

Sending an XL-Saw Back for Refurbishment

Updated 1/5/2026

When packaging an XL-Saw **DO NOT CUT** the wires between the saw and the control cabinet.

These two units should be packaged together. Severing wires can cause costly delays.

This guide is meant only to be of assistance, take caution to monitor and inspect for possible dangers or damages. **User discretion is strongly advised.**

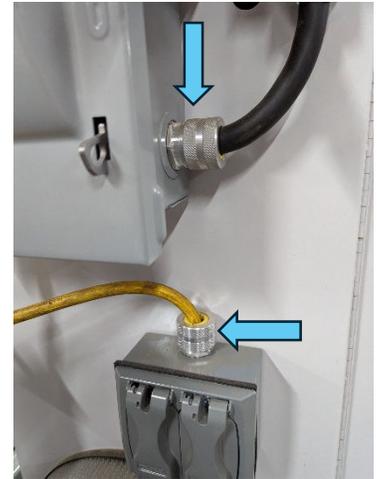
Supplies Required: x2 Lumber 4" x 4" x 72" (For Under Saw)
x2 Lumber 2" x 6" x 60" (For Under Control Panel)
x1 Box Made from 2" x 6" (For Around Monitor and Buttons)
Interior of Box Opening Should be Min 22.5" x 16.5"
x4 Lag Screws 3" (For Saw Base)
x4 Lag Screws 1-3/4" (For Control Panel Base)
Misc Wood Screws 3"
Steel Banding

Before shutting down and disconnecting the saw:

Pump clean acetone through the print head for storage purposes.
Remove print head and ink bottle. Store for later use.

Turn off all power going to saw at main breaker.

Confirm all power is off and locked out.
Disconnect incoming 240V, 110v and incoming Ethernet lines.
This may be best handled by an electrician.
Secure any open connections to prevent injury.

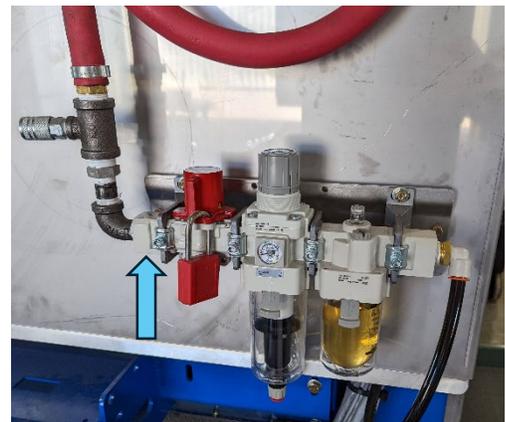


Disconnect scrap and outfeed conveyors.

(VFD 2 - Scrap Conveyor & C3 Contactor - Outfeed Conveyor)
Remove wires at motor junction boxes.
Stage wires to be coiled and secured before shipment.

Turn off air supply going to saw.

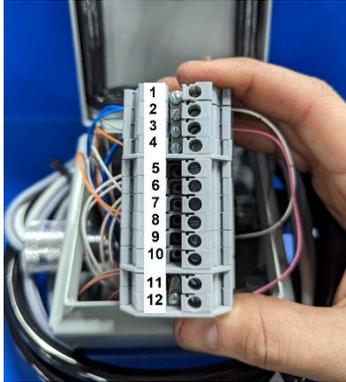
Remove fitting at the inlet of trio.
Secure hose away from saw for later use.



Disconnecting the XL-Feeder

At the XL-Feeder junction box, clip the control wires coming from the saw.

Take caution not to trim the wires going to the valves or sensors on the XL-Feeder itself. Trimming the wires gives you an indicator of what color wires go where for reinstall. The refurbished saw will have a fresh TB2 control wire.



TB2 Cable Termination		
1	⊕	-
2	⊕	-
3	⊕	-
4	⊕	BLACK
5		ORANGE
6		WHITE
7		BROWN
8		PURPLE
9		YELLOW
10		GRAY
11	⊕	RED
12	⊕	-



Confirm the homing sensor wire is not threaded through or attached to the saw.

Remove and relocate as needed.

Disconnect chain and roller wires.

(VFD 3 - XL-Feeder Chains & VFD 4 - XL-Feeder Roller)
Remove wires at motor junction boxes.
Stage wires to be coiled and secured before shipment.



Remove encoder cable from the XL-Feeder.

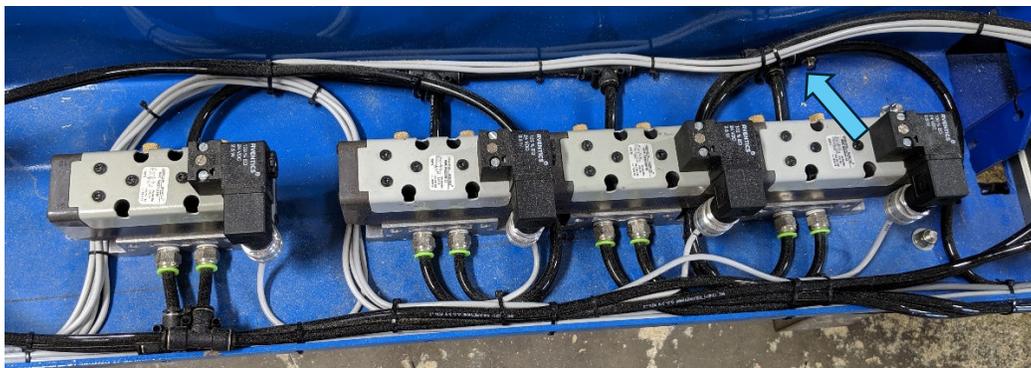
Stage with other wires awaiting securement.

Disconnect the air hose at the first valve on the XL-Feeder.

Stage with wires awaiting securement.



NOTE: See additional document "Packaging an XL-Feeder" for shipping notes on the feeder.



Remove anchor studs (and/or feet) from:

Scrap conveyor below saw.

Remove and store conveyor for later use.

From saw and control panel. Store saw feet for later use.

Disconnect transformer if you have one, store for later use.



Protect monitor and buttons.

Affix the 2x6 frame around the monitor and buttons.

Interior dimensions of the frame should be a minimum 16.5" x 22.5".

Frame may be banded or clear plastic wrapped to control panel.



16.5"

22.5"

Confirm the saw is clear all the way around.

Check for equipment from in/under/around saw.

Coil any loose hoses or wires into a reel with zip ties.

Secure the reel at base of stainless steel cage.



Install supports under the saw.

Lift and set saw on 4x4s, secure at each foot location with a 3" lag.

Secure 2x6s across 4x4s with 3" wood screws.

Step panel up onto 2x6s using forklift or two people. Caution unit is top heavy.

Tightly push panel to saw to prevent rocking. Confirm no components will be crushed.

Secure panel to 2x6s with four 1-3/4" lags.

Install minimum 1 steel band, or two plastic bands around saw and panel.

Confirm none of the exterior components such as pneumatics, wires ect are crushed.



Pick up saw by inserting forks into fork tubes provided at the base of saw.

Picking up saw and control panel combo in any other configuration can result in damage.

Secure saw on trailer. Must use chains and binders going through the fork tubes of saw.

One strap should be put over roof of saw to prevent it from blowing off on the highway.

Straps up and over the saw should not be relied on for securement.

Tarp as needed. Saw control panel can not get wet.

Protect and secure pneumatics under tarp. Loose flapping can damage gauges.