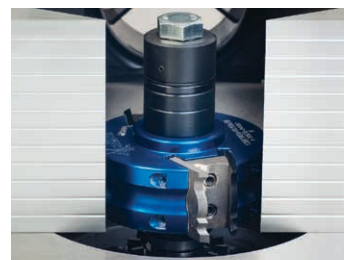


AC150SM

Spindle Moulder



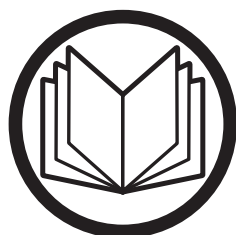
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EU Declaration of Conformity

Cert No: WS500F, MX5111BF, MX5111BR Axminster Tools & Machinery Ltd Axminster Devon EX13 5PH UK axminster.co.uk declares that the machinery described:- <table border="1"> <tr> <td>Type</td> <td>Spindle Moulder</td> </tr> <tr> <td>Model</td> <td>AC150SM</td> </tr> </table> Signed  Andrew Parkhouse Operations Director Date: 15/12/2017	Type	Spindle Moulder	Model	AC150SM	EU Declaration of Conformity This machine complies with the following directives: <table> <tr> <td>EN 61000-3-3:2013</td> <td>EN 55014-2:2015</td> </tr> <tr> <td>EN 55014-1:2006+A1+A2</td> <td>EN 61000-3-2:2014</td> </tr> <tr> <td>EN 55014-2:1997+A1+A2</td> <td></td> </tr> <tr> <td>EN 55014-1:2017</td> <td></td> </tr> </table> and conforms to the machinery example for which the EC Type-Examination Certificate No AE 50390657 has been issued by Laizhou Planet Machinery Co., Ltd. at: Yutai West Street, Laizhou, Shandong 261400, Shandong, China (Mainland) and complies with the relevant essential health and safety requirements.	EN 61000-3-3:2013	EN 55014-2:2015	EN 55014-1:2006+A1+A2	EN 61000-3-2:2014	EN 55014-2:1997+A1+A2		EN 55014-1:2017	
Type	Spindle Moulder												
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EN 61000-3-3:2013	EN 55014-2:2015												
EN 55014-1:2006+A1+A2	EN 61000-3-2:2014												
EN 55014-2:1997+A1+A2													
EN 55014-1:2017													

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



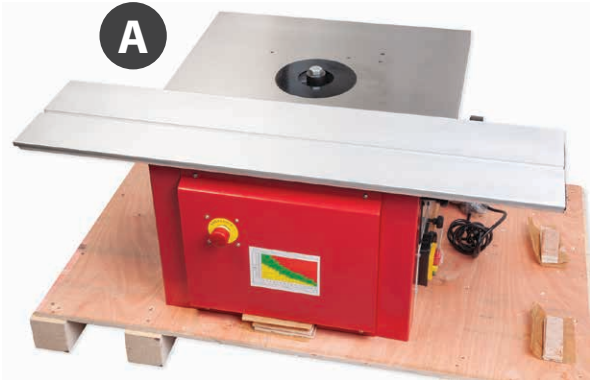
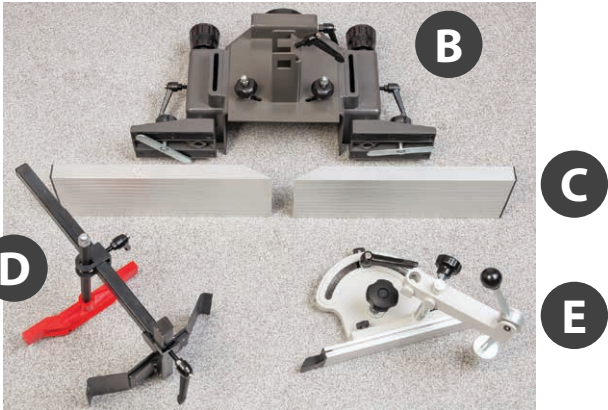
Dust mask
should be worn



HAZARD

What's Included

Quantity	Item	Part	Model Number
			AC150SM
1	Spindle Moulder (Main Body)	A	
1	Spindle Guard Assembly	B	
2	Spindle Guard Fences	C	
1	Guide Assembly Comprising: • Guide Arm • Anti-kickback Plate • Guide	D	
1	Mitre Fence Work Clamp Assembly	E	
2	Side Panels & Front/Back Panels	F	
4	Lower Leg Columns	G	
1	Collet Adaptor	H	
2	Collets	I	
2	Insert Rings	J	
2	Collet Nuts (E0C12A-T22X1.5)	K	
1	22-24mm Spanner	L	
1	32mm Spanner	M	
2	M8 x 40mm Lift & Shift Handles	N	
1	5-6mm Hex Keys	O	
20	M8 Nuts	P	
20	M8 x 15mm Bolts	Q	

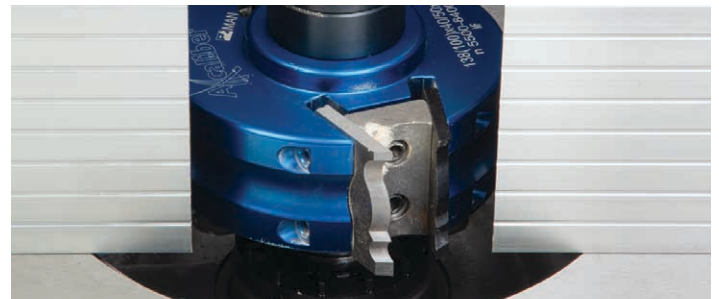


Optional Accessories

Quantity	Item	Part	
1	AC150SM Bobbin Sander Attachment	R	Code: 106184
1	A150SM Bobbin Sander Abrasive	S	Code: 106185



See the full range of 'Axcaliber Euro Cutter Heads' in our catalogue and on our web site at axminster.co.uk



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 ensure 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.**

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	106178
Model	AC150SM
Rating	Craft
Power	1.5 kW
Spindle Travel	105 mm
Spindle Diameter	30 mm
Spindle Speed	1,400, 4000, 6000, & 8,000 rpm
Sound Power Level [Uncertainty K]	68 dB(A)
Max Spindle Projection above Table	100 mm
Max Tooling Diameter Above Table	140 mm
Max Tooling Diameter Below Table	140 mm
Table Height	800 mm
Table Size	600 x 400 mm
Min Extraction Airflow Required	1,200 m³/hr
Dust Extraction Outlet	100 mm
Overall L x W x H	660 mm x 1,000 mm x 1,100 mm
Weight	100kg

Assembly



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

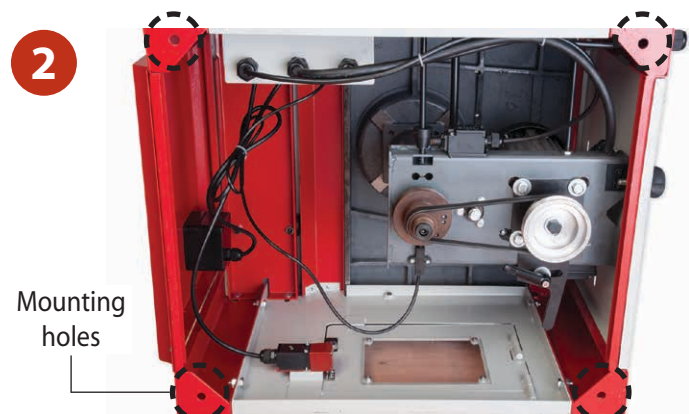
Unpack all the boxes and check all the components against the 'What's in Included' list. If any parts or components are missing, please contact our customer services department using the procedures and telephone numbers listed on our website, and you will be dealt with quickly and efficiently.

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.

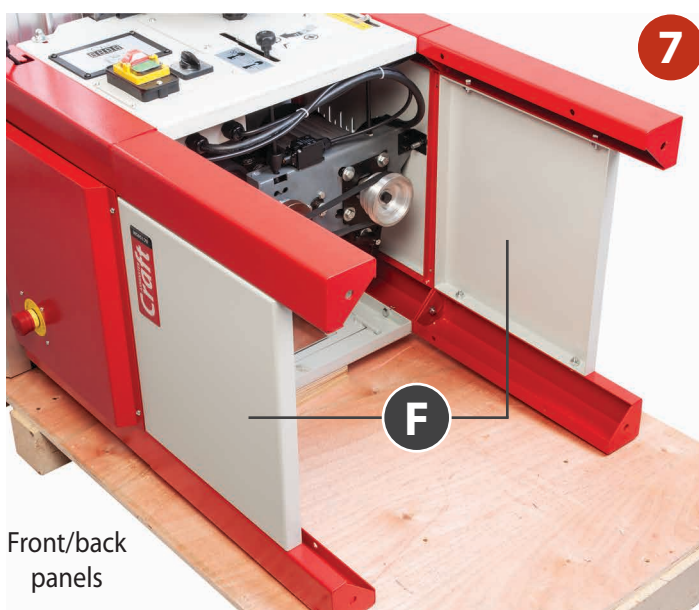
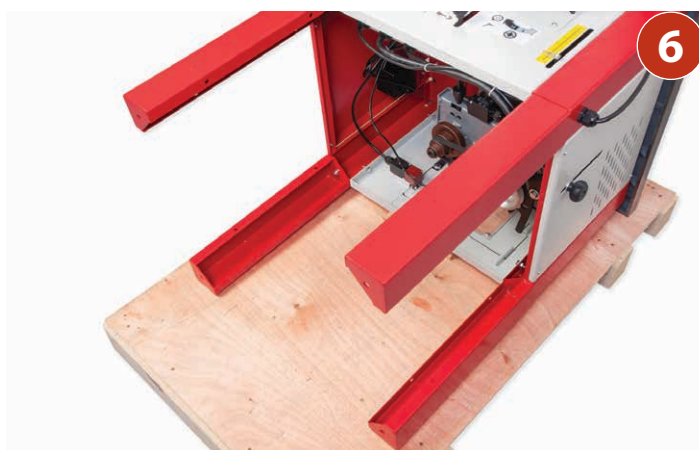
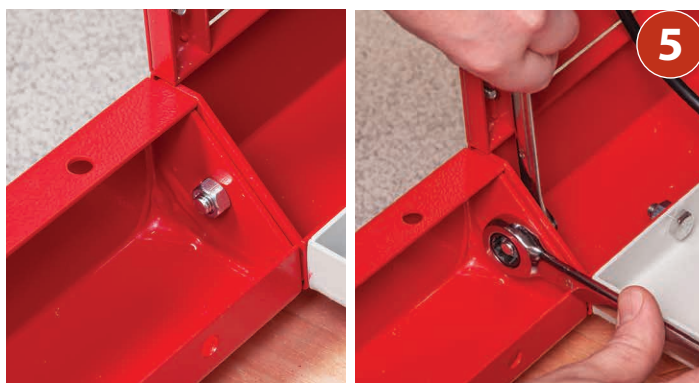
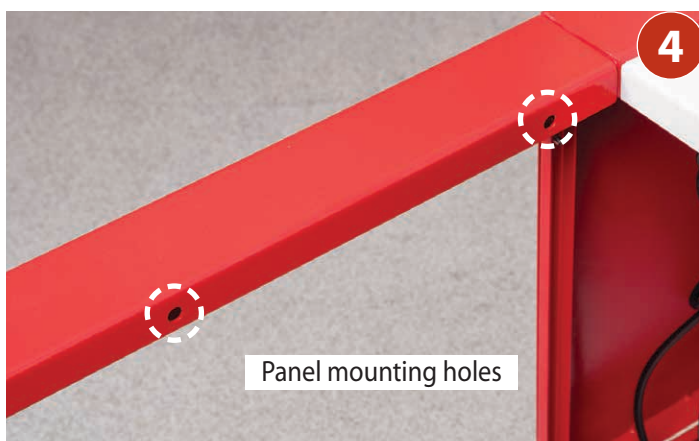
Leg Assembly



Remove the motor door lift & shift handle to prevent it from being damaged when the machine is turned on its side.

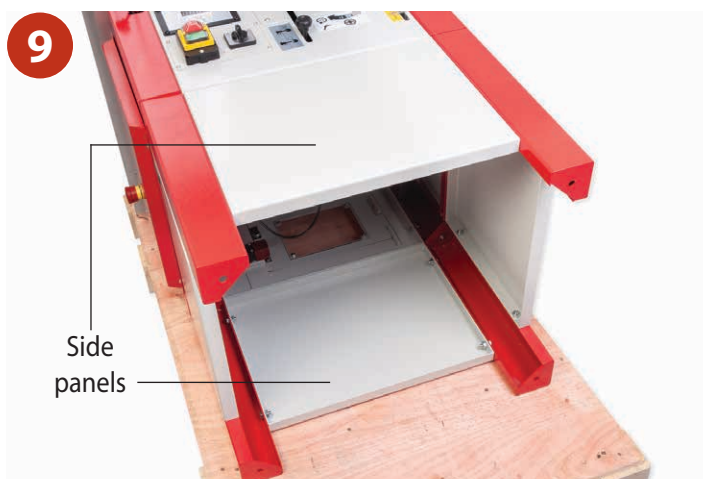


Locate the four lower leg columns (G), M8 bolts & washer (P) and nuts (Q). Mount the legs to each corner of the machine's base and secure in position. NOTE: Make sure the two holes on the side of each leg are in the upward position as shown in fig 4.



