



SERVICE PROCEDURE

Cast Iron Wing Leveling

Applicable Model(s)

Industrial Cabinet Saw (ICS), Professional Cabinet Saw (PCS), Contractor Saw (CNS)

Tools Needed

- 3' precision straight edge
- Feeler gauges
- 13mm box end wrench
- 5mm hex wrench
- Block of wood
- C Clamp 5" or F Clamp 5"
- Cellophane tape
- Shop towels

Part(s) or Service Kit(s) Needed

- [Cast Iron Extension Wing for CB and ICS- CB104 004](#)
or
- [CNS Cast Iron Extension Wing – CNS-07-017](#)
or
- [Cast Iron Extension Wing for PCS - PCS-003](#)

Related Links

- [Level and Align Cast Iron Wings](#)

PROCEDURE SUMMARY

This procedure will demonstrate how to align the wing to the cast iron table.

SAFETY

WARNING: Disconnect the plug from the power source from the tool before making any adjustments, changing accessories, or storing power tools. Such preventive safety measures reduce the risk of starting the power tool accidentally.

WARNING: Wear gloves when handling the saw blade.

WARNING: When servicing your tool, use only replacement parts from SawStop.

WARNING: Keep handles and grasping surfaces dry, clean and free from oil and grease. Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

SERVICE PROCEDURE

DISASSEMBLY

1. Remove Table insert before checking for flatness.
2. With the feeler gauge and straightedge check for flatness on both the table and wings. If the wings or table are out of spec (.010) please contact the SawStop Service Department.
3. Using a 13mm end wrench, loosen the cap screws that attach the wing to the table. (Image 1)

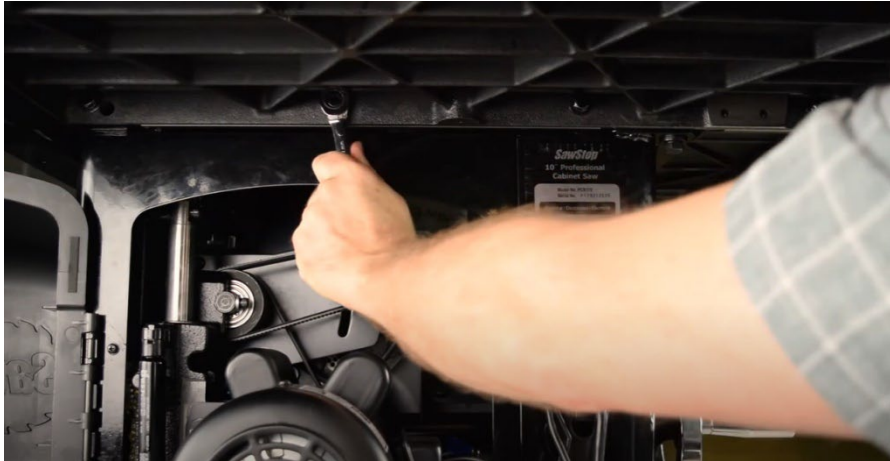


Image 1

4. With the 5mm Hex wrench, loosen the bolts that attach the wing to the rails. (Image 2 front) & (Image 3 rear)



Image 2 Front



Image 3 Rear

ALIGNING WING TO TABLE SEAM

5. Using the 13mm wrench, begin the alignment with one of the inner cap screws. Align the seam at that cap screw, and fully tighten. Repeat for the other cap screws. (Image 4)

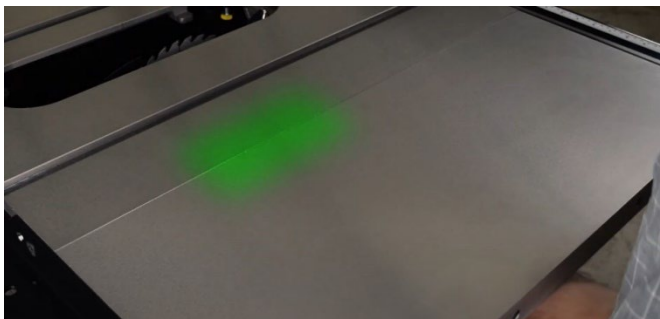


Image 4

SERVICE PROCEDURE

6. Once the inner seam is aligned and tightened, align either the front or rear edge and tighten that corresponding cap screw.
7. If switch box is already mounted, remove the bracket from the underside using a 5mm hex wrench.
8. Place the block of wood over the uneven seam. Position the clamp so that it is applying pressure through the block of wood directly over the seam. (Image 5)

