

# **POWERMATIC®**

## **Operating Instructions and Parts Manual Straight Line Rip Saw**

**Model SLR12**



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# IMPORTANT SAFETY INSTRUCTIONS



## **WARNING – To reduce risk of injury:**

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This rip saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a rip saw, do not use until you obtain proper training and knowledge.
5. Do not use this rip saw for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use. Your rip saw is provided with a 15HP main motor; do not equip your rip saw with a motor of higher horsepower.
6. Always wear approved safety glasses/face shields while using this rip saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating the rip saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Keep hands outside the machine. Never reach under the guards to try to clear stock that stops feeding.
9. Wear ear protectors (plugs or muffs) during extended periods of operation.
10. Do not operate this machine while tired or under the influence of drugs, alcohol, or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source. Red Tag a machine under repair to show that it should not be used until maintenance is complete.
14. Remove adjusting keys and wrenches before operating rip saw. Form a habit of checking to see that adjusting keys and wrenches are removed from the machine before turning it on.
15. Always keep safety guards in place when the machine is in use. If removed for maintenance purposes, use extreme caution, and replace the guards immediately.
16. Check damaged parts. Before further use of the machine, carefully check a guard or other part that is damaged to determine if it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area as well as non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil, and grease.
19. Keep visitors a safe distance from the work area. **Keep children away.**
20. Make your workshop child proof with padlocks, master switches, or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
22. Always maintain a balanced stance so that you do not fall or lean against moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Be sure the blade rotates under power in a counterclockwise direction when viewed from the front of rip saw (see page 6 for orientation of machine sides).

24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Turn off the machine and disconnect from power before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
28. Do not stand on the machine. Serious injury could occur if the machine tips over.
29. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
30. Remove loose items and unnecessary work pieces from the area before starting the machine.

 **WARNING:** This product can expose you to chemicals including lead and cadmium which are known to the State of California to cause cancer, and phthalates which are known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

 **WARNING:** Drilling, sawing, sanding, or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection.

Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

**Familiarize yourself with the following safety notices used in this manual:**

 **CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

 **WARNING** This means that if precautions are not heeded, it may result in serious injury or possibly even death.

**- - SAVE THESE INSTRUCTIONS - -**

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# Introduction

This manual is provided by Powermatic covering the safe operation and maintenance procedures for a Powermatic Model SLR12 Rip Saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions, and parts breakdown. This machine has been designed and constructed to provide consistent, long-term operation if properly used according to instructions provided in this manual. If there are any questions or comments, please contact either your local supplier or Powermatic. Powermatic can also be reached at our web site: [www.powermatic.com](http://www.powermatic.com).

# Specifications

|                                  |  |
|----------------------------------|--|
| Stock number.....                | 1791285                                    |
| Main motor.....                  | 15HP, 3Ph, 230/460V* (pre-wired 230V)      |
| Feed motor.....                  | 2HP, 3Ph, 230/460V* (pre-wired 230V)       |
| Controls.....                    | 220V Magnetic                              |
| Blade speed.....                 | 4500 RPM                                   |
| Feed speeds.....                 | 30-120 FPM variable                        |
| Arbor size.....                  | 1" (25.4 mm)                               |
| Provided blade size.....         | Dia. 12" (305 mm) x 4.0mm x 48T            |
| Cutting depth.....               | 3-7/8" (98 mm)                             |
| Maximum ripping width.....       | 18" (460 mm)                               |
| Minimum thickness.....           | 3/8" (10 mm)                               |
| Pressure rollers.....            | 5  |
| Anti-kickback devices.....       | 2  |
| V-belts.....                     | 4  |
| Table size.....                  | 35" x 55" (890 mm x 1397 mm)               |
| Table height.....                | 32" (813 mm)                               |
| Dust collection port.....        | 4" (102 mm)                                |
| Minimum CFM required.....        | 600  |
| Shipping weight.....             | 2530 lbs.                                  |
| Net weight.....                  | 2090 lbs.                                  |
| Overall dimensions (LxWxH).....  | 62" x 56" x 41" (1575 x 1422 x 1041 mm)    |
| Shipping dimensions (LxWxH)..... | 62 x 45-1/2 x 66" (1575 x 1156x 1676.4 mm) |

*\*Conversion to 460V power requires additional purchase and installation of 460V overload relays.*

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Powermatic reserves the right to change specifications at any time and without prior notice and without incurring obligations.

# Features

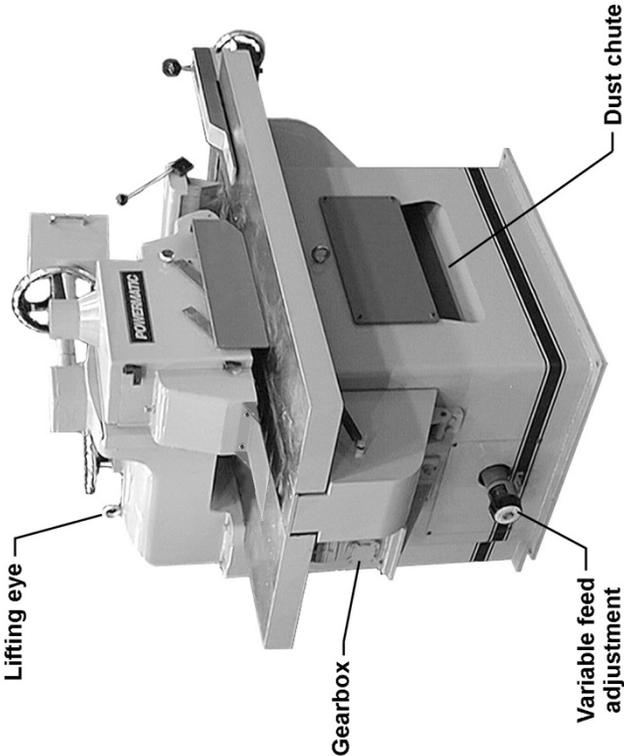
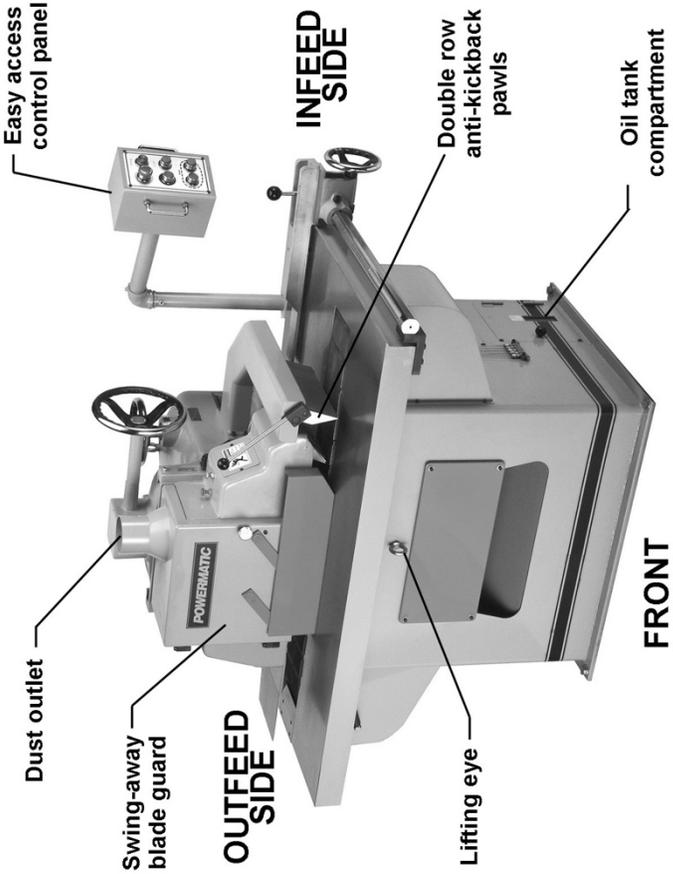


Figure 1

## Receiving

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Rip Saw is installed and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance, and safety instructions.

### Contents of crate:

- 1 Rip saw body
- 1 Rip fence
- 1 Blade
- 1 Toolbox containing (shown in Figure 2):
  - A – 1 grease gun
  - B – 1 set open-end wrenches
  - C – 1 set hex wrenches
  - D – 4 cast iron foot pads
  - E – 4 M16x80 leveling screws
  - E – 4 M16 hex nuts
  - F – 1 arbor wrench
  - G – 1 T-wrench
- 1 Instruction manual
- 1 Warranty card

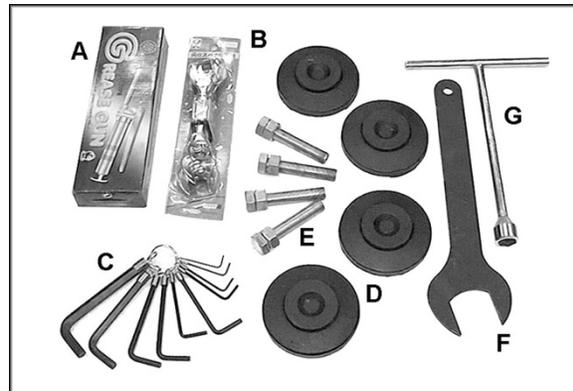


Figure 2

## Installation

### Tools required for assembly:

- Forklift or hoist, with slings
- Open-end wrenches (provided)
- Hex wrenches (provided)
- Arbor wrench (provided)
- T-wrench (provided)

NOTE: The terms “front”, “infeed side” and “outfeed side” are explained on page 6.

1. Lift the machine with a hoist or forklift, using slings through the lifting eyes on the machine. Make sure the capacity of the lifting unit is sufficient to lift this size machine.
2. Locate the rip saw in an area that is well-lit, with a sturdy, level floor and enough space for loading and off-loading stock and general servicing of the machine.
3. You can bolt the rip saw to the floor through the holes at the four corners. If not bolting to the floor, attach the four cast iron foot pads beneath the corners, with the four M16 x 80 leveling screws and four M16 nuts. See Figure 3.

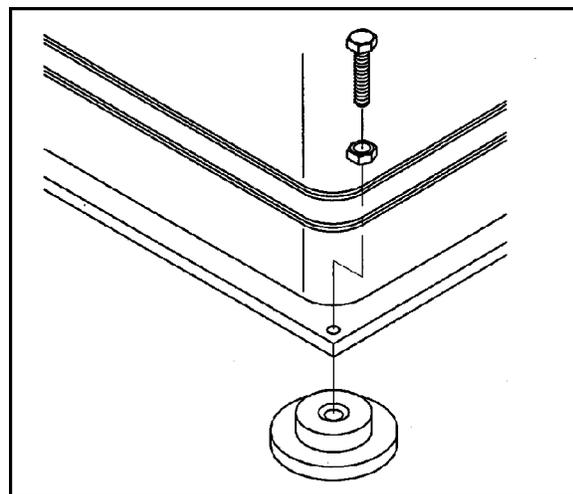


Figure 3

- Place a level on the machine table and adjust the screws over the foot pads as necessary. When the machine is level, tighten all four hex nuts against the machine's base.

Unpainted surfaces, such as the worktable and fence, have a protective coating from the factory. Remove this coating with a soft rag moistened with a good commercial solvent. Do not use acetone, lacquer thinner, gasoline or any flammable solvents. Do not use an abrasive pad.

### Control Box

Swing out the control box (Figure 4). Use the set screws to control the tightness of the mounting arm.

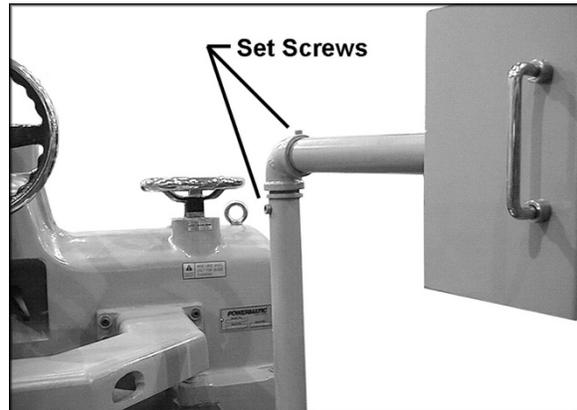


Figure 4

### Grounding Instructions

**⚠WARNING** Electrical connections must be made by a qualified electrician in compliance with state and local codes. The machine must be properly grounded to help prevent electrical shock and possible death.

Grounding provides a path of least resistance to help divert current away from the operator in case of electrical malfunction.