Front/back panels

Secure the front and back panels as shown in fig 7.



Secure the side panels as shown in fig 8-9.

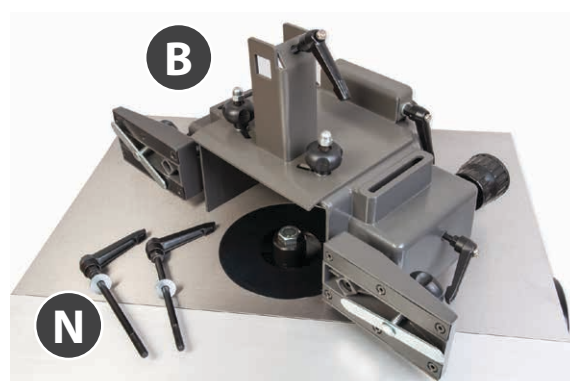


Tighten all the fixings and with assistance place the spindle moulder on its feet, see fig 10-11. Replace the door handle.

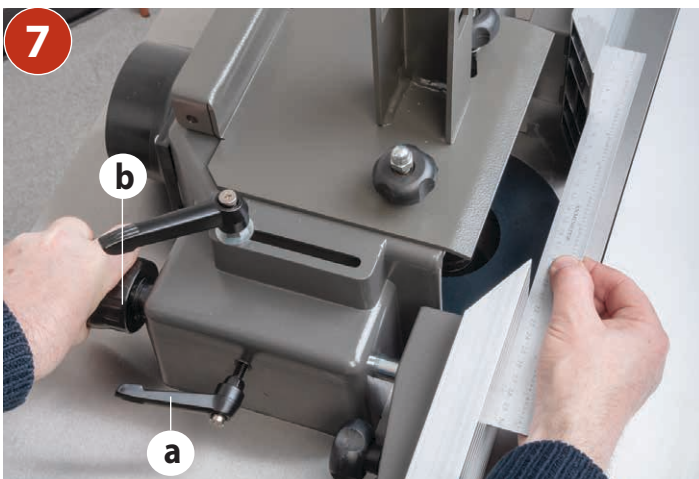
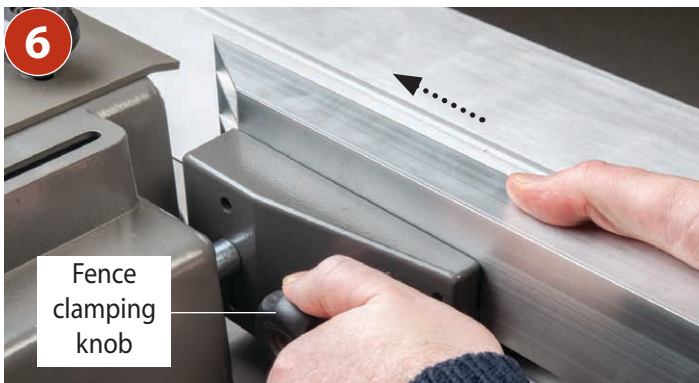


Spindle Guard Assembly

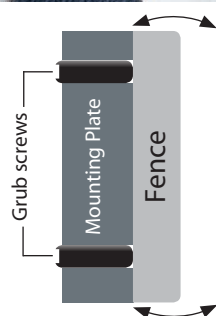
Locate the spindle guard (B), spindle guard fences (C) and two lift & shift handles/washers (N).



Continues over...



The fence is a two piece adjusting system. Each fence is independently adjustable to compensate for different cutting thicknesses. Place a steel straight edge across both fences (C), loosen the fence advance clamping handle (a) and adjust the fence advancing knob/s (b). Adjust until both are aligned, see fig 7. Nip-up the clamping handle (a) to lock the setting.



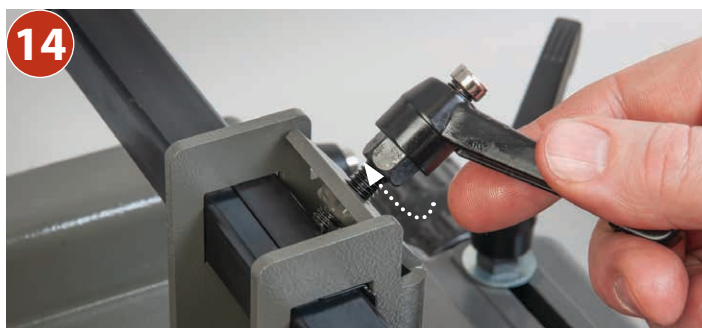
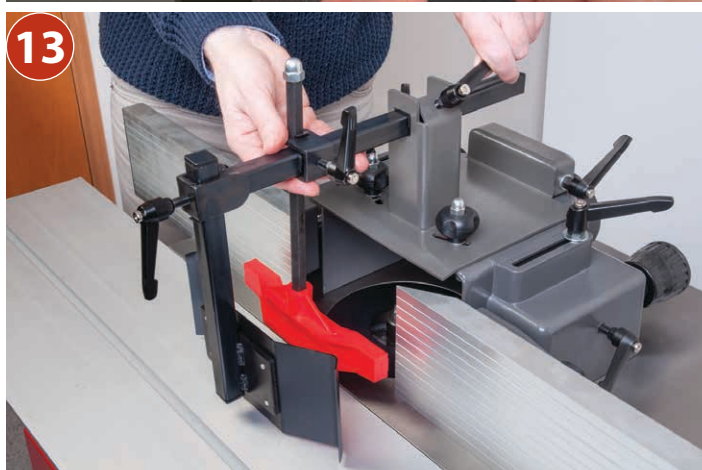
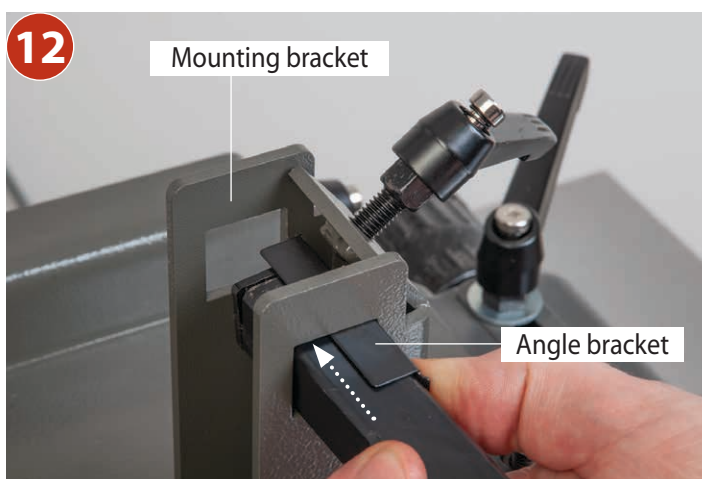
Make sure the fence is square to the work surface, place a 90° square up against the fence and check it is perpendicular to the work surface. If adjustment is required adjust the four grub screws to the rear of the fence mounting plates, see fig 8. This pivots the fence forward and aft. Adjust until correct, see fig 9-10.



Guide Assembly

Locate the guide assembly (D). Insert the guide arm through the guide arm mounting bracket on the spindle guard assembly (B). Note: align the guide arm angle bracket between the mounting bracket and nip-up the clamping handle (c), see fig 11-12-13-14.





Mitre Fence Assembly

Locate the Mitre fence work clamp (E) and slide it into the sliding tables "T" slot, see fig 15. Using an engineers square, set the mitre fence at 90° degrees to the spindle guard fence (C), see fig 16. Check the scale pointer is set to 'zero' and adjust if necessarily. Tighten both the clamping knob and handle, see fig 17-18.

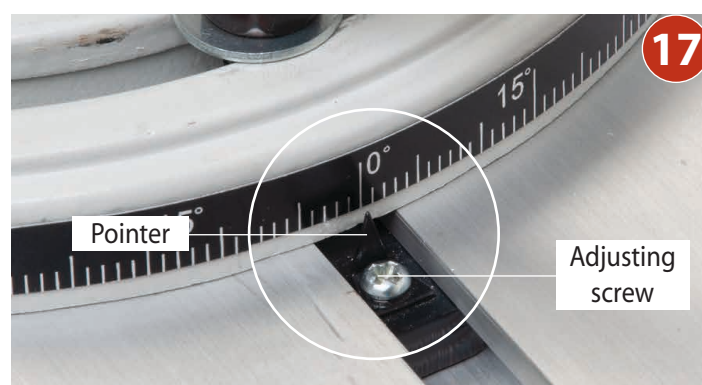
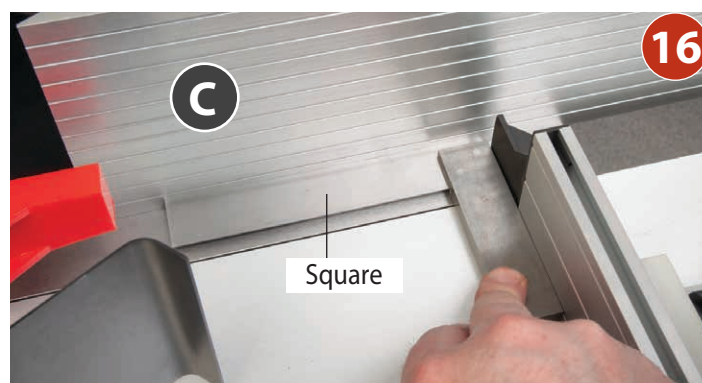
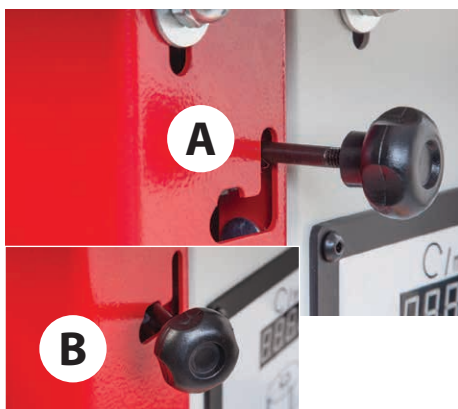


Illustration & Parts Description

Front View



Emergency stop
Twist clockwise to unlock



Sliding table locking lever in the locked position (A)
Lever in the unlocked position (B)

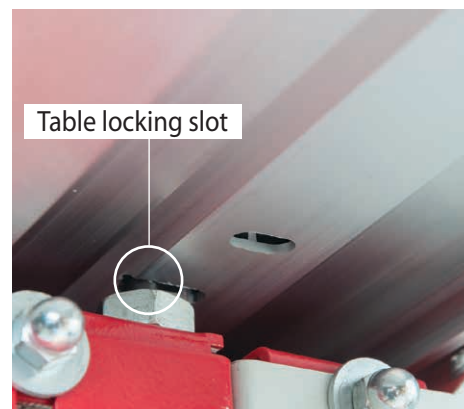
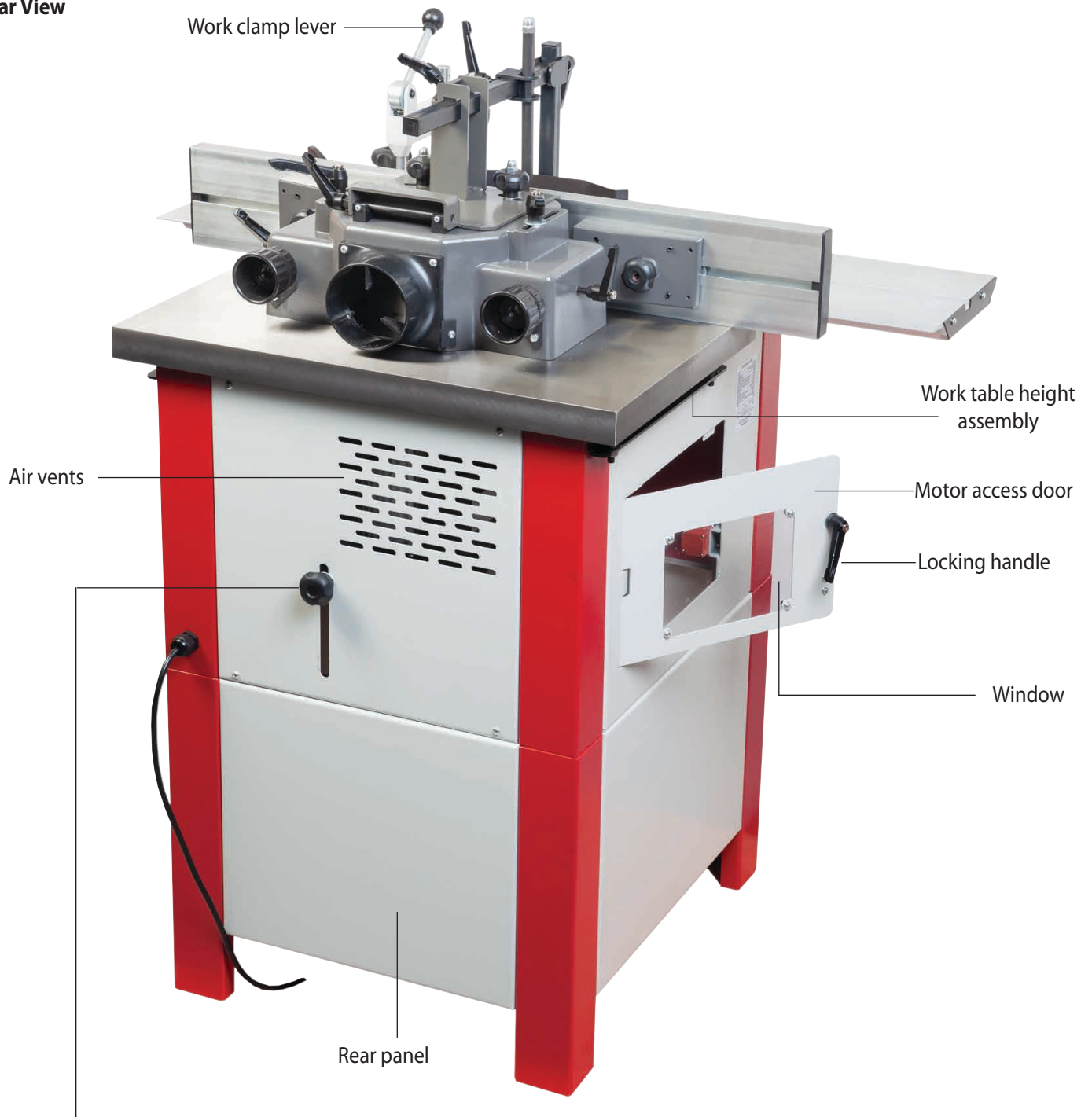


