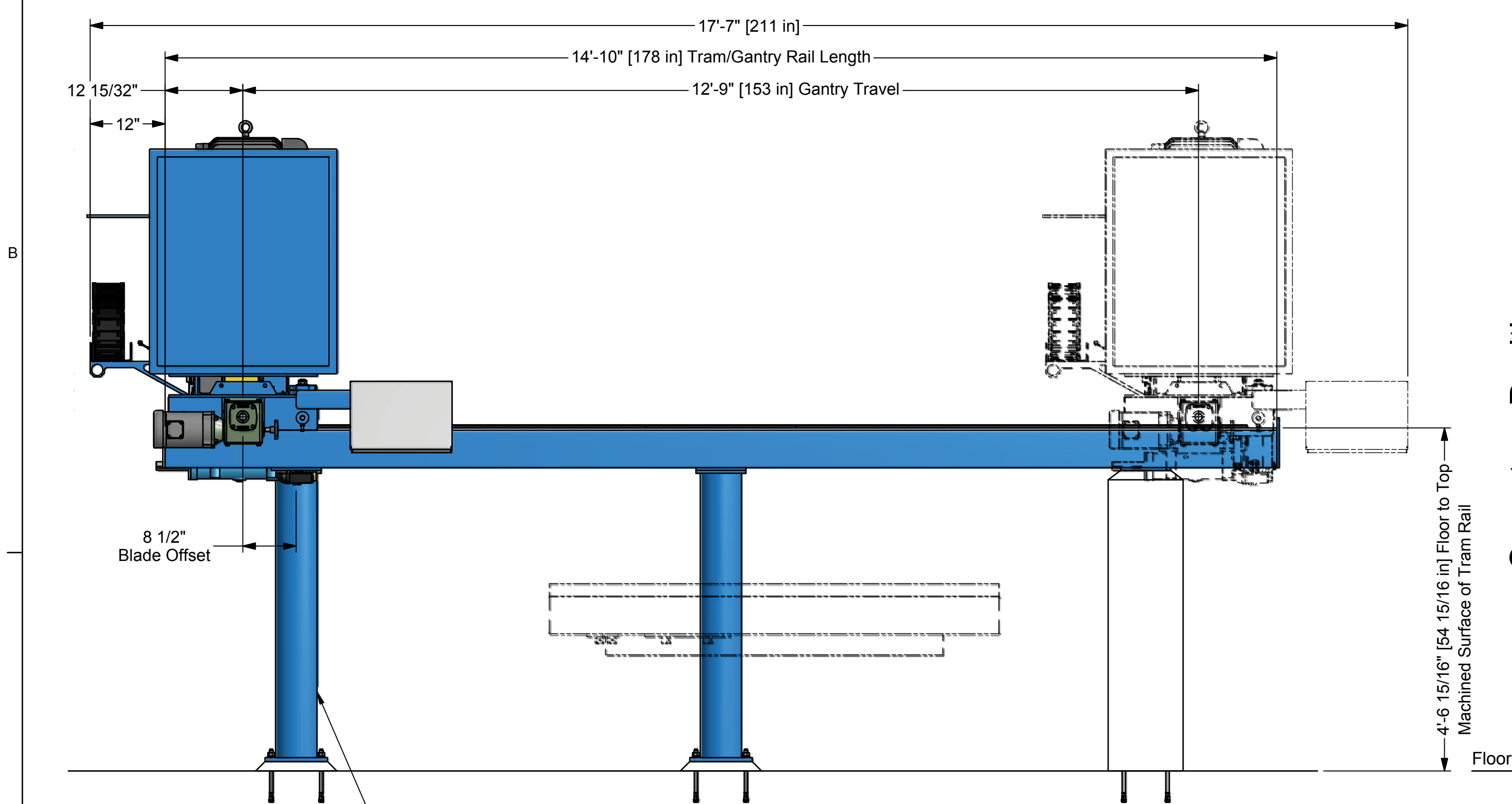