A power plug is not provided with the SLR12. You may either connect one, or "hard-wire" the saw directly to your electrical panel, provided there is a disconnect near the machine for the operator. Consult electrical connection diagrams on pages 31 and 32 for further clarification of wiring setup.

Make sure the voltage of your power supply matches the specifications on the motor plate of the machine.

### Voltage Conversion

The Rip Saw is prewired 230V but may be converted to 460V as follows. Electrical connection diagrams are located inside the motor junction boxes. Electrical connection diagrams are also on pages 31 and 32 of this manual. *Note: In case of discrepancies, diagram on machine takes precedence.*

- Arbor motor: Open junction box and reconnect wires according to diagram.
- Conveyor motor: Open junction box and reconnect wires according to diagram.
- Reconnect wire to transformer from 230V to 460V terminal.

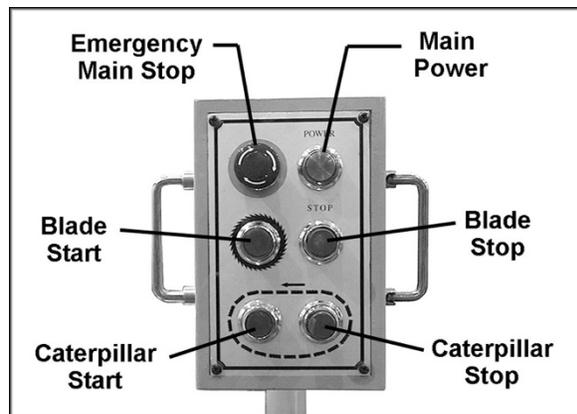


Figure 5

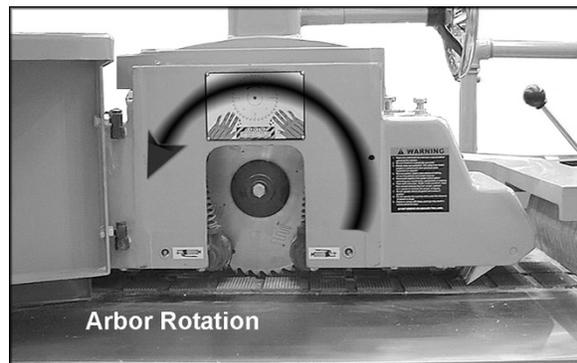


Figure 6

4. Replace 230V overload relay for *main motor* with 460V overload relay (separate purchase, p/n SLR12-611A). Set relay to 9A.
5. Replace 230V overload relay for *conveyor motor* with 460V overload relay (separate purchase SLR12-609AA). Set relay to 3A.
6. If using plug, replace with proper 460V plug.

## Operating Controls

The buttons on the control panel are explained in Figure 5. After making electrical connections, the machine should be turned on to verify the direction of rotation. The blade arbor should rotate counterclockwise when viewed from front of machine (Figure 6). If rotation is wrong, turn off the machine, disconnect power and switch any two of the three electrical leads.

**IMPORTANT:** The emergency stop button (Figure 5) shuts down all operations on the machine simultaneously. To release the emergency stop button, twist it clockwise.

## Installing/Changing Blade

1. Disconnect machine from power source.
2. Unscrew knurled knob on blade guard and swing guard away, as shown in Figure 8.
3. Loosen the arbor lock lever (A, Figure 7) and raise the arbor with the handwheel (B, Figure 7) until the blade can slip on to the arbor without interference from the caterpillar.
4. Place the arbor wrench on the flat of the arbor shaft. Place the T-wrench on the screw head as shown (Figure 8). Hold the shaft stationary with the arbor wrench while loosening the screw.
5. Remove screw and flange and install new blade, making sure to orient it properly - the teeth at bottom of blade should face toward infeed side of machine (as shown in Figure 6).
6. Replace flange and screw and tighten screw with the T-wrench while holding the arbor wrench stationary.
7. Lower the blade down into the inserts on the caterpillar track (blade teeth should be 0.5mm to 1.5mm lower than caterpillar surface).

**CAUTION** The blade teeth should not contact the bottom of the inserts.

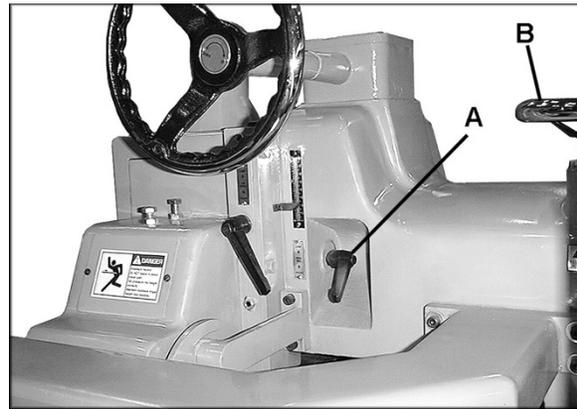


Figure 7

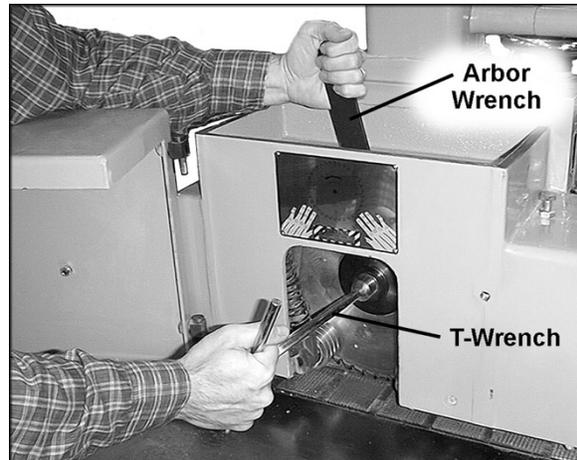


Figure 8

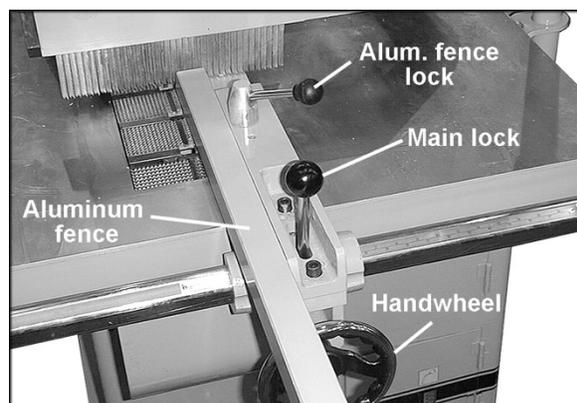


Figure 9

8. Close blade guard and tighten knurled knob.

## Mounting the Fence

1. Slide the fence casting onto the end of the guide bar while pulling back the main lock handle (Figure 9).
2. Move the fence along the guide bar by rotating the handwheel. Use the main lock handle to secure the fence casting in place.
3. Loosen the other lock handle and slide the aluminum fence onto the casting. Tighten the handle.



Figure 10

## Adjustments

### Main Belt Tension

1. Disconnect machine from power source.
2. Open back panels to expose the motor, pulleys, and belts, as shown in Figure 10. Loosen hex nut (Fig. 11) and turn the adjustment screw as needed to adjust the tension. Proper tension is achieved when there is a small amount of deflection by using moderate finger pressure on the belt midway between the pulleys.
3. Tighten hex nut (Fig. 11) and replace panels.

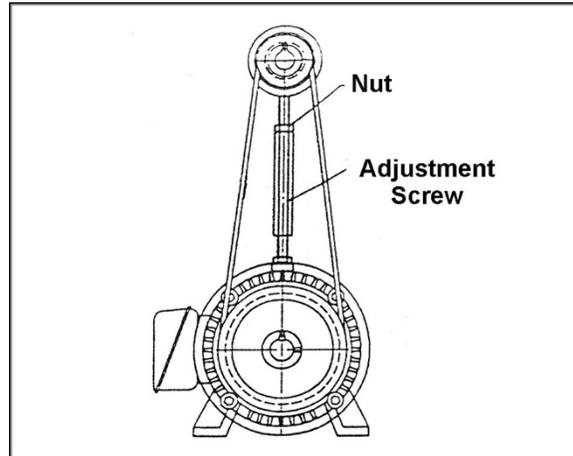


Figure 11

### Gearbox Belt Tension

1. Disconnect machine from power source.
2. Open lower back panel and loosen nuts on the motor base (Fig. 12). Adjust motor base up or down as needed, then tighten nuts. Proper tension is achieved when there is a small amount of deflection by using finger pressure on the belt midway between the pulleys.
3. Replace panels.

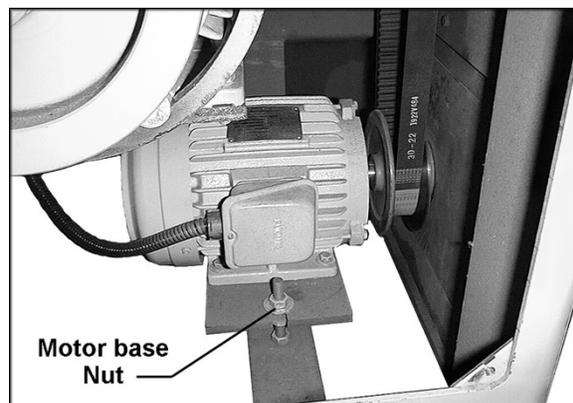


Figure 12

## Feed Speed

The feed speed adjuster is found below the gearbox (Figure 13). Adjust feed speed while the machine is running and the caterpillar is in motion.

Turn feed speed adjuster clockwise to decrease feed speed and counterclockwise to increase.

## Fence Alignment

For accurate cutting, the fence must be parallel to the line of cut:

1. Place a straight edge against the fence with its other side flush to the blade, and check that the fence is in line with the blade.
2. If adjustment is needed, loosen the socket head cap screws on one end of the bar (Figure 14). Move the bar in or out as needed until fence is in line with blade.
3. Retighten screws.

## Adjusting Blade and Roller Height

Raise or lowers the blade using the small handwheel (A, Figure 15). Lock the blade setting by tightening lever (B, Figure 15).

The large handwheel (C, Figure 15) raises and lowers the entire head including the pressure rollers. Lock the roller setting by tightening the lever (D, Figure 15). A scale near the lever displays the height.

The maximum travel of the blade can be adjusted; for example, if a blade smaller than 12" is installed. To adjust:

1. Remove the back panels.
2. Loosen the socket head cap screw on the stop mechanism (Figure 16).
3. Rotate the stop mechanism as needed to allow more blade drop.
4. When finished adjusting, re-tighten socket head cap screw, and install back panels.

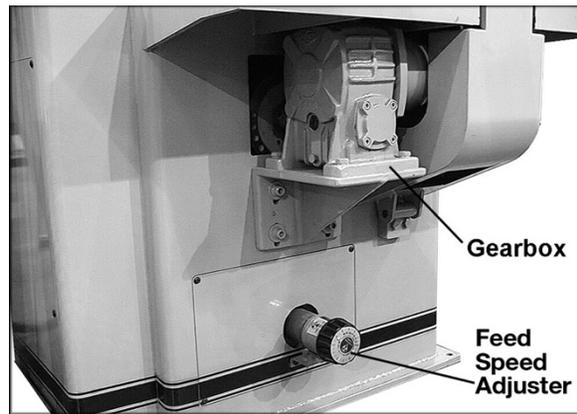


Figure 13



Figure 14

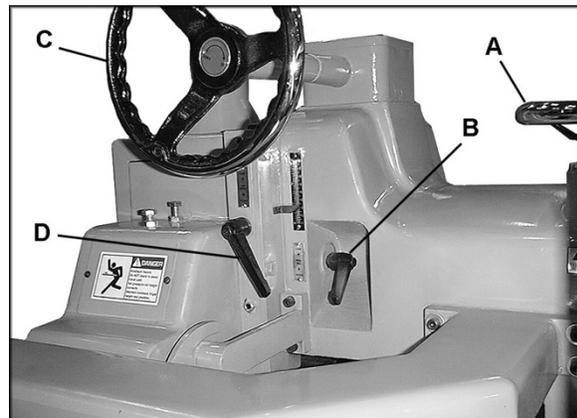


Figure 15



Figure 16

## Oiler Adjustment

1. Remove plastic cover.
2. Loosen set screw (Figure 17) and rotate knurled dial clockwise to increase oil output; counterclockwise to decrease oil output. The scale is in cubic centimeters.
3. Retighten set screw and install plastic cover.

## Operation

1. Check the oil tank at the infeed side of the machine (Figure 18). If it is not full, remove the cap and add light, 20-weight oil through the fill hole. Replace cap when finished.

