

SETUP & OPERATION MANUAL

FEATURES & SPECIFICATIONS

- 2 HEAVY DUTY 3" WHEELS.
- 2 HEAVY DUTY 2-1/2" CASTERS.

CAPACITY
500 lbs (227kg)

MINIMUM SQUARE SIZES:
11" X 11" (279 X 279 mm)

MAXIMUM SQUARE SIZES:
35 1/4" X 35 1/4" (894 X 894 mm)

MINIMUM RECTANGULAR SIZES:
17" X 11" (434 X 279 mm)

MAXIMUM RECTANGULAR SIZES:
51" X 19" (1295 X 483 mm)

UNIVERSAL MOBILE BASE



MODEL

#50-025



Revision 1 June 19,2006



GENERAL® INTERNATIONAL

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THANK YOU for choosing this General® International model 50-025 Mobile Base. This mobile base has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this mobile base as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

GENERAL® INTERNATIONAL WARRANTY

All component parts of General® International machinery are carefully tested and inspected during all stages of production, and each unit is thoroughly inspected upon completion of assembly. Because of our commitment to quality and customer satisfaction, General® International agrees to repair or replace, within a period of 24 months from date of purchase, any genuine part or parts which, upon examination, prove to be defective in workmanship or material. In order to obtain this warranty, all defective parts must be returned freight pre-paid to General® International Mfg. Co., Ltd. Repairs attempted without our written authorization will void this warranty.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit with which it was supplied. However, special orders and "after

factory" modifications may render some or all information in this manual inapplicable to your unit. Further, as several generations of this mobile base and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your mobile base exactly. If you have any doubts or questions contact your retailer or our support line with the model number of your unit for clarification.

Rules for Shop Safety

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate machinery when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the machine is in operation; do not permit them to operate the machine.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. Stay alert! Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate saw dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces and ornaments while the machine is in operation.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before commencing operation.
9. Keep hands well away from blades and all moving parts. Use a push stick to feed stock, and use a brush, not hands, to clear away chips and sawdust.
10. Use recommended-speed blades, cutting tools and accessories for the workpiece material.
11. Be sure the blade or cutting tool has gained full operating speed before beginning to cut.
12. Always use a clean, properly sharpened blade. Dirty or dull blades are unsafe and can lead to accidents.
13. Do not push or force stock into the blade or cutting tool. The machine will perform better and more safely when working at the rate for which it was designed.
14. Use suitable support when cutting stock that does not have a flat surface. Always hold stock firmly against the fence when ripping, or against the miter gauge when cross-cutting.
15. To minimize risk of injury in the event of work piece kickback, never stand directly in-line with the blade or in the potential kickback path of the work piece.
16. Avoid working from awkward or off balance positions. Do not overreach during cutting operation; keep both feet on floor. Never lean over or reach over the blade and never pull the work piece over the blade from behind. Use outfeed support or have an assistant help when ripping long material.
17. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning, be sure it is properly reattached before using the tool again.
18. Never leave the machine running with the power on when not in operation.
19. If using a power feeder, stop the feeder before stopping the machine.
20. Use of parts and accessories NOT recommended by General® International may result in equipment malfunction or risk of injury.
21. Never stand on machinery. Serious injury could result if the tool is tipped over or if blade or cutting tool is unintentionally contacted.
22. Always disconnect the tool from the power source before servicing, changing accessories, performing any maintenance, cleaning, adjustments, or if the machine will be left unattended.
23. Make sure that switch is in the "OFF" position before plugging in the power cord.
24. Make sure tool is properly grounded. If tool is equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.



Additional Safety Instructions **for Mobile Bases**



Because each shop situation is unique, no list of safety guidelines can ever be complete.

The most important safety feature in any shop is the knowledge and good judgement of the user. Use common sense and always keep safety considerations, as they apply to your individual shop conditions, first and foremost in mind. If you have any doubts about the safety of an operation you are about to perform: **STOP!** Do not perform the operation until you have validated from qualified individuals if the operation is safe to perform and what is the safest method to perform it.

