

# **HTC (and XACTA Fence II) Fine Adjust Fence Kit Installation Instructions**

*Please note this installation kit is designed **ONLY** for installation on the Commercial HTC Micro-Adjust (and Commercial XACTA Fence II with fine-adjust). Accurate Technology manufactures kits for other fences in which some or all of the components may be different. For more information about ProKits™ please contact Accurate Technology.*

## **SAFETY WARNING**

**To avoid injury: Before installing ProScale on a machine, turn off the machine and disconnect it from its power source.**

## **Warranty**

Accurate Technology, Inc., warrants ProKit™ systems against defective parts and workmanship, commencing from the date of original purchase. Upon notification of a defect, Accurate Technology, Inc. shall have the option to repair or replace any defective part. Such services shall be the customer's sole and exclusive remedy. Expenses incidental to repair, maintenance, or replacement under warranty, including those for labor and material, shall be borne by Accurate Technology, Inc.

Except as expressly provided in this warranty, Accurate Technology, Inc., does not make any warranties with respect to the product, either expressed or implied, including implied warranties of merchantability or fitness for a particular purpose, except as expressly provided in this agreement.

Accurate Technology, Inc., shall not be liable for any special, incidental, or consequential damages, for loss, damage or expense directly or indirectly arising from the customer's use of or inability to use the equipment, either separately or in combination with other equipment.

## **Tools Required**

- ☐ 3" (or larger) clamps
- ☐ Center punch
- ☐ Marking pen
- ☐ Drill Motor
- ☐ 7/32" (or equivalent) drill
- ☐ Drill and tap for 8-32 threads (included)
- ☐ Tap Handle
- ☐ Phillips screw driver
- ☐ Adjustable wrench
- ☐ SAE Hex wrench set

Some parts for this installation may have been preassembled for your convenience. Additional photos of this installation are available at [www.digi-kit.com](http://www.digi-kit.com) or by request.

## Installation Photos:

**READ THROUGH THE ENTIRE INSTRUCTIONS BEFORE BEGINNING INSTALLATION:**

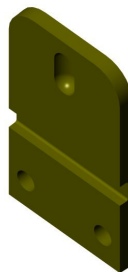
Digital Scale:



Readhead:



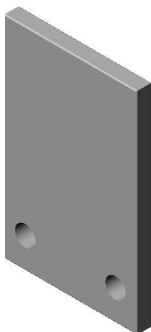
Guide Clip:



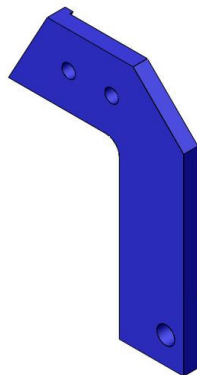
Digital Display



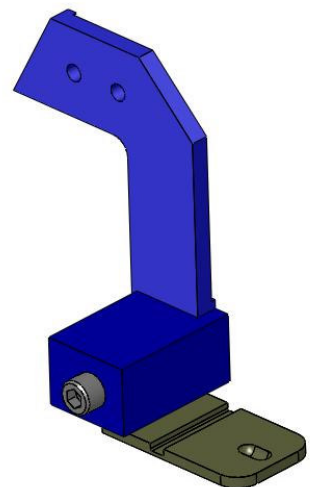
Guide Clip Protector:



Adapter Bracket



Bracket Assembly:



## Mounting the Scale:

1. Place the scale on the underside of the fence tube so the right end of the scale is **4 inches from the** right end of the fence tube, and the inside edge of the scale rests against the edge of the angle iron.
2. With the scale in this position, use a marker or center punch to mark the hole locations on the underside of the fence tube. Remove the scale for now.
3. Drill and tap 8-32 holes into the fence at the marked locations. Be sure the holes go completely through the metal. Remove any burrs.
4. Attach the scale using the 8-32 screws. Be sure the screw heads are flush or below the surface of the scale. Tighten all 8-32 screws.
5. Slide the readhead onto the scale if it was removed. Be *very* careful to not damage the sensitive grounding fingers inside. (The readhead's wire should exit to the rear (away from the operator)).