**IMPORTANT:** The lubricator has a safety device to ensure a longer service life. If the oil is below minimum level, the device will automatically shut off machine operations. The operator must fill the oil tank to re-start the machine. Use light, 20-weight oil.

2. Set the head (rollers) at the proper height for the stock being used, and make sure the blade is approximately 0.5 to 1.5mm below the caterpillar surface.
3. Start the saw blade. Let it run for about 10 seconds and then start the caterpillar. Verify that the lubricating system feeding the caterpillar is operating properly.

**CAUTION** If the lubricating system is not operating properly, shut down machine operations immediately to prevent damage to the caterpillar.

4. Adjust the fence to the proper measurement on the scale and feed the stock through the blade.

**WARNING** Anti-kickback pawls are provided to reduce the chance of kickback. However, to increase safety, never stand in path of workpiece while feeding stock and/or operating machine.

## Feeding Curved Wood

Excessively curved or warped stock should not be fed through the rip saw. If the stock has moderate curvature, it should be fed through the rip saw with the concave surface down (Figure 19).

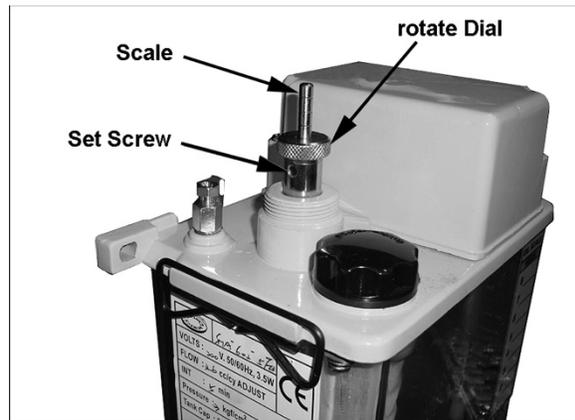


Figure 17

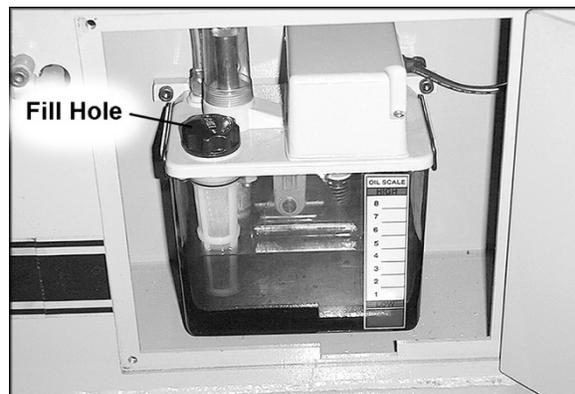


Figure 18

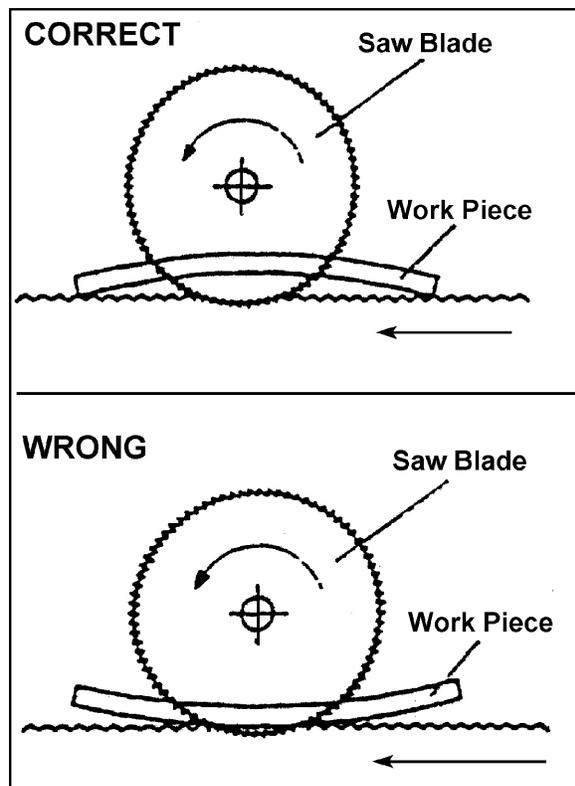


Figure 19

## Maintenance

**⚠WARNING** Before doing maintenance on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch. Failure to do so may cause serious injury.

Always keep interior of oil tank clean.

Always keep the track of the caterpillar chain lubricated using the machine's lubrication system.

Oil should be checked weekly. Add more oil when needed. Use light, 20-weight oil. Change the oil after 2000 hours of operation. Insufficient oil may cause fast wear of gears; excessive oil into the gear reducer may cause oil leakage. Never overfill the oil tank and never use recycled oil.

Refill the oil in the gear reducer until the level reaches over half its full capacity.

Properly clean chips and sawdust from your machine after each work session. Never use your hands to clean the machine. Use a brush or compressed air.

## Optional Accessory

| Part No.  | Description    |
|-----------|----------------|
| SLR12-700 | Laser Assembly |

## Troubleshooting (Electrical)

| Trouble                                    | Probable Cause                      | Remedy                          |
|--|-------------------------------------|---------------------------------|
| Power light won't come on (no power).      | Power source not functioning.       | Check three phase power source. |
|  | Motor overload relay tripped.       | Reset overload relay.           |
|  | Fuse burned out.                    | Replace fuse.                   |
| Power light won't come on (lack of phase). | Power source is insufficient.       | Check three phase power source. |
|  | YL-60P wire is broken.              | Replace YL-60.                  |
|  | Poor connection on magnetic switch. | Replace magnetic switch.        |
|  | Poor connection on terminals.       | Replace TB1, TB2.               |
|  | Screw loosened.                     | Tighten screw.                  |
| Motor runs abnormally.                     | Motor jammed.                       | Clean motor.                    |
|  | Magnetic switch damaged.            | Replace magnetic switch.        |
|  | Motor damaged.                      | Replace motor.                  |
| Motor won't run.                           | Magnetic switch damaged.            | Replace magnetic switch.        |
|  | Motor burned out.                   | Replace motor.                  |

## Troubleshooting (Mechanical)

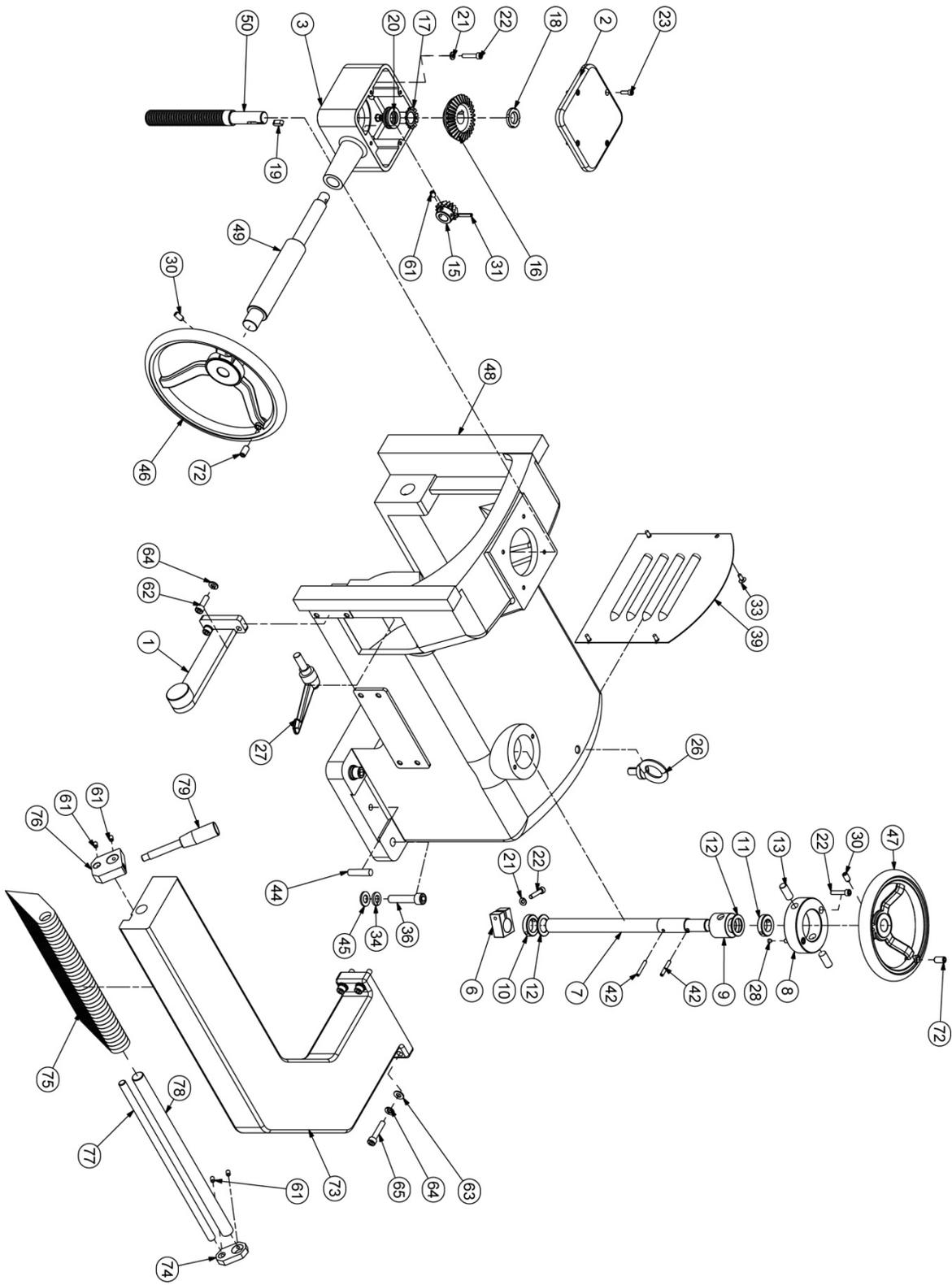
| Trouble   | Probable Cause   | Remedy   |
|---|--|--|
| Saw arbor won't run.                            | Saw arbor guard or rear guard not closed.                        | Check and close guards.  |
| Caterpillar won't move.                         | Variable speed belt too loose or dropped.                        | Adjust variable speed belt tension or replace belt. See page 11.     |
| Workpiece slips.                                | Pressure roller too high.  | Lower the pressure roller.   |
| Convex cut causes jointing failure.             | Saw blade too dull.  | Replace blade (page 9).  |
|   | Fence is bumped.   | Adjust fence (page 10).  |
| Concave cut causes jointing failure.            | Saw blade too dull.  | Replace blade (page 9).  |
|   | Fence is bumped.   | Adjust fence (page 10).  |
| Uneven product thickness at front and rear end. | Saw blade too dull.  | Replace blade (page 9).  |
|   | Fence is bumped.   | Adjust fence (page 10).  |
| Abnormal speed of link chain conveyor           | No oil in lubricator.  | Fill tank with oil (page 12).  |
|   | Oil distributor jammed.  | Blow off dust with air gun.  |
|   | Variable speed belt loosened.                                    | Adjust belt tension (page 10).                                       |
| Wood is not cut off.                            | Saw blade position is too high to cut.                           | Lower saw blade 0.5 to 1.5mm below surface of caterpillar (page 11). |
| Insufficient power causes blade to stop.        | Using same saw blade for trimming and cutting off.               | Use correct saw blade.   |
|   | Saw arbor belt is loosened.                                      | Adjust arbor belt tension.   |
| Finished cut not square.                        | Fence not square.  | Square fence (page 11).  |
|   | Damage caused by poor lubrication on chain rail and chain block. | Replace chain rail and chain block and maintain proper oil level.    |
| Power light on, but machine won't start.        | Emergency stop button not released.                              | Check pushbutton (page 8).   |
|   | Safety door cover not closed.                                    | Close door.  |
|   | Overload relay tripped.  | Replace R1.  |
|   | Start switch not functioning.                                    | Replace MS1, MS2.  |
| Machine starts briefly then quits.              | Stop pushbutton malfunctioning.                                  | Check PB2, PB3. Replace pushbutton or replace magnetic switch.       |

## **Replacement Parts**

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from Powermatic. Some parts are shown for reference only and may not be available individually.

