x5	1
64.	DIN 985	Sechskantmutter M16	1
65.	S2300.02.00.00.46	Achse	1
66.	S2300.02.00.00.47	Gewindestange M10x365	1
67.	S2300.02.00.00.49	Gabelkopf	1
68.	DIN 1481	Stift Ø8x20	1
69.	S2300.02.00.00.51	Nabe	1
70.	S2300.02.00.00.52	Wellenstück	1
71.	S2300.02.00.00.53	Gewindespindel	1
72.	S2300.02.00.30.00	Seitenblech	1
73.	BDS 206-83	Scheibe	2
74.	DIN 985	Sicherungsmutter M8	2
75.	S2300.02.00.00.57	Flachstahl	1
76.	BDS 1359-83	Sechskantschraube M8x30	1
77.	BDS 1359-83	Sechskantschraube M8x25	1
78.	S2300.02.00.00.61	Klemmblech	1
79.	S2300.02.00.00.62	Spaltkeil	1
80.	S2300.02.00.00.63	Führung	1
81.	S2300.02.00.65.00	Sägeblattabdeckung	1
82.	S2300.02.00.00.69	Distanzstück	1
83.	BDS 1230-85	Sechskantschraube M8x25	5
84.	BDS 833-82	Federring Ø8,5	5
85.	BDS 206-83	Beilage Ø8,5	4
86.	T90LB-2AL	Motor 380V; B3; 3kW; 2810 U/min-1	1
87.	S2300.02.10.00.06	Scheibe Ø40xØ8,5x4	1
88.	S2300.02.10.00.07	Keilriememscheibe	1
89.	S2300.02.02.00.04	Zeiger	1
90.	BDS 832-83	Zylinderschraube M5x10	2



