

# INSTRUCTION MANUAL



## D28700

## HEAVY-DUTY 355MM (14") CHOP SAW

DeWALT Industrial Tool Co.,  
20 Fletcher Road, Mooroolbark, VIC 3138 Australia (03 8720 5100)  
5 Te Apunga Place, Mt Wellington, New Zealand (09 259 1111)

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The following are trademarks for one or more DeWALT power tools: the yellow and black color scheme; the "D" shaped air intake grill; the array of pyramids on the handgrip; the kit box configuration; and the array of lozenge-shaped humps on the surface of the tool.

IF YOU HAVE ANY QUESTIONS OR COMMENTS ABOUT THIS OR ANY DeWALT TOOL, CALL US AT: 1800 654 155 (Aust) or 09 259 1111 (NZ).

### SAFETY INSTRUCTIONS FOR POWER TOOLS

When using power tools, always observe the safety regulations applicable in your country to reduce the risk of fire, electric shock and personal injury. Read the following safety instructions before attempting to operate this product. Keep these instructions in a safe place.

#### General Safety Rules

**⚠WARNING! Read all instructions.** Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury. The term "power tool" in all of the warnings listed below refers to your mains operated (corded) power tool or battery operated (cordless) power tool.

### SAVE THESE INSTRUCTIONS

#### 1. WORK AREA

- Keep work area clean and well lit.** Cluttered and dark areas invite accidents.
- Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

#### 2. ELECTRICAL SAFETY

- Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.
- When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.

##### Minimum Gage for Cord Sets

Volts	Total Length of Cord in Feet			
120V	0-25	26-50	51-100	101-150
240V	0-50	51-100	101-200	201-300

Ampere Rating		American Wire Gage			
More Than	Not more Than				
10	- 12	16	16	14	12
12	- 16	14	12	Not Recommended	

#### 3. PERSONAL SAFETY

- Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- Use safety equipment. Always wear eye protection.** Safety equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- Avoid accidental starting. Ensure the switch is in the off position before plugging in.** Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.
- Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of these devices can reduce dust related hazards.

#### 4. POWER TOOL USE AND CARE

- Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- Disconnect the plug from the power source before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tools operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- Use the power tool, accessories and tool bits etc., in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.

#### 5. SERVICE

- Have your power tool serviced by a qualified repair person using only identical replacement parts.** This will ensure that the safety of the power tool is maintained.

#### Electrical Safety

The electric motor has been designed for one voltage only. Always check that the power supply corresponds to the voltage on the rating plate. 240 V AC means your tool will operate on alternating current. As little as 10% lower voltage can cause loss of power and can result in overheating. All DeWALT tools are factory tested; if this tool does not operate, check the power supply. Your DeWALT tool is double insulated, therefore no earth wire is required.

- Young children and the infirm.** This appliance is not intended for use by young children or infirm persons without supervision. Young children should be supervised to ensure that they do not play with this appliance.
- Replacement of the supply cord.** If the supply cord is damaged, it must be replaced by the manufacturer or an authorised DeWALT Service Centre in order to avoid a hazard.

#### Extension Cords

**⚠CAUTION:** Use only extension cords that are approved by the country's Electrical Authority. Before using extension cords, inspect them for loose or exposed wires, damaged insulation and defective fittings. Replace the cord if necessary.

#### Additional Safety Instructions for Chop Saws

- Always wear proper eye and respiratory protection.**
- Before using, inspect the cutting wheel for cracks or flaws. If such a crack or flaw is evident, discard the wheel. The wheel should also be inspected whenever you think the tool may have been dropped.** Flaws may cause wheel breakage.
- When starting the tool with a new or replacement wheel or if you are unsure of the condition of the wheel, hold the tool in a well protected area and let it run for one minute.** If the wheel has an undetected crack or flaw, it should burst in less than one minute. Never start the tool with a person in line with the wheel. This includes the operator.
- In operation, avoid bouncing the wheel or giving it rough treatment.** If this occurs, stop the tool and inspect the wheel for cracks or flaws.
- Clean your chop saw periodically following the procedure in this manual.
- Do not remove wheel guards or base.
- ALWAYS USE THE VISE OR SPECIAL FIXTURE TO CLAMP WORK SECURELY.** Other aids such as spring, bar, or C-clamps may be appropriate for certain sizes and shapes of workpiece. Use care in selecting and placing these clamps and make a dry run before making a cut.
- Use only 355mm (14") type 1 wheels rated at 4100 rpm or higher.
- Allow cut off parts to cool before handling.
- Do not attempt to cut wood, plastic, masonry or non-ferrous metals with this tool.
- NEVER CUT MAGNESIUM WITH THIS TOOL.**
- Use chop saw in a well-ventilated area.
- Turn chop saw off before removing any pieces from the base.
- DO NOT CUT ELECTRICALLY LIVE MATERIAL.**
- Do not use circular saw blades or any other toothed blades with this tool.** Serious injury may result.
- DO NOT OPERATE THIS TOOL NEAR FLAMMABLE LIQUIDS, GASES OR DUST.** Sparks or hot chips from cutting or arcing motor brushes may ignite combustible materials.
- Do not use the side of the abrasive wheel as a deburring grinder. This will substantially weaken the wheel creating an unsafe condition. The wheel may come apart

