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- Die Bohrung muss genau senkrecht sein, sonst führt dies zu einer ungleichmäßigen Abdichtung.
- Die Bohrung muss sauber und frei von Schmutz sein.

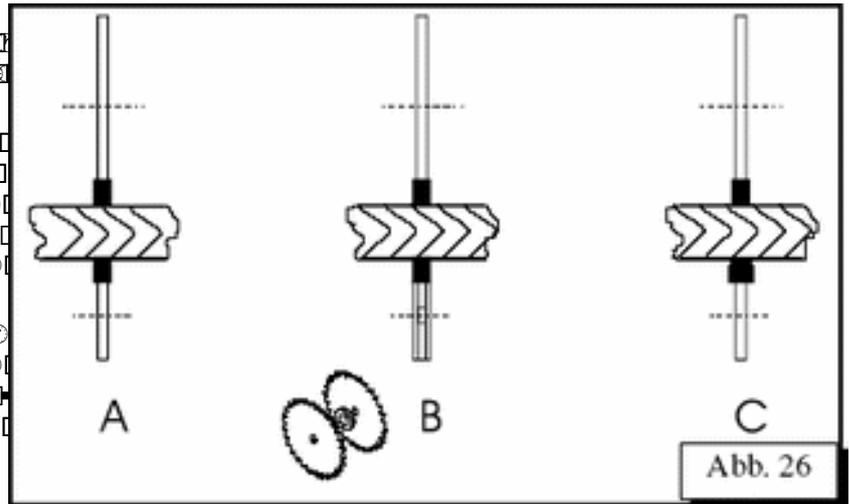


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5.3 Notes on using the panel saw

Cross-cutting of workpieces made of solid wood

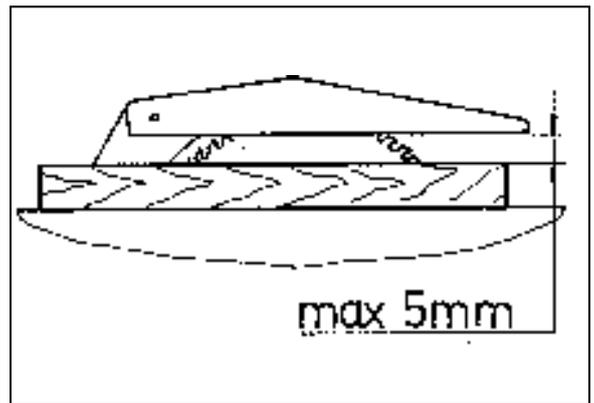
When performing this operation, the following equipment shall be used for safe working:

- The table extension
- the miter gauge
- the guard of the saw blade
- the riving knife
- the hold-down
- the insert in the table

Cutting boards

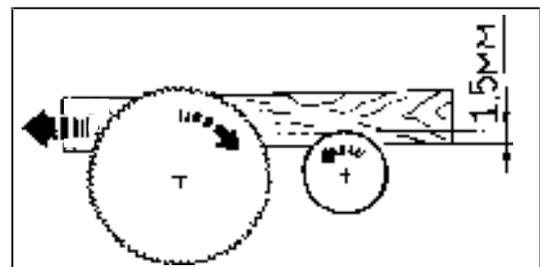
When performing this operation, the following equipment shall be used for safe working:

- The table extension
- the miter fence with support for the workpiece
- the guard of the saw blade
- the riving knife
- the hold-down
- the insert in the table



In some cases, it is the cutting of laminated boards required before using the scoring blade to prevent the demolition of the cutting edge with the main saw blade.

The scoring saw blade must be adjusted in height so that a slot with a depth of 1 - 1.5 mm results.



- Set the guard of the saw blade.
- Carry out the work evenly, without relapses and without take it back to the end of the cutting.
- Set the saw blade so high that the ring gear is really reliably covered by the protective cover (distance between the protective cover and the workpiece - max. 5 mm)
- Perform the adjustment of the saw blade height and tilt only with the machine switched off.

