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Professional

GTS 254

Robert Bosch Power Tools GmbH
70538 Stuttgart
GERMANY

www.bosch-pt.com

1 609 92A 72K (2025.09) PS / 29

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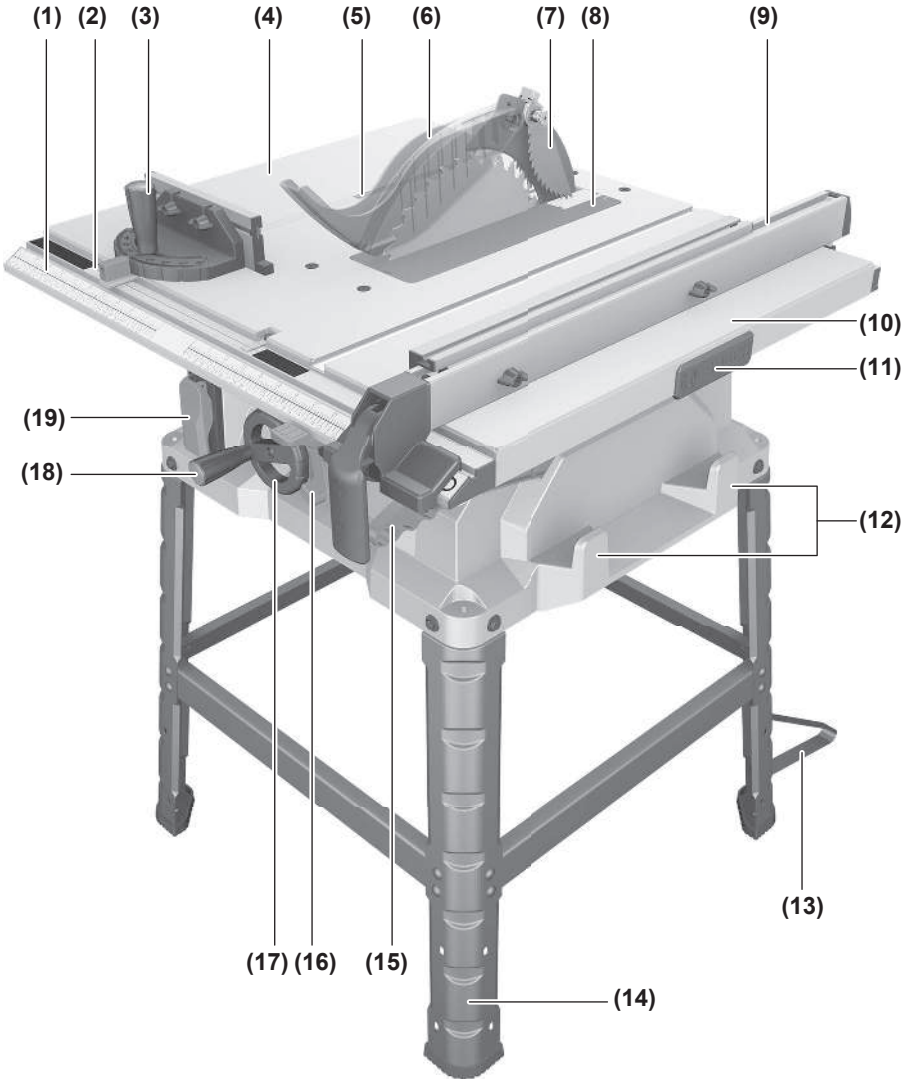
en Original instructions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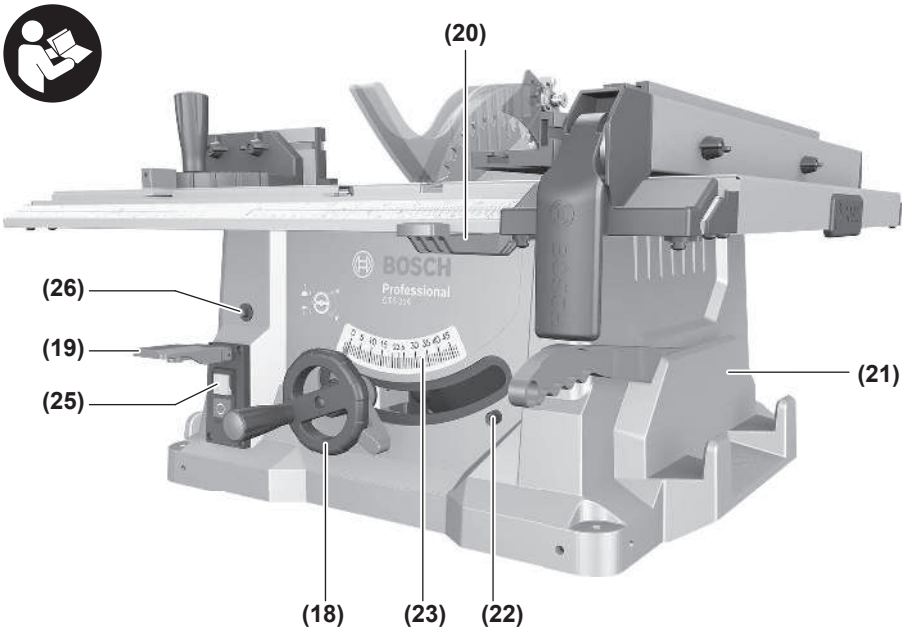
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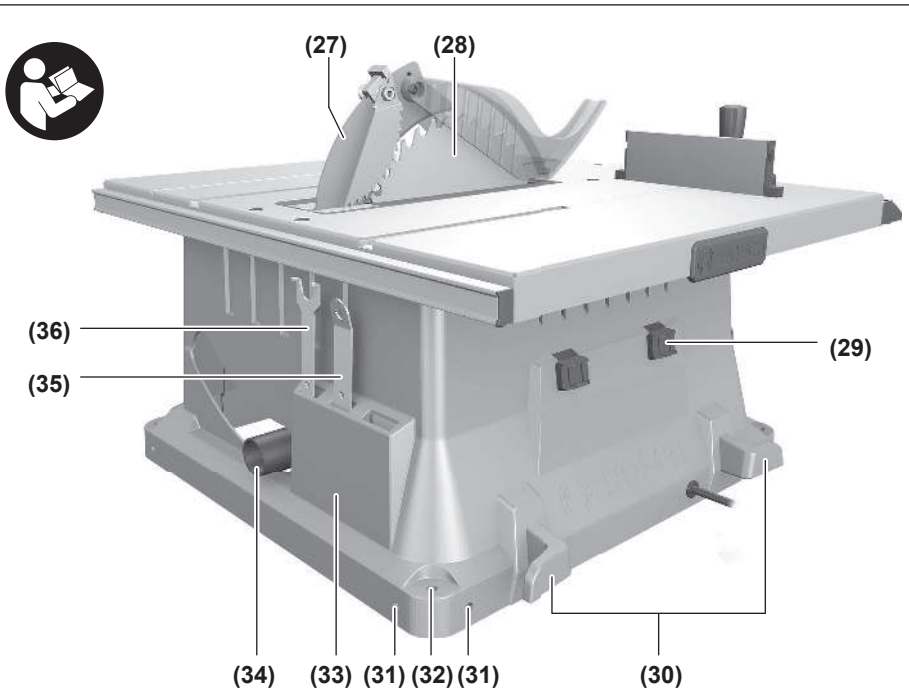
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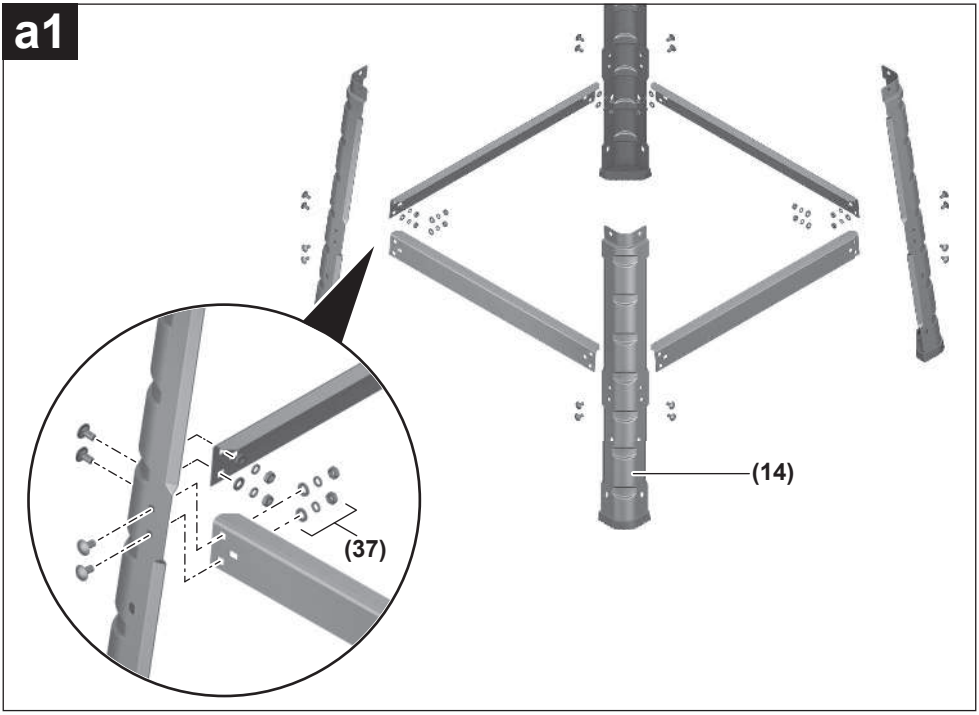
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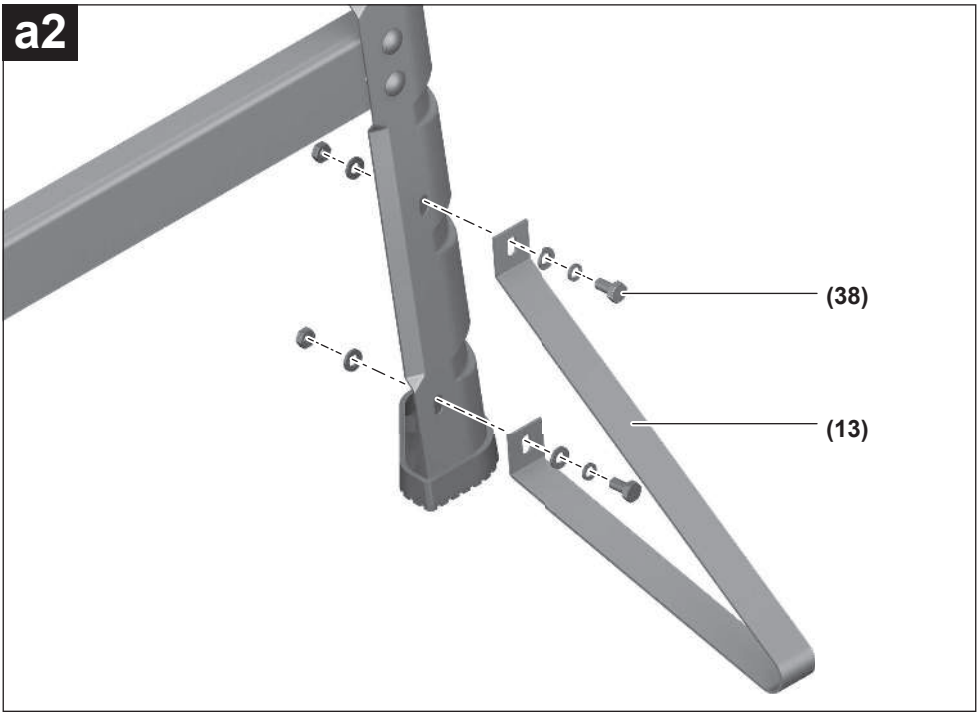
