

# INSTRUCTION MANUAL

## ST-254T Sliding Table 1500mm



**W487**

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# SLIDING TABLE

MODEL NO.:ST-254T

Instruction and spare parts Manual

*For your safety, please read this manual carefully before operation*

**SLIDING TABLE ASSEMBLY TO SUIT HAFCO ST-254 SAW BENCH**

**1-9-14**

The following instructions are for the assembly and set up to fit this sliding table to a Hafco W486 ST-254 Saw Bench that has first been assembled as per its Hafco instructions "SET UP #2" with both cast extension tables fitted on the right hand side of machine as shown below.



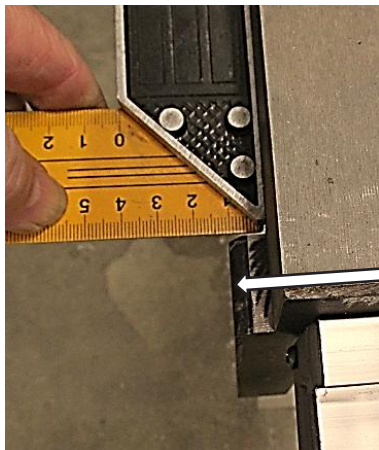
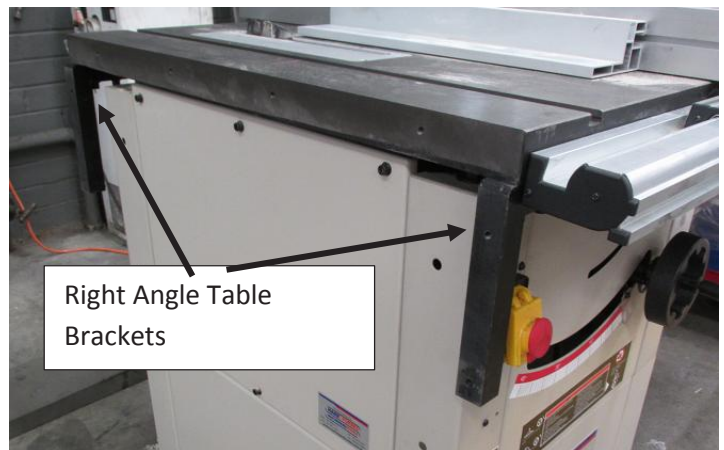
**ASSEMBLY INSTRUCTIONS**

**# Fitting Sliding table Rail and table**

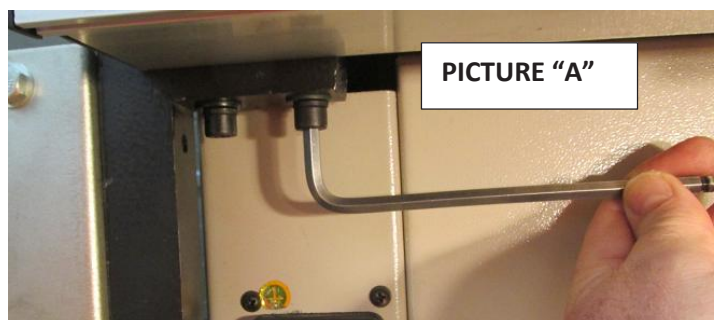
- # Ensure the machine is **UNPLUGGED** and isolated from its Power source.
- # A second person will be needed to help assemble rail onto machine.
- # Lower Blade all the way down.

**# Fitting Sliding table rail**

Attach the 2off, "Right Angle Table brackets" as shown to the underside of the left hand side of the main table, (Picture "A") Using 2 off, M8 x 50mm long Socket head cap screws with flat washers and a lock washer on each



Set the brackets both protruding 10mm out from the front table edge before tightening the 4 bolts.



# Mount the 2 off pressed metal rail hanging brackets to them, using 4 off M8 x 20mm long Socket Head Cap Screws and flat washers provided Tighten all bolts well.



# Fit the 2 off, pressed metal Quick mount hanger brackets with the Black plastic wing nuts facing into each other, onto the hanging brackets on the machine as shown.



Undo the Adjustment Lock Bolts and Leave the Hanger Lock Nut Loose for the moment (See Picture "B")

