



**INSTALLATION / OPERATION**

**MANUAL**

# Woodshop TOOL ST-1530 APPRENTICE

## Limited Warranty Statement

Woodshop Tool warrants each new ST-1530 Apprentice product to be free from defects in material and workmanship. This warranty is applicable only for the normal service life expectancy of the product or components, not to exceed 6 consecutive months from date of purchase.

Genuine ST-1530 Apprentice parts and components will be warrantied for 30 days from date of purchase.

Our obligation under this warranty shall be limited to repairing or replacing, free of charge to the original purchaser, any part that, in our judgment, shall show evidence of such defect, provided further that such part, is so requested shall be returned within (30) days from date of failure to Woodshop Tool. Under no circumstances will it cover any merchandise or components thereof, which, in the opinion of the company, have been subject to misuse, unauthorized modification, alteration and accident, or if repairs have been made with parts other than those approved by Woodshop Tool. Shipping charges for returned items shall be paid by the user. This warranty shall not interpret to render Woodshop Tool or dealer liable for injury or damages of any kind or nature to person or property. This warranty does not extend to the loss of material, loss because of delay in job, or any expense or loss incurred for labor, substitute machinery, rental or for any other reason. Except as set forth above, Woodshop Tool shall have no obligation or liability of any kind on account of any of its equipment and shall not be liable for special or consequential damages.

*Woodshop Tool reserves the right to change specifications  
as we strive to achieve better quality equipment.*

# Woodshop TOOL ST-1530 APPRENTICE

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MODEL# ST-1530AP

# Woodshop TOOL ST-1530 APPRENTICE

## Safety Information

Woodworking machines are dangerous and can cause personal injury if not used properly.

Read safety instructions and operating instructions for your machine completely before installing the ST-1530. Using this system before understanding its safe and proper use could result in severe injury to the operator.

***For your own safety, read or watch instruction manual before operating the ST-1530.*** Learn the tool's application and limitations as well as the specific hazards distinctive to it.

Keep all guards and safety devices on your machine in the proper place while using this product.

Always wear proper Personal Protective Equipment.

Keep hands away from rotating bit on your machine when operating the ST-1530.

Avoid awkward hand positions, where a sudden slip could cause contact with pinch points. Keep the proper footing and balance.

This system was designed for certain applications only. We strongly recommend that this system **NOT** be modified and/or used for any application other than that for which it was designed.

Be aware of kickbacks. Always use sharp bits. Keep the tool aligned and maintained properly. Follow operating procedures.

Turn your machine off before adjusting. Never adjust the fence, plate position, or any other part of the ST-1530 while the machine is running. Wait for the machine to come to a complete stop.

Use the right tool, never 'force' the ST-1530 to do work for which it was not intended. If used properly the St-1530 will produce better results in less time, under safer conditions.

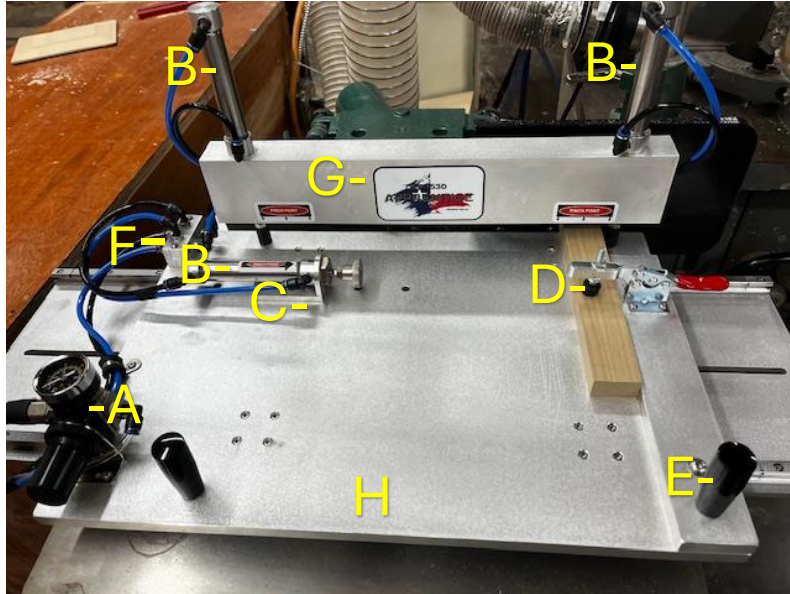
Maintain tools top condition. Keep clean, and properly maintained for highest quality and safest performance. Remember to follow all lubrication and maintenance practices in this instruction manual.

Check for damaged parts before use of the ST-1530, a careful assessment of all guards and other parts should be made to ensure that it will operate properly and perform as intended. Check for alignment of moving parts, binding of moving parts, breakage of parts, tightness of mounting hardware, and any other conditions that may affect its operation. A guard or other part should be repaired or replaced as soon as possible, preceding any additional use.

Keep children and visitors away, or at a safe distance. Never leave a running machine unattended.