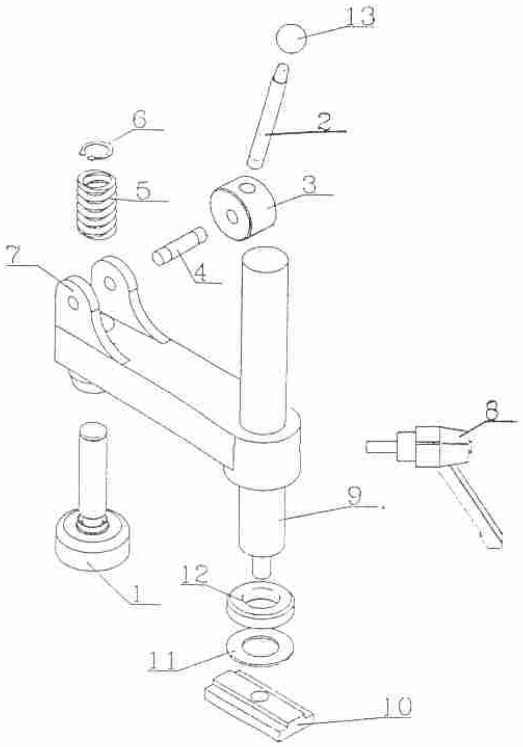
S2300.07.00.00.00 Roller table

Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.03.00.00.01	Oberteil	1
2.	S2300.03.00.00.02	Einstellleiste L=2300	2
3.	S2300.03.00.00.04	Kugelkäfig	1
4.	S2300.03.00.00.05	Unterteil	1
5.	BDS 4885-82	Kugel ∅15.081mm	18
6.	DIN 913	Gewindestift mit Innensechskant M6x8	24
7.	DIN 7380	Flachrundkopfschraube M6x16	24
8.	BDS 2171-83	Imbusschraube M8x12	4
9.	S2300.04.00.00.01	Führungsstück	1
10.	S2300.04.00.00.02	Bolzen	2
11.	BDS 2170-77	Sicherungsring	2
12.	S2300.04.00.00.04	Anschlagbolzen	1
13.	S2300.04.00.00.05	Spiralfeder	1
14.	BDS 2171-83	Imbusschraube M6x30	2
15.	BDS 833-82	Federring Ø 6,5	6
16.	S2300.04.00.00.08	Anschlagleiste	1
17.	BDS 2171-83	Imbusschraube M6x16	4
18.	S2300.04.00.00.10	Bolzenführung	1
19.	S2300.04.00.00.11	Sicherungsring	2
20.	S2300.05.00.00.01	Anschlagplatte	3
21.	S2300.05.00.00.02	Nutmutter M12	6
22.	BDS 1234-83	Sechskantschraube M10x25	6
