AXMINSTER PROFESSIONAL

Code 107703

Original Instructions

AP200SM

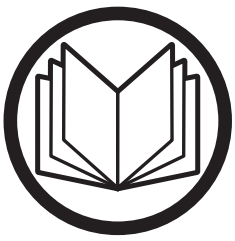
Spindle Moulder

AXMINSTER THREE YEAR GUARANTEE

AT:05/12/2023
BOOK VERSION: 7

INDEX OF CONTENTS

The symbols below advise the correct safety procedures when using this machine.



Fully read manual and safety instructions before use

Ear protection should be worn

Eye protection should be worn

Dust mask should be worn

HAZARD

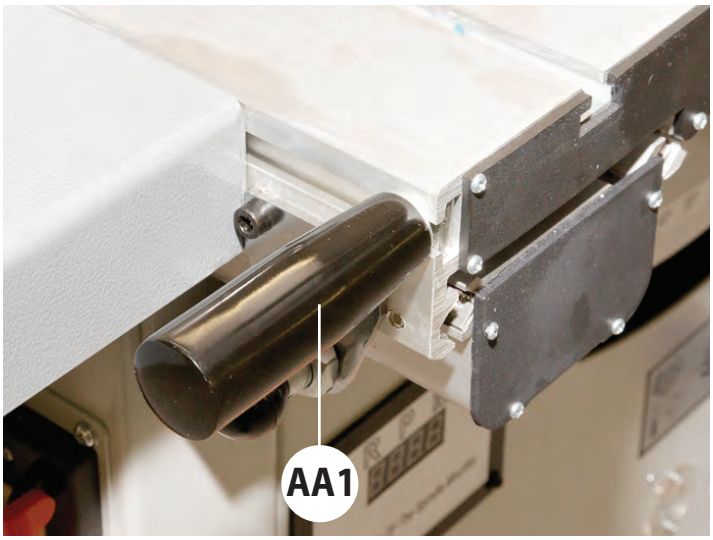
WHAT'S INCLUDED

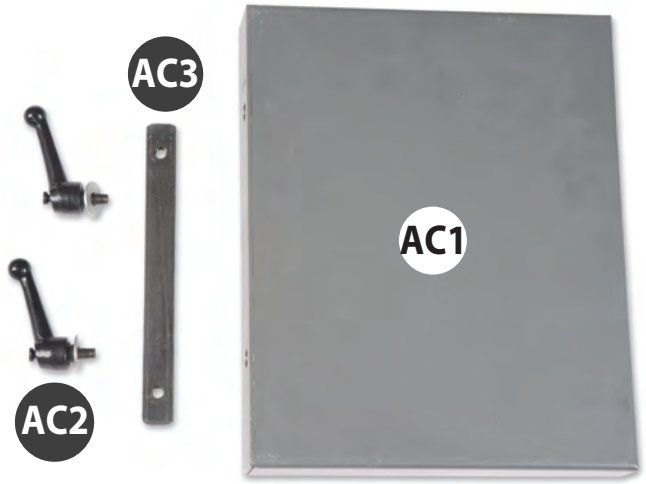
Quantity	Item	Part	Model Number
			MX5110A
1 No	AP200SM Spindle Moulder	AA	
1 No	Sliding Table Operating Handle	AA1	
Support Table Assembly		**AC**	
1 No	Support Table	AC1	
2 No	Lift & Shift Handles with Washers (M8 Thread)	AC2	
1 No	Pre-drilled Steel Plate	AC3	
Spindle Guard Assembly		**AD**	
1 No	Spindle Guard with Adjustable Fence	AD1	
2 No	Lift & Shift Handles with Washers M8 x 140mm	AD2	
1 No	Guide Assembly Mounting Bracket	AD3	
1 No	Fence Top & Side Guards	AD4	
Guide Assembly		**AE**	
1 No	Guide Arm & Guide Arm Clamping Plate	AE1	
1 No	Guide Assembly	AE2	
1 No	Anti-Kickback Assembly	AE3	
Mitre Fence Work Clamp Assembly		**AF**	
1 No	10mm Allen Key and 4mm Double Ended Allen Key		
Spindle Preset Stop Pin Assembly			
1 No	Spindle Preset Stop Pin 90˚ to -5˚	**AG**	
1 No	Instruction Manual		

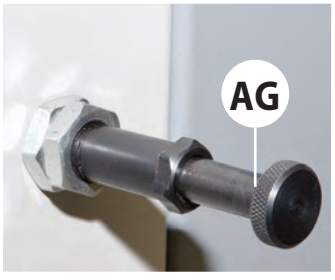
OPTIONAL ACCESSORIES

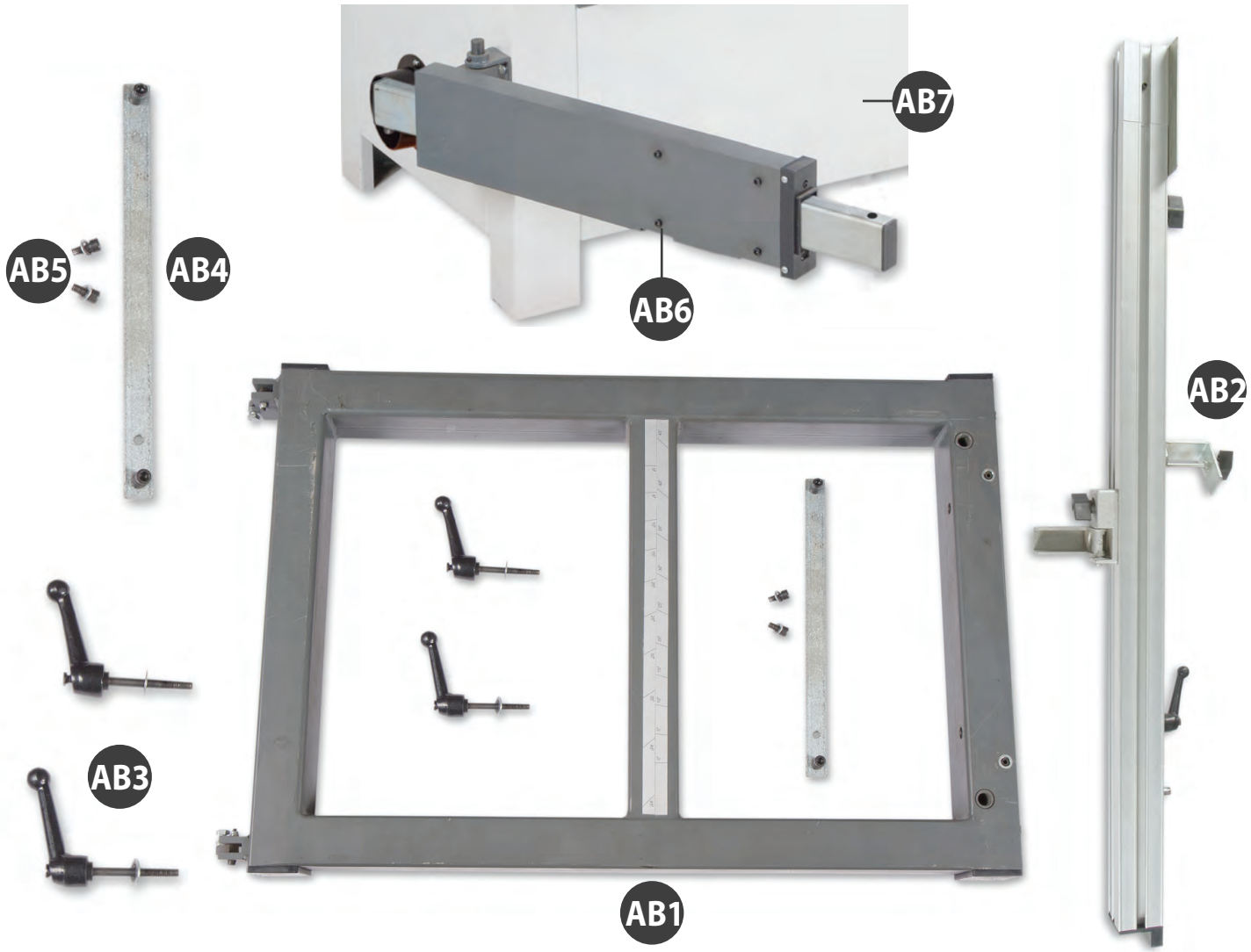
Quantity	Item	Part	
Extension Table Assembly		**AB**	Code: 950505
1 No	Extension Table	AB1	
1 No	Extension Table Fence (Adjustable)	AB2	
2 No	Lift & Shift Handles with Washers	AB3	
1 No	Pre-drilled Steel/Pin Plate	AB4	
2 No	Caphead Screws and Washers	AB5	
1 No	Pivot Arm with Four Bolts & Washers	AB6	
1 No	Extension Table Support Rod	AB7	
1 No	Co-Matic AF32 Junior Power Feed		Code: 340195
1 No	Tension Plate for AT200SM Spindle moulder		Code: 950506

WHAT'S INCLUDED









Code: 340195

Code: 950506

GENERAL INSTRUCTIONS FOR 230V MACHINES

The following will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.

WARNING!! KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN

KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.

Mains Powered Tools

- Tools are supplied with an attached 16 Amp plug.
- Inspect the cable and plug to ensuree that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.
- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.
- Carry out a final check e.g. check the cutting tool is securely tightened in the machine and the correct speed and function set.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check cutters are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

SPECIFIC SAFETY PRECAUTIONS

Authorised Use

This machine is designed for shaping wood and wood derived materials.

- Machining of other materials is not permitted and may be carried out in specific cases only after consulting with the manufacturer.

- The proper use also includes compliance with the operating and maintenance instructions given in this manual

- The machine must be operated only by persons familiar with its operation and maintenance and who are familiar with its hazards.

- The required minimum age must be observed.

- The machine must only be used in a technically perfect condition.

- When working on the machine, all safety mechanisms and covers must be in operation.

- In addition to the safety requirements contained in these operating instructions and your country's applicable regulations, you should observe the generally recognized technical rules concerning the operation of woodworking machines.

- Any other use exceeds authorisation.

- In the event of unauthorised use of the machine, the manufacturer renounces all liability and the responsibility is transferred exclusively to the operator.

General Safety Notes

- Woodworking machines can be dangerous if not used properly. Therefore the appropriate general technical rules as well as the following notes must be observed.

- Read and understand the entire instruction manual before attempting assembly or operation.

- Keep these operating instructions close by the machine, protected from dirt and humidity, and pass them over to the new owner if you part with the tool.

- No changes to the machine may be made.

- Daily inspect the function and existence of the safety appliances before you start the machine.

- Remove all loose clothing and enclose long hair.

- Before operating the machine, remove tie, rings, watches, other jewellery, and roll up sleeves above elbows.

- Wear safety shoes; never wear leisure shoes or sandals.

- Always wear the approved working outfit.

- Do not wear gloves while operating the machine.

- For the safe handling of cutting tools wear work gloves.

- Control the stopping time of the machine, it may not exceed 10 seconds.

- Remove cut and jammed work pieces only when the machine is at a complete standstill and motor is turned off.

- Install the machine so that there is sufficient space for safe operation and work piece handling.

- Keep work area well lit.

SPECIFICATION

Code	107703
Model	AP200SM
Rating	Trade/Professional
Power	2.8 kW 230V 1ph
Spindle Travel	100 mm
Spindle Diameter	30 mm
Spindle Speed	1,800, 3,000, 6,000 & 9,000 rpm
Max Spindle Projection above Table	100 mm
Max Tooling Diameter Above Table	200 mm
Max Tooling Diameter Below Table	180 mm
Table Height	900 mm
Table Size	1,000 mm x 360 mm
Min Extraction Airflow Required	1,000 m^3/hr
Noise Level dB(A)	77.2dB(A)
Dust Extraction Outlet	2 x 100 mm
Overall L x W x H	1,010 mm x 690 mm x 900 mm
Weight	218 kg

PLEASE NOTE: FOR YOUR OWN SAFETY IT IS REQUIRED THAT TWO PEOPLE ASSEMBLE THIS MACHINE!

Unpack all the boxes and check all the components against the "What's in the Boxes' List. If any parts or components are missing, please contact our customer services department using the procedures and telephone numbers liste on our website, and you will be dealt with quickly and efficiently.

Having unpacked the boxes, (please dispose of any unwanted packaging responsibly), put the parts and components whereby they are readily to hand. Break down the main box by knocking the sides away (be careful of exposed nails etc.), but leave the machine sitting on its pallet. Remove the protective grease film that is coating all the unpainted parts of the machine.

Support Table Assembly

Fig 01

Fig 02

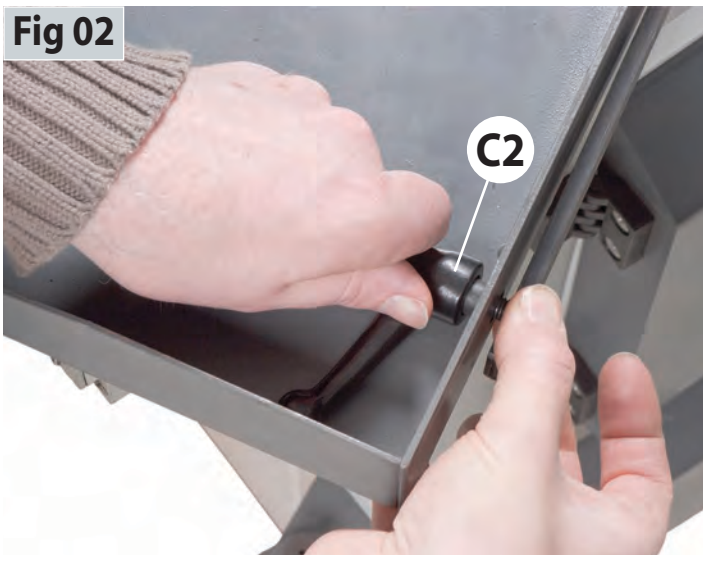


Fig 03

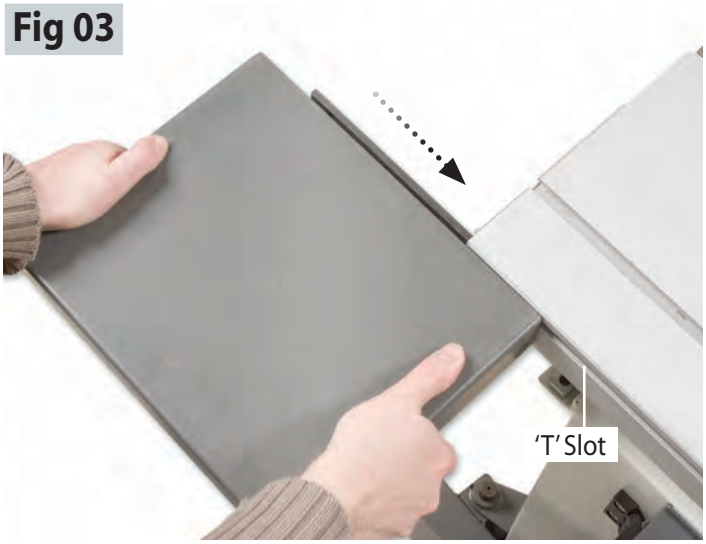
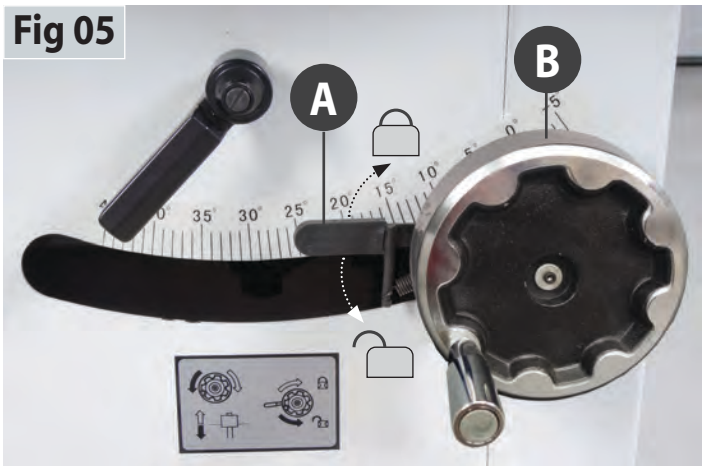


Fig 04

Spindle Guard Assembly

1. Raise the spindle to its maximum height by unlocking the spindle moulder's rise/fall locking handle (A) and turning the operating wheel (B) clockwise. Re-lock the spindle in place, see fig 05.

Fig 05



Fence Guards

The spindle moulder comes with new guarding and guide arm assembly. Please follow the instructions below to install.

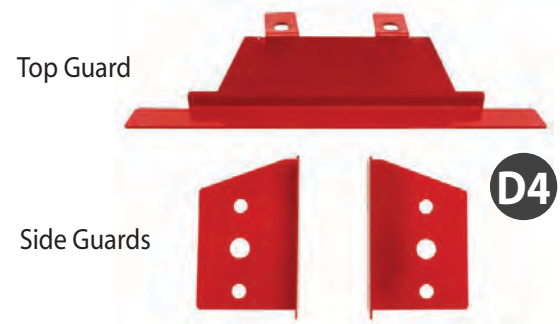
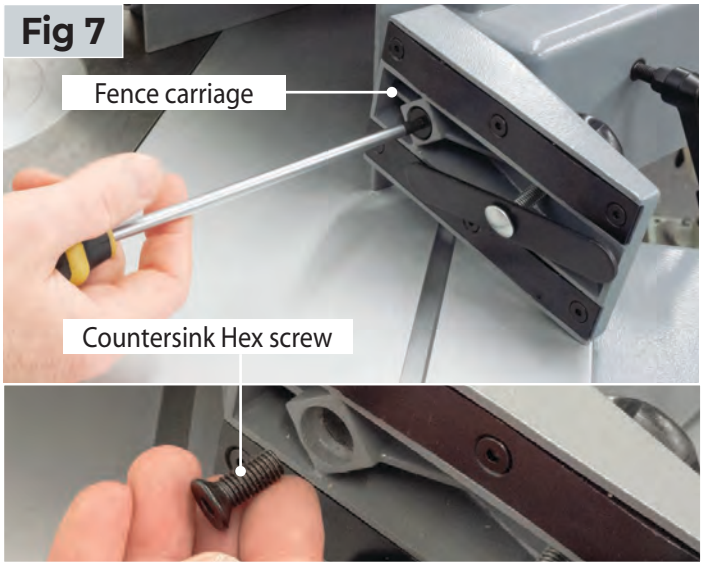


Fig 6

Fig 7



1. Remove the both fence's and place safely aside, see fig 01. Using a Hex key remove the countersink screws holding the fence carriages and slide the carriages off the shafts, see fig 07.

2. Locate the left and right side angle guards (B), line up the centre holes in the guards and slide them over the shafts, see fig 08.