**⚠WARNING:** Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead-based paints,
- crystalline silica from bricks and cement and other masonry products, and
- arsenic and chromium from chemically-treated lumber (CCA).

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

- Avoid prolonged contact with dust from power sanding, sawing, grinding, drilling, and other construction activities. Wear protective clothing and wash exposed areas with soap and water.** Allowing dust to get into your mouth, eyes, or lay on the skin may promote absorption of harmful chemicals.

**⚠WARNING:** Use of this tool can generate and/or disburse dust, which may cause serious and permanent respiratory or other injury. Always use NIOSH/OSHA approved respiratory protection appropriate for the dust exposure. Direct particles away from face and body.

**⚠CAUTION:** Wear appropriate personal hearing protection during use. Under some conditions and duration of use, noise from this product may contribute to hearing loss.

**⚠CAUTION:** Spark deflector will get hot. Avoid touching or adjusting while hot. Keep cordset and materials away from spark deflector.

- The label on your tool may include the following symbols. The symbols and their definitions are as follows:

V .....	volts	A .....	amperes
Hz.....	hertz	W .....	watts
min.....	minutes	~ .....	alternating current
==== .....	direct current	n <sub>0</sub> .....	no load speed
☐ .....	Class II Construction	⊕ .....	earthing terminal
⚠ .....	safety alert symbol	.../min.....	revolutions per minute
sfp.....	surface feet per minute		

For your convenience and safety, the following warnings are on your Heavy-Duty 355mm (14") Chop Saw:

- ⚠ FOR SAFE OPERATION READ THE INSTRUCTION MANUAL.**

**DO NOT USE TOOTHED BLADES.**

**USE ONLY REINFORCED WHEELS RATED 4100 RPM OR HIGHER.**

**WHEN SERVICING USE ONLY IDENTICAL REPLACEMENT PARTS.**

**ALWAYS: WEAR EYE PROTECTION, USE GUARDS, CLAMP WORK IN VISE, USE PROPER RESPIRATORY PROTECTION.**

**DO NOT EXPOSE TO RAIN OR USE IN DAMP LOCATIONS.**

**ONLY USE CHOP SAW WHEEL OF A MAX. THICKNESS OF 3.1mm AND A MAX. DIAMETER OF 355mm**

#### FEATURES (Fig. 1, 4)

- |                          |                     |
|--------------------------|---------------------|
| A. Lock pin              | J. Wheel            |
| B. Spark deflector screw | K. Guard            |
| C. Spark deflector       | L. Wheel lock lever |
| D. Base                  | M. Depth stop bolt  |
| E. Fence                 | N. Trigger switch   |
| F. Vise                  | O. Padlock hole     |
| G. 8mm hex wrench        | P. Jam nut          |
| H. Crank                 | Q. Fence bolts      |
| I. Vise lever            |                     |

#### Cutting Capacity

The wide vise opening and high pivot point provide cutting capacity for many large pieces. Use the cutting capacity chart to determine total maximum size of cuts that can be made with a new wheel.