# With the assistance of a second person, fit the sliding table rail onto the of hanging bracket assemblies,

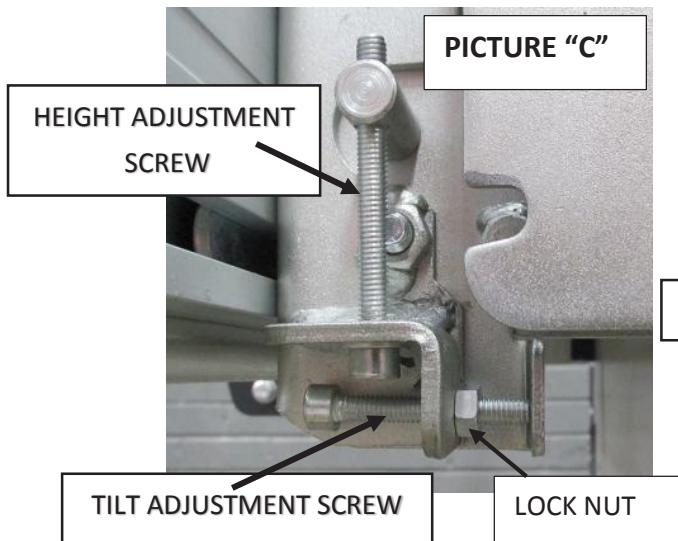
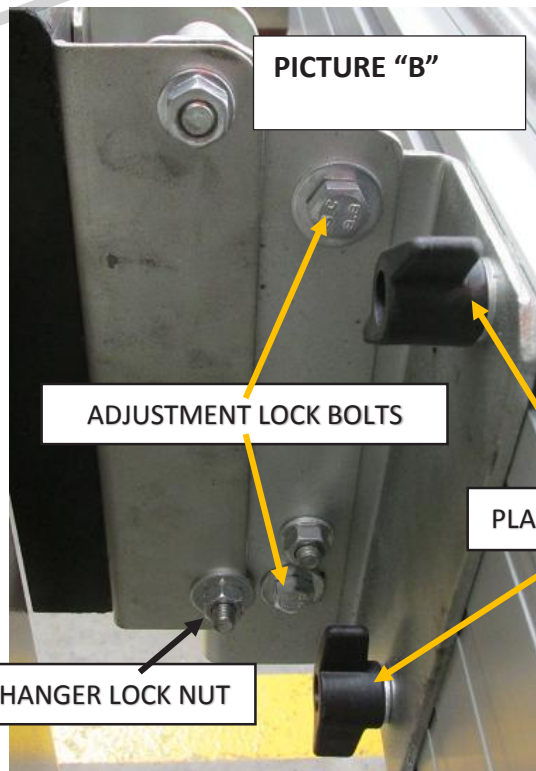
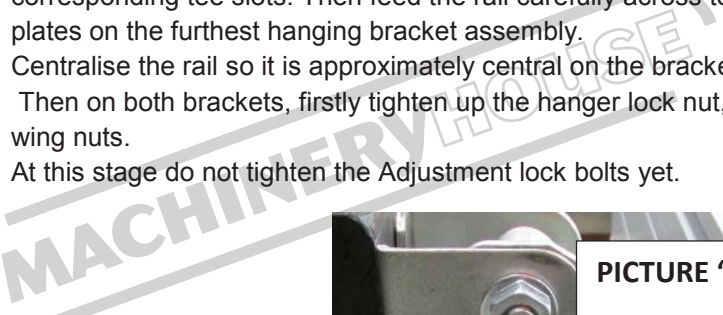
First introducing the tee slot plates of the brackets into one end of the rails corresponding tee slots. Then feed the rail carefully across to the other set of tee slot plates on the furthest hanging bracket assembly. Centralise the rail so it is approximately central on the brackets.

Then on both brackets, firstly tighten up the hanger lock nut, then tighten the Plastic wing nuts.

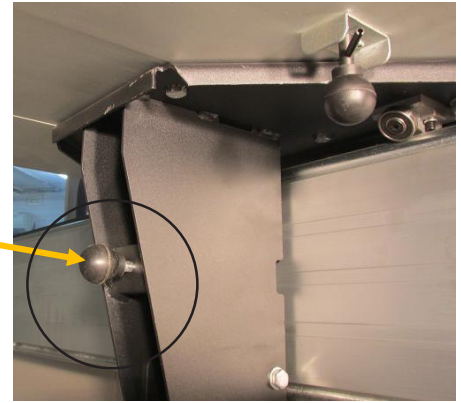
At this stage do not tighten the Adjustment lock bolts yet.



At this stage do not tighten the Adjustment lock bolts yet.



# The Sliding Table assembly can now be put onto the rails  
 To do this, firstly pull and lock out the spring loaded table stop under the sliding table.



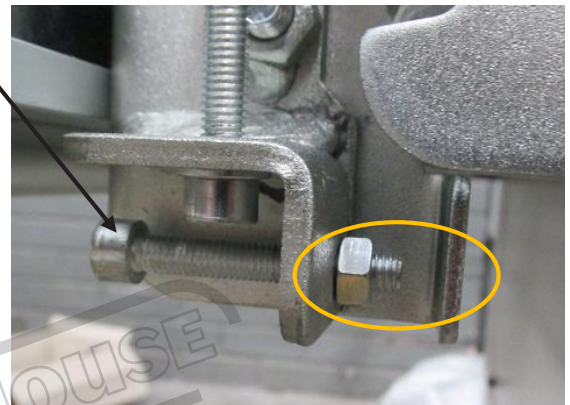
Hold the Sliding table up the correct way and introduces the front top set of top table bearings onto the top rail bar, feed the table on and while doing this, align the bottom set of table bearings to go under the bottom rail bar, Continue to slide table on, aligning the back set of top bearings onto the top rail bar as it comes towards them.

Push table further on and then pull and unlock the spring loaded table stop, allowing it to go in, so as to stop table from now being slid off the rails.

Check its operation carefully, sliding table to each end of the rails to hit rubber stops each end.

**# Sliding Table Adjustments**

# On each hanging bracket assembly, check the tilt adjustment screw is backed off and not touching the bracket on the other side.