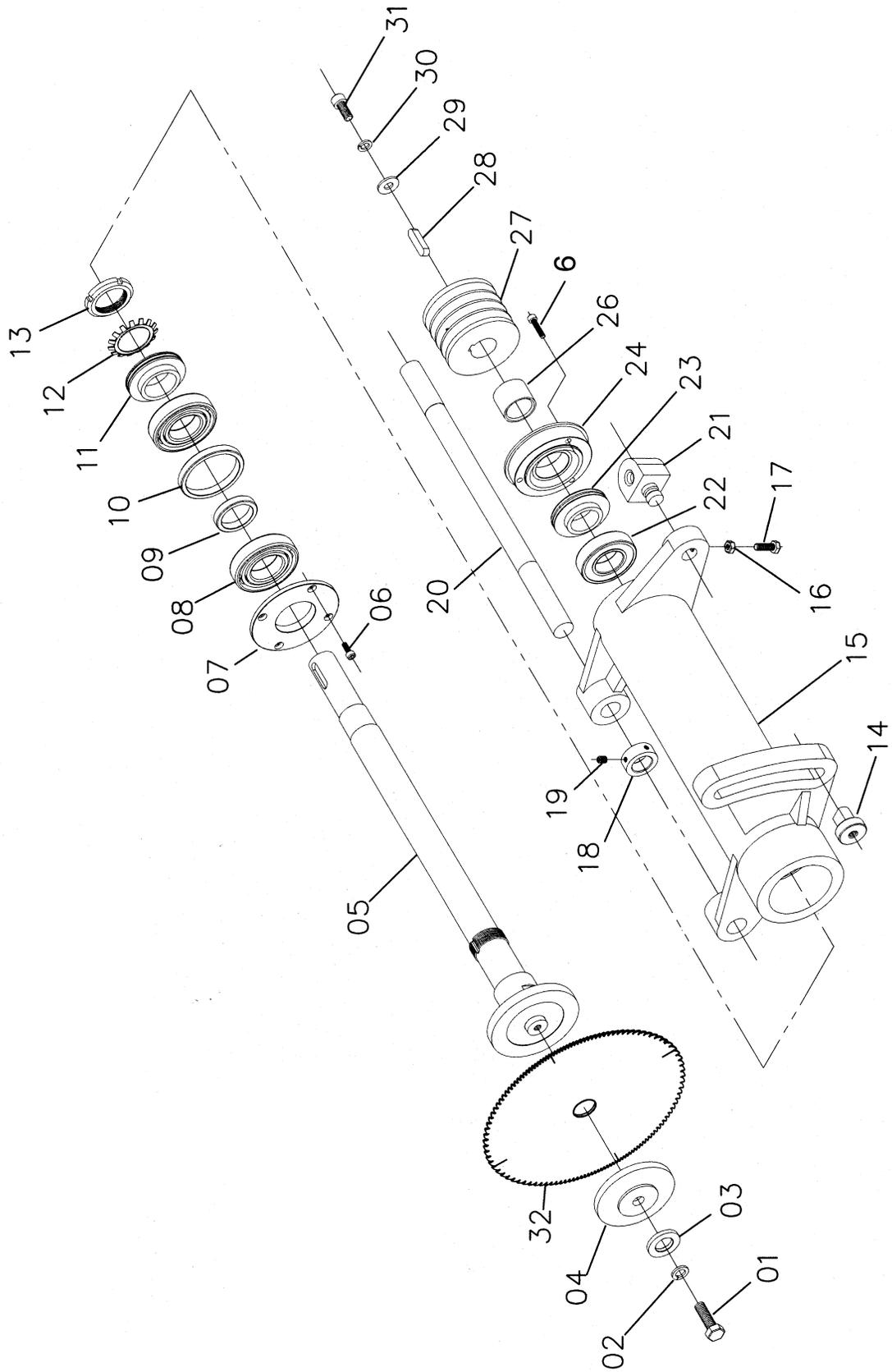
# Infeed Body Assembly – Exploded View



## Infeed Body Assembly – Parts List

| Index No. | Part No.   | Description   | Size          | Qty |
|-----------|------------|---|---------------|-----|
|           | SLR12-300  | Cover Assembly (Items 2, 17-18 and 20-23)           |               | 1   |
|           | SLR12-100  | Gear Box Assembly (Items 2-3, 15, 17-23, 31, 49-50) |               | 1   |
| 1         | SLR12-109  | Bracket   |               | 1   |
| 2         | SLR12-101  | Gear Box Cover                                      |               | 1   |
| 3         | SLR12-104  | Gear Box Housing                                    |               | 1   |
| 6         | SLR12-119  | Stop Block  |               | 1   |
| 7         | SLR12-126  | Lead Screw (Tracking)                               |               | 1   |
| 8         | SLR12-131  | Cover   |               | 1   |
| 9         | SLR12-134  | Bushing   |               | 1   |
| 10        | SLR12-121  | Spacer  |               | 1   |
| 11        | SLR12-129  | Spacer  |               | 1   |
| 12        | SLR12-133  | Collar  |               | 2   |
| 13        | SLR12-130  | Bushing Pin   |               | 2   |
| 15        | SLR12-120  | Small Bevel Gear                                    |               | 1   |
| 16        | SLR12-128  | Bevel Gear  |               | 1   |
| 17        | SLR12-103  | Bearing Lock Washer                                 | # AW04        | 1   |
| 18        | SLR12-102  | Bearing Lock Nut                                    | # AN04        | 1   |
| 19        | SLR12-105  | Key   | 7 x 7 x 18 mm | 1   |
| 20        | BB-51104   | Thrust Bearing                                      | # 51104       | 1   |
| 21        | TS-2361061 | Lock Washer   | M6            | 5   |
| 22        | TS-1503071 | Socket Head Cap Screw                               | M6 x 30       | 7   |
| 23        | TS-1502041 | Socket Head Cap Screw                               | M5 x 16       | 4   |
| 26        | SLR12-125  | Lifting Eye Bolt                                    | M12           | 1   |
| 27        | SLR12-108  | Locking Handle                                      |               | 1   |
| 28        | TS-1523011 | Socket Set Screw                                    | M6 x 6        | 2   |
| 30        | TS-1524041 | Socket Set Screw                                    | M8 x 16       | 6   |
| 31        | SLR12-127  | Pin   | Φ5 x 25 mm    | 1   |
| 33        | TS-1533042 | Pan Head Machine Screw                              | M5 x 12       | 4   |
| 34        | TS-2361121 | Lock Washer   | M12           | 4   |
| 36        | TS-1506091 | Socket Head Cap Screw                               | M12 x 60      | 4   |
| 39        | SLR12-124  | Cover   |               | 1   |
| 42        | SLR12-140  | Pin   | Φ5 x 32 mm    | 1   |
| 44        | SLR12-118  | Taper Pin   | # 7           | 3   |
| 45        | TS-2360121 | Flat Washer   | M12           | 4   |
| 46        | SLR12-123  | Handwheel   | # 250         | 1   |
| 47        | SLR12-132  | Handwheel   | # 200         | 1   |
| 48        | SLR12-107  | Infeed Body Housing                                 |               | 1   |
| 49        | SLR12-122  | Shaft   |               | 1   |
| 50        | SLR12-106  | Lead Screw (Blade Raising)                          | TM25-5x160    | 1   |
| 61        | TS-1523031 | Socket Set Screw                                    | M6 x 10       | 5   |
| 62        | TS-1504051 | Socket Head Cap Screw                               | M8 x 25       | 2   |
| 63        | TS-1550061 | Flat Washer   | M8            | 4   |
| 64        | TS-1551051 | Lock Washer   | M8            | 6   |
| 65        | TS-1504081 | Socket Head Cap Screw                               | M8x40         | 4   |
| 72        | TS-0271031 | Socket Set Screw                                    | 3/8-16 x 3/8  | 2   |
| 73        | SLR12-116B | Bracket   |               | 1   |
| 74        | SLR12-117  | Shaft Block   |               | 1   |
| 75        | SLR12-114  | Anti-Kickback Finger                                |               | 37  |
| 76        | SLR12-112  | Handle Block  |               | 1   |
| 77        | SLR12-113  | Shaft   |               | 1   |
| 78        | SLR12-110  | Shaft   |               | 1   |
| 79        | SLR12-111  | Knob  |               | 1   |

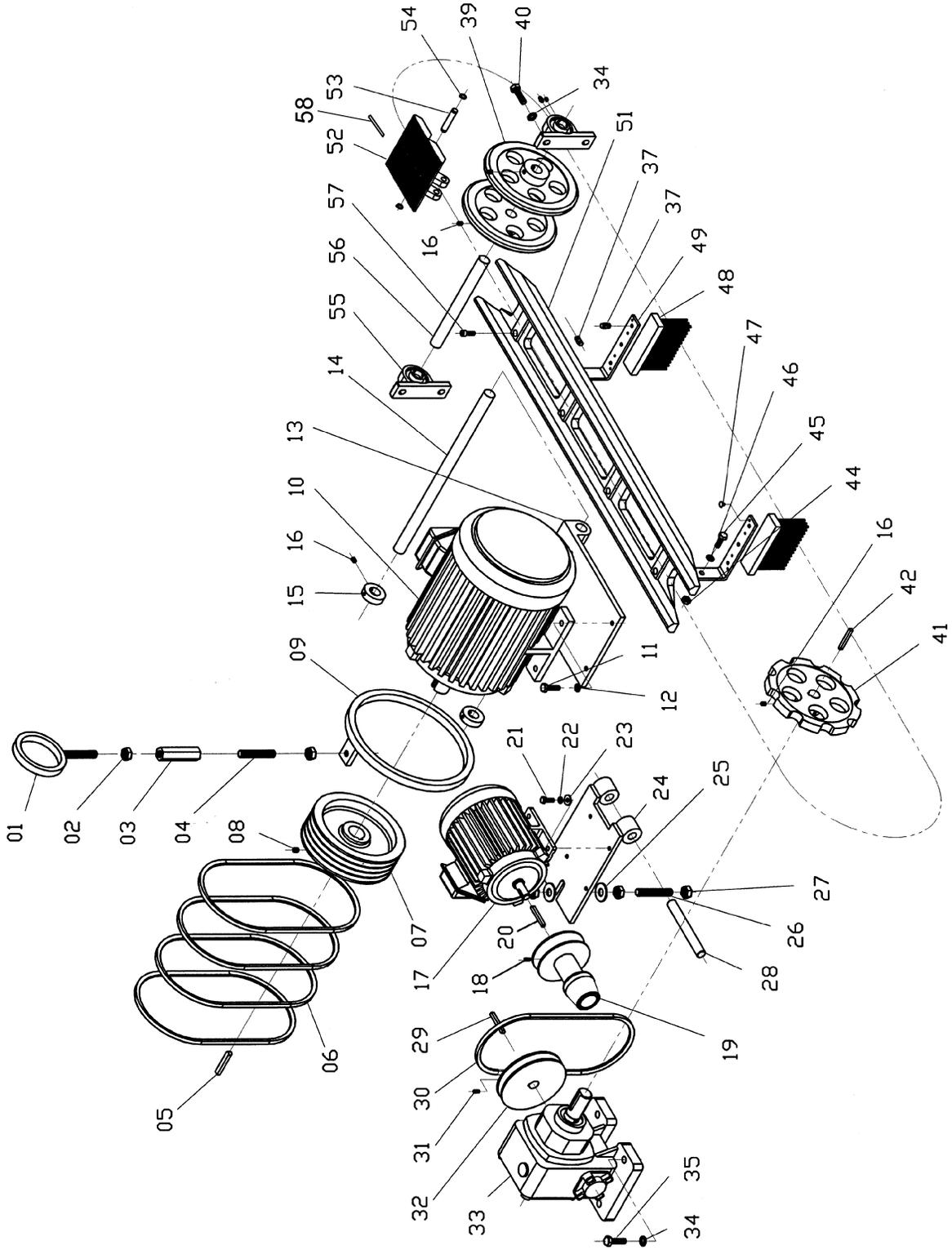
# Arbor Spindle Assembly – Exploded View