**⚠CAUTION: CERTAIN LARGE, CIRCULAR OR IRREGULARLY SHAPED OBJECTS MAY REQUIRE ADDITIONAL HOLDING MEANS IF THEY CANNOT BE HELD SECURELY IN VISE.**

**⚠CAUTION: DO NOT CUT MAGNESIUM WITH THIS TOOL.**



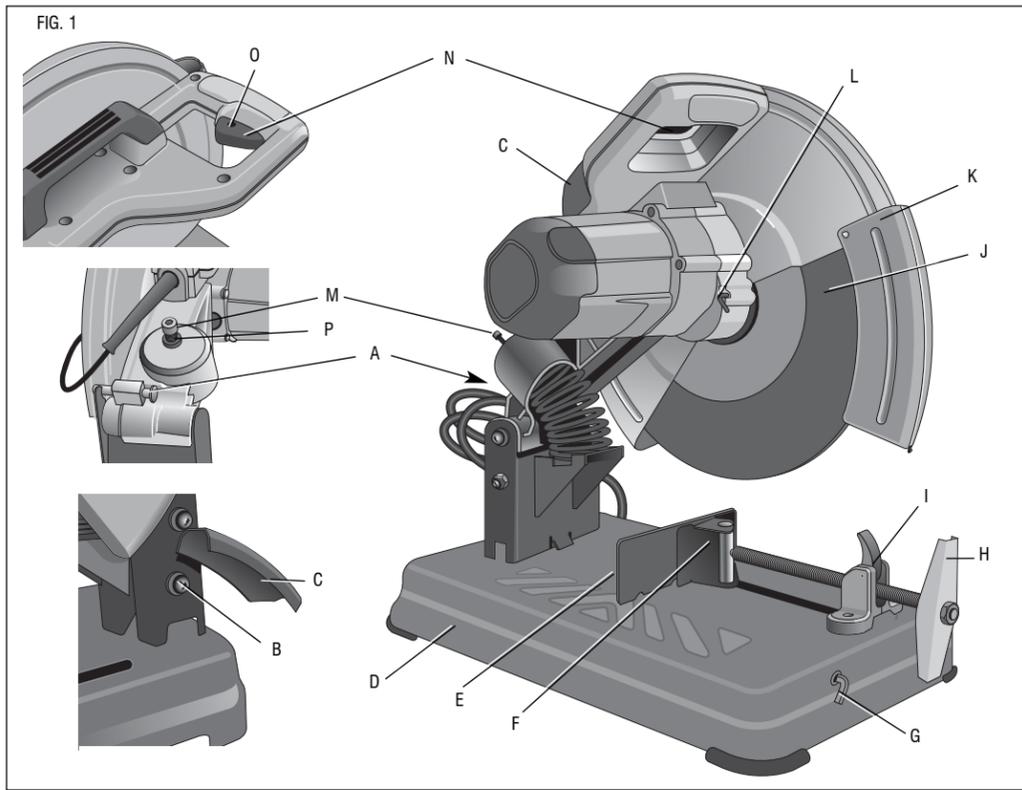


FIG. 2

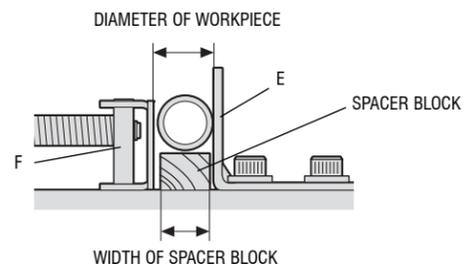


FIG. 3

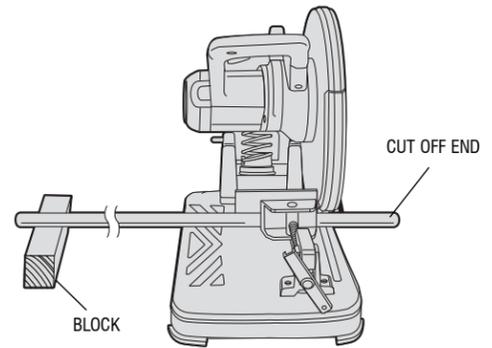


FIG. 4

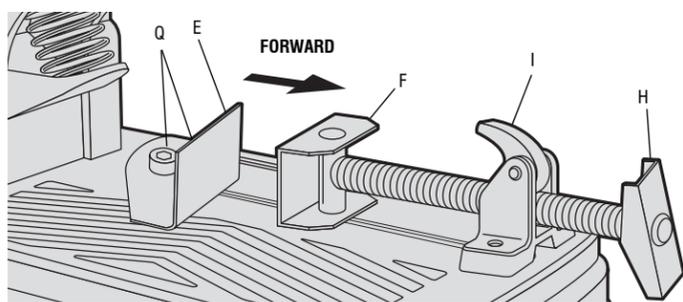


FIG. 5

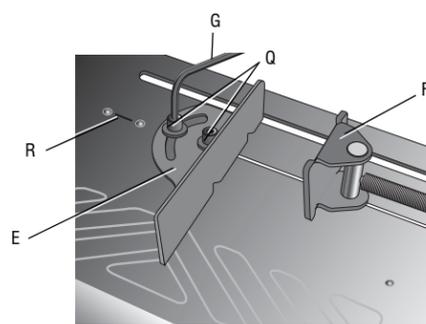


FIG. 6

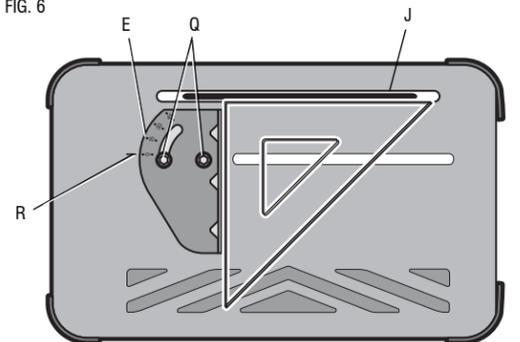


FIG. 7

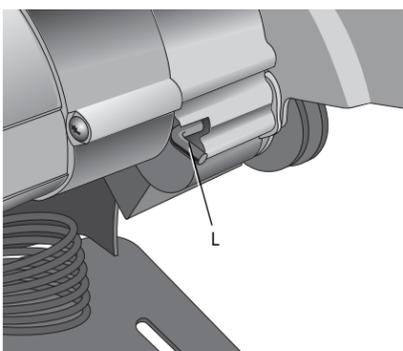


FIG. 8

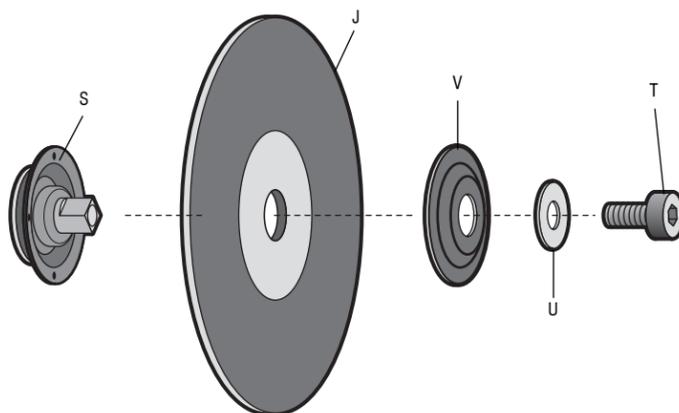
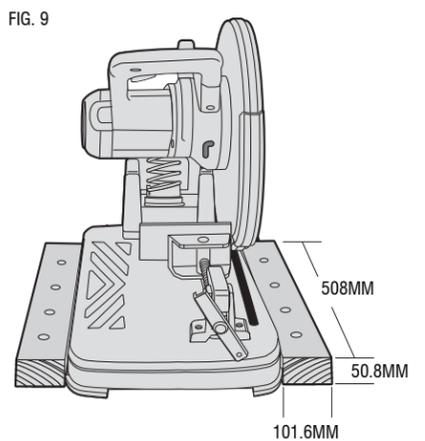


FIG. 9



### Maximum Cutting Capacity

**NOTE:** Capacity shown on chart assumes no wheel wear and optimum fence position.

Workpiece Shape:				
90° Cutting Angle	A = 115mm (4.5")	A = 119mm (4-11/16")	<b>A x B</b> 115mm x 130mm (4-1/2" x 5-1/8") 102mm x 194mm (4" x 7-5/8") 76mm x 229mm (3" x 9")	A = 137mm (5-3/8")
45° Cutting Angle	A = 98mm (3-13/16")	A = 98mm (3-13/16")	115mm x 98mm (4-1/2" x 3-13/16")	A = 98mm (3-13/16")

### Standard Equipment

- 1 355mm (14") Metal Cutting Abrasive Wheel
- 1 8mm Hex Wrench
- 1 Instruction manual

### To Carry (Fig. 1)

Fold down unit to position where you can carry the saw. Push in lock pin (A) to lock arm down.

### Unlocking (Fig. 1)

To unlock tool and raise head, depress motor arm slightly and pull lock pin (A) out. Motor arm will then pivot upward.

