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manual for our

MODEL SUP-500-NF

PRECISION MITER UP-CUT

NON-FERROUS SAW



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MODEL

SUP-500 NF

COLD SAW

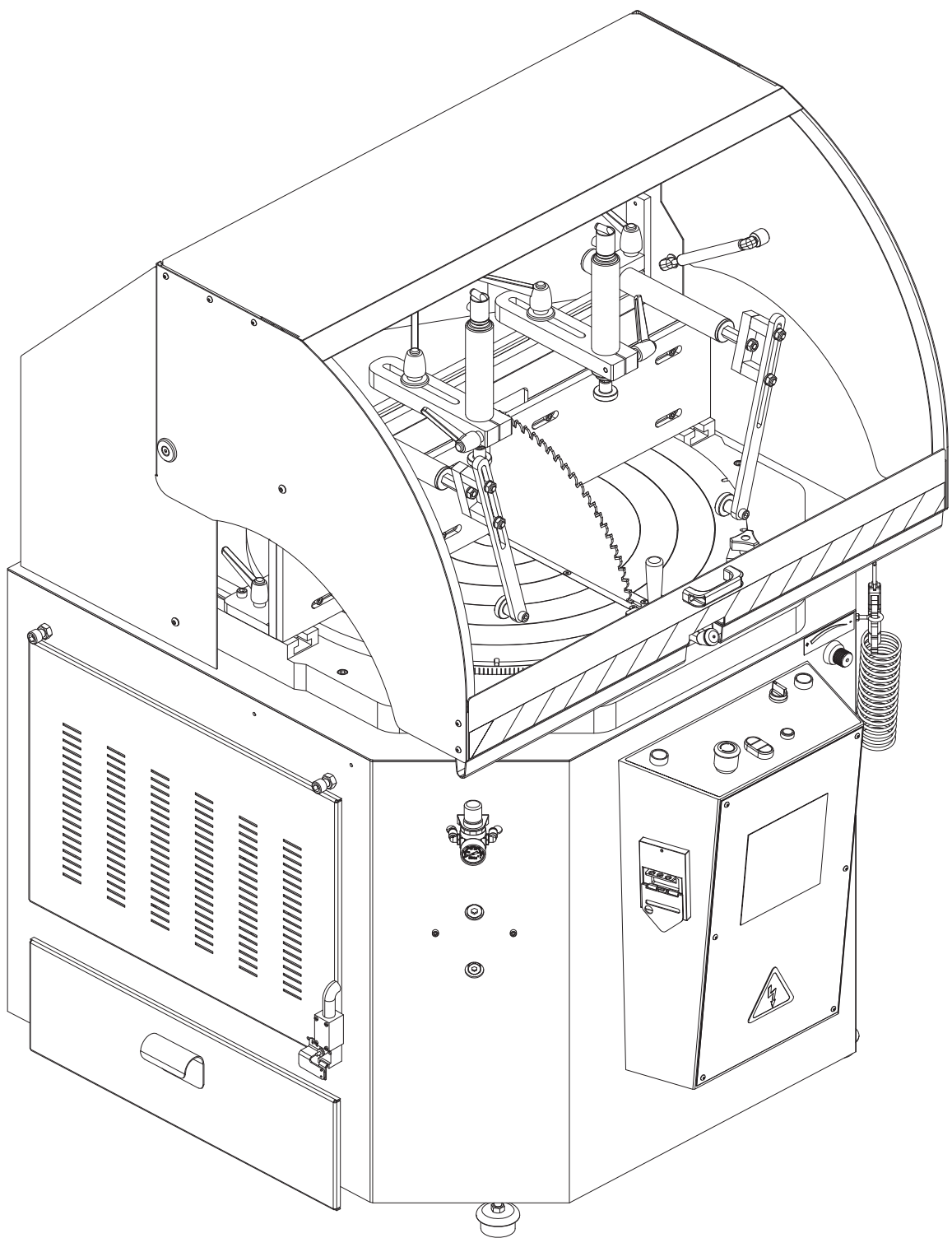


FIGURE 1

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1.0 INTRODUCTION

The instruction manual represents an integral part of the machine. It must be consulted before, during and after the machine is put into service, as well as whenever it is considered necessary, thereby respecting its content in each and every one of its parts. This is the only way in which the fundamental objectives that have been established on the basis of this manual will be achieved; such as, accident prevention and making optimal use of the machine features. Within the framework of this manual, all aspects regarding safety and accident prevention on the job while using the machine have been considered in every detail, herein highlighting the information that is of greatest interest to the user.

- ☛ **ATTENTION** Carefully read this manual before installing the machine. The manual must be kept throughout the machine's lifetime in a place that is easy to find in the event that it is needed. In the event that a used machine is sold, the machine shall be sold together with this manual. In the event that the machine is scrapped, the identification plate and any other document supplied with the same shall be destroyed.

1.1 WARRANTY

Scotchman Industries, Inc. will, within three years of the date of purchase, replace F.O.B. the factory or refund the purchase price for any goods which are defective in materials or workmanship, provided the buyer, at the seller's option, returns the defective goods freight and delivery prepaid to the seller, which shall be the buyer's sole and exclusive remedy for defective goods.

This warranty does not apply to machines and/or components which have been altered, changed or modified in any way or subjected to abuse and abnormal use, inadequate maintenance and lubrication or subjected to use beyond the seller's recommended capacities and specifications. In no event shall the seller be liable for labor cost expended on such goods or consequential damages.

The seller shall not be liable to the purchaser or any other person for loss or damage directly or indirectly arising from the use of the goods or from any other cause.

No officer, employee or agent of the seller is authorized to make any oral representations or warranty of fitness or to waive any of the foregoing terms of sale and none shall be binding on the seller.

Any electrical changes made to the standard machine due to local electrical code variation must be paid by purchaser.

As we constantly strive to improve our products, we reserve the right to make changes without notification.

This warranty is effective December 1, 2009.

2.0 GENERAL INFORMATION

2.1 Machine Identification Data

Model----- SUP-500-NF

Serial number-----

Manufacturing year-----

- ☒ **NOTE: IN ORDER TO REQUEST SPARE PARTS, WHETHER COVERED BY THE WARRANTY OR NOT, ALWAYS INDICATE THE MODEL AND SERIAL NUMBER OF THE MACHINE, AS WELL AS THE NAME OF THE PART AND THE PART NUMBER THAT APPEAR IN THE LAST CHAPTER OF THE PARTS EXPLODED VIEWS.**

2.2 Technical Data

CHARACTERISTIC	DIMENSION
Three phase motor	4HP, 220/380V
Motor speed	3000 RPM
Interior Ø of blade	1.97"
Maximum Ø of saw blade	19.7"
Turn	35° RIGHT 45° LEFT
Working pressure	6.07 Bar, 88.17 PSI
Pneumatic hold-down clamps	2 vertical + 2 horizontal
Lubrication system	Pneumatic, by sprayer
Dimensions	47" x 43" x 59"
Weight	950 lbs

FIGURE 2

2.3 Dimensions of the Machine

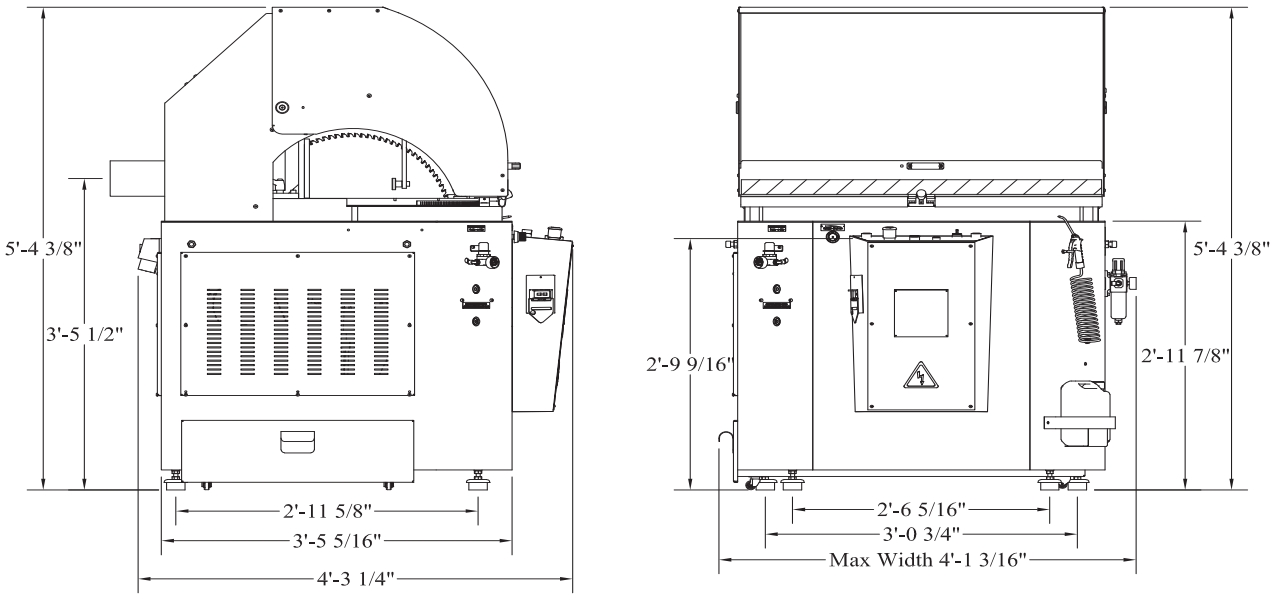


FIGURE 3

2.4 Cutting Capacity

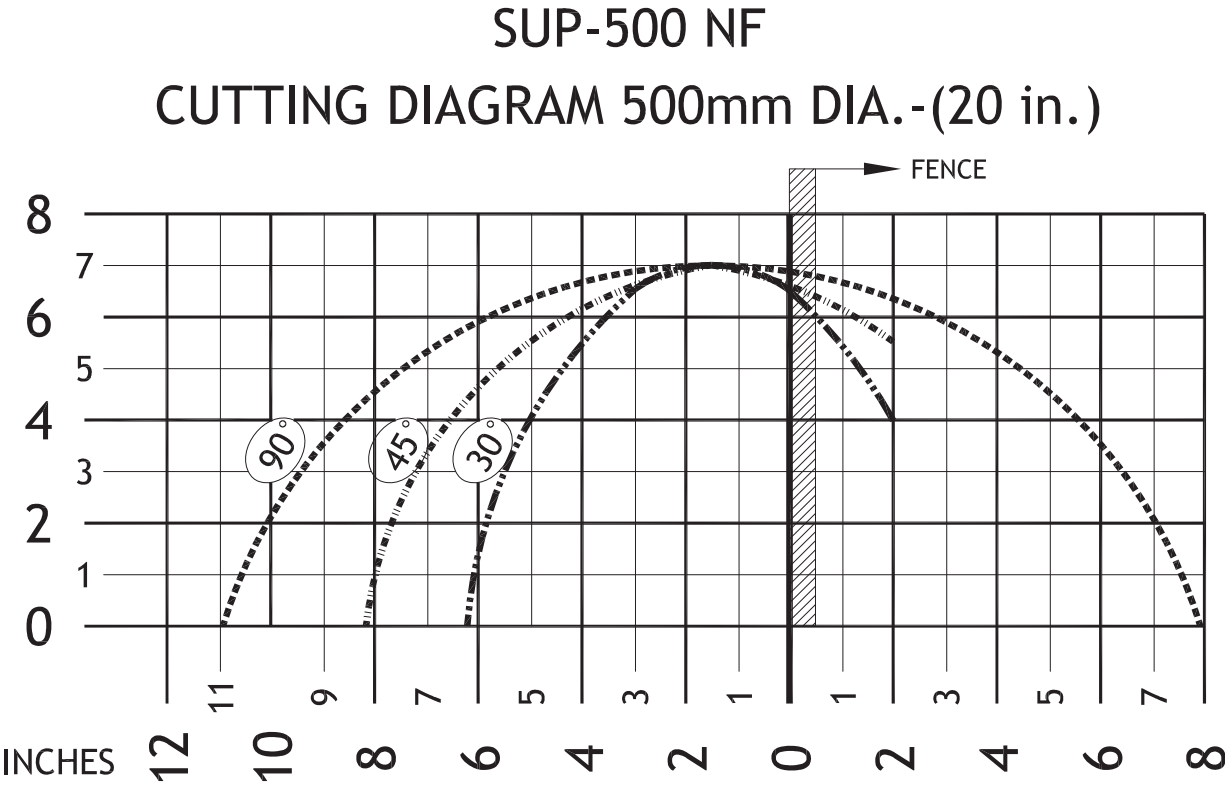


FIGURE 4

2.5 Electrical Data

Power Supply	Motor Power	Total Consumption
230 V Three phase	3 kW/ 4 HP	12 Amps at 60Hz
460 V Three phase	3 kW/ 4 HP	7 Amps at 60Hz