3. Replace both carriages and secure in place, see fig 09-10-11.

4. Slide the adjustable aluminium fences back onto the carriages and nip-up the locking knobs, see fig 12.

Fig 8

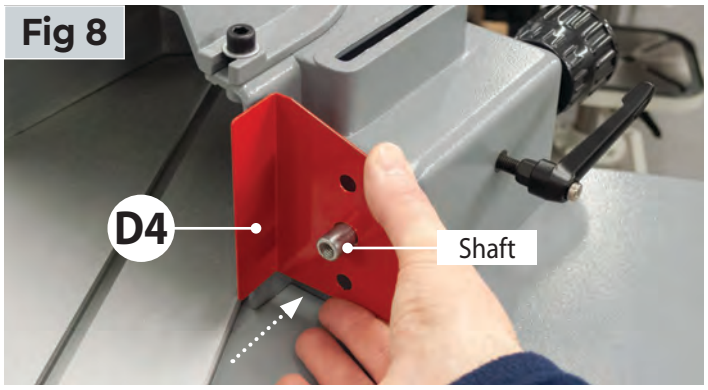


Fig 9

Fig 10

Fig 11

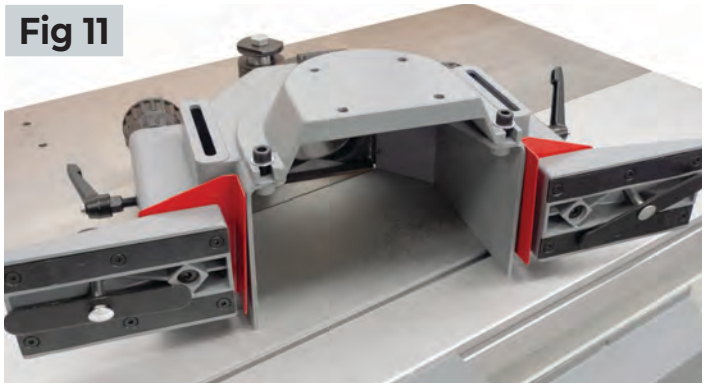
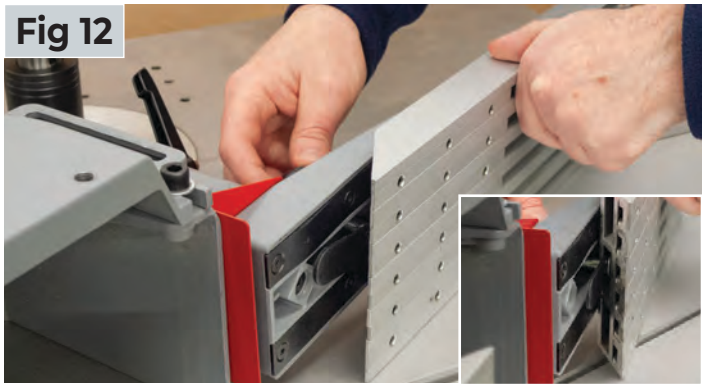


Fig 12



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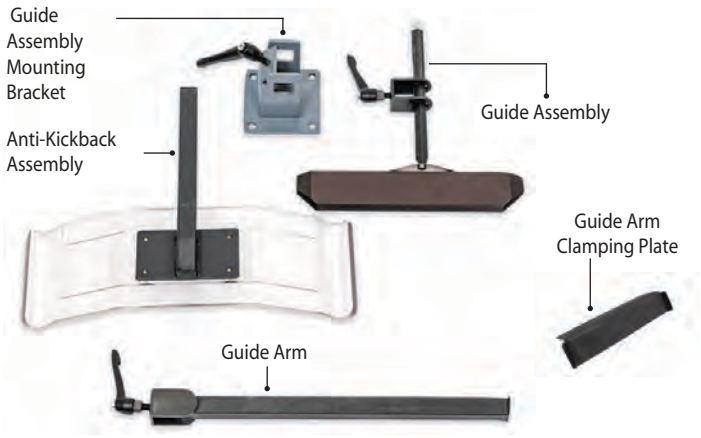
Guide & Anti-Kick Back Assembly



1. Lower the spindle guard assembly (D1) down onto the table, line up the two threaded holes on either side of the spindle with the slots in the guard secured in place with the lift & shift handles (D2), see fig 13-14-15.

2. Secure the guide mounting bracket (D3) on top of the spindle guard assembly (D1) using two cap head bolts & washers, see fig 09. **NOTE: Only use the two rear holes on the mounting bracket in preuration for the next step.**

Fig 13

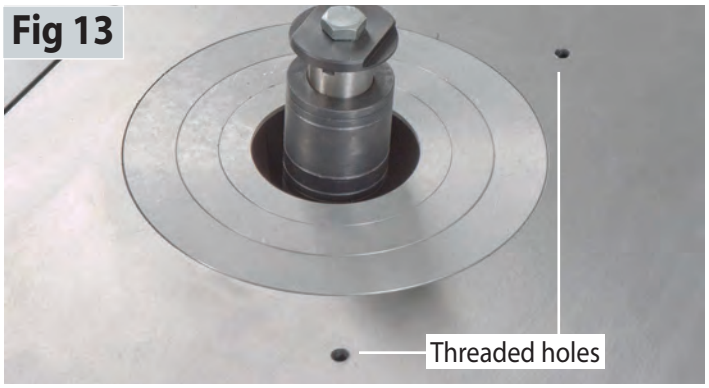


Fig 14

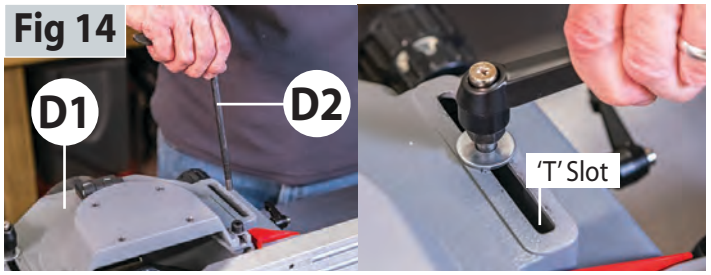


Fig 15

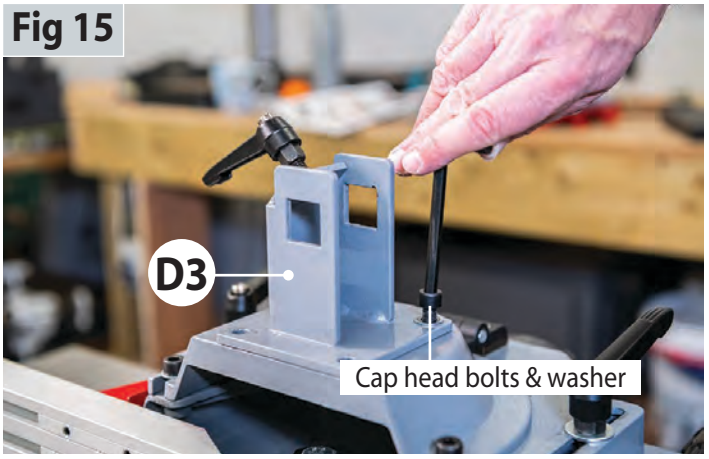
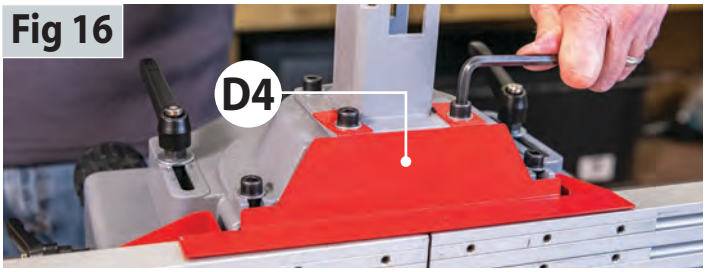


Fig 16



3. Locate the top guard (D4) and two cap head bolts/washers. Lower the guard down on top of the adjustable fence. Line-up holes in the top guard with the holes on the guide mounting bracket (D3) and secure in place with the cap head bolts/washers, see fig 16.

4. Put together the guide assembly as shown in figures 17-18-19.

5. Slide the guide assembly arm through the mounting bracket and nip-up the clamping handle.

Fig 17

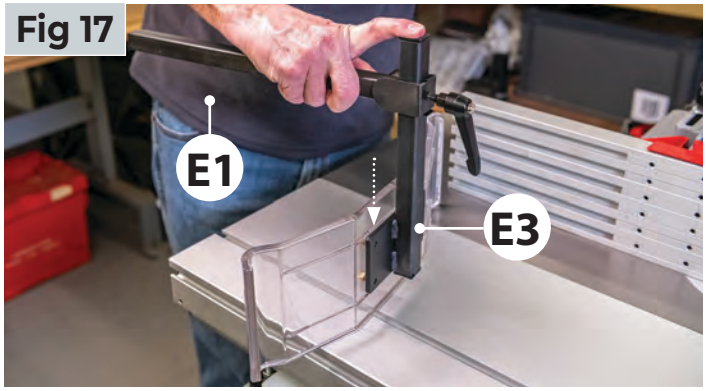


Fig 18

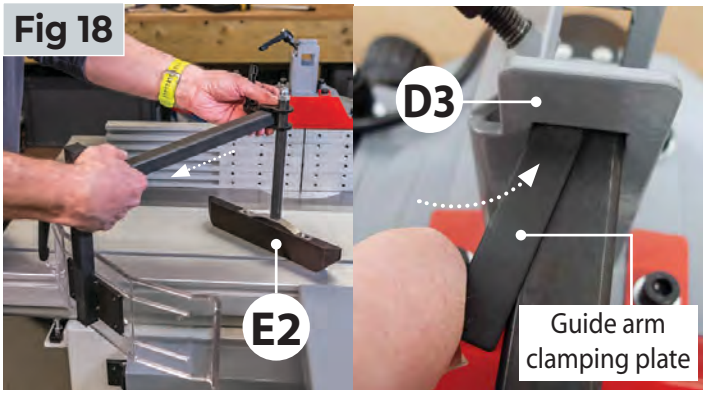
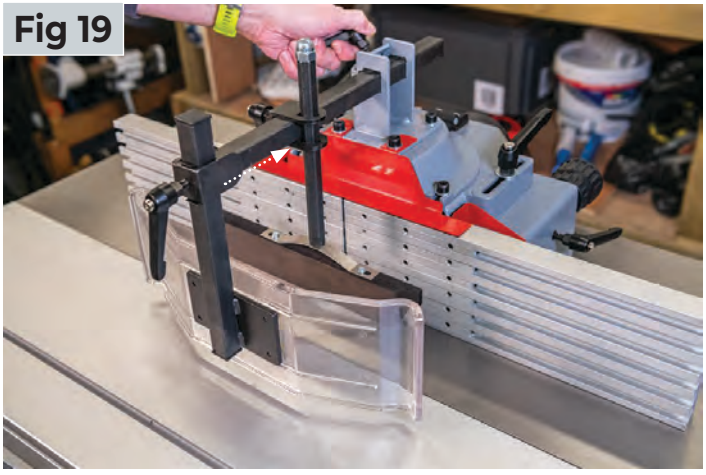
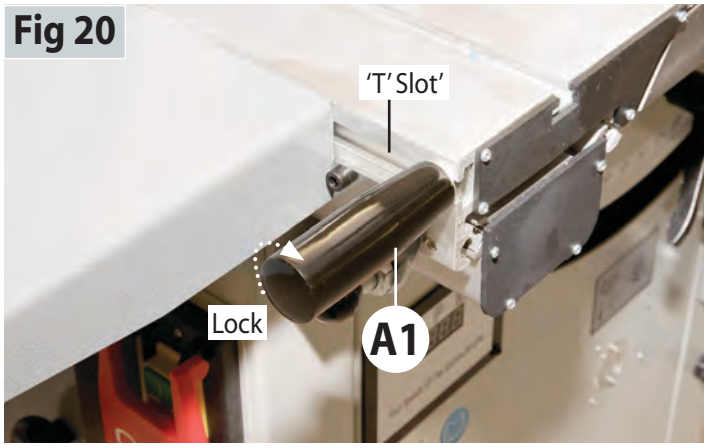


Fig 19



Sliding Table Operating Handle

Fig 20



Mitre Fence Work Clamp Assembly

Fig 21

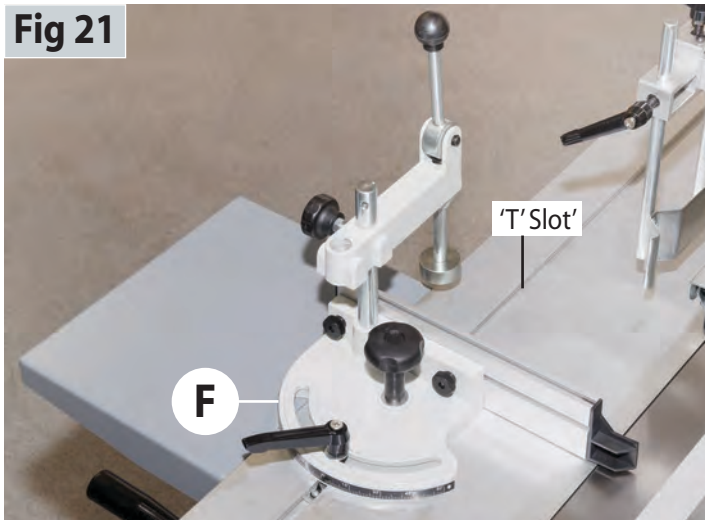


Fig 22

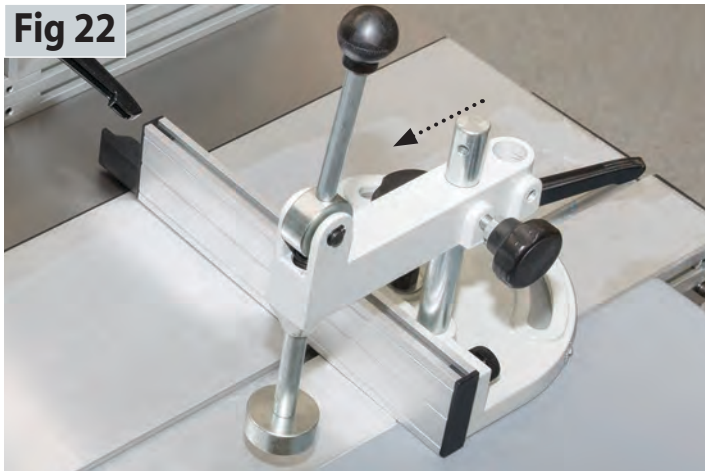
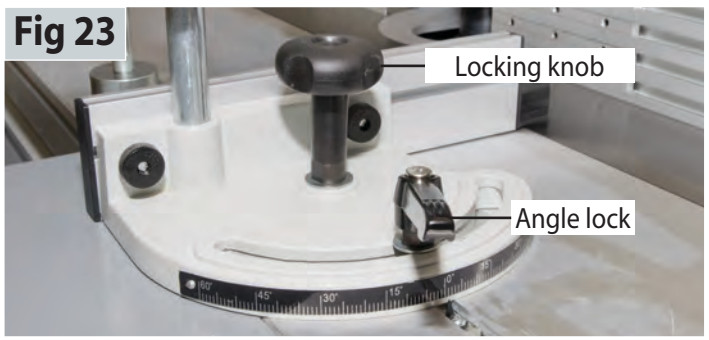


Fig 23



Optional Extension Table Assembly (Code 950505)

1. Line up the pivot arm mounting bracket (B6) with the four threaded holes to the side of the spindle moulder (A) and secure in place with four bolts and washers provided, see fig 24-25-26-27.

Fig 24

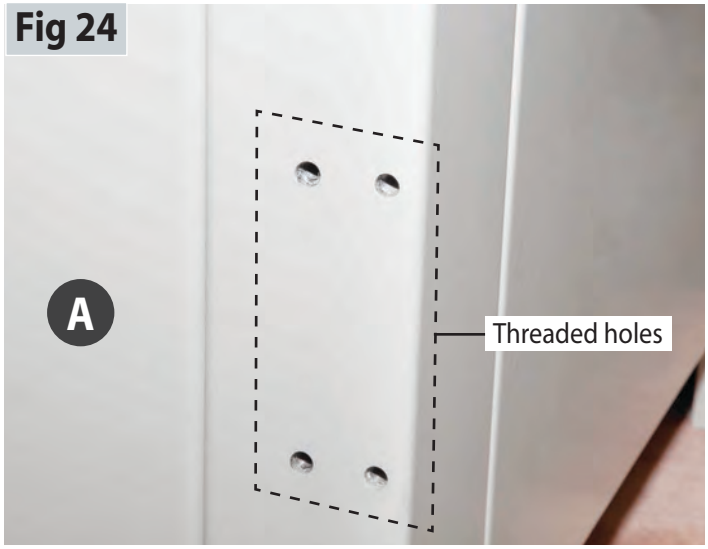
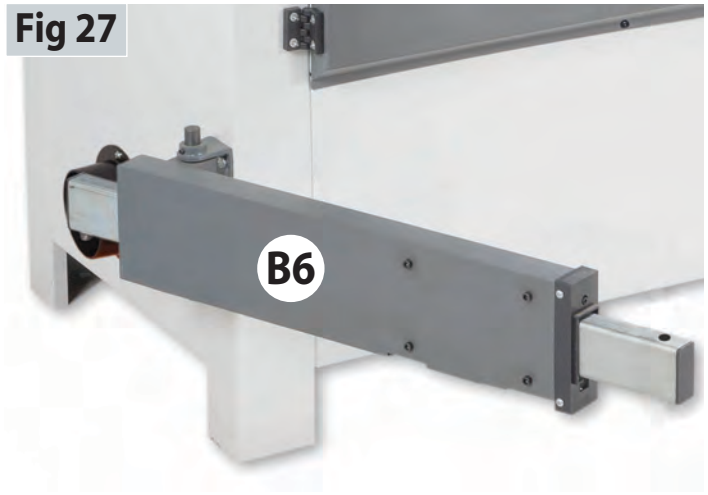


Fig 25

Fig 26

Fig 27



2. Pull out the extension table support arm (B6) and introduce the support rod (B7) through the hole on the support arm (B6) and secure in place using the nuts and washers, see fig 28-29.

