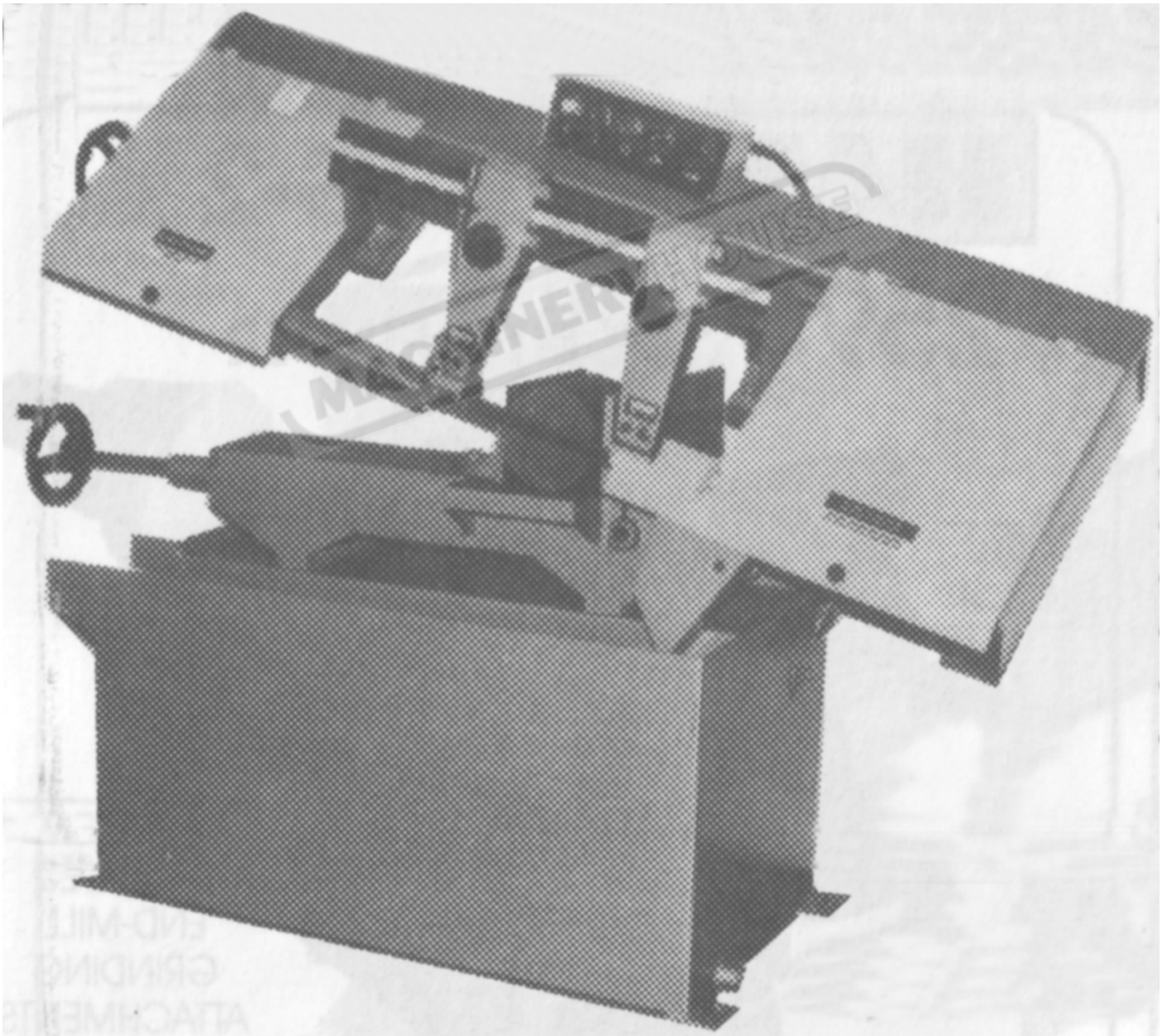


# INSTRUCTION MANUAL

**BS-10**

**Swivel Head Metal Cutting Band Saw (415V)  
400 x 230mm (W x H) Rectangle**



**B023**



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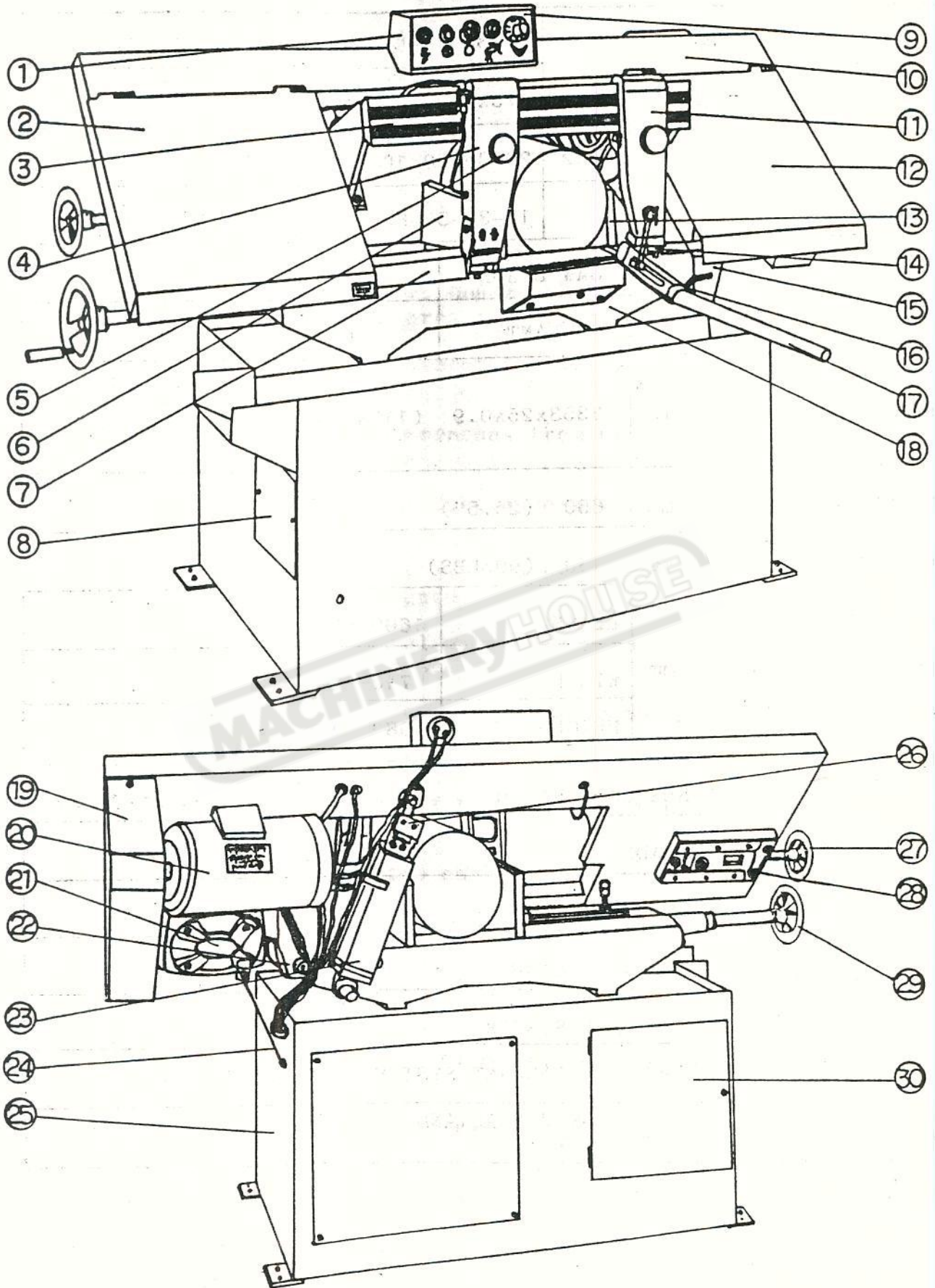
S A F E T Y

1. Know your band saw. Read the Operator's Manual carefully. Learn the operations, applications and limitations.
2. Use recommended accessories. Improper accessories may be hazardous.
3. Wear proper apparel.
4. Keep unnecessary people away.
5. Don't overreach or stand on tool.
6. Avoid dangerous environment. Don't use bandsaw in damp or wet locations. Keep work area well lighted.
7. Keep work area clean. Cluttered and slippery floors invite accidents.
8. Remove adjusting keys and wrenches from bandsaw before turning on power.
9. Avoid accidental starting. Make sure switch is off before plugging in power cord.
10. Don't force bandsaw. It is safe to operate at the cutting rate for which it was designed.
11. Never hand hold the material with saw in horizontal position. Always use the vise, clamp securely.
12. Keep belt guard and wheel covers in place and in working order.
13. Support long, heavy work from the floor.
14. Always remember to switch off the machine when the work is completed.
15. Disconnect power cord before adjusting, servicing and changing blade.
16. Check damaged parts. Damaged parts must be replaced or repaired.
17. Moving parts should keep in alignment. All adjustments are to be made with power disconnected.
18. Use a sharp blade and keep tool clean for best and safest performance.
19. Safety is a combination of operator's common sense and alertness at all times when the saw is functioning.
20. Keeping the bandsaw in top condition is essential for safety.

