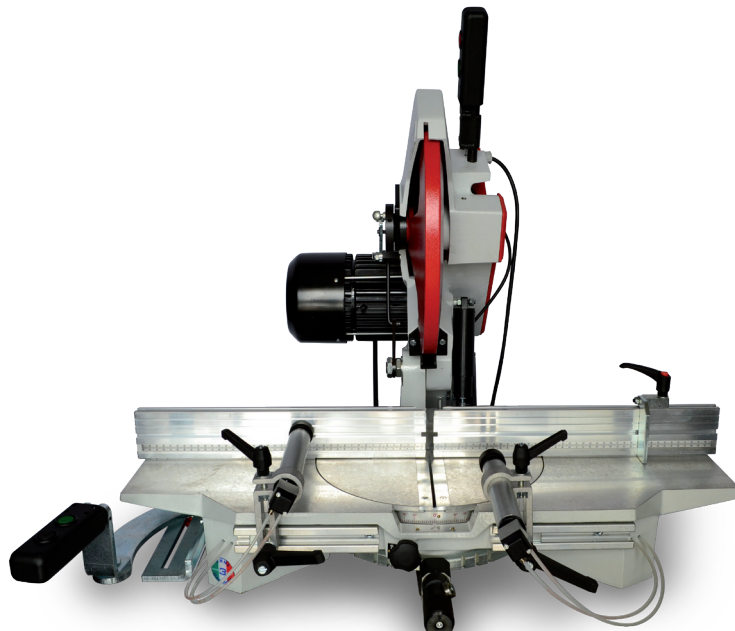
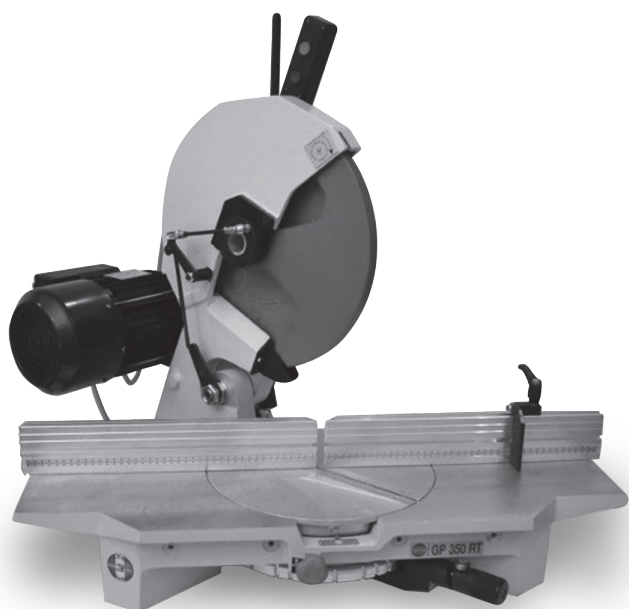




Operating manual, safety indications, spare parts



GP 300 RT - GP 350 RT

**Circular cut-off saws for wood,
aluminium profiles and PVC**



A-Plus Automation srl

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QUICK GUIDE - BLADE ASSEMBLY AND/OR REPLACEMENT

6 BLADE ASSEMBLY AND/OR REPLACEMENT

WARNING: remove the plug from the power socket and wear cut-resistant gloves before performing this operation.

WARNING: Choose the appropriate blade according to the type of material to be cut (wood, aluminum or PVC).

Raise the saw/motor arm to the hold position (lifted) until it connects with the non-return latch. Using a pair of pliers, remove the clip from the fork **43** (fig. 6-1-1), then release the lever **44** (fig. 6-1) and turn the blade guard **45** to end of travel. Lock the drive shaft at the tip by inserting the setscrew wrench **46** into the hole of the belt casing and unscrew the left screw with the setscrew wrench **47** (fig. 6-2). Completely unscrew and remove the left screw **48** and the external flange **49** (fig. 6-3). Disassemble or re-assemble the blade **50** (fig. 6-4), using two hands to remove it from the lower part. Having terminated the operation, fit the external flange **49** back in place taking care to check its timing, and strongly tighten the left screw **48** (fig. 6-3) using the previously mentioned wrenches.

Lower the blade protection **45** (fig. 6-1), insert the previously released lever **44** and fit the clip back into the fork.

WARNING: when assembling the blade, make sure that the teeth are pointing in the direction shown on the sticker affixed to the saw/motor arm. Never install damaged blades. Do not use blades with diameters that differ from the original (diameter 300 for mod. GP 300 RT; diameter 350 for mod. GP 350 RT) or with a fixing hole larger than 30 mm and then make up for the difference with compensating rings.

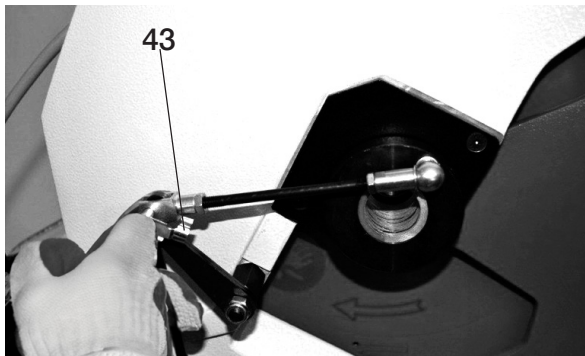


IMAGE 6-1-1

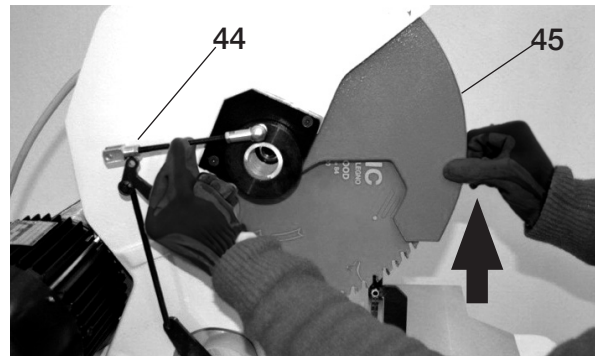


IMAGE 6-1

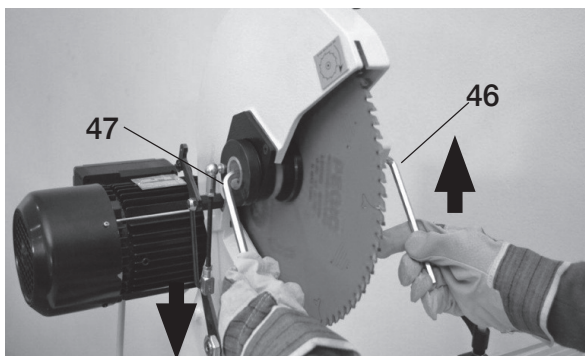


IMAGE 6-2

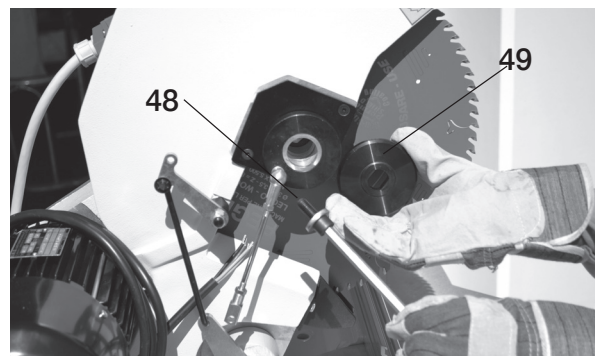


IMAGE 6-3

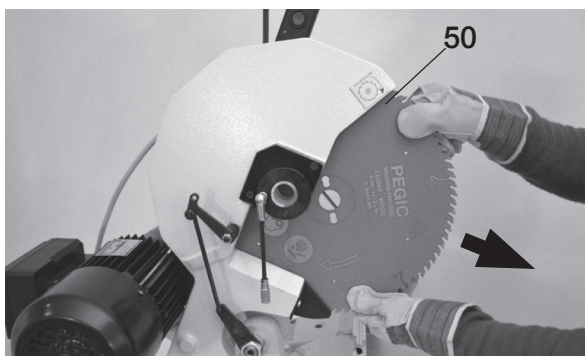


IMAGE 6-4



1. GENERAL INFORMATION

A-Plus Automation srl shall not be held responsible for any damage resulting from use not described in this manual or from improperly performed maintenance.

All rights reserved to A-Plus Automation srl.

This manual is an integral part of the product and all data, descriptions and illustrations in this booklet may be subject to change. A-Plus Automation srl reserves the right to make, without notice, any changes it deems appropriate for technical requirements or improvements.

For any needs or advice on use, please contact your local dealer.

1.1. Foreword

In writing this manual, we have considered all operations that are part of normal use and regular maintenance of the machine. Therefore, for proper and optimal use of the machine itself, it is necessary to scrupulously follow the instructions described. Use of the machine should be entrusted only to authorized and trained personnel regarding the use, adjustment and operation of the machine.

It is recommended that no repairs or work not indicated be carried out. All operations requiring disassembly of machine parts should be entrusted to authorized technical personnel. Keep this manual in good condition and keep it available near the machine.

1.2. Declaration

A-Plus Automation srl, as the manufacturer, declares under its own responsibility that the GP 300 RT and GP 350 RT model circular mitre saws comply with the essential safety requirements of the European Union Directive 2006/42/EC on Safety of Machinery - European Union Directive 2014/35/EU on Low Voltage - European Union Directive 2004/108/EC on Electromagnetic Compatibility.

1.3. Warranty

The machine is guaranteed for a period of 12 months from the date of the purchase invoice. It consists of free replacement of all mechanical parts that have material or manufacturing defects.

All electrical and electronic components are exempt from warranty. Also not covered are failures or defects due to external factors, maintenance errors, improper use of the machine, use of the machine under overloaded conditions, natural wear and tear or other causes not attributable to us. Shipment of replacement material is intended ex our factory. The returned machine, even if under warranty, shall be shipped carriage paid.



1.4. Identification

The machine is identified by a nameplate (fig. 1-1), located on the front of the basement, which shows the following data:

- manufacturer name
- machine type
- machine mode
- serial number
- year of construction
- motor characteristics
- weight
- blade Ø
- blade bore Ø
- blade thickness
- operating voltage
- mains frequency
- power

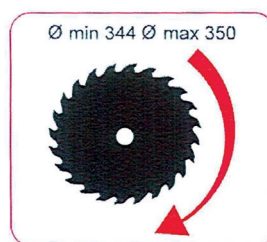
IMAGE 1-1



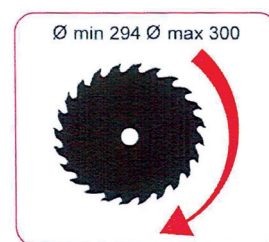
Rotational direction plate

A-Plus Automation S.r.l. Via Selva, 23/25 - 47122 Forlì /FC) - Italy service@a-plusautomation.com				CE	
Tipo: Troncatrice Manuale Type: Miter Saw		Modello: Model:		GP 350 RT	
Marchio: PEGIC	Matricola Serial N.	Anno Year		2023	
52 Kg	Lama Blade Ø 350mm	Foro Bore Ø 30mm	Spessore Thickness	3,2mm	
M	Trifase / Three-phase		Giri/minuto RPM	2810	
P= 1,8Kw		I_n= 10,2A	U_n= 230V	f= 50Hz	
A+AUTOMATION MADE IN ITALY					

GP 350 RT



GP 300 RT



1.5. Communications

For any written or telephone correspondence requirements with your local dealer or with A-Plus Automation srl regarding the machine, you must provide the following information:

- machine model
- serial number
- machine voltage and frequency
- name of the Dealer from whom it was purchased
- description of any defect found
- description of the type of work being performed
- hours of use per day

Send to A-Plus Automation srl
Via Selva, 23/25
47122 FORLÌ (FC) ITALIA
service@a-plusautomation.com



2. DESCRIPTION OF THE MACHINE AND SPECIFICATIONS

2.1. Foreseen use of the machine and contraindications

The machine is intended for professional use and has been designed to perform cutting operations on semi-finished wood and materials with similar physical characteristics. Equipped with a vice and carbide blade, it is suitable for cutting plastics (PVC), aluminium and light alloys.

