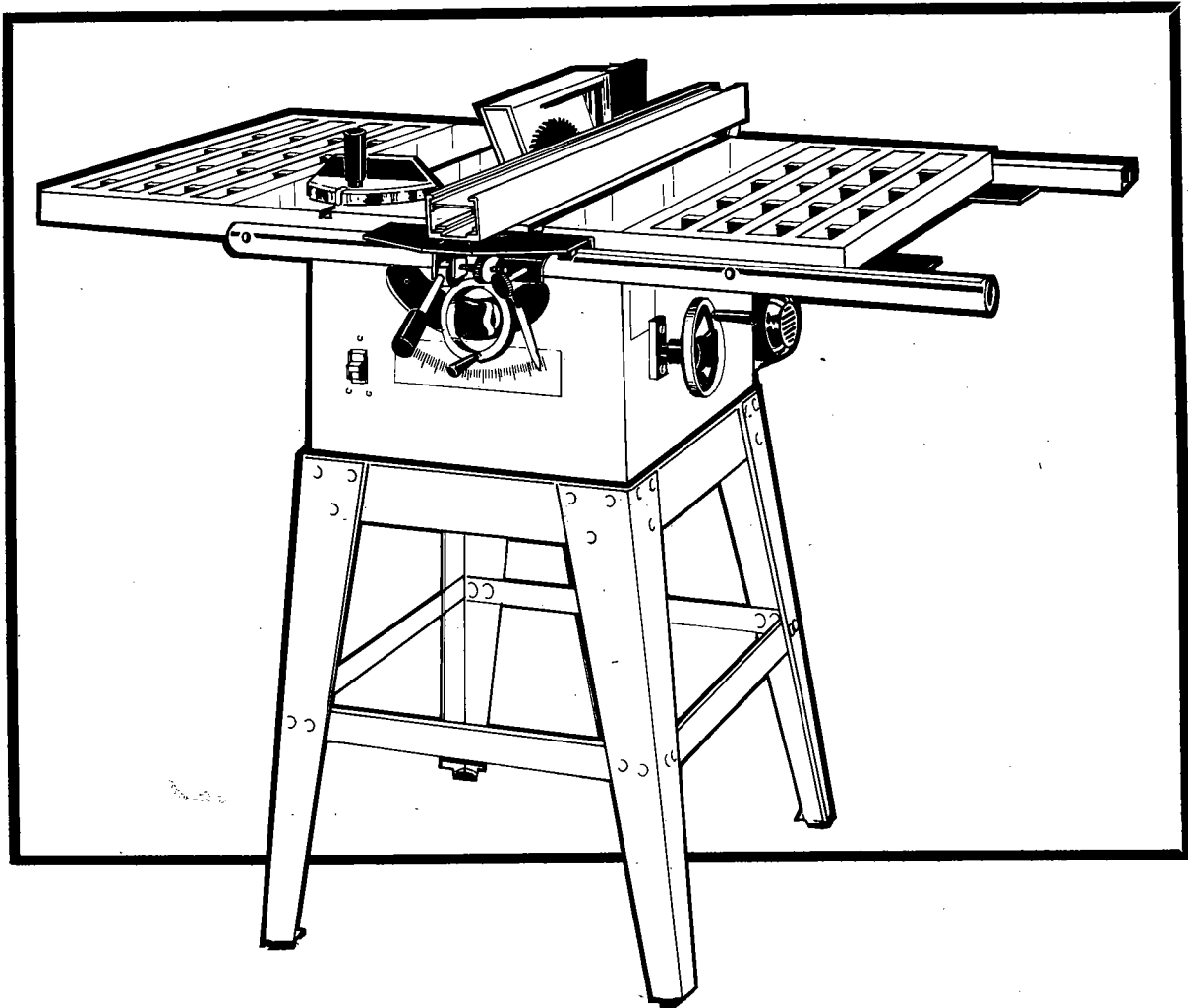


EDP 0460174

Model 63, 10" Artisan's Saw

INSTRUCTION MANUAL



Better By Design™

POWERMATIC® ®

McMINNVILLE, TENNESSEE 37110 □ AC 615-473-5551

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FOREWORD

This manual has been prepared for the owner and those responsible for the maintenance of a **Powermatic Model 63, 10" Artisan's Saw**.

Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operation and maintenance procedures. Read the safety and maintenance instructions thoroughly before operating or servicing the machine.

In order to obtain maximum life and efficiency from your **Powermatic 10" Artisan's Saw** and to aid in operating and maintaining the artisan's saw with safety, read this manual thoroughly and follow all instructions carefully.

The specifications put forth in this manual were in effect at the time of publication. However, owing to **Powermatic's** policy on continuous improvement, changes to these specifications may be made at any time without obligation on the part of **Powermatic**.

The information and recommendations contained in this publication come from sources believed to be reliable and to represent the best current practice. Powermatic does not intend this manual to be a complete course of instruction on how to use this machine with safety and does not guarantee or represent that the information is absolutely correct or sufficient. In addition, it cannot be assumed that all acceptable safety measures are listed or that other additional measures are not needed under particular or exceptional circumstances or conditions.

WARNING

FOR YOUR OWN SAFETY READ INSTRUCTION
MANUAL BEFORE OPERATING TABLE SAW

1. Wear eye protection.
2. Use saw-blade guard and spreader for every operation for which it can be used, including all thru sawing.
3. Keep hand out of line with saw blade.
4. Use a push-stick when required.
5. Know how to reduce risk of kickback.
6. Do not perform any operation free hand.
7. Never reach in back of or over the saw blade.

SAFETY: General Rules

As with all power tools there is a certain amount of hazard involved with the operator and use of the tool. Use the tool with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or completely ignored, personal injury to the operator can develop.

1. **KNOW YOUR POWER TOOL.** Read the owner's manual carefully. Learn the tools applications and limitations, as well as the specific potential hazards peculiar to it.
2. **KEEP GUARDS IN PLACE** and in working order.
3. **GROUND ALL TOOLS.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.
4. **REMOVE ADJUSTING KEYS AND WRENCHES.** From habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
5. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
6. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
7. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
8. **MAKE WORKSHOP KIDPROOF** - with padlocks, master switches, or by removing starter keys.
9. **DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
10. **USE RIGHT TOOL.** Don't force tool or attachment to do a job it was not designed for.
11. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, or jewellery to get caught in moving parts. Nonslip footwear is

recommended. Wear protective hair covering to contain long hair.

12. **USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty.
13. **SECURE WORK.** Use clamps or a vise to hold work, when practical. It's safer than using your hand and frees both hands to operate tool.
14. **DON'T OVERREACH.** Keep your proper footing and balance at all times.
15. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters.
17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause hazards.
18. **AVOID ACCIDENTAL STARTING.** Make sure switch is in "OFF" position before plugging in cord.
19. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
20. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that 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.
21. **DIRECTION OF FEED.** Feed work into a

blade or cutter against the direction of rotation of the blade or cutter only.

22. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

SAFETY: Specific Rules

WORK AREA: Keep the floor around the machine clean and free of scrap material, saw dust, oil and grease to minimize the danger of tripping or slipping. Be sure the table is free of all scrap, foreign material and tools before starting to cut. Powermatic recommends the use of anti-skid floor strips on the floor area where the operator normally stands and that each machine's work area be marked off. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Provide adequate work space around the machine.

GUARDS: Keep the machine guards in place for every operation on which they can be used. If any guards are removed for maintenance, DO NOT OPERATE the machine until the guards are reinstalled.

ALIGNMENT: Check the alignment of the splitter, fence and miter slot to the blade. Note: A caution decal is attached to warn against the hazards of misalignment.

MAINTAIN TOOLS IN TOP CONDITION: Check the saw blade or cutter for cracks or missing teeth. Do not use a cracked or dull blade or one with missing teeth or improper set. Make sure the blade or cutter is securely locked on the arbor.

OPERATOR POSITION: Do not stand in line with the saw blade or work piece and do not allow anyone else to do so. Never climb on or near the saw.

WARNING: ALWAYS KEEP ALERT. DO NOT ALLOW FAMILIARITY GAINED FROM FREQUENT USE OF YOUR SHAPER TO CAUSE A CARELESS MISTAKE. ALWAYS REMEMBER THAT A CARELESS FRACTION OF A SECOND IS SUFFICIENT TO INFLICT SEVERE INJURY.

23 DRUGS, ALCOHOL, MEDICATION. Do not operate tool while under the influence of drugs, alcohol or any medication.

READ, UNDERSTAND & FOLLOW the safety and operating instructions found in this manual. Know the limitations and hazards associated with this saw. A Safety Rules decal is installed on each machine to serve as a reminder of basic safety practice.

GROUNDING OF THE TABLE SAW: Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.

EYE SAFETY: Wear an approved safety shield, goggles, or glasses to protect eyes when operating the table saw.

PERSONAL PROTECTION: Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. Protective type footwear should be used. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations use hearing protective devices. Do not wear gloves.

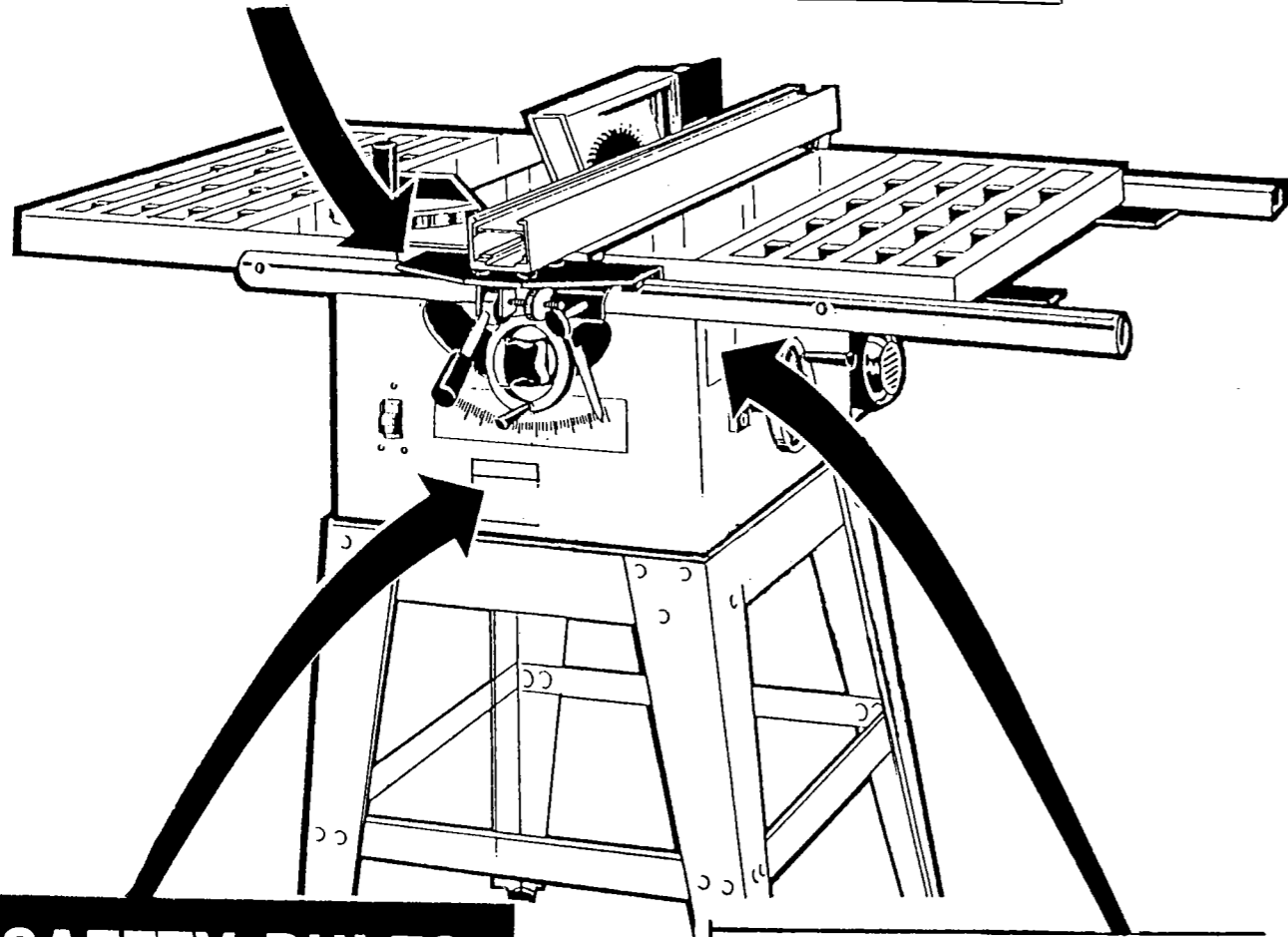
HAND SAFETY: Keep hands clear of the blade area. Do not reach past the blade to clear parts or scrap with the saw blade running. Never saw free hand. Avoid awkward operations and hand positions where a sudden slip could cause your hand to contact the blade.

SAFETY: Decal Instruction

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CAUTION

**DO NOT START SAW
WITHOUT ALIGNING
SPLITTER TO BLADE**



SAFETY RULES

CAREFULLY READ INSTRUCTION MANUAL BEFORE OPERATING MACHINE.
DO NOT OPERATE WITHOUT ALL GUARDS AND COVERS IN POSITION.
BE SURE MACHINE IS ELECTRICALLY GROUNDED.
REMOVE OR FASTEN LOOSE ARTICLES OF CLOTHING SUCH AS NECKTIES, ETC. CONFINE HAIR.
REMOVE JEWELRY SUCH AS FINGER RINGS, WATCHES, BRACELETS, ETC.
USE SAFETY FACE SHIELD, GOGGLES, OR GLASSES TO PROTECT EYES AND OTHER PERSONAL SAFETY EQUIPMENT AS REQUIRED.
STOP MACHINE BEFORE MAKING ADJUSTMENTS OR CLEANING CHIPS FROM WORK AREA.
KEEP THE FLOOR AROUND THE MACHINE CLEAN AND FREE FROM SCRAPS, SAWDUST, OIL OR GREASE TO MINIMIZE THE DANGER OF SLIPPING.