Fig 28

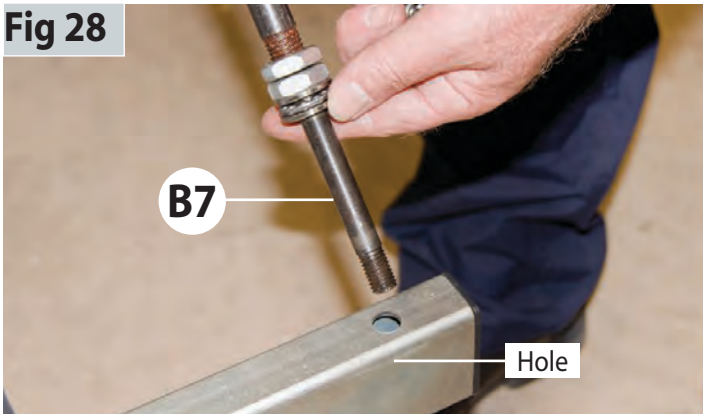


Fig 29

3. Slide the steel/pin plate (B4) into the machined 'T' slot to the left side of the sliding table, see fig 30-31.

Fig 30

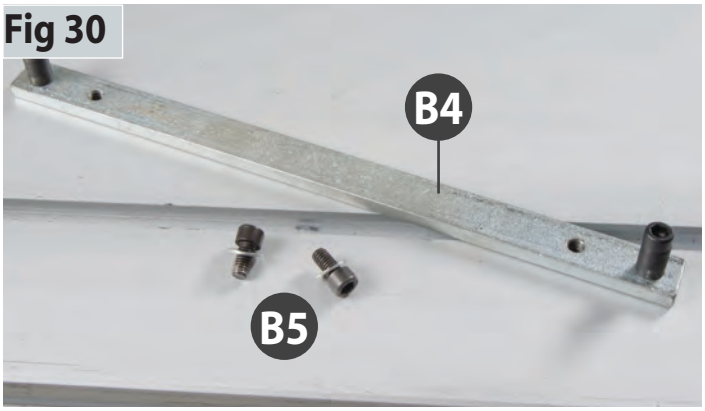


Fig 31

Fig 32

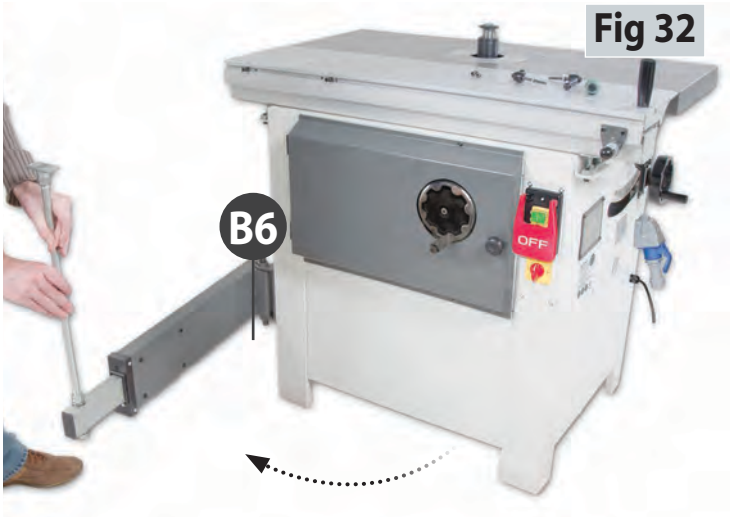


Fig 33

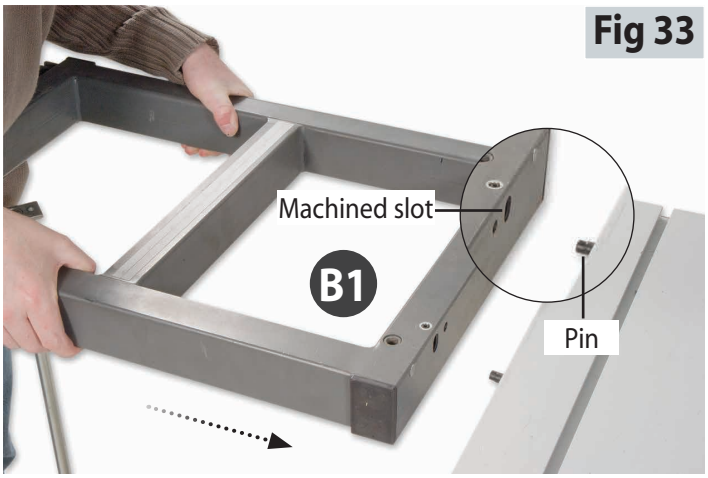
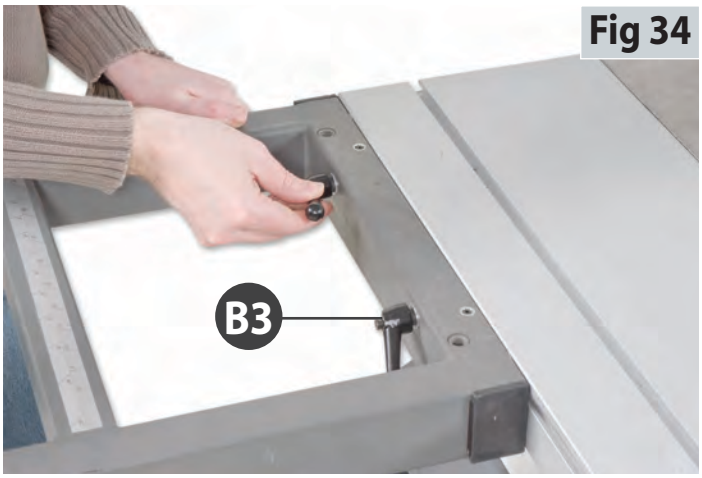


Fig 34



4. Pull out the table support arm (B6), insert the machined slots in the extension table (B1) over the pins (B4). Locate the two lift & shift handles (B3), insert them through the holes in the table (B1) into the threaded holes in the steel plate (B4), see fig 32-33-34.

5. Locate the two cap head screws/washers (B5), line up the table support rod bracket (B7) with the two pre-drilled holes beneath the extension table (B1) and secure in place with the cap head screws (B5), see fig 35.

Fig 35

Fig 36

6. Place a straight edge across both tables and using a Hex key adjust the two grub screws on the extension table (B1) until both tables are level, see fig 36-37.

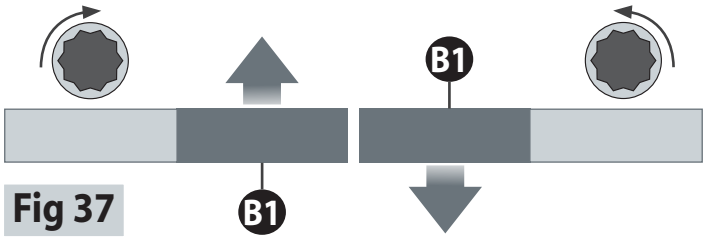


Fig 37

7. Place a level on the extension table (B1) and using two spanners adjust nuts on the support rod (B7) until the extension table is level, see fig 38-39.

Fig 38

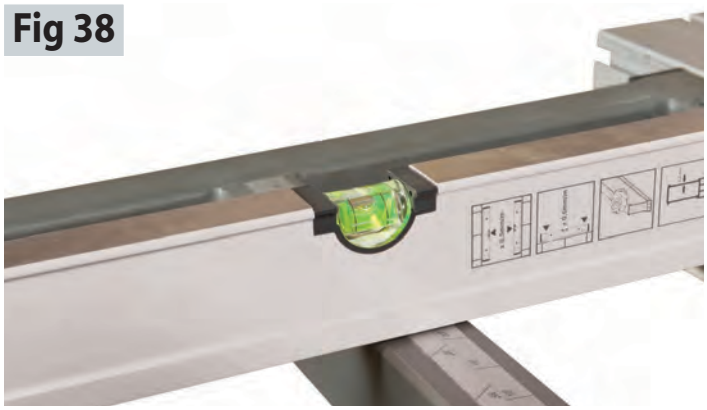


Fig 39

8. Lift up the left 90˚ stop, see fig 40 lower the fence (B2) down onto the extension table (B1) making sure the 'PIN' beneath the fence engages into the hole on top of the extension table (B1). Push the fence up against the 90˚ stop, see fig 41-42.

9. Slide the fence clamping bracket (B2) over the tables column (B1) and tighten the butterfly nut. Lastly turn the fence locking handle to secure it in position, see fig 43-44.

Fig 40

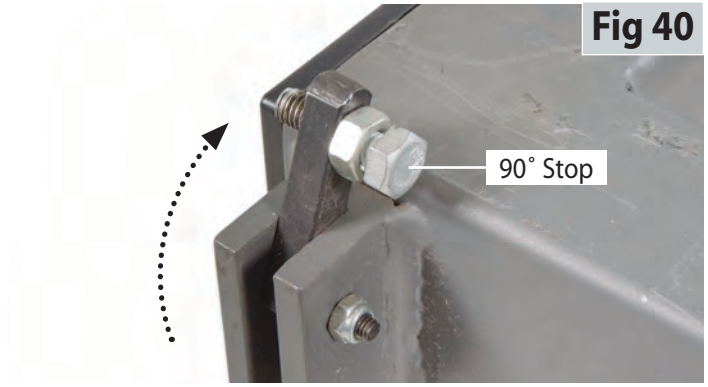


Fig 41

Continues Over...

Fig 42

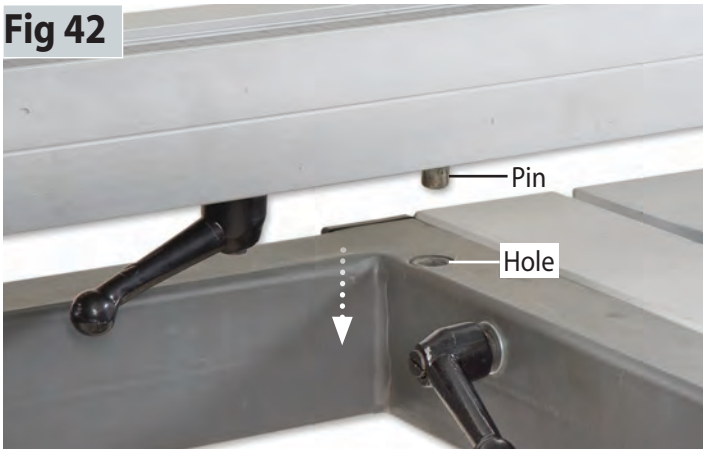


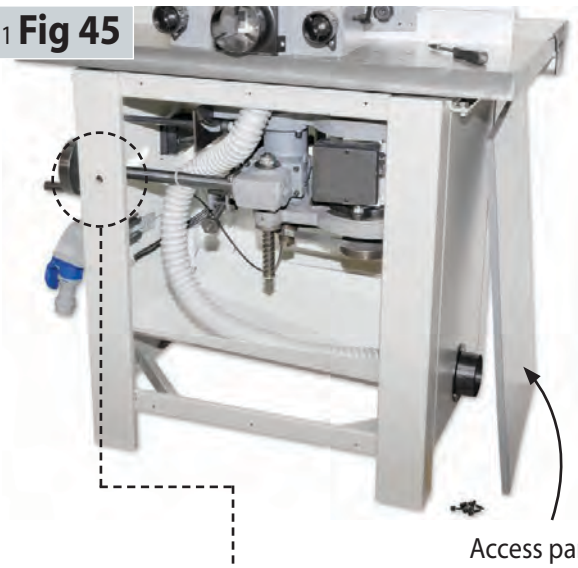
Fig 43

Fig 44

Spindle Preset Stop Pin 90˚ to -5˚

Follow the instructions below to assemble the spindle stop assembly (G).

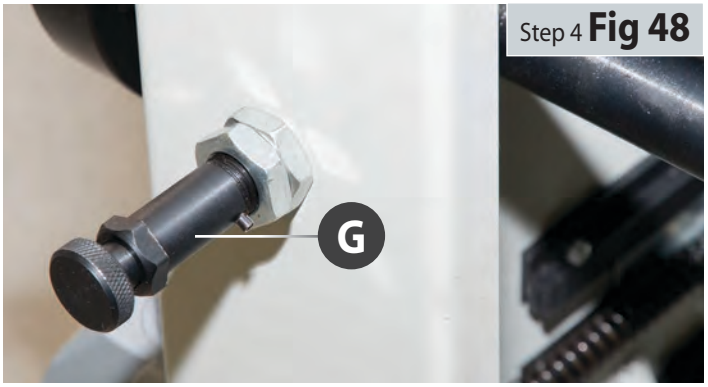
Step 1 **Fig 45**



Step 2 **Fig 46**

Step 3 **Fig 47**

Step 4 **Fig 48**



Step 5 **Fig 49**

Sliding table locking knob
Pull out the knob and twist

NVR Switch assembly with a slap down emergency stop lever

Reversing selector switch

Mitre fence work clamp assembly

Fully adjustable fences (A) with adjustable fingers (B)

Spindle at -45˚ degrees

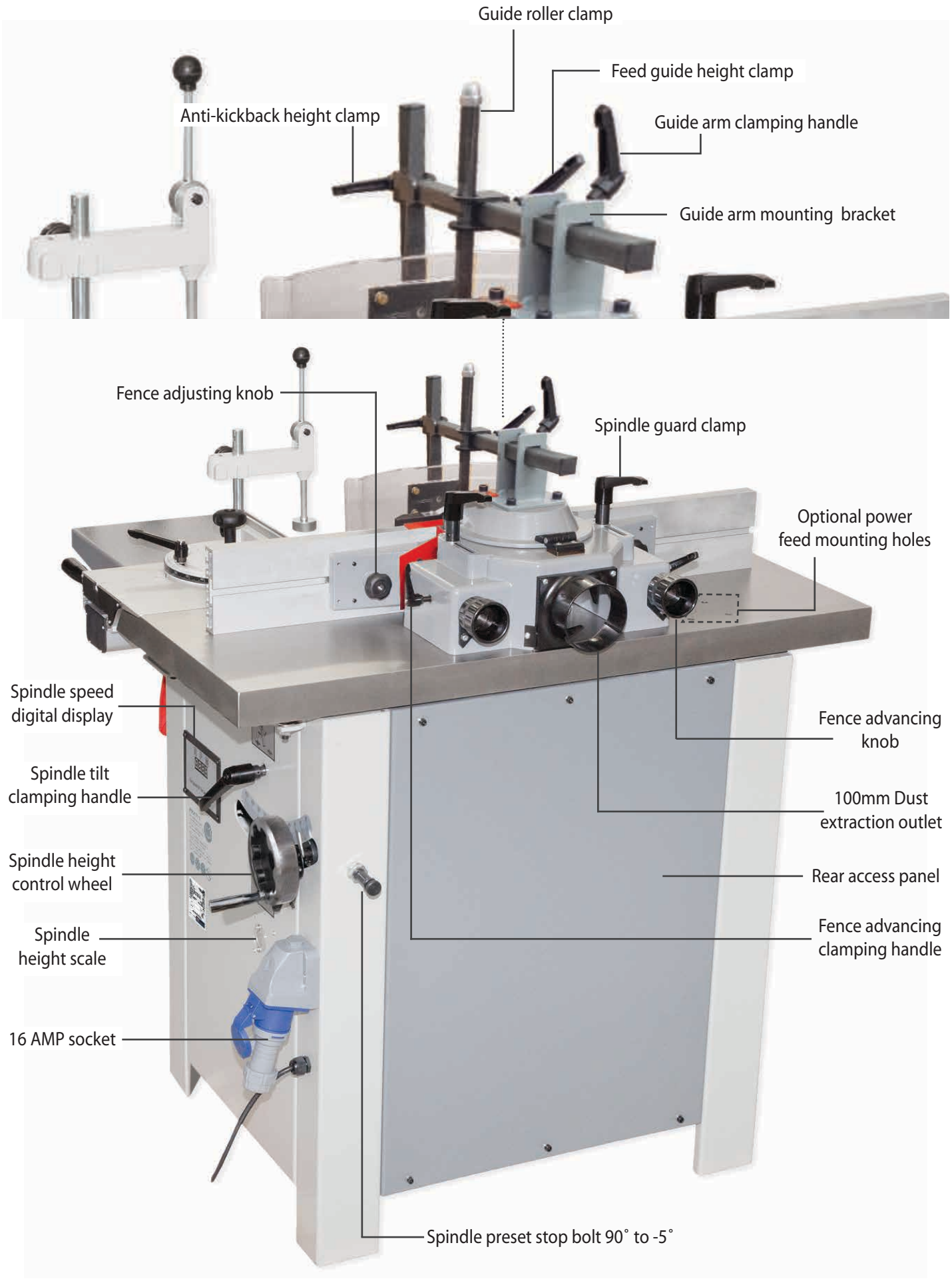
Spindle at 90˚ degrees

Spindle at +05˚ degrees

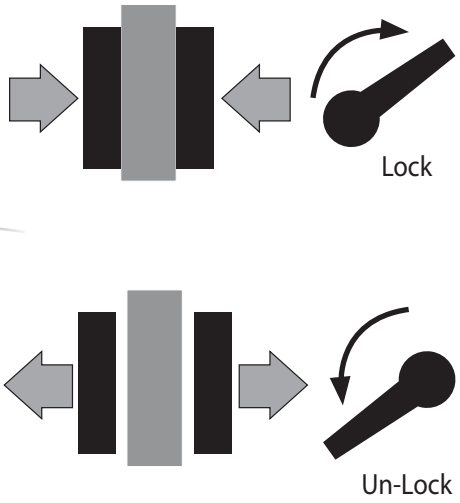
Spindle tilt operating wheel

Spindle preset stop pin set at 90˚ degrees

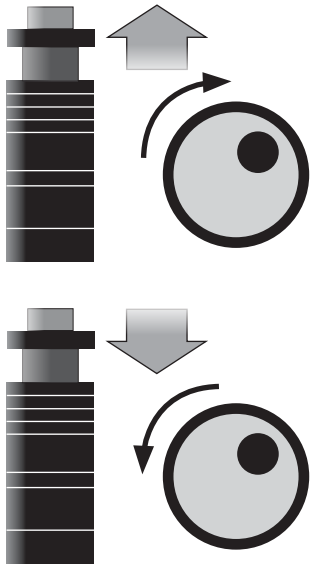
Spindle preset stop pin set at +05˚ degrees


Guide roller clamp
Feed guide height clamp
Anti-kickback height clamp
Guide arm clamping handle
Guide arm mounting bracket
Fence adjusting knob
Spindle guard clamp
Optional power feed mounting holes
Spindle speed digital display
Fence advancing knob
Spindle tilt clamping handle
100mm Dust extraction outlet
Spindle height control wheel
Rear access panel
Spindle height scale
Fence advancing clamping handle
16 AMP socket
Spindle preset stop bolt 90˚ to -5˚

Spindle tilt locking handle and scale (A), Spindle rise & fall locking handle (B), Spindle height scale (C), 16 AMP socket for optional AF32 power feed assembly (D)



