

# **POWERMATIC®**

## **Instructions and Parts Manual 10-inch Cabinet Saw Model PM2000**



Model PM2000 Table Saw shown with optional extension table and legs

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# Warranty and Service

Powermatic warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

## Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official Powermatic branded website.

- Powermatic products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

## Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

## What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

## Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

## How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. Powermatic has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the Powermatic website.

## More Information

Powermatic is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the Powermatic website.

## How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

## Limitations on This Warranty

POWERMATIC LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

POWERMATIC SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Powermatic sells through distributors only. The specifications listed in Powermatic printed materials and on the official Powermatic website are given as general information and are not binding. Powermatic reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

## Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery

NOTE: Powermatic is a division of JPW Industries, Inc. References in this document to Powermatic also apply to JPW Industries, Inc., or any of its successors in interest to the Powermatic brand.

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The specifications in this manual are given as general information and are not binding. Powermatic reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

# Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This table saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a table saw, do not use until proper training and knowledge have been obtained.
5. Do not use this table saw for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this table saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this table saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
  - Lead from lead based paint.
  - Crystalline silica from bricks, cement and other masonry products.
  - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the machine is properly grounded.
12. Make all machine adjustments or maintenance with the machine unplugged from the power source. A machine under repair should be RED TAGGED to show it must not be used until maintenance is complete.
13. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
14. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
15. Check the alignment of the riving knife, fence and miter slot to the blade. A caution decal is installed on each guard to remind the operator of the dangers of improper machine operation.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine 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.

# Warnings

17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. Keep children away.
20. Make your workshop child proof with padlocks, master switches or by removing safety keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep blade sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Check the saw blade 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 is securely locked on the arbor.
27. 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 freehand. Avoid awkward operations and hand positions where a sudden slip could cause your hand to contact the blade.
28. Do not attempt to saw boards with loose knots or with nails or other foreign material, on its surface. Do not attempt to saw twisted, warped, bowed or “in wind” stock unless one edge has been jointed for guiding purposes prior to sawing.
29. Do not attempt to saw long or wide boards unsupported where spring or weight could cause the board to shift position.
30. Always use the riving knife, blade guard, push stick and other safety devices for all operations where they can be used. On operations such as dadoing or molding where the blade guard cannot be used, use feather boards, fixtures and other safety devices and use extreme caution. Reinstall the riving knife and blade guard immediately after completing the operation that required their removal.
31. Be sure the saw blade rotates clockwise when viewed from the motor side (left side) of the machine.
32. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
33. Do not stand on the machine. Serious injury could occur if the machine tips over.
34. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
35. Remove loose items and unnecessary work pieces from the area before starting the machine.

## **Familiarize yourself with the following safety notices used in this manual:**

**CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

**WARNING** This means that if precautions are not heeded, it may result in serious injury or possibly even death.

# Introduction

This manual is provided by Powermatic covering the safe operation and maintenance procedures for a Powermatic Model PM2000 Table Saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or Powermatic. Powermatic can also be reached at our web site: [www.powermatic.com](http://www.powermatic.com).

# Specifications

Model number .....	PM2000
Stock Number	
3HP, 230V, 60Hz, 1 Phase, 3600 RPM, 13A, TEFC.....	1791999
5HP, 230V, 60Hz, 1 Phase, 3600 RPM, 21A, TEFC.....	1791998
5HP, Prewired 230V (for 460V see <b>Note</b> below), 60Hz, 3 Phase, 3600 RPM, 12/6A, TEFC.....	1791997
Table size with standard extensions (L x W/in.).....	42 x 30 1/2
Table size without extensions (L x W/in.) .....	22 x 30 1/2
Arbor diameter (in.).....	5/8
Saw blade diameter (in.).....	10
Arbor speed (RPM).....	4300
Left tilt range .....	0–45
Maximum depth of cut (in.) .....	3-1/8 at 90-degrees; 2-1/8 at 45-degrees
Maximum diameter of dado (in.).....	8
Maximum width of dado cut (in.) .....	13/16
Drive system .....	Poly-V Belt
Table height to floor (in.).....	34-1/2
Dust port diameter (in.) .....	4
Caster elevation (in.).....	1/8
Shipping weight (saw only) .....	All Models: Net: 540 lbs, Gross: 604 lbs

**Note:** For 460V operation, magnetic switch (Part No. PM2000-293E) must be purchased separately and installed. A qualified electrician is recommended.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Powermatic reserves the right to change specifications at any time and without prior notice, without incurring obligations.

**⚠WARNING** Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury

# Shipping Contents

## Unpacking

Remove box and wood crating completely from around saw. Check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Table Saw is assembled and running properly.

Compare the contents of your container with the parts lists in the next two pages to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

1. Unbolt the saw from the skid.
2. Carefully slide the saw from the pallet onto the floor.

**CAUTION** Make sure that the castors do not get damaged when removing from the skid.

The Table Saw should be placed in an area with a sturdy level floor, good ventilation and sufficient lighting. Leave enough space around the machine for mounting extension wings and rail assemblies, and loading and off-loading stock and general maintenance work.

## Cleaning

Exposed metal surfaces, such as the table top and extension wings, have been given a protective coating at the factory. This should be removed with a soft cloth moistened with kerosene. Do not use acetone, gasoline, or lacquer thinner for this purpose. Do not use solvents on plastic parts, and do not use an abrasive pad because it may scratch the surfaces.

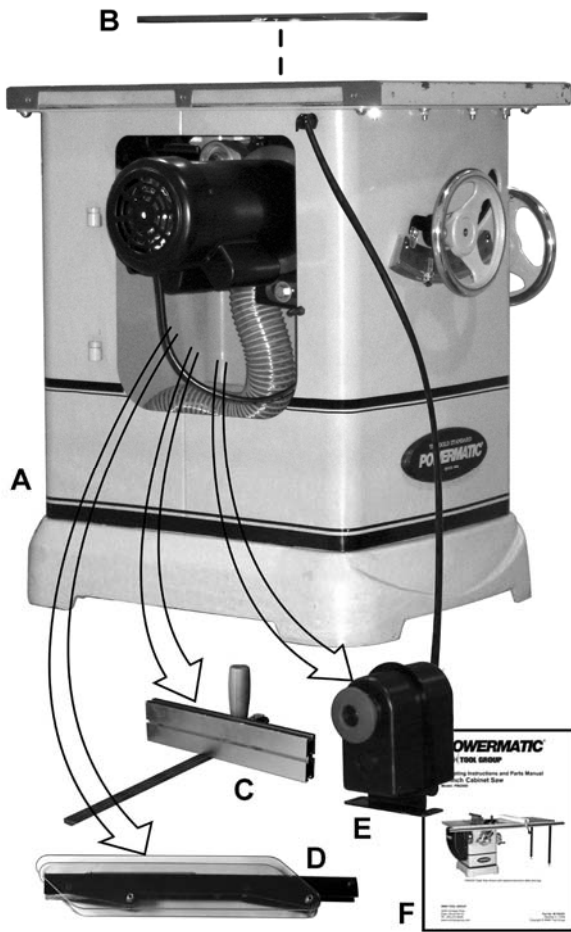
## Contents of the Shipping Container

### Main Saw Container

- 1 Table Saw (A)
- 1 Table Insert (B)

The following items are inside the saw:

- 1 Miter Gauge Assembly (C)
- 1 Blade Guard Assembly (D)
- 1 Switch in box (E)
- 1 Owner's Manual (F)
- 1 Warranty Card (not shown)

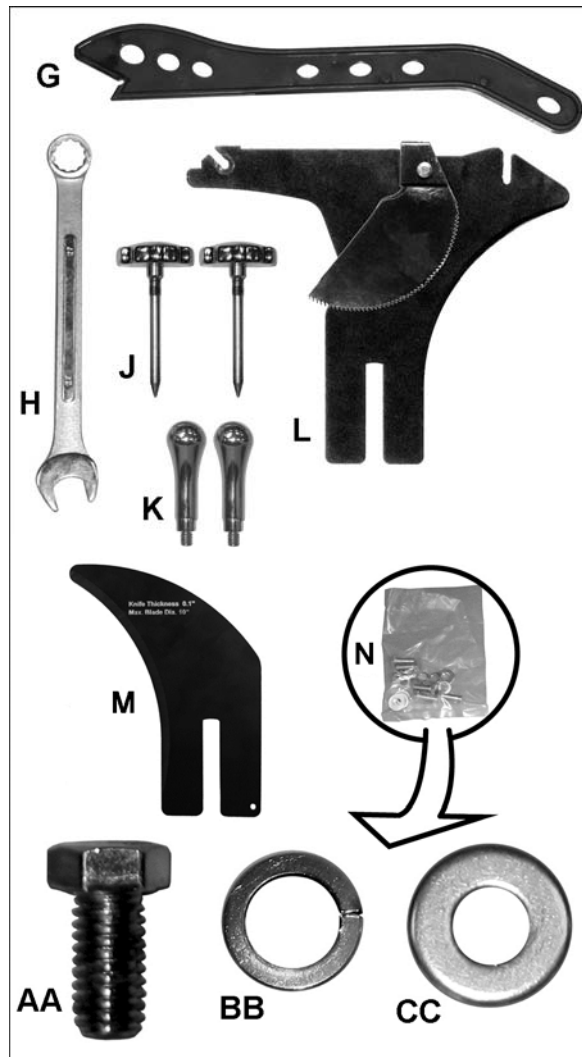


Main Saw Container

### Small Box

The small box consists of the following items:

- 1 Push Stick (G)
- 1 27mm Arbor Wrench (H)
- 2 Lock Knobs (J)
- 2 Swivel Handles (K)
- 1 Riving Knife and Pawl Assembly (L)
- 1 Low Profile Riving Knife (M)
- 1 Hardware Bag (N) consisting of:
  - 6 3/8-16 x 1 Hex Cap Screw (AA)
  - 6 3/8 Lock Washer (BB)
  - 6 3/8 Flat Washer (CC)

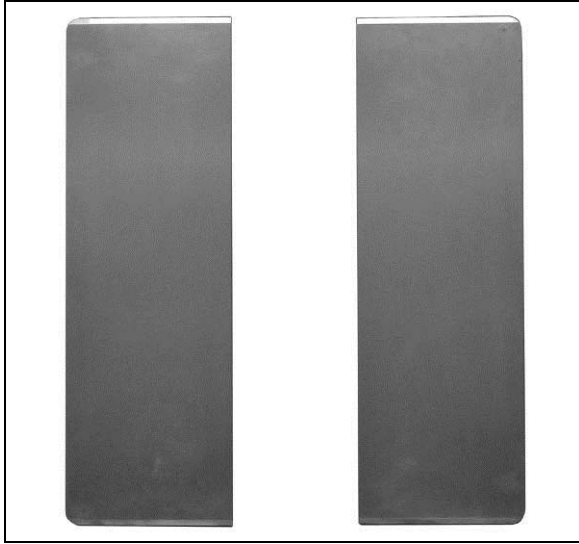


Contents of the Small Box



*Extension Tables*

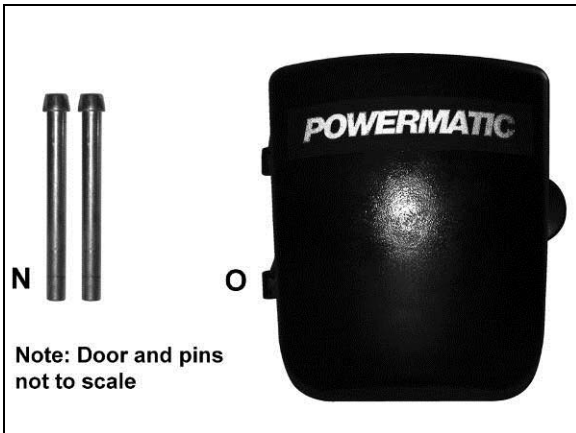
Two extension tables are packaged in individual boxes.



*Extension Tables*

*Side Cover Box*

- 2 Hinge Pin (N)
- 1 Side Cover (O)



*Contents of Side Cover Box*

*Fence and Rail*

Carton contents and installation instructions for the fence, rail system, and optional wooden extension table are described in the *Accu-Fence Owner's Manual* (No. M-2195079Z).

# Assembly

## Mounting Extension Wings

Referring to Figure 1:

1. Mount a *cast iron extension wing* (A) to the right or left side of the *table* (B) using three each  $3/8$ -16x1 *hex head screws* (C),  $3/8$  *lock washers* (D) and  $3/8$  *flat washers* (E). Have an assistant hold the extension wing up to the table while inserting the screws and washers. Finger-tighten only.

**Note:** If an assistant is not available, hold the wing in vertical position up to the saw table, insert the middle screw and lock washer finger tight, then pivot the wing to level position. Insert the other two screws and washers finger tight.

2. Mount the remaining extension wing to the other side of the table in the same manner.
3. Make sure that the *front edge* of the extension wings are flush with the front edge of saw table (Figure 2).

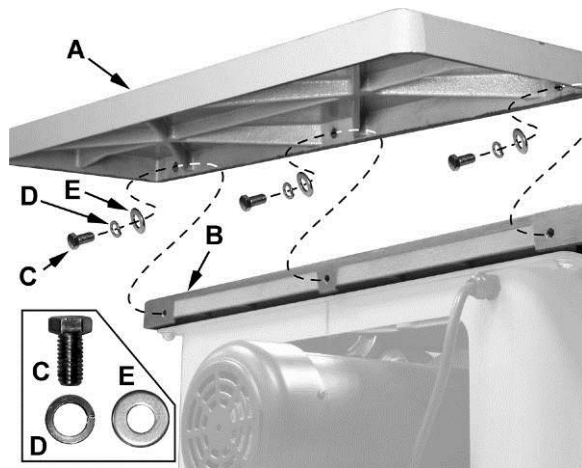


Figure 1

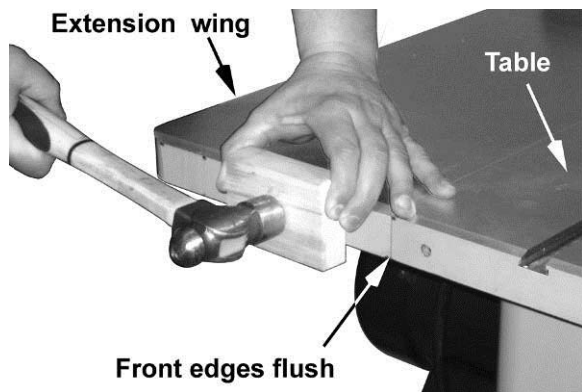


Figure 2

4. Level the extension wing with the saw table across its entire width (Figure 3) using a straight edge and hammer with block of wood (or rubber hammer).

