

Pneumatic Double Miter Saw

Model# DY103



lfp UNIVERSAL
machines

800 668 3627

Setup

Electric: The saw and external vacuum requires 220-volt (208-220 volt), single-phase 30-amp connection. The saw without the external vacuum will run on 20 amp.

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

Stable footing: The saw accessory package 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 two bolts in the middle row, 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.

The straight edge should make contact along its entire length along the saw and right hand table. If all is correct the moulding stop will 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. The left table should be level with the saw and the height of the fence will be approximately 1/8 inch higher than the fence on the saw.

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 until 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, not tighten 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.

What is included with the saw:

- 1 left and 2 right tables
- 2 metal plates and 16 bolts to attach the second right side table
- 1 package containing the 93-inch sight gauge in 2 sections
- External dust collector
- Dust collector hose
- 4 disks and 4 nuts and bolts to level saw

Operation

Clamps: Place moulding on the table, set the clamps to the proper position.

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 rocking.

Speed: To set the speed of how fast the blades come down, use the black knobs on either side of the saw, one for each blade. For example you should cut polystyrene mouldings quickly and hard wood moulding slowly.



Sight gauge and stops: Your new saw comes with two production stops, each stop can be pivoted up 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. Make the first cut on a new stick of moulding using the left pedal. Slide the moulding along the table and align the inch marker on the sight gauge to the rabbit on the moulding, add your allowance, set the stop and press the right foot pedal to make the cut. In the picture below, the frame side being cut will be just over 26 inches long at the rabbit.



Never press both pedals at the same time.

The sight gauge is 6.8 inches wide and 103 inches long allowing you to accurately cut wide mouldings and frame sizes up to 103 inches.

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 service door covering the blades is closed and secure.