

# *XC-18*



**NOTE:**

\*Machine shown without Lift-Up Safety Guard. This guard is included with machine. Machine should not be operated without this guard.

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## **GENERAL SAFETY RULES**

There is a certain amount of hazard involved with the use of woodworking machinery. Using the machine 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 ignored, severe personal injury to the operator can occur.

1. Read the operation manual before operating this machine.
2. If you are not thoroughly familiar with the machine operation, obtain advice from a supervisor or other qualified person.
3. The machine should be disconnected from the power source before performing maintenance or adjustments to the internal mechanisms, or when making repairs.
4. After maintenance job is finished, check to see if there are any tools or objects left on the machine. Close all safety guards.
5. Before leaving the machine, make sure the work area is clean.
6. Check timber for loose knots, nails, or other items, which may cause a hazard or affect the machine's performance.
7. Learn the machine's applications and limitations, as well as the specific potential hazards peculiar to it. Keep the machine in top condition for best and safest performance.
8. Keep all guards in place and in working order.
9. Do not force the machine. It will do the job better and be safer working at the rate for which it was designed.
10. All children and visitors should be kept a safe distance from the working area.
11. The operator should keep proper footing and balance at all times.
12. Do not operate the machine while under the influence of drugs, alcohol, or any other medication.
13. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the cutterhead.
14. Never leave the machine until it comes to a complete stop, and never leave the machine running unattended.
15. The employer is responsible for selecting competent and qualified employees.
16. The employer must make sure that employees study and utilize this safety information.
17. Supervisors must alert personnel of any unsafe practices they observe.
18. All employees should be aware of first aid facilities and be encouraged to use them, regardless of the severity of the injury.
19. Fire prevention must be practiced and fire protection must be available to prevent loss of life, personal injury, and property damage.
20. Safety shoes should be worn to provide protection against rolling objects, falling objects, and sharp edges in the workplace.
21. Eye protection should be worn and such devices should be carefully selected, fitted and used. Compulsory wearing of glasses with impact resistant lenses and side shields is a good safety policy. All eye protection should conform to ANSI 87 standards.
22. Wear hearing protection when operating the machine.
23. Do not wear rings, necklaces or jewelry around moving machinery.
24. Do not wear loose fitting clothes. Clothing should be comfortable, but long sleeves, neckties, etc. should not be worn.
25. Do not wear gloves or other hand covering articles around moving machinery.
26. Cover long hair with a hair net or cap.

27. Protective guards and shields must be in place at all times unless they must be removed for specific service or maintenance. They should be immediately replaced when service or maintenance is completed.
28. Make sure that operator clearly knows how to stop the machine before starting work.
29. Never clean or remove chips while the machine is running.
30. Maintain the machine in good operating condition. Report unusual conditions or machine malfunctions immediately.
31. Do not alter or remove guards and warning labels.
32. Keep the immediate area clean. Do not allow the floor to become slippery, or covered with dust or obstacles. Dust that accumulates in the work area is a hazard that can cause you to fall or slip against the machine or its controls.
33. Employees should be required to report to their supervisors any hazardous condition of the machine or in the immediate area.

### **SHIPPING & RECEIVING INSTRUCTIONS**

This machine has been carefully inspected and tested before packing. It was delivered in good condition and was shipped in one wooden pallet.

When receiving this machine, inspect the wooden pallet and check to see if there is any damage. Then check the machine model and all items as according to the packing list.

If there is any damage on the machine or any missing parts, report it to your local distributor or the machine manufacturer immediately.

### **UNPACKING & CHECKING CONTENTS**

The machine has been well packed at the manufacturer's factory and shipped in good condition. The machine is shipped in one wooden pallet.

Upon receiving the machine, carefully unpack it and check all items as according to the packing list.

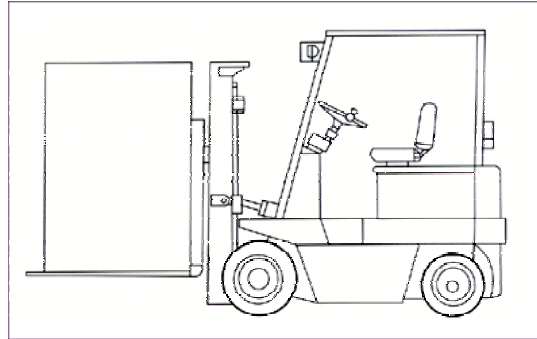
If you find any part is missed or damaged, contact your local distributor or the manufacturer of the machine immediately. Do not attempt to operate the machine until the missing parts are obtained and are installed correctly.