As each area of the wing becomes flush with the table, tighten the screw under that area. Continue until all three screws are fully tightened.

5. Repeat for the other extension wing.

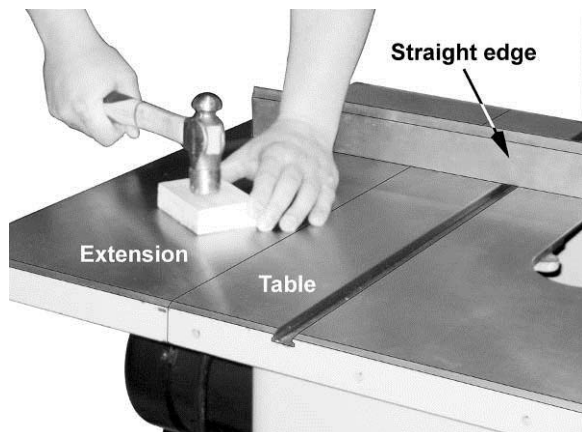


Figure 3

## Lock Knobs and Swivel Handles

Referring to Figure 4:

1. Thread the *swivel handles* (A) into the front and side *handwheels* (C) and tighten with a 14mm wrench.
2. Screw *lock knobs* (B) into the threaded openings on the end of the shafts located in the middle of the *handwheels* (C).

**Note:** Do not tighten the lock knobs all the way at this time.

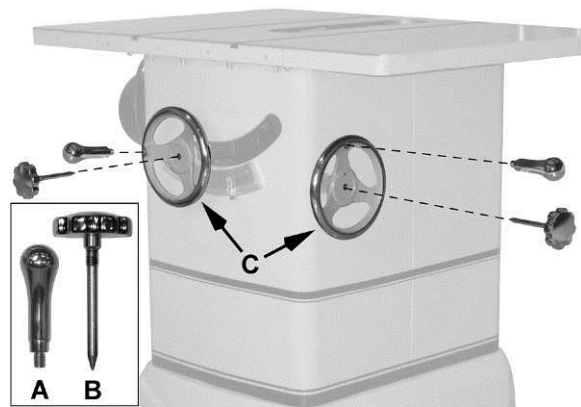


Figure 4

## Dust Chute

Referring to Figure 5:

The Model 2000 comes equipped with a *dust chute and hose assembly* (Inset 2) for use with a *dust collection system*. If you do not intend to use a dust collection system, the dust chute may be disconnected and removed as described below.

To provide sufficient clearance for removal of the dust chute:

1. Raise the *blade height* all the way up and set the *blade tilt* to 0° (refer to *Handwheel Adjustments* on page 14).
2. Remove the *arbor nut* and *collar* as described in the *Blade Installation/Replacement* on page 12, steps 3-4.

*Removing the dust chute:*

3. Remove two *socket head button screws* (D, E) with 4mm and 5mm hex wrenches respectively.
4. Through the opening on the left side of the cabinet, remove the *hose* (Inset 1, 2) by twisting and pulling back on the *dust port* (F).

Take the entire assembly (Inset 2) out through the side opening.

Do not replace the arbor nut and collar at this time, but proceed to the *Blade Installation/Replacement* section (following page).

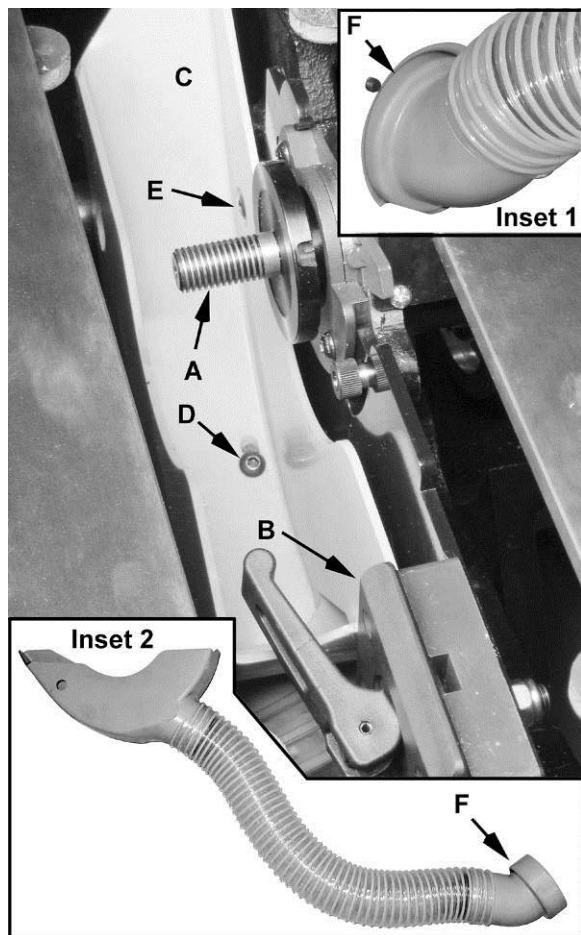


Figure 5

## Blade Installation/Replacement

**CAUTION** Use care when working with or around sharp saw blade to prevent injury!

To install or replace a blade (refer to Figure 6):

1. Disconnect machine from power source.
2. Raise the *blade height* all the way up and set the *blade tilt* to 0° (refer to *Handwheel Adjustments* on page 14).
3. Press the *arbor lock* (D) in the direction shown by the arrow to engage it into the slot in the *arbor* (C). At the same time remove the arbor nut (loosen with a 27mm wrench if necessary).
4. Remove the *collar* (B).
5. Install the blade, making sure the cutting teeth at the top of the blade point toward the front of the saw. If unsure, refer to Figure 10 for the proper blade orientation.
6. Replace the collar (B) and arbor nut (A).
7. Engage the arbor lock (D) and tighten the nut (A) with a 27mm wrench.
8. Lower the blade below the table.

## Mounting Rails and Accu-Fence®

With the extension wings properly aligned, the rail, guide tube and fence assembly can now be mounted to the saw. Consult the *Accu-Fence® Owner's Manual* (Part No. M-2195079Z) for instructions.

## Optional Wood Extension Table

For instructions on mounting the accessory wood extension table, or router table, consult the *Accu-Fence® Owner's Manual* (Part No. M-2195079Z) for instructions.

## Switch Installation

Referring to Figure 7:

1. Place the *switch assembly* (A) under the *rail* (B) and *guide tube* (C) so that the two holes in the *switch bracket* (D) line up with the left two holes in the rail and guide tube.

**Note:** The screws and lock washers may already have been installed when the rail and guide tube were installed and need to be removed for this operation.

2. Secure with two 1/4 *lock washers* (E) and 1/4 x 3/4 *hex cap screws* (F).

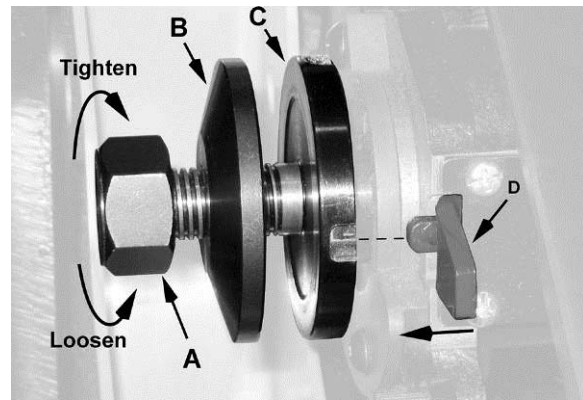


Figure 6

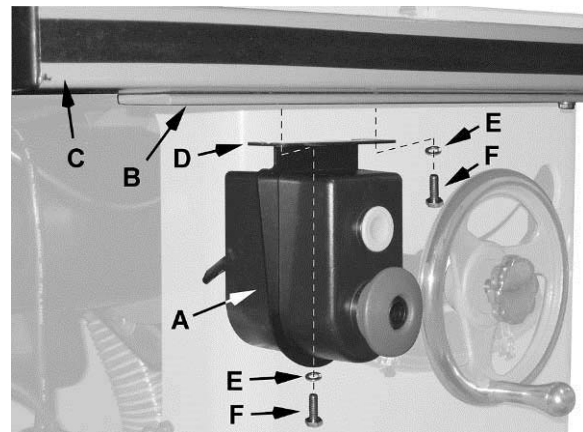


Figure 7

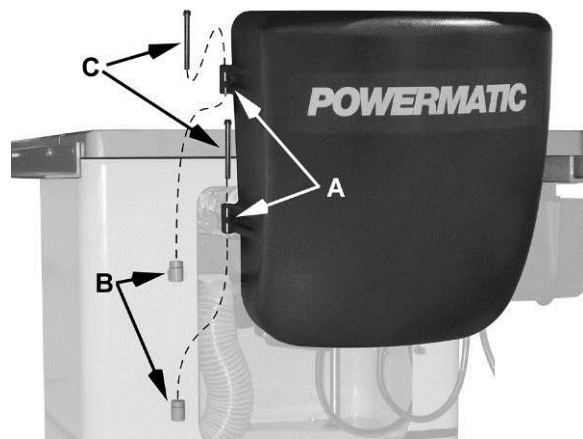


Figure 8

## Motor Cover

Line up the *door hinges* (A, Fig. 8) with the *cabinet hinges* (B, Fig. 8) and insert *hinge pins* (C, Fig. 8).

**Note:** The locking mechanism may require adjustment to insure proper alignment.

## Riving Knife and Guard Installation

### Description

Referring to Figure 9:

The complete *riving knife and guard assembly* is shown in A. Before installing onto the saw, the *anti-kickback pawl* (E) must be separated from the *riving knife* (H) as described below.

1. Press and hold the *quick-release button* (D) on the base of the *anti-kickback pawl* (E) and lift the pawl to remove from the *riving knife* (H).

### Installation

Referring to Figure 10:

1. Set the saw blade to the 90 degree position and raise it all the way (refer to *Handwheel Adjustments* on page 14).
2. Remove the table insert (J).
3. Located inside the table and accessible through the insert opening (Figure 10 inset), place the quick-release clamp lock handle (K) in the *unlock* position.
4. The *floating clamp block* (L) is spring loaded and will move away (O) from the *fixed block* (M), leaving a gap.
5. Insert the bottom of the *riving knife* (N<sub>1</sub>, N<sub>2</sub>) all the way into the gap between the *clamp blocks* (L, M), then lock the handle (K).
6. Replace the *insert* (J) back on the table. The saw blade and riving knife should protrude through the slot in the insert.

Referring back to Figure 9:

7. Attach the *anti-kickback pawl* (E) by pressing and holding the *quick-release button* (D) and inserting the lock pin of the pawl into the appropriate *slot* (F) on the riving knife.
8. In similar manner attach the guard (C) by pressing and holding the *quick-release button* (B) and inserting the lock pin of the guard into the appropriate *slot* (G) on the riving knife.

You should feel a snap as each piece locks in position. Attempt to lift as a test to make sure that they are securely locked in place.

### Adjustment

The clamping blocks (L, M, Fig. 10) are adjusted at the factory and no further adjustment of the blade guard and riving knife assembly should be necessary. However, **proper alignment is very important**. Before operating the table saw, read the *Riving Knife Adjustment* section (p.18) to verify and follow the adjustment procedure if necessary.

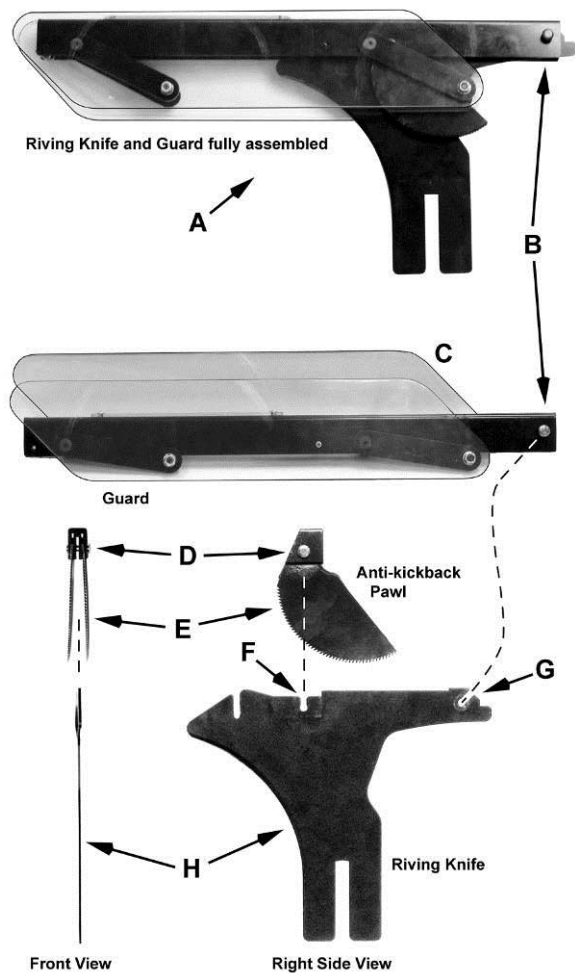


Figure 9

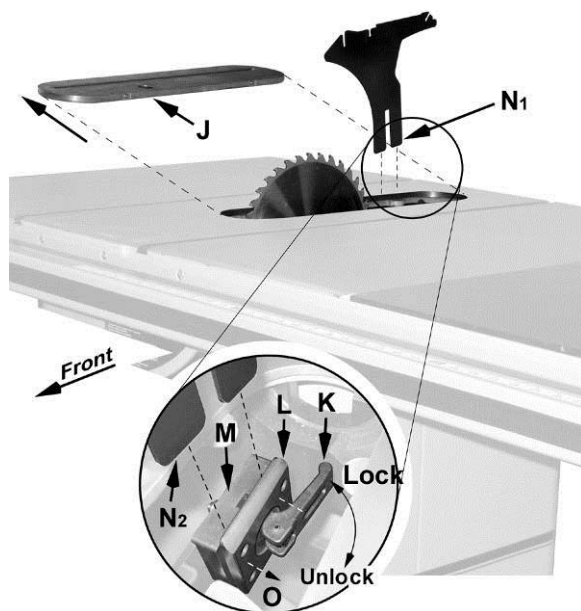


Figure 10

## Grounding Instructions

**⚠WARNING** Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

A power plug is not provided with the Model 2000. You may either connect the proper UL/CSA listed plug or “hardwire” the machine directly to your electrical panel provided there is a disconnect near the machine for the operator. Consult electrical drawings on pages 38-41 for further clarification of wiring setup.