### Material Clamping and Supporting

- Angles are best clamped and cut with both legs resting against base.
- A spacer block slightly narrower than the workpiece can be used to increase wheel utilization (Fig. 2).
- Long workpieces must be supported by a block so it will be level with top of base (Fig. 3). The cut-off end should be free to fall downward to avoid wheel binding.

### Spark Deflector Adjustment (Fig. 1)

To best deflect sparks away from surrounding persons and materials, loosen the screw (B), adjust the spark deflector (C) and then retighten screw. Do not allow cordset to come into contact with deflector or sparks as damage to cordset may occur.

### Vise Operation (Fig. 4)

The vise (F) has a quick-travel feature. To release the vise when it is clamped tightly, turn the crank (H) counterclockwise one or two times to remove clamping pressure. Lift vise lever (I) up. Pull crank assembly out as far as desired. Vise may be pushed forward into work without cranking. Lower vise lever (I) then tighten vise (F) on work by using crank (H).

### Fence Operation

**CAUTION:** Turn off and unplug the tool before making any adjustments or removing or installing attachments or accessories. Be sure the trigger switch is in the OFF position.

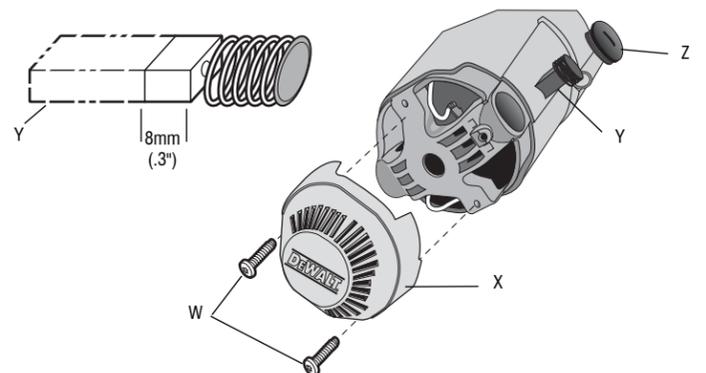
The fence (E) can be adjusted two ways: to change desired cutting angle and to change spacing between the fence and vise.

#### TO CHANGE THE DESIRED CUTTING ANGLE (FIG. 5, 6)

Use the wrench provided to loosen (do not remove) the two fence bolts (Q). Align the desired angle indicator line with the slot line (R) in the base (D). Securely tighten both fence bolts before use.

For more accurate square cuts, disconnect the power supply, loosen the two fence bolts, push arm down until wheel extends into base. Place a square against the wheel and adjust fence against the square. Securely tighten both fence bolts before use.

FIG. 10



When making a miter cut, the vise (F) may not clamp securely, depending on the thickness of the workpiece and the miter angle. Other aids (such as spring, bar or C-clamps) will be necessary to secure the workpiece to the fence when making these cuts.

#### TO CHANGE SPACING BETWEEN THE FENCE AND VISE

Using the wrench provided, loosen and remove the two fence bolts (Q). Adjust the fence (E) to desired locations. Insert both fence bolts in provided locations. Securely tighten both fence bolts before use.

#### Depth Stop (Fig. 1)

Depth stop is set at the factory for a new 355mm (14") wheel to prevent wheel from cutting into the supporting surface. To allow more depth of cut, use the 8mm hex wrench (G) provided to loosen the depth stop bolt (M) and raise bolt to desired height and then turn jam nut (P) clockwise until seated firmly on the casting. Securely tighten the depth stop bolt before use.

**CAUTION:** When changing to a new wheel, readjust depth stop to original position to prevent cutting into supporting surface.

#### Trigger Switch (Fig. 1)

To start the tool, depress the trigger switch (N). To turn the tool off, release the trigger switch. Keep hands and material from wheel until it has coasted to a stop.

To prevent unauthorized use of tool, install a standard padlock (not included) into the padlock hole (O) located in the trigger.

#### Removal and Installation of Wheels (Fig. 7, 8)

**CAUTION:** Turn off and unplug the tool before making any adjustments or removing or installing attachments or accessories. Be sure the trigger switch is in the OFF position. Do not make any adjustment while the wheel is in motion. Do not make any adjustment while chop saw is plugged into power supply.