Table locking slot

Rear View

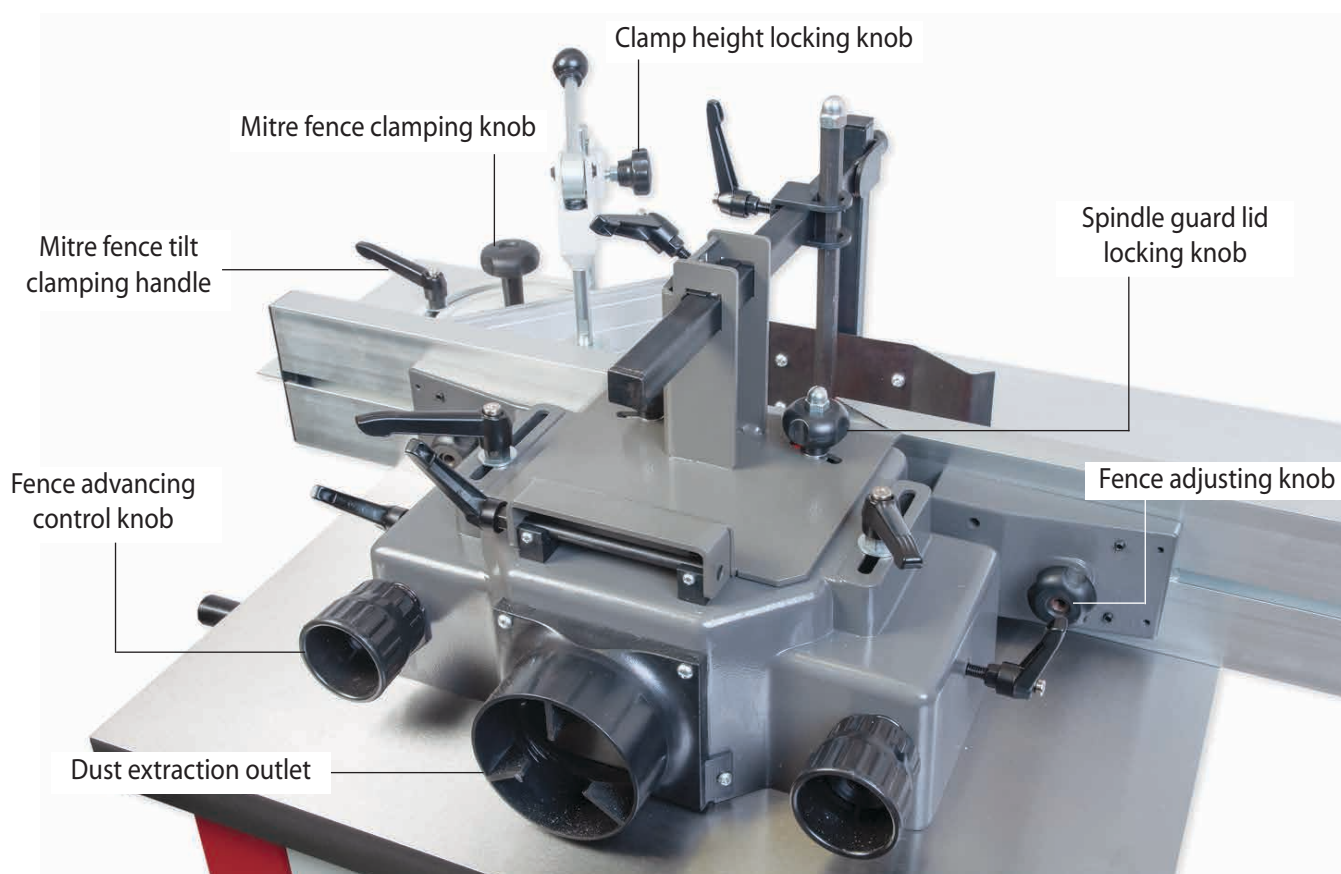
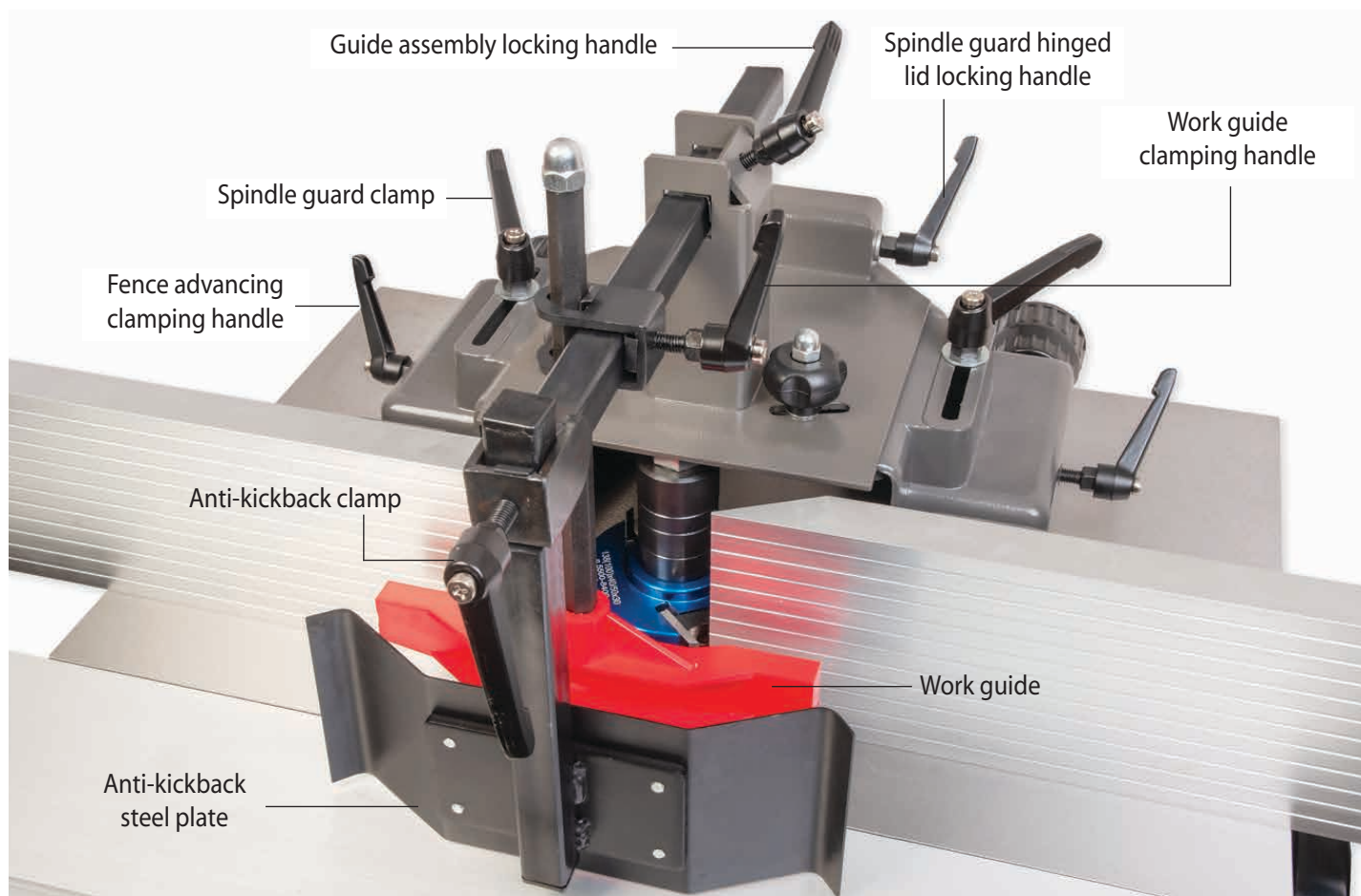


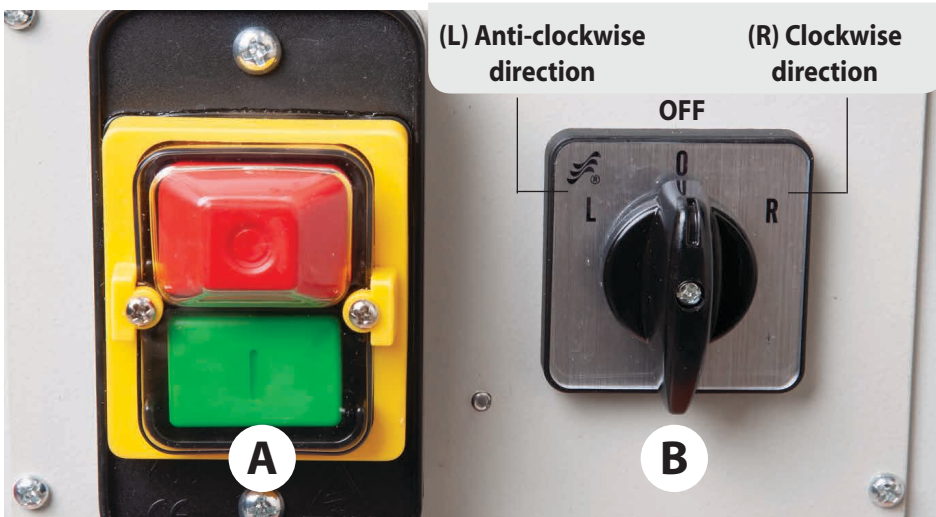
Motor/Spindle assembly height locking knob



Motor and spindle access door

Illustration & Parts Description





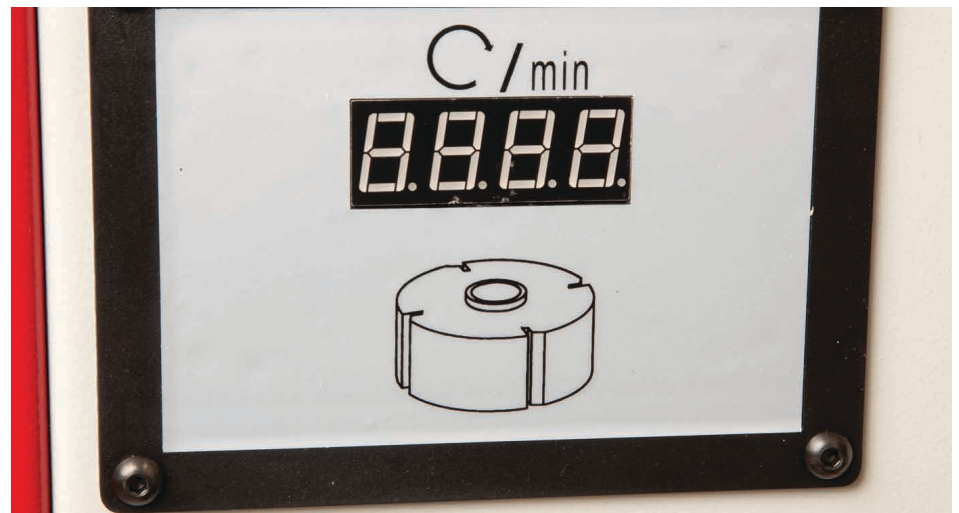
ON/OFF control switch (A), Spindle control switch (B)



Spindle height scale/pointer



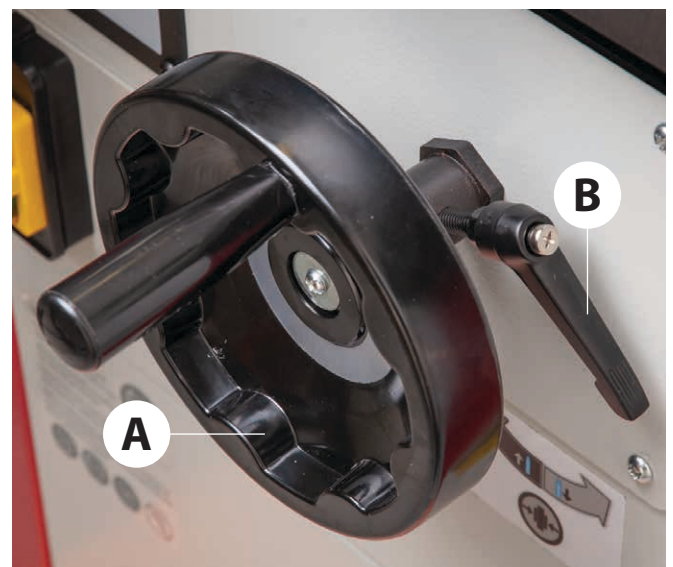
Turn the spindle & press in the locking knob to lock the spindle



Cutter block speed D.R.O. 'Digital Read Out'



Mitre fence/ work clamp assembly



Spindle rise and fall control wheel (A)
Control wheel locking handle (B)

Positioning the Machine



THE 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) BEFORE YOU ATTEMPT TO LIFT OR MOVE THIS MACHINE.