1. SECURE ALL FASTENERS

Make sure that all nuts, bolts or other fasteners on the mobile base are fully tightened before installing a machine on your mobile base.

2. RESPECT THE RATED WEIGHT LIMIT

Do not install machines weighing more than the rated weight capacity of the mobile base.

3. SELECT APPROPRIATE LOCATION FOR USE

Use only on flat, smooth, sturdy and stable surfaces, that are free of debris and able to support the weight of the machine and the operator.

4. ENGAGE LOCKING LEVERS

Verify that all wheel locking levers are fully engaged on your mobile base before turning on your machine. Failure to ensure that your machine is completely immobile may cause serious injury if the machine begins to move across the floor when in use or as the workpiece is fed into the blade(s) or cutting tool.

5. LOOK BEFORE YOU MOVE THE MACHINE

Ensure that there is a clear path to the spot where you are re-locating the machine before moving it. Avoid rolling over the power cord or any debris, clutter or obstructions.

6. DO NOT OVEREXERT

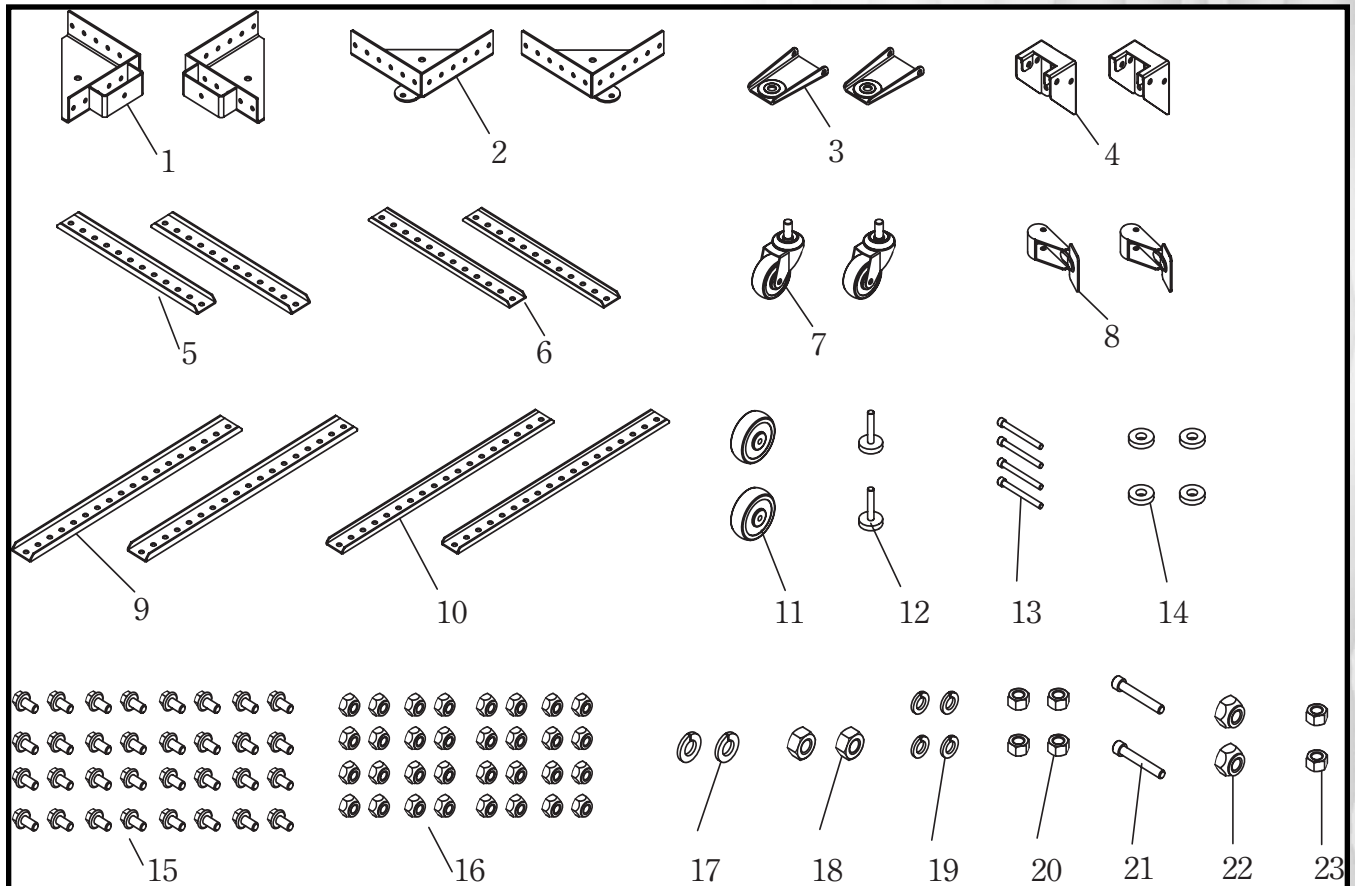
The mobile base is designed to roll smoothly up to its rated weight capacity and requires only steady firm and even pressure to re-locate the machine. If you find that excessive force is needed: **STOP** and check for obstructions or damage to the wheels before proceeding.



