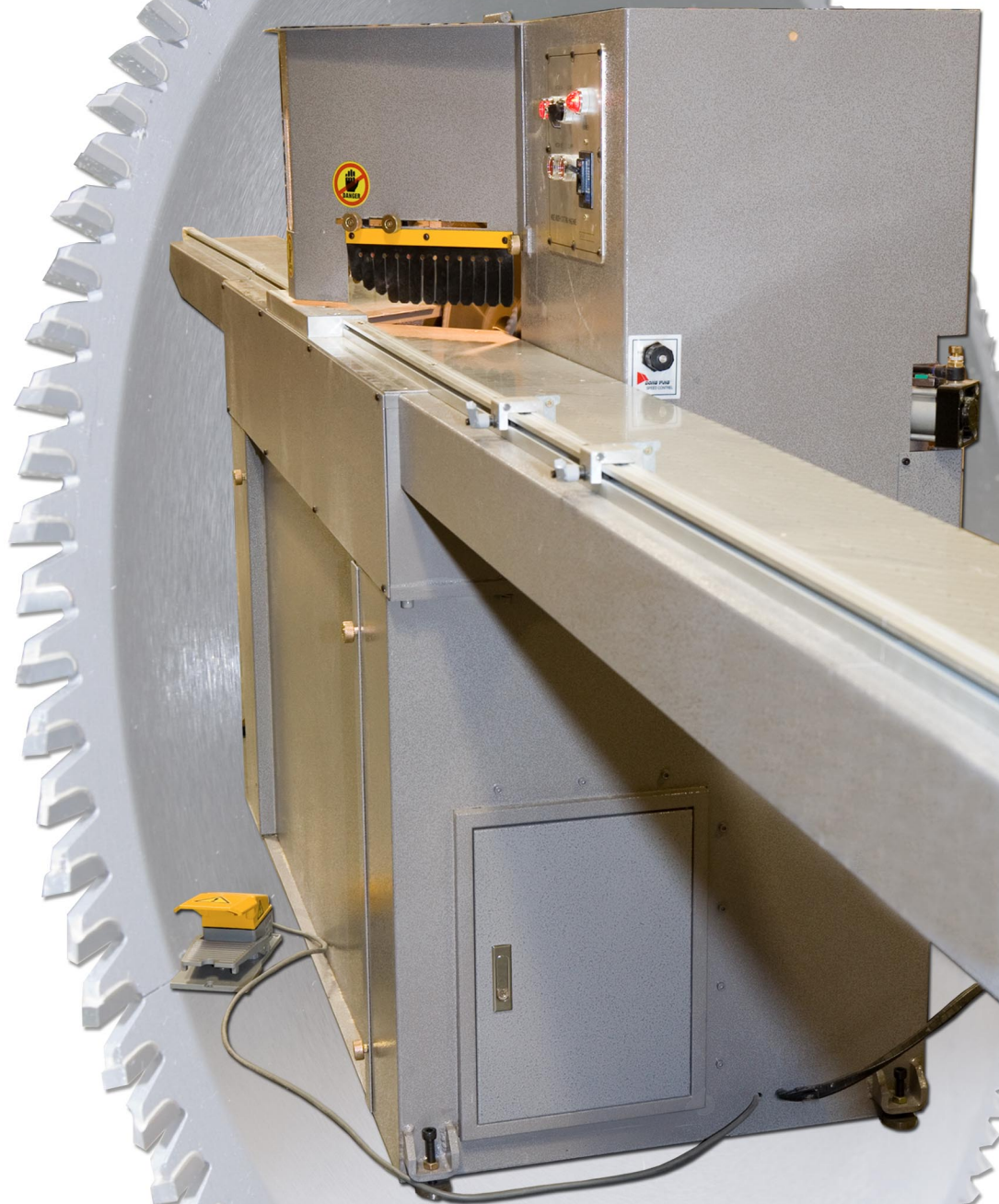


# Automatic Double Miter Saw

## Model# DY101



**lfp** UNIVERSAL  
machines

800 668 3627



## Control Panel

**Motor on** Press to turn blade motors on.

**Blower** Turn clockwise to turn dust collector on.

**Power** Light turns on when main power switch is turned on.

**Motor Off** Press to turn blade motors off.

**Clamp** Press to lower clamps to check clamp position before cut is made. Clamps will remain in the lowered position until button is released.

**Unnamed Switch** Master power switch and circuit breaker. When turned on, the "Power" light will be on and the saw will be ready for use. When the Master power switch is turned off, the motors will stop, the blades will immediately return to their full back position, and all circuits will be cold.

**Emergency Stop-Big Red Button** Pressing this button will immediately retreat the blades to their full back position without stopping the motors.



**Flow control Valve (Knob)** One on each side of the saw, controls the speed that the blades move from back to front (through the moulding). Turn the knob clockwise to decrease the speed and counter clockwise to increase the speed.