23.	BDS 206-83	Beilagscheibe Ø 10,5	6
24.	S2300.05.00.00.03	Stiftschraube M12x50	3
25.	DIN 985	Sechskantmutter M12	3
26.	S2300.05.00.00.04	Unterlegscheibe	6
27.	BDS 744-83	Sechskantmutter M12	3
28.	BDS 1234-83	Auflageplatte	6
30.	S2300.07.00.00.01	Bolzen	1
31.	S2300.07.00.00.02	Scheibe ∅24x8.5x3	1
32.	S2300.07.00.00.03	Nutmutter	1
33.	S2300.09.00.00.01	Abdeckblech	1
34.	S2300.09.00.02.00	Abdeckung	1
35.	S2300.09.00.00.03	Abdeckblech	2
36.	BDS 832-83	Sechskantschrauben M8x12	8
37.	BDS 832-83	Senkschraube M4x10	6
38.	GN628-117-B-DGR	Griffstück	1



S2300.10.00.00.00 Excentric clamp

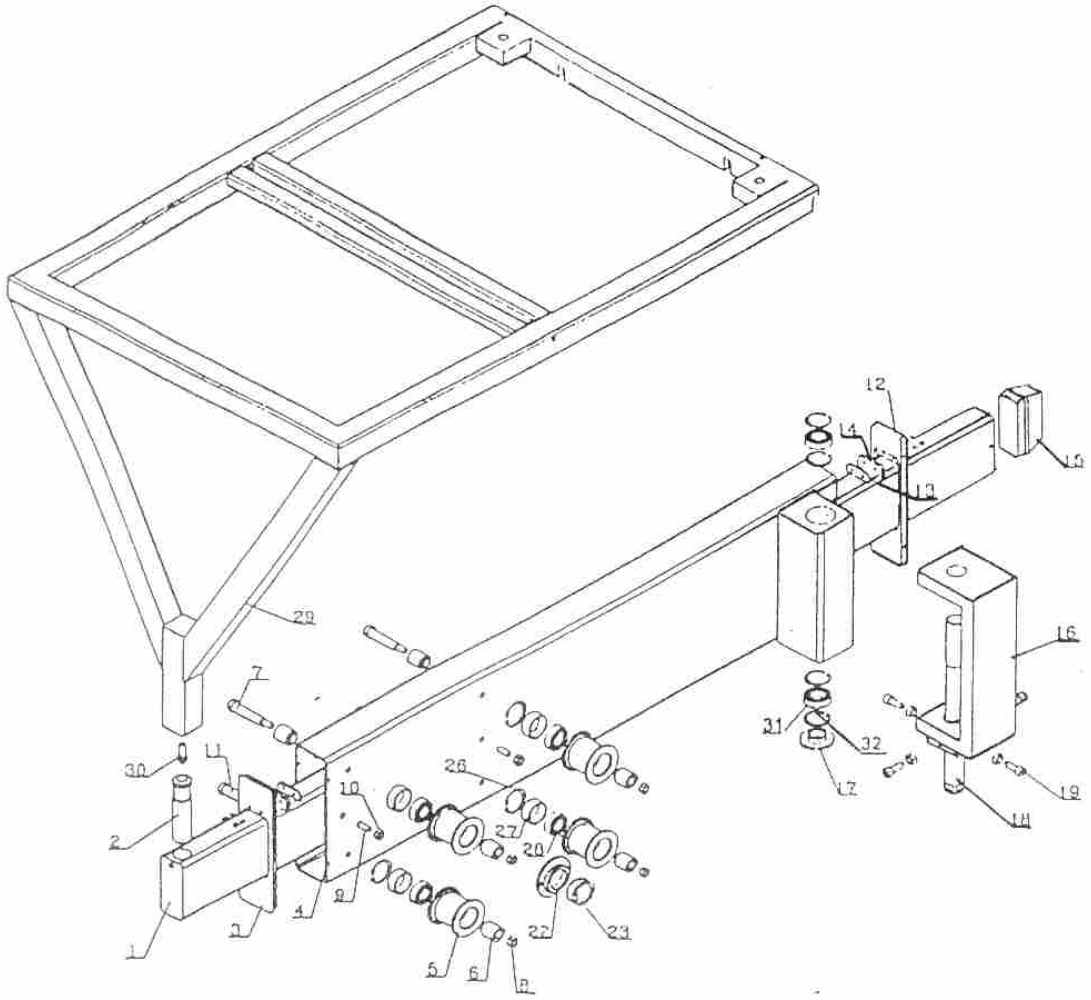
Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.10.01.00.00	Druckteller	1
2.	S2300.10.00.00.02	Hebel	1
3.	S2300.10.00.00.03	Nabe	1
4.	S2300.10.00.00.04	Bolzen	1
5.	DM5-321.40.30.14	Spiralfeder	1
6.	BDS 2170-77	Wellensicherungsring B18 DIN 471	1
7.	S2300.10.00.00.07	Ausleger	1
8.	S2300.10.08.00.00	Feststellschraube	1
9.	S2300.10.00.00.09	Säule	1