## SPECIFICATION

MAX CAPACITY	 mm	90°	230 ( 9" )	45°	230 ( 9" )
	 mm		175x400(7"x16")		150x230(6"x9")
CUTTING SPEED RANGE	m/min.	60Hz	20-36-60-100(68-120-176-330 fpm)		
		50Hz	17-30-50-85 (57-100-164-277 fpm)		
MOTOR OUTPUT	SAW BLADE		1.125		
	COOLANT		0.1		
BLADE SIZE	mm	3353x25x0.9 (11"x1"x0.035")			
HEIGHT OF WORK BED	mm	650 (25.5")			
WEIGHT	kg	450 (995LBS)			
FLOOR SPACE	mm	LENGHT	1600 (63")		
		WIDTH	710 (28")		
		HEIGHT	1080 (42.5")		
STANDARD ACCESSORIES	HEXAGON WRENCH			ONE SET (1.5mm-10mm)	
	BLADE			ONE PIECE	
	BRUSH			ONE PIECE	
	MATERIAL STOP			ONE PIECE	
	ELECTRIC SYSTEM			ONE UNIT	
	COMPLETE COOLANT SYSTEM			ONE UNIT	
	OPERATION MANUAL AND PARTS LIST			ONE COPY	

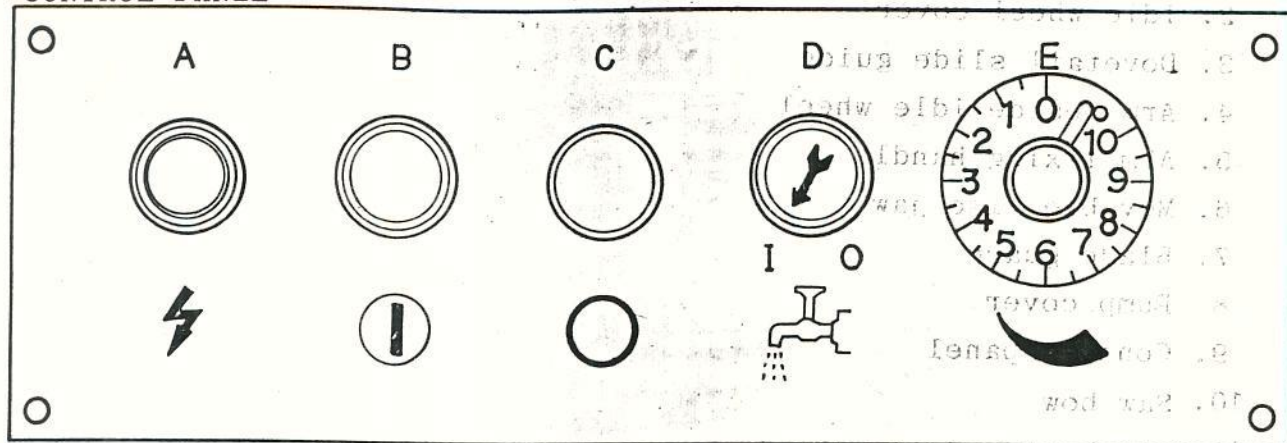
### THE NOMENCLATURE OF THE PARTS OF THE MACHINE



1. Control panel box
2. Idle wheel cover
3. Dovetail slide guide
4. Arm beside idle wheel
5. Arm fixing handle
6. Movable vise jaw
7. Blade guard
8. Pump cover
9. Control panel
10. Saw bow
11. Arm beside drive wheel
12. Drive wheel cover
13. Fixed vise jaw
14. Blade guide roller
15. Blade guard
16. Stopper
17. Depth bar (Length bar)
18. Bed
19. Cover for belt
20. Motor
21. Transmission
22. Saw bow bracket
23. Hydraulic cylinder
24. Feed tension spring
25. Basement
26. Limit switch
27. Tension handle
28. Idle wheel tension adjustment slide
29. Vise hand wheel
30. Electric cabinet door

## OPERATION

## CONTROL PANEL



## A. Operation light:

This light will be on when this button (B) is depressed.

## B. Operation button:

When the button is depressed, the saw blade motor operates and the indicator light is on.

## C. Emergency stop button:

When this button is depressed, machine operation stop immediately.

## D. Cutting fluid pump switch:

When this switch is set at "I", the cutting fluid pump operates and the cutting fluid will be injected. When this switch is set at "O", both the cutting fluid pump and cutting fluid stop.

## E. Cutting pressure control:

When the control is turned counterclockwise, the cutting force of the saw blade increases; when it is turned clockwise, the cutting force decreases.

**NOTE** The saw will stop automatically when the material has been cut through.

**WARNING** WHEN READY TO CUT, MAKE SURE "SWITCH" IS OFF BEFORE PLUGGING IN "POWER CORD". PUSH THE START BOTTOM TO START SAW AND LOWER THE BLADE ONTO THE MATERIAL TO BE CUT. DO NOT ENFORCE EXTRA FORCE OR DROP THE BLADE.

## CHECK TO MAKE PRIOR TO OPERATION

- 1) Make sure the teeth are pointing in the right direction.
- 2) Band should be properly seated on the wheels after correct tension is applied.
- 3) Set blade holder guides for approximately 003" to 005" clearance between the guides and blade.
- 4) Check for slight clearance between back up rollers and back of blade.
- 5) Move guides as close to work as possible.
- 6) Select proper speed and feed.
- 7) Material should be securely held in vise.
- 8) Coolant, if required, should be turned on.
- 9) If possible, do not start cut on a sharp edge.
- 10) Keep machine lubricated.