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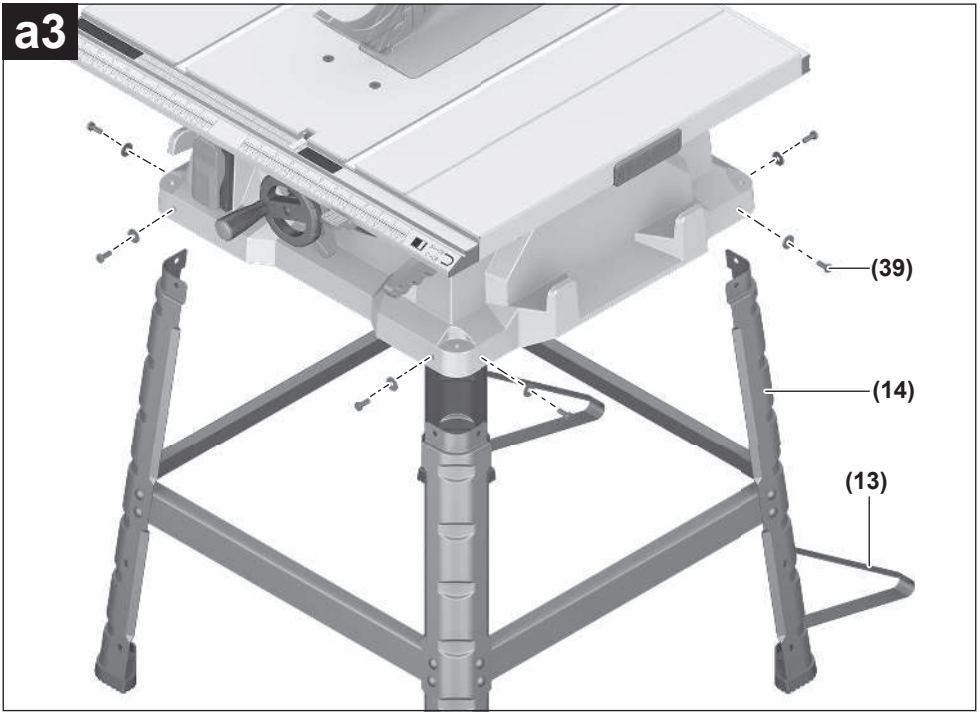
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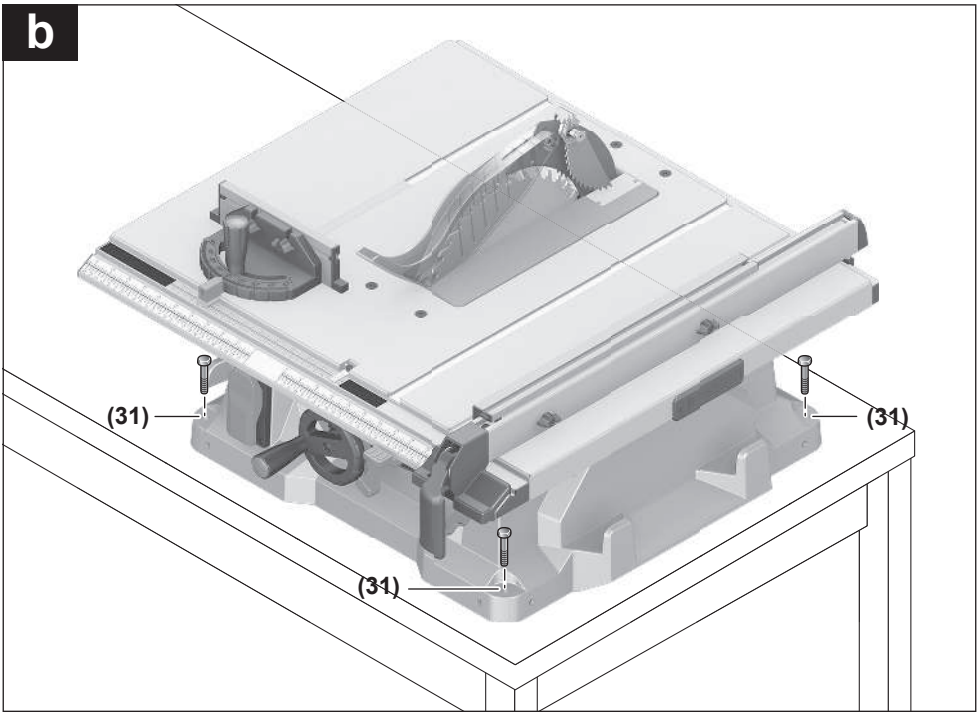
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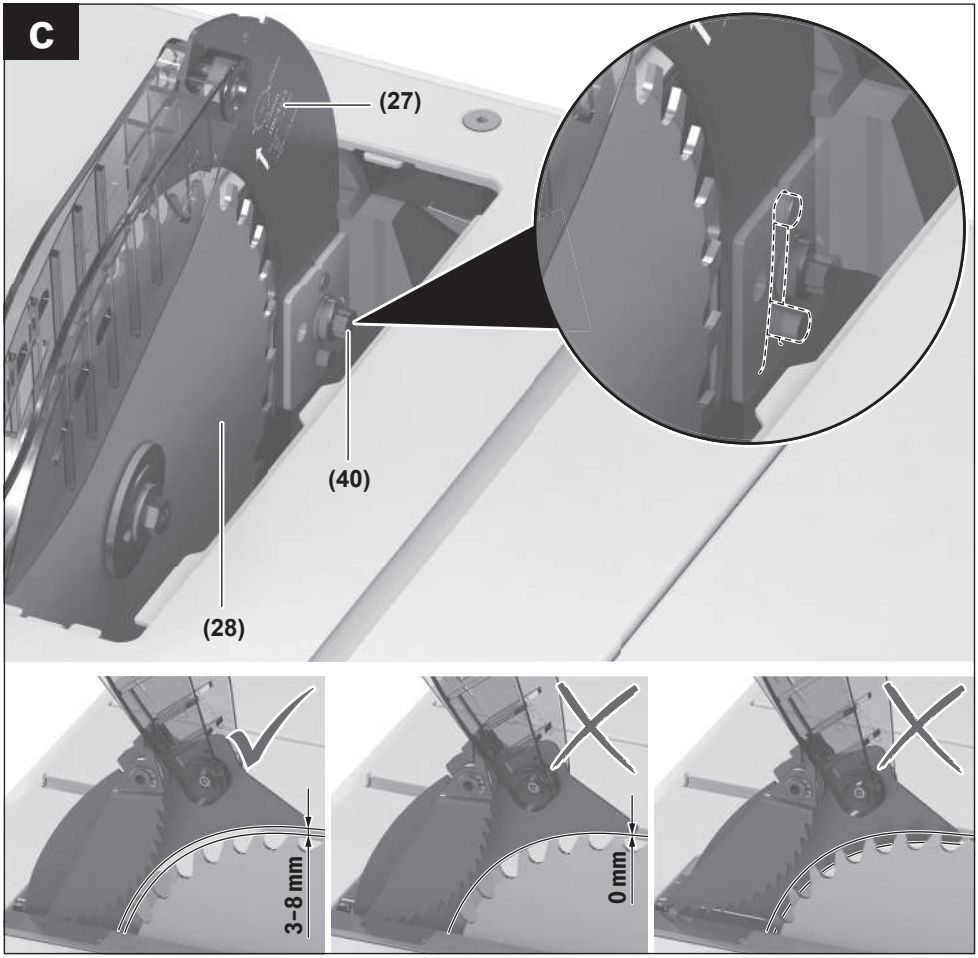
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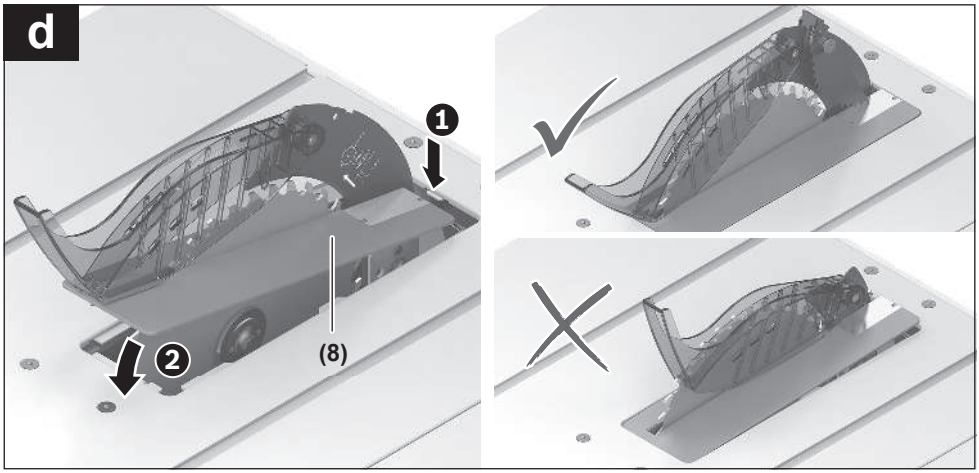
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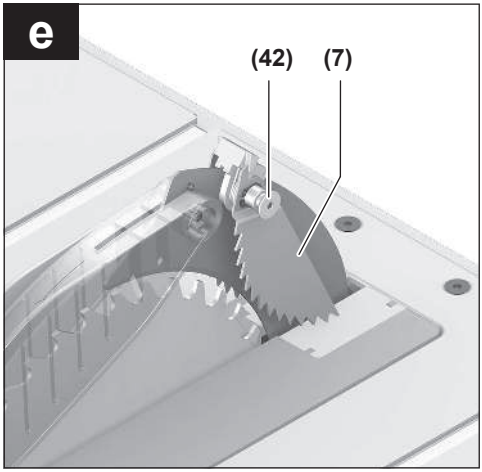
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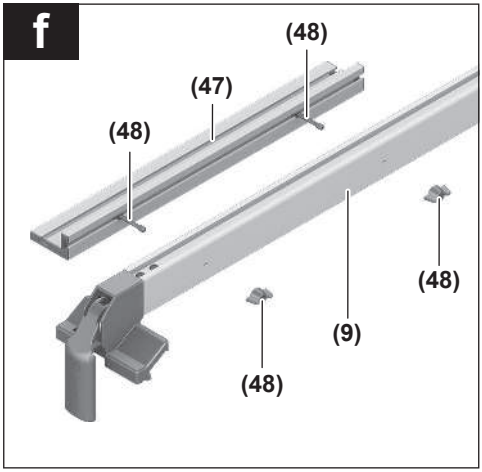
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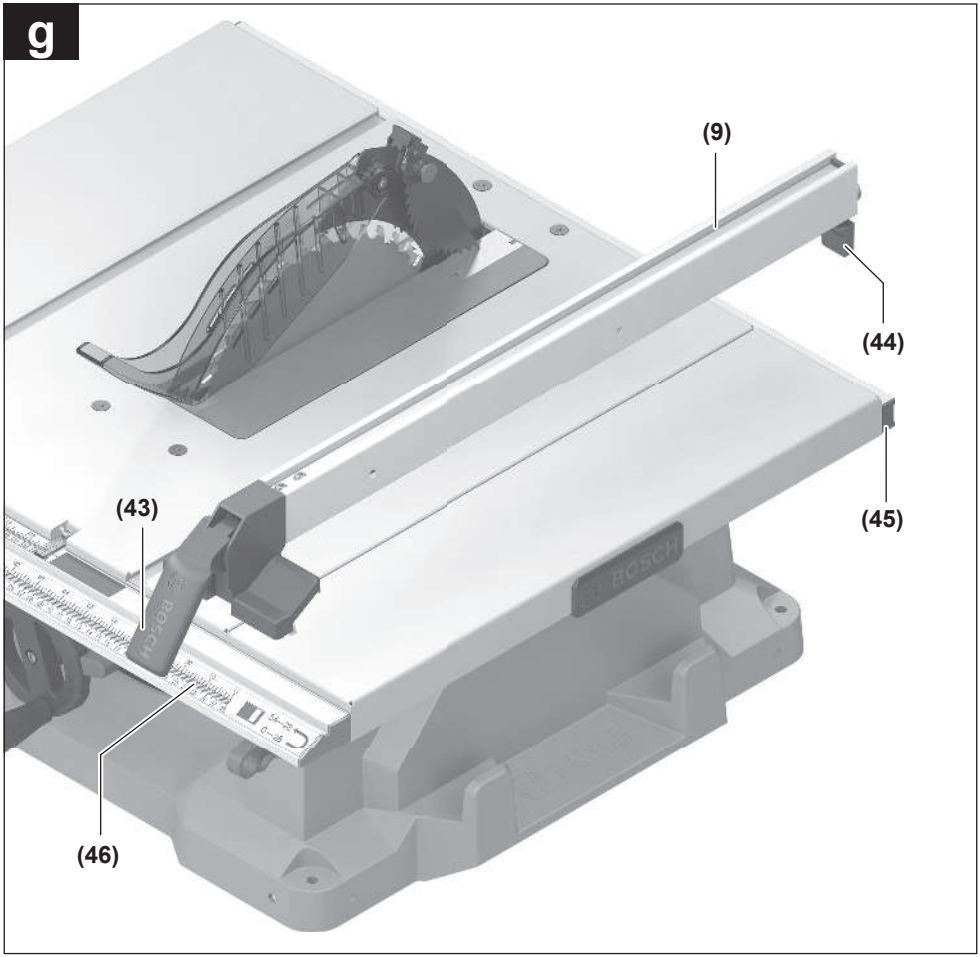
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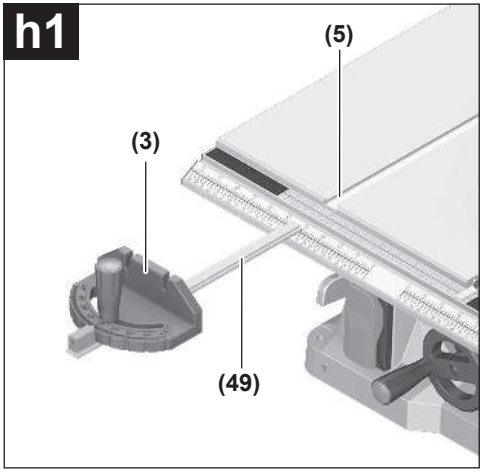

