

# **POWERMATIC®**

## **Operating Instructions and Parts Manual Accu-Fence® and Rail System For PM2000B, PM3000B Table Saws**



**Powermatic**  
427 New Sanford Road  
LaVergne, Tennessee 37086  
Ph.: 800-274-6848  
[www.powermatic.com](http://www.powermatic.com)

**Part No. M-2195079B**  
Edition 4 08/2019  
Copyright © 2017 Powermatic



## 1.0 IMPORTANT SAFETY INSTRUCTIONS

READ ALL INSTRUCTIONS BEFORE USING THIS MACHINE.

### WARNING – To reduce risk of injury:

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand all instructions and safety information that accompanied the table saw with which this fence system will be used.
3. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
4. Replace the warning labels if they become obscured or removed.
5. The table saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a table saw, do not use until proper training and knowledge have been obtained.
6. Do not use the table saw for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
7. Always wear approved safety glasses or face shield while using a table saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
8. Before operating the table saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
9. Wear ear protectors (plugs or muffs) during extended periods of operation.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the machine is properly grounded.
12. Make all machine adjustments or maintenance with the machine unplugged from the power source. A machine under repair should be RED TAGGED to show it must not be used until maintenance is complete.
13. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
14. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
15. Check the alignment of the riving knife, fence and miter slot to the blade. A caution decal is installed on each guard to remind the operator of the dangers of improper machine operation.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. Keep children away.
20. Make your workshop child proof with padlocks, master switches or by removing safety keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep blade sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Check the saw blade for cracks or missing teeth. Do not use a cracked or dull blade or one with missing teeth or improper set. Make sure the blade is securely locked on the arbor.

27. Keep hands clear of the blade area. Do not reach past the blade to clear parts or scrap with the saw blade running. Never saw freehand. Avoid awkward operations and hand positions where a sudden slip could cause your hand to contact the blade.
28. Do not attempt to saw boards with loose knots or with nails or other foreign material, on its surface. Do not attempt to saw twisted, warped or bowed stock unless one edge has been jointed for guiding purposes prior to sawing. Excessively warped stock should not be used.
29. Do not attempt to saw long or wide boards unsupported where spring or weight could cause the board to shift position.
30. Always use the riving knife, blade guard, push stick and other safety devices for all operations where they can be used. On operations such as dadoing or molding where the blade guard cannot be used, use feather boards, fixtures and other safety devices and use extreme caution. Reinstall the riving knife and blade guard immediately after completing the operation that required their removal.
31. Be sure the saw blade rotates clockwise when viewed from the motor side (left side) of the machine.
32. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use bare hands.
33. Do not stand on the machine. Serious injury could occur if the machine tips over.
34. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
35. Remove loose items and unnecessary work pieces from the area before starting the machine.
36. Blade should have minimum exposure during cuts. Adjust blade to approximately 1/8" inch above surface of workpiece.

**⚠ WARNING:** This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

**⚠ WARNING:** Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection.

Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

## 1.1 Kickback

The most common accidents among table saw users, according to statistics, can be linked to kickback, the high-speed expulsion of material from the table that can strike the operator. Kickback can also result in the operator's hands being pulled into the blade.

### Kickback Prevention

Tips to avoid the most common causes of kickback:

- Make sure the riving knife is always aligned with the blade. A workpiece can bind or stop the flow of the cut if the riving knife is misaligned, and result in kickback.
- Use a riving knife during every cut. The riving knife maintains the kerf in the workpiece, which will reduce the chance of kickback.
- Never attempt freehand cuts. The workpiece must be fed parallel to the blade, otherwise kickback will likely occur. Always use the rip fence or miter gauge to support the workpiece.
- Make sure that rip fence is parallel to blade. If not, the chances of kickback are very high. Take the time to check and adjust the rip fence.
- Feed cuts through to completion. Anytime you stop feeding a workpiece that is in the middle of a cut, the chance of binding, resulting in kickback, is greatly increased.

### Tips for Kickback Protection

Kickback can happen even if precautions are taken to prevent it. Listed below are some tips to protect you if kickback *does* occur:

- Stand to the side of the blade when cutting. An ejected workpiece usually travels directly in front of the blade.
- Wear safety glasses or a face shield. Your eyes and face are the most vulnerable part of your body.

- Never place your hand behind the blade. If kickback occurs, your hand will be pulled into the blade.
- Use a push stick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.

**Familiarize yourself with the following safety notices used in this manual:**

**⚠CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

**⚠WARNING** This means that if precautions are not heeded, it may result in serious or possibly fatal injury.

## 2.0 About this manual

This manual is provided by Powermatic covering the safe operation and maintenance procedures for the Accu-Fence<sup>®</sup> table saw fence system. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your fence has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions set forth in this document.

This manual is not intended to be an exhaustive guide to table saw operational methods, use of jigs or after-market accessories, choice of stock, etc. Additional knowledge can be obtained from experienced users or trade articles. Whatever accepted methods are used, always make personal safety a priority.

If there are questions or comments, please contact your local supplier or Powermatic. Powermatic can also be reached at our web site: [www.powermatic.com](http://www.powermatic.com).

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

**⚠WARNING** Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

# 3.0 Table of contents

Section	Page
1.0 IMPORTANT SAFETY INSTRUCTIONS .....	2
1.1 Kickback .....	3
2.0 About this manual .....	4
3.0 Table of contents.....	5
4.0 Accu-Fence specifications .....	6
5.0 Unpacking .....	7
5.1 Shipping contents.....	7
6.0 Set-up and assembly (Powermatic saw).....	8
6.1 Tools required for assembly .....	8
6.2 Installing front rail .....	8
6.3 Installing back rail.....	8
6.4 Installing wood extension table (optional accessory) .....	9
6.5 Installing guide tube .....	11
6.6 Mounting Accu-Fence .....	11
6.7 Side plate replacement.....	12
7.0 Rail installation on a non-Powermatic Saw .....	13
7.1 Tools required for assembly .....	13
7.2 Installing front rail .....	13
7.3 Installing back rail.....	14
8.0 Replacement parts .....	15
8.1.1 Rail Assembly – Exploded View.....	15
8.1.2 Rail Assembly – Parts List.....	16
8.2.1 Accu-Fence Assembly – Exploded View.....	17
8.2.2 Accu-Fence Assembly – Parts List.....	18
9.0 Warranty and Service.....	19

## 4.0 Accu-Fence specifications

Table 1

<b>Fence</b>		
	<b>10" Saws</b>	<b>12" Saws</b>
Stock number	2195079B	2195080B
Side plate height	2-1/2 in. (63.5 mm)	2-1/2 in. (63.5 mm)
Side plate length	37-3/8 in. (950 mm)	43-1/4 in. (1099 mm)
Fence width	4-5/8 in. (118 mm)	4-5/8 in. (118 mm)
Body material	Steel	Steel
Side plate material	Polyethylene	Polyethylene
Cross bar length	16 in. (407 mm)	16 in. (407 mm)
<b>Rail Sets</b>		
	<b>30 in. Rip set</b>	<b>50-in. Rip set</b>
Stock number	2653039B	2653031B
Material	Steel	Steel
Actual length, front and back rails	52 in. (132 cm)	72 in. (183 cm)
Actual length, guide tube	64-1/4 in. (163 cm)	84 in. (213 cm)

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, Powermatic reserves the right to change specifications at any time and without prior notice, without incurring obligations.