- Push in wheel lock lever (L) and rotate wheel (J) by hand until wheel lock lever engages slot in inside flange (S) to lock wheel. Loosen the bolt (T) counterclockwise in the center of the abrasive wheel with the 8mm hex wrench (G). Bolt has right-hand thread.
- Remove the bolt (T), washer (U), outside flange (V) and old wheel (J).
- Make sure flange surfaces are clean and flat. Install the new abrasive wheel by reversing the above steps.
- Do not over tighten bolt.

**WARNING:** Check the work surface that the chop saw rests on when replacing with a new abrasive wheel. It is possible that the wheel may contact ANY ITEMS OR STRUCTURE THAT EXTENDS ABOVE work surface (under the base) when the arm is fully lowered.

## Mounting

**CAUTION:** Tool must be supported on stable, level, non-skid surface to prevent unexpected movement when operating.

### Procedure For Permanent Mounting

1. Mark through the holes in the base (D) and drill two holes, 7.94mm (5/16") diameter, through the mounting surface.
2. Use 6.35mm (1/4") fasteners to securely mount base to mounting surface.

### Cradle Mounting (Fig. 9)

1. Cut two boards approximately 508mm long x 50.8mm high x 101.6mm wide (20" x 2" x 4").
2. Place the chop saw at desired work location.
3. Place boards tightly along side and nail to work surface .

### Operation Tips for More Accurate Cuts

- Allow the wheel to do the cutting. Excessive force will cause the wheel to glaze reducing cutting efficiency and/or to deflect causing inaccurate cuts.
- Properly adjust fence angle.
- Make sure material is laying flat across base.
- Properly clamp material to avoid movement and vibration.
- Position the fence so the workpiece is central to the cutting disc.

## MAINTENANCE

### Motor Brush Inspection and Replacement (Fig. 10)

**WARNING:** Turn off and unplug the tool. Be sure the trigger switch is in the OFF position.

Brushes should be regularly inspected for wear. To inspect brushes, unscrew the two end cap screws (W) and remove end cap (X). Remove brush cap (Z). Brushes (Y) should slide freely in brush box. If brushes are worn down to 8mm (.3") as shown in Figure 10 they should be replaced. To reinstall, push new brush back into brush box. If replacing existing brush, maintain same orientation as when removed. Replace the brush cap (**do not overtighten**). Replace end cap and two screws. Tighten securely.

### Cleaning

Blowing dust and grit out of the main housing by means of an air hose is recommended and may be done as often as dirt is seen collecting in and around the air vents. Always wear proper eye and respiratory protection.

### Repairs

To assure product SAFETY and RELIABILITY, repairs, maintenance and adjustment (including brush inspection and replacement) should be performed by certified service centers or other qualified service organizations, always using identical replacement parts.

### Lubrication

Closed-type, grease-sealed ball bearings are used throughout. These bearings have sufficient lubrication packed in them at the factory to last the life of the chop saw.

## ACCESSORIES

**WARNING:** Since accessories, other than those offered by DeWALT, have not been tested with this product, use of such accessories with this tool could be hazardous. To reduce the risk of injury, only DeWALT, recommended accessories should be used with this product.

Recommended accessories for use with your tool are available at extra cost from your local service center. If you need any assistance in locating any accessory, please contact DeWALT Industrial Tool Co., 20 Fletcher Road, Mooroolbark, VIC 3138 Australia or call 1800 654 155 or (NZ) 09 259 1111.

## Guarantee

Applicable to hand held Power Tools, Lasers and Nailers.

### Three Year Limited Warranty

DeWALT will repair, without charge, any defects due to faulty materials or workmanship for three years from the date of purchase. Please return the complete unit, transportation prepaid, to any DeWALT Service Centre, or any authorised service station.

For warranty repair information, call (AUS) 1800 654 155 or (NZ) 09 259 1111.

This warranty does not apply to

- Accessories
- Damage caused where repairs have been made or attempted by others.
- Damage due to misuse, neglect, wear and tear, alteration or modification.

This warranty gives you specific legal rights and you may have other rights under the provisions of the Consumer Guarantee Act 1993 (New Zealand only), Trade Practices Act 1974 and State Legislation (Australia only).

