INSTRUCTION MANUAL

FOR

CP25 & CP32

PANEL SIZING AND DIMENSION SAWS

Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual.

[ ] PLEASE INSERT SERIAL NUMBER OF MACHINE

Instruction Manual

CP25 & CP32

Panel Sizing and Dimension Saws

FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES
CONTACT: DURHAM 852385 (5 LINES), EXTN:45 SPARES DEPT.
TELEX: 53441 (BURDRM G)

Bursgreen (Durham), Division of Wadkin PLC, Fence Houses,
Houghton-le-Spring, Tyne & Wear, England, DH4 5RQ

HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

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

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

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

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.

2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.

3. Only personnel trained in the safe use of a machine should operate it.

4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.

5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

oOo

WADKIN LTD GREEN LANE WORKS · LEICESTER LE5 4PF · ENGLAND TELEPHONE 0533 769111
and York House Empire Way, Wembley, Middlesex HA9 0PA
Telephone 01-902 7711a Telex: 262210
Telex: 34646 (Wadkin Leicester)
Telegrams: Woodworker Leicester Telex

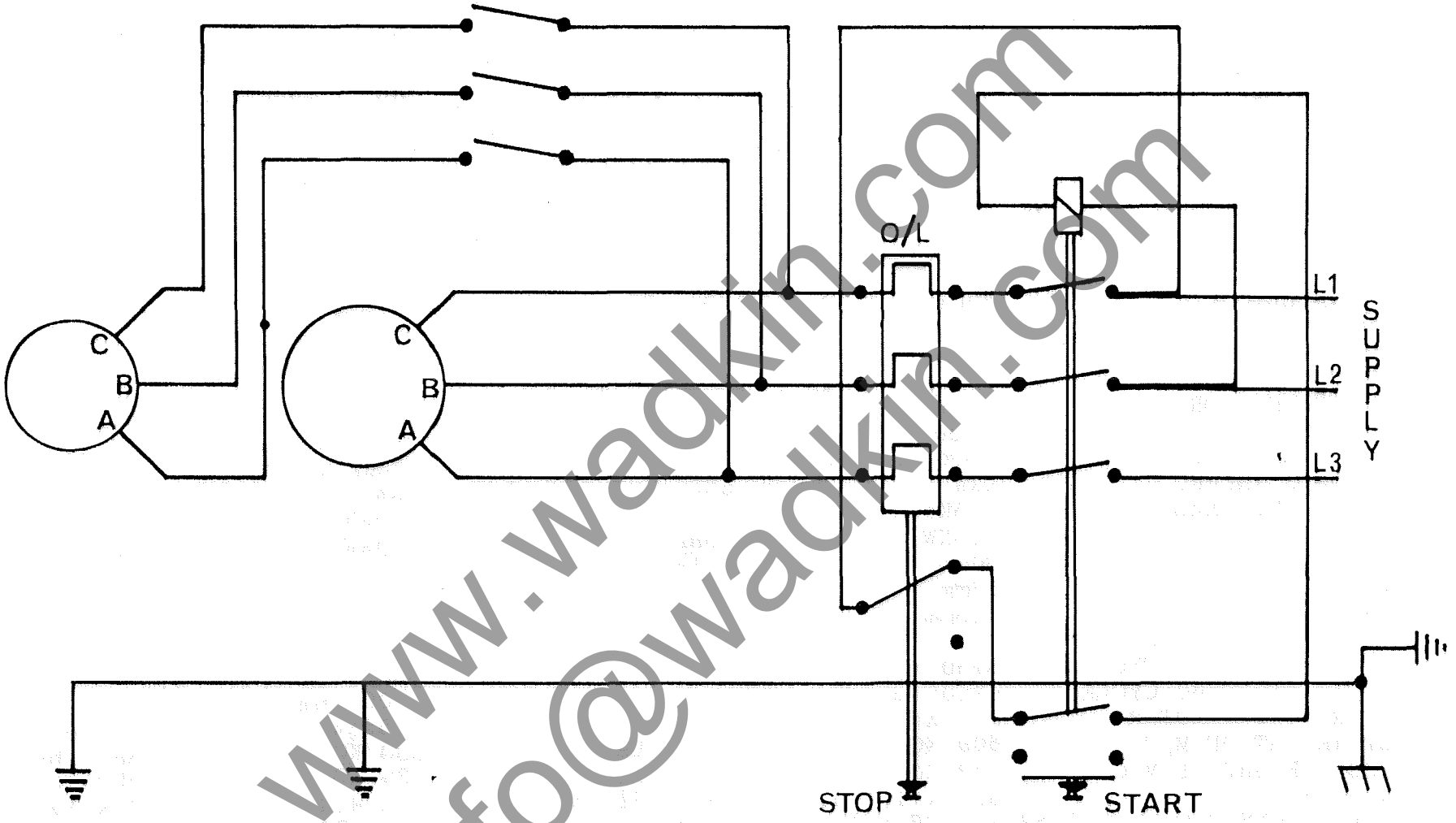
Safety

CAREFULLY READ INSTRUCTION MANUAL WITH PARTICULAR REFERENCE TO THE FOLLOWING INSTRUCTIONS:-

1. SLINGING, i.e. SAFE LIFTING LIMITS FOR SLINGS ETC.
2. INSTALLATION AND FOUNDATION, i.e. SAFE WORKING AREA OF MACHINE AND BOLT POSITIONS, ETC.
3. WIRING DETAILS, i.e. WIRING DIAGRAM AND INSTRUCTIONS FOR SAFE WIRING OF MACHINE.
4. MACHINE CONTROLS AND OPERATING INSTRUCTIONS.
5. SELECT CORRECT SPEED FOR CUTTER EQUIPMENT AND ENSURE CUTTERS ARE SECURELY LOCKED IN POSITION.
6. SET GUARDS CORRECTLY TO COVER CUTTER EQUIPMENT AS MUCH AS POSSIBLE.
7. NOTE START/STOP CONTROL POSITION AND ISOLATOR SWITCH POSITION (IF FITTED) BEFORE OPERATING MACHINE.
8. USE FEEDING DEVICES WHERE POSSIBLE.
9. REFER TO HEALTH AND SAFETY AT WORK BOOKLET No.41 (IN U.K.) FOR SAFETY IN THE USE OF WOODWORKING MACHINERY.
10. DO NOT RUN LARGE SAWBLADES AT HIGH SPEED.

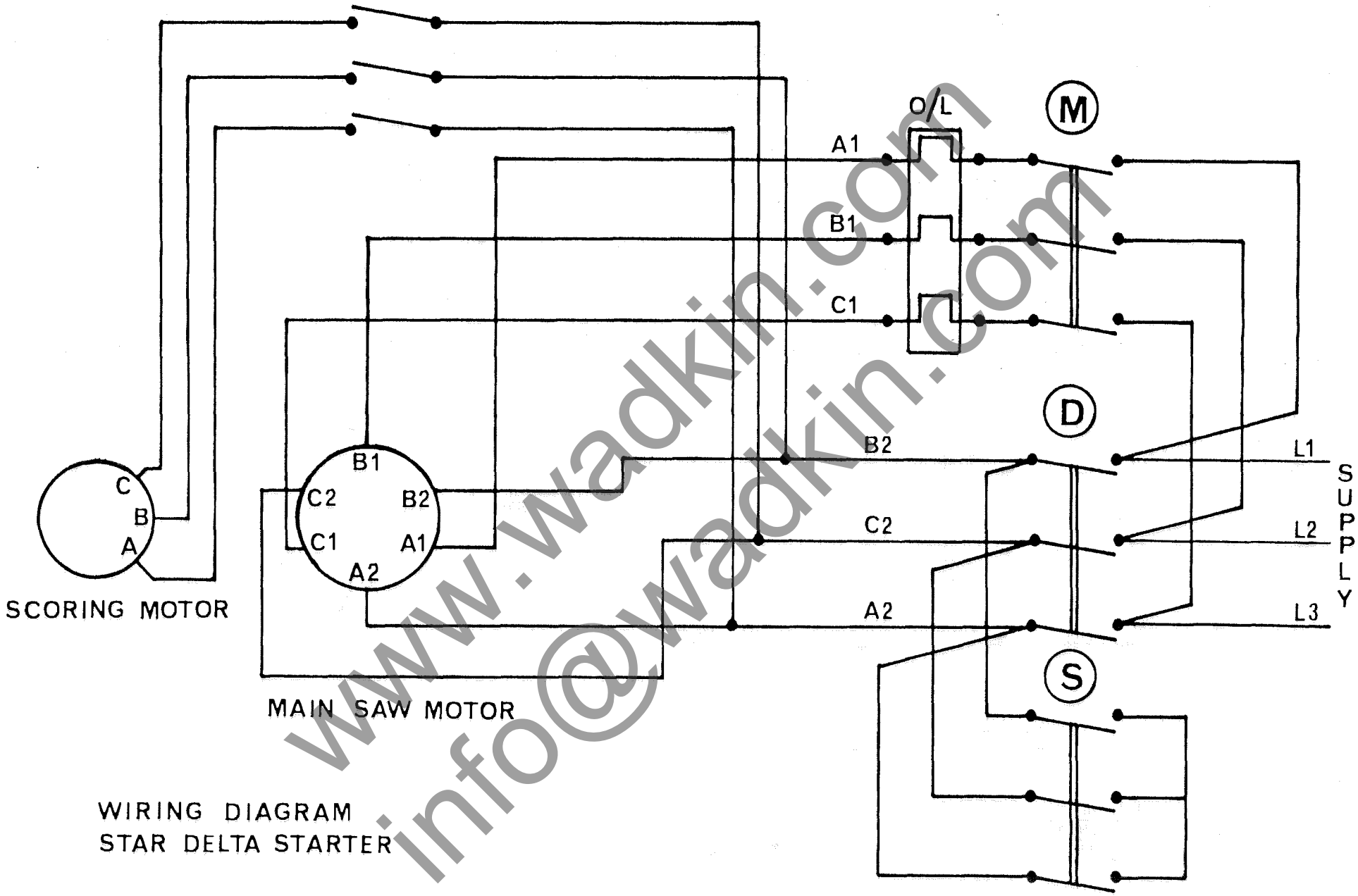
Panel Sizing and Dimension Saws Types CP25 and CP32

SPECIFICATION	CP25		CP32	
FIXED TABLE SIZE	744 x 1067mm	29 x 42in	744 x 1067mm	29 x 42in
SLIDING TABLE SIZE	400 x 2500mm	15¾ x 98in	400 x 3200mm	15¾ x 125in
LENGTH OF CUT USING SLIDING TABLE	2550mm	100in	3200mm	125in
MAX. DISTANCE SAW TO STOP ON CROSSCUT FENCE	3200mm	125in	3200mm	125in
MAX. DISTANCE SAW TO STOP ON MITRE FENCE	655mm	25¾in	655mm	25¾in
MAX. DISTANCE SAW TO RIP FENCE	870mm	34in	870mm	34in
MAX. SAW DIAMETER	400mm	15¾in	400mm	15¾in
MAX. SAW PROJECTION AT 90°	135mm	5.3/8in	135mm	5.3/8in
MAX. SAW PROJECTION AT 45°	95mm	3¾in	95mm	3¾in
MIN. DIA OF SAW BLADE	250mm	10in	250mm	10in
MAX. SAW DIA WITH SCORER	350mm	14in	350mm	14in
SAW SPINDLE SPEEDS 50 CYCLE	2400 & 3400 rpm		2400 & 3400 rpm	
60 CYCLE	2880 & 4080 rpm		2880 & 4080 rpm	
POWER OF MOTOR STANDARD	4KW	5HP	4KW	5HP
POWER OF MOTOR OPTIONAL	5.5KW	7.5HP	5.5KW	7.5HP
	7.5KW	10HP	7.5KW	10HP
SAW BORE DIA ON SPIGOT	30mm	1¼in	30mm	1¼in
SAW SPINDLE DIA	25mm		25mm	
SCORING SAW DIA	105mm	4in	105mm	4in
SCORING SAW SPINDLE SPEED 50 CYCLE	8250 rpm		8250 rpm	
60 CYCLE	9900 rpm		9900 rpm	
POWER OF SCORING SAW MOTOR	0.55KW	0.75HP	0.55KW	0.75HP
APPROX. NET WEIGHT OF M/C	609 KG	1340 lbs	630 KG	1386 lbs
APPROX. GROSS WEIGHT OF M/C	612 KG	1347 lbs	634 KG	1395 lbs
MIN. FLOOR AREA	5.5 x 4.4 m	18 x 14½ ft	7 x 4.4 m	23 x 14½ ft
SHIPPING DIMENSIONS M/C	1.82 x 1.36 x 1.10	71 x 53 x 43 ins	1.82 x 1.36 x 1.10m	71 x 53 x 43 ins
SHIPPING DIMENSIONS TABLE	2.60 x 0.53 x 0.41m	102 x 21 x 16 ins	3.30 x 0.53 x 0.41m	129 x 21 x 16 ins



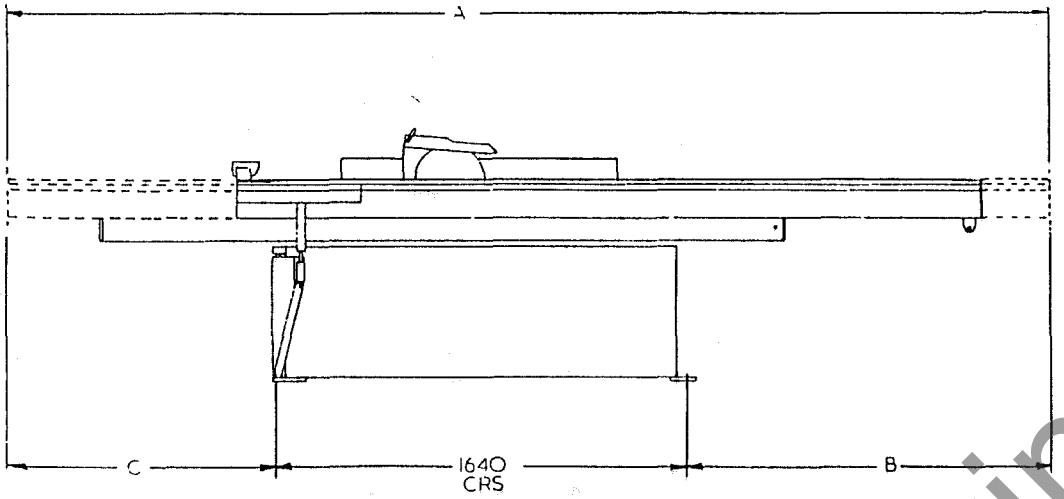
WIRING DIAGRAM
DIRECT ON LINE STARTER

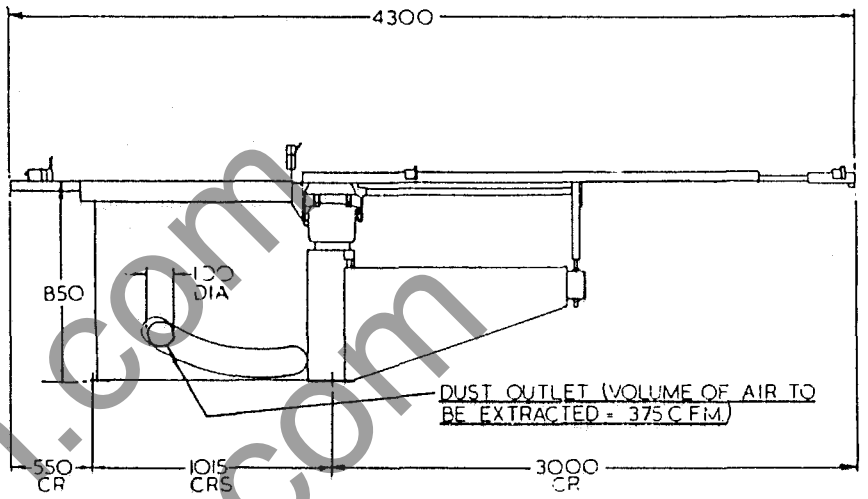
FIG. 2.

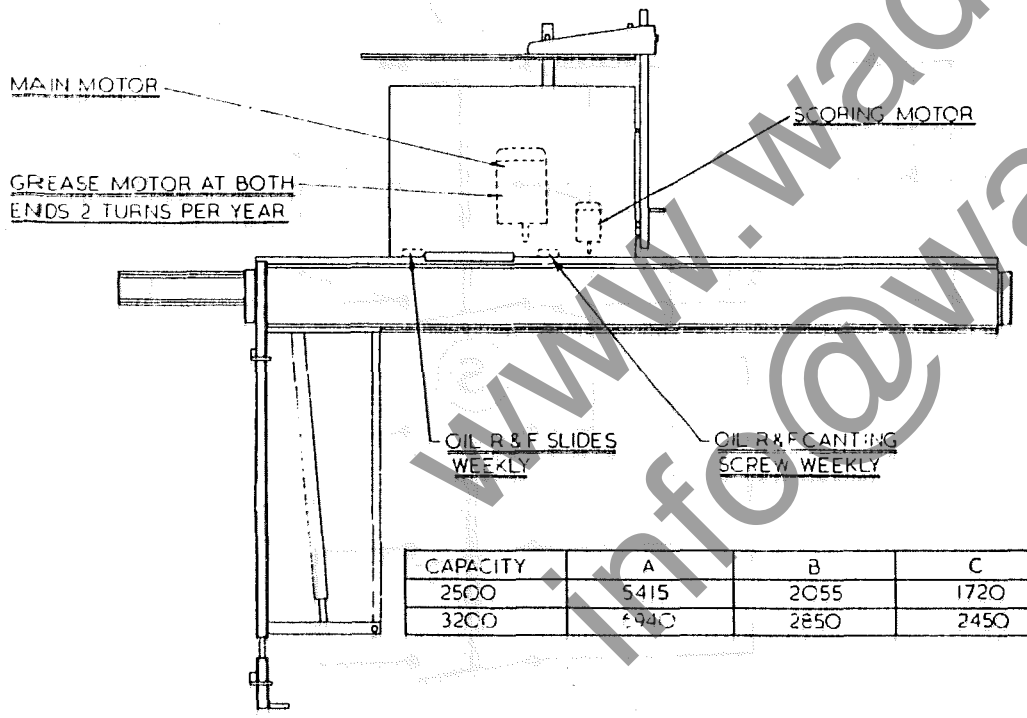


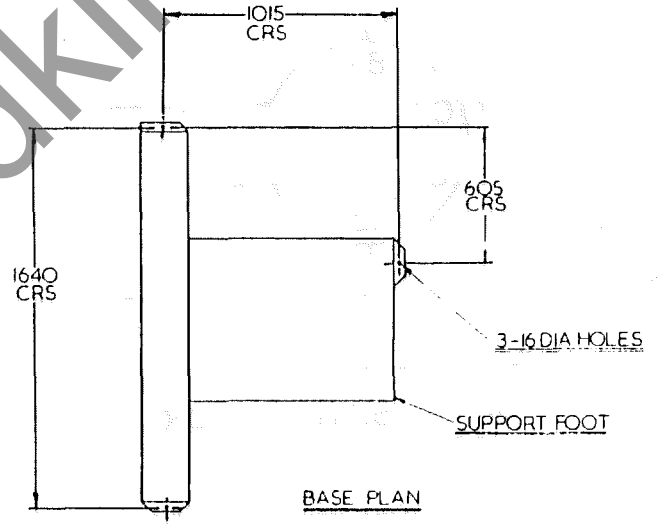
WIRING DIAGRAM
STAR DELTA STARTER

FIG.2A.