### **CLEANING THE MACHINE**

The machine is coated with rust preventative oil before shipment. When the machine has been moved to the proper work site, wipe the oil from the machine using a soft cloth soaked in kerosene. Do not use gasoline, lacquer thinner, or any other volatile solvent, as these may damage the paint surface of the machine.

## **LIFTING THE MACHINE**

The machine should be lifted or moved by a forklift. Make sure the loading capacity of the forklift is sufficient to raise the machine. Pay special attention to the machine balance while lifting the machine to prevent the machine from falling. The forks of the forklift must protrude over the machine bottom for uniform distribution of the entire machine weight.



## **ELECTRICAL SAFETY RULES**

1. Do not alter or bypass any protective interlock.
2. Before starting the machine, read and observe all warning labels and markings such as nameplates and identification plates.
3. Only personnel who are properly trained and have adequate knowledge and skill should undertake all electrical/electronic troubleshooting and repair.
4. Use extra precautions in damp areas to prevent yourself from accidental grounding.
5. Make sure your body and your tools are clear of electrical grounding.
6. The control panel doors should be opened only when it is necessary to check the electrical equipment or electrical wiring.
7. Before applying power to any equipment, establish without a doubt that all persons are clear.
8. Be alert and be sure you can work with no outside distractions.
9. Avoid wearing metal frame glasses or wearing a metallic necklace or chain, and never work on electrical equipment while wearing rings, watches, or bracelets.
10. When replacing conductors, make sure they conform to the manufacturer's specifications, including proper color-coding.
11. Do not alter the electrical circuits. If machine damage is caused by an unauthorized alteration, the user is responsible, not the manufacturer.
12. Always assume the electrical power is ON and treat circuit as live. This caution develops a habit that may prevent an accident.
13. Give capacitors time to discharge. Otherwise, it should be done manually with care.
14. Use proper test equipment to make certain you have an open circuit. Test equipment must be checked and calibrated at regular intervals.
15. Open the control panel doors only when it is necessary to check the electrical equipment or wiring. After closing the door, make sure the disconnecting means are operating with the disconnecting handle mechanism in its proper position.
16. All covers on junction boxes must be closed before leaving any job.

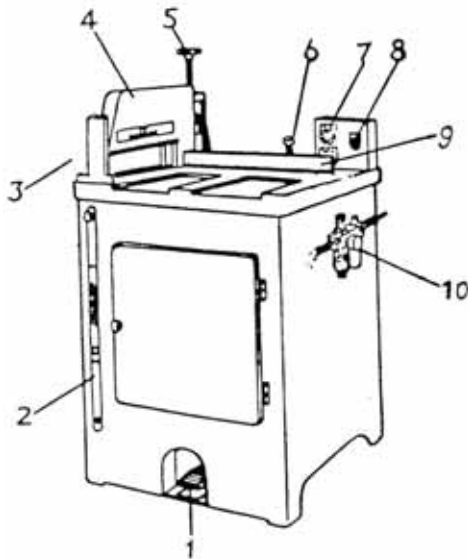
## **OPERATION PROCEDURES**

1. The dust collection outlet is set on the lower left side of the machine. Connect the machine to the dust collection system and the air compressor before beginning any operations.
2. Connect the machine to the power source and check the rotation of the spindle. It must be similar to the direction of the label (counter-clockwise).
3. Increase the air pressure at the regulator.
4. Push the power switch.
5. Step on the foot pedal to begin operating the machine.

## **MAINTENANCE**

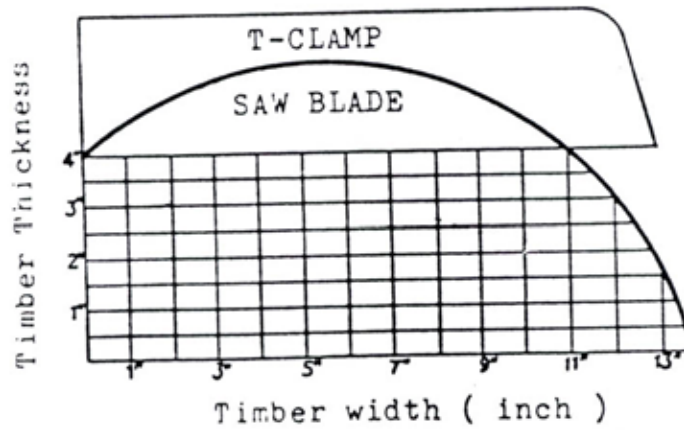
1. Lubricate the saw spindle weekly.
2. Periodically fill oil feeder, and clean the filter.
3. Clean the machine at the end of every operation.
4. Keep saw blade sharp at all times.