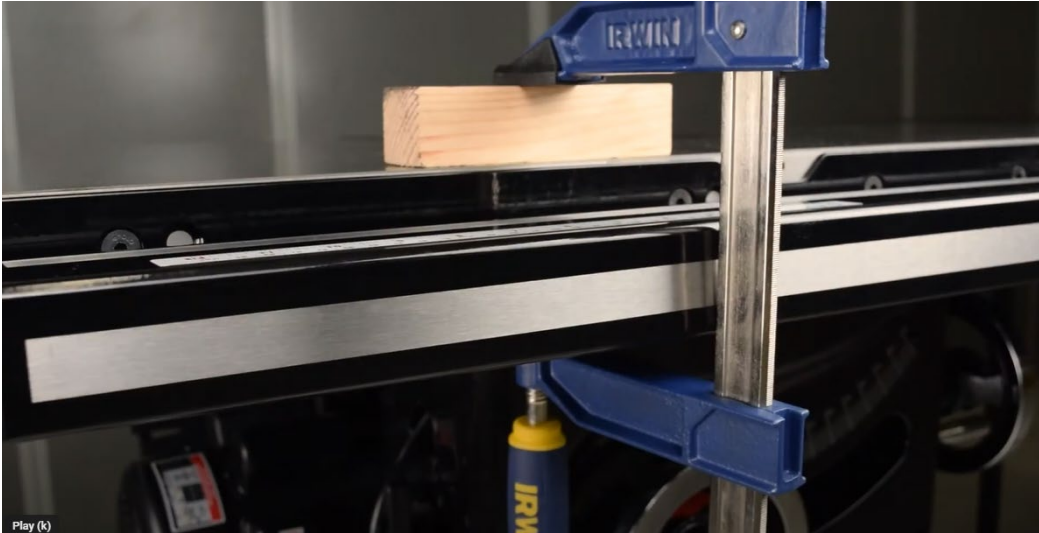


Image 5

9. Check the seam visually to be sure that it is flush. If the seam is still not flush with wing and table tighten continue tightening the clamp. (Image 6)



Image 6



SERVICE PROCEDURE

CAST IRON WING SAG ADJUSTMENT OR FIX

10. If the wing-to-table seam is flush and secure but the wing protrudes above or below the level of the main table, continue with the adjustment steps below. (Image 7)

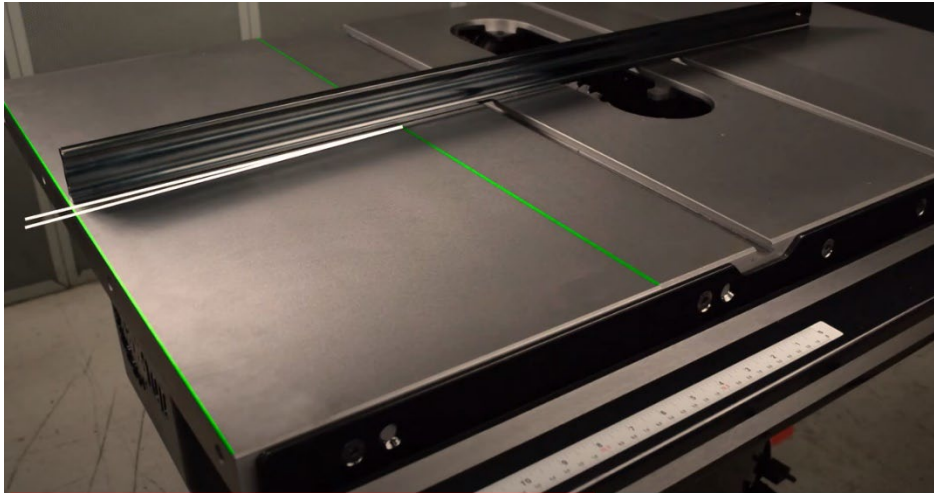


Image 7

USING RAILS TO FLEX WING INTO ALIGNMENT

11. The first method is to take advantage of the strength of the rails to hold the wing in alignment. (Image 8)



Image 8



SERVICE PROCEDURE

- Using a 13mm combo wrench, make sure the cap screws that attach the wing to the table are tightened down. (Image 9)