With a soft hammer, just above each bracket. Give the sliding rail top rod a light tap a few times, This will help to loosen the parts to drop them home in their adjustment slots, This will assist future adjustment and or removal and replacement of the

sliding rail assembly on the hanger brackets to be correctly put back in place as set.

# Tighten up the 2 adjusting lock bolts and the Hanger Lock Nuts. (Picture "B")



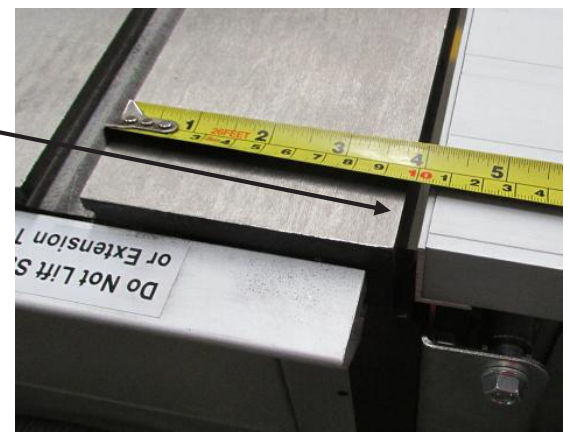
**# Adjust sliding table movement parallel to blade**

Measure the distance from the front edge of the sliding table to the mitre slot in the saw bench table as shown.

Firstly, with sliding table at the front edge of the saw bench. Then with the sliding table at the back edge of the sliding table. Using the same reference point on the sliding table each time (Say the front corner edge!)

These two measurements need to be the same to ensure the sliding table slides in line with the blade cut.

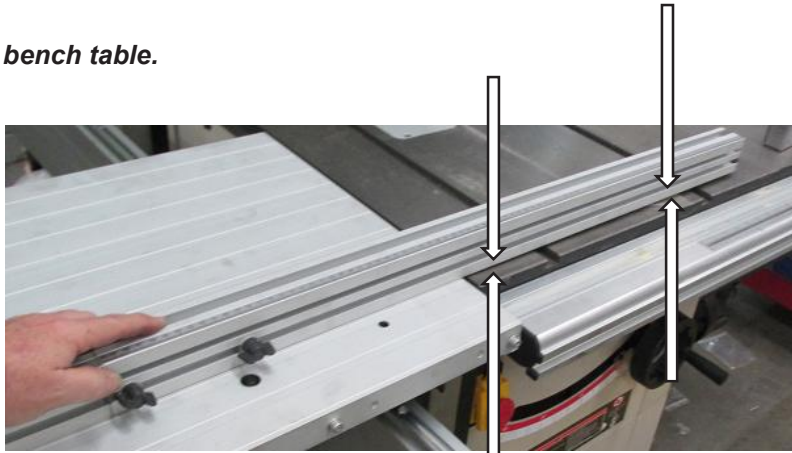
Adjust as needed by loosening off the screws holding one of the right angle table hanger brackets on. (PICTURE "A") Tap the bracket in or out as needed, then tighten the screws and recheck measurements. One or both brackets may need adjusting. The closer the sliding table is to the fixed table the better. Re-adjust as needed until correct.



*(This may have to be rechecked and reset after further below adjustments are done)*

**# Adjust sliding table top surface parallel to Saw bench table.**

Firstly loosen the 2 Adjustment Lock Bolts (Picture "B") off both hanging bracket assemblies. Screw in the Tilt Adjustment Screws (Picture "C") of each bracket to just touch the bracket. Using the sliding table fence as a straight edge. Hold the fence flat on the sliding table with the sliding table over one of the rail hanging brackets with fence also hanging over the saw bench table as shown

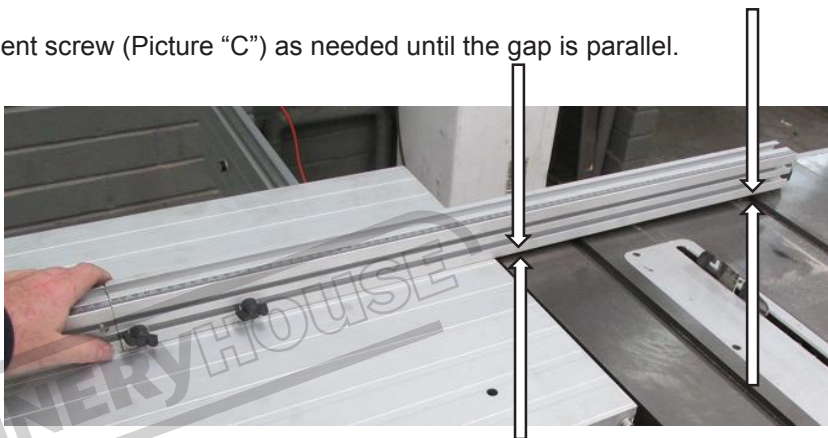


The gap between the fence overhanging the table and the table top needs to be the same from the front of table to the end of straight edge (to be parallel)

If the fence is rubbing on the saw bench table the sliding table is too low to get a gap. You will need to raise the sliding table up first (See "Sliding table height adjustment instructions" below)

To adjust the gap parallel, screw in the tilt adjustment screw (Picture "C") as needed until the gap is parallel.

Then slide the table and fence over the other hanger bracket assembly and repeat the adjustment if needed.