Spindle tilt clamp illustration



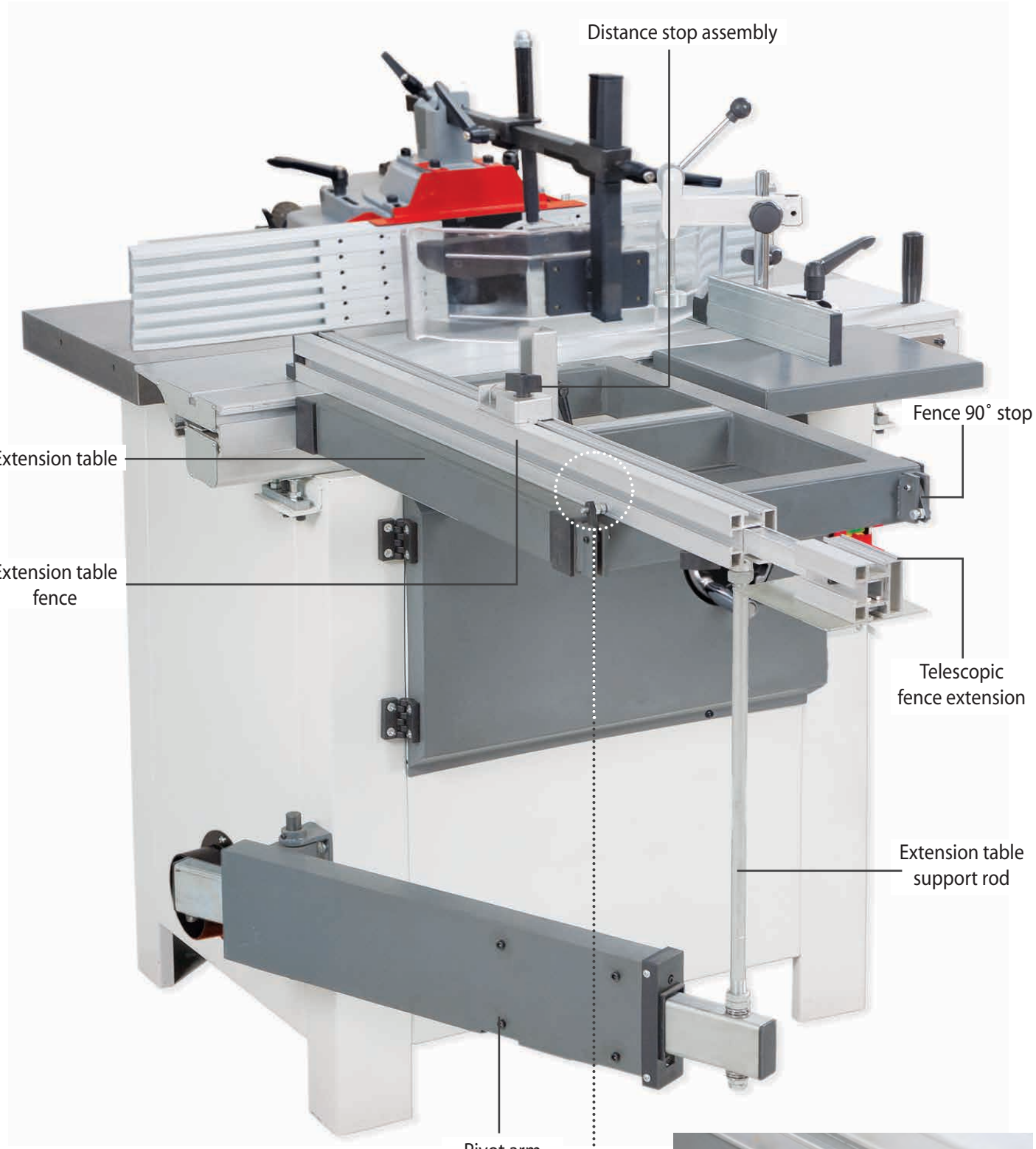
Spindle rise and fall illustration

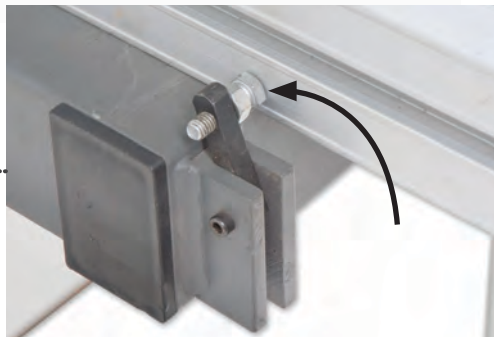
Spindle height scale

Spindle tilt scale

Spindle speed digital display

Spindle Moulder with Extension Table Fitted





Extension table fence 90˚ stop

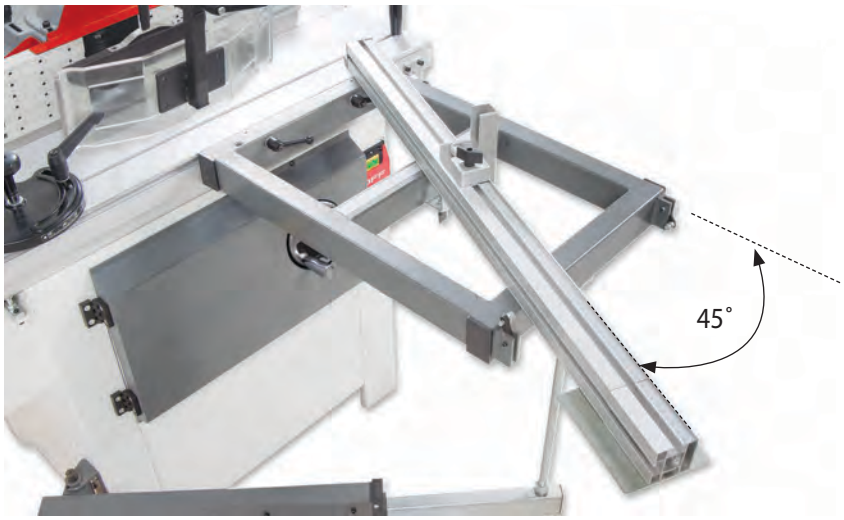
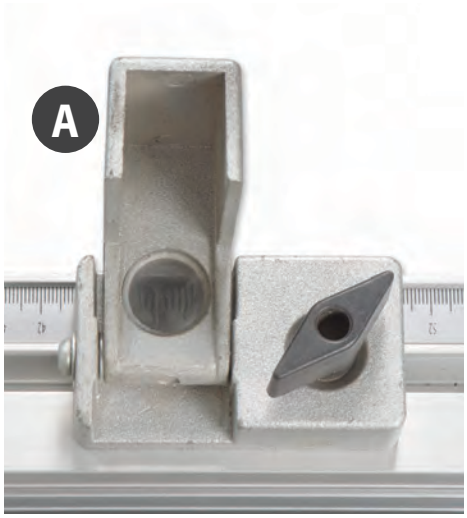
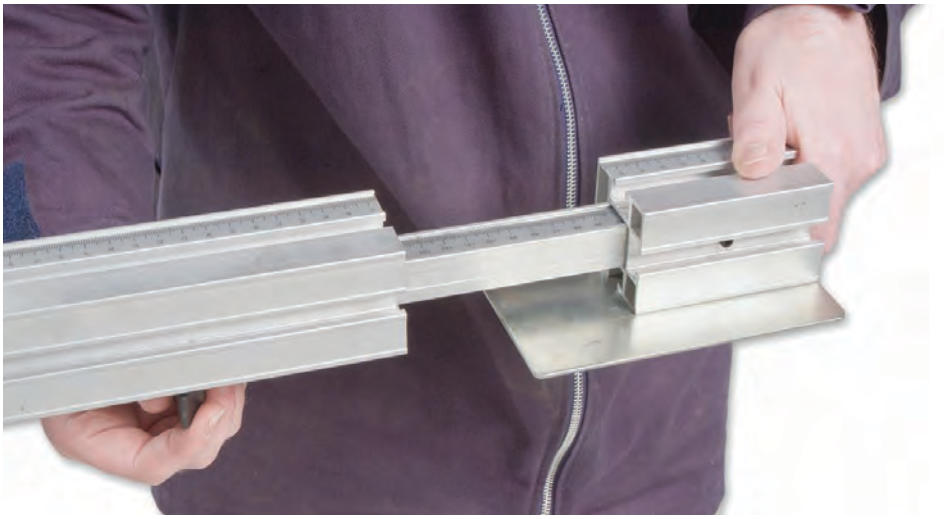


Table fence set to 45˚

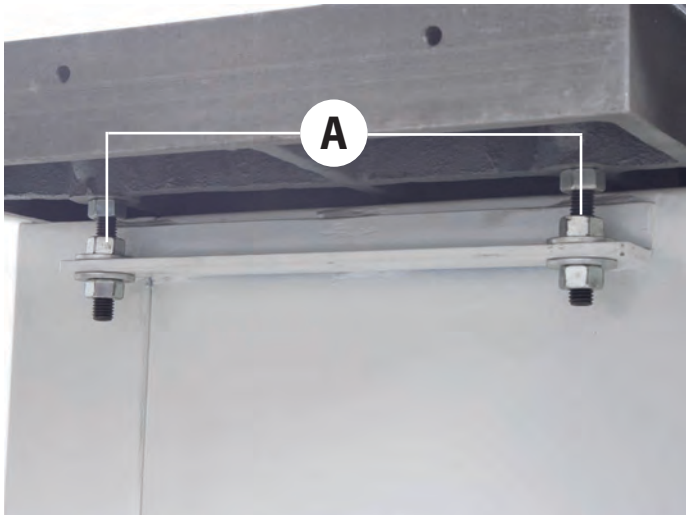
Extension table angle scale



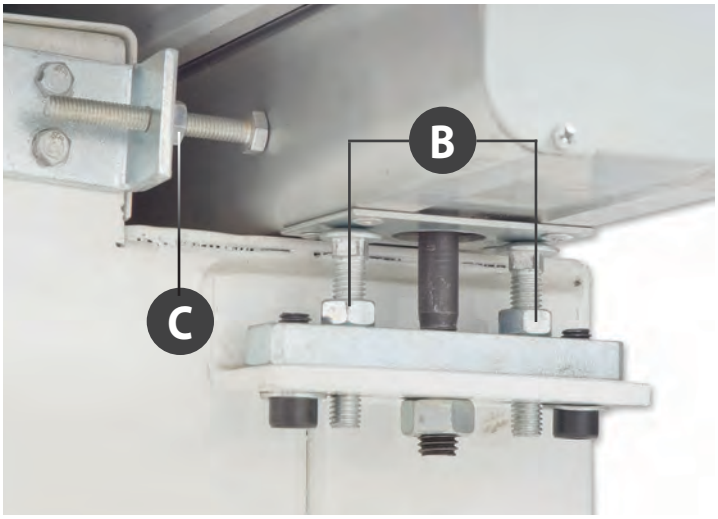
Distance stop assembly
magnifying glass (A), Clamp (B)



Telescopic extension assembly



Main table height adjusting nuts (A)



Sliding table height adjusting nuts (B)
Table clearance adjusting nut (C)

Ascertain the orientation of the machine and move it to its desired position in the workshop. Ensure that the machine is positioned to allow sufficient clearance all round to cater for the maximum length of timber you wish to machine.
The machine should be positioned on a flat level surface.
Manoeuvre the machine to the chosen location, then carefully lower the machine down.

SAFETY WARNING!

The WS1000TA Spindle Moulder is a heavy piece of equipment. You are advised to seek help or the use of some form of lifting device, (hoist, engine crane etc.,) before you attempt to lift or move this machine.

SETTING THE FENCE

The fence is a two piece adjusting system. Each fence is independently adjustable to compensate for different cutting thicknesses. Make sure the fence is square to the work surface, place a 90° square up against the fence and check it is perpendicular to the work surface. If adjustment is required turn the fence adjusting knob (a) until it is correct, see fig 50-51-52.

Fig 50

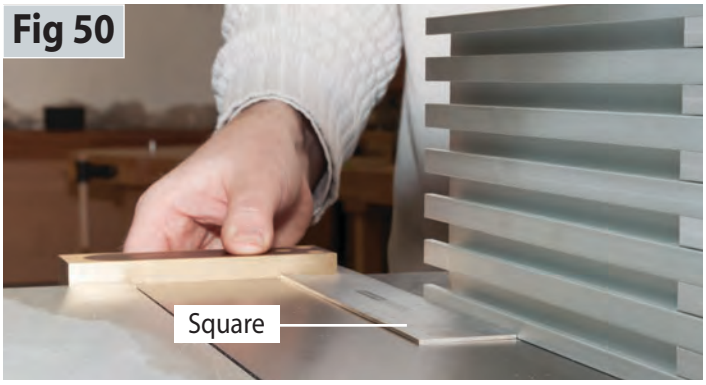


Fig 51

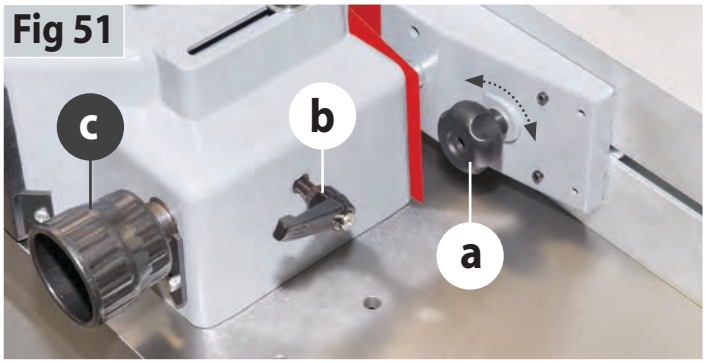
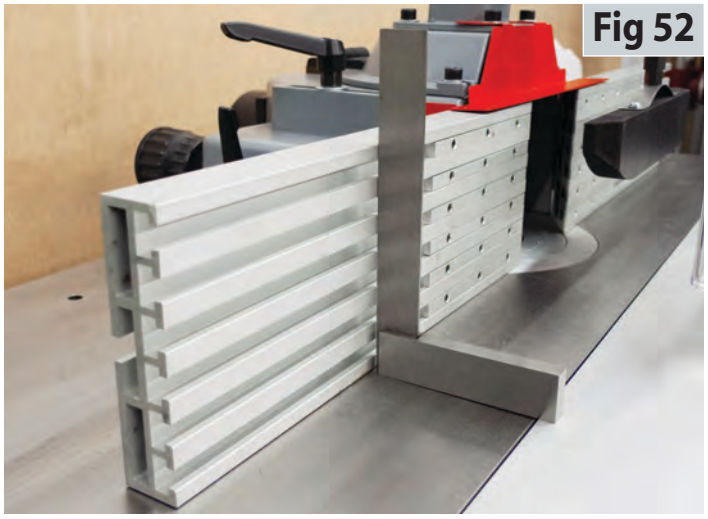
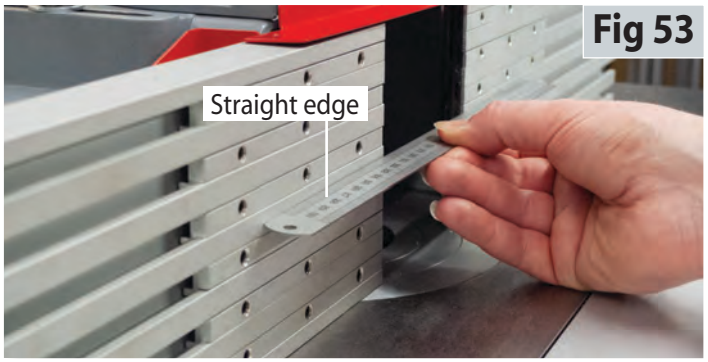


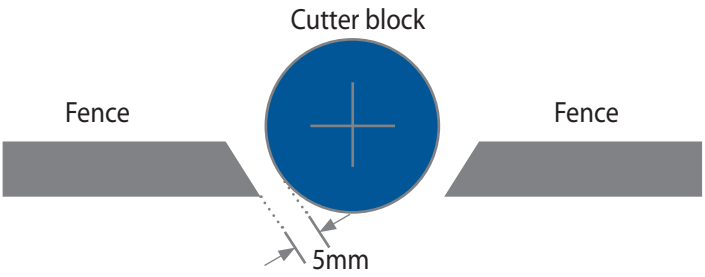
Fig 52



Place a straight edge up-against both fences, loosen the fence advancing clamping handles (b) and turn the fence advancing knobs (c) until both fences are aligned, see fig 53.

Fig 53

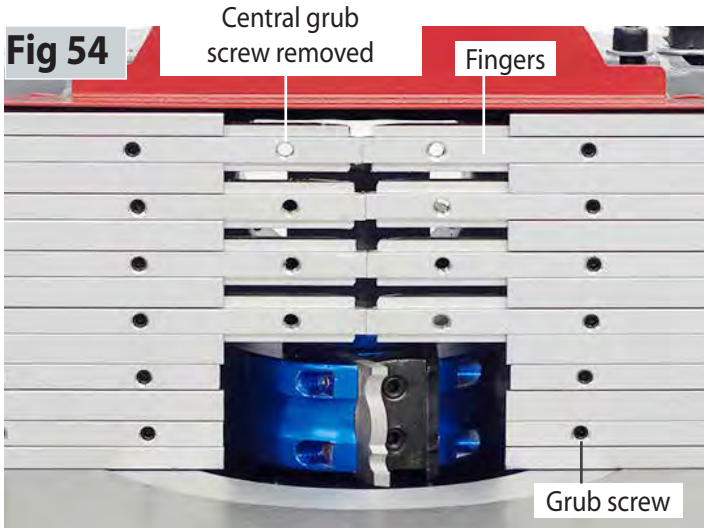




Adjust the position of the fence assembly to give both the required cutter protrusion and adequate clearance between the cutter and the fence. Close up the aluminium fences to give approximately 5mm clearance around the cutter, see diagram above.

NOTE: For improved safety the fence assembly has an integral finger fence system designed to enclose the gap around the cutting area. Set the cutter block & fence to the desired position, release the 3 grub screws & slide each finger into position leaving approximately 6-8mm gap around the cutter block., see fig 53.

- Remember to remove all central grub screws that aren't locked in place.

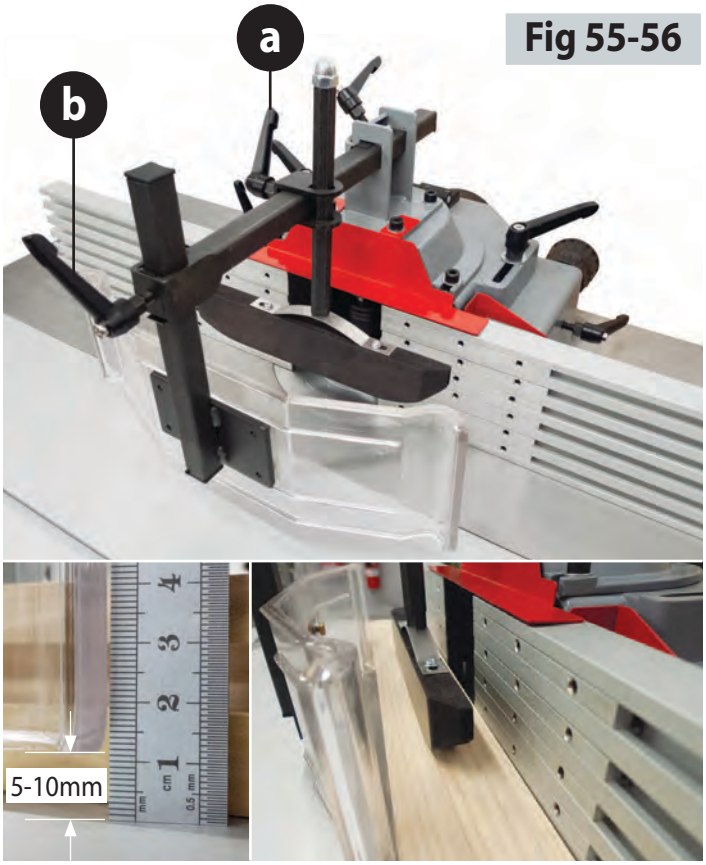


The fence is used to guide small work pieces through the cutter without them being trapped between the fence and the cutter. The dust extraction hose is connected to the aperture at the rear of the fence assembly.

Before starting work, carefully check that the cutter can rotate freely without fouling the inside of the guard and that the guard is clamped firmly in place.

Adjusting the Feed Guide & Ant-Kickback Assembly

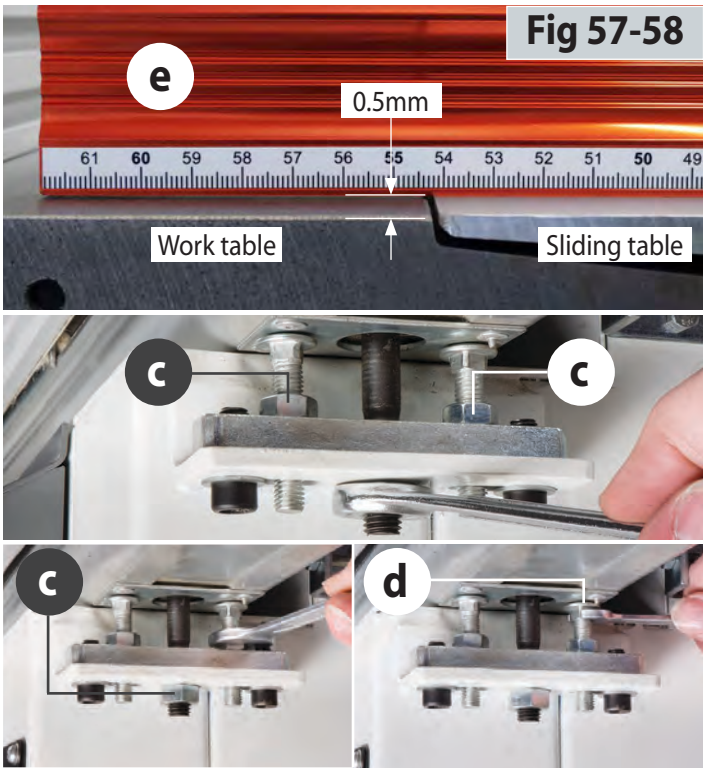
Loosen the feed guide clamp handle (a) and move the feed guide to the centre of the work piece, retighten the handle. Undo the anti-kickback clamp handle (b) and move the assembly near the work piece, retighten the handle. Raise the anti-kickback assembly so the steel plate is about 5-10mm above the work table, see figs 55-56.



Levelling the Sliding Table

Note: The tables are preset at the factory but can be adjusted.

