

# 260MM [10-1/4"] TABLE SAW 2704N

## REPAIR MANUAL



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## 2 CAUTION

Repair the machine in accordance with “Instruction manual” or “Safety instructions”.

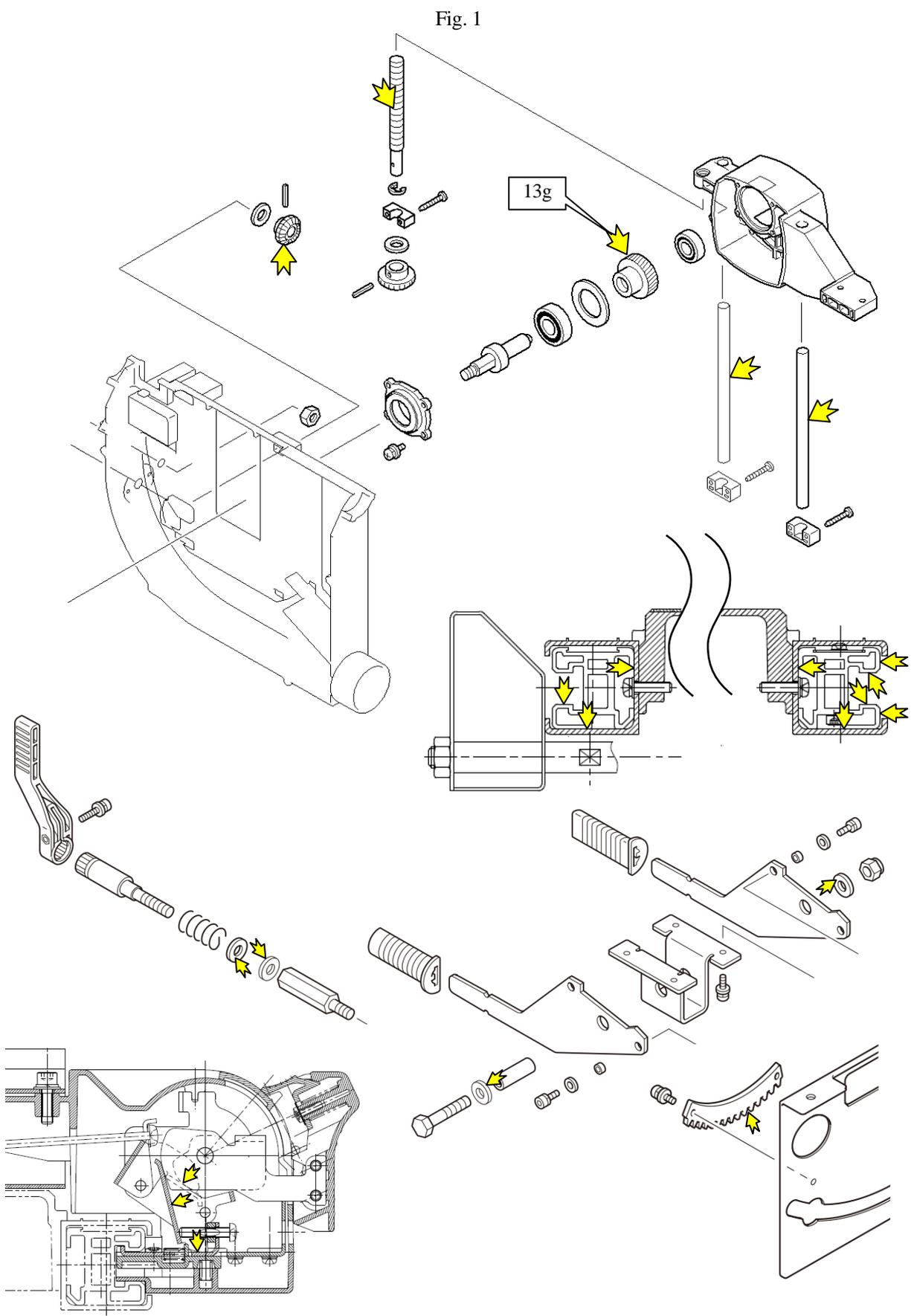
Follow the instructions described below in advance before repairing:

- Wear gloves.
- In order to avoid wrong reassembly, draw or write down where and how the parts are assembled, and what the parts are. It is also recommended to have boxes ready to keep disassembled parts by group.
- Handle the disassembled parts carefully. Clean and wash them properly.

## 3 NECESSARY REPAIRING TOOLS

Code No.	Description	Use for
1R033	Bearing setting plate 10.2	press-fitting Armature ass'y and Ball bearing 609LLB
1R035	Bearing setting plate 15.2	press-fitting Armature ass'y and Helical gear 42
1R036	Bearing setting plate 17.2	holding Spindle
1R207	45-degree Set square	<ul style="list-style-type: none"> <li>• adjusting Center cover</li> <li>• adjusting the bevel angle of Saw blade to 45 degrees</li> </ul>
1R208	90-degree Set square	adjusting the bevel angle of Saw blade to 90 degrees
1R208-A	90-degree long set square	adjusting the angle of Gear housing complete to Table complete to 90 degrees
1R269	Bearing extractor (small)	removing Ball bearing 6000DDW
1R283	Round bar for arbor 9-50	removing Spindle
1R308	Spring pin extractor 4.0	assemble Spring pin 4-20
1R341	Spanner head 41	locking Cover
1R356	Bearing plate 10mm (for arbor press)	supporting Helical gear 42
1R370	Ring terminal setting jig	fitting Ring terminal
1R401	Bearing extractor	removing Ball bearing 6202DDW and Ball bearing 6203DDW
1R456	Hexalobular screwdriver T30x120	removing/ installing M6x50 Torx-plus bolt
1R457	Security torx driver T30Hx75	

#### 4 LUBRICANT AND ADHESIVE APPLICATION

	Description	Amount
	Makita Grease FA No.2	a little unless specified in the figure
<p style="text-align: center;">Fig. 1</p>  <p>The diagram shows an exploded view of a mechanical assembly. Yellow arrows indicate the application points for Makita Grease FA No.2. A callout box labeled '13g' points to a specific bearing assembly. The diagram includes various components such as bearings, shafts, gears, and housing parts, with arrows indicating where to apply the grease.</p>		

## 5 TIGHTENING TORQUE SPECIFICATIONS

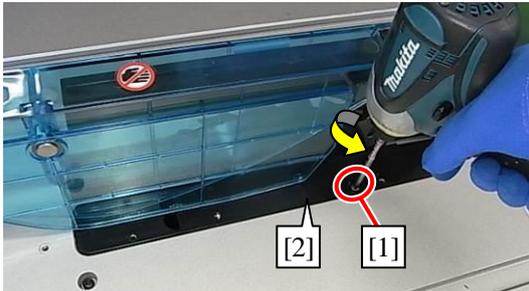
No.	Parts to fasten		Fastener	Tightening torque (N·m)	
1	Center cover assembly	⇔	Table complete	M5x20 Pan head screw	0.88 – 1.8
2	Dust joint	⇔	Frame	Bind CT 4x8 Tapping screw	0.7 – 1.0
3	Knob 37 (for storing a cord)	⇔	Base complete	M6x25 Hex bolt	1.8 – 3.5
4	Knob 37 (for storing Saw blade)	⇔	Base complete	M14x65 Hex bolt	1.8 – 3.5
5	M8 Hex nut (for storing a wrench)	⇔	Base complete	M8x40 Hex bolt	1.8 – 3.5

## 6 REPAIR

### 6-1 Center cover assembly

#### 6-1-1 Disassembling

Fig. 2

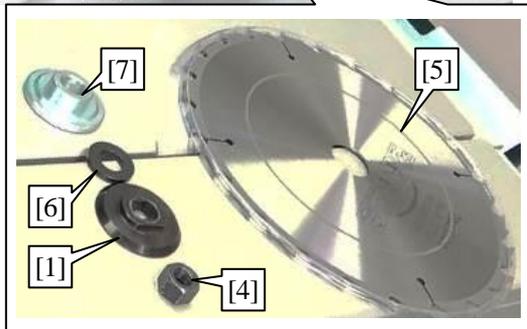


- 1 Unplug the machine.
- 2 Remove M5x20 Pan head screw [1], then remove Center cover assembly [2].

### 6-2 Saw blade

#### 6-2-1 Disassembling

Fig. 3



- 1 Lock Outer flange 53 [1] with Wrench 13-22 [2], then remove M12-19 Hex nut [4] with Wrench 19 [3].

#### Tips

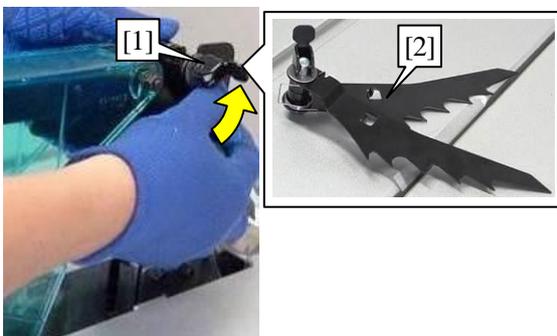
Adjust the cutting depth to the maximum.

#### Note

Be careful not to lose M12-19 Hex nut [4].

- 2 Remove the following parts in order from the top:
  - Outer flange 53 [1]
  - Saw blade [5]
  - Ring 15.8 or Ring 16 [6]
  - Inner flange 53 [7]

Fig. 4

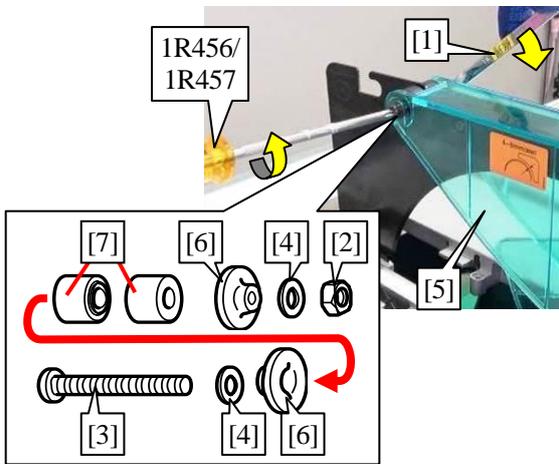


- 3 Remove Finger part [2] by raising Lock lever [1].

**6-3 Safety cover**  
**6-3-1 Disassembling**

**1** Remove Saw blade. (6-2-1)

Fig. 5

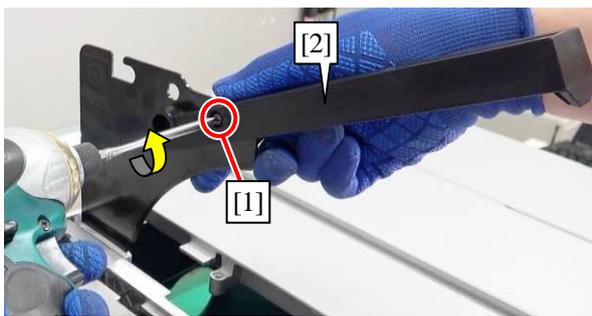


**2** Remove M6x50 Torx-plus bolt [3] with 1R456 and 1R457 while holding M6-10 Hex lock nut [2] with Offset wrench [1].

**3** Remove the following parts:

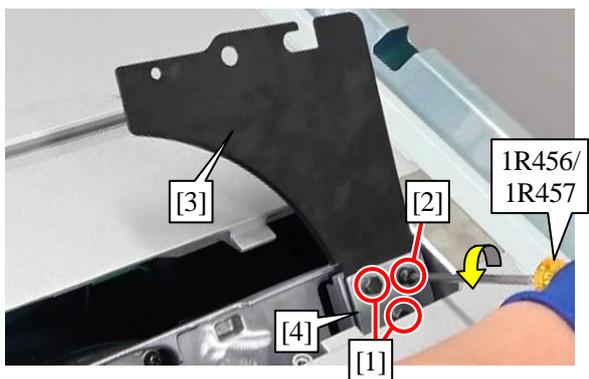
- M6-10 Hex lock nut [2]
- Flat washer 6 [4] (2 pcs)
- Cover part [5]
- Collar [6] (2 pcs)
- Sleeve 6 [7] (2 pcs)

Fig. 6



**4** Remove M4x20 Pan head screw [1] and M4 Hex nut, then remove Top guard [2].

Fig. 7



**5** Remove M6x20 Torx-plus bolt [2] with 1R456 and 1R457.

**6** Remove M6x20 Hex bolts [1] (2 pcs).

**7** Remove Riving knife [3] and Pressure plate [4].

**Tips**

- Adjust the cutting depth to the maximum.
- Adjust the blade bevel angle to 45 degrees.

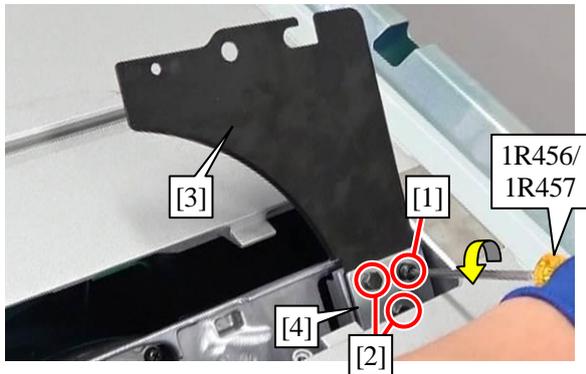
**Note**

After the adjustment of the bevel angle, be sure to lock Handle 100 [6] by raising Lever 120 [5].

## 6-3-2 Assembling

### 1 Assemble Rear table. (6-4-2)

Fig. 8

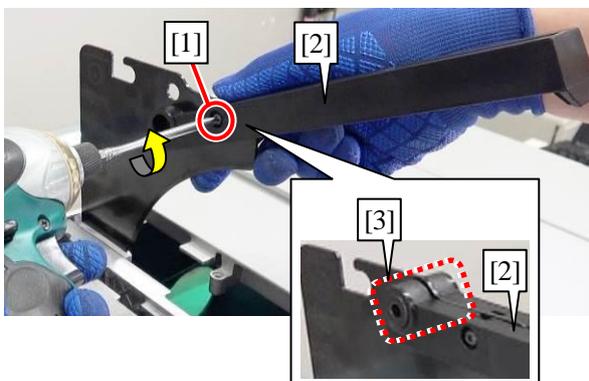


- 2 Assemble Riving knife [3] and Pressure plate [4] to Knife holder with M6x20 Torx-plus bolt [1] and M6x20 Hex bolts [2] (2 pcs).

#### Tips

- Adjust the cutting depth to the maximum.
- Adjust the blade bevel angle to 45 degrees.

Fig. 9



- 3 Assemble Top guard [2] to Riving knife with M4x20 Pan head screw [1].

#### Tips

- Adjust the blade bevel angle to 0 degrees.

#### Note

- The hinge protrusion [3] of Top guard [2] should be facing upward.

Fig. 10

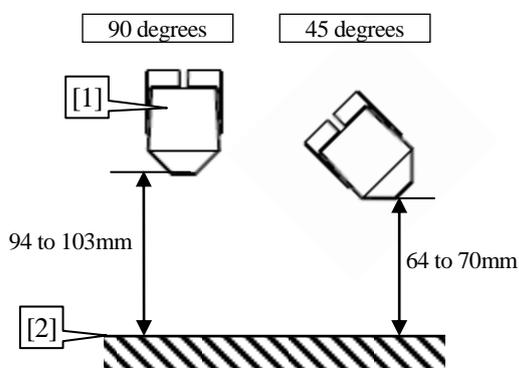


- 4 Insert Sleeves 6 [1] (2 pcs) into Top guard.

#### Note

- The stepped side of each Sleeve 6 [1] should be facing inside the hinge hole.

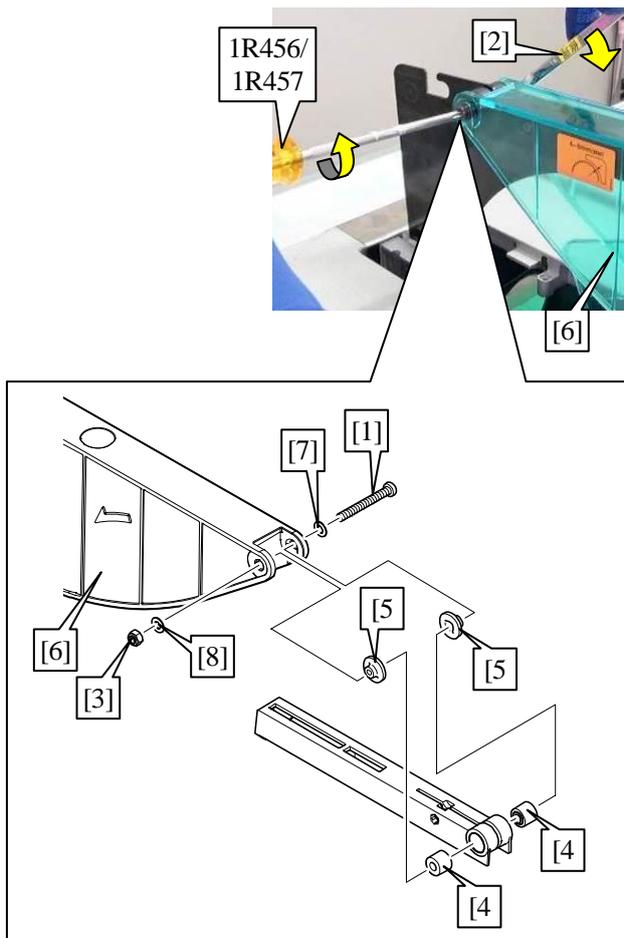
Fig. 11



- 5 The height of Top guard [1] from Table complete [2] should be adjusted to the listed value by adjusting M4x20 Pan head screw.