## **LEGEND OF THE MACHINE**



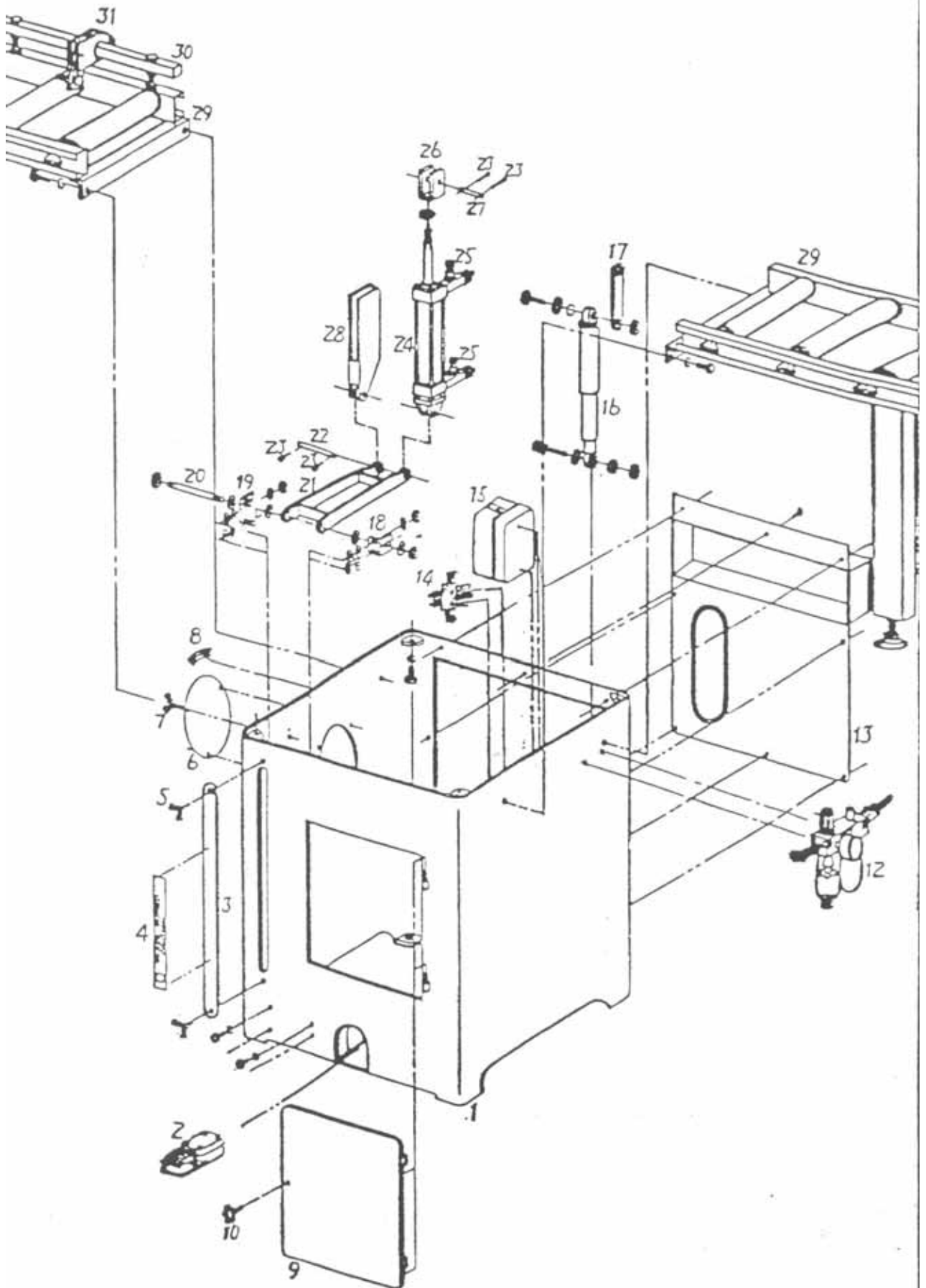
1. Foot Pedal
2. Inlet & outlet opening of was blade
3. Safety Guard
4. T-Clamp of Timber
5. Higher & Lower Adjustment Knob of T-Clamp
6. Adjustable Handle of Guide Plate
7. ON-OFF Switch of Saw Spindle
8. Change-over Switch of Air Gate
9. Guide Plate
10. Air Inlet