BASE PLAN

CAPACITY	A	B	C
2500	5415	2055	1720
3200	6940	2850	2450

SLINGING

ALWAYS USE A SLING WITHIN SAFE WORKING LOAD OF MACHINE WEIGHT.
CP25 - Approx. net weight of machine: 609 KG
CP25 - Approx. gross weight of machine: 612 KG
CP32 - Approx. net weight of machine: 630 KG
CP32 - Approx. gross weight of machine: 634 KG

Attach slings to machine as shown in FIG.3 and FIG.4 ensuring damage will not be caused to machine during slinging operation.

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

CLEANING

Clean protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

FOUNDATION

The machine is front loading and should be sited to allow working room for all capacities. Refer to foundation plan, page 8. Ensure floor is level then mark floor to suit-3-M12 rawlbolts. These bolts are not supplied with the machine but can be supplied at an additional charge.
Drill floor to suit the 3-M12 rawlbolts.
Loosen M10 bolt "A" FIG.4A, on adjustable foot "B", then secure machine to floor by one rawlbolt through each of the 3 feet.
When machine is bolted to floor move adjustable foot "B" down to make firm contact with floor then tighten M10 bolt "A".

WIRING DETAILS

The motor and control gear have been wired in before despatch.
All that is required is to connect the power supply to the isolating switch.
Points to note when connecting power supply:-

1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.

2. It is important that the correct cable is ued to give the correct voltage to the starter as running on low voltage will damage the motor.

3. Check the main line fuses are of the correct capacity. See fuse list inside starter cover.

4. Connect the line leads to the appropriate terminals. See wiring diagram, page 6 or 7.

5. Check all connections are sound.

6. Check the rotation of both motors for the correct direction. if these are incorrect, reverse any two of the line lead connections.

LUBRICATION

All bearings are sealed for life and require no lubrication.
Oil Rise/Fall screw and slides:- once weekly.
Approved Lubricants, See Page 26 .
It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

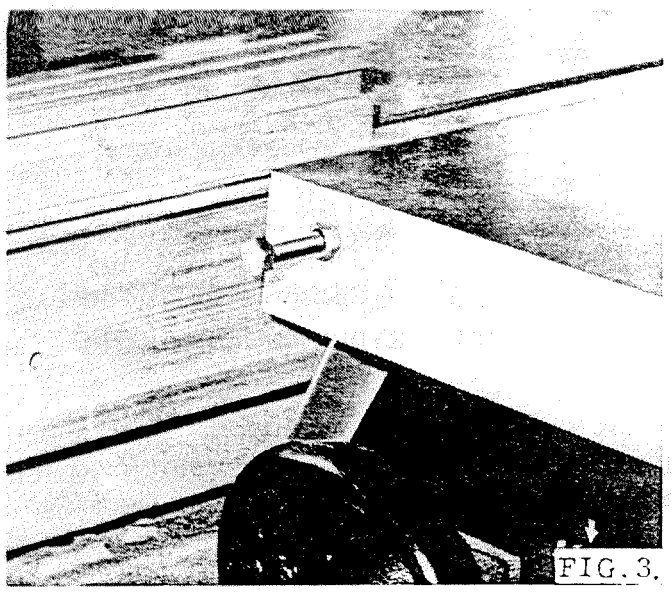


FIG. 3.

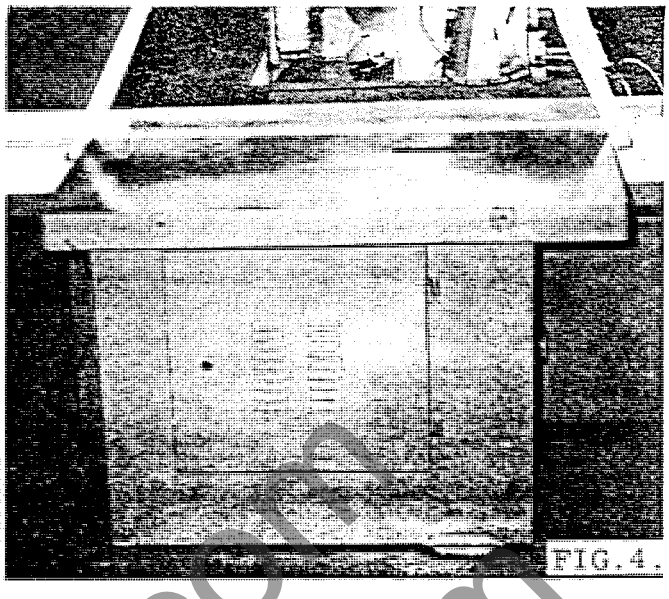


FIG. 4.

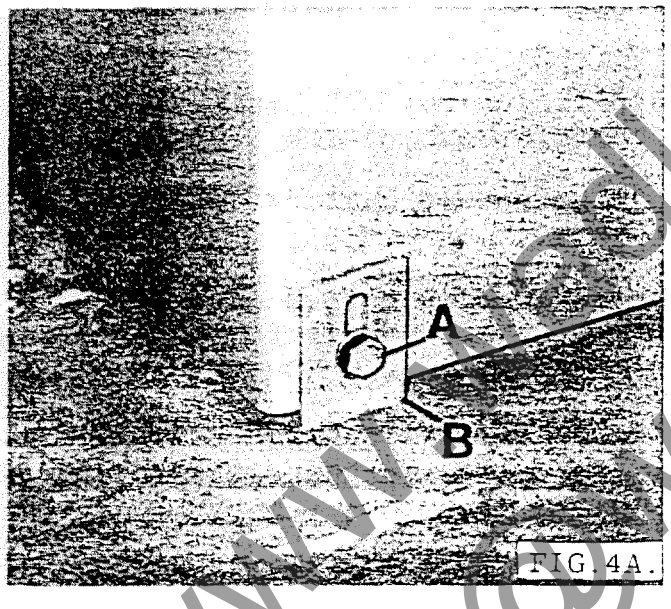


FIG. 4A.

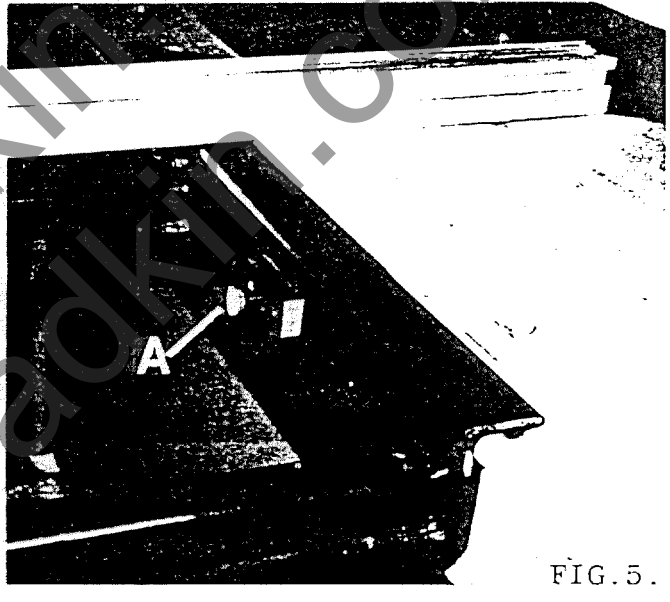


FIG. 5.

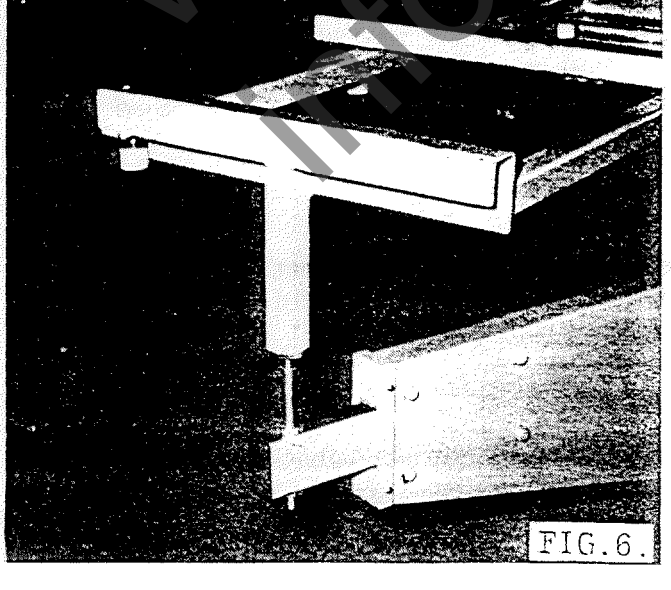


FIG. 6.

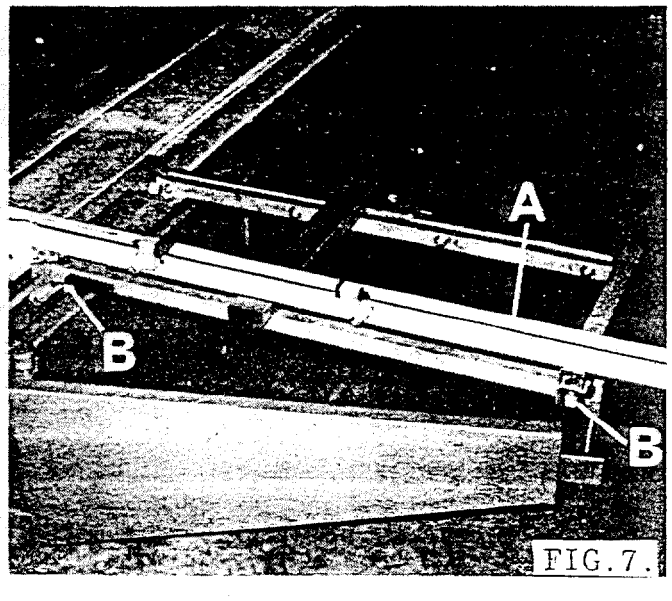


FIG. 7.

ASSEMBLY OF MACHINE

When the machine is for the home market, the extension table, crosscut fence and rip fence are removed, for ease of transportation. These should be assembled as described in SECTION 1.
When the machine is for the export market, the beam and sliding table are packed in a separate case. For re-assembly see SECTION 2, then refer to SECTION 1 for re-assembly of the extension table and crosscut fence. For re-assembly of rip fence refer to SECTION 3.

SECTION 1 To assemble Extension Table to aluminium sliding table, proceed as follows:-

1. Support extension table and locate the 2 extension table mounting blocks in outer slot of aluminium sliding table as shown in FIG.5.

2. Lift outer end of extension table only sufficient to allow swinging arm outer pivot to be located in extension table as shown in FIG.6.

3. Position extension table flush with end of aluminium sliding table as shown in FIG.5, and carefully lock knurled handwheel "A".

NOTE: Overtightening handwheel will damage the aluminium table.

The crosscut fence is fitted to the rear of table and is accurately located in hole at inner end and hole at outer end of extension table secured by 2 handwheels as shown in FIG.7.
To fit the crosscut fence, proceed as follows:-

1. Locate spigots on bottom of fence into the 2 holes in extension table and position crosscut fence "A" as shown in FIG.7.

2. Secure fence in position by handwheels "B".

NOTE: Ensure handwheels are securely locked before using crosscut fence.

SECTION 2 To assemble beam and sliding table, proceed as follows:-

1. Lift beam/sliding table assembly and locate over mounting studs "A" and against stops "B", FIG'S 8 and 9.

NOTE: The beam horizontal alignment stops "B" are pre-set before machine leaves the works.

2. Release sliding table lock (see FIG.18) and move sliding table to give access to beam mounting cover plate. Remove cover plate (Plate shown removed in FIG.10).

3. Slide table and remove cover plate at opposite end of beam.

4. Use box spanner supplied to tighten M16 nut and washer "B", FIG.10, then replace cover plate.

   Use same procedure to secure beam at opposite end of base.

NOTE: The beam level stops "A", FIG.11, are pre-set before machine leaves the works.

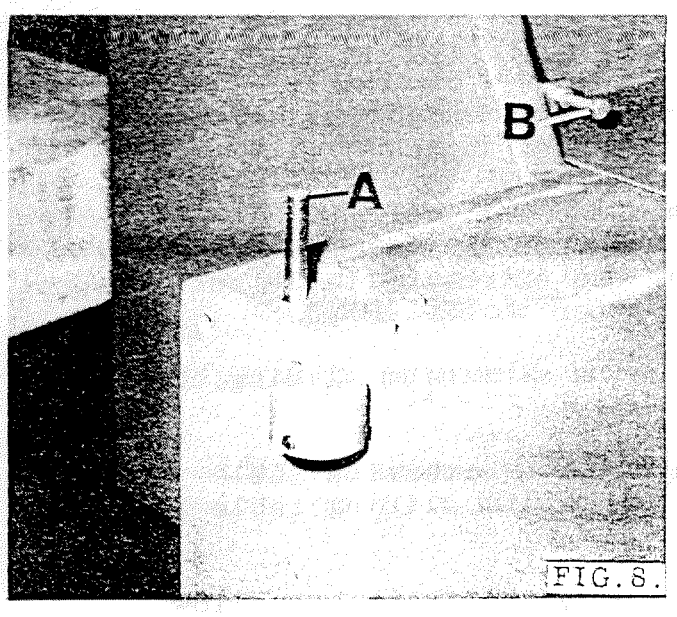


FIG.8.

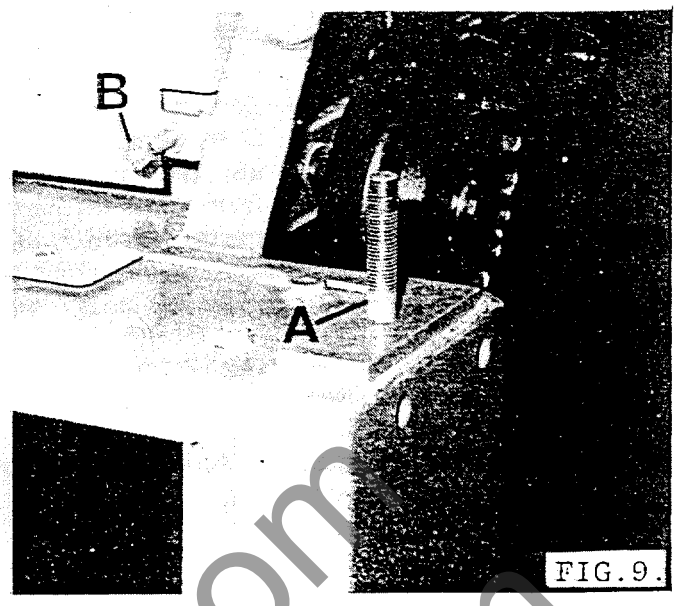


FIG.9.

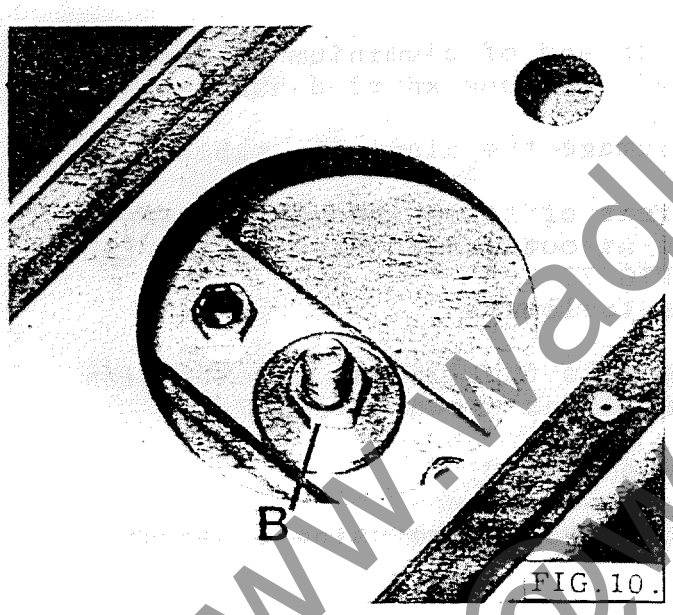


FIG.10.

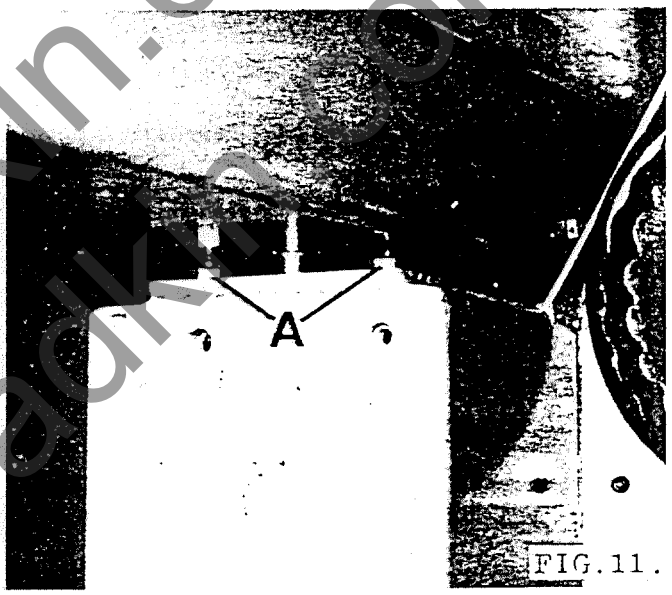


FIG.11.

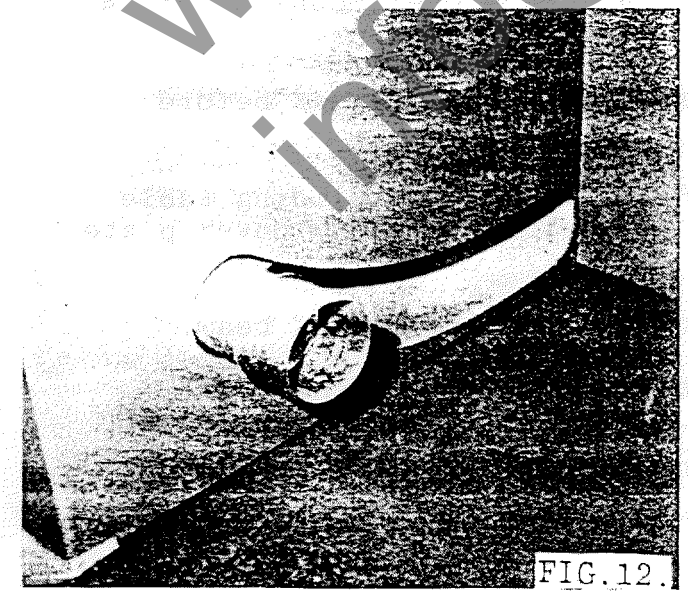


FIG.12.