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.



Set Up and Adjustment

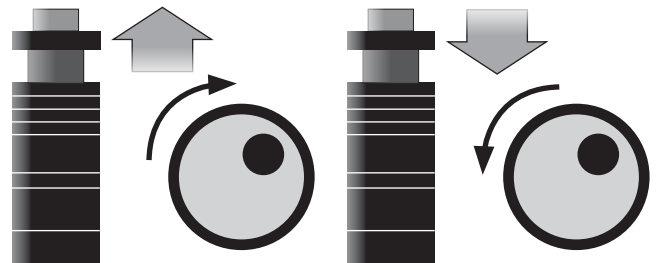
Installing the Cutter Block

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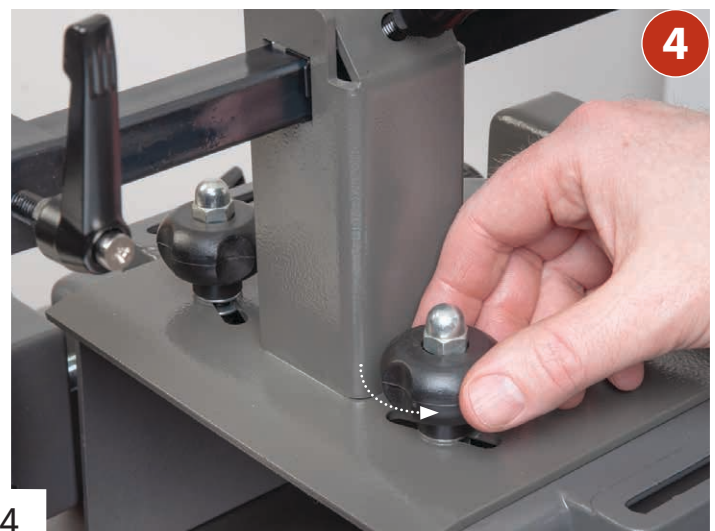


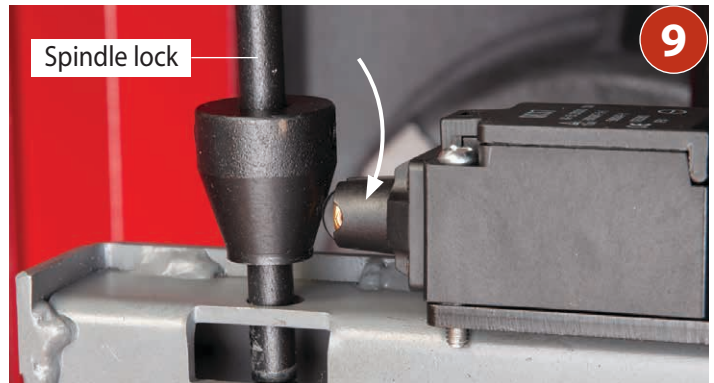
MAKE SURE THE MACHINE IS DISCONNECTED FROM THE MAINS!

Raise the spindle to its maximum height by unlocking the rise/fall control wheel locking handle and the locking knob to the rear of the machine see fig 1-2. Turn the control wheel clockwise to raise the spindle, see fig 3.

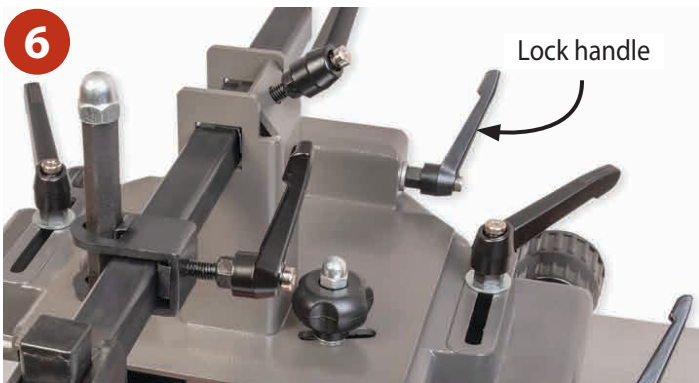


Loosen the two locking knobs to either side spindle guard lid and raise the lid. Nip-up the lid locking handle, see fig 4-5-6.

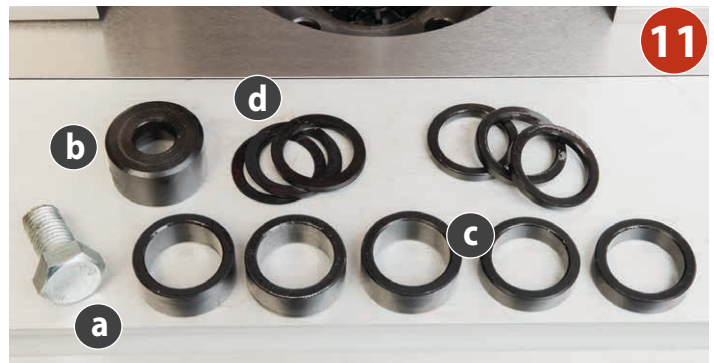
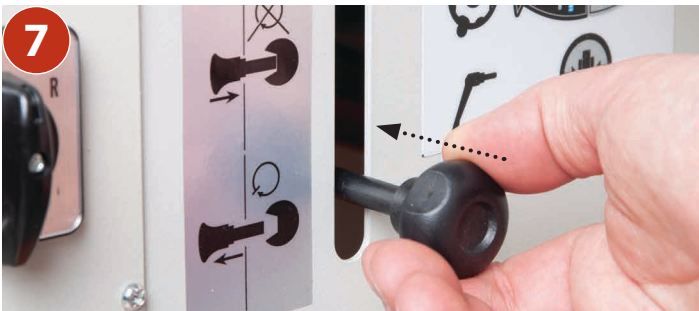




Spindle lock micro switch prevents the machine from starting accidentally, avoiding damage to the spindle mechanism.



Turn the spindle by hand and press the spindle lock rod in, until the lock engages into the spindle's machined hole. Thus locking the spindle in place, see fig 7-8.



CLEAN ALL SURFACES OF SPINDLE ARBOR BEFORE MOUNTING THE CUTTER BLOCK.

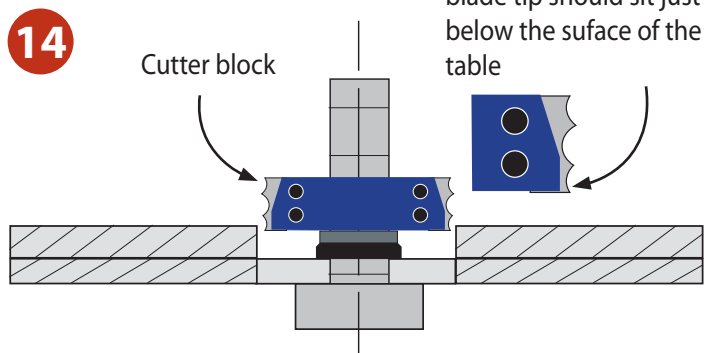
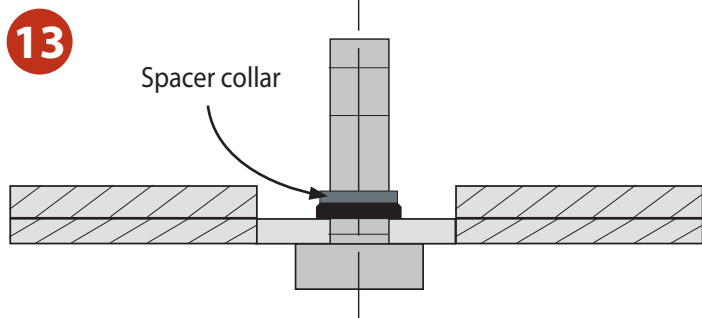
Using the supplied 24mm spanner (L), remove the bolt (a) and clamping block (b) from the spindle. Place safely aside the spacer collars (c) and shims (d), see fig 10-11.

NOTE: Removing the insert rig from the arbor, see fig 12 may depend on what size of cutter block is being used and what your machining. Introduce a spacer collar (c) down over the arbor, see fig 13 on page 16.



NOTE: THE MACHINE WILL NOT START WITH THE SPINDLE LOCK ENGAGED, SEE FIG 9!

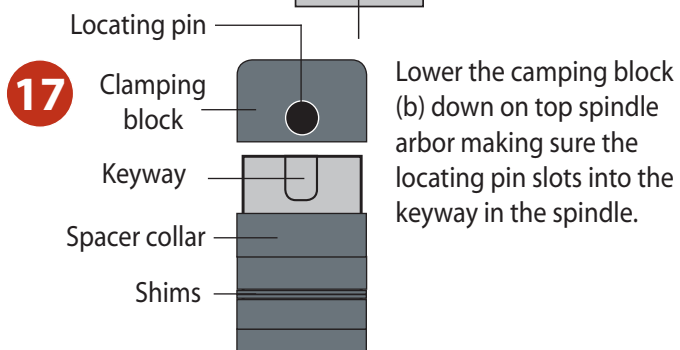
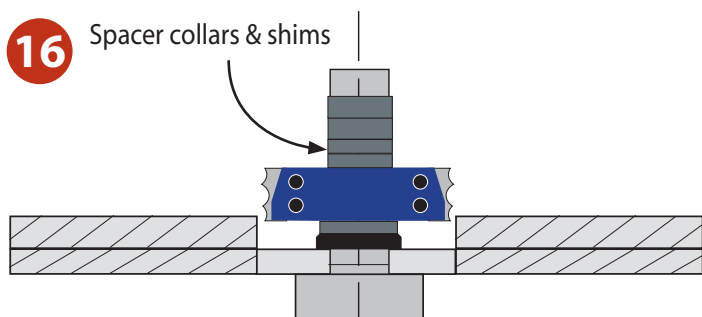
Set Up and Adjustment



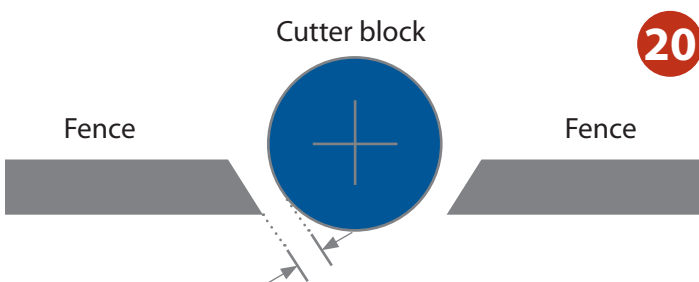
Lower the cutter block down over the spindle arbor making sure the description of the block is on top, see fig 14-15.



WEAR GLOVES WHEN CHANGING OR REPLACING THE BLADES!



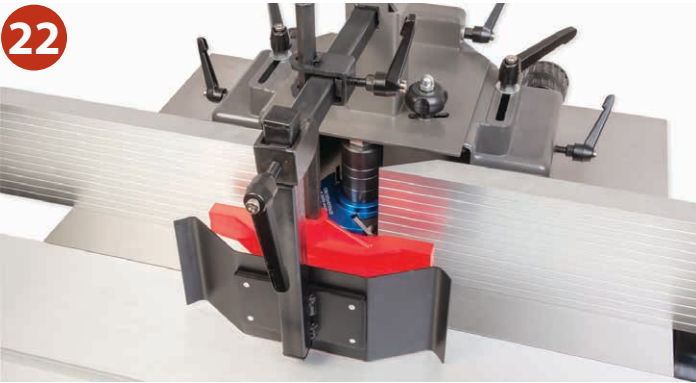
Replace the bolt (a) and tighten using the 24mm spanner.



Adjust the fences as close to the cutter block as possible but not too close that it come into contact with the cutter.