10.	S2300.10.00.00.10	Nutenstein	1
11.	S2300.10.00.00.11	Scheibe	1
12.	S2300.10.00.00.12	Ring	1
13.	BDS 3596-77	Kugel 25	1



S2300.11.00.00.00 Telescopic support

Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.11.01.00.00	Teleskoparm	1
2.	SF3000.06.00.00.02	Auflagebolzen	1
3.	SF3000.06.00.13.01	Vordere Abdeckung	1
4.	S2300.11.02.00.00	Träger	1
5.	SF3000.06.03.00.01	Laufrolle	4
6.	SF3000.06.00.00.06	Distanzhülse	8
7.	SF3000.06.00.00.07	Bolzen	2
8.	DIN 985	Sechskantmutter M8	4
9.	SF3000.06.00.00.09	Gewindestift M8x15	5
10.	BDS 744-83	Sechskantmutter M8	10
11.	SF3000.06.00.00.11	Achse	2
12.	SF3000.06.00.12.00	Hintere Abdeckung	1
13.	SF3000.06.00.03.02	Deckblech	2
14.	SF3000.06.00.03.03	Abstreifer	2
15.	SF3000.06.00.00.16	Abdeckung	1
16.	SF3000.06.04.00.00	Konsole	1
17.	SF3000.06.00.00.17	Mutter	2
18.	SF3000.06.00.00.18	Achse	1
19.	SF3000.06.00.00.19	Einstellschraube	4
22.	S2300.11.00.00.22	Distanzring	1
23.	S2300.11.00.00.23	Sicherungsring	1
26.	BDS 2170-77	Sicherungsring A35 DIN 471	4