- Carefully choose the blade according to the type and characteristics of the material to be cut.
- Use the machine within the limits of the values indicated in the technical data.
- Do not use the machine for purposes or jobs other than those for which it was built.
- The machine must never be used to cut materials such as iron, steel, cast iron, glass, bone, rubber materials, electric cables, etc.
- The machine must not be used to cut profiles larger than those specified in the technical data.
- Do not use blades that are cracked, deformed, chipped or missing.
- The machine may only be used by one adult and it is absolutely forbidden for more than one person to work on the machine at the same time.
- Do not use the machine outdoors, where it could be exposed to rain or high humidity.
- The machine must not be operated in explosive environments.
- The degree of protection of the electrical system is IP 54 and any damage resulting from use other than that specified in this manual is the sole responsibility of the user.

2.2. Residual risks

Some risks cannot be eliminated by construction. Such risks are:

- electrical hazards, due to the presence of electrical energy
- cutting hazards, also due to handling of the blade during assembly and disassembly
- assembly errors (e.g. of the blade)
- vibrations, due to an unbalanced and/or toothed blade
- noise, depending on the working environment
- dust, if not properly vacuumed.

2.3. Foreseen duration of the machine

The foreseen duration of the machine under normal use and regular maintenance is estimated to be at least 10 years.

2.4. Disposal of the machine

Once the operating activity of the machine has come to an end, its disposal can take place through a standard plant for the collection and disposal of industrial waste.

2.5. Safety

WARNING: To prevent injury, contact with electric power, and fire hazard, the following safety instructions must always be observed. Read and observe these indications before using the machine and keep this manual in a safe and easy-to-reach place.

Goggles and headphones: as indicated by the sticker on the machine, always use goggles for possible dust expulsion and headphones for work that generates high noise.

Work clothing: wear appropriate clothing to work, avoid the use of loose-fitting or over-sleeved gowns, scarves and ties.

Avoid unstable positions: take care to be in a safe and stable position that allows you to perform good force while maintaining good balance at all times.

Keep the area adjacent to the machine tidy: clutter and dirt in the workplace poses a danger of distraction and thus accidents.

Secure the workpiece properly: be sure that the workpiece is clamped with the vise before starting the cutting operation (cutting aluminum or light alloys).

NOTE: when cutting very long workpieces, provide appropriate support.

Environmental condition: do not expose the machine to rain. Do not use the machine in humid or wet environment. Always



work with good lighting. Do not use the machine in the vicinity of flammable liquids or gas.

Tool selection: do not use tools that are weak in strength or for purposes and work for which they are not designed. Keep tools sharp and clean at all times. Follow service prescriptions and directions for changing consumable parts. Always unplug the tool from the power outlet before making repairs and changing tools.

Do not overload the tool: the blade tool will work better and safer within the nameplate power rating.

Tool storage: store the tool in a dry and safe place and in a way that is not accessible to third persons.

Repairs: this machine complies with current safety regulations. Any repairs must be carried out only by authorized Service Centers if the operating instructions do not state otherwise.

Maintenance: when carrying out maintenance work, always disconnect the machine from the power socket. If the machine is fitted with a pneumatic clamp, disconnect the quick coupling for the compressed air connection.

WARNING: Check the cable regularly and have it replaced by a qualified person if it is stripped or damaged. Check extension cables regularly and replace if damaged. Avoid contact with earthed objects. Before using the appliance, carefully check that all safety devices are working properly. Check that the moving parts work, that they are not blocked, that there are no broken parts, that all the other parts have been fitted correctly and that all the conditions likely to affect the correct operation of the machine are optimal.

WARNING: Make sure that the safety device 60 (Image 2-1) engages when the saw/motor arm is released from its initial position. If it does not, contact a service centre to replace the arm lift spring if necessary. All safety devices or damaged parts must be repaired or replaced by an authorised service centre.



IMAGE 2-1

2.6. Safety instructions

1. Protection against electric shock

Avoid contact with earthed objects (e.g. pipes, radiators and refrigerators). In applications with a high level of humidity and/or metallic dust, electrical safety can be increased by connecting an isolation transformer or residual current circuit breaker in series. 2. Use personal protective equipment

2. Use personal protective equipment

- Hearing protection to prevent the risk of hearing damage
- Breathing protection to prevent inhalation of hazardous dust
- Gloves to handle blades and raw materials.

3. Remove dangerous objects

Remove all nails and metal objects from the workpiece before beginning machining.

4. Clamp the workpiece.

The workpiece should rest securely. Use clamps or vices to clamp the workpiece. Irregularly shaped workpieces should be prepared so that they cannot move or block the blade. For round workpieces (e.g. bars, pipes), always use appropriate clamping devices or clamps.

5. Do not cut “freehand”.

The use of vices is recommended. Cut only one workpiece per operation.

WARNING: Do not place your hand on the work surface, either when entering or leaving.

6. Operations to be carried out if the cutting blade jams

The workpiece must not jam or be pressed against the rotating cutting blade for any other reason. If the workpiece or the cutting blade jams or jams, carry out the following operations:

- Release the on/off switch and stop the machine immediately.
- Wait until all moving parts have stopped and unplug the power plug.
- Remove the workpiece
- Proceed to restore the initial working conditions.

7. Always check that the blade guard is working properly

The return of the saw head to its initial position must not be prevented by swarf or deposits. If this is the case, the saw blade guard cannot close completely. If this is not the case, stop the machine, unplug the power plug, put on gloves and, when the saw blade has stopped, remove the workpiece or shavings that are preventing the blade guard from working properly.

WARNING: Do not use the machine if the blade guard is not working properly, in which case contact the A-Plus Automation service.

2.6.1. Hazardous areas and safety deliverie



Do not rest your hand

Do not rest your hands on the work surface.



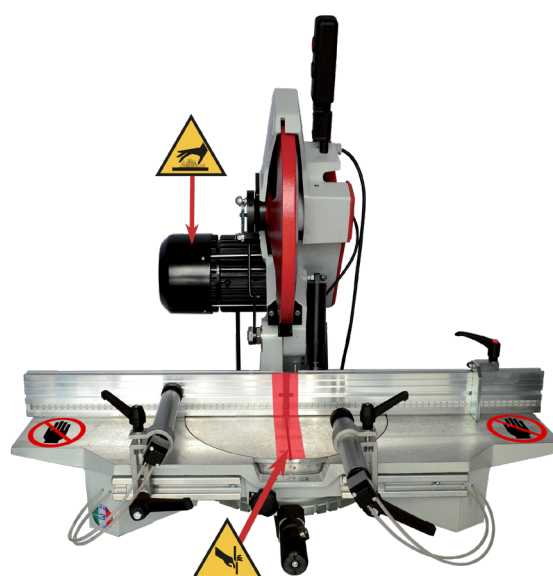
Burn hazard

Do not touch the surface indicated



Danger of cutting

Avoid the indicated surface



2.7. Personal protective equipment required

- Work gloves (handling materials and tools)
- Protective goggles
- Earmuffs or earplugs
- Avoid work clothing with loose sleeves
- Remove rings, bracelets and watches



2.8. Acoustic examination

The machines are equipped with steel blades with widia teeth.

- the machine is not installed on anti-vibration surfaces
- the machine is not equipped with sound-proof panels
- the machine is not equipped with particular external devices for controlling noise
- the low noise emission of the machine derives from the special mechanical construction

tab. 2-1






Type of functioning GP 300 RT	empty	wood	aluminium
Average value of sound pressure "measured" at the operator's place [dB(A)]	81.3	86.2	96.1
Environmental correction factor [dB(A)]	4.5	4.5	4.5
Average value of sound pressure "corrected" at the operator's place [dB(A)]	76.9	81.8	91.7
Weighted sound power A	91.1	96.0	105.9

tab. 2-2

Type of functioning GP 300 RT	empty	wood	aluminium
Average value of sound pressure "measured" at the operator's place [dB(A)]	91.5	90.5	96.5
Environmental correction factor [dB(A)]	4.5	4.5	4.5
Average value of sound pressure "corrected" at the operator's place [dB(A)]	87.0	86.0	92.0
Weighted sound power A	101.2	100.2	106.2

2.9. Technical features

Table 2-3-1

MOD.	PESO WEIGHT	POTENZA REALE MOTORE REAL ENGINE POWER	GIRI MINUTO RPM	Ø	IMBALLO PACKING
GP 300 RT CE	 Kg = 52	 1 = Kw 2,2 - 3 = Kw 2,2	 3000	 Ø300 x 30 x 3,2	 H = 63 A = 97 B = 54

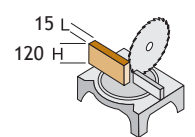
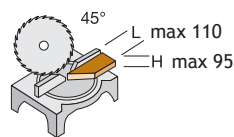
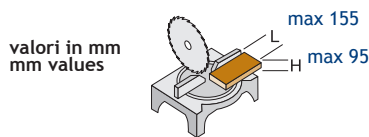





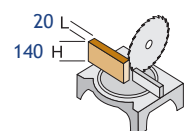
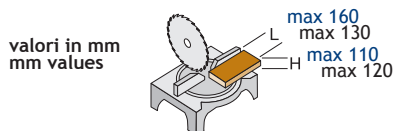


Table 2-3-2

MOD.	PESO WEIGHT	POTENZA REALE MOTORE REAL ENGINE POWER	GIRI MINUTO RPM	Ø	IMBALLO PACKING
GP 350 RT CE	 Kg = 52	 1 = Kw 2,2 - 3 = Kw 2,2	 3000	 Ø350 x 30 x 3,5	 H = 63 A = 97 B = 54



2.10. Optional equipments

- Manual vise
- Pneumatic vise
- Pneumatic vise plus blade lubrication (only for cutting aluminium)
- Fence extension
- Fence and table extension
- Handgrip with non-release enabling button (man present function)

2.11. Main parts of the machine

- 8. Basement
- 9. Rotating table
- 10. Saw/motor-carrying arm
- 11. Resting fences
- 12. Blade
- 13. Blade guard
- 14. Grip
- 15. Motor
- 16. Pneumatic vise

- 17. Handgrip with non-release enabling button (man present function)