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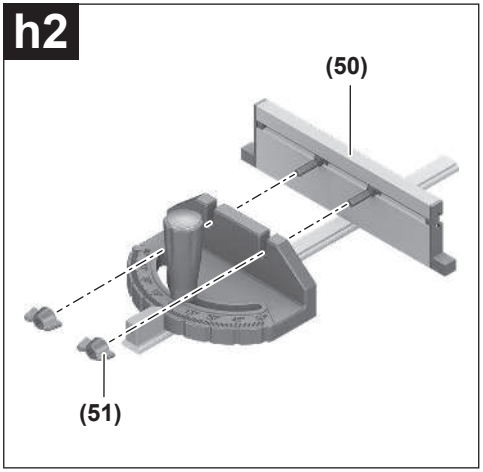

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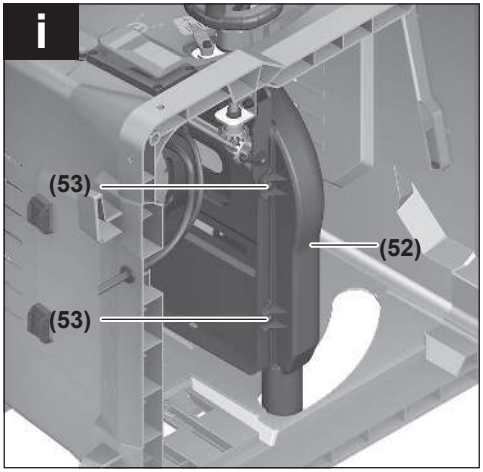

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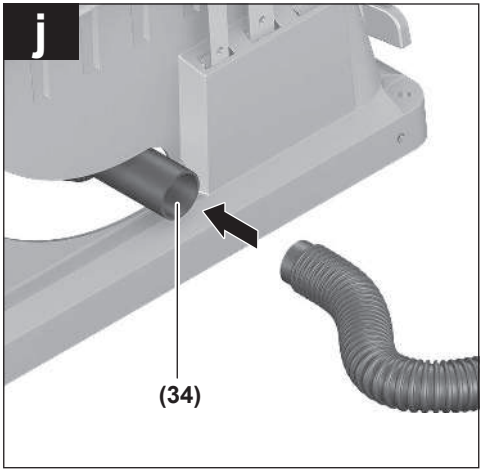

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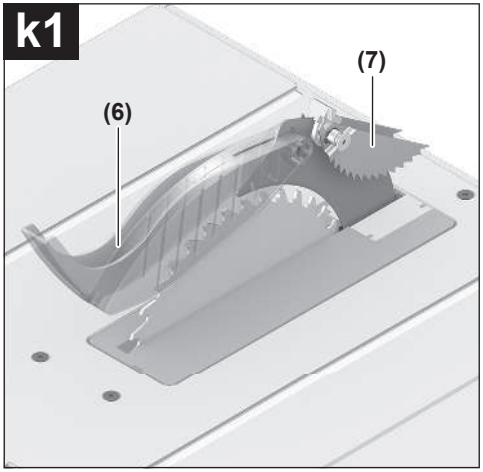

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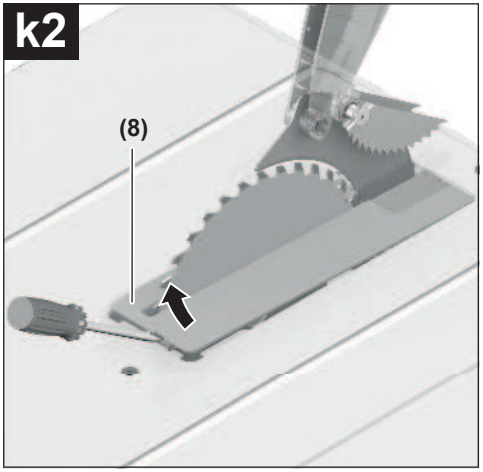

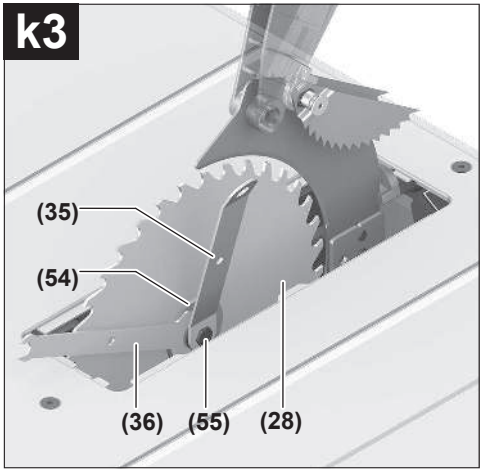
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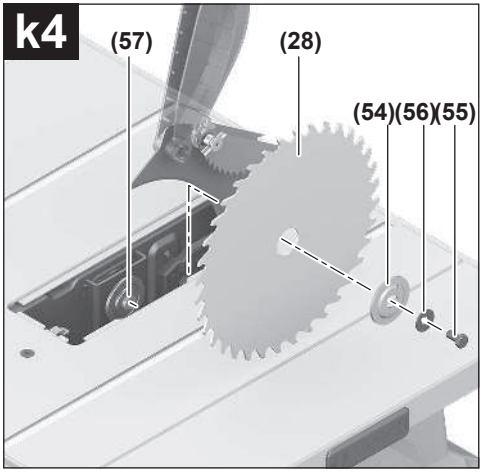
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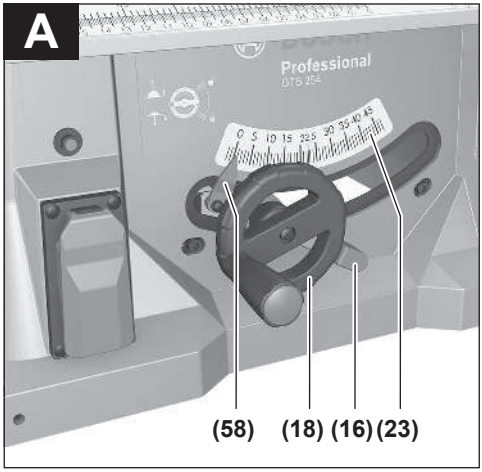
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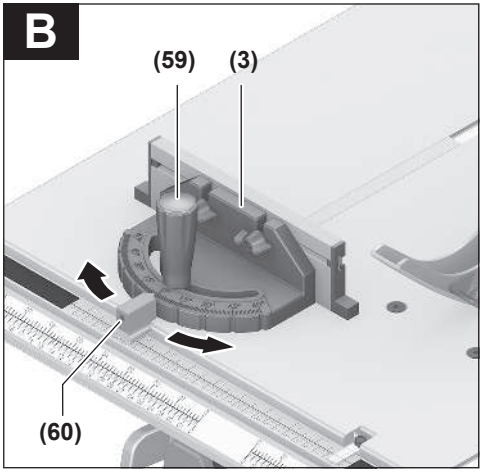
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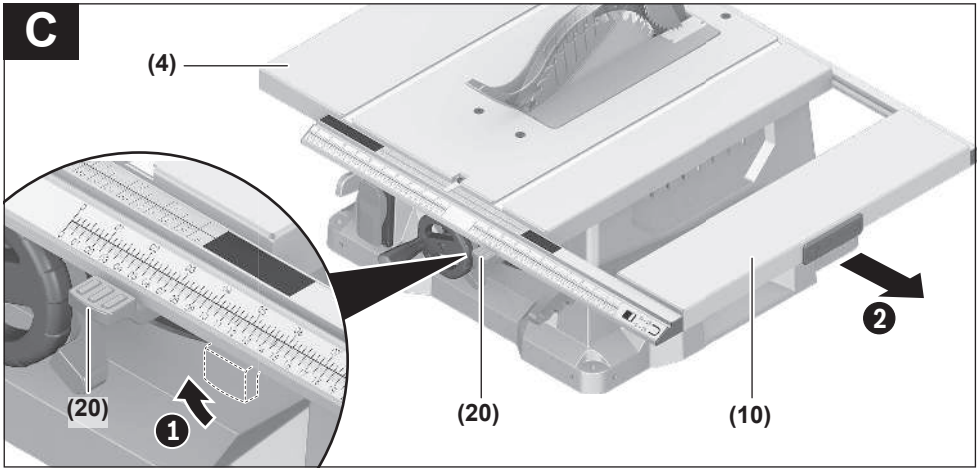
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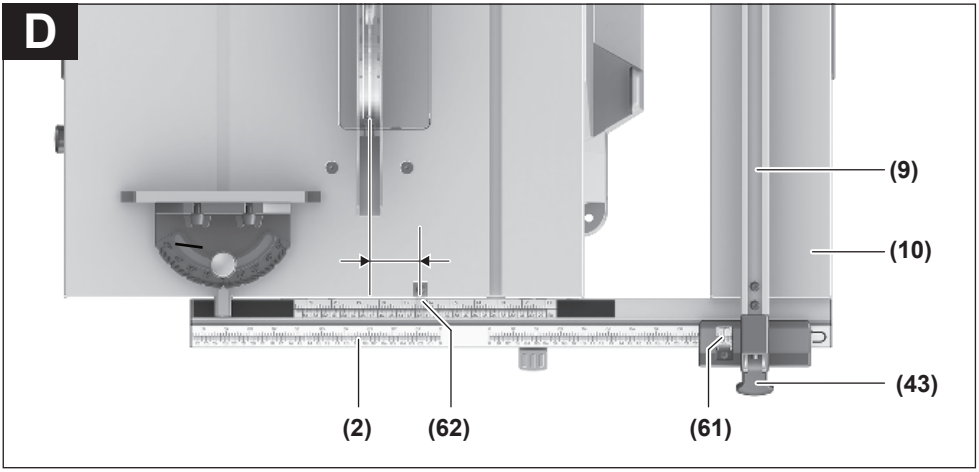