The sliding table should sit 0.5mm above and level with the main saw table. Place a straight edge (e) across the joint of both tables, if adjustment is required loosen the 3 nuts (c) beneath the sliding table and adjust the two coach bolts (d) to obtain thecorrect position, retighten the three nuts, see fig 57-58.



Sliding Table Clearance

Fig 59

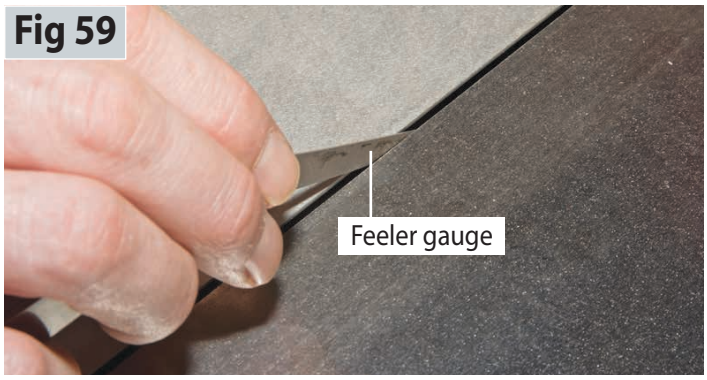
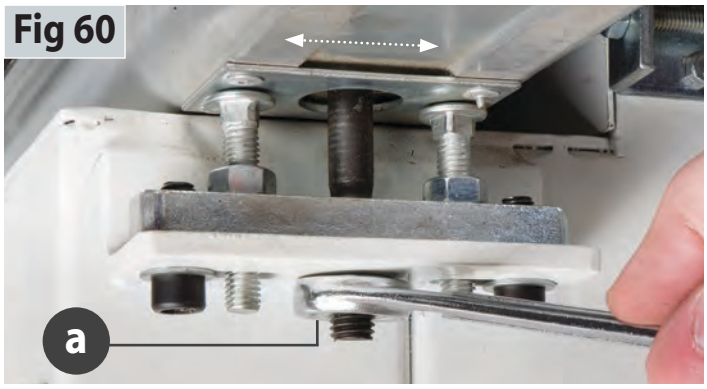


Fig 60



Loosen the sliding table clamping nut (a). Slot the feeler gauge down the gap between the two tables from one side and adjust until the gap is set between (0.5 to 2mm), repeat the procedure for the opposite side. Retighten the nuts (a) to secure the table in position, see fig 59-60.

Changing the Cutter Block

Raise the spindle to the maximum height by unlocking the rise/fall locking handle (A), turning the spindle moulder rise/fall handle (B) clockwise then lock in place, see fig 60-61. Using a 19mm spanner remove the bolt & clamping block (C), spacing collar/s (D) and clamping washer (E) and place them safely aside, remove the cutter block, see fig 62. Check the new cutter block for damage,sharpness etc. Fit the new cutter block on the arbor as low as possible, see fig 63-64. Watch the direction of rotation (counter-clockwise) when mounting the cutter. Replace the clamping washer (E), spacing collar/s (D), clamping block (C) and bolt. Tighten securely.

Fig 60

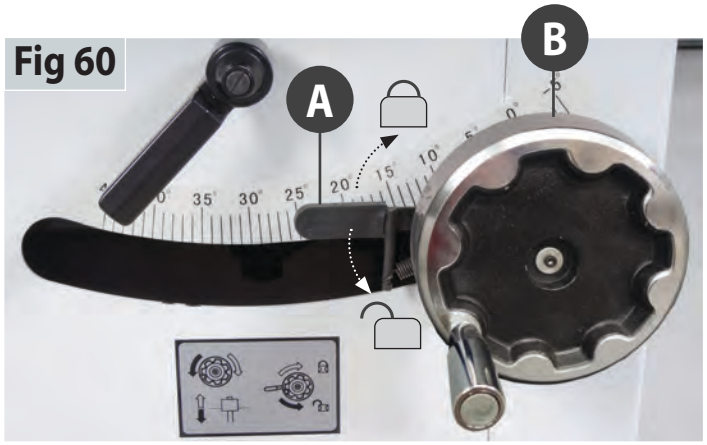
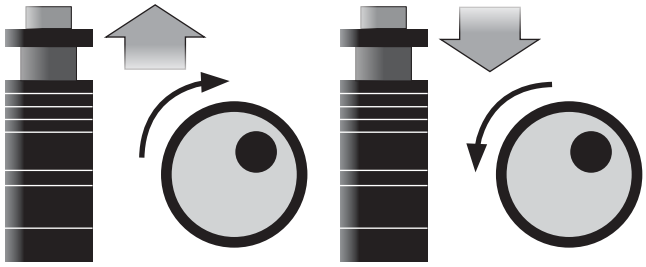


Fig 61



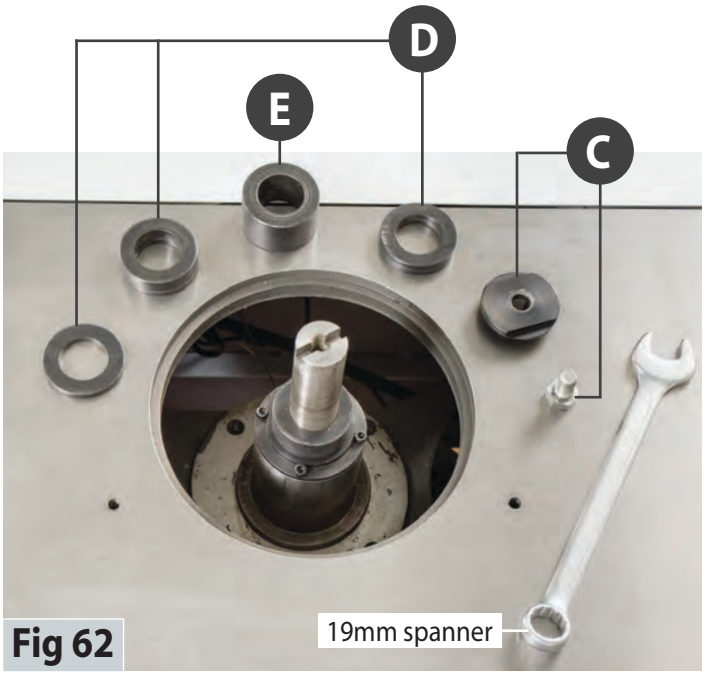
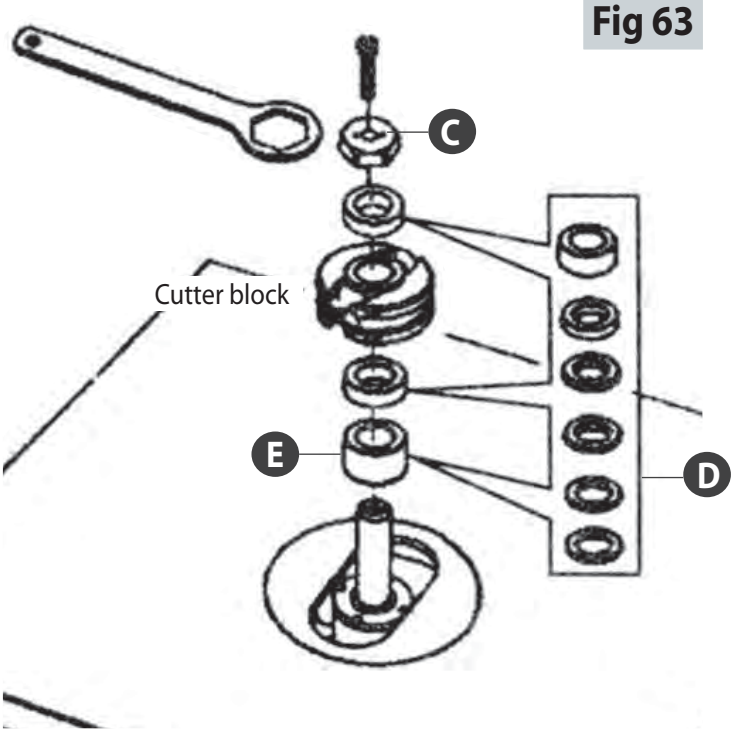


Fig 62

Fig 63



Continues Over...

IMPORTANT NOTES:

• There is a risk of personal injury by cuts from the cutter knives. Wear suitable gloves when changing cutters.

Only use tooling with manual feed cutter blocks marked "MAN", see fig 65.

• Clean all surfaces of cutters and spindle arbor before remounting the cutter block.

• Unsuitable, incorrectly mounted, dull, cracked or bent cutter knives can break or increase the risk of kickback considerably.

• The installation of sanding or polishing tools is not permissible.

• The cutter block must be positioned on the arbor as low as possible, see diagrams below.

• Watch the direction of rotation (counter-clockwise) when mounting the cutter.

• Fill the space between cutter and clamping washer with spacing collars.

• Tighten the arbor cap head screw securely.

• Don't use a wrench extension or a hammer to tighten the cap head screw.

• Cover the clearance zone around the cutter with table insert rings

Fig 64

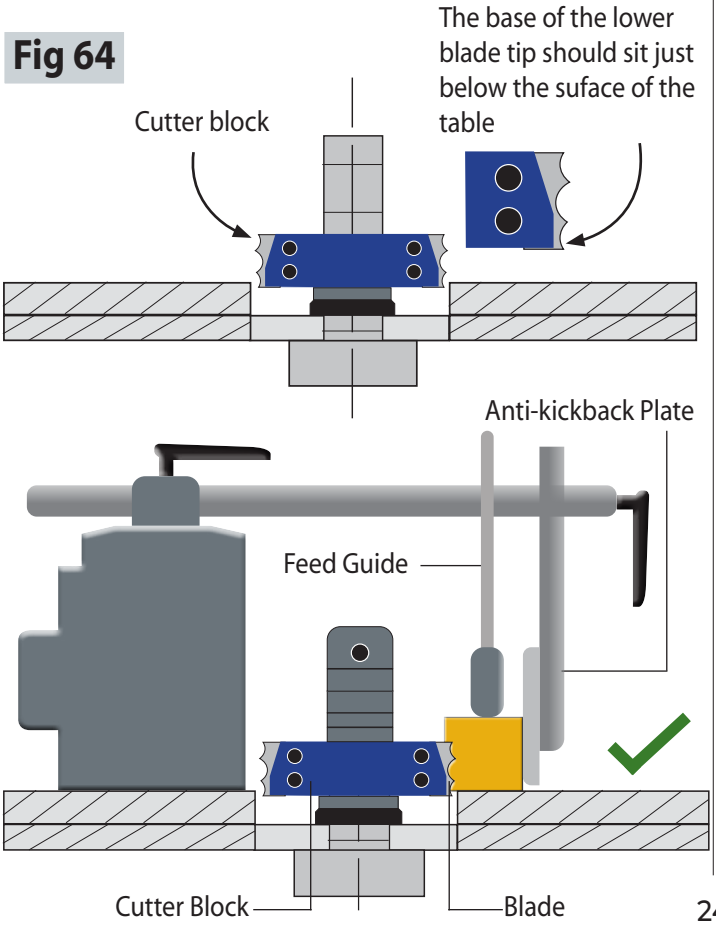


Fig 65

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY

Changing the Spindle Speed

Open the motor access door to the front of the machine, by removing the two cap head screws, see figs 66-67 lower the spindle to it's lowest point, if not done so already. Locate the 10mm Hex key (F), loosen the cap head bolt (G) on top of the motor, pull the motor tension lever (H) out, to allow the belt to go slack and reposition the belt on the pulleys as required. When you are happy, push back the tension lever H) and tighten the cap head bolt (G) to keep the tension, see fig 68-69.

Fig 66

Fig 67

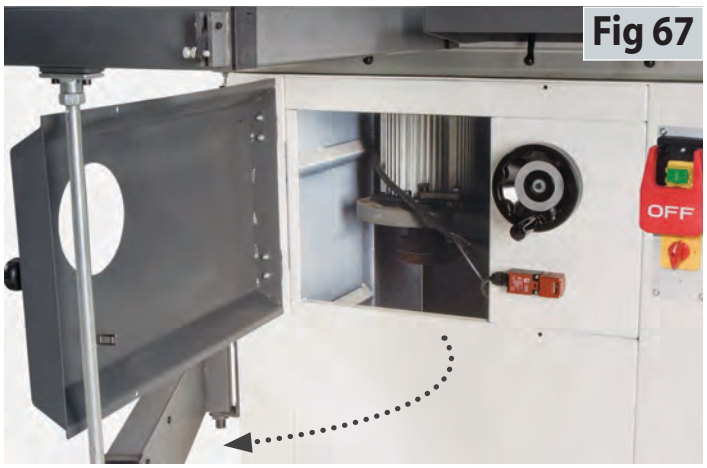


Fig 68

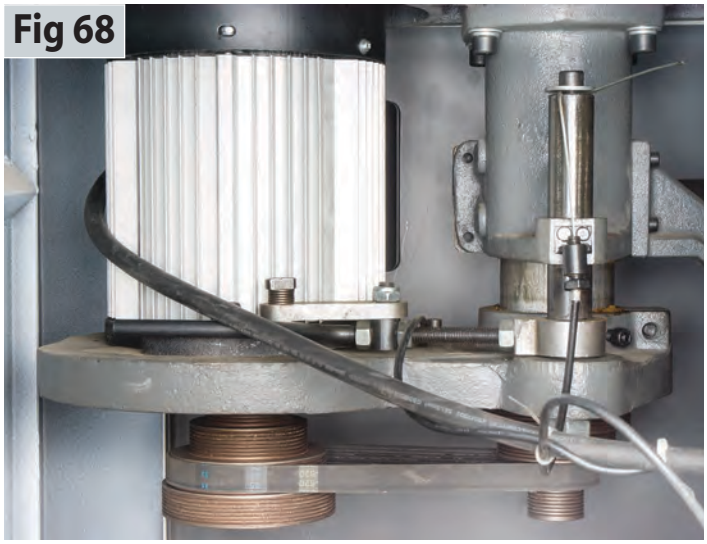
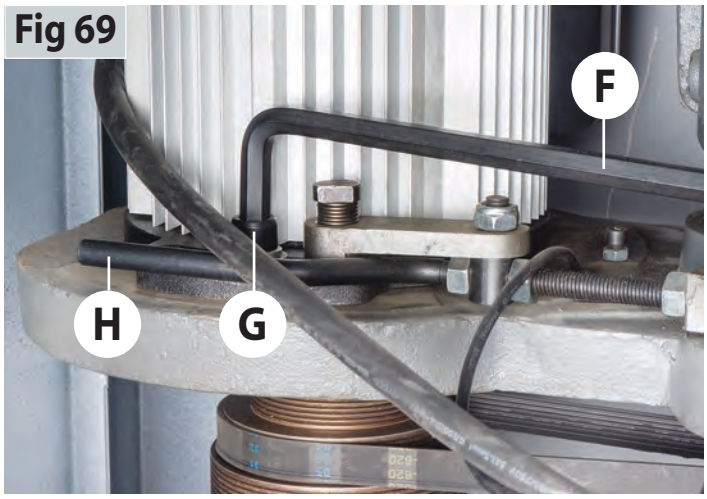
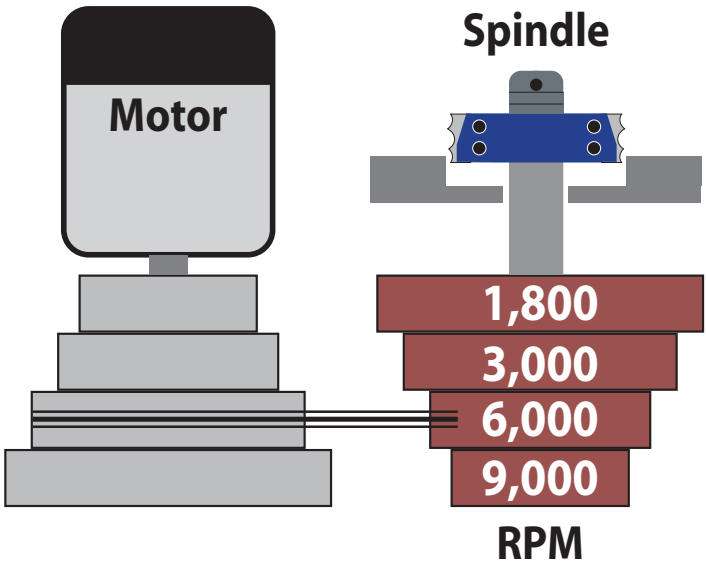


Fig 69



Spindle Chart

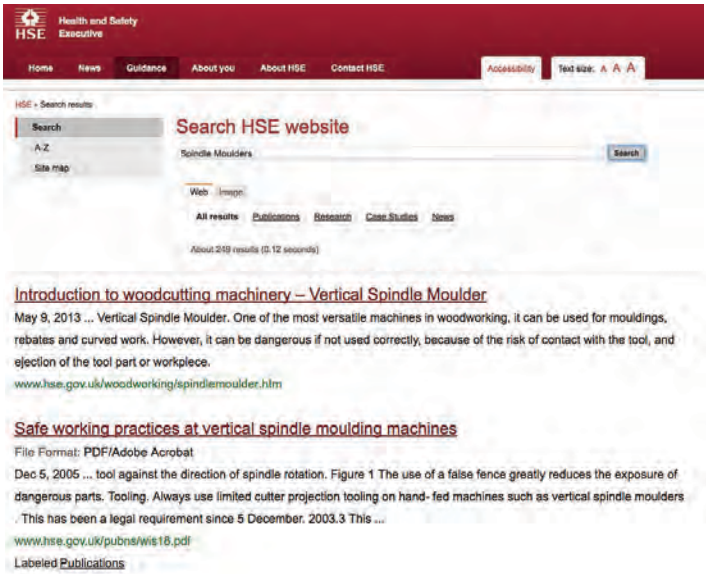


Close the access door, raise the spindle, reconnect the machine to the mains supply. Give the machine a 'quick' burst check (i.e. quick ON-OFF) to ensure everything is O.K. If everything is satisfactory, continue to use the machine.

OPERATING INSTRUCTIONS

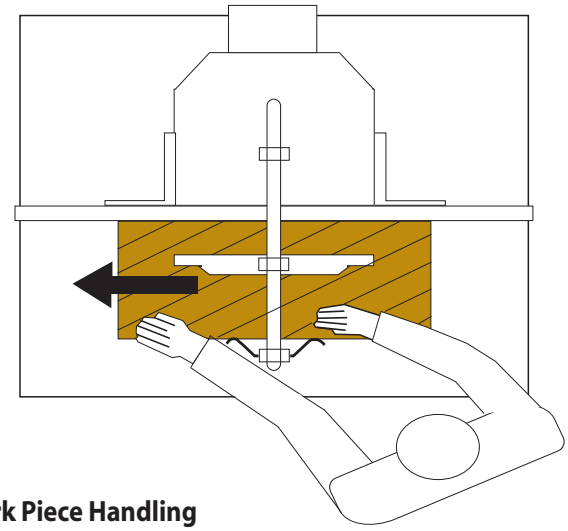
HSE (Health and Safety Executive)

To operate the machine correctly, it is recommended to read the HSE (Health and Safety Executive) information working sheet on the safe use of the Spindle Moulder.



Correct Operating Position

Position yourself offset to the machine as shown.



Work Piece Handling

- Feed the work piece straight across the machine table, holding the fingers close together and guiding the work piece with the palms of your hands.

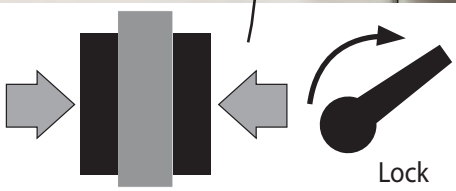
Continues Over...