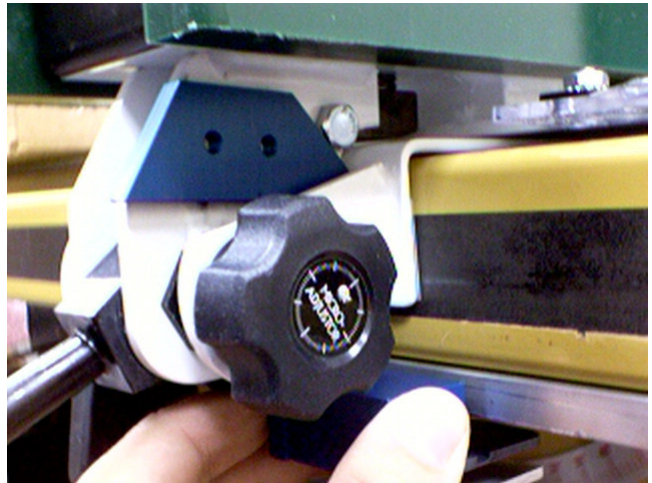




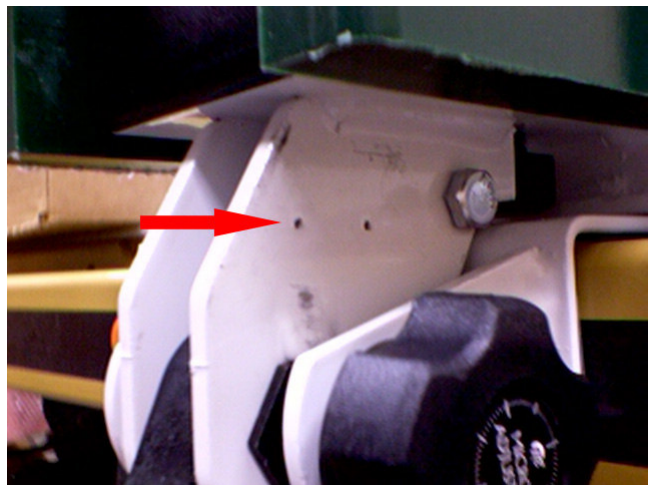
### Mounting the Readhead Bracket:

6. Move the readhead adapter bracket into place as shown in the pictures. The front lip on the adapter bracket should be against the front edge of the stop-cam assembly. The lower lip on the adapter bracket should be against the lower edge of the stop-cam assembly. (IMPORTANT: Be sure the lower lip on the adapter bracket is against the lower edge of the stop-cam assembly.)

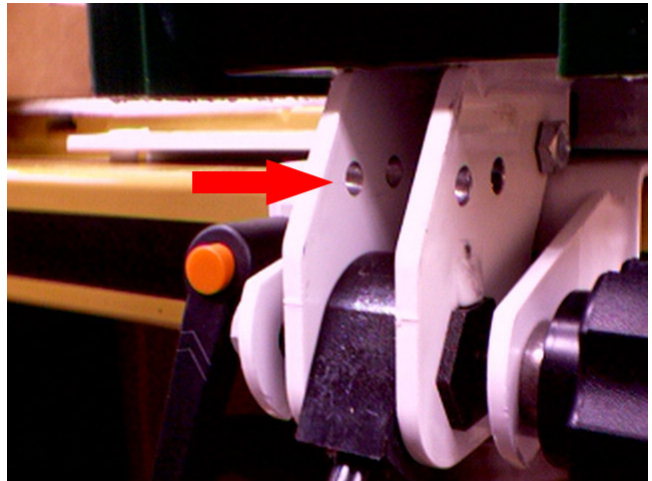
NOTE: The head of a hex bolt on the stop-cam assembly may need to be rotated a few degrees for the bracket assembly to properly seat.



7. Mark the hole positions on the stop-cam assembly. Remove the adapter bracket for now.
8. Drill the holes through BOTH SIDES of the stop-cam assembly as shown using a 7/32" drill.
9. Bolt the adapter bracket in place using the 10-32 x 3/8" Socket Head Bolts. (IMPORTANT! Verify the lower lip on the adapter bracket is against the lower edge of the stop-cam assembly.)
10. Assemble the other parts of the readhead bracket assembly (as shown on page 2).