Image 9

- With the 13mm combo wrench and the 5mm hex wrench, loosen the bolts that attach the wing to both rails. (Image 10) & (Image 11)



Image 10



Image 11



SERVICE PROCEDURE

14. Lift up or push down, as needed, to make the wing level with the table. Assistance may be required to simultaneously hold the wing and tighten the bolts. (Image 12)

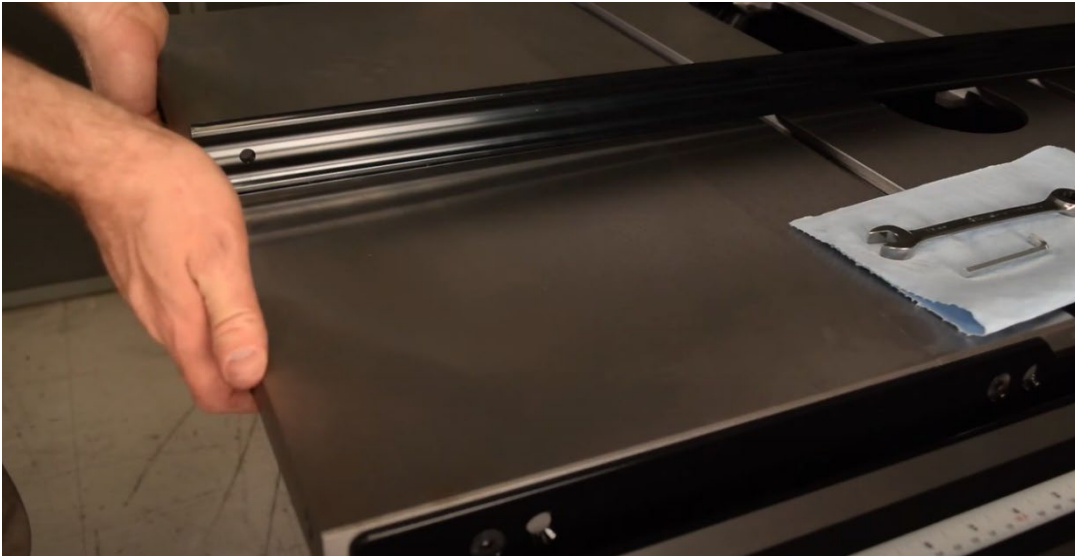


Image 12

SHIMMING THE WING INTO ALIGNMENT

15. The second method is to use tape to shim the edge. This example uses packing tape cut to a 26 inch by half inch strip. Begin by noting whether the outer edge of the wing is too low or too high. (Image 13)