Bevel angle	Height
90 degrees	94 to 103mm
45 degrees	64 to 70mm

Fig. 12

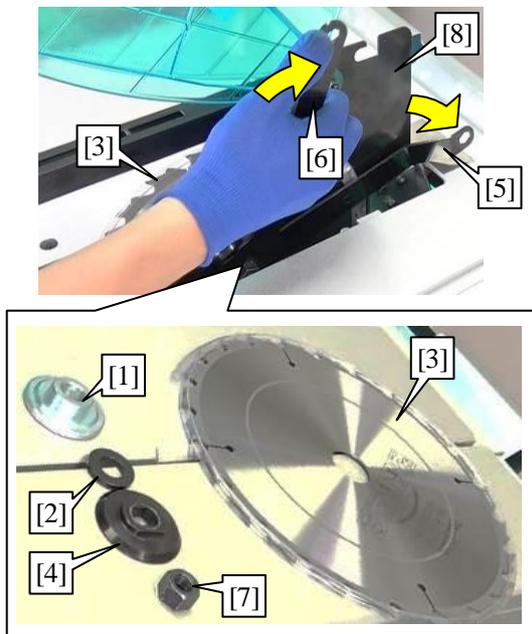


- 6** Assemble Collars [5] (2 pcs) to Cover part [6].
- 7** Insert M6x50 Torx-plus bolt [1] through the following parts:
- Flat washer 6 [7]
  - Cover part [6] with Collars [5] (2 pcs)
  - Sleeves 6 [4] (2 pcs) on Riving knife
- 8** Slide Flat washer 6 [8] and M6-10 Hex lock nut [3] onto M6x50 Torx-plus bolt [1], then tighten the nut using 1R456, 1R457 and Offset wrench [2].

**Note**

Do not tighten M6-10 Hex lock nut [3] too much to open/close Cover part [6] smoothly.

Fig. 13



- 9** Install the following parts, in order from the top.
- Inner flange 53 [1]
  - Ring 15.8 or Ring 16 [2]
  - Saw blade [3]
  - Outer flange 53 [4]
- 10** Lock Outer flange 53 [4] with Wrench 13-22 [5], and then tighten M12-19 Hex nut [7] with Wrench 19 [6].

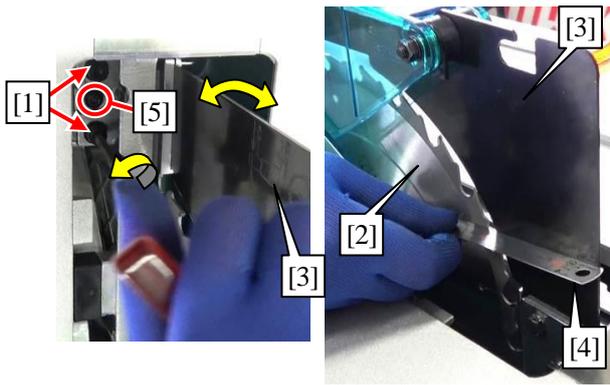
**Tips**

- The printed side of Saw blade [3] should be facing to the right (as viewed from the front).
- The gap between the edge of Saw blade [3] and Riving knife [8] should be 4 to 5mm.

**Note**

Do not remove a protecting tube of Saw blade [3] (if attached) until Saw blade [3] is completely installed.

Fig. 14



- 11 Adjust M6x20 Hex socket head bolts [1] (2 pcs) until Saw blade [2] is flush with Riving knife [3] (as viewed from the front).

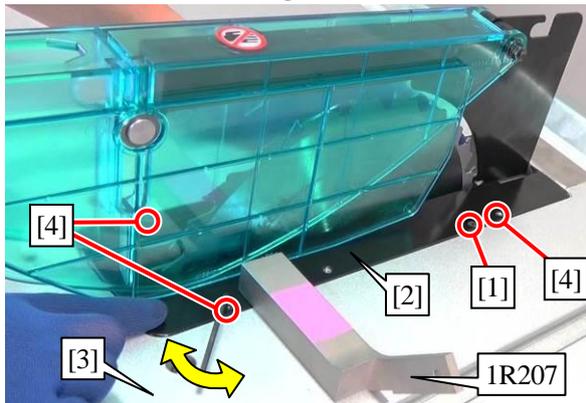
**Tips**

Set a ruler [4] against both sides of Riving knife [3] to make sure that Saw blade [2] is flush with Riving knife [3].

**Note**

Do not loosen M6x20 Torx-plus bolt [5].

Fig. 15



- 12 Temporarily fix Center cover assembly [2] by temporarily tightening M5x20 Pan head screw [1].

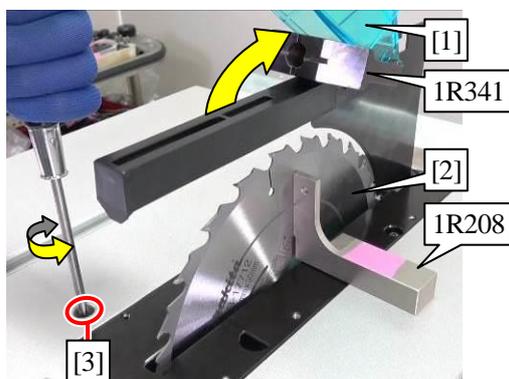
- 13 Adjust M5x6 Hex socket set screws (flat point) [4] (4 pcs) until Center cover [2] is flush with Table complete [3] using 1R207.

- 14 Fix Center cover assembly [2] securely with M5x20 Pan head screw [1].

**Note**

Make sure that O ring 4 is installed on M5x20 Pan head screw [1].

Fig. 16

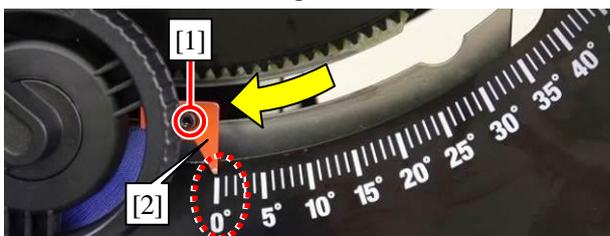


- 15 Lock Cover [1] with 1R341.

- 16 Tighten Lever 120 slightly, then turn Handle 100 until Pointer is positioned at 0 degrees.

- 17 Set 1R208 against Saw blade [2], and then adjust the saw blade [2] by turning M5x18 (+) Pan head screw [3] until the saw blade [2] is 90 degrees to 1R208.

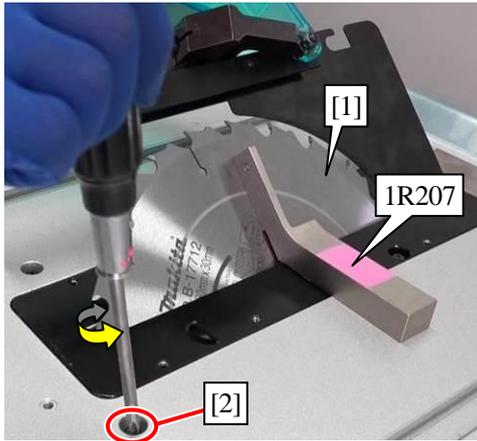
Fig. 17



- 18 Adjust the blade bevel angle to 0 degrees.

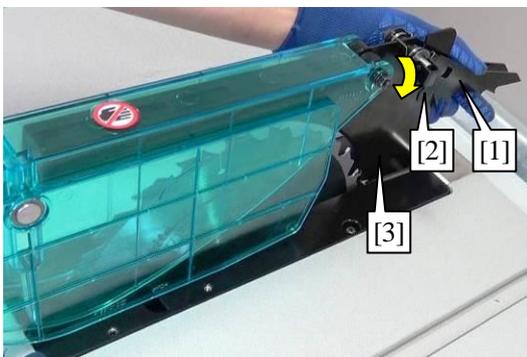
- 19 Loosen M4x6 Hex socket head bolt [1], and then adjust Pointer [2] so that it indicates 0 degrees.

Fig. 18



- 20 Adjust the blade bevel angle to 45 degrees.
- 21 Set 1R207 against the saw blade [1].
- 22 Adjust the saw blade [1] by turning M5x18 (+) Pan head screw [2] until it is at 45 degrees to 1R207.

Fig. 19



- 23 Adjust the blade bevel angle to 0 degrees.
- 24 Install Finger part [1] on Riving knife [3].
- 25 Make sure the followings while raising and lowering Riving knife [3].
  - Fingers L and R do not touch any parts.
  - Fingers L and R operate smoothly.

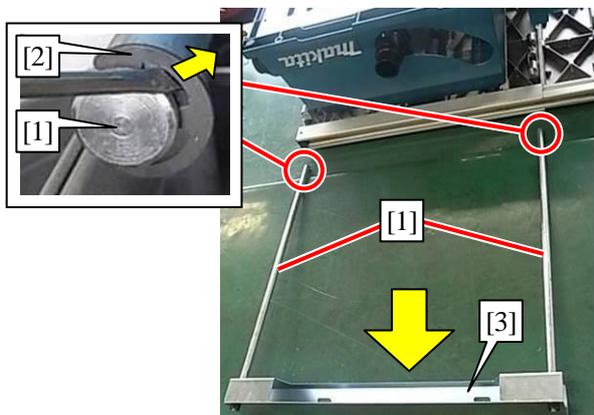
**Tips**

- The connecting bar of Torsion spring 17 should be placed on the top part of Riving knife [3].
- Finger part [1] should be fixed at the farthest back of the notch in Riving knife [3].
- Make sure that Finger part [1] returns to its original position by spring force.

**6-4 Rear table**  
**6-4-1 Disassembling**

- 1 Remove Safety cover. (6-3-1)

Fig. 20

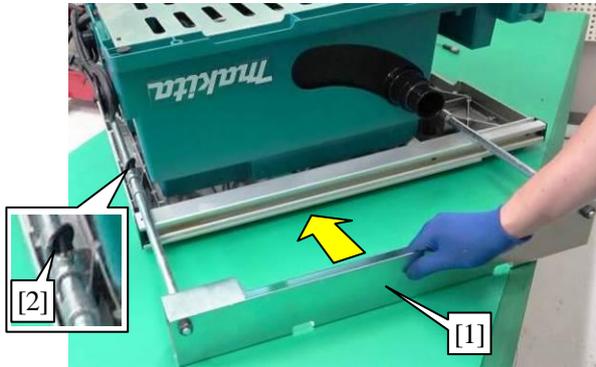


- 2 Turn the machine upside down, then remove Stop rings E-10 [2] (2 pcs) from Rear rods [1] (2 pcs).
- 3 Loosen M5x15 Screws (2 pcs), then pull out Rear table [3].

## 6-4-2 Assembling

- 1 Assemble Base under cover. (6-5-2)

Fig. 21



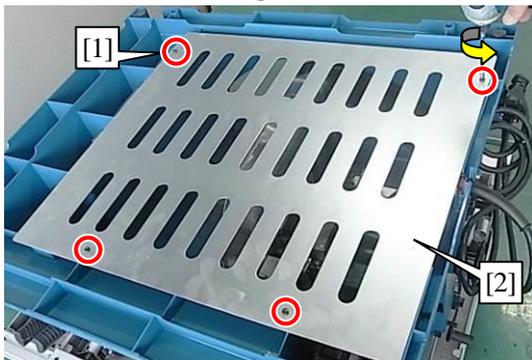
- 2 Turn the machine upside down, then insert Rear table [1] into Slide rod holders (2 pcs).
- 3 Assemble Stop rings E-10 (2 pcs).
- 4 Tighten M5x15 Screws [2] (2 pcs).

## 6-5 Base under cover

### 6-5-1 Disassembling

- 1 Remove Saw blade. (6-2-1)

Fig. 22



- 2 Remove 4x14 Tapping screws [1] (4 pcs), then remove Base under cover [2].

## 6-5-2 Assembling

1 Assemble Motor. (6-6-2)

2 Assemble Base under cover by reversing the disassembly procedure.

### Tips

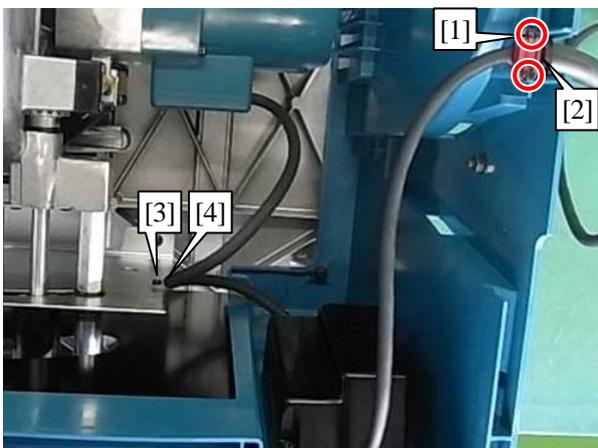
The burr side of Base under cover should be facing inward.

## 6-6 Motor

### 6-6-1 Disassembling

1 Remove Base under cover. (6-5-1)

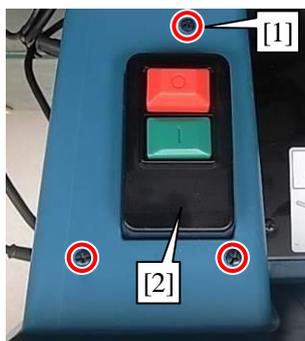
Fig. 23



2 Remove 4x18 Tapping screws [1] (2 pcs), then remove Strain relief [2].

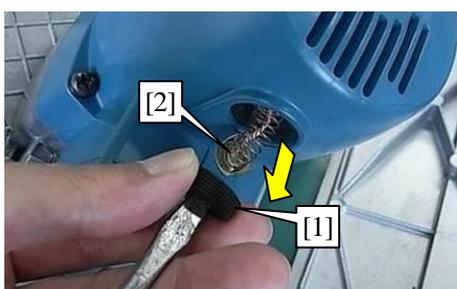
3 Remove M4x10 (+) Pan head screw [3], then remove Strain relief [4].

Fig. 24



4 Remove 4x14 Tapping screws [1] (3 pcs), then remove Switch base section [2].

Fig. 25

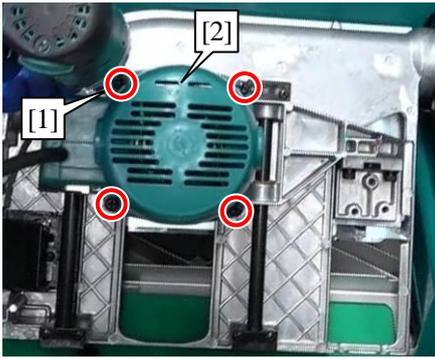


5 Remove Brush holder caps 6.5 [1] (2 pcs), then remove Carbon brushes [2] (2 pcs).

### Tips

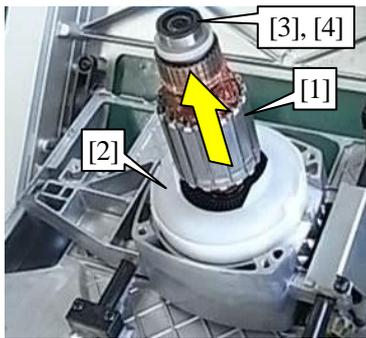
- Adjust the cutting depth to the maximum.
- Adjust the blade bevel angle to 45 degrees.
- Use a short screwdriver in tight spaces.

Fig. 26



- 6 Remove M6x60 Pan head screws [1] (4 pcs) with a No.3 Phillips screwdriver, then remove Motor section [2].

Fig. 27

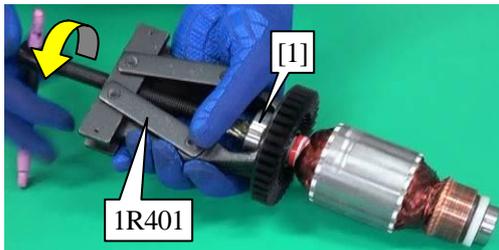


- 7 Pull out Armature ass'y [1] and Baffle plate [2].

Note

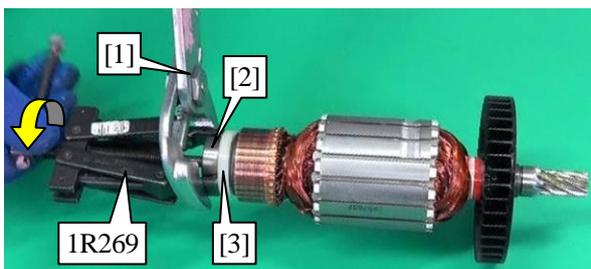
Be careful not to lose Flat washer 18 [3] and Urethane washer 18 [4] on the rear of Armature ass'y [1].