Work only with good grounds tools

- Use the push rod at the end of cutting when the distance between the circular saw blade and the parallel ruler is less than 120 mm.
- Make sure that the machine is working without vibrations.
- Cracked and deformed saw blades can not be repaired. You need to be sorted out immediately as a committee and be replaced by ordinary.

- For repair and maintenance of circular saw blades with soldered fins (eg. soldering new cutting blades) the construction of the circular saw blades (tooth shape, tooth width) must not be changed. The circular saw blades with soldered fins can be grinding up to minimum dimensions of the plate of 1 mm
- Then the circular saw blade must be removed from service.
- Select the number of teeth of the saw blade so that at least 2-3 teeth working simultaneously). If only one tooth works, a poor working surface is, the danger of the vibrations and noise pollution from increased setback increase.

7 MAINTENANCE

ATTENTION

**Don't clean or do maintenance on the machine while it is still connected to the power supply:
Damages to machine and injuries might occur due to unintended switching on of the machine!**



Therefore: Switch the machine off and disconnect it from the power supply before any maintenance works or cleaning is carried out

The machine is low maintenance and contains little parts that must undergo a maintenance operator.

Faults or defects that may affect the safety of the machine, must be rectified immediately. Repair work may only be performed by qualified personnel!

The complete and utter cleaning ensures a long life for the machine and represents a safety requirement.

After each shift the machine and all its parts must be thoroughly cleaned by the dust and swarf sucked through the suction system and all other waste is disposed of by compressed air.

Check regularly that all warning and safety instructions on the machine and available in a perfectly legible condition.

Check before every use the perfect condition of the safety devices.

For storage of this machine may not be stored in a humid room and must be protected from the influence of weather conditions.

- + **The elimination of defects does your dealer**
- + **Repair work may only be performed by qualified personnel!**

6.1 Cleaning

NOTE

The use of solvents, harsh chemicals or abrasive cleaners leads to damage to the machine!

Therefore: When cleaning water and mild detergent if necessary use.

Bare surfaces of the machine against corrosion impregnate (with anti-rust WD40)

6.2 Maintenance

All parts (except the bearings of the main saw mandrel) should be lubricated twice weekly.

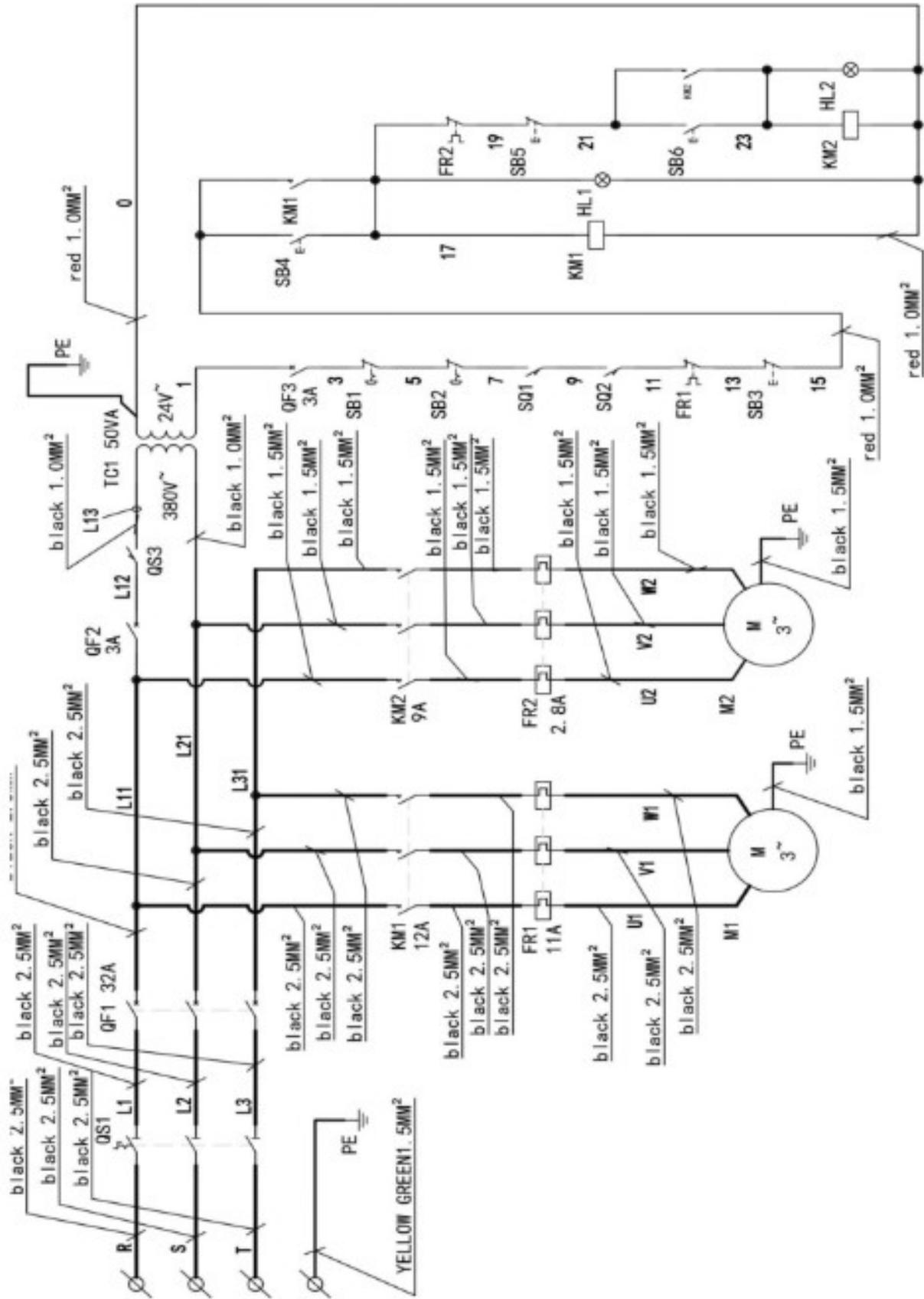
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TROUBLESHOOTING