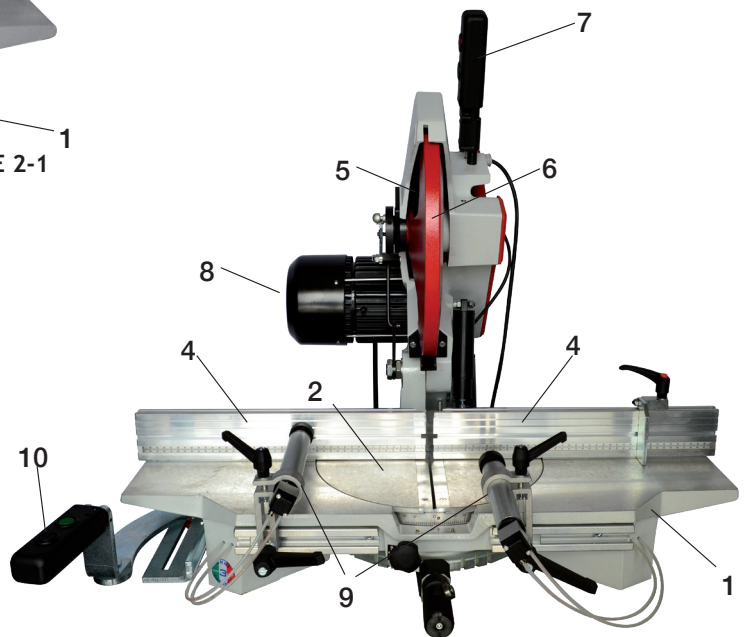
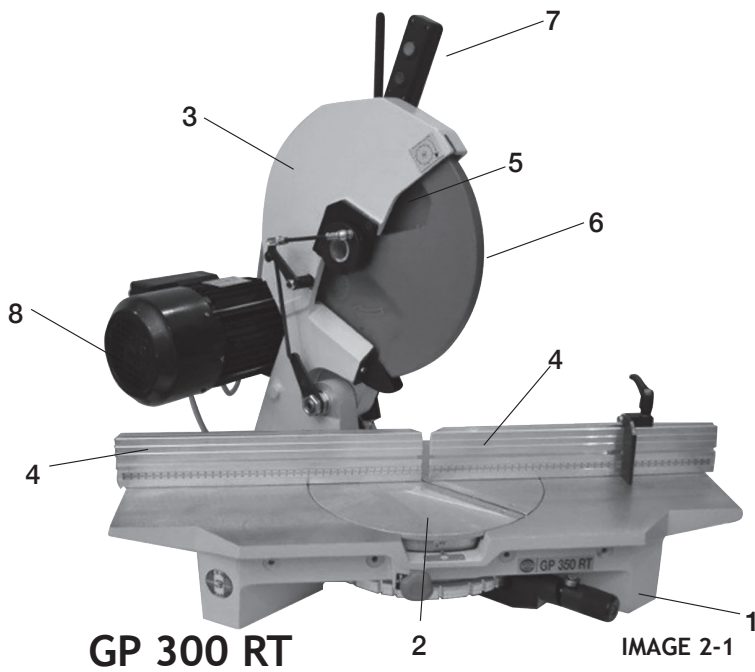
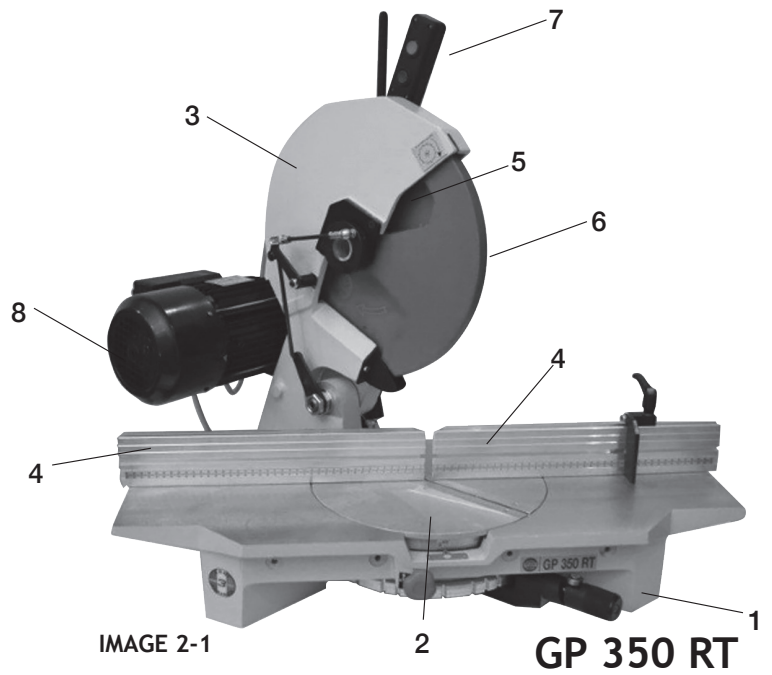
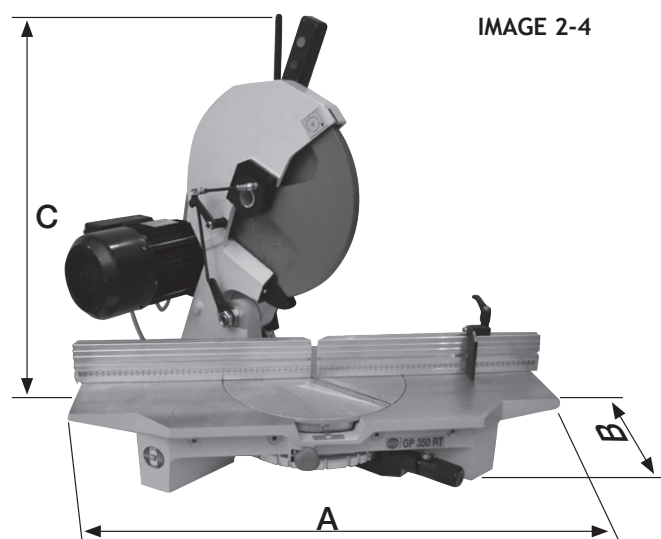
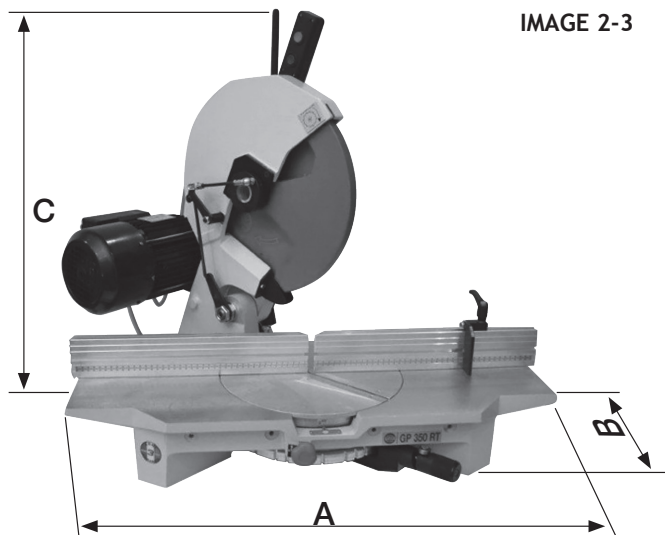


IMAGE 2-2-1
GP 300 RT - GP 350 RT
 MAINTAINED CONSENT BUTTON (MAN PRESENT) - OPTIONAL



2.12. Overall dimensions



Tab. 2-4


GP 300 RT			
A	820mm	B	750mm
		C	500mm


Tab. 2-5


GP 350 RT			
A	820mm	B	750mm
		C	530mm


Note: the dimension C is to be considered with saw/motor carrying arm in lower position


2.13. Explanation of symbols and their location

A -  Read carefully the instructions before use

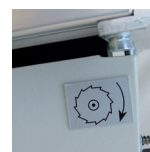
B -  Use of face mask is mandatory

C -  Use of safety glasses is mandatory


D -  The use of ear muffs is mandatory

E -  The use of gloves is mandatory

F -  Blade rotation direction



Warning symbols appear on the machine: follow them carefully, otherwise you risk serious injury.

G -  Keep your hands off

H -  Risk of cutting

I -  Risk of burns

Veillez à ce que les symboles soient toujours présents et lisibles, sinon appliquez-les et remplacez-les





3. INSTALLATION

All machines are thoroughly tested in the factory. They are shipped fully assembled in perfect conditions and do not need to be completed in any way by the user.

Any damages found on the machines must be immediately notified to the transporter. Also check if all standard and optional accessories, as written on the accompanying transport bill, are available.

3.1. Lifting

Since the machine together with its packing weighs approx. 55 kgs, we suggest to move it by means of a standard parcel carriage as shown on fig. 3-1. Once the machine has been moved from its packing, it can be lifted and transported manually.



IMAGE 3-1

3.2. Positioning

We suggest to position the machine in the middle of a working bench having a height of approx. 80 cm with a flat surface of at least 70 x 100 cm. Find an area with sufficient light and space around it to allow cutting the workpieces.

The machine needs no particular levelling operation, provided the bench surface where it is laid is regular. It is also possible to fix the machine through the two existing holes on the rear part of the basement, by means of two screws M10 (fig. 3-3) having a suitable length.

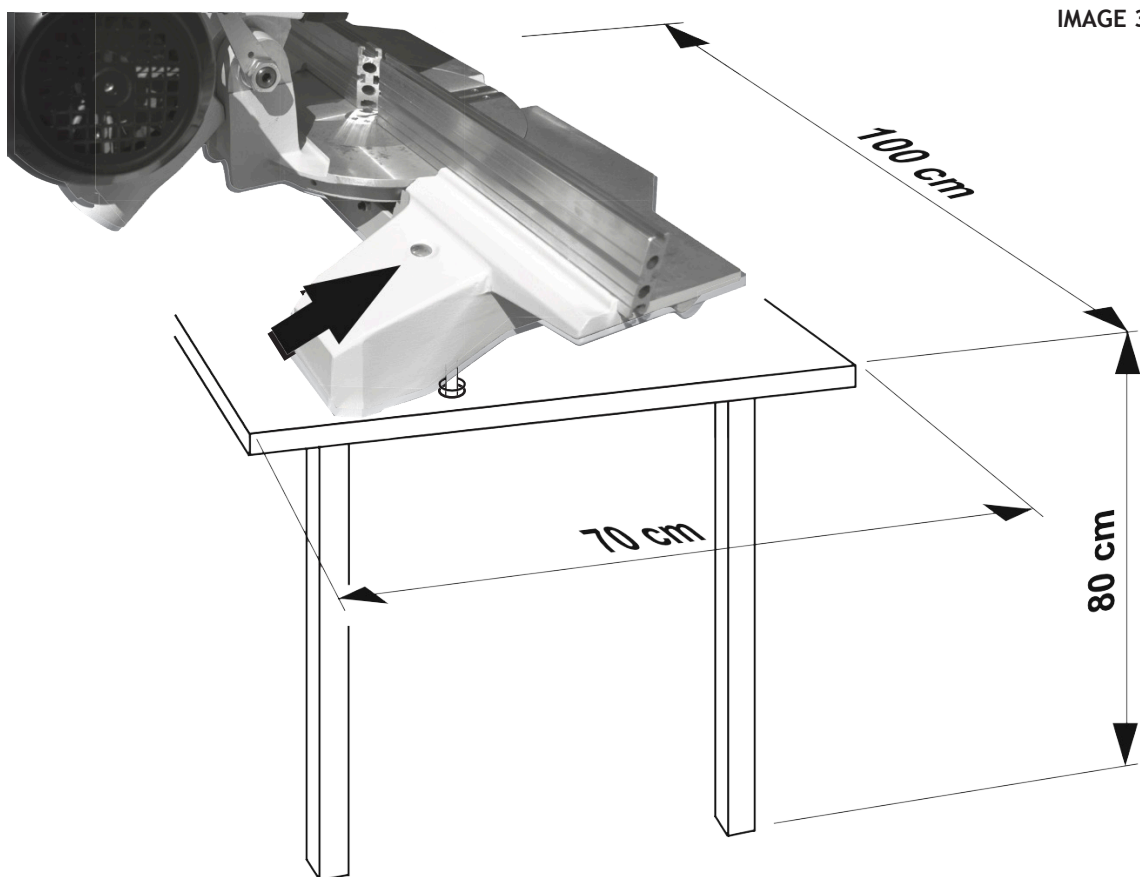


IMAGE 3-3



3.3. Electric connection

Before connecting the machine to the mains, make sure that the voltage of the motor, as indicated on the motor label, coincides with the voltage of the mains.