Fig. 28



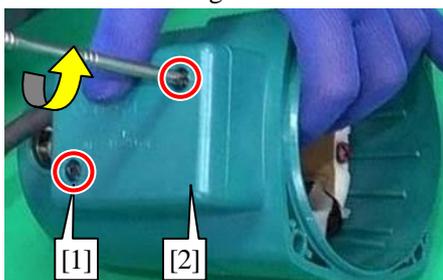
- 8 Remove Ball bearing 6202DDW [1] with 1R401, then remove Flat washer 15.

Fig. 29



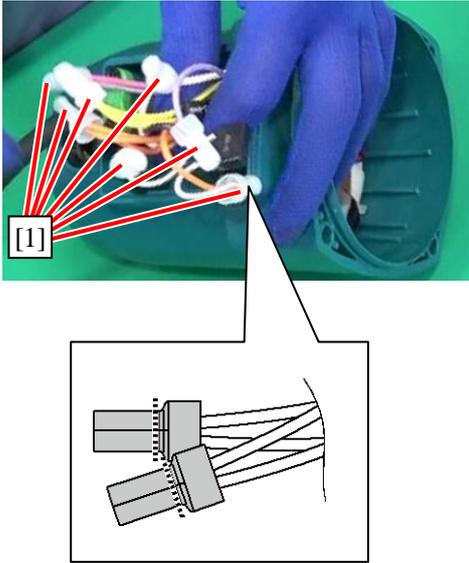
- 9 Remove Ball bearing 6000DDW [2] with 1R269 and water pump pliers [1], then remove Insulation washer [3].

Fig. 30



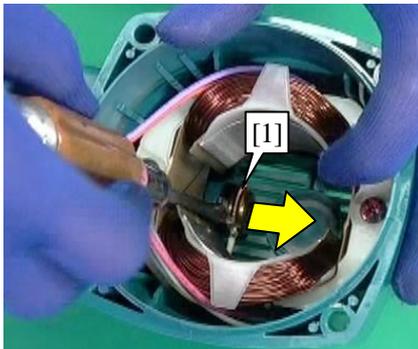
- 10 Remove 4x18 Tapping screws [1] (2 pcs), then remove Cover [2].

Fig. 31



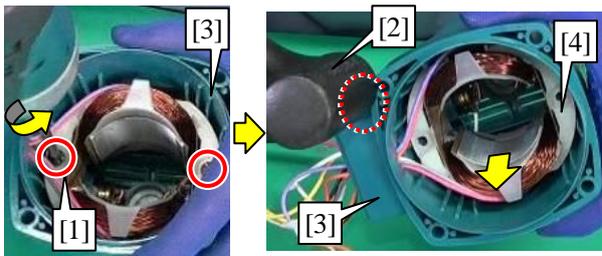
11 Cut Closed end splices [1] along the dotted lines.

Fig. 32



12 Remove Ring terminals [1] (2 pcs).

Fig. 33



13 Remove 5x65 Tapping screws [1] (2 pcs), then remove Field ass'y [4] by tapping Motor housing complete [3] with a plastic hammer.

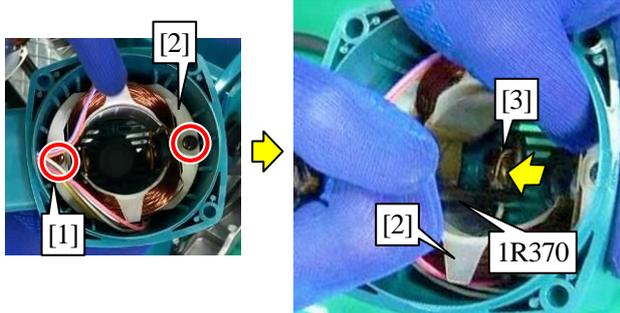
Note

Do not tap the thin portion of Motor housing complete [3].

## 6-6-2 Assembling

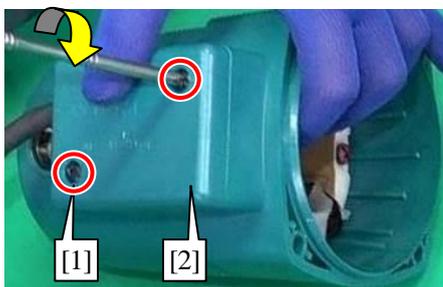
### 1 Assemble Base complete and Switch. (6-7-2, 6-8-2)

Fig. 34



- 2 Fix Field ass'y to Motor housing complete with 5x65 Tapping screws [1] (2 pcs).
- 3 Fit Ring terminals [3] (2 pcs) onto Brush holders with 1R370.

Fig. 35

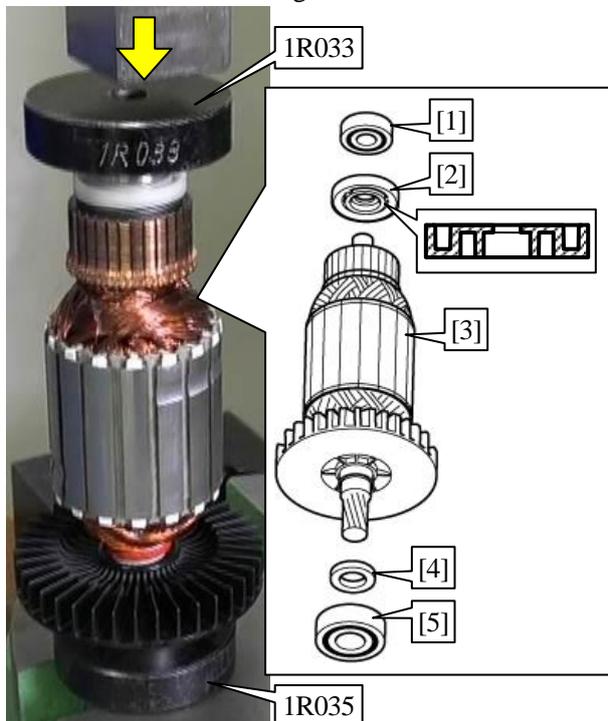


- 4 Fix Cover [2] to Motor housing complete with 4x18 Tapping screws [1] (2 pcs).

**Note**

Be careful not to pinch Lead wires.

Fig. 36



- 5 Press-fit the following parts with 1R033 and 1R035:

- Ball bearing 6000DDW [1]
- Insulation washer [2]
- Armature ass'y [3]
- Flat washer 15 [4]
- Ball bearing 6202DDW [5]

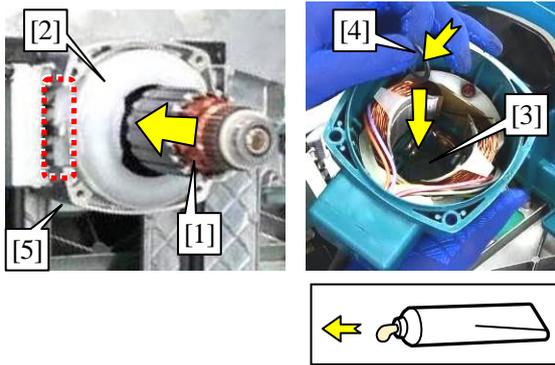
**Tips**

Note the orientation of Insulation washer [2].

**Note**

Turn Armature ass'y [3] to prevent it from tilting.

Fig. 37



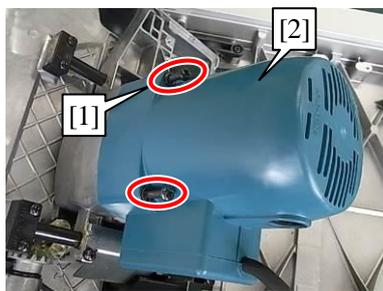
6 Assemble Armature ass'y [1] and Baffle plate [2].

Tips

- Adjust the cutting depth to the maximum.
- Adjust the blade bevel angle to 45 degrees.
- Align the notch of Baffle plate [2] with the projection of Gear housing complete [5].

7 Attach Urethane washer 18 [3] and Flat washer 18 [4] into the bearing room in Motor housing complete with grease, then assemble Motor housing complete to Armature ass'y.

Fig. 38

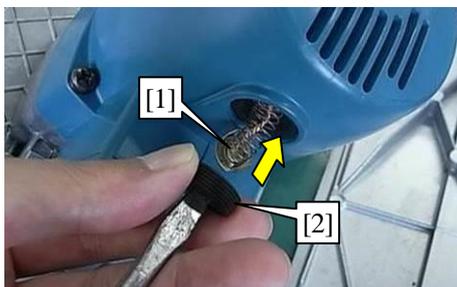


8 Assemble Motor section [2] with M6x60 Pan head screws [1] (4 pcs).

Tips

Tap Motor housing complete with a plastic hammer to push Armature ass'y into Gear housing complete.

Fig. 39

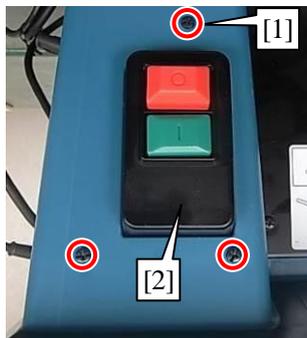


9 Install Carbon brushes [1] (2 pcs) and Holder caps 6.5 [2] (2 pcs).

Tips

Use a short screwdriver in tight spaces.

Fig. 40

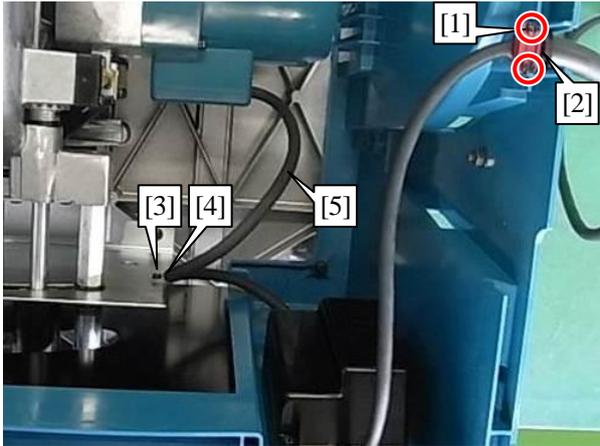


10 Assemble Switch base [2] to Base complete with 4x14 Tapping screws [1] (3 pcs).

Tips

Be careful not to strip the screws.

Fig. 41



- 11 Fix Strain relief [2] with 4x18 Tapping screws [1] (2 pcs).
- 12 Fix Strain relief [4] with M4x10 (+) Pan head screw [3].

**Tips**

When fixing Strain relief [4], adjust the cutting depth to the maximum, and the blade bevel angle to 45 degrees to make excess length of Cord [5].

## 6-7 Switch

### 6-7-1 Disassembling

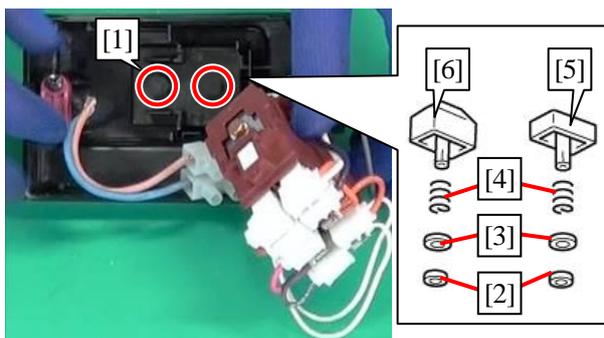
- 1 Remove Switch base section. (6-6-1)

Fig. 42



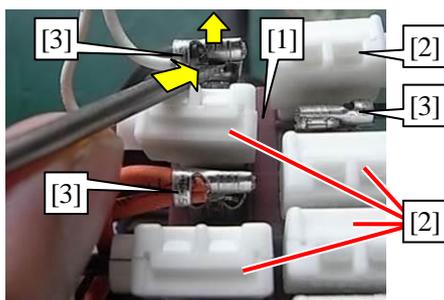
- 2 Remove 4x18 Tapping screws [1] (2 pcs), then remove Switch box [2].

Fig. 43



- 3 Remove Pins [1] (2 pcs), and remove the following parts:
  - Felt rings 6 [2] (2 pcs)
  - Flat washers 7 [3] (2 pcs)
  - Compression springs 8 [4] (2 pcs)
  - Switch button ON [5]
  - Switch button OFF [6]

Fig. 44



- 4 Disconnect the terminals from Relay [1].

**Tips**

How to disconnect terminals:

- Terminal [2] with Insulation cover: by just pulling it off
- Terminal [3] without Insulation cover: by pulling it off while pushing in the locking tab to unlock it

## 6-7-2 Assembling

- 1 Assemble Switch by reversing the disassembly procedure.

### Tips

Insert Terminals until they click.

Fig. 45



- 2 Assemble Switch box [2] to Switch base with 4x18 Tapping screws [1] (2 pcs).

### Note

Be careful not to pinch Lead wires.

## 6-8 Base complete

### 6-8-1 Disassembling

- 1 Remove Motor. (6-6-1)

Fig. 46



- 2 Adjust the blade bevel angle to 25 degrees.

Fig. 47



- 3 Remove Bind CT 4x8 Tapping screws [1] (2 pcs), then remove Dust joint [2].

### Tips

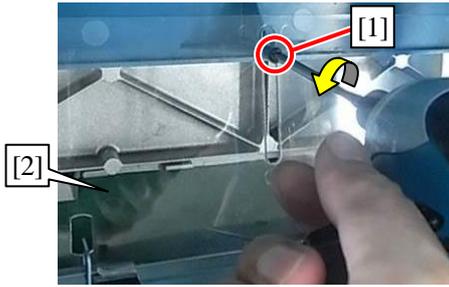
Dust joint [2] can be removed by sliding it.

Fig. 48



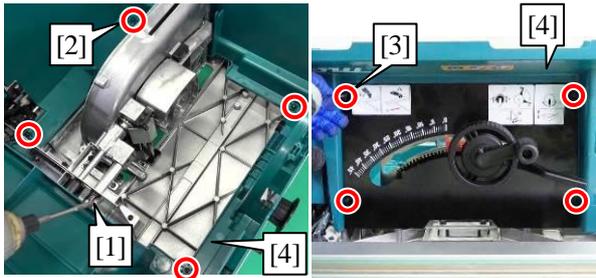
- 4 Adjust the blade bevel angle to 0 degrees.

Fig. 49



- 5 Remove 4x18 Tapping screw [1] with a No.3 Phillips bit to release Slide cover [2].

Fig. 50

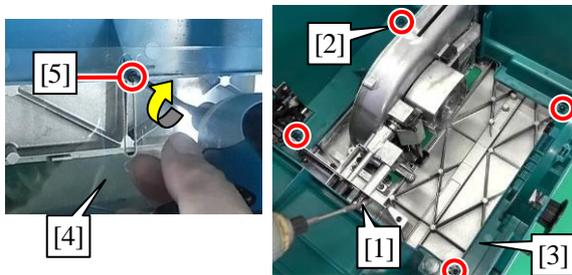


- 6 Remove M6x25 Pan head screws [2] (4 pcs) and 4x14 Tapping screws [3] (4 pcs) with a No.3 Phillips bit [1], then remove Base section [4].

## 6-8-2 Assembling

- 1 Assemble Frame section. (6-10-2)

Fig. 51



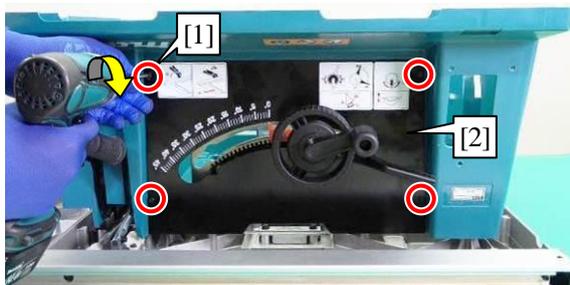
- 2 Assemble Base complete [3] to Table complete with M6x25 Pan head screws [2] (4 pcs) using a No.3 Phillips bit [1].

### Tips

When assembling Base complete [3], raise Slide cover [4] upright so that it does not get trapped under Base complete [3].

- 3 Fix Slide cover [4] with 4x18 Tapping screw [5] using a No.3 Phillips bit [1].

Fig. 52



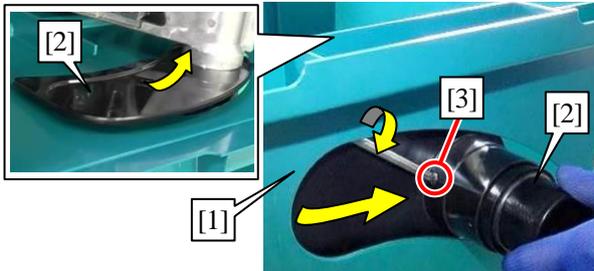
- 4 Assemble Base front cover [2] with 4x14 Tapping screws [1] (4 pcs) using a No.3 Phillips bit.

Fig. 53



- 5 Adjust the blade bevel angle to 25 degrees.