## OPERATING INSTRUCTIONS

**WARNING** DO NOT CONNECT POWER CORD TO POWER SOURCE UNTIL THE FOLLOWING INSTRUCTIONS ARE CLEARLY UNDERSTOOD, AND FOLLOWED.

## SPEED SELECTION:

Blade speed selection should be made according to the material to be cut. The following chart is for general reference only.

## SPEED SELECTION

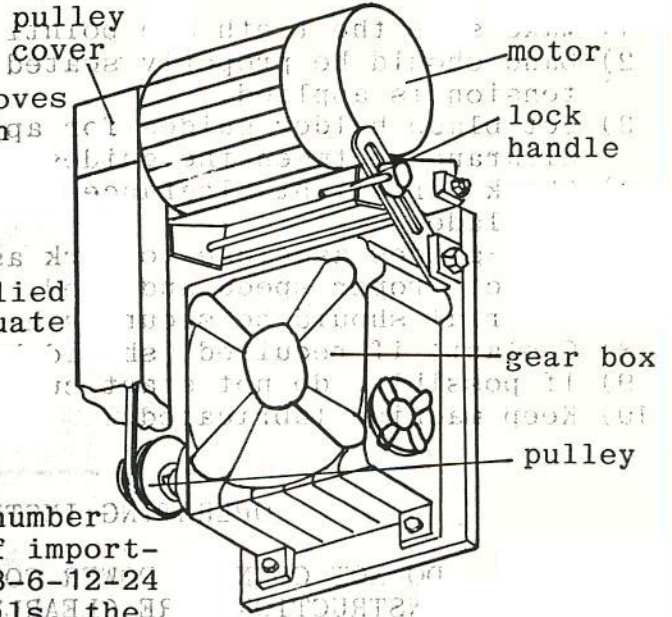
Material	Speed		Pulley Groove Used	
	50Hz	60Hz	motor pulley	saw pulley
High speed alloy, stainless and heavy cross section material	57	68	smallest	large
Tool, stainless and alloy steel; bearing bronzes	100	120	small	medium
Cast iron, mild steel hard brass and bronze	164	196	medium	small
Plastic, copper, soft brass, aluminum, other light materials	277	330	large	smallest

Some materials due to manufacturing processes such as certain types of cast iron pipe or materials containing certain types of welds, cannot be cut on this machine.

A GENERAL RULE TO FOLLOW IS, " IF THE MATERIAL CAN BE CUT WITH A FILE, IT CAN BE CUT ON THIS SAW."

CHANGING SPEEDS:

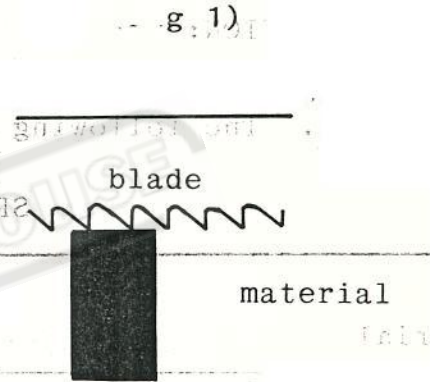
1. Remove pulley cover.
  2. Loosen lock handle.
  3. Position belt in proper grooves according to speed selection chart.
  4. Apply tension to belt and tighten lock handle.
- NOTE** 1/2" deflection of belts under moderate pressure applied between the pulleys is adequate tension.
5. Replace pulley cover.



BLADE SELECTION:

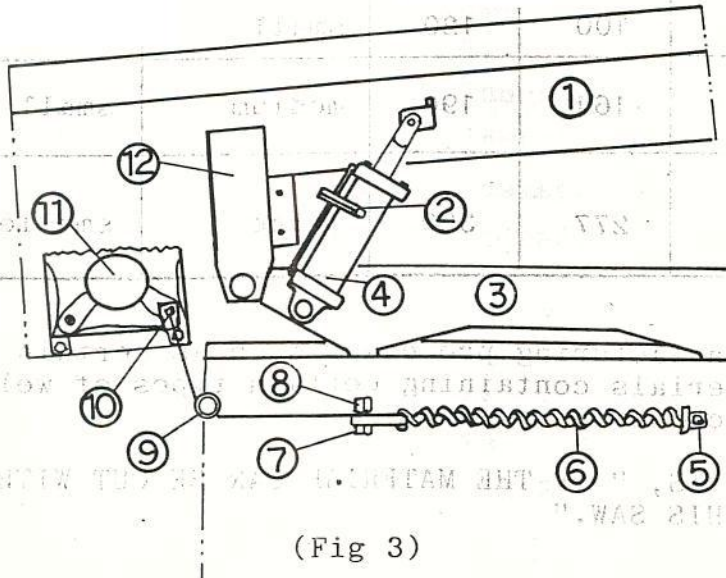
For best results, the correct number of teeth on the workpiece is of important. For mild materials, the 3-6-12-24 rule applies. For hard materials, the 6-12-24-48 rule applies.