Make the connection by inserting the plug 1 in a socket as per fig. 3-4 or in a cable extension.

WARNING: If the use of extension cords is necessary, check that the cross-section of the cords is suitable to withstand the intensity of current drawn by the machine. However, it is advisable to use extension cords that are as short as possible. Always remove the plug from the power outlet before carrying out any work on the machine. Never leave the machine with the power outlet plugged in.

WARNING: Checking the conformity of the electrical system to which the machine is connected is the responsibility of the user. Ensure that the plant electrical system complies with the standards and directives of the country of use. The installation must be protected with maximum 16A fuses and 30 mA residual current circuit breaker. The user's manual gives the technical characteristics of the electrical system of the machine.

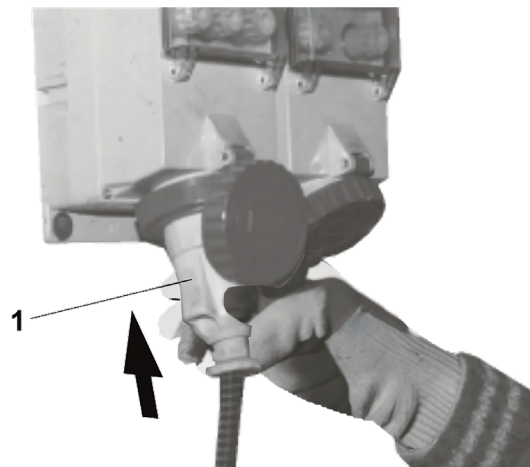


IMAGE 3-4

3.4. Suction connection

The machine can be connected to an independent suction unit by inserting a flexible tube 3 with an inner diameter of 80 mm in the rear suction outlet 4 of the saw/motor-carrying arm (fig. 3-5).

N.B. The air flow required for good suction is approximately 140 m³/h.

WARNING: For indoor use, the use of an extraction system is compulsory..

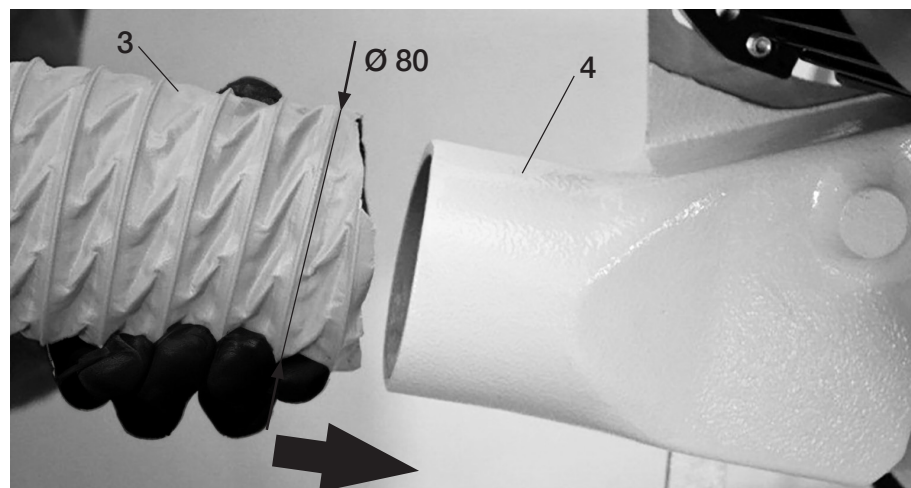


IMAGE 3-5

4. ADJUSTMENTS

4.1. Stop rods

This device is used as reference stop for cutting various pieces having the same length and can be indistinctly mounted on the left or on the right side of the machine.

Insert the longer rod (\varnothing 12 mm) in the hole made in the rear part of the fence side and tighten the knob **7** (fig. 4-1) on the rear side.

Act on the two knobs **8** to adjust the rod **9** or the rod-carrying telescope **19** according to your requirements.

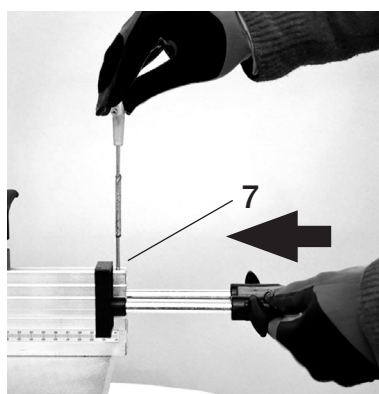


IMAGE 4-1

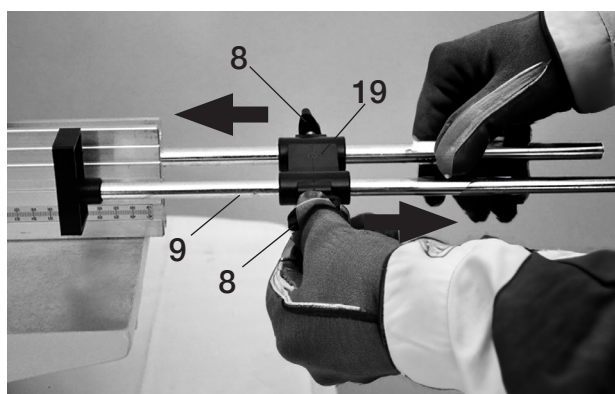


IMAGE 4-2

4.2. Drop-leaf sliding stop

This device is used as a reference stop for cutting several workpieces of the same length and can be mounted on either the right or left side of the machine.

Operate the handle **20** to adjust the stop, positioning it at a specific distance readable on the graduated scale **21** (fig. 4-2-2).

Once the cutting operation has been completed, simply remove this device by raising it as shown in fig. 4-2-3, allowing several types of reference to be used.

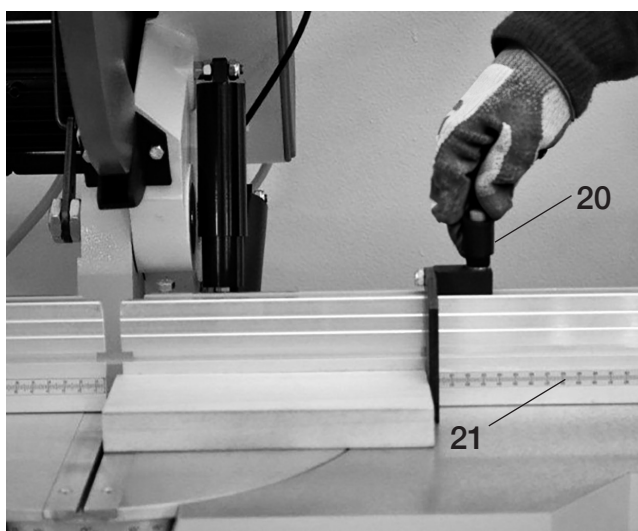


IMAGE 4-2-1

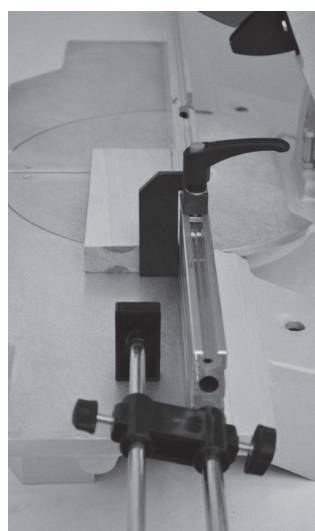


IMAGE 4-2-2

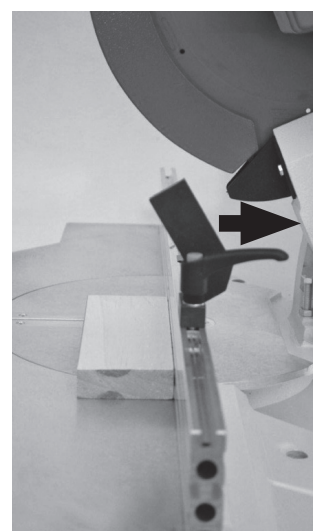


IMAGE 4-2-3



4.3. Optional equipments

4.3.1. Manual vise

Mount the T-fence **10** on the basement on the right or left side according to your requirements, by tightening the screws supplied by means of the wrench **11** after inserting a shim washer between the two elements (fig. 4-3). Insert the vise in the fence previously mounted, position it as close as possible to the blade cutting edge and lock with the handle **12** (fig. 4-4). Loosen the screw **13**, adjust the pressor **14** by positioning it at 2÷3 cm. from the workpiece and tighten the screw **13** (fig. 4-5) again. At this stage, turn the knob **15** clockwise to clamp the workpiece before starting to cut (fig. 4-6).

WARNING: The vise is indispensable for cutting aluminium and PVC.
Do not tighten too much for not damaging the workpiece or the fence of the machine.



IMAGE 4-3



IMAGE 4-4

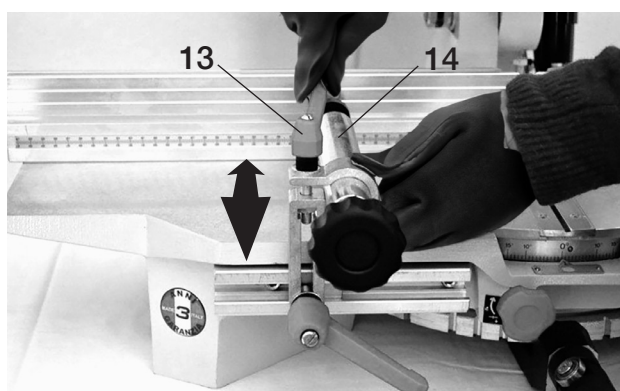


IMAGE 4-5



IMAGE 4-6

4.3.2. Pneumatic vise

Insert the vice assembly in the T-guide on the front of the front of the basement and position it as close as possible to the blade cutting edge. Lock the vice by the handle **61** (fig. 4-7). Loosen the screw **62**, adjust the pressor **63** by positioning it at 0,2 - 0,3 mm from the workpiece and relock the screw **62**.

WARNING: the pneumatic pressor closes automatically when lowering the blade-holding arm thanks to the valve **64** (fig. 4-7-1) situated on the rear of the machine.

With the motor off, make sure that when the saw/motor arm is lowered, the blade does not touch the pneumatic clamp and that it locks properly into the material to be cut.

Fix the cooling oil tank bracket **65** (fig. 4-7-2) to the work table (optional). Unscrew the cap **66** and fill the tank **67** with emulsified cooling oil. Adjust the oil flow through the valve **68** (fig. 4-7-1) situated in the upper part of the machine.

WARNING: Oil flows only when the motor is on. Use emulsified oil. Fence extension

This device enables to increase in length the surface of the fence, when you need to cut very long pieces; it can be mounted on either right or left side of the machine.

Insert the extension **16** in the fence by using the two centering pins **17** (fig. 4-8) and tighten the screw in the rear by means of the wrench **18** (fig. 4-8).