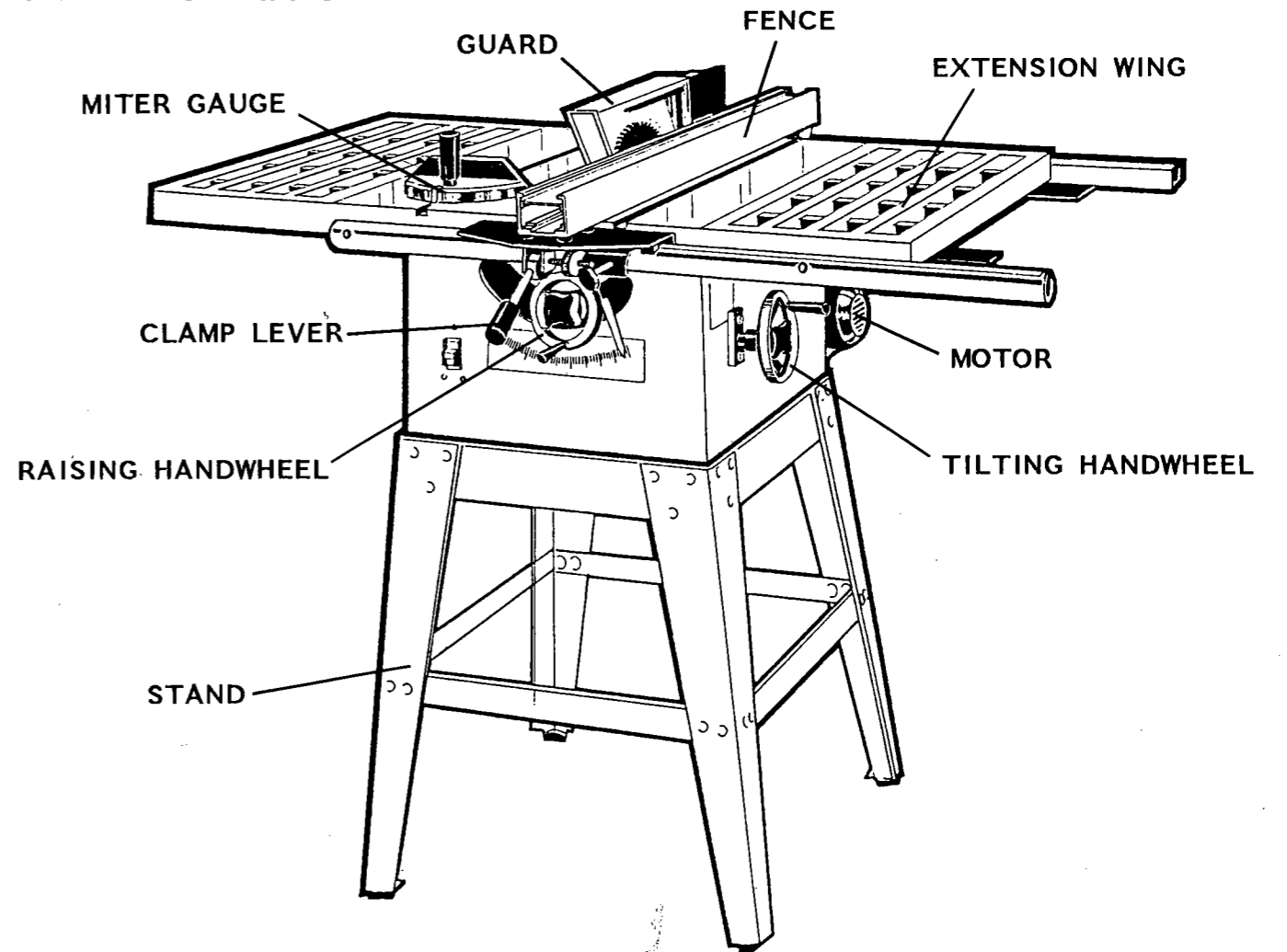
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WARNING

FOR YOUR OWN SAFETY READ INSTRUCTION MANUAL BEFORE OPERATING TABLE SAW

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2. Use saw-blade guard and spreader for every operation for which it can be used, including all thru sawing.
3. Keep hand out of line with saw blade.
4. Use a push-stick when required.
5. Know how to reduce risk of kickback.
6. Do not perform any operation free hand.
7. Never reach in back of or over the saw blade.

CONTROL LOCATIONS



SPECIFICATIONS

Table size with extensions.....	40-9/16 x 27
Blade size.....	5/8 arbor, 10" dia.
Fence size	2-1/2 high x 36" long
Motor.....	1-1/2 HP, 115/203V, 1 phase
Blade speed.....	4500 RPM
Max. depth of cut at 90	3-1/8
Max. depth of cut at 45	2-1/8
Blade tilt.....	45
Miter gauge adjustment.....	60 left or right

MACHINE INSTALLATION, ADJUSTMENTS, AND MAINTENANCE

RECEIVING THE ARTISAN'S SAW

Remove the artisan's saw and accessories from the shipping carton and inspect for damage. Any damage should be reported to your distributor and shipping agent immediately.

Before proceeding further, read your instruction manual thoroughly to familiarize yourself with proper assembly, set-up, maintenance and safety procedures.

Remove the protective coating from the saw table surface with a soft cloth moistened with a good commercial solvent. **DO NOT USE** acetone, gasoline, or lacquer thinner to remove the protective coating. An occasional coat of past wax on the table will allow the woodstock to glide smoothly across the work surface.

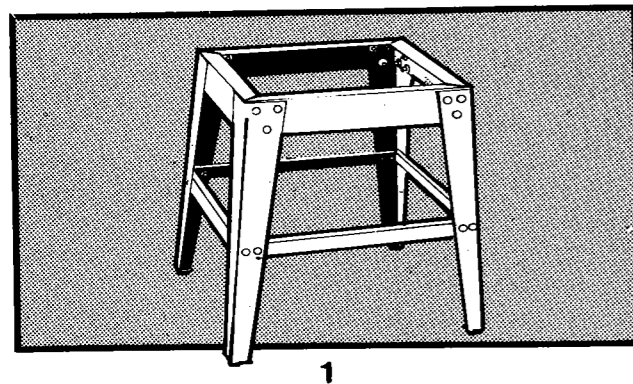
ASSEMBLY AND INSTALLATION OF SAW

The use of socket with a ratchet will lessen the assembly time required.

Mount machine on a solid foundation and lag to the floor through holes provided in legs of saw cabinet.

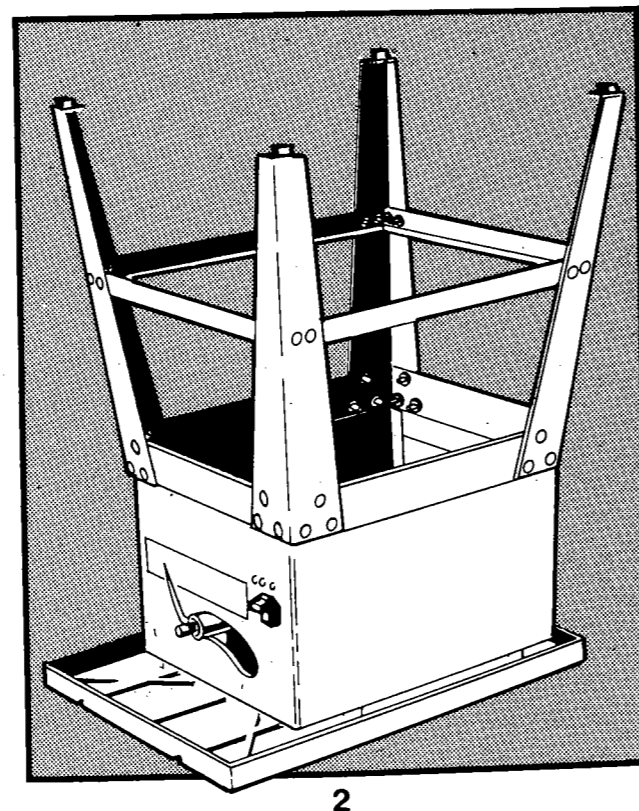
STAND ASSEMBLY

On a level surface, assemble the stand as shown in Fig. 1. Only finger tighten the screw, washer, and nut provided for each hole. When assembly is completed and all parts are aligned properly, tightly secure the screws and nuts.



SAW TO STAND ASSEMBLY

1. Place table top upside down with its surface on a flat floor, and mount stand, with legs upside down, to the cabinet as shown in Fig. 2.
2. Align the holes of stand with holes on bottom flange of saw base and tightly secure with bolts, nuts, and washers provided.
3. Carefully set the machine to its upright position.



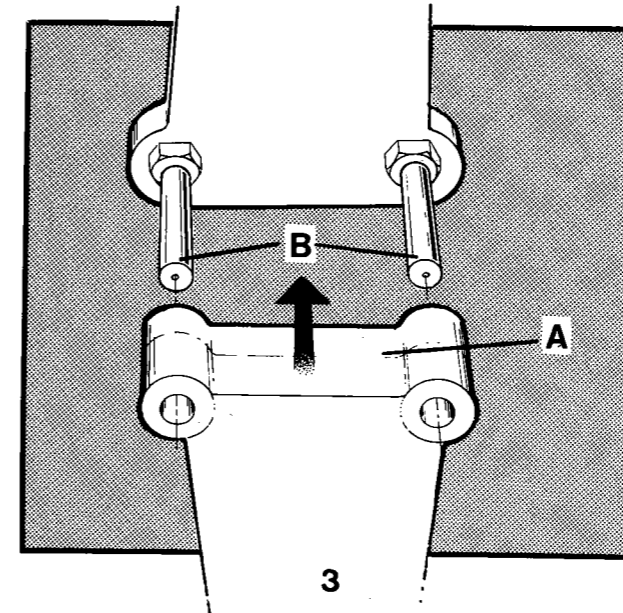
4. The machine should be placed on a solid foundation and lagged to the floor through holes provided in legs of the stand.

NOTE: If the saw is to be used without the stand provided, care must be taken to provide a hole in the wood stand or bench utilized by the operator to facilitate the removal of sawdust.

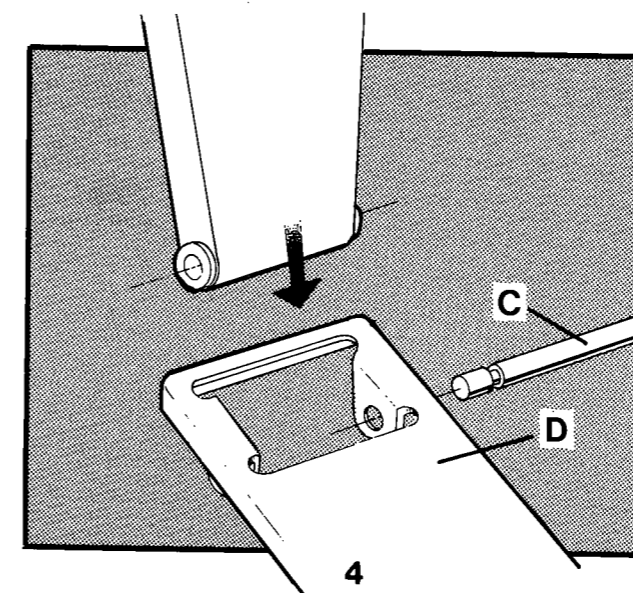
CAUTION: If there is any tendency to slide, walk, or tip over during operation, the stand or bench **MUST** be secured to the floor.

MOTOR MOUNTING BRACKET AND PLATE ASSEMBLY

1. By turning the side handwheel clockwise, set the blade arbor to its vertical position.
2. Mount the motor mounting bracket A to the two posts B as shown in Fig. 3 and secure with setscrews.



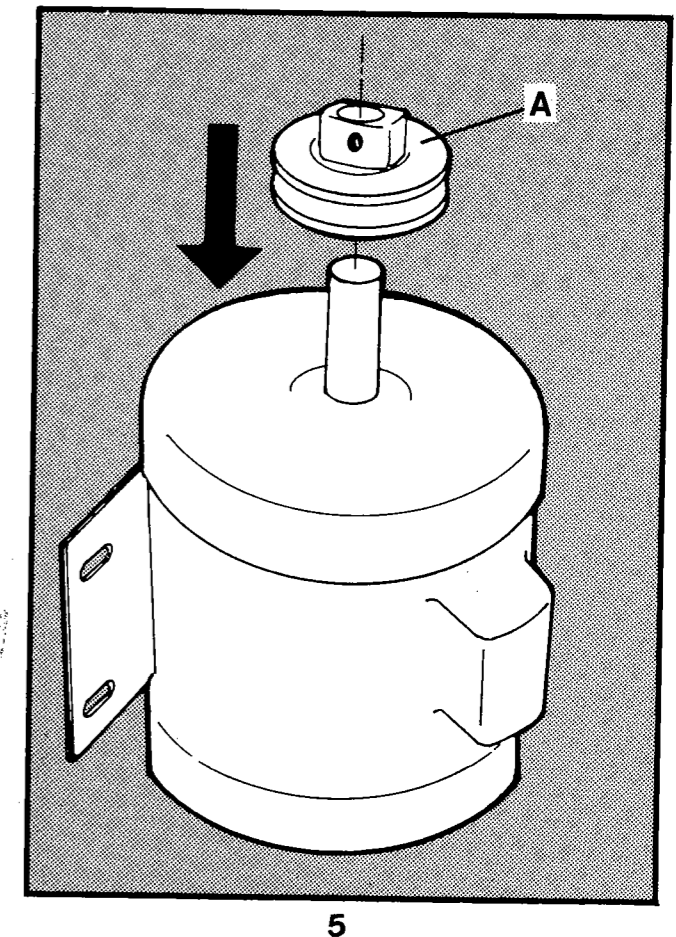
3. Loosen the pivot rod setscrew C and remove pivot rod from mounting bracket.
4. Assemble the motor mounting plate D, with ears down, to mounting bracket as shown in Fig. 4.