22

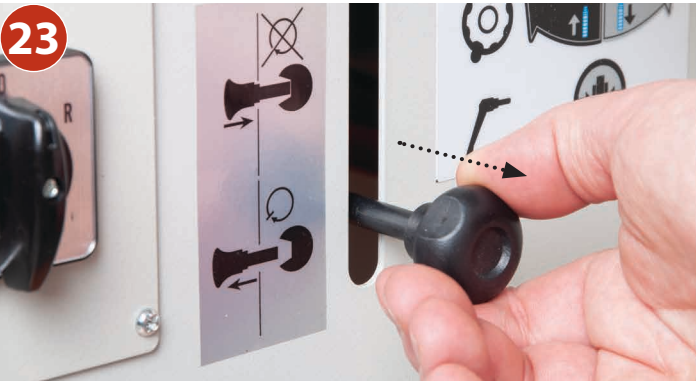


Close the spindle guard lid and re-secure. Release the spindle by pulling out the locking rod, see fig 23.



A GENTLE PULL IS SUFFICIENT!

23



REMOVE ALL TOOLS AWAY FROM WORK AREA!



CONNECT THE MACHINE TO THE MAINS SUPPLY!

24



Move the control select switch to the 'R' (Clockwise Direction), see fig 24. Give the machine a 'quick' burst check (i.e. quick ON-OFF) to ensure everything is O.K. If everything is satisfactory, switch off the machine and wait until it has come to a complete stop.



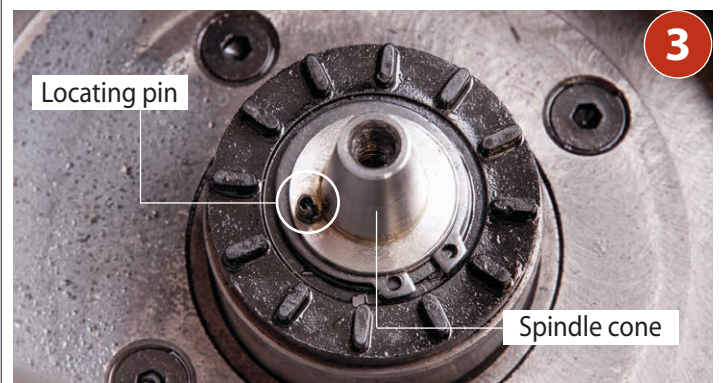
DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

Installing the Collet Adaptor

The spindle moulder can be converted into a router table by fitting the 'Collet Adaptor' (H), see fig 1.



Press in the spindle lock. Remove the spindle arbor by removing the centre Hex screw, see fig 2. Place to one side. Use a soft mallet and tap the arbor top to release the vacuum on the taper.

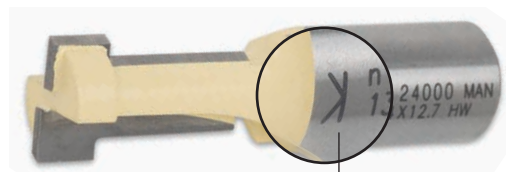


Set Up and Adjustment



Line up the locating pin with the hole to the base of the collet adaptor and insert the adaptor (H) onto the spindle cone. Replace the Hex screw and tighten. Insert the collet (I) and screw on the collet nut (K), see fig 3-4-5-6-7-8-9-10.

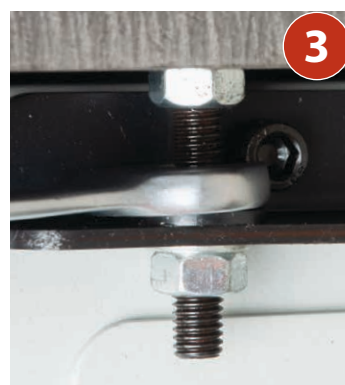
Modern cutters have a safe hold (K) line and a maximum running speed engraved upon the shank as a general guide.



Safe hold 'K' Line

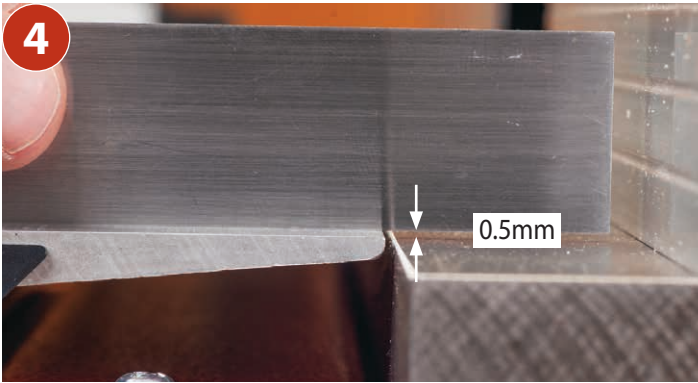
Setting the Cast Iron Table

The cast iron table can be adjusted by the two height bolts/nuts, beneath the table. Two to each side, see fig 1. Place a level on the table and adjust the bolts if required, see fig 2-3.

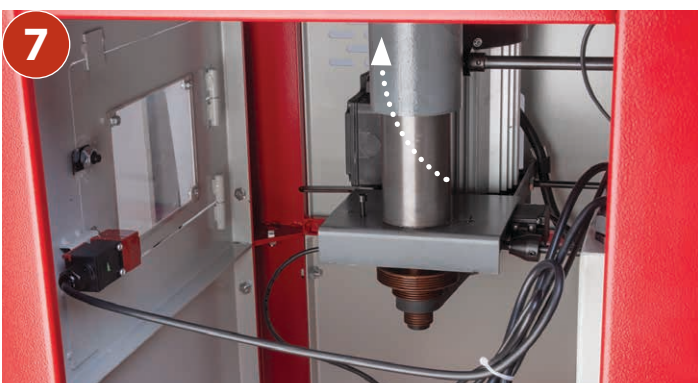
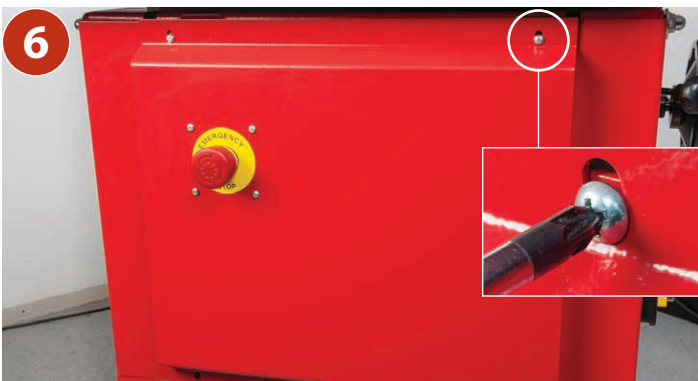


Setting the Sliding Table

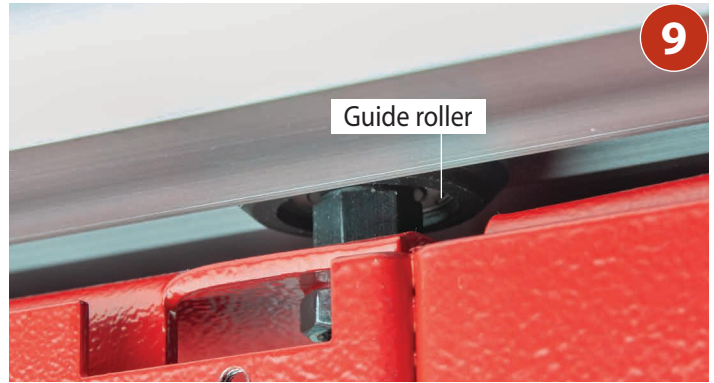
The sliding table needs to be set about 0.5mm above the main table. If adjustment is required adjust the two domed head nuts to two each side of the table, see fig 4-5.



Another method is to adjust the guide rollers beneath the sliding table. First remove the access panel and place carefully to one side, see fig 6-7.



Inside and above are two threaded nuts, see fig 8. Adjust the nuts to raise or lower guide rollers, see fig 9.



Once completed replace the access panel.

Sliding Table Clearance

Adjust the two domed head nuts to two each side of the table, see fig 5. 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, see fig 10.



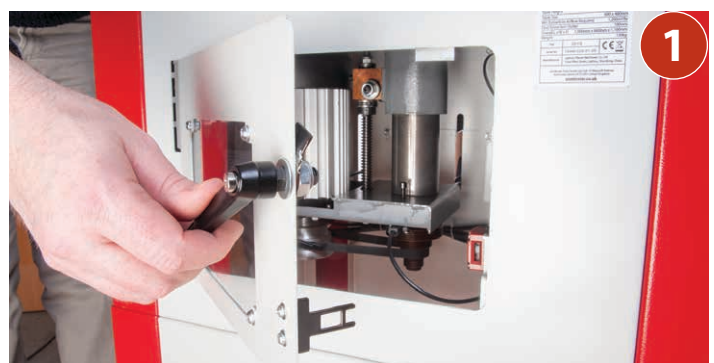
CHECK THE TABLE IS STILL SQUARE TO THE FENCE AND MAKE ADJUSTMENTS IF REQUIRED!

Changing the Spindle Speed

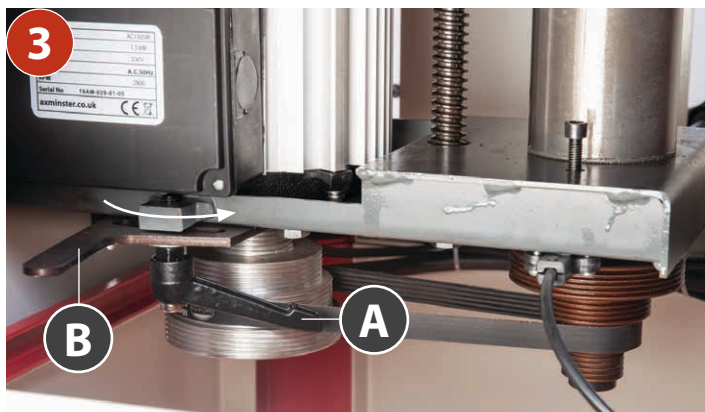
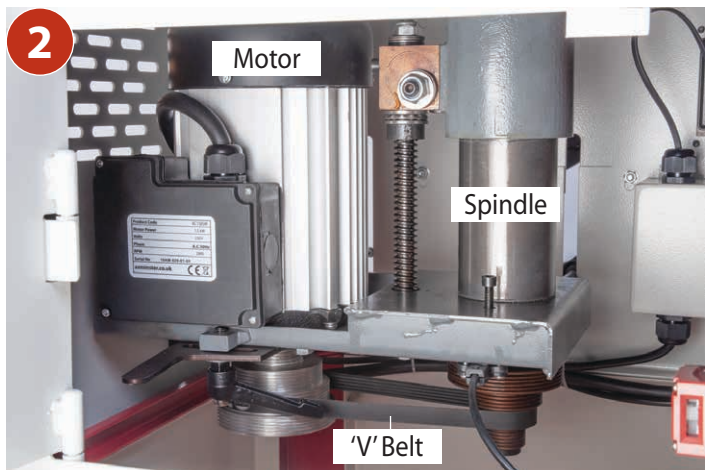


DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

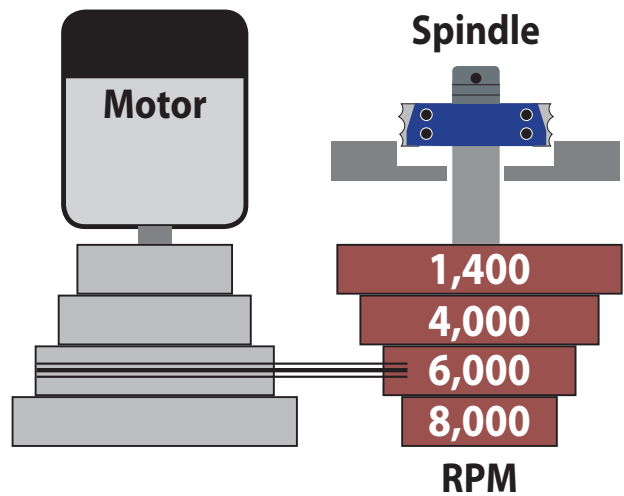
Open the motor access door to the side of the machine, see fig 1-2. Lower the spindle to its lowest point, if not done so already.



Set Up and Adjustment



Spindle Chart



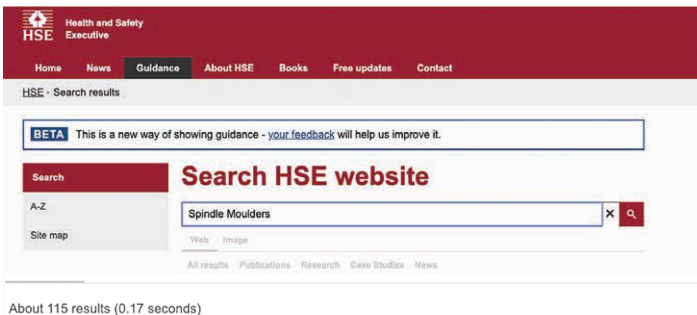
Loosen the locking handle (A) beneath the motor and pivot the motor to the right using the operating lever (B). Using the 'Spindle Chart' above and 'Cutter Block Speed Chart' below reposition the 'V' belt to the appropriate speed required. Make sure the grooves in the belt set correctly in the pulley grooves. Push the motor back to retention the belt. Tighten the locking handle to secure the setting, see fig 3-4.