At least two (2) teeth must be in cutting area at all times. The finer tooth blade is used when cutting thin sections and harder materials. Coarse teeth are for sawing large work and tough gummy metals.



ADJUSTING FEED

The "hydraulic cylinder" (Fig 3-4) and "feed tension spring" (Fig 3-6) are adjusted together to obtain the correct rate of feed for any desired feed pressure.



- 1 saw bow
- 2 by-pass valve (don't re-adjust it)
- 3 bed
- 4 hydraulic cylinder
- 5 bracket
- 6 feed tension spring
- 7 lock nut
- 8 adjustment screw
- 9 wire rope guide wheel
- 10 lock screw
- 11 gear box
- 12 screw bow bracket

(Fig 3)

FEED PRESSURE is the amount of pressure forcing the blade downward into the material.

#### RATE OF FEED

Proper rate of feed is important. Excessive pressure can break the blade or stall the saw. Insufficient pressure rapidly dulls the blade. The hydraulic cylinder (Fig 3-4) regulates the rate at which the blade is lowered into the material being cut. Adjusting the "Cutting pressure control" (Page 5, control panel "E") provides an infinite choice for rate of feed.

When cutting workpiece within 2mm of thickness, please adjust the knob of cutting pressure control (Page 5-E) between 1 - 2 in graduation, above 3mm of thickness, 3 - 4 in graduation.

In the event of the head is manually forced downward while making adjustments or setting up damage will occur to the hydraulic cylinder due to its internal By-Pass Over-Ride feature.

**CAUTION** BY-PASS VALVE (FIG 3-2) IS FACTORY ADJUSTED AND SHOULD NOT BE ALTERED.

While positioning material to be cut, the head can be raised to the mid-vertical position and held there by turning the knob of the cutting pressure control clockwise as far as it will go.