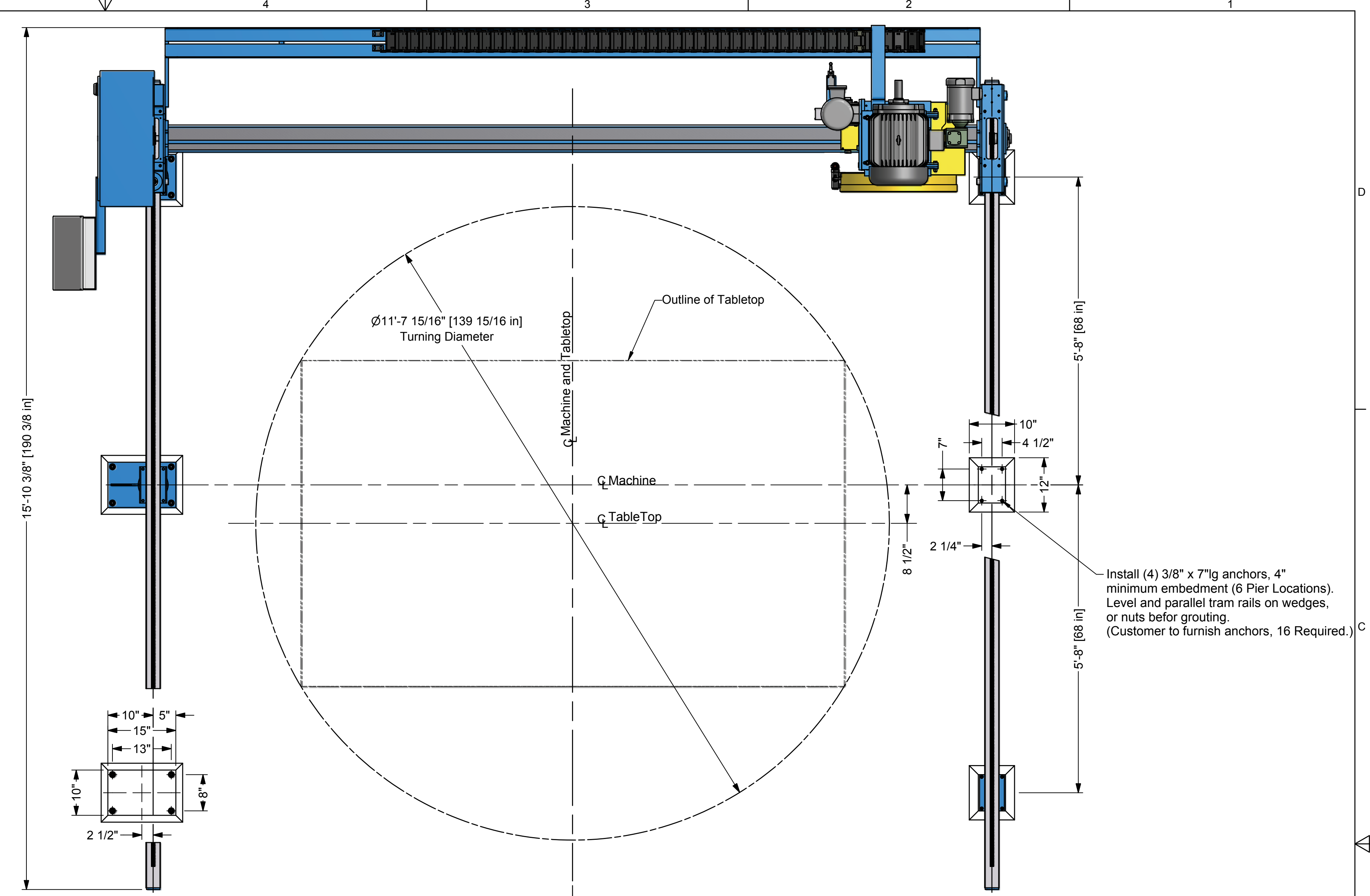