This machine must be grounded. Grounding provides a path of least resistance to help divert current away from the operator in case of electrical malfunction.

Make sure the voltage of your power supply matches the specifications on the motor plate of the machine.

## Extension Cords

If an extension cord is necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

The chart in *Table 1* shows the correct size cord to use based on cord length and motor plate amp rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Amps	Extension Cord Length *					
	25 feet	50 feet	75 feet	100 feet	150 feet	200 feet
< 5	16	16	16	14	12	12
5 to 8	16	16	14	12	10	NR
8 to 12	14	14	12	10	NR	NR
12 to 15	12	12	10	10	NR	NR
15 to 20	10	10	10	NR	NR	NR
21 to 30	10	NR	NR	NR	NR	NR

\*based on limiting the line voltage drop to 5V at 150% of the rated amperes.

NR: Not Recommended.

*Table 1*

## Adjustments

### Handwheel Adjustments

Referring to Figure 11:

The *front handwheel* (B) controls the raising and lowering of the blade (*blade height*).

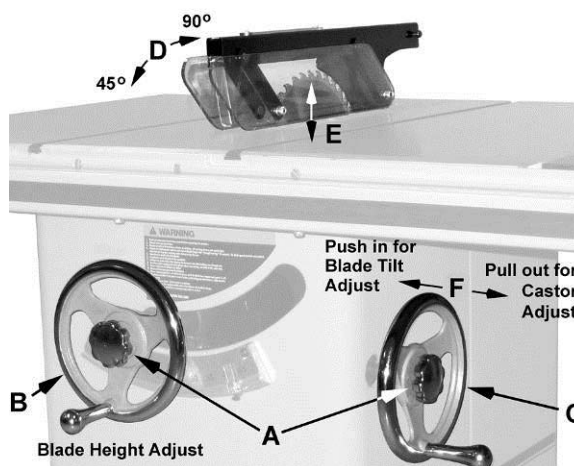
The *side handwheel* (C) controls the *blade tilt* and *castors*. The blade can be adjusted for a tilt between 90° (vertical or a setting of 0° on the scale) and 45° left tilt (D). The Model 2000 also has a retractable castor system that can be extended to permit the table saw to be rolled from one location to another.

### Blade height

1. Loosen the *lock knob* (A) on the *blade height adjust handwheel*.
2. Turn the *handwheel* (B) clockwise to raise and counterclockwise to lower the blade.
3. Tighten the *lock knob* (A).

### Blade tilt adjustment

1. Loosen the *lock knob* (A) on the *side handwheel* (C).
2. Push the handwheel *in* (F).
3. Turn the *handwheel* (C) counterclockwise to adjust the saw blade down to 45° left tilt (D). Turn clockwise to adjust the saw blade to maximum of 90° (D).
4. After selecting the position, tighten the *lock knob* (A).



*Figure 11*

### Castor system adjustment

Retractable castors can be extended permitting the saw to be moved:

1. Loosen the *lock knob* (A) on the *side handwheel* (C).
2. Pull the handwheel *out* (F).
3. Turn the handwheel (C) clockwise to extend the castors, raising the saw.

**Note:** Because of the weight of the machine, both hands will be needed to turn the handwheel. Raise the saw just enough to permit moving to another location.

When the saw has been repositioned:

4. Retract the castors by turning the *handwheel* (C) counterclockwise.
5. Push the handwheel *in* (F) and tighten the *lock knob* (A).

### Zero-Clearance Insert Setup

Under normal operations where the standard *table insert* (which is provided) is used, the top edge of the saw blade will come to rest approximately 1/8" below the table surface when the blade height is positioned all the way down.

In situations where a zero-clearance insert is desired, the saw blade *may* be lowered further for accommodation of inserts that have potential clearance issues with the blade. This is done as follows:

1. Remove the *guard* and *pawl* (Figure 9, Items C, E).
2. Open the side cover and locate the *blade depth stop* (A, Fig. 12) located between the *arbor pulley* and *motor*.
3. Using a 6mm hex wrench, loosen the *locking screw* (B, Fig. 12).
4. This will allow the depth stop to swing free and the saw blade to be adjusted lower.
5. With the *height adjust handwheel* (B, Fig. 11), lower the saw blade all the way.

The *zero-clearance insert* can now be placed into the table opening without contacting the saw blade.

**CAUTION** Never use a zero-clearance insert with the saw blade in a tilted position. Never operate the saw without the blade guard, riving knife and anti-kickback pawls for operations where they can be used.

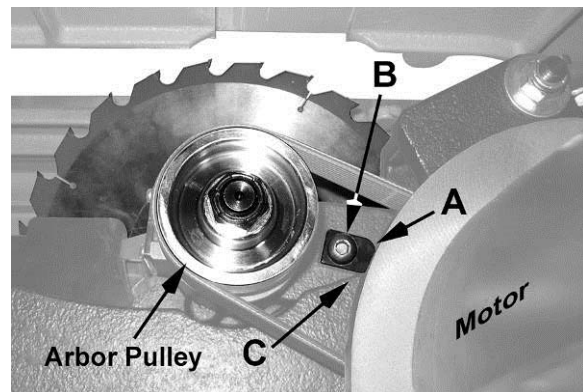


Figure 12

When the standard insert is to be used again, the saw blade must be readjusted as follows:

6. With the *height adjust handwheel* (B, Fig. 11), adjust height of the saw until the top of the saw blade is 1/8" below the top of the table.
7. The *blade depth stop* (A, Fig. 12) should be resting against the *trunnion* (C, Fig. 12). Verify that this is the case; then tighten the *locking screw* (B, Fig. 12).
8. Replace the *standard insert*, *pawl* and *blade guard*.

## Miter Slot Alignment

**⚠WARNING** Disconnect machine from power source before making this adjustment.

To check the alignment of the miter slot to the blade:

1. Raise the blade to its maximum height at the 90° vertical position (0° on scale).
2. Mark one tooth with a grease pencil and position the tooth slightly above the top edge of the table at the front.
3. Raise the miter gauge slightly out of its slot to serve as a shoulder. Using a combination square against the side of the bar, slide the scale over until it touches the tip of the blade, and lock the scale in position (A, Fig. 13).
4. Rotate the marked tooth so that it is slightly above the table top at the rear (B, Fig. 13) and using the square as before, check whether the distance to the blade is the same.
5. If the distance is not the same, loosen the four mounting screws that lock the table top to the cabinet (two in front, two in back).
6. Nudge the table to bring the miter slot in line with the blade.

The blade must be kept centered *with the slot in the table insert* to ensure clearance at both the 90° and 45° positions.

7. After alignment, secure the table to the cabinet by re-tightening the four mounting screws.

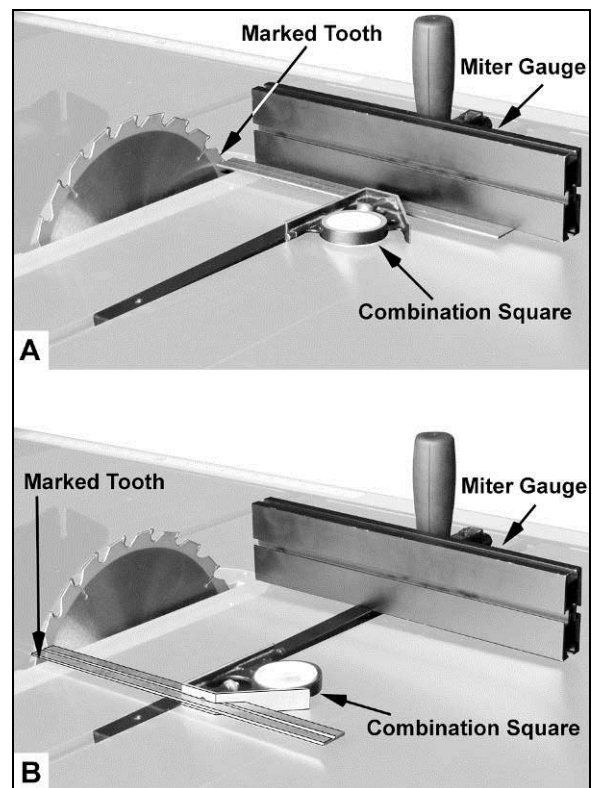


Figure 13

## Tilt Stop Adjustment

1. Adjust the blade tilt for 90° as described in *Blade Tilt Adjustment* on page 14.
2. Using a combination square, check the 90° stop (Figure 14 shows the 90° stop being checked).
3. Adjust the 90° stop position if required, using the stop screws as shown.

The 90° stop adjustment is accessible through the left side opening. 14mm wrenches are required to loosen the lock nut and adjust the screw.

4. Check the accuracy of the *pointer* at 0° (blade at 90° vertical position) and adjust if required.
5. Adjust the blade tilt for 45°. If required, adjust the stop and pointer in the same manner as above. The 45° stop adjustment is accessible through the slot on the front of the cabinet.

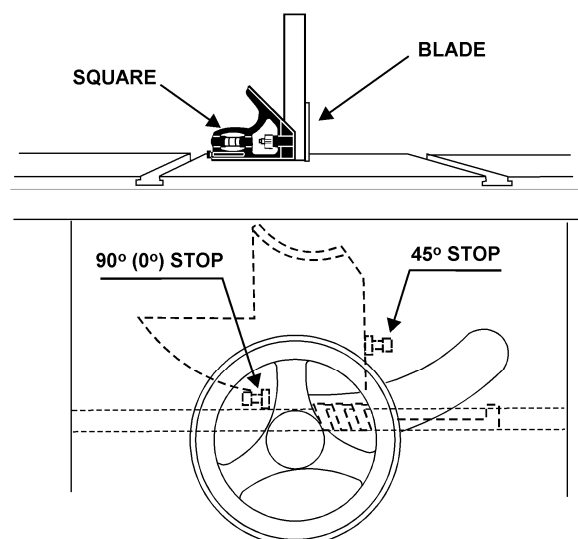


Figure 14



## Precision Miter Gauge

### Setting the miter gauge angle

Referring to Figure 15:

The precision miter gauge has a *rack and pinion adjustment* for setting the angle. To operate:

1. Slide the miter gauge into one of the slots on the table top.
2. Loosen *lock handle* (A).

To adjust the *body* (B) of the miter gauge to the desired angle:

3. Pull the *spring-loaded knob* (C) out and turn until the *body* (B) of the miter gauge is at the desired angle as indicated on the scale.
4. Tighten the *lock handle* (A).

### Indent settings

There are indents at the 0°, 30° and 45° right and left positions. At these settings, release the *knob* (C) to engage the stop rod. Then tighten the *lock handle* (A).

**Note:** Do not rely solely on the indents for an accurate setting. After the stop rod engages at the 0°, 30° and 45° positions, make a fine adjustment with the knob (C), if necessary, setting it against the scale indicator.

### Extension plate

The *extension plate* (D) can be adjusted by sliding to the right or left or removed entirely.

To adjust – loosen two *lock handles* (E), position the extension plate and tighten the lock handles.

To remove – slide the extension plate completely off and remove the lock handles (E) and mounting hardware.

### Calibrating the miter gauge

1. Place the miter gauge in one of the *slots* (H) on the table top.
2. Set the miter gauge to 90° (0° setting on the scale) by loosening the *lock handle* (A), then pulling the *spring-loaded knob* (C) out and turning the *body* (B) until 0° is indicated on the scale (F).
3. Measure the accuracy of the gauge against the slot with a combination square.

If adjustment is necessary:

4. Adjust the *body* (B) until it is perfectly square (90°) to the *miter slot* (H).
5. Tighten the *lock handle* (A).

6. Verify that the *scale indicator* (G) reads 0°. If further adjustment is necessary:
7. Loosen the *screw* (F) and adjust the *indicator* (G) until it reads 0°.
8. Tighten the *screw* (F).

NOTE: The bar of the miter gauge has a slot with two set screws. Adjust these set screws to eliminate any play between bar and miter slot.

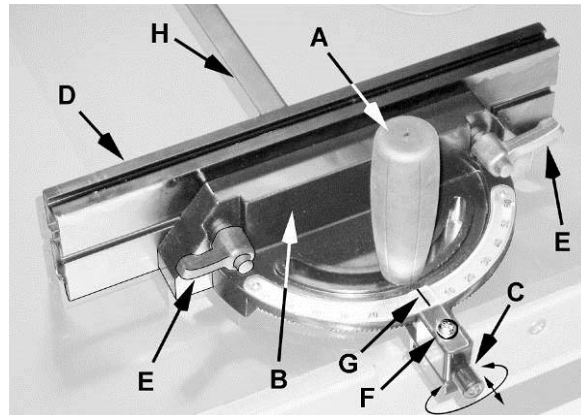


Figure 15

## Drive Belt

Lower the blade to access poly-V belt adjustment.

Referring to Figure 16:

**To adjust the belt tension** – loosen the *hex nut* (B) on the motor pivot and *hex cap screw* (A) on the bracket with a 19mm socket or wrench. Pivot the motor (C) and bracket to the right to increase the belt tension. Retighten screw and nut (A, B).

**To remove and replace belt** – loosen the *hex nut* (B) on the motor pivot and *hex cap screw* (A) on the bracket with a 19mm socket or wrench. Pivot the motor (C) and bracket to the left as far as possible. Remove the old *poly-V belt* (D) and replace. Adjust belt tension as described above.

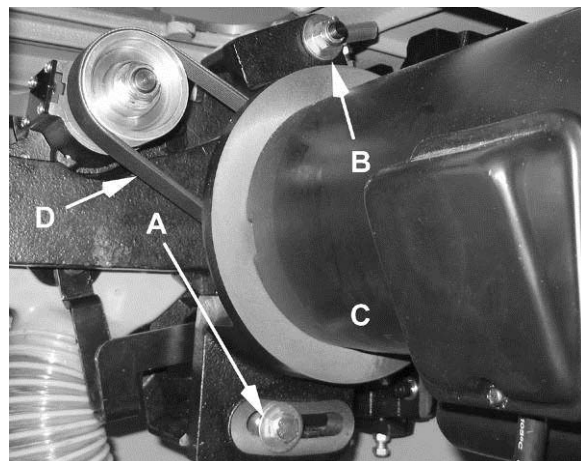


Figure 16

## Riving Knife Adjustment

### Lateral alignment

The saw blade and riving knife must be in line as close as possible with each other (*lateral alignment*) for the prevention of kickback. Upon initial blade guard and riving knife installation no further adjustment should be necessary. Alignment should be checked and adjusted, if required, after each blade change.