When both are OK, Tighten the Adjustment Lock Bolts and the lock nuts of the tilt adjustment screws on each hanger assembly. (See Picture "C")

*(This may have to be rechecked and reset after further below adjustments are done)*

**# Sliding table Height Adjustment.**

The Height the sliding table needs to be above the table is generally around 0.5mm although this adjustment can vary depending on the user and material being cut

Use the fence sitting on Sliding table as per the above 2 Pictures to see the gap as adjusted.

To adjust the height of the sliding table, firstly loosen the 2 adjustment lock bolts on both hanging bracket assemblies (See Picture "B")

The height of the sliding table can be adjusted by turning the Height adjustment screw. (See Picture "C") Turning the screw Anti-Clockwise looking from the top lifts the sliding table UP! Turning it Anti-clockwise looking from the top drops the sliding table down

A light tap of the sliding rail with a soft hammer may be needed to help it adjust as the screw is turned.

(See Picture "D")

When the correct table height is set on one side repeat the setting on the other hanger bracket.

NB: while adjusting the height of the table the angle tilt can also be affected so correct this at the same time if needed (see *Adjust sliding table top surface parallel to Saw bench table.*)

*(This may have to be rechecked and reset after further below adjustments are done)*

# Recheck all adjustments are still correct and re-adjust were needed until set as needed.....

**# Setting Position of Sliding table Travel**

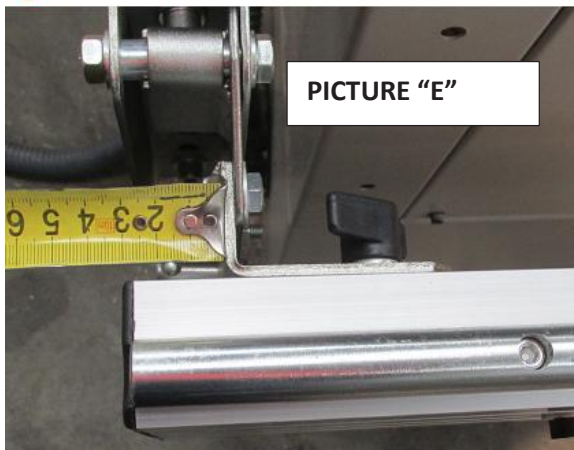
At this Point the machine should be moved to its final Position if not already there.

# Fit the outrigger leg to the rear of the Sliding Rail at the front of the saw bench as shown with its rubber foot up off the ground.

Firstly assemble the tee plates onto the leg assembly then slide the plates into the rear tee slots in the rail extrusion and slide the leg assembly about 100mm in from the end of the rail then tighten the dome nuts.

Fit the black plastic caps into each end of the rail. They will have to be encouraged in with the use of a soft hammer. Be careful to only hit the plastic over the tight bits, or it can be easily broken if the ends of the plastic are hit.

The Sliding rail can now be "pulled out" Unlock the 4off Plastic Wing Nuts that secure it to the hanging brackets (See Picture "B") Pull the rail sideways to the Right to the position you require it. To get full travel (1480mm) leave 30mm at the left hand side (See picture "E") Before locking the Plastic Wing Nuts! First push down on the left Hand Side of the rail to ensure the hanger is sitting correctly and then at the same time tighten the Plastic Wing Nuts.

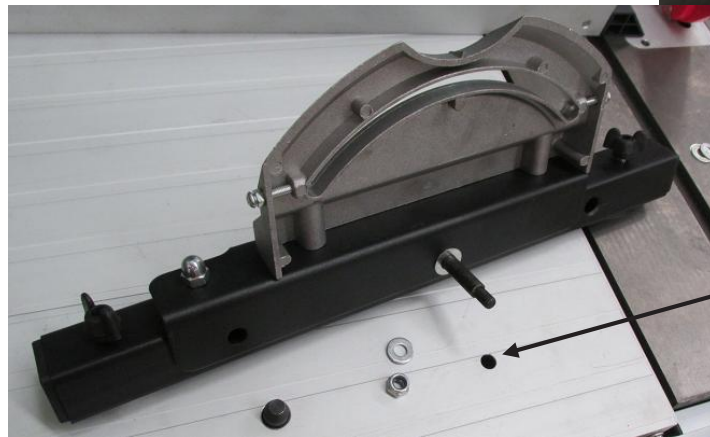
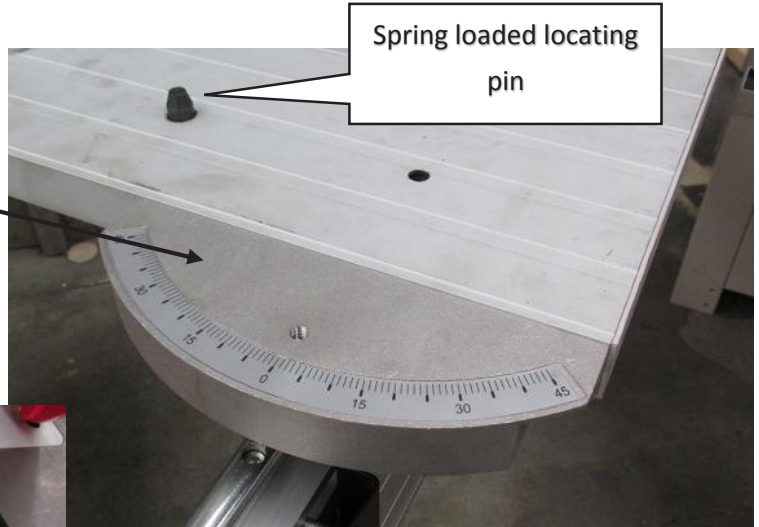


# You can now lower the outrigger Leg and adjust the rubber foot tightly to take the load.

### # Fixing fence to sliding table

Firstly fit lower quadrant to the sliding table.  
Noting it is adjustable left and right.  
Just nip us screws for now.