Disconnect the machine from the power supply prior to any checks performed at the machine itself !

Trouble	Possible cause	Solution
Machine does not start	<ul style="list-style-type: none"> • Emergency stop switch to switch off • switch or a phase is broken • Overload protection is triggered. • Safety fuse is blown • Open cover plate for saw blades 	<ul style="list-style-type: none"> • Turn the emergency OFF switch to the right to unlock to • Repair the defective circuit or the faulty phase • Wait until the engine cools down • Replace the fuse • Cover plate close
Burn marks on the workpiece	<ul style="list-style-type: none"> • The blade is blunt 	<ul style="list-style-type: none"> • Replace the blade
Velocities different from the set value	<ul style="list-style-type: none"> • adjusted rulers 	<ul style="list-style-type: none"> • Make a right the attacks
The finished size of the machined workpiece is incorrect for the cutting width on rip fence	<ul style="list-style-type: none"> • Adjusted measurement scale for the cutting width display 	<ul style="list-style-type: none"> • Setting dimension scale: cut workpiece on the rip fence, measure the workpiece and the measuring scale move so that the measured average width is shown at the edge of the ruler
Sliding table at end positions higher than machine table	<ul style="list-style-type: none"> • Lower rollers set incorrectly 	<ul style="list-style-type: none"> • Adjust the lower rollers
Workpiece clamped while advancing	<ul style="list-style-type: none"> • dull blade • Riving knife thickness does not match the used blade 	<ul style="list-style-type: none"> • Replace with sharp blade • Splitting wedge thickness must be leader than or equal to blade thickness.
Broken edges on the work-piece	<ul style="list-style-type: none"> • The scoring saw is not on the same line with the main saw 	<ul style="list-style-type: none"> • Set the scoring saw a new
Arm running smoothly	<ul style="list-style-type: none"> • Telescopic tube or track rollers dirty 	<ul style="list-style-type: none"> • telescopic tube or track rollers clean • Check wipers

8 ELECTRIC DIAGRAM



9 SPARE PARTS

9.1 spare parts order

With original spare parts you use parts that are attuned to each other shorten the installation time and elongate your machines lifespan.