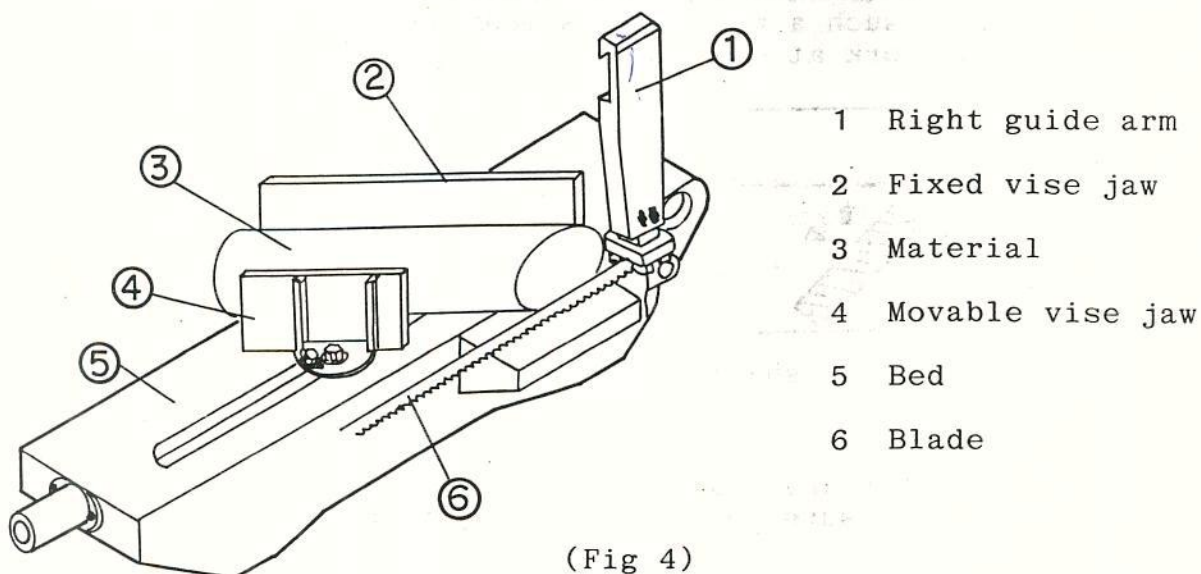
#### WISE

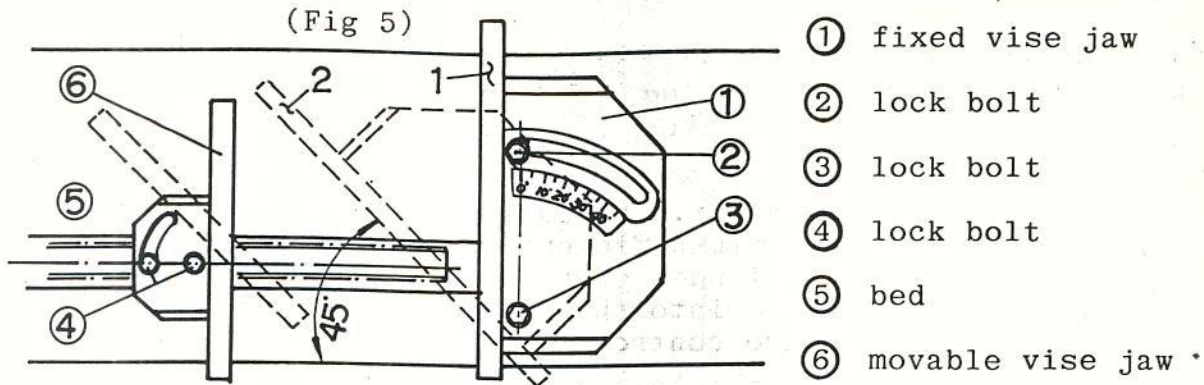
**CAUTION** WHEN CUTTING HORIZONTALLY, ALWAYS USE THE VISE TO HOLD THE WORK; NEVER HAND-HOLD THE WORK.

Clamp material securely by turning vise hand wheel clockwise. The vise allows great flexibility in cutting when set at the No.1 position (Fig 5), the cutting at any degree is possible by adjusting the vise as whole. The vise can be moved up to 45°, which is the No.2 position (Fig 5).

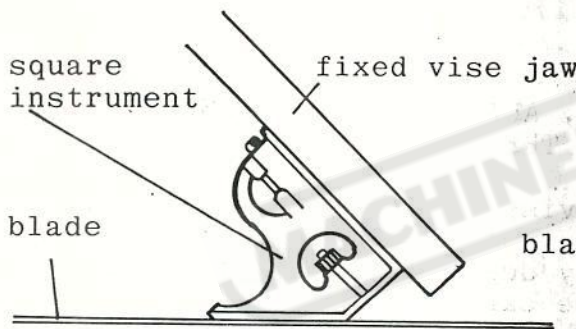
#### 45° CUTTING

1. Move right guide arm(2-6) to the end of dovetail guide (1-13).

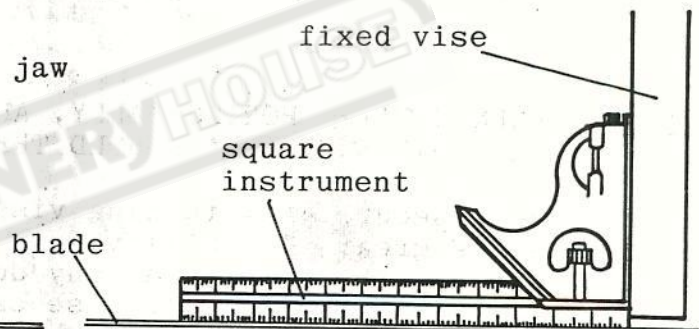




2. Lift the saw bow up to the maximum vertical position.
3. Loosen the two lock bolts (Fig 5-2, Fig 5-3) of the fixed vise jaw (Fig 5-1), then adjust the fixed vise jaw 45° against saw blade by an accurate square instrument (Fig 6). Tighten the two lock bolts (Fig 5-2, Fig 5-3).
4. Clamp the material to be cut by the movable jaw (Fig 4-4).  
**WARNING** DO NOT TRY TO TIGHTEN OR LOOSEN THE LOCK BOLT (FIG 5-4) OF THE MOVABLE VISE JAW (FIG 5-6), FOR IT IS FUNCTIONING AS A PIVOT FOR Movable Vise Jaw SWIVELING WHEN CLAMPING MATERIAL TO BE CUT.
5. When repositioning the vise for 90° cutting, check for squareness by placing an accurate square instrument against the fixed vise jaw and alongside the saw blade (Fig 7).

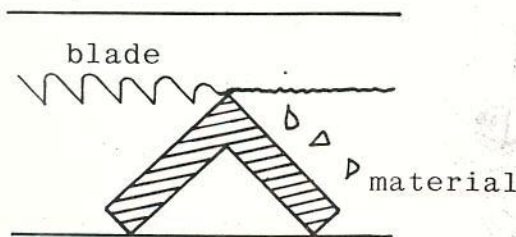


(Fig 6) 45°



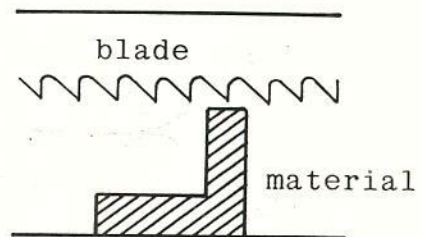
(Fig 7) 90°

When cutting irregularly shaped material, if possible, avoid positioning the work so that the cut is started on a sharp corner. Arrange work in such a way that as many teeth as possible are applied to the work at one time.