## Arbor Spindle Assembly – Parts List

| Index No. | Part No.     | Description                              | Size        | Qty |
|-----------|--------------|--|-------------|-----|
|           | SLR12-200    | Arbor Spindle Assembly (Items 1 thru 13) |             | 1   |
| 1         | TS-1492041   | Hex Cap Screw                            | M12x40      | 1   |
| 2         | TS-2361121   | Lock Washer                              | M12         | 14  |
| 3         | SLR12-201    | Arbor Washer                             |             | 1   |
| 4         | SLR12-202    | Outer Collar                             |             | 1   |
| 5         | SLR12-203    | Arbor Spindle                            |             | 1   |
| 6         | TS-1503071   | Socket Head Cap Screw                    | M6x30       | 7   |
| 7         | SLR12-204    | Front Cover                              |             | 1   |
| 8         | SLR12-BB7208 | Ball Bearing                             | # 7208      | 2   |
| 9         | SLR12-205    | Spacer (Inner)                           |             | 1   |
| 10        | SLR12-206    | Spacer (Outer)                           |             | 1   |
| 11        | SLR12-207    | Spacer, Front                            |             | 1   |
| 12        | SLR12-208    | Bearing Washer                           | # AW08      | 1   |
| 13        | SLR12-209    | Bearing Nut                              | # AN08      | 1   |
| 14        | SLR12-210    | Adjustment Nut                           |             | 1   |
| 15        | SLR12-211    | Arbor Spindle Housing                    |             | 1   |
| 16        | TS-1540061   | Hex Nut                                  | M8          | 1   |
| 17        | TS-1490061   | Hex Cap Screw                            | M8x35       | 1   |
| 18        | SLR12-212    | Collar Retainer                          |             | 1   |
| 19        | TS-1524021   | Socket Set Screw                         | M8x10       | 2   |
| 20        | SLR12-213    | Pivot Shaft                              |             | 1   |
| 21        | SLR12-214    | Adjustment Nut                           |             | 1   |
| 22        | BB-6207      | Ball Bearing                             | # 6207      | 1   |
| 23        | SLR12-215    | Rear Spacer                              |             | 1   |
| 24        | SLR12-216    | Spindle Cover                            |             | 1   |
| 26        | SLR12-217    | Spacer                                   |             | 1   |
| 27        | SLR12-218    | Spindle Sheave                           |             | 1   |
| 28        | SLR12-219    | Key                                      | 10x8x40mm   | 1   |
| 29        | TS-1550071   | Flat Washer                              | M10         | 1   |
| 30        | TS-2361101   | Lock Washer                              | M10         | 1   |
| 31        | TS-1505031   | Socket Head Cap Screw                    | M10x25      | 1   |
| 32        | SLR12-220    | Saw Blade                                | Φ12"x48T×4W | 1   |
|           | SLR12-221    | Arbor Wrench (not shown)                 |             | 1   |
|           | SLR12-222    | T-Wrench (not shown)                     |             | 1   |

# Motor and Drive Unit Assembly – Exploded View

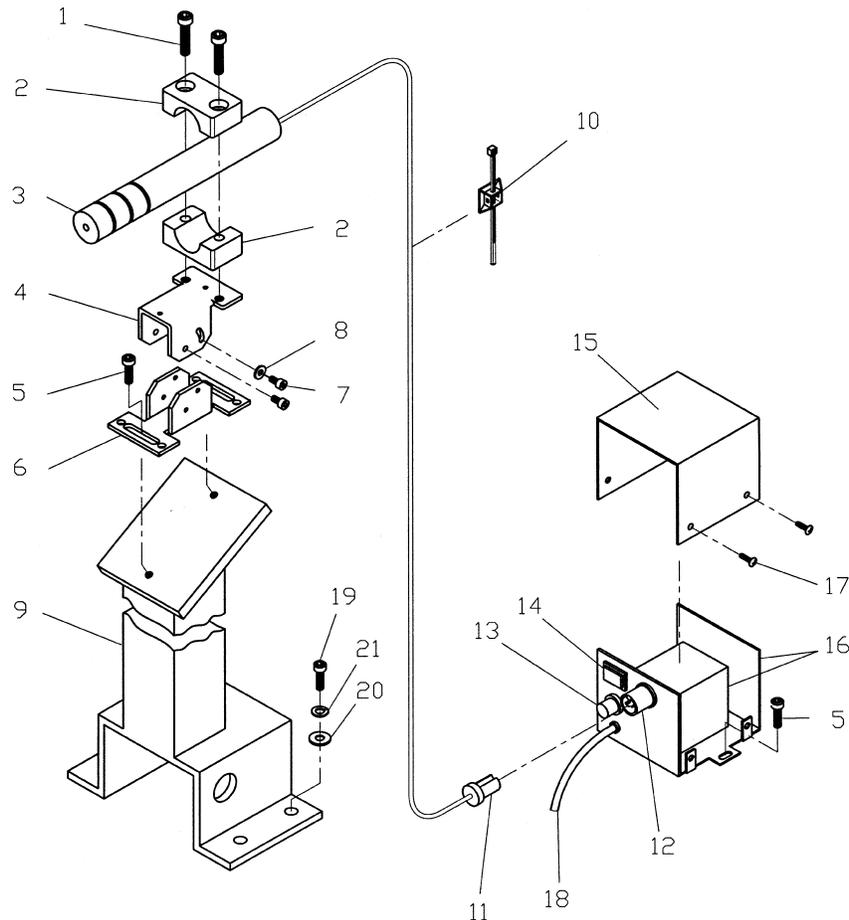


## Motor and Drive Unit Assembly – Parts List

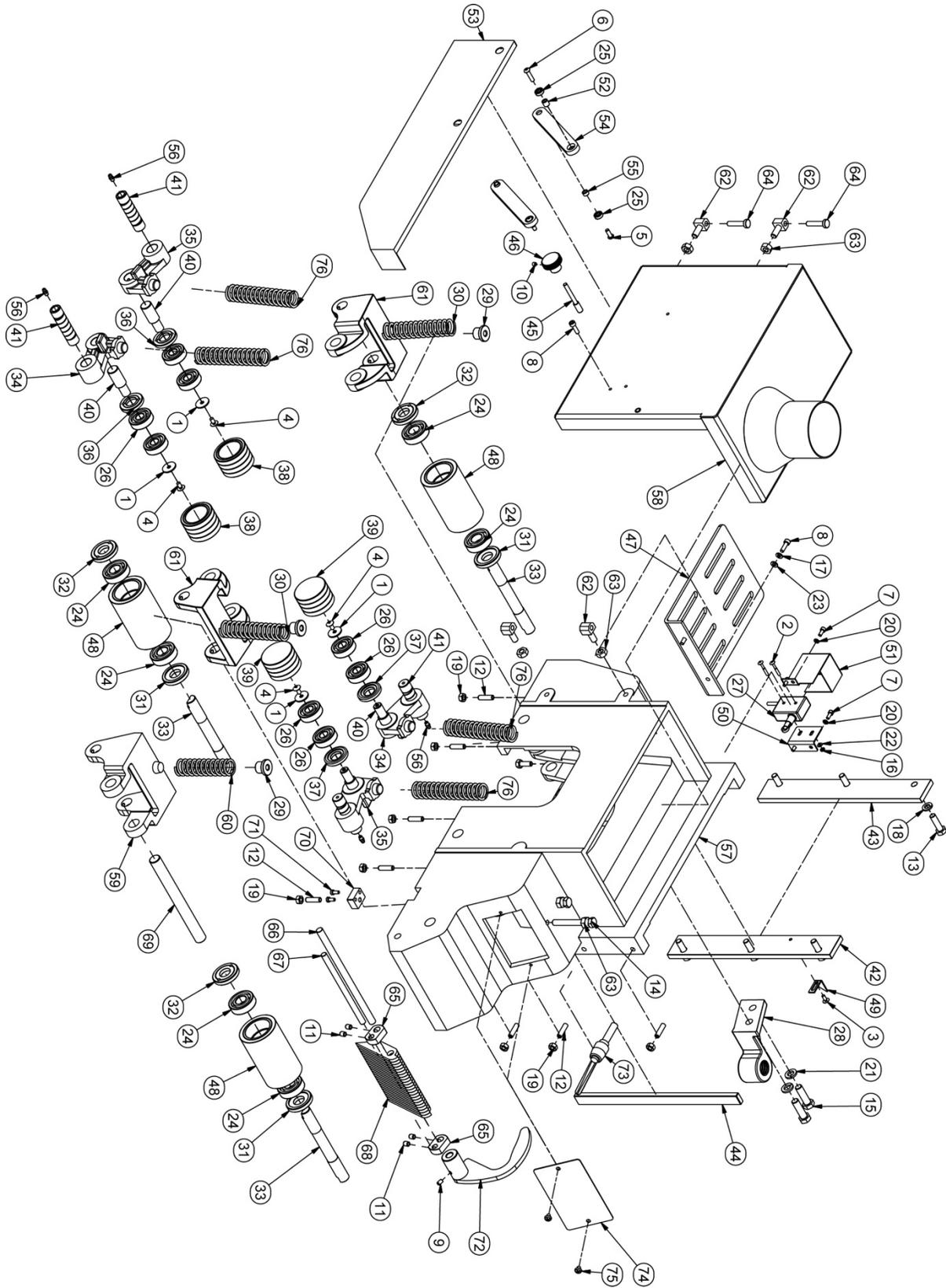
| Index No. | Part No.   | Description                      | Size               | Qty |
|-----------|------------|----------------------------------|--------------------|-----|
| 1         | SLR12-501  | Eye-Bolt                         |                    | 1   |
| 2         | TS-2311161 | Hex Nut                          | M16                | 2   |
| 3         | SLR12-502  | Adjustment Nut                   | M16                | 1   |
| 4         | SLR12-503  | Adjustment Bolt                  | M16                | 1   |
| 5         | SLR12-504  | Key                              | 10x8x65            | 1   |
| 6         | SLR12-505  | V-Belt                           | A-56               | 4   |
| 7         | SLR12-506  | Sheave                           |                    | 1   |
| 8         | TS-1525011 | Socket Set Screw                 | M10x10             | 2   |
| 9         | SLR12-507  | Adjusting Ring                   |                    | 1   |
| 10        | SLR12-508  | Motor                            | 15HP,230V/460V,3PH | 1   |
| 11        | TS-149105  | Hex Cap Screw                    | M10x35             | 4   |
| 12        | TS-2361101 | Lock Washer                      | M10                | 6   |
| 13        | SLR12-509  | Motor Base                       |                    | 1   |
| 14        | SLR12-510  | Shaft                            |                    | 1   |
| 15        | SLR12-511  | Spacer                           |                    | 2   |
| 16        | TS-1524021 | Socket Set Screw                 | M8x10              | 4   |
| 17        | SLR12-512  | Motor                            | 2HP,230V/460V,3PH  | 1   |
| 18        | TS-1524041 | Socket Set Screw                 | M8x16              | 2   |
| 19        | SLR12-513  | Reducer Sheave                   |                    | 1   |
| 20        | SLR12-514  | Key                              | 6x6x60mm           | 1   |
| 21        | TS-1490041 | Hex Cap Screw                    | M8x25              | 4   |
| 22        | TS-2361081 | Lock Washer                      | M8                 | 4   |
| 23        | TS-1550061 | Flat Washer                      | M8                 | 4   |
| 24        | SLR12-515  | Motor Base                       |                    | 1   |
| 25        | TS-2360121 | Flat Washer                      | M12                | 2   |
| 26        | SLR12-516  | Stud Bolt                        | M12x100            | 1   |
| 27        | TS-1540081 | Hex Nut                          | M12                | 3   |
| 28        | SLR12-517  | Shaft                            |                    | 1   |
| 29        | SLR12-518  | Key                              | 7x7x40mm           | 1   |
| 30        | SLR12-519  | V-Belt                           | 1220VB30-22        | 1   |
| 31        | TS-1523031 | Socket Set Screw                 | M6x10              | 2   |
| 32        | SLR12-520  | Reducer Sheave                   |                    | 1   |
| 33        | SLR12-521  | Worm Gear Reducer                |                    | 1   |
| 34        | TS-2361121 | Lock Washer                      | M12                | 4   |
| 35        | TS-1492041 | Hex Cap Screw                    | M12x40             | 4   |
| 37        | SLR12-522  | Oil Nozzle                       | PT1/8"             | 5   |
| 39        | SLR12-523  | Idle Wheel                       |                    | 2   |
| 41        | SLR12-524  | Sprocket                         | 10T                | 1   |
| 42        | SLR12-525  | Key                              | 10x8x60mm          | 1   |
| 44        | TS-2311101 | Hex Nut                          | M10                | 2   |
| 45        | TS-1491041 | Hex Cap Screw                    | M10x30             | 2   |
| 47        | TS-0803052 | Slotted Round Head Machine Screw | #5-40x5/8"         | 8   |
| 48        | SLR12-526  | Brush                            |                    | 2   |
| 49        | SLR12-527  | Rail Bracket                     |                    | 2   |
| 51        | SLR12-528  | Rail Body                        |                    | 1   |
| 52        | SLR12-529  | Caterpillar Block                |                    | 38  |
| 53        | SLR12-530  | Shaft                            |                    | 38  |
| 54        | SLR12-531  | Retaining Ring                   | C12                | 76  |
| 55        | SLR12-532  | Ball Bearing Assembly            | # UCP205           | 2   |
| 56        | SLR12-533  | Shaft                            |                    | 1   |
| 57        | TS-1504051 | Socket Head Cap Screw            | M8x25              | 8   |
| 58        | SLR12-534  | Caterpillar Chain Insert         |                    | 38  |