2.6 Noise Level

At a distance of 2'	RUNNING OFF-LOAD	68 dB (A)
	MACHINING A 2.75" X 2" PROFILE	120 dB (A)

⊠ ATTENTION: When working with the machine, use individual hearing protection equipment.

3.0 INSTRUCTIONS REGARDING TRANSPORT & STORAGE

The machine is delivered on a pallet in order to be moved by a forklift.

Store in the vertical position. Do not stack.

If the machine remains stored for a long period of time, periodically lubricate it.

Do not expose to the elements.

The packaging is made of properly designed and sized wood and is also wrapped in plastic.

➡ CAUTION: Do not improperly dispose of the packaging. Send this material to be recycled or disposed of in accordance with all legislation in force.

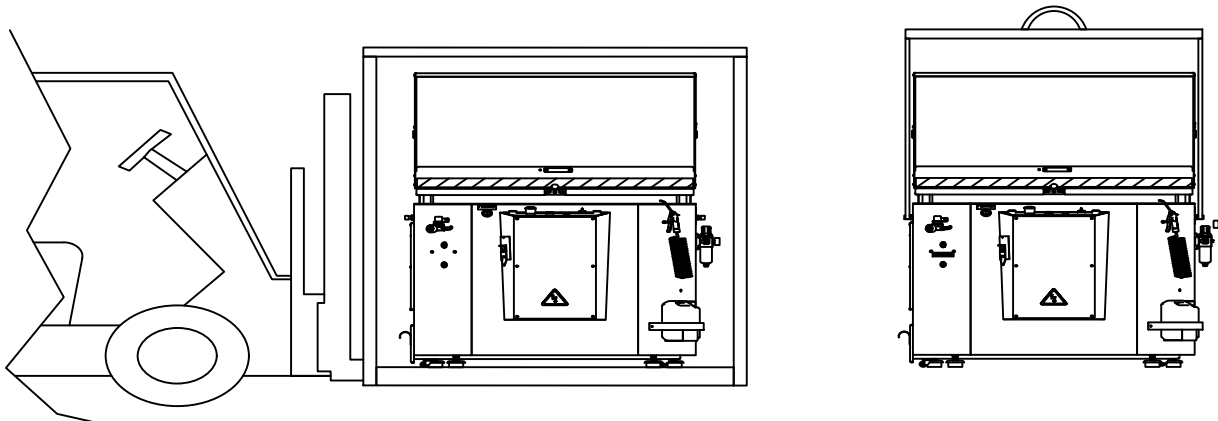


FIGURE 5

4. INSTRUCTIONS FOR ANCHORING/ SERVICE START-UP

4.1 Anchoring Instructions

Ensure that the machine has not suffered any damage during transport by making an initial visual inspection. If damage is observed, advise the carrier immediately.

The machine must be installed on a firm surface that is as level as possible, in order to reduce vibrations during operation and so that it operates within the parameters established by the manufacturer.

Verify that the power supply voltage corresponds to the voltage indicated on the specifications plate of the machine. Connect the cable to the power supply, using a plug that is appropriate for the characteristics of same, thereby respecting the color codes. Once connected to the machine, verify the sense of rotation; if the rotation is not correct, change two phases of the plug.

4.2 Power Supply Connection

Verify that the power supply voltage corresponds to the voltage indicated on the specifications plate of the machine. Connect the cable to the power supply, using a plug that is appropriate for the characteristics of same, and complies with local and national electric codes.

Once the machine is connected, verify that the motor rotation agrees with the direction of the saw blade teeth (rotation to the right). If the motor rotation were not correct, change the two phases of the motor. Then, check the rotation again.

The pneumatic connection must be made to the supply system, using a tube that is appropriate for the spigot of the machine. Adjust the pressure at the filtering group.

➡ **ATTENTION:** The pneumatic working pressure must be between 88 and 103 PSI (6 to 7 Bar).

4.3 Pressure Regulator

The pressure of the air inlet in the machine must be 95 to 105 PSI (6.55 to 7.23 Bar).

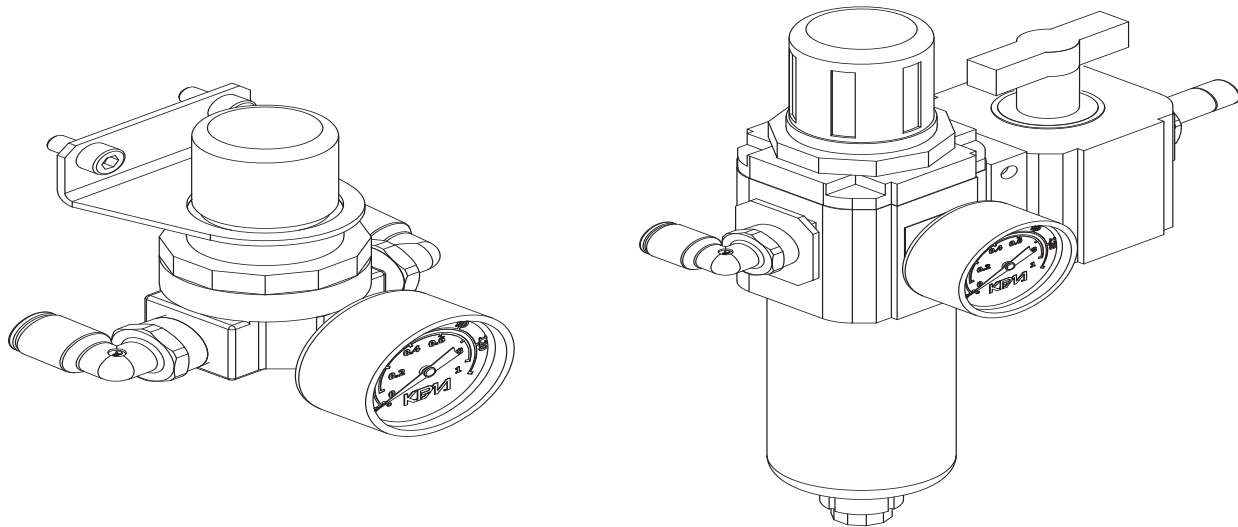


FIGURE 6

4.4 Blade Installation Instructions

This machine uses a 500mm blade with a 50mm arbor.

1. Set the saw to 90 degrees and disconnect the power. Open the cabinet door and remove the existing blade.

☒ **NOTE:** The blade nut is right hand threaded.

2. Insert the rod provided with the machine into the blade flange (1) and loosen the blade nut (2) with the wrench provided. The teeth on carbide blades are very sharp and we recommend using gloves while changing blades. Remove the blade.
3. Check the blade flange and the blade seat for any chips or nicks before installing the new blade.
4. Install the new blade and the blade flange and blade nut. Before locking the blade in place, rotate the blade up against the pin (3) and lock the blade in place. The teeth of the blade rotate away from the operator when the operator is standing in front of the machine.

- **CAUTION:** Make sure that the blade is installed with the teeth in the right direction for the rotation and that the saw is wired for the correct rotation. If the saw is not wired for the correct rotation, the blade will come loose when the saw is powered. If the blade is not installed in the proper orientation, the teeth will be dulled almost immediately.
5. Close the access panel and reset the safety switch.

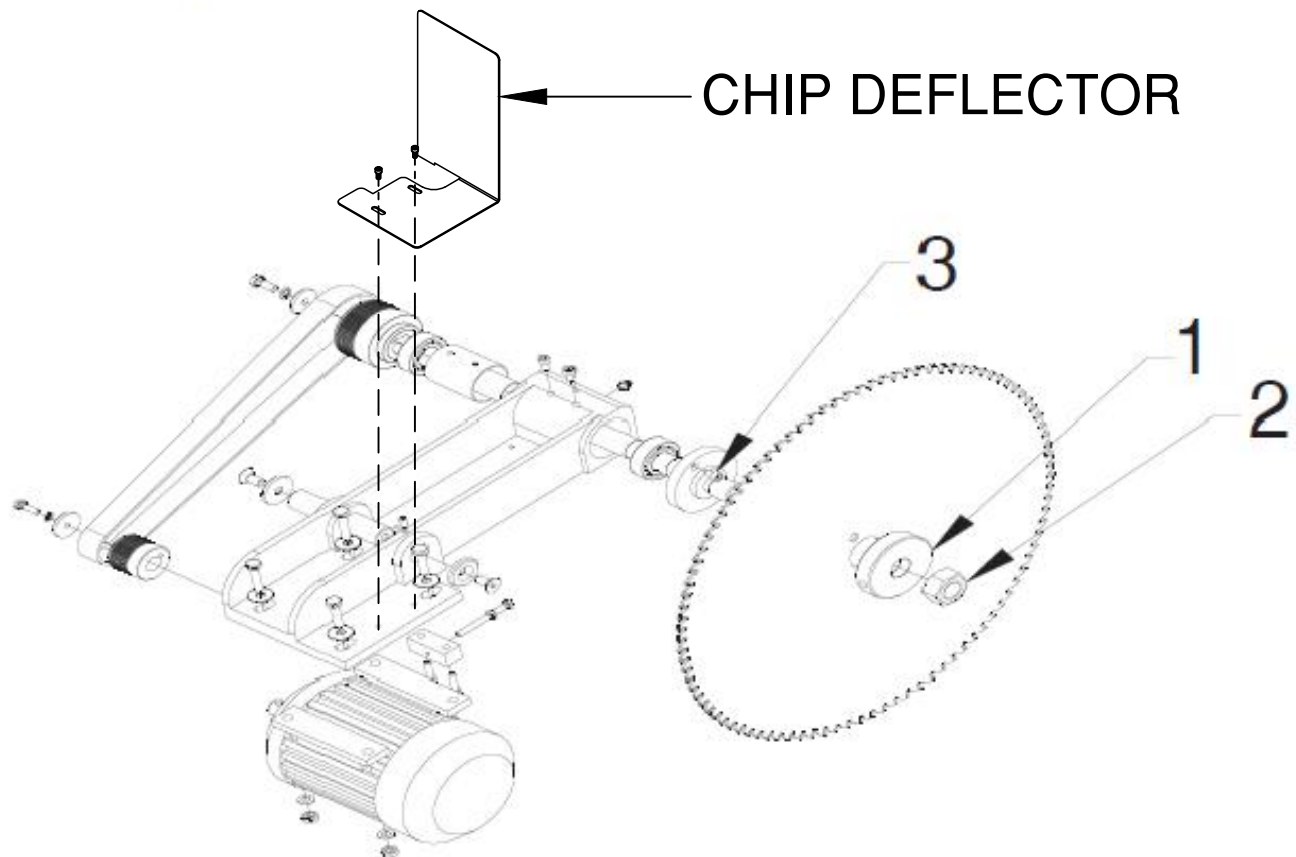


FIGURE 7

4.5 Cutting Coolant

In order to fill the machine with cutting coolant, open the reservoir and fill with Econolube or, equivalent.