Pull down the mitre fence spring loaded locating pin and turn it 90 degrees to lock it down.

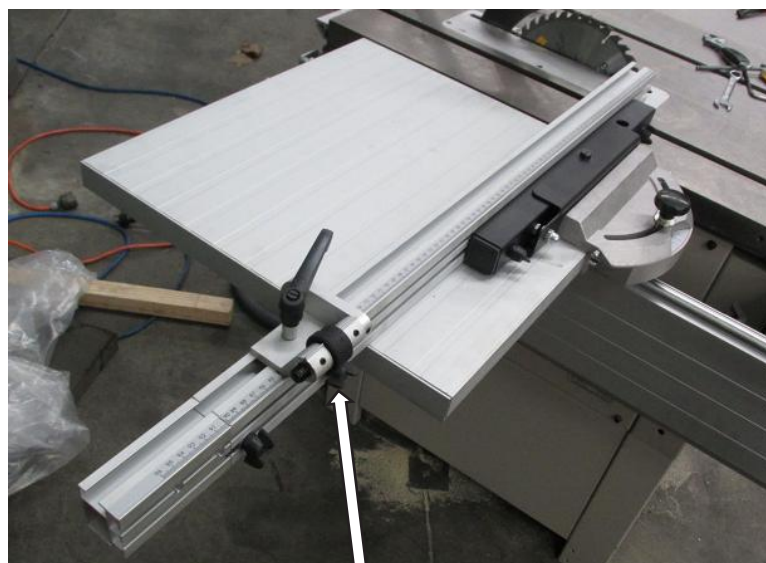


Slide the table all the way to the front of the Sliding rail.  
Fit the mitre fence assembly to the sliding table.  
Firstly put the supplied shims in the pivot pin and then insert pin into hole in table.  
The pin is a good fit and it must be all the way through before the lower Washer and then Locknut is fitted and tightened enough to still allow the fence to pivot on the Pivot Pin. Do not force the pin through.



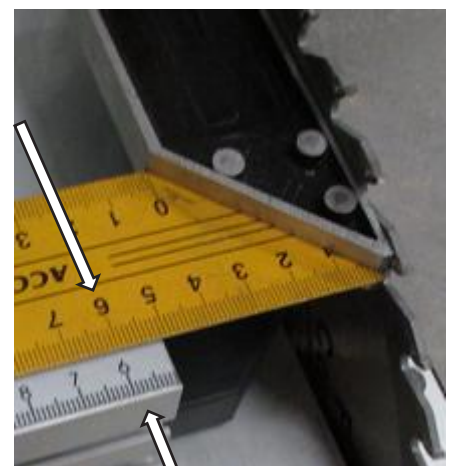
Release the mitre fence spring loaded pin so it locates up into the hole in the mitre fence.  
The lower Quadrant can now be adjusted to align the "0" mark

When this is done the plastic lock knob can be put back in and tightened.  
Ensuring machine is unplugged  
Carefully wind blade all the way up  
**## Caution of Sharp Teeth! ##**



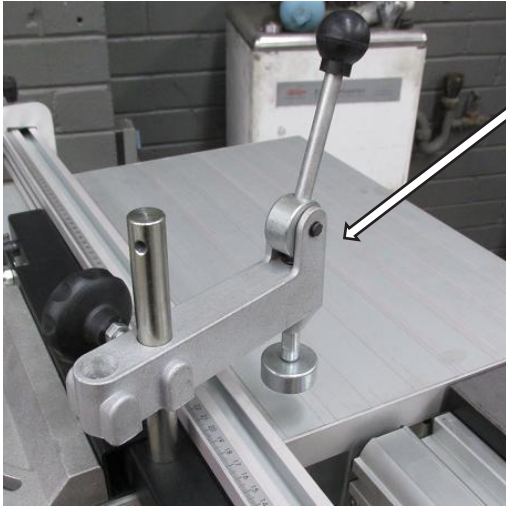
# Slide the flip over work stop onto the fence.

With a rule square (or similar) up against the Mitre fence and the blade as shown below, set the measurement of the fence in the correct place corresponding that on the rule



# Fit the work clamp post to the hole in the right hand side of the mitre fence assembly (note hole it top to tighten it)

Fit work clamp to post



Your Hafco Sliding table should now be ready to use.

# After the final set up and a test cut is done.

The squareness of the cut can be fine adjusted by adjusting the angle Stop on the mitre fence assembly.

Take a test Cut and check with a good quality Square.  
If needed.