- Feed the work piece straight across the machine table, holding the fingers close together and guiding the work piece with the palms of your hands.
- Never put your hands under or behind the cutter guard.
- Always keep your hands well clear of the rotating cutter.
- Always feed the work piece against the cutter rotation as shown by the arrow in illustration.
- Use a push stick when working the ends of narrow stock.
- Use a feeding aid if you are going to machine a work piece shorter than 300mm.
- Always machine the work piece over its entire length.

Recess machining may only be carried out with the aid of suitable longitudinal work piece stops.

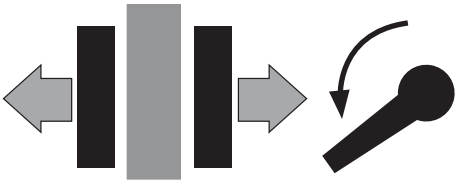
- When working complex shapes, make jigs and guides to guide the work piece properly and safely.
- Make trial cuts on a piece of scrap before working the actual work piece.
- Support long work pieces with roller stands or table extensions.
- Always work one work piece at a time.

Setting the Spindle Angles



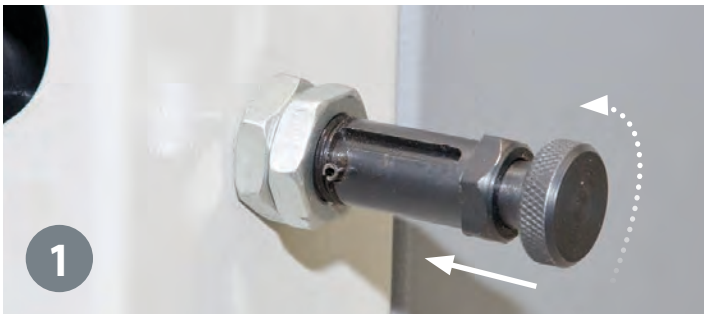
Lock

2



Un-Lock

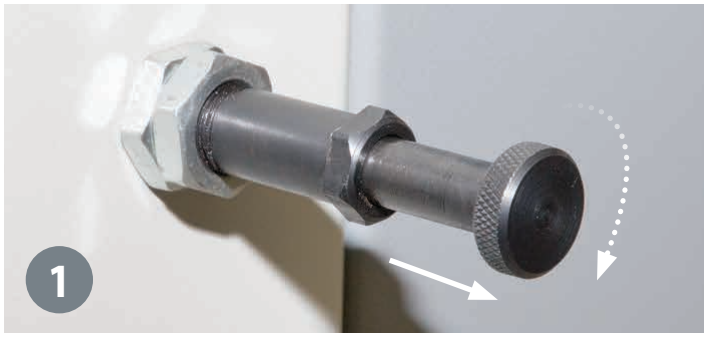
Setting Spindle at 90˚ (degrees)



Preset stop bolt set at 90˚ degrees

Spindle at 90˚ degrees

Setting Spindle at -5˚ (degrees)



Preset stop bolt set at +05˚ degrees

Spindle at +05˚ degrees

Setting Spindle at 45˚ (degrees)

Spindle at 45˚ degrees

Optional Accessories

The spindle moulder can be fitted with the following optional accessories:

Extension Table Assembly Code: 950505

This accessory is a support table complete with a telescopic support arm. It clamps to the sliding table to provide extra support when machining panels or the ends of long boards, see fig 70.

- Provides support for panels and long boards
- Easy to fit and can be removed for storage when not required
- Supplied with a long fence with a length stop

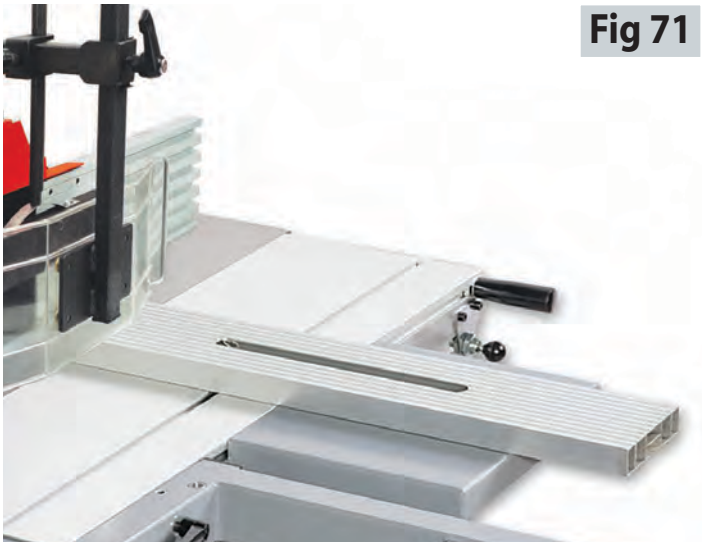
Fig 70

Tenon Plate Code: 950506

This accessory is a simple alloy plate that lifts the work piece above the table. This means that you can machine the top and bottom surface of the work, such as when creating a tenon. It can be mounted next to the mitre fence and clamp so as to make the machining of end grain material as safe as possible. Overall length 650mm x 120mm width, see fig 71.

- Special tenon plate to allow machining to the top and bottom of the work piece
- Allows up to 200mm diameter tooling to be used
- Easy and safe to use, clamps next to the mitre fence

Fig 71



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Co-Matic AF32 Junior Power Feed Code: 340195

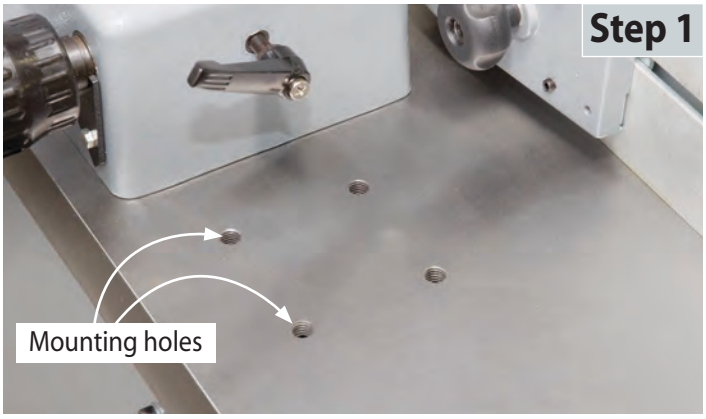
A medium weight power feed unit with three PU rollers, all spring-loaded to provide a constant feed rate for many machining or cutting tasks. There is a choice of four feed speeds, easily selectable by removing the side plate and re-positioning the drive gears. Reverse feed is available via a selection switch. The horizontal and vertical position of the drive head can be precisely adjusted with the aid of the two adjusting screws and then securely locked in place with the two handles. An additional feature is the ability to rotate the head through 90° so that pressure can be applied to the work in either the vertical or horizontal planes. The unit is secured to the table of the machine, by bolting through or by screwing into holes tapped into the machine bed, see fig 72.

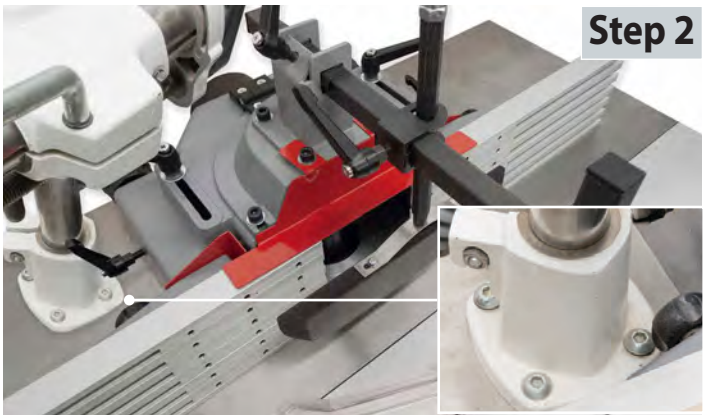
NOTE: The Co-Matic AF32 comes with a standard 13Amp plug. You need to remove this plug and wire in the 16Amp three pin plug that comes with the spindle moulder. This should be done by a competent electrician.

- 240W motor fitted with reverse
- Feed speeds 5, 8, 9 & 11m/min
- Max height under rollers 150mm
- Max reach 260mm
- Column Diameter 40mm

Fig 72

Co-Matic Power Feed Assembly





Connect the 16Amp three pin plug for the AF32 into the 16Amp socket to the side of the spindle moulder

WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!

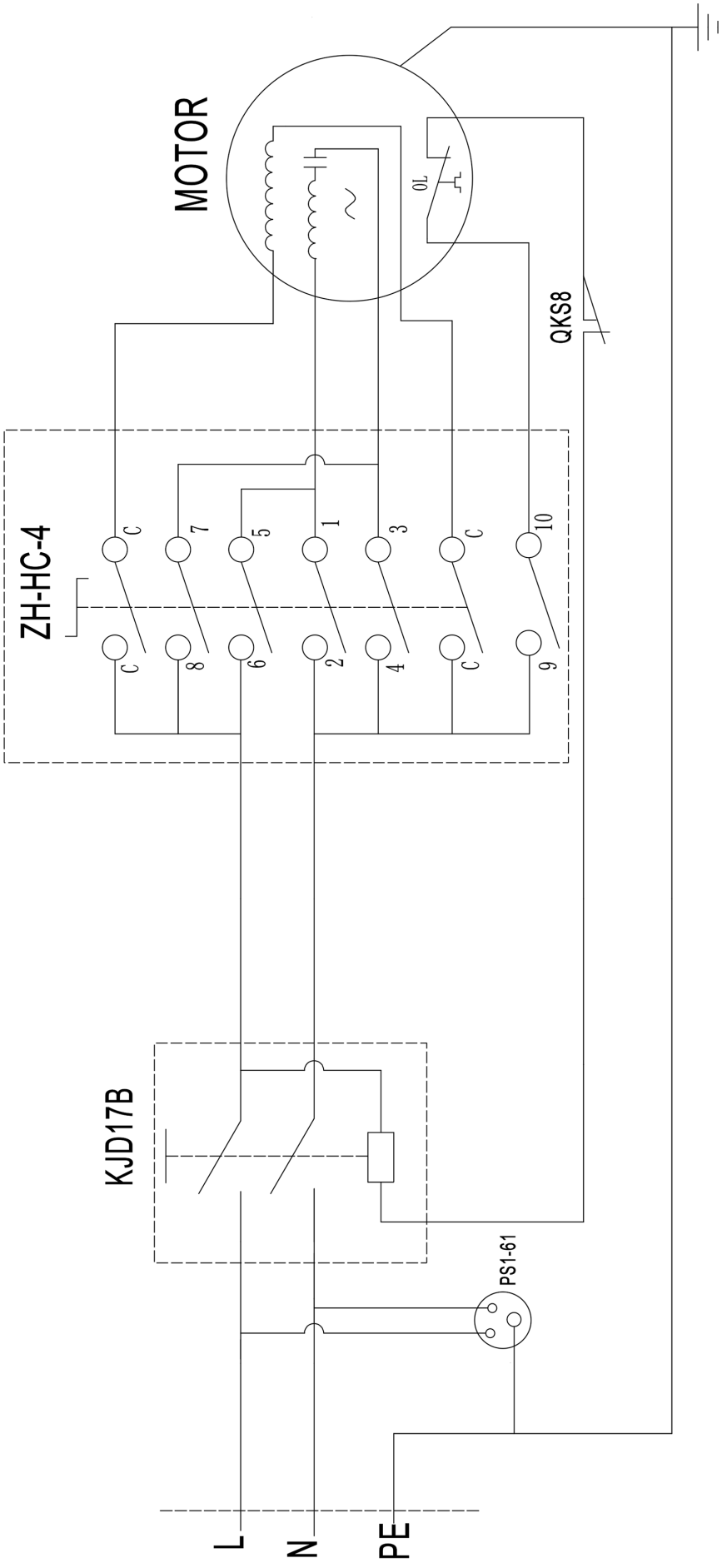
- Keep the cutter block clean and free from dust build up.
- Check the cutter block regularly for chipped blades and damage to block i.e cracks in the cutter block.
- When changing the cutter block, remove the cutter block and place safely away, clean the spindle by spraying a light coating of oil over the shaft and install a new cutter block.
- Opening the access door for the spindle moulder, check the belt tension. If the belt is loose, using the 16mm socket spanner loosen the motor bolts and push/pull until the belt is under tension again, tighten the motor bolts to keep the tension.
- After several months of constant use the condition of the chains, sprockets,tension of the drive belts and the threaded drive shafts of the rise and fall tilt mechanisms will need to be checked. That may require a service engineer to oversee the job.

If you find that the machine is not performing as it should please contact our "Technical Sales Team" by phone on 03332 406406.

TROUBLE SHOOTING CHART

Problem	Cause	Solution
Motor is slow or weak	Voltage from source is low Windings are burned out or open Power switch is defective Circuit is overloaded with appliance, lights or other electrically power equipment	Check the voltage from your electricity supplier Have the Motor checked/repaired Have the power switch replaced DO NOT use other appliances on the same circuit when using this machine
Motor overheats	Motor is overloaded Blunt cutting tool	Check the voltage from your electricity supplier Replace the cutting tool
When cutting the cutter burns the work-piece or stalls the motor	Cutting tool is blunt Work-piece is warped	Replace the cutting tool Replace the work-piece
Spindle tilt and height handles are hard to turn	Tilt locking handle is not fully released Spindle height handle is not fully released	Release tilt locking handle Release height locking handle
Spindle moulder vibrates excessively	Floor surface is uneven V-belt is damaged Milling tool is damaged Loose bolt, screws and nuts	Adjust each leg in turn until machine is level Replace the V-belt Replace the cutting tool Tighten all fixing
Spindle moulder does not start up	Motor power cord is not plugged in Circuit fuse is blown Circuit breaker is tripped Motor power cord or switch is damaged	Plug in the motor power cord into the socket and switch on Replace the circuit fuse Reset the circuit breaker Have the motor power cord or switch replaced
Power switch does not function	Power switch contacts are burned out Capacitor is defective Wiring connections are loose or damaged	Have the power switch replaced Check the voltage from your electricity supplier Have the capacitor replaced Have the wiring connections checked/replaced
Fuses or circuit breakers open frequently	Motor is overloaded Fuses or curcit breakers are the wrong size or defective Blunt cutting tool Power switch is defective	Feed work-piece more slowly Replace fuses or circuit breakers Replace the cutting tool Have the power switch replaced
Motor stalls, blows fuses or trips the circuit breakers	Motor is overloaded Blunt cutting tool Fuses or circuit breakers are the wrong size or defective Feeding work-piece too rapidly	Check the voltage from your electricity supplier Replace the cutting tool Replace fuses or circuit breakers Feed the work-piece through more slowly
Spindle moulder is noisy when in operation	Motor is loose or defective	Have the motor checked or replaced

WARNING! To prevent personal injury or damage to the spindle moulder, maintenance and other repairs should be carried out by a qualified technician. (Contact Axminster Tools & Machinery on 0800 371822)


MOTOR
TO
QKS8
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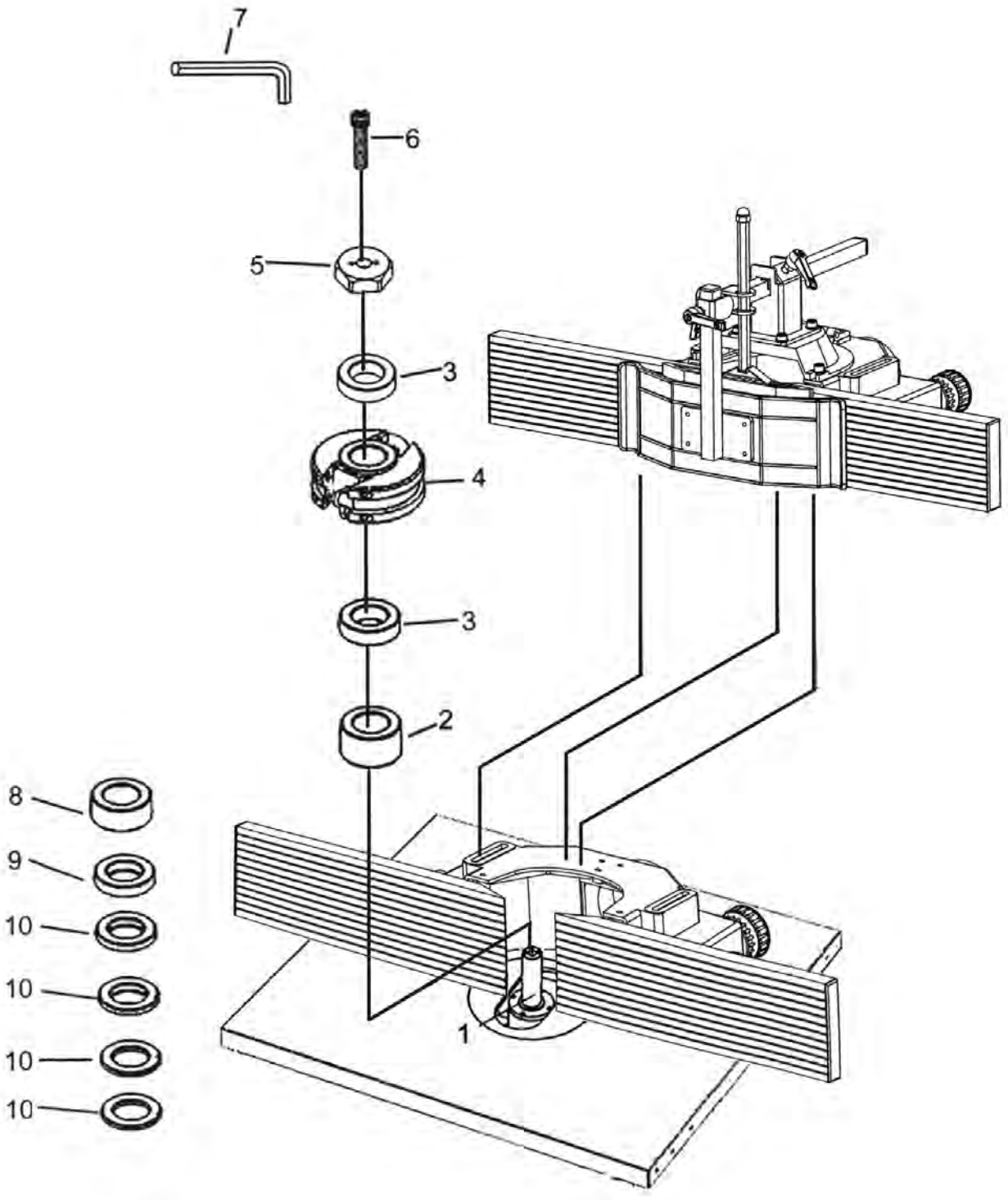
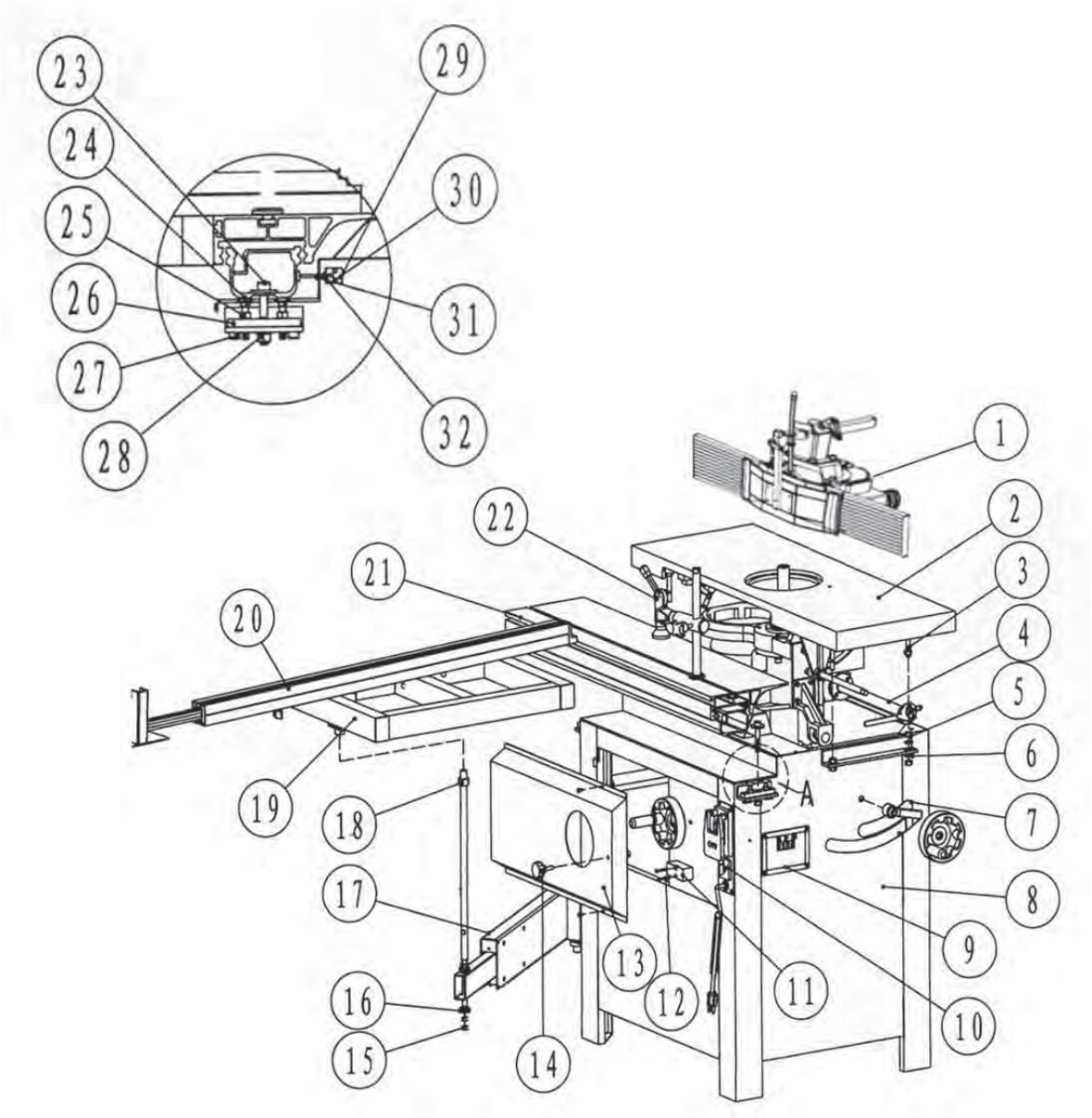