5. Replace pivot rod through plate and bracket and retighten pivot rod setscrew in V-groove.

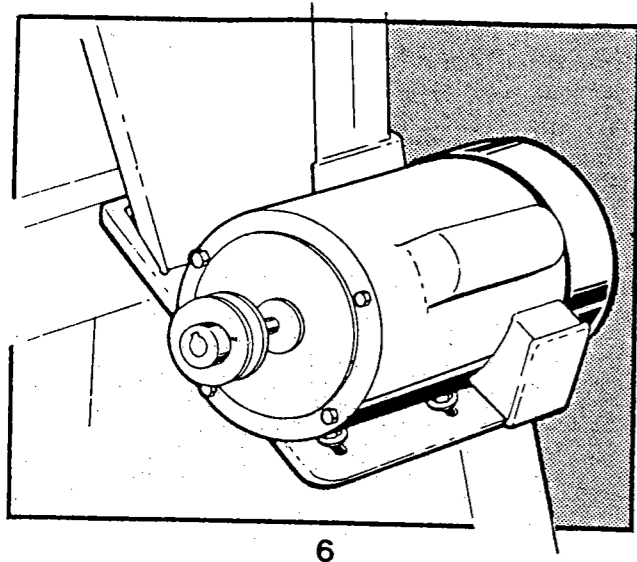
MOTOR BELT ASSEMBLY

Make sure the motor is **DISCONNECTED** from its power source and assemble to the saw as follows:



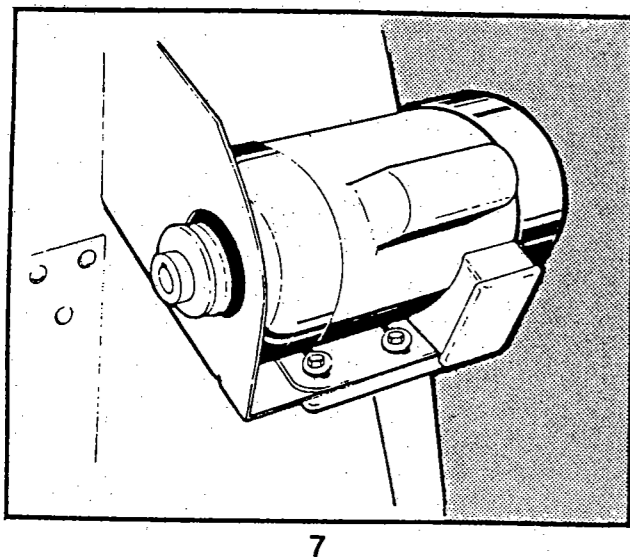
1. Mount the motor pulley A to the motor shaft as shown in Fig. 5.

2. Looking at machine from rear, position motor with shaft on the left side as seen in Fig. 6.



3. Attach motor to base plate B, using long bolts, nuts, and washers. **DO NOT TIGHTEN.**

4. Slide the belt and pulley guard bracket between the motor plate and motor mounting plate as shown in Fig. 7.



Care should be taken to make sure the motor pulley is centered through the hole of the guard bracket.

5. Snug motor mounting screws, washers, lock washers, and nuts.

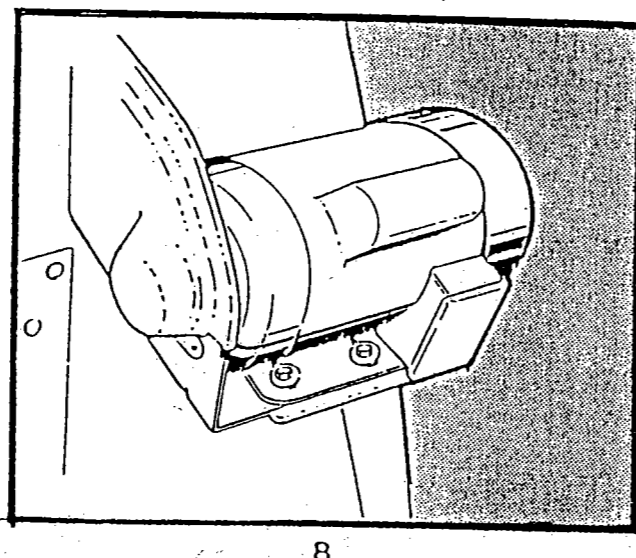
6. Align the motor pulley to the arbor pulley using straight edge to assist in lining up the pulleys. Slide the motor

pulley in or out on the shaft and tighten down with set screw when aligned.

NOTE: Re-check to see that guard bracket is still centered and aligned with pulley.

7. Assemble V-belt to motor and arbor pulley and adjust for correct belt tension.

8. Attach the belt and pulley cover to the bracket using the hex. screws, washers, and hex. nuts as shown in Fig. 8.



GROUNDING INSTRUCTIONS

1. All grounded, cord connected tools: In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if

in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damage or worn cord immediately.

2. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating less than 150 volts:

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Sketch A in Figure 9. The tool has a grounding plug that looks like the plug illustrated in Sketch A.

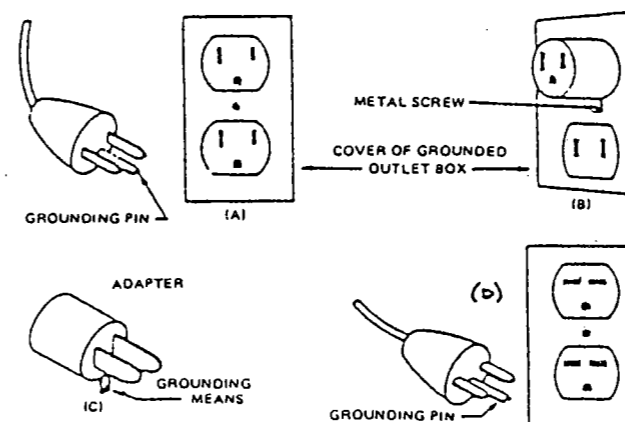
A temporary adapter, which looks like the adapter illustrated in Sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in Sketch B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

3. Grounded, cord-connected tools intended for use on a supply circuit having a nominal rating between 150-250 volts, inclusive: :

This cord is intended for use on a circuit that has an outlet that looks like the one illustrated in Sketch D in Figure 9. The tool has a grounding plug that looks like the plug illustrated in Sketch D.

Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be

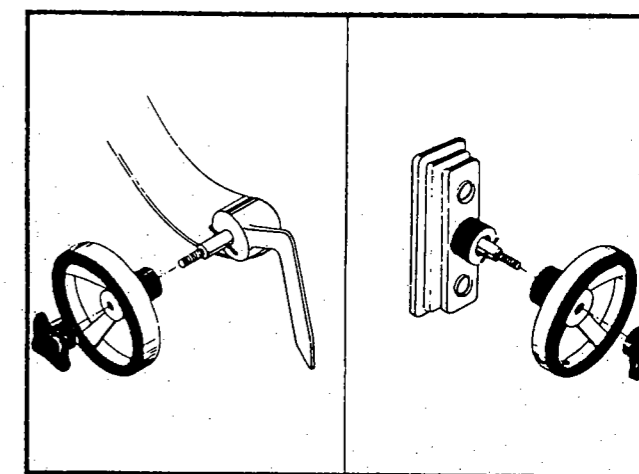
GROUNDING METHODS



reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel and after reconnection, the tool should comply with all local codes and ordinances.

HANDWHEELS AND LOCK KNOBS ASSEMBLY:

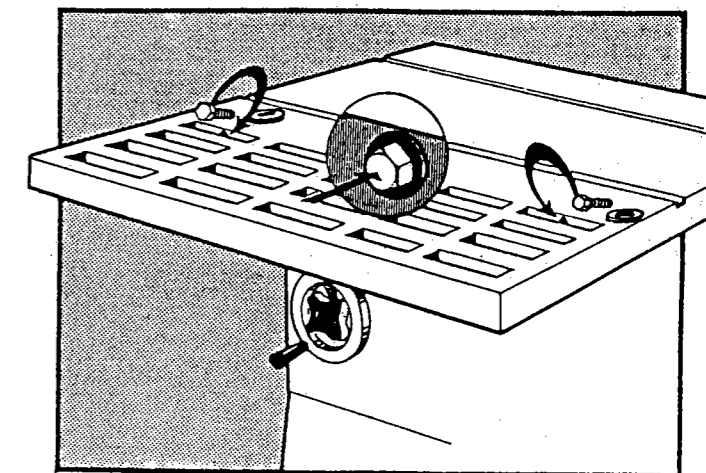
Attach the raising and tilting handwheels with lock knobs to the raising and tilting screws, as shown in Fig. 10. Make sure the slot in both handwheels engages with the roll pins in the raising and tilting screws. See **PARTS: Exploded View**, page 25 for correct assembly.



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TABLE EXTENSION WINGS ASSEMBLY

1. Match holes in extension wings (ears down) to holes in each table end and insert bolts and washers provided as shown in Fig. 11.

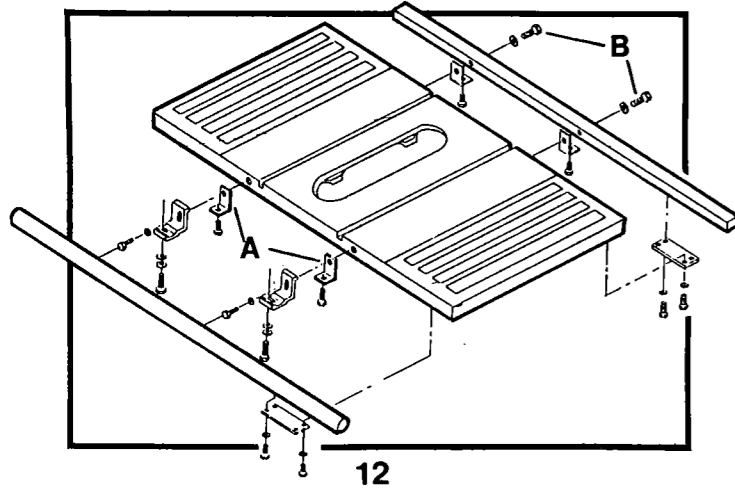


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2. Place straight edge across table and wings and flush wings to straight edge. With wings held firmly in place, tighten up bolts.

GUIDE RAIL ASSEMBLY

1. Attach the guide rail with calibrations to the front of the saw table as shown in Fig. 12, using two spacers A and special screws B threaded into tapped holes.

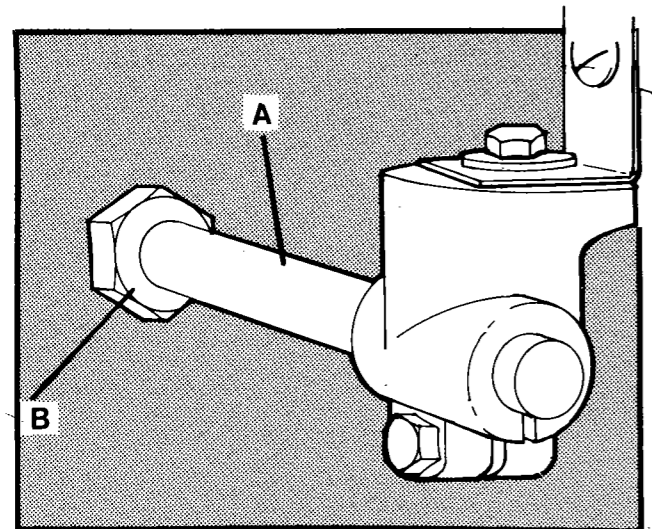


2. Attach the plain rear guide rail to saw table by the same method used for the front guide rail. Make sure both guide rails extend out from the same side of the saw.

BLADE GUARD AND SPLITTER ASSEMBLY

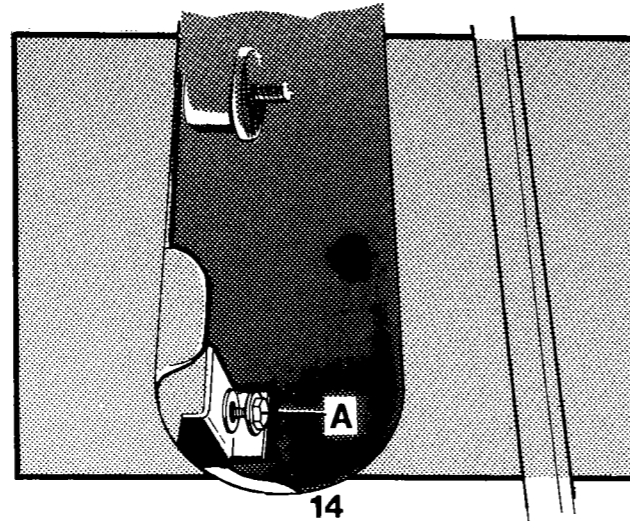
1. Remove table insert.

2. Insert rear blade guard support rod A into threaded hole in trunnion as shown in Fig. 13.



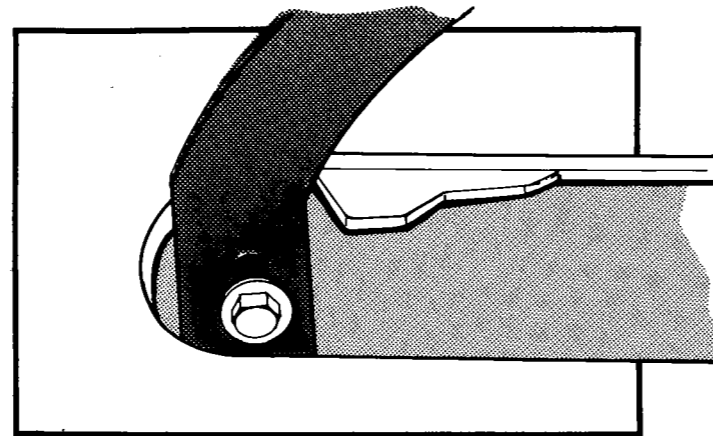
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3. Looking down into insert opening, loosen the capscrew A as shown in Fig. 14 and insert the outer splitter bracket holder through opening.



4. Slip blade guard bracket slot over capscrew between the washer and bracket, but **DO NOT** tighten.

5. Place rear frame of splitter guard assembly against rear bracket and attach as shown in Fig. 15.



15

6. When splitter aligns with saw blade and is square with table, tighten the two set screws at front and rear of splitter guard bracket.

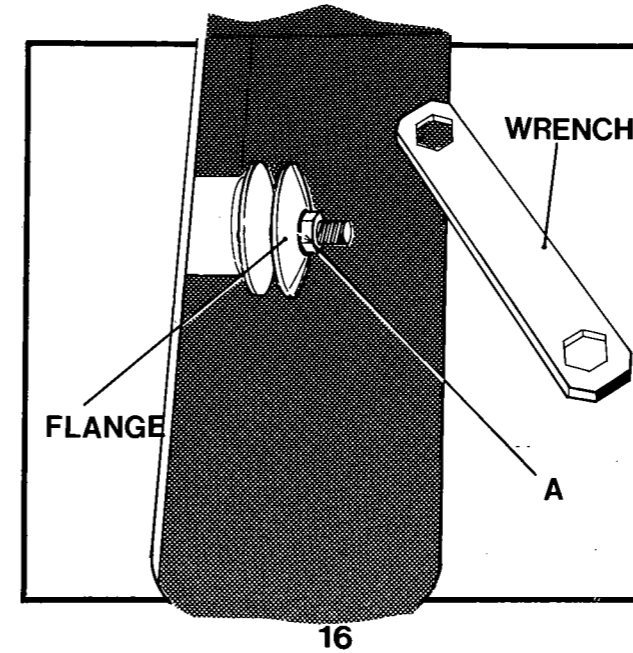
7. Tighten nut B on trunnion rod shown in Fig. 13 to keep rod from rotating.