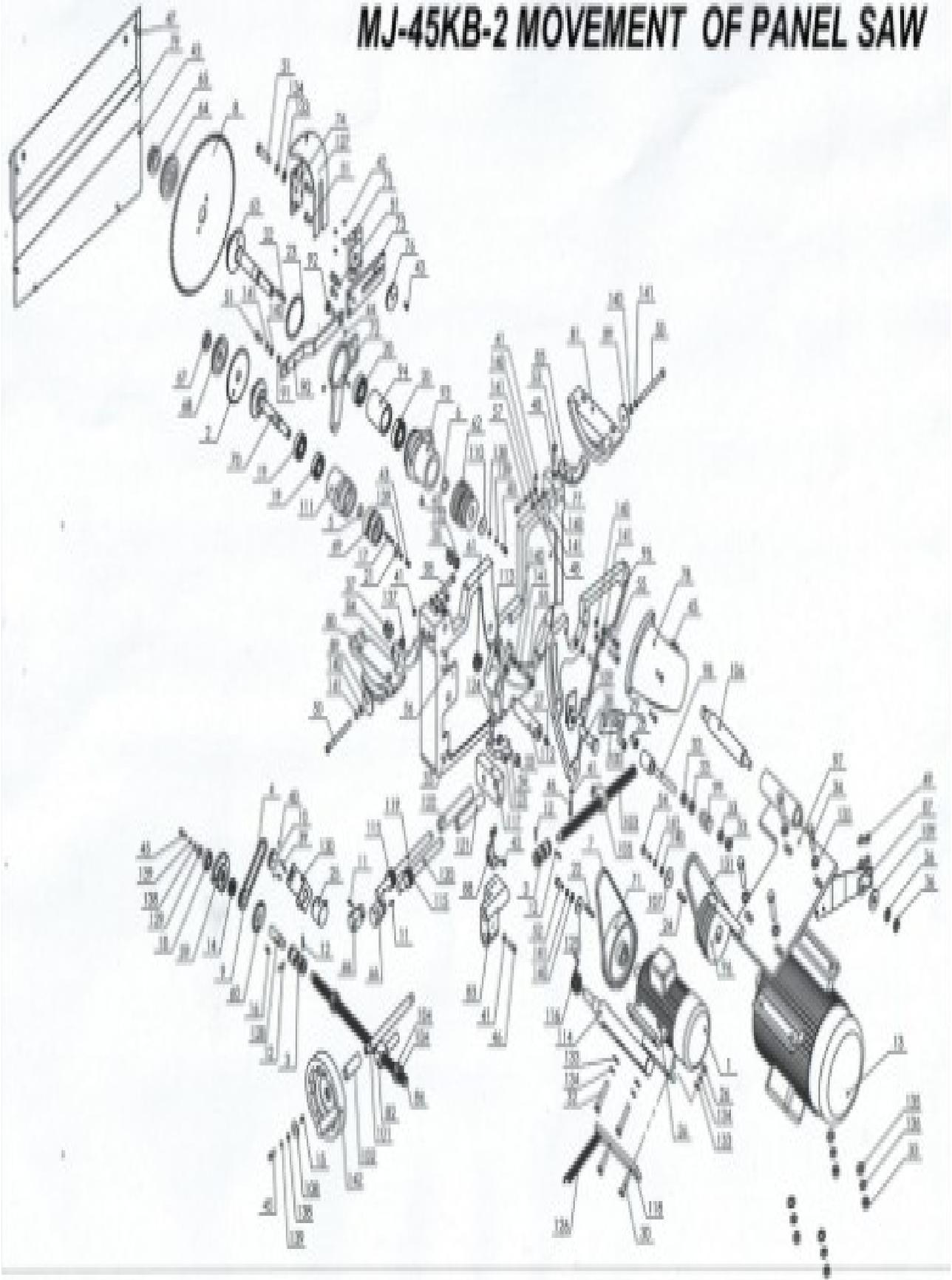
IMPORTANT

The installation of other than original spare parts voids the warranty! So you always have to use original spare parts

By the order of spare parts use the service formular that you can find at the end of this manual. Make always a note of the type, spare part number and a definition of the machine. That there are no mistakes, we recommend to make a copy of the spare part list where you can mark with a pen the spare parts which you order.