**CAPACITY TABLE**

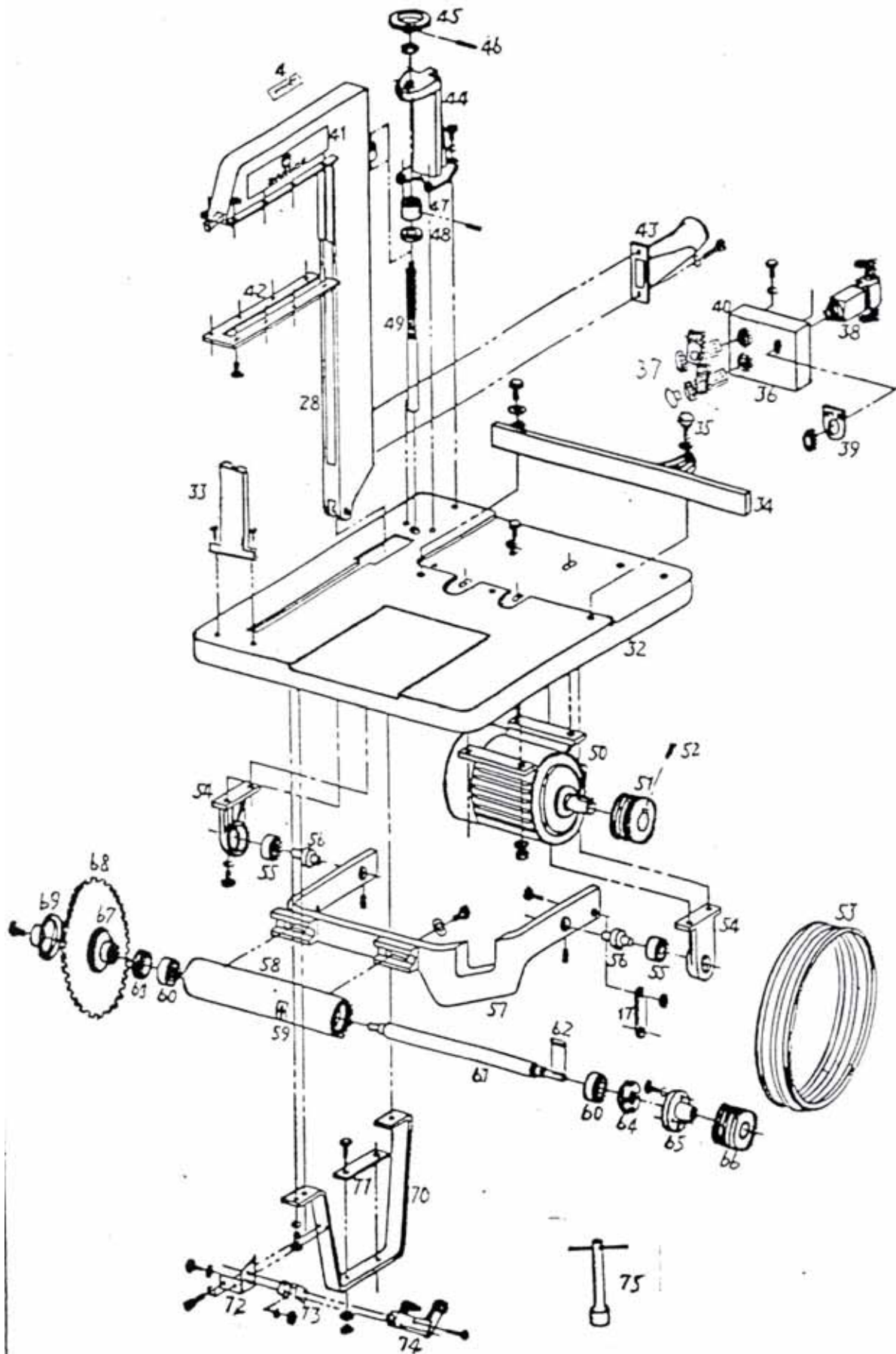


**SPECIFICATIONS**

Revolution of Saw Spindle	3320/3180 RPM (60/50HZ)
Saw Blade	1" x 18" x 3/4mm x 120T
Driving Motor	10HP
Table Dimension	26-5/16" x 27-13/16"
Level Height of Table	33-1/16"
Air Required	4 kg/cm <sup>2</sup>
Packing Measurement (wooden crate)	37" x 31-7/64" x 47-5/8"
Net Weight	792 lbs.
Gross Weight	925lbs.