**WARNING**

Read and understand the entire contents of this manual, and your table saw manual, before attempting set-up or operation. Failure to comply may cause serious injury.

## 5.0 Unpacking

### 5.1 Shipping contents

Open shipping cartons and check that all parts are intact. Report any damage or missing parts to your distributor. Read the instruction manual thoroughly for assembly, alignment, and maintenance instructions.

See Figures 6-1 thru 6-3.

#### Box 1:

- 1 Accu-Fence – A
- 1 Locking handle – B
- 2 Plastic shims (not shown)
- 1 Product registration card
- 1 Operating Instructions and Parts Manual

#### Box 2:

- 1 Front rail – C
- 1 Back rail – D
- 1 Guide tube – E
- 1 Hardware kit (see below)

Hardware kit PM2000B-HK-30 (for 30" rails)

- 6 Flat head socket screw M8x40
- 2 Socket head cap screw M8x40
- 10 Lock washer M8
- 12 Flat washer M8
- 8 Hex nut M8
- 2 Socket head cap screw M8x20
- 6 Hex cap screw M6x20
- 6 Lock washer M6
- 6 Flat washer M6

Hardware kit PM2000B-HK-50 (for 50" rails)

- 9 Flat head socket screw M8x40
- 5 Socket head cap screw M8x40
- 16 Lock washer M8
- 21 Flat washer M8
- 14 Hex nut M8
- 2 Socket head cap screw M8x20
- 8 Hex cap screw M6x20
- 8 Lock washer M6
- 8 Flat washer M6

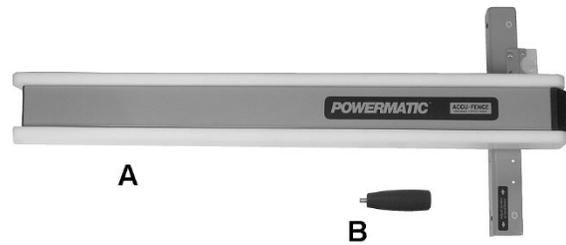


Figure 5-1: contents of Box #1

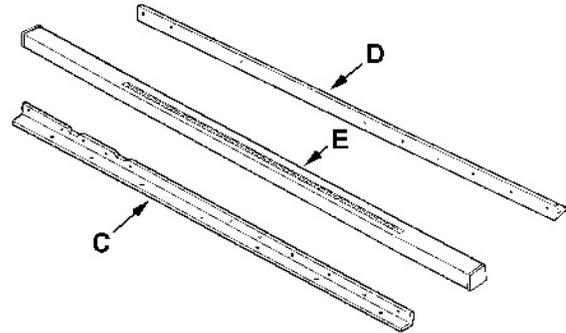
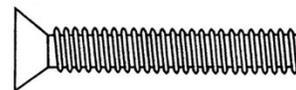


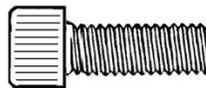
Figure 5-2: contents of Box #2



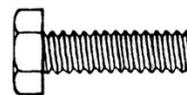
Flat Hd Screw  
M8 x 40



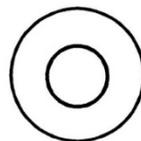
Soc Hd Cap Screw  
M8 x 40



Soc Hd Cap Screw  
M8 x 20



Hex Cap Screw  
M6 x 20



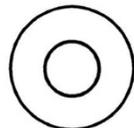
M8 Flat Wshr



M8 Lock Wshr



M8 Hex Nut



M6 Flat Wshr



M6 Lock Wshr

Figure 5-3: contents of hardware package

## **⚠WARNING**

Read and understand the entire contents of this manual, and your table saw manual, before attempting set-up or operation. Failure to comply may cause serious injury.

## 6.0 Set-up and assembly (Powermatic saw)

The following instructions are for installing the Accu-Fence and Rail System on a *Powermatic* Model PM2000B or PM3000B table saw. The rails should bolt up to the Powermatic saw without any drilling.

For mounting to a *non*-Powermatic saw, see sect. 7.0.

### 6.1 Tools required for assembly

Open-end wrenches, 10mm, 13mm  
Hex wrenches, 5mm, 6mm  
Phillips screwdriver  
Adjustable square  
Straight edge  
Rubber mallet (or hammer with block of wood)

Note: A ratchet wrench with sockets will speed assembly time. Additional tools may be needed for adjustments.

### 6.2 Installing front rail

1. Identify the front rail, which is 3" x 3" with notches on one side.
2. Align holes on notched side of front rail to holes in front edge of table saw top, as shown in Figure 6-1. The notches should fall below the miter slots.

**Note:** The rail's second hole from the left should line up with the first hole in table top as shown. The saw's extension wings are not pre-drilled at the factory, so use of the first hole on the rail is optional. Also, rails are designed to be shifted to the right to accommodate attachments, such as a sliding table (not included).

3. Lightly secure front rail to saw table with four M8x40 flat head screws with washers and hex nuts (Figure 6-2). *Finger-tighten only.*

The front rail must be parallel to table top in order for the Accu-Fence system to function properly.

1. Place an adjustable square on table as shown in Figure 6-3.
2. Check height of front rail at several locations along table. The measurements should be the same along the length of rail. (Generally, this dimension will range from 2-3/4" to 2-7/8".