4.6 Pneumatic Oil

Both the oleo-pneumatic converters and the filter group lubricator must be filled with ISO VG 16 VISCOSITY PNEUMATIC OIL or AW 32, 10 weight hydraulic oil. If none is available, use hydraulic oil 16. SUP 500 or 600 will take approximately 4 cups or 1 quart.

5. INSTRUCTIONS FOR USE

5.1 Proper and Improper Use

This is a semiautomatic cut-off machine especially designed for cutting aluminum profiles. The use of the machine for cutting other materials is hereby prohibited. Such use may cause damage to the machine and put the health and safety of the worker at risk.

► **DANGER:** We are not responsible for any possible accident caused by the failure to comply with the aforementioned provision.

5.2 Function of the Operating Mechanisms

1. Horizontal hold down clamp
2. Vertical hold down clamp
3. Turret travel lever
4. Hood
5. Back fence adjustment handle
6. Filter regulator
7. Pneumatic cleaning gun
8. Advance blade feed regulator
9. Pushbuttons for raising the saw blade
10. Hold down clamp operation
11. Green indicator light
12. Saw blade on-off
13. Emergency stop
14. Clamp pressure regulator

► **DANGER:** Always work with the protective shield lowered.

► **DO NOT DISCONNECT ANY SAFETY DEVICES!**

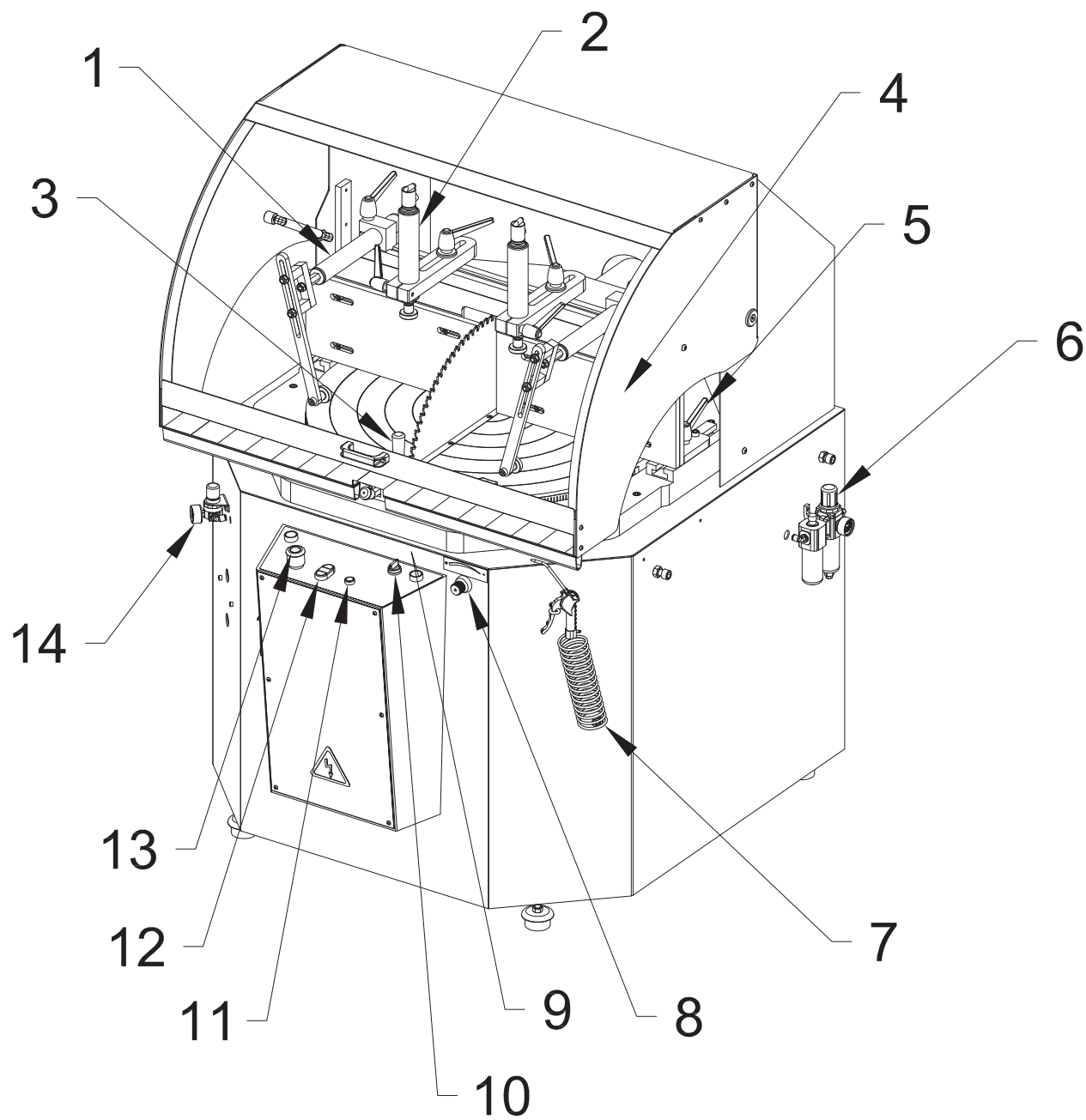


FIGURE 8

5.3 Adjusting the Digital Degrees

NOTE: This is **OPTIONAL** for this machine.



FIGURE 9

5.4 General Rules and Safety Checks

- ✓ Before using the machine, check the efficiency and operation of all safety devices and check that the moving parts of the machine are not blocked, that there are no damaged parts and that all machine components are positioned and working correctly.
- ✓ NEVER operate the machine with any of the safety devices disabled or removed from this machine.
- ✓ It is entirely prohibited to work without the protective shield in position.
- ✓ It is mandatory to use to use gloves an protective eyewear.
- ✓ It is mandatory to use regulation work clothing. (It must be work fastened)
- ✓ Before starting work, the operator must ensure that all tools and wrenches, used for maintenance or adjustment, have been removed.
- ✓ In the event of a fire, use powder extinguishers and disconnect the machine from the electric system.

6.0 RECOMMENDATIONS AND MAINTENANCE

6.1 Type and Frequency of Inspections

The operator's knowledge of the machine is one of the best ways of daily control of any possible problem. If any failure is detected, work must be stopped and qualified personnel must be informed immediately.

☒ **NOTE:** Always clean the machine and the work area at the end of the work day.

MAINTENANCE TABLE

LUBRICATION POINTS	TYPE OF GREASE/OIL	FREQUENCY
Turret travel rail	SAE 30 lubricating oil	WEEKLY
Rocker bearings (Figure 7.4)	Roller bearings grease	ANNUALLY
Pneumatic cylinder	AW 32	ANNUALLY

CHECK POINTS	FREQUENCY
Machine cleaning	WEEKLY
Condition of the transmission belt	WEEKLY

6.2 Qualified Personnel for Maintenance and Repair Work

All repairs shall be made exclusively by qualified personnel. Always use original replacement parts. If not, the machine may be damaged or the user may be injured. The maintenance and cleaning of the machine must not be neglected. The life of the machine and its optimal operation depend on it.

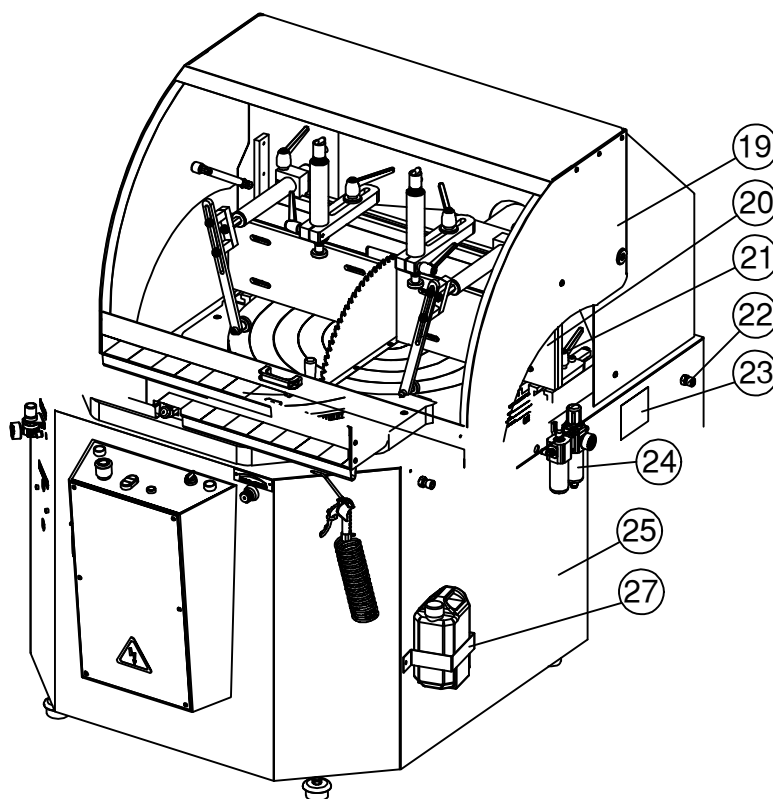
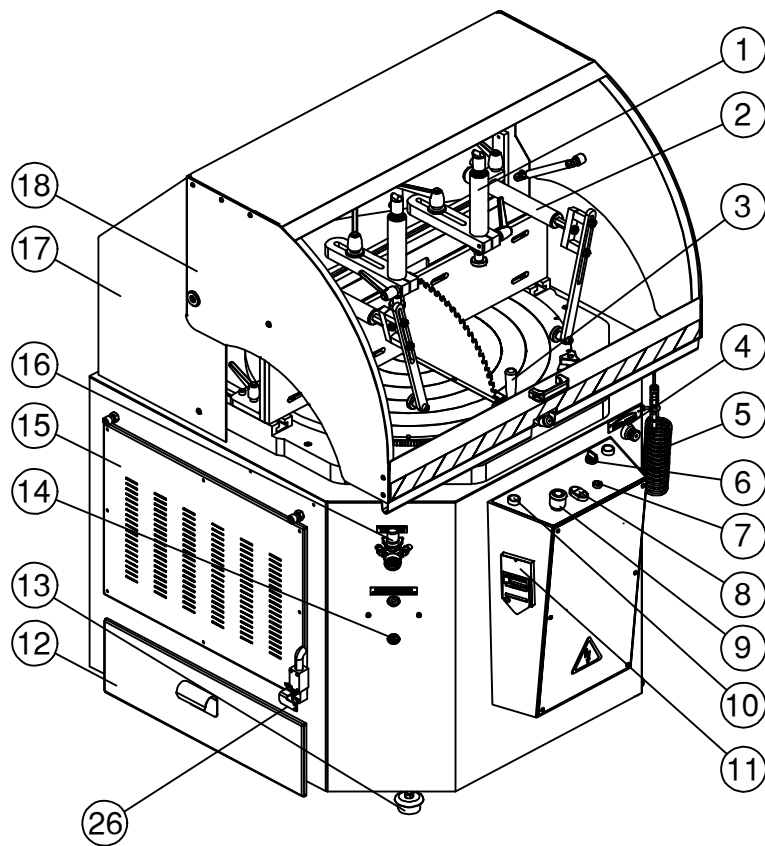
6.3 Manufacturer's Recommendations