UNIVERSAL MOBILE BASE 50-025

UNPACKING & CHECKING CONTENTS

Remove all parts and components from the box and check for missing or damaged items as per the list of contents below. **Note: please report any damaged or missing items to your General® International distributor immediately.**



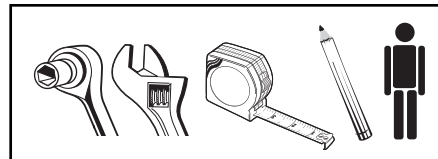
1. FIXED WHEEL MOUNTING BRACKET x 2
(LEFT AND RIGHT)
2. FRONT CASTER BRACKET x 2
(LEFT AND RIGHT)
3. CASTER MOUNTING PLATE x 2
4. WHEEL BRACKET x 2
5. EXTERIOR SHORT PLATE x 2
6. INTERIOR SHORT PLATE x 2
7. CASTER x 2
8. FOOT LEVER x 2
9. EXTERIOR LONG PLATE x 2
10. INTERIOR LONG PLATE x 2

11. FIXED WHEEL x 2
12. FOOT PAD x 2
13. CAP SCREW x 4 (5/16" x 3-1/2")
14. SPACER/BUSHING x 4
15. FLANGE BOLT x 32 (1/4" x 1/2")
16. HEX NUT x 32 (1/4")
17. LOCK WASHER x 2 (1/2")
18. HEX NUT x 2 (1/2")
19. LOCK WASHER x 4 (5/16")
20. HEX NUT x 4 (5/16")
21. CAP SCREW x 2 (1/4" x 1-3/4")
22. LOCK NUT x 2 (1/4")
23. HEX NUT x 2 (3/8")