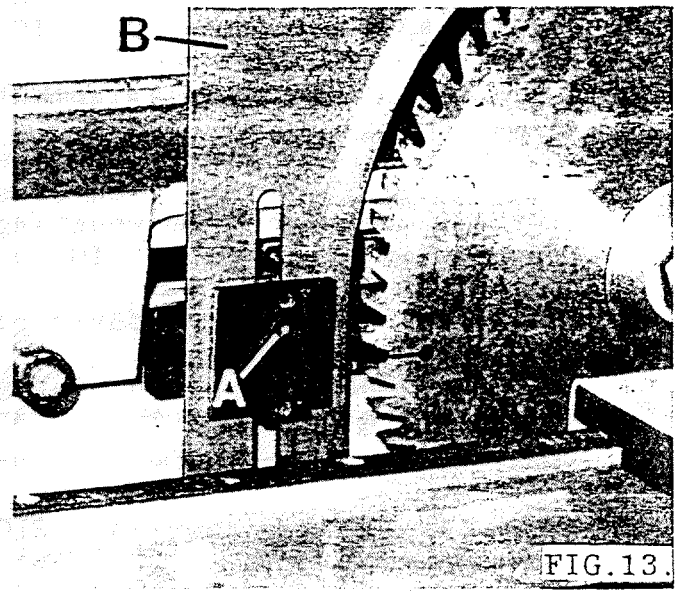


FIG.13.

ASSEMBLY OF MACHINE

SECTION 3 To re-assemble rip fence proceed as follows and refer to FIG.16.

Locate the stud "N" in fence bar "H" into the holes in the front of table. Set level to table top and lock in position with nuts provided. Assemble fence and put stop screw in end of fence bar. Fit fence support "O" to table edge and ensure support is set level to table top.

EXHAUST OUTLET

This is situated at rear of machine FIG.12, and if required can be fitted to a dust exhaust system.

GUARD AND RIVING KNIFE ADJUSTMENT

The riving knife and guard rise and falls with the saw.
The riving knife should be adjusted to the closest practicable distance from the saw teeth.
To adjust the riving knife to this position proceed as follows:-

1. Isolate machine electrically.
2. Move sliding table for access to riving knife adjustment, FIG.13.
3. Loosen M16 socket head screw "A" and move riving knife "B" to correct position.
4. Tighten securely socket head screw "A".

The sawguard should then be adjusted to cover as much of the saw as possible FIG.14.

RISE AND FALL CONTROLS

For rise and fall of saw arbor proceed as follows:-

Release locking handle "A" in FIG.16, and raise or lower the saw arbor by the handwheel "B" to the required position then relock handle "A".

CANTING CONTROLS

The saw cants 45° to the right with positive stops at 90° and 45°.
For canting of saw arbor proceed as follows:-

Release locking handle "C" in FIG.16, and turn handwheel "D" working in conjunction with the canting scale indicated by the pointer "E" to the required saw position. Relock handle "C".

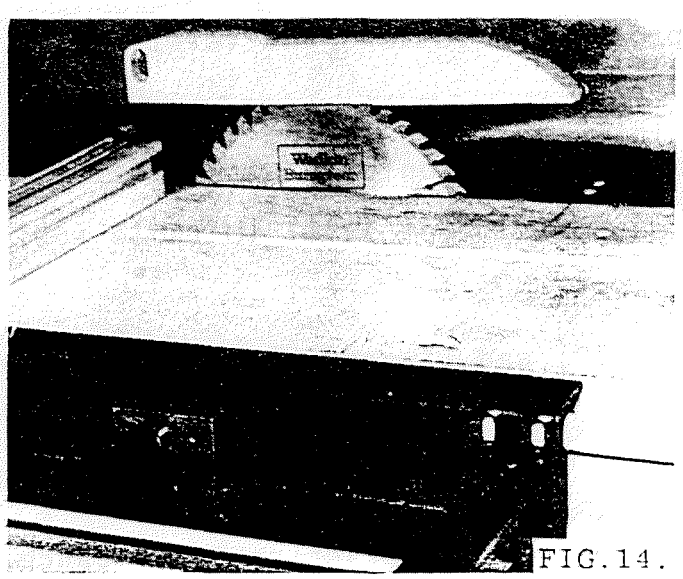


FIG.14.

FIG.15.

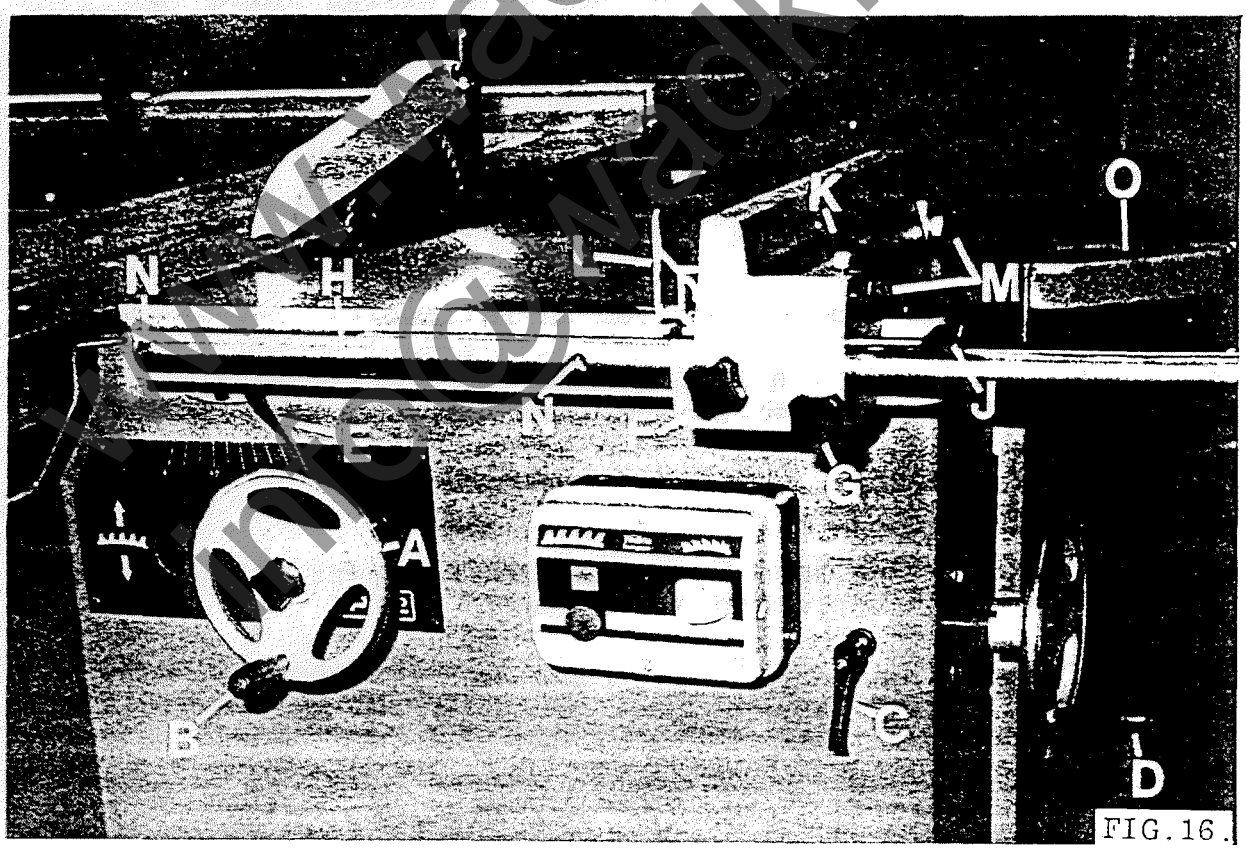


FIG.16.

RIP FENCE CONTROLS

The rip fence slides on a round bar fitted to front of table. Rapid fence adjustment and micro-adjustment are provided with an effective lock.
For rapid fence adjustment, proceed as follows:-

1. Loosen handwheel "F", FIG.16, then disengage pinion from front racked fence bar by pulling handwheel "G" out of fence front bracket.

2. Position fence where required then turn handwheel "F" to lock fence in position. A ripping capacity scale on fence slide bar "H" is indicated by an adjustable pointer "J" located in the fence body and secured by knob "K".

3. For micro-adjustment, the pinion should be engaged in the racked fence slide bar, i.e. handwheel "G" pushed into the fence front bracket.

Fence Plate Positions

The fence plate "L" in FIG.16, has two positions.
Position shown in FIG.16, is for use with deep stock.
Position shown in FIG.15, is for use with faced panels, melamine, veneer, etc.

To change the fence plate position, proceed as follows:-

1 Loosen handwheels "M" in FIG.16, then slide fence plate "L" from fence body.

2. Slide fence plate over the two locking plates to position shown in FIG.15, then relock handwheels "M".

Fence Pointer Adjustment

When the fence plate position has been changed as previously described, the pointer "J" in FIG.16, must be reset accordingly.

To Reset Pointer Proceed as follows:-

1. Loosen handwheel "F", FIG.16, then move fence to a position which would allow a reasonable cut to be taken. Turn handwheel "F" to lock fence in position.

2. Start machine, then feed a piece of timber past the sawblade keeping timber firmly against the fence. Stop machine.

3. Accurately measure the width of timber after then loosen handwheel "K", and set rule pointer "J" accordingly. Relock handwheel "K".

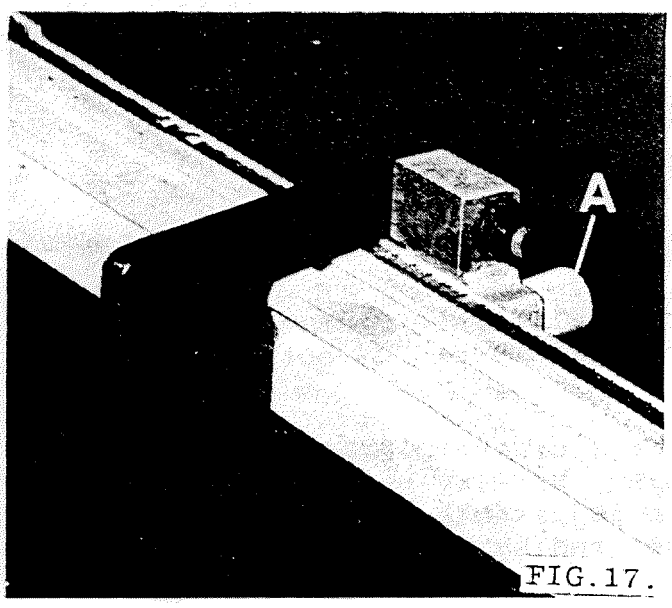


FIG.17.

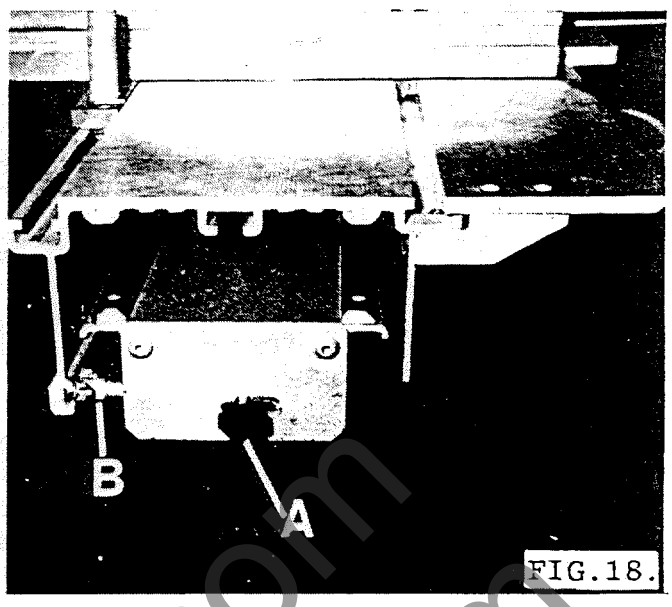


FIG.18.

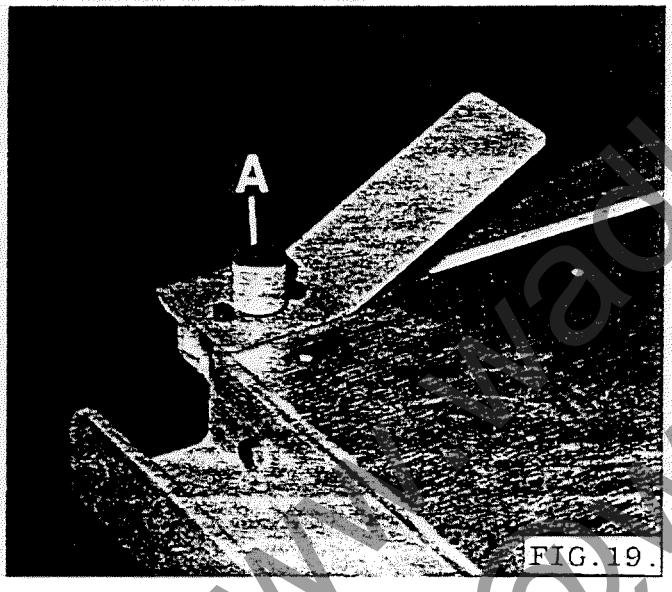


FIG.19.

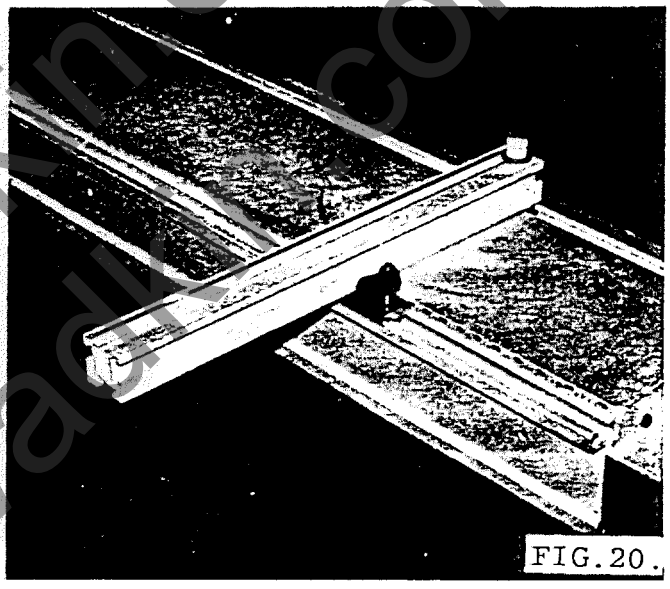


FIG.20.


FIG.21.

FIG.22.

TURN OVER STOPS

2-Turn Over Stops are supplied with machine and are fitted to the crosscut fence as shown in FIG.17.
These stops are fitted to enable timber to be positioned in correct relation to sawblade and for repeat cuts on same size timber.

To move each stop, loosen handwheel "A", position stop as required then relock handwheel "A".

POSITIONING OF SLIDING TABLE CARRIAGE

At the start of each working day push sliding table to maximum forward position then to maximum rear position to ensure sliding table carriage is correctly positioned in relation to table stops. This will avoid "shuffling" of table and carriage.

SLIDING TABLE LOCK

When the machine is used for ripping operations the sliding table can be locked by locating the locking bar "A" between domed nuts "B" as shown in FIG.18.

WANEY EDGE BOARD SUPPORT

The Waney Edge Board Support is shown in FIG.19, and is locked in the sliding table "tee" slot by handwheel "A". This attachment is used to support boards or planks when no square edge is available, to give a straight edge from which future operations can be carried out.

MITRE FENCE

A Mitre Fence as shown in FIG.20, can be supplied for angle cutting or for cutting packs of thin material up to 3 ft square.

MAIN SAW START-STOP

Main saw start-stop buttons "A", FIG.21, are conveniently situated on front of machine.

SCORING SAW START-STOP SWITCH

The scoring saw start-stop switch "B", FIG.21, is conveniently situated on front of machine.

ISOLATOR SWITCH (Optional Extra)

A lockable isolator switch is fitted on below the control boxes shown in FIG.21.

PIVOT ARM SECURING LATCH

The extension table pivot arm, when not in use can be secured to base by pivot arm securing latch "A", FIG.22.

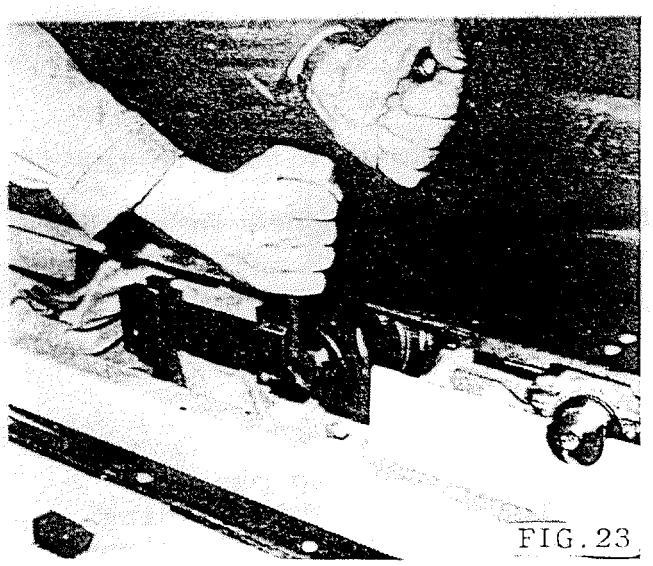


FIG. 23

FIG. 24

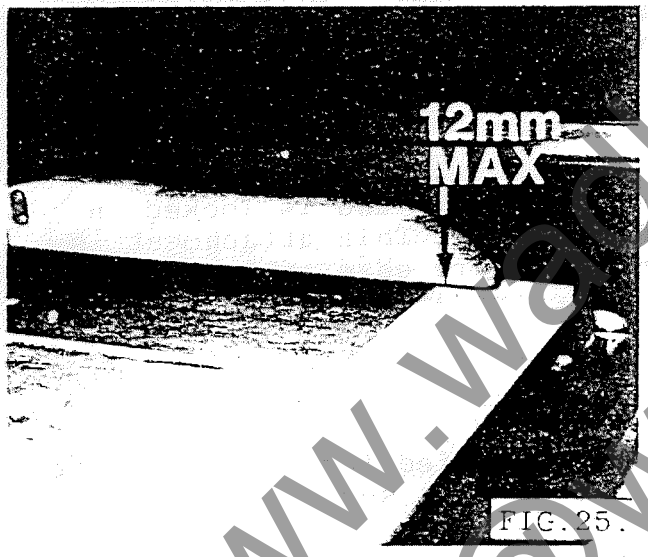


FIG. 25

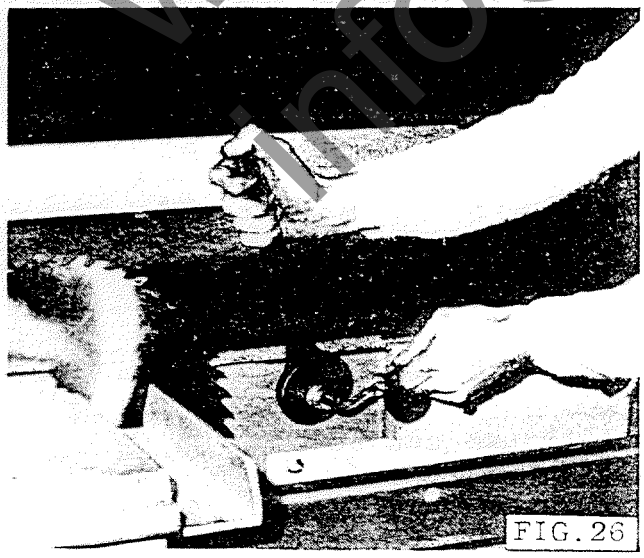


FIG. 26

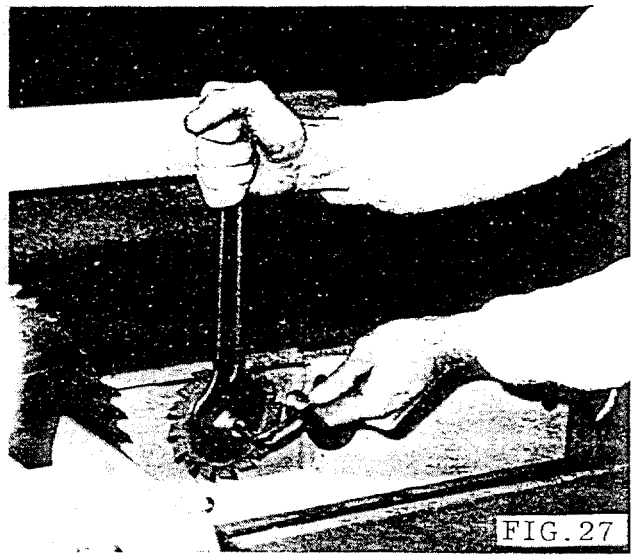


FIG. 27

MOUNTING MAIN SAW BLADE

To mount the main sawblade, proceed as follows:-

1. Isolate machine electrically.

2. Move saw spindle to uppermost position.

3. Move sliding table for access to main sawblade.

4. Locate 8mm allenkey (supplied) in main saw spindle as shown in FIG.23, then remove arbor nut (left hand thread) and front saw flange.

