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The Unofficial Survival Guide

Felder 700 and 900 Series Saws
Felder 700 Series Shapers
Felder 700 Series Combination Machines
Format-4 kappa 30 and kappa 40

An owner's guide to installation, alignment verification, adjustment and use.
Includes Commissioning Checklist



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Table of Contents

Acknowledgements	iii
Introduction and Disclaimer	1
Section 1 Shipping, receiving, unpacking and cleaning the equipment.....	3
Section 2 Electrical service and wiring considerations	11
2.1 Single- and 3-phase trade-off considerations	11
2.2 Electrical wiring of the shop	13
2.3 Connection of the Felder equipment to electrical service.....	16
Section 3 Basic machine setup	18
3.1 Sliding table installation.....	18
3.2 Machine chassis, cast iron top and fixed extension table setup.....	22
3.3 Sliding table alignment verification.....	25
3.4 Sliding table height and alignment tolerance – what is “good enough”?	28
3.5 Saw station setup and alignment verification.....	28
3.5.1 Saw arbor run-out verification	28
3.5.2 Installing saw blades	29
3.5.3 Setting blade height indicators.....	30
3.5.4 Saw 90- and 45-degree tilt-stop position verification	31
3.5.5 Sliding table trajectory alignment – toe-out verification	33
3.5.6 Toe-in verification of 45-degree saw position on 700-Series machines	35
3.5.7 Splitter / riving knife adjustment.....	37
3.5.8 Installing saw guards.....	39
3.5.9 Leveling the saw blade table insert.....	42
3.6 Rip fence setup and alignment verification.....	43
3.7 Spindle shaper station setup and alignment verification.....	47
3.7.1 Checking table flatness.....	47
3.7.2 Installing a shaper spindle	48
3.7.3 Shaper spindle run-out and vertical alignment verification	51
3.7.4 High Speed Router Spindle run-out and vibration verification	53
3.8 Outrigger table and long crosscut fence installation and alignment verification.....	55
3.8.1 Outrigger table installation.....	55
3.8.2 Aligning the long crosscut fence on the outrigger table.....	60
3.8.3 Checking the alignment accuracy of the precision miter guide.....	65
3.9 Short crosscut fence installation and alignment	68
3.10 Measuring scale calibration	72
3.10.1 Setting the measuring scale on the rip fence.....	72
3.10.2 Setting the measuring scales on the long crosscut fence.....	73
3.10.3 Setting the measuring scales on the short crosscut fence	78
3.10.4 Setting the measuring scale on the parallel fence	82
Section 4 Scoring blade and dado cutter installation	83
4.1 Installing and aligning the scoring blade	83
4.1.1 “Standard” scoring option on the 700-Series saws.....	83
4.1.2 “Industrial” scoring option on the 700-Series saws.....	85
4.1.3 900-Series scoring option	85
4.1.4 Adjusting the scoring blade to the main saw blade.....	89
4.2 Installing and adjusting the Felder dado cutter	93
4.3 Mounting a Forrest “Dado King” (or similar) dado cutter set.....	98
Section 5 Edging shoe installation and use	99
Section 6 Parallel fence and extension tables	101
6.1 Parallel fence use – ripping on the sliding table	101