In addition to the warranty, DeWALT tools are covered by our:

#### FREE ONE YEAR SERVICE CONTRACT

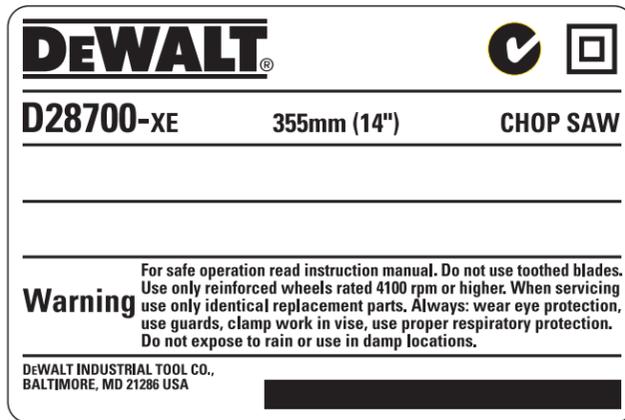
DeWALT will also maintain the tool for free at any time during the first year of purchase. This includes labour, parts and lubrication required to restore the product to sound mechanical and/or electrical condition. Normal wear parts are not covered in this service. Carbon brushes worn more than 50% will be replaced.

**NOTE:** Three Year Warranty is not applicable to items deemed as consumables. Radial arm saws are covered by a one (1) year warranty only. DeWALT Reserves the right to review its warranty policy prior to launch of any new business development products.

#### 30 DAY NO SATISFACTION GUARANTEE

If you are dissatisfied with any DeWALT power tool, laser or nailer, for any reason, simply return it to the point of purchase with your sales receipt within 30 days for a replacement unit or a full refund.

**FREE WARNING LABEL REPLACEMENT:** If your warning labels become illegible or are missing, call (AUS) 1800 654 155 or (NZ) 09 259 1111 for a free replacement.



<b>Troubleshooting Guide</b>	
<b>TROUBLE! TOOL WILL NOT START</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Tool not plugged in.</li><li>2. Fuse blown or circuit breaker tripped.</li><li>3. Cord damaged.</li><li>4. Brushes worn out.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. Plug in saw.</li><li>2. Replace fuse or reset circuit breaker.</li><li>3. Have cord replaced by authorized service center.</li><li>4. Replace brushes.</li></ol>
<b>TROUBLE! TOOL MAKES UNSATISFACTORY CUTS</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Glazed wheel.</li><li>2. Workpiece incorrectly placed or clamped.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. Dress the wheel or replace with a new one.</li><li>2. Firmly clamp and support workpiece central to cutting disc.</li></ol>
<b>TROUBLE! BLADE DOES NOT COME UP TO SPEED</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Extension cord too light or too long.</li><li>2. Low voltage.</li><li>3. Low generator voltage.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. Replace with adequate size cord. See chart.</li><li>2. Contact your electric company.</li><li>3. Check generator output voltage. Reduce number of tools powered by the generator.</li></ol>
<b>TROUBLE! TOOL VIBRATES EXCESSIVELY DURING CUT</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Tool not mounted securely to stand or work bench.</li><li>2. Damaged wheel.</li><li>3. Workpiece not clamped properly.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. Tighten all mounting hardware. See <b>Procedure for Permanent Mounting</b>.</li><li>2. Replace wheel.</li><li>3. Refer to <b>Material Clamping and Supporting</b>.</li></ol>
<b>TROUBLE! DOES NOT MAKE ACCURATE CUTS</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Fence not adjusted correctly.</li><li>2. Wheel is not square to fence.</li><li>3. Excessive force used to make cut.</li><li>4. Work piece moving.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. Check and adjust. See <b>Fence Operation</b>.</li><li>2. Check and adjust.</li><li>3. Reduce cutting force, let the wheel do the work.</li><li>4. Clamp workpiece securely. See <b>Material Clamping and Supporting</b>. Make sure material is laying flat against the base.</li></ol>
<b>TROUBLE! CANNOT MOVE ARM</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Lock down pin is engaged.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. Push down slightly on the arm, pull down lock down pin and raise arm.</li></ol>
<b>TROUBLE! MATERIAL MOVES DURING CUT</b> <b>WHAT'S WRONG?</b> <ol style="list-style-type: none"><li>1. Fence slipping or workpiece incorrectly placed or clamped.</li><li>2. Vise too loose</li><li>3. Excessive cutting force.</li></ol>	<b>WHAT TO DO...</b> <ol style="list-style-type: none"><li>1. See <b>Material Clamping and Supporting</b>.</li><li>2. Tighten vise clamping.</li><li>3. Reduce cutting force.</li></ol>