Cutter Block Speed Chart

Cutter Block Diameter (mm)	450	59	66	71	82					DANGER Risk of fracture, increased noise pollution														
	420	55	62	66	77																			
	400	52	59	63	73	84																		
	380	50	56	60	70	80																		
	350	46	51	55	64	73	82																	
	320	42	47	50	59	67	75	84																
	300	39	44	47	55	63	71	79		DANGER Increased kickback														
	280	37	41	44	51	59	66	73	82															
	250		37	39	46	52	59	65	73									79	85					
	220			35	40	46	52	58	65									70	75	81				
	200				37	42	47	52	59									63	68	73	79	84		
	180	DANGER Increased kickback					37	42	47									53	57	61	66	71	75	85
160							38	42	47	50	54	59	63	67	75	84								
140								37	41	44	48	51	55	59	66	73	88							
120									35	38	41	44	47	50	57	63	75							
100											34	37	39	42	47	52	63							
80															33	38	42	50						
60													31	38										
	2500	2800	3000	3500	4000	4500	5000	5500	6000	6500	7000	7500	8000	9000	10000	12000								
	Spindle Speed (RPM)																							

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.



[Introduction to woodcutting machinery – Vertical Spindle Moulder](https://www.hse.gov.uk/woodworking/spindlemoulder.htm)
<https://www.hse.gov.uk/woodworking/spindlemoulder.htm>

28 Nov 2019 ... Grooving on a Vertical **Spindle Moulder**. Whilst it is recommended in Safe use of woodworking machinery (PUWER 1998 as applied to ...

[Vertical spindle moulding machines: Safe working practices WIS18](https://www.hse.gov.uk/pubns/wis18.pdf)
<https://www.hse.gov.uk/pubns/wis18.pdf>

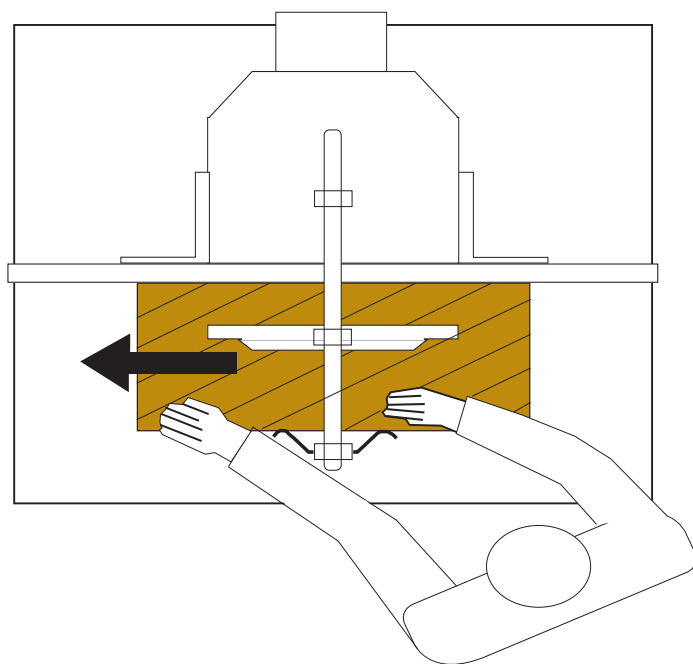
File Format: PDF/Adobe Acrobat
BS EN 847 Part 1.3. Safeguarding of vertical **spindle moulders**. To reduce the risk of contact with the cutter block during rundown, machines must be fitted with a.
Labeled [Publications](#)

[COSHH essentials: WD4: Vertical spindle moulder](https://www.hse.gov.uk/pubns/guidance/wd4.pdf)
<https://www.hse.gov.uk/pubns/guidance/wd4.pdf>

File Format: PDF/Adobe Acrobat
www.hse.gov.uk/woodworking/. Hazards. / Cutting with a vertical **spindle moulder** produces high dust levels. / Wood dust includes dust from hardwood softwood

Correct Operating Position

Position yourself offset to the machine as shown.

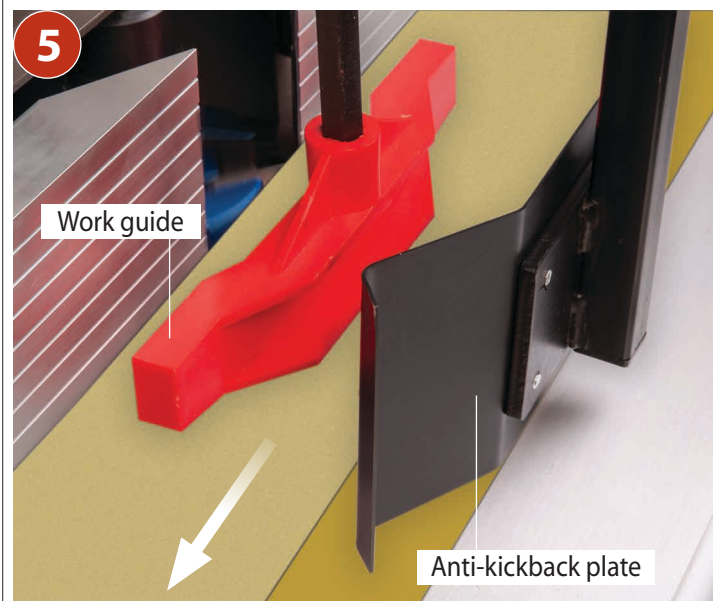


Work Piece Handling

- 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.
- 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.



Loosen the work guide clamping handle and set the 'Work Guide', just above and to centre of the work piece. Set the 'Anti'kickback' plate to the front of the work piece and set the height just above the table, see fig 5 and operating position on the opposite page.

Operating Instructions/ Optional Accessories



NOTE: BEFORE USING YOUR SPINDLE MOULDER, GO ROUND AND MAKE SURE EVERYTHING IS SECURE, FASTENED DOWN, THAT ALL TOOLS ARE CLEARED AWAY FROM THE WORK AREA!



CHECK: THE BLADE FOR SHARPNESS, RESIN BUILD UP ETC., CLEAN IF NECESSARY. CHECK THE CUTTER BLOCK IS SECURELY CLAMPED IN PLACE (I.E. NOT LOOSE)!



CONNECT A DUST EXTRACTION MACHINE TO THE SPINDLE MOULDER EXTRACTION OUTLET!



UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN THE WORK AREA AND KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN!



ALWAYS WEAR EYE PROTECTION AT ALL TIMES!



ALWAYS WEAR EAR PROTECTION AT ALL TIMES!



CONNECT THE MACHINE TO THE MAINS SUPPLY!



Move the control select switch to the 'R' (Clockwise Direction) position, see fig 6. Give the machine a 'quick' burst check (i.e. quick ON-OFF) to ensure everything is O.K. If everything is satisfactory, switch off the machine and wait until it has come to a complete stop. The spindle moulder is ready for use.

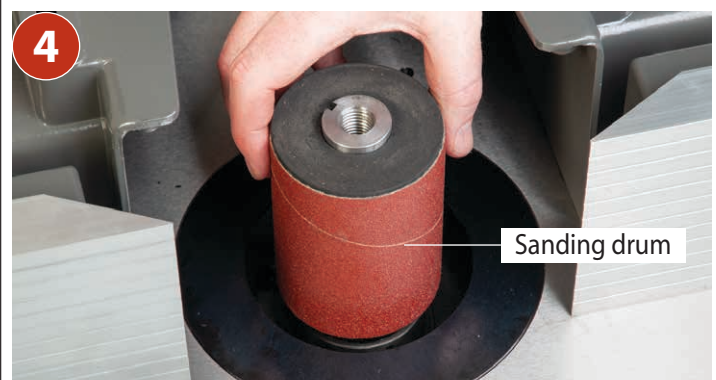
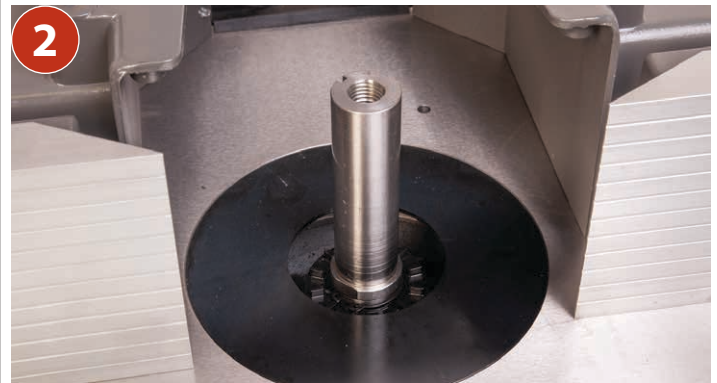


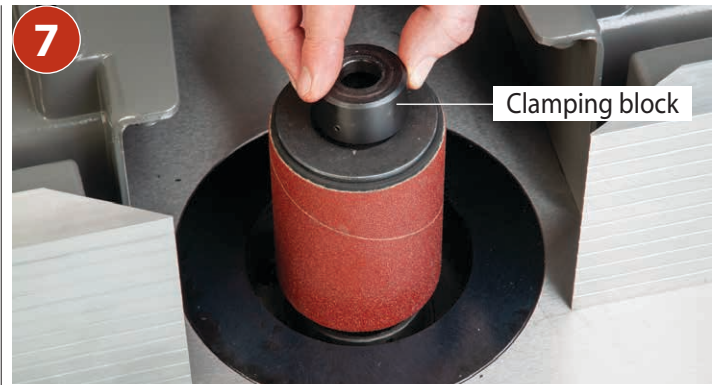
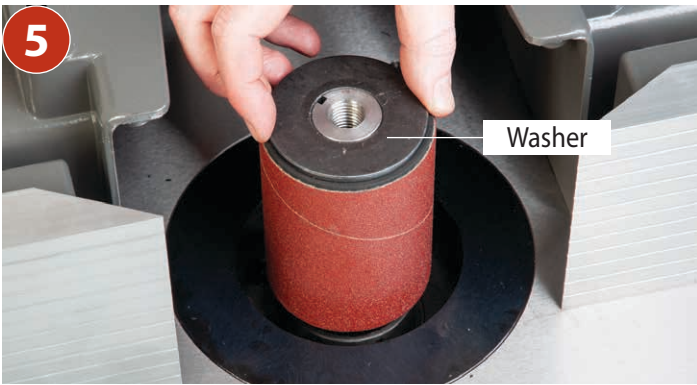
DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

AC150SM Bobbin Sander Attachment

Code: 106184

This bobbin sander attachment simply replaces the spindle in the machine and can be used for shape profiling wood or plastics. **Always use on the lowest speed to prevent the wood from burning.**





Routine Maintenance



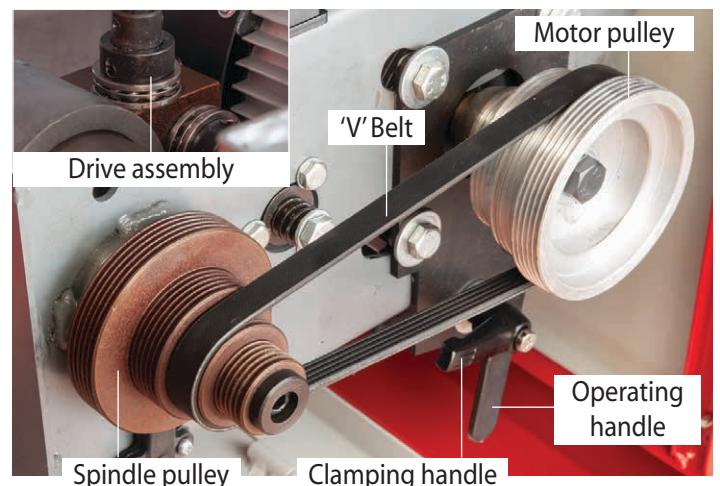
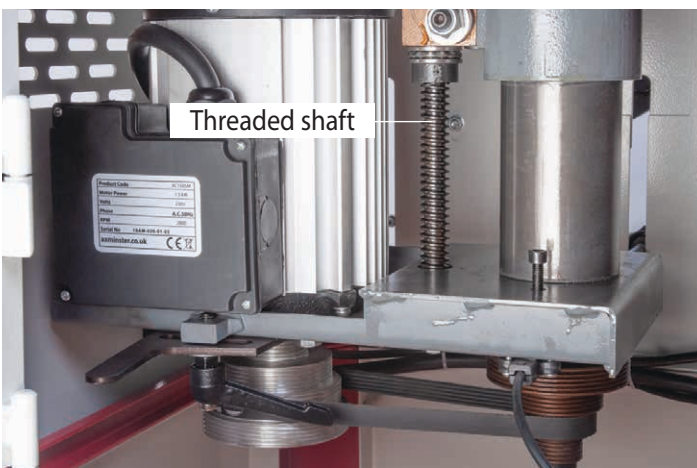
WARNING!! DISCONNECT THE MACHINE FROM THE MAINS BEFORE CONTINUING!

- Keep the cutter block clean and free from dust build up.
- Check the cutter block regularly for chipped blades and damage to the block i.e cracks in the cutter block.
- When changing the cutter block, remove the cutter block and place safely away, clean the spindle arbor by spraying PTFE Lubricant 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, loosen the motor clamping handle and rotate the operating handle until the belt is under tension again. Tighten the motor clamping handle to keep the tension.