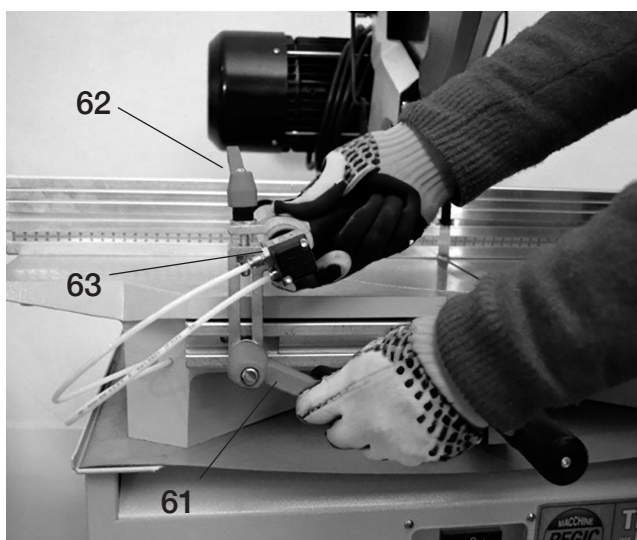


IMAGE 4-7

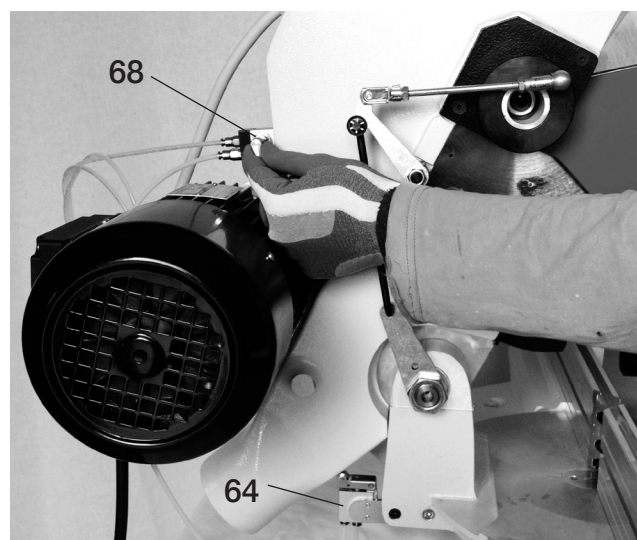


IMAGE 4-7-1

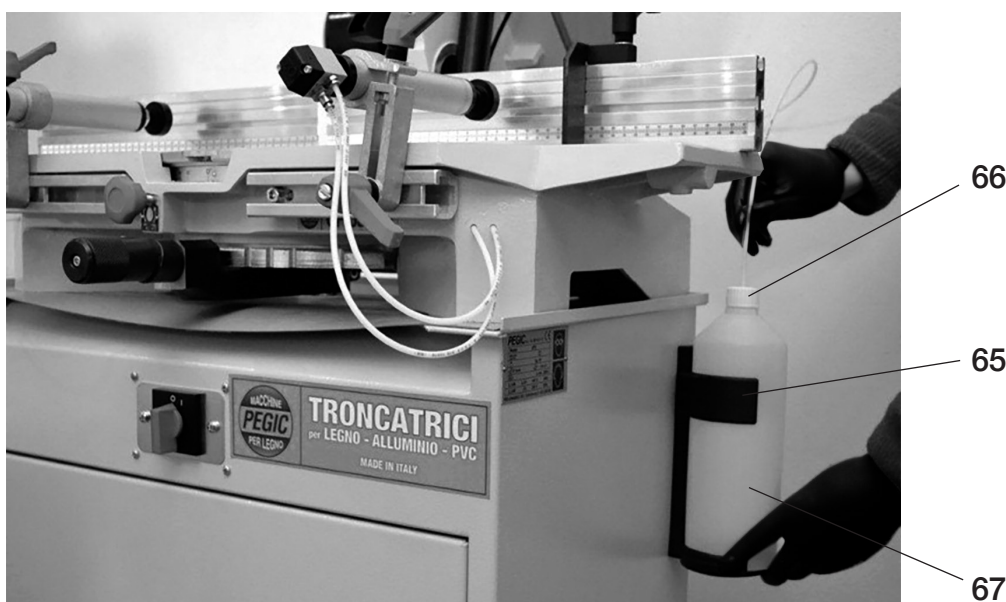


IMAGE 4-7-2



4.3.3. Fence extension

This device enables to increase in length the surface of the fence, when you need to cut very long pieces; it can be mounted on either right or left side of the machine.

Insert the extension **16** in the fence by using the two centering pins **17** (fig. 4-8) and tighten the screw in the rear by means of the wrench **18** (fig. 4-8).

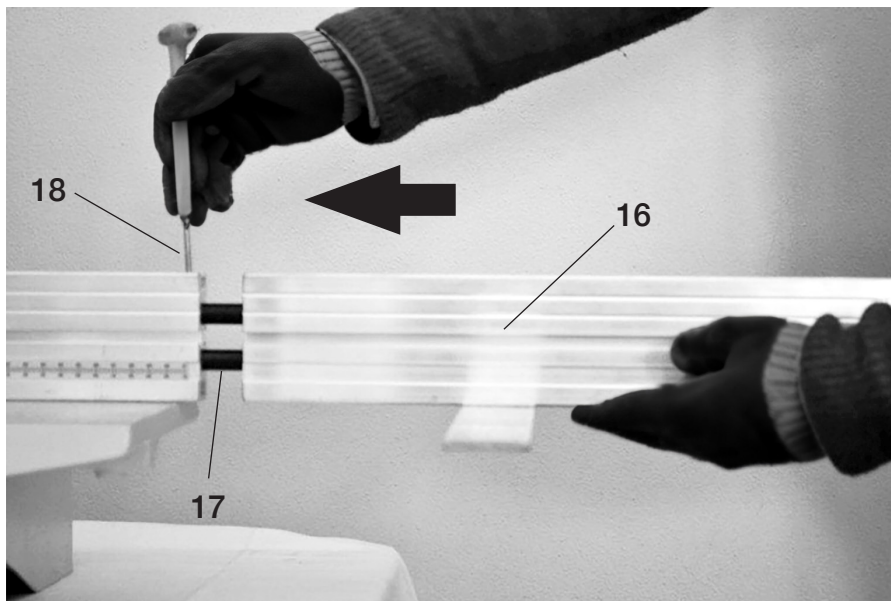


IMAGE 4-8

4.3.4. Fence and table extension

This device enables to increase in length the surface of the basement when you have to cut very long pieces; it can be mounted on either right or left side of the machine only with the optional fence extension.

Mount as described in the previous paragraph 4.3.3.

4.4. Cutting angle of the rotating table

The rotating table can be turned to the right or to the left on 4 fixed positions: 15° 22,30° 30° 45°, and on central position at 90°. The table can be unlocked for adjusting it to the above angles by turning clockwise or counterclockwise the grip **22** (fig. 4-10) until you understand the table is unlocked, then rotate by pulling the **22** to the right or to the left. If the desired angle indicated on the graduated scale **24** coincides with the fixed index **25** (fig. 4-11) on the basement, stop and turn the grip **22** (fig. 4-10) thus locking the rotating table on the fixed positions 0° 15° 22,30° 30° 45°.

WARNING: Make sure, by moving the saw/motor-carrying arm to the right or to the left, that the rotating table is well locked.

The table can be locked in the intermediary positions by turning clockwise or counterclockwise the grip **22** (fig. 4-10) until you understand the table is unlocked, then rotate by pulling the **22** to the right or to the left. Once the desired angle has been reached on the graduated scale **24** in coincidence with the fixed index **25** (fig. 4-11), lock the rotating table by turning the knob **26** (fig. 4-12).

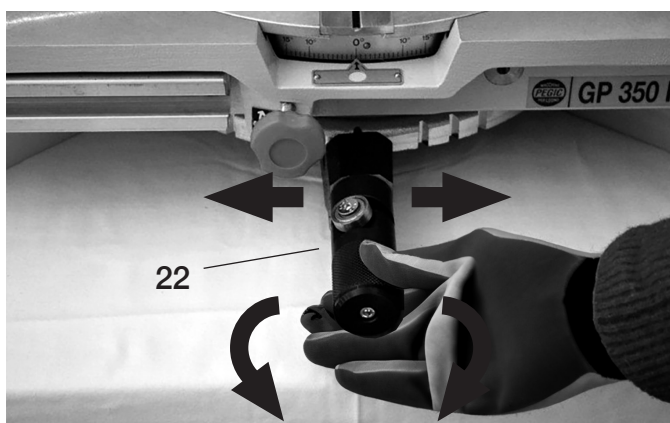


IMAGE 4-10

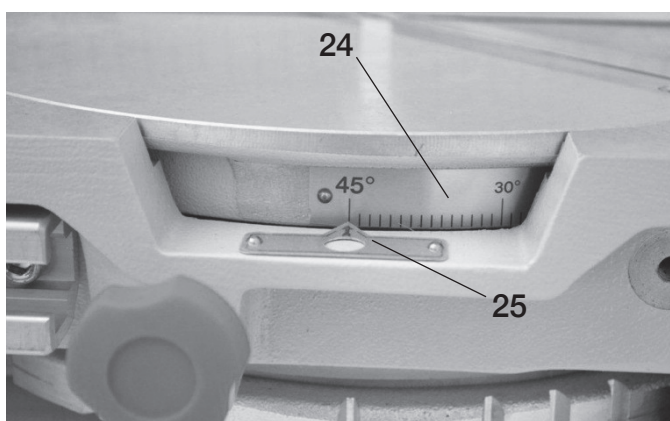


IMAGE 4-11

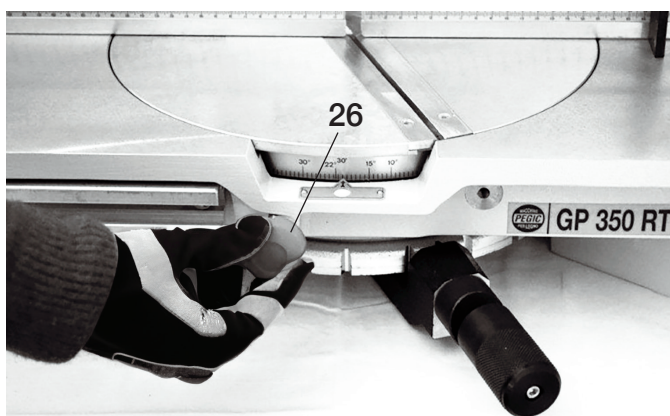


IMAGE 4-12



9.1. GPS Suction Base

4.4.1. Safety Directions.

This accessory needs the third wire for ground connection.

Headphones: as indicated, use headphones for work that generates high noise.ù

Environmental conditions: do not expose the machine to rain. Do not use the machine in humid or wet environments. Always work with good lighting: Do not use the machine near flammable liquids or gas. Do not open except when necessary the engine compartment.

4.4.2. Specifications

MOD.	PESO WEIGHT	POTENZA REALE MOTORE REAL ENGINE POWER	Ø		IMBALLO PACKING
GPS	 Kg = 48	 1 = Kw 0,75 - 3 = Kw 0,75	 3000	 1200 m ³ /h	 H = 63 A = 97 B = 54



4.4.3. Electrical connection

Before connecting the machine to the mains, make sure that the motor voltage corresponds to the voltage of the power line.

In the bench with three-phase motor, check if the connection is correct (when turning on the power, the bag inflates) possibly reverse two phase wires.

WARNING: Do not use the bench with suction if the motor is running in the reverse direction.

4.4.4. Intended terms of use

The GPS model is suitable for support of miter saws model GP300RT and GP350RT.

9.1.1. Package contents

- 2 wrenches for locking storage cabinet
- 1 suction hose diam. 80mm. Length m. 1.10
- 3 elastic bands
- 1 chip collection bag
- 2 TTQST 8x100 for fastening the mitre saw to the base

4.4.5. Preparation and set-up

The base is complete with the suction tube and chip bag.