- ☒ In the event that the machine is broken down or the saw blades must be replaced, place a padlock on the protection switch and place the keys under the care of qualified personnel.
- ☒ Before working on any electrical devices, disconnect the plug from the power supply.
- ☒ If extension cords are used, ensure that the cable has the appropriate cross-section for the power of the machine.
- ☒ Whenever any part has to be replaced, use an original replacement part and endeavor to use the oil recommended by the manufacturer.
- ☒ **NOTE:** In case of any doubt or problem, do not hesitate to consult the manufacturer.
- ➡ **ATTENTION:** The manufacturer hereby guarantees the supply of each of the parts or components for at least three years from the manufacturing date of the machine.
- ➡ **ATTENTION:** The manufacturer is not responsible for breakdowns caused by the improper use of the machine.
- ☒ Once a week, all of the chips in the saw should be thoroughly cleaned out. This includes blowing out the chips in the motor fan guard.
- ☒ Once a month, check the motor belt for any wear.
- ☒ Once a month, grease the bearing hub.

7.0 DRAWINGS & SCHEMATICS

7.1 General Schematic

ITEM	PART #	DESCRIPTION
1	1677	Ø 45 Pnuematic Hold-Down Clamp
2	N00PT14050	Horizontal Clamp Ø40X220
3	2040000482	Angle Lock
4	N000000018	Advance Regulator 3/8"
5	N000000021	Cleaning Gun With Hose
6	011877	Selector Switch
7	E000000030	Green Indicator 24V
8	E000000011	Blade On-Off Switch- Operator Only
9	11837	E-Stop Switch Ass'y
9A	11862	E-Stop Operator Pkgd. W/ 11872
10	N000000008	Green Vertical Align Button
11	000943	230V Motor Protect Switch 10-16A
11A	000940	460V Motor Protect Switch 6-10A
12		Chip Drawer
13	B000121001	Feet Levelers M12
13A	1156	M16 Feet Levelers
14	2040000092	Oleo Pneu Converter
15		Left Door
16	N000000030	Pressure Regulator
17		Protective Shield Support
18	2050004542	Hood Window SUP500
19	E00000BD25	Hood Switch
20		Turret
21	B0000P1040	M10X40 Lever
22		M14 X 40 Screw + (2) M14 Nuts
23		CE Identification
24	N000000017	Filter Regulator - Manometer
25		Sheet Metal Base
26	CE000000R81	Door Interlock
27	077927	NF Coolant Reservoir USA Only



Filter Regulator
Lubricator has a 1/4"
BSPT Thread

FIGURE 10

7.2 Power Circuit

ITEM	PART #	DESCRIPTION
01	000940	Motor Protect Switch 6-10A
	K000000005	Main Switch 16A
02	060071	Contactor TKC9 24V 50/60Hz
03	C2050000522	5.5HP 230V/460V 3PH Motor
04	E000000014	Transformer 50VA 24V REF#1881
05	071085	2 Amp Fuse
06	011862	E-Stop Operator With 011872 (Adapter)
6A	011832	Contactor EK10 (for E-Stop)
07	E000000030	Green Indicator 24V

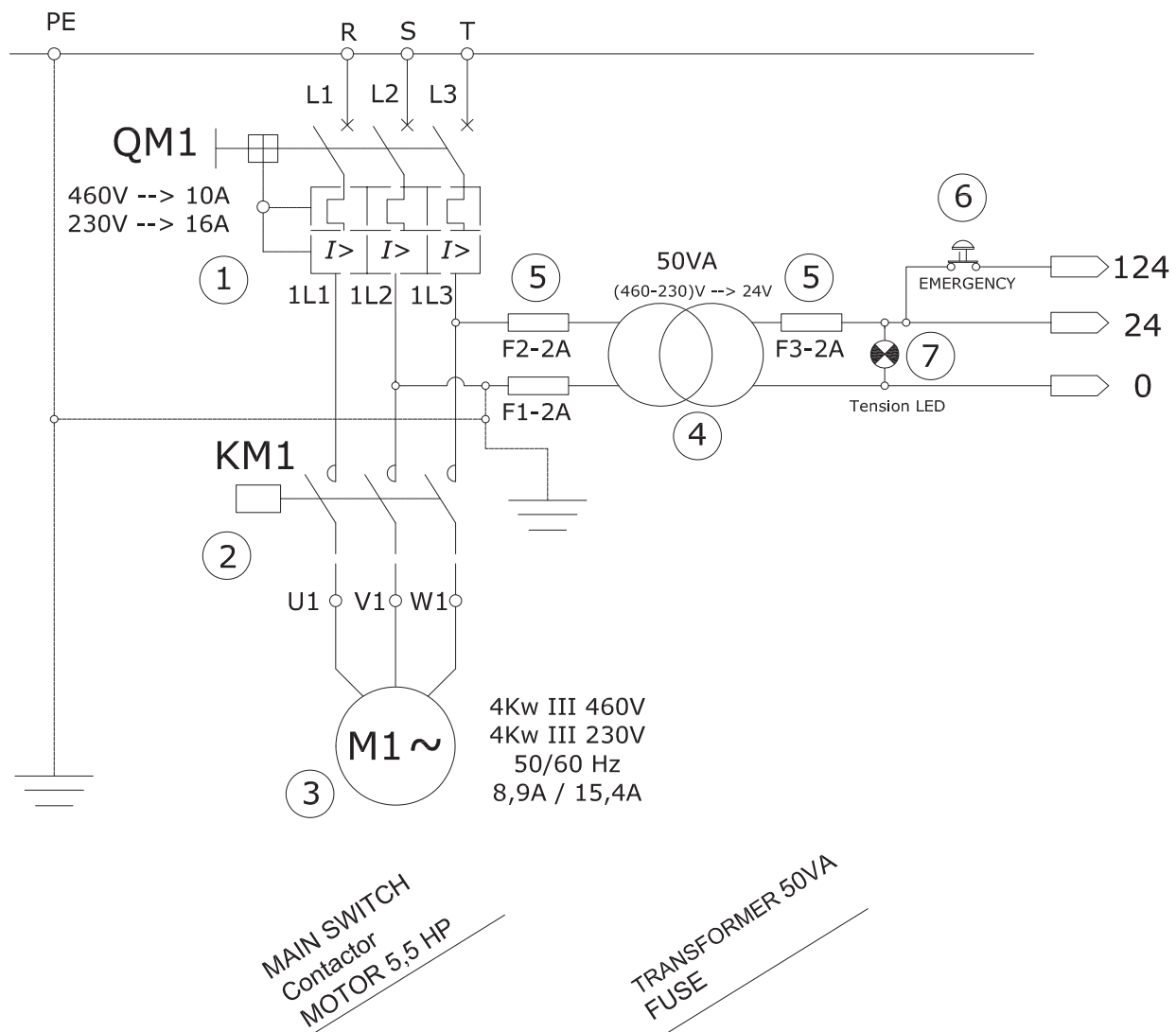


FIGURE 11

7.2A Switching Power Circuit

ITEM	PART #	DESCRIPTION
8	011877	Selector Switch
9	E00000BD25	Hood Switch
10	12152	Microswitch (End Of Travel M-12 For SUP-500)
11	E000000011	Blade ON-OFF Switch- Operator Only (Add 011867 & 011874 for complete switch)
12	N000000008	Green Vertical Align Operator Only
13	1618	KPM Valve With Coil
13A	1620	KPM Coil 24VAC
14	1440	High + Low Pneumatic
15	060071	DILM 12-10 24VAC Contact
16	1724	Magnetic Sensor - Power Hood (Must Specify KT-50R or KT50-P)
16A	028459	Wire Harness with #1724 (Above)
17	E000000095	Omron Relay SUP500/SUP600
18	078557	ESR5-NZ-21-24VAC-DC

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7.2B Operating Controls

- 6 Emergency button w/interlock.**
- 7 Green indicator light, power supplied to the machine.**
- 8 Hold-down clamp selector.**
If the customer has a Razor Gauge, this is what is needed:
 - 1 Switch (Part # 011878)**
 - 2 NC Contact (Part # 011867)**
 - 1 Mounting Adaptor (Part # 011872)**
 - 1 No contact (Part # 011874)**
- 11 Saw blade ON-OFF; On, green colored symbol - I, Off, red O**
- 12 Push buttons, for raising the saw blade**
- 18 Auto-manual selector for the pneumatic protective shield operation (Optional)**
- 19 P/N 677 - Legend Plate**

19. P/N 677 - LEGEND PLATE

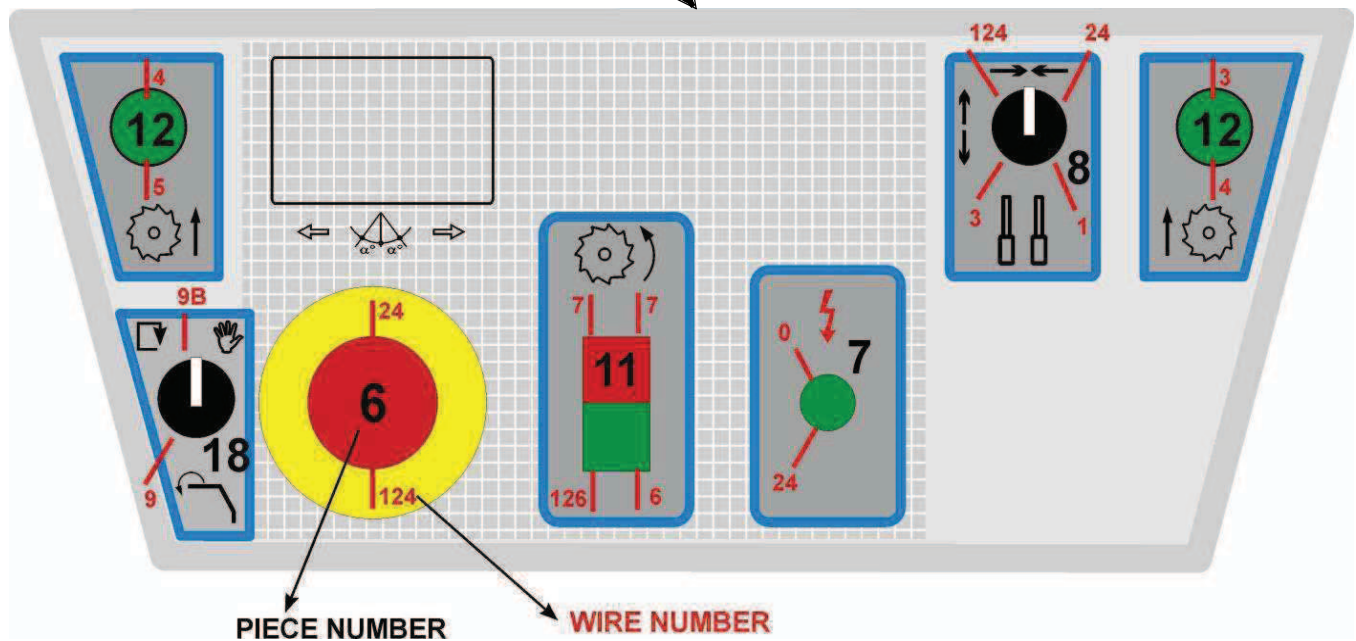


FIGURE 13

7.3 Pneumatic Schematic

ITEM	PART #	DESCRIPTION
00		Line
01	N000000017	F + R + L 1/4"
02	1620	KPM Coil 24VAC
03	1440	High + Low Pneumatic
04	N000000038	Quick Exhaust Valve 1/8"
05	N000000030	Pressure Regulator 1/4"
06	N02PT14050	Horiz Clamps Ø40 x 320
07	2K20000281	Mini Ball Valve 1/8" M-H
08	N0CCRC1806	Flow Regulation 1/8" Ø6 CIL.
09	N000000038	Quick Exhaust Valve 1/8"
10	N000000015	Uni Directional Valve
11	*1677	Holddown Clamp 45MM
12	N000000021	Blow Air Duster
13	1618	KPM Valve With Coil
14	2040000092	Oleo Pneumatic Converter
15	N000000018	Advance Regulator 3/8"
15A	1667	Speed Regulator Knob (for above)
16	N000000025	Cylinder ISO 50 x 200
17	N000000036	Venturi Sprayer
18	077927	NF Coolant Resivoir (USA only)
19	1439	Pneumatic Protective Shield (Powerhood SUP-500) (see Section 8.1)