Table of Contents

6.2	Parallel fence conversion to extension table	102
6.3	F-channel and European rail-mounting table extensions and parallel fence installation	103
Section 7	Shaper tooling, power feeder and accessory installation and use	106
7.1	Mounting shaper tooling to the shaper spindle	106
7.2	Mounting shaper tooling with spindle bushings	109
7.3	Tool height reference points and calibrating the cutter height indicators	110
7.4	Standard shaper hood mounting and adjustment.....	117
7.5	Dealing with the heavy shaper hood	122
7.6	Power feeder installation and use.....	124
7.7	Shaper Integral fence system	134
7.8	Cutter-Guided shaper operations - template and guide-ring use	141
7.8.1	Shaper cutters with integral guide-rings or guide-bearings	141
7.8.2	Felder Guide Ring set – setup and use	143
7.9	Felder Heavy Duty Curved Shaping Device – aka Aigner BowmouldMaster.....	149
7.10	Tenoning operations – tenoning hood and tenoning plate options and use.....	155
Section 8	Outrigger mobility cart setup and usage	169
8.1	Outrigger mobility cart assembly and alignment.....	169
8.2	Mounting the outrigger table on the sliding table from the mobility cart	173
8.3	Dismounting the outrigger table from the sliding table using the mobility cart	176
Section 9	Air distribution system within sliding table for use with air clamps	180
Section 10	Advanced alignment procedures and techniques.....	185
10.1	Sliding table alignment – adjusting the trajectory for correct toe-in/toe-out	185
10.1.1	700-Series sliding table trajectory adjustment.....	185
10.1.2	900-Series sliding table trajectory adjustment.....	186
10.2	Sliding table alignment – vertical position and elevation consistency overview & theory	188
10.3	Sliding table vertical alignment – a step by step guide.....	196
10.4	700-Series saw trunion.....	202
10.4.1	700-Series saw trunion overview.....	202
10.4.2	Adjusting rip fence toe-in and toe-out to the saw blade on 700-Series.....	203
10.4.3	Adjusting the toe-in and toe-out of the blade at 45-degree angles on 700-Series	205
10.5	700-Series 90- and 45-degree saw blade tilt-stop adjustment	207
10.6	900-Series and Format-4 90- and 45-degree saw blade tilt-stop adjustment	208
10.7	900-Series and Format-4 kappa 30/40 PowerDrive control panel programming	209
10.7.1	PowerDrive control panel buttons & displays	209
10.7.2	PowerDrive Blade height calibration.....	210
10.7.3	PowerDrive entering programming mode.....	210
10.7.4	PowerDrive Imperial (inch) / Metric (millimeter) selection	211
10.7.5	PowerDrive Programming custom blade heights	211
10.7.6	PowerDrive recalibration of the angle display	212
10.8	700-Series shaper trunion adjustments.....	215
10.8.1	700-Series 90- and 45-degree shaper spindle tilt-stop adjustment.....	215
10.8.2	700-Series shaper spindle side-to-side angle adjustment.....	216
10.8.3	Drilling and tapping the shaper top for the Aigner BowmouldMaster hood system.....	219
10.9	Outrigger table alignment	225
10.9.1	Aligning the pivot axle on the outrigger support bracket	225
10.9.2	Aligning the trajectory of the outrigger support arm.....	229
10.10	Aligning the outrigger mitering fixtures	232
10.10.1	Alignment of the outrigger miter indicator.....	232
10.10.2	Aligning the precision miter guide fixture.....	236

Table of Contents

Appendix A	Troubleshooting common problems.....	243
Appendix B	Recommended tools for assembly, alignment and calibration.....	248
Appendix C	Sources of supply for aftermarket enhancements and accessories.....	253
Appendix D	Cleaning and rust prevention suggestions.....	256
Appendix E	K900-Series factory default control panel parameter settings.....	257
Appendix F	Electrical power connections and wire color-coding conventions.....	259
Appendix G	The five-sided-cut method of checking crosscut fence alignment.....	260
Appendix H	Proper assembly technique for the high speed router spindle collet.....	267
Appendix I	Boring diagram for 700-Series saw blades and dado cutters.....	268
Appendix J	Commissioning Checklist.....	270
Index.....		276

Sample

Introduction and Disclaimer



This manual is intended to assist current and potential owners of Felder sliding table equipment in several ways:

- If you are an expectant Felder owner, this manual can help you specify, plan for and deal with equipment delivery and electrical service needs.
- New users can be on the same page with the Felder technician during commissioning, and insure the equipment is properly calibrated and aligned.
- If you are inclined to install and calibrate the equipment yourself, this is an insider's look at how it's done, and done right the first time.
- Existing users will find this a valuable resource in maintaining alignment and performance of their equipment.

This manual is titled a ***Survival Guide*** precisely because it includes most of the information needed to become self-reliant in the setup and service of selected Felder equipment. It is also titled ***Unofficial*** because the information contained within is neither provided by, nor sanctioned by Felder USA or its parent company.