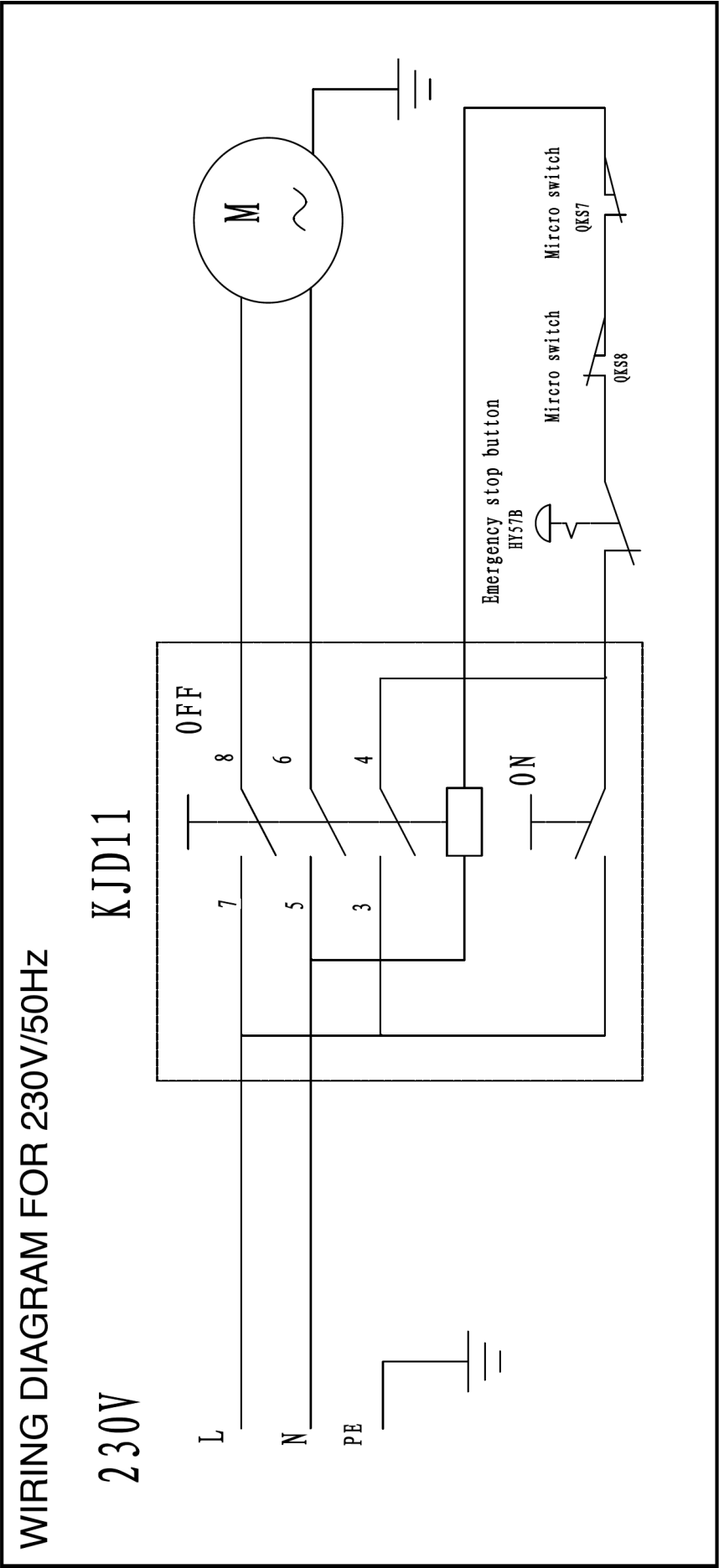
- After several months of constant use the condition of the chains, sprockets, tension of the drive belts and the threaded drive shafts of the rise and fall mechanisms will need to be checked. That may require a service engineer to oversee the job.

If you find that the machine is not performing as it should please contact our "Technical Support Team" on 03332 406406 or email: <mailto:technicalsupport@axminster.co.uk>



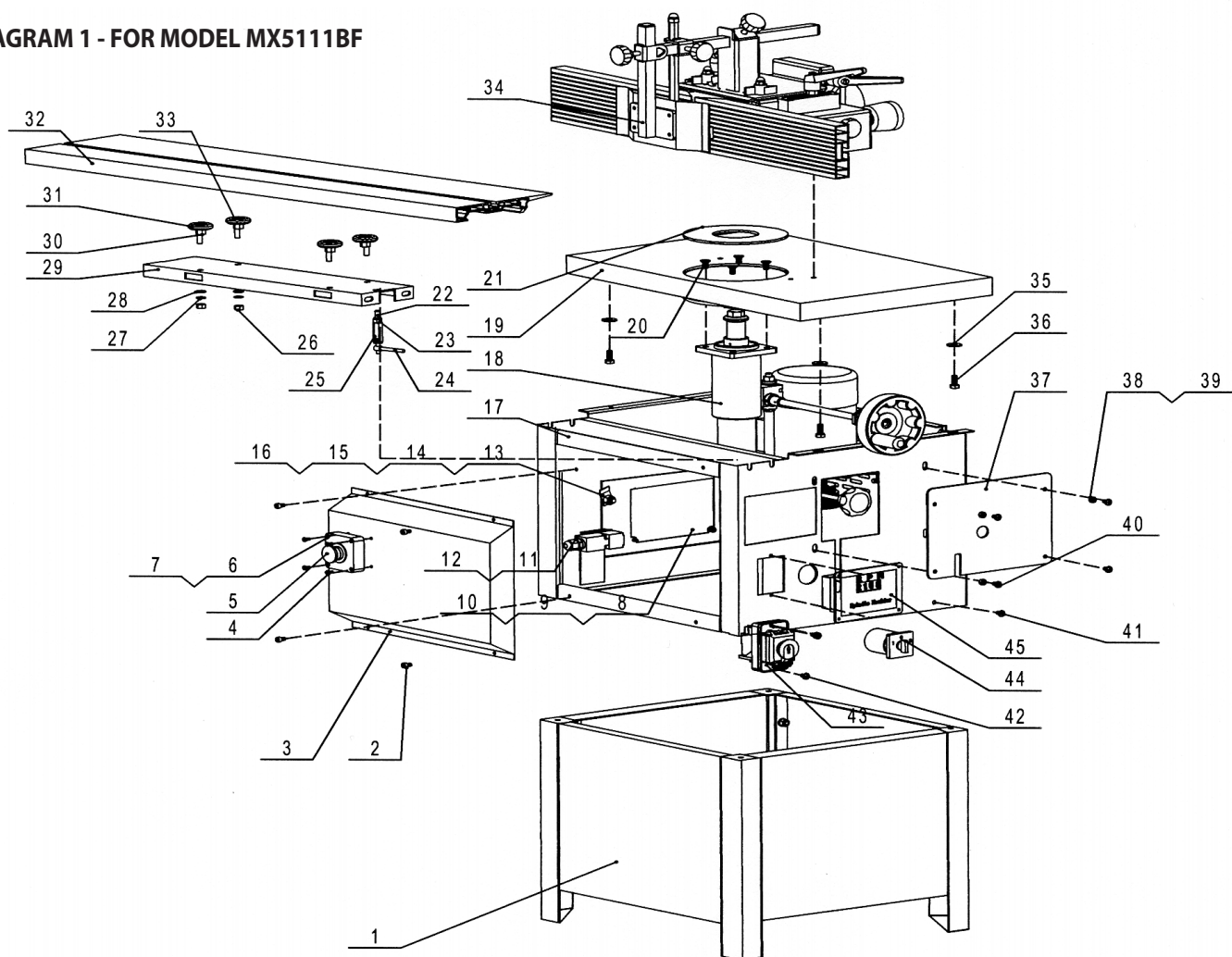
Trouble Shooting

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/repared 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 circuit 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 on 0800 371822)		



Exploded Diagrams/Lists

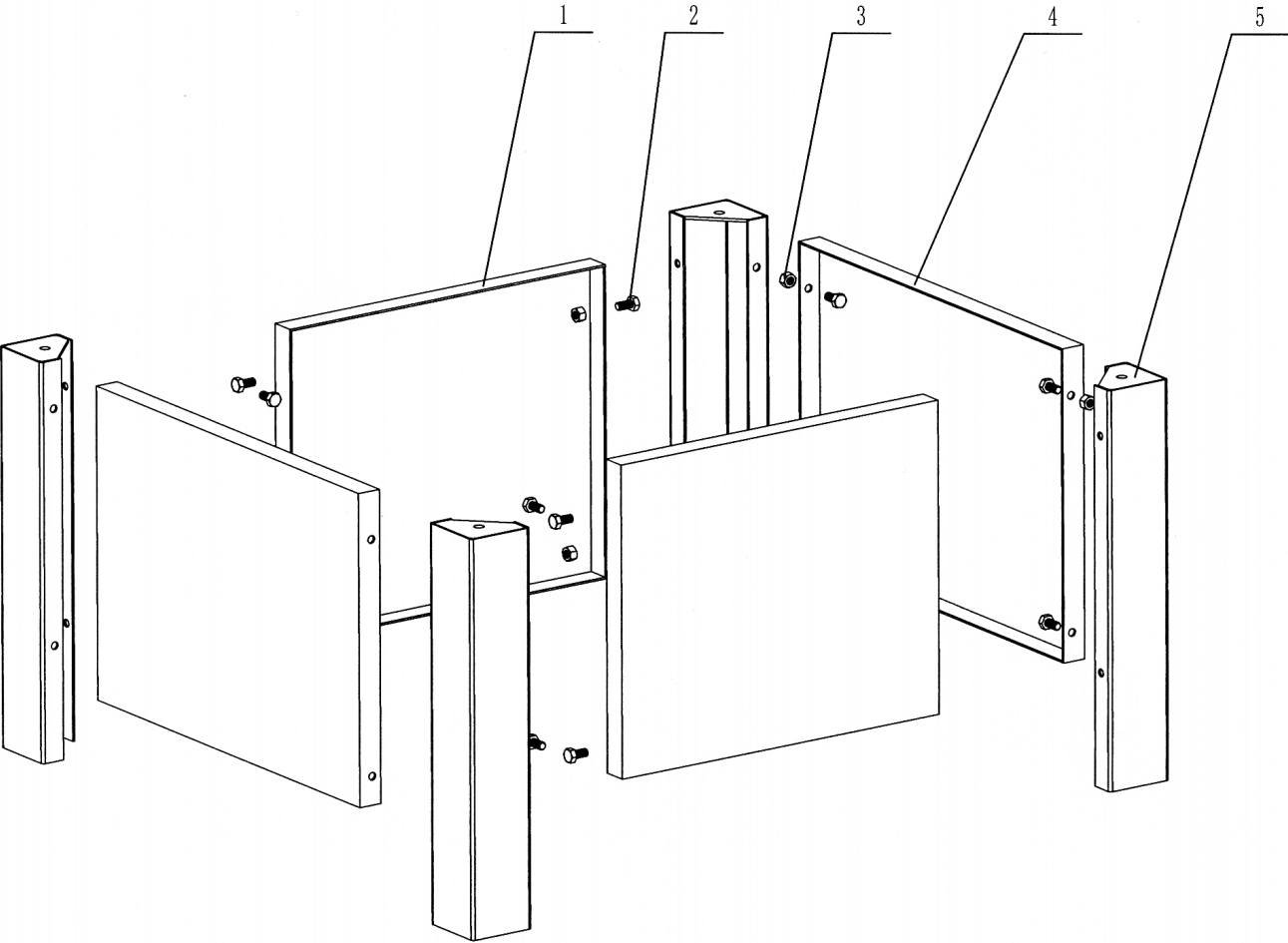
DIAGRAM 1 - FOR MODEL MX5111BF



PARTS LIST 1 - FOR MODEL MX5111BF

PART	DESCRIPTION	Q'TY			
1	BODY STAND ASSEMBLY	1	23	NUT M14	1
2	CAP BOLT M5 X 10	4	24	PULLEY ROD	1
3	PROTECTIVE COVER	1	25	LOCATING SLEEVE	1
4	PHILLIPS SCREW M4 X 35	4	26	NUT M8	4
5	EMERGENCY SWITCH	1	27	SPRING WASHER 8	4
6	EMERGENCY SWITCH COVER	1	28	FLAT WASHER M10	4
7	EMERGENCY SWITCH BOX	1	29	SUPPORT SEAT	1
8	WINDOW	1	30	ECCENTRIC SHAFT	4
9	PHILLIPS SCREW M5 X 12	4	31	ROLLER	4
10	MICRO SWITCH	1	32	ALUMINIUM SLIDING TABLE	1
11	NUT M5	4	33	AXLE RING 10	4
12	PHILLIPS SCREW M4 X 30	2	34	PROTECTION COVER ASSEMBLY	1
13	LOCKING PLATE	1	35	SPRING WASHER 8	4
14	LOCKING HANDLE	1	36	HEX BLOT M8 X 15	4
15	SELF-LOCKING NUT M10	1	37	COVER PLATE	1
16	FLAT WASHER M10	1	38	FLAT WASHER 6	4
17	BODY ASSEMBLY	1	39	NUT M6	4
18	MOULDER DRIVING ASSEMBLY	1	40	PHILLIPS SCREW M6 X 12	4
19	WORKING TABLE	1	41	CAP BOLT M5 X8	4
20	SCREW M8 X 20	4	42	PHILLIPS SCREW M5 X12	2
21	SPINDLE COVER RING	1	43	SWITCH KJD11-230V	1
22	ANGULAR SETTING ASSEMBLY	1	44	DIVERTING SWITCH	1
			45	DIGITAL DISPLAY DEVICE	1