***ITEM 11:** THIS REPLACEMENT CYLINDER WILL RANGE FROM 225MM TO 250MM IN LENGTH. IT IS 100% INTERCHANGEABLE.

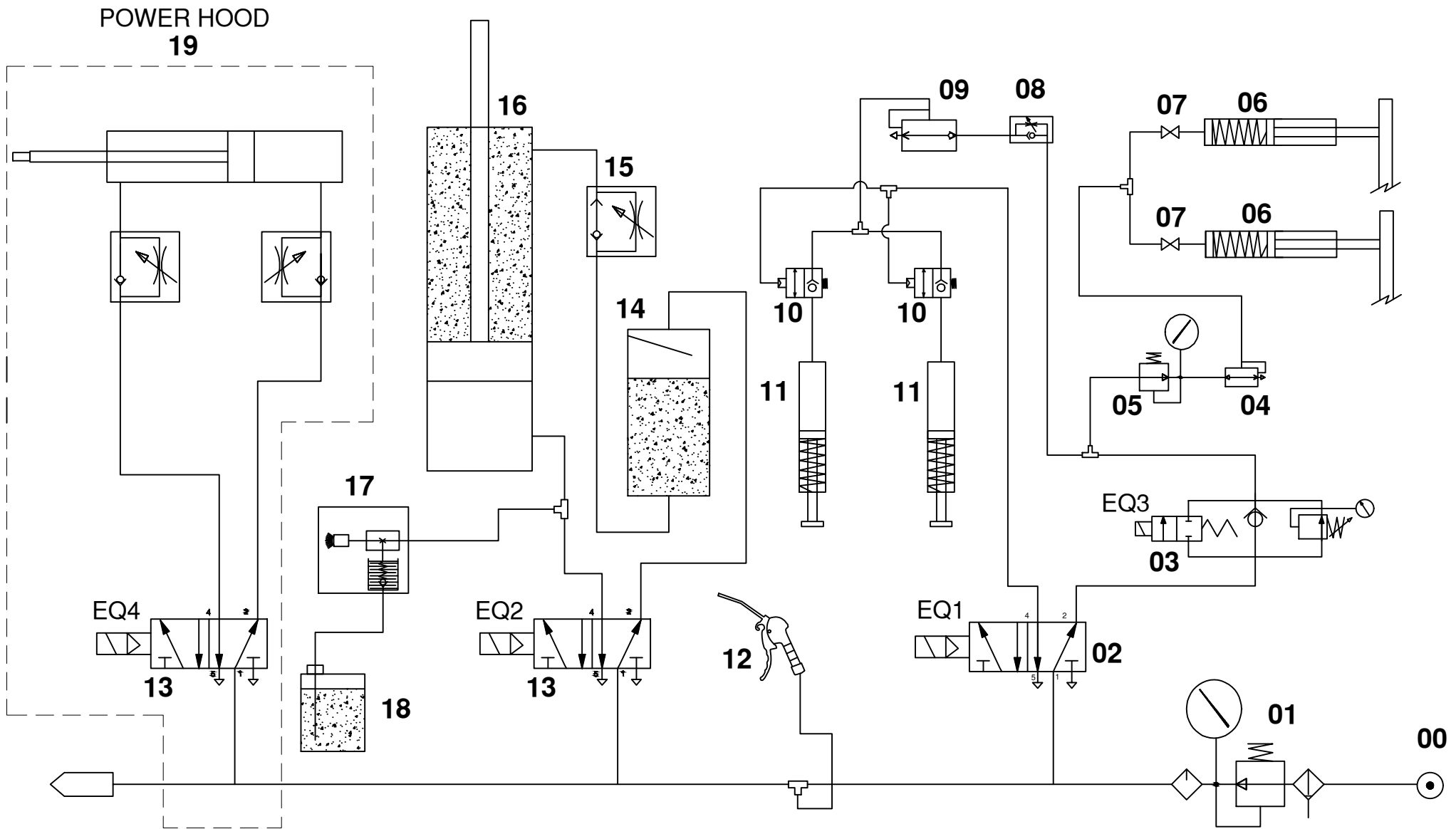


FIGURE 14

7.4 Clamp Jaws (Exploded View)

ITEM	PART #	DESCRIPTION
1	205000F012	Cast Iron Table
2	2040000482	Angle Lock
2B	B000000011	M8 Knob
3	TD79910820	DIN7991 M8 x 20 Screw
4	TD91210060	DIN912 M10 x 60 Screw
5	2040000F62	Angle Arrow
6	20400010312	Lock Guide Plate
6B	2040010312	Zero Position
6C	TD69120616	DIN6912 M6 x 16
7	2040000402	Turret Cotter
8	TD91206020	DIN912 M6 x 20 Screw
9	205000F022	Cast Iron Disc
9B	2050000522	Blade Groove
9C	TD79910616	DIN7991 M6 x 16
10	TD91208025	DIN912 M8 x 25 Screw
11	2350000131	Nylon Cleat Black M-10
12	2050000102	Aluminum Plates
13	2040000112	Horizontal Clamps Arm
14	TD79840620	ISO7984 M6 x 20 Screw
15	B0000000H2	Handle Tristar M-10
16	TD91210010	DIN912 M19 x 10 Screw
17*	B0000P1040	M10 x 40 Lever
18	2040001482	Clamps Aluminum Guide
19	N00PT14050	Horizontal Clamp Ø40 x 220
20	TD91208020	DIN912 M8 x 20 Screw
21*	B0000P1070	M10 x 70 Lever
22*	B0000P1270	M12 X 70MM Lever
23	204000A502	Aluminum Rod Hor. Clamp
24	2040000212	Vertical Clamps Ø45
25*	025361	M12 X 50MM Adjustment Handle
26	204000A452	Ø45-Æ12 Washer
27	2040000062	Ø45 Aluminum Rod
28	2040001512	Flat Nut M-12
29	2042000181	Nylon Brake Cleat
30	TD91310070	DIN913 M10 x 70 Screw

* SEE NOTE ON THE NEXT PAGE

31	B0000000H2
32	N000000015
33	2050000212

Handle Tristar M-10
Uni Directional Valve
Cast Iron Turret

NOTE:

ITEMS 17*, 21*, 22*, & 25* are all handles and are all different sizes. Please measure the diameter and length of threads before ordering to make sure you get the right size.

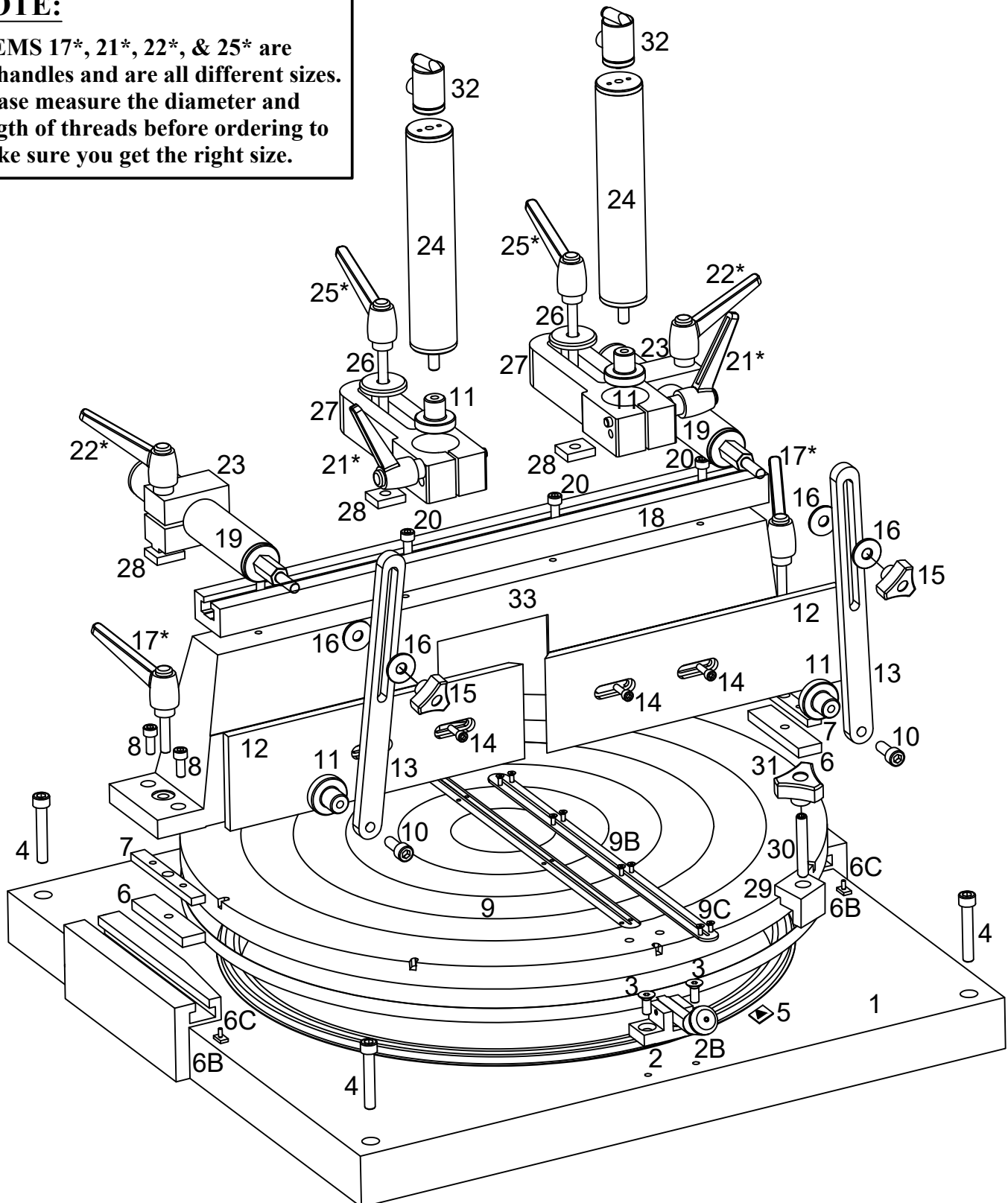


FIGURE 15

7.5 Protective Shield (Exploded View)

ITEM	PART #	DESCRIPTION
1	20400TB452	Ball Screw M-8 x 10
2	204000R452	Swivel Joint
3	2050000452	M-8 x 20 ØEXT 25 Separator
4	235000S471	M-8 x 20 ØEXT 25mm Separator
5	4884	Hood Rubber SUP Saws
6	B000000017	M-6 Handle
7	220014	M6 X 10MM BHCS
8	2050004521	Front Closing
9	23500040B1	Shield Post
10	220026	M8 X 12MM BHCS
11	2050004571	Protective Shield Support
12	073206	M6 Hex Nut
13	2040060291	Screen Hinges
14	214011	M8 Regular Washer
15	230007	M6 X 16 FSHCS
16	073206	M6 Hex Nut
17	215013	M8 Greer Nut
18	20500M6452	Eye M-6
19	2050451312	Left Protective Shield
20	T173800850	M8 X 50 BHCS
21	2050004542	Hood Window SUP500
22	2050004551	Above Closing
23	073206	M6 Hex Nut
24	20504513D2	Right Protective Shield
25	E00000BD25	Hood Switch