## Laser Assembly (Optional Accessory) – Parts List & Exploded View

| Index No. | Part No.   | Description                             | Size    | Qty   |
|-----------|------------|---|---------|-------|
| .....     | SLR12-700  | Laser Assembly (Items 1 thru 18)        | .....   | ..... |
| 1         | TS-1503081 | Socket Head Cap Screw                   | M6 x 35 | 2     |
| 2         | SLR12-701  | Clamp Seat                              | .....   | 2     |
| 3         | SLR12-702  | Laser                                   | .....   | 1     |
| 4         | SLR12-703  | Adjustment Bracket                      | .....   | 1     |
| 5         | TS-1502041 | Socket Head Cap Screw                   | M5 x 16 | 4     |
| 6         | SLR12-704  | Bracket                                 | .....   | 1     |
| 7         | TS-1501021 | Socket Head Cap Screw                   | M4 x 8  | 4     |
| 8         | TS-1550021 | Flat Washer                             | M4      | 2     |
| 9         | SLR12-705  | Mounting Bracket                        | .....   | 1     |
| 10        | SLR12-706  | Cord Holder                             | .....   | 6     |
| 11        | SLR12-707  | DC Power Connector (Male)               | .....   | 1     |
| .....     | SLR12-714  | Transformer Assembly (Items 12 thru 18) | .....   | 2     |
| 12        | SLR12-708  | DC Power Connector (Female)             | .....   | 1     |
| 13        | SLR12-709  | Fuse                                    | 1A      | 1     |
| 14        | SLR12-710  | Power Switch                            | .....   | 1     |
| 15        | SLR12-711  | Control Box                             | .....   | 1     |
| 16        | SLR12-712  | Transformer with Base Plate             | .....   | 1     |
| 17        | TS-1531012 | Philips Pan Head Machine Screw          | M3 x 6  | 4     |
| 18        | SLR12-713  | Power Cord                              | .....   | 1     |
| 19        | TS-1504041 | Socket Head Cap Screw                   | M8 x 20 | 4     |
| 20        | TS-1550061 | Flat Washer                             | M8      | 4     |
| 21        | TS-2361081 | Lock Washer                             | M8      | 4     |



# Roller and Frame Assembly – Exploded View

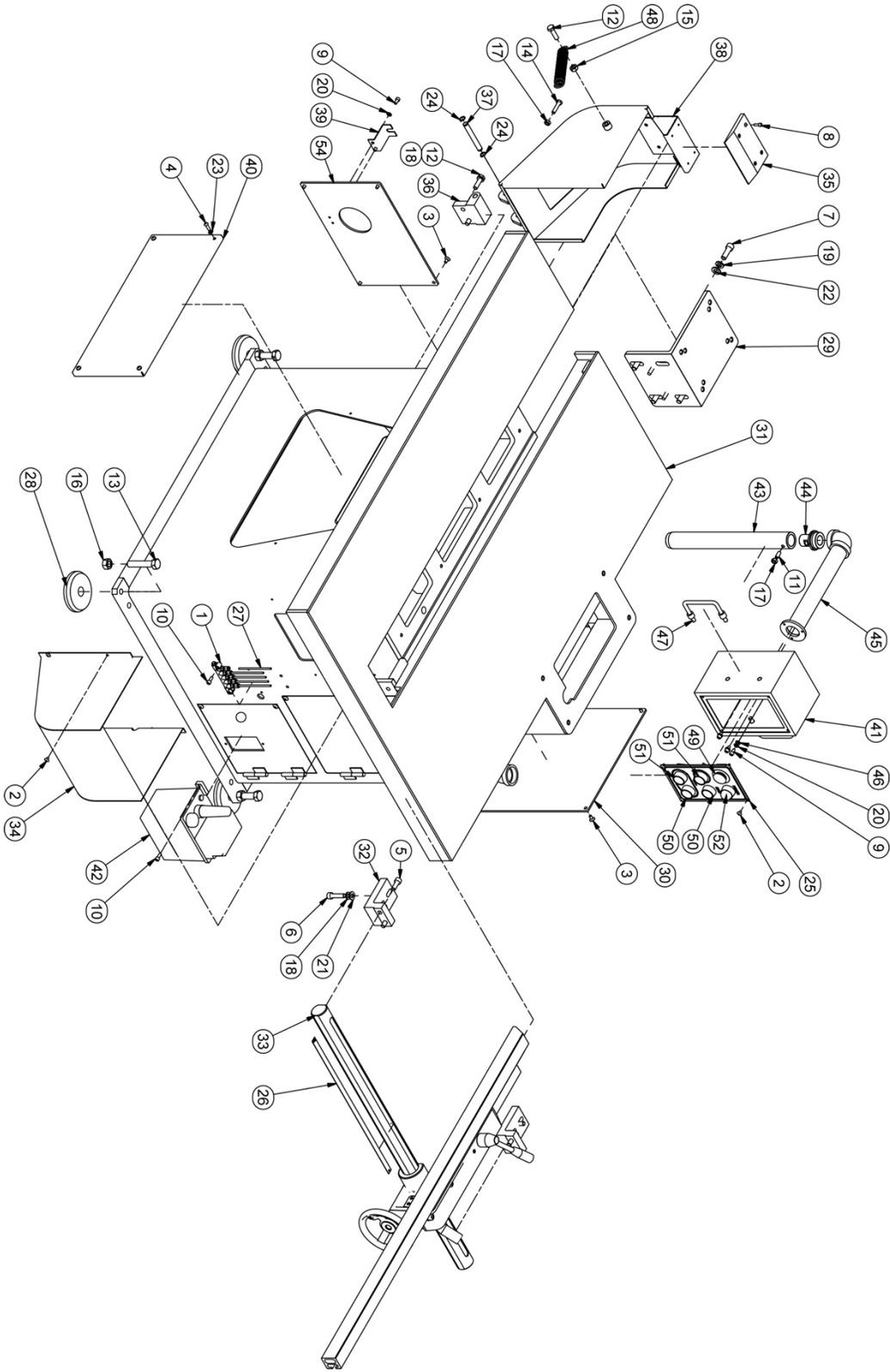


## Roller and Frame Assembly – Parts List

| Index No. | Part No.   | Description                                 | Size      | Qty |
|-----------|------------|---|-----------|-----|
|           | SLR12-300  | Cover Assembly (Items 10, 45-46, 58, 62-64) |           | 1   |
| 1         | SLR12-346  | Washer                                      | 6.5 x 25  | 4   |
| 2         | TS-2284302 | Pan HD Phillips Mach Screw                  | M4 x 30   | 2   |
| 3         | TS-1533042 | Pan HD Phillips Mach Screw                  | M5 x 12   | 1   |
| 4         | TS-1534042 | Pan HD Phillips Mach Screw                  | M6 x 12   | 4   |
| 5         | TS-2246162 | Socket HD Button Screw                      | M6 x 16   | 2   |
| 6         | TS-2246252 | Socket HD Button Screw                      | M6 x 25   | 2   |
| 7         | TS-1502031 | Socket Cap Screw                            | M5 x 12   | 4   |
| 8         | TS-1503051 | Socket Cap Screw                            | M6 x 20   | 3   |
| 9         | TS-1523031 | Socket Set Screw                            | M6 x 10   | 6   |
| 10        | TS-1523011 | Socket Set Screw                            | M6 x 6    | 1   |
| 11        | TS-1524021 | Socket Set Screw                            | M8 x 10   | 12  |
| 12        | TS-1524071 | Socket Set Screw                            | M8 x 30   | 13  |
| 13        | TS-1491041 | Hex Cap Screw                               | M10 x 35  | 6   |
| 14        | TS-2210801 | Hex Cap Screw                               | M10 x 80  | 3   |
| 15        | TS-1492041 | Hex Cap Screw                               | M12 x 40  | 2   |
| 16        | TS-1540021 | Hex Nut                                     | M4        | 2   |
| 17        | TS-2361061 | Lock Washer                                 | M6        | 2   |
| 18        | TS-2361101 | Lock Washer                                 | M10       | 6   |
| 19        | TS-1540061 | Hex Nut                                     | M8        | 13  |
| 20        | TS-2361051 | Lock Washer                                 | M5        | 4   |
| 21        | TS-2361121 | Lock Washer                                 | M12       | 2   |
| 22        | TS-1550021 | Flat Washer                                 | M4        | 2   |
| 23        | TS-1550041 | Flat Washer                                 | M6        | 2   |
| 24        | BB-6204VV  | Ball Bearing                                | 6204-2NSE | 6   |
| 25        | BB-696ZZ   | Ball Bearing                                | 696ZZ     | 4   |
| 26        | BB-6302VV  | Ball Bearing                                | 6302-2NSE | 8   |
| 27        | SLR12-344  | Limit Switch                                | TZ7311    | 1   |
| 28        | SLR12-336  | Bracket                                     |           | 1   |
| 29        | SLR12-310  | Spring Seat                                 |           | 3   |
| 30        | SLR12-311  | Spring                                      | 135 mm    | 2   |
| 31        | SLR12-307  | Right Bearing Cover                         |           | 3   |
| 32        | SLR12-309  | Left Bearing Cover                          |           | 3   |
| 33        | SLR12-306  | Shaft                                       |           | 3   |
| 34        | SLR12-322  | Left Arm                                    |           | 2   |
| 35        | SLR12-314  | Right Arm                                   |           | 2   |
| 36        | SLR12-318  | Left Bearing Cover                          |           | 2   |
| 37        | SLR12-321  | Right Bearing Cover                         |           | 2   |
| 38        | SLR12-319  | Left Roller                                 |           | 2   |
| 39        | SLR12-320  | Right Roller                                |           | 2   |
| 40        | SLR12-317  | Shaft                                       |           | 4   |
| 41        | SLR12-315  | Shaft                                       |           | 4   |
| 42        | SLR12-334  | Lock Bar                                    |           | 1   |
| 43        | SLR12-337  | Lock Bar                                    |           | 1   |
| 44        | SLR12-333  | Slide Plate                                 |           | 1   |
| 45        | SLR12-304  | Lock Screw                                  | M10       | 1   |
| 46        | SLR12-305  | Knob  |           | 1   |
| 47        | SLR12-342  | Safety Guard                                |           | 1   |
| 48        | SLR12-308  | Roller                                      |           | 3   |
| 49        | SLR12-335  | Needle                                      |           | 1   |
| 50        | SLR12-345  | Bracket                                     |           | 1   |
| 51        | SLR12-343  | Cover                                       |           | 1   |
| 52        | SLR12-347  | Bushing                                     |           | 2   |
| 53        | SLR12-339  | Side Guard                                  |           | 1   |
| 54        | SLR12-340  | Arm   |           | 2   |
| 55        | SLR12-348  | Bushing                                     |           | 2   |
| 56        | SLR12-316  | Grease Fitting                              | M6        | 4   |

| Index No. | Part No.   | Description                | Size     | Qty |
|-----------|------------|----------------------------|----------|-----|
| 57        | SLR12-326  | Roller Housing             |          | 1   |
| 58        | SLR12-301  | Cover w/ Dust Port         |          | 1   |
| 59        | SLR12-323  | Arm                        |          | 1   |
| 60        | SLR12-349  | Spring                     | 110 mm   | 1   |
| 61        | SLR12-312  | Arm                        |          | 2   |
| 62        | SLR12-303  | Special Screw              |          | 4   |
| 63        | TS-1540071 | Hex Nut,                   | M10      | 7   |
| 64        | SLR12-302  | Rotation Shaft             |          | 2   |
| 65        | SLR12-328  | Block                      |          | 2   |
| 66        | SLR12-329  | Shaft                      |          | 1   |
| 67        | SLR12-332  | Shaft                      |          | 1   |
| 68        | SLR12-330  | Anti-Kickback Fingers      |          | 23  |
| 69        | SLR12-324  | Shaft                      |          | 1   |
| 70        | SLR12-325  | Block                      |          | 2   |
| 71        | TS-1502031 | Socket Head Cap Screw      | M5 x 12  | 4   |
| 72        | SLR12-331  | Bracket                    |          | 1   |
| 73        | SLR12-327  | Locking Handle             | M12 x 45 | 1   |
| 74        | SLR12-338  | Cover                      |          | 1   |
| 75        | TS-1534032 | Pan HD Phillips Mach Screw | M6 x 8   | 2   |
| 76        | SLR12-313  | Spring                     | 145 mm   | 4   |