ASSEMBLY INSTRUCTIONS

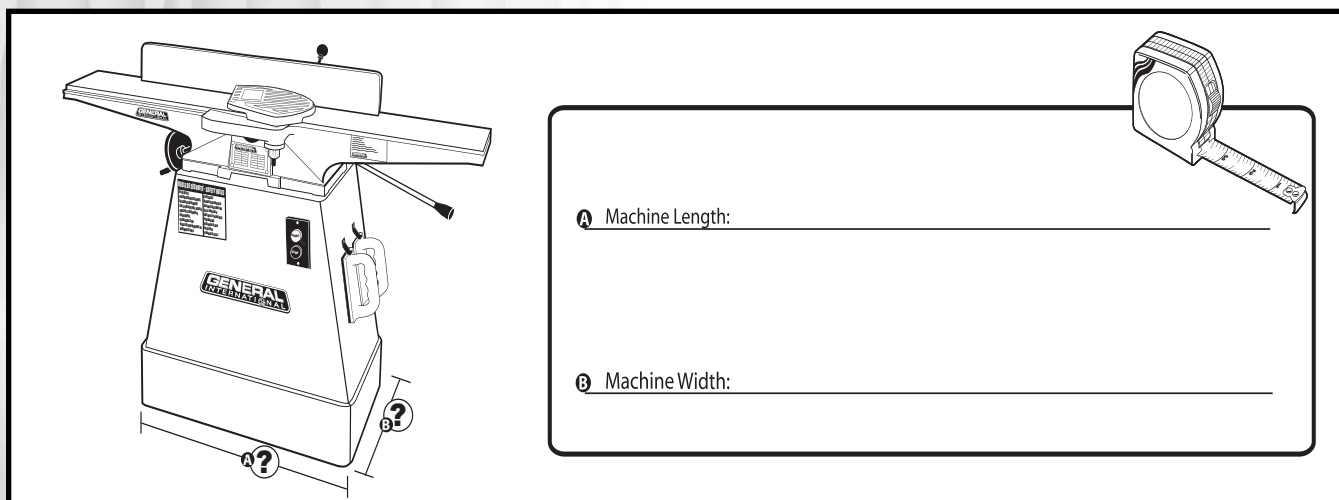
REQUIREMENTS FOR ASSEMBLY AND SET UP

- Socket wrench kit
- Adjustable wrench
- Tape measure
- Pen or Pencil
- An extra person for help with lifting



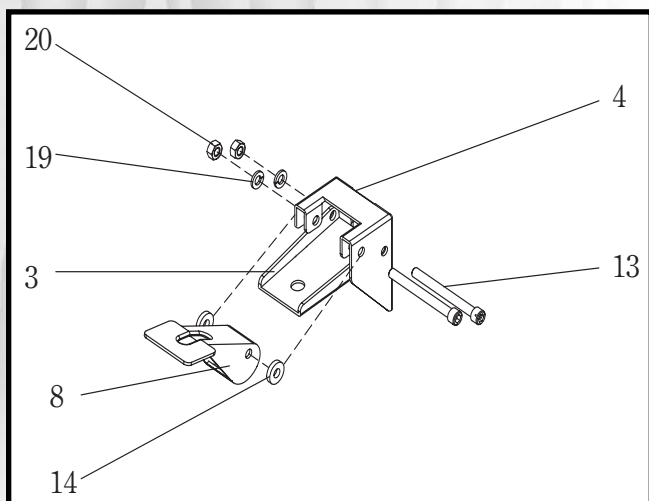
NOTE: A jointer is depicted in this example for illustration purposes only. You can use your 50-025 mobile base on any open or closed base machinery within the minimum and maximum square or rectangular sizes as listed on the cover page.

 Maximum rated load capacity of this mobile base is 500 lbs (227 kg). Surpassing the rated load capacity can lead to mobile base failure, serious personal injury and/or damage to your machine.



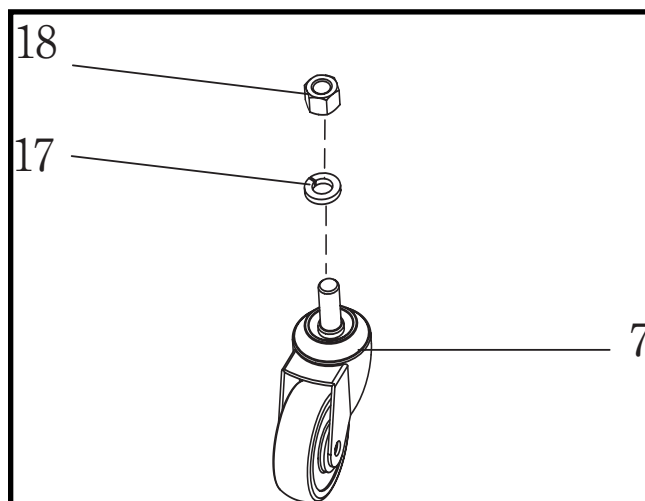
STEP 1

Before starting to assemble the mobile base, take note of the outside measurements of your machine.



