



OWNER'S MANUAL



B524WF 10" TILTING ARBOR TABLE SAW



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Introduction

As part of the growing line of Craftex woodworking equipment, we are proud to offer the B524WF 10" Cabinet Table Saw. The Craftex name guarantees *Craft Excellence*. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The B524WF is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

FEATURES

- ❑ Large cast iron table with "T" mitre slots.
- ❑ 5/8" tilting arbour with sealed bearings.
- ❑ Triple 'V' belt drive.
- ❑ Cast Iron trunions and worm gear.
- ❑ 3 HP, 220v enclosed motor.
- ❑ Magnetic start switch.
- ❑ See-through guard, splitter and anti-kickback pawls.
- ❑ Full cabinet with 4" dust chute.
- ❑ Large blade height and bevel hand wheels.
- ❑ 'T' slot mitre gauge.

SPECIFICATIONS

- ❑ Table Size (with extensions) – 27" x 36"
- ❑ Saw Height – 34 1/4"
- ❑ Motor – 3 HP. Single Phase, 220 volts, 3450 RPM
- ❑ Shipping Weight – 500 lbs.
- ❑ Maximum Cut @ 90 Degrees – 3"
- ❑ Maximum Cut @ 45 Degrees – 2 1/8"
- ❑ Magnetic Safety On/Off Switch
- ❑ Cast Iron Table Top & Extensions
- ❑ Blade Guard and Anti-Kickback Pawls
- ❑ Compatible To Most After-Market Rip Fences
- ❑ 4" Dust Chute

GENERAL SAFETY INSTRUCTIONS

EXTREME CAUTION SHOULD BE USED IN OPERATING ALL POWER TOOLS. KNOW YOUR POWER TOOL, BE FAMILIAR WITH ITS OPERATION. READ THE OWNER'S MANUAL AND PRACTICE SAFE USAGE PROCEDURES AT ALL TIMES.

- ❑ **CONNECT** your machine **ONLY** to the matched and specified power source.
- ❑ **WEAR SAFETY GLASSES, RESPIRATORS, HEARING PROTECTION** and **SAFETY SHOES** when operating this machine.
- ❑ **DO NOT** wear loose clothing or jewellery when operating machinery.
- ❑ **A Safe Environment is important.** Keep the area free of dust, dirt and other debris in the immediate vicinity of the machine.
- ❑ **BE ALERT!** Do Not Use prescription or other drugs that may affect your ability or judgement to safely use this machine.
- ❑ **DISCONNECT** the power source when changing blades or making other adjustments or repairs.
- ❑ **DO NOT** force tool. Tools work best when allowed to perform at their own speed and pace.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **NEVER** reach over the table when the tool is in operation.
- ❑ **NEVER** make crosscuts with the rip fence in place.
- ❑ **NEVER** attempt cut material that is warped or twisted.
- ❑ **NEVER** stand or lean on tool
- ❑ **ALWAYS** keep blades, knives or bits sharp and properly aligned.
- ❑ **ALWAYS** keep all safety guards in place and ensure their proper function.
- ❑ **ALWAYS** use push sticks and featherboards to safely feed your work through the machine.
- ❑ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❑ **ALWAYS** secure your work with the appropriate clamps or vises.
- ❑ **ALWAYS** keep bystanders safely away while operating machinery.
- ❑ **THINK SAFETY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

Package Contents

YOUR B524WF TILTING ARBOR CABINET SAW SHIPPING CRATE CONTAINS THE FOLLOWING ASSEMBLY TOOLS AND TABLE SAW COMPONENTS:

1 - Hand Wheel Handle

1 - Splitter/Blade Guard Bracket

1 - Arbor Lock Wrench

1 - Blade Nut Wrench

1 - 5/8" Wrench

1 - 12mm/14mm Wrench

2 - Allen Keys

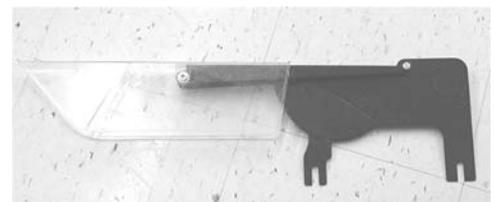


2 - 8" x 27" Cast Iron Extension Tables

1 - Mitre Gauge



1 - Blade Guard/Splitter/Safety Pawl Assembly



ASSEMBLY

1. Carefully open the crate and remove the carton containing the assembly components and all other packaged parts and set aside.
2. Remove the plastic covering and set aside the cast iron extension tables found on top of the saw table.
3. The protective lubricant on the cast iron extension tables, saw tabletop and other parts can be removed with mineral spirits and it is recommended that a coat of paste wax be applied to the tabletop surfaces. Be sure to clean the mitre gauge 'T' slots as well.