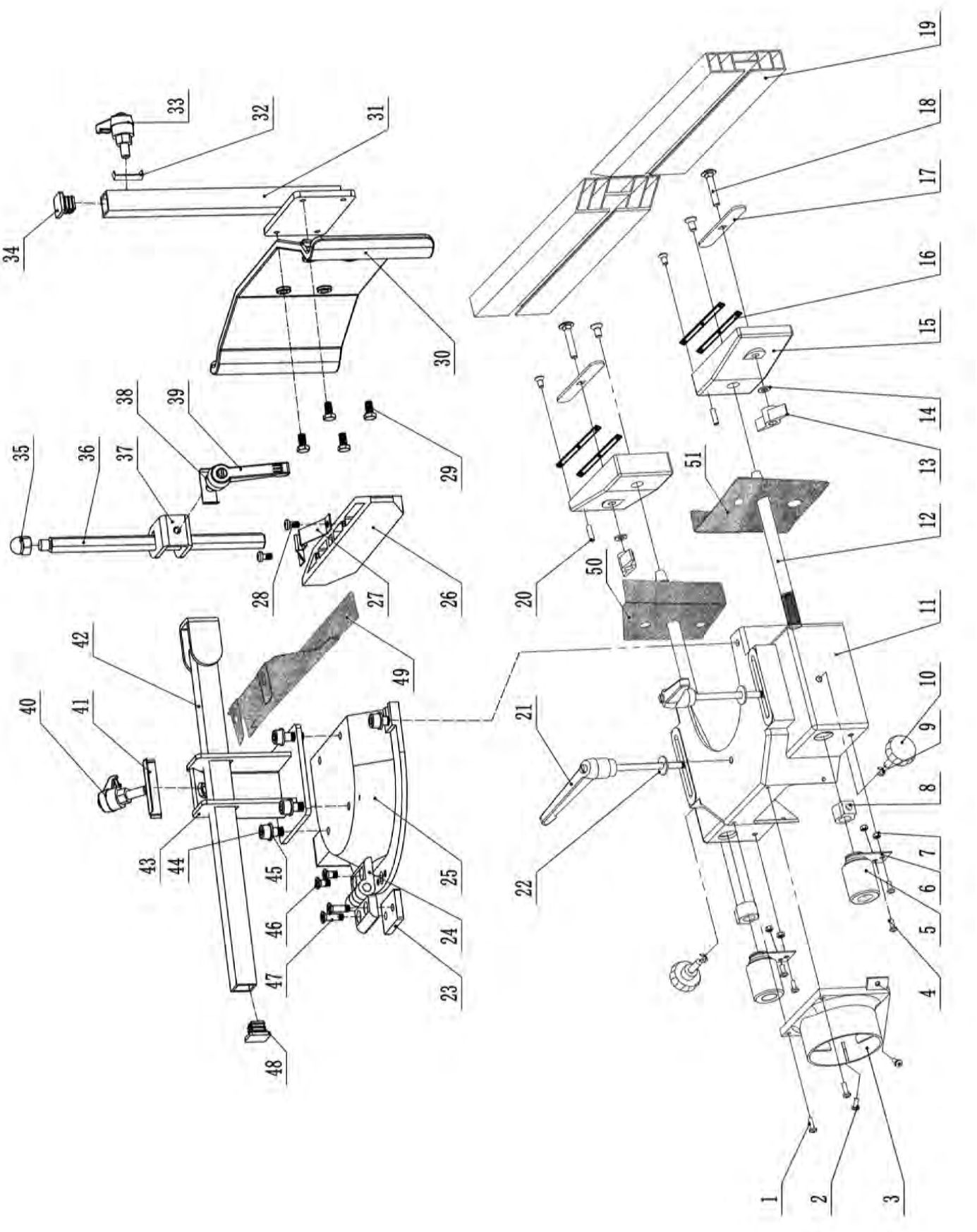
No.	DESCRIPTION	Qty
1	Spindle shaft	1
2	Spindle ring 50x30x30mm	1
3	Spindle ring 50x30x 10mm	1
4	Cutting tool	1
5	Lock flange	1

6	Allen bolt M12x25	1
7	Allen wrench 10mm	1
8	Spindle ring 50x30x20mm	1
9	Spindle ring 50x30x10mm	1
10	Spindle ring 50x30x5mm	4

EXPLODED DIAGRAMS/LIST



No.	DESCRIPTION	Qty
A-1	Safe guard	1
A-2	Table	1
A-3	Allen bolt M10x70	4
A-4	Mill drive set	1
A-5	Lock nut M10	12
A-6	Flat washer 10mm	8
A-7	Scutcheon	1
A-8	Workstand	1
A-9	Spindle height display	1
A-10	Main switch (No-volt release)	1
A-11	Switch(QKS8)	1
A-12	Cross recessed pan head screw M4x30	2
A-13	Left panel, machine housing	1
A-14	Startype screw M8x15	1
A-15	Lock nut M12	4
A-16	Thrust bearing 8101	2
A-17	Swing arm	1
A-18	Lock nut M16	1
A-19	Sliding bench (optional)	1
A-20	Guide rail	1
A-21	Sliding rail	1
A-22	Workpiece Clamp	1
A-23	Allen bolt M 12x65	2
A-24	Carriage bolt, M8x45	2
A-25	Lock nut M8	4
A-26	Guide, bolt	2
A-27	Allen bolt M8x16	4
A-28	Lock nut M12	2
A-29	End stop, guide	2
A-30	Hex head screw M5x16	4
A-31	Hex head screw M6x50	2
A-32	Lock nut M6	2



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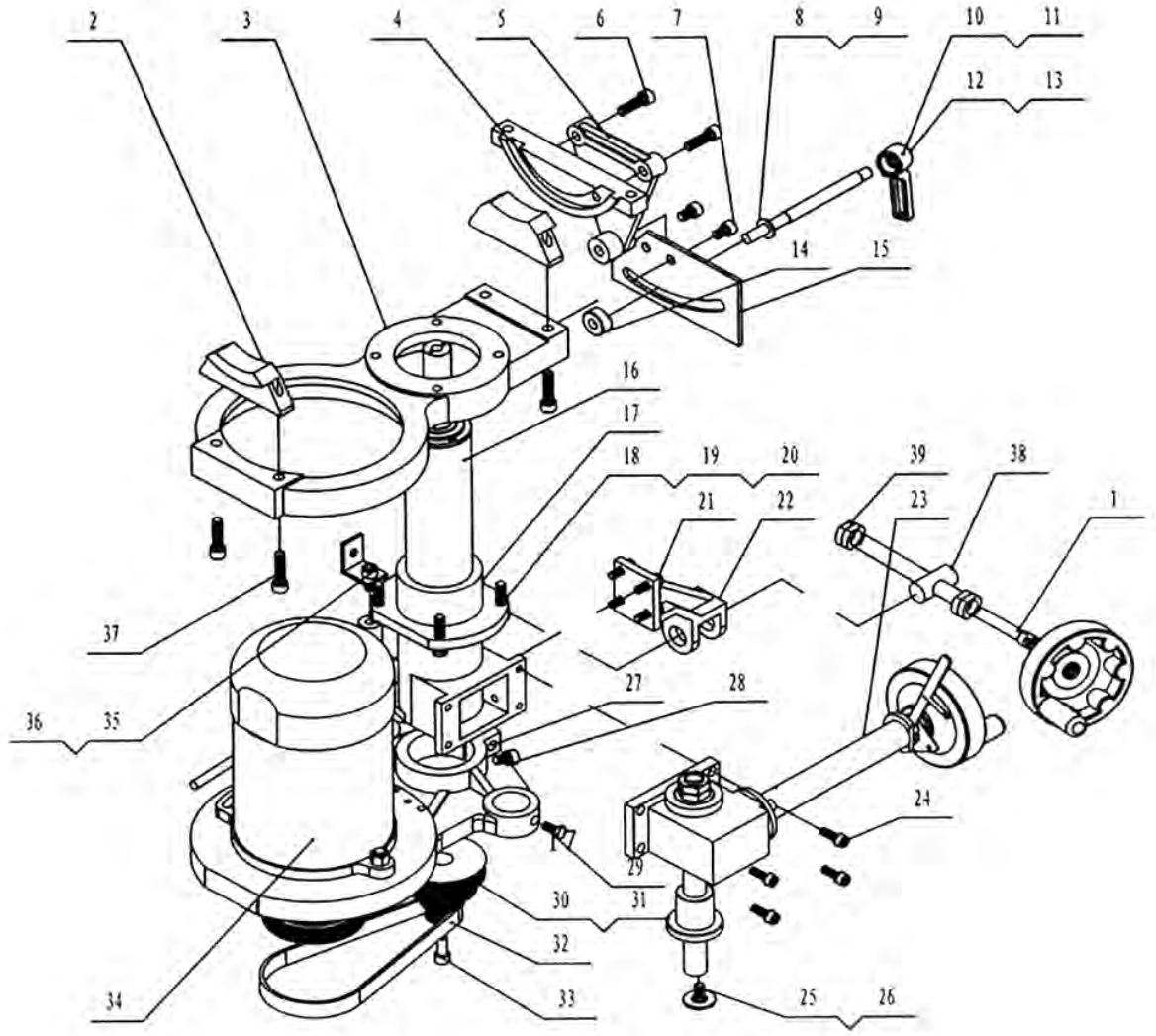
EXPLODED DIAGRAMS/LIST

NO.	DESCRIPTION	QTY
1	Cross recessed pan head screw M5x16	2
2	Cross recessed pan head screw M5x12	2
3	Dust outlet	1
4	Hexagonal screw M5X16	4
5	Adjusting handwheel	2
6	Plate	2
7	M5 nut	4
8	Locking block	2
9	Nut	2
10	Locking handle	2
11	Safe guard	1
12	Guide spindle, spindle latch	2
13	Locking handwheel	2
14	Flat washer 8	2
15	Fence extrusion carriage	2
16	Batten	4
17	Guide	2
18	Carriage bolt	2
19	Fence extrusion	2
20	Locking screw	8
21	Locking handle	2
22	Flat washer 8	2
23	Base plate	1
24	Hinge	1
25	Safe guard cover	1
26	Holddown clamp	1
27	Spring plate	1
28	screw	2
29	Hexagon bolt	4
30	Anti-kickback plate	1
31	Vertical Rod	1
32	Spring plate	1
33	Locking handle	1
34	End cap	1
35	Cap nut	1
36	Hexagonal rod	1
37	Clamping plate	1
38	Spring plate	1
39	Locking handle	1
40	Locking handle	1
41	Long spring plate	1
42	Cross rod	1
43	Bracket	1
44	Hexagon socket bolt	6
45	Flat washer 8	6
46	Cross recessed countersunk head screw	2
47	Cross recessed countersunk head screw	2
48	End cap	1

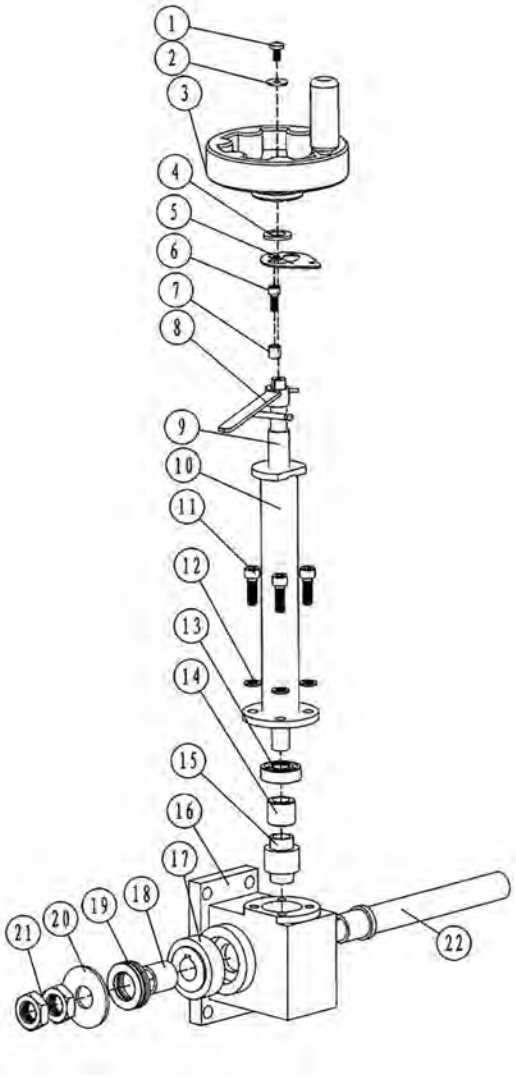
Supplied By Axminster Tools Ltd		
49	Fence Top Guard	1
50	Fence Carriage Right Guard	1
51	Fence Carriage Left Guard	1



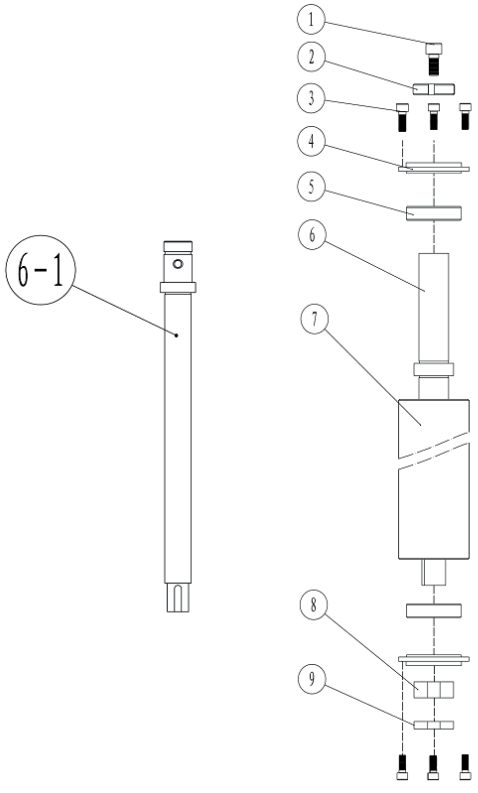
No.	DESCRIPTION	Qty
C-1	Tilting set	1
C-2	Support, swivel turnion	2
C-3	Swivel guide	1
C-4	Swivel, turnion	2
C-5	Lockup seat	1
C-6	Allen bolt M10x35	2
C-7	Allen bolt M8x 16	2
C-8	Flat washer 12mm	1
C-9	Lockup shaft	1
C-10	Tilt locking lever	1
C-14	Tilt locking block	1
C-15	Lockup seat	1
C-16	Spindle shaft set	1
C-17	Swivel head	1
C-18	Allen bolt M10x35	4
C-19	Spring washer 10mm	4
C-20	Flat washer 10mm	4
C-21	Allen bolt M6x20	4
C-22	Joint, swivel rod	1
C-23	Elevator	1
C-24	Allen bolt M8x20	4
C-25	Allen bolt M10x16	1
C-26	Big flat washer 10mm	1
C-27	Allen bolt M12x30	1
C-28	Allen bolt M8x20	2
C-29	Hex head screw M8x16	1
C-30	Spindle pulley	1
C-31	Flat key 8x8x25	1
C-32	V-belt	1
C-33	Allen bolt M10x45	1
C-34	Motor set	1
C-35	Allen bolt M10x16	1
C-36	End stop, guide	1
C-37	Allen bolt M10x45	4
C-38	Nut, swivel rod	1
C-39	Nut fix rod	4

EXPLODED DIAGRAMS/LIST

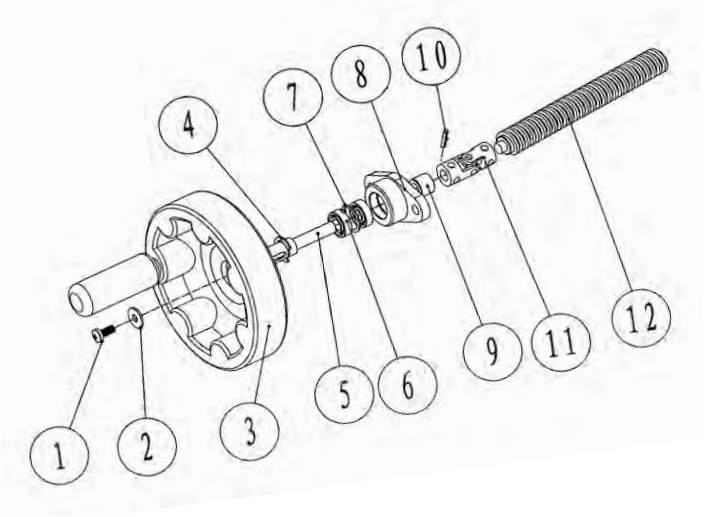
No.	DESCRIPTION	Qty
D-1	Countersunk head screw M5x12	1
D-2	Large washer 6mm	1
D-3	Wheel handle	1
D-4	Large washer 12mm	1
D-5	Pear plate, lock lever	1
D-6	Hex bolt M6x25	1
D-7	Bushing pointer	1
D-8	Lock lever rise	1
D-9	Rise shaft	1
D-10	Housing rise shaft	1
D-11	Hex bolt M8x25	4
D-12	Spring washer 8mm	4
D-13	Ball bearing 80202	1
D-14	Bushing worm	1
D-15	Worm	1
D-16	Carrier rise gear	1
D-17	Gear-helical	1
D-18	Bushing, spindle	1
D-19	Thrust bearing 8105	1
D-20	Special washer	1
D-21	Thin hex nut M20	2
D-22	Rising spindle	1