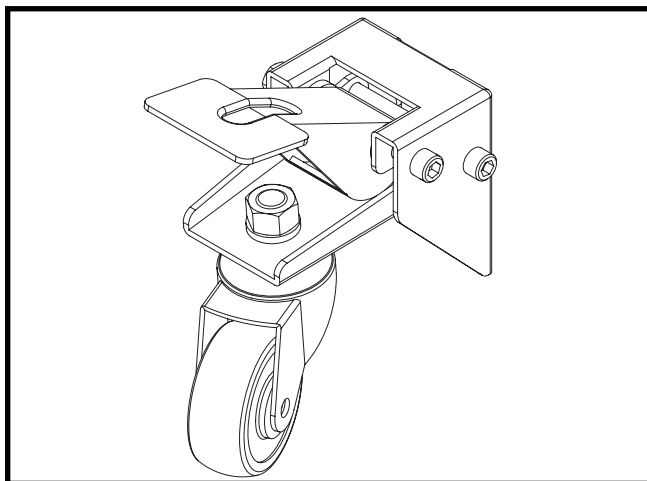
STEP 2

Assemble the wheel bracket (#4), caster mounting plate (#3), and foot lever (#8) as shown using the 5/16" hex nuts (#20), 5/16" lock washers (#19), spacer/bushing (#14) and 5/16" x 3-1/2" cap screws (#13).



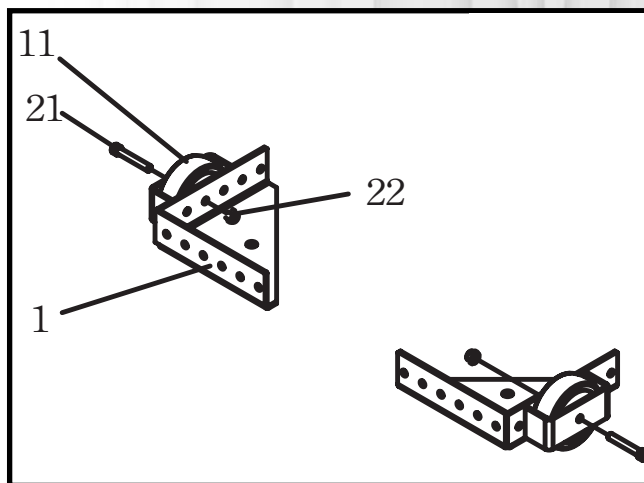
STEP 3

Install the caster (#7) to the wheel bracket assembly using the lock washer (#17) and hex nuts (#18).



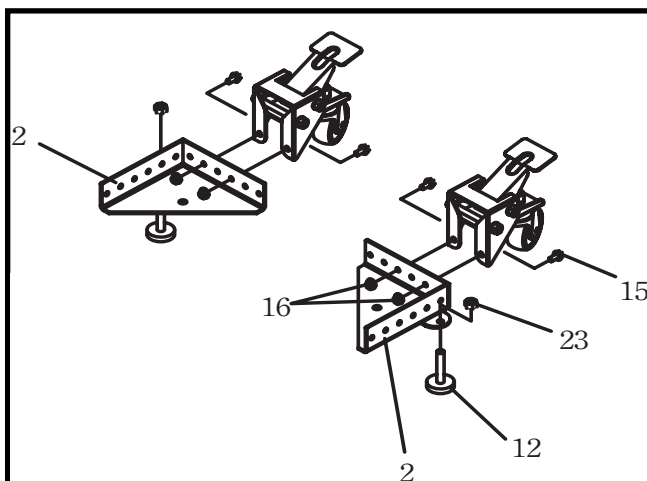
STEP 4

The completed assembly is shown in the illustration above. Follow the same procedures for the second caster mounting plate and wheel bracket assembly.



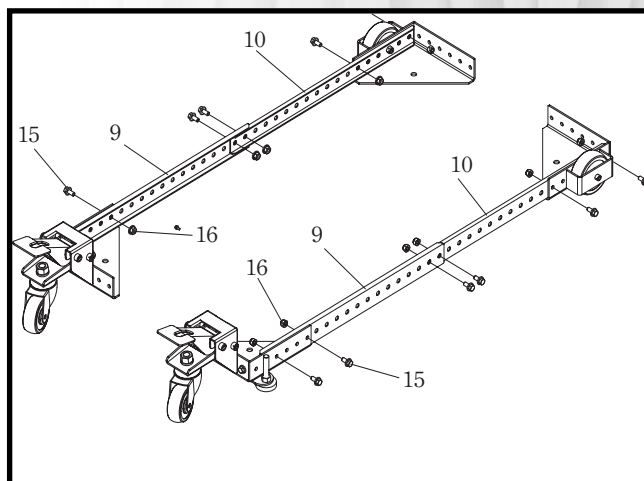
Step 5

Fit the two fixed wheels (#11) onto the two fixed wheel mounting brackets (#1) as shown using the two 1/4" x 1-3/4" cap screws (#21) and 1/4" lock nuts (#22).