27.	SF3000.06.03.00.03	Distanzhülse	4
28.	DIN	Rillenkugellager 6003-ZZ	4
29.	S2300.12.00.00.00	Zusatztisch	1
30.	S2300.12.00.00.12	Druckstift	1
31.		Rillenkugellager 6005-ZZ	2
32.	BDS 2170-77	Wellensicherung A47	4

H



S2300.13.00.00.00 Telescopic fence

Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.13.00.00.06	Anschlagverlängerung	1
2.	BDS 744-83	Sechskantmutter M8	2
3.	BDS 206-85	Unterlegscheibe Ø8,5	2
4.	BDS 1362-83	Gewindestift M8x40	2
5.	S2300.13.00.00.10	Platte	1
6.	S2300.13.00.00.11	Grundplatte	2
7.	S2300.13.00.00.12	Spiralfeder	2
8.	S2300.13.00.00.13	Anschlagklappe	2
9.	DIN 1481	Bolzen ∅4x40	2
10.	BDS 2171-83	Imbusschraube M6x16	4
11.	BDS 833-82	Federring 6H	4
12.	S2300.13.00.00.17	Platte	2
13.	S2300.13.00.00.18	Scheibe	2
14.	S2300.13.00.00.19	Bolzen	2
15.	GN636-56-M8-E-DSG	Feststellschraube-Griff	2
16.	S2300.13.00.00.21	Führungsplatte	2
17.	S2300.13.00.00.22	Endstück	1
18.	S2300.13.00.00.23	Anschlag	1
19.	BDS 1361-83	Gewindestift M6x10	1