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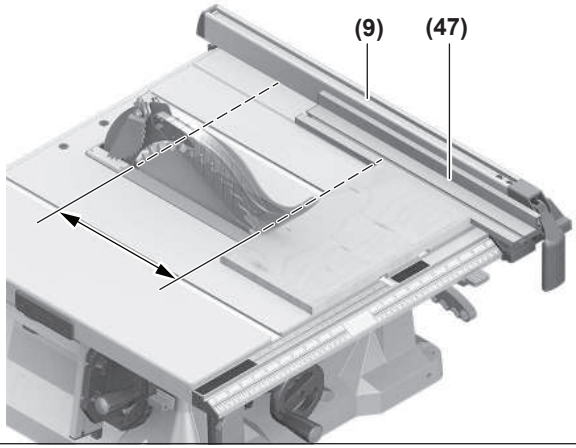

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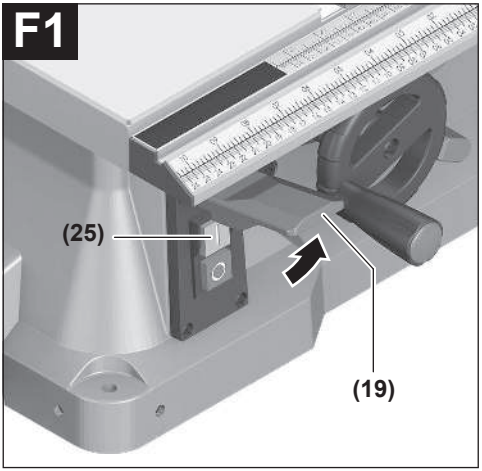

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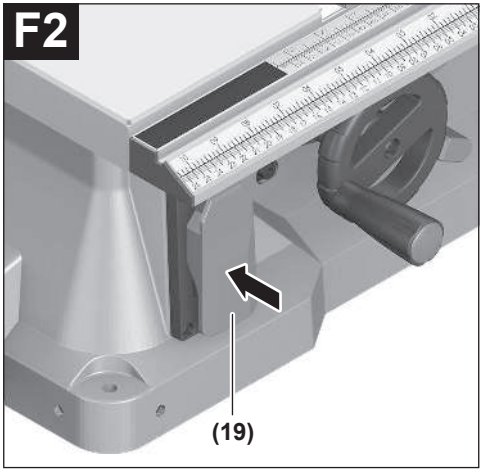

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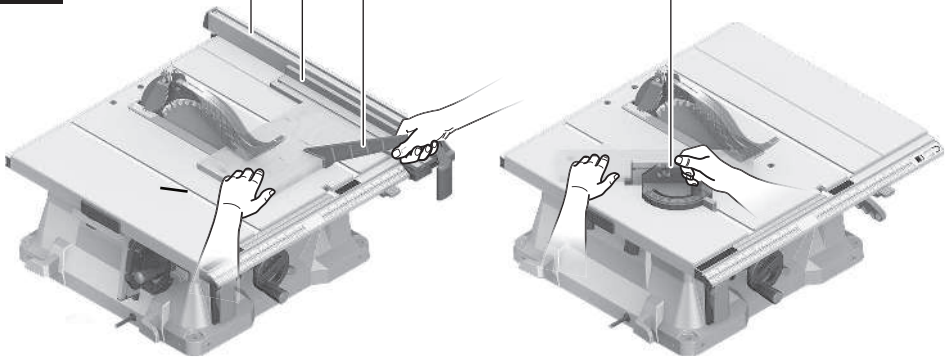

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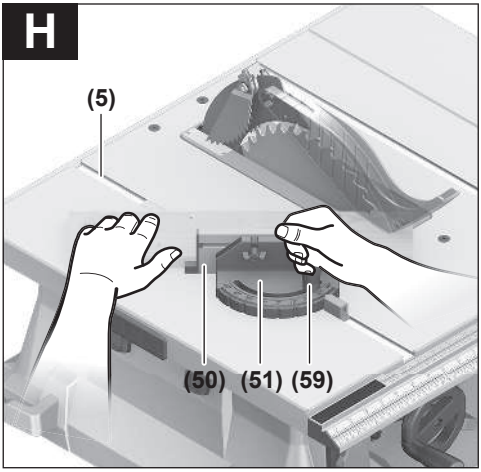

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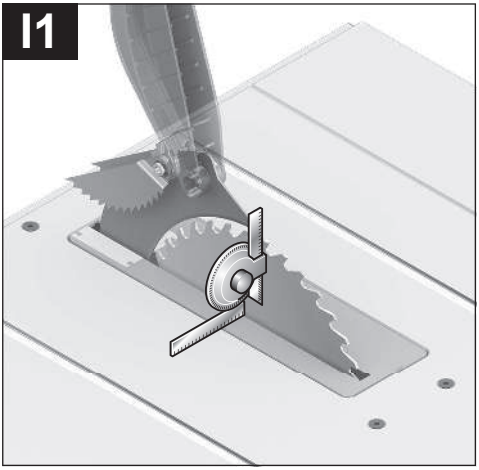

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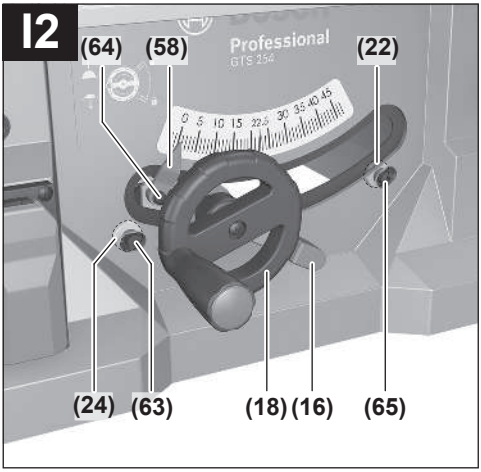

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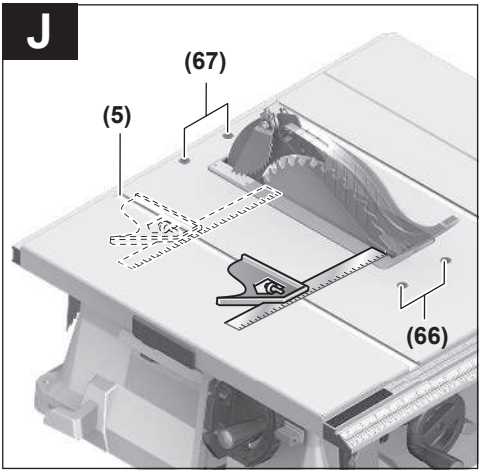

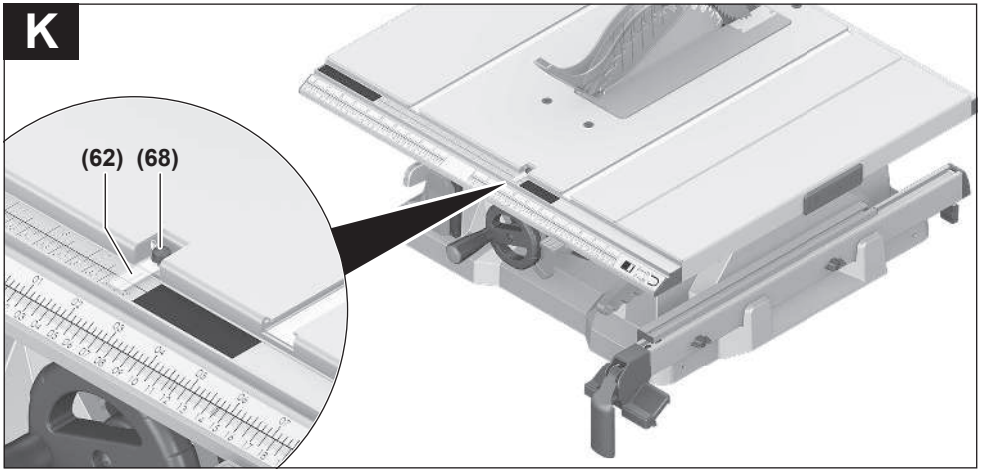
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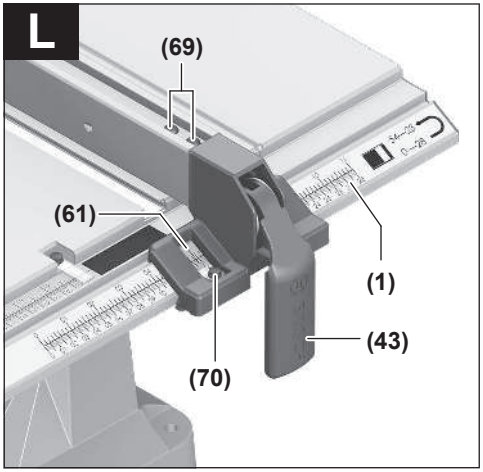
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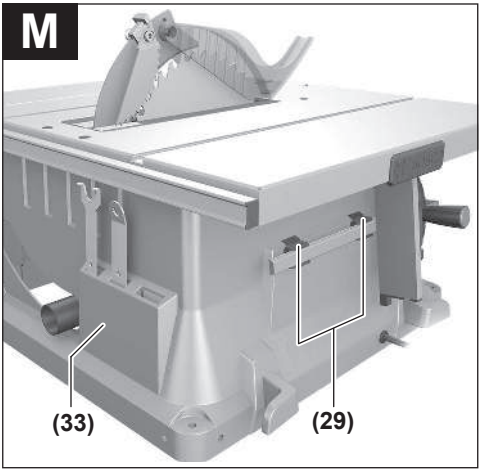
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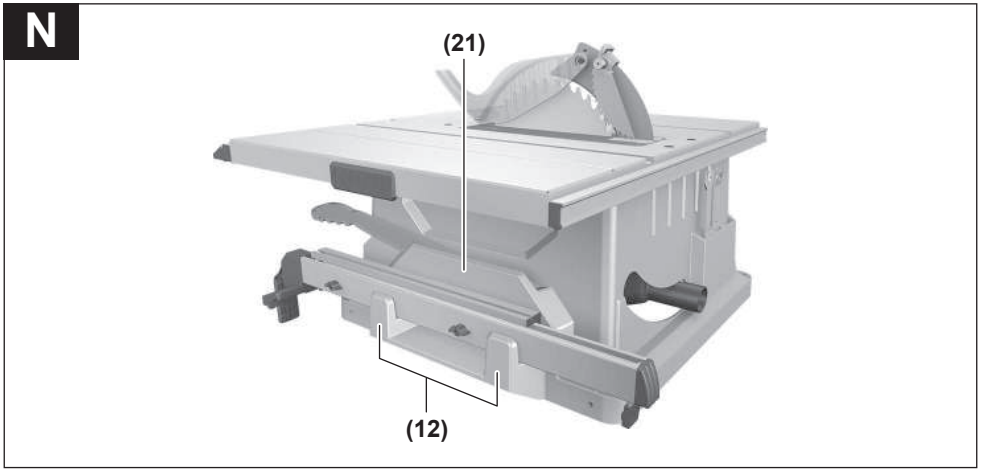
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English