Check the alignment as follows:

1. Remove the *blade guard* and *pawl* (C, E, Fig. 9).
2. Place a *straightedge* (A, Fig. 17) on the table so it rests against the *blade* (B, Fig. 17) and *riving knife* (C, Fig. 17). Rotate the blade so the top of the blade tooth touches the straightedge.

The saw blade and riving knife must be in line.

If adjustment is required:

3. Remove the *blade guard* (C, Fig. 9) and *table insert*.
4. Loosen the *lock handle* (A, Fig. 18) and remove the riving knife, making a note as to which direction the riving knife needs to be moved to align it with the saw blade.
5. Using a 3mm hex wrench, make adjustments to four *set screws* (D, Fig. 19) accessible through openings located in the corners of the *floating clamp block* (B, Fig. 19).

Adjust any number of setscrews required to bring the riving knife in alignment with the saw blade. Then reinsert the riving knife, secure by tightening the *lock handle* (A, Fig. 18) and check the alignment per step 2.

**Note:** Position the lock handle *towards* the saw blade as shown in Figure 18. This will avoid the table insert from being lifted when the blade is raised with the handwheel.

6. Repeat steps 3–5 until the alignment is correct.

### Blade proximity alignment

The gap between the saw blade and riving knife must be between 3 and 8mm (Figure 20). If adjustment is needed, note whether the blade to knife gap needs to be increased or decreased. Then adjust as follows:

1. Remove the blade guard, pawl, table insert and riving knife.

Referring to Figure 19:

2. With a 5mm hex wrench, loosen two *socket head button screws* (E).

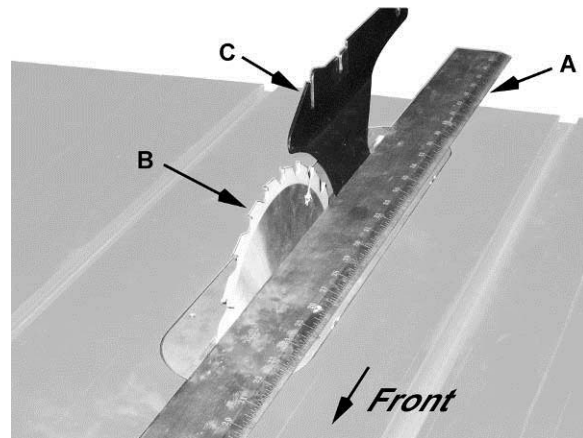


Figure 17

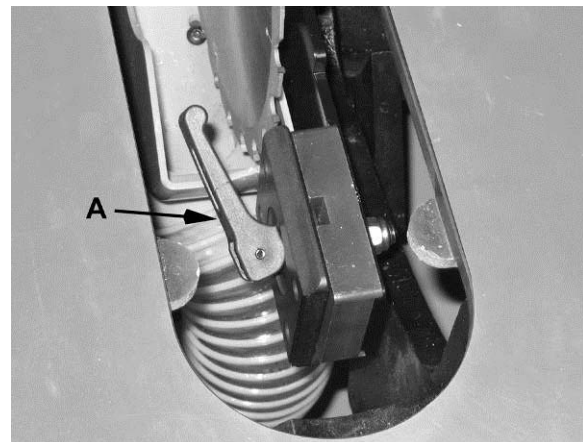


Figure 18

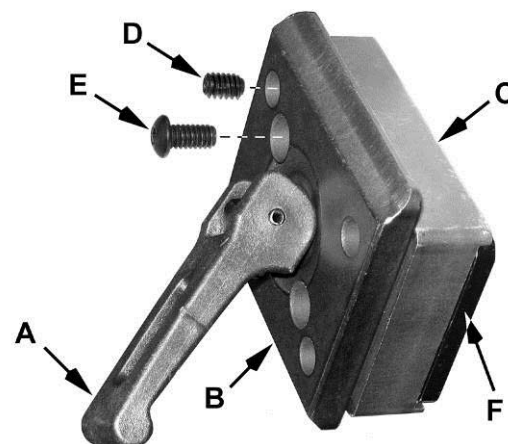


Figure 19

**Note:** These screws are accessible through openings on the *floating clamp block* (B) located diagonally on either side of the *lock handle* (A). They secure the *fixed clamp block* (C) to the *ripping knife extension plate* (F).

Loosening these screws (E) will allow the *fixed clamp block* (C) to slide back and forth on the *extension plate* (F).

3. Slide the *fixed clamp block* (F) toward or away from the saw blade as required.
4. Tighten the *socket head button screws* (E).
5. Reinsert the *ripping knife*; tighten the *lock handle* (A, Fig. 18) and check that the saw blade/knife gap is between 3 - 8mm (Figure 20).

**Note:** Attempt to make the gaps as even as possible.

### Insert Adjustment

Adjust the setscrews in the insert with a 3mm hex wrench (Figure 21) to ensure that the insert is stable and flush with the table top.

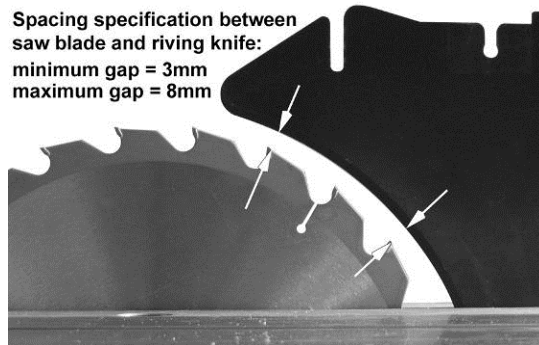


Figure 20

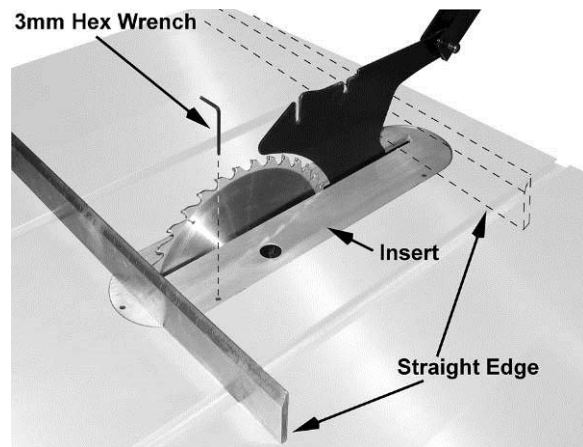


Figure 21

### Arbor and Arbor Bearing Removal

The saw arbor is *press fit* in the saw raising arm housing. If the arbor needs to be removed for bearing replacement, it should be done by a qualified service technician. Call your customer service representative at the phone number on the front cover.

# Operating Controls

## Start/Stop

**Power Indicator Light** – The *start switch* has a power indicator lamp which is *on whenever there is power connected* to the saw, not just when the saw is running. *Do not assume that no light means there is no power to the machine.* If the bulb is bad, there will no indication. Always check before use.

**⚠WARNING** Do not rely that no light means no power to the machine. Always check for power first. Failure to comply may cause serious injury!

Referring to Figure 22:

**Start** – Press the green start switch.

When power is connected to the machine, the green light is always on regardless of whether the saw is running or not.

**Stop** – Press the red switch to stop.

**Reset** – In the event that the saw stops without pressing the stop button, as the result of a tripped fuse or circuit breaker, etc.:

1. Press red button to reset
2. Press the green button to restart the machine.

## Safety Key

The start/stop switch on the Model 2000 comes equipped with a magnetic safety key. When in place on the switch as shown in Figure 22, the magnetic safety key trips a relay which will allow the machine to start and stop when the respective switches are pressed. Being magnetic, the lock can be removed to make the machine inoperable and can be hidden for safe storage by attaching it underneath the rail or another magnetic surface.

When using the saw, place the key on the switch cover lining up the arrow on the key with the REMOVE arrow on the cover. Then rotate the key so the arrow lines up with the LOCK arrow. This will prevent the safety key from coming loose from vibration when the machine is in use.

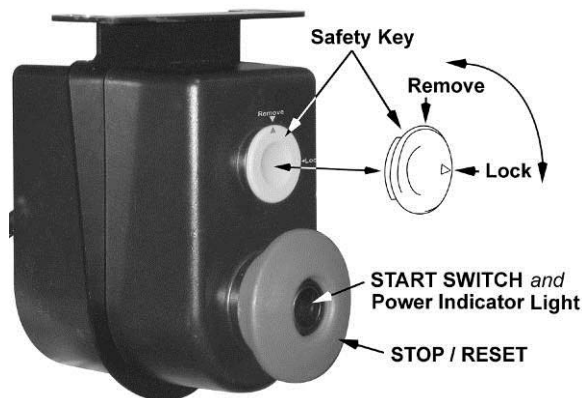


Figure 22

# Operations

## Overview

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.

## Kickback

Serious injury can result from kickbacks which occur when a work piece binds on the saw blade or binds between the saw blade and rip fence or other fixed object. This binding can cause the work piece to lift up and be thrown toward the operator.

Listed below are conditions, which can cause kickbacks:

- Confining the cutoff piece when crosscutting or ripping.
- Releasing the work piece before completing the operation or not pushing the work piece all the way past the saw blade.
- Not using the riving knife when ripping or not maintaining alignment of the riving knife with the saw blade.
- Using a dull saw blade.
- Not maintaining alignment of the rip fence so that it tends to angle toward rather than away from the saw blade front to back.
- Applying feed force when ripping to the cutoff (free) section of the work piece instead of the section between the saw blade and fence.
- Ripping wood that is twisted (not flat), or does not have a straight edge, or a twisted grain.

To minimize or prevent injury from kickbacks:

- Avoid conditions listed above.
- Wear a safety face shield, goggles, or glasses.
- Do not use the miter gauge and rip fence in the same operation unless provision is made by use of a facing board on the fence so as to allow the cutoff section of the workpiece to come free before the next cut is started (see Figure 30).
- As the machine receives use, the operation of the anti-kickback pawls should be checked periodically (Figure 23). If the pawls do not stop the reverse motion of a workpiece, sharpen all the points.
- Where possible, keep your face and body out of line with potential kickbacks including when starting or stopping the machine.

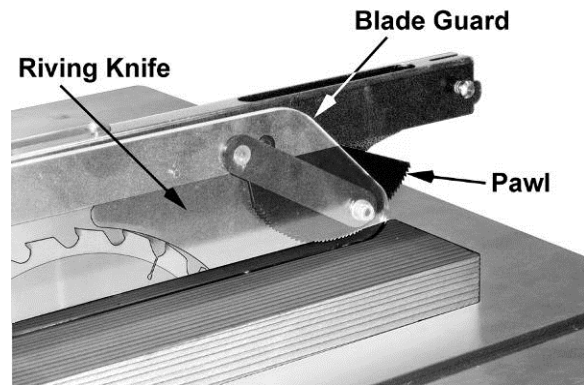


Figure 23

Dull, badly set, improper, or improperly filed cutting tools and cutting tools with gum or resin adhering to them can cause accidents. Never use a cracked saw blade. The use of a sharp, well maintained, and correct cutting tool for the operation will help to avoid injuries.

Support the work properly and hold it firmly against the gauge or fence. Use a push stick or push block when ripping short, narrow (6" width or less), or thin work. Use a push block or miter gauge holddown when dadoing or molding.

For increased safety in crosscutting, use the provided *extension plate* (Figure 24) attached to the *miter gauge* using the holes provided in the gauge.

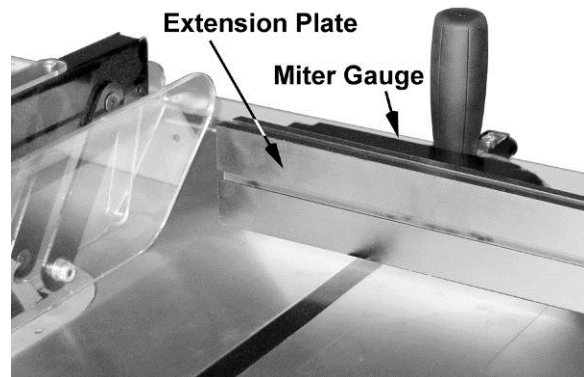


Figure 24

Never use the fence as a length stop when crosscutting. Do not hold or touch the free end or cutoff section of a workpiece. On through-sawing operations, the cutoff section must NOT be confined.

Always keep your hands out of the line of the saw blade and never reach back of the cutting blade with either hand to hold the workpiece.

Bevel ripping cuts should always be made with the fence on the right side of the saw blade so that the blade tilts away from the fence and minimizes the possibility of the work binding and the resulting kickback.

## Rip Sawing

Ripping is where the work piece is fed with the grain into the saw blade using the fence as a guide and a positioning device to ensure the desired width of cut (Figure 25).



Figure 25

**CAUTION** Before starting a ripping cut, be sure the fence is clamped securely and aligned properly.

- Never rip freehand or use the miter gauge in combination with the fence.
- Never rip workpieces 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 blade guard, riving knife and anti-kickback pawls. Make sure the riving knife 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 installed on each guard to remind the operator of the dangers of improper machine operation.

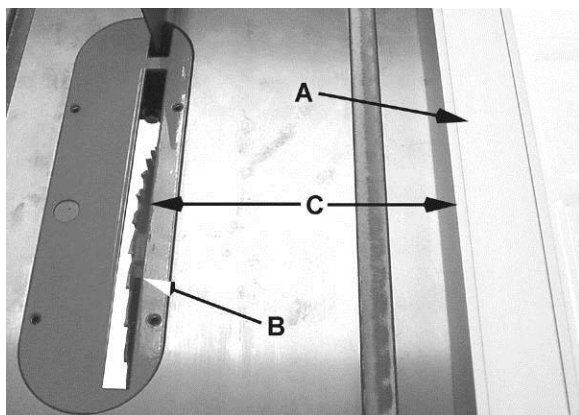


Figure 26

The *rip fence* (A, Fig. 26) should be set for the *width of the cut* (C, Fig. 26) by using the scale on the front rail, or by measuring the distance between the blade (B) and fence (A). Stand out of line with the saw blade and workpiece to avoid sawdust and splinters coming off the blade or a kickback, if one should occur.