CHANGING SAW BLADE

1. Make sure the machine is disconnected from its power source.

2. Remove the table insert.

3. Remove the arbor nut A Fig. 16 by turning nut clockwise.



4. Remove the flange and place saw blade on the arbor making sure the cutting edge of the teeth at the top face **TOWARD** the **FRONT** of the saw.

5. Slide the flange on the arbor and start the nut on the threads. Snug the nut against the flange using the wrench while holding saw blade with thumb and fingertips. Wedge a block of wood between the saw blade and table as shown in Fig. 17 and tighten the arbor nut securely.

6. Replace the table insert and reconnect the machine to its power source.

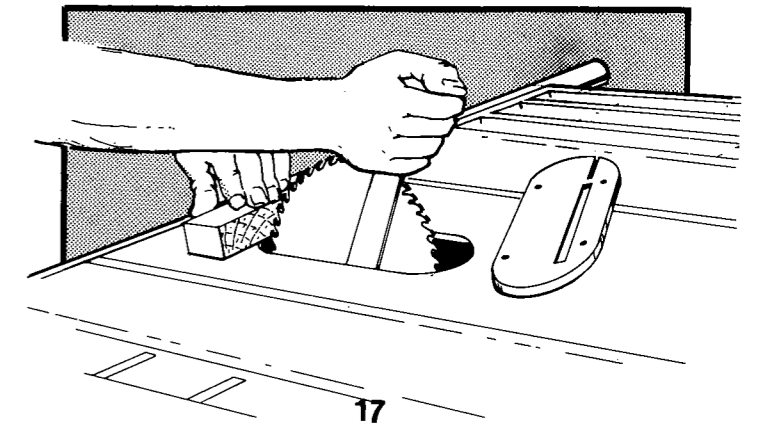
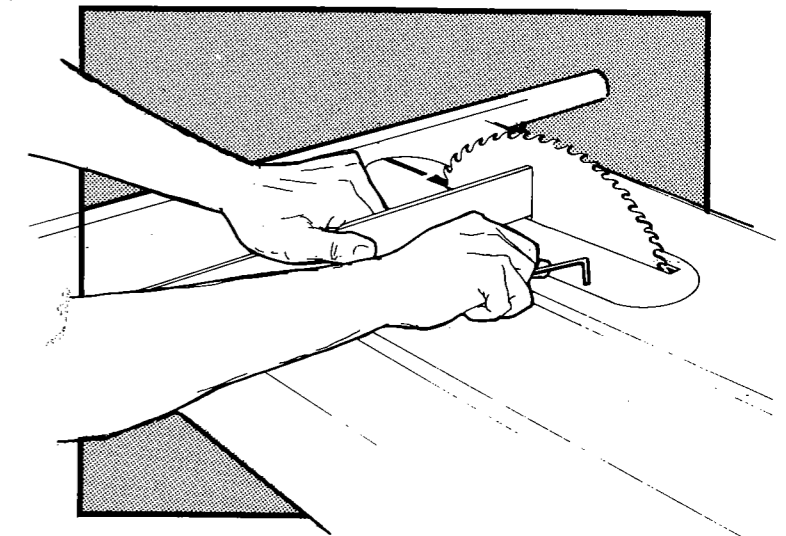


TABLE INSERT ASSEMBLY

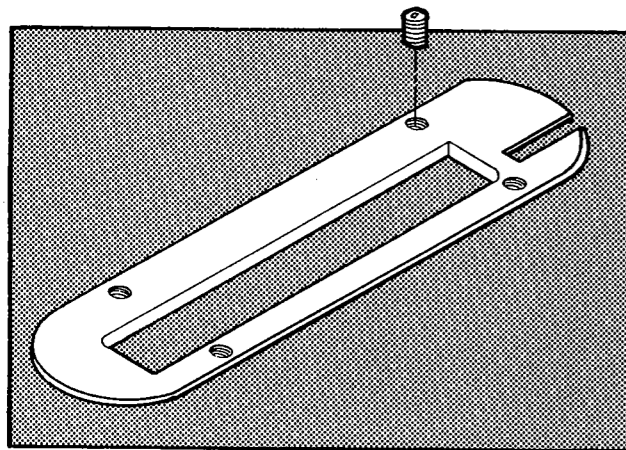
Place the table insert in the saw blade opening as shown in Fig. 18. If the insert is not level with the surface of the table, correct by using a straightedge A and turn the four (4) adjusting screws in or out until the insert is flush with the table.



18

DADO INSERT

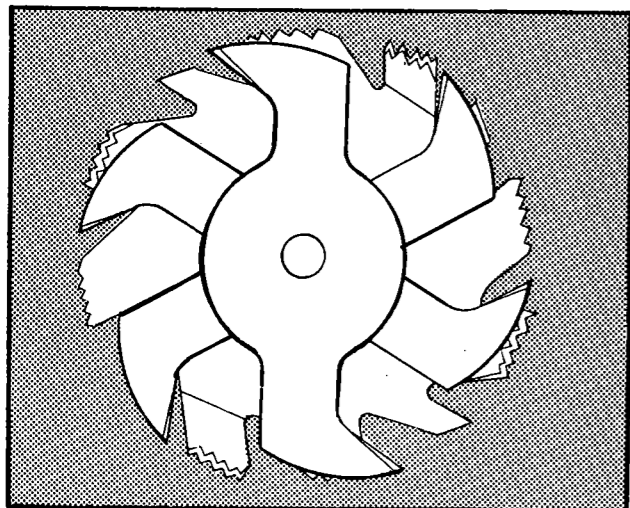
The dado insert as shown in Fig. 18-A is included as standard equipment with your 10" artisan's saw. **DO NOT USE THE STANDARD TABLE INSERT FOR DADOING OPERATION.** Dadoing is cutting a rabbet or a wide groove into the workpiece.



18-A

In order to cut grooves from 1/8" to 13/16", a variety of combinations of saws and cutters are available for shelving, making joints, tenoning, etc.

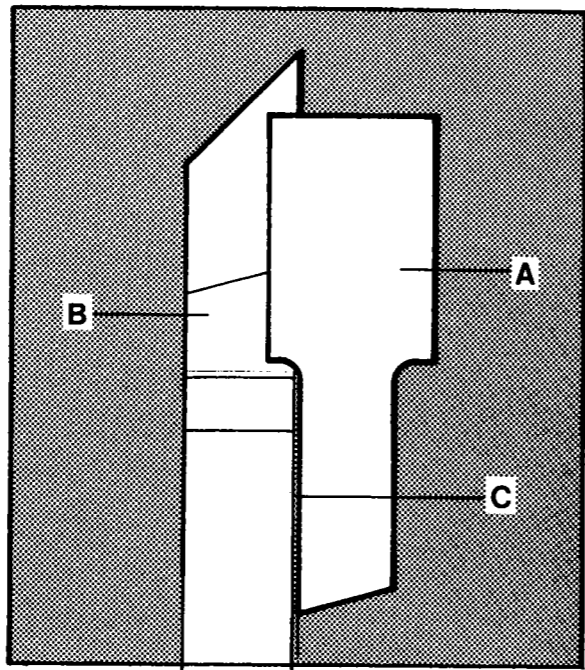
The cutters are heavily swaged and must be arranged so that the heavy section falls in the gullets of the outside saws as shown in Fig. 19.



19

While set up, the outside saw A, and the inside cutter B, overlap as shown in Fig. 20.

In order to control the exact width of the groove, paper washer(s) C are inserted between the saw blade and inside cutter.



20

As stated in **UL 987 STANDARD for SAFETY**, paragraph 42.11 "a guard is not required for attachments such as a dado set, a molding head, or the like, that are not intended to cut through the workpiece".

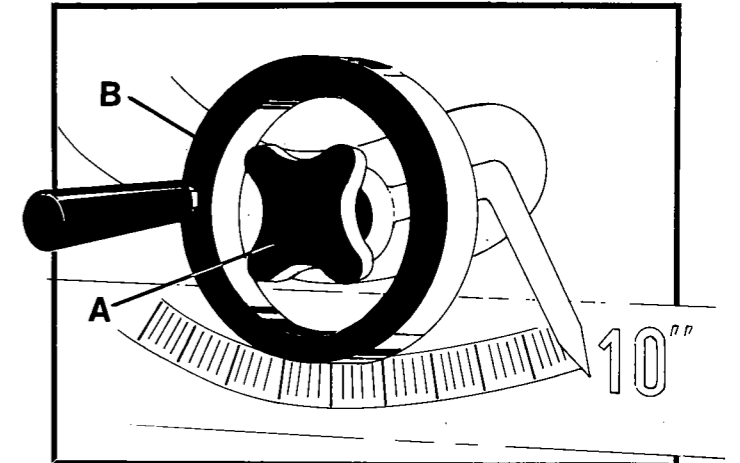
NEVER USE THE DADO HEAD IN A BEVEL POSITION.

ALWAYS INSTALL THE BLADE GUARD AFTER THE DADO OPERATION IS COMPLETE.

ADJUSTMENTS

TO RAISE AND LOWER THE SAW BLADE:

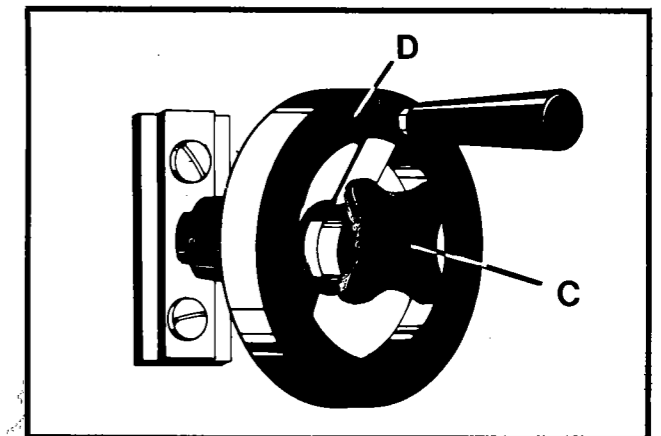
1. Loosen front lock knob A Fig.21.
2. Turn front handwheel B clockwise to raise saw blade and counterclockwise to lower saw blade.
3. Tighten front lock knob.



21

TILTING SAW BLADE

1. Loosen side lock knob C Fig.22.
2. Turn side handwheel D to desired angle.
3. Tighten side lock knob.

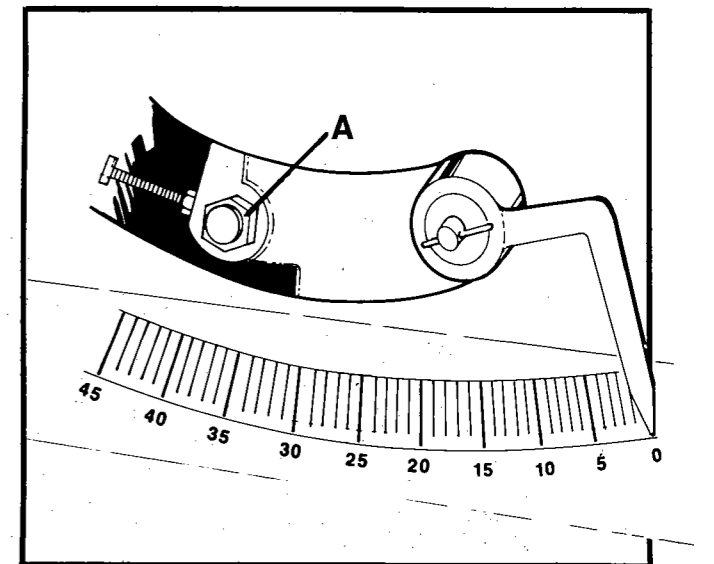


22

RESETTING THE POINTER

After a long period of time the pointer may require adjusting. If this is necessary, do the following:

1. Remove the lock knob and raising handwheel as shown in Fig.23.
2. Loosen locknut A.
3. Adjust the pointer to the left or right until play (between worm and arbor bracket) is removed.
4. Reset pointer.
5. Tighten locknut.
6. Attach lock knob and handwheel.



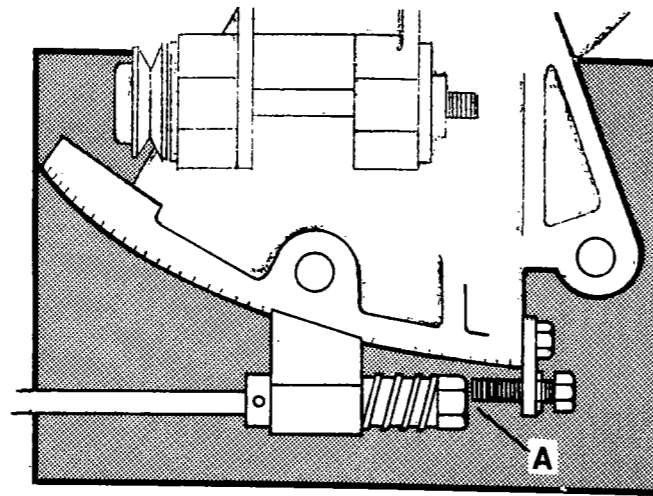
23

ADJUSTING 90 DEGREE POSITIVE STOP

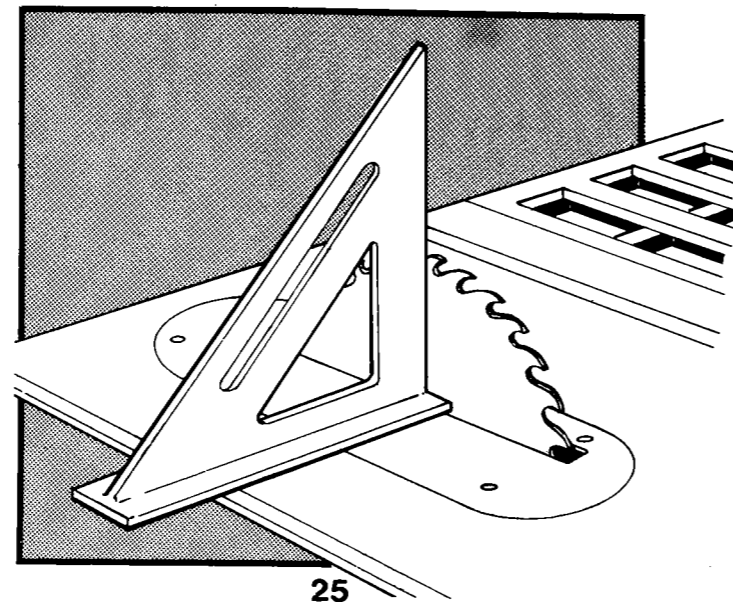
An adjustable 90 degree positive stop A is located under the table on the front trunnion as shown in Fig.24.