Safety instructions

General Power Tool Safety Warnings

⚠ WARNING **Read all safety warnings, instructions, illustrations and specifications provided with this power tool.** Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

Work area safety

- **Keep work area clean and well lit.** Cluttered or 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.

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.
- **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.

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 personal protective equipment. Always wear eye protection.** Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising 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 and clothing 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 dust collection can reduce dust-related hazards.
- **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.

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 and/or remove the battery pack, if detachable, from the power tool 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 and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's 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, 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.
- ▶ **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

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.

Safety instructions for table saws

Guarding related warnings

- ▶ **Keep guards in place. Guards must be in working order and be properly mounted.** A guard that is loose, damaged, or is not functioning correctly must be repaired or replaced.
- ▶ **Always use saw blade guard, riving knife and anti-kickback device for every through–cutting operation.** For through-cutting operations where the saw blade cuts completely through the thickness of the workpiece, the guard and other safety devices help reduce the risk of injury.
- ▶ **After completing a non-through cut such as rabbeting, restore the riving knife to the extended-up position. With the riving knife in the extended-up position, reattach the blade guard and the anti-kickback device.** The guard, riving knife, and anti-kickback device help to reduce the risk of injury.
- ▶ **Make sure the saw blade is not contacting the guard, riving knife or the workpiece before the switch is turned on.** Inadvertent contact of these items with the saw blade could cause a hazardous condition.
- ▶ **Adjust the riving knife as described in this instruction manual.** Incorrect spacing, positioning and alignment can make the riving knife ineffective in reducing the likelihood of kickback.
- ▶ **For the riving knife and anti-kickback device to work, they must be engaged in the workpiece.** The riving knife and anti-kickback device are ineffective when cutting workpieces that are too short to be engaged with the riving knife and anti-kickback device. Under these conditions, a kickback cannot be prevented by the riving knife and anti-kickback device.
- ▶ **Use the appropriate saw blade for the riving knife.** For the riving knife to function properly, the saw blade diameter must match the appropriate riving knife and the body of the saw blade must be thinner than the thickness of the riving knife and the cutting width of the saw blade must be wider than the thickness of the riving knife.

Cutting procedures warnings

- ▶ **DANGER: Never place your fingers or hands in the vicinity or in line with the saw blade.** A moment of inattention or a slip could direct your hand towards the saw blade and result in serious personal injury.
- ▶ **Feed the workpiece into the saw blade only against the direction of rotation.** Feeding the workpiece in the same direction that the saw blade is rotating above the table may result in the workpiece, and your hand, being pulled into the saw blade.
- ▶ **Never use the mitre gauge to feed the workpiece when ripping and do not use the rip fence as a length stop when cross cutting with the mitre gauge.** Guiding the workpiece with the rip fence and the mitre gauge at the same time increases the likelihood of saw blade binding and kickback.
- ▶ **When ripping, always keep the workpiece in full contact with the fence and always apply the workpiece feeding force between the fence and the saw blade. Use a push stick when the distance between the fence and the saw blade is less than 150 mm, and use a push block when this distance is less than 50 mm.** "Work helping" devices will keep your hand at a safe distance from the saw blade.
- ▶ **Use only the push stick provided by the manufacturer or constructed in accordance with the instructions.** This push stick provides sufficient distance of the hand from the saw blade.
- ▶ **Never use a damaged or cut push stick.** A damaged or cut push stick may break causing your hand to slip into the saw blade.
- ▶ **Do not perform any operation "freehand". Always use either the rip fence or the mitre gauge to position and guide the workpiece.** "Freehand" means using your hands to support or guide the workpiece, in lieu of a rip fence or mitre gauge. Freehand sawing leads to misalignment, binding and kickback.
- ▶ **Never reach around or over a rotating saw blade.** Reaching for a workpiece may lead to accidental contact with the moving saw blade.
- ▶ **Provide auxiliary workpiece support to the rear and/or sides of the saw table for long and/or wide workpieces to keep them level.** A long and/or wide workpiece has a tendency to pivot on the table's edge, causing loss of control, saw blade binding and kickback.
- ▶ **Feed the workpiece at an even pace. Do not bend, twist or shift the workpiece from side to side. If jamming occurs, turn the tool off immediately, unplug the tool, then clear the jam.** Jamming the saw blade by the workpiece can cause kickback or stall the motor.
- ▶ **Do not remove pieces of cut-off material while the saw is running.** The material may become trapped between the fence or inside the saw blade guard and the saw blade pulling your fingers into the saw blade. Turn the saw off and wait until the saw blade stops before removing material.

- **Use an auxiliary fence in contact with the table top when ripping workpieces less than 2 mm thick.** A thin workpiece may wedge under the rip fence and create a kickback.

Kickback causes and related warnings

Kickback is a sudden reaction of the workpiece due to a pinched, jammed saw blade or misaligned line of cut in the workpiece with respect to the saw blade or when a part of the workpiece binds between the saw blade and the rip fence or other fixed object.

Most frequently during kickback, the workpiece is lifted from the table by the rear portion of the saw blade and is propelled towards the operator.

Kickback is the result of saw misuse and/or incorrect operating procedures or conditions and can be avoided by taking proper precautions as given below.

- **Never stand directly in line with the saw blade. Always position your body on the same side of the saw blade as the fence.** Kickback may propel the workpiece at high velocity towards anyone standing in front and in line with the saw blade.
- **Never reach over or in back of the saw blade to pull or to support the workpiece.** Accidental contact with the saw blade may occur or kickback may drag your fingers into the saw blade.
- **Never hold and press the workpiece that is being cut off against the rotating saw blade.** Pressing the workpiece being cut off against the saw blade will create a binding condition and kickback.
- **Align the fence to be parallel with the saw blade.** A misaligned fence will pinch the workpiece against the saw blade and create kickback.
- **Use a featherboard to guide the workpiece against the table and fence when making non-through cuts such as rabbeting.** A featherboard helps to control the workpiece in the event of a kickback.
- **Support large panels to minimise the risk of saw blade pinching and kickback.** Large panels tend to sag under their own weight. Support(s) must be placed under all portions of the panel overhanging the table top.
- **Use extra caution when cutting a workpiece that is twisted, knotted, warped or does not have a straight edge to guide it with a mitre gauge or along the fence.** A warped, knotted, or twisted workpiece is unstable and causes misalignment of the kerf with the saw blade, binding and kickback.
- **Never cut more than one workpiece, stacked vertically or horizontally.** The saw blade could pick up one or more pieces and cause kickback.
- **When restarting the saw with the saw blade in the workpiece, centre the saw blade in the kerf so that the saw teeth are not engaged in the material.** If the saw blade binds, it may lift up the workpiece and cause kickback when the saw is restarted.
- **Keep saw blades clean, sharp, and with sufficient set. Never use warped saw blades or saw blades with cracked or broken teeth.** Sharp and properly set saw blades minimise binding, stalling and kickback.

Table saw operating procedure warnings

- **Turn off the table saw and disconnect the power cord when removing the table insert, changing the saw blade or making adjustments to the riving knife, anti-kickback device or saw blade guard, and when the machine is left unattended.** Precautionary measures will avoid accidents.
- **Never leave the table saw running unattended. Turn it off and don't leave the tool until it comes to a complete stop.** An unattended running saw is an uncontrolled hazard.
- **Locate the table saw in a well-lit and level area where you can maintain good footing and balance. It should be installed in an area that provides enough room to easily handle the size of your workpiece.** Cramped, dark areas, and uneven slippery floors invite accidents.
- **Frequently clean and remove sawdust from under the saw table and/or the dust collection device.** Accumulated sawdust is combustible and may self-ignite.
- **The table saw must be secured.** A table saw that is not properly secured may move or tip over.
- **Remove tools, wood scraps, etc. from the table before the table saw is turned on.** Distraction or a potential jam can be dangerous.
- **Always use saw blades with correct size and shape (diamond versus round) of arbour holes.** Saw blades that do not match the mounting hardware of the saw will run off-centre, causing loss of control.
- **Never use damaged or incorrect saw blade mounting means such as flanges, saw blade washers, bolts or nuts.** These mounting means were specially designed for your saw, for safe operation and optimum performance.
- **Never stand on the table saw, do not use it as a stepping stool.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
- **Make sure that the saw blade is installed to rotate in the proper direction. Do not use grinding wheels, wire brushes, or abrasive wheels on a table saw.** Improper saw blade installation or use of accessories not recommended may cause serious injury.

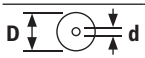
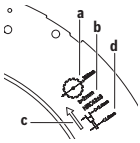
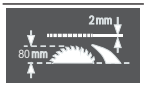
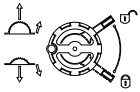
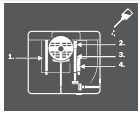
Additional safety warnings

- **When mounting the saw blade, wear protective gloves.** This poses a risk of injury.
- **Do not use HSS saw blades.** Such saw blades can easily break.
- **Only use saw blades that match the specifications given in this operating manual and that are tested and marked in accordance with EN 847-1**
- **Never use the tool without the table insert. Replace table insert if defective.** Without flawless table inserts, injuries are possible from the saw blade.