If the work piece does not have a straight edge, attach 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.

In ripping, use one hand to hold the board down against the fence or fixture, and the other to push it into the blade between the blade and the fence. If the workpiece is narrower than 6" or shorter than 12", use a push stick or push block to push it through between the fence and saw blade (Figure 27). 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. Always push the workpiece completely past the blade at the end of a cut to minimize the possibility of a kickback.

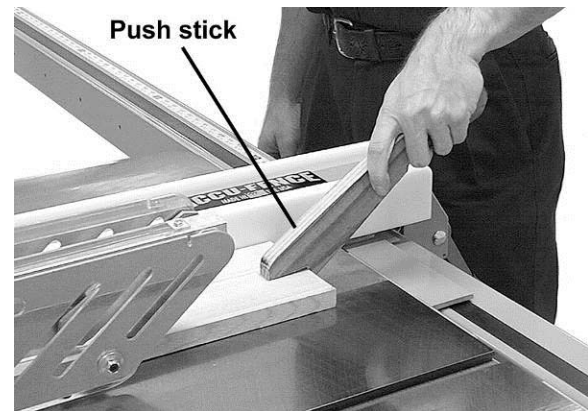
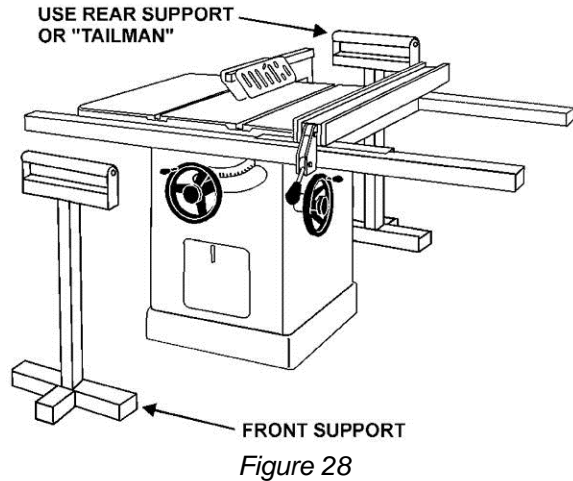


Figure 27

When ripping long boards, use a support at the front of the table, such as a roller stand, and a support or "tailman" at the rear as shown in Figure 28.

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 workpiece. Exposing the blade above this point can be hazardous.



## Crosscutting

Crosscutting is where the workpiece is fed cross grain into the saw blade using the miter gauge to support and position the workpiece (Figure 29).



Figure 29

Crosscutting should **never** be done freehand nor should the fence be used as an end stop unless an auxiliary block is clamped to the front of the blade area such that the cutoff piece comes free of the block before cutting starts (Figure 30).

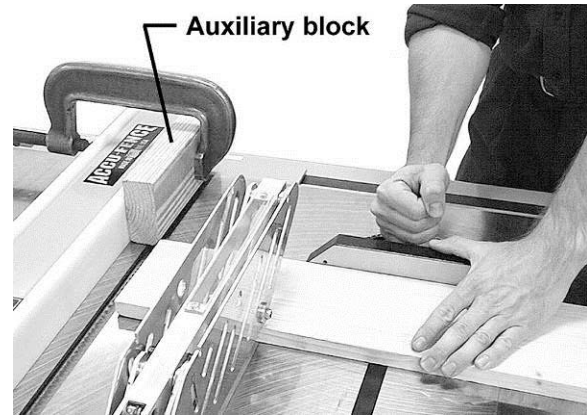


Figure 30

Length stops should not be used on the free end of the workpiece in the cutoff area.

Do **not** crosscut workpieces shorter than 6". Before starting a cut, be sure the miter gauge is securely clamped at the desired angle. Hold the workpiece firmly against the table and back against the miter gauge. **Always** use the saw guard and riving knife and make sure the riving knife is properly aligned.

For 90 degree crosscutting, most operators prefer to use the left-hand miter gauge slot. When using it in this position, hold the workpiece against the gauge with the left hand and use the right hand to advance the workpiece. 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.

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

## Bevel and Miter Operations

**Bevel Cut** – 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 (Figure 31). Operations are performed in the same manner as ripping or crosscutting except the fence or miter gauge should be used on the right-hand side of the saw blade to provide added safety in avoiding a binding action between the saw blade and the table top. When beveling with the miter gauge, the workpiece must be held firmly to prevent creeping.

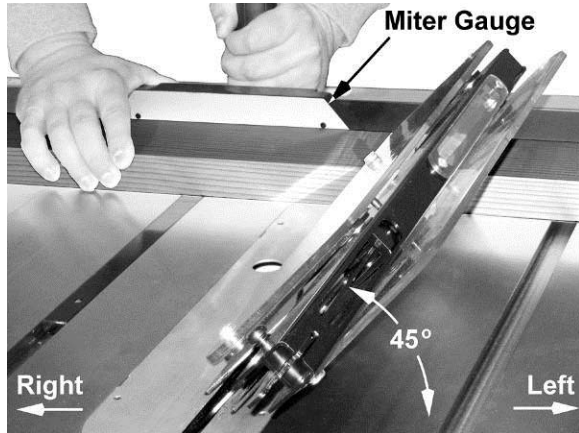


Figure 31

**Crosscut** – Crosscuts made at an angle to the edge of the workpiece are called miters (Figure 32). Set the miter gauge at the required angle, lock the miter gauge, and make the cut the same as a normal crosscut except the workpiece must be held extra firmly to prevent creeping.

**Note:** When making compound miters (with blade tilted) use the miter gauge in the **right** hand slot to provide more hand clearance and safety.

Have the blade extend only 1/8" above the top of the workpiece. Exposing the blade above this point can be hazardous.

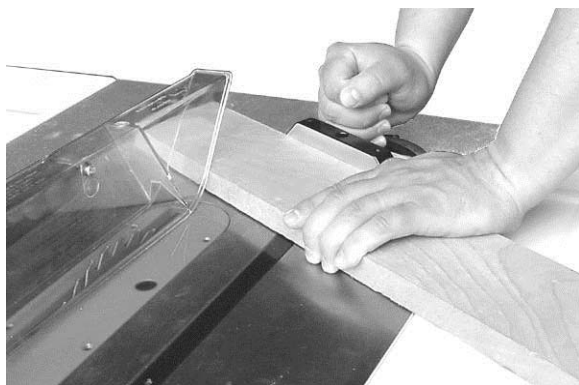


Figure 32

**Dado Cutting** – Dadoing is cutting a wide groove into a workpiece or cutting a rabbet along the edge of a workpiece. A dado insert, shown in Figure 33, is necessary for this type of operation.

**CAUTION** Do not use the standard table insert for dadoing operations.



Figure 33

The process of cutting 1/8" to 13/16" grooves in workpieces is accomplished by the use of a stacked dado blade set or an adjustable type blade mounted on the saw arbor. By using various combinations of the stacked dado blades, or properly setting the dial on an adjustable blade, an accurate width dado can be made. This is very useful for shelving, making joints, tenoning, etc. The guard, riving knife, and anti-kickback pawls supplied with the saw should be used for all cutting operations where they can be used. When performing operations where the guard cannot be used, as in some dadoing operations, alternative safety precautions should be taken. These include push sticks, feather boards, filler pieces, fixtures, jigs and any other appropriate device that can be utilized to keep operator's hands away from the blade. Upon completion of the operation requiring removal of the guard, the entire guard assembly must be placed back on the machine in its proper working order.

**CAUTION** Never use a dado head in a tilted position. Never operate the saw without the blade guard, riving knife and anti-kickback pawls for operations where they can be used.



# Safety Devices

## Feather Board and Push Blocks

Feather boards and push blocks can be purchased at most woodworking stores that sell table saws and accessories, although some users prefer to make their own. In addition, a multitude of after-market products are available that can be used in conjunction with the miter slot and fence.

## Push Stick

The use of a push stick provides an added level of safety for the operator and is provided with this machine.

## Filler Piece

A filler piece (Figure 34) is necessary for narrow ripping and permits the blade guard to remain on the machine. It also provides space for the safe use of a push stick.

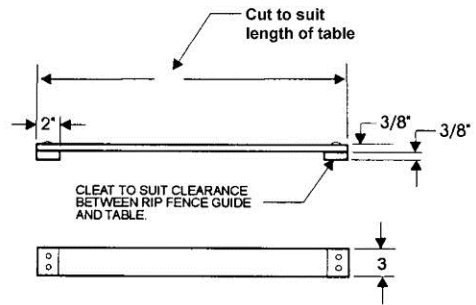
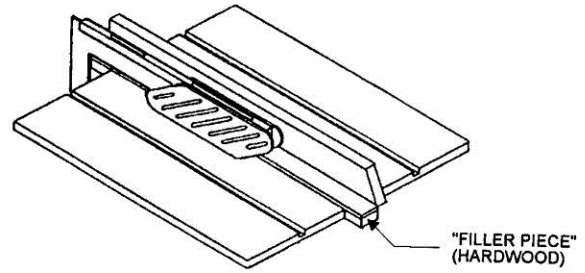


Figure 34 – Filler Piece

# Maintenance

**⚠WARNING** Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

## Cleaning

**Note:** The following maintenance schedule assumes the saw is being used every day.

### Daily:

- Wipe down the table surface and grooves with a rust preventive.
- Clean the pitch and resin from the saw blade.

### Weekly:

- Table surface must be kept clean and free of rust for best results. Apply a coat of paste wax to the surface to facilitate this. An alternative is to apply white talcum powder, rubbed in vigorously once a week with a blackboard eraser; this 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. Important also is the fact that talcum powder will not stain wood or mar finishes as wax pickup does.
- Clean the motor housing with compressed air.
- Wipe down the fence rails with a dry silicon lubricant.

## Periodic:

- Keep the inside of the cabinet and trunnion area clean.
- Check for excessive play in the tilting and raising mechanism and in the saw arbor and re-adjust as required.
- Check for belt tension and wear. Readjust or replace belt as required.

## Lubrication

- Grease the tilting worm gear, raising worm gear, castor system worm gear and the trunnion areas with a good grade non-hardening grease.
- Check all adjustments after lubricating.

## Miscellaneous

Always be aware of the condition of your machine. Routinely check the condition of the following items and repair or replace as necessary:

- Mounting bolts
- Power switch
- Saw blade
- Blade guard assembly

## Troubleshooting

Trouble	Probable Cause	Remedy
Excessive vibration.	Tilt or raising clamp knobs not tightened.	Tighten knobs.
	Blade out of balance.	Change blade. [page 12]
	Bad motor.	Replace motor.
	Loose arbor or motor sheave.	Tighten set screws.
Cuts out-of-square when crosscutting.	Miter gauge out of adjustment.	Reset pointer. [page 17]
	Miter slot misaligned.	Realign table. [page 16]
Motor stalls or workpiece binds or burns.	Excessive feed.	Reduce feed.
	Bad motor.	Replace motor.
	Dull or incorrect blade.	Replace blade. [page 12]
	Miter slot misaligned.	Realign miter slot. [page 16]
Fence misalignment.	Realign fence. [see <i>Fence Manual</i> No. M-2195079Z]	
Cuts not true at 90 or 45 degrees.	Stop screws not set properly.	Readjust stop screws. [page 16]
Tilt or saw raising handwheels difficult to turn.	Lock knob not released.	Loosen lock knob.
	Worm and worm gear segment caked with sawdust and pitch.	Clean and re-grease.
	Worm and worm gear segment out of alignment.	Realign worm and worm gear segment.
Motor overheats.	Motor overloaded.	Correct overload condition such as reducing the feed rate.
	Improper cooling of motor.	Clean sawdust from fan and duct areas of motor.
Motor starts slowly or fails to come up to speed.	Low voltage.	Request voltage check from power company and correct low voltage condition.
	Centrifugal switch not operating.	Replace switch.
	Bad motor.	Replace motor.
Motor fails to develop full power.	Power line overloaded.	Correct overload condition.
	Undersize wires in supply system.	Increase supply wire size.
	Low voltage.	Request voltage check from power company and correct condition.
	Bad motor.	Replace motor.

## Optional Accessories

- 2195042K Accu-Fence® and rail system for ripping 50" to right and 12" to left of saw blade.
- 2195079Z Accu-Fence® - fence assembly only, no rails.
- 1791787 Low Profile Riving Knife.
- 1791791 Thin Kerf Riving Knife.
- 1791792 Low Profile Thin Kerf Riving Knife
- 1791790 Table Insert.
- 1791788 Dado Insert Plate for 8" dado head.
- 2726008 Replacement side panel kit for Model 66 Accu-Fence®.
- 1791789 Miter Gauge.
- 6827044 Motor cover.
- 708295 Tenoning Jig.
- 1791786 Zero Clearance Insert.
- 6441000Z Set of 2 legs for 6827028 table.
- 6682004 Rout-R-Lift with deluxe fence.
- 6827041 Wood Extension Table for 50" capacity with Rout-R-Lift hole.
- 6827043 Wood Extension Table for 30" capacity with Rout-R-Lift hole.
- 6827040 Wood Extension Table for 50" capacity.
- 6827042 Wood Extension Table for 30" capacity.