20.	S2300.13.00.00.25	Druckplatte	1
21.	GN636.4-56-M8-30-DSG	Einstellschraube	2
22.	S2300.13.00.00.27	Anschlag	1
23.	GN603-63-M8-20-DOR	Knebelschraube M8x20	1
24.	S2300.13.00.00.29	Scheibe ∅40x9x4	2
25.	S2300.13.00.30.00	Nutmutter	1
26.	BDS 1362-83	Gewindestift M8x10 DIN 915	2
27.	BDS 1362-83	Scheibe	1
28.	S2300.13.00.00.35	Scheibe Ø30x9x8	2
29.	S2300.13.00.00.36-1	Linker Seintenteil	1
30.	S2300.13.00.00.37	Winkelstück	1
31.	DIN 7380	Senkschraube M6x10	4
32.	S2300.13.00.00.39	Einlagen	2
33.	S2300.13.00.00.36-2	Rechter Seitenteil	1
34.	S2300.13.00.40.00	Führungsstein	1
35.	S2300.13.00.00.41	Auflageplatte	1
36.	GN636.4-56-M8-30-DSG	Feststellschraube M8x30	1
37.	DIN 551	Gewindestift M4x10	1

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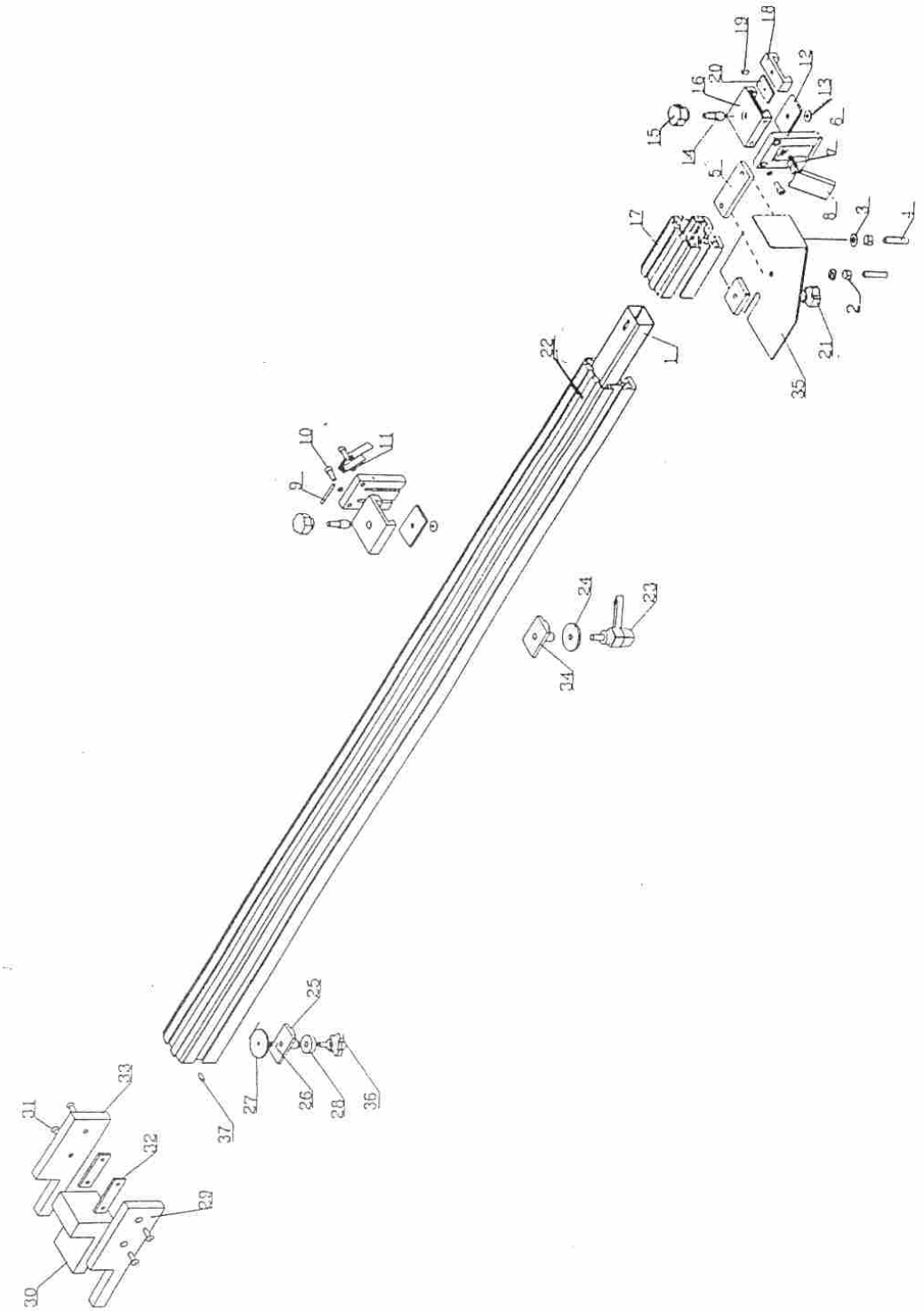
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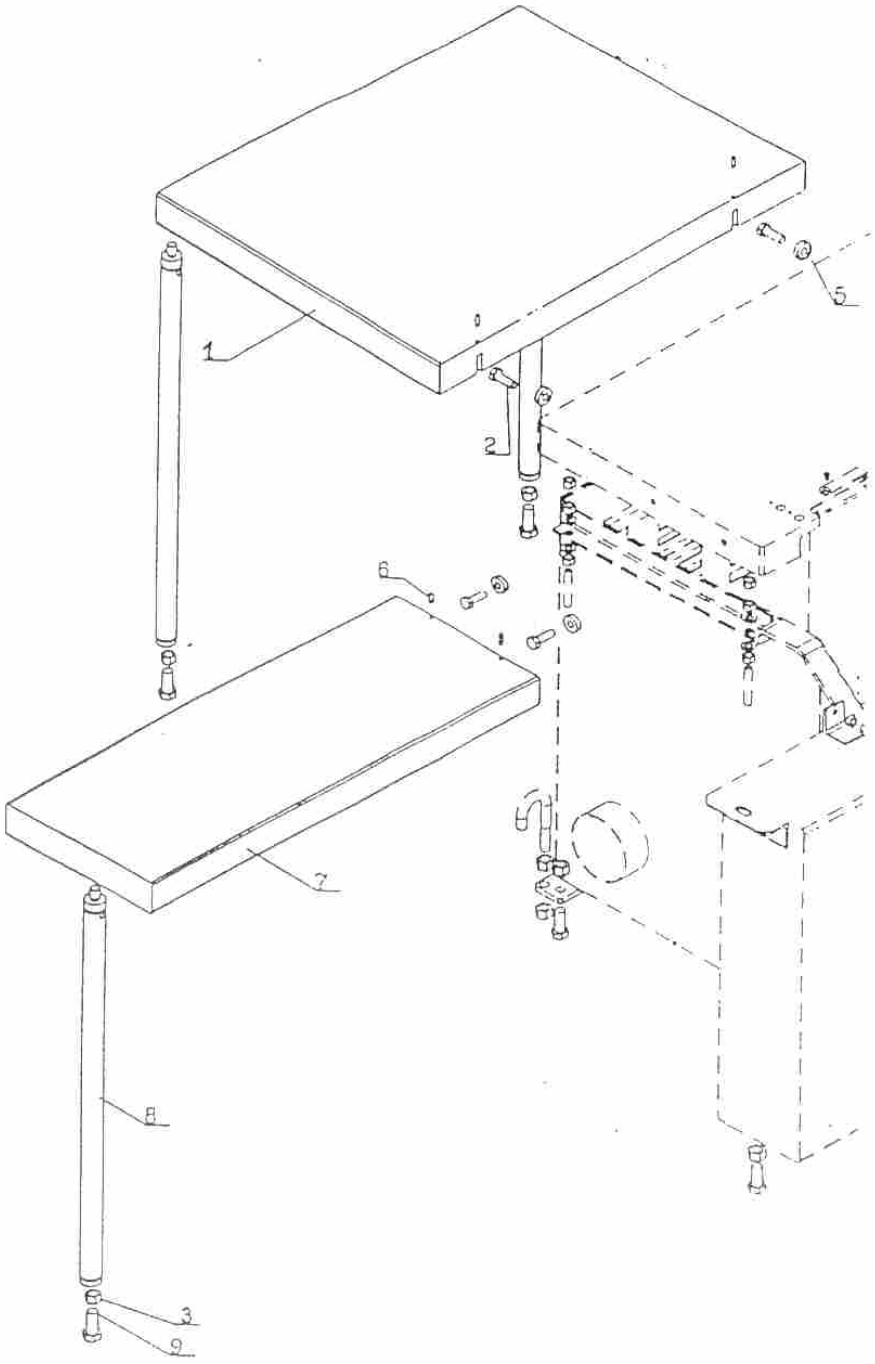
Working surface enlargment

Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.14.00.00.00	Arbeitsflächenvergrößerung hinten	1