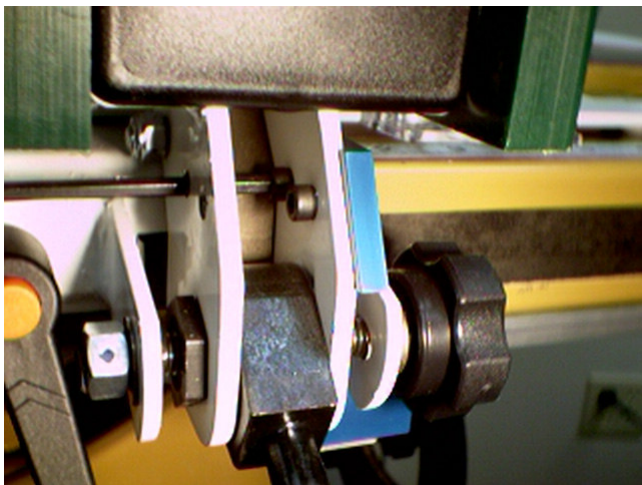


11. Slide the readhead along the scale and up to the readhead adapter bracket assembly. Center the guide clip over the post on the readhead so that it applies light pressure. **Use the supplied washers and spacers to achieve the correct pressure (the guide clip should flex approximately 1/16"). Tighten all screws attached to the display bracket.**
12. Slide the fence left and right and check for binding. Assure the readhead post remains centered in the guide clip, with constant pressure over the full range of fence travel.



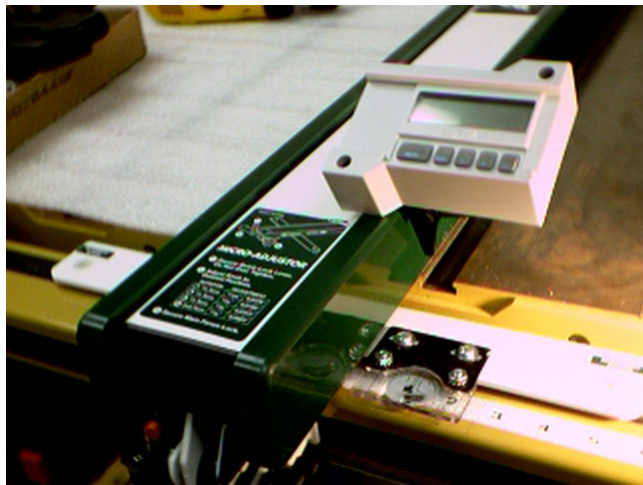
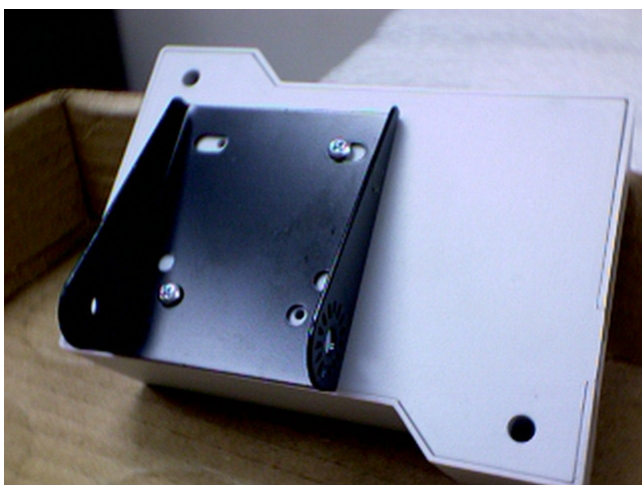
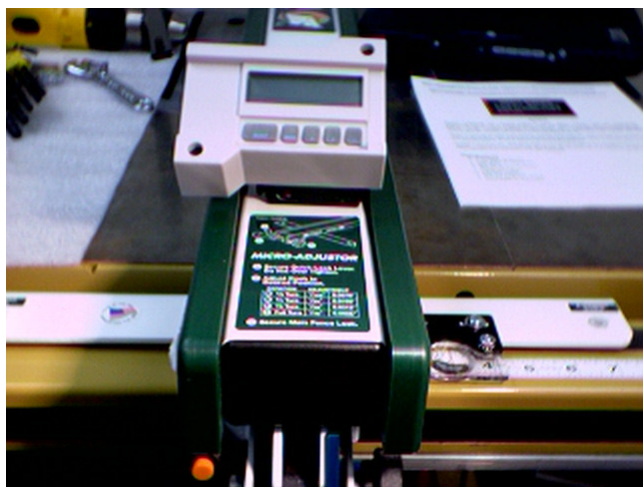
(MORE PHOTOS ON NEXT PAGE)