## **PARTS LIST**

<b>No</b>	<b>Part Name &amp; Specification</b>	<b>Qty</b>	<b>Part No</b>
01	Body	1	4117
02	Pedal Switch	1	1046
03	Inlet & Outlet Opening Strip of Saw Blade	1	4118
04	Label of Blade Guard Caution	2	4119
05	Lobe Knob with 5/16" Threaded Stud	1	4120
06	Plate of Auxiliary Hole of Saw Blade Replacement	1	4121
07	Wing Nut	3	4122
08	Label of Rotation Direction of Saw Spindle	1	4123
09	Front Door Plate	1	4124
10	Lob Knob With 3/8" Threaded Stud	1	4125
11	Cable	1	4126
12	Air Filter – Pressure Regulator – Oil Feeder	1	4127
13	Rear Cover Plate	1	4128
14	Solenoid Valve	1	4129
15	Magnetic Switch Box	1	4130
16	Cushion	1	1047
17	Connecting Link	1	1048
18	Supporting Angle Iron of Right End	1	4132
19	Supporting Angle Iron of Left End	1	4133
20	Stud Bolt	1	4134
21	Supporting Frame	1	4135
22	Pin Coupling (1/2" x 5")	1	4136
23	Splite Pin	4	4137
24	Air Cylinder	1	4138
25	Pressure Regulating Valve	2	4139
26	Toggle	1	4140
27	Pin Coupling (3/8" x 2")	1	4141
28	T-Clamp	1	4142
29	Roller Conveyors *	2	4143
30	Strut of Equal Distance Gauge *	1	4144
31	Equal Distance Gauge *	1	4145
32	Table	1	4146
33	Safety Guard	1	4147
34	Guide Plate	1	4148
35	½" Adjustable Handle	1	4149
36	Switch Base	1	4150
37	Driving Switch of Saw Spindle	1	1048
38	Switch of Air Inlet	1	1049
39	ON-OFF Index of Switch of Air Inlet	1	4151
40	Label of Power	1	4152
41	Label of Danger	2	4153
42	T-Clamp Gasket	1	1050
43	Dust Exhaust Tube	1	4154
44	Supporting stand of T-Clamp Higher-Lower Adjustment	1	4155

No	Part Name & Specification	Qty	Part No
45	2-1/2" Lobe Knob	1	4156
46	Spring Pin	1	4157
47	Locating Ring of Guide Screw	1	4158
48	Damper of T-Clamp	1	4159
49	Guide Screw	1	4160
50	Driving motor	1	4161
51	Motor Pulley	1	4162
52	Pulley Washer	1	4163
53	#M-31 V-Belt	3	4164
54	Brackets of Suspension Beam	2	4165
55	Ball Bearing 6204ZZ	2	1051
56	Stub Arbor of Suspension Beam	2	4166
57	Suspension Beam of Saw Spindle	57	4167
58	Outer Tube of Saw Spindle	1	4168
59	Label of Rotation Direction of Saw Spindle	1	4169
60	Ball Bearing 6206ZZ	2	1052
61	Saw Spindle	1	4170
62	Square Key	1	4171
63	Locking Nut (Left Thread)	1	4172
64	Locking Nut (Right Thread)	1	4173
65	Taper Seat of Locating of saw Spindle Pulley	1	4174
66	Pulley of Saw Spindle	1	4175
67	Inside Flange of Saw Blade	1	4176
68	Circular saw Blade (1" x 18" x 3.4mm x 120T) *	1	4177
69	Outside Flange of Saw Blade	1	4178
70	Lower Limit Locating Bracket of Saw Spindle	1	4179
71	Damper of Saw Spindle Lower Limit	1	4180
72	Bracket of Limit Switch	1	4181
73	Adjustable Seat of Limit Switch	1	4182
74	Limit Switch of Upper Limit Locating	1	4183
75	19mm Socket Wrench	1	4184

\* parts for optional accessories