3. When front rail is correctly positioned, tighten all mounting screws securely with 5mm hex wrench and 13mm wrench.



Figure 6-1

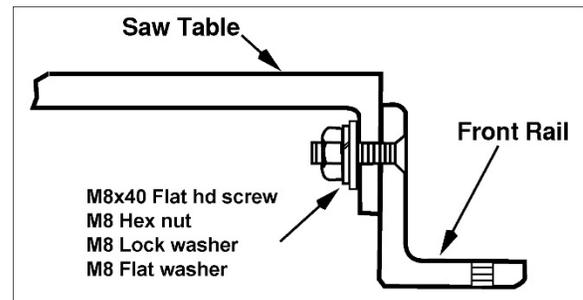


Figure 6-2

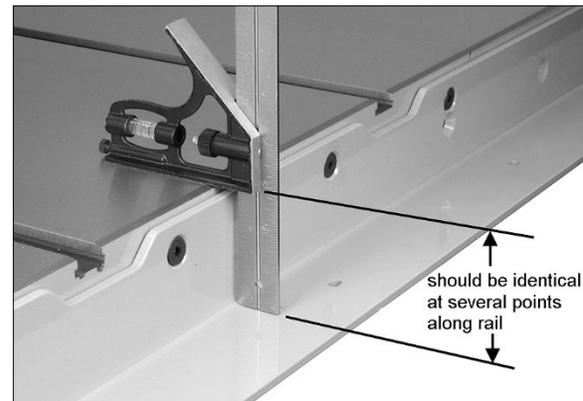


Figure 6-3

### 6.3 Installing back rail

1. Locate the back rail which is 2" x 2" with holes running along one side only. The back rail should be installed parallel to table top.
2. Align holes in back rail to holes in table top, as shown in Figure 6-4.

**Note:** The rail's second hole from the right should line up with the first hole in the table top as shown. The saw's extension wings are not pre-drilled at the factory, so use of the first hole on the rail is optional.

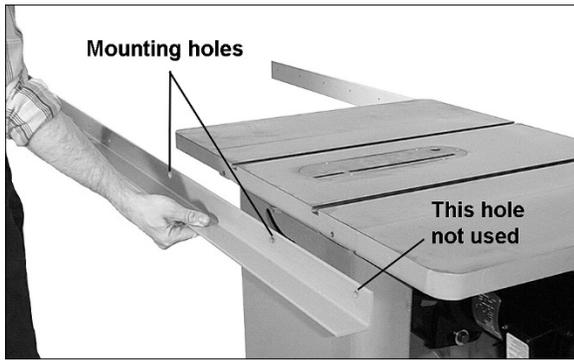


Figure 6-4

3. Secure back rail (A, Figure 6-5) to pre-tapped holes in saw table (B) in two places with M8x20 socket hd cap screws and washers. *Finger tighten only.*
4. Use the adjustable square to measure at several points along rail to achieve parallel with table. Tighten screws securely with 13mm wrench.

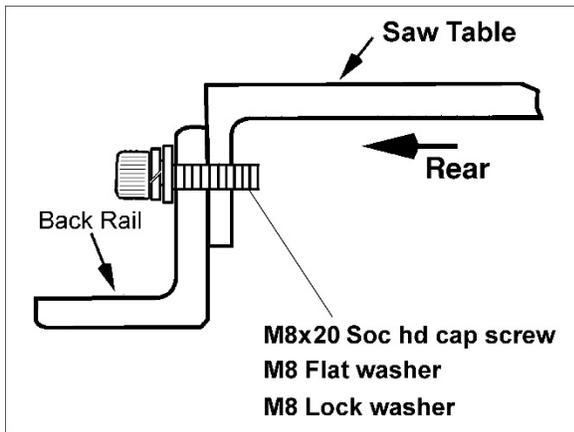


Figure 6-5

**Important:** If you are installing an optional wood extension table on your saw, it should be installed first before mounting guide tube. This will prevent having to mount and align the guide tube twice.

If you are not mounting an optional wood table, proceed to *sect. 6.5, Installing guide tube.*

## 6.4 Installing wood extension table (optional accessory)

### 6.4.1 Tools required for assembly

- Electric drill
- Philips screwdriver
- Open-end wrenches, 10mm, 13mm
- Hex wrenches, 5mm, 6mm
- Four clamps
- Straight edge
- Rubber mallet (or hammer with block of wood)

### 6.4.2 Installing table legs

Legs are optional accessories. If your wood table does not require legs, proceed to *sect. 6.4.3.*

Place the optional wood extension table upside down. (Use a mat or cloth to protect the surface).

### Installing on PM2000B (folding legs):

1. Install leg brackets to the pre-drilled holes, using screws provided with the legs.
2. Press both ball detents (A, Figure 6-6) and swing leg until it “clicks” into position.
3. Turn wood table right-side up.
4. The levelers at bottom of legs can be rotated to help level wood table with saw during the following procedure.

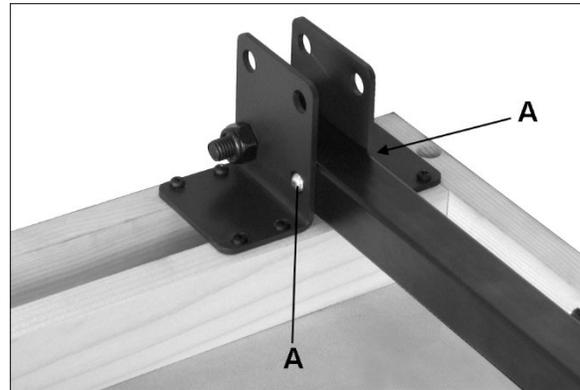


Figure 6-6: for PM2000B

### Installing on PM3000B (non-folding legs):

1. Position legs at inside corners of wood table at the end where the Powermatic logo is placed. See Figure 6-6b).

Note: If you are using a mobile base under your saw, you may need to shift the placement of the legs so that they rest properly upon the shelves of the base.

2. Drill pilot holes, making sure not to drill completely through table and sides.
3. Secure with the eight screws provided.
4. Turn wood table right-side up.
5. The levelers at bottom of legs can be rotated to help level wood table with saw during the following procedure.



Figure 6-6b: for PM3000B

### 6.4.3 Installing wood table

The optional wood extension table (including optional router table) sits flush against saw table and along inside of rails. The Powermatic logo should face outward. The extension table is not bolted to the saw table; it is bolted only to the rails.

Extension table and saw table must be aligned properly so the Accu-Fence will slide smoothly from one to the other.

1. Place extension table between rails and up against saw table, leaving extension table raised just slightly above saw table. Clamp extension table to front and back rails as shown in Figure 6-7. Clamping pressure should be enough to secure table yet allow minor adjustments.

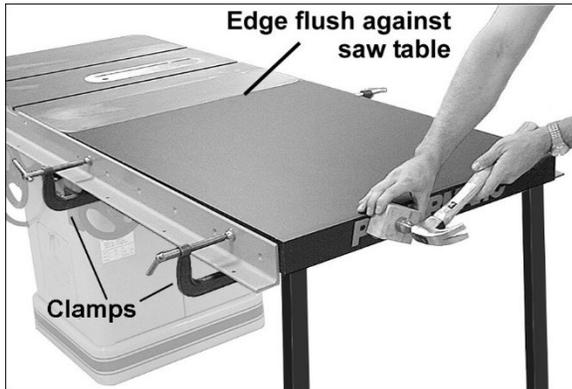


Figure 6-7

2. Use a rubber mallet (or hammer and flat block of wood) to tap extension table up flush against saw table (Figure 6-7). Then tap down extension table at various points along its edge where it meets saw table, until it is level with saw table (Figure 6-8).