For its preparation:

- place the bench in a level and stable spot;
- attach the base to the floor and the cut-off machine to the suction base using the screws provided;
- make sure the work place is free of any obstructions.

4.4.6. Connecting the machine to the base

To connect the machine to the bench with suction:

- connect by threading the 80mm-diameter suction hose on one side into the suction nozzle of the miter saw and on the other side into the suction nozzle of the bench.
- secure both sides with a supplied 80mm-diameter elastic band.

4.4.7. Conditions of use

Starting the vacuum cleaner motor is done through the switch located in the center half of the crankcase by turning the knob clockwise. Position 0 = motor off

Position 1 = motor on

WARNING: Before starting to work, carefully check the condition of the machine and make sure the engine runs properly.



4.4.8. Maintenance

This base requires no special maintenance; however, it should be checked periodically:

- the chip bag, empty or replace it if necessary;

To empty or replace the swarf bag: open the motor compartment, unscrew the elastic band, remove the bag (empty or replace it), reassemble the bag in the correct position and secure it to the nozzle with the elastic band, close the motor compartment again.

WARNING: OPERATIONS TO BE CARRIED OUT WITH ENGINE OFF AND PLUG DISCONNECTED FROM POWER OUTLET

- Check the fan blades in case resinous or damp woods are used.

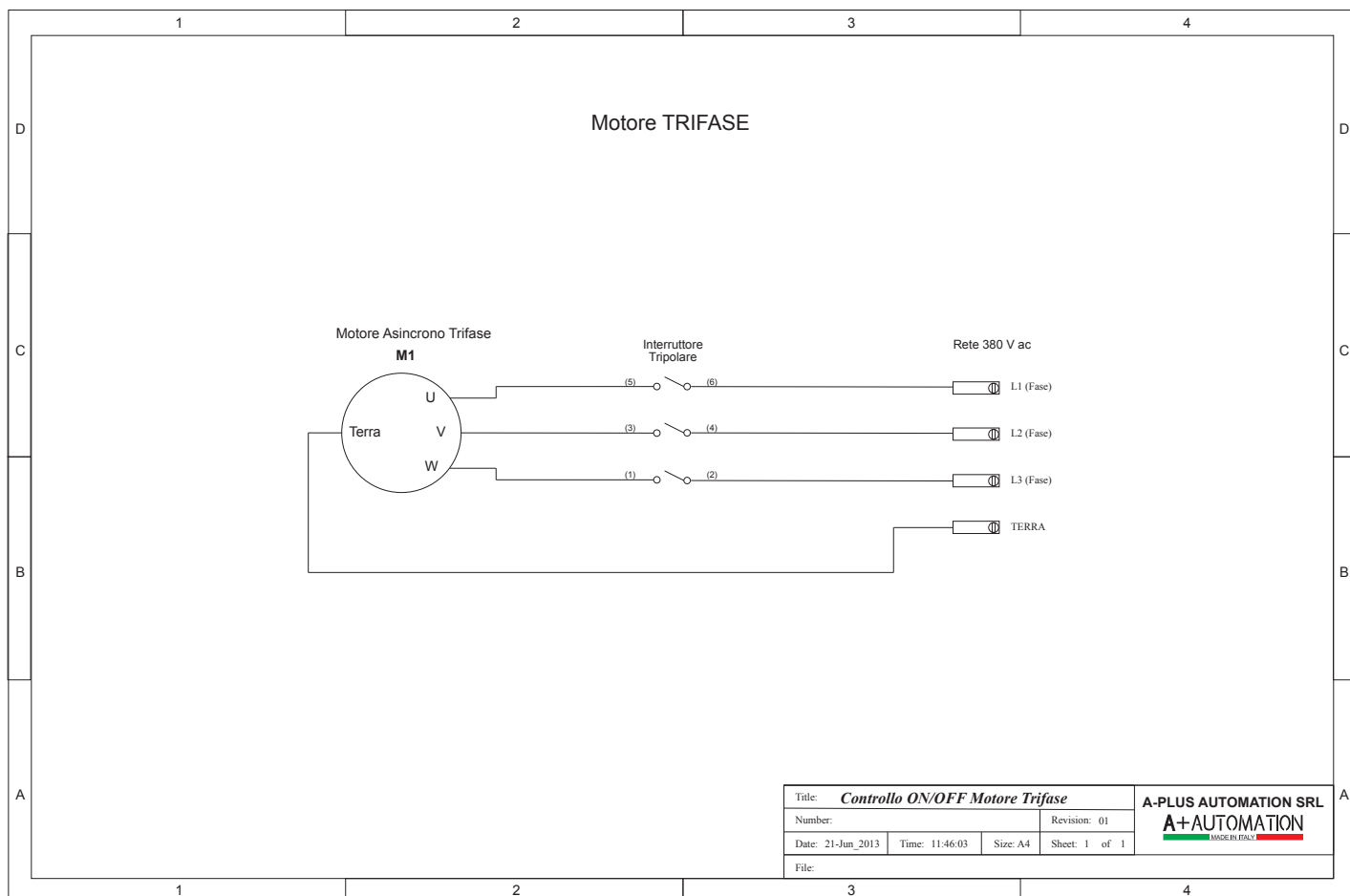
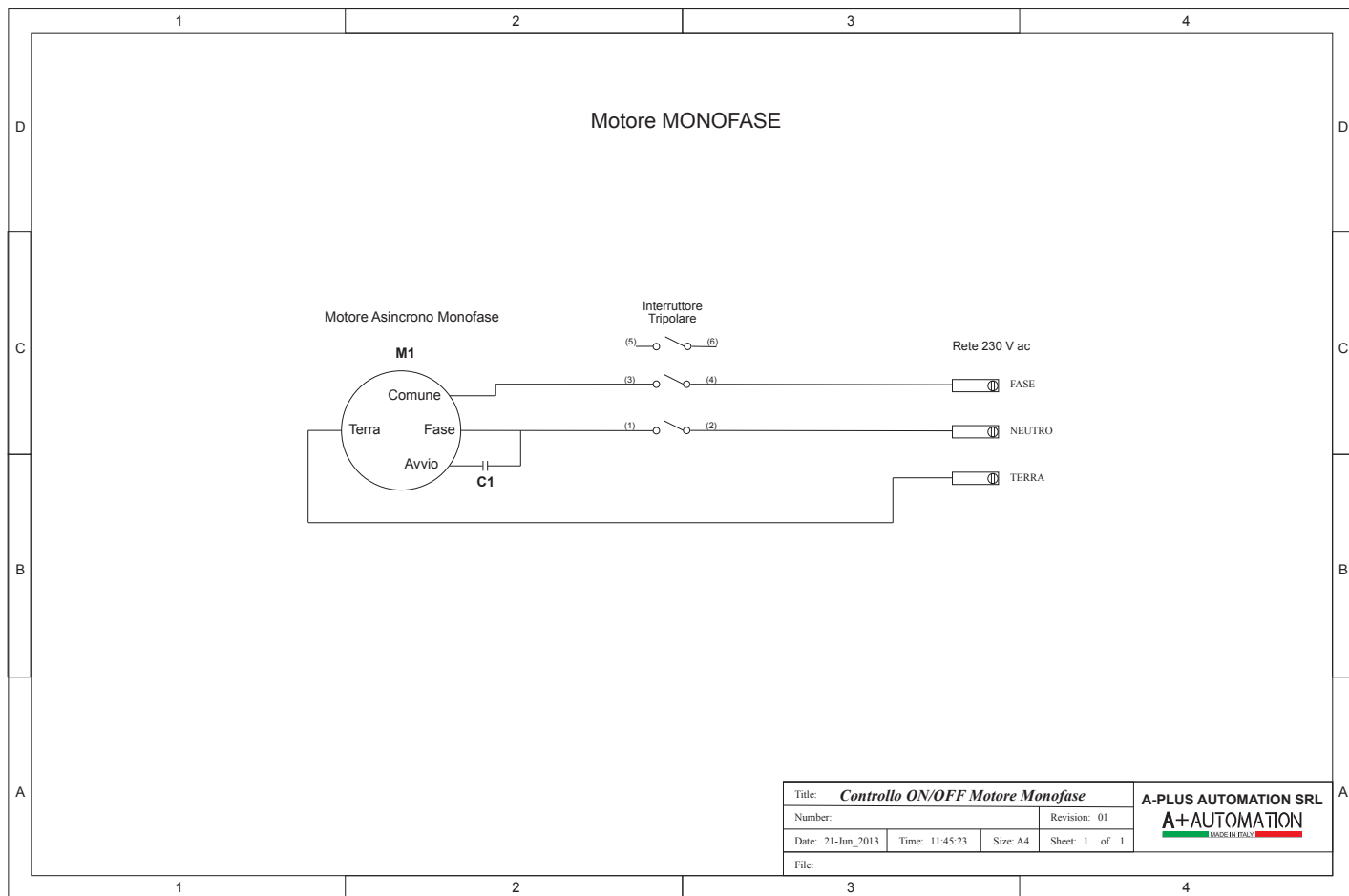
To clean any clogged fan blades: pull out the 80mm diameter tube from the intake nozzle, using compressed air, after wearing a pair of goggles, blow inside until the blades are completely clean.

WARNING: OPERATIONS TO BE CARRIED OUT WITH ENGINE OFF AND PLUG DISCONNECTED FROM POWER OUTLET

4.4.9. Parts and service

For any maintenance, it is recommended to contact A-Plus Automation srl directly.

4.4.10. Diagrams of the GPS Suction Base





5. USE

5.1. Cutting operation (version without retained consent button)

Secure the material to be cut firmly on the work base by holding it against the support rows with one hand or with the vice so that it does not move during cutting (see Figure 5-2-1).

Press the green switch **33** (Figure 5-2) located on the handle, wait for the motor to reach its speed after about 2 seconds. Pull the lever **31** located behind the handle **32**.

Use the handle to lower the blade until it contacts the material to be cut, then push progressively until the desired cut is made.

WARNING: greater pressure on the handle during cutting does not necessarily mean higher cutting speed; on the contrary, it can lead to excessive motor overload and less efficient operation.

At the end of the cut, guide the sawhead/motor to the rest position and switch off the motor by pressing the red switch **34** (Figure 5-3) on the handle.

WARNING: when cutting very short workpieces (2-3 mm thick), the following precautions must be taken: once the operation is complete, before raising the saw/motor arm, switch off the motor and wait for the blade to stop. This prevents the cut piece from being sucked up by the rotation of the blade, which could damage or break the blade itself or the supports.