TO CHECK FOR 90 DEGREE ACCURACY

1. Disconnect machine from its power source.
2. With front handwheel, raise the saw blade to maximum.
3. Turn the tilting handwheel counterclockwise to maximum.
4. Position steel square on the table with vertical edge against the blade as shown in Fig.25, and check to see if blade is 90 degrees to the table.



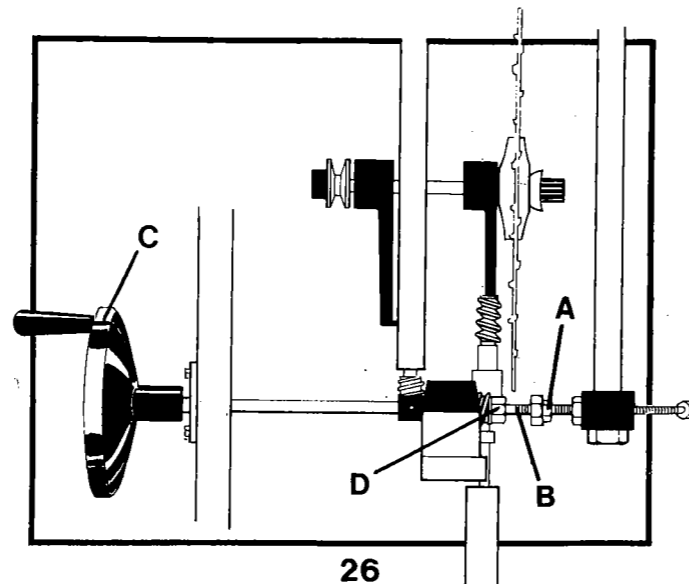
24



25

IF ADJUSTMENT IS NECESSARY

5. Loosen locknut A Fig.26.
6. Back out adjusting stop screw B.
7. Turn tilting handwheel C until blade is exactly 90 degrees to the table.
8. Turn stop screw until it stops against end of the tilting worm D.
9. Tighten and lock in this position with locknut A.



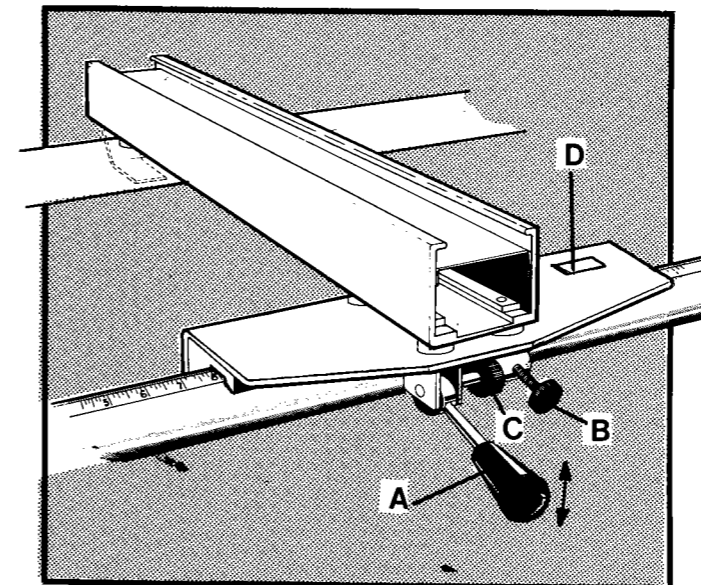
26

RIP FENCE ADJUSTMENT

The rip fence moves to either side of saw blade. Front and rear rails guide the fence. The front guide rail has calibrations showing distance between the fence and saw blade.

TO ADJUST RIP FENCE:

1. Raise clamp lever A Fig.27 all the way up and move fence to desired position.
2. Push clamp lever down to lock fence.
3. For fine adjustment loosen the micro adjusting knob, B and adjust the fine setting by turning the micro adjusting nut, C.



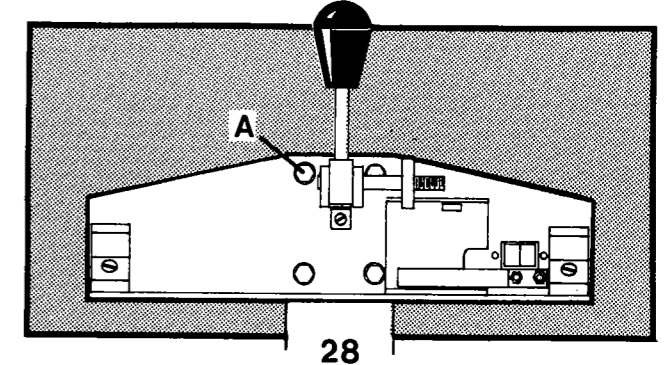
27

NOTE: The fence comes equipped with a hairline magnifier, D located on the fence head.

YOUR ARTISAN'S SAW IS FACTORY-SHIPPED WITH MITER GAUGE SLOTS PARALLEL TO THE SAW BLADE. IT IS NECESSARY TO MAKE SURE THE RIP FENCE IS PARALLEL TO THE MITER GAUGE SLOTS. TO CHECK, DO THE FOLLOWING:

1. Set fence at a miter gauge slot and tighten clamp lever A Fig.27.

2. If adjustment is necessary, loosen the four hex. bolts A located on the underside of the fence head as shown in Fig.28.



28

3. Adjust the fence to be parallel with the miter gauge slot and tighten down the two outside hex. bolts at the front of the head.
4. Remove the fence and tighten the two remaining hex. bolts.

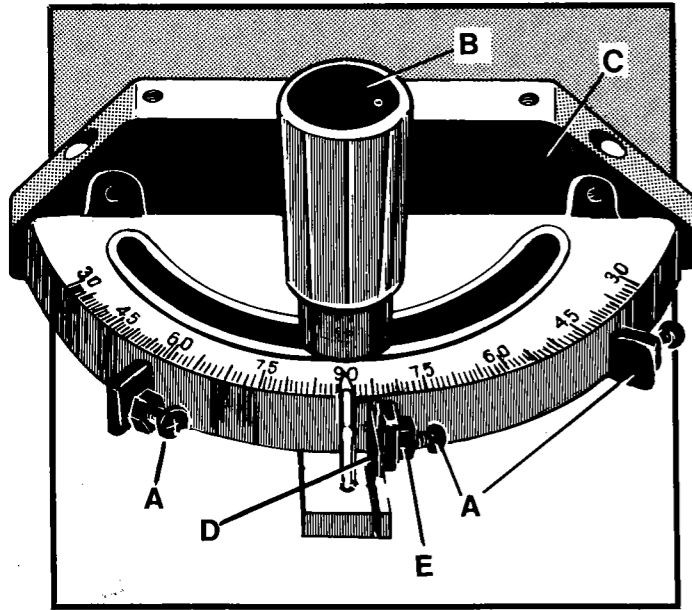
GENERAL MAINTENANCE

Good saw operation requires periodic preventive maintenance. Keep the inside of the cabinet and trunnion area clean. A stiff brush will remove sawdust before it cakes and pitch or gum is easily removed with a commercial solvent or with a good oven cleaner. To accomplish this, remove the table by removing the three mounting screws and exposing the working mechanisms of the saw. After cleaning the tilting and raising worm and worm gear segments and the trunnions, grease these three areas with a good grade non-hardening grease such as Fiske Company "Lubriplate".

The table surface must be kept clean and free of rust for best results. Although some users prefer a wax coating, white talcum powder applied with a blackboard eraser rubbed in vigorously once a week will fill casting pores and form a moisture barrier. This method provides a table top that is slick and allows rust rings to be easily wiped from the surface. It is also important to note that talcum powder will not stain wood or mar finishes as wax pickup does.

MITER GAUGE ADJUSTMENT

Your miter gauge is equipped with individually adjustable index stops at 90 degrees and 45 degrees right and left. The index stops can be adjusted by tightening or loosening the three adjusting screws A Fig. 29.

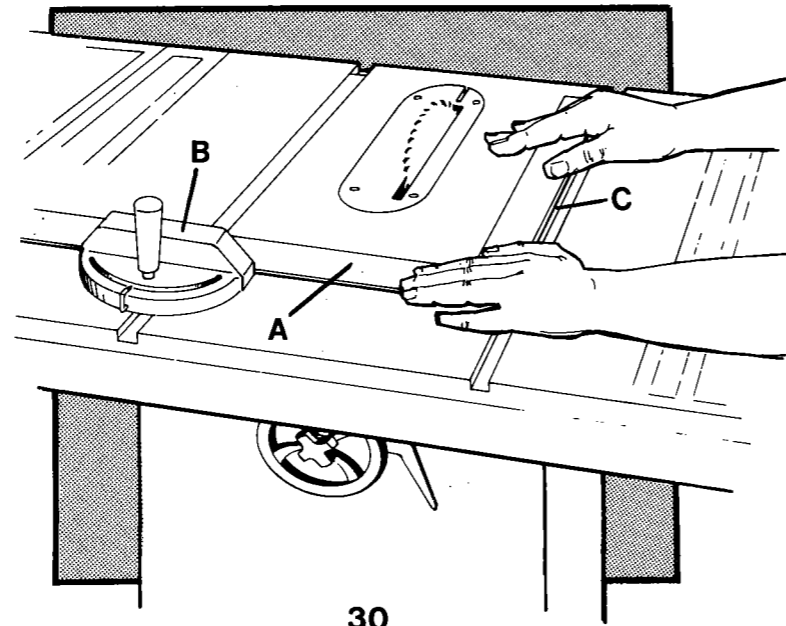


29

To operate the miter gauge, loosen lock handle B Fig. 29 and move the body of the miter gauge C to the desired angle. The miter gauge body is set to stop at 0 degrees and 45 degrees left or right. To move the gauge beyond these points, the stop link D, Fig. 29, must be flipped out of the way.

TO CHECK AND ADJUST THE 90 DEGREE SETTING OF THE MITER GAUGE, DO THE FOLLOWING:

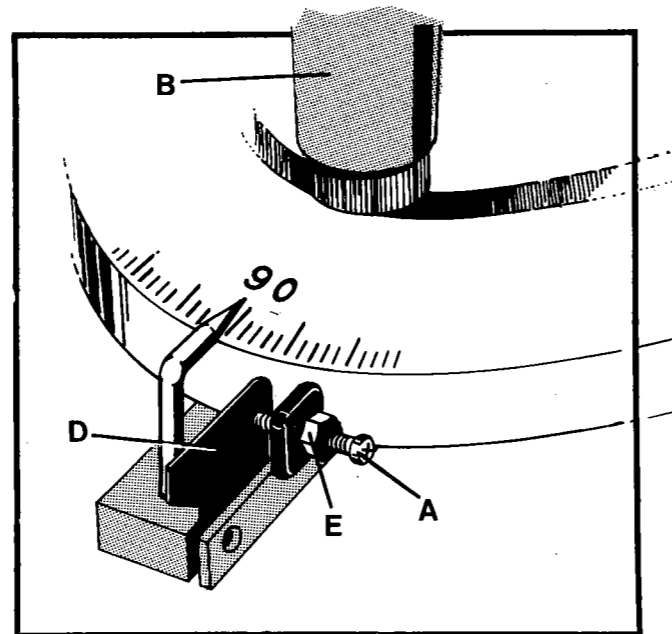
1. Set the gauge at 90 degrees as shown in Fig. 29
2. Place a metal square A against the face of the miter gauge B and along one edge of the miter gauge slot C as shown in Fig. 30.



30

If adjustment is necessary

1. Loosen lock handle B Fig. 29.
2. Loosen locknut E, Fig. 31 and adjust the stop screw, A so it strikes the stop link D when the gauge is at 90 degrees.
3. Retighten both the locknut E and lock handle B.



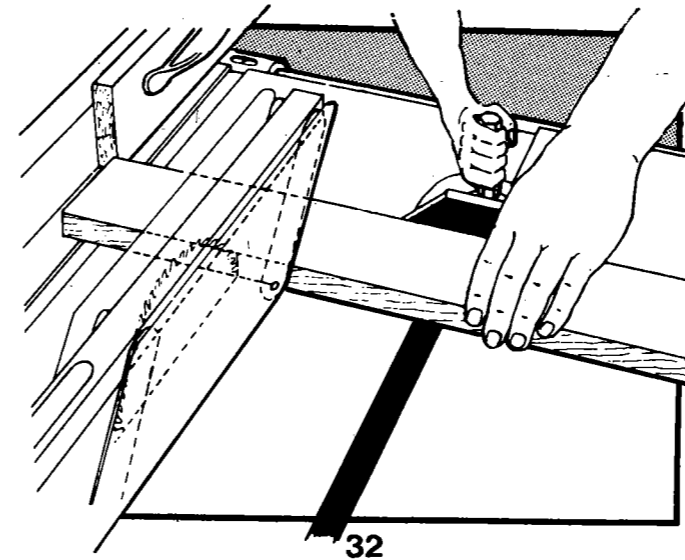
31

BASIC ARTISAN'S SAW OPERATION

Familiarize yourself with the location and operation of all controls and adjustments and the use of accessories such as the miter gauge and rip fence.

CROSSCUTTING

1. The sawing process where the work piece is fed cross grain into the saw blade using the miter gauge to support and position the work piece is called crosscutting. Crosscutting should **NEVER** be done free-hand nor should the fence be used as an end stop unless an auxiliary block is clamped to the fence in front of the blade area such that the cutoff piece comes free of the block before cutting starts as shown in Fig. 32.



32

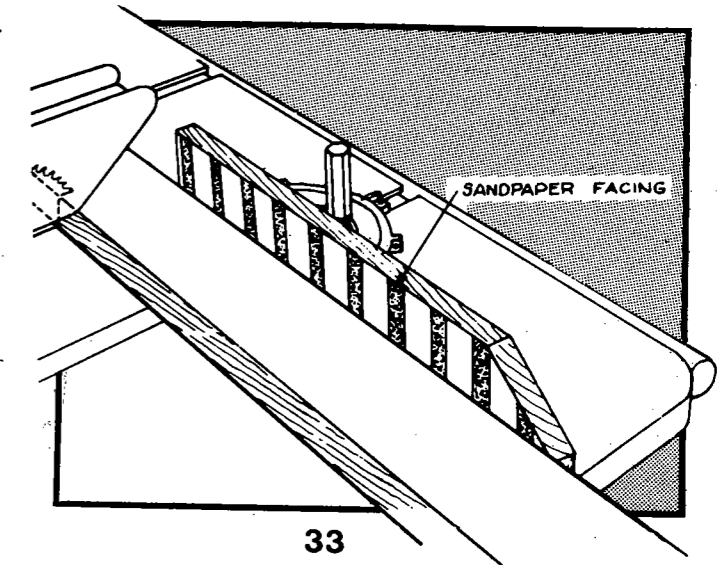
Length stops should not be used on the free end of the work piece in the cutoff area. **DO NOT** crosscut work pieces **shorter** than 6". Before starting a cut, be sure that the miter gauge is securely clamped at the desired angle. Hold the work piece firmly against the table and back against the miter gauge. Always use the saw guard and splitter and make sure the splitter is properly aligned.