The illustrations and tutorial information contained in this manual describe a series of methods to verify alignment, and make specific adjustments to selected Felder and Format-4 saw and/or shaper machines. This manual is an assemblage of helpful information based on the experience of the author, and drawing from the experience and teachings of other Felder users and field technicians. For many new Felder owners, the most practical use of this compendium will be to aid them in understanding and verifying the commissioning process performed by a Felder technician. For others, this manual can be the gateway to self-sufficiency in the installation and maintenance of these sophisticated and capable machines.

Some of the adjustments discussed in this manual can lead an inexperienced user to bollix up an otherwise useful machine. Some procedures may void the Felder warranty; so if you have doubts, check with Felder before diving into any of the detailed adjustments yourself. While most, if not all of the information contained within, is believed to be accurate and factual, and conforms to commonly accepted practices, the author does not guarantee the accuracy of the information contained within, and makes no representation or warranty that the information conforms to Felder published specifications, methods or guidelines. Use of the information contained within is at the sole discretion of the user. The author assumes no responsibility for problems, damage or injury resulting from the use of the information contained within. If you elect to use this information, you do so at your own risk.

The alignment techniques covered in this manual are specifically applicable to the following Felder machines.

- Felder K700 Saw and F700 Shaper
- Felder KF700 Saw/Shaper Combination Machine
- Felder 900-Series Saw
- Format-4 kappa 30 and kappa 40 Saws

Within the context of this manual, most of the information regarding the 900-Series saw is directly applicable to the Format-4 kappa 30 and kappa 40 saws. Certain sections of this manual are applicable to other Felder equipment (CF700 specifically) and may also be useful as a guide on alignment methods with earlier generation Felder sliding table equipment.

Introduction and Disclaimer

For completeness, a list of the alignment checks and adjustments typically performed on a new machine by the Felder technician during commissioning can be found in the commissioning checklist (see Appendix J on page 270). The new user is encouraged to go through this checklist with the technician during commissioning.

Just as Felder documentation is biased toward the German-speaking community, this guide is also biased. The target audience for this guide is not only English-speaking, but also American dwelling. Sections on transportation and electrical service in particular are unique to North America.

This manual is organized in a tutorial fashion. It contains step-by-step illustrated guides to most of the assembly and alignment chores a user will likely face. That said, this manual stops short of trying to assist the user in serious overhaul or faulty mechanical parts replacement.

In spite of the tutorial nature of the materials, it is organized with the goal of also being an effective reference resource. For instance:

- The final section in this manual contains an extensive index.
- The manual is organized in a manner that progresses from delivery planning to basic assembly and alignment verification, with the more advanced topics dealing with complex calibration methods in the back sections.
- There are several Appendix sections provided primarily as reference, including a trouble-shooting guide.

What is not included in this manual?

- This version of the manual does not include information unique to the CF-700 series of machines. In particular, there is no section on the alignment verification or calibration of the jointer/planer.
- Rip and crosscut fences with digital readouts are not covered in this version
- DigiDrive specifics are not covered, although the PowerDrive aspects are included
- Although the sections dealing with the 900-Series machines are applicable to the Format-4 kappa 30 and 40 machines, this manual does not have information unique to the Format-4 machines, including the rip and crosscut fence differences.

Corrections and updates to this manual are inevitable. And to aid in this need, a web-based errata section is online and ready to assist in reporting errors and sources of confusion as well as communicating clarifications and publishing corrections. The errata web page is found here:

www.stonehorsefarm.com/Felder/Survival/October04/errata.htm

Comments and suggestions may be emailed to the author at the following address:

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Additional information on specific alignment topics can be found at the Felder Owners Group on Yahoo.com:

One final word of caution: These machines are very capable in skilled hands. They can be extremely dangerous and/or life threatening in the hands of someone who is careless, tired or under the influence of drugs or alcohol. Every attempt has been made in this manual to describe techniques that are safe and generally considered good practice. Take care when operating the machines and follow normally accepted safety practices, including wearing hearing and eye protection, and wearing clothing that does not have the potential to get caught in the machining operations and pull you or parts of your body into the machine.



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