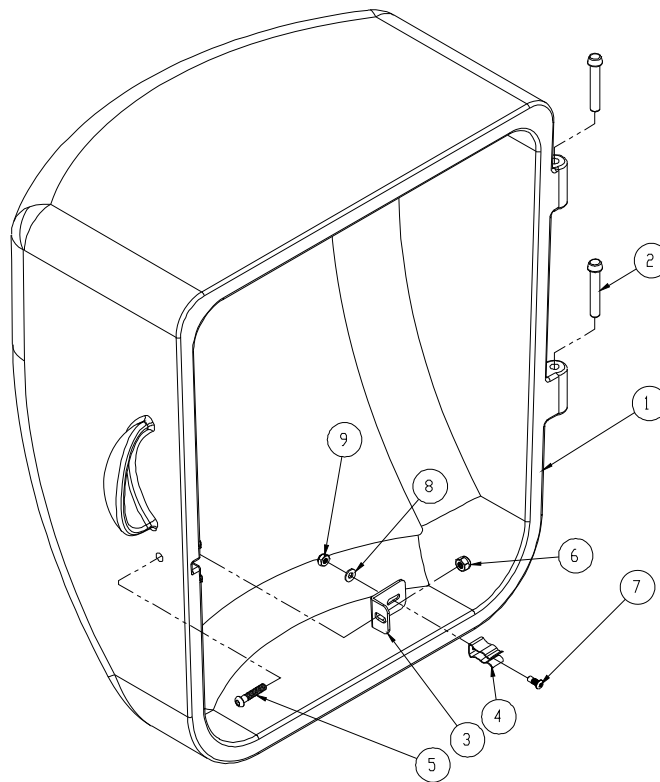
## Ordering Replacement Parts

To order parts or reach our service department, call 1-800-274-6848, Monday through Friday (see our website for business hours, [www.powermatic.com](http://www.powermatic.com)). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

# Model PM2000 Table Saw Parts List

## Side Cover Assembly

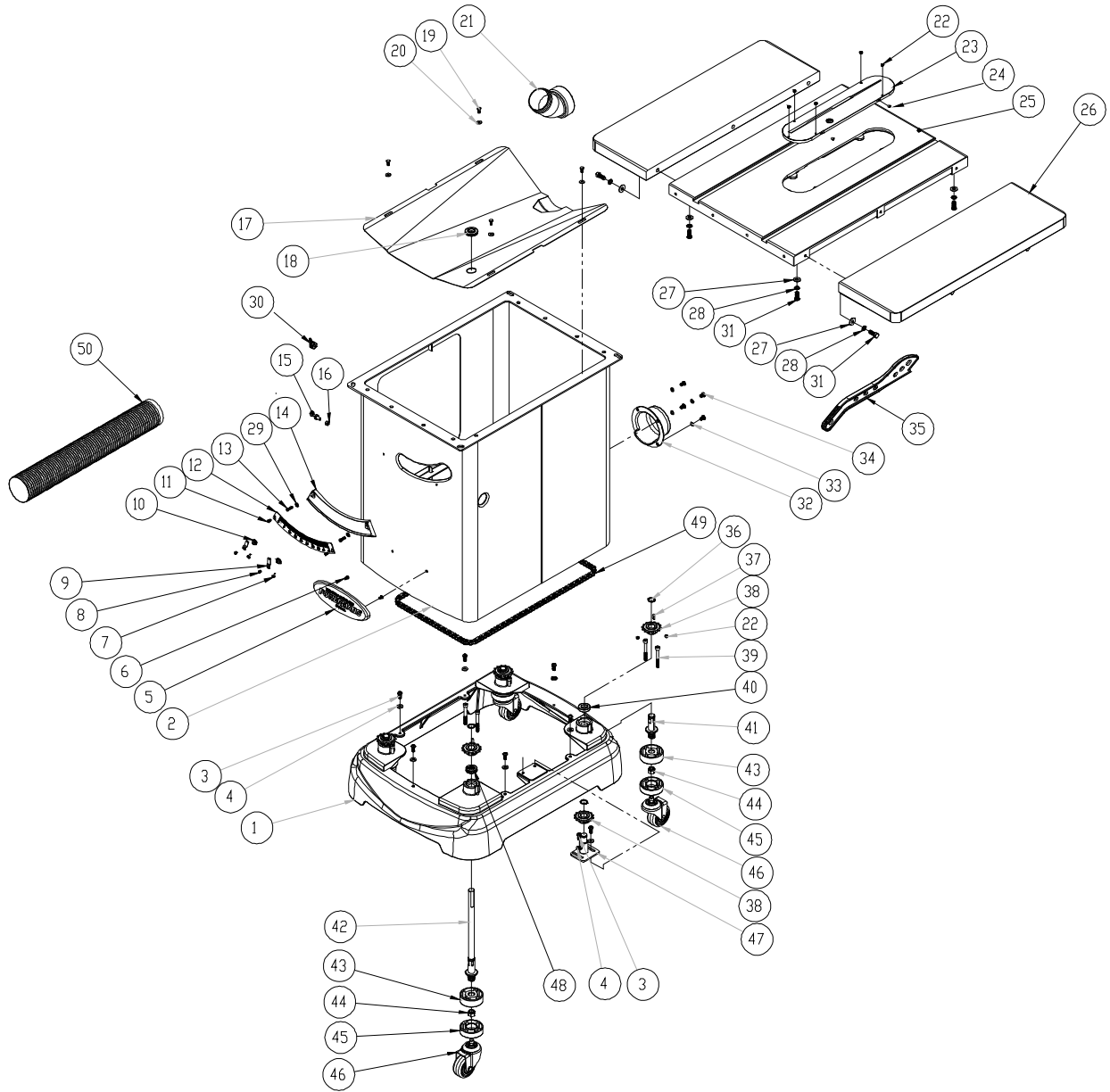
Index No.	Part No.	Description	Size	Qty
.....	6827044.....	PM2000 Motor Cover Assembly (Index #1 thru #9).....		1
1.....	PM2000-401.....	Cover.....		1
2.....	PM2000-402.....	Hinge Pin.....		2
3.....	PM2000-403.....	Bracket.....		1
4.....	PM2000-404.....	Latch Clip.....		1
5.....	PM2000-405.....	Button Head Socket Screw.....	1/4-20x1-1/4.....	1
6.....	TS-0640071.....	Nylon Insert Lock Nut.....	1/4-20.....	1
7.....	TS-081C032.....	Pan Head Screw.....	#10-24x1/2.....	1
8.....	TS-069204.....	Flat Washer.....	#10.....	1
9.....	TS-0560071.....	Hex Nut.....	#10-24.....	1



## Table & Cabinet Assembly

Index No.	Part No.	Description	Size	Qty
1	PM2000-101	Base		1
2	PM2000-102	Cabinet		1
	PM2000-102A	Cabinet (for 5HP 1PH / 5HP 3PH)		1
3	TS-0255041	Button Head Socket Screw	5/16-18x3/4	8
4	TS-0680031	Flat Washer	5/16	8
5	PM2000-105	Powermatic Name Plate		1
6	TS-0255011	Socket Head Button Screw	5/16-18x3/8	2
7	PM2000-107	Lock Screw		2
8	TS-081C011	Flat Head Machine Screw	#10-24x1/4	2
9	PM2000-109	Pointer		2
10	PM2000-110	Pointer Block		2
11	TS-081C032	Pan Head Screw	#10-24x1/2	2
12	PM2000-112	Tilt Angle Scale		1
13	TS-0254021	Button Head Socket Screw	1/4-20x1/2	2
14	PM2000-114	Scale Base		1
15	PM2000-115	Latch Post		1
16	TS-0561021	Hex Nut	5/16-18	1
17	PM2000-117	Dust Plate		1
18	PM2000-118	Bushing		1
19	TS-0050011	Hex Cap Screw	1/4-20x1/2	4
20	TS-0680021	Flat Washer	1/4	6
21	PM2000-121	Dust Port		1
22	TS-0267021	Set Screw	1/4-20x1/4	13
23	1791790	Table Insert		1
24	PM2000-124	Ball Plunger		2
25	PM2000-125	Table		1
26	PM2000-126	Extension Table		2
27	TS-0680041	Flat Washer	3/8	10
28	TS-0720091	Lock Washer	3/8	10
29	TS-0720071	Lock Washer	1/4	2
30	PM2000-130	Strain Relief		1
	PM2000-130A	Strain Relief (for 5HP 1PH / 5HP 3PH)		1
31	TS-0060051	Hex Cap Screw	3/8-16x1	10
32	PM2000-132	Dust Chute		1
33	TS-0720081	Lock Washer	5/16	4
34	TS-0255021	Button Head Socket Screw	5/16-18x1/2	4
35	PM2000-135	Push Stick		1
36	PM2000-136	Retaining Ring		5
37	PM2000-137	Key	5x5x18	4
38	PM2000-138	Sprocket		5
39	TS-0208121	Socket Head Cap Screw	5/16-18x2-1/2	8
40	BB-6904ZZ	Ball Bearing	6904ZZ	3
41	PM2000-141	Shaft		3
42	PM2000-142	Lead Screw		1
43	PM2000-143	Adjusting Block		4
44	TS-0640111	Nylon Insert Lock Nut	1/2-13	4
45	PM2000-145	Elevating Block		4
46	PM2000-146	Castor		4
47	PM2000-147	Bracket		1
48	BB-51104	Thrust Bearing	51104	1
49	PM2000-149	Chain		1
50	PM2000-150	Dust Collection Tube		1

# Table & Cabinet Assembly



Retractable caster system, patent US 8,006,596 B2.

## Trunnion & Motor Assembly Parts List

Index No.	Part No.	Description	Size	Qty
1	PM2000-201	Knob		2
2	PM2000-202	Hand Wheel		2
3	TS-0270051	Set Screw	5/16-18x1/2	2
4	PM2000-204	Collar		1
5	TS-0270011	Set Screw	5/16-18x1/4	4
6	PM2000-206	Washer		2
7	TS-0810012	Round Head Screw	#10-24x1/4	1
8	PM2000-208	Pointer		1
9	PM2000-209	Bracket		1
10	PM2000-210	Roll Pin		1
11	TS-0271131	Set Screw	3/8-16x2	1
12	TS-0561031	Hex Nut	3/8-16	14
13	PM2000-213	Front Trunnion		1
14	TS-0267041	Set Screw	1/4-20x3/8	9
15	PM2000-215	Key	5x5x25	3
16	PM2000-216	Worm Gear		1
17	TS-0256051	Button Head Socket Screw	3/8-16x1	8
18	PM2000-218	Lock Nut	5/8-18 L.H.	1
19	PM2000-219	Support Base		1
20	PM2000-220	Raising Shaft		1
21	PM2000-221	Woodruff Key		2
22	PM2000-222	Roll Pin		3
23	PM2000-223	Bushing		1
24	PM2000-224	Worm		2
25	PM2000-225	Shaft		1
26	PM2000-226	Bushing		1
27	PM2000-227	Worm		1
28	TS-0209061	Socket Head Cap Screw	3/8-16x1-1/4	9
29	TS-0680041	Flat Washer	3/8	3
30	TS-0720091	Lock Washer	3/8	18
31	PM2000-231	Bracket		1
32	TS-081F051	Flat Head Machine Screw	1/4-20x3/4	2
33	TS-0254041	Button Head Socket Screw	1/4-20x3/4	1
34	PM2000-234	Shaft		1
35	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	2
36	PM2000-236	Washer		2
37	PM2000-237	Lock Nut	1-1/8-12	1
38	PM2000-238	Center Trunnion		1
39	PM2000-239	Poly-V Belt		1
40	PM2000-240	Key	7x7x25	1
41	PM2000-241	Motor Pulley		1
42	TS-0270031	Set Screw	5/16-18x3/8	4
43	PM2000-243	Motor Base		1
44	PM2000-244	Stud		1
45	TS-0680061	Flat Washer	1/2	2
46	TS-0640111	Nylon Insert Lock Nut	1/2-13	2
47	TS-0070031	Hex Cap Screw	1/2-13x1-1/2	1
48	PM2000-248	Motor	3HP, 230V, 1PH	1
	PM2000-MF	Motor Fan (not shown)		1
	PM2000-MFC	Motor Fan Cover (not shown)		1
	PM2000-CS	Centrifugal Switch (not shown)		1
	PM2000-SC	Starting Capacitor (not shown)	250MFD, 250VAC	1
	PM2000-RC	Running Capacitor (not shown)	20µF, 450VAC	1
	PM2000-SCC	Starting Capacitor Cover (not shown)		1
	PM2000-RCC	Running Capacitor Cover (not shown)		1
	PM2000-JB	Junction Box (not shown)		1