2.	S2300.14.01.00.06	Sechskantschraube M10x30	4
3.	S2300.14.01.00.07	Sechskantmutter M16	4
5.		Scheibe ∅30x13x8	4
6.	BDS 1362-85	Gewindestift M6x20	4
7.	S2300.15.00.00.00	Arbeitsflächenvergrößerung seitlich	1
8.	S2300.17.00.00.00	Stützfuß	3
9.	GN342.2-60-M16-80-KR	Sechskantschraube M16x40	3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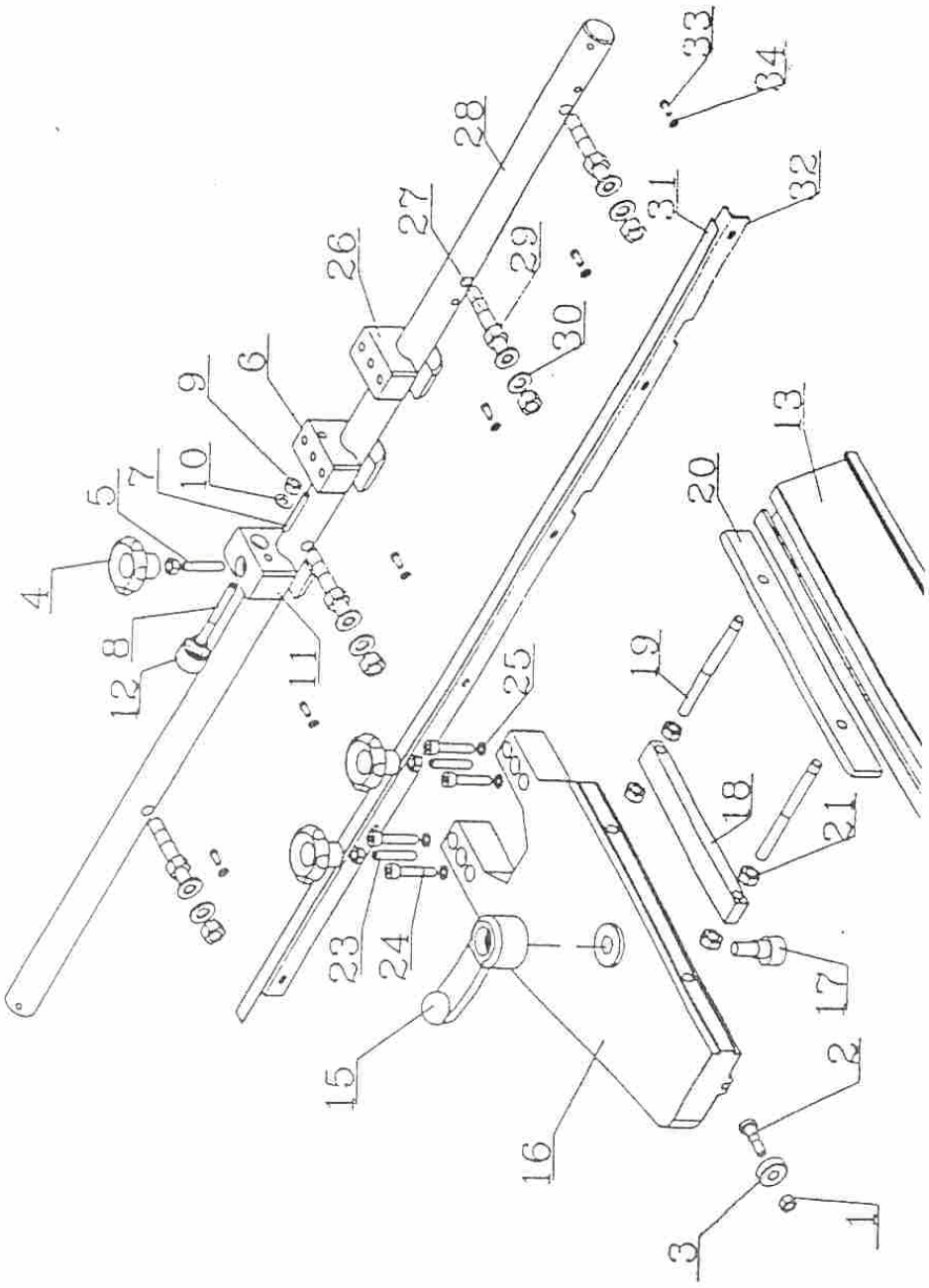
S2300.16.00.00.00 Parallel fence



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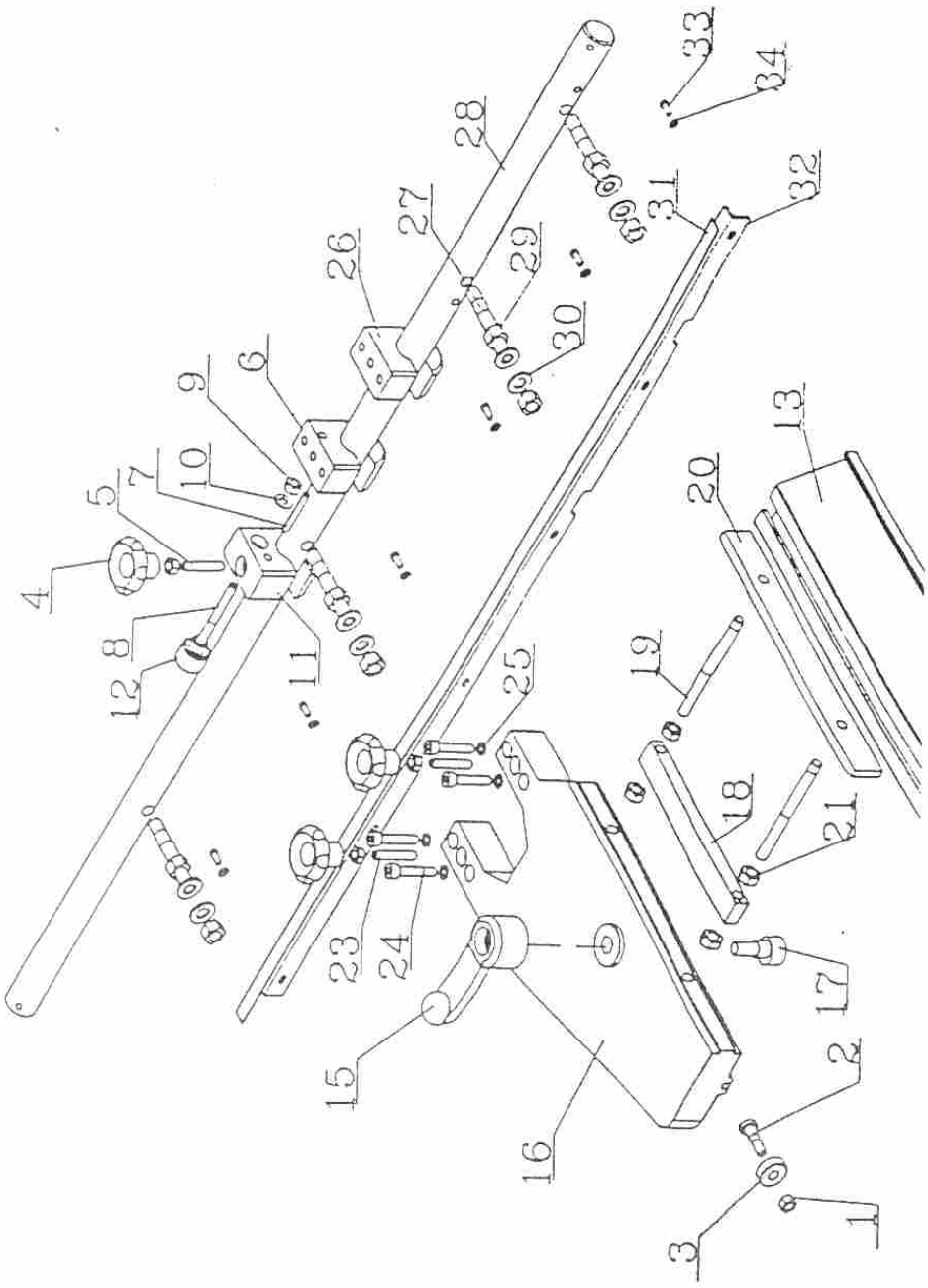
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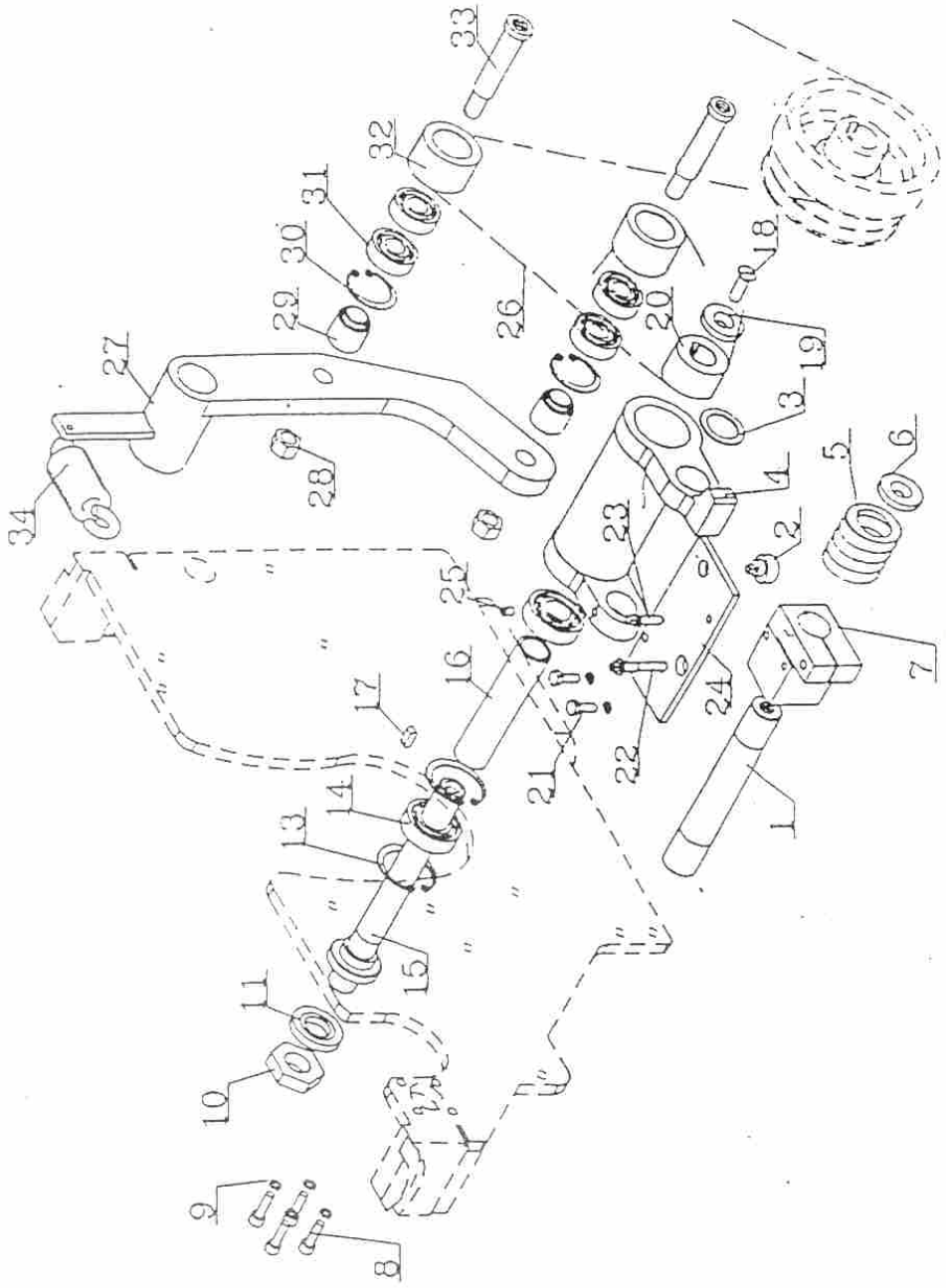
S2300.28.00.00.00 Scoring unit

Pos.	Artikelnummer	Bennenung	Stk.
1.	S2300.28.00.00.01	Achse	1
2.	S2300.28.00.00.02	Schneckenrad	1
3.	S2300.28.00.00.03	Distanzring	1
4.	S2300.28.00.00.04	Lagergehäuse	1
5.	S2300.28.00.00.05	Schnecke	1
6.	S2300.28.00.00.06	Scheibe	1
7.	S2300.28.00.00.07	Lagerbock	1
8.	BDS 2171-83	Imbusschraube M6x20	4