Fig. 54



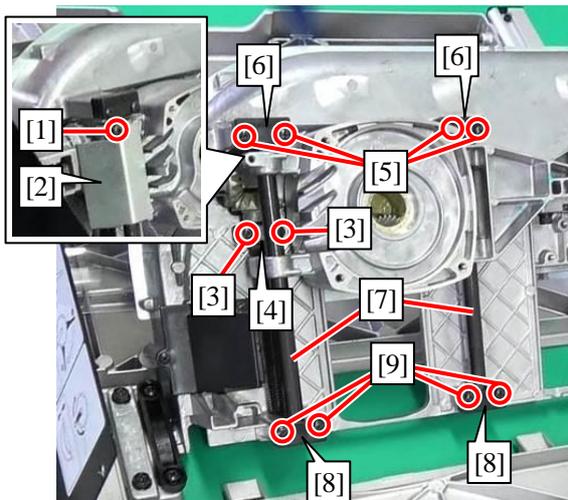
- 6 Assemble Dust joint [2] to Base complete [1] with Bind CT 4x8 Tapping screws [3] (2 pcs).

## 6-9 Gear section

### 6-9-1 Disassembling

- 1 Remove Base complete. (6-8-1)

Fig. 55

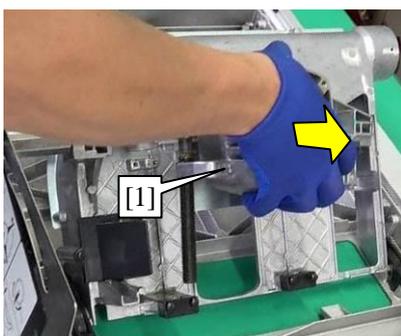


- 2 Remove M5x12 Pan head screw [1], then remove Gear housing plate [2].
- 3 Remove CT 4x25 Tapping screws [3] (2 pcs), then remove Screw bar retainer [4].
- 4 Remove CT 4x25 Tapping screws [5] (4 pcs), then remove Guide bar retainers [6] (2 pcs) and Guide bars [7] (2 pcs).

#### Tips

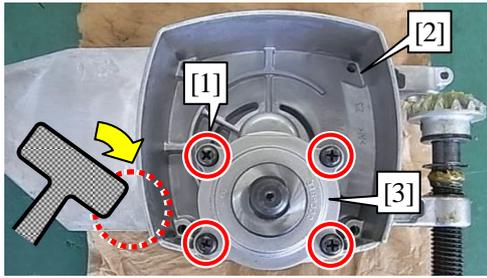
- Adjust the cutting depth to the maximum.
- Adjust the blade bevel angle to 45 degrees.
- Adjust the bevel angle of Slide cover to the maximum.
- Loosen CT 4x25 Tapping screws [9] (4 pcs) that fix Guide bar retainers [8] (2 pcs).

Fig. 56



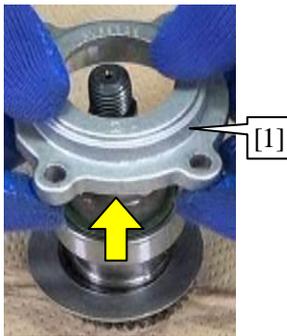
- 5 Remove Gear housing section [1].

Fig. 57



- 6 Remove M5x20 Pan head screws [1] (4 pcs).
- 7 Remove Gear section [3] by tapping Gear housing complete [2] with a plastic hammer.

Fig. 58

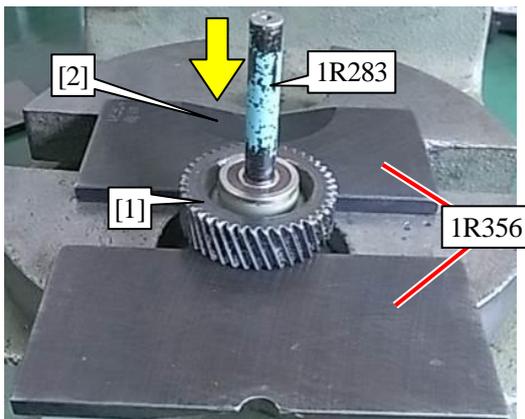


- 8 Remove Bearing box [1].

**Tips**

Do not tilt Bearing box [1] when removing it.

Fig. 59



- 9 Support Helical gear 42 [1] with 1R356 (2 pcs).
- 10 Then push out Spindle with Arbor press and 1R283.

**Tips**

- Do not use the notched side [2] of 1R356.
- Spindle can be removed by applying a light shock to it.

**Note**

Be careful not to let Spindle section or Flat washer 34 on the floor.

Fig. 60

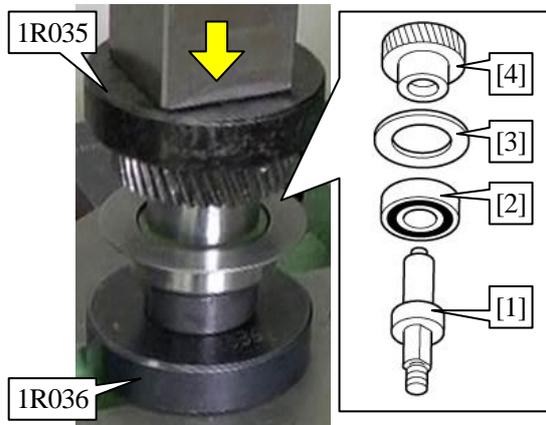


- 11 Remove Ball bearing 6203DDW [1] with 1R401.

## 6-9-2 Assembling

### 1 Assemble Table. (6-11-2)

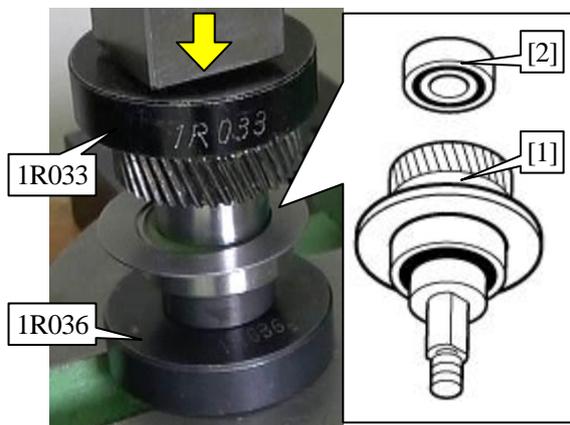
Fig. 61



2 Set Spindle [1] on 1R036, then press-fit the following parts with Arbor press and 1R035:

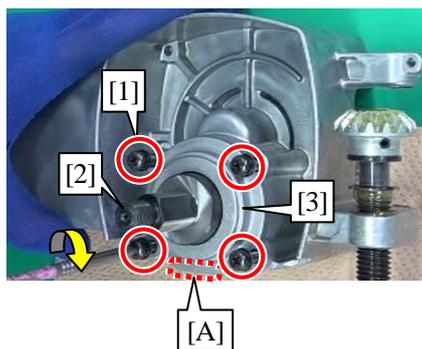
- Ball bearing 6203DDW [2]
- Flat washer 34 [3]
- Helical gear 42 [4]

Fig. 62



3 Set Spindle section [1] on 1R036, then press-fit Ball bearing 609LLB [2] with Arbor press and 1R033.

Fig. 63

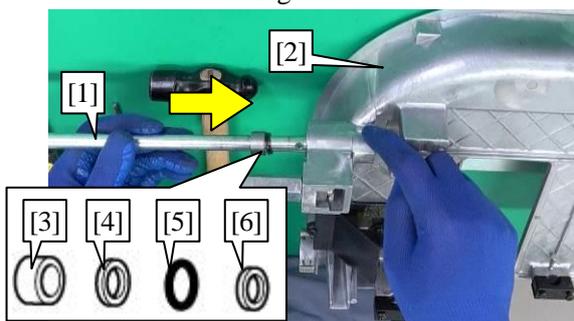


4 Assemble Gear section consisting of Spindle section [2] and Bearing box [3] with M5x20 Pan head screws [1] (4 pcs).

#### Note

Note the orientation of Bearing box [3]. The flat part [A] should be positioned as shown.

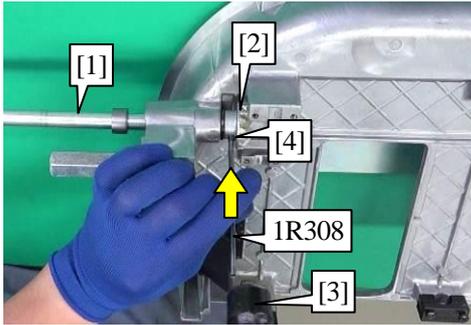
Fig. 64



5 Slide the following parts onto Handle shaft [1], then insert Handle shaft [1] into Frame [2]:

- Plane bearing 12 [3]
- Flat washer 12 (big) [4]
- O ring 12 [5]
- Flat washer 12 (small) [6]

Fig. 65

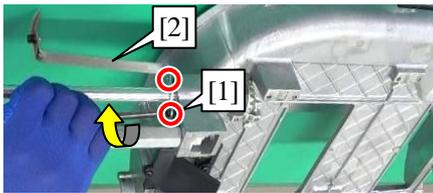


- 6 Set Flat washer 12 and Straight bevel gear [2] on Handle shaft [1].
- 7 Tap Spring pin 4-20 [4] into place with a hammer [3] and 1R308.

**Tips**

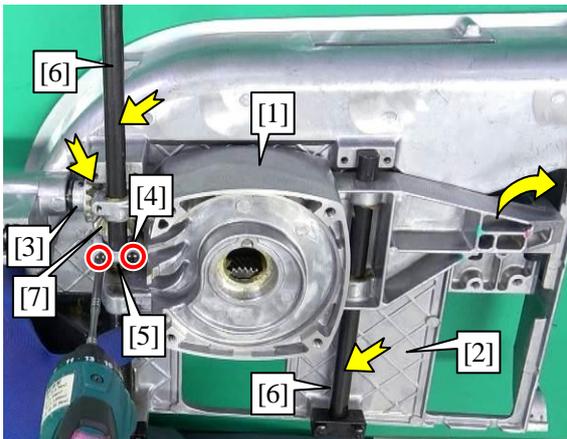
Apply the specified grease to Flat washer 12.

Fig. 66



- 8 Assemble Stay section [2] with CT 4x16 Tapping screws [1] (2 pcs).

Fig. 67



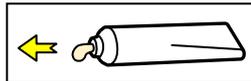
- 9 Assemble Gear housing section [1] to Frame [2].

**Tips**

Apply the specified grease to Straight bevel gear [3].

**Note**

- The [A] of Gear housing section [1] should be under the [B] of Frame [2].
- Assemble Gear housing section [1] to Frame section [2] so that Straight bevel gear [3] engages with Straight bevel gear [7].



- 10 Temporarily fasten Screw bar retainer [5] by lightly tightening CT 4x25 Tapping screws [4] (2 pcs).

- 11 Apply the specified grease to Guide bars [6] (2 pcs), then pass them through the holes of Gear housing complete [1].

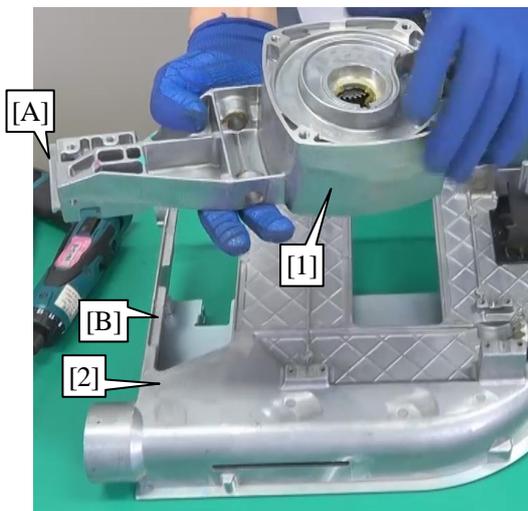
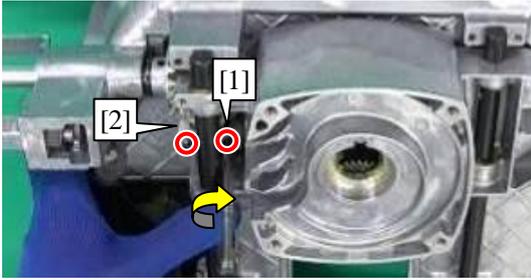


Fig. 68

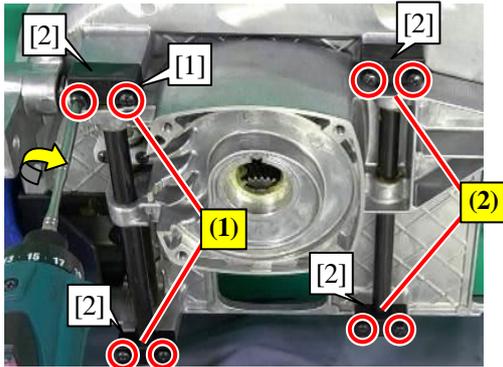


- 12** Assemble Screw bar retainer [2] by completely tightening CT 4x25 Tapping screws [1] (2 pcs).

**Note**

Adjust CT 4x25 Tapping screws [1] (2 pcs) so that Gear housing section moves up and down smoothly.

Fig. 69

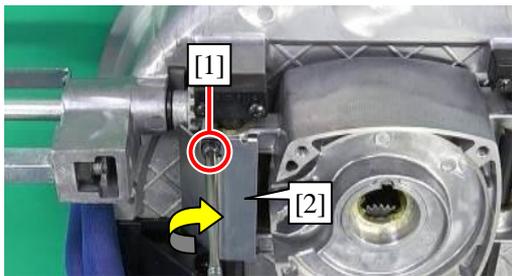


- 13** Assemble Guide bar retainers [2] (4 pcs) by tightening CT 4x25 Tapping screws [1] (8 pcs) in the order from (1) to (2).

**Note**

Make sure that Handle shaft rotates.

Fig. 70



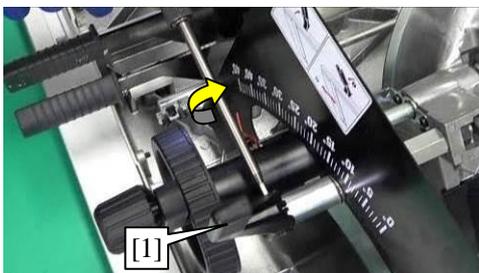
- 14** Assemble Gear housing plate [2] by tightening M5x12 Pan head screw [1].

## 6-10 Frame section

### 6-10-1 Disassembling

- 1** Remove Gear section. ([6-9-1](#))

Fig. 71

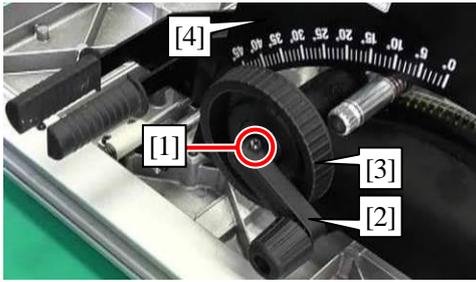


- 2** Loosen M5x20 Hex socket head bolt, then remove Lever 120 [1].

**Tips**

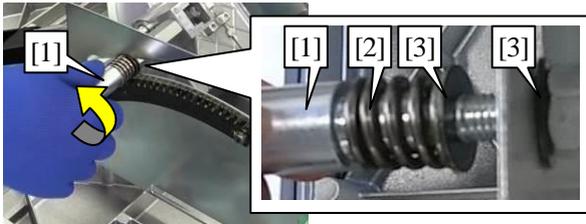
Slightly loosen the lock of Lever 120 [1] in advance.

Fig. 72



- 3 Remove M5x16 Pan head screw [1], then remove Arm 60 [2], Handle 100 [3] and Base front cover [4].

Fig. 73

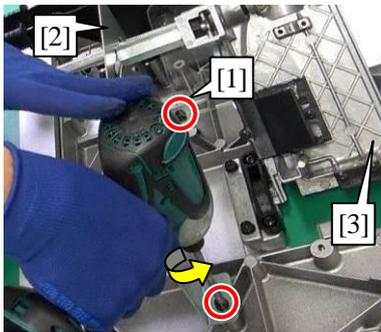


- 4 Remove Lock lever shaft [1], then remove Compression spring 14 [2] and Flat washers 10 [3] (2 pcs).

**Note**

Be careful not to lose Flat washers 10 [3] (2 pcs).

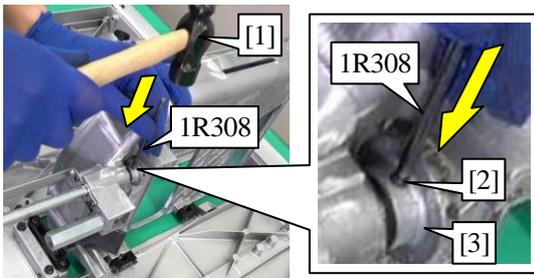
Fig. 74



- 5 Remove M6x16 Pan head screws [1] (2 pcs) to release Plate [2].

- 6 Raise Frame [3].

Fig. 75

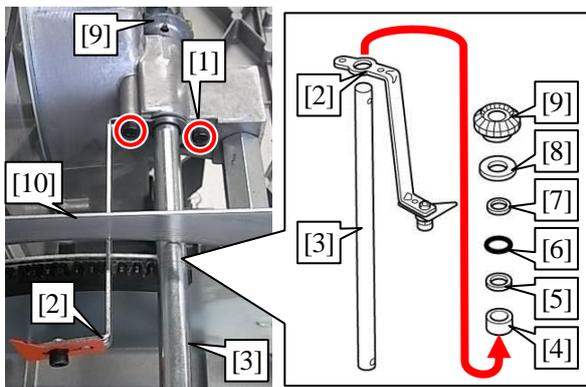


- 7 Remove Spring pin 4-20 [2] by tapping it with 1R308 and a hammer [1] to release Straight bevel gear [3].