| Parts List | | | |
|------------|-----|---------------|---------------------------------------|
| ITEM | QTY | PART NUMBER | DESCRIPTION |
| 1 | 6 | B-4002-14H-12 | PIER - Steel - 46 5/8" |
| 2 | 2 | B-4307-3A | Weldment - Tram Rail Assembly |
| 3 | 1 | E-4016-2D | TRAM/GANTRY - Machine Assembly - 541 |
| 4 | 1 | E-4090-1B | CARRIAGE/SADDLE - 11 7/8" Tall - 541 |
| 5 | 1 | E-4020-8 | SPINDLE - Heavy Duty - 541 |
| 6 | 1 | B-4055-1-24 | GUARD - Blade - 24" |
| 7 | 1 | B-4054-1B | RH WATER DISTRIBUTOR |
| 8 | 1 | BT-5000-058 | CARRIER - Nylatrac - NP-400-10 X 132" |
| 9 | 1 | 10K14 | ENCLOSURE-N412363012 - Wiegmann |
| 10 | 1 | EC-5000-727 | ENCLOSURE - WC12C16 - Wiegmann |

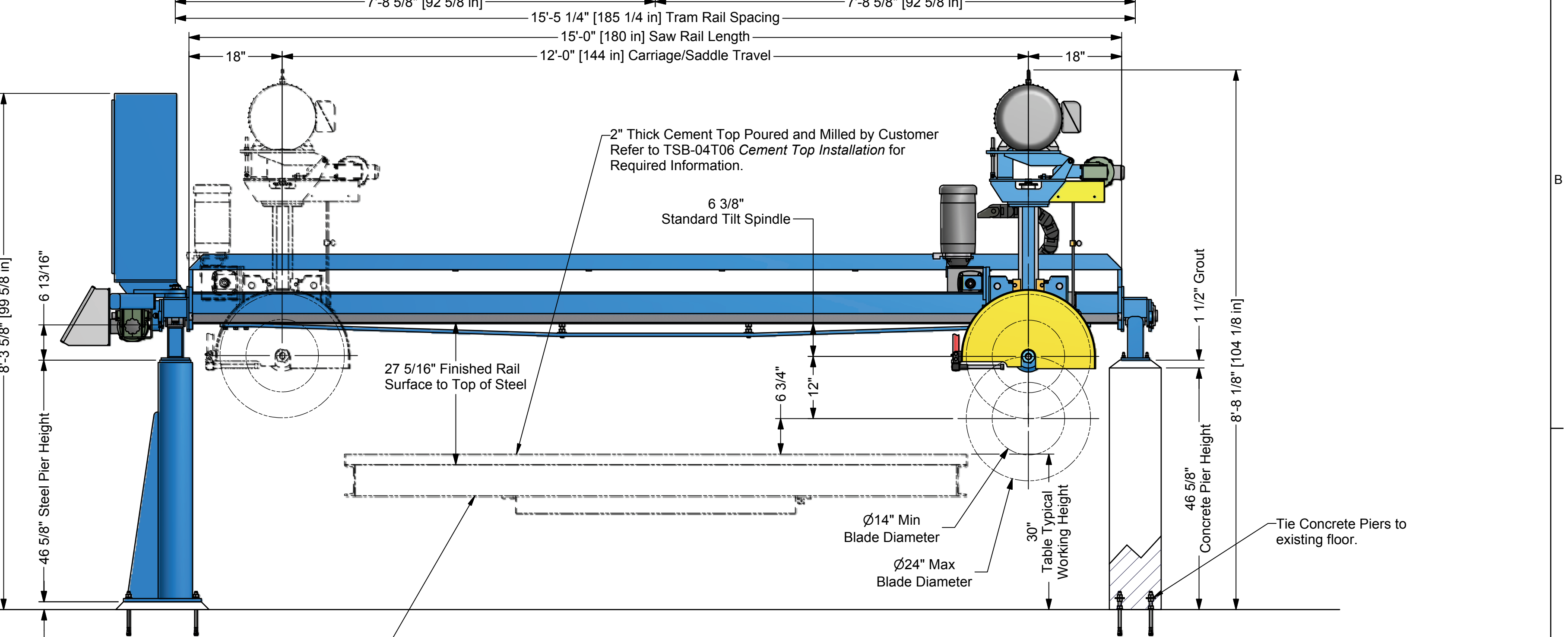


Pre-assemble tram rails to posts and set roughly in place on shim/spacers (preferably 1.5" minimum thickness).
 For large rails set posts roughly in place then bolt on rails.
 Use transit or water level to set elevation and pitch of machined rail surface.
 Use precision (.005/mark) machinist level to set "roll".
 For multi-section tram rails, use music wire to set straightness.
 Drill anchor holes in floor through the post holes.
 Set Ø5/8" Anchor, 4" minimum embedment.
 If anchor type requires, set posts aside then put back on anchors.
 Repeat leveling operation to finished precision.
 Place machine on rails and test movement. Grout the posts.