DIAGRAM 3 - FOR BOTH MX5111BF AND MX5111BR

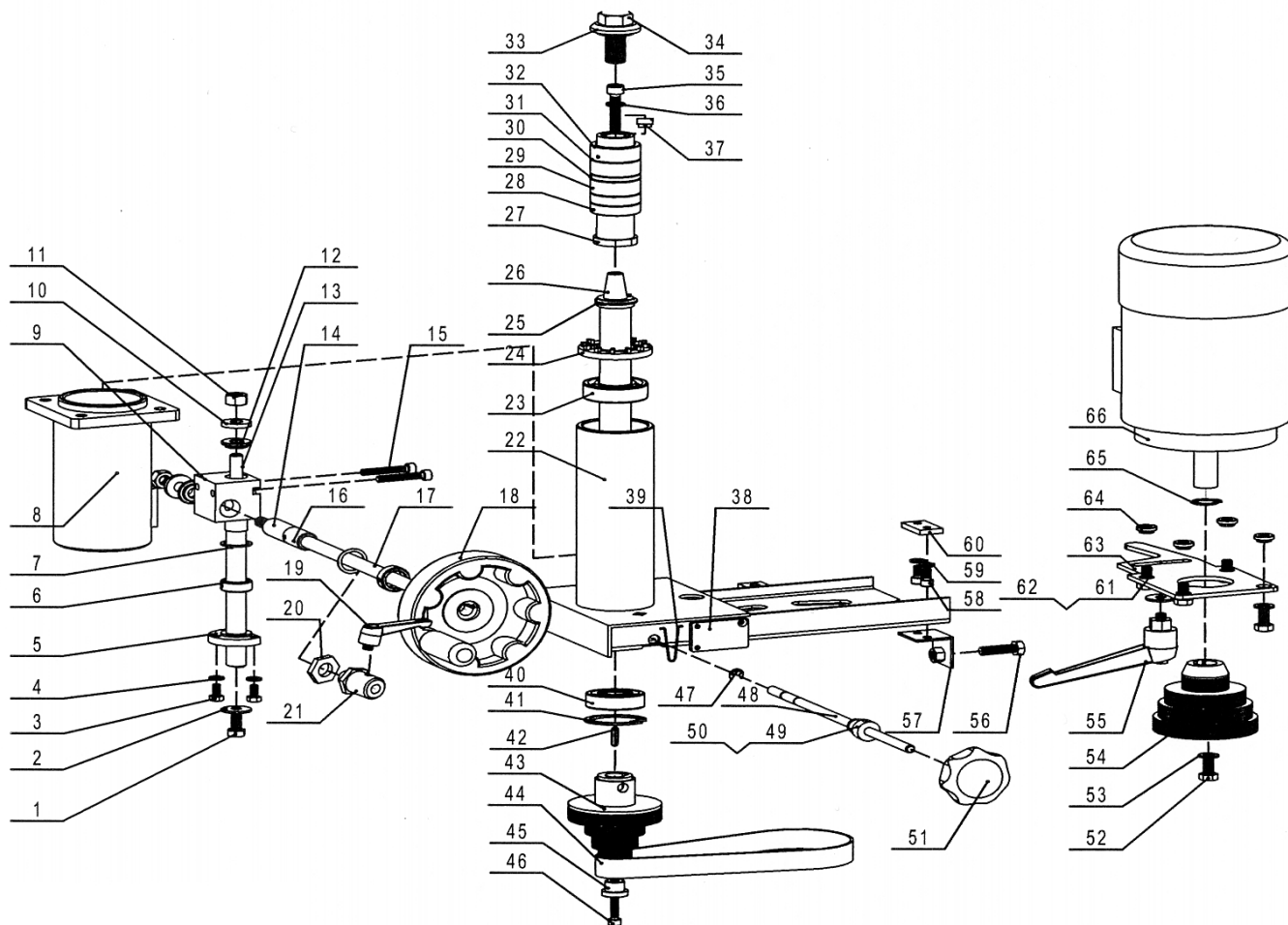


PARTS LIST 3 - FOR BOTH MX5111BF AND MX5111BR

PART	DESCRIPTION	Q'TY
1	SIDE PLATE	2
2	HEX BOLT M8 X 16	16
3	NUT M8	16
4	STAND	4
5	LINKING PLATE	2

Exploded Diagrams/Lists

DIAGRAM 4 - FOR BOTH MX5111BF AND MX5111BR



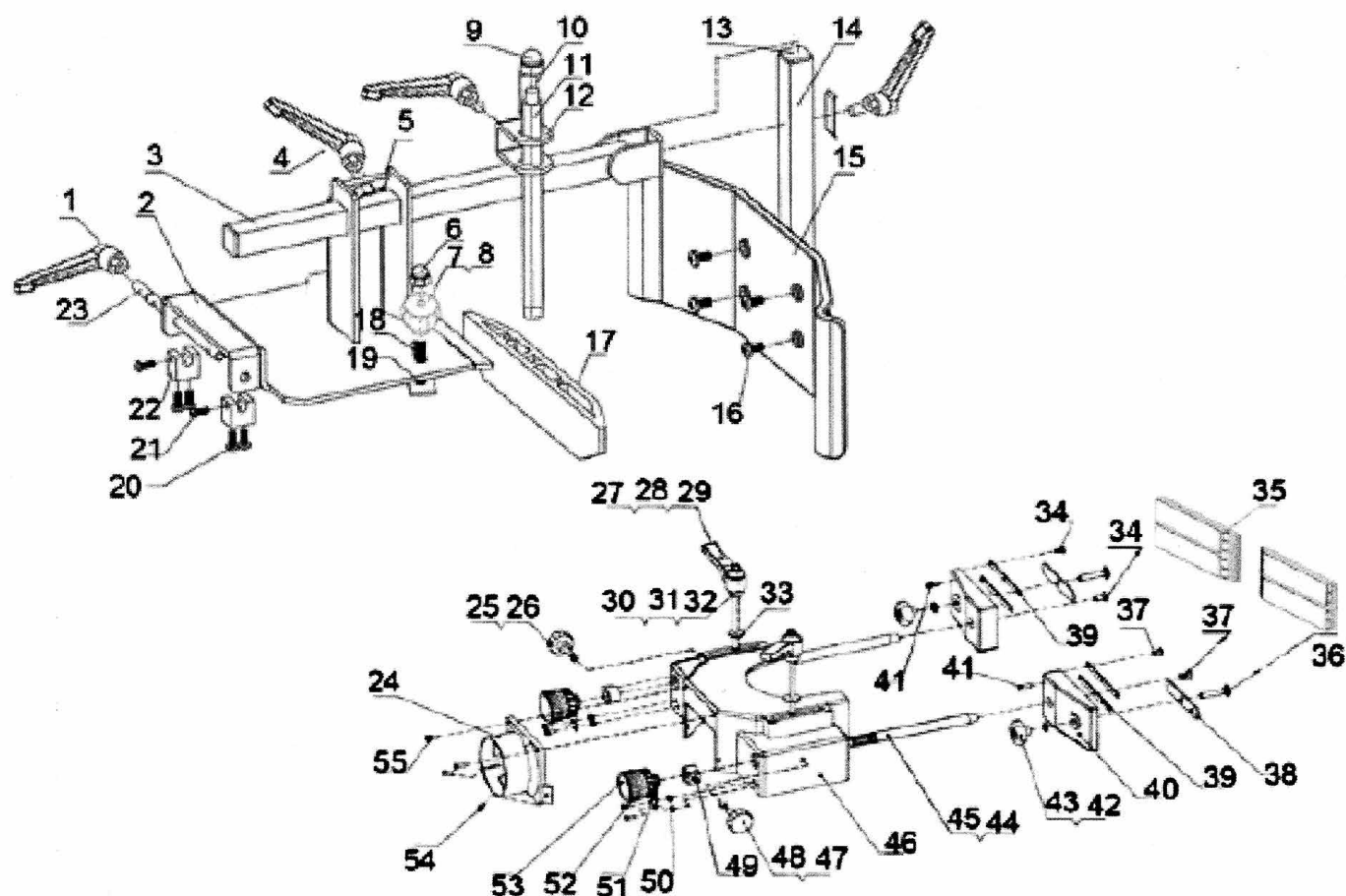
PARTS LIST 4 - FOR BOTH MX5111BF AND MX5111BR

PART	DESCRIPTION	Q'TY
1	HEX BOLT M8 X 10	1
2	FLAT WASHER M8	1
3	HEX BOLT M6 X 12	3
4	FLAT WASHER M6	3
5	NUT BUSH	1
6	GEAR TUBE	2
7	BEARING 8103	2
8	LIFTING TUBE BRACKET	1
9	GEAR BOX	1
10	BEARING	2
11	NUTM 10	2
12	SPINDLE TUBE	2
13	GEAR SHAFT	1
14	GEAR	1
15	SCREW M6 X 40	2
16	SPRING PIN 4 X 25	3
17	HAND WHEEL AXLE	1
18	HAND WHEEL	1
19	LOCKING HANDLE	1
20	NUT M 20	1
21	LOCKING BUSH	1
22	SPINDLE COLUMN	1

23	BEARING NSK	1
24	BEARING CAP	1
25	BEARING C RING 30	1
26	SPINDLE	1
27	SHORT SPINDLE 30MM	1
28	SPINDLE WASHER 10	2
29	SPINDLE WASHER 15	2
30	SPINDLE WASHER 5	3
31	SPINDLE WASHER 0.5	10
32	SPINDLE WASHER	1
33	SPINDLE CAP	1
34	HEX BOLT M16 X 40	1
35	CAP SCREW M8 X 40	1
36	SPRING WASHER M8	1
37	NUT	1
38	PLATE	1
39	SPRING CLAMP	1
40	BEARING 6204	1
41	C RING 47	1
42	PIN A5 X 35	1
43	SPINDLE PULLEY	1
44	BELT 508J5	1
45	FIX TUBE	1

46	CAP SCREW M6 X 35	1
47	C RING 6	1
48	CONTROL AXLE	1
49	SEPARATE TUBE	1
50	FLAT HEAD SCREW M6 X 8	2
51	LOCKING HANDLE	1
52	BOLT M18	1
53	FLAT WASHER M8	2
54	MOTOR PULLEY	1
55	LOCKING HANDLE M8 X 20	1
56	HEX BOLT M8 X 30	1
57	ANGLE IRON	1
58	CAP SCREW M6 X 12	2
59	FLAT WASHER M6	2
60	NUT PLATE	1
61	HEX BOLT M8 X 20	4
62	FLAT WASHER M8	4
63	TENSION BLOCK	1
64	ADJUSTING TUBE	4
65	C RING 19	1
66	MOTOR	1

DIAGRAM 5 - FOR BOTH MX5111BF AND MX5111BR



PARTS LIST 5 - FOR BOTH MX5111BF AND MX5111BR

Part	Description	Q'ty	18	Spring	2	40	Activity Block	2
1	Locking Handle	1	19	Locking Block	2	41	Flat Head Screw M6 x 20	8
2	Exhaustion Cover	1	20	Phillips Screw M5 x 12	4	42	Locking Handle	2
3	Square Leader Assembly	1	21	Phillips Screw M4 x 12	2	43	Flat Washer M8	2
4	Locking Handle	3	22	Small Support	2	44	Guide Plate Adjusting Axle	2
5	Long Washer	1	23	Shaft	1	45	Flat Washer M8	2
6	Lock Nut M8	2	24	Dust Port	1	46	Exhaustion Socket	1
7	Locking Handle	2	25	Nut	1	47	Nut	1
8	Flat Washer M8	2	26	Locking Handle	1	48	Locking Handle	1
9	Lock Nut M10	1	27-32	Locking Handle M8 x 80 x 140	2	49	Locking Block	2
10	Hex Square Leader	1	33	Flat Washer M8	2	50	NutM5	4
11	Washer	1	34	Head Screw M5 x 10	6	51	Baffle	2
12	Clamp Plate	1	35	Fence	2	52	Hex Bolt M5 x 16	4
13	Square Block	3	36	Bolt M8 x 45	2	53	Handle Wheel	2
14	Stand Pipe	1	37	Head Screw M5 x 10	6	54	Phillips Screw M5 x 12	2
15	Anti-Kickback Plate	1	38	Splint	2	55	Phillips Screw M5 x 16	2
16	Phillips Screw M6 x 12	4	39	Board	4			
17	Vertical Hold Down Guide	1						

[illegible]

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