2. For 90 degree crosscutting, most operators prefer to use the left-hand miter gauge slot. When using it in this position, hold the work piece against the gauge with the

left hand and use the right hand to advance the work piece. When using the right hand slot for miter and compound crosscutting so that the blade tilts away from the gauge, the hand positions are reversed.

3. When using the miter gauge, the work piece must be held **firmly** and advanced smoothly at a slow rate. If the work piece is not held firmly, it can vibrate causing it to bind on the blade and dull the saw teeth.

4. To improve the effectiveness of the miter gauge in cross cutting, some users mount to the miter gauge an auxiliary wooden extension face with a glued-on strip of sandpaper as shown in Fig. 33.



33

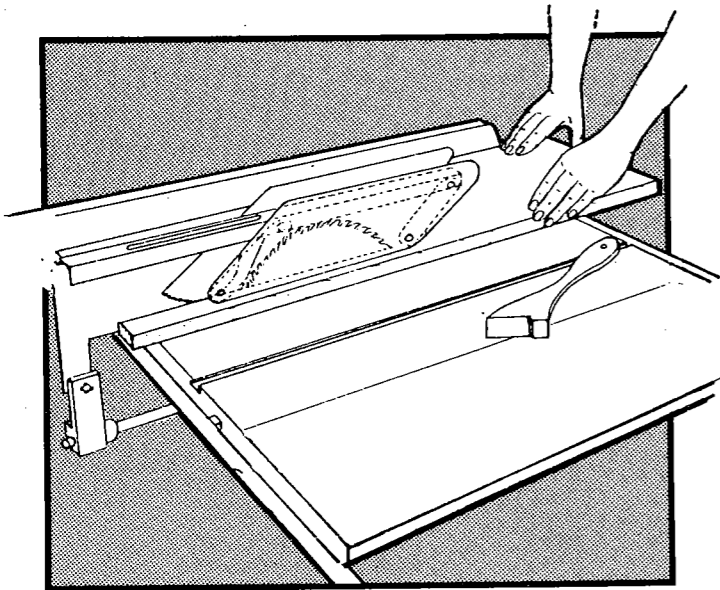
5. Provide auxiliary support for any work piece which extends beyond the table top which has a tendency to sag and lift up off the table.

6. Stop rods can be used in the holes provided in the miter gauge for repetitive work of equal length. Do not use a stop rod on the free end of a work piece. It should be used on the side of the miter gauge opposite the saw blade.

7. Have the blade extend about 1/8" above the top of the work piece. Exposing the blade beyond this point can be hazardous.

RIPPING

Ripping is a sawing process where the work piece is fed with the grain into the saw blade using the fence as a guide to insure the desired width of cut as shown in Fig. 34.



34

CAUTION: Before starting a ripping cut, be sure the fence is clamped securely and aligned properly. **NEVER** rip free hand or use the miter gauge in combination with the fence. **NEVER** rip work pieces shorter than the saw blade diameter. **NEVER** reach behind the blade with either hand to hold down or remove the cutoff piece with the saw blade rotating.

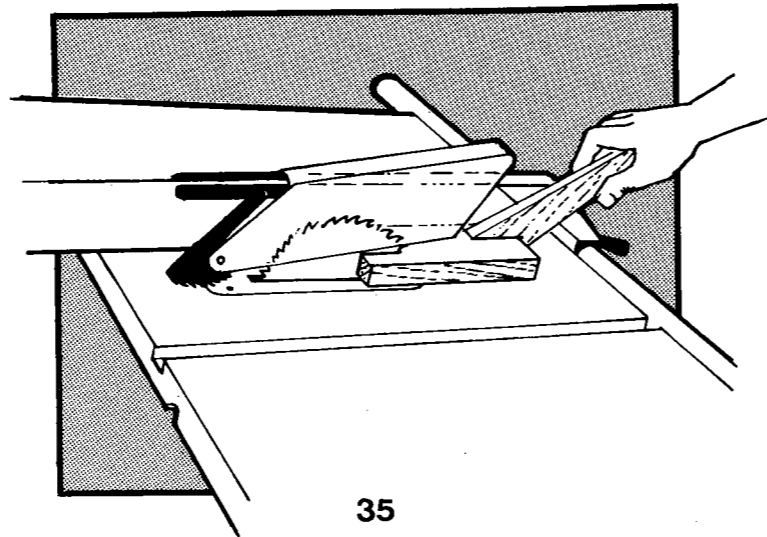
Always use the saw guard, splitter and kickback pawls and make sure that the splitter is properly aligned. When wood is cut along the grain, the kerf tends to close and bind on the blade and kickbacks can occur.

NOTE: A caution decal is displayed warning of the hazard of misalignment.

The rip fence should be set for the width of the cut by using the scale on the front rail or by measuring the distance between the blade and fence. Stand out of line with the saw blade and work piece to avoid sawdust and splinters coming off the blade and a kickback if one should occur.

If the work piece does not have a straight edge, nail an auxiliary straight edged board on it to provide one against the fence. To cut properly, the board must make good contact with the table; if it is warped, turn the hollow side down.

In ripping, use one hand to hold the board down and against the fence or fixture, and the other to push it into the blade between the blade and the fence. If the work piece is narrow (less than 6") use a push stick as shown in Fig. 35. **NEVER** push in a location such that the pushing hand is in line with the blade. Move the hand serving as a hold-down a safe distance from the blade as the cut nears completion. For very narrow ripping where a push stick cannot be used, use a push block or auxiliary fence.

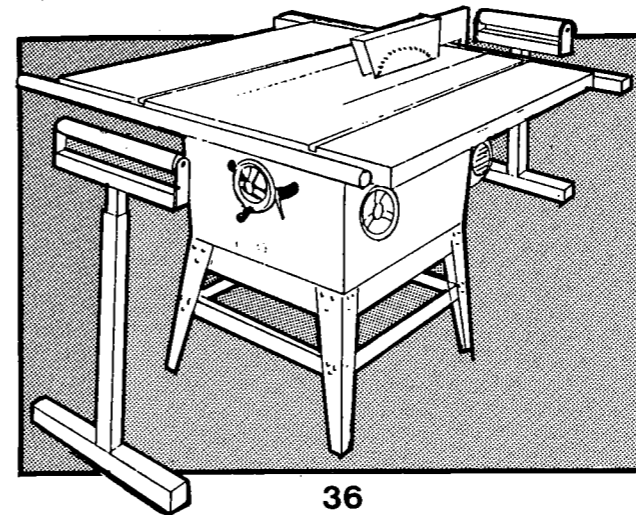


35

ALWAYS push the work piece completely past the blade at the end of a cut to minimize the possibility of a kickback.

In ripping long boards, as shown in Fig. 36, use a support at the front of the table and a support or tailman at the rear.

For work shorter than 12" or narrower than 6", use a push stick or block to push it through between the fence and the saw blade.



36

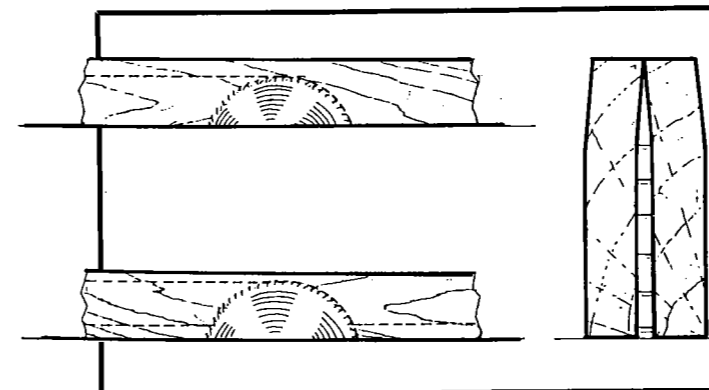
Never use the rip fence beyond the point where the carriage is flush with the end of the rails.

Have the blade extend about 1/8" above the top of the work piece. Exposing the blade above this point can be hazardous.

RESAWING

Resawing is a ripping operation to make thick boards into thinner ones. Narrow boards up to 3" can be resawed in one pass. Wider boards up to 6" must be resawed in two passes.

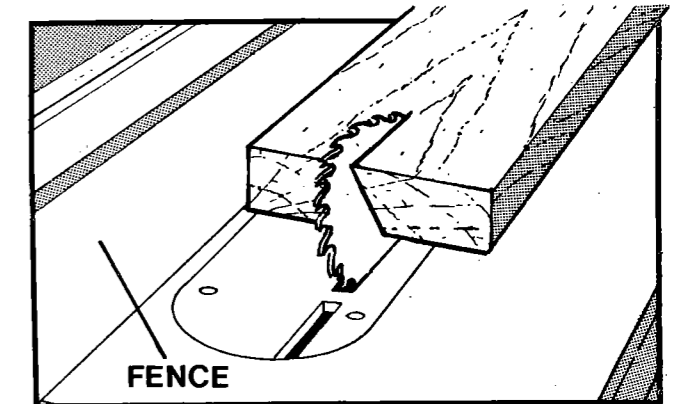
In resawing wider boards, adjust the blade height so as to overlap the two cuts by 1/2". If the first cut is too deep as shown in Fig. 37, the second cut can result in binding and kickback. Always use the same side of the board against the fence for both cuts.



37

BEVEL and MITER OPERATIONS

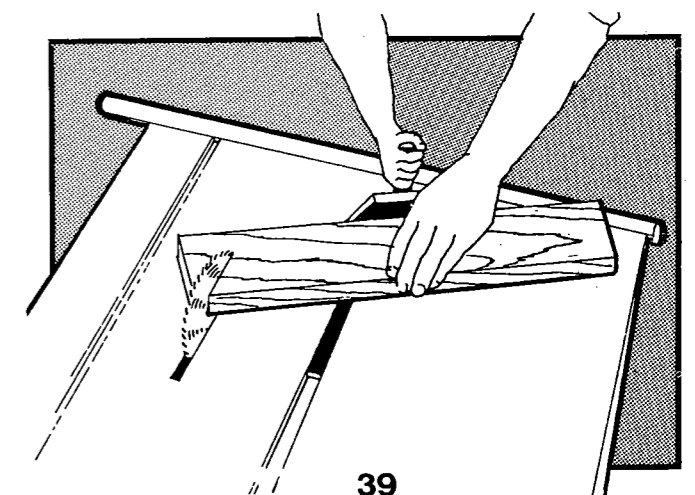
A bevel cut is a special type of operation where the saw blade is tilted at an angle less than 90 degrees to the table top as shown in Fig. 38. Operations are to be performed in the same manner as ripping or crosscutting. As always, it is essential that the saw blade be aligned with the rip fence and the miter slots in order to minimize the potential of binding and kickback. When beveling with the miter gauge, the work piece must be held firmly to prevent creeping.



38

Crosscuts made at an angle to the edge of the work piece are called miters as shown in Fig. 39. Set the miter gauge at the required angle, lock the miter gauge, and make the cut the same as a normal crosscut except hold the work piece extra firmly to prevent creeping.

Have the blade extend about 1/8" above the top of the work piece. Exposing the blade above this point can be hazardous.