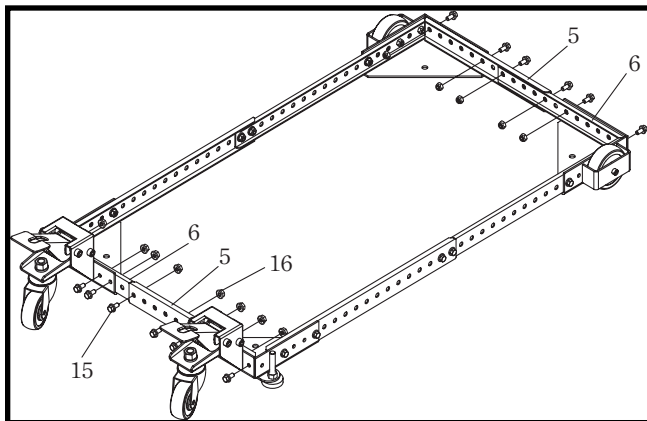
Step 6

Attach the completed wheel bracket assembly from step 2 to the front caster brackets (#2) as shown using two 1/4" x 1/2" flange bolts (#15) and two 1/4" hex nuts (#16) per bracket.



Step 7

Using your machine length (measurement "A" from Step 1) as a reference, assemble the exterior (#9) and interior long plates (#10), and then attach them to the caster assembly and fixed wheel assembly as shown using 1/4" x 1/2" flange nuts (#15) and 1/4" hex nuts (#23). As each side is completed, double check your measurements and, if necessary, adjust the length to fit the length of your machine.



Step 8

Using your machine width (measurement "B" from Step 1) as a reference, assemble the exterior (#5) and the interior short plates (#6) as shown, using 1/4" x 1/2" flange bolts (#15) and 1/4" hex nuts (#16).

As each end is completed, double check your measurements and if necessary, adjust the width to fit the width of your machine.

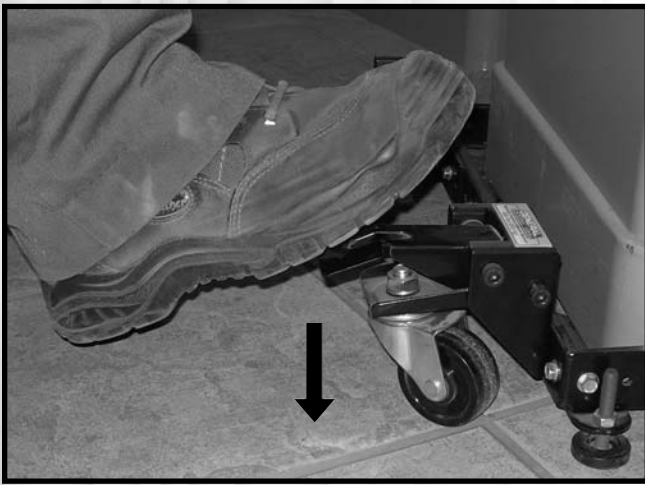
Your mobile base assembly should now be completed. Before attempting to install the machine on the base, double check all measurements to ensure that the machine will fit onto the base without problems. Lengthen or shorten-up any base dimensions as needed, then re-check your measurements. You are now ready to install your machine onto your mobile base.



