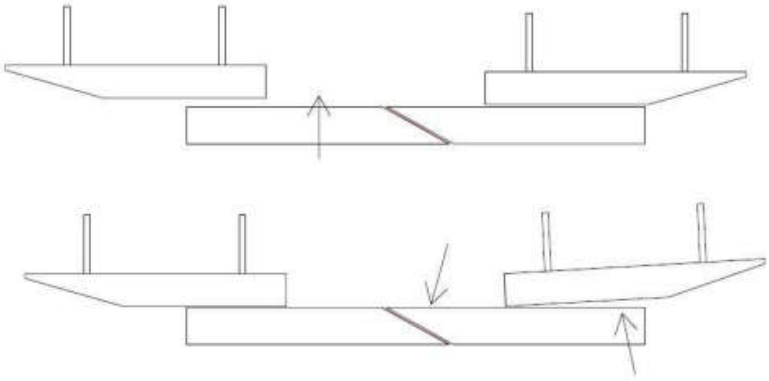
Websaw 1300 Calibration

1) Rollers should be clean and knurling should be sharp as to grip the wood well

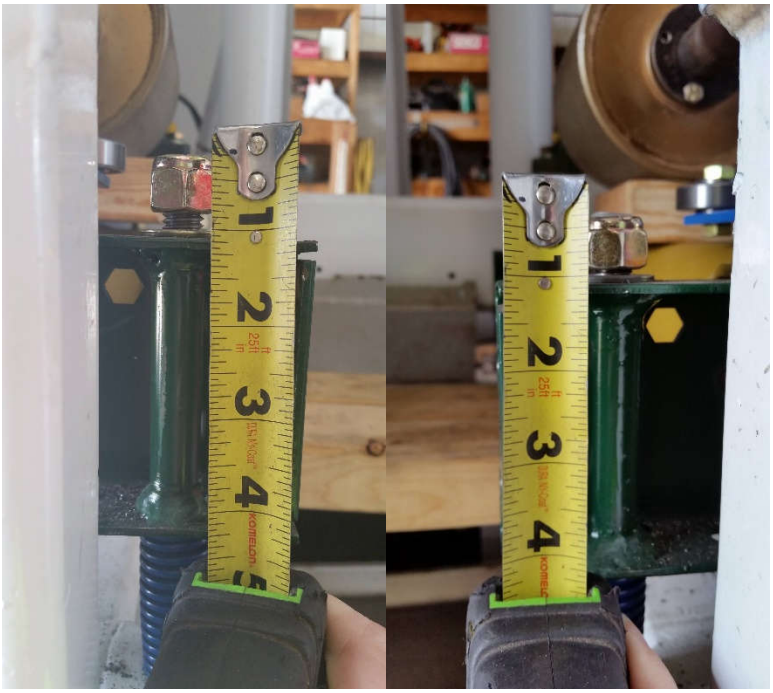
2) Clean Z-Axis lead screw. Move Z-Axis to “Clean Position” and use a wire brush to clean off saw dust build up on lead screw, and spray with white lithium grease. Do not use excessive WD-40 near ACME nut, it can cause damage. Home Z-Axis and confirm it fully reaches hard stop.

3) Oil upper carriage. Drop a few drops of tool oil into the access TEE just before upper carriage ceram valve.

4) Make certain that the infeed and outfeed fences are aligned. Fence as shown is misaligned and will cause blade to pinch.