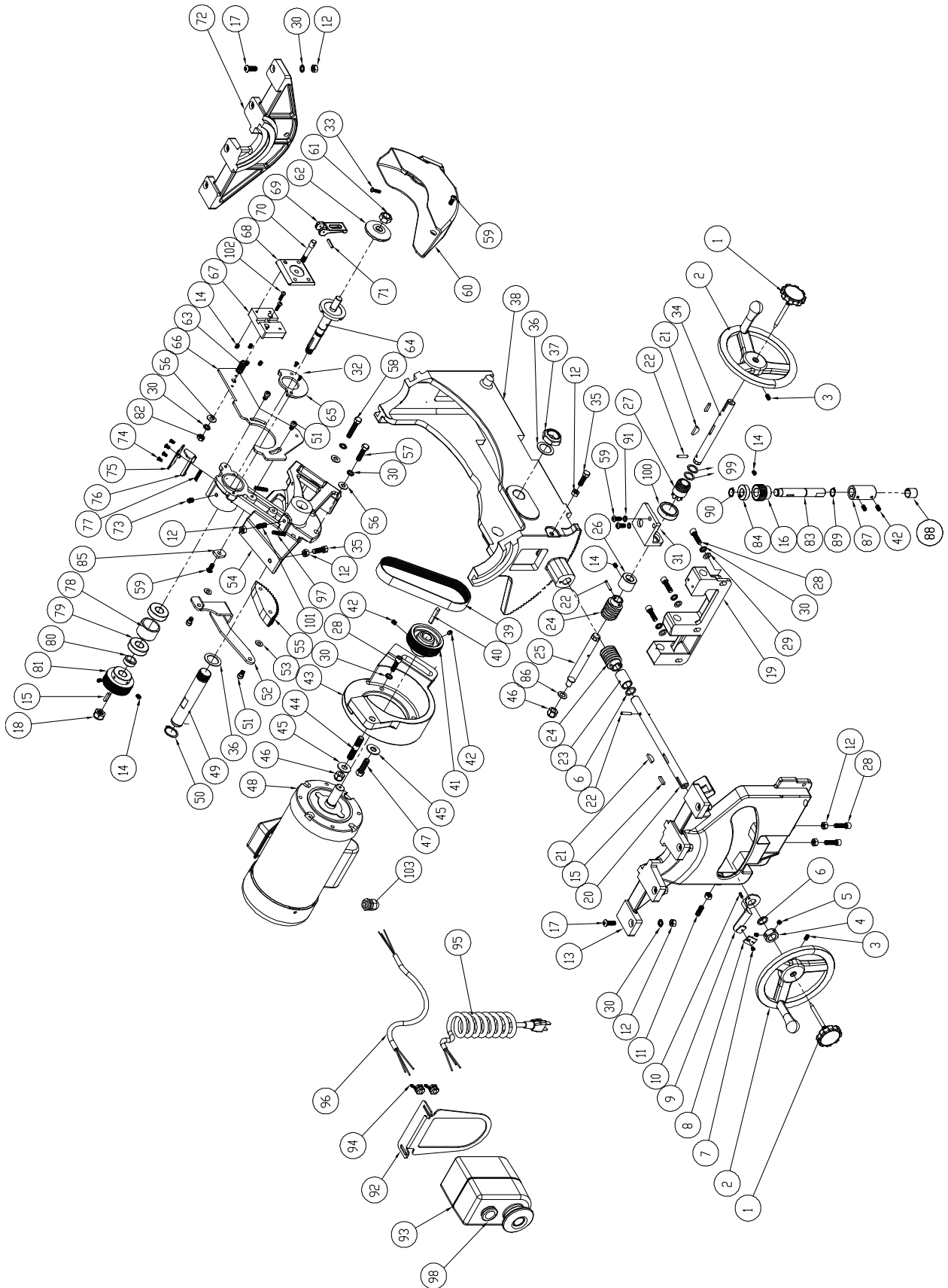
## Trunnion & Motor Assembly Parts List

Index No.	Part No.	Description	Size	Qty
	PM2000-JBC	Junction Box Cover (not shown)		1
	PM2000-248C	Motor	5HP, 230V, 1PH	1
	PM3000-MF	Motor Fan (not shown)		1
	PM2000-MFCB	Motor Fan Cover (not shown)		1
	PM2000-CSA	Centrifugal Switch (not shown)		1
	PM3000-SCA	Starting Capacitor (not shown)	250MFD, 250VAC	1
	PM2000-RCA	Running Capacitor (not shown)	35µF, 450VAC	1
	PM2000-SCCA	Starting Capacitor Cover (not shown)		1
	PM3000-JBA	Junction Box (not shown)		1
	PM3000-JBC	Junction Box Cover (not shown)		1
	PM2000-248D	Motor	5HP, 230/460V, 3PH	1
	PM2000-MF	Motor Fan (not shown)		1
	PM2000-MFCA	Motor Fan Cover (not shown)		1
	PM2000-JBA	Junction Box (not shown)		1
	PM2000-JBC	Junction Box Cover (not shown)		1
49	PM2000-249	Shaft		1
50	PM2000-250	Retaining Ring		1
51	PM2000-251	Shoulder Screw		4
52	PM2000-252	Extension Support Bracket		1
53	TS-0680031	Flat Washer	5/16	2
54	PM2000-254	Bearing Arm		1
55	PM2000-255	Gear Block		1
56	TS-0680041	Flat Washer	3/8	3
57	TS-0060071	Hex Cap Screw	3/8-16x1-1/2	1
58	TS-0060091	Hex Cap Screw	3/8-16x2	1
59	TS-0255041	Button Head Socket Screw	5/16-18x3/4	4
60	PM2000-260	Blade Dust Chute		1
61	PM2000-261	Arbor Nut		1
62	PM2000-262	Arbor Collar		1
63	PM2000-263	Spring		1
64	PM2000-264	Arbor		1
	PM2000-AA	Arbor Assembly (Index #61, #62, #64, #78 thru #80)		
65	PM2000-265	Fixed Plate		1
66	PM2000-266	Riving Knife Extension Plate		1
67	PM2000-267	Clamping Block		1
68	PM2000-268	Clamping Block		1
69	PM2000-269	Lock Handle		1
70	PM2000-270	Locking Pin		1
71	PM2000-271	Roll Pin		1
72	PM2000-272	Rear Trunnion		1
73	TS-0271051	Set Screw	3/8-16x1/2	1
74	TS-081C032	Pan Head Screw	#10-24x1/2	4
75	PM2000-275	Plate		1
76	PM2000-276	Arbor Lock Insert		1
77	PM2000-277	Spring		1
78	PM2000-278	Bushing		1
79	BB-6204VV	Ball Bearing	6204VV	2
80	PM2000-280	Bushing		1
81	PM2000-281	Arbor Pulley		1
82	TS-0640091	Nylon Insert Lock Nut	3/8-16	1
83	PM2000-283	Shaft		1
84	BB-6003ZZ	Ball Bearing	6003ZZ	1
85	PM2000-285	Stop Block		1
86	PM2000-286	Washer		1
87	PM2000-287	Bushing		1

## Trunnion & Motor Assembly Parts List

Index No.	Part No.	Description	Size	Qty
88	PM2000-288	DU Bushing		1
89	PM2000-289	Retaining Ring		1
90	PM2000-290	Retaining Ring		1
91	TS-0720081	Lock Washer	5/16	2
92	PM2000-292	Switch Plate		1
93	PM2000-293	Magnetic Switch	3HP, 230V, 1PH	1
	PM2000-293A	Magnetic Switch	5HP, 230V, 1PH	1
	PM2000-293D	Magnetic Switch	5HP, 230V, 3PH	1
	PM2000-293E	Magnetic Switch	5HP, 460V, 3PH	1
94	PM2000-294	Strain Relief for Magnetic Switch (for 3HP 1PH)		2
	PM2000-294A	Strain Relief for Magnetic Switch (for 5HP 1PH / 5HP 3PH)		2
95	PM2000-295	Power Cord (for 3HP/1PH)		1
	PM2000-295A	Power Cord (for 5HP/1PH)		1
	PM2000-295C	Power Cord (for 5HP/3PH)	600V	1
96	PM2000-296	Motor Cord (for 3HP/1PH)		1
	PM2000-296A	Motor Cord (for 5HP/1PH)		1
	PM2000-296C	Motor Cord (for 5HP/3PH)	600V	1
97	TS-0270101	Set Screw	5/16-18x1-1/4	2
98	PM2000-298	Safety Key for Magnetic Switch		1
99	PM2000-299	Bearing Washer		2
100	BB-6805ZZ	Ball Bearing	6805ZZ	1
101	TS-0271091	Set Screw	3/8-16x1	1
102	TS-0254021	Button Head Socket Screw	1/4-20x1/2	2
103	PM2000-294	Strain Relief for Motor (for 3HP 1PH)		1
	PM2000-2103	Strain Relief for Motor (for 5HP 1PH / 5HP 3PH)		1

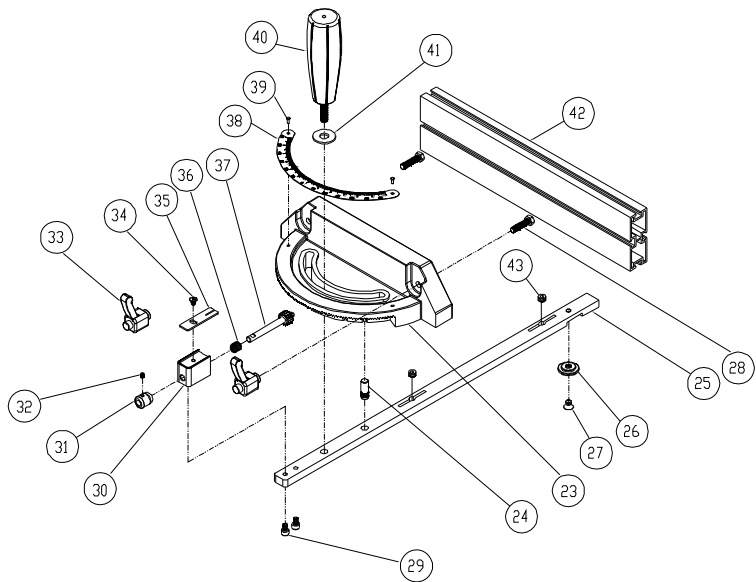
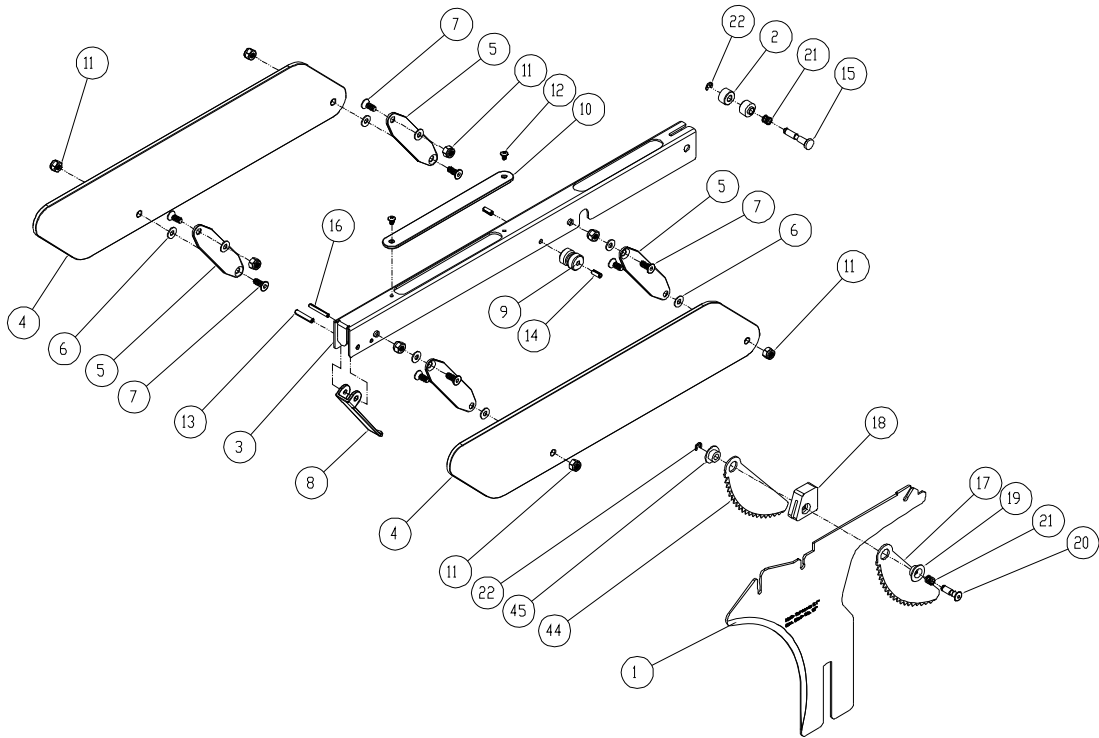
# Trunnion & Motor Assembly



## Blade Guard & Miter Gauge Assembly Parts List

Index No.	Part No.	Description	Size	Qty
1	PM2000-301	Riving Knife		1
	PM2000-BGA	Blade Guard Assembly (Index #2 thru #16, #21, #22)		1
2	PM2000-302	Bushing		2
3	PM2000-303	Blade Guard Body		1
4	PM2000-304	Blade Guard Side Shield		2
5	PM2000-305	Linking Plate		4
6	TS-1550041	Flat Washer	M6	8
7	TS-1514021	Flat Head Socket Screw	M6x16	8
8	PM2000-308	Front Shield		1
9	PM2000-309	Bushing		1
10	PM2000-310	Top Sight Shield		1
11	TS-1541021	Nylon Insert Lock Nut	M6	8
12	TS-081B012	Pan Head Screw	#8-32x1/4	2
13	PM2000-313	Roll Pin	5x25	1
14	PM2000-314	Roll Pin	5x12	2
15	PM2000-315	Lock Pin		1
16	PM2000-316	Roll Pin	4x30	1
	PM2000-AKPA	Anti-Kickback Pawl Assembly (Index #17 thru #22, 44, 45)		1
17	PM2000-317	Right Anti-Kickback Pawl		1
18	PM2000-318	Pawl Base		1
19	PM2000-319	Right Flange		1
20	PM2000-320	Lock Pin		1
21	PM2000-321	Spring		2
22	PM2000-322	E-Clip		2
	1791789	Miter Gauge Assembly (Index #23 thru #43)		1
23	PM2000-323	Miter Gauge Body		1
24	PM2000-324	Pin		1
25	PM2000-325	Miter Bar		1
26	PM2000-326	Guide Washer		1
27	PM2000-327	Flat Head Machine Screw	M6x9	1
28	TS-0050051	Hex Cap Screw	1/4-20x1	2
29	PM2000-329	Socket Head Cap Screw	M5x8	2
30	PM2000-330	Support Base		1
31	PM2000-331	Knob		1
32	TS-1521011	Set Screw	M4x4	1
33	PM2000-333	Locking Handle		2
34	TS-0810012	Round Head Screw	#10-24x1/4	1
35	PM2000-335	Pointer		1
36	PM2000-336	Spring		1
37	PM2000-337	Gear Shaft		1
38	PM2000-338	Scale		1
39	PM2000-339	Rivet		2
40	PM2000-340	Handle		1
41	TS-0680031	Flat Washer	5/16	1
42	PM2000-342	Fence		1
43	PM2000-343	Set Screw	M8x6	2
44	PM2000-344	Left Anti-Kickback Pawl		1
45	PM2000-345	Left Flange		1
46	1791787	Low Profile Riving Knife (not shown)		1