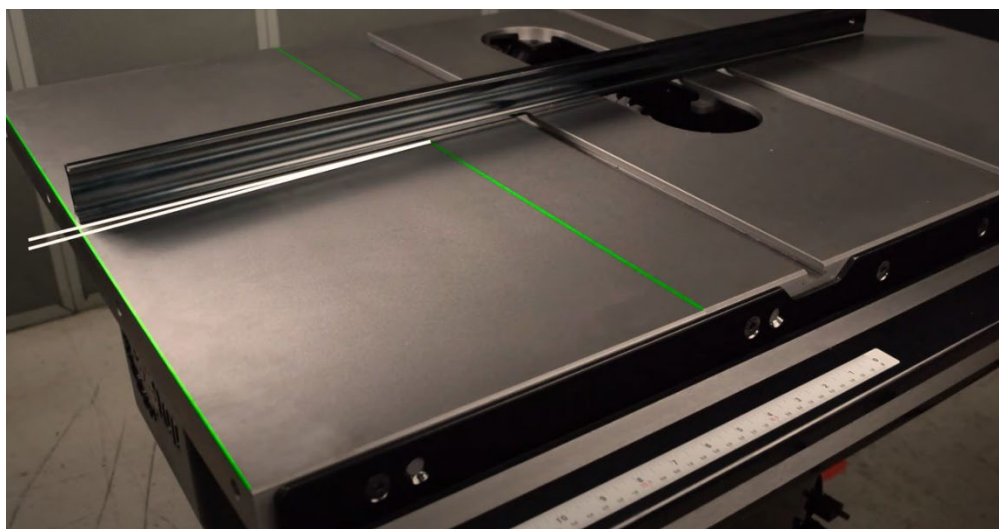


Image 13



SERVICE PROCEDURE

16. Remove the bolts holding the wing to the rails. (Image 14)



Image 14

17. Take the wing off by removing the cap screws using a 13mm combo wrench. (Image 15) & (Image 16)



Image 15



Image 16

SERVICE PROCEDURE

18. Using a shop towel remove any grease or residue left on the wing that the tape will attach to (Image 17)



Image 17

19. In this example, the outer edge of the wing is too low shim the lower portion of the surface that contacts the table to force the wing up. If the outer edge of the wing is high, shim the upper portion to force the wing down. (Image 18)



Image 18



SERVICE PROCEDURE

20. Reinstall the wing. It is advisable to insert screwdrivers, or something similar, through the holes in the rails and the wing to prevent the wing from falling while attaching the wing to the table. (Image 19)



Image 19

21. Using the 13mm combo wrench, secure and tighten down the bolts that hold the cast iron wing to the table. (Image 20)

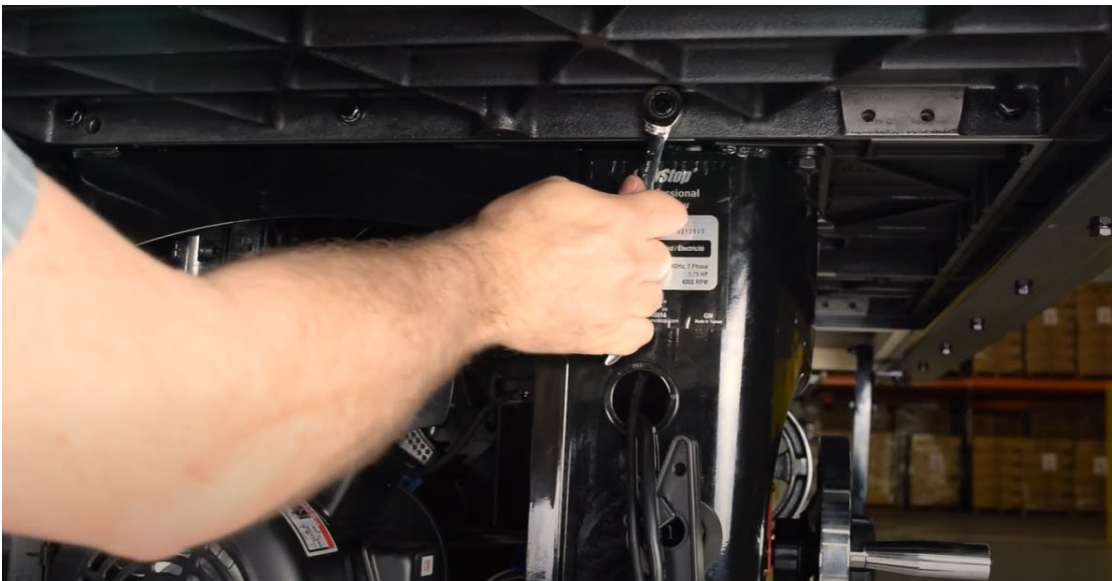


Image 20

SERVICE PROCEDURE

22. With the 5mm hex wrench and 13mm combo wrench secure the rails back onto the cast iron wing. (Image 21) & (Image 22)



Image 21



Image 22

FINAL ADJUSTMENTS

23. Make sure all bolts are secured and tightened down firmly. A good idea would be to wipe down and clean off all cast iron that was touched to prevent rust marks from appearing on the surface.