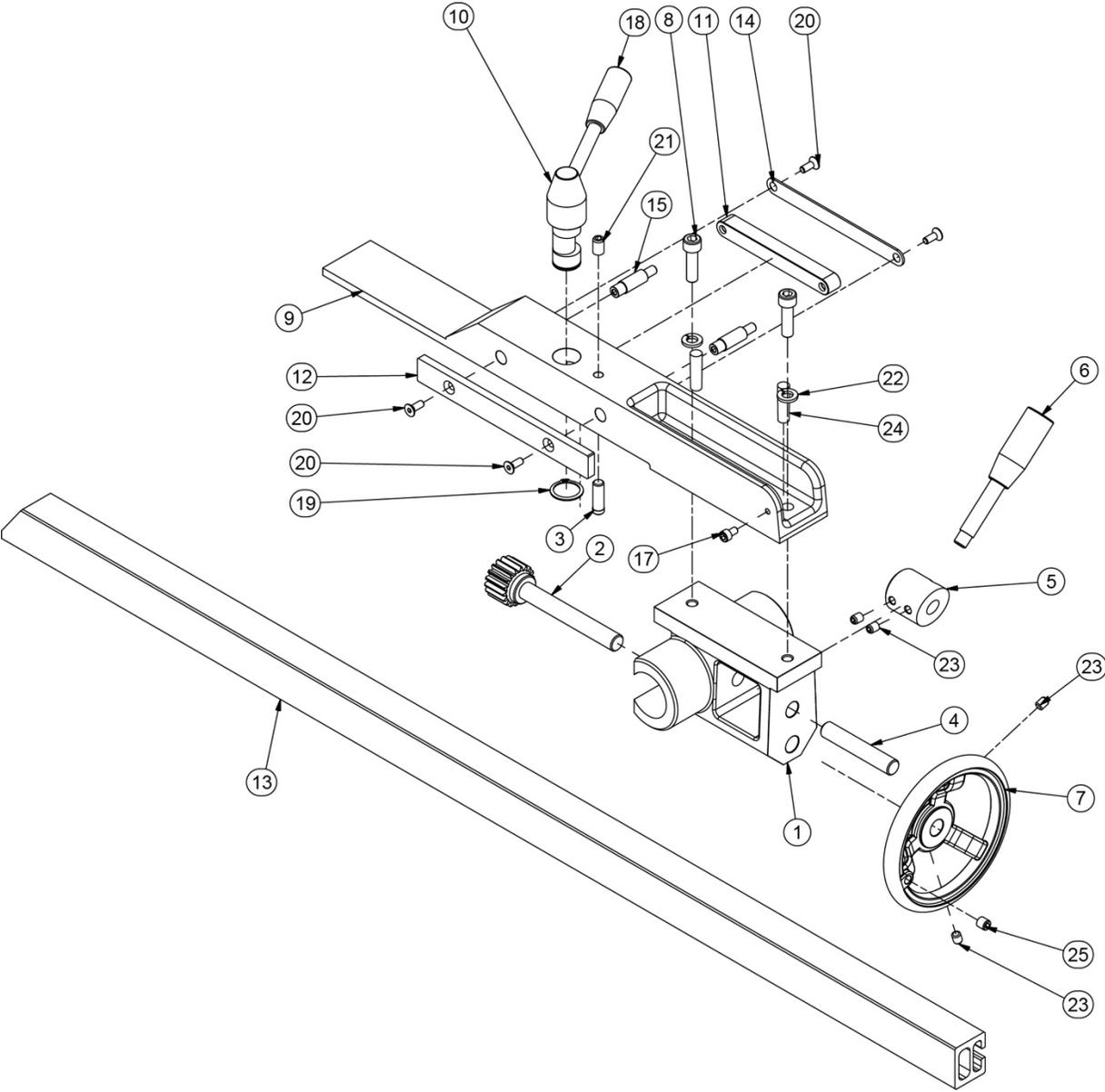
# Table and Stand Assembly – Exploded View



## Parts List: Table and Stand Assembly

| Index No. | Part No.   | Description             | Size            | Qty |
|-----------|------------|-------------------------|-----------------|-----|
| 1         | SLR12-423  | Oil Reservoir Contactor |                 | 1   |
| 2         | TS-1533032 | Pan Head Machine Screw  | M5 x 8          | 10  |
| 3         | TS-1534042 | Pan Head Machine Screw  | M6 x 12         | 12  |
| 4         | TS-2246202 | Socket HD Button Screw  | M6 x 20         | 4   |
| 5         | TS-1505031 | Socket Head Cap Screw   | M10 x 25        | 4   |
| 6         | TS-1505061 | Socket Head Cap Screw   | M10 x 40        | 4   |
| 7         | TS-1506041 | Socket Head Cap Screw   | M12 x 35        | 4   |
| 8         | TS-1502041 | Socket Head Cap Screw   | M5 x 16         | 4   |
| 9         | TS-1503031 | Socket Head Cap Screw   | M6 x 12         | 5   |
| 10        | TS-1503041 | Socket Head Cap Screw   | M6 x 16         | 4   |
| 11        | TS-1524051 | Socket Set Screw        | M8 x 20         | 1   |
| 12        | TS-1491051 | Hex Cap Screw           | M10 x 35        | 3   |
| 13        | TS-149B15  | Hex Cap Screw           | M16 x 80        | 4   |
| 14        | TS-1490061 | Hex Cap Screw           | M8 x 35         | 1   |
| 15        | TS-1540071 | Hex Nut                 | M10             | 1   |
| 16        | TS-2311161 | Hex Nut                 | M16             | 4   |
| 17        | TS-1540061 | Hex Nut                 | M8              | 6   |
| 18        | TS-2361101 | Lock Washer             | M10             | 6   |
| 19        | TS-2361121 | Lock Washer             | M12             | 4   |
| 20        | TS-2361061 | Lock Washer             | M6              | 5   |
| 21        | TS-1550071 | Flat Washer             | M10             | 4   |
| 22        | TS-2360121 | Flat Washer             | M12             | 4   |
| 23        | TS-1550041 | Flat Washer             | M6              | 4   |
| 24        | SLR12-413  | Retaining Ring          | S12             | 2   |
| 25        | SLR12-436  | Panel                   |                 | 1   |
| 26        | SLR12-419  | Scale                   |                 | 1   |
| 27        | SLR12-424  | Oil Tube                | O.D. 4 x 2.5 mm | 5   |
| 28        | SLR12-451  | Foot Pad                |                 | 4   |
| 29        | SLR12-401  | Bracket                 |                 | 1   |
| 30        | SLR12-407  | Cover                   |                 | 1   |
| 31        | SLR12-405  | Stand                   |                 | 1   |
| 32        | SLR12-409  | Bracket                 |                 | 2   |
| 33        | SLR12-420  | Gear Column             |                 | 1   |
| 34        | SLR12-422  | Cover                   |                 | 1   |
| 35        | SLR12-406  | Cover Plate             |                 | 1   |
| 36        | SLR12-447  | Bracket                 |                 | 1   |
| 37        | SLR12-446  | Shaft                   |                 | 1   |
| 38        | SLR12-402  | Cover                   |                 | 1   |
| 39        | SLR12-445  | Bracket                 |                 | 1   |
| 40        | SLR12-404  | Cover                   |                 | 1   |
| 41        | SLR12-428  | Control Box             |                 | 1   |
| 42        | SLR12-421  | Oil Reservoir           |                 | 1   |
| 43        | SLR12-452  | Support Column          |                 | 1   |
| 44        | SLR12-453  | Rotating Seat           |                 | 1   |
| 45        | SLR12-454  | Support Tube            |                 | 1   |
| 46        | TS-1550041 | Flat Washer             | M6              | 3   |
| 47        | SLR12-444  | Handle                  |                 | 2   |
| 48        | SLR12-448  | Spring                  |                 | 1   |
| 49        | SLR12-437  | Emergency Stop Button   |                 | 1   |
| 50        | SLR12-440  | Stop Button             |                 | 2   |
| 51        | SLR12-438  | Start Button            |                 | 2   |
| 52        | SLR12-442  | Power Indicator         |                 | 1   |