5. Select required blade (350 dia max if scoring is required), and check blade is free from dirt, gum or sawdust, especially where it will be gripped by saw flanges. Check rear saw flange is clean and fit saw on arbor.

NOTE: Saw teeth must point towards front of machine. Check front saw flange is clean and fit on arbor.

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

6. Lock saw securely in position with arbor nut (left hand thread) as shown in FIG.24.

7. Position sawguard depending on thickness of timber to be worked

NOTE: Sawguard must cover blade as much as is practicable. Clearance between sawguard and timber should never exceed 12mm, FIG.25 (Woodworking Machine Regulation 1974 16(3)).

MOUNTING SCORING SAWBLADE

To mount the scoring sawblade, proceed as follows:-

1. Isolate machine electrically.

2. Move sliding table for access to scoring saw.

3 Locate 8mm allenkey (supplied) in scoring saw spindle as shown in FIG.26 and remove scoring saw nut (right hand thread) with spanner supplied.

4 Fit scoring saw with teeth pointing towards rear of machine,FIG.27
NOTE: See FIG.31, for use of shims as fitted between scoring saw blades for correct kerf alingment.

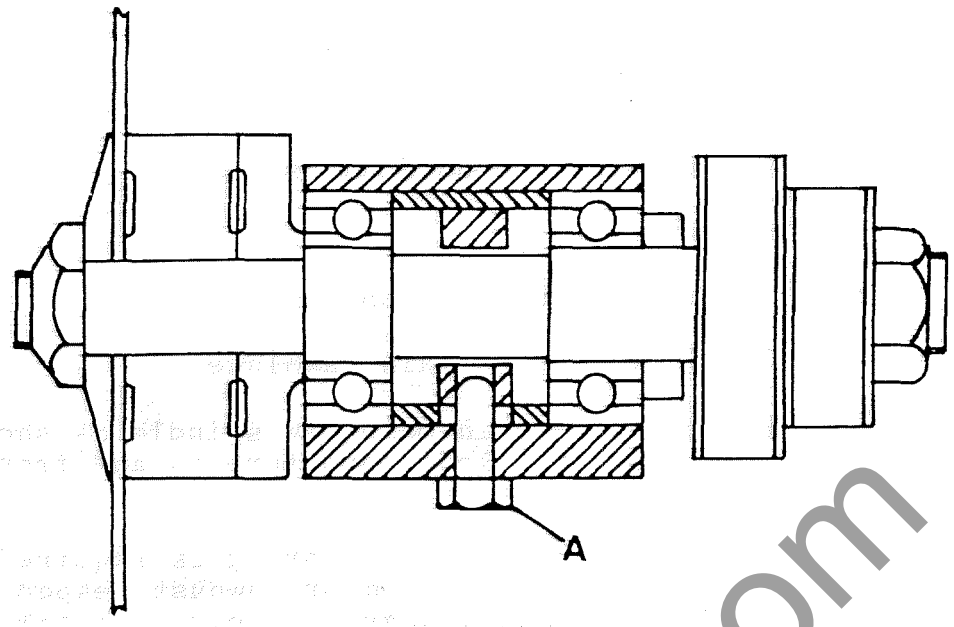


FIG. 28

FIG. 29

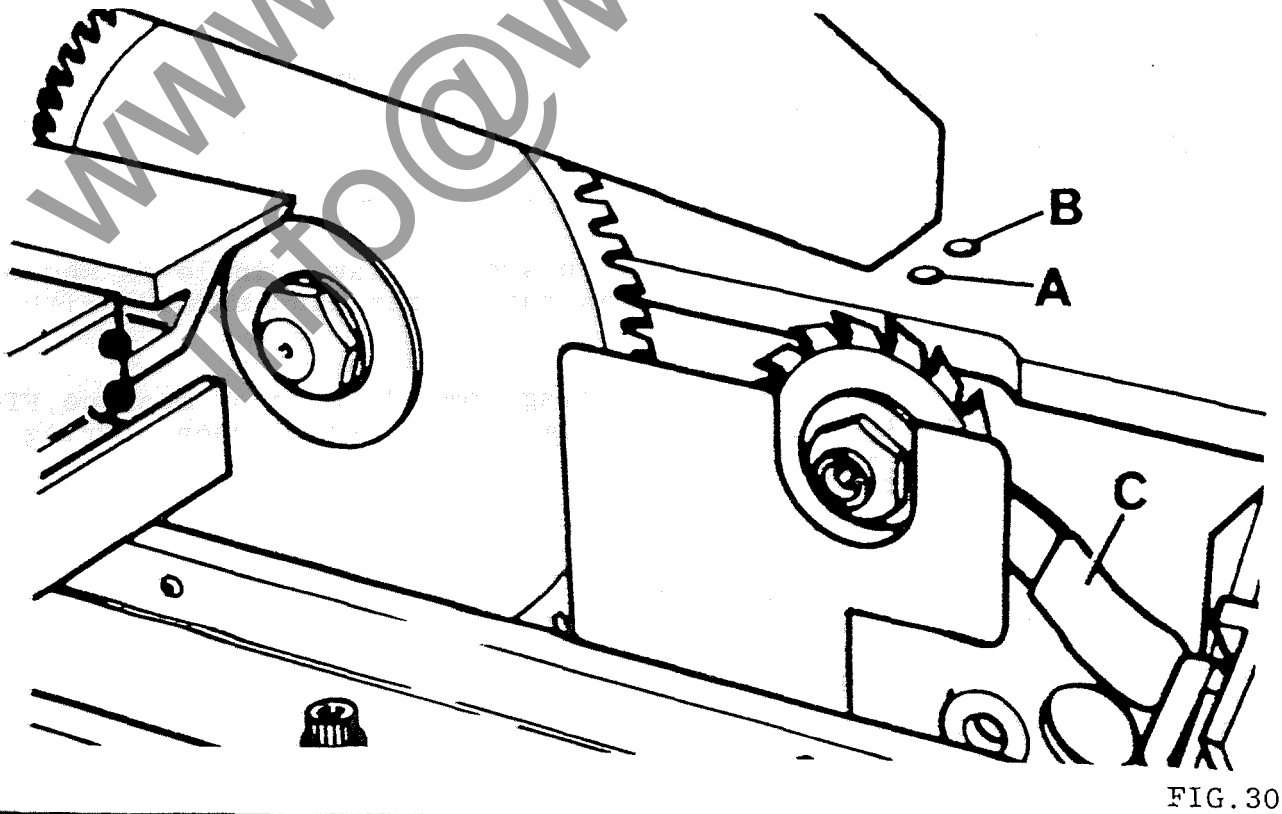


FIG. 30.

SETTING SAW TO RIVING KNIFE

It is most important that the saw and riving knife are in line. To re-set if spindle bearings have been changed or saw is cutting out of line proceed as follows:-

1. Loosen the hexagon head adjuster bolt "A" in FIG.28, and tap spindle (with hide-face hammer) as required, taking care not to damage the threads on spindle ends.
   Place a steel rule along both sides of riving knife to check that saw is central.

2. When set re-tighten the hexagon head bolt "A".

3. To check this setting, feed a short piece of timber from the rear, along both sides of the riving knife. If riving knife is set correctly the blade will cut equal shoulders as shown in FIG.29A and when set incorrectly, unequal shoulders as shown in FIG.29B.

SCORING SAW

Is designed to prevent spelching of all materials including plywood, firbeboard, chipboard, thicker solid plastics and materials having two face layers of veneer, etc.

A twin blade scoring saw must be used with 3 shims of 0.010", 0.005" and 0.003" thick. These shims can be positioned between the blades as required to ensure the scoring saw kerf is identical to, or wider than, the main saw kerf.

Scoring saw lateral and vertical adjustments are provided to ensure accurate alignment to thickness of main saw blade so that brittle materials can be cut with perfect finish on upper and lower edges at both sides of cut.

SCORING SAW ALIGNMENT TO MAIN SAWBLADE

1. Place a steel rule or similar straight edge across main blade and scoring blade to check approximate lateral alignment.

2. Lateral adjustment to scoring blade is by releasing 8mm socket head cap screw lock "A" in FIG.30 (8mm allen key supplied) then adjust blade laterally by 8mm socket head cap screw "B". When set correctly, re-lock socket head cap screw "A".

3. Adjust scoring blade vertically by loosening 8mm socket head cap screw lock "A" in FIG.30, then move blade vertically by lever "C". When set correctly, re-lock socket head cap screw "A".
   Correct vertical adjustment is attained when the scoring saw scores the full underside length of panel.
   NOTE: Some panels may be badly bowed in which case the scoring saw should be vertically adjusted to suit.

4. Proceed to take trial cuts to establish the accuracy of the alignment of the scoring blade with main blade. The correct alignment is shown in FIG.31.

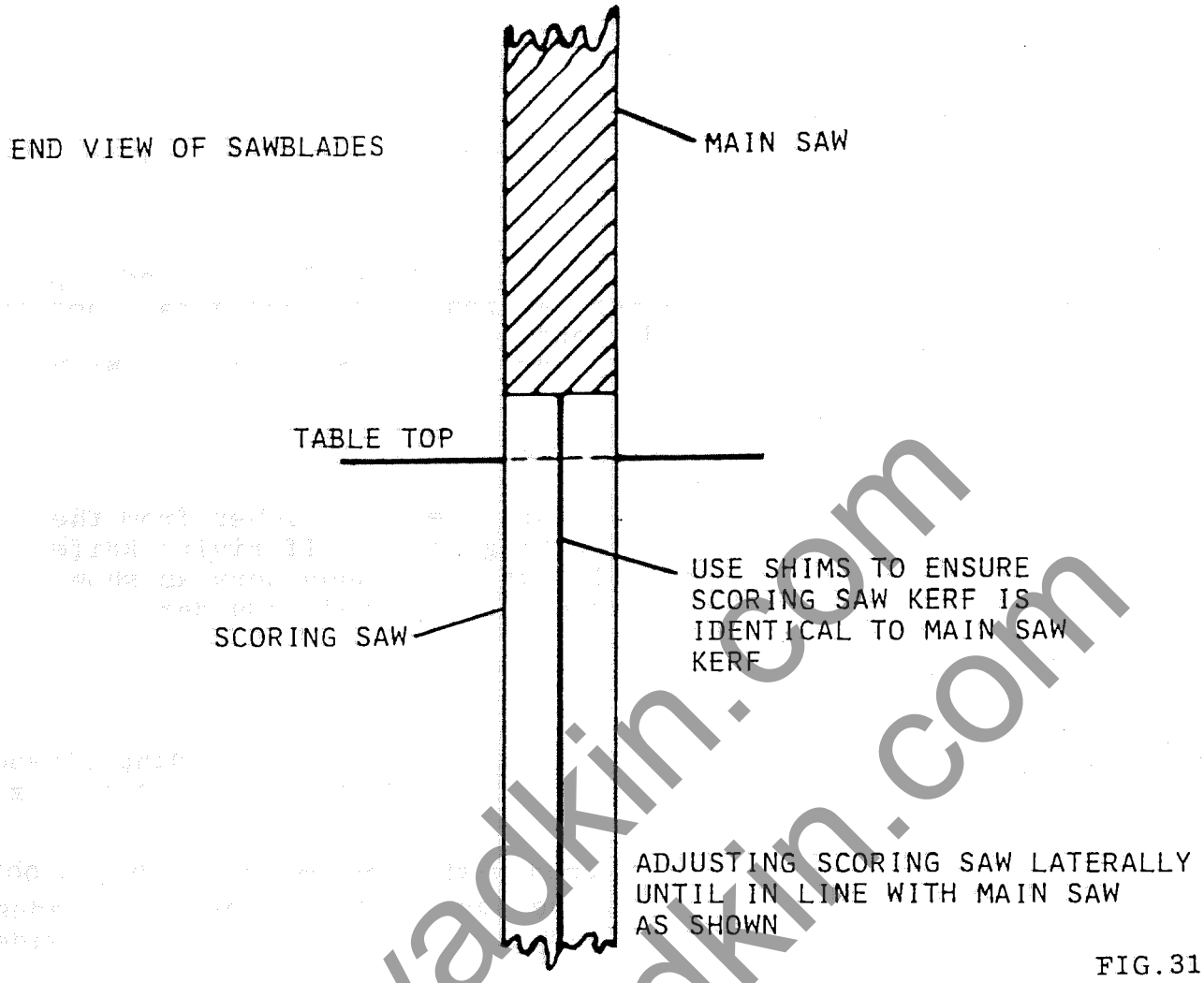


FIG.31.

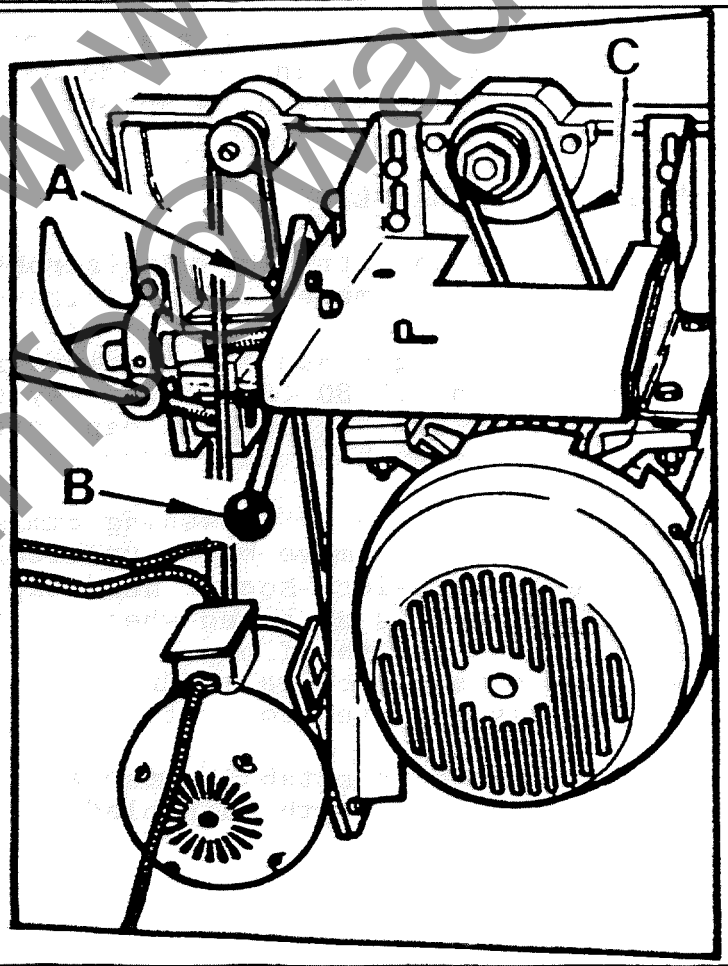


FIG.32.

GENERAL MAINTENANCE

SAW SPINDLE SPEED CHANGING OR BELT CHANGING

The saw spindle is driven by 1 "Poly Vee" belt on a 2 step pulley from the main motor giving speeds of 2400 rpm and 3400 rpm at 50 cycle and speeds of 2880 rpm and 4080 rpm at 60 cycle
To change belt for required speed proceed as follows:-

1. Isolate machine electrically.

2. Open access door at rear of machine.

3. Loosen aerotight nut "A" in FIG.32 and move handle "B" to release belt tension. Hold motor in this position and securely re-tighten nut "A".

4. Change belt "C" to required pulley on spindle pulley and motor pulley. See pulley diagram FIG.33 for required spindle speed.

5. When belt has been change, hold handle "B" in FIG.32 and loosen aerotight nut "A" then pull handle "B" to apply tension to belt.

NOTE: Belt tensioned too tight will cause bearing failure.
Belt tensioned too slack will cause belt slip.

6. When belt is tensioned correctly securely tighten aerotight nut "A".

7. Close access door at rear of machine.

IMPORTANT: DO NOT RUN LARGE SAWBLADES AT HIGH SPEED.

BELT CHANGING ON SCORING MOTOR

To change belt on scoring motor, proceed as follows:-

1. Isolate machine electrically.

2. Open access door at rear of machine.

3. Pivot motor by hand to change belt.

NOTE: Weight of motor tensions belt.

4. Close access door at rear of machine.

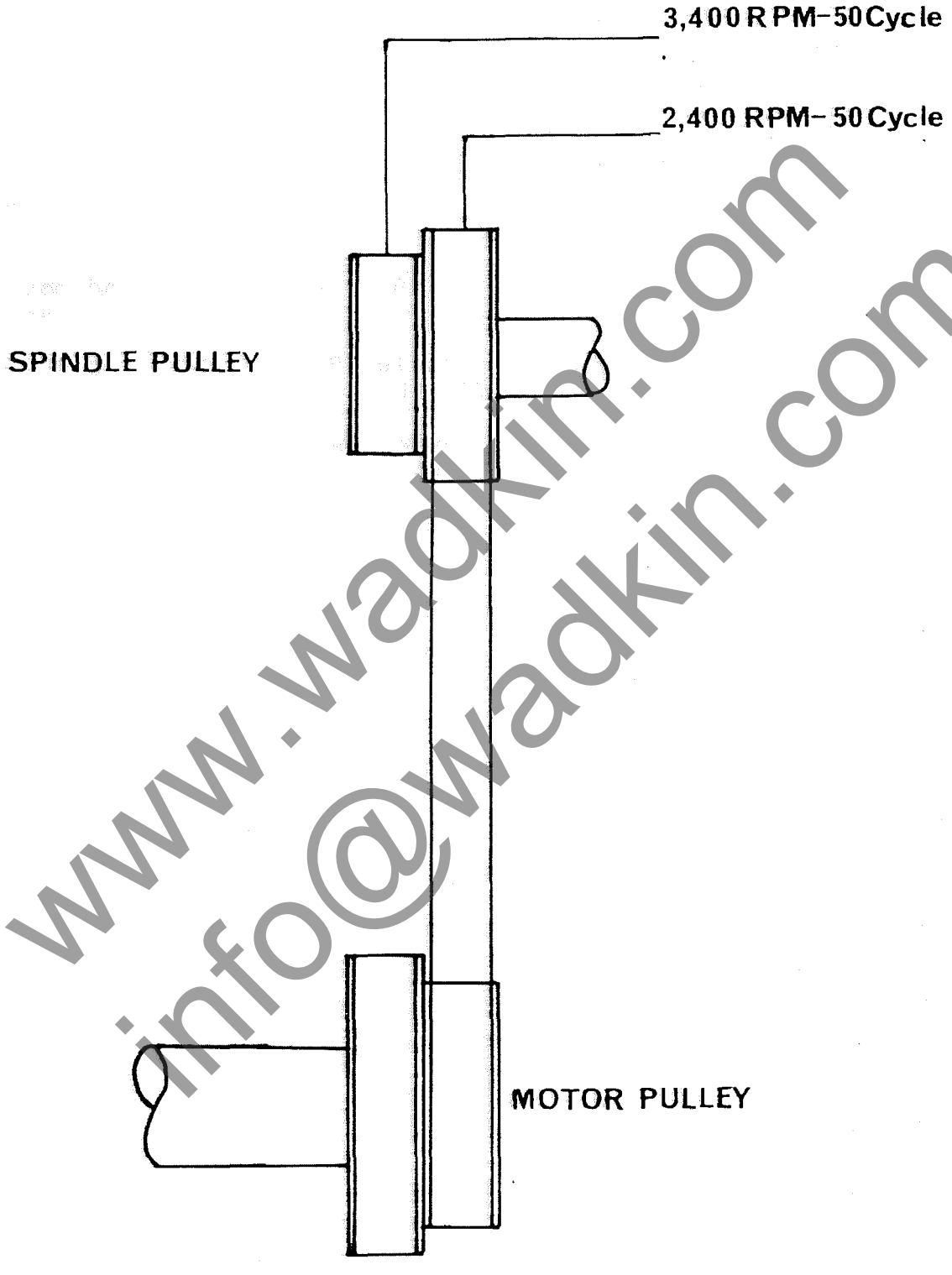


FIG.33.