(wrong teeth strike sharp edge)

(Fig 8-A)

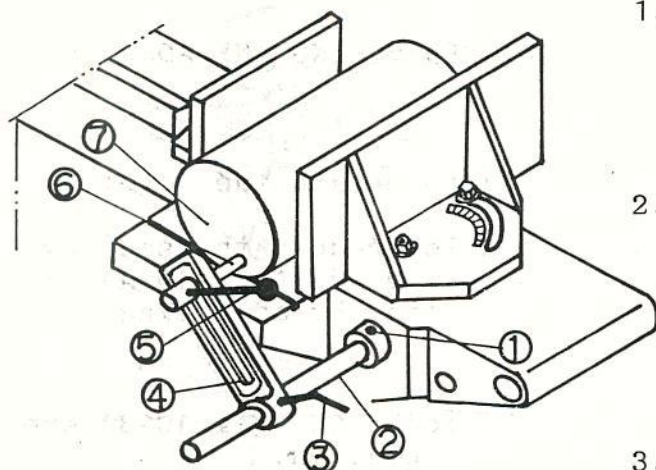


(right position several teeth contact work)

(Fig 8-B)

Position the upper and lower blade guides as close to the vise jaw as possible. Make sure they clear the jaws before starting to cut.

## MATERIAL STOP BRACKET



(Fig 9)

- ① set screw
- ② depth bar
- ③ fastening bolt
- ④ stopper bracket
- ⑤ stopper handle
- ⑥ stopper
- ⑦ front end of material

1. Fix up the depth bar (Fig 9-2) and tighten the set screw (for the safety of depth bar during transit, it is taken off from machine base.)
2. Lift the saw bow and clamp material by vise, then lower down saw bow to allow about 1mm clearance between saw blade teeth edge and top surface of material, and measure the desired length of workpiece to be cut.
3. Loosen the fastening bolt. (Fig 9-3)
4. Slide the stopper (Fig 9-6) in a proper position in order that the end of stopper could face against the front end of material. Then tighten the stopper (Fig 9-6) in bracket (Fig 9-4) by stopper handle (Fig 9-5).

5. Move the stopper bracket (Fig 9-4) toward the workpiece to touch against it, then tighten the fastening bolt (Fig 9-3).

## CHANGING BLADES

1. Make sure power cord is disconnected from power source.
2. Position saw vertically.
3. Open top wheel cover.
4. Release tension and remove blade.
5. Install new blade with teeth pointing downward and follow the direction of teeth.
6. Apply tension by truing hand wheel (1-65) clockwise. Proper tension exists when blade does not slip on Drive Wheel while cutting.
7. Apply a proper amount of tension and push the blade back so that it touches the flanges on the wheels.

## QUICK ACTION VISE

This machine is secured with quick action vise. Turning hand wheel (3-13 Page 24) clockwise is to clamp material; turning hand wheel counterclockwise is to unclamp.

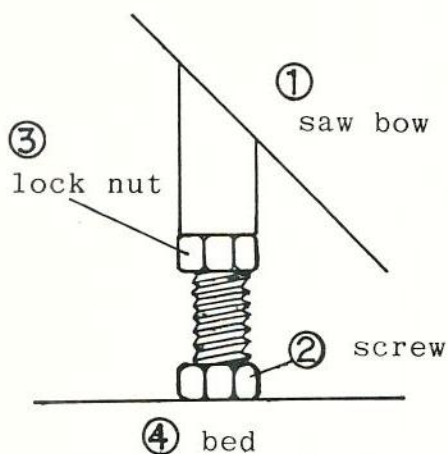
When hand wheel is turned counterclockwise, the movable vise jaw is movable to any position desired.

## ADJUSTMENTS

**WARNING** ALWAYS DISCONNECT POWER CORD WHEN MAKING ANY ADJUSTMENTS.

## HORIZONTAL STOP SCREW

1. Place a level on the bed (Fig 10-4) to obtain the levelling.
2. Loosen the lock nut (Fig 10-3), and lower down the saw bow, then place the level on the top of saw blade (Fig 10-A) to set levelling against bed horizontal line by adjusting the screw (Fig 10-2).



(Fig 10)

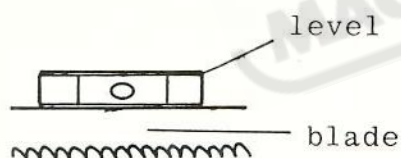
3. Tighten the lock nut (Fig 10-3) when levelling is obtained.

**NOTE** If the saw blade top line is not levelling against the bed horizontal line, the workpiece of material can not be cut off throughly.

## AUTOMATIC SHUT-OFF

The motor should shut off immediately after the blade has cut through the material and just before the head comes to rest on the horizontal stop screw.

If it does not, the horizontal stop screw must be adjusted.



(Fig 10-A)

1. Check adjustment of horizontal stop screw. Refer to "Horizontal Stop Screw Adjustments."
2. Raise head, and push switch button to "on" position. Lower head slowly and observe actuation of switch mechanism.