**Note:** Never use a steel-face hammer directly against saw table or extension table.



Figure 6-8

3. As one part of the edge becomes level with table, tighten the clamp on that side. Then move to the other side and repeat, until the full length of the edge is level with saw table.

4. Lay a straight edge across both extension table and saw table to ensure proper leveling.
5. When extension table is properly aligned, drill holes into wood table using holes in rails as guide. See Figure 6-9. (You may wish to drill 3/32" pilot holes first.) Drill 9mm (or 11/32") holes into front edge and back edge of table using holes in the rails as your guide.

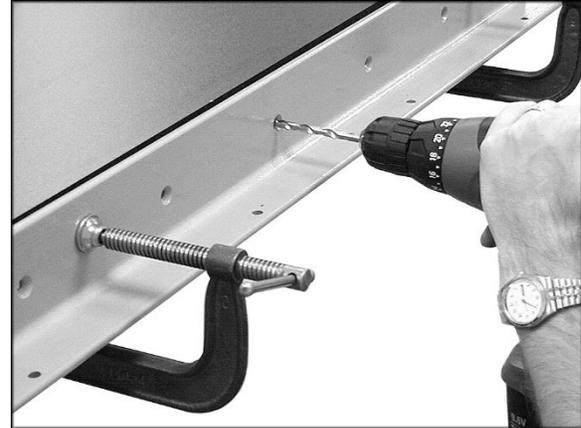


Figure 6-9

### 6.4.4 Securing wood table to front rail

See Figure 6-10.

Insert flat head screws (A, Figure 6-10) through front rail and wood extension table, and secure with washers and hex nuts. *Finger-tighten only at this time.*

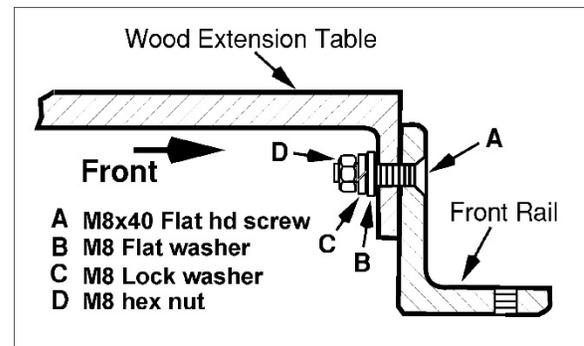


Figure 6-10

### 6.4.5 Securing wood table to back rail

See Figure 6-11.

1. Insert six socket hd cap screws (E, Figure 6-11) and flat washers (F) through back rail and wood extension table, and secure with washers and nuts. *Finger-tighten only.*
2. Re-check table for alignment along front and back rails. Make further adjustments if necessary.
3. Tighten all screws and nuts.

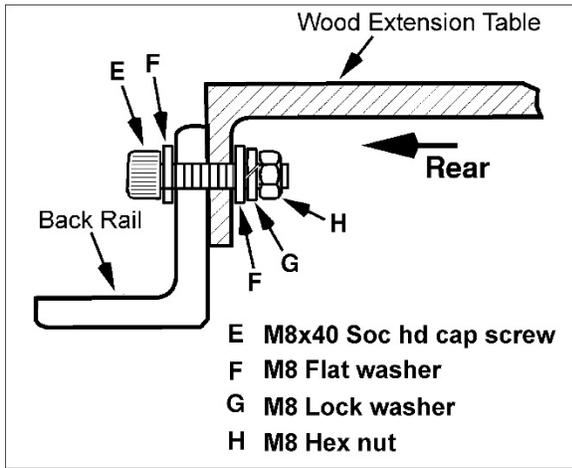


Figure 6-11

## 6.5 Installing guide tube

- The guide tube mounts to front rail with scale facing toward operator (Figure 6-12). Align holes in bottom of guide tube with holes in front rail. When properly positioned the guide tube should extend about 6-inches beyond left end of front rail.

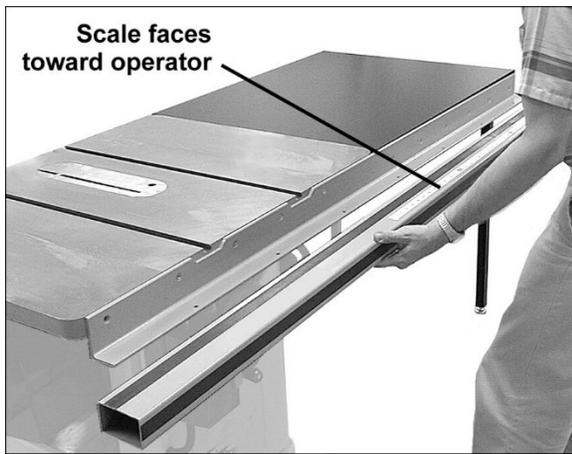


Figure 6-12

- Fasten guide tube to rail from beneath, with eight M6x20 hex cap screws and lock washers (Figure 6-13). *Finger-tighten only.*

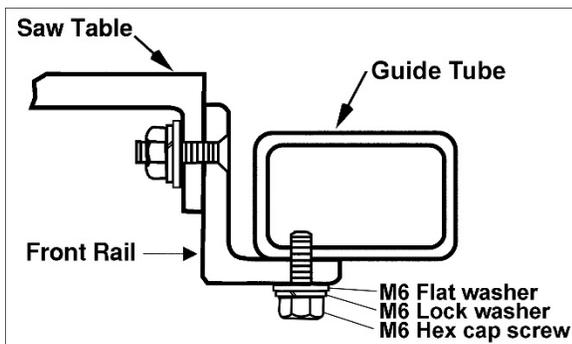


Figure 6-13

- The holes in front rail are over-sized to allow slight adjustment of guide tube. Pull guide tube away from rail as far as it will go.

- Measure distance from edge of guide tube to front rail; do this at both ends of guide tube to ensure guide tube is parallel to front rail. (The distance itself is not important, but it should be the same along the length of the guide tube.)

NOTE: Install table saw switch onto front rail at the same time as the guide tube.

- Tighten all screws with a 10mm wrench.