- ▶ **Keep your work area clean.** Material mixtures are particularly hazardous. Light metal dust may catch fire or explode.
- ▶ **Choose the saw blade suited to the material you want to work on.**
- ▶ **Only use saw blades that are recommended by the power tool manufacturer and are suitable for using on the material you want to saw.**
- ▶ **Only advance the workpiece towards the saw blade when it is running.** Otherwise there is a risk of kickback occurring if the saw blade catches in the workpiece.
- ▶ **Products sold in GB only:**
  Your product is fitted with an BS 1363/A approved electric plug with internal fuse (ASTA approved to BS 1362). If the plug is not suitable for your socket outlets, it should be cut off and an appropriate plug fitted in its place by an authorised customer service agent. The replacement plug should have the same fuse rating as the original plug.
  The severed plug must be disposed of to avoid a possible shock hazard and should never be inserted into a mains socket elsewhere.

Symbols

The following symbols may be important for the operation of your power tool. Please take note of these symbols and their meaning. Correctly interpreting the symbols will help you to operate the power tool more effectively and safely.

Symbols and their meaning	
	**Keep hands away from the cutting area while the power tool is running.** Contact with the saw blade can lead to injuries.
	**Wear safety goggles.**
	**Wear hearing protection.** Exposure to noise can cause hearing loss.
	**Wear a dust mask.**
	Take note of the dimensions of the saw blade (saw blade diameter **D**, hole diameter **d**). The hole diameter **d** must match the tool spindle without play. If it is necessary to use reducers, ensure that the dimensions of the reducer are suitable for the base blade thickness and the saw blade hole diameter, as well as the tool spindle diameter. Wherever possible, use the reducers provided with the saw blade. The saw blade diameter **D** must match the information specified on the symbol. See also: "Dimensions of suitable saw blades" in the "Technical Data" section.
	**a** The saw blade must be no more than 254 mm in diameter. **b** The riving knife is 2 mm thick. **c** The direction arrow of the teeth (direction of the arrow on the saw blade) must match the direction of the arrow on the riving knife. **d** When changing the saw blade, make sure that the cutting width is no smaller than 2.4 mm and the base blade thickness is no larger than 1.8 mm. Otherwise, there is a risk that the riving knife will hook into the workpiece.
	The riving knife is 2 mm thick. The maximum possible workpiece height is 80 mm.
	**Left-hand side:** Indicates the direction of rotation of the crank for lowering (**transport position**) and raising (**work position**) the saw blade. **Right-hand side:** Indicates the position of the locking lever for securing the saw blade and setting the bevel angle (saw blade can be swivelled).
	Oil the power tool as necessary at the points indicated.
	Protection class II power tools are strengthened or double-insulated.
CE	The CE mark provides confirmation from the manufacturer that the power tool complies with the applicable EU Directives.

Product Description and Specifications

Read all the safety and general instructions. Failure to observe the safety and general instructions may result in electric shock, fire and/or serious injury.

Please observe the illustrations at the beginning of this operating manual.

Intended use

The power tool is a stationary machine for cutting in a straight line with and against the grain in hardwood, softwood, chipboard and fibreboard. Mitre angles of **–30°** to **+30°** as well as bevel angles of **0°** to **45°** are possible.

It is also possible to saw aluminium profiles and plastic using the appropriate saw blades.

Product features

The numbering of the product features refers to the diagram of the power tool on the graphics page.

(1) Scale for spacing between saw blade and parallel guide
(2) Scale for spacing between saw blade and parallel guide when the saw table is pulled out
(3) Angle guide
(4) Saw table
(5) Guide groove for angle guide
(6) Protective cover
(7) Anti-kickback pawls
(8) Table insert
(9) Parallel guide
(10) Saw table expansion
(11) Recessed handles
(12) Parallel guide storage compartment
(13) Tilt protector
(14) Base unit
(15) Push stick
(16) Locking lever for setting the vertical bevel angle
(17) Crank for raising and lowering the saw blade
(18) Hand wheel
(19) Safety flap for the on/off switch
(20) Saw table expansion clamping handle
(21) Push stick storage compartment
(22) Stop for 45° bevel angle (vertical)
(23) Scale for bevel angle (vertical)
(24) Stop for 0° bevel angle (vertical)
(25) On button
(26) Restart button
(27) Riving knife
(28) Saw blade
(29) Angle guide storage compartment
(30) Cable holder
(31) Mounting holes on base unit
(32) Assembly holes
(33) Tool/anti-kickback pawls storage compartment
(34) Dust extraction adapter
(35) Ring spanner (10 mm; 13 mm)
(36) Hook spanner/open-ended spanner (10 mm)
(37) "Base unit" fastening set
(38) "Tilt protector" fastening set
(39) "Power tool" fastening set
(40) Riving knife bolt
(41) Recesses for table insert
(42) Anti-kickback pawls push button
(43) Clamping handle for parallel guide
(44) V guide for parallel guide
(45) V guide groove on the saw table for the parallel guide
(46) Guide groove for parallel guide
(47) Additional parallel guide
(48) "Additional parallel guide" fastening set
(49) Guide rail for angle guide
(50) Profile rail
(51) Profile rail wing nut
(52) Lower saw blade cover
(53) Fastening screws for lower saw blade cover
(54) Clamping flange
(55) Saw blade hexagon screw
(56) Washer
(57) Mounting flange
(58) Angle indicator (vertical)
(59) Locking knob for various bevel angles (horizontal)
(60) Angle indicator on the angle guide
(61) Magnifying glass
(62) Saw table spacing indicator
(63) Cross-head screw for setting the 0° stop
(64) Screw for bevel angle indicator (vertical)
(65) Cross-head screw for setting the 45° stop
(66) Hex socket screws (5 mm) on the front for adjusting the parallelism of the saw blade
(67) Hex socket screws (5 mm) on the rear for adjusting the parallelism of the saw blade
(68) Screw for saw table spacing indicator
(69) Hex socket screws (5 mm) for adjusting the parallelism of the parallel guide
(70) Screw for parallel guide spacing indicator

Technical data

Table saw		**GTS 254**
Article number		**3 601 M45 0..**
Rated power input	W	1800
No-load speed	min^{-1}	4300

Table saw		GTS 254
Starting current limitation		●
Weight[A)]	kg	24.4
Protection class		⧈ / II
Dimensions (including detachable parts of the tool)		
Width x depth x height	mm	690 x 620 x 1000
Dimensions of suitable saw blades		
Saw blade diameter **D**	mm	254
Base blade thickness	mm	< 1.8
Min. tooth thickness/offset	mm	> 2.4
Hole diameter **d**	mm	30

A) Without mains connection cable

The specifications apply to a rated voltage [U] of 230 V. These specifications may vary at different voltages and in country-specific models.

Maximum workpiece dimensions: (see "Maximum workpiece dimensions", page 23)

Values can vary depending on the product, scope of application and environmental conditions. To find out more, visit www.bosch-professional.com/wac.

Noise information

Noise emission values determined according to **EN 62841-3-1**.

Typically, the A-weighted noise level of the power tool is: Sound pressure level **90** dB(A); sound power level **105** dB(A). Uncertainty K = **3** dB.

Wear hearing protection!

The noise emission value given in these instructions has been measured in accordance with a standardised measuring procedure and may be used to compare power tools. It may also be used for a preliminary estimation of noise emissions.

The noise emission value given represents the main applications of the power tool. However, if the power tool is used for other applications, with different application tools or is poorly maintained, the noise emission value may differ. This may significantly increase noise emissions over the total working period.

To estimate noise emissions accurately, the times when the tool is switched off, or when it is running but not actually being used, should also be taken into account. This may significantly reduce noise emissions over the total working period.

Assembly

▶ **Avoid starting the power tool unintentionally. The mains plug must not be connected to the power supply during assembly or when carrying out any kind of work on the power tool.**

Items included

Check to ensure that all the parts listed below have been supplied before using the power tool for the first time:

- Table saw with mounted saw blade **(28)**
- "Power tool" fastening set **(39)** (8 fastening screws, 8 washers)
- Base unit **(14)**
- "Base unit" fastening set **(37)** (16 fastening screws, 16 washers, 16 securing rings, 16 nuts)
- Tilt protector **(13)**
- "Tilt protector" fastening set **(38)** (4 fastening screws, 8 washers, 4 securing rings, 4 nuts)
- Angle guide **(3)**
- Profile rail **(50)**
- "Profile rail" wing nut **(51)**
- Parallel guide **(9)**
- Additional parallel guide **(47)**
- "Additional parallel guide" fastening set **(48)** (2 fastening screws, 2 wing nuts)
- Riving knife **(27)** with protective cover **(6)** fitted
- Anti-kickback pawls **(7)**
- Ring spanner **(35)**
- Hook spanner/open-ended spanner **(36)**
- Push stick **(15)**
- Table insert **(8)**

Note: Check the power tool for possible damage. Before continuing to use the power tool, carefully check that all protective devices or slightly damaged parts are working perfectly and according to specifications. Check that the moving parts are working perfectly and without jamming; check whether any parts are damaged. All parts must be fitted correctly and all the conditions necessary to ensure smooth operation must be met.
If the protective devices or any parts become damaged, you must have them properly repaired or replaced by an authorised service centre.

Stationary or flexible mounting

▶ **To ensure safe handling, the power tool must be mounted on a flat, stable work surface (e.g. work bench) before use.**

Assembly with base unit and tilt protector (see figures a1–a3)

For assembly, use the "base unit" **(37)**, "tilt protector" **(38)** and "power tool" **(39)** fastening sets

- Screw the base unit **(14)** together. Tighten the screws firmly.
- Screw the tilt protector **(13)** to the base unit.
- Place the power tool on the base unit so that the tilt protector points to the rear.
- Attach the power tool to the base unit. For this, use the lateral holes **(31)** of the power tool as well as the holes in the base unit.

Assembly without base unit (see figure b)

- Use a suitable screwed connection to secure the power tool to the work surface. The holes **(32)** are used for this purpose.

Fitting individual components

– Carefully remove all parts included in the delivery from their packaging.
– Remove all packing material from the power tool and the accessories provided.
– Make sure that you remove the packaging material beneath the motor block.

The following parts of the tool are attached directly to the housing: Anti-kickback pawls **(7)**, ring spanner **(35)**, hook spanner/open-ended spanner **(36)**, angle guide **(3)**, parallel guide **(9)**, additional parallel guide **(47)** with fastening set **(48)**, protective cover **(6)**, push stick **(15)**, saw blade **(28)**.

– If you require one of these parts, remove it carefully from its storage location.

Fitting the Riving Knife (see figure c)

Note: If necessary, clean all parts to be fitted before you position them.

– Remove the table insert **(8)** if necessary.
– Turn the crank **(17)** clockwise as far as possible so that the saw blade **(28)** is in the highest possible position above the saw table.
– Loosen the bolt **(40)** using the ring spanner **(35)**.
– Insert the riving knife **(27)** and push it down as far as possible.
The riving knife must be in contact with both guide pins (see magnified figure **c**).
– Re-tighten the bolt **(40)** using the ring spanner **(35)** (2.0–2.5 Nm torque).
Note: The radial clearance between the saw blade and the riving knife must not exceed 3–8 mm (max.). The riving knife must always be aligned with the saw blade.
– Fit the table insert **(8)**.

Fitting the Table Insert (see figure d)

– Hook the table insert **(8)** into the rear recesses **(41)** of the tool chamber.
– Guide the table insert down.
– Press down on the table insert until it engages in the front of the tool chamber.