IMAGE 5-2

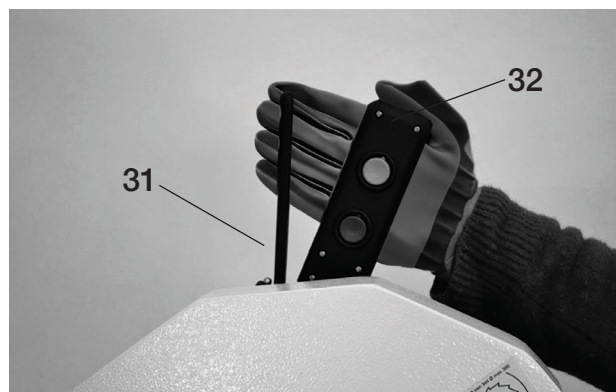


IMAGE 5-1

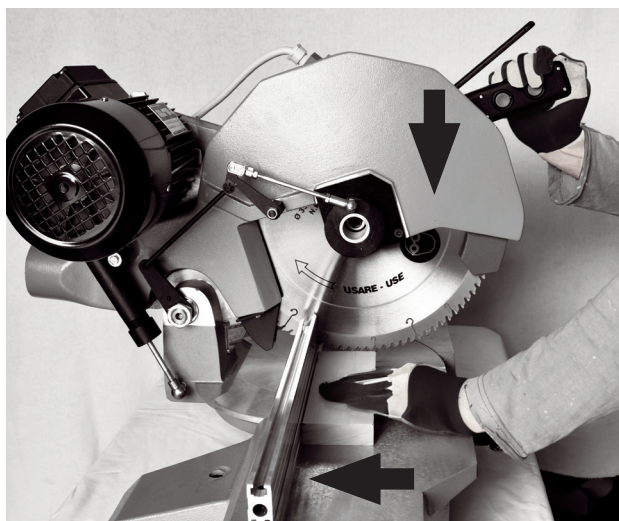


IMAGE 5-2-1

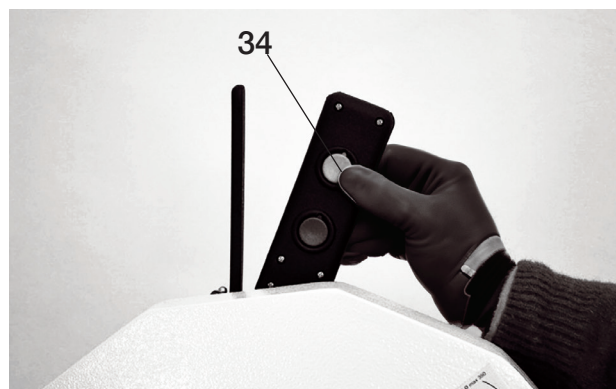


IMAGE 5-3

6. BLADE ASSEMBLY AND/OR REPLACEMENT

WARNING: Remove the plug from the power socket and wear cut-resistant gloves before performing this operation.

WARNING: Choose the appropriate blade according to the type of material to be cut (wood, aluminum or PVC).

Raise the saw/motor arm to the hold position (lifted) until it connects with the non-return latch. Using a pair of pliers, remove the clip from the fork **43** (fig. 6-1-1), then release the lever **44** (fig. 6-1) and turn the blade guard **45** to end of travel. Lock the drive shaft at the tip by inserting the setscrew wrench **46** into the hole of the belt casing and unscrew the left screw with the setscrew wrench **47** (fig. 6-2). Completely unscrew and remove the left screw **48** and the external flange **49** (fig. 6-3). Disassemble or re-assemble the blade **50** (fig. 6-4), using two hands to remove it from the lower part. Having terminated the operation, fit the external flange **49** back in place taking care to check its timing, and strongly tighten the left screw **48** (fig. 6-3) using the previously mentioned wrenches.

Lower the blade protection **45** (fig. 6-1), insert the previously released lever **44** and fit the clip back into the fork.

WARNING: when assembling the blade, make sure that the teeth are pointing in the direction shown on the sticker affixed to the saw/motor arm. Never install damaged blades. Do not use blades with diameters that differ from the original (diameter 300 for mod. GP 300 RT; diameter 350 for mod. GP 350 RT) or with a fixing hole larger than 30 mm and then make up for the difference with compensating rings.

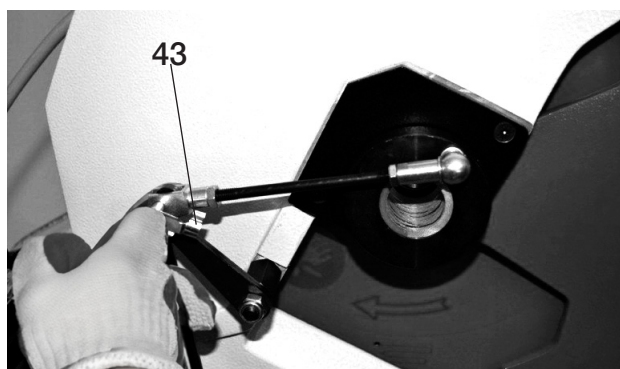


IMAGE 6-1-1

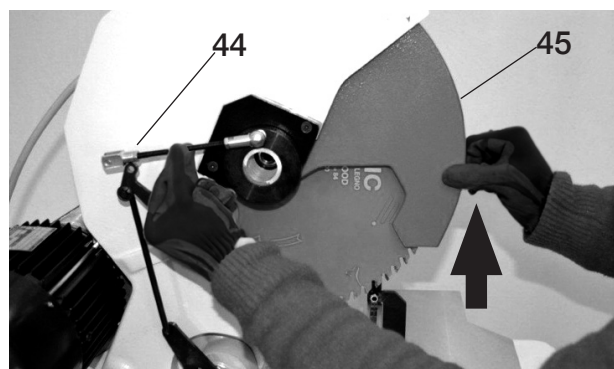


IMAGE 6-1

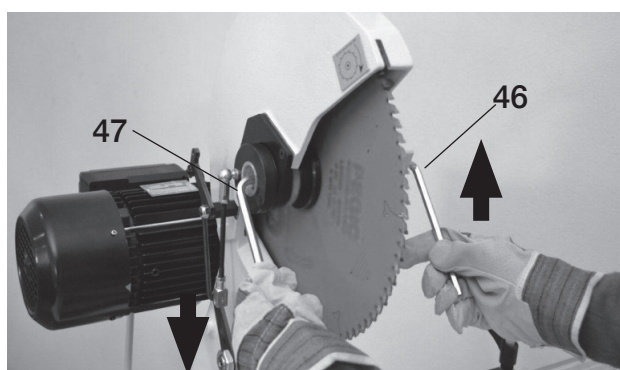


IMAGE 6-2

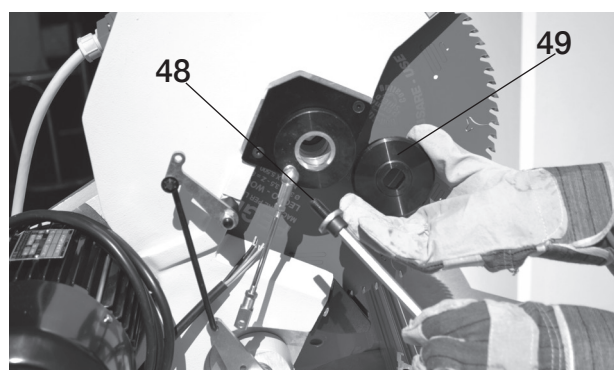


IMAGE 6-3

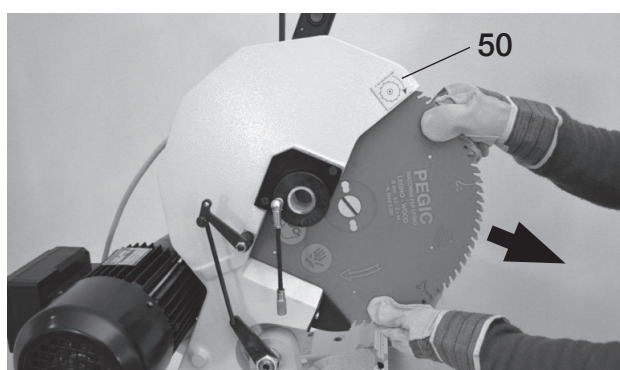


IMAGE 6-4



7. SAFETY DEVICES

WARNING: during the use of the machine never remove the safety devices and always check if they are efficient.

1. The saw/motor-carrying arm is held in resting position, lifted, by a special spring-loaded cylinder .
2. In resting position the blade is fully covered by its safety guard and is gradually uncovered when it is lowered for cutting.
3. The machine is equipped with a contactor.
This prevents, in case of power failure, that the machine starts immediately when power is reset.
4. The machine is fitted with a locking system for the saw/motor-carrying arm in resting position (lifted), which avoids any accidental lowering of the same.

8. MAINTENANCE

8.1. Tensioning the driving belt

If, while cutting, it is noticed that the blade tends to stop but the motor maintains speed, the drive belt must be tightened.

Loosen the two screws securing the belt cover **51** using the spanner **52** (Figure 8-1) and remove the belt cover **51** (Figure 8-2).

Check that the oscillation of the driven (upper) part of the belt is 3÷5 mm (as shown in Figure 8-3) using the pressure of a finger.

If the oscillation is greater, loosen the motor fixing screw using the spanner **53** (Figure 8-4). Loosen the adjustment screw using key **54** (image 8-5) and pull on the motor with a screwdriver until you obtain the appropriate tension.

Without releasing the motor, firmly retighten the adjustment screw using key **54** (image 8-5) and the motor fixing screw using key **53** (image 8-4).

Recheck the belt oscillation and close the casing using the screws previously removed.

Make another cut to check that belt slippage has been eliminated. If this is not the case, repeat the operation using a more appropriate tension.

WARNING: Never use the machine without properly installing the protective casing.

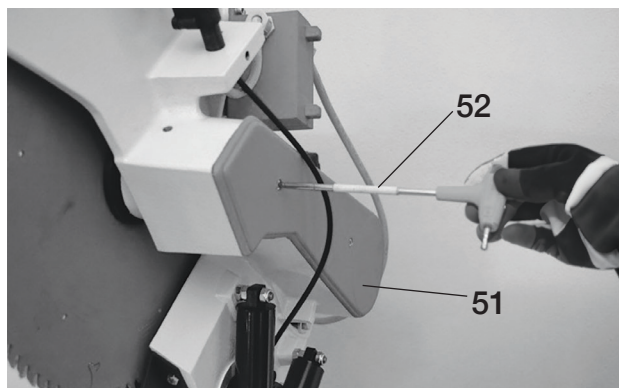


IMAGE 8-1

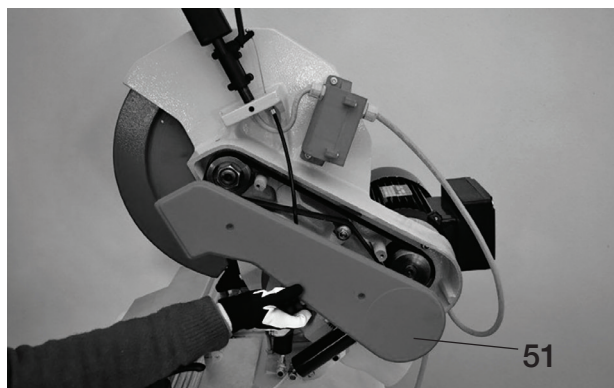


IMAGE 8-2

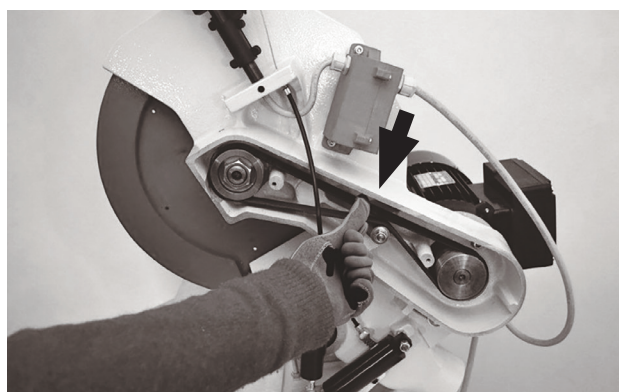


IMAGE 8-3



IMAGE 8-4

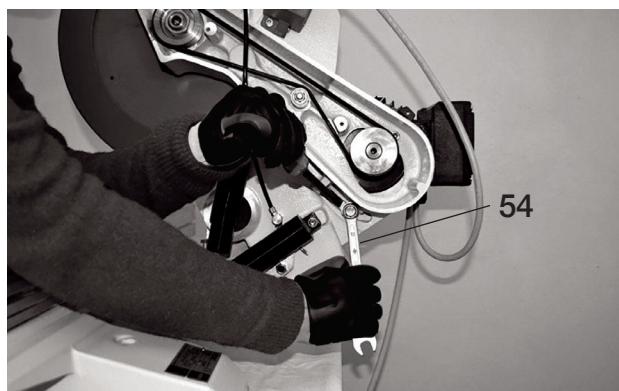
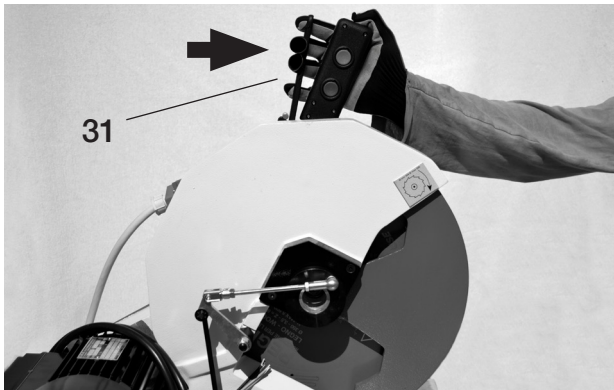