**Tips**

Adjust the blade bevel angle to 90 degrees to easily remove Spring pin 4-20 [2].

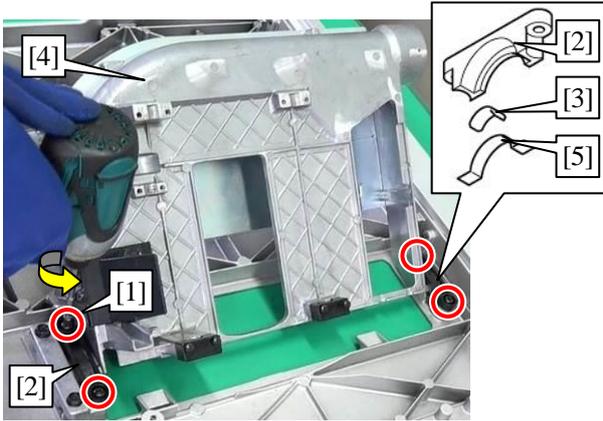
Fig. 76



- 8 Remove CT 4x16 Tapping screws [1] (2 pcs), then remove the following parts:

- Stay section [2]
- Handle shaft [3]
- Plane bearing 12 [4]
- Flat washer 12 (big) [5]
- O ring 12 [6]
- Flat washer 12 (small) [7]
- Flat washer 12 [8]
- Straight bevel gear [9]
- Plate [10]

Fig. 77



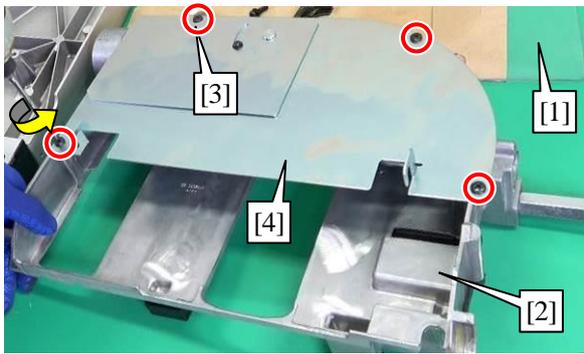
**9** Remove M6x20 Pan head screws [1] (4 pcs) with a No.3 Phillips screwdriver, then remove the following parts:

- Frame retainers [2] (2 pcs)
- Leaf springs [3] (2 pcs)
- Frame section [4]
- Slide seats [5] (2 pcs)

**Tips**

Adjust the blade bevel angle to 45 degrees for easy removal of the screws.

Fig. 78



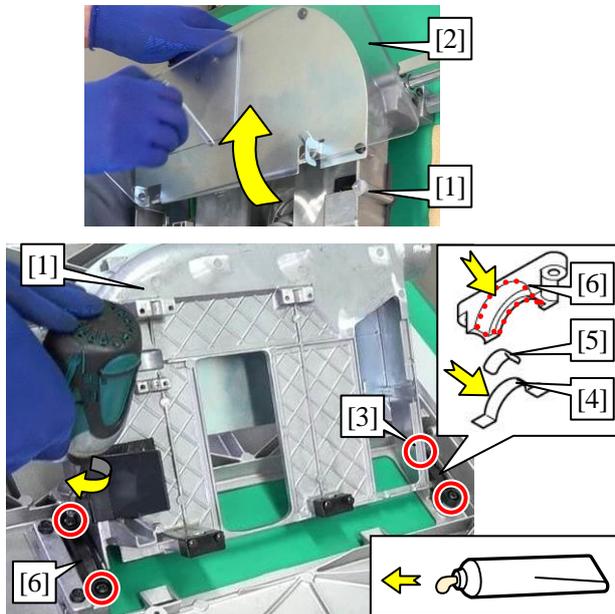
**10** Remove Slide cover [1].

**11** Remove Bind CT 5x12 Tapping screws [3] (4 pcs) from Frame [2], then remove Frame cover complete [4].

## 6-10-2 Assembling

### 1 Assemble Gear section. (6-9-2)

Fig. 79

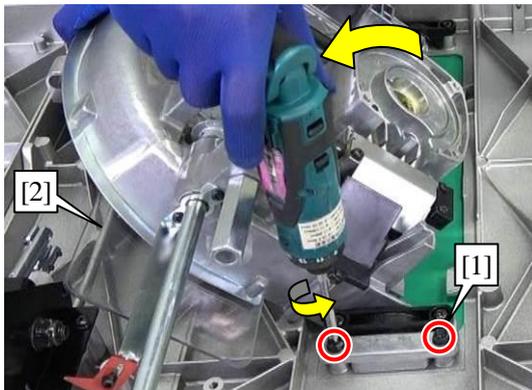


- 2 Assemble Slide cover [2] to Frame section [1].
- 3 Assemble the following parts by tightening M6x20 Pan head screws [3] (4 pcs) with a No.3 Phillips screwdriver:
  - Slide seats [4] (2 pcs)
  - Frame section [1]
  - Leaf springs [5] (2 pcs)
  - Frame retainers [6] (2 pcs)

#### Note

Apply the specified grease to Slide seats [4] (2 pcs) and Frame retainers [6] (2 pcs).

Fig. 80



- 4 Loosen M6x20 Hex bolts [1] (2 pcs).

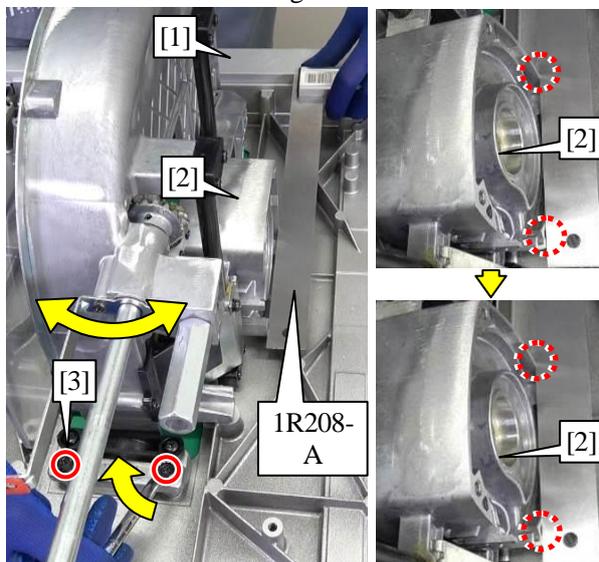
#### Tips

Raise Slide cover [2] so that it does not prevent smooth adjustment of Frame section.

#### Note

Adjust the cutting depth to the maximum.

Fig. 81

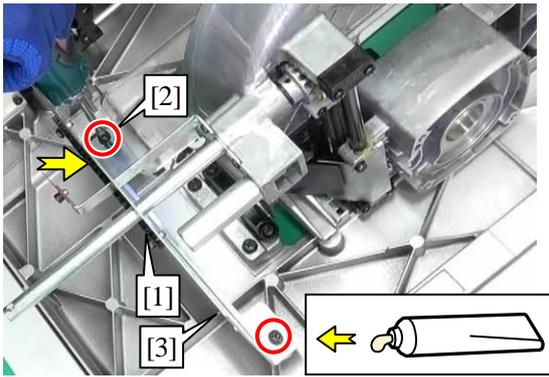


- 5 Set 1R208-A against Rear rail section [1], then adjust the gap between 1R208-A and Gear housing complete [2] until there are no gaps between them.
- 6 After adjustment, tighten M6x20 Hex bolts [3] (2 pcs).

#### Note

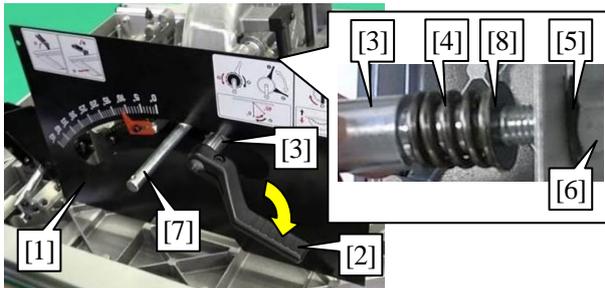
Tighten M6x20 Hex bolts [3] (2 pcs) while always checking there are no gaps between 1R208-A and Gear housing complete [2].

Fig. 82



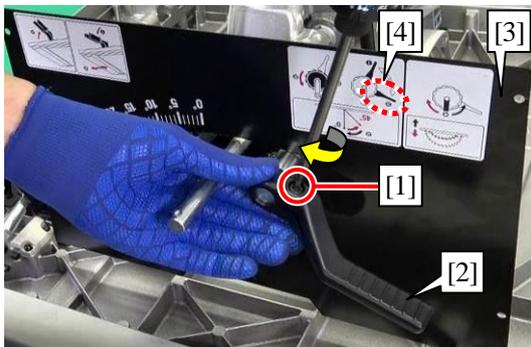
- 7 Apply the specified grease to Rack plate [1].
- 8 Assemble Plate [3] with M6x16 Pan head screws [2] (2 pcs).

Fig. 83



- 9 Pass Base front cover [1] through Handle shaft [7].
- 10 Set Flat washer 10 [5] to Lock lever connector [6].
- 11 Set Compression spring 14 [4] and Flat washer 10 [8] to Lock lever shaft [3].
- 12 Assemble Lock lever shaft [3] to Lock lever connector [6].
- 13 Tighten Lock lever shaft [3] with Lever 120 [2].

Fig. 84

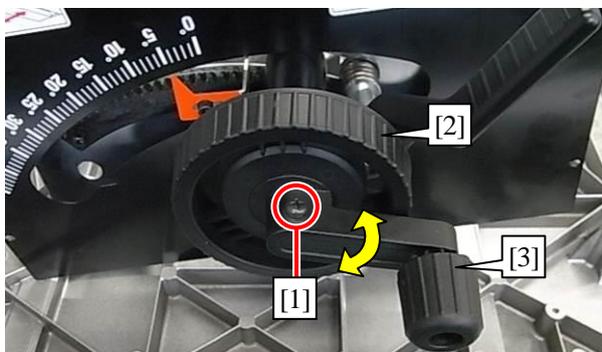


- 14 Assemble Lever 120 [2] to Lock lever shaft with M5x20 Hex socket head bolt [1].

**Note**

The position of Lever 120 [2] should be referred to the illustration [4] printed on Base front cover [3].

Fig. 85



- 15 Assemble Handle 100 [2] and Arm 60 [3] with M5x16 Pan head screw [1].

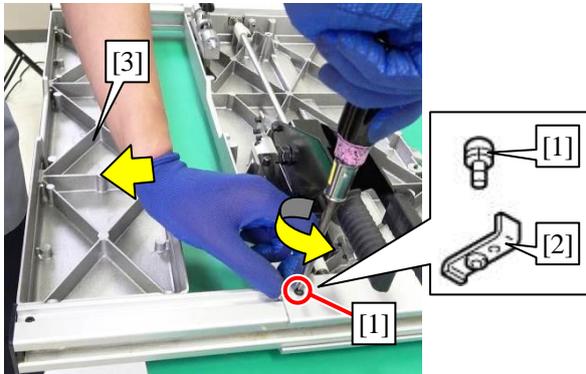
**Note**

Make sure that Gear housing complete moves up and down smoothly.

**6-11 Table section**  
**6-11-1 Disassembling**

**1** Disassemble Frame section and Rear table section. (6-10-1, 6-4-1)

Fig. 86



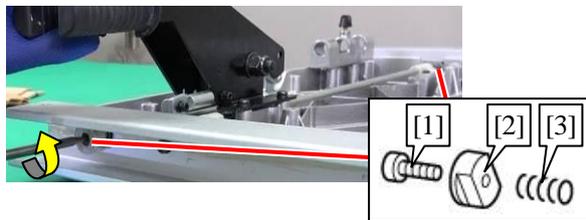
- 2** Remove M4x10 (+) Pan head screw [1], then remove Rail stopper [2].

**Tips**

Sub table [3] should be pulled out in advance.

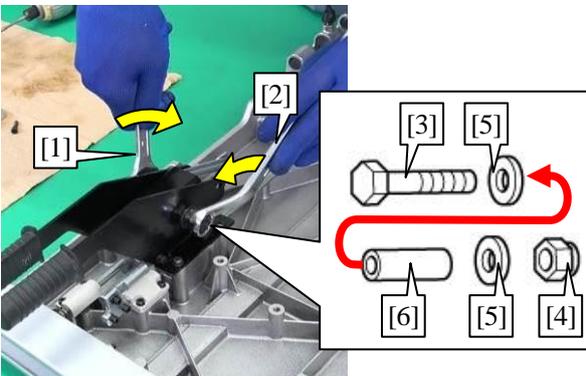
- 3** Remove Sub table [3].

Fig. 87



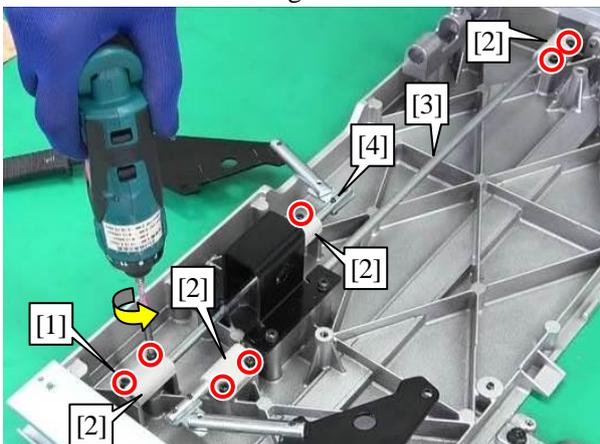
- 4** Remove M5x20 Hex socket head bolts [1] (2 pcs), then remove Hook rings [2] (2 pcs) and Compression springs 8 [3] (2 pcs).

Fig. 88



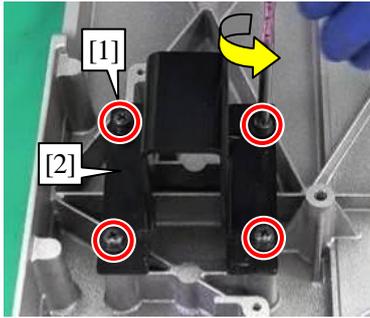
- 5** Remove M10x60 Hex bolt [3] using a wrench [1] and an offset wrench [2], then remove M10-17 Hex lock nut [4], Flat washers 10 [5] (2 pcs) and Sleeve 10 [6].

Fig. 89



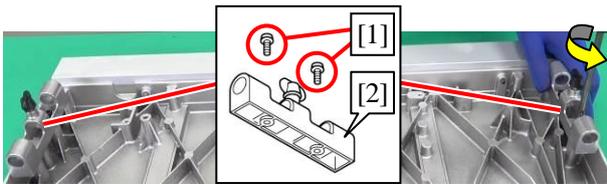
- 6** Remove M4x16 Pan head screws with WR [1] (8 pcs), then remove Rod holders [2] (4 pcs), Rod R [3] and Rod F [4].

Fig. 90



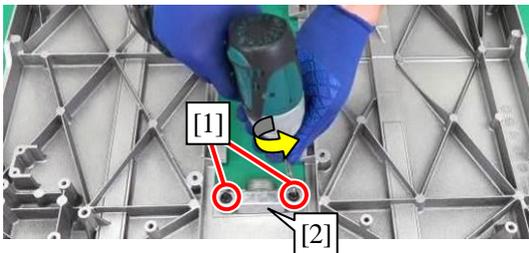
- 7 Remove M5x16 Pan head screws [1] (4 pcs), then remove Handle plate holder [2].

Fig. 91



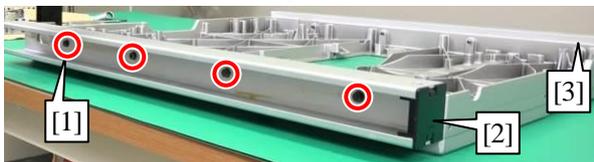
- 8 Remove M5x16 Hex socket head bolts [1] (4 pcs), then remove Slide rod holders [2] (2 pcs).

Fig. 92



- 9 Remove M6x20 Hex bolts [1] (2 pcs) with a No.3 Phillips screwdriver, then remove Adjust block [2].

Fig. 93

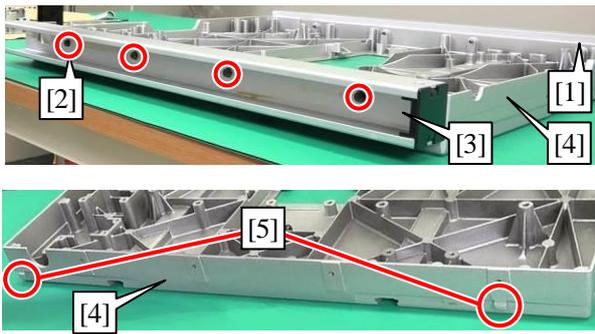


- 10 Remove M5x20 Pan head screws [1] (4 pcs), then remove Front outer rail complete [2].