[You find the order address in the preface of this operation manual.](#)

MJ-45KB-2 MOVEMENT OF PANEL SAW



10 CERTIFICATE OF CONFORMITY



MANUFACTURER
SHENYANG LEAD MACHINERY MANUFACTURE CO.,LTD
No.31 Hongrun Road, Yuhong District,Shenyang, China

Fax 0086 024 2932 6866

this machine is manufactured under request of:
FREUTEK srl - ITALY

name	
	Panel saw
Type / model	
	MJ-45K,MJ-45KB,MJ-45KB-2,MJ-45KA,PS2600,MJ-45KC,MJ-45KD,MJ-45KE,MJ-45M,PS1600,FKS305VF,FKS315VF,FKS315VFN
EC-directives	
	2006/42/EC
applicable Standards	
Hereby we declare that the above mentioned machines meet the essential safety and health requirements of the above stated EC directives. Any manipulation or change of the machine not being explicitly authorized by us in advance renders this document null and void. EN 60204-1:2006+A1:2009 EN 60770-1:2013	

11 GUARANTEE TERMS

Please consult our troubleshooting section for initial problem solving. Feel free to contact us for Customer Support!

Warranty claims based on your sales contract, including your statutory rights, shall not be affected by this guarantee declaration. Freutek grants guarantee according to following conditions:

- A) The guarantee covers the correction of deficiencies to the tool/machine, at no charge, if it can be verified adequately that the deficiencies were caused by a material or manufacturing fault.
- B) The guarantee period lasts 12 months, and is reduced to 6 months for tools in commercial use. The guarantee period begins from the time the new tool is purchased from the first end user. The starting date is the date on the original delivery receipt, or the sales receipt in the case of pickup by the customer.
- C) Please lodge your guarantee claims you acquired the claimed tool from with following information:
- > Original Sales receipt and/or delivery receipt
 - > Service form (see next page) filed, with a sufficient deficiency report
 - > for spare part claims: a copy of the respective exploded drawing with the required spare parts being marked clear and unmistakable.
- D) The Guarantee handling procedure and place of fulfillment is determined according to Freutek sole discretion. Transport charges for sending to and from our Service Center are not covered in this guarantee.
- E) The Guarantee does not cover:
- Wear and tear parts like belts, provided tools etc., except to initial damage which has to be claimed immediately after receipt and initial check of the machine.
 - Defects in the tool caused by non-compliance with the operating instructions, improper assembly, insufficient power supply, improper use, abnormal environmental conditions, inappropriate operating conditions, overload or insufficient servicing or maintenance.
 - Damages being the causal effect of performed manipulations, changes, additions made to the machine.
 - Defects caused by using accessories, components or spare parts other than original spare parts.
 - Slight deviations from the specified quality or slight appearance changes that do not affect functionality or value of the tool.
 - Defects resulting from a commercial use of tools that - based on their construction and power output - are not designed and built to be used within the frame of industrial/commercial continuous load.
- F) Claims other than the right to correction of faults in the tool named in these guarantee conditions are not covered by our guarantee.
- G) This guarantee is voluntary. Therefore Services provided under guarantee do not lengthen or renew the guarantee period for the tool or the replaced part.

SERVICE

After Guarantee and warranty expiration specialist repair shops can perform maintenance and repair jobs. But we are still at your service as well with spare parts and/or machine service. Place your spare part / repair service cost inquiry by filing the SERVICE form on the following page and send it:

via Mail to info@freutek.com

Product experience form

We observe the quality of our delivered products in the frame of a Quality Management policy.

Your opinion is essential for further product development and product choice. Please let us know about your:

- Impressions and suggestions for improvement.
- experiences that may be useful for other users and for product design
- Experiences with malfunctions that occur in specific operation modes

We would like to ask you to note down your experiences and observations and send them to us via FAX, E-Mail or by post:

My experiences:

Name: Product: Purchasedate: Purchasedfrom :MyEmail:
Thankyouforyourkindcooperation!

CONTACTS: Freutek Srl C.so Tassoni 21 (To) Italy www.freutek.com Made in Prc