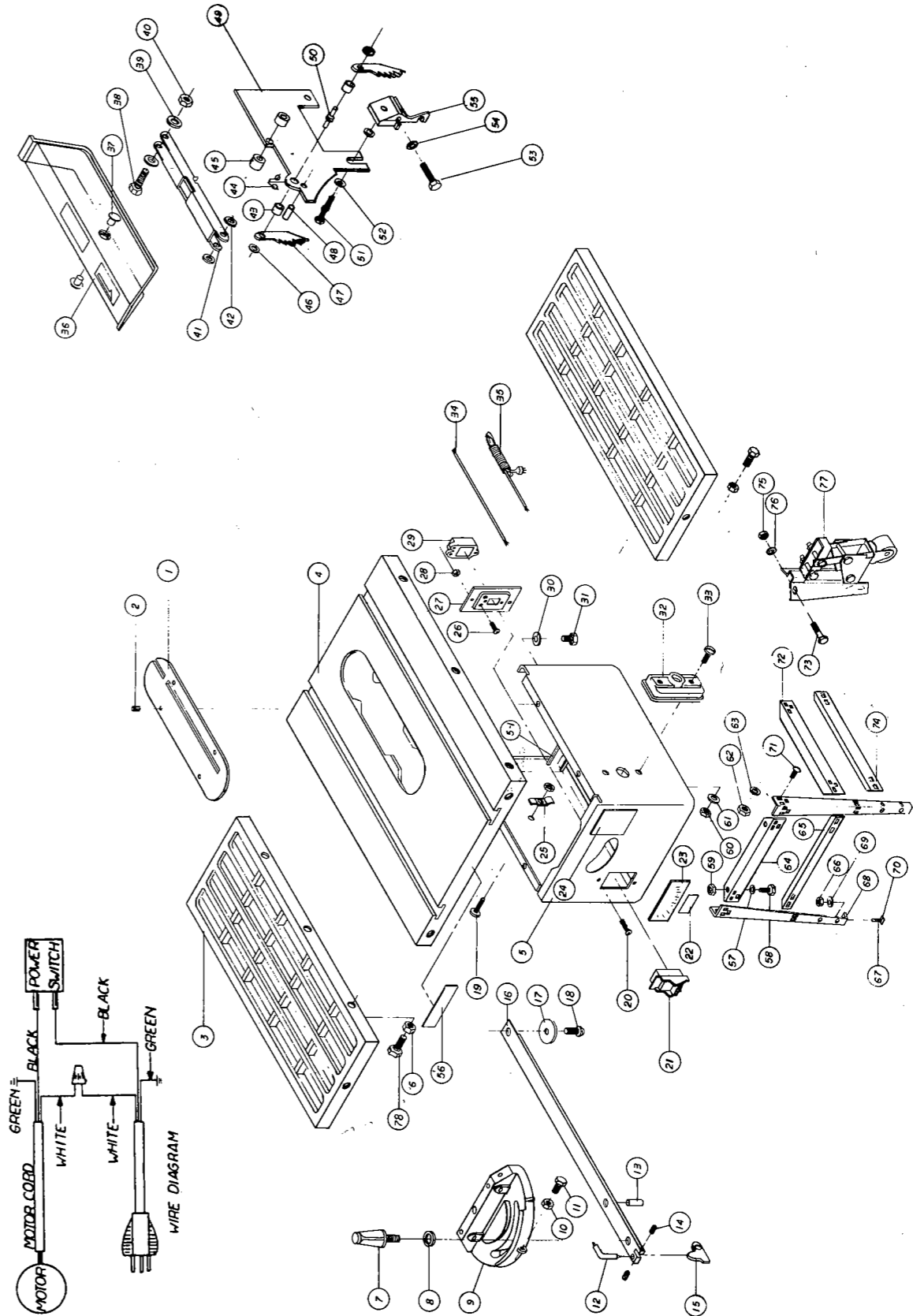
39

PARTS LIST

ITEM NO.	EDP. NO.	DESCRIPTION
1	6285202	INSERT
2	6285303	SCREW, SOC. SET.
3	6285206	WING, EXTENSION
4	6285205	TABLE
5	6285209	SHELL
6	6285207	COLLAR
7	6285329	MITER GAUGE ASSY (ITEMS 7 THRU 18)
8	6285214	BAR, SET
9	6285215	WASHER
10	6285213	SCALE, ANGLE
11	6285312	NUT, HEX.
12	6285308	SCREW, CR.-RE. PAN HD.
13	6285218	POINTER, ANGLE
14	6285220	PIN
15	6285208	BRACKET
16	6285301	SCREW, SOC. SET.
17	6285219	PLATE, SET
18	6285216	BAR, SHEET
19	6285217	WASHER
20	6285306	SCREW, CR.-RE. COUNT. HD.
21	6285305	SCREW, CR.-RE. COUNT. HD.
22	6285305	SCREW, CR.-RE. COUNT. HD.
23	6285322	ROCKER SWITCH
24	6285270	LABEL
25	6285212	SCALE, PLATE
26	6285269	LABEL, WARNING
27	6285201	WIRE CLIP
28	6285325	CR.-RE. PAN HD. TAPPING
29	6285267	SWITCH COVER
30	6285374	NUT, HEX.
31	6285264	SWITCH BOX
32	6285289	WASHER, FLAT
33	6285294	BOLT, HEX. HD.
34	6285210	BRACKET, GEAR
35	6285211	SCREW, CAP
36	6285320	MOTOR WIRE
37	6285319	POWER CABLE
38	6285330	BLADE GUARD ASSY (ITEMS 36 THRU 55)
39	6285246	BLADE GUARD (LEFT)
40	6285310	RIVET
41	6285299	BOLT, HEX. HD.
42	6285286	WASHER, FLAT
43	6285281	NUT CHUCK
44	6285263	U-BAR
45	6285324	RING, LOCKING RING
46	6285274	BUSHING
47	6285278	SPRING
48	6285277	SPACER
49	6285324	RING, SELF-LOCKING
50	6285273	PAWL, KICK BACK
51	6285283	PIN, SPRING
52	6285221	SUPPORT, GUARD
53	6285275	PIN, ROLL
54	6285294	BOLT, HEX. HD.
55	6285289	WASHER, FLAT
56	6285292	BOLT, HEX. HD.
57	6285287	WASHER, FLAT
58	6285222	PLATE, LINKING
59	6285271	LABEL, CAUTION
60	6285287	WASHER, FLAT
61	6285294	BOLT, HEX. HD.
62	6285314	NUT, HEX.
63	6285314	NUT, HEX.
64	6285289	WASHER, FLAT
65	6285314	NUT, HEX.
66	6285261	STIFFENER END, UPPER
67	6285313	STIFFENER SIDE, DOWNER
68	6285292	NUT, HEX.
69	6285204	BOLT, HEX. HD.
70	6285286	LEG
71	6285203	WASHER, FLAT
72	6285304	SPACER
73	6285259	CAP HD. SQUARE SHOULDER
74	6285300	STIFFENER SIDE, UPPER
75	6285262	BOLT, HEX. HD.
76	6285316	BRACKET, SUPPORT
77	6285287	NUT, HEX.
78	6285200	WASHER, FLAT
79	6285298	CASTER ASS'Y
80	6285298	BOLT, HEX. HD.

26.00

PARTS: Exploded View, electrical schematic

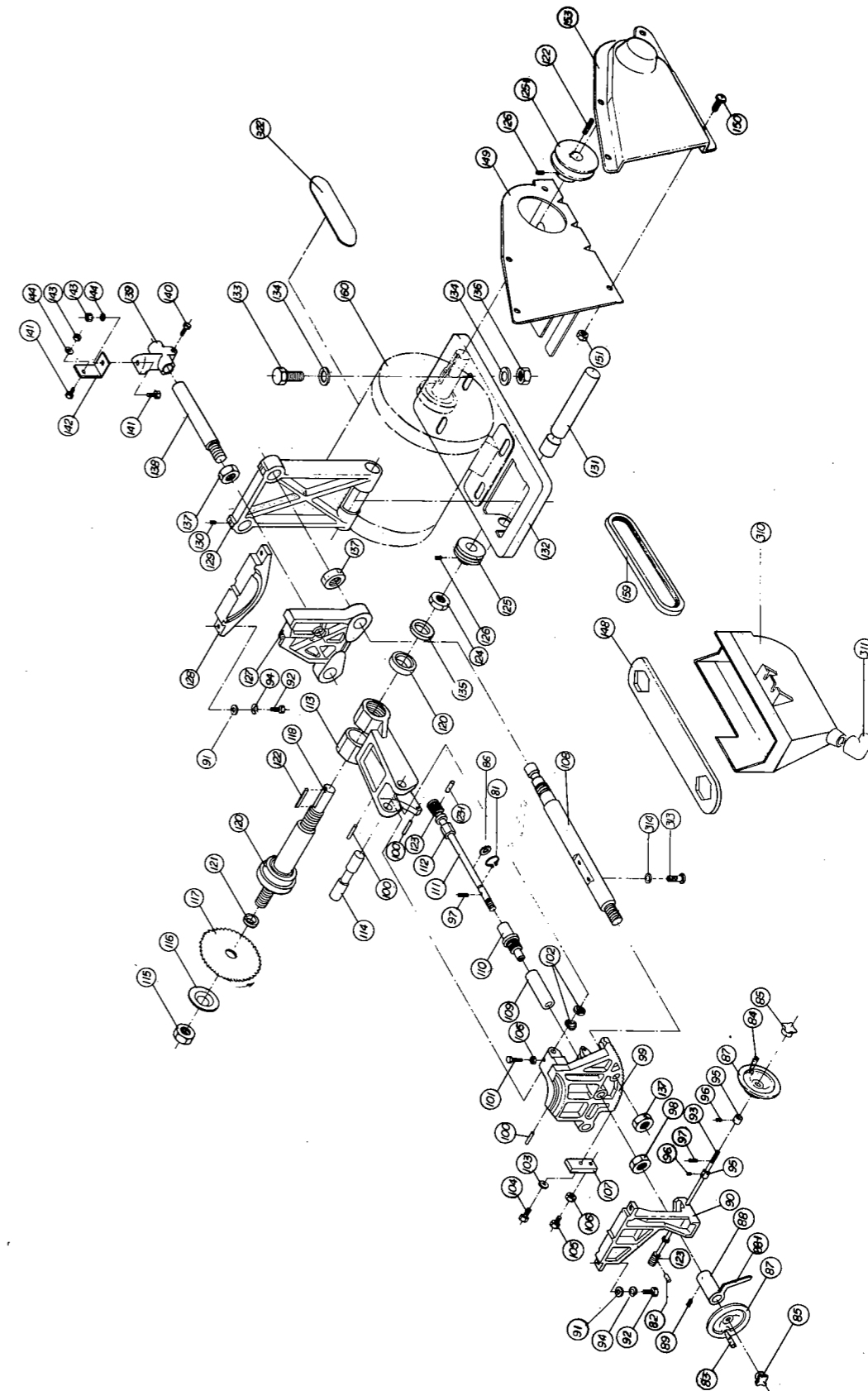


PARTS LIST

PART NO.	EDP NO.	DESCRIPTION
81	6285327	RING, SNAP
82	6285282	PIN, SPRING
83	6285223	HANDLE
84	6285224	BAR, HANDLE
85	6285225	KNOB
86	6285328	WASHER, FLAT
87	6285279	HANDWHEEL
88	6285226	SLEEVE, POINTER
88-1	6285227	POINTER
89	6285302	SCREW, SOC. SET.
90	6285228	BRACKET, FRONT
91	6285289	WASHER, FLAT
92	6285296	BOLT, HEX. HD.
93	6285229	WORM
94	6285290	WASHER, SPRING
95	6285230	COLLAR
96	6285302	SCREW, SOC. SET.
97	6285282	PIN, SPRING
98	6285315	NUT, HEX.
99	6285231	BRACKET, TAPER REGULATOR
100	6285284	PIN, SPRING
101	6285293	BOLT, HEX. HD.
102	6285280	WASHER, WAVE
103	6285286	WASHER, FLAT
104	6285293	BOLT, HEX. HD.
105	6285293	BOLT, HEX. HD.
106	6285313	NUT, HEX.
107	6285232	PLATE, SET
108	6285233	BAR, LINK
109	6285234	SPACER
110	6285235	SLEEVE, ECCENTRIC
111	6285236	WORM
112	6285237	COLLAR
113	6285238	BRACKET, HEIGHT
114	6285239	PIN
115	6285240	NUT, HEX.
116	6285241	COLLAR, SPINDLE
117	6285323	BLADE
118	6285242	SPINDLE
120	6285321	BEARING, BALL
121	6285243	BUSHING, BLADE SHAFT
122	6285317	KEY, PARELLEL
123	6285244	GEAR, WORM
123-1	6285282	PIN, SPRING
124	6285245	NUT, HEX.
125	6285246	PULLEY, SPINDLE
125-1	6285247	PULLEY, MOTOR
126	6285302	SCREW, SOC. SET.
127	6285248	ANGLE REGULATOR
128	6285249	BRACKET, REAR
129	6285250	BRACKET, MOTOR
130	6285303	SCREW, SOC. SET.
131	6285251	PIN
132	6285252	BRACKET, MOTOR
133	6285297	BOLT, HEX. HD.
134	6285289	WASHER, FLAT
135	6285291	WASHER, LOCK FOR BEARINGS
136	6285314	NUT, HEX.
137	6285315	NUT, HEX.

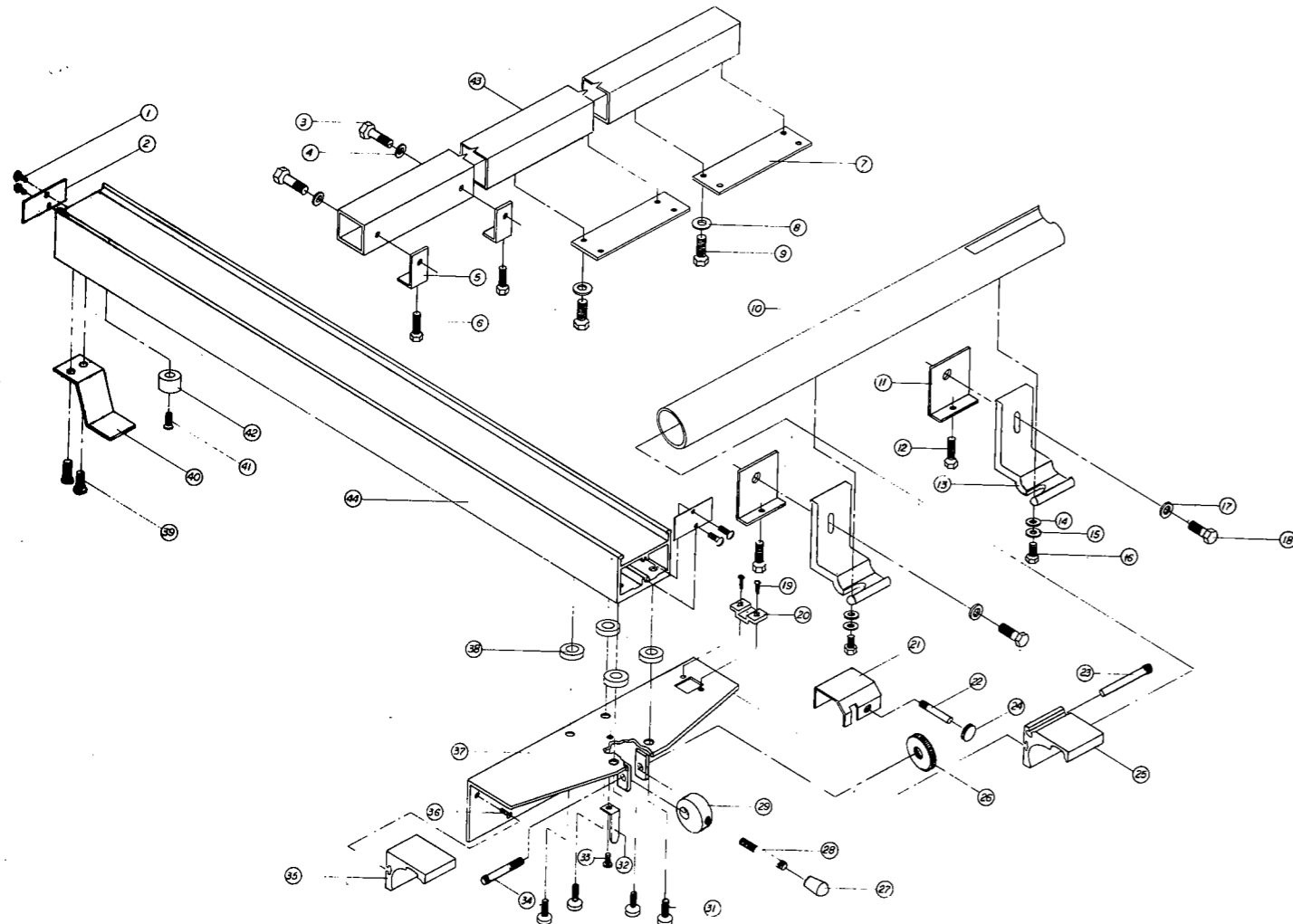
NO.	EDP. NO.	DESCRIPTION
138	6285253	LEVER
139	6285254	CONNECTOR
140	6285297	BOLT, HEX. HD.
141	6285295	BOLT, HEX. HD.
142	6285255	PLATE, CONNECTOR
143	6285314	NUT, HEX.
144	6285289	WASHER, FLAT
148	6285256	SPANNER
149	6285257	PULLEY, COVER SEAT
150	6285305	SCREW, CR.-RE. COUNT. HD
151	6285312	NUT, HEX.
153	6285258	PULLEY, COVER
159	6285318	V-BELT
160	6285326	MOTOR ASS'Y
310	6285265	DUST COLLECTOR
311	6285266	ELBOW
313	6285309	SCREW, CR.-RE. PAN HD.
314	6285285	FLAT WASHER
322	6285272	LABEL, MOTOR