# Fence Assembly – Exploded View

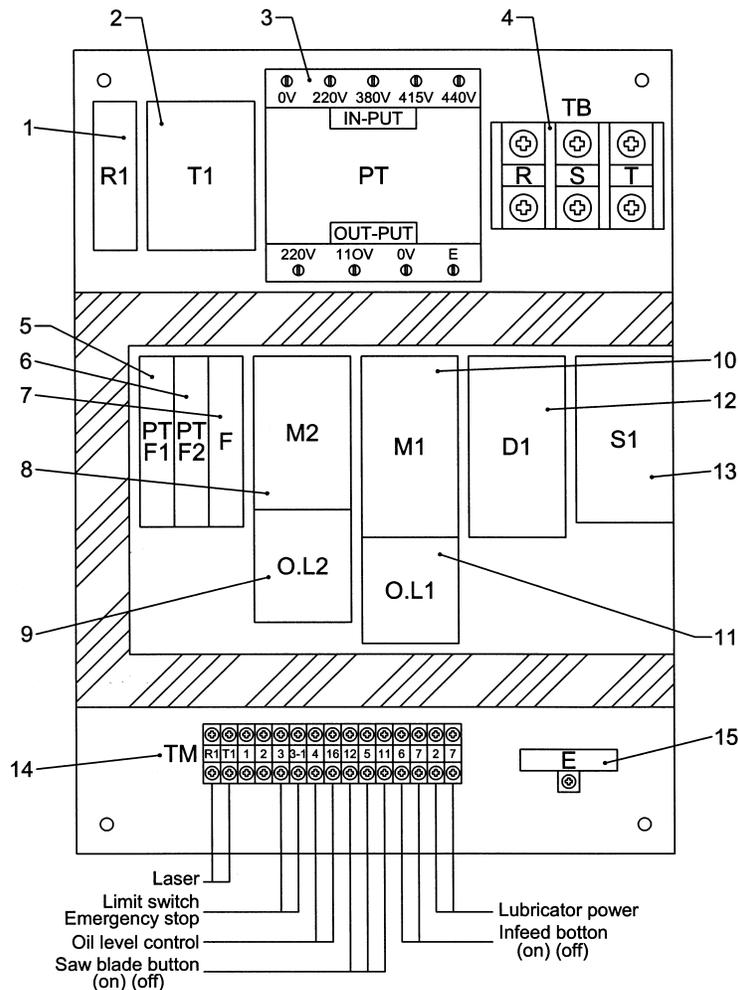


## Parts List: Fence Assembly

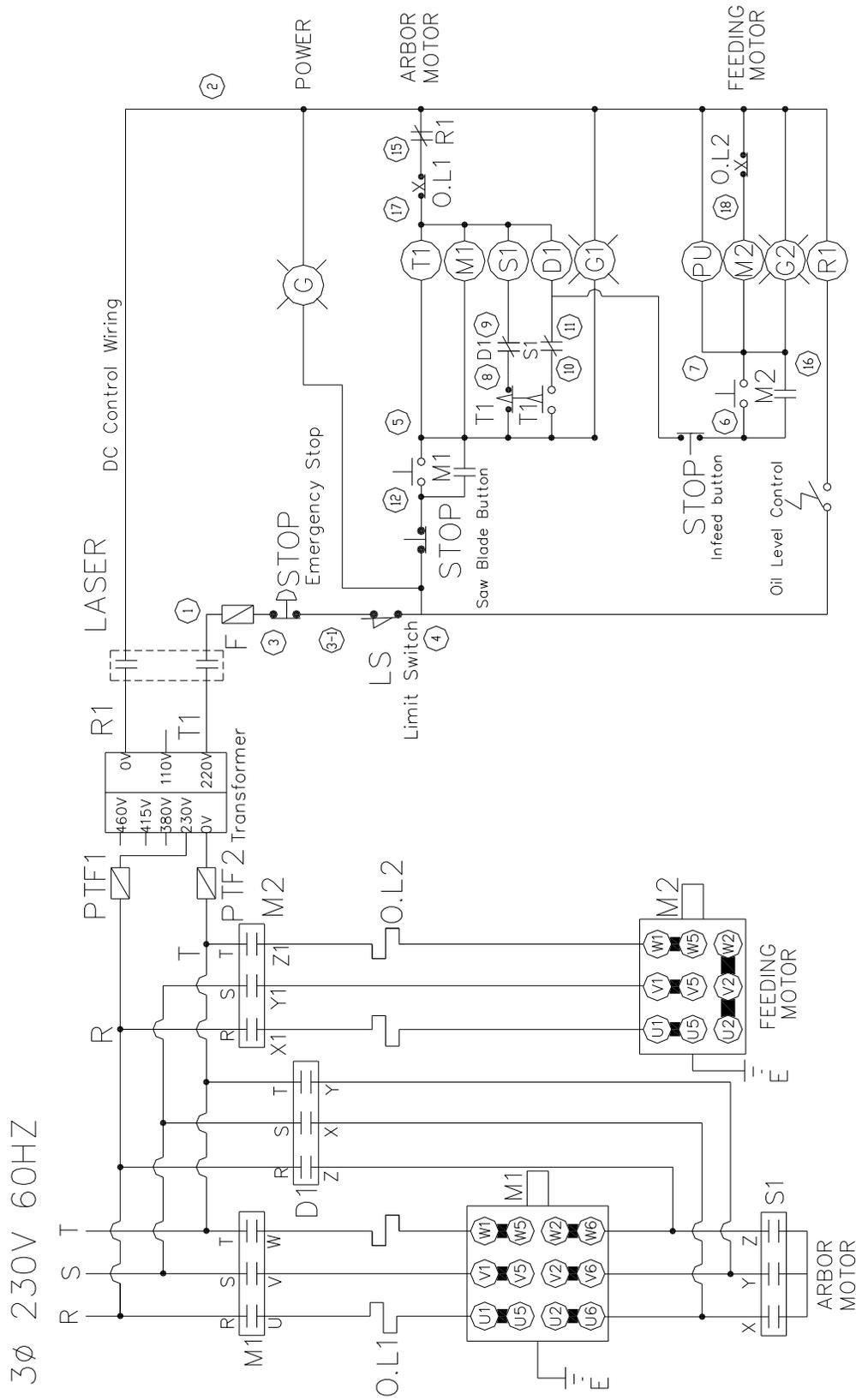
| Index No. | Part No.     | Description                                       | Size         | Qty |
|-----------|--------------|---|--------------|-----|
|           | SLR12-400FAN | Fence Complete Assembly (Index 1-7, 10-15, 17-25) |              | 1   |
| 1         | SLR12-414N   | Gear Box  |              | 1   |
|           | SLR12-414NK  | Gear Box Kit (includes #4 thru 6)                 |              | 1   |
| 2         | SLR12-408N   | Gear  |              | 1   |
| 3         | SLR12-411    | Special Screw                                     |              | 1   |
| 4         | SLR12-418N   | Shaft   |              | 1   |
| 5         | SLR12-417N   | Setting Block                                     |              | 1   |
| 6         | SLR12-416N   | Knob Handle                                       |              | 1   |
| 7         | SLR12-415    | Handwheel   | Dia. 150 mm  | 1   |
| 8         | TS-1505051   | Socket Head Cap Screw                             | M10 x 35     | 2   |
| 9         | SLR12-410    | Fence   |              | 1   |
| 10        | SLR12-432    | Lock Lever  |              | 1   |
| 11        | SLR12-433    | Clamp   |              | 1   |
| 12        | SLR12-431    | Clamping Strip                                    |              | 1   |
| 13        | SLR12-429    | Side Plate  |              | 1   |
| 14        | SLR12-434    | Cover   |              | 1   |
| 15        | SLR12-483    | Clamping Shaft                                    |              | 2   |
| 17        | TS-1523031   | Socket Head Cap Screw                             | M6 x 10      | 1   |
| 18        | SLR12-449    | Knob Handle                                       |              | 1   |
| 19        | SLR12-430    | Retaining Ring                                    | C25          | 1   |
| 20        | TS-1514021   | Socket HD Flat Screw                              | M6 x 16      | 4   |
| 21        | TS-1525031   | Socket Set Screw                                  | M10 x 16     | 1   |
| 22        | TS-2361101   | Lock Washer                                       | M10          | 2   |
| 23        | TS-1524021   | Socket Set Screw                                  | M8 x10       | 4   |
| 24        | SLR12-412    | Taper Pin   | 10-40        | 2   |
| 25        | TS-0271031   | Socket Set Screw                                  | 3/8-16 x 3/8 | 1   |

# Electrical Control Panel (SLR12-443) – Parts List & Diagram

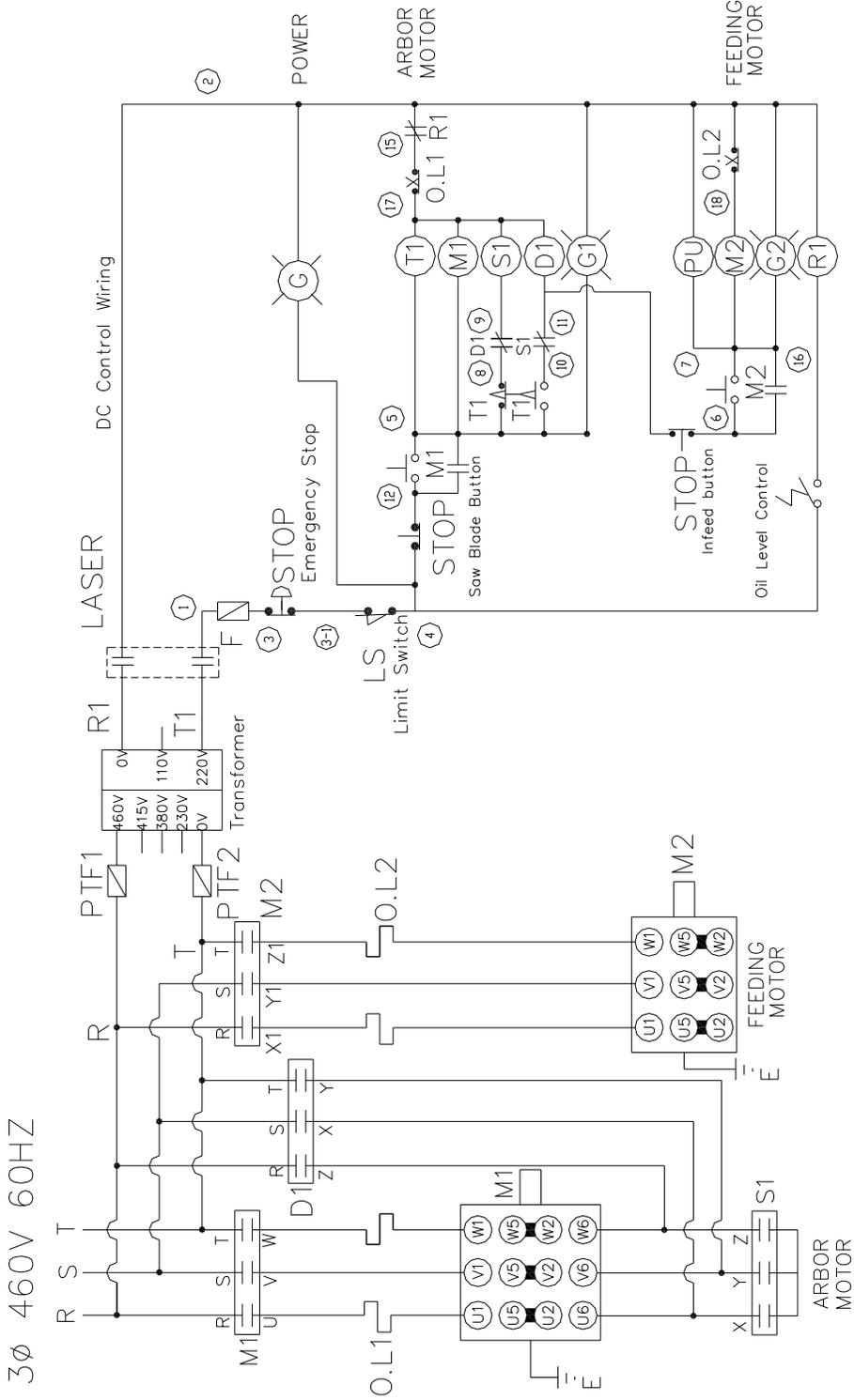
| Index No. | Part No.    | Description         | Size       | Qty  |
|-----------|-------------|---------------------|------------|--|
| 1         | SLR12-601   | Control Relay       | R1         | MY2NJ-200/220VAC .. 1                                    |
| 2         | SLR12-602   | Timer               | T1         | 1  |
| 3         | SLR12-603   | Transformer         | PT         | 0V~440V .. 1   |
| 4         | SLR12-604   | Terminal Plate      | TB         | 1  |
| 5         | SLR12-605   | Fuse                | PTF1       | 10x38-4A .. 1  |
| 6         | SLR12-606   | Fuse                | PTF2       | 10x38-4A .. 1  |
| 7         | SLR12-607   | Fuse                | F          | 10x38-4A .. 1  |
| 8         | SLR12-608   | Switch              | M2         | LC1D096 .. 1   |
| 9         | SLR12-609   | Conveyor Overload   | OL2 (230V) | LR3D12 5.5~8A .. 1                                       |
|           | SLR12-609A  | Conveyor Overload   | OL2 (460V) | LR3D10 4~6A .. 1   |
|           | SLR12-609AA | Conveyor Overload   | OL2 (460V) | LR3D08 2.5~4A<br><i>s/n 1703SLR12256 and higher</i> .. 1 |
| 10        | SLR12-610   | Switch              | M1         | LC1D256 .. 1   |
| 11        | SLR12-611   | Main Motor Overload | OL1 (230V) | LR3D22, 16~24A .. 1                                      |
|           | SLR12-611A  | Main Motor Overload | OL1 (460V) | LR3D16, 9~13A .. 1                                       |
| 12        | SLR12-612   | Switch              | D1         | LC1D256 .. 1   |
| 13        | SLR12-613   | Switch              | S1         | LC1D186 .. 1   |
| 14        | SLR12-614   | Terminal            | TM         | 1  |
| 15        | SLR12-615   | Grounding Block     | G          | 1  |



# Electrical Connections – 3 Phase, 230V, 60Hz



# Electrical Connections – 3 Phase, 460V, 60Hz



# Preventive Maintenance

## Checklist for Model SLR12 Straight Line Rip Saw

- [ ] Work area around machine marked off clearly.
- [ ] Non-skid floor strips in area where operator normally stands.
- [ ] Inspect entire machine for loose bolts, nuts, screws. Tighten and replace as necessary.
- [ ] Clean table area, removing sawdust and chips with a soft bristle brush. Remove gum and pitch with oven cleaner.
- [ ] Lubricate appropriate places with a good grade non-hardening grease.
- [ ] Clean table and fence surface. If rusted, use paste mixture of household ammonia, a good commercial detergent and 000 steel wool. Wash surface down with hot, soapy water, rinse and dry thoroughly. Coat surface with talcum powder, rubbing briskly into surface with a clean blackboard eraser.
- [ ] Check blade condition; should be sharp and free of nicks or grooves.
- [ ] Check belt condition. Replace as needed. Dress with paraffin. Check belt tension.
- [ ] Check motor for loose wiring and sawdust congestion, pulleys tight and in line.
- [ ] Check bearings. Replace any bad or suspect bearings immediately.
- [ ] Fence properly aligned with blade.

# Warranty and Service

Powermatic warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

## Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official Powermatic branded website.

- Powermatic products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90-day limited warranty against manufacturer's defects.

## Who is Covered?

This warranty covers only the initial purchaser of the product from the date of delivery.

## What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations, or lack of maintenance. Powermatic woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

## Warranty Limitations

Woodworking products with a Five-Year Warranty that are used for commercial or industrial purposes default to a Two-Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

## How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. Powermatic has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the Powermatic website.

## More Information

Powermatic is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the Powermatic website.

## How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

## Limitations on This Warranty

POWERMATIC LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. POWERMATIC SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Powermatic sells through distributors only. The specifications listed in Powermatic printed materials and on the official Powermatic website are given as general information and are not binding. Powermatic reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

## Product Listing with Warranty Period

|   |
|---|
| 90 Days – Parts; Consumable items   |
| 1 Year – Motors, Machine Accessories                                      |
| 2 Year – Woodworking Machinery used for industrial or commercial purposes |
| 5 Year – Woodworking Machinery  |

NOTE: Powermatic is a division of JPW Industries, Inc. References in this document to Powermatic also apply to JPW Industries, Inc., or any of its successors in interest to the Powermatic brand.

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