Operators Position

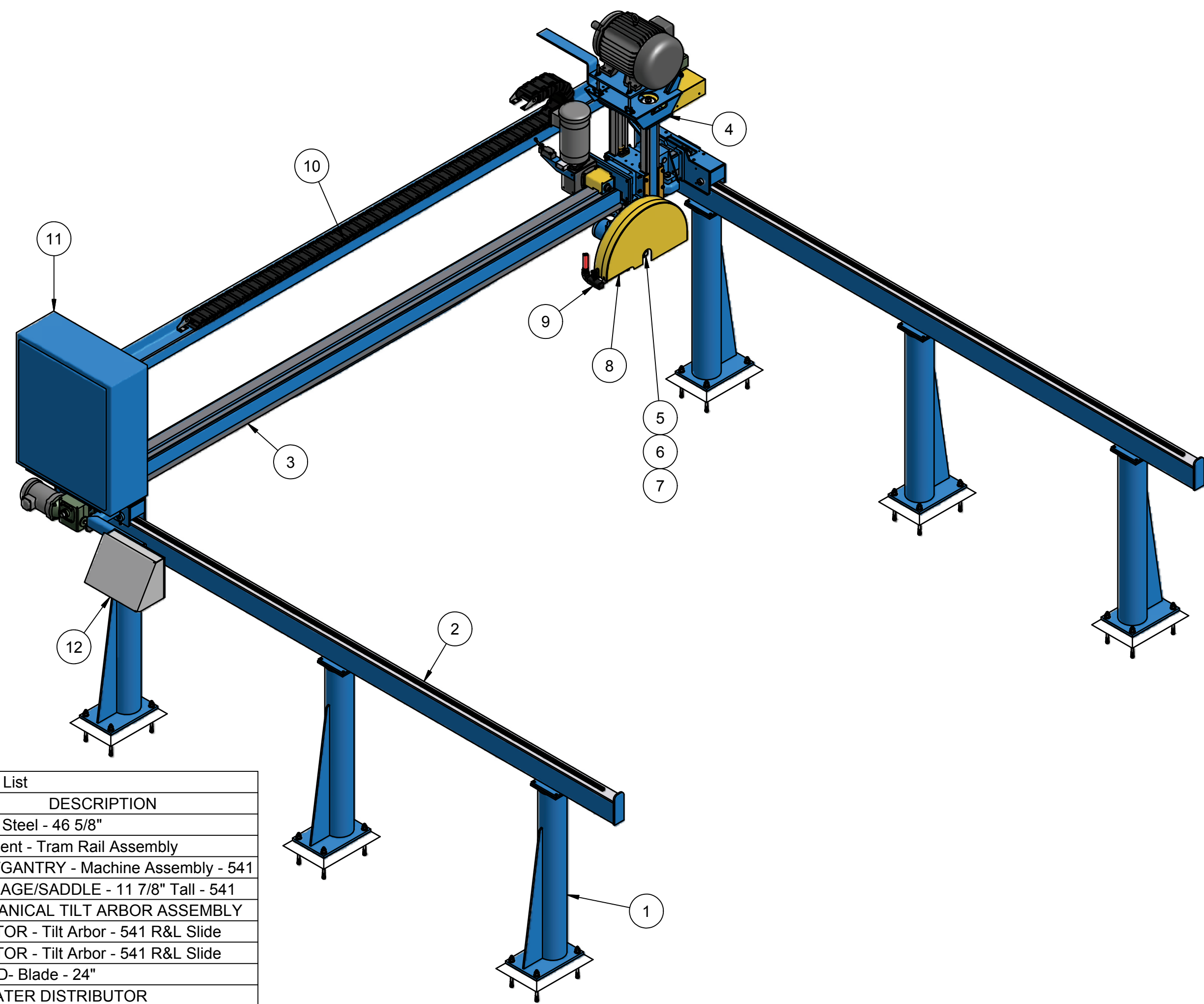


Operators Position



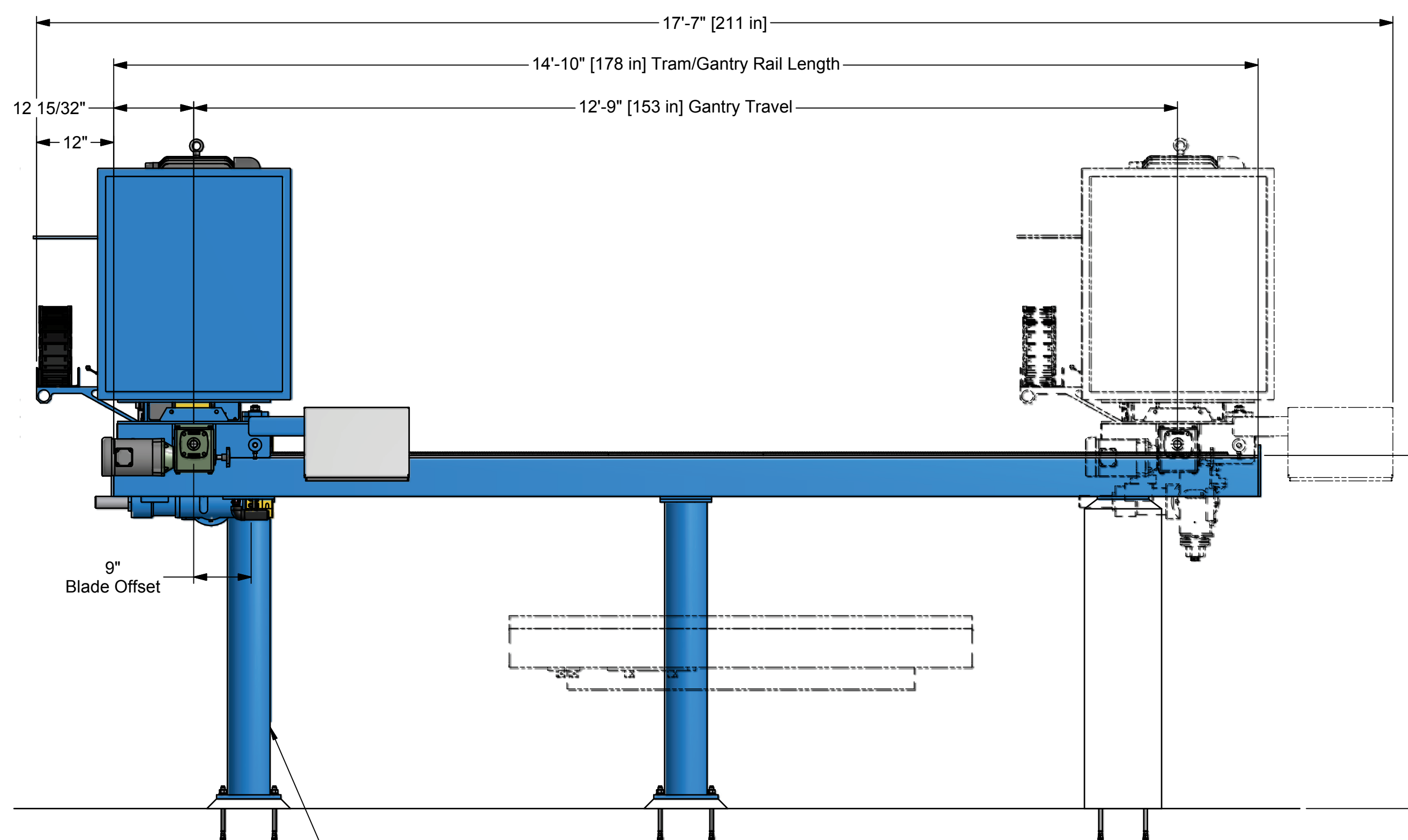
For Table Installation, Refer to TSB-04T02 Turntable Installation for Required Information. Customer to Furnish Anchors, 5/8" x 8 1/2"lg. (4 Req'd - Standard Turntable / 6 Req'd - Hyd. Tilt Turntable)