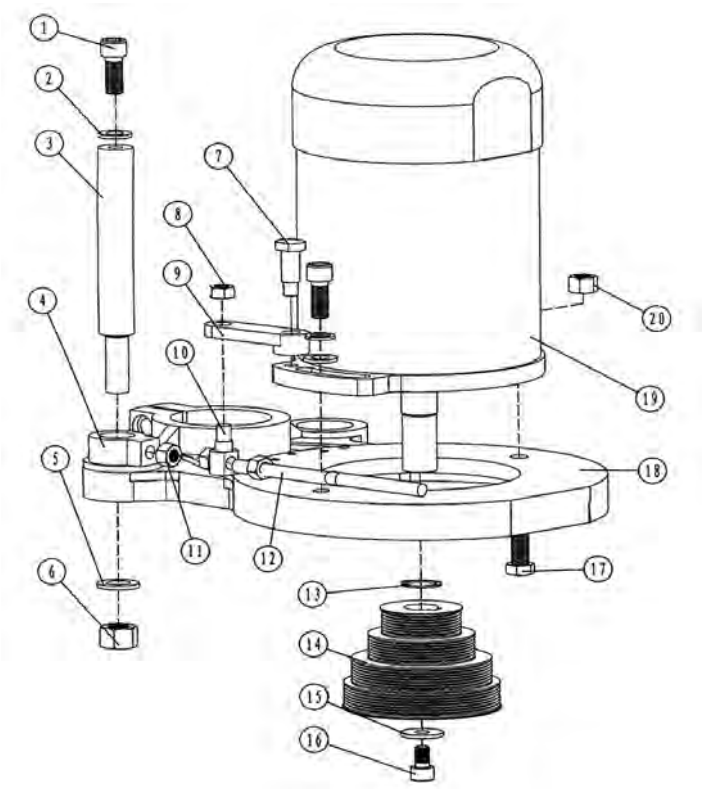
No.	DESCRIPTION	Qty
E-1	Allen bolt M12x25	1
E-2	Lock flange	1
E-3	Allen bolt M4x16	8
E-4	Cup spindle guide tube	2
E-5	Ball bearing 80106	2
E-6	Spindle shaft A	1
E-6-1	Spindle shaft B	1
E-7	Spindle guide tube	1
E-8	Lock nut M30	1
E-9	Lock nut M30	1



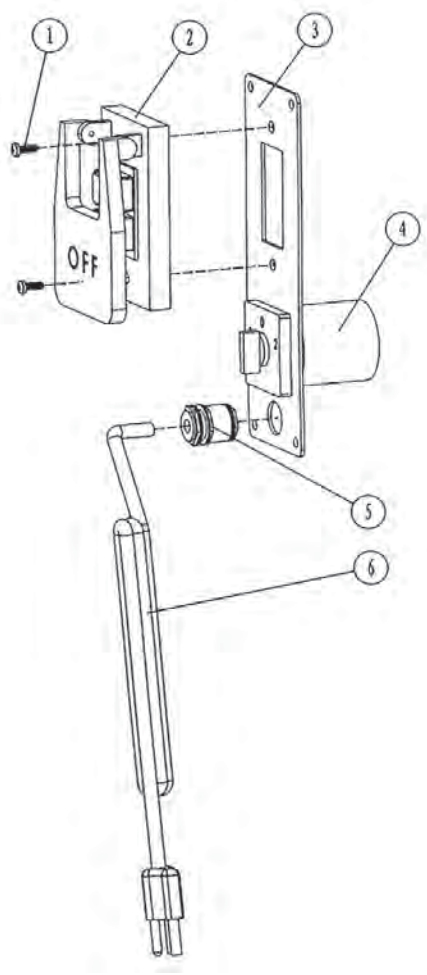
No.	DESCRIPTION	Qty
F-1	Countersunk head screw M5x12	1
F-2	Large washer 6mm	1
F-3	Wheel handle	1
F-4	Circle 9mm	1
F-5	Pin cone gear	1
F-6	Ball bearing 619/8	2
F-7	Circle 19mm	1
F-8	Gear base	1
F-9	Bushing worm	1
F-10	Roll pin 3x16	1
F-11	Gimbal	1
F-12	Swivel rod	1



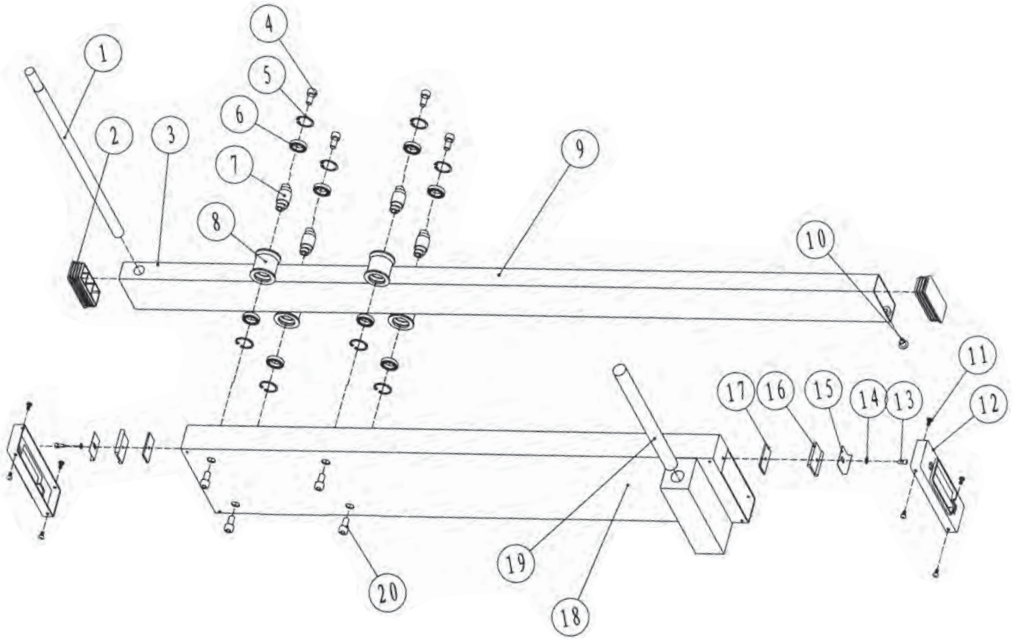
No.	DESCRIPTION	Qty
G-1	Hex bolt M10x15	1
G-2	Flat washer 10mm	1
G-3	Guide bar	1
G-4	Joint tension	1
G-5	Flat washer 16mm	1
G-6	Hex nut M16	1
G-7	Thread joint	1
G-8	Lock nut M10	1
G-9	Joint motor tension	1
G-10	Thread tension	1
G-11	Lock nut M10	3
G-12	Lever tension	1
G-13	Circle 24mm	1
G-14	Motor pulley	1
G-15	Large washer 10mm	1
G-16	Hex bolt M10x20	1
G-17	Hex head screw M12x40	1
G-18	Mount, motor	1
G-19	Motor	1
G-20	Hex nut M12	1

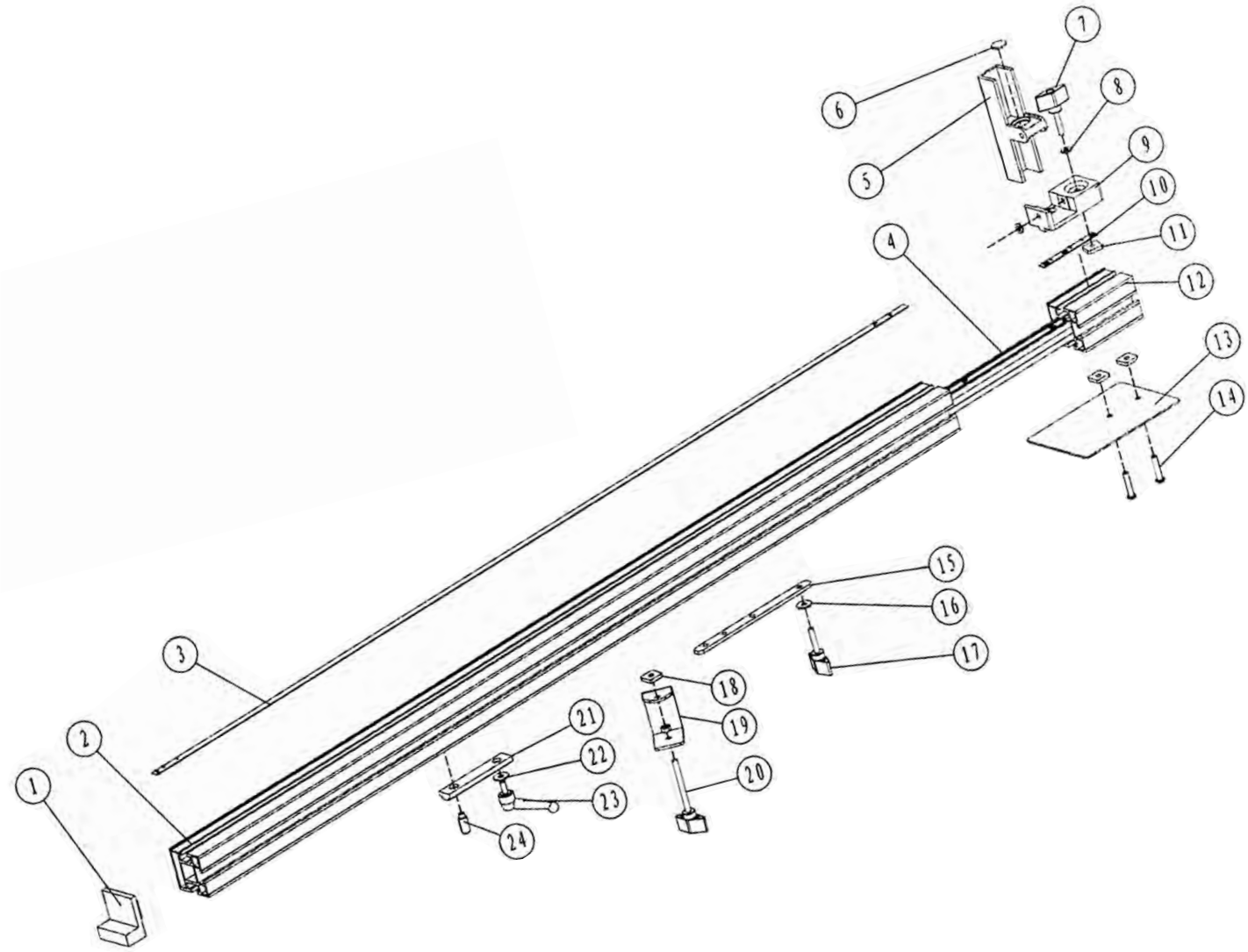


No.	DESCRIPTION	Qty
H-1	Cross recessed pan head screw M4x12 2	2
H-2	Switch KJD17B-16	1
H-3	Switch Batten	1
H-4	ZH-HC-3 switch	1
H-5	Nut M20	1
H-6	Electrical wire	1



No.	DESCRIPTION	Qty
I-1	Guide bar	1
I-2	End cap	2
I-3	Telescopic arm	1
I-4	Hex bolt M6x12	4
I-5	Circle 24mm	8
I-6	Ball bearing 61901	8
I-7	Partiality shelf	4
I-8	Wheel	4
I-9	Telescopic arm	1
I-10	Hex bolt M6x12	1
I-11	Cross recessed pan head screw M5x12	8
I-12	End cap	2
I-13	Hex bolt M6x12	1
I-14	Washer 6mm	1
I-15	Guide bolt, bolt A	1
I-16	Guide bolt, bolt B	1
I-17	Guide bolt, bolt C	1
I-18	Swing arm	1
I-19	Guide bar	1
I-20	Hex bolt M6x12	1



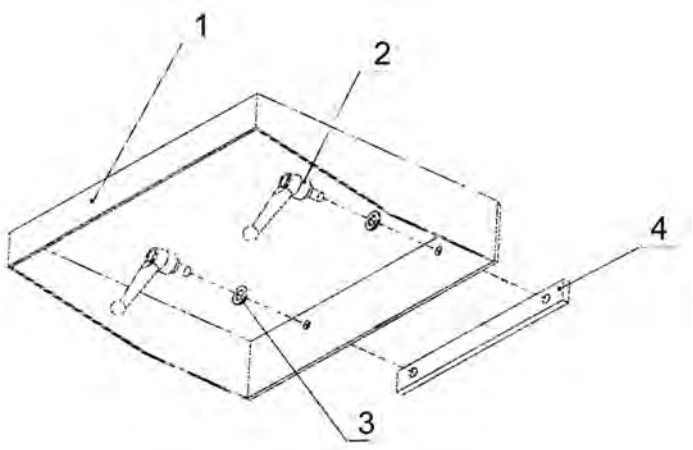


No.	DESCRIPTION	Qty
J-1	End cap	1
J-2	Guide rail	1
J-3	Staff gauge A	1
J-4	Stop rail	1
J-5	Seat A	1
J-6	Convex	1
J-7	Flower handle	1
J-8	Spring washer 6mm	1
J-9	Seat B	1
J-10	Staff gauge B	1
J-11	Block	1
J-12	End stop	1

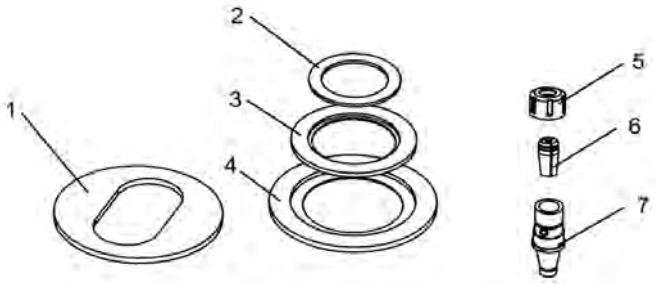
J-13	Slaver	1
J-14	Countersunk head screw M6x30	2
J-15	Bolt guide	1
J-16	Spring washer 6mm	1
J-17	Flower handle	1
J-18	Block	1
J-19	Seat C	1
J-20	Flower handle	1
J-21	Intermediate plate	1
J-22	Spring washer 6mm	1
J-23	Ratchet lever M6	1
J-24	Roll	1

EXPLODED DIAGRAMS/LIST

No.	DESCRIPTION	Qty
K-1	Sliding bench	1
K-2	Tilt lock	2
K-3	Spring washer 6mm	2
K-4	Bolt guide	1

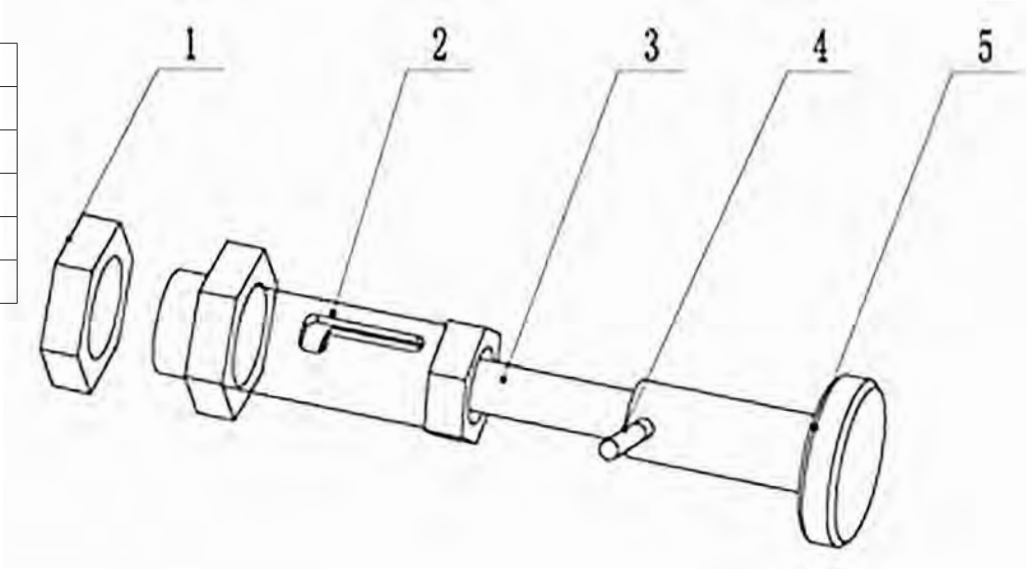


No.	DESCRIPTION	Qty
L-1	Table ring 200mm for tilt	1
L-2	Table ring 110/80mm	1
L-3	Table ring 150/110mm	2
L-4	Table ring 200/150mm	1
L-5	Flange	1
L-6	Collet	1
L-7	Spindle shaft	1



Spindle Stop Assembly

No.	DESCRIPTION	Qty
1	M16 Nut	2
2	Bush	1
3	Spring	1
4	Spring pin	1
5	Locating pin	1



CE **Axminster Tool Centre Ltd**

EC DECLARATION OF CONFORMITY
'original'

Product model: AP200SM Spindle Moulder

Name and address of the manufacturer: Axminster Tool Centre Ltd, Unit 10 Weycroft Avenue, Axminster, Devon EX13 5PH, United Kingdom

This declaration of conformity is issued under the sole responsibility of the manufacturer.

Object of the declaration: AP200SM Spindle Moulder

The object of the declaration described above is in conformity with the relevant GB legislation:

Supply of Machinery (Safety) Regulations 2008 as amended.
Electromagnetic Compatibility Regulations 2016 as amended.

References to the relevant harmonised standards used or references to the other technical specifications in relation to which conformity is declared:

EN ISO 12100:2010 Safety of Machinery. General principles for design. Risk assessment and risk reduction.
EN ISO 19085-6:2017 Woodworking machines. Safety. Single spindle vertical moulding machines ("toupeis")
EN 60204-1:2018 Safety of machinery - Electrical equipment of machines - General requirements.
EN 61000-6-1:2007 Electromagnetic compatibility (EMC). Generic standards. Immunity for residential, commercial and light-industrial environments.
EN 61000-6-3:2007 Electromagnetic compatibility (EMC). Generic standards. Emission standard for residential, commercial and light-industrial environments.

Additional information:

Name and address of person authorised to compile the technical file: Axminster Tool Centre Ltd, Unit 10 Weycroft Avenue, Axminster, Devon EX13 5PH, United Kingdom

The machinery fulfils all relevant provisions of Supply of Machinery (Safety) Regulations 2008 as amended.

Signed for and behalf of: Axminster Tool Centre Ltd;

(place and date of issue): Axminster, Devon, United Kingdom Kingdom, 23rd May 2023

(name, function): Andrew Parkhouse, Supply Chain Director

Signature: 

Axminster Tool Centre Ltd

UK DECLARATION OF CONFORMITY
'original'

Product model: AP200SM Spindle Moulder

Name and address of the manufacturer: Axminster Tool Centre Ltd, Unit 10 Weycroft Avenue, Axminster, Devon EX13 5PH, United Kingdom

This declaration of conformity is issued under the sole responsibility of the manufacturer.

Object of the declaration: AP200SM Spindle Moulder

The object of the declaration described above is in conformity with the relevant GB legislation:

Supply of Machinery (Safety) Regulations 2008 as amended.
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(place and date of issue): Axminster, Devon, United Kingdom, 23rd May 2023

(name, function): Andrew Parkhouse, Supply Chain Director

Signature: ……

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