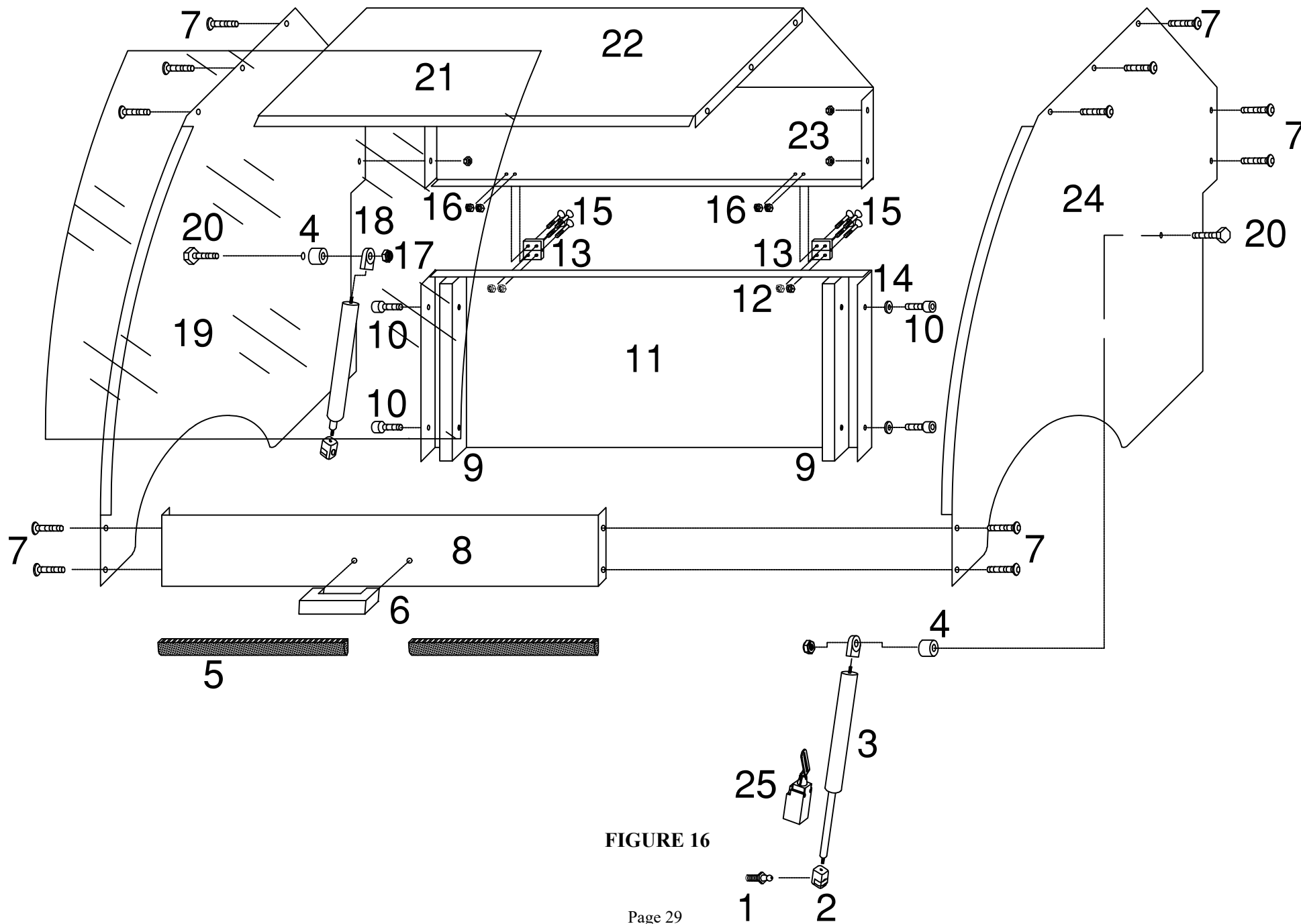


FIGURE 16

7.6 Rocker Assembly (Exploded View)

ITEM	PART #	DESCRIPTION
1	2050000522	4KW Motor III 230/460V
2	2050000332	Cast Iron Rocker
3	2050000322	Rocker Support
4	TD91310050	DIN931 M-10 x 50 Screw
5	2050000062	30 x 139 Connecting Rod Pin
6	2040000202	Belt Tension Adjuster
7	TD93308050	Tension Adjuster Screw
8	TD91208030	DIN912 M-8 x 30 Screw
9	2050000152	Blade Protector
10	N000000036	Venturi Sprayer
11	2040001172	Cylinder Anchor
12	2040060582	Ø60 Separator
13	2040025582	Ø36 Separator
14	2050000162	4206 Bearing
15	2040000402	Motor Cotter
16	2050000092	Ø30 Shaft
17	205DW35032	Ø500 Widia Blade
18	2050000032	Blade Washer
19	2040000232	Blade Shaft Nut
20	2050000132	Rocker Shaft Pulley
21	T00CH08040	8x7x40 Cotter
22	2050000142	Motor Pulley
23	2050000012	960 J12 Poly V-Belt
24	TD91212050	DIN912 M-12 x 50
25	2070000012	1/8" Lubricator
26	TD91208012	DIN912 M-8 X 12 Screw
27	TD91308015	DIN913 M-8 X 15 Stud
28	TD91206010	DIN912 M-6 x 10 Screw
29	TD93308025	DIN933 M-8 X 25 Screw
30	TD91212025	DIN912 M-12 X 25 Screw
31	TD12500012	Ø12 Connect Rod Pin Washer
32	TD12500008	Ø8 Washer
33	2040000532	Venturi Angle Plate
34	027500	SUP 500 Chip Deflector

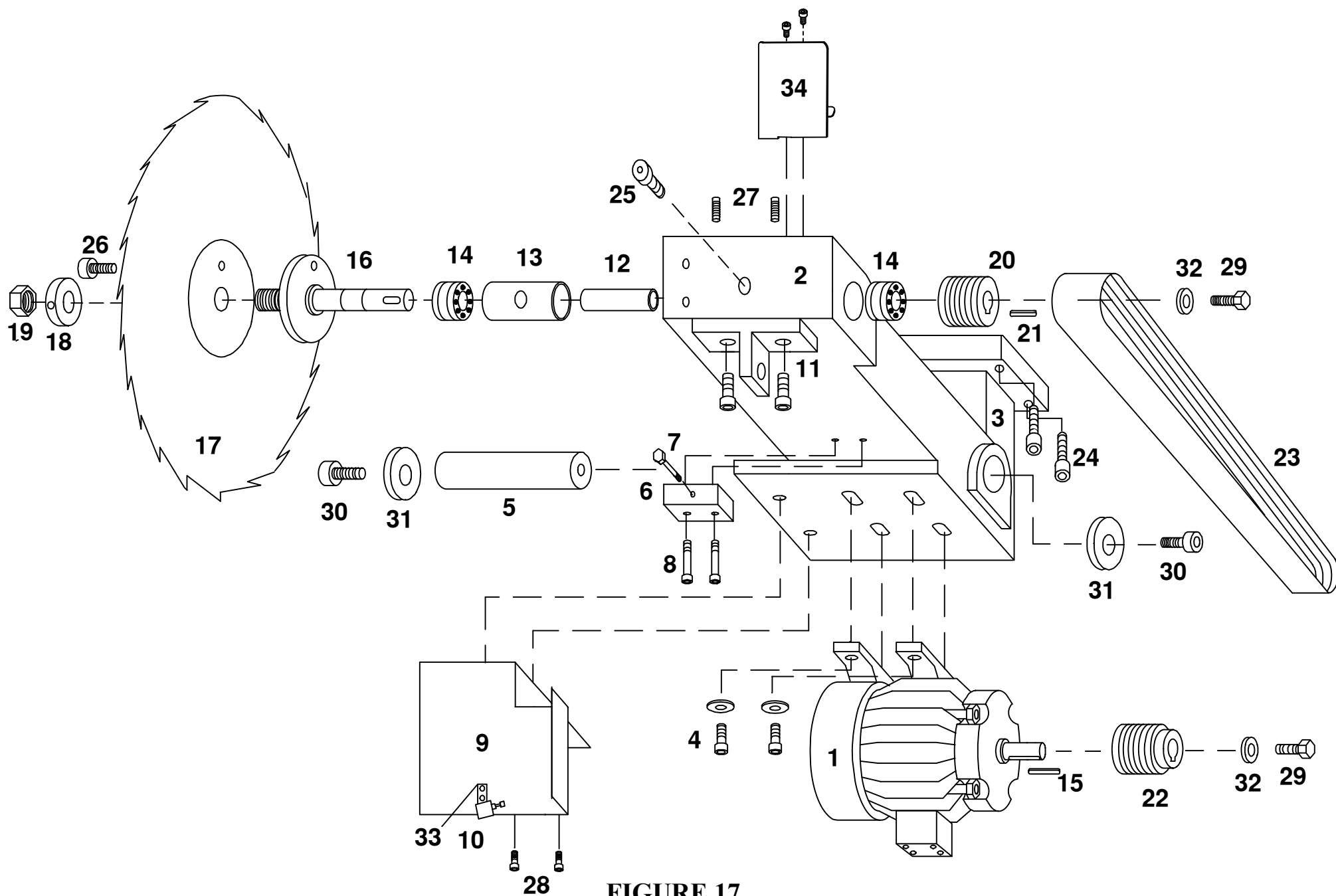


FIGURE 17

7.6B Rocker Assembly (Exploded View 2)

ITEM	PART #	DESCRIPTION
1	2050000112	Post
2	N000000026	ISO 50x225 Cylinder
3	N000000057	ISO 50/63 Cyl. Yoke
4	N000000059	ISO 50 Cyl. Female Pin Joint
5	2040001172	Cylinder Anchor
6	2040004162	Raise Stop
7	TD91208015	DIN912 M-8 x 15 Screw
8	B0000P1420	M-8 x 20 Lever
9	2040004162	Lever Support
10	2050000332	Cast Iron Rocker
11	N00RCC1410	Male Thread Elbow
12	N000CC1410	Simple Male Elbow
13	205000F022	Cast Iron Disk
14	2050000012	965 J12 V-Belt
15	2050000132	Shaft Pulley