Extension Tables

4. Mount the extension tables to the saw with the nuts, bolts and lock washers supplied. These will be found already inserted in the appropriate holes on the sides of the saw tabletop. Use a straight edge to ensure that the extensions are level with the saw table.

Blade Guard/Rear Splitter

5. Place the rear splitter support (the round steel rod) into the hole in the rear of the saw frame and tighten the nut securely.
6. Place the block (bracket) for the splitter support on the support rod but **Do Not Tighten**.
7. Place the splitter in front and rear support blocks and tighten. A straight edge should be used to align both the front and rear of the splitter with the saw blade.
8. Tighten the block on the support rod at this time.

Magnetic On/Off Switch

9. Mount the magnetic on/off switch on the right side of the saw frame with the screws provided.

The power required for the B524WF saw is 220 volts, 20 amps, single phase and it is suggested that the saw be connected to a dedicated power outlet. The cable from the switch to the power supply is not provided. The magnetic power on/off switch is provided with a thermal relay. Overheating will cause the relay to shut off and will require three or more minutes to reset.



Operation And Adjustments

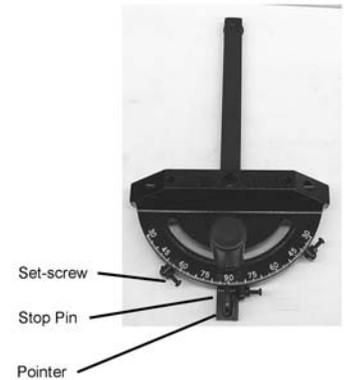
Mitre Gauge

The mitre gauge supplied with the table saw has adjustable index stops at 90 degrees and at 45 degrees both left and right. To select different angles simply loosen the lock-knob, pull out the stop and rotate the gauge to where you want to position it and then tighten the knob.

To ensure that the mitre gauge is accurate, place the gauge upside down in the mitre slot and hold it against the saw table edge. If there is any space between the gauge and the table edge it means that your gauge index pointer is not set correctly. Loosen the knob and while pressing the gauge tight against the table edge, re-tighten the knob. Remove the gauge from the slot and using an allen key, turn the stop set-screw to set the pointer to the 90 degree mark. The pointer is now accurate.

Loosen the lock-knob and rotate the gauge clockwise to the 45-degree mark and turn the stop setscrew until the pointer is at the 45-degree line. Repeat the procedure at the other 45-degree indicator.

Note: the stop pin should be to the left of the stop.



Blade Raising

To raise or lower the saw blade on the B524WF loosen the lock knob in the centre of the blade raising hand wheel. Rotate the wheel until the saw blade is at the desired height and tighten the lock knob. Better cuts can be made if the blade is 1/8" to 1/4" above the surface of the material to be cut.



Blade Tilting

To tilt the blade, loosen the lock knob in the centre of the blade tilting hand wheel and rotate the wheel to the desired angle as indicated on the angle pointer. Positive stops are set at both 90 and 45 degrees. A combination square should be used to verify the accuracy of the angle when set at 90 degrees. Set screws allow for any adjustments to be made and lock nuts secure the setting.



Blade Installation

CAUTION – Disconnect the saw from the power source. Failure to do so may result in serious injury.

- 1 – Fully raise the blade arbor, and tighten the lock knob in a clockwise direction.
- 2 – Remove the arbor nut and flange.
- 3 – Choose your desired blade, (be careful when handling saw blades) and place it on the arbor shaft. Make sure the teeth are pointing down towards you. Replace the arbor nut and flange and tighten fully.
- 4 – TEST. For precautionary measures, take a piece of thin scrap wood and place it in the blade's teeth. Hold this piece of wood in the same manner as you would if you were cutting, to ensure that when the blade turns or if the piece of wood slips, your hand will not come into contact with the blade.