| | | | | |
|---------------|------|---|---|--|
| RELEASED | DATE | DIMENSIONS ARE IN INCHES AND DEGREES UNLESS OTHERWISE NOTED. DIMENSIONING AND TOLERANCES IN ACCORDANCE WITH ANSI Y14.5-1994 | | SAWING SYSTEMS INC. P.O. Box 3754 • Knoxville, TN 37927-3754 • (865) 525-0600 (800) 489-0601 • Telefax (865) 525-2320 |
| APPROVED | DATE | | | |
| PROJ. MGR. | DATE | FRACTIONS DECIMALS ANGLES ± 1/16" .X ± .050 ± .06" .XX ± .010 .XXX ± .005 | TITLE: Model 541CA | |
| MATERIAL: | | BREAK AND DEBURR ALL SHARP EDGES | 12x12 Foundation - Model 541CA - HD Spindle | |
| WEIGHT: | | THIRD ANGLE PROJECTION | | |
| NEXT ASSEMBLY | | | DRAWN: DLL | SCALE: DWG/PART NO: E-4001-45-1212 |
| | | This drawing is the property of SAWING SYSTEMS Incorporated, including all patented and patentable features. Confidential information and use hereof is conditioned upon the user's agreement not to reproduce the drawing, in whole or part, nor the material described thereon, nor the use of the drawing for any purpose other than specifically permitted in writing by SAWING SYSTEMS Incorporated. | DATE: 5/12/2009 | SIZE: E |
| | | | WEIGHT: | SHEET 1 OF 2 |