IMAGE 8-5

8.2. Replacing the arm-releasing cable

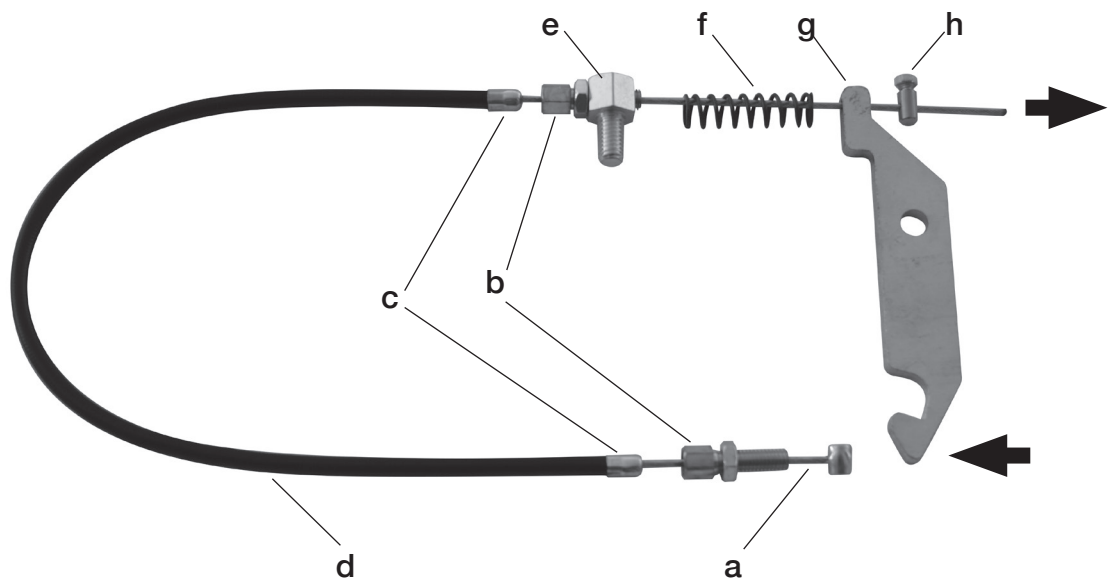
If, when pulling the lever **31** (fig. 8-6) for lowering the saw/motor arm this does not lower, it means that the release cable is broken. For replacing the cable, loosen the piece **55** (fig. 8-7), take out the broken cable.

Mount the new cable in the same order shown in the scheme on fig. 8-9. Close the piece **55** (fig. 8-7) previously removed and tension the cable adequately.



- a..... cable
- b adjuster
- c..... sheath ends
- d sheath
- e..... hexagonal piece
- f spring
- g release
- h clamp

IMAGE 8-9



8.3. Adjustments

8.3.1. Blade cutting capacity

If the cutting capacity decreases due to the blade wear or to the various sharpenings, it is necessary to intervene on the adjusting screw **57** after loosening the counternut **58** (fig. 8-10)

WARNING: After this adjustment has been made and before starting the blade, make sure that when this is in the fully lowered position it is unable to touch the rotation table section 2.9 page 10)



IMAGE 8-10

8.3.2. Blade stopping time

Once a month, check the time the blade takes to stop using a simple stop-watch. Consult an authorized assistance centre if it takes longer than 4-5 seconds to stop.

NOTE: Tension the belt until the prescribed stopping time has been reached and the belt is driven without sliding.

8.4. Further maintenance and controls

- Electrical components with safety functions should be replaced every 20 years. Contact an authorized service center for this operation.
- Periodically check the condition of the power cord and contact the manufacturer for replacement if it is damaged or stripped.
- Always keep machine handles clean and free of oil in order to prevent accidental grip slippage.
- It is also important that the base plates and support rows are always clean.
- In case of indoor use, connection to a vacuum system is mandatory; the machine is already equipped with a special port cut out in the back of the saw/engine arm.
- After use, clean the machine thoroughly with a low-pressure air jet or a dry brush and remove any glues or materials carried over to the material contact surfaces.
- For best results, the condition of the blade should be checked periodically and sharpened as soon as the need arises.

Warning: Always take great care when using compressed air. Always wear protective goggles.



9. INCONVENIENTS, CAUSES AND SOLUTIONS

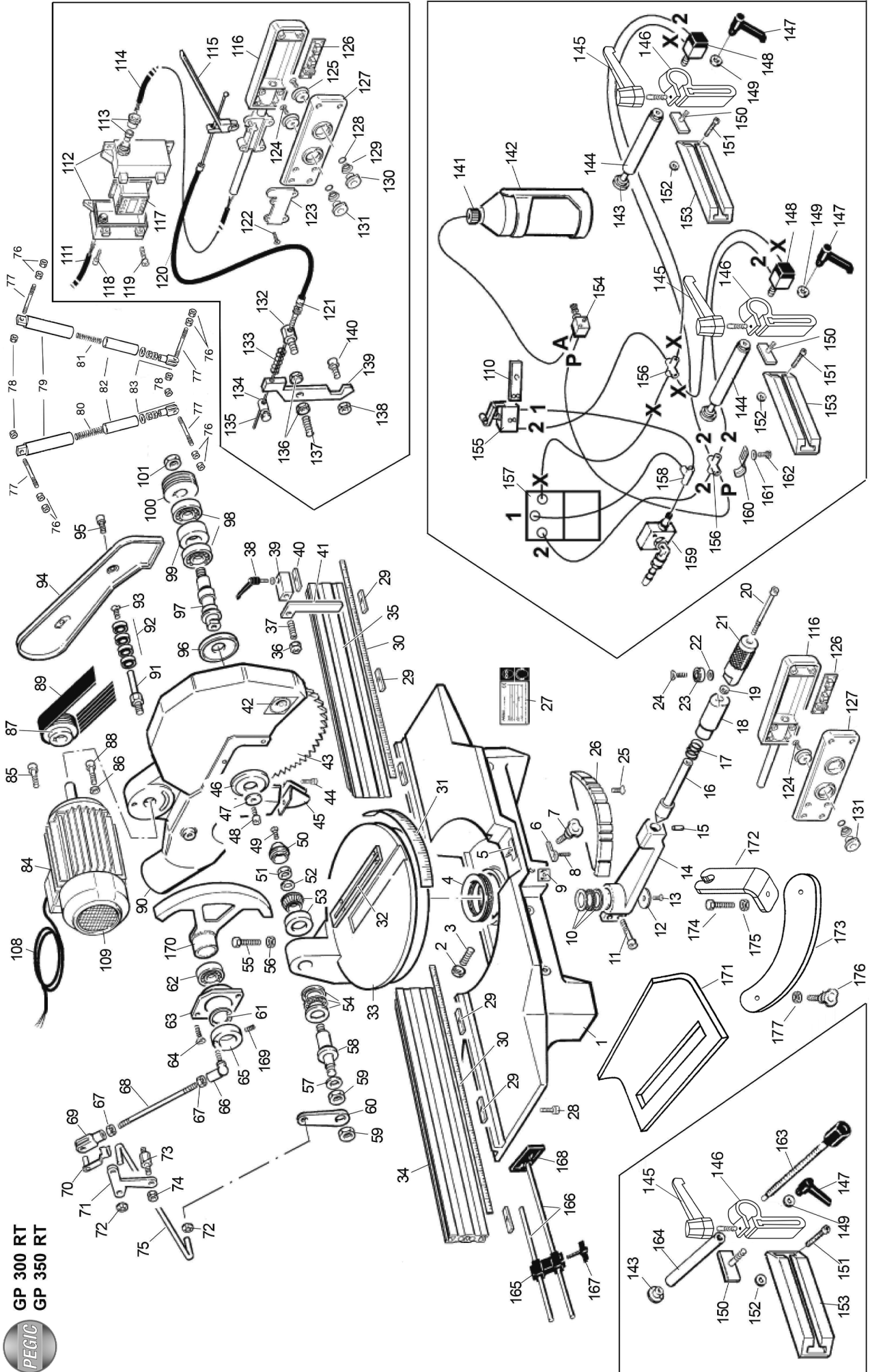
Each machine is assembled and scrupulously tested in the factory before shipment and will very difficultly be subject to failure or breakdown. However, we offer below a summary of the main causes of verifiable faults and the corresponding measures needed to remedy them.

tab. 9-1

Inconvenient	Cause	Solution
The motor of the machine does not start	Power failure	Check the mains current
	The plug is not inserted	Insert the plug
	The start button is faulty	Contact an authorized Assistance
	Broken braking system	Center
The cutting operation is difficult and motor efficiency is reduced	Excessive pressure on the grip	Decrease the cutting pressure by pressing less on the grip
	The blade is worn out	Sharpen or replace the blade (see ch. 6)
The safety device for hooking the saw/motor-carrying arm does not engage	The spring is weak and cannot take the arm fully to its resting position	Contact an authorized Assistance Center for replacing the spring
The lateral release operation of the saw/motor arm is difficult to perform	The cable that operates the release function has slackened	Make a correct adjustment through the clamping device (see ch. 8.2)
	The cable which controls the unhooking process is broken	Replace as explained at par. 8.2.
	The cable which controls the unhooking process is not free (hits an obstacle)	Remove the obstacle
The process for unhooking on one side the saw/motor-carrying arm is impossible	The cable which controls the unhooking process is broken	Replace the cable as explained at par. 8.2.
The cutting capacity decreases	The blade, due to wear, has reduced its diameter	Adjust correctly as explained at par. 8.3.1.
The rotating table is hard to run	There is saw dust in the rotating table	Contact an authorized Assistance Center
The circular blade does not enter in the slit of the rotating table	The saw/motor-carrying arm is deformed due to a shock during transport	Contact an authorized Assistance Center
During the cut the blade tends to stop and the motor maintains its turning speed	The trasmission belt skids	Perform a correct tensioning of the belt like explained in paragraph 8.1.
The bearings produce abnormal noise during work	Worn blade shaft	Contact an authorized Assistance Center
	Worn bearings	Contact an authorized Assistance Center
The motor of the machine fails to stop within 4-5 seconds	Broken braking system	Contact an authorized Assistance Center
	Adjust the motor brake	Contact an authorized Assistance Center
The saw/motor arm fails to return completely to its hold position	Broken spring	Contact an authorized Assistance Center
	Slackened spring	Contact an authorized Assistance Center

10. SPARE PARTS TABLE

GP 300 RT
GP 350 RT



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