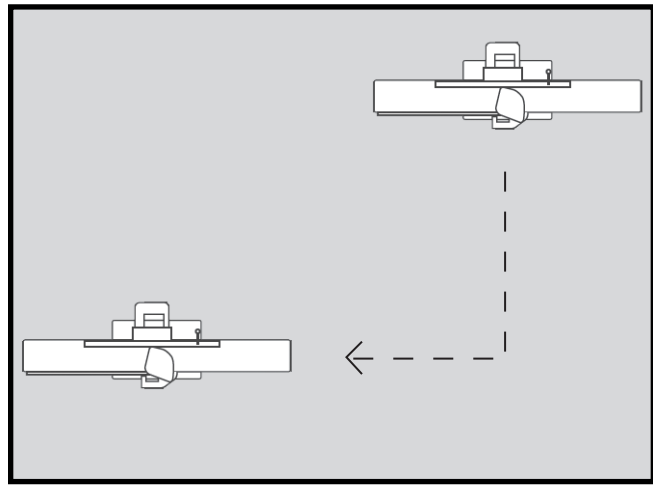
Make sure the wheels are locked and the machine has been immobilized before starting the machine.

NOTE: Follow the manufacturers' recommendations for handling or lifting the machine. Make sure to have adequate help available for lifting - Do Not Over Exert!

OPERATING INSTRUCTIONS



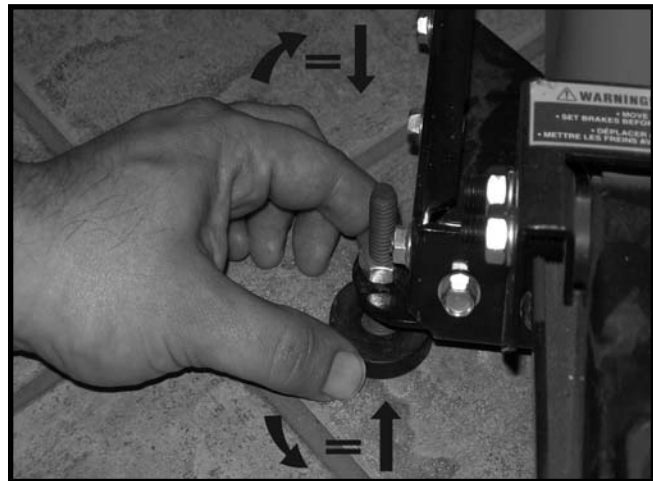
1. Push foot pedals down to engage wheels.



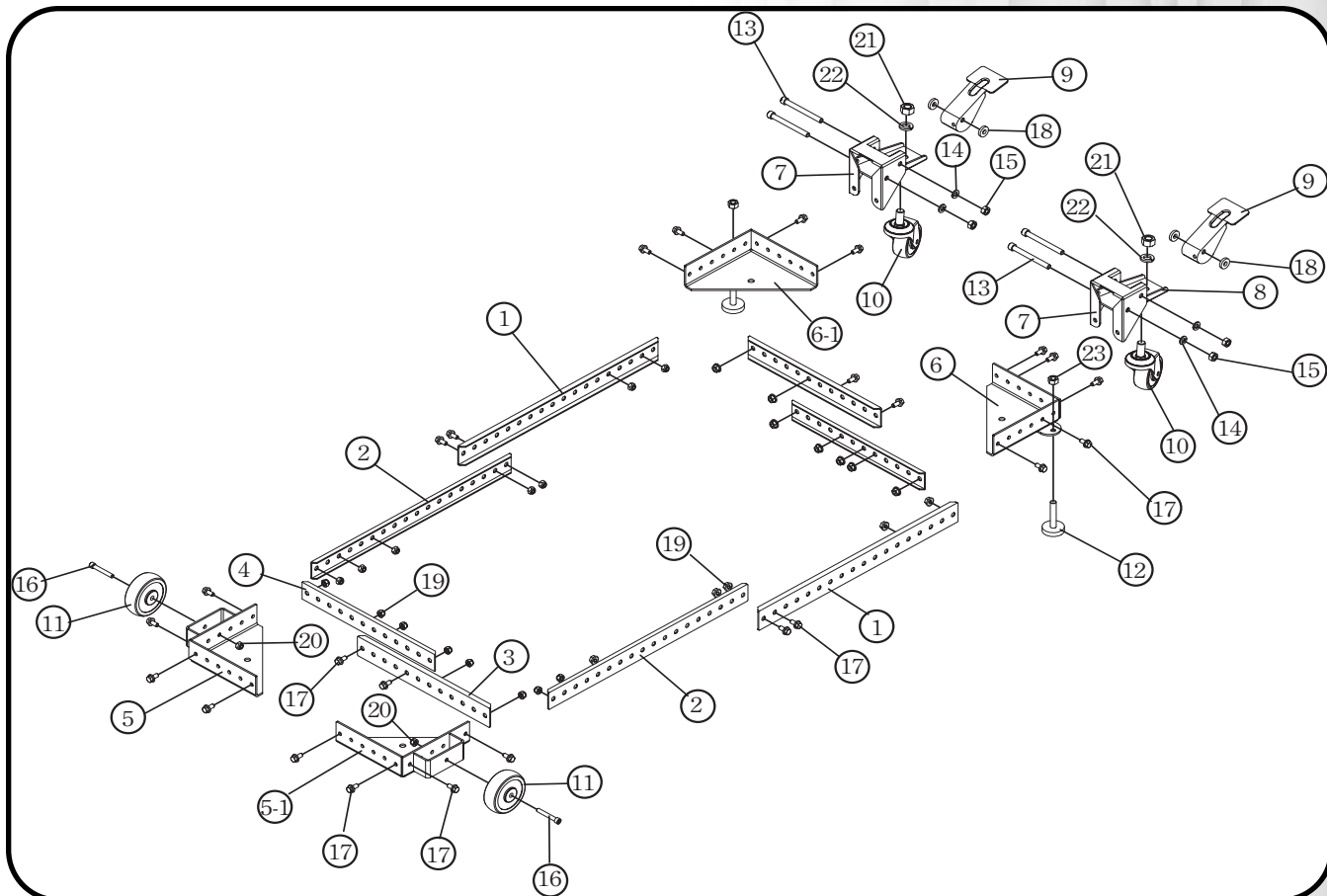
2. Move the machine to desired location in the shop.