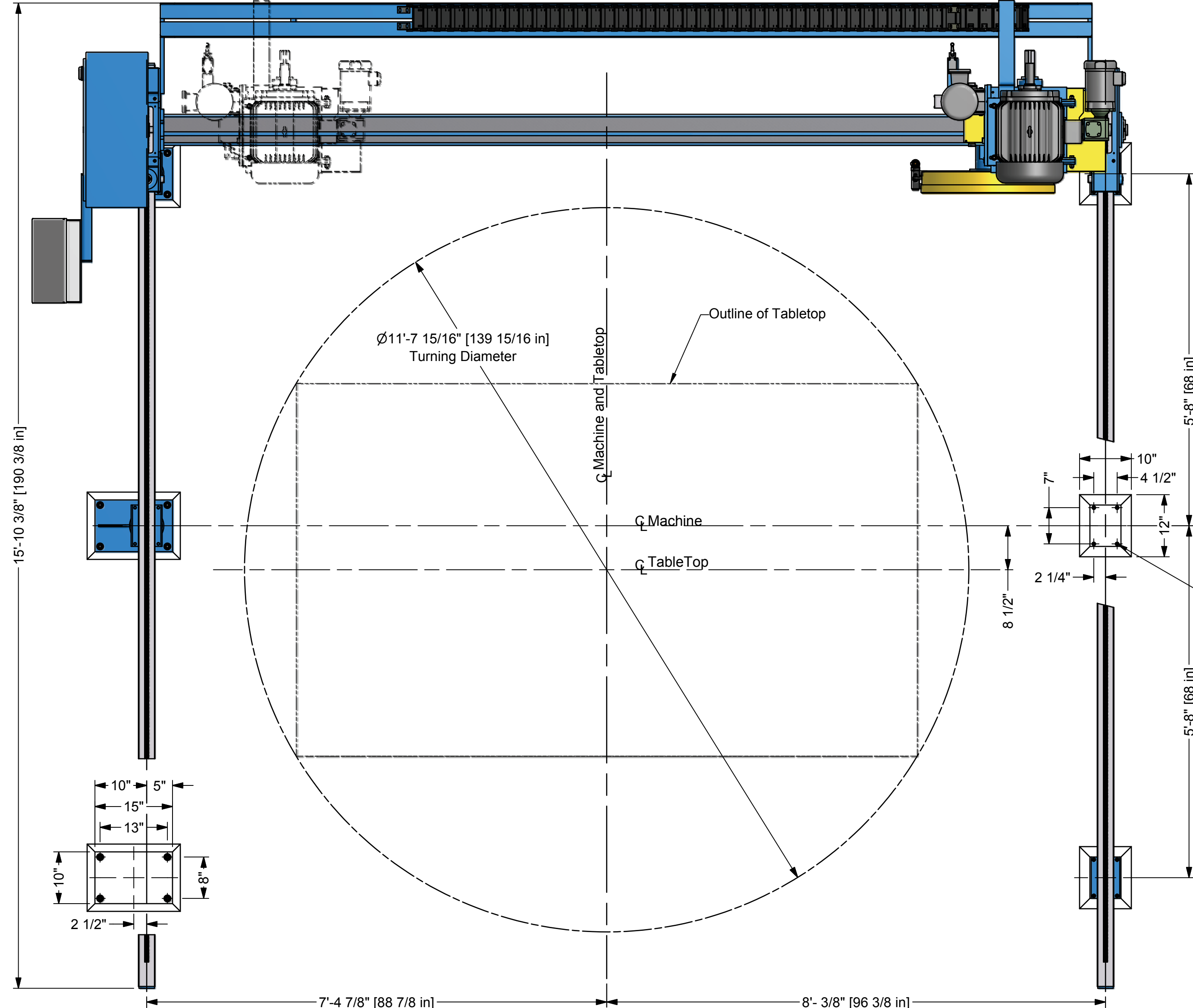
Parts List

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|-----|---------------|---------------------------------------|
| 1 | 6 | B-4002-14H-12 | PIER - Steel - 46 5/8" |
| 2 | 2 | B-4307-3A | Weldment - Tram Rail Assembly |
| 3 | 1 | E-4016-2D | TRAM/GANTRY - Machine Assembly - 541 |
| 4 | 1 | E-4090-1B | CARRIAGE/SADDLE - 11 7/8" Tall - 541 |
| 5 | 1 | E-4020-1 | MECHANICAL TILT ARBOR ASSEMBLY |
| 6 | 1 | A-4323-1 | ADAPTOR - Tilt Arbor - 541 R&L Slide |
| 7 | 1 | A-4324-1 | ADAPTOR - Tilt Arbor - 541 R&L Slide |
| 8 | 1 | B-4055-1-24 | GUARD - Blade - 24" |
| 9 | 1 | B-4054-1B | RH WATER DISTRIBUTOR |
| 10 | 1 | BT-5000-058 | CARRIER - Nylatrac - NP-400-10 X 132" |
| 11 | 1 | 10K14 | ENCLOSURE-N412363012- Wiegmann |
| 12 | 1 | EC-5000-727 | ENCLOSURE - WC12C16 - Wiegmann |