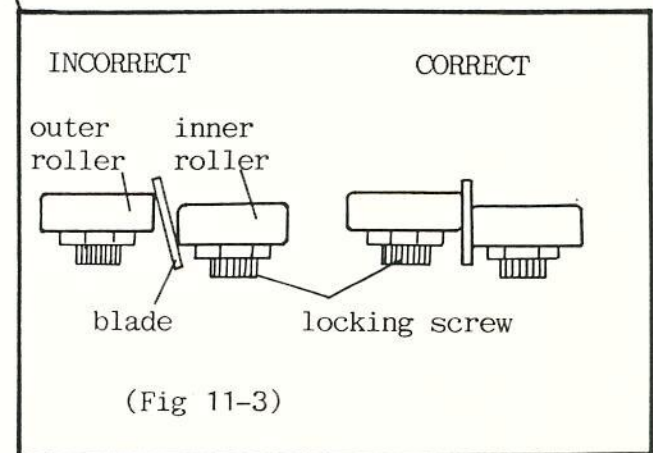
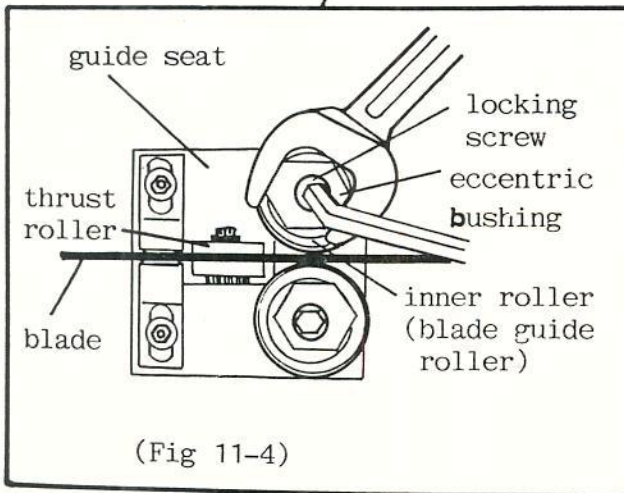
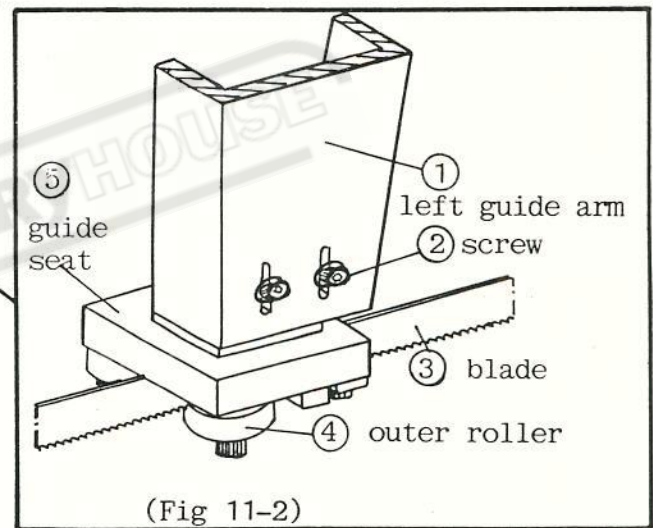
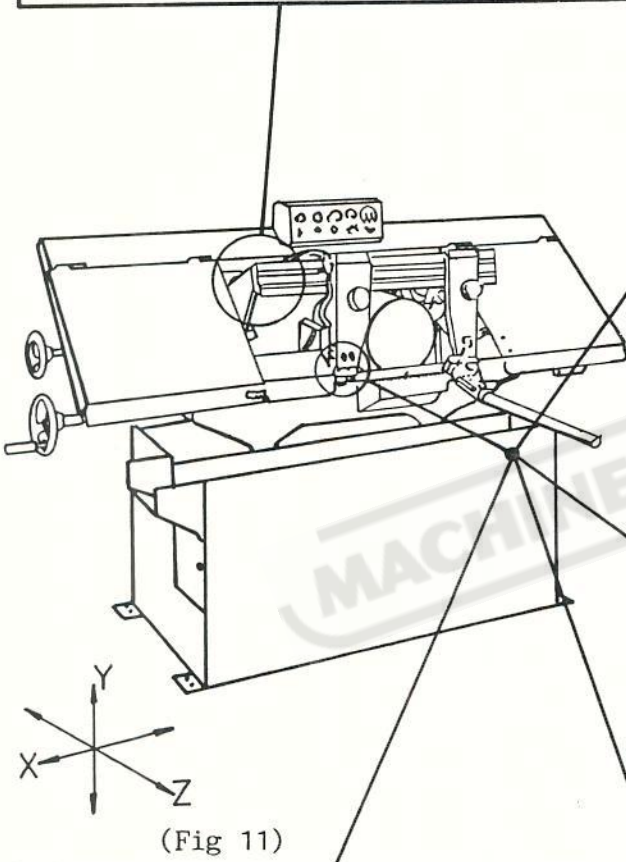