## Readhead Bracket Installation Photos (cont.):



## Digital Display Installation:

13. Decide on a mounting location for the digital display. Attach one side of the hinge to the back of the display using the supplied 4-40 screws. Mount the other side of the hinge using Velcro. (To mount the display using the 8-32 screws, a drill and tap are needed.)
14. Plug the readhead into the display and turn on the display.
15. Move the fence left and right along the fence. The display should read small numbers near the saw blade and large numbers away from the blade. If the readings are backwards, consult the Operation Manual for more information.



**Calibration:**

(See Operation Manual for additional information)

1. With the fence locked in position near the saw blade, cut a small square board.
2. Measure this board with the most precise measuring tool available and write down the measurement.
3. Press ZERO on the digital display.
4. Use the PLUS and MINUS buttons to enter the measured value into the digital display.
5. Press and hold the ON/OFF button. Press the MODE button (press and release in less than a second). Release the ON/OFF button. The keyboard is now locked. It can be unlocked by repeating this procedure.
6. The digital display should be re-calibrated when the saw blade is changed (kerf allowance) or when the batteries in the display are changed.
7. Familiarize yourself and other operators with the product's functions by reading the Operation Manual.

**Removing the Fence from the Saw:**

If you should need to remove the fence, follow these steps:

1. Disconnect the readhead cable from the display.
2. Disengage the guide clip from the readhead.
3. Slide the readhead to the left.
4. Slide the fence to the right and remove from the table.
5. Fasten the loose end of the readhead cable under the saw table to protect it from damage.
6. Be sure to recalibrate when the fence is re-installed.



## **Troubleshooting:**

The reading is accurate close to the saw blade, but not accurate at larger distances:

- ❑ Check the alignment of the saw fence. The alignment *will* affect the measurements at larger distances.
- ❑ Also be sure to check the mounting of all components. Any loose bolts can allow for “slop” measurements.

The display resets itself while saw is running and the fence is locked:

- ❑ The display has been accidentally reset. Large voltage spikes from nearby motors, inverters, or dust collection systems can cause this. Be sure that all devices are properly grounded.
- ❑ Also, extreme vibration can cause this. Mount the display in a different location.
- ❑ Be sure the ABS/INC key (if equipped) has not been accidentally pressed. If so, press and hold for 3 seconds to return to ABS reading.

The display resets itself while the saw is *not* running and the fence is locked:

- ❑ Be sure the ABS/INC key (if equipped) has not been accidentally pushed. If so, press and hold for 3 seconds to return to ABS reading.
- ❑ Be sure the ZERO button has not been accidentally pushed. If so, you will need to recalibrate the saw fence. Be sure to lock the value into the display.

The display reads **ERR 2 or No Enc:**

- ❑ Make sure the connector is fully inserted into the display. Also, be sure the readhead is on the scale. To clear the error, simply unplug the readhead for one second and re-insert the connector to the display. You will need to recalibrate.
- ❑ The fence has been moved too quickly. To clear the error, simply unplug the readhead for one second and re-insert the connector to the display. You will need to recalibrate.

The display reads **B, BAT, or displays a battery symbol:**

- ❑ Your batteries need to be changed. The display uses two standard AA alkaline cells. To change the batteries, unscrew the top cover (two screws) and remove old batteries. Be sure to avoid touching the brass battery contacts as much as possible. These are specially designed to be loose while you are changing batteries-**do not attempt to bend them.**

My problem is not listed-where do I get help?

- ❑ Read through all the manuals for answers to other commonly asked questions.
- ❑ Check Accurate Technology's web site for more information.
- ❑ Contact Accurate Technology at 828-654-7920. Have the following information ready when calling: machine model, part number, date of purchase, and point of purchase.
- ❑ E-mail our service department at [customerservice@accurate-technology.com](mailto:customerservice@accurate-technology.com).