SAFETY SECTION

All safety precautions should be taken to comply with relevant safety regulations, ie Woodworking Machines Safety Regulation 1974 - No. 903 (Great Britain). Always adjust the riving knife and guard to protect as much of the saw as is possible. These adjustments have been previously described.

Do not use sawblades at higher than recommended speed. When changing sawblades, belts or any other maintenance or lubricating etc., always isolate the machine electrically. Use a wood push stick as much as practicable when feeding timber, to avoid accidents.

SAWBLADES

For best results we recommend the purchase of sawblades from Bursgreen (Durham). All blades have a kerf of 3.2mm.

Sawblades available:-

400mm diameter x 30mm bore alloy rip sawblade B-S-239
400mm diameter x 30mm bore alloy crosscut sawblade B-S-240
300mm diameter x 30mm bore TCT sawblade B-S-242
105mm diameter x 20mm bore TCT split scoring sawblade B-S-230
Do not use sawblades at higher than recommended speed.

The material should be fed past the sawblade at a reasonable speed otherwise overheating of the balde will occur causing cracks. The machine is available with a range of 2 speeds up to 3400 rpm at 50 cycle and 4080 rpm at 60 cycle.

As a guide, the normal peripheral speed for alloy sawblades is approximately 10000 ft/min (3048m/min and for TCT sawblades approximately 12000 ft/min 3658m/min).

BEARINGS

6 - SKF6202RS	Sliding Table
1 - SKFSY20LX	Rise and Fall
1 - SKFFYTB205D	Trunnion
2 - SKF62062RS	Saw Spindle
4 - SNR62002RS	Pivot Arm
2 - SNR62032RS	Pivot Arm
2 - SNR60032RS	Scorer
2 - Oilite Bushes	Rip Fence
2 - FBM20 Headed Oilite Bushes	Pivot Arm

BELTS

1 - Poly-V-Belt 300J8 (50 & 60 cycle)
1 - Poly-V-Belt 460J4 (50 & 60 cycle)

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

EXTENSION TABLE (OPTIONAL EXTRA) FOR CP25 AND CP32 PANEL SAWS

Parts supplied for extension table are as follows:-

1 - Extension fence slide bar	No. B-1041/170
1 - Tie bar	No. P32/121
2 - Extension table support bar	No. P32/120
2 - Tee filboe for extension table	No. S25/99
2 - Extension table support leg	No. S25/84
2 - Extension table support foot	No. S25/85
4 - 20 mm conduit clamps	
4 - M10 x 25 long hexagon head bolt	
1 - M10 locknut	
2 - M10 x 10 long hexagon head bolt	

To fit extension table proceed as follows:-

A. Secure 2 support bars "A", Photo 1, to main table as shown.

B. Secure fence bar "A", Photo 2, to main table as shown.

C. Secure tie bar "B", Photo 2, to fence bar "A" with support legs in position shown.

D. Make extension table from plywood to sizes shown on drawing below.

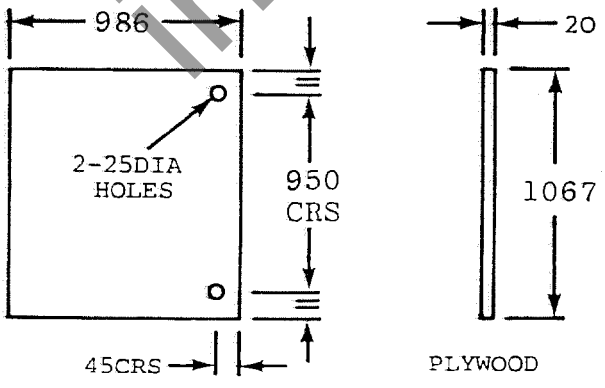
E. Position table as shown in Photo 3, and secure with clips provided as shown in Photo's 4, 5 and 6.

NOTE: Ensure that the 2 holes in outer end of wood table are located over the tee filboes as shown in Photo's 4 and 5.

F. Loosen clip screws on the 2 support bars "A", Photo 6, then loosen support bar securing nuts "B" and turn support bar eccentric adjusting nuts "C" until wood table is level with main table.
Re-lock clip screws and securing nuts "B".

G. Set outer end of wood table "A", Photo 3, level with machine table by lossening bolts in feet "B", moving height of legs "C" as required then relocking bolts in feet "B".

H. When set, secure all bolts and screws.



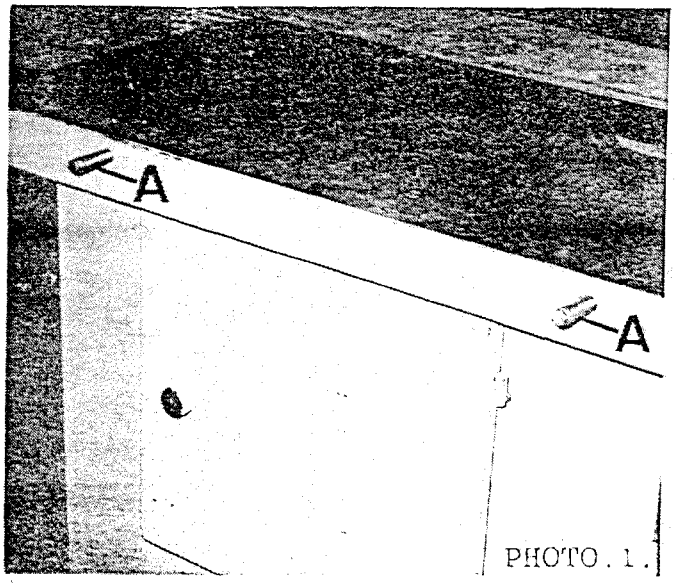


PHOTO . 1 .

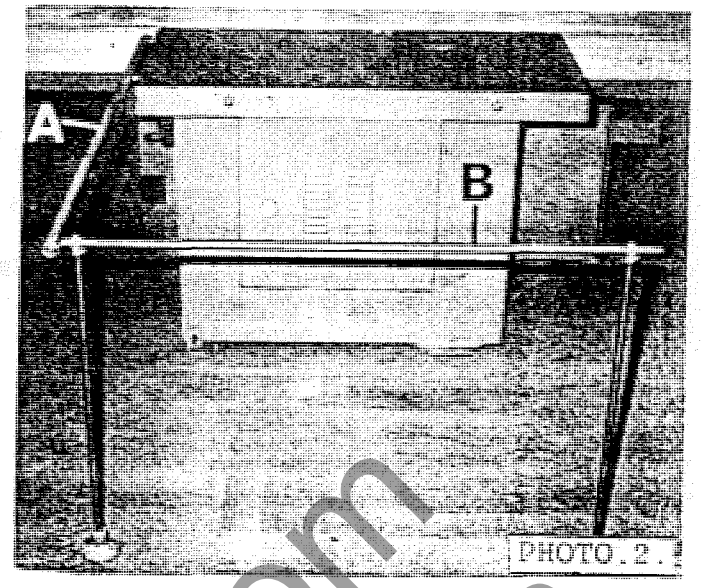


PHOTO . 2 .

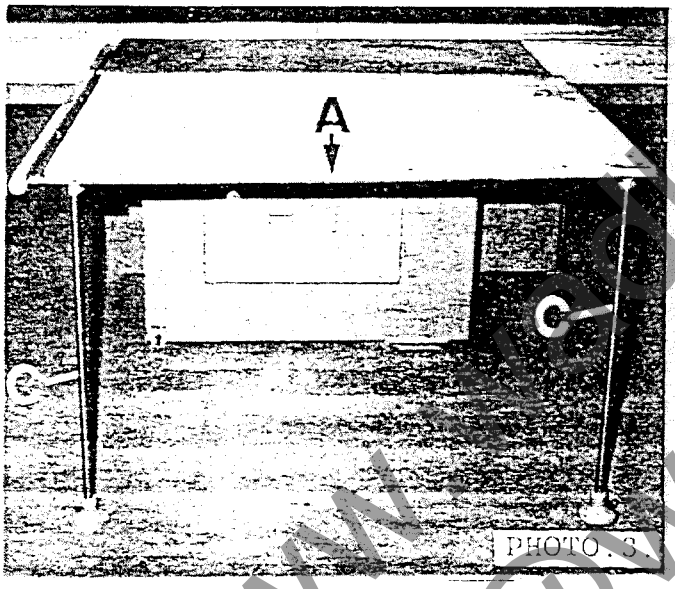


PHOTO . 3 .


PHOTO . 4 .

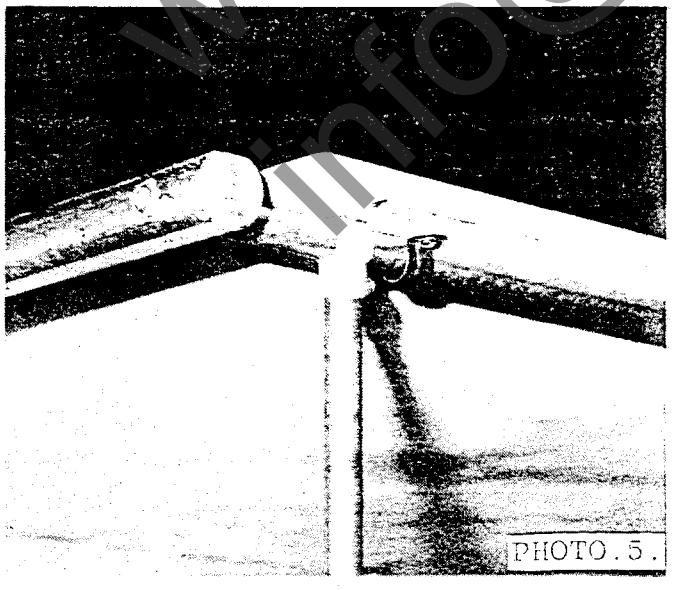


PHOTO . 5 .

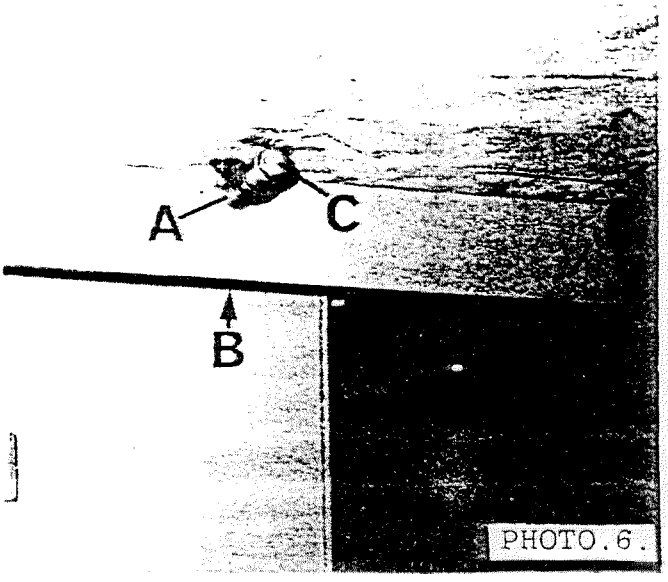
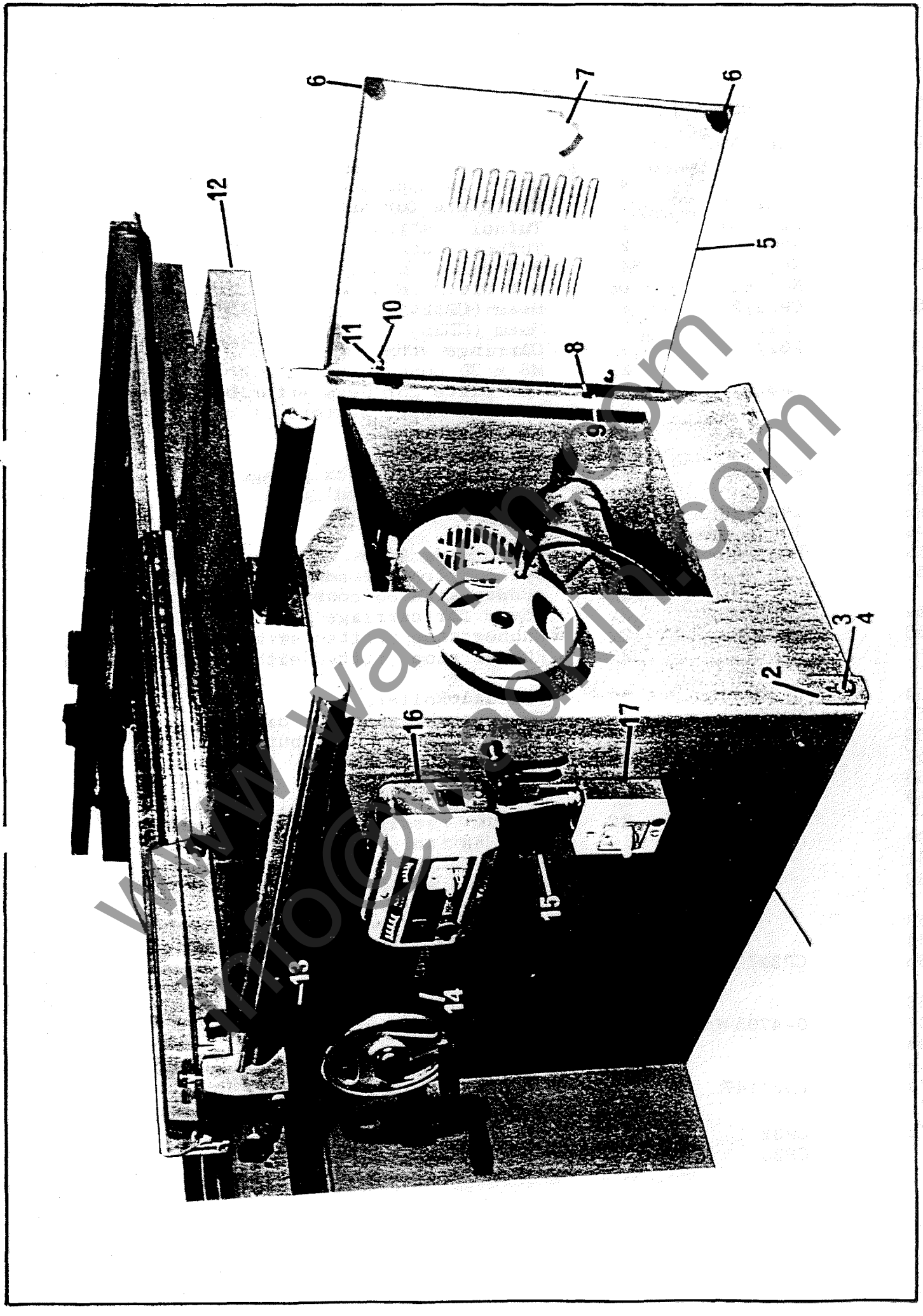


PHOTO . 6 .