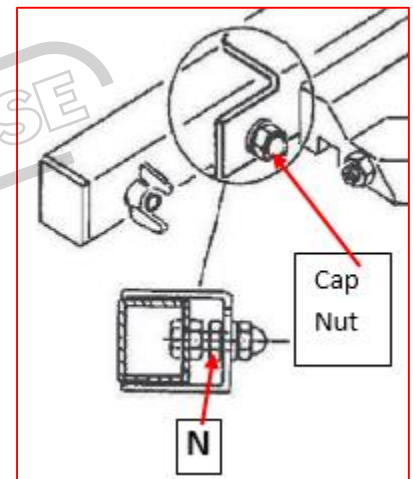
Loosen the cap nut to make the necessary correction.

Adjust Nut ("N") as needed.

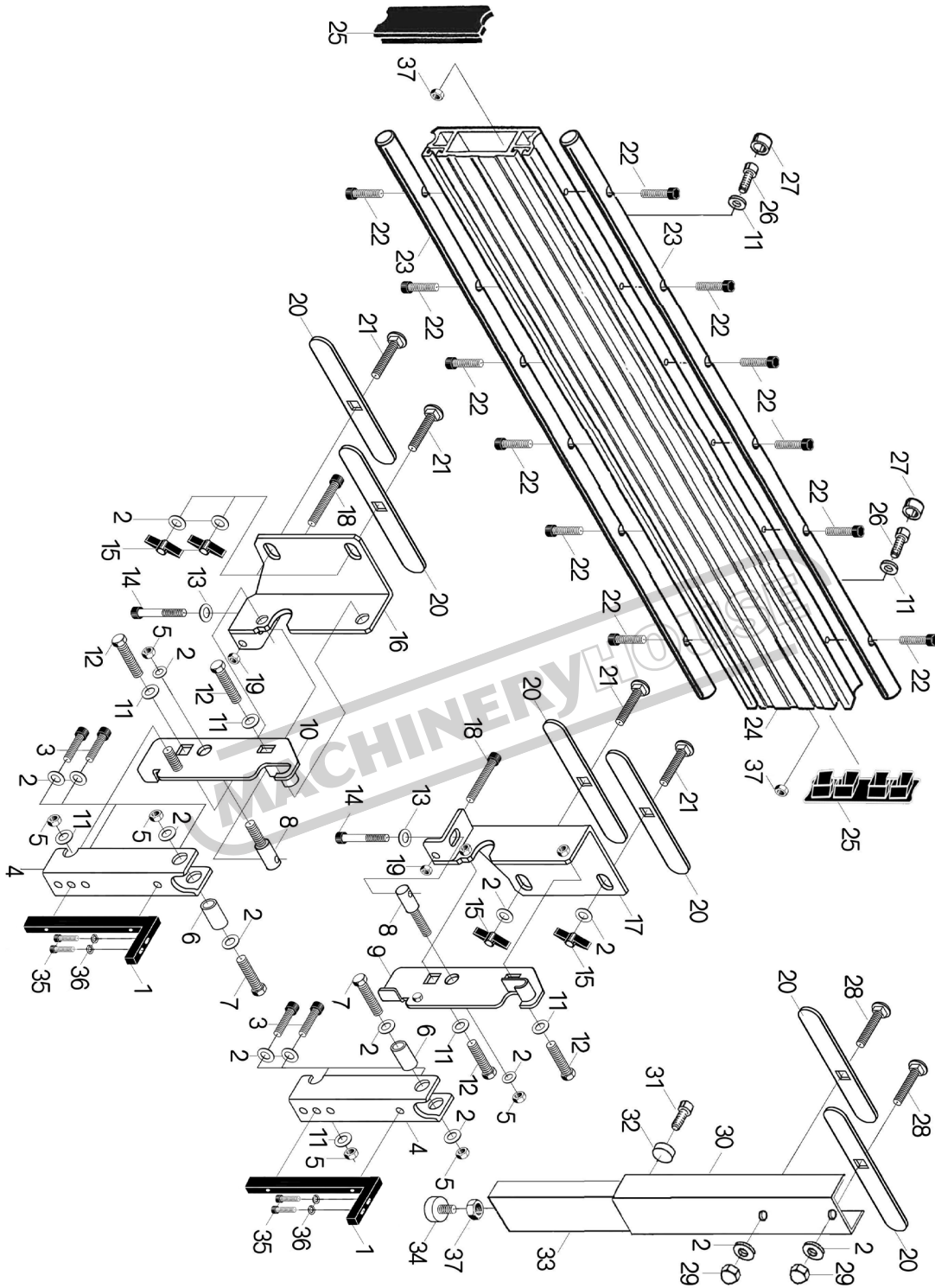
Tighten the cap nut again and make a further test cut .

Repeat the correction procedure as necessary.

Reset the lower quadrant "0" if needed.