To remove the blade, reverse the above procedure. Remember, when performing any interior saw operations, ALWAYS disconnect the saw from the power source.

Sawdust Collection

Your B524WF is equipped with a 4" male dust chute to accommodate fittings for a Craftex (or other) sawdust collection systems. This will remove most of the sawdust created in normal saw operations. You should, as a routine maintenance procedure; regularly vacuum the interior of the table saw housing paying particular attention to the motor. Removing sawdust will extend the life of the saw and its moving parts.



Cross Cutting Operation

The mitre gauge must always be used to position the work when crosscutting. (**NEVER CUT FREE HAND**) Place the mitre gauge against the work piece and move the two together towards the saw blade. Either T-Slot on the table may be used depending on individual preference and which side has clearance when bevel cutting. Hold the work firmly against the mitre gauge and table and start to cut slowly. **DO NOT** attempt to remove the cut off piece while the saw is still running.

NEVER use the fence as a cut off gauge when cross cutting.

An auxiliary wooden facing may be fastened to the front of the mitre gauge using two wood screws through the slots in the mitre gauge body. This auxiliary facing should be at least 1 inch higher than the maximum depth of cut. The facing may extend on both sides of the mitre gauge when making cuts, which do not extend all the way through the stock. (eg. Dados) and the guard and splitter are removed.