The table insert must be completely flush with the saw table **(4)**, both at the front and at the back.

Fitting the anti-kickback pawls (see figure e)

In the event of a kickback, the anti-kickback pawls **(7)** prevent the workpiece from being flung towards the operator. The pawls' sharp teeth dig into the surface of the workpiece and hold it back.

– Press the anti-kickback pawls' **(7)** pushbutton **(42)** together.
This pulls back the guide pin.
– Guide the anti-kickback pawls **(7)** over the riving knife **(27)** and release the pushbutton **(42)**.
– Slide the anti-kickback pawls towards the protective cover until the guide pin engages in the rear hole at the top of the riving knife.
– Check that the guide pin is firmly connected to the hole and that the anti-kickback pawls are functioning properly. Carefully lift the anti-kickback pawls. When released, the spring-loaded pawls must go down and touch the table insert.

Fitting the additional parallel guide (see figure f)

To saw narrow workpieces and bevel angles, you must fit the additional parallel guide **(47)** on the parallel guide **(9)**. The additional parallel guide can be fitted on the left or right of the parallel guide **(9)** as required.

Use the "additional parallel guide" fastening set **(48)** (two fastening screws, two wing nuts) for fitting the guide.

– Slide the fastening screws through the lateral holes on the parallel guide **(9)**.
– The heads of the screws are used to guide the additional parallel guide.
– Slide the additional parallel guide **(47)** over the heads of the fastening screws.
– Tighten the screws using the wing nuts.

Fitting the parallel guide (see figure g)

The parallel guide **(9)** can be positioned on either the left or the right of the saw blade.

– Loosen the clamping handle **(43)** of the parallel guide **(9)**. This lightens the load on the V guide **(44)**.
– First insert the parallel guide with the V guide into the guide groove **(45)** of the saw table. Then position the parallel guide in the front guide groove **(46)** of the saw table. The parallel guide can now be moved freely.
– To secure the parallel guide, push the clamping handle **(43)** down.

Fitting the angle guide (see figure h1-h2)

– Push the rail **(49)** of the angle guide **(3)** into one of the guide grooves **(5)** provided in the saw table.

To make it easier to position long workpieces, the angle guide can be extended with the profile rail **(50)**.

– If necessary, fit the profile rail on the angle guide using the wing nuts **(51)**.

Dust/Chip Extraction

Do not perform work without taking dust-reducing measures. Using a suitable dust extraction attachment will reduce exposure to harmful dust. Provide good ventilation at the workplace. Always use suitable breathing protection. Use a dust extraction system that is suitable for the material wherever possible. The regulations on the materials being machined that apply in the country of use must be observed.

▶ **Avoid dust accumulation at the workplace.** Dust can easily ignite.

Requirements for the Dust Extractor		
Recommended hose nominal diameter	mm	**28**
Required vacuum pressure[A)]	mbar hPa	≥ **140** ≥ **140**

Requirements for the Dust Extractor		
Required flow rate[A]	l/s m^3/h	≥ **23** ≥ **82.8**
Recommended filter efficiency		Dust class M[B]

A) Power value at the power tool's dust extractor connection

B) According to IEC/EN 60335-2-69

Refer to the dust extractor's instructions. If there is reduced suction power, stop working and eliminate the cause.

The dust/chip extraction system can be blocked by dust, chips or fragments of the workpiece.

– Switch the power tool off and pull the mains plug out of the socket.
– Wait until the saw blade has come to a complete stop.
– Determine the cause of the blockage and eliminate it.

▶ **To prevent the risk of fire when sawing aluminium, empty the chip ejector and do not use chip extraction.**

Emptying the chip ejector (see figure i)

You can open the lower saw blade cover **(52)** to remove workpiece fragments and large chips.

– Switch the power tool off and pull the mains plug out of the plug socket.
– Wait until the saw blade has come to a complete stop.
– Tilt the power tool sideways.
– Loosen the fastening screws **(53)** and open the lower saw blade cover **(52)**.
– Remove workpiece fragments and chips.
– Close the lower saw blade cover and screw it back on.
– Bring the power tool into the work position.

External dust extraction (see figure j)

– Firmly insert a suitable dust extraction hose into the dust extraction adapter **(34)**.

The dust extractor must be suitable for the material being worked.

When extracting dry dust that is especially detrimental to health or carcinogenic, use a special dust extractor.

Changing the saw blade (see figures k1–k4)

▶ **Pull the plug out of the socket before carrying out any work on the power tool.**

▶ **When mounting the saw blade, wear protective gloves.** This poses a risk of injury.

▶ **Only use saw blades the maximum permitted speed of which is higher than the no-load speed of the power tool.**

▶ **Only use saw blades that match the specifications given in this operating manual and that are tested and marked in accordance with EN 847-1**

▶ **Only use saw blades that are recommended by the power tool manufacturer and are suitable for use on the material you want to saw.** This prevents the saw tooth tips from overheating and the plastic you want to saw from melting.

▶ **Do not use HSS saw blades.** Such saw blades can easily break.

Removing the saw blade

– Turn the crank **(17)** clockwise as far as possible so that the saw blade **(28)** is in the highest possible position above the saw table.
– Fold the protective cover **(6)** backwards.
– Use a screwdriver to lift the table insert **(8)** at the front and remove it from the tool chamber.
– Unscrew the hexagon screw **(55)** anticlockwise with the ring spanner **(35)** while holding the clamping flange **(54)** in place with the hook spanner **(36)**.
– Remove the washer **(56)** and the clamping flange **(54)**.
– Remove the saw blade **(28)**.

Fitting the saw blade

If required, clean all the parts you want to fit before installing them.

– Place the new saw blade on the mounting flange **(57)** of the tool spindle.

Note: Use sufficiently large saw blades. The radial clearance between the saw blade and the riving knife must not exceed 3–8 mm (max.).

▶ **When fitting the saw blade, make sure that the cutting direction of the teeth (arrow direction on the saw blade) matches the direction of the arrow on the protective cover.**

– Fit the clamping flange **(54)**, the washer **(56)** and the hexagon screw **(55)**.
– Tighten the hexagon screw **(55)** clockwise with the ring spanner **(35)** while holding the clamping flange in place with the hook spanner **(36)**.
– Reinsert the table insert **(8)**.
– Fold the protective cover **(6)** forwards.

Operation

▶ **Pull the plug out of the socket before carrying out any work on the power tool.**

Transport position and work position of the saw blade

Transport position

– Remove the protective cover **(6)**, remove the table insert **(8)** and place the riving knife **(27)** in the bottom position. Reinsert the table insert **(8)**.
– Turn the crank **(17)** anticlockwise until the teeth of the saw blade **(28)** lie below the saw table **(4)**.
– Push the saw table expansion **(10)** in fully. Push the clamping handle **(20)** down. This fixes the saw table expansion in place.
– Remove the protective cover **(6)**, remove the table insert **(8)** and place the riving knife **(27)** in the bottom position. Reinsert the table insert **(8)**.

– Turn the crank **(17)** anticlockwise until the teeth of the saw blade **(28)** lie below the saw table **(4)**.
– Move the guide rail fully in.
Push the clamping handle **(20)** down. This fixes the saw table expansion in place.

Work position

– Position the riving knife **(27)** in the top position directly over the centre of the saw blade, insert the table insert **(8)** and fit the protective cover **(6)**.
– Turn the crank **(17)** clockwise until the top teeth of the saw blade **(28)** are approx. 3–6 mm above the workpiece.

Setting mitre and bevel angles

To ensure precise cuts, the basic settings of the power tool must be checked and adjusted as necessary after intensive use.

Setting Bevel Angles (saw blade) (see figure A)

The bevel angle can be set between **0°** and **45°**.

– Loosen the locking lever **(16)** by turning it anticlockwise.

Note: When the locking lever is fully loosened, gravity causes the saw blade to tilt into a position that corresponds to approximately 30°.

– Pull or push the hand wheel **(18)** along the slotted link until the angle indicator **(58)** shows the required bevel angle.
– Hold the hand wheel in this position and retighten the locking lever **(16)**.

For quick and precise setting of the standard bevel angles of 0° and 45°, there are pre-set stops (**(24)**, **(22)**).

Setting mitre angles (angle guide) (see figure B)

The mitre angle can be set between **30°** (left-hand side) and **30°** (right-hand side).

– Loosen the locking knob **(59)** if it is tightened.
– Turn the angle guide until the angle indicator **(60)** shows the required mitre angle.
– Retighten the locking knob **(59)**.

Extending the saw table

The free end of long and heavy workpieces must have something placed underneath it or be supported.

Saw table expansion (see figure C)

The saw table expansion **(10)** increases the width of the saw table **(4)** on the right to a maximum of **950** mm.

– Pull the clamping handle **(20)** for the saw table expansion all the way up.
– Pull out the saw table expansion **(10)** to the required length.
– Push the clamping handle **(20)** down. This fixes the saw table expansion in place.

Adjusting the Parallel Guide (see figure D)

The parallel guide **(9)** can be positioned on the left or the right of the saw blade. The marking in the magnifying glass **(61)** indicates the set distance of the parallel guide to the saw blade on the scale **(1)**.
Position the parallel guide on the required side of the saw blade (see "Fitting the parallel guide (see figure **g**)", page 20).

Adjusting the parallel guide when the saw table is not pulled out

– Loosen the clamping handle **(43)** of the parallel guide **(9)**. Move the parallel guide until the marking in the magnifying glass **(61)** indicates the required distance from the saw blade.
When the saw table is not pulled out, the marking on the scale **(1)** applies.
– To secure it in place, push the clamping handle **(43)** back down.

Adjusting the parallel guide when the saw table is pulled out (see figure D)

– Position the parallel guide on the right of the saw blade. Move the parallel guide until the marking in the magnifying glass **(61)** shows **(1) 28** cm on the lower scale.
To secure it in place, push the clamping handle **(43)** back down.
– Pull the clamping handle **(20)** for the saw table expansion all the way up.
– Pull out the saw table expansion **(10)** until the spacing indicator **(62)** shows the required distance from the saw blade on the scale **(2)**.
– Push the clamping handle **(20)** down.
This fixes the saw table expansion in place.

Adjusting the additional parallel guide (see figure E)

To saw narrow workpieces and bevel angles, you must fit the additional parallel guide **(47)** on the parallel guide **(9)**.

The additional parallel guide can be fitted on the left or right of the parallel guide **(9)** as required.

When sawing, workpieces can become jammed between the parallel guide and the saw blade, caught in the saw blade as it rises and ejected.
You should therefore set the additional parallel guide so that the end of the guide is between the front tooth of the saw blade and the front edge of the riving knife.

– To do so, loosen all of the fastening set's wing nuts **(48)** and move the additional parallel guide accordingly.
– Retighten the wing nuts.

Start-up

▶ **Pay attention to the mains voltage.** The voltage of the power source must match the voltage specified on the rating plate of the power tool.

▶ **Products that are only sold in AUS and NZ:** Use a residual current device (RCD) with a nominal residual current of 30 mA or less.

Switching on (see figure F1)

– Fold up the safety flap **(19)**.
– To start, press the green "on" button **(25)** .
– Drop the safety flap **(19)** back down.