- 11 Remove M5x20 Pan head screws (4 pcs), then remove Rear outer rail [3].

## 6-11-2 Assembling

Fig. 94

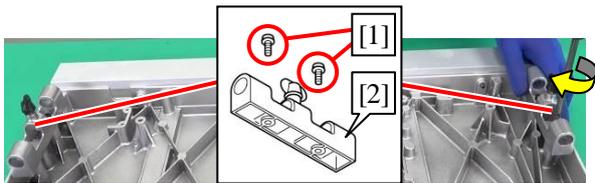


- 1 Assemble Rear outer rail [1] with M5x20 Pan head screws (4 pcs).
- 2 Assemble Front outer rail complete [3] with M5x20 Pan head screws [2] (4 pcs).

### Tips

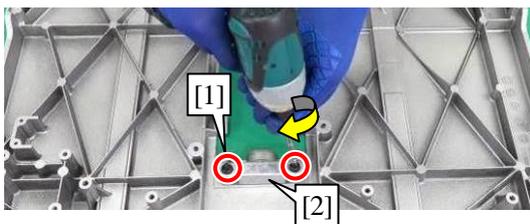
Each rail should be put on the hooks [5] on Table complete [4].

Fig. 95



- 3 Assemble Slide rod holders [2] (2 pcs) with M5x16 Hex socket head bolts [1] (4 pcs).

Fig. 96

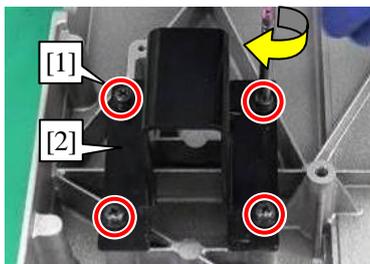


- 4 Fix Adjust block [2] by temporarily tightening M6x20 Hex bolts [1] (2 pcs) with a No.3 Phillips screwdriver.

### Tips

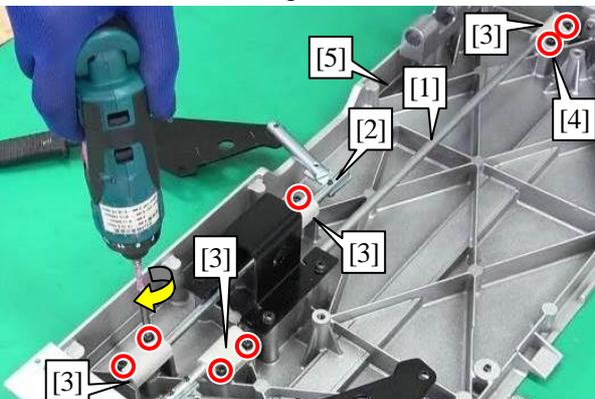
Adjust the position of Adjust block [2] later.

Fig. 97



- 5 Assemble Handle plate holder [2] with M5x16 Pan head screws [1] (4 pcs).

Fig. 98



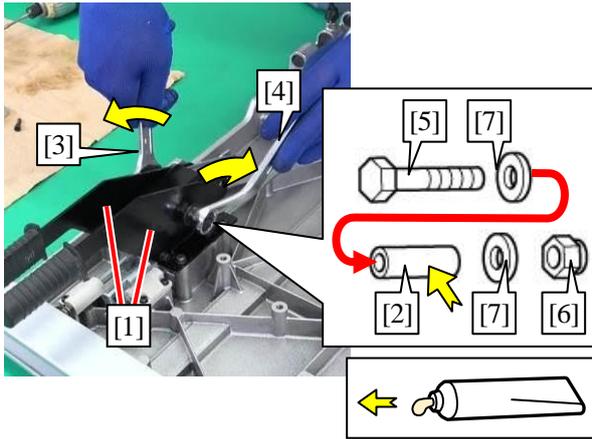
- 6 Slide Rod holders [3] (2 pcs) onto Rod R [1].
- 7 Slide Rod holders [3] (2 pcs) onto Rod F [2].

### Note

Note the orientation of Rod holder [3].

- 8 Assemble Rod holders [3] (4 pcs) to Table complete [5] by temporarily tightening M4x16 Pan head screws with WR [4] (8 pcs).

Fig. 99

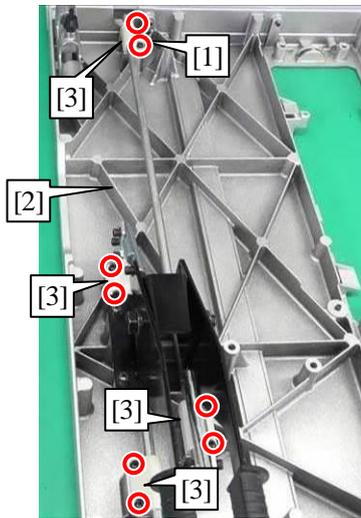


- 9 Apply the specified grease to the inside of Handle plates [1] (2 pcs) and the outer circumference of Sleeve 10 [2].
- 10 Install Handle plates [1] (2 pcs) on Handle plate holder with M10x60 Hex bolt [5], M10-17 Hex lock nut [6], Flat washers 10 [7] (2 pcs) and Sleeve 10 [2], using a wrench [3] and an offset wrench [4].

**Note**

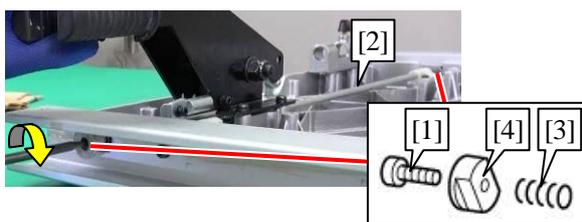
- Adjust M10x60 Hex bolt [5] and M10-17 Hex lock nut [6] so that you can operate Handle plates [1] (2 pcs) smoothly, and without looseness.
- Do not tighten M10x60 Hex bolt [5] too much.

Fig. 100



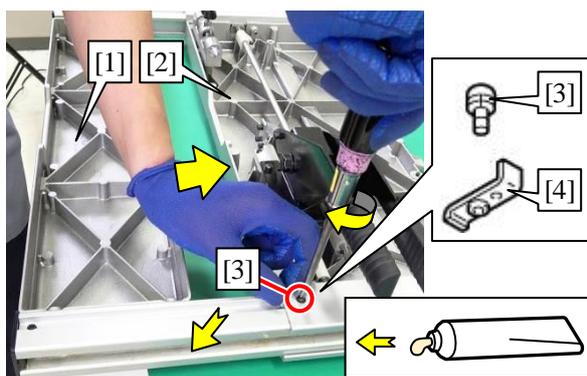
- 11 Assemble Rod holders [3] (4 pcs) to Table complete [2] by completely tightening M4x16 Pan head screws with WR [1] (8 pcs).

Fig. 101



- 12 Assemble Hook ring [4] and Compression spring 8 [3] to Rod R [2] with M5x20 Hex socket head bolt [1].
- 13 Assemble Hook ring [4] and Compression spring 8 [3] to Rod F with M5x20 Hex socket head bolt [1].

Fig. 102

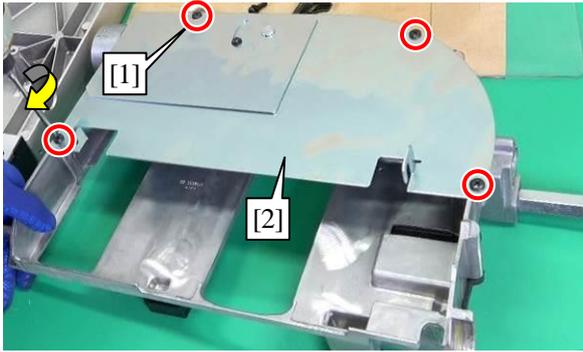


- 14 Apply the specified grease to the sliding surface of Sub table section [1], then insert it into Table complete [2].
- 15 Assemble Rail stopper [4] with M4x10 (+) Pan head screw [3].

**Tips**

- After assembling, check if:
- Sub table section [1] slides smoothly when unlocked.
  - Sub table section [1] does not slide when locked.

Fig. 103

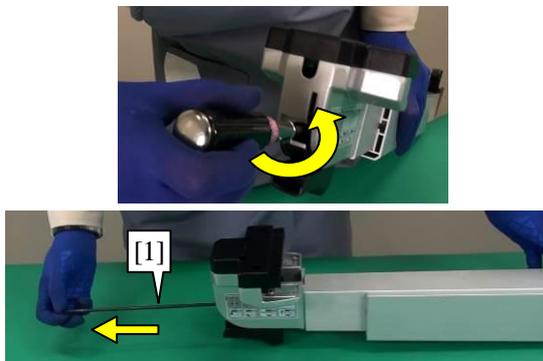


- 16 Assemble Frame cover complete [2] with Bind CT 5x12 Tapping screws [1] (4 pcs).

## 6-12 Ruler ass'y

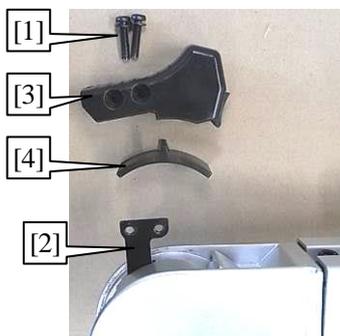
### 6-12-1 Disassembling

Fig. 104



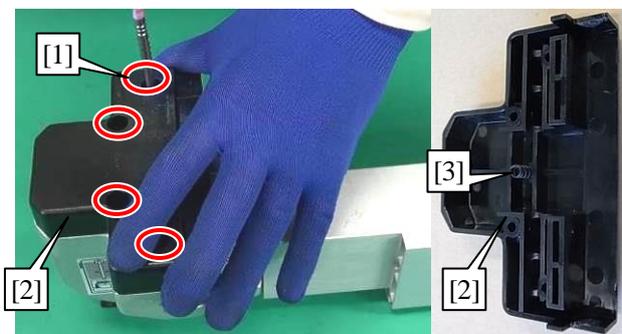
- 1 Remove M5x655 (+) Pan head screw [1].

Fig. 105



- 2 Remove M5x22 Pan head screws [1] (2 pcs), then remove Lever [3] and Cover [4] from Handle cam [2].

Fig. 106

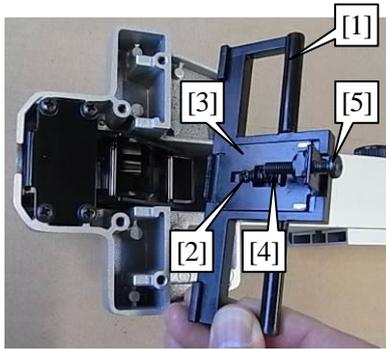


- 3 Remove M4x18 Pan head screws [1] (4 pcs), then remove Rule holder guide [2].

#### Tips

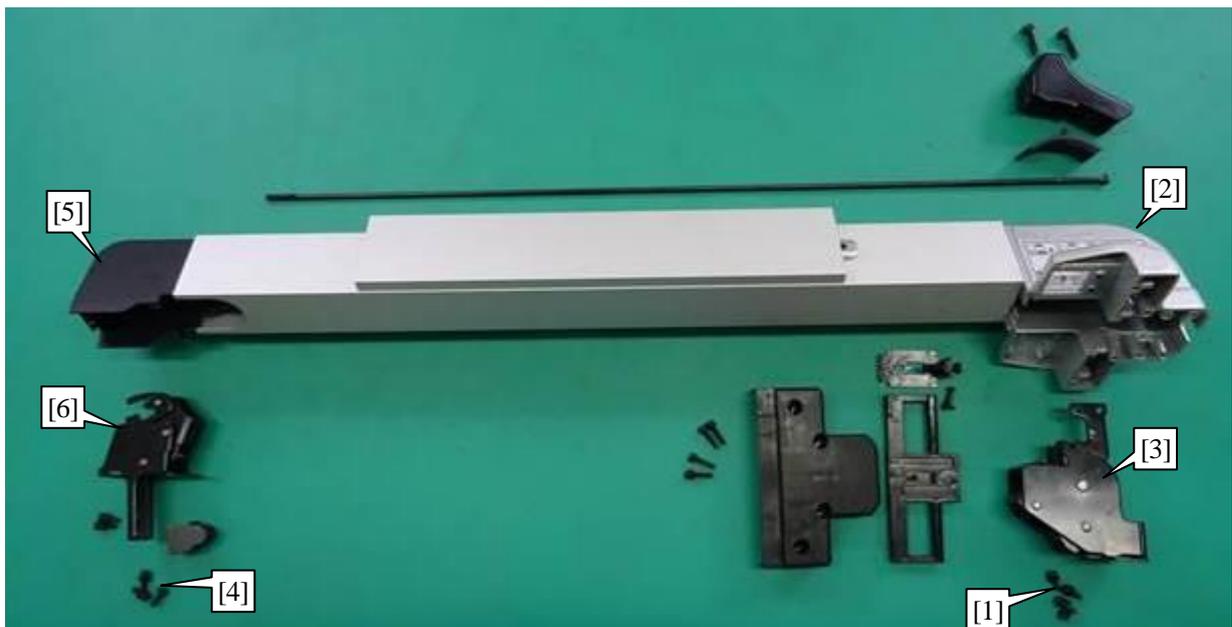
Compression spring 4 [3] is installed on the back of Rule holder guide [2].

Fig. 107



- 4 Remove Square guide [1].
- 5 Remove Bind PT 3x8 Tapping screw [2], then remove Lock plate [3], Compression spring 4 [4] and M5x25 (+) Pan head screw [5].

Fig. 108



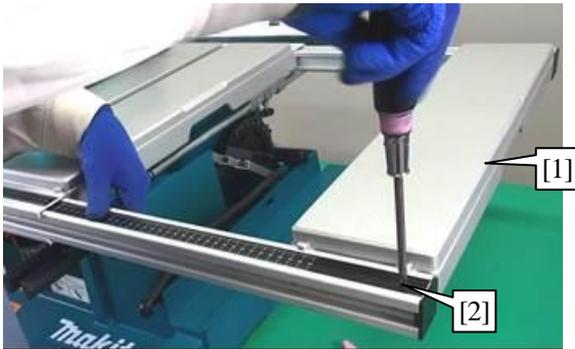
- 6 Remove M4x12 Pan head screws [1] (4 pcs), then remove Handle cam support complete [3] from Rule holder complete [3].
- 7 Remove M4x12 Pan head screws [4] (3 pcs), then remove Ruler top support complete [6] from Ruler top holder [5].

## 6-12-2 Assembling

- 1 Apply the specified grease to the moving part of Ruler top support complete and Lock plate, then assemble Ruler ass'y by reversing the disassembly procedure.

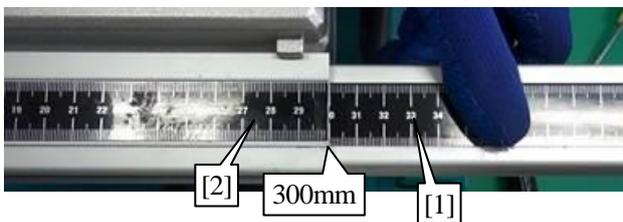
**6-13 Adjustment**  
**6-13-1 Inner scale plate**

Fig. 109



- 1 Fully pull Sub table [1].
- 2 Slightly loosen M4x10 (+) Pan head screw [2].

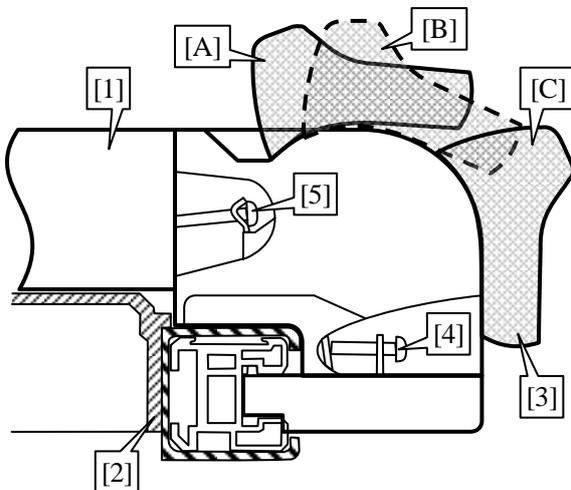
Fig. 110



- 3 Align the 300mm graduation line of Inner scale plate [1] with that of Outer scale plate [2], then tighten M4x10 (+) Pan head screw.