## Operation

**Clamps** Lay moulding on the table, set the clamps to the proper position. You may check the position of the clamps by pressing the "Clamp Button." If there is no moulding under the front clamp, the one closest to the fence, the blade(s) will not cycle. This will save you time by not having to wait for the blade to cycle when there is no cut to be made.

Clamps may be set from the outside of saw while the saw is running. Make sure the clamps are set to hold the moulding flat to the table without any rocking.

**Speed** Set the speed, how fast the blades move forward. For example you should cut poly styrene mouldings quickly and hard wood moulding slowly.

**Sight gauge and stops** Your new saw comes with two production stops, each stop can be moved out of the moulding path without changing a stop position. This allows cutting of the long and short sides of a frame without having to reset the stop positions.

To make an accurate cut, make sure the moulding is tight against the fence, align the inch marker on the sight gauge to the rabbit on the moulding, add your allowance and press the foot pedal. In the picture below, the frame side being cut will be just over 26 inches long at the rabbit.



## Setup

**Electric** The saw requires 220-volt (208-220 volt), single-phase 30 amp connection. The saw will run on 20-amps 30 amp is needed only if three motors (two blade drive and dust collector) are started simultaneously .

**Compressor** The saw requires a compressor with a storage tank and capable of maintaining at least 60 pounds of pressure. Oil less compressors make significantly more noise than compressors that require oil and the bigger the storage tank the less the compressors will turn on and off.

**Stable footing** The saw comes with 4 round metal disks with a shallow hole drilled on one side and 4 Allen head bolts and nuts. There are 4 brackets at the corners of the saw, which the bolts can be screwed into.

If the saw rocks on the floor, screw the bolts in one or more (as needed) of the corner brackets, put the metal disks under the bolt with the end of the bolt coming into the shallow hole (this will prevent damage to your floor) and tighten until the saw no longer rocks. Tighten the nuts into the brackets to lock the position.

**Attaching Tables** The saw comes with three tables. The one with two squared ends attaches to the right side of the saw. The tapered table with eight bolt holes and a bracket welded underneath to hold the support leg is the second right hand table. The remaining tapered table attaches to the left side of the saw.

Attach the right table to the saw using the three middle bolts, snug but do not tighten the bolts.

You may want to lay (do not glue at this time) the sight gauge ruler on the table to get the proper vertical alignment. Suggestion: use a rubber mallet or the soft end of a hammer handle to tap the table into position.

Place a straight edge from the sight gauge attached to the saw over the right side table then tighten the two bottom bolts (half turn at a time on each bolt) until the straight edge makes contact along its entire length on saw and right hand table. If all is correct, the moulding stop should move easily between the saw and right table.

Remove the paper covering the glue strips and carefully attach the correct sight gauge to the table. Make sure the square ends are touching and aligned correctly. When you confirm all is correct, apply pressure along the entire length of the sight gauge to set the glue.

Bring the fence up to the sight gauge and tighten.

The left table is attached following the same procedure except there is no sight gauge used on the left side. This should make the left table level with the saw and the depth of the sight gauge (approximately 1/8 inch) higher than the right side table.

Use a straight edge along the fence that is attached to the saw to align and then tighten the fence attached to the left table.

To attach the second right side table adjust the leg to approximately the correct height by placing it under the end of the first table and screwing the adjustment bolt out till the top of the leg touches the bottom of the table. This is easier if you can hold the adjustment bolt with your feet and turn the gray tube.

Attach the leg to the second right side table section and secure by tightening the two bolts.

Attach the two metal plates loosely to the inside of the first table then bolt the second table to the plates, make sure there is a smooth transition between the tables and snug the bolts.

Check that a straight edge is in contact along its entire length across both tables, a small adjustment may have to be made in the length of the leg to make up for uneven floors.

Using a straight edge from the fence on the first table align the fence on the second table then tighten.

Remove the paper covering the glue strips and carefully attach the correct sight gauge to the table against the fence. When you confirm all is correct apply pressure along the entire length of the sight gauge to set the glue.

**Changing Blades** To change the blades, use a 8mm Allen head wrench, turning counter clockwise to loosen the blades.

### What is included with the saw:

1 left and 2 right bolt on tables.

Two metal plates and 16 bolts to attach the second right side table.

1 package containing the 10-foot sight gauge in 2 sections.

External dust collector structure.

Two dust collector filter bags.

Dust collector hose.

### Troubleshooting

Saw is turned on but nothing happens when the pedal is pushed.

Check that the saw is connected to an air supply and the pressure gauge reads approximately 4 atmospheres of pressure.

Make sure both flow controls valves are open

Make sure that there is moulding on the table and at least one of the front (closest to the fence) clamps is in contact with the moulding