9.	BDS 833-82	Federring Ø6,5	6
10.	KK-315.03.02.20-E	Sechskantmutter	1
11.	S2300.28.00.00.12	Scheibe	1
13.	BDS 2170-77	Sicherungsring A42 DIN 471	2
14.	FAG	Rillenkugellager 6004-2Z	2
15.	S2300.28.00.00.15	Welle	1
16.	S2300.28.00.00.16	Distanzhülse	1
17.	BDS 3389-75	Einlegekeil 6x6x16	1
18.	BDS 1359-83	Senkkopfschraube M8x20	1
19.	S2300.28.00.00.19	Scheibe	1
20.	S2300.28.00.00.20	Riemenscheibe	1
21.	BDS 1230-85	Sechskantschraube M6x16	2
22.	S2300.28.00.00.22	Einstellschraube	1
23.	S2300.28.00.00.23	Einstellschraube	1
24.	S2300.28.00.00.24	Aufnahmeplatte	1
25.	DIN 914	Gewindestift M6x10	1
26.		Flachriemen 25x20x1580	1
27.	S2300.28.01.01.00	Spannhebel	1
28.	DIN 985	Sechskantmutter M12	2
29.	S2300.28.01.00.04	Distanzhülse	2
30.	BDS 2170-77	Sicherungsring A35 DIN 471	2
31.	BDS 4843-84	Rillenkugellager 6202-2Z	4
32.	S2300.28.01.00.06	Umlenkrolle	2
33.	S2300.28.01.00.02	Achse	2
34.	S2300.01.00.08	Zugfeder	1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