## 6.6 Mounting Accu-Fence

- Screw handle into fence head.
- Set fence on table and guide tube. Pull handle up to slide fence; push down to lock fence to guide tube.
- Check height of side plates from the table top. The Accu-Fence has been pre-set by the manufacturer for a side plate height of 1/32" from table top. If any misalignment has occurred during shipment, you can easily reset side plates to correct height as described below.

### 6.6.1 Setting side plate height

- Figure 6-14 shows a fence where misalignment of side plates has occurred; the side plates are in contact with front edge of saw table.

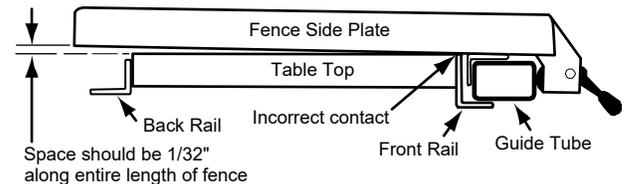


Figure 6-14

- Turn Accu-Fence upside down and with a rubber mallet (or hammer and block of wood), gently tap the side plates to create a height greater than 1/32" from table top.

**Note:** Do not use a steel faced hammer directly on the side plates as this will damage them.

- Reposition Accu-Fence on table and place the plastic shims (included with shipping contents) beneath side plates. Tap the sides down until they contact the shims as shown in Figure 6-15.
- Remove shims. The Accu-Fence should now have correctly positioned side plates.



Figure 6-15

### 6.6.2 Fence/miter slot parallelism

See Figure 6-16.

1. Place fence on table. Slide it over until left edge (A) lines up with right miter slot (B), and lock fence.
2. The locked fence must be even (parallel) with miter slot from front to back.
3. If fence is not even along length of miter slot, unlock fence and remove it from guide rail (Figure 17).
4. Adjust one of two setscrews (C, Figure 6-17) with 5mm hex wrench until fence is even with miter slot edge along its entire length when locked.

**Note:** You may need to re-adjust clamping pressure (described below) after aligning fence.

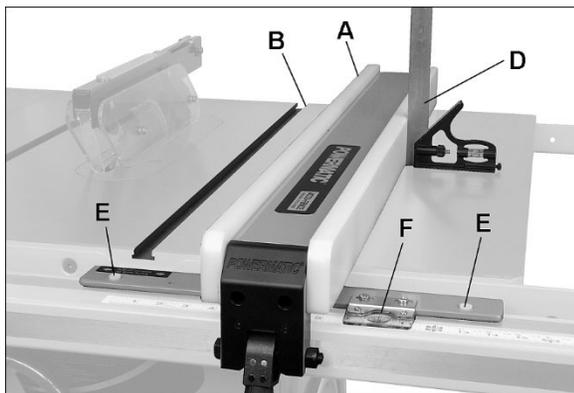


Figure 6-16



Figure 6-17

### 6.6.3 Clamping pressure adjustment

The Accu-Fence has been pre-set by the manufacturer to lock securely when handle is pushed down. If adjustment is needed:

1. Unlock fence and remove it from guide rail.
2. Adjust each of two setscrews (C, Figure 6-17) exactly the same number of rotations until fence is held securely when handle is pushed down.

Clockwise rotation of setscrews will increase cam pressure. Counterclockwise rotation will decrease cam pressure.

### 6.6.4 90° to table adjustment

1. Place fence on saw table and lock it.
2. Place a square (D, Figure 6-16) on table next to fence. Fence should be 90° to table.
3. If adjustment is necessary, unlock fence, and turn one of two nylon adjustment screws (E, Figure 6-16) until fence is 90° to table.
4. Lock fence and verify the adjustment.

### 6.6.5 Cursor adjustment

1. Disconnect table saw from power source.
2. Remove blade guard and raise blade above tabletop.
3. Unlock fence and slide it to approximately 4-inches from saw blade. Lock fence.
4. Measure distance between saw blade and inside of fence. **Note:** Measure from a tooth edge, not the flat side of the blade.
5. Adjust cursor (F, Figure 6-16) to read the distance just measured, and tighten cursor assembly to fence.
6. Take a test cut and confirm that the adjustment is correct.

**Note:** Slots in cursor should allow enough adjustment travel. If cursor lacks enough travel to give correct measurement, loosen guide tube and adjust as needed. If you still cannot achieve correct measurement, loosen front rail and adjust as needed. If you have to adjust front rail, you will need to go through front rail assembly instructions again.

Cursor position should be checked after installing a new blade.

### 6.7 Side plate replacement

The Accu-Fence is specially designed to save many hours of down-time when side plates need to be replaced. In an operation that can last an entire day with other fences, the Accu-Fence side replacement takes only a few minutes.

1. Turn fence upside down and loosen lock nuts with a 10mm wrench through the slots (Figure 6-19). **Note:** A socket wrench can fit into the slot, and will speed the process.

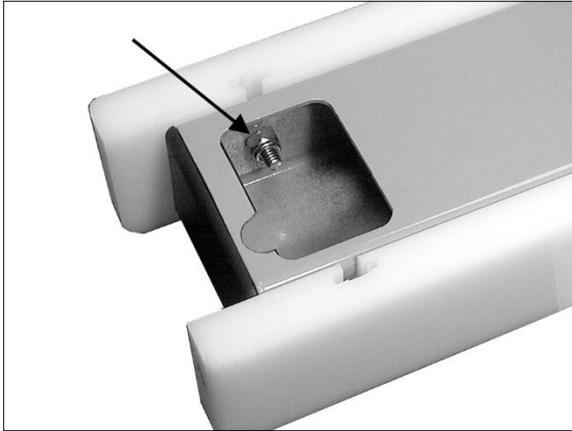


Figure 6-19

2. Remove lock nuts.
3. Turn fence on its side and pull side plate from frame (Figure 6-20).
4. Replacement side plates come with fasteners already attached. With fence still on its side, align new side plate so that the attached bolts line up with the holes on the frame. See Figure 6-20. Mount the new side plate to the frame.
5. Turn fence on its back and secure side plate by lightly tightening all nuts. Do not overtighten.
6. Make any necessary adjustments to side plate height according to preceding instructions.

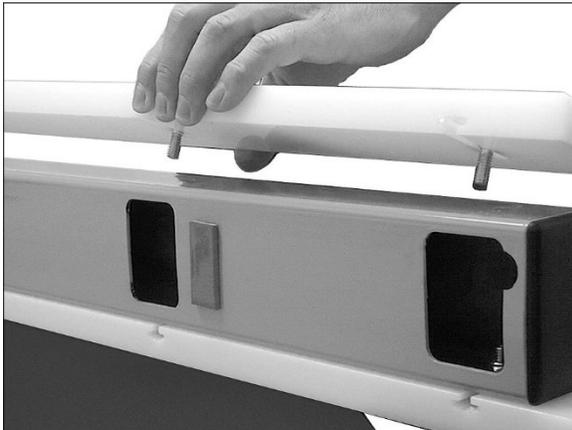


Figure 6-20

## 7.0 Rail installation on a non-Powermatic Saw

The following instructions are for installing the Accu-Fence and Rail System on a table saw other than a Powermatic model. Some drilling is required.