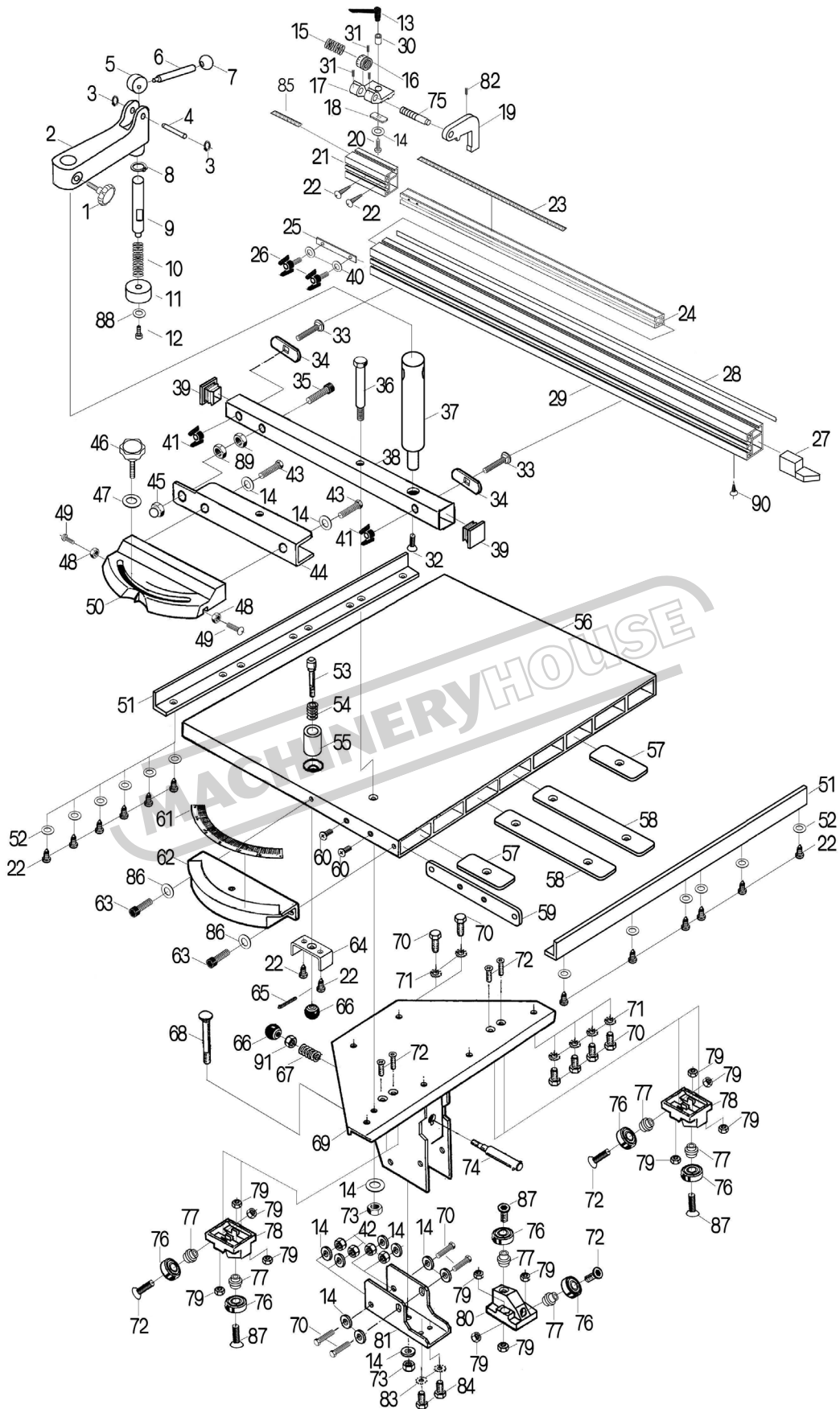
# DIAGRAM F



## PARTS LIST—PART F

NO.	DESCRIPTION	Q'TY
F-1	RAIL BRACKET	2
F-2	WASHER 8	16
F-3	INNER HEX. SCREW M8×16	4
F-4	MOUNTING BRACKET	2
F-5	HEX.NUT M8	6
F-6	SPACER OF MOUNTING BRACKET	2
F-7	HEX.BOLT M8X50	2
F-8	ADJUSTING NUT	2
F-9	MOUNTING BRACKET 2 OF SLIDING TABLE	1
F-10	MOUNTING BRACKET1 OF SLIDING TABLE	1
F-11	WASHER 8	8
F-12	HEX.BOLT M8X20	4
F-13	WASHER 6	2
F-14	INNER HEX.SOCKET CAP HEAD SCREW M6×65	2
F-15	WING SHAPE NUT	4
F-16	MOUNTING BRACKET3 OF SLIDING TABLE	1
F-17	MOUNTING BRACKET4 OF SLIDING TABLE	1
F-18	INNER HEX.SOCKET CAP HEAD SCREW M6×40	2
F-19	HEX.NUT M6	2
F-20	STEP BOLT PAD	6
F-21	STEP BOLT M8X25	4
F-22	INNER HEX.SOCKET CAP HEAD SCREW M6×20	12
F-23	SLIDING TABLE RAIL	2
F-24	SLIDING RAIL	1
F-25	END CAP,SLIDING RAIL	2
F-26	INNER HEX.SOCKET CAP HEAD SCREW M8×20	2
F-27	RUBBER BUSHING	2
F-28	STEP BOLT M8X40	2
F-29	HEX.CAP NUT M8	2
F-30	UPPER CONNECTION,SUPPORT LEG	1
F-31	INNER HEX.SOCKET CAP HEAD SCREW M8×25	1
F-32	SCREW PAD	1
F-33	LOWER CONNECTION,SUPPORT LEG	1
F-34	FINE ADJUSTING DISC	1
F-35	INNER HEX.SOCKET CAP HEAD SCREW M8×45	4
F-36	WASHER 8	4
F-37	HEX.NUT M8	3