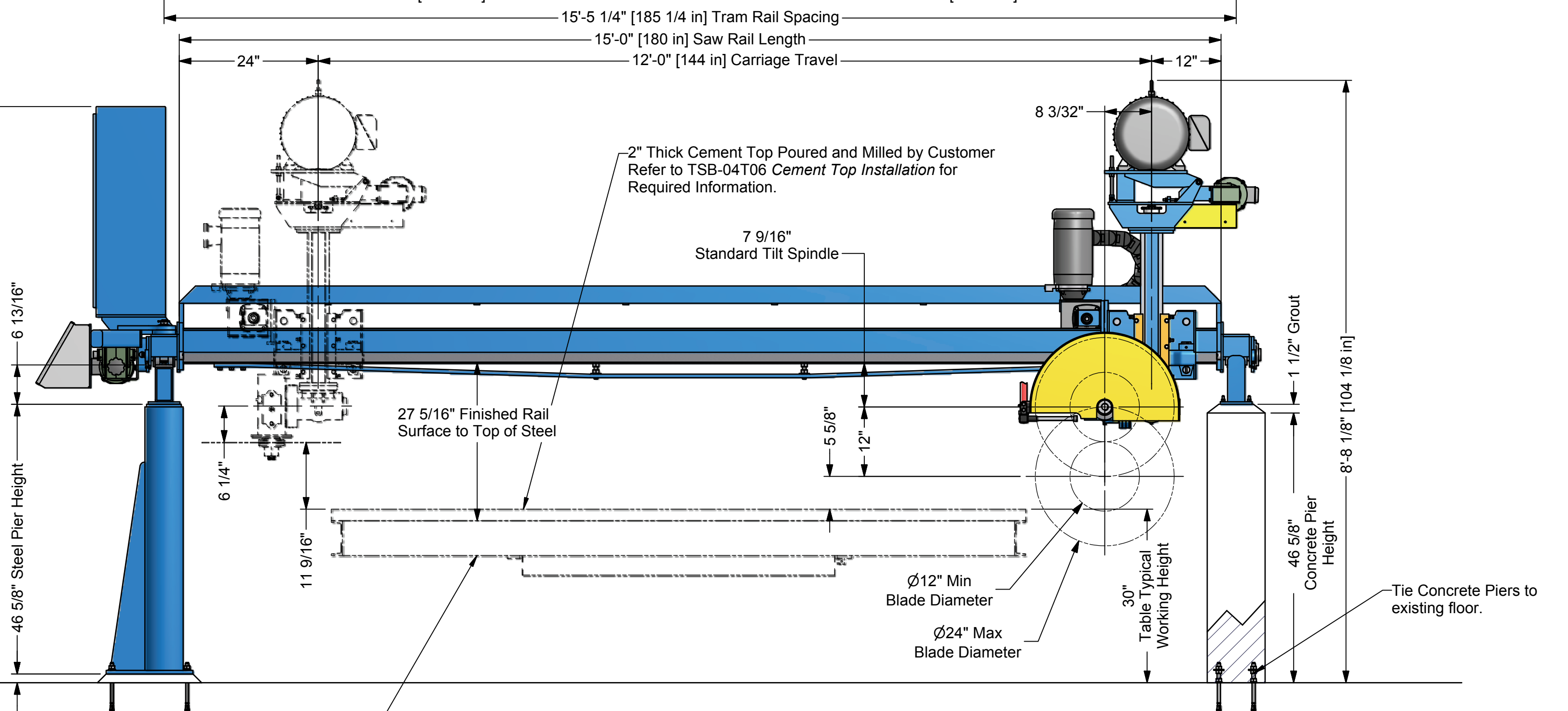
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 Place machine on rails and test movement. Grout the posts.

Operators Position



Install (4) 3/8" x 7"lg anchors, 4" minimum embedment (6 Pier Locations). Level and parallel tram rails on wedges, or nuts before grouting. (Customer to furnish anchors, 16 Required.)

Operators Position



For Table Installation, Refer to TSB-04T02 Turntable Installation for Required Information. Customer to Furnish Anchors, 5/8" x 8 1/2"lg. (4 Req'd - Standard Turntable / 6 Req'd - Hyd. Tilt Turntable)

| | | | |
|----------------|-------|---|---|
| RELEASED: | DATE: | DIMENSIONS ARE IN INCHES AND DEGREES UNLESS OTHERWISE NOTED. DIMENSIONING AND TOLERANCES IN ACCORDANCE WITH ANSI Y14.5-1994 | <p>SAWING SYSTEMS INC. P.O. Box 3754 • Knoxville, TN 37927-3754 • (865) 525-0600 (800) 489-0601 • Telefax (865) 525-2320</p> |
| APPROVED: | DATE: | FRACTIONS DECIMALS ANGLES ± 1/16" .X ± .050 ± .06" .XX ± .010 .XXX ± .005 | |
| PROJ. MGR: | DATE: | BREAK AND DEBURR ALL SHARP EDGES | TITLE: Model 541CA |
| MATERIAL: | | THIRD ANGLE PROJECTION | 12x12 Foundation - Model 541CA - Tilt Arbor |
| WEIGHT: | | | DRAWN: DLL |
| NEXT ASSEMBLY: | | | SCALE: 1" = 1'-0" |
| | | | DWG/PART NO: E-4001-45-1212 |
| | | | DATE: 5/12/2009 |
| | | | SIZE: E |
| | | | SHEET 2 OF 2 |
| | | | REV |