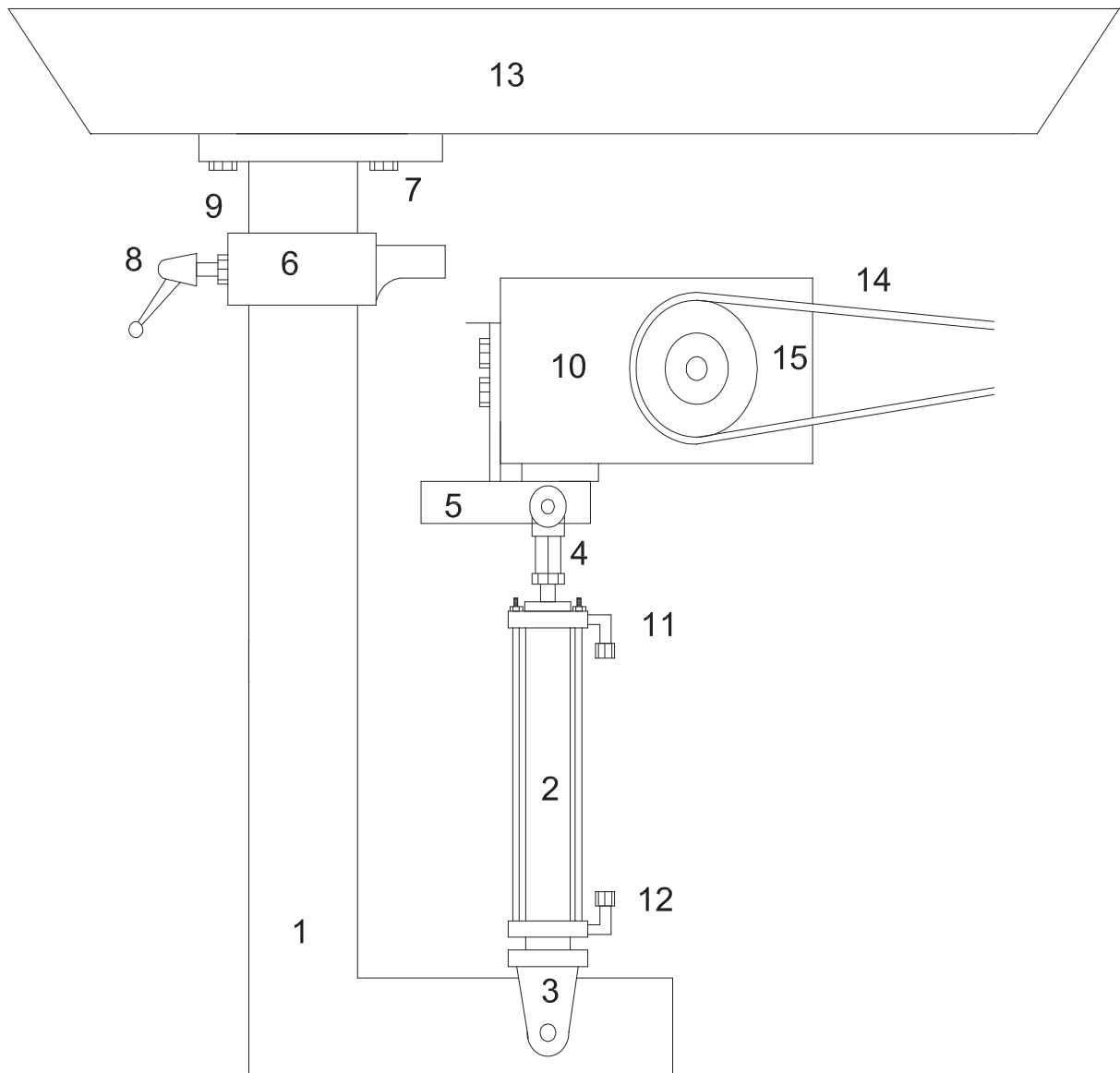


FIGURE 18

8.0 OPTIONAL EQUIPMENT

8.1 Pneumatic Protective Shield

ITEM	PART #	DESCRIPTION
1		DIN471 Ø12
2		ISO 40 Pin
3	TD93400006	DIN934 M-6 Nut
4	T173800620	ISO 7380 M-6 x 20 Screw
5	CN000904059	90° Swivel Flange ISO 40
6	TD91208025	DIN912 M-8 X 25 Screw
7	CN000004059	ISO 40 Swivel Flange
8		DIN471 Ø12
9	CN00040075	ISO 40 x 75 Cylinder
10		ISO 8675 M-10 Nut
11	TD93112035	DIN931 M-12 X 35 Screw
12	N000012125	M-12 ISO 40 Joint
13	TD12500012	DIN 125 Ø12 Washer
14		Joint Support
15	T17381016	ISO 7380 M-10 x 16 Screw

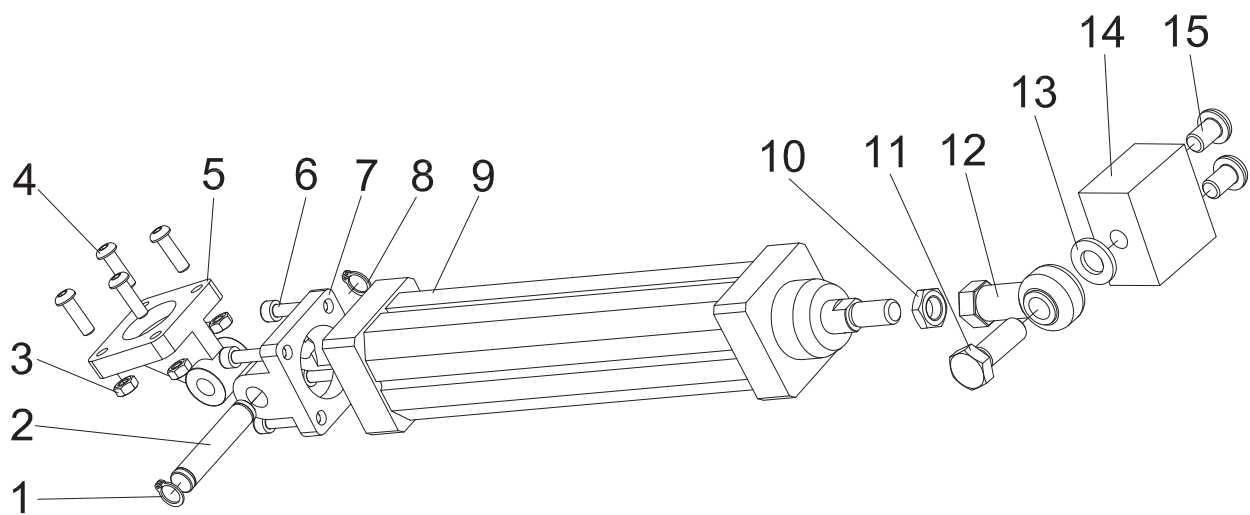


FIGURE 19

8.2 Digital Control of the Cut Height

In Order To Change The Cut Height:

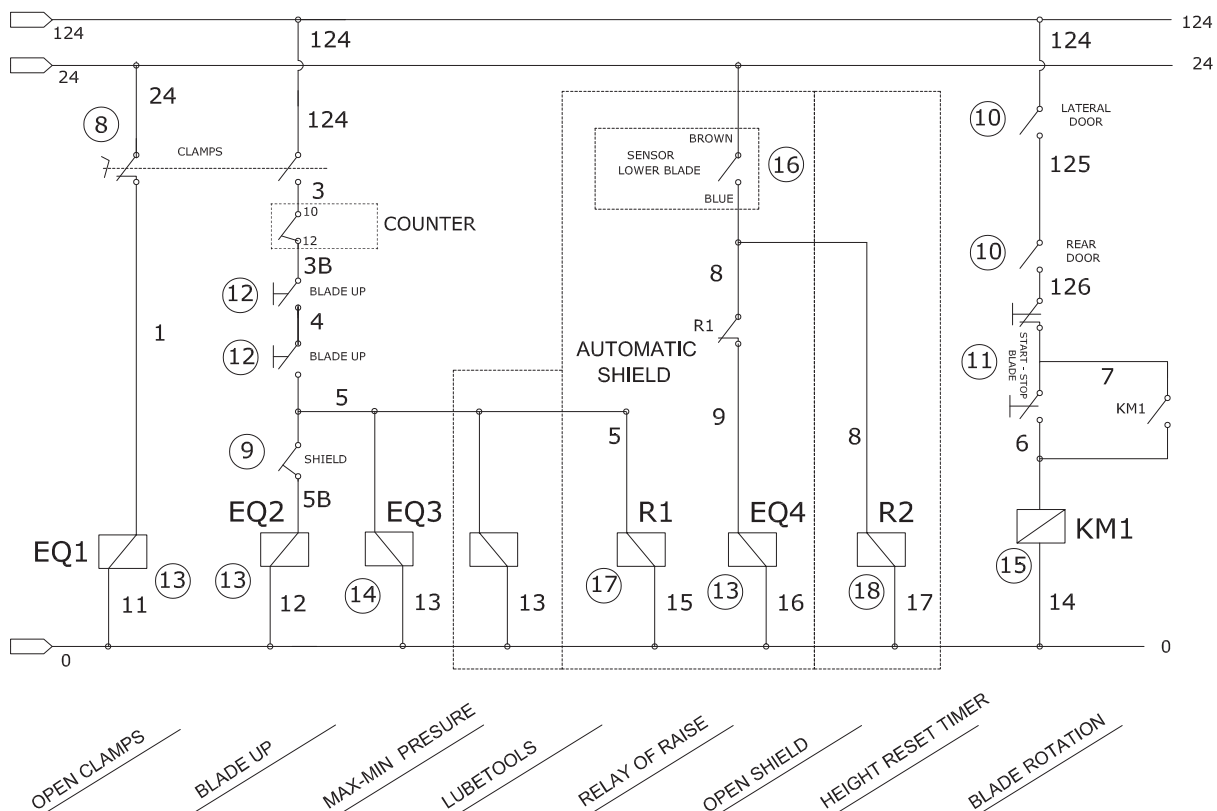
Press the PRESET to edit the height.

To Change The Value With The Key:

Press SET + PRESET + UP + RESET.

Press PRESET to finish the edition.

PARTS LIST		
ITEM	PART #	DESCRIPTION
18	E000000096	Timer 24V
19	028588	Power Supply
20	285	Digital Pulse Counter SUP & GAA-500
21	CE000100068	Encoder Hohner REF# 2845 (FOR #1269)



PULSE COUNTER CONNECTION

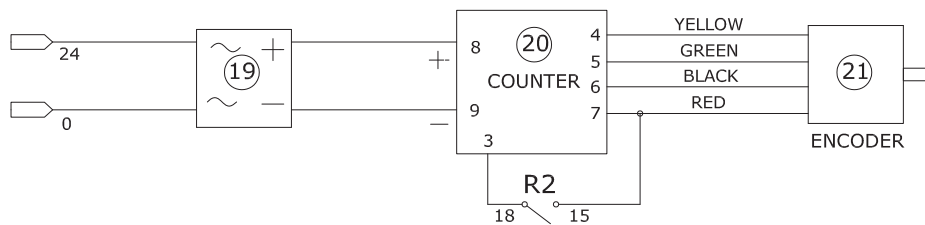


FIGURE 20

8.3 DIGITAL ANGLE DISPLAY (PART # 695)

SETTING AN ELGO DIGITAL READOUT TO READ 90 DEGREES:

Turn the saw head to 90 degrees.