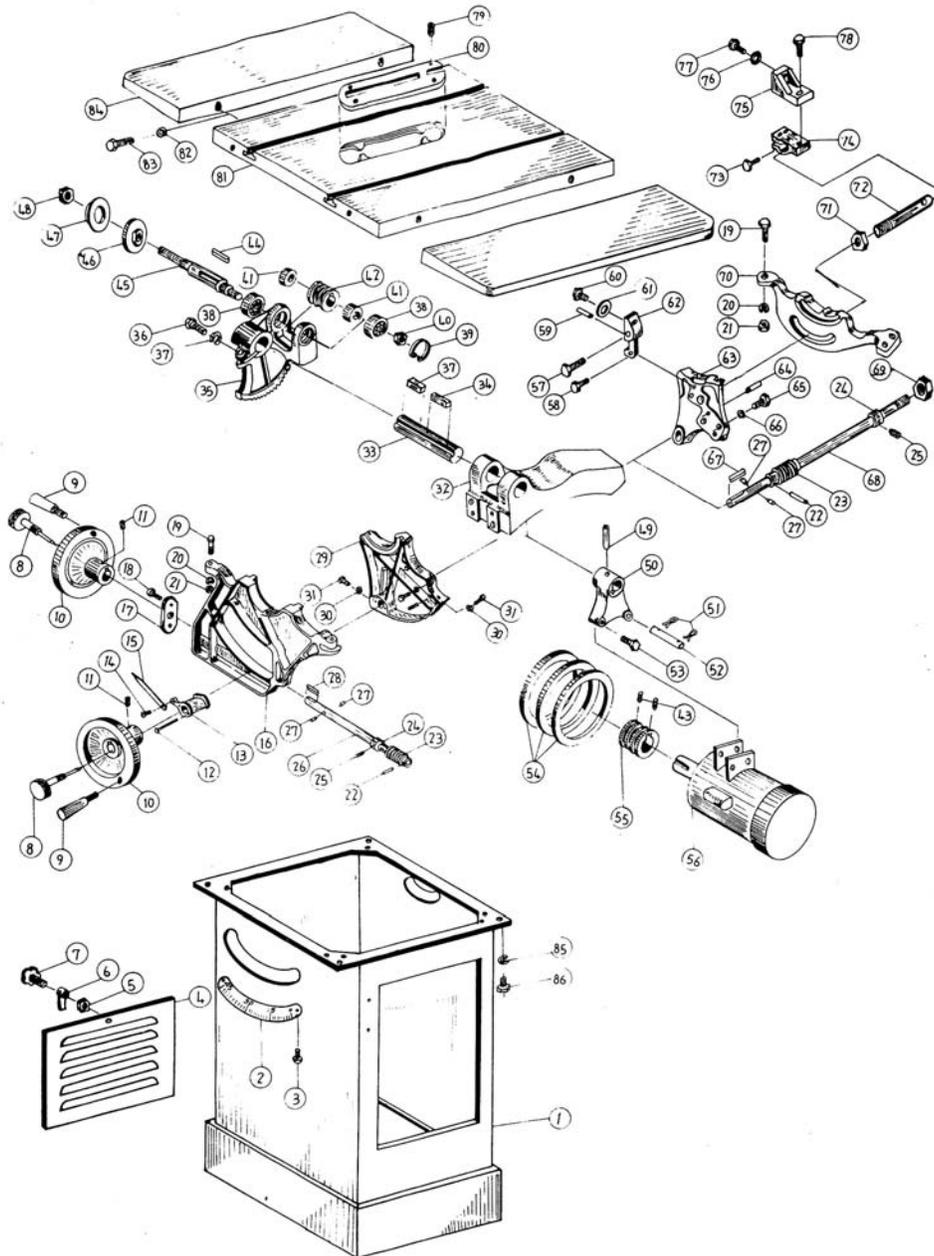
Ripping Operation

Ripping is the operation of making a lengthways cut through a board.

The rip fence serves to support and guides the work. The surface in contact with the table should be flat and the edge along the fence should be straight. The guards, with its splitter and anti-kick back pawls prevent the saw kerf from binding the blade and kicking back. Use the guard on all through cuts. The fence may be used on either side of the blade, but the scale is only useful when the fence is on the right hand side.

Start the saw and stand to one side of the line of the saw cut. Holding your work piece with both hands against the table and fence, slowly push towards the saw blade. Continue to feed with one or two hands until the work is beyond the saw blade and anti-kick back pawls. **DO NOT** allow the work piece to come forward past the moving blade for removal. If the work that is being ripped is less than 3” wide, a push stick should be used to complete the feed.