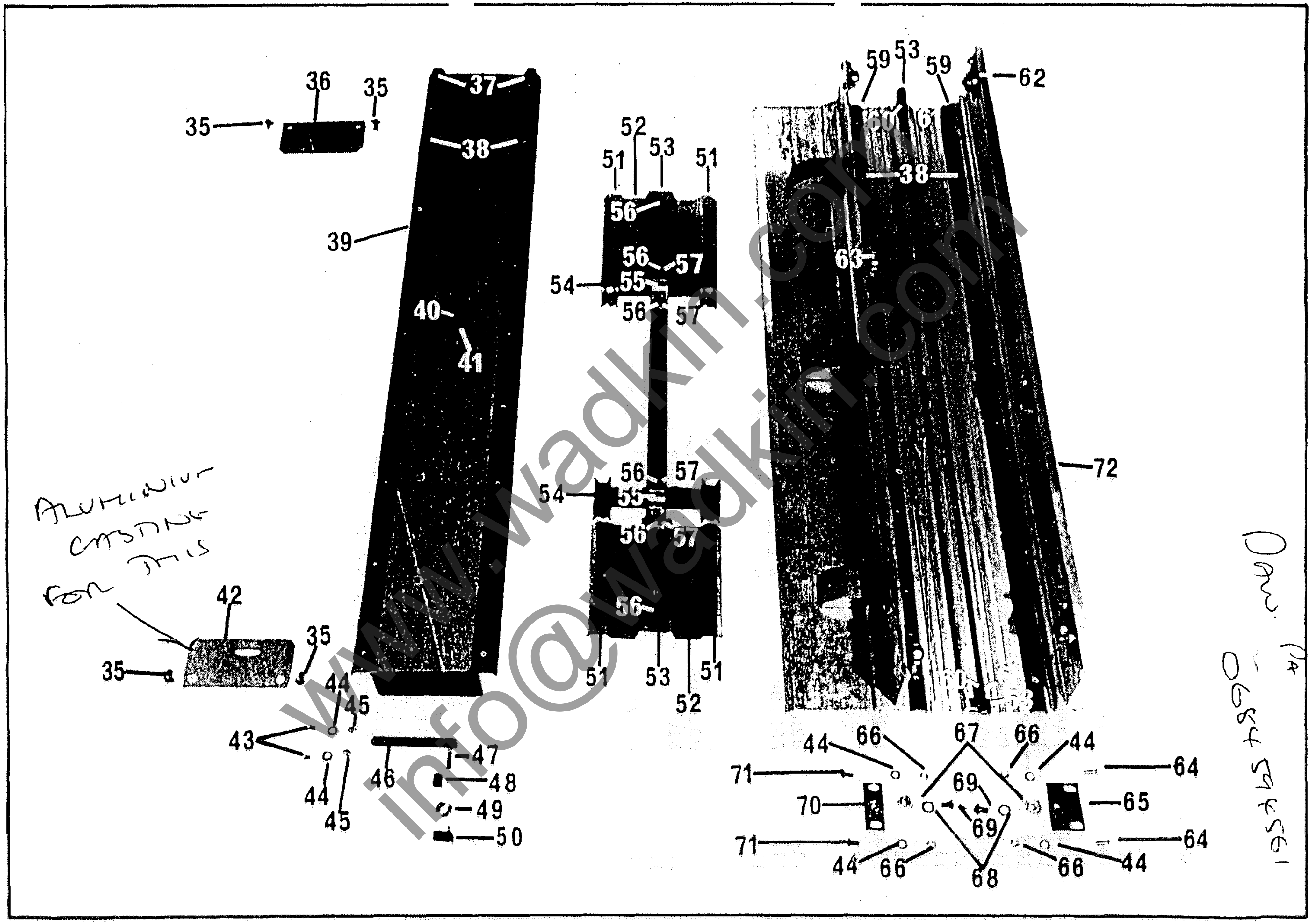
BASE ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
1	CP32/1	1	Base
2	P32/107	1	Adjustable Foot
3		1	M10 x 30 Long hexagon set screw
4		1	10mm Washer
5	CP32/6	1	Door
6	BRA/69	2	Rubber Stops
7	EM/108	1	Cam for door
8	1085/321	4	Hinge for door
9	1085/366	2	Pin for hinge
10	P32/255	4	Door hinge stud
11		8	M8 Locknuts
12	CP32/3	1	Main Table
13	1073/299	1	Canting pointer
14	CP32/8	1	Front plate
15	A-S-333	1	Machine number plate
16	1247ADS	1	MEM starter with scorer switch T1-1 (415-3-50)
	1237ADS	1	MEM starter with scorer switch T1-1 (380-3-50)
	1617ADS	1	MEM starter with scorer switch T1-1 (22o-3-50)
17		1	Isolator (fitted as extra)



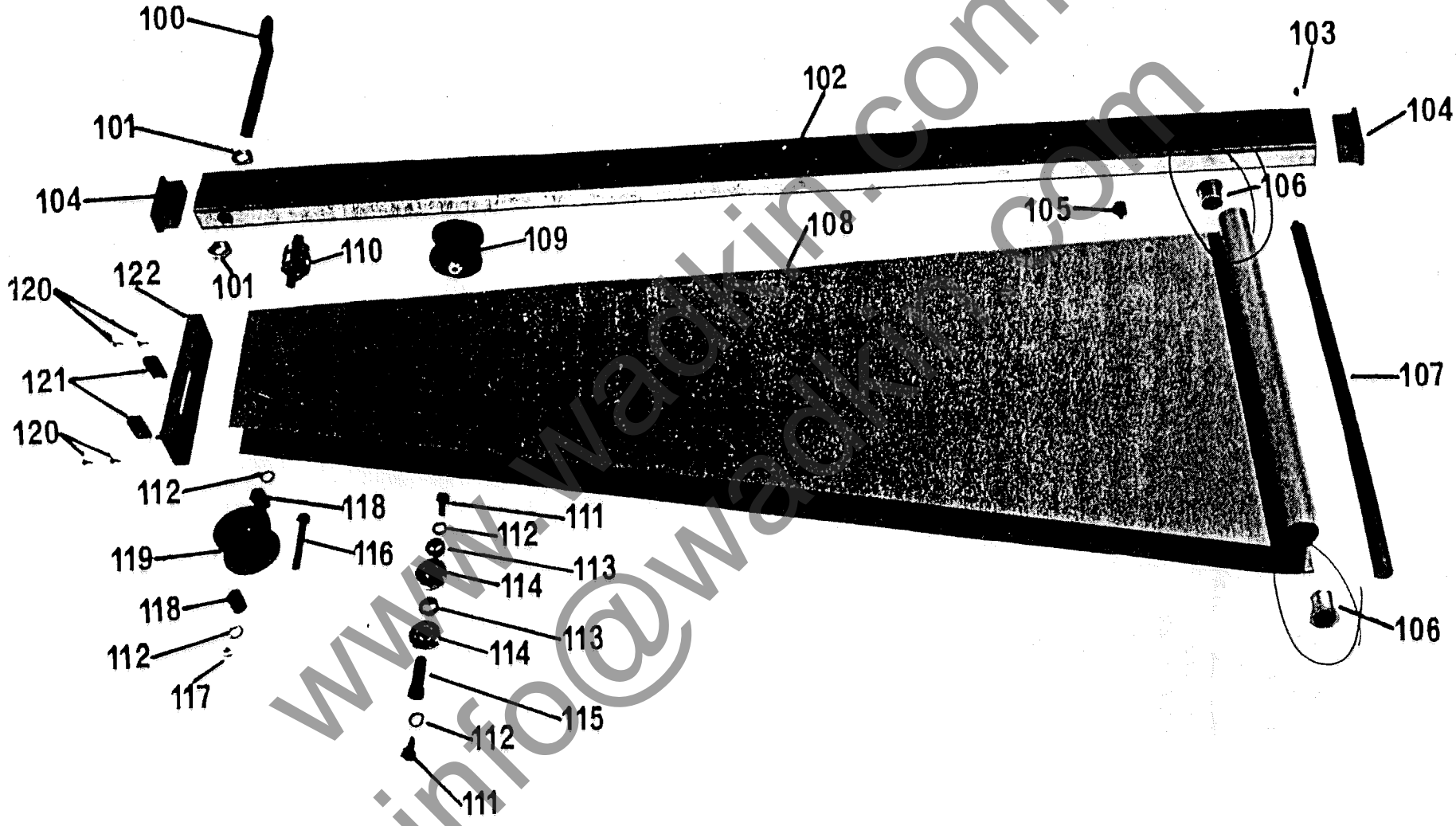
SLIDING TABLE ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
35		4	M10 x 20 Long socket button head screws
36	CP32/19	1	End plate for beam
37	P32/137	2	Tufnol strip for beam
	P25/4	2	Tufnol strip for beam
38	No. 614	84	4.8 dia x 16.3 long pop rivets
	No. 614	68	4.8 dia x 16.3 long pop rivets
39	CP32/2	1	Beam (CP32)
	CP25/2	1	Beam (CP25)
40	P32/211	1	Carriage stop
41		2	M8 x 20 Long socket cap screw
42	CP32/18	1	End plate for beam with lock
43		2	M8 x 12 Long countersunk machined screws
44		14	8mm Washers
45		2	M8 Dome nuts
46	P32/49	1	Sliding table lock plunger
47		1	M8 x 40 Long stud
48	1041/88	1	Washer
49	1079/654	1	Spacer
50	Pat 98	1	M8 Locking knob
51		As Req'd	Nylon pile self adhesive draught excluder (Under side of cover for carriage)
52	CP32/52	2	Cover for carriage
53	BRA 69	2	Rubber stop (fitted either end of carriage)
		2	Rubber stop (fitted either end of sliding table)
54	CP32/16	2	Diabalo Rollers
55	CP32/61	2	Trapping bracket for diabalo
56		6	M6 x 10 Long socket button head screws
57		2	M6 Nuts
58	CP32/53	1	Carriage
59	P32/138	2	Tufnol strip for sliding table
	P25/5	2	Tufnol strip for sliding table
60	SP12/14	2	Sliding table stop
61		4	M10 x 12 Long socket set screws
62			Extended adjusting plate undertable roller assembly
63			Adjusting plate undertable roller assembly
64		6	M8 x 20 Long countersunk machined screws
65	CP32/34	3	Extended adjusting plate for undertable rollers
66		12	M8 Nuts
67	0-4705-00	6	Roller
68		6	10mm Washers
69		2	M10 x 20 Long socket button head screws
70	P32/147	3	Adjusting plate for undertable rollers
71		2	M8 x 16 Long socket button head screws
72	CP32	1	Sliding Table
	CP25	1	Sliding Table



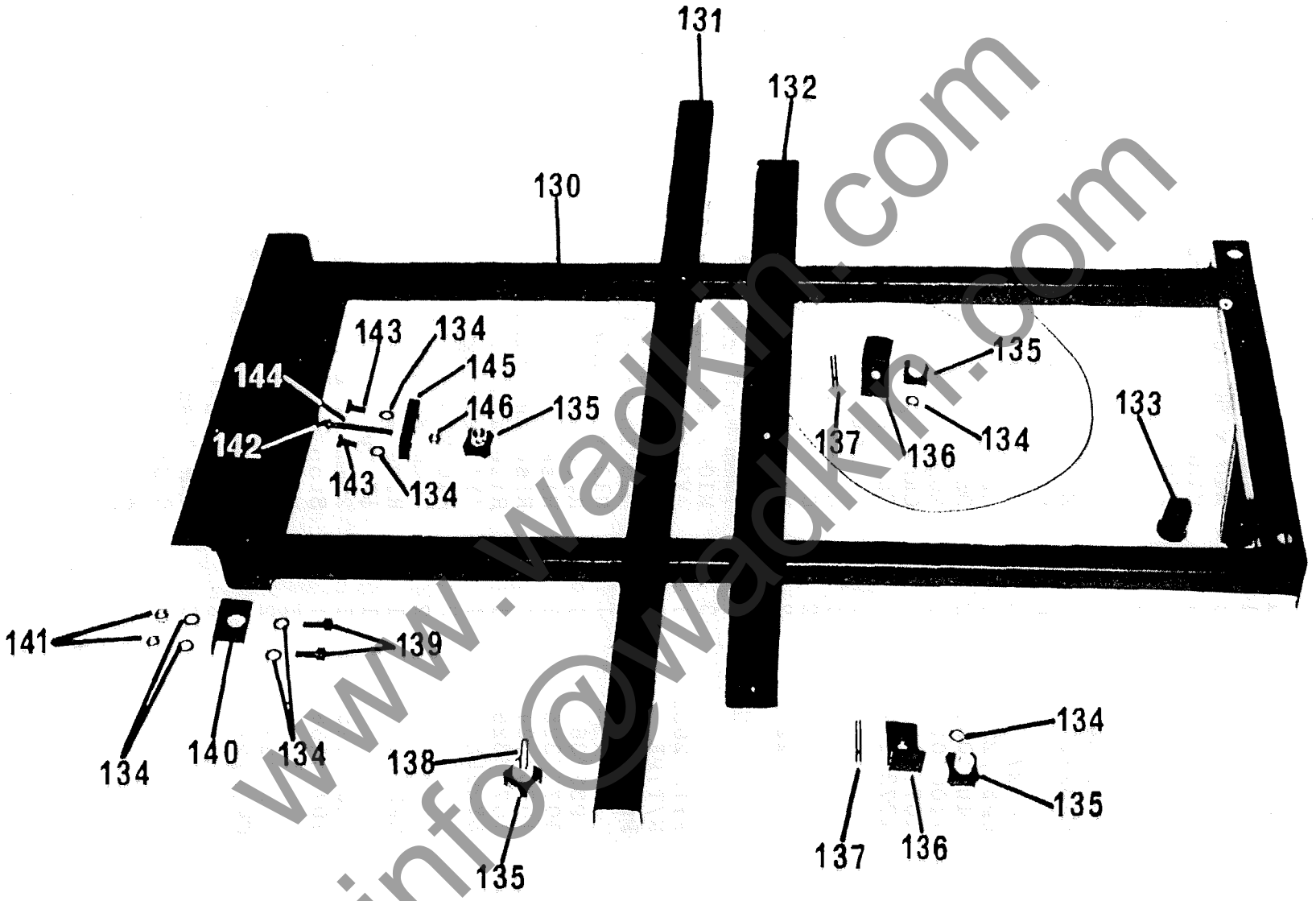
PIVOT ARM ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
100	P32/44	1	Adjusting screw for pivot arm
101		2	M20 Locknuts
102	P32/29	1	Inner slide arm
103		1	M5 x 10 Long socket capscrew
104	5988	2	Ribbed inserts
105	BRA 69	1	Rubber stop
106	FBM 20	2	Headed oil bushes
107	CP32/49	1	Pivot bar
108	P32/91	1	Pivot arm
109		2	Guide roller assembly
110		2	Support bearing assembly
111		4	M10 x 25 Long hexagon set screw
112		8	10mm Washers
113	P32/73	2	9mm Long (outer) distance pieces for support bearing
		2	7.5mm Long (inner distance pieces for support bearing
114	6203 2RS	4	Bearings
115	P32/30	2	Plain pin for pivot arm
116		2	M10 x 70 Long hexagon set screws
117		2	M10 Aerotight nuts
118	P32/93	4	Distance pieces for guide roller
119	P32/101	2	Guide roller complete with bearing
120	Z10	4	Self tapping screws
121		2	Foam wiper for inner arm
122	P32/50	1	End plate for pivot arm



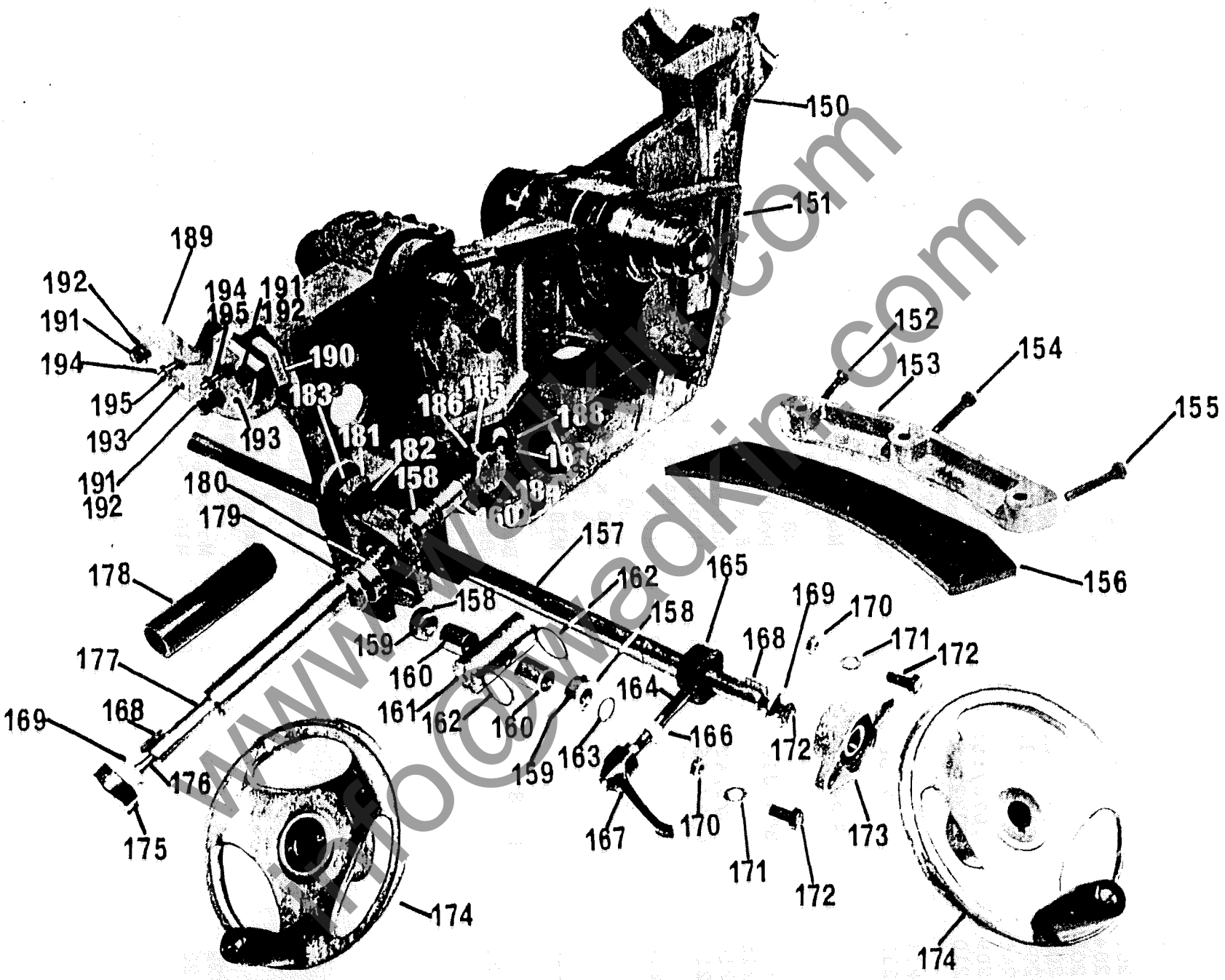
OUTRIGGER ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
130	P32/311	1	Outrigger table
131	P32/266	1	Adjustable table support
132	P32/102	1	Outrigger table support
133	P32/45	1	Bush for pivot arm adjusting screw
134	KQS23164	8	10mm Washers
135	~~Pat 99~~ KQS27139	4	M10 Locking knobs
136	1073/221	2	Clamp for outrigger table support
137	1073/222	2	Clamp locking stud
138	P32/291	1	Locking knob stud
139		2	M10 x 25 Long socket capscrews
140	P32/37	1	Adjusting bracket for crosscut fence
141		2	M10 Areotight nuts
142	CP32/30	1	Pip for locking screw
143		2	M10 x 20 Long hexagon set screws
144	CP32/29	1	Locking screw
145	CP32/15	1	Clamp plate
146		1	M10 Nut