Press and hold the "F" key until the screen reads "P 01".

Press the "F" key until the screen reads "P 09".

Press the "F" key one more time so the screen will read "00000.00".

Press the "Set" key three times so the tens number is flashing.

Press the "Incr/Abs" key until the screen reads "00090.00".

Press and hold the "F" key for 3 seconds until the screen reads an angle.

Press and hold both the "F" key and the "Set" key until the screen reads 90.00° .

- ☒ **NOTE:** This is a battery operated readout. When the battery goes dead, or is removed, the screen will go blank. Or, when the battery is replaced, the readout will default to its original setting. If it was programmed, like above to 90 degrees, you will simply need to set the saw at 90 degrees. Press the "F" key and the "Set" key and it will re-set to 90 degrees.

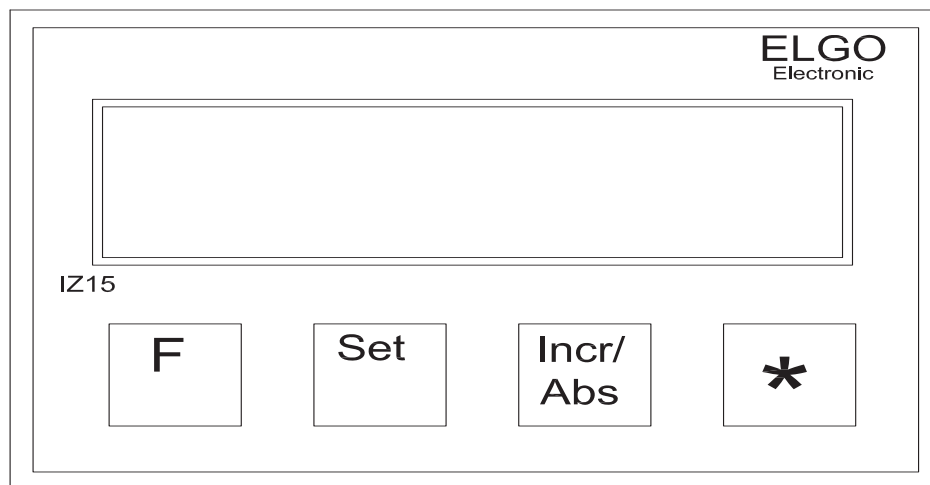
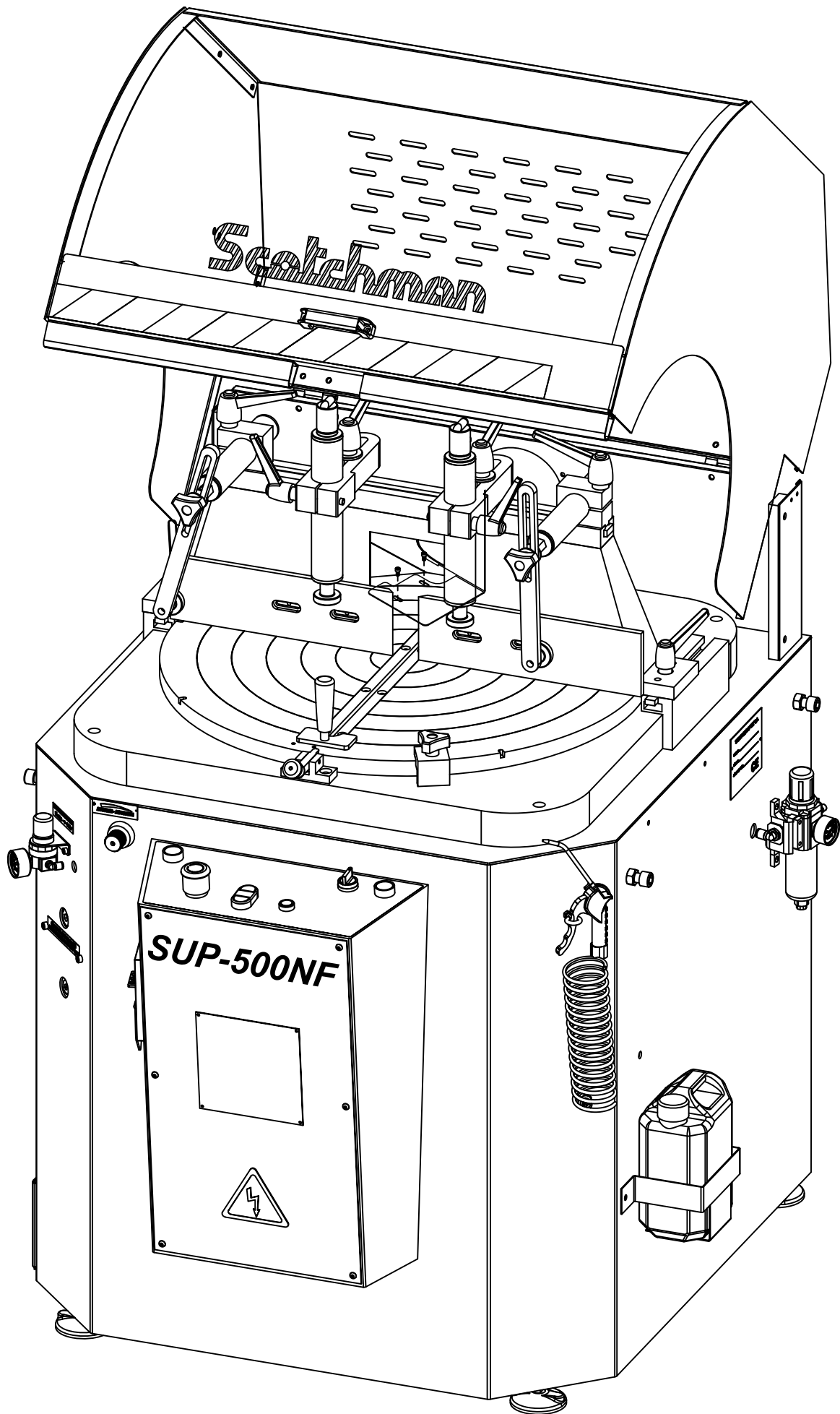


FIGURE 21



9.0 ANGLEMASTER W/CHIP COLLECTOR WIRE LOCATIONS

**These are instructions on how to wire the Chip Collector
(P/N 829230 - 230V 3PH or P/N 829460 - 460V 3PH)
to our SUP-500 or SUP-600 NF Upcut Anglemaster saws.**

**TO MAKE THE CHIP COLLECTOR START WITH THE ANGLEMASTER, READ THE BELOW
AND USE THE WIRE LOCATIONS DRAWING ON THE FOLLOWING PAGE.**

- 1. Attach the Auxiliary Contact (P/N 011981) to the top of the saw contactor.**
- 2. Attach the Brown Wire from the Chip Collector to the #33 NO on the Auxiliary Contact.**
- 3. Attach a Brown Jumper Wire from #34 NO on the Auxiliary Contact to the bottom of the terminal strip where the #124 wire is.**
- 4. Attach the Blue Wire to the top of the Ground Terminal on the right end. The Ground Terminal is yellow and green.**
- 5. It should now be able to run with the Remote Setting on the Chip Collector.**

ANGLEMASTER WITH CHIP COLLECTOR WIRE LOCATIONS

SUP-500 & SUP-600 SAWS

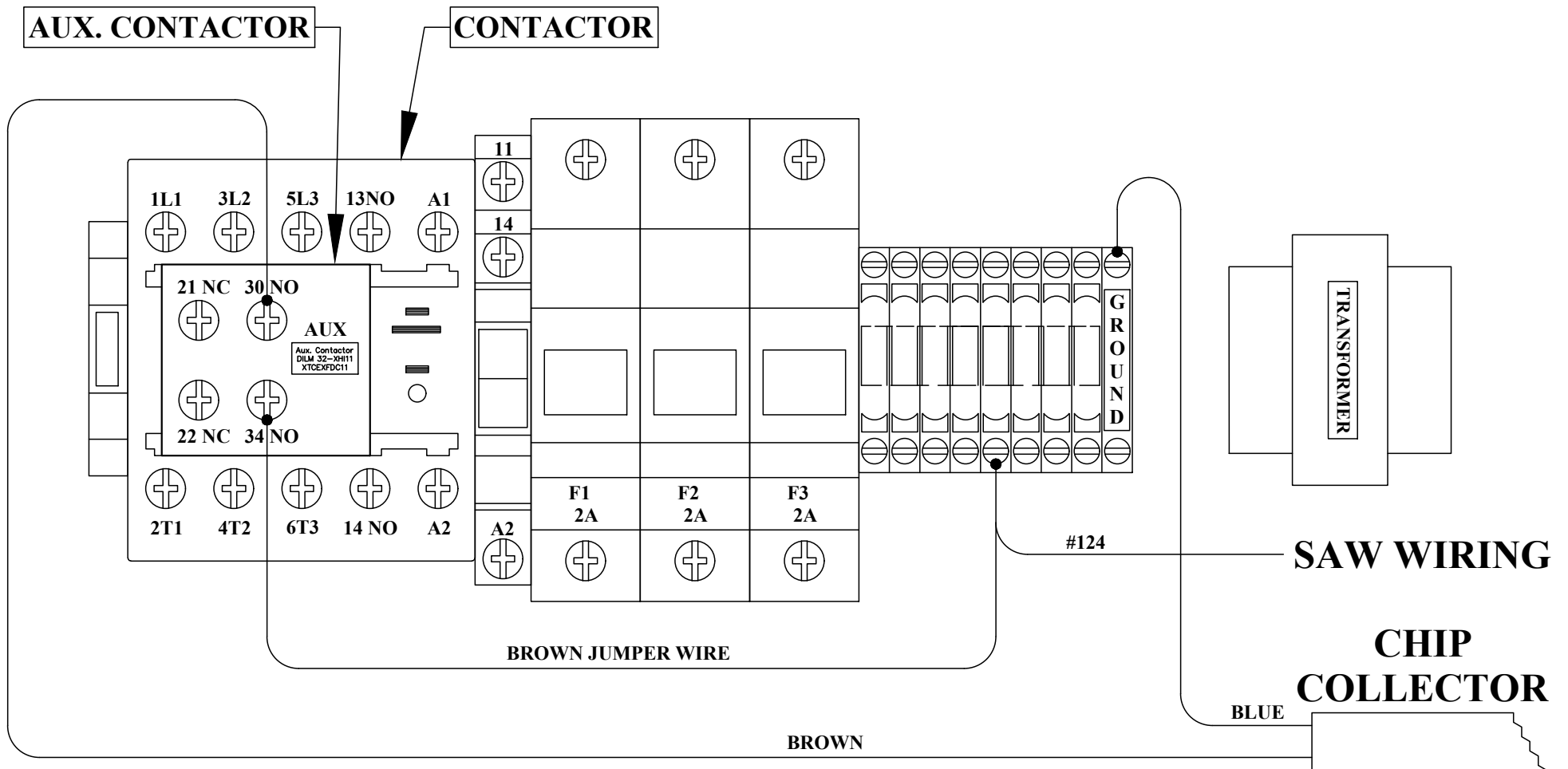


FIGURE 22