3. Flip up foot pedals to lock wheels in place.



4. On uneven surfaces, adjust foot pads (#12) to level the base and keep the machine from rocking when in use.



PARTS LIST 50-025

PART NO.	DESCRIPTION	SPECIFICATION	QTY
50025-01	EXTERIOR LONG PLATE	17-1/2" x 1-1/2" (445 x 40 mm)	2
50025-02	INTERIOR LONG PLATE	17-3/4" x 1-3/8" (450 x 35 mm)	2
50025-03	EXTERIOR SHORT PLATE	11-1/2" x 1-1/2" (295 x 40 mm)	2
50025-04	INTERIOR SHORT PLATE	11-3/4" x 1-3/8" (300 x 35 mm)	2
50025-05	FIXED WHEEL MOUNTING BRACKET (LEFT) REAR		1
50025-05-1	FIXED WHEEL MOUNTING BRACKET (RIGHT) REAR		1
50025-06	FRONT CASTER BRACKET (RIGHT)		1
50025-06-1	FRONT CASTER BRACKET (LEFT)		1
50025-07	WHEEL BRACKET		2
50025-08	CASTER MOUNTING PLATE		2
50025-09	FOOT LEVER		2
50025-10	CASTER	1/2" x 2-1/2" (12.7 x 63.5 mm)	2
50025-11	FIXED WHEEL	5/16" x 3" (8 x 76.2 mm)	2
50025-12	FOOT PAD	3/8" x 2" (9.5 x 51 mm)	2
50025-13	CAP SCREW	5/16" x 3-1/2"	4
50025-14	LOCK WASHER	5/16"	4
50025-15	HEX NUT	5/16"	4
50025-16	CAP SCREW	1/4" x 1-3/4"	2
50025-17	FLANGE BOLT	1/4" x 1/2"	32
50025-18	SPACER / BUSHING	Ø 8.5 x Ø 18 x 3.8 T	4
50025-19	HEX NUT	1/4"	32
50025-20	LOCK NUT	1/4"	2
50025-21	HEX NUT	1/2"	2
50025-22	LOCK WASHER	1/2"	2
50025-23	HEX NUT	3/8"	2

50-025



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IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.