SCHEMATIC DIAGRAM B524WF TILTING ARBOR TABLE SAW

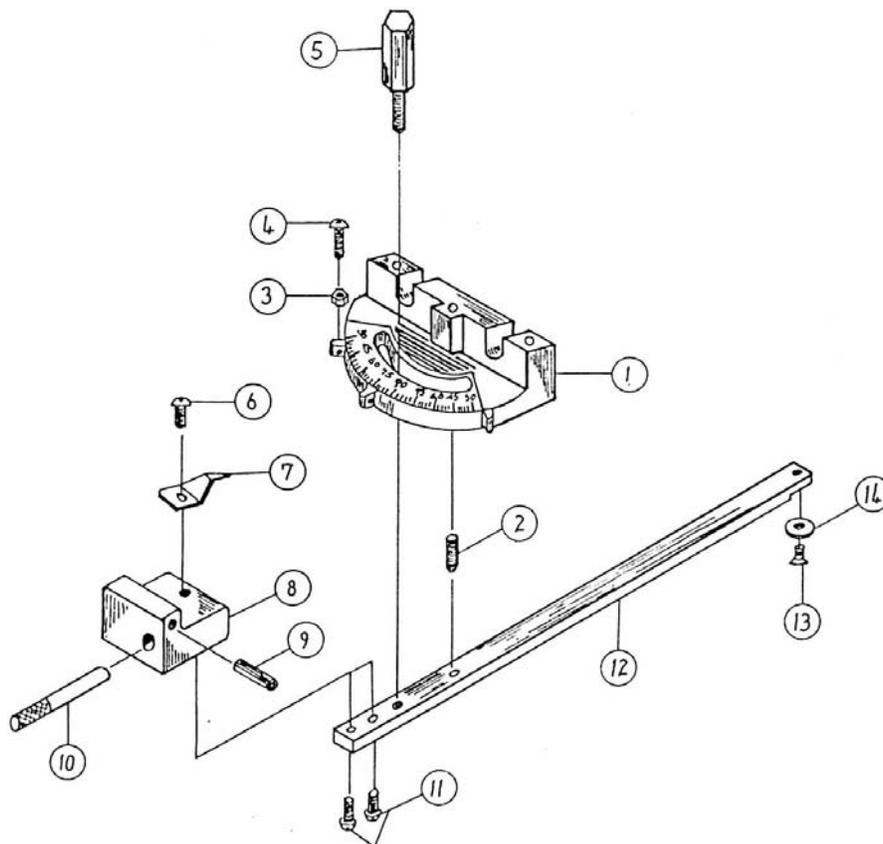


PARTS LIST

Part No.	Part Name	Part No.	Part Name
	Main Base	44.	Key
2.	Scale	45.	Shaft
3.	Screw	46.	Collar
4.	Trap Door	47.	Washer
5.	Trap Door Lock	48.	Nut
6.	Trap Door Lock	49.	Pin
7.	Trap Door Lock	50.	Motor Frame Support
8.	Hand Wheel Lock	51.	Clip
9.	Hand Wheel Handle	52.	Pin
10.	Hand Wheel	53.	Bolt
11.	Allen Screw	54.	Belts
12.	Screw	55.	Motor Pulley
13.	Rear Handle Support	56.	Motor
14.	Screw	57.	Bolt
15.	Pointer	58.	Bolt
16.	Front Trunion	59.	Pin
17.	Plate	60.	Bolt
18.	Screw	61.	Washer
19.	Bolt	62.	Support Flange
20.	Lock Washer	63.	Flange Casting
21.	Nut	64.	Pin
22.	Pin	65.	Bolt
23.	Worm	66.	Washer
24.	Collar	67.	Key
25.	Allen Screw	68.	Shaft
26.	Shaft	69.	Nut
27.	Pin	70.	Rear Trunion
28.	Key	71.	Nut
29.	Geared Trunion	72.	Threaded Shaft
30.	Nut	73.	Screw
31.	Bolt	74.	Block
32.	Flange	75.	Block Angle
33.	Shaft	76.	Washer
34.	Key	77.	Screw
35.	Geared Bearing Housing	78.	Screw
36.	Bolt	79.	Set Screw
37a. 37b.	Key, Clip	80.	Blade Insert
38.	Bearings (2) 620322	81.	Table
39.	Clip	82.	Washer
40.	Nut	83.	Bolt
41.	Collars (2)	84.	Wing
42.	Arbor Pulley	85.	Washer
43.	Allen Screw	86.	Bolt

MITRE GAUGE ASSEMBLY

Part No.	Part Name	Part No.	Part Name
1.	Mitre Gauge Body	8.	Angle
2.	Guide Screw	9.	Rolled pin
3.	Nut	10.	Push Pin
4.	Screw	11.	Screws (2)
5.	Push Handle	12.	Bar
6.	Screw	13.	Screw
7.	Pointer	14.	Guide Washer





WARRANTY

CRAFTEX 2 YEAR LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **two years** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.

Proof of purchase is necessary.

All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.

This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etceteras.

Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom. Craftex is a brand of equipment that is exclusive to Busy Bee Tools.

All merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.

- Returns must be pre-authorized by us in writing.
- **We do not accept collect shipments.**
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse (see locations on inside back cover of this manual).
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labour.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.
- For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repairs.

NOTES

Optional Accessories

Optional Fences for B524

B524FEN – H.D Fence for B524



B231830 – Align-A-Rip Fence

Structural steel rails, aluminum extrusion fence with T-slots on both sides. Front lock, optical cursor w/metric and inch scale. 30"



B231860 – Align-A-Rip Fence

Structural steel rails, aluminum extrusion fence with T-slots on both sides. Front lock, optical cursor w/metric and inch scale. 50"



B191360 – Accusquare Fence

Accusquare Rip fence. T-slots, 60" rail allows for 10" to left, 50" to right. Precision extruded aluminum fence guide rails and oval measuring scale.



Support box not included

B1913T – Mule T-Slot Fence

Accusquare Rip fence with T-slots. Rip 36" either left or right.



For a wide selection of **Freud & Craftex** Saw Blades, safety aids and other table saw accessories, check our catalogue or web site @ www.busybeetools.com

**Some of the above fences may require drilling.*

BUSY BEE TOOLS - - SHOWROOMS -Coast to Coast

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We have been serving the Canadian woodworking and metalworking industry for over 26 proud years. We stand behind our machines. If you have any questions, comments, or concerns, please call or write to our head office or call toll free at 1-800-461-BUSY.

Email us busybee@busybeetools.com, or contact us through our web site at

www.busybeetools.com