# Blade Guard & Miter Gauge Assembly

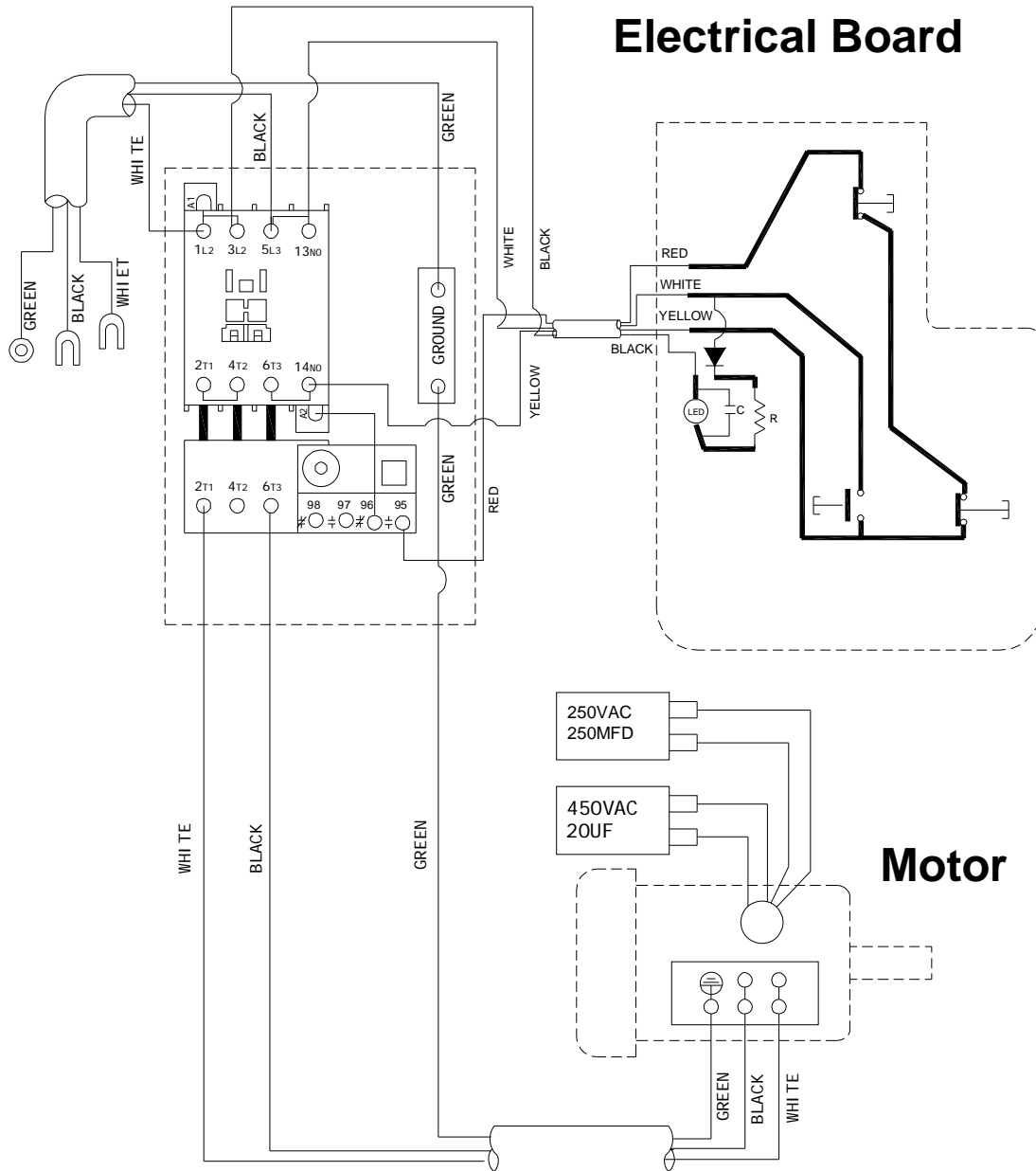


# Wiring Diagrams

## 3HP, 230V, 1Phase

### Magnetic Switch

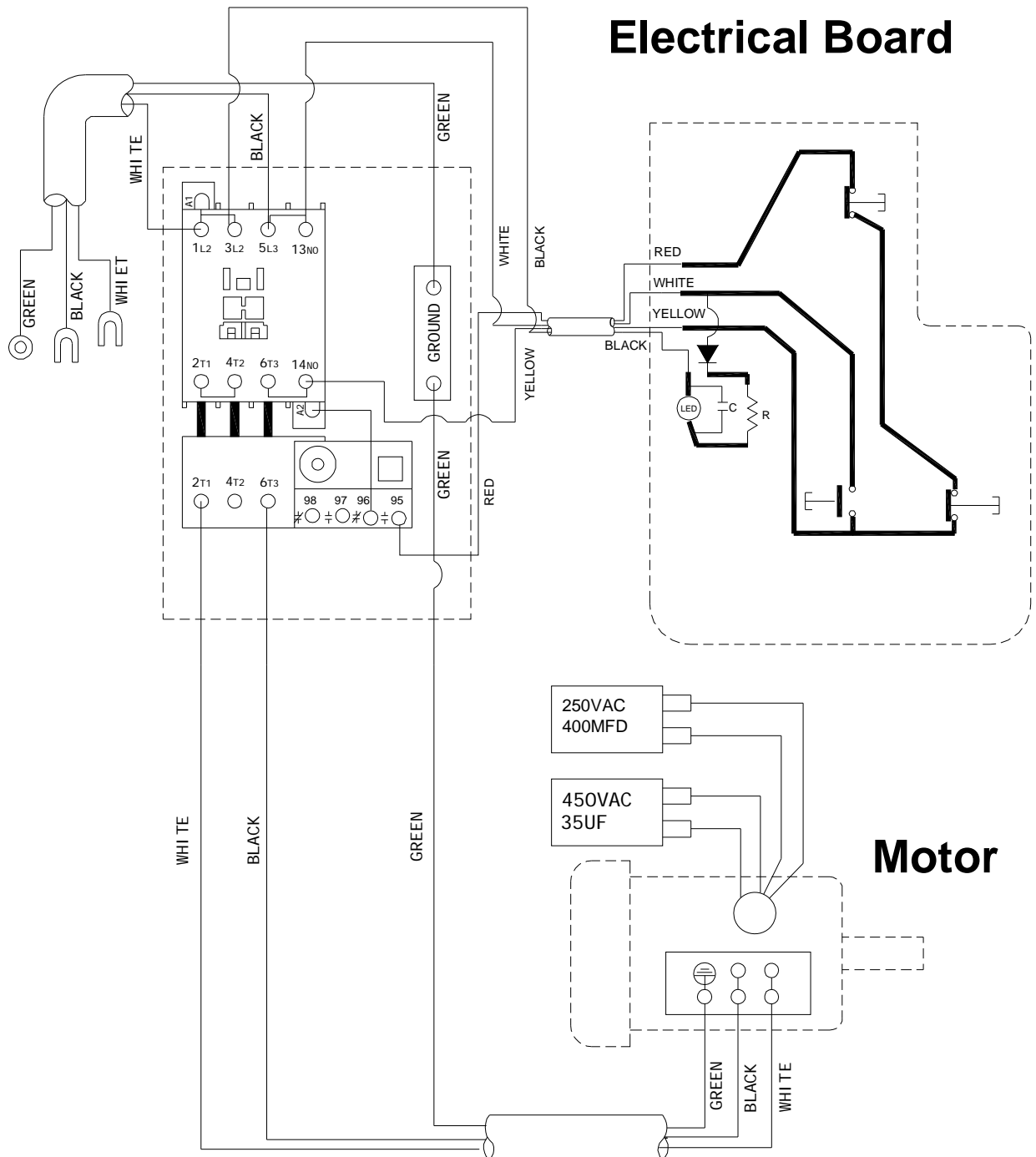
### Electrical Board



5HP, 230V, 1Phase

# Magnetic Switch

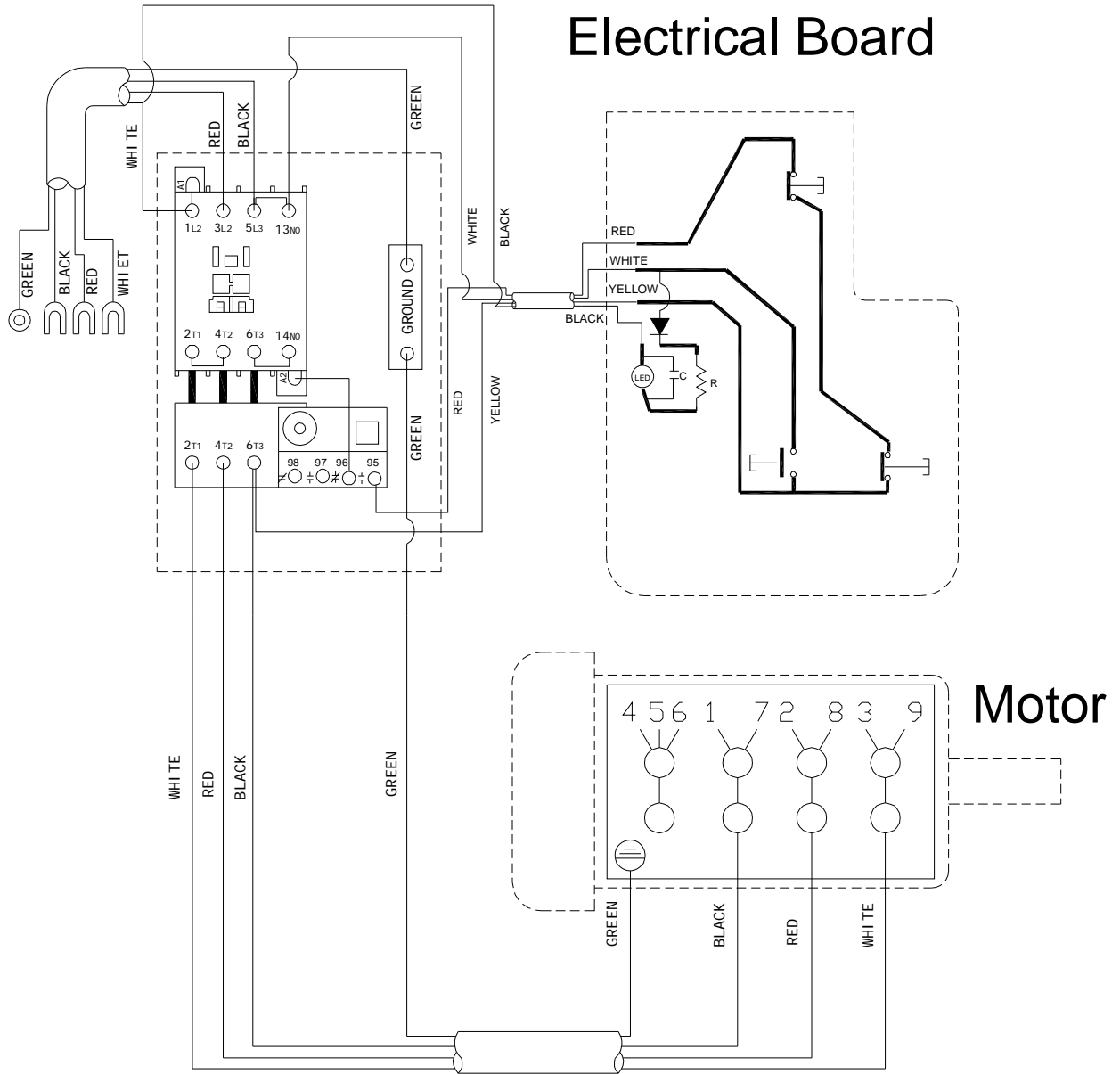
# Electrical Board



5HP, 230V, 3Phase

# Magnetic Switch

# Electrical Board

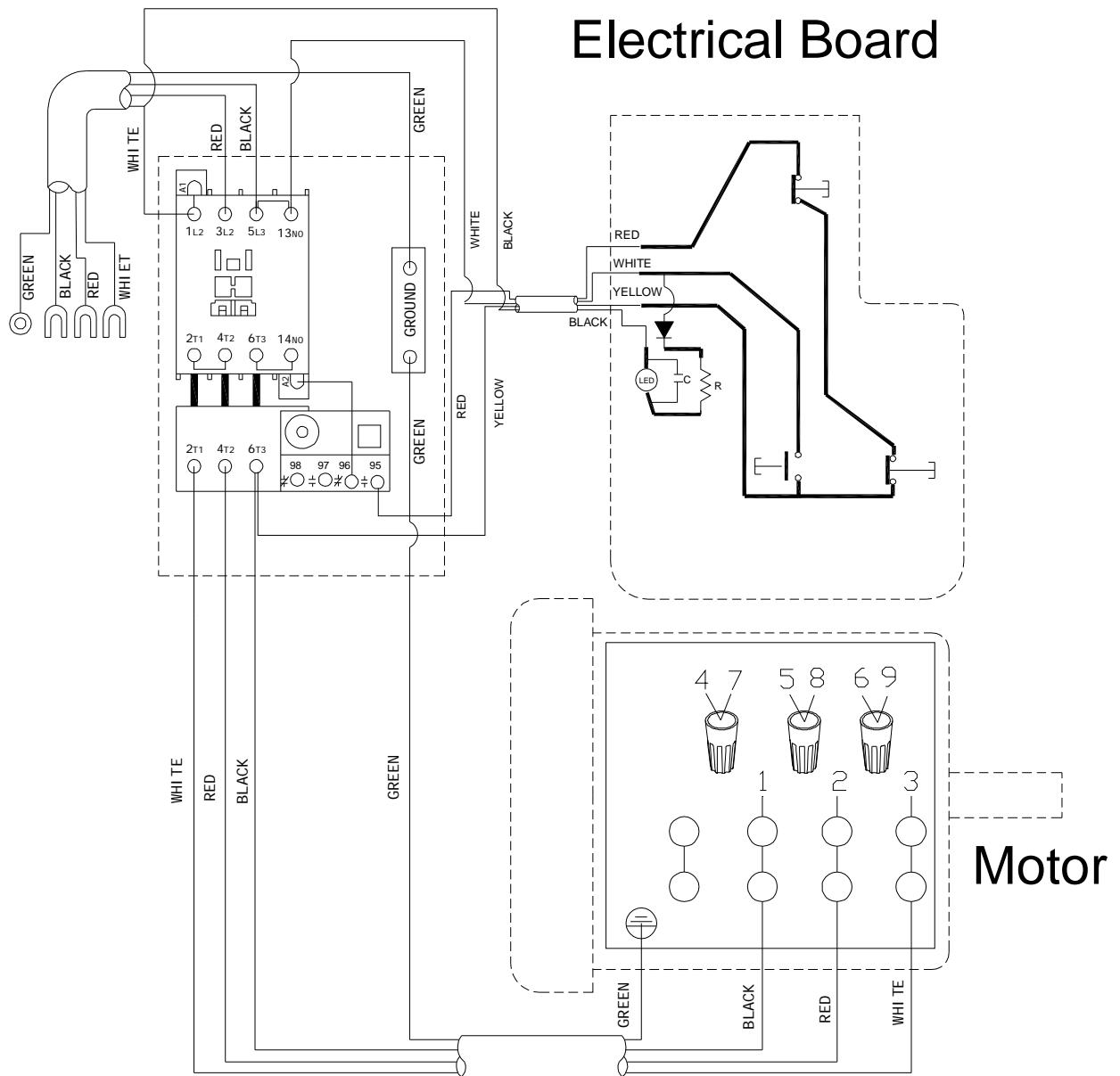




# 5HP, 460V, 3Phase

## Magnetic Switch

## Electrical Board



# Notes





427 New Sanford Road  
LaVergne, Tennessee 37086  
Phone: 800-274-6848  
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