PARTS: Exploded View



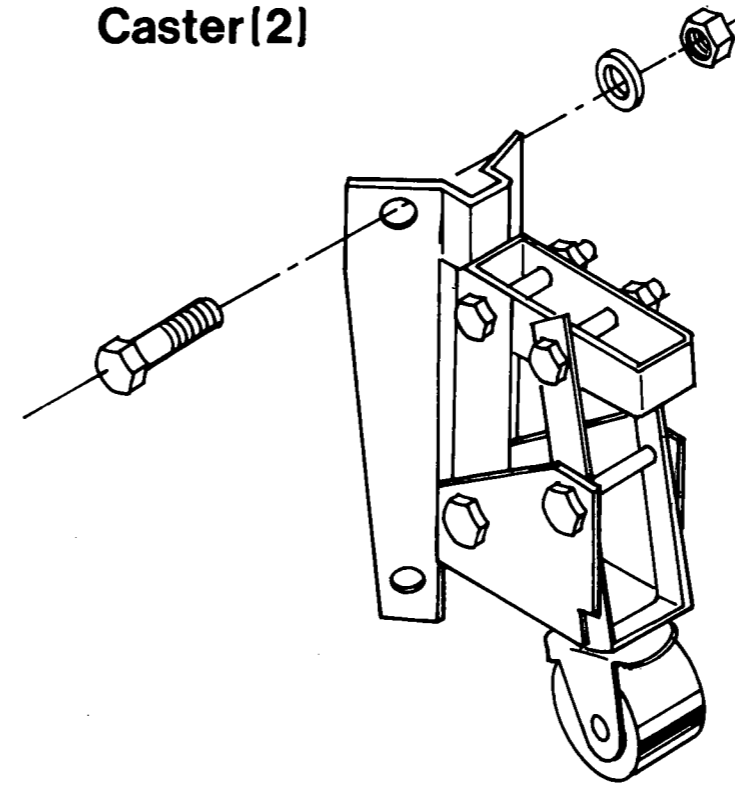
PARTS LIST, FENCE

ITEM NO.	EDP. NO.	DESCRIPTION
1	6285349	SCREW, PAN HD.
2	6285346	FENCE BAR END CAP
3	6285350	BOLT, HEX HD.
4	6285351	WASHER, FLAT
5	6285334	PLATE, ADJUSTMENT
6	6285352	BOLT, HEX. HD.
7	6285353	PLATE, SUPPORT
8	6285354	WASHER, FLAT
9	6285355	BOLT, HEX. HD.
10	6285339	FRONT RAIL
11	6285348	FRONT ADJUSTMENT PLATE
12	6285356	BOLT, HEX. HD.
13	6285347	SUPPORT EXTRUSION
14	6285357	WASHER, FLAT
15	6285358	WASHER, LOCK
16	6285359	BOLT, HEX. HD.
17	6285360	WASHER, FLAT
18	6285361	BOLT, HEX. HD.
19	6285362	SCREW, ROUND HD.
20	6285337	READER
21	6285344	HEAD MICRO ADJUST BLOCK
22	6285363	PIN. MICRO-HEAD
23	6285345	HEAD MICRO ADJUST BLOCK GUIDE PIN
24	6285364	KNOB
25	6285336	GUIDE
26	6285332	HEAD MICRO ADJUST KNOB
27	6285365	KNOB
28	6285331	CAM HANDLE FENCE HEAD
29	6285333	HEAD LOCKING CAM
31	6285366	SCREWS, CAP HD.
32	6285342	HEAD LOCKING CAM WEAR PLATE
33	6285367	SCREWS, BOTTOM HD.
34	6285343	HEAD LOCKING CAM PIN
35	6285336	GUIDE
36	6285368	SCREWS, ROUND HD.
37	6285341	HEAD WELD ASSEMBLY
38	6285369	SPACERS, HD.
39	6285370	SCREWS, ROUND HD.
40	6285335	FENCE BAR HOLD DOWN BRACKET
41	6285371	SCREWS, ROUND HD.
42	6285372	BUTTON, SUPPORT
43	6285340	REAR RAIL
44	6285338	FENCE EXTRUSION



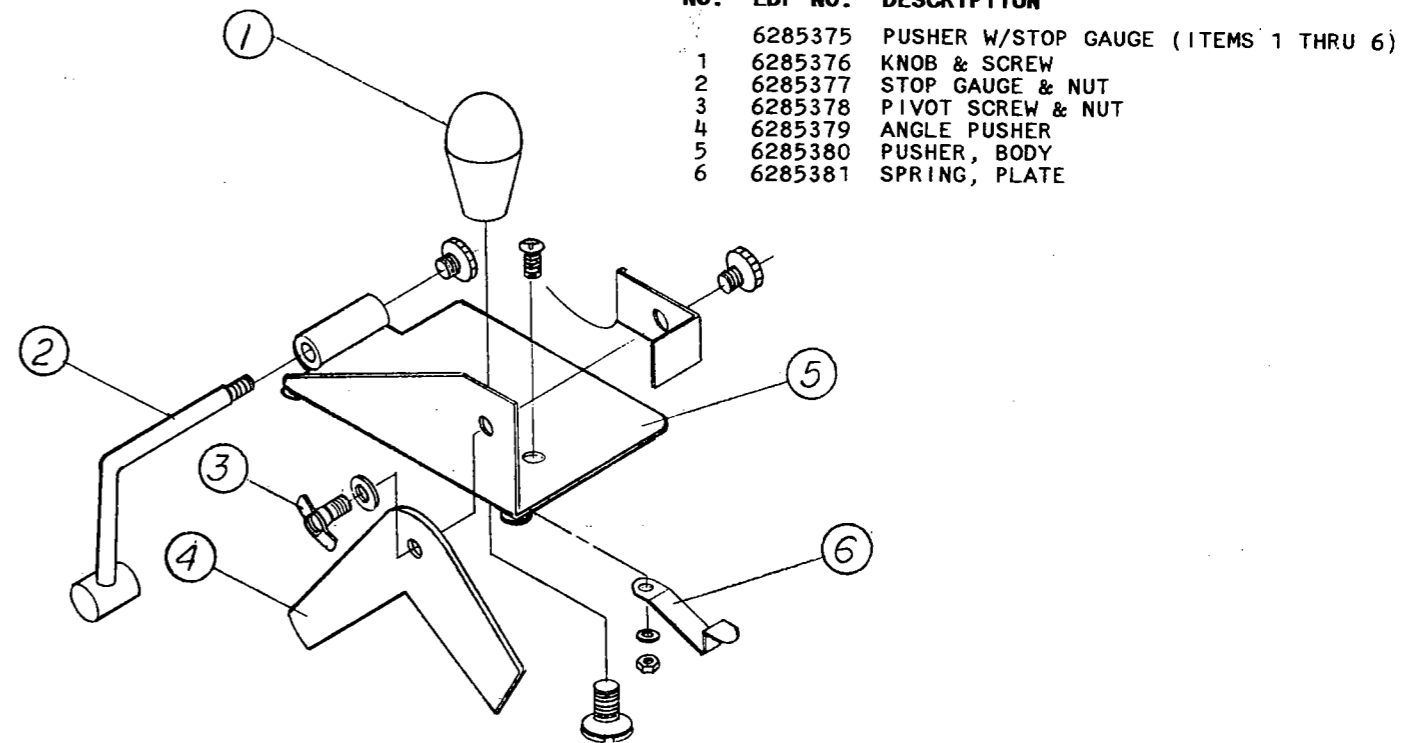
OPTIONS

Caster(2)



EDP NO.	DESCRIPTION
6285200	CASTER (2) (ITEMS 73, 75, 76, & 77 SEE PARTS LIST, PAGE 22)

Pusher with Stop Gauge



ITEM NO.	EDP NO.	DESCRIPTION
	6285375	PUSHER W/STOP GAUGE (ITEMS 1 THRU 6)
1	6285376	KNOB & SCREW
2	6285377	STOP GAUGE & NUT
3	6285378	PIVOT SCREW & NUT
4	6285379	ANGLE PUSHER
5	6285380	PUSHER, BODY
6	6285381	SPRING, PLATE

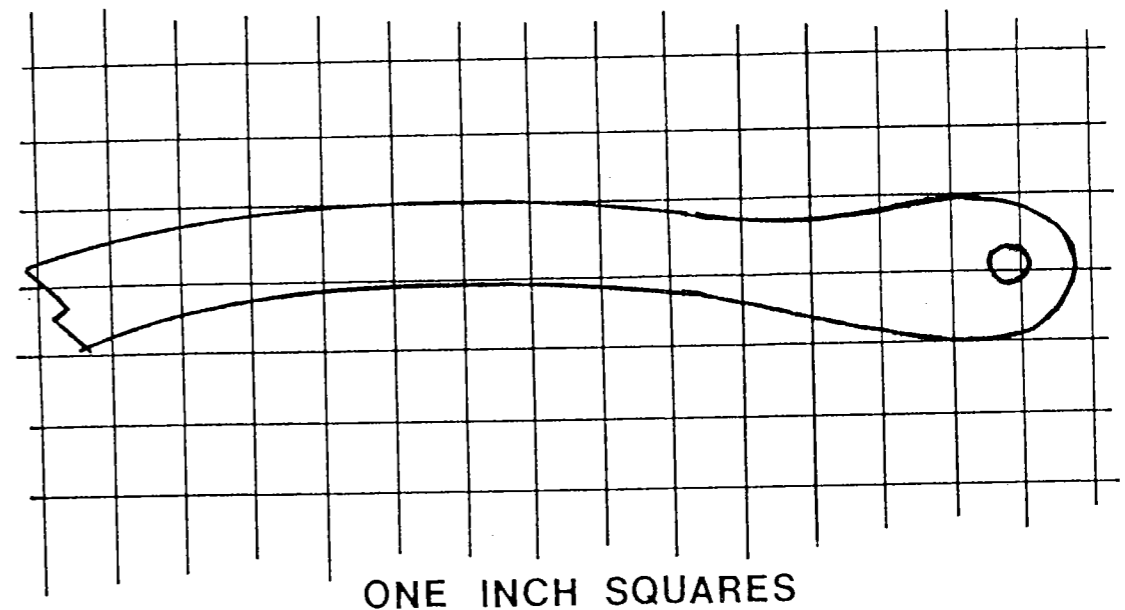
TROUBLE SHOOTING HINTS

TROUBLE	POSSIBLE CAUSE	REMEDY
EXCESSIVE VIBRATION	<ol style="list-style-type: none"> 1. Tilt or raising clamp knobs not tightened. 2. Blade out of balance. 3. Bad Motor. 	<ol style="list-style-type: none"> 1. Tighten knobs. 2. Change blade. 3. Replace motor.
CUT OUT-OF-SQUARE WHEN CROSSCUTTING	<ol style="list-style-type: none"> 1. Miter gauge out of adjustment. 2. Miter slot misaligned. 	<ol style="list-style-type: none"> 1. Reset stops and pointer. 2. Realign table.
MOTOR STALLS OR WORK PIECE BINDS OR BURNS	<ol style="list-style-type: none"> 1. Excessive feed. 2. Bad motor. 3. Dull or incorrect blade. 4. Miter slot misaligned. 5. Fence misalignment. 	<ol style="list-style-type: none"> 1. Reduce feed. 2. Replace motor. 3. Replace blade. 4. Realign miter slot. 5. Realign fence.
CUTS NOT TRUE AT 90 OR 45	<ol style="list-style-type: none"> 1. Stop screws not set properly. 	<ol style="list-style-type: none"> 1. Readjust stop screws.
TILT OR SAW RAISING HANDWHEELS DIFFICULT TO TURN	<ol style="list-style-type: none"> 1. Clamp knobs not released. 2. Worm and worm gear segment caked with sawdust and pitch. 3. Worm and worm gear segment out of alignment. 	<ol style="list-style-type: none"> 1. Unclamp. 2. Clean and grease. 3. Realign worm and worm gear segment.
MOTOR OVERHEATS	<ol style="list-style-type: none"> 1. Motor overloaded. 2. Improper cooling of motor. 	<ol style="list-style-type: none"> 1. Correct overload condition such as reducing the feed rate. 2. Clean sawdust from fan and duct areas of motor.
MOTOR STARTS SLOWLY OR FAILS TO COME UP TO FULL SPEED	<ol style="list-style-type: none"> 1. Low voltage. 2. Centrifugal switch not operating. 3. Bad motor. 	<ol style="list-style-type: none"> 1. Request voltage check from power company and correct low voltage condition. 2. Replace switch. 3. Replace motor.
MOTOR FAILS TO DEVELOP FULL POWER	<ol style="list-style-type: none"> 1. Power line overloaded. 2. Undersize wires in supply system. 3. Low voltage. 4. Bad motor. 	<ol style="list-style-type: none"> 1. Correct overload condition. 2. Increase supply wire size. 3. Request voltage check from power company and correct low voltage condition. 4. Replace motor.

WARNING: ALWAYS KEEP ALERT. DO NOT ALLOW FAMILIARITY (GAINED FROM FREQUENT USE OF YOUR ARTISAN'S SAW TO CAUSE A CARELESS MISTAKE. ALWAYS REMEMBER THAT A CARELESS FRACTION OF A SECOND IS SUFFICIENT TO INFLICT SEVERE INJURY.

OPTIONS

MAKE A PUSHTICK



NOTES

POWERMATIC WARRANTY

Powermatic will repair or replace, at its expense and at its option, any Powermatic machine, machine part or machine accessory which in normal use has proven to be defective in workmanship or material, provided that the customer returns the product prepaid to the Authorized Powermatic Distributor from which the machine was purchased within one year and provides Powermatic with reasonable opportunity to verify the alleged defect by inspection. Powermatic will not be responsible for any asserted defect which has resulted from normal wear, misuse, abuse or repair or alteration made or specifically authorized by any one other than an authorized Powermatic service representative. Under no circumstances will Powermatic be liable for incidental or consequential damages resulting from defective products. This warranty is Powermatic's sole warranty and sets forth the customer's exclusive remedy, with respect to defective products all other warranties expressed or implied whether of merchantability, fitness for purpose or otherwise are expressly disclaimed by Powermatic.

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