### 7.1 Tools required for assembly

Open-end wrenches, 10mm and 13mm  
 Hex wrenches, 5mm and 6mm  
 Adjustable square  
 Rubber mallet (or hammer and block of wood)  
 Straight edge  
 Electric drill with 9mm (or 11/32") bit

### 7.2 Installing front rail

1. Identify the front rail, which is 3" x 3" with notches on one side.
2. Place a mark 18" from left end of front rail (Figure 7-1). This mark will be lined up with saw blade.

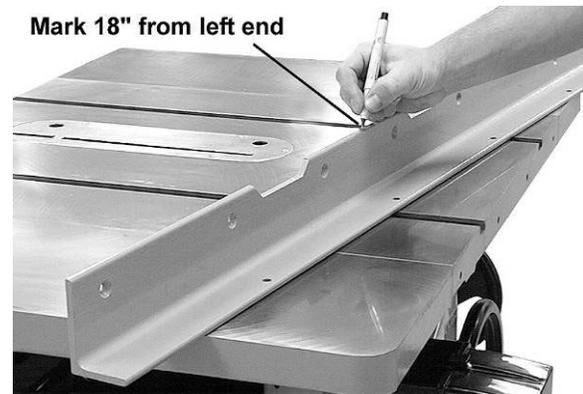


Figure 7-1

3. Lay a straight edge flush against right side of saw blade, as shown in Figure 7-2, and place notched side of front rail against saw table as shown. Hold front rail to saw table with clamps. Make sure the mark on front rail aligns with left edge of straight edge (and thus in line with the blade).



Figure 7-2

4. The front rail must be parallel to table top in order for the Accu-Fence system to function properly. Place an adjustable square on the table, as shown in Figure 7-3.

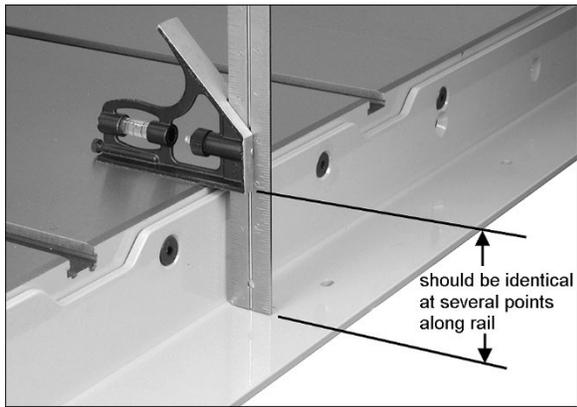


Figure 7-3

5. Check height of front rail at several locations along surface of table. The measurements should be the same along the length of the rail. Adjust as needed.
6. When front rail has been correctly positioned, and your mark still lined up with the straight edge, drill 1/4" holes into lip of table saw top, using holes in front rail as guide (Figure 7-4).
7. Lightly secure front rail to saw table with four M8x40 flat head screws with washers and hex nuts (Figure 7-5). *Finger-tighten only.*



Figure 7-4

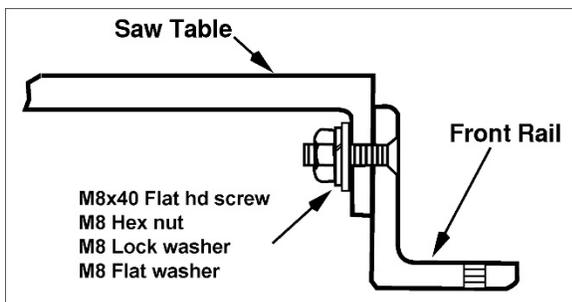


Figure 7-5

### 7.3 Installing back rail

1. Locate the back rail which is 2" x 2" with holes running along one side only. The height of the back rail when attached to the saw is not critical, but it should be parallel to table top.

2. Position back rail approximately 9/16" below table surface, with the ends even with those of front rail (Figure 7-6). Hold back rail to saw with clamps.
3. Drill 9mm (or 11/32") holes into lip of saw table using holes in back rail as guide (Figure 7-7).
4. Insert socket head cap screws with washers through back rail and saw table, and secure with washers and hex nuts. See Figure 7-8. *Finger-tighten only at this time.*

The rest of the installation is the same as with a Powermatic table saw. Refer back to sect. 6.4 to mount the optional wood extension table (if applicable) and the guide tube in sect. 6.5, and proceed from there.