# Woodshop TOOL ST-1530 APPRENTICE

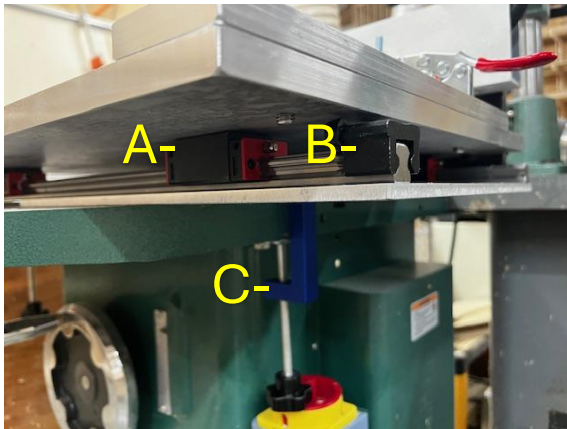
## Specifications and Features



- A-Pressure regulator**
- B-Air Cylinder**
- C-Adjustable cylinder mount**
- D-Toggle clamp**
- E-Conical Handles**
- F-Air manifold**
- G-Clamp bar**
- H- Aluminum slide table**

13 ½ clamping width, 1 ¼ clamping height. 50-60 psi recommended operating pressure.

27-48 ½, rail plate adjustment width to fit most machines.

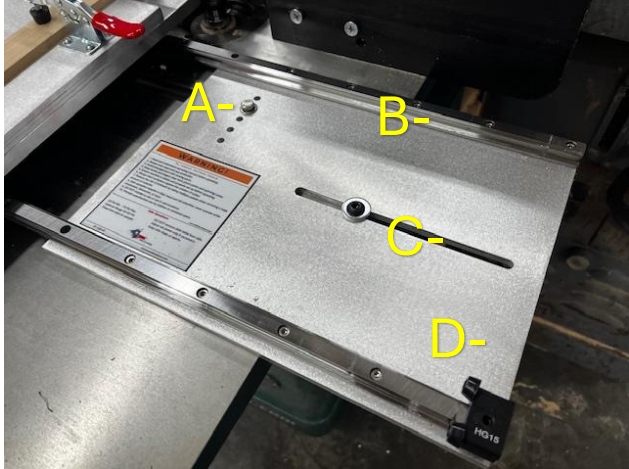


- A-HG15 Carriage blocks**
- B-Rubber stop blocks**
- C-Rail plate to machine clamp**

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# Woodshop TOOL ST-1530 APPRENTICE

## Specifications and Features



**A- Miter slot Index pin for quick placement of tool and distance adjustment of slide table to cutter.**

**B- Linear rail for smooth sliding**

**C- Slot for hold down**

**D- Adjustable Aluminum rail plates for wider machine widths**



**Locking 5-way foot valve with cover.**

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# Woodshop TOOL ST-1530 APPRENTICE

## Installation Instructions

**It is highly recommended you watch the installation video at [www.woodshoptool.com](http://www.woodshoptool.com)**

**a:** Remove the ST-1530 from the box, carefully unwrap each piece, inspect for damage.

**a-2:** Remove the two G clamps from the rail plates that secure the tool for transport, keep all hardware for each piece.

**b:** Before placing the ST-1530 on your machine install your preferred cutter and line up your fence with the cutter bearing or rubcollar, and parallel with miter slot. Cut a test board out of your rail material 10-12 inches long and run board thru you machine to insure allignment, when the allignment is correct **keep that board.** (*this will be your set up board*)

*Do not connect to air until step K and the ST-1530 is securly mounted. Leave the foot valve and hoses rolled up on the slide table.*

**c:** Lifting from the rail plates, place the ST-1530 on your machine by inserting the index pins into the miter slot. Double check the distance from the cutter to the slide table, to insure it is as close as possible without hitting the cutter.

*The St-1530 comes set at 31 ½ inches wide and on #2 miter slot Index pin. Index pin may be replaced with a ¼ -20 T-Slot nut if avalable on your machine.*

**c-2:** If adjustments need to be made to increase or decrease the distance from the cutter to the slide table, remove the ST-1530 from machine and sit on a stable surface. Remove the ¼ inch bolt (7/16 socket) from the Index pins on both of the rail plates, place in the preferred hole and tighten. Place back on machine and check distance (*reference c*)

**d:** Now that the cutter and fence have been installed and adjust, the Index pins on the ST-1530 have been adjusted and the ST-1530 has been placed back on your machine, Center the rail plates from side to side on your machine table.

### Mounting Method 1

**e:** Using the G clamps and harware from **a-2** Reverse the mounting direction from transport and hand tighten. With G clamps in place pull back on the plates at the same time to insure the index pins are snug against the miter slot.

**f:** Slide the G clamps against your machine table, and insure you have a proper place to tighten the hand nut and plate.