Switching off (see figure F2)

– Press the safety flap **(19)**.

Overload protection

The power tool is equipped with an overload protection system. In normal conditions of use, the power tool cannot be overloaded. In the event of overloading, the power tool automatically shuts off the electronics.

Follow these steps to restart the power tool:

– Allow the power tool to cool down for at least ten minutes.
– Press the restart button **(26)** and then switch the power tool back on.

Power outage

The on/off switch acts as a zero-voltage switch that prevents the power tool from starting up again following a power outage (e.g. if the mains plug is removed during operation). To restart the power tool following a power outage, press the green "on" button **(25)** again.

Practical advice

General sawing instructions

▶ **Before making any cuts, first make sure that the saw blade cannot come into contact with the stops or any other parts of the tool at any time.**

▶ **Only use the power tool for grooving or routing if a suitable protective guard (e.g. tunnel blade guard, featherboard) is in place.**

▶ **Do not use the power tool for cutting slots (stopped grooves).**

Protect the saw blade against impact and shock. Do not subject the saw blade to lateral pressure.

The riving knife must be aligned with the saw blade in order to prevent the workpiece from jamming.

Do not saw workpieces that have become bent or twisted out of shape. The workpiece must always have a straight edge to face against the parallel guide.

Always store the push stick on the power tool.

Position of the operator (see figure G)

▶ **Never stand directly in line with the saw blade. Always position your body on the same side of the saw blade as the fence.** Kickback may propel the workpiece at high velocity towards anyone standing in front and in line with the saw blade.

– Keep hands, fingers and arms away from the rotating saw blade.

Pay attention to the following instructions:

– Hold the workpiece firmly with both hands and press it securely against the saw table.
– When using narrow workpieces or sawing bevel angles, always use the push stick **(15)** provided.

Maximum workpiece dimensions

Bevel angle	max. height of the workpiece [mm]
0°	**80**
45°	**55**

Sawing

Making straight cuts

– Adjust the parallel guide **(9)** to the desired cutting width.
– Place the workpiece on the saw table in front of the protective cover **(6)**.
– Use the crank **(17)** to raise or lower the saw blade as far up or down as needed to position the top teeth of the saw blade **(28)** approx. 3–6 mm above the workpiece.
– Switch on the power tool.
– Saw through the workpiece applying uniform feed. If you apply too much pressure, the tip of the saw blade could overheat and damage the workpiece.
– Switch off the power tool and wait until the saw blade has come to a complete stop.

Sawing a bevel angle

– Set the required saw blade bevel angle. If the saw blade is tilted to the left, the parallel guide **(9)** must be to the right of the blade.
– Follow the work steps set out in the (see "Making straight cuts", page 23) section

Sawing mitre angles (see figure H)

– Set the required mitre angle on the angle guide **(3)**.
– Place the workpiece on the profile rail **(50)**. The profile must not be positioned along the cut line. If it is, loosen the wing nut **(51)** and reposition the profile rail.
– Use the crank **(17)** to raise or lower the saw blade as far up or down as needed to position the top teeth of the saw blade approx. 3–6 mm above the workpiece.
– Switch on the power tool.
– Hold the workpiece against the profile rail with one hand; place your other hand on the locking knob **(59)** and slide the angle guide slowly forwards in the guide groove **(5)**.
– Switch off the power tool and wait until the saw blade has come to a complete stop.

Checking and adjusting the basic settings

To ensure precise cuts, the basic settings of the power tool must be checked and adjusted as necessary after intensive use.

Experience and suitable special tools are required for this.

A Bosch after-sales service point will handle this work quickly and reliably.

Adjusting the stops for a standard bevel angle 0°/45°

– Bring the power tool into the work position.
– Set the saw blade to a bevel angle of 0°.

Checking (see figure I1)

– Set an angle gauge to 90° and place it on the saw table **(4)**.

The leg of the angle gauge must be flush with the saw blade **(28)** along its entire length.

Setting (see figure I2)

– Loosen the screw **(63)**. This enables the 0° stop **(24)** to be moved.
– Loosen the locking lever **(16)**.
– Slide the hand wheel **(18)** towards the 0° stop until the leg of the angle gauge is flush with the saw blade along its entire length.
– Hold the hand wheel in this position and retighten the locking lever **(16)**.
– Retighten the screw **(63)**.

If the angle indicator **(58)** is not aligned with the 0° mark on the scale **(23)** following adjustment, loosen the screw **(64)** using a conventional cross-headed screwdriver and align the angle indicator along the 0° mark.

Repeat the work step above for the bevel angle of 45° (loosen the screw **(65)**; move the 45° stop **(22)**). The angle indicator **(58)** must not be repositioned when doing this.

Parallelism of the Saw Blade with the Guide Grooves of the Angle Guide (see figure J)

– Bring the power tool into the work position.

Checking

– Use a pencil to mark the first left-hand saw tooth that is visible at the back above the table insert.
– Set an angle gauge to 90° and place it on the edge of the guide groove **(5)**.
– Move the leg of the angle gauge until it touches the marked saw tooth and read the distance between the saw blade and the guide groove.
– Turn the saw blade until the marked tooth at the front lies above the table insert.
– Move the angle gauge along the guide groove up to the marked saw tooth.
– Measure the distance between the saw blade and the guide groove again.

The two measured distances must be identical.

Setting

– Loosen the hex socket screws **(66)** at the front on the saw table and the hex socket screws **(67)** at the rear on the saw table using a hex key.
– Carefully move the saw blade until it lies parallel with the guide groove **(5)**.
– Retighten all screws **(66)** and **(67)**.

Adjusting the saw table spacing indicator (see figure K)

– Position the parallel guide on the right of the saw blade. Move the parallel guide until the marking in the magnifying glass **(61)** shows **28** cm on the lower scale. To secure it in place, push the clamping handle **(43)** back down.
– Pull the clamping handle **(20)** all the way up and pull the saw table expansion **(10)** out as far as possible.

Checking

The scale **(2)** of the spacing indicator **(62)** must show the same value as the marking in the magnifying glass **(61)** on the scale **(1)**.

Setting

– Pull the saw table expansion **(10)** out fully.
– Loosen the screw **(68)** with a cross-headed screwdriver and align the spacing indicator **(62)** along the **28** cm mark on the upper scale **(1)**.

Adjusting the Parallelism of the Parallel Guide (see figure L)

– Bring the power tool into the work position.
– Remove anti-kickback pawls **(7)** and fold the protective cover **(6)** backwards.
– Loosen the clamping handle **(43)** of the parallel guide and move it until it touches the saw blade.

Checking

The parallel guide **(9)** must touch the saw blade along its entire length.

Setting

– Loosen the hex socket screw **(69)** using a hex key.
– Carefully move the parallel guide **(9)** until it touches the saw blade along its entire length.
– Hold the parallel guide in this position and push the clamping handle **(43)** down again.
– Retighten the hex socket screws **(69)**.

Adjusting the magnifying glass of the parallel guide (see figure L)

– Bring the power tool into the work position.
– Remove anti-kickback pawls **(7)** and fold the protective cover **(6)** backwards.
– Move the parallel guide **(9)** from the right until it touches the saw blade.

Checking

The marking in the magnifying glass **(61)** must be in line with the 0 mm mark on the scale **(1)**.

Setting

– Loosen the screw **(70)** using a cross-headed screwdriver and align the marking along the 0 mm mark.

Storage and transport

Storing tool elements (see figures M–N)

You can attach certain tool elements to the power tool to store them.

– Detach the additional parallel guide **(47)** from the parallel guide **(9)**.
– Place all loose components of the tool in their storage compartments on the housing (see the following table).

Figure	Tool element	Storage compartment
M	Ring spanner **(35)**	Place in storage compartment **(33)**
M	Hook spanner/ open-ended spanner **(36)**	Place in storage compartment **(33)**
M	Anti-kickback pawls **(7)**	Place in storage compartment **(33)**
M	Angle guide **(3)** with profile rail **(50)**	Slide into the storage compartment holders **(29)**
N	Parallel guide **(9)** with fitted additional parallel guide **(47)**	Place in storage compartment **(12)**
N	Push stick **(15)**	Place in storage compartment **(21)**

Maintenance and Service

Maintenance and Cleaning

- ▶ **Pull the plug out of the socket before carrying out any work on the power tool.**
- ▶ **To ensure safe and efficient operation, always keep the power tool and the ventilation slots clean.**

In order to avoid safety hazards, if the power supply cord needs to be replaced, this must be done by **Bosch** or by an after-sales service centre that is authorised to repair **Bosch** power tools.

Cleaning

Always remove dust and chips after working by blowing out with compressed air or using a brush.

Lubricating the power tool

Lubricant:

SAE 10/SAE 20 engine oil

– Oil the power tool as necessary at the points indicated.

An authorised Bosch after-sales service centre will handle this work quickly and reliably.

Dispose of lubricants and cleaning products in an environmentally friendly manner, taking legal regulations into account.

Noise reduction measures

Measures implemented by the manufacturer:

– Soft start
– Provided with a saw blade specially developed for noise reduction

Measures implemented by the operator:

– Low-vibration mounting on a stable work surface
– Use of saw blades with noise-reducing functions
– Regular cleaning of the saw blade and power tool

After-Sales Service and Application Service

Great Britain

Tel. Service: (0344) 7360109

GB Importer:

Robert Bosch Ltd.
Broadwater Park
North Orbital Road
Uxbridge
UB9 5HJ

You can find the link to our service addresses and warranty conditions on the last page.

In all correspondence and spare parts orders, please always include the 10-digit article number given on the nameplate of the product.

Disposal

The power tool, accessories and packaging should be recycled in an environmentally friendly manner.

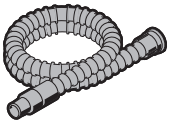
Do not dispose of power tools along with household waste.

Only for EU countries and United Kingdom:

Electrical and electronic equipment that is no longer suitable for use must be collected separately and disposed of in an environmentally friendly manner. Use the designated collection systems.Incorrect disposal may cause harmful effects on the environment and human health, due to the potential presence of hazardous substances.

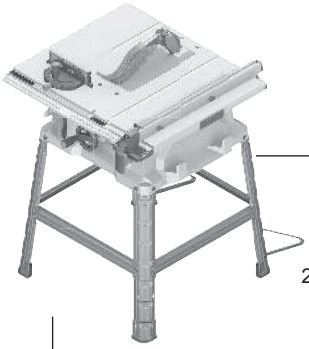
1 600 A02 2D7

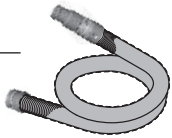
2 610 015 508



Ø 28 mm:
2 608 000 772 (3.2 m)

GAS 18V-12 MC

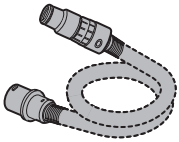




Ø 28 mm:
2 608 000 885 (4 m)

GAS 12-40 MA

GAS 35 M AFC



Ø 22 mm:
2 608 000 567 (5 m)
Ø 35 mm:
2 608 000 565 (5 m)

GAS 55 M AFC

Ø 22 mm:
2 608 000 568 (5 m)
Ø 35 mm:
2 608 000 566 (5 m)

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Contacts de Service
Contactos de Servicio

https://www.bosch-pt.com/serviceaddresses

Garantiebedingungen
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