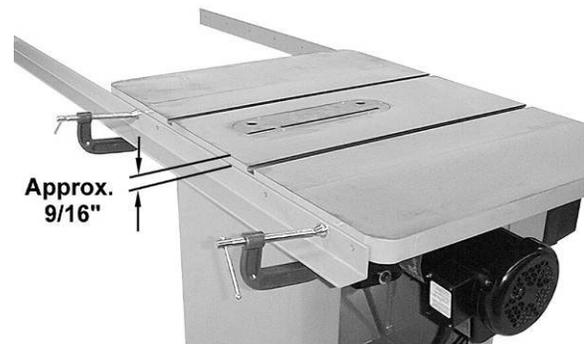


Figure 7-6



Figure 7-7

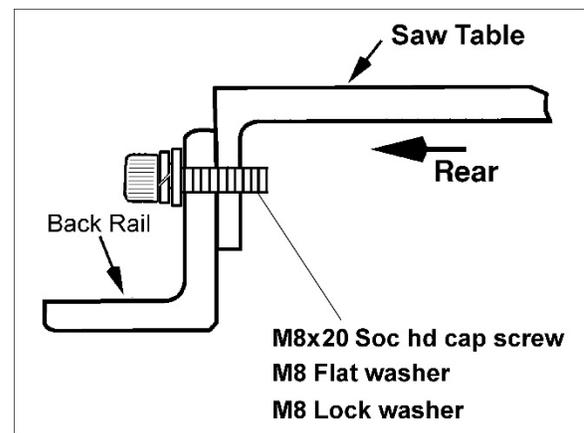


Figure 7-8

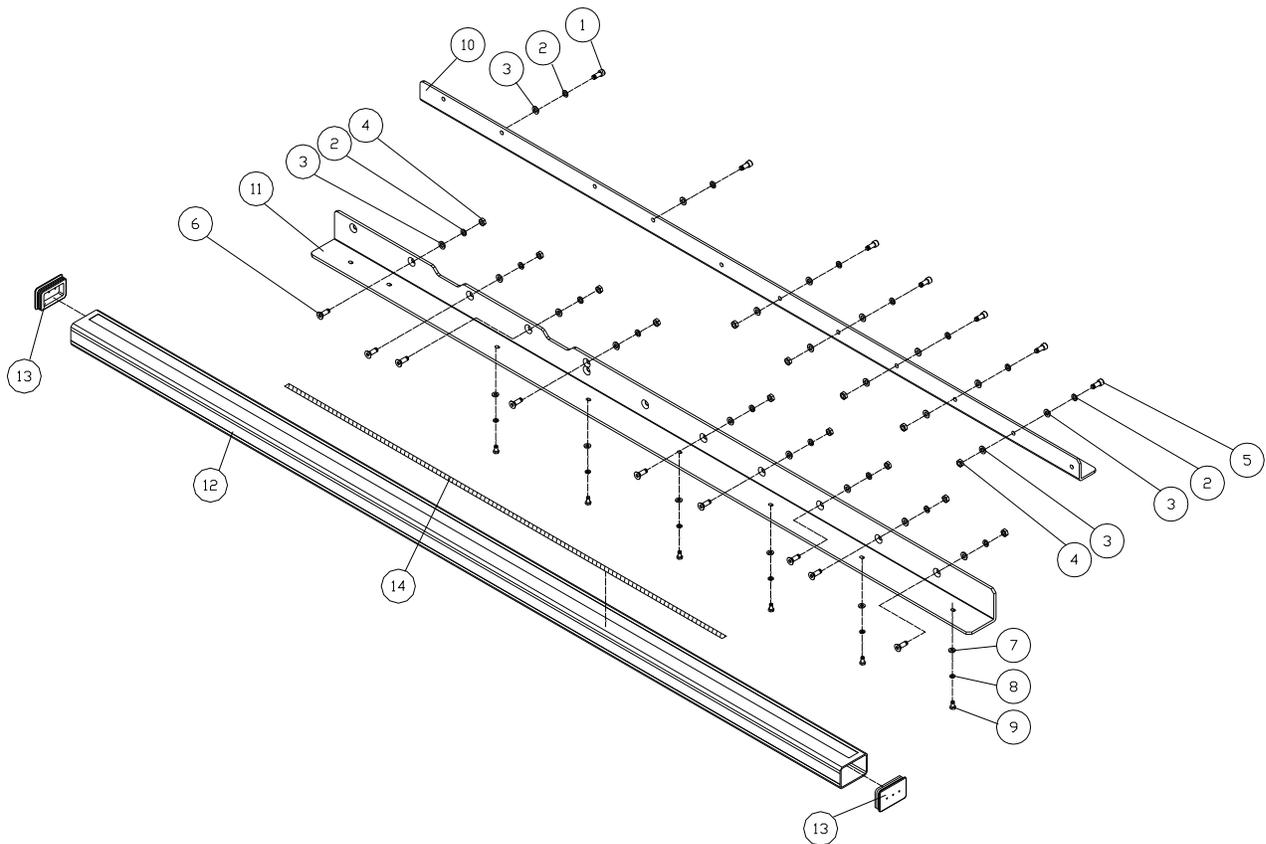
## 8.0 Replacement parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday (see our website for business hours, [www.powermatic.com](http://www.powermatic.com)). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from Powermatic.

Some parts are shown for reference only, and may not be available individually.