**g:** Proceed to tighten the G clamp to the rail plate and tighten the hand nuts.. Double check to make sure the clamp has gripped the bottom of the machine table. (a scrap piece of wood may be needed)

*Continue to next page....*

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## Installation Instructions

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### Optional Mounting Method

**h:** Using Mounting Method 1 you can also drill and tap a 5/16 hole into the machine table thru the slot in the rail plates or elsewhere on the plates. This would be for a permanent installation or for a quicker set up for a dual use machine.

*Always double check with manufacturer of your machine before modifying or drilling and tapping the table surface, this action may void warranty or damage machine surface.*

**i:** Now that the ST-1530 is securely mounted to your machine, unroll the air lines attached to the foot valve and straighten so the foot pedal sits flat on the floor.

*The ST-1530 ships in the open position with the regulator at 0*

**j:** At this point slide the St-1530 from side to side to insure smooth operating. Make sure the adjustable cylinder bracket is secure before proceeding to next step.

**k:** With the air line unrolled and foot valve on the floor connect your air to the ST-1530 air input hose and slowly increase the air pressure until the clamp bar lifts up, set pressure to at least 35psi min 70psi max (optimal setting is 50-60psi upon use.)

*You may have to adjust the hoses once you apply air.*

**l:** With step **k:** done press and lock then unlock the foot valve several times to insure proper function and that the regulator maintains your desired pressure.

*Always keep hands and fingers clear of the Air Cylinder operation*

**Now that you have installed the best way to cope your stick, its time to put it to work.**

Continue to next page.....



# Woodshop TOOL ST-1530 APPRENTICE

## Operating Instructions

### STEP 1 *Machine OFF*

With your machine off, and the ST-1530 in the open position slide tool fully to the right, insert your test board against the side stop and up to your fence, then adjust toggle clamp to hold your test board down, be sure its snug.

### STEP 2 *Machine OFF*

Release the toggle clamp and slide the ST-1530 so that the test board is close to the cutter. Raise your cutter to line up with your test board, slide the ST-1530 to the left, push test board up against the bearing or rub collar, and lock down the toggle clamp.

### STEP 3 *Machine OFF*

*At this point, if you have a split fence on your machine you can adjust the left fence to the back of the machine you do not need it for operation.*

Slide the ST-1530 to the right and adjust the fence if needed to keep your test board in place lined up with the bearing or rub collar. Once this is done, you are now in alignment and ready to work.

*(Minor adjustments may be needed, never use primary rail material to run your first cuts)*

### STEP 4 *Machine OFF*

Rip your test board to at least  $\frac{3}{4}$ -1  $\frac{1}{2}$  this will be your Tear Out Board TOB. With the ST-1530 in the right and open position insert the TOB back into the ST-1530 up against the side stop and machine fence. Clamp down the toggle clamp. *(make sure it's the same cutting position as your cutter)* Cut four boards 10-12 inches long out of your rail material.

### STEP 5 *Machine ON / WEAR SAFETY EQUIPMENT*

In the right and open position, insert your four boards against the TOB and up to your machine fence, adjust your table air cylinder so that it will stroke up against your boards.

*(When running less than four boards use a small piece of scrap under the left side of the clamp bar to evenly clamp down on stock.)*

Hold your boards up against the machine fence, watch your fingers and lock the foot valve this will operate the ST-1530 clamping your boards to the ST-1530 make sure they are snugly clamped. Increase pressure to your liking.

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# Woodshop TOOL ST-1530 APPRENTICE

## Operating Instructions

### **STEP 6** *Machine ON / WEAR SAFETY EQUIPMENT*

Using the handles slowly slide the ST-1530 to the left until you approach the cutter. Proceed into the cut with a consistent speed and pressure, careful not to bog down your machine, after a few cuts you will know how fast you can run boards through the cutter.

### **STEP 7** *Machine ON / WEAR SAFETY EQUIPMENT*

Once you have run your boards through the cutter, you will be in the left position. For best results release the foot valve, unclamping the ST-1530. Pull your boards back away from cutter path and slide the ST-1530 back to the right, do not unclamp the TOB. Inspect the test material for fitness adjust if needed if correct you are ready to run your primary rail material.

### **FINALLY**

Woodshop Tool does not recommend passing the coped boards back through the cutter head after cut.

Clamp on the right - run boards through

Unclamp on the left - pull boards back

Be sure to turn your boards and not flip them for the second pass.

Please watch the operational tips videos at [www.woodshoptool.com](http://www.woodshoptool.com) that cover tips on how to run small pieces, long pieces, maintenance and more.

**It is time to increase production and accuracy because time is MONEY!!**

**Thank you for your purchase.**

# Woodshop TOOL ST-1530 APPRENTICE

## Maintenance

Little maintenance is needed on the ST-1530 but it's always best to check a few things.

**Blow off the St-1530 before and after use.**

**Keep rails clean and apply a small amount of lithium grease monthly. Or use grease certs to inject.**

*To use grease certs, remove the collision blocks and slide the ST-1530 to the edge for access to the grease certs.*

**Double check clamps and all bolts and nuts after a few uses.**

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### CONTACT

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