**6-13-2 Clamp adjustment of Ruler ass'y**

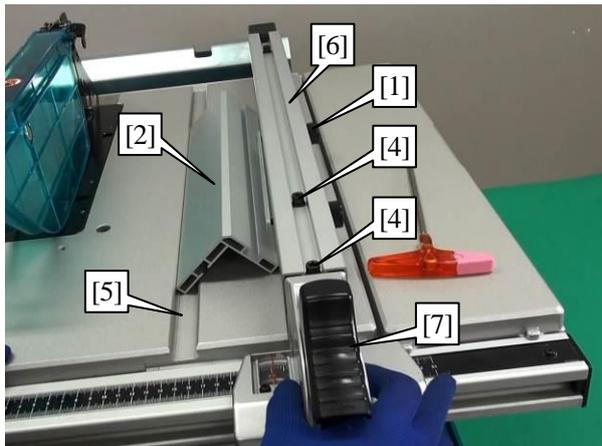
Fig. 111



- 1 Set Ruler ass'y [1] on Table complete [2].
- 2 Set Lever [3] to the [B] position, then tighten M5x25 (+) Pan head screw [4] until Ruler ass'y [1] does slides neither right nor left, and then loosen it a 1/4 to 1/2 turn.
- 3 Tighten M5x655 (+) Pan head screw [5] until Ruler ass'y [1] is securely fixed to Table complete [2], then loosen it 2 turns.
- 4 Adjust M5x25 (+) Pan head screw [4] and M5x655 (+) Pan head screw [5] so that:
  - When Ruler ass'y [1] is in the [A] position, it can be removed from Table complete [2].
  - When Ruler ass'y [1] is in the [B] position, it cannot be removed, but it slides smoothly right and left.
  - When Ruler ass'y [1] is in the [C] position, it is completely locked.

### 6-13-3 Parallel adjustment of Ruler ass'y

Fig. 112

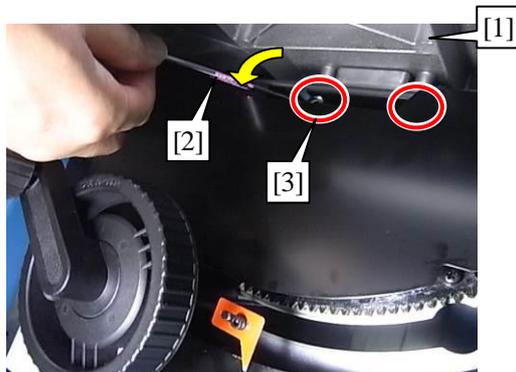


- 1 Slightly loosen M6x52 Thumb screws [1] (2 pcs), then remove Ruler adapter [2].
- 2 Slightly loosen M6x20 Hex socket head bolts [4] (2 pcs).
- 3 Put one end of Ruler adapter [2] in the groove of Table complete [5], then slide Ruler [6] to Ruler adapter [2] until there is no gap between them, and then lock Ruler ass'y with Lever [7].
- 4 Tighten M6x20 Hex socket head bolts [4] (2 pcs).

### 6-13-4 Parallel adjustment of Saw blade

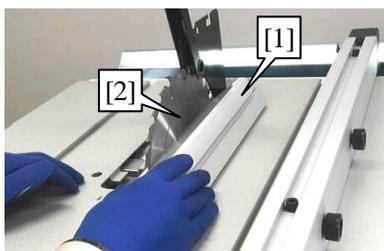
- 1 Adjust Ruler ass'y so that it is parallel to Table complete. (6-13-3)
- 2 Remove Finger part. (Fig. 4)
- 3 Remove Sub cover part. (6-3-1)
- 4 Remove Center cover assembly. (Fig. 2)

Fig. 113



- 5 Slightly loosen M6x20 Hex bolts [3] (2 pcs) on the bottom of Table complete [1] with a wrench 10 or an offset wrench [2].

Fig. 114

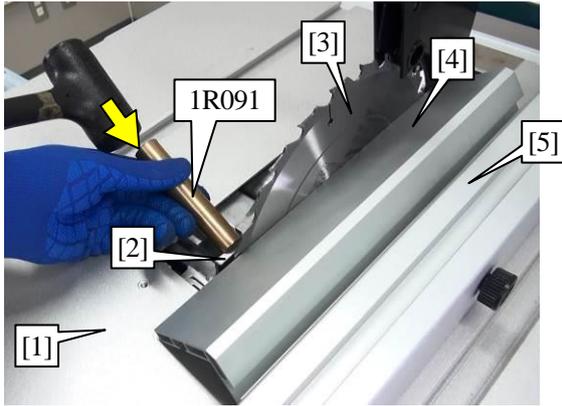


- 6 Set Ruler adapter [1] against Saw blade [2].

**Note**

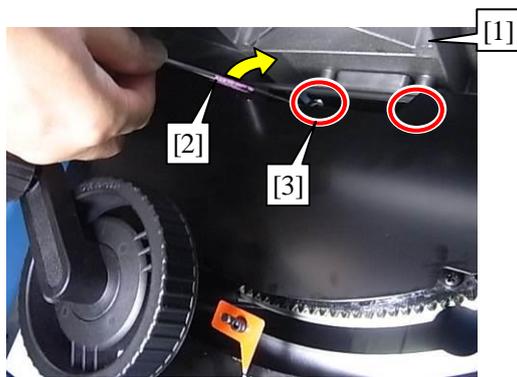
Do not allow Ruler adapter [1] to touch Riving knife or the tips of Saw blade.

Fig. 115



- 7 Gently tap Frame [2] with 1R091 and a plastic hammer until there is no gap between Saw blade [3], Ruler adapter [4] and Ruler ass'y [5].
- 8 Check that they are parallel to each other.

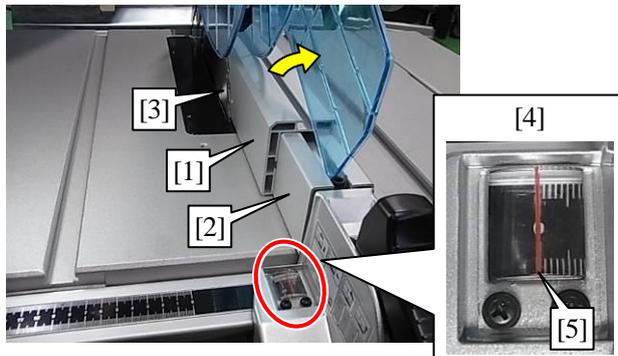
Fig. 116



- 9 Tighten M6x20 Hex bolts [3] (2 pcs) on the bottom of Table complete [1] with a wrench 10 or an offset wrench [2].

### 6-13-5 Lens

Fig. 117



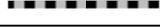
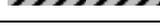
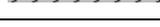
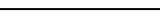
- 1 Set Ruler adapter [1] to Ruler ass'y [2].
- 2 Set Ruler adapter [1] against Saw blade [3].
- 3 Align the red line [5] on Lens [4] with the 0mm on the scale of Outer scale plate.

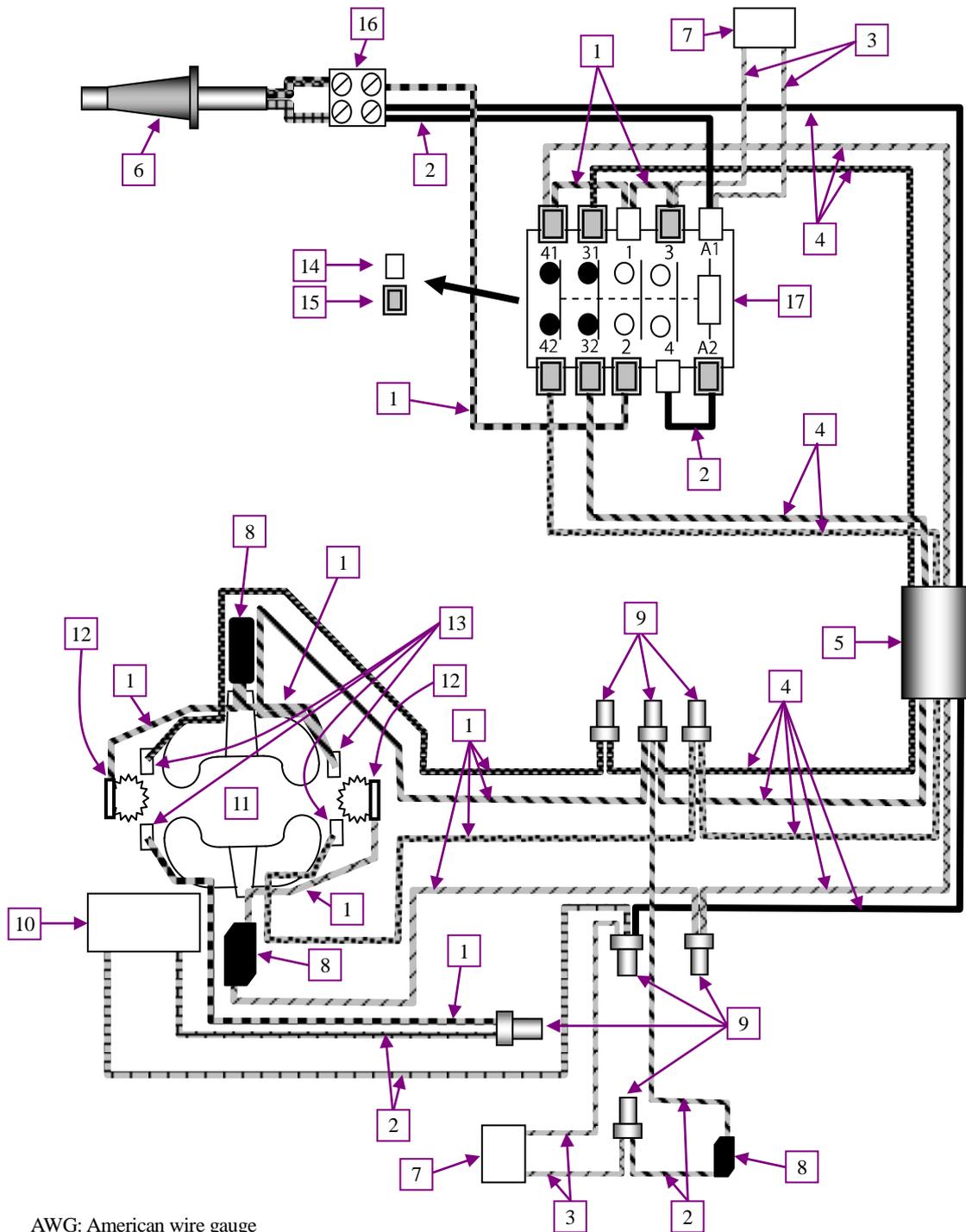
## 7 CIRCUIT DIAGRAM

### 7-1 For countries where High voltage EMI standards are regulated

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Fig. 118

Color index of lead wires' sheath	
White	
Blue	
Yellow	
Red	
Orange	
Gray	
Purple	
Brown	
Black	

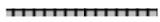


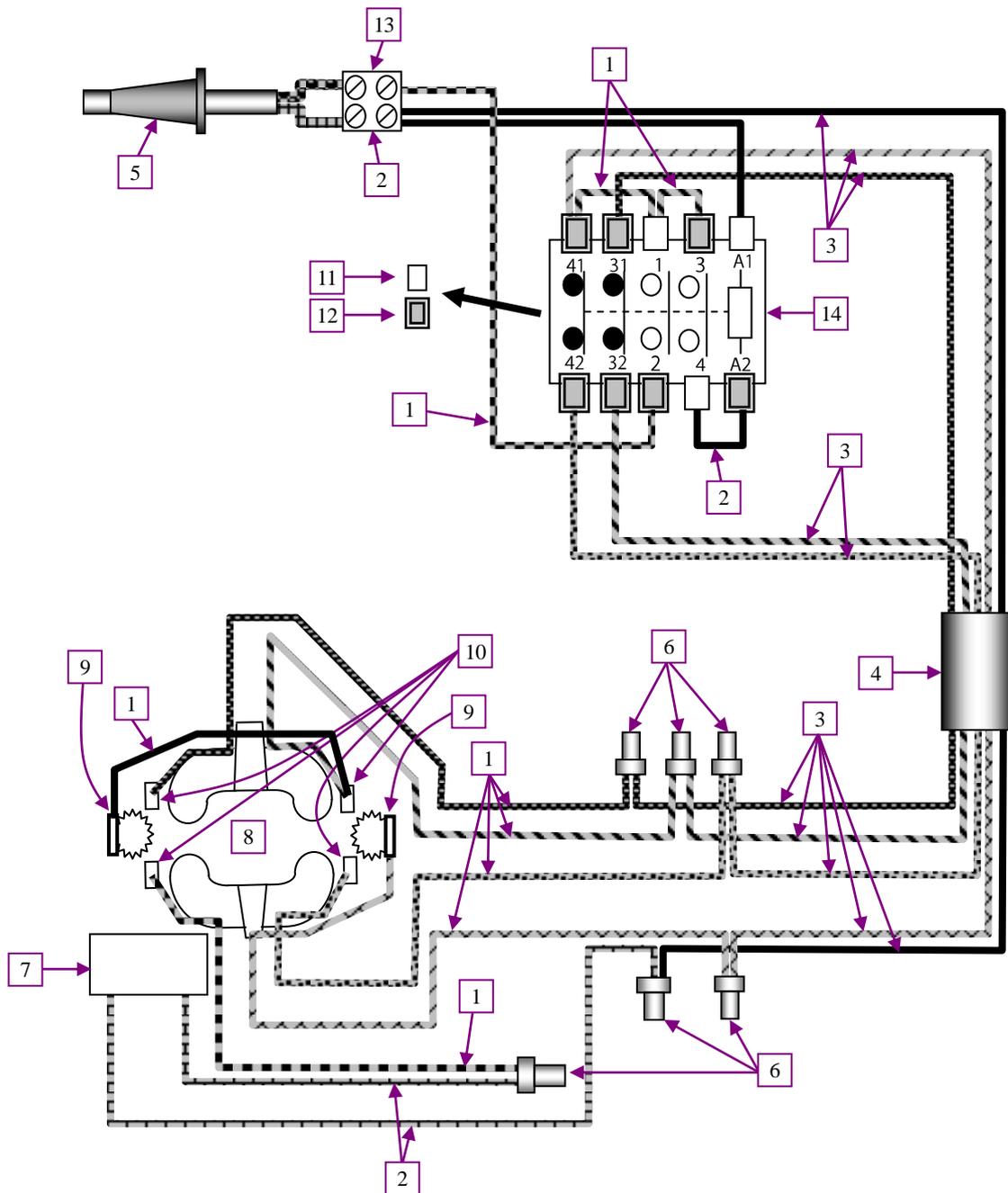
1	AWG16	10	Soft start circuit
2	AWG18	11	Field
3	AWG20	12	Ring terminal + Non-insulated terminal
4	1.0mm <sup>2</sup>	13	Flag receptacle without lock (#250, t=0.8mm)
5	Power supply cord (for relay)	14	Flag receptacle with lock (#250, t=0.8mm)
6	Power supply cord (for AC power supply)	15	Flag receptacle with lock (#250, t=0.8mm) + Receptacle sleeve
7	Noise suppressor	16	Terminal block
8	Choke coil	17	Relay
9	Closed end splice		

**7-2 For countries where High voltage EMI standards are not regulated**

---

Fig. 119

Color index of lead wires' sheath	
White	
Blue	
Yellow	
Red	
Orange	
Gray	
Purple	
Brown	
Black	

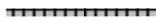


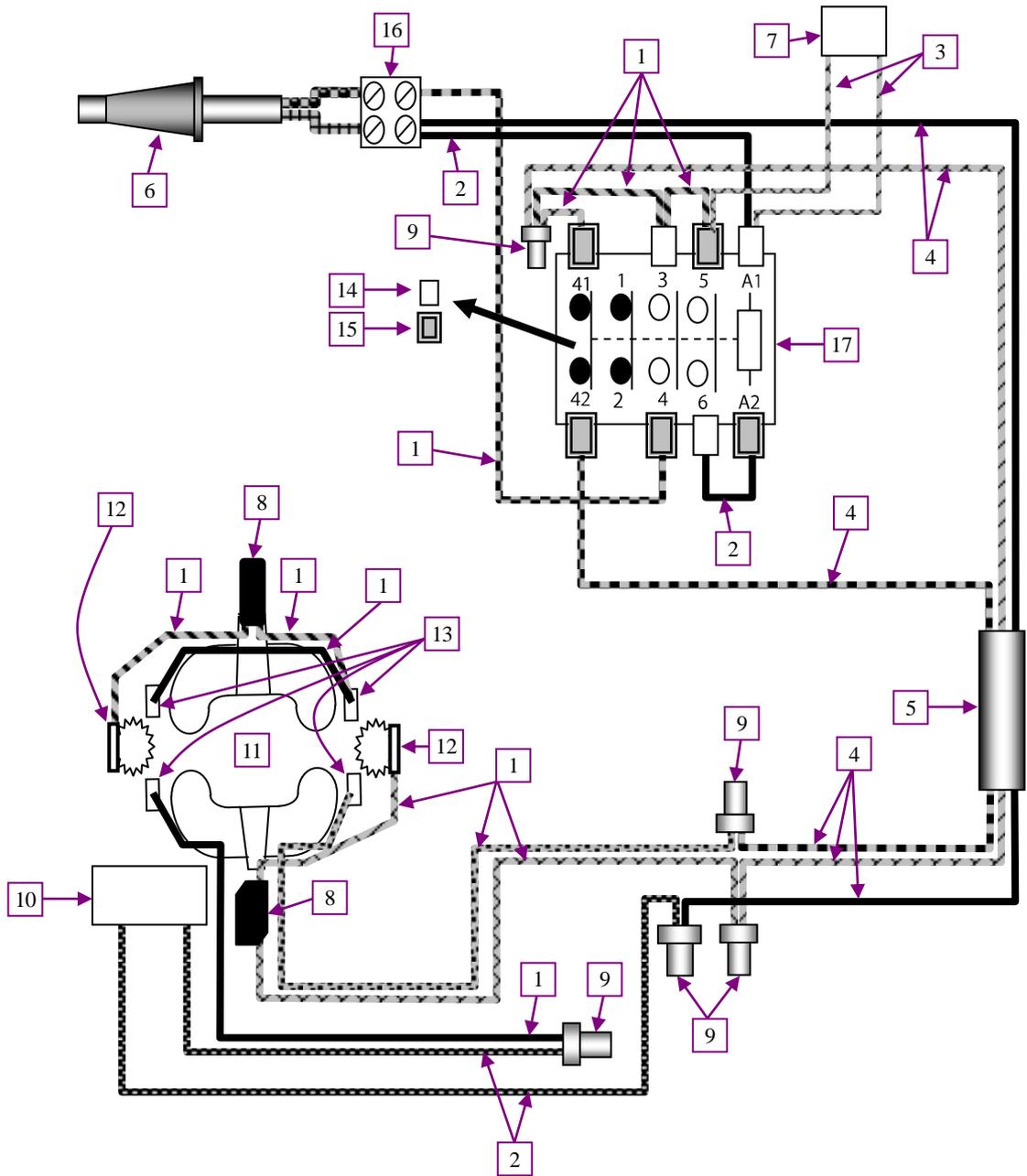
AWG: American wire gauge

1	AWG16	8	Field
2	AWG18	9	Ring terminal + Non-insulated terminal
3	1.0mm <sup>2</sup>	10	Flag receptacle without lock (#250, t=0.8mm)
4	Power supply cord (for relay)	11	Flag receptacle with lock (#250, t=0.8mm)
5	Power supply cord (for AC power)	12	Flag receptacle with lock (#250, t=0.8mm) + Receptacle sleeve
6	Closed end splice	13	Terminal block
7	Soft start circuit	14	Relay

7-3 For UK (110V)

Fig. 120

Color index of lead wires' sheath	
White	
Blue	
Yellow	
Red	
Orange	
Purple	
Brown	
Black	



AWG: American wire gauge

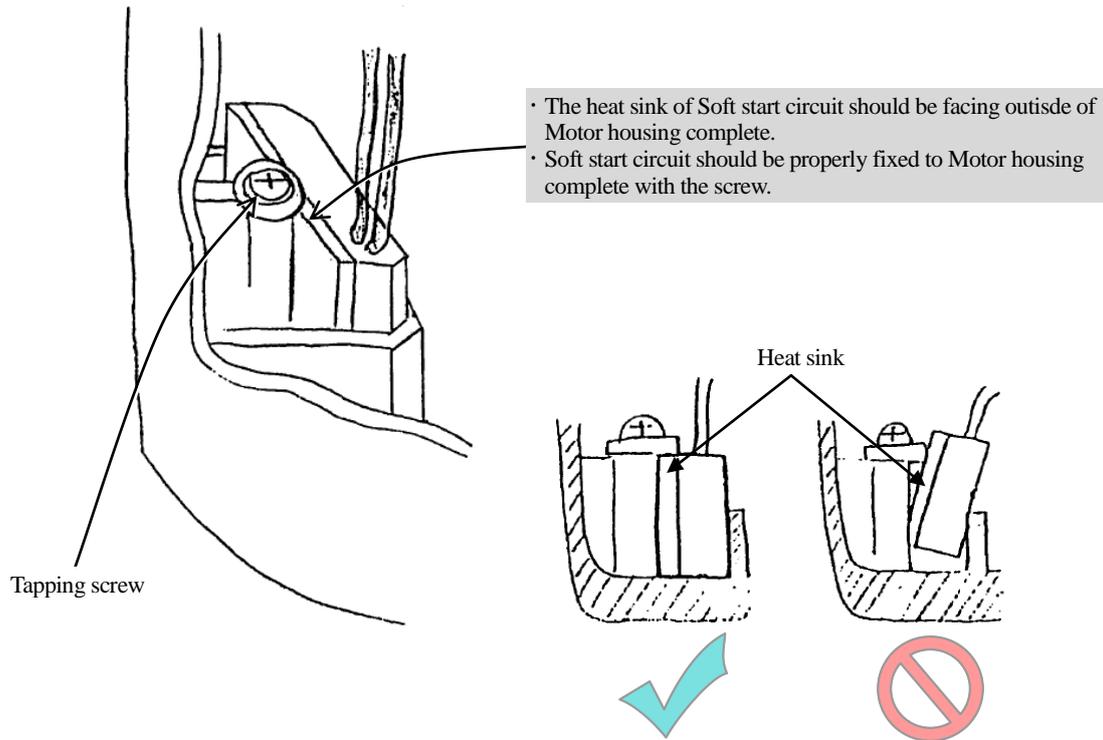
1	AWG16	10	Soft start circuit
2	AWG18	11	Field
3	AWG20	12	Ring terminal + Non-insulated terminal
4	1.5mm <sup>2</sup>	13	Flag receptacle without lock (#250, t=0.8mm)
5	Power supply cord (for relay)	14	Flag receptacle with lock (#250, t=0.8mm)
6	Power supply cord (for AC power)	15	Flag receptacle with lock (#250, t=0.8mm) + Receptacle sleeve
7	Noise suppressor	16	Terminal block
8	Choke coil	17	Relay
9	Closed end splice		

## 8 WIRING DIAGRAM

### 8-1 When using Soft start circuit

#### 8-1-1 How to install Soft start circuit to the bottom of Motor housing complete

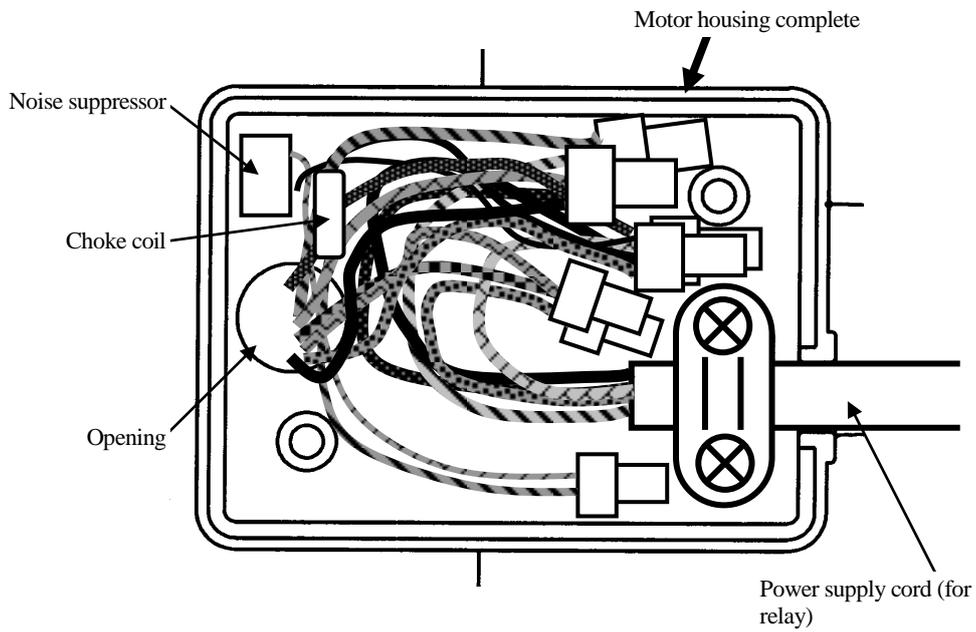
Fig. 121



## 8-2 For countries where High voltage EMI standards are regulated

Fig. 122

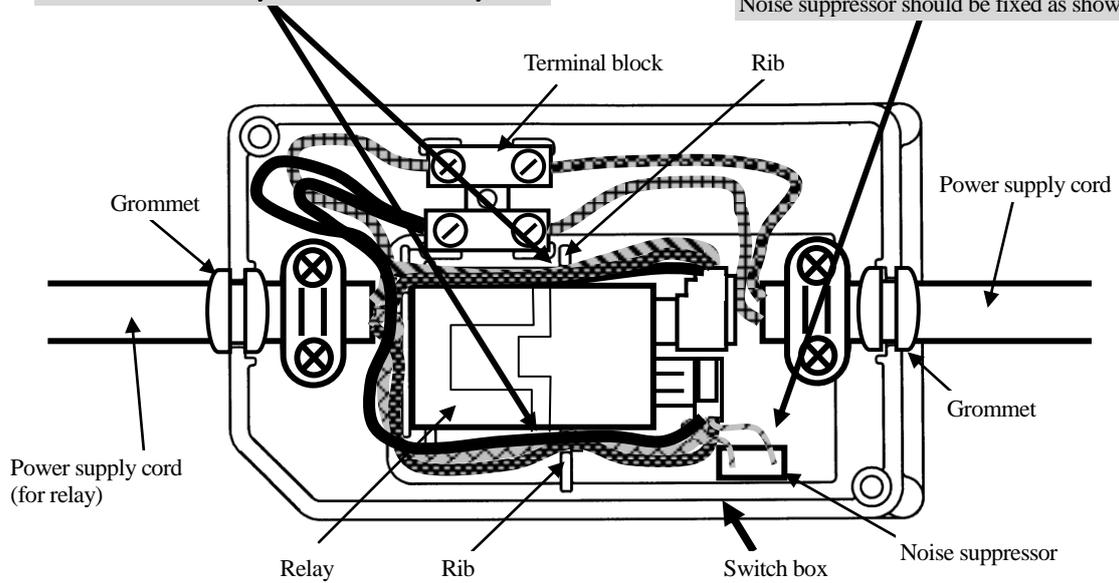
Route Lead wires to Motor housing complete as shown.



Route Lead wires to Switch box as shown.

Pass Lead wires of Relay between Rib and Relay.

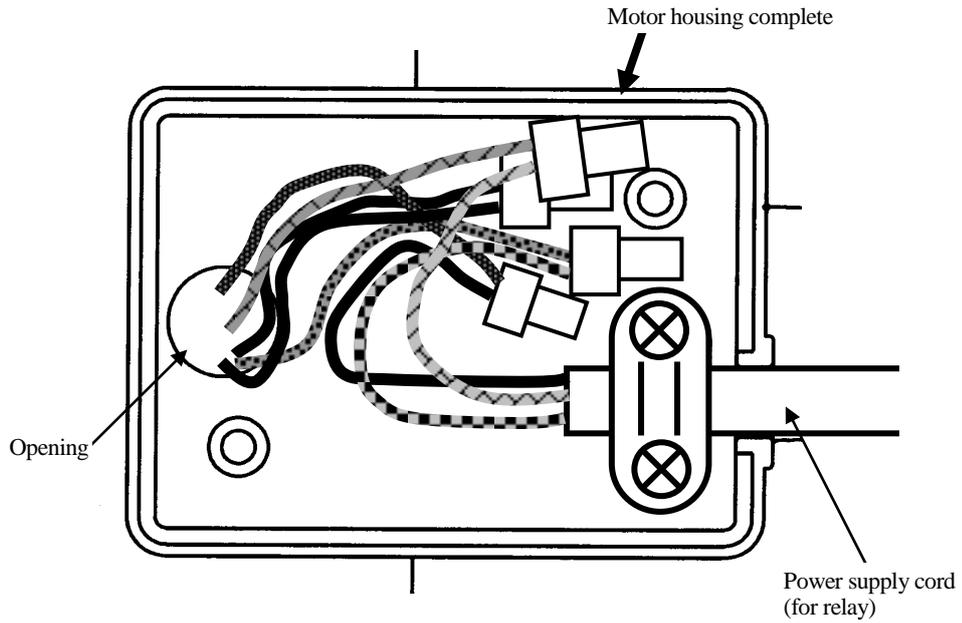
Noise suppressor should be fixed as shown.



8-3 For UK (110V), countries where High voltage EMI standards are not regulated

Fig. 123

Route Lead wires to Motor housing complete as shown.



Route Lead wires to Switch box section as shown.

Pass Lead wires of Relay between Rib and Relay.

Noise suppressor (if used) should be fixed to Switch box as shown.

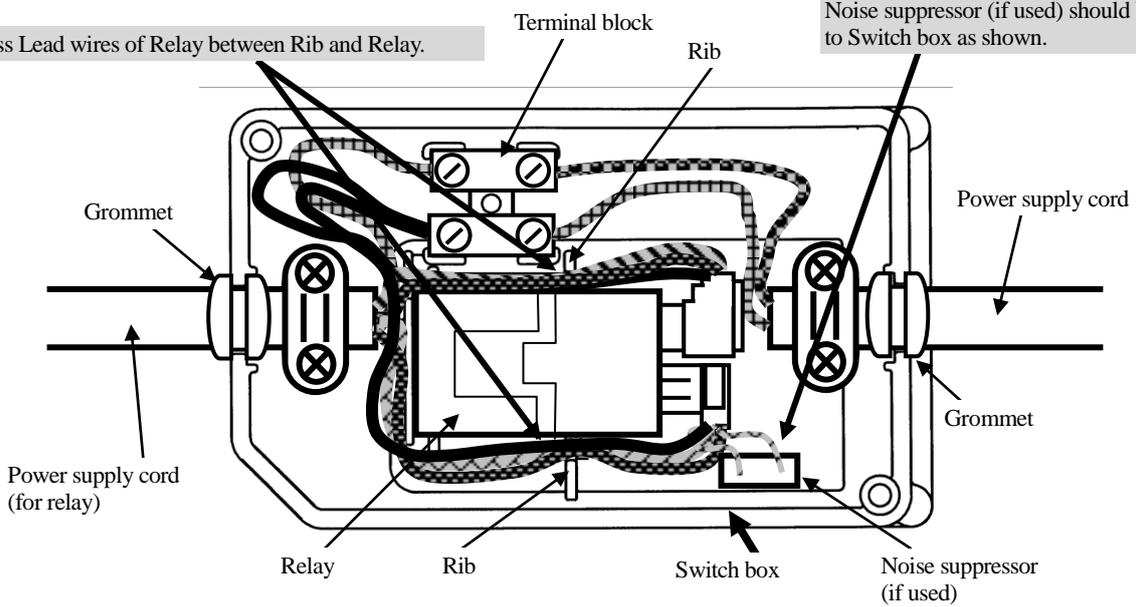
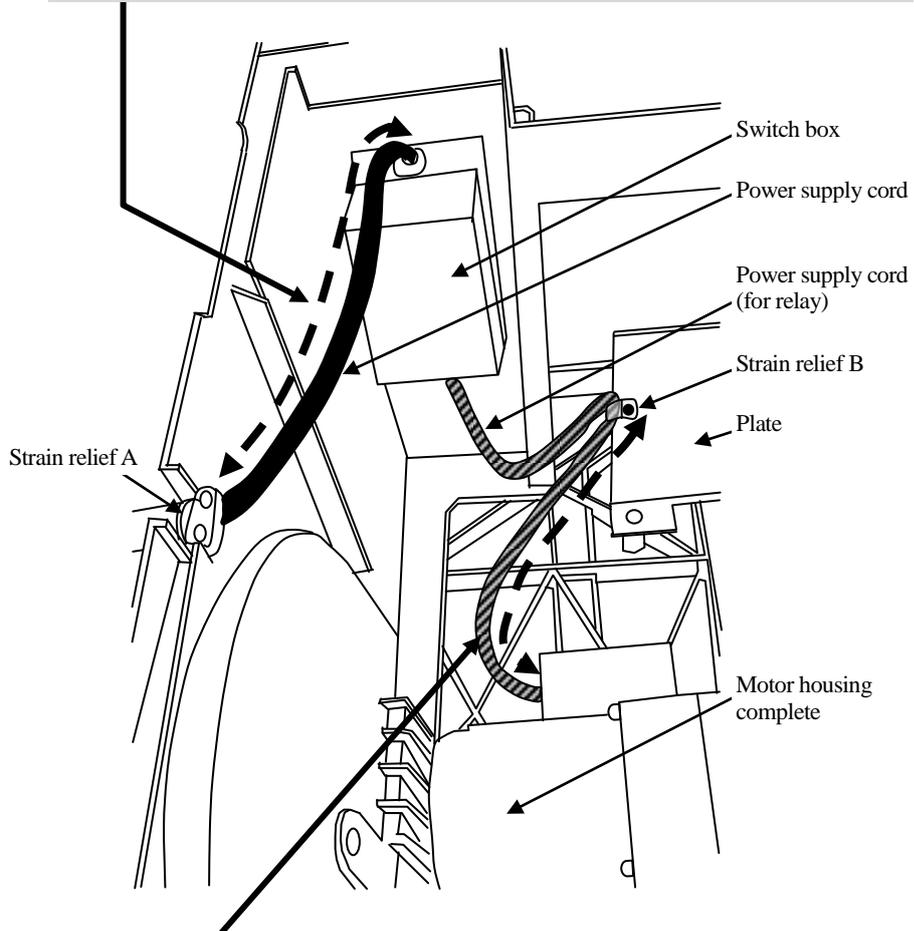


Fig. 124

There should not be slack in the wires of Power supply cord between Switch box and Strain relief A.



Power supply cord (for relay) should be fixed with Strain relief B by following the instructions below.