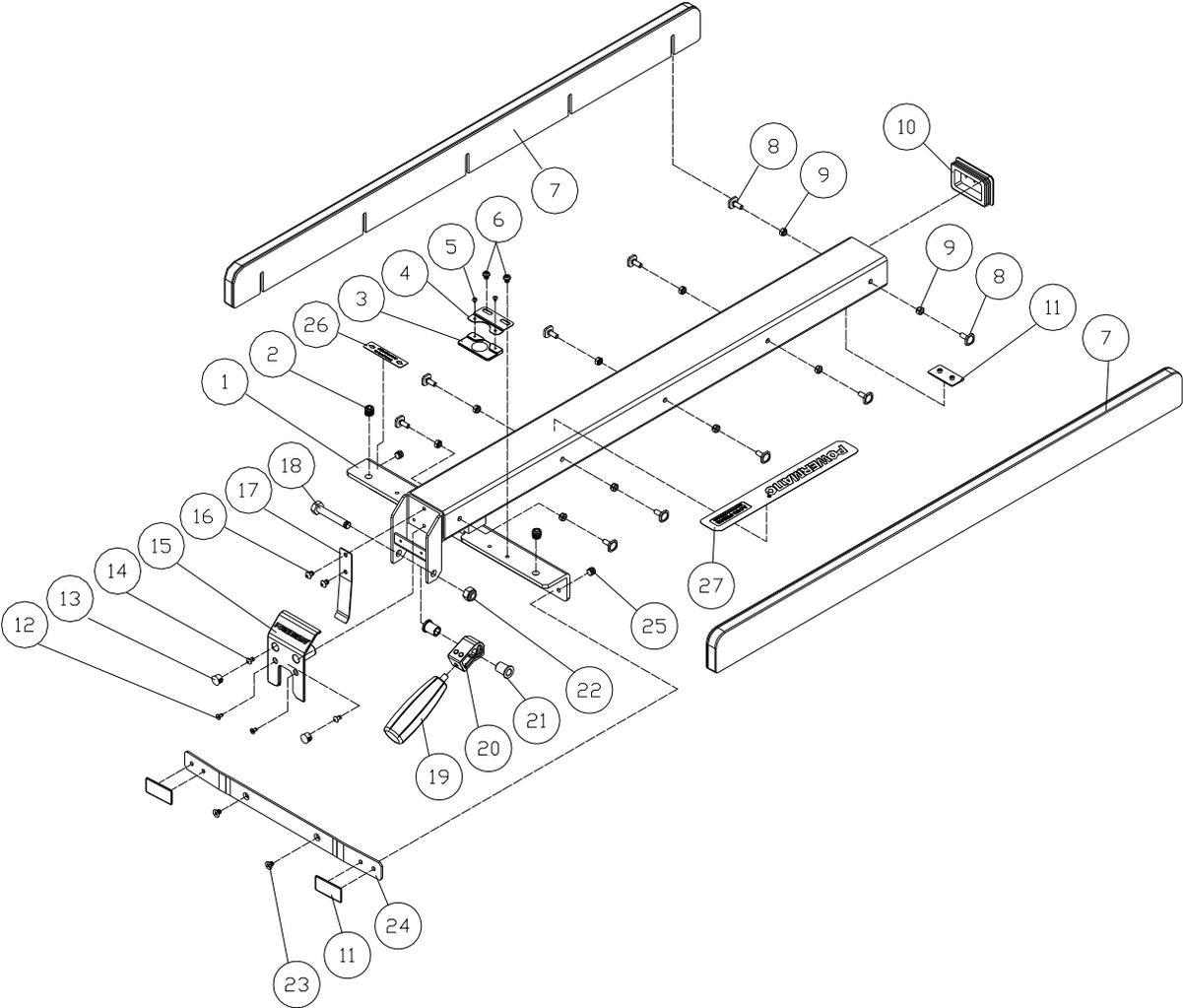
### 8.1.1 Rail Assembly – Exploded View



## 8.1.2 Rail Assembly – Parts List

Index No	Part No	Description	Size	Qty
	2653031B	50" PW Rail Set for PM2000B & PM3000B		
	2653039B	30" PW Rail Set for PM2000B		
	PM2000B-HK-50	Hardware Kit for 50" Rail Assembly (includes #1 thru 9)		1
1	TS-1504041	Socket Head Cap Screw	M8-1.25P x 20L	2
2	TS-1551061	Lock Washer	M8	16
3	TS-1550061	Flat Washer	8.5 x 16 x 2.0T mm	21
4	TS-2311081	Hex Nut	M8-1.25P	14
5	TS-1504081	Socket Head Cap Screw	M8-1.25P x 40L	5
6	TS-1515051	Socket Head Flat Screw	M8-1.25P x 40L	9
7	TS-1550041	Flat Washer	6.3 x 13 x 2.0T mm	8
8	TS-1551041	Lock Washer	M6	8
9	TS-1482041	Hex Cap Screw	M6-1.0P x 20L	8
	PM2000B-HK-30	Hardware Kit for 30" Rail Assembly (includes #1 thru 9)		1
1	TS-1504041	Socket Head Cap Screw	M8-1.25P x 20L	2
2	TS-1551061	Lock Washer	M8	10
3	TS-1550061	Flat Washer	8.5 x 16 x 2.0T mm	12
4	TS-2311081	Hex Nut	M8-1.25P	8
5	TS-1504081	Socket Head Cap Screw	M8-1.25P x 40L	2
6	TS-1515051	Socket Head Flat Screw	M8-1.25P x 40L	6
7	TS-1550041	Flat Washer	6.3 x 13 x 2.0T mm	6
8	TS-1551041	Lock Washer	M6	6
9	TS-1482041	Hex Cap Screw	M6-1.0P x 20L	6
10	PM2000B-610	Back Fence Rail (50" rip)	72" L	1
	PM2000B-610S	Back Fence Rail (30" rip)	52" L	1
11	PM2000B-611	Front Fence Rail (50" rip)	72" L	1
	PM2000B-611S	Front Fence Rail (30" rip)	52" L	1
12	PM2000B-612	Front Fence Guide (50" rip)	84" L	1
	PM2000B-612S	Front Fence Guide (30" rip)	64-1/4" L	1
13	PM2000B-613	Tube Cap		2
14	PM2000B-614	Scale	53"L x 3/4"W	1
	PM2000B-614S	Scale	32"L x 3/4"W	1

8.2.1 Accu-Fence Assembly – Exploded View



## 8.2.2 Accu-Fence Assembly – Parts List

Index No	Part No	Description	Size	Qty
	2195079B	Accu-Fence Assembly for PM2000B		1
	2195080B	Accu-Fence Assembly for PM3000B		1
1	PM2000B-501	Fence Body (only for PM2000B)		1
	PM3000B-501	Fence Body (only for PM3000B)		1
2	PM2000B-502	Nylon Adjustment Screw	M12-1.75	2
3	PM2000B-503	Cursor		1
4	PM2000B-504	Cursor Bracket		1
5	PM2000B-2100	Phillips Pan HD Tapping Screw	M3-1.06 x 6L	2
6	F001222	Phillips Pan HD Machine Screw	M6-1.0 x 6L	2
7	PM2000B-507	Fence Side Plate (only for PM2000B)		2
	PM3000B-507	Fence Side Plate (only for PM3000B)		2
8	PM2000B-508	T-Bolt (q'ty 10 for PM2000B)		10
	PM3000B-508	T-Bolt (q'ty 12 for PM3000B)		12
9	TS-1541021	Nylon Lock Hex Nut (q'ty 10 for PM2000B)	M6-1.0	10
	TS-1541021	Nylon Lock Hex Nut (q'ty 12 for PM3000B)	M6-1.0	12
10	PM2000B-510	End Cap		1
11	PM2000B-511	Fluoroway Pad		3
12	F010946	Socket Head Flat Screw	M4-0.7 x 8L	2
13	PM2000B-513	Plug	H-13	2
14	F009884	Socket Head Button Screw	M5-0.8 x 8L	2
15	PM2000B-515	Fence Head Cover		1
16	TS-2246082	Socket Head Button Screw	M6-1.0 x 8L	2
17	PM2000B-517	Spring Plate		1
18	TS-1491151	Hex Cap Screw	M10-1.5 x 90L	1
19	PM2000B-519	Handle		1
20	PM2000B-520	Locking Cam Assembly		1
	PM2000B-520C	Locking Cam		1
	PM2000B-520M	Magnet		2
21	PM2000B-521	Spacer		2
22	TS-2342101	Nylon Lock Hex Nut	M10-1.5	1
23	F001220L	Phillips Flat HD Machine Screw w/thrdlckr	M6-1.0 x 8L	2
24	PM2000B-524	Fluoroway Pad Holder		1
25	F010431L	Soc Set Screw CPP w/thrdlckr	M10-1.5 x 8L	2
26	PM2000B-526	Indicator Label		1
27	PM2000B-527	Powermatic Logo Label		1

## 9.0 Warranty and Service

Powermatic® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

### Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official Powermatic branded website.

- Powermatic products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

### Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

### What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. Powermatic woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

### Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

### How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. Powermatic has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the Powermatic website.

### More Information

Powermatic is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the Powermatic website.

### How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

### Limitations on This Warranty

POWERMATIC LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

POWERMATIC SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Powermatic sells through distributors only. The specifications listed in Powermatic printed materials and on the official Powermatic website are given as general information and are not binding. Powermatic reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

### Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors, Machine Accessories
2 Year – Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery

NOTE: Powermatic is a division of JPW Industries, Inc. References in this document to Powermatic also apply to JPW Industries, Inc., or any of its successors in interest to the Powermatic brand.



427 New Sanford Road  
LaVergne, Tennessee 37086  
Phone: 800-274-6848  
[www.powermatic.com](http://www.powermatic.com)