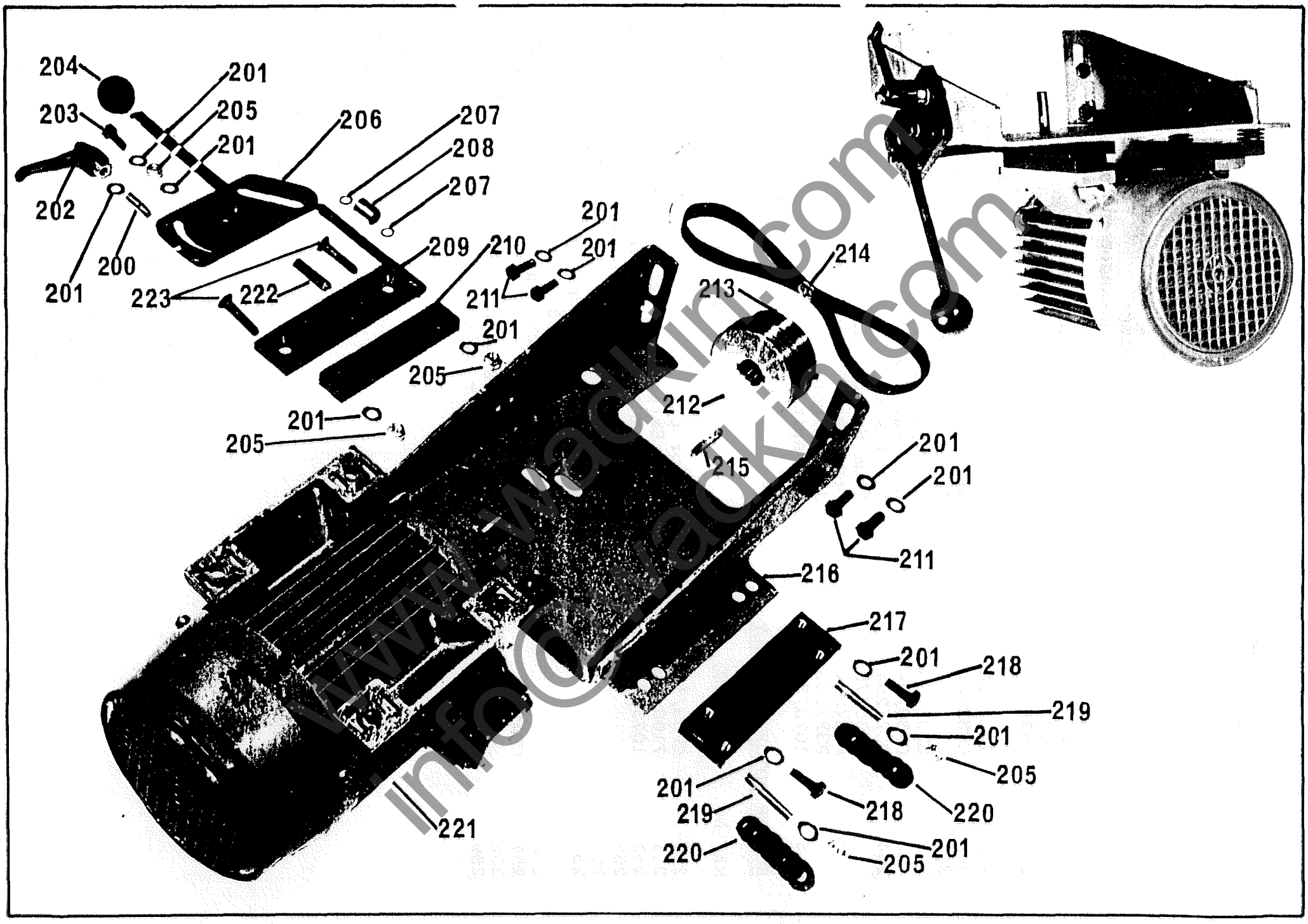
RISE AND FALL AND TUNNION ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
150	CP32/45	1	Trunnion bracket
151	1073/1	1	Rise and fall bracket
152		1	M10 x 60 Long countersunk screw
153	1073/48	1	Rise and fall bracket packing piece
154		1	M10 x 110 Long hexagon set screw
155		1	M10 x 60 Long hexagon set screw
156	1073/56	1	Rise and fall bracket trapping plate
157	CP32/34	1	Canting screw
158	CP32/25	3	Stop nuts
159		6	M6 x 6 Long socket set screws
160	CP32/26	3	Stop collar
161	CP32/27 –	1	Canting nut
162	7100 035	2	35mm External circlips
163	7100 020	1	20mm External circlip
164	1073/126	1	Canting screw lock stud
165	1073/127	1	Canting lock bush
166		1	Grommet
167		1	M10 Bristol locking handle
168		2	6 x 6 x 20 Long feather keys
169	1026/22	2	Handwheel washers
170		2	M10 Nuts
171		2	10mm Washers
172		3	M10 x 25 Long hexagon set screws
173	FYTB 205D	1	'Y' bearing flange unit
174	N/TYPE	2	Handwheels
175	Pat 99	1	M10 Locking knob
176		1	M10 x 30 Long stud
177	CP32/36	1	Rise and fall screw
178	1073/325	1	Rise and fall locking tube
179	1073/324	1	Rise and fall locking washer
180	1073/326	1	Rise and fall locking spacer
181	SY20LX	1	'Y' Bearing plummor block unit
182		2	M10 x 30 Long hexagon set screws
183		2	10mm Washers
184	CP32/37	1	Rise and fall nut
185		1	¼" Push in flip up straight oiler
186	7100 025	1	25mm External circlip
187	1073/136	1	Stop washer for rise and fall shaft
188		1	M6 x 16 long socket capscrew
189	CP32/22	2	Trunnion trapping plate
190	CP32/23	2	Trunnion slide
191		6	M8 x 25 Long hexagon set screw
192		6	8mm Washers
193		4	6 dia x 16 long groverlock dowels
194		4	M8 x 20 Long slotted grubscrews
195		4	M8 Nuts



SAW MOTOR ASSEMBLY (2 SPEED)

REF NO.	PART NO.	NO. OFF	DESCRIPTION
200		1	M10 x 30 Long stud
201		13	10mm Washers
202		1	M10 Bristol locking handle
203		1	M10 x 35 Long hexagon set screw
204		1	M12 x 1¾" dia tapped ball
205		5	M10 Aerotight nuts
206	1073/153	1	Motor tension lever
207	7100 012	2	12mm External circlips
208		1	12mm x ¾" x 1" Long headless pressfit bush
209	1073/155	1	Motor tension bracket
210	CP32/42	1	Packing piece for motor (4kw-50 & 60 cycle only)
211		4	M10 x 25 Long hexagon set screws
212	CP32/56	1	Motor pulley 2 speed (50 & 60 cycle 4kw & 5.5kw)
	CP32/57		Motor pulley 2 speed (50 & 60 cycle 7.5kw)
213		2	M8 x 20 long socket set screws
214	300 J10	1	Poly - V - belt (2 speed)
215		1	8 x 7 x 40 Long feather key
216	1073/42	1	Motor platform
217	CP32/43	1	Mounting plate for motor (4kw - 50 & 60 cycle only)
218		2	M10 x 30 Long hexagon set screws (4kw - 50 & 60 cycle only)
		2	M10 x 50 Long hexagon set screws (5.5kw & 7.5kw - 50 & 60 cycle)
219		2	M10 x 50 Long stud (4kw - 50 & 60 cycle only)
220	No.8	12	Belleville washers
221		1	Brook D100L, foot mounted TEFC 4kw (5HP) 3000 rpm 50 cycle motor
		1	Brook D100L, foot mounted TEFC 5HP 3600 RPM 60 cycle motor
		1	Brook D112M, foot mounted TEFC 5.5kw 3 phase 3000 RPM 50 cycle motor
		1	Brook D112M, foot mounted 7½HP 3 phase 3600 RPM 60 cycle motor
		1	Brook D132Sa,foot mounted motor 7.5kw 3 phase 3000 RPM 50 cycle motor
		1	Brook D132M, foot mounted 10HP 3 phase 3600 RPM 60 cycle motor
222	1073/156	1	Motor guide pin
223		2	M10 x 50 Long countersunk socket screws

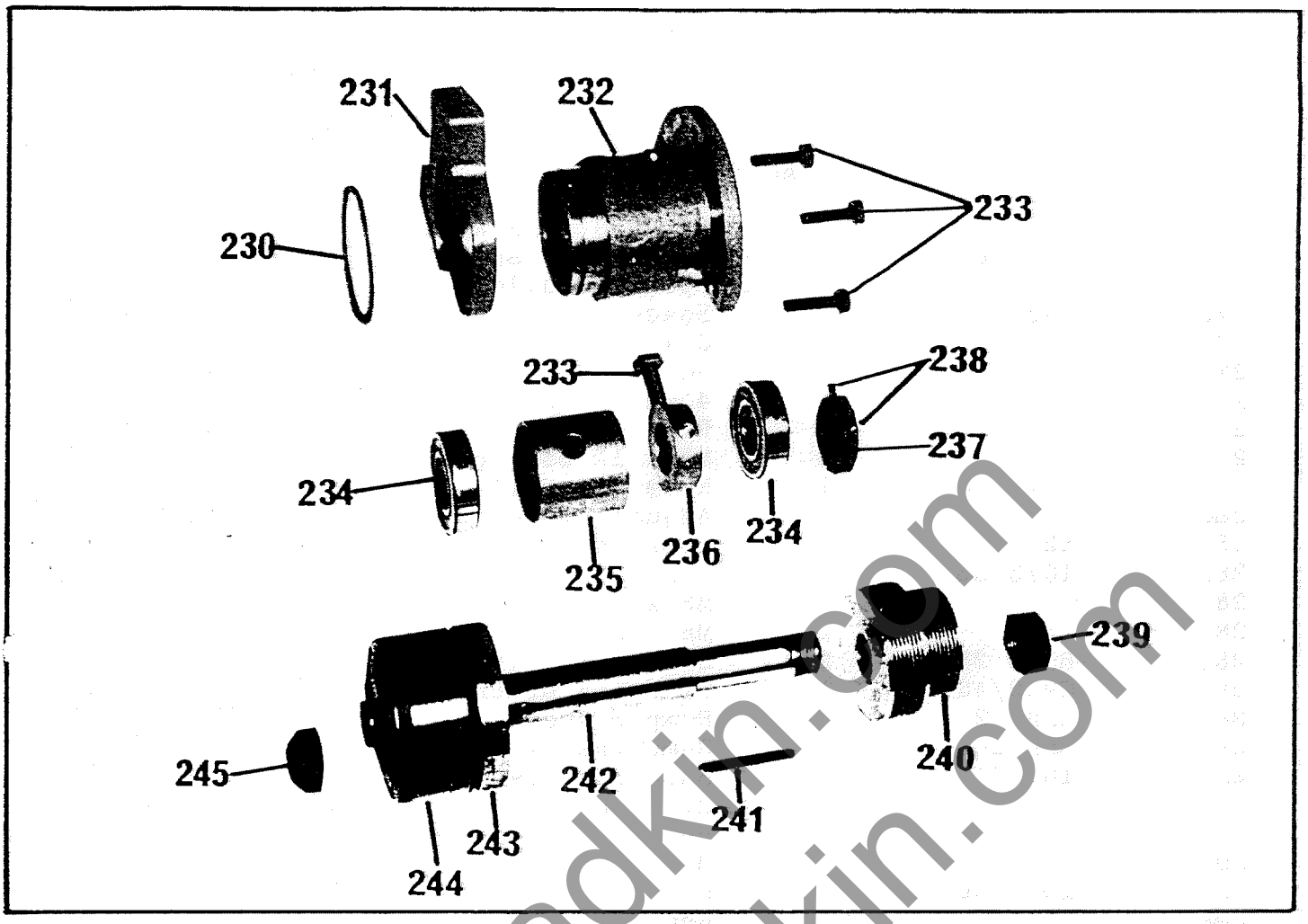


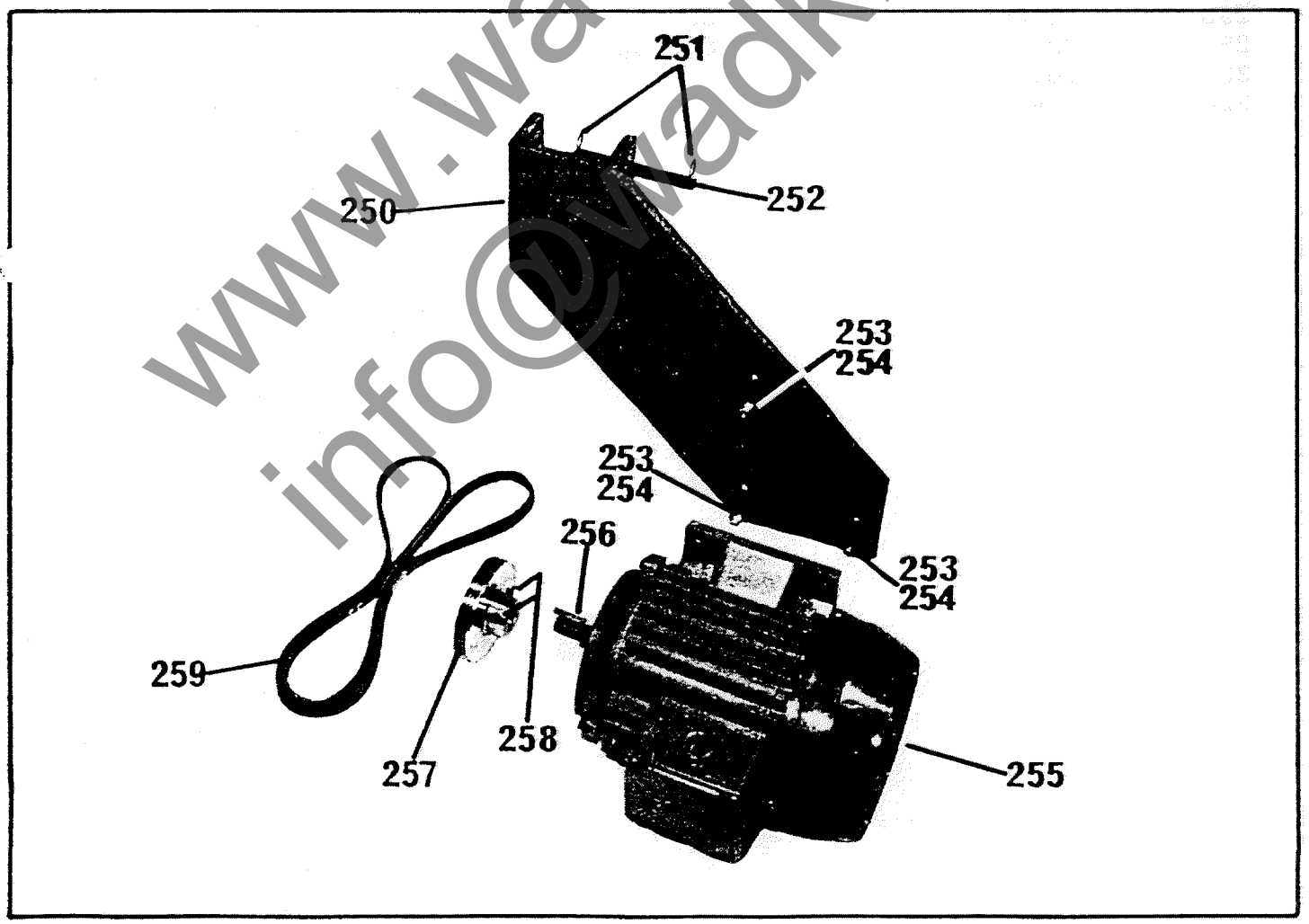
MAIN SAW SPINDLE ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
230	7100 080	1	80mm External circlip
231	1073/15	1	Riving knife pivot bracket
232	1073/44	1	Spindle housing
233		4	M10 x 30 Long hexagon set screws
234	6206 2RS	2	Bearings
235	1030/183	1	Spindle distance piece
236	1073/139	1	Spindle trapping collar
237	1073/140	1	Spindle locking collar
238		2	M6 x 10 Long socket set screws
239	1030/184	1	Saw spindle locknut
240	CP32/55	1	Spindle pulley
241		1	8 x 7 x 55 Long feather key
242	CP32/38	1	Saw spindle
243	CP32/54	1	Back saw flange
244	P32/254	1	Front saw flange (30mm dia spindle)
	1030/75	1	30mm Spigot bush
	P32/234	1	Front saw Flange (1¼" dia spindle)
	P32/235	1	1¼" Spigot bush
245	1073/311	1	Saw spindle nut

SOCRER MOTOR ASSEMBLY

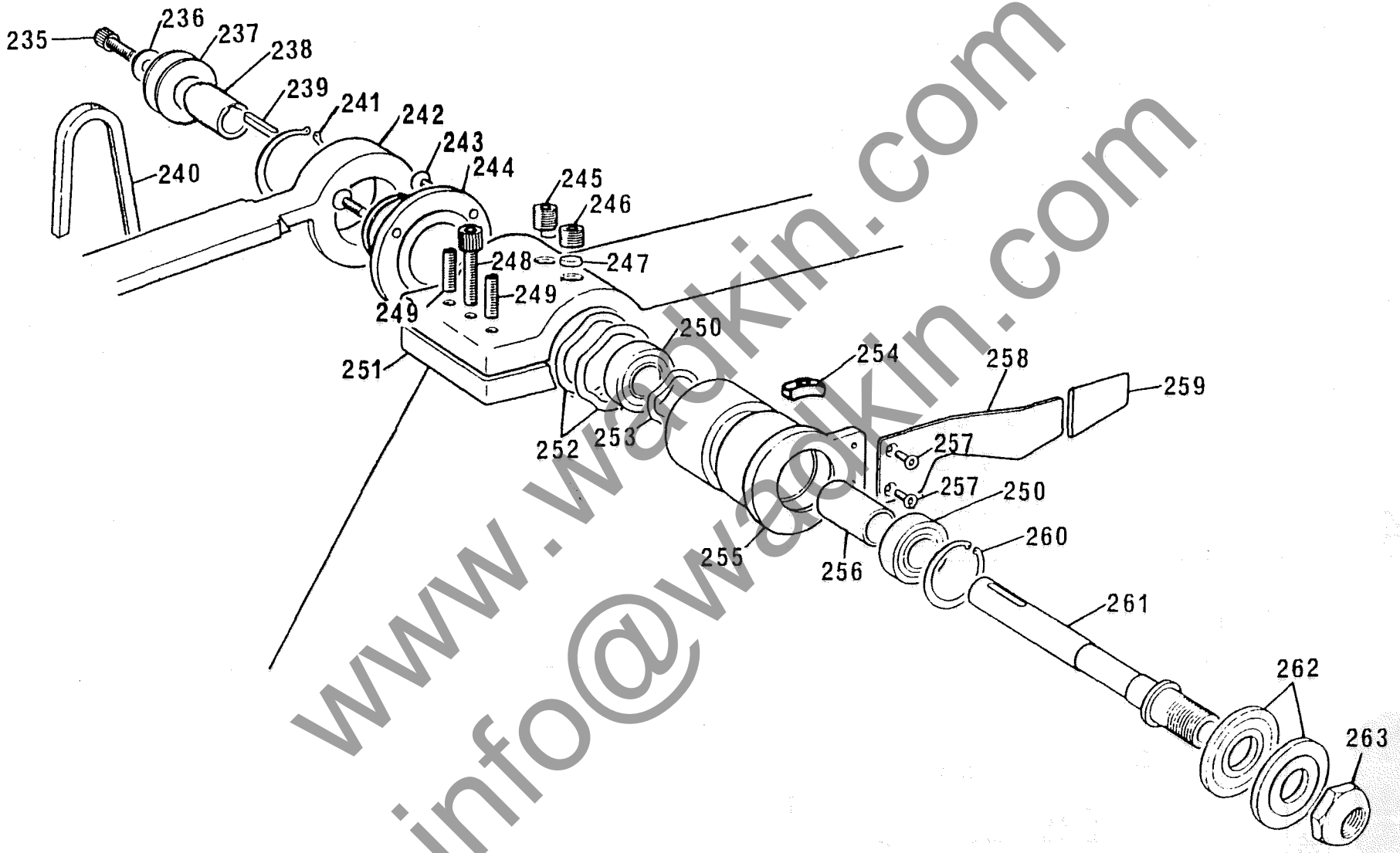
REF NO.	PART NO.	NO. OFF	DESCRIPTION
250	CP32/13	1	Motor platform
251	7100 010	2	10mm External circlips
252	1073/68	1	Scoring saw motor pivot pin
253		3	M6 x 25 Long coach bolts
254		3	M6 Aerotight nuts
255		1	Brook D71b Frame motor 0.55kw 3000 rpm 415v 50 cycle
256		1	6 x 6 x 32 Long feather key
257	CP32/21	1	Motor pulley
258		2	M6 x 6 Long socket set screws
259	460 J4	1	Poly - V - belt