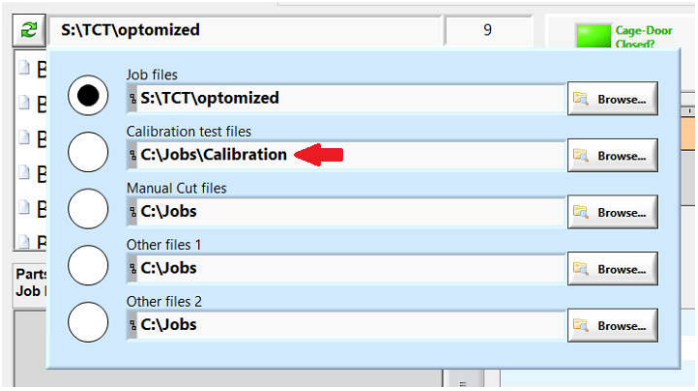
5) Jog a 2x4 into both rollers and check the tension on the table springs. Infeed should have 3/16” gap under the adjustment nut washer, under the outfeed adjustment nuts should be free but very little up and down clearance, no more than 1/16”. Make sure the spring studs are not broken.



6) You should be able to jog a straight 16’ 2x4 thru the saw and the board will stay tight against the fence. When you back the board up, it should ride away from the fence not more than ½” in 10 ft of jogging backwards. If it will not do this, the angle of the bottom rollers must be adjusted. It is best to do this one roller at a time. This can be done by using the wedges from the 100 inch test.

7) Check for mechanical slop between the feed roller and the servo motor. You can do this by jogging a 2x4 into first the infeed roller only and try to push it by hand in and out. It should only move about a quarter inch one way or another and should spring back to the middle position when released. Check the outfeed in the same manner.

Note: Calibration files are found under C:/JOBS/Calibration. Please disregard blade kerf warnings on any calibration file. This will not effect the results of calibration.



8) Use length test file to cut a 90 degree cut on the front of a 2x6 or 2x8. Set temp front cleanup to 1". Confirm cut is 90 degrees with a framing square, see below. If it is out of square, hit 'initialize motors' on the saw screen, and adjust motor homing position. Rehome. Recut. Recheck. Also confirm that take sure that the saw is cutting the proper amount off the front end the board.

9) Using the same length test file confirm that the saw is only cutting dust off the front of the board, a piece should not fall. Change "front clean up" under the settings screen to adjust this cut. The "front clean up on the main screen is a temporary clean up only. Do not adjust this cut here. Only adjust the front clean up in the settings window.

10) Set your scale factors: Release the tension on the roller **not** being tested. This is best done by pushing wood wedges in between the housing and the roller table (see attached picture) the wedges are cut at 90 degree / 80 degree with a 2.5" centerline. Then go to settings on the desktop of the saw operators screen and calibrate infeed and out feed separately.

1. Block up opposite side of table. (IE Infeed)
2. Push board under unused roller (IE Infeed) make sure board moves freely.
3. Jog board through roller being calibrated (IE Outfeed)
4. Press calibrate button (IE Outfeed)
5. Operator will mark the across the board
6. Jog what is supposed to be 100"
7. Marking a second spot on the board
8. Measure to confirm that it is 100"
9. Enter the number if it is not 100" to recalculate
10. Once 100" exactly is achieved, the test is complete

11) Cut a double 45 degree cut on the front end of a 2x4. Make sure that it is exactly 1.75 inches from the back edge of the board. Adjust the Z-Axis homing position until this point is perfect.

12) Stretch shrink adjustment. Set your length adjustments to zero and cut a 16ft 90/90 board. Slide adjustment to + to add to length and – to subtract from length of lumber you are calibrating. Calibrate 2x4, 2x6 and 2x8 separately. You can use the same board for subsequent test by cutting it again at 15-11 then 15-10 then 15-9 and so on. You can use the length adjustment to dial in the exact length. If you did everything right, you should get a very consistent length +1/-1 (Screen shows 2x10 and 2x12. Not applicable to 1300 model)

13) The last test is the 30-150 test. It will determine if the saw motor is positioned in the center of the pivot. You can find all these test files in C:\jobs\calibration on the saw. If all 4 boards do not come out the same length as each other, consult the attached XL-Saw manual under 30-150 test. Keep in mind the length of board is not as critical as the relationship between the 4 boards. Number them 1-4 as they come out.