# DIAGRAM G



NO.	DESCRIPTION	Q'TY
G-1	KNURL BOLTM8×20	1
	HEX.BOLT M8×30	1
	HEX. NUT M8	1
G-2	CLAMPING BRACKET	1
G-3	RETAINING RING d=8	2
G-4	ECCENTRIC SHAFT	1
G-5	ECCENTRIC BLOCK	1
G-6	ECCENTRIC BAR	1
G-7	KNOB FOR BAR	1
G-8	RETAINING RING d=12	1
G-9	CLAMPING BLOCK SHAFT	1
G-10	CLAMPING BLOCK SPRING	1
G-11	CLAMPING BLOCK	1
G-12	HEX. SCREW M5×12	1
G-13	ADJUSTMENT HANDLE	1
	SPRING FOR ADJUSTING HANDLE	1
	SCREW FOR ADJUSTMENT HANDLE	1
	GEAR FOR ADJUSTMENT HANDLE	1
G-14	8MM WASHER	13
G-15	SPRING FOR MICRO ADJUSTMENT WHEEL	1
G-16	MICRO ADJUSTMENT WHEEL	1
G-17	BASE OF MOVABLE FLAPPER	1
G-18	CLAMPING WAHSER FOR BASE	1
G-19	MOVABLE FLAPPER	1
G-20	CARRIAGE BOLT M6×35	1
G-21	EXTENSION SQUARE BAR BASE	1
G-22	SELF-TAPPING SCREW ST3.5×10	16
G-23	SCALE FOR EXTENSION SQUARE BAR	1
G-24	EXTENSION SQUARE BAR	1
G-25	FIXING PLATE FOR SQUARE BAR	1
G-26	BUTTERFLY NYLON BOLT M6×25	2
G-27	END STOP OF GUIDE	1
G-28	SCALE FOR GUIDE	1

**PARTS LIST—PART G (2)**

NO.	DESCRIPTION	Q'TY
G-29	GUIDER	1
G-30	SLEEVE	1
G-31	INNER HEX. SCREW M5×6	3
G-32	INNER HEX. SCREW M8×20	1
G-33	CARRIAGE BOLT M6×50	2
G-34	FIXING WASHER FOR GUIDER	2
G-35	INNER HEX. SCREW M8×25	1
G-36	SCREW	1
G-37	COLUMN	1
G-38	SQUARE TUBE	1
G-39	END CAP FOR TUBE	2
G-40	WASHER 6MM	2
G-41	BUTTERFLY NUT M6	2
G-42	HEX. NUT M8	4
G-43	HEX. BOLT M8×12	2
G-44	U-BAR FOR GUIDER	1
G-45	NUT M8	1
G-46	KNURL SCREW FOR SCALE LOCKING	1
	HEX. BOLT M8×35	1
	HEX. NUT M8	1
G-47	WASHER 8MM	1
G-48	HEX. NUT M5	2
G-49	SCREW M5×30	2
G-50	MITER GAUGE	1
G-51	ANGLE AL.	2
G-52	WASHER 4MM	12
G-53	FIXING SHAFT	1
G-54	SLEEVE FOR FIXING SHAFT	1
G-55	FIXING SLEEVE	1
G-56	SLIDING TABLE	3
G-57	SHORT FIXING PLATE	2

**PARTS LIST—PART G (3)**

NOF	DESCRIPTION	Q'TY
G-58	LONGER FIXING PLATE	2
G-59	FIXING PLATE FOR TRUNNION	1
G-60	SCREW M4×10	2
G-61	SCALE FOR TRUNNION	1
G-62	TRUNNION	1
G-63	INNER HEXFSCREW M6×16	2
G-64	BRACKET FOR FIXING SHAFT	1
G-65	SPRING PIN $\phi$ 4×35	1
G-66	KNOB	2
G-67	SPRING FOR STOP SHAFT	1
G-68	CARRIAGE BOLT M8×90	1
G-69	TABLE BRACKET A	1
G-70	HEXFBOLT M8×20	10
G-71	STAR WASHER 8MM	6
G-72	INNER HEXFSCREW M6×22	7
G-73	LOCKING NUT M8	2
G-74	STOP SHAFT	1
G-75	MOVABLE FLAPPER SHAFT	1
G-76	BALL BEARING 6100-2RS	6
G-77	SPACER	6
G-78	UPPER BEARING BLOCK	2
G-79	LOCKING NUT M6	12
G-80	LOWER BEARING BLOCK	1
G-81	BEARING ADJUSTING BLOCK	1
G-82	SPRING PIN $\phi$ 3×10	1
G-83	STAR WASHER 6MM	2
G-84	HEXFBOLT M6×20	2
G-85	EXTENSION SCALE	1
G-86	WASHER 6MM	2
G-87	INNER HEXFSCREW M6×25	3
G-88	WASHER 5MM	1
G-89	HEXFTHIN NUT M8	2
G-90	SELF-TAPPING SCREW ST4×13	1
G-91	HEXFTHINNUT M8	1