SCORING SAW ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
270		1	M8 x 20 Long nylock socket capscrew
271	1041/88	1	Washer for spindle pulley
272	CP32/20	1	Spindle pulley
273	CP32/51	1	Spacer for pulley
274		1	6 x 6 x 32 Long feather key
275	460 J4	1	Poly - V - belt
276	7100 040	1	40mm External circlip
277	1073/1	1	Rise and fall bracket
278		3	M8 x 12 Long countersunk socket screws
279	1073/66	1	Rise and fall pivot bracket
280	1073/334	1	Adjusting screw for scorer
281	S25/537	1	Lock screw for scorer
282	1073/336	1	Brass bot for scorer
283		1	M8 x 25 Long socket capscrew
284		2	M8 x 25 Long socket grubscrews
285	6003 2RS	2	Sealed for life bearings
286	CP32/45	1	Trunnion bracket
287	ELP 42	2	Bump washer
288	ELP 26	1	Bump washer
289	1041/147	1	Shoe for rise and fall quill
290	1073/27	1	Rise and fall quill
291	1073/62	1	Bearing spacer
292		2	M5 x 8 Long countersunk socket screws
293	1041/86	1	Rise and fall lever
294		1	Red PVC plastic handle
295	7000 035	1	35mm Internal circlip
296	CP32/50	1	Saw spindle
297	1041/77	2	Saw flange
298	1041/76	1	Saw spindle nut



Wadkin

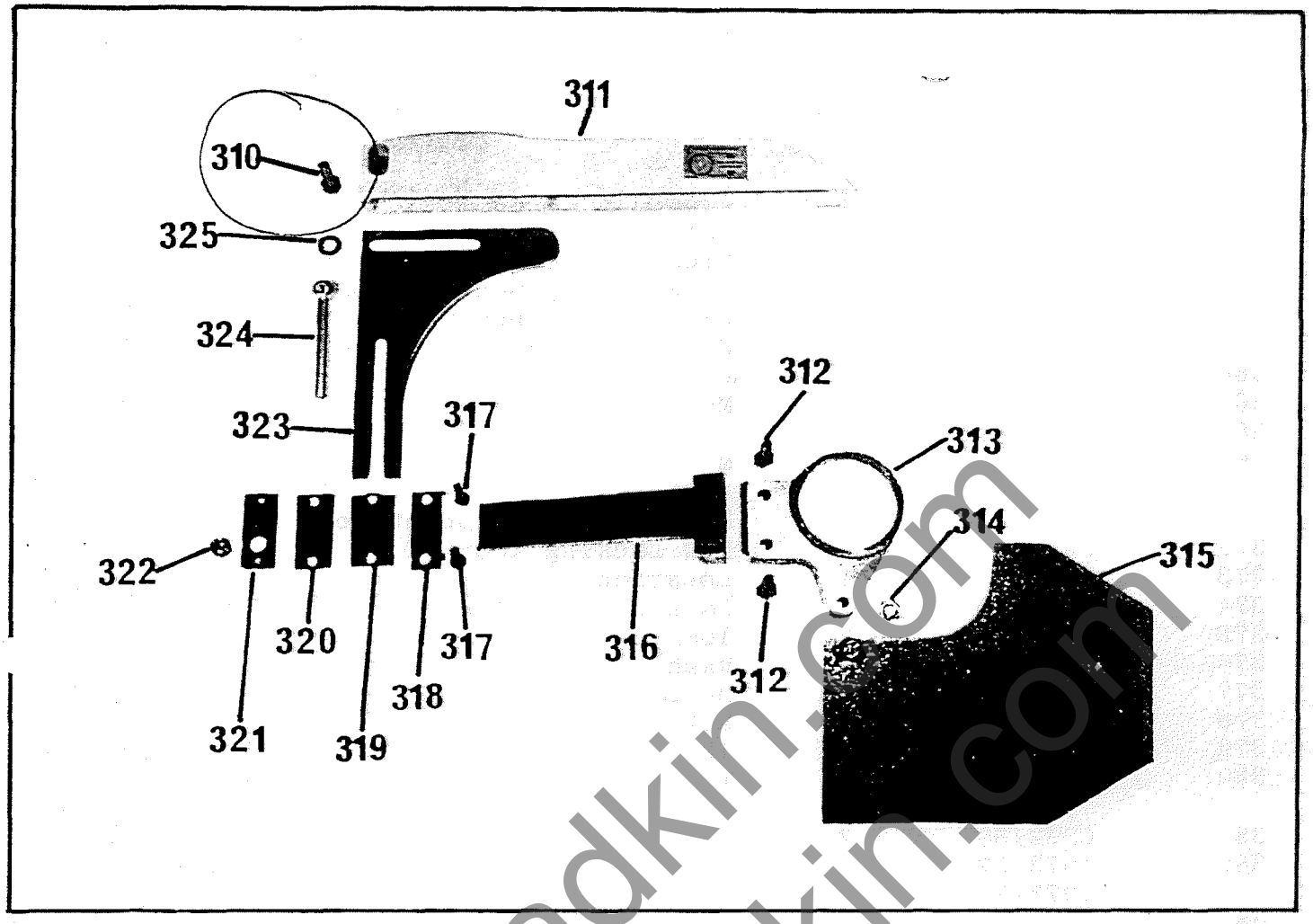
ILLUSTRATED PARTS LIST

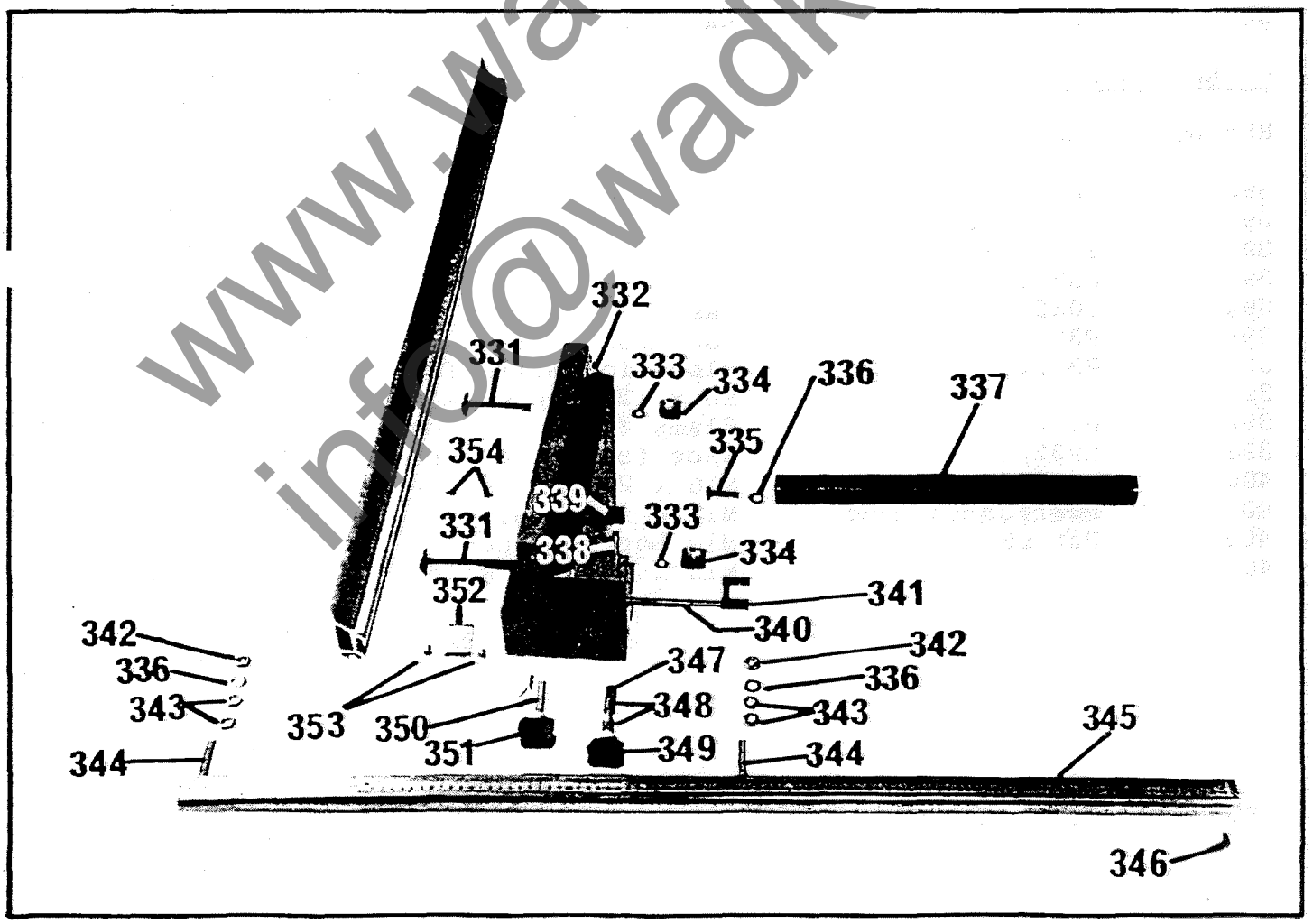
ASSEMBLY:- RIVING KNIFE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
270	1041-144	1	Sawguard
271		1	M10 x 35 Long Hexagon Set Screw
272	S25-396	1	Washer
273	K51-27-191	1	M10 Locking Handle
274	P32-353	1	Riving Knife (250-300 Dia Saw)
	1086-36	1	Riving Knife (350-400 Dia Saw)
275	S25-537	1	M16 Locking Screw
276	S25-370	1	Front Clamp Plate
277	S25-368	1	Pressure Plate
278	S25-359	1	Guide Plate
279	S25-369	1	Rear Clamp Plate
280		2	M8 x 35 Long Socket Button Head Screws
281	CP32-146	1	Slide Plate for Riving Knife
282		2	M8 x 22 Long Nylok Socket Capscrews
283	CP32-144	1	Riving Knife Pivot Bracket
284		2	M10 Aerotight Nuts
285	CP32-145	1	Riving Knife Link Plate

– ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE NUMBER WHEN ORDERING SPARES



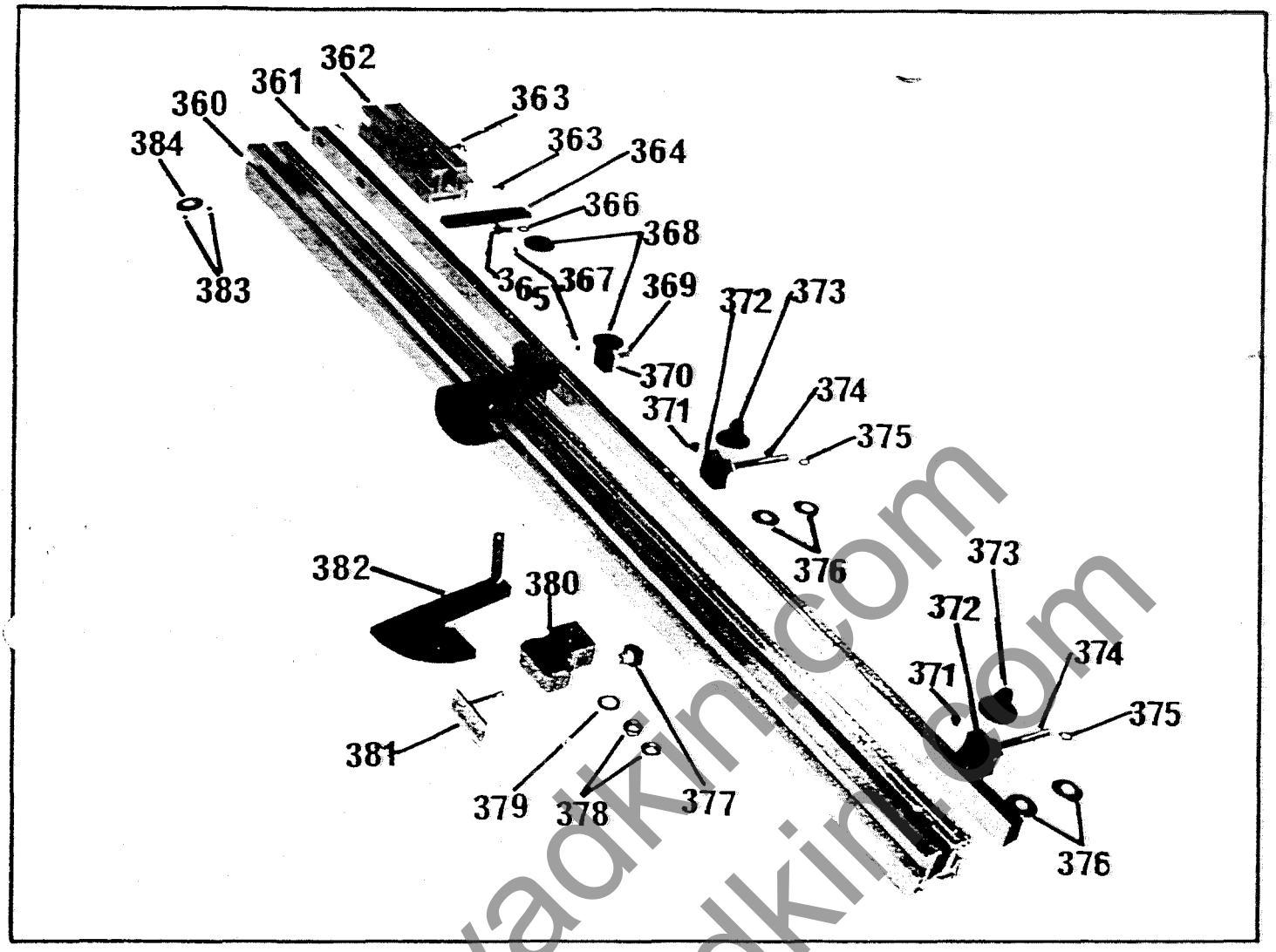


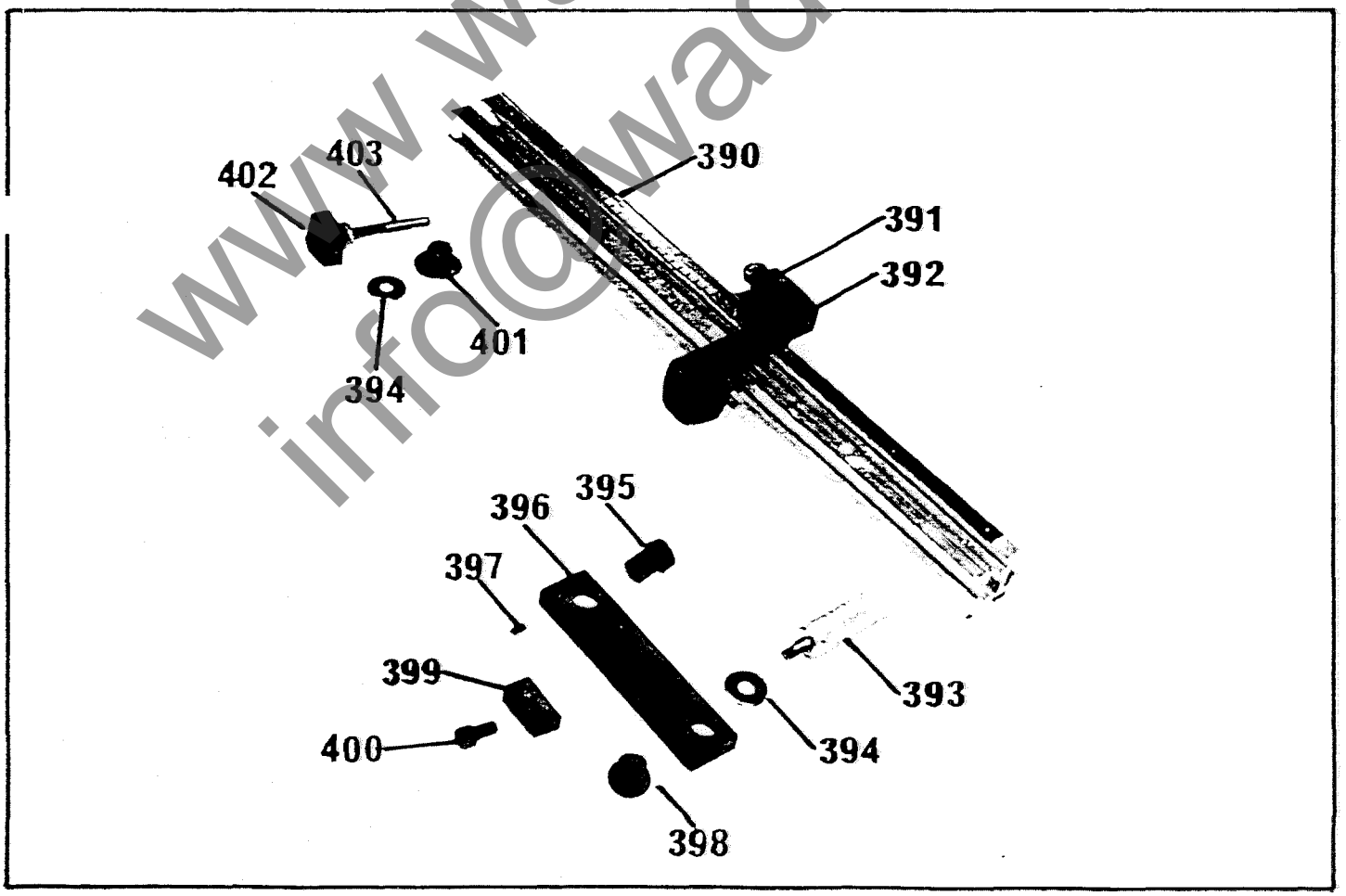
CROSSCUT FENCE ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
360	1073/346	1	Crosscut fence
361	S25/424	1	Extension stop bar
362	S25/413	1	Crosscut fence extension
363		2	M6 x 6 Long socket capscrews
364	S25/418	1	Extension support
365		1	M8 x 20 Long hexagon set screw
366		1	8mm Washer
367		2	M6 x 6 Long socket set screws
368	1073/347	2	Fence locking boss
369		1	M8 x 30 Long stud
370	Pat 98	1	M8 Locking knob
371		2	M10 x 16 Long socket set screws
372	Pat 99	2	M10 Locking knobs
373	P32/38	2	Location pin for crosscut fence
374	P32/245	2	Locking stud
375	7100-010	2	10mm External circlips
376	1026/22	4	Washers
377	Pat 97	2	M6 Locking knobs
378		4	M12 Locknuts
379		2	12mm Brass Washer
380	1073/368	1	Turnover stop bracket RH
	1073/369	1	Turnover stop bracket LH
381	CP32/65	2	Shoe for turnover stop
382	1073/371	1	Turnover stop RH
	1073/371	1	Turnover stop LH
383		2	M3 x 8 Long pan head machined screws
384	S25/452	1	Magnifier

MITRE FENCE ASSEMBLY

REF NO.	PART NO.	NO. OFF	DESCRIPTION
390	CP32/31	1	Mitre fence
391	1073/368	1	Turnover stop bracket
392	1073/371	1	Turnover stop
393	P32/134	1	Mitre fence locking handle
394	1026/22	2	Washers
395	P32/40	1	Location boss
396	P32/41	1	Block for mitre fence
397		1	M6 x 12 Long socket set screw
398	P32/43	1	Clamp for mitre fence
399	CP32/58	1	Shoe for mitre fence pivot
400		1	M10 x 20 Long socket capscrew
401	P32/103	1	Mitre fence pivot
402	Pat 99	1	M10 Locking knob
403		1	M10 x 90 Long stud





FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES

CONTACT SPARE PARTS DEPARTMENT

WADKIN GREEN LANE ROAD
LEICESTER
LE5 4PF

TEL NO : (44) 0116 2769111
FAX NO : (44) 0116 2461021

FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES

CONTACT SPARE PARTS DEPARTMENT

WADKIN GREEN LANE ROAD
LEICESTER
LE5 4PF

TEL NO : (44) 0116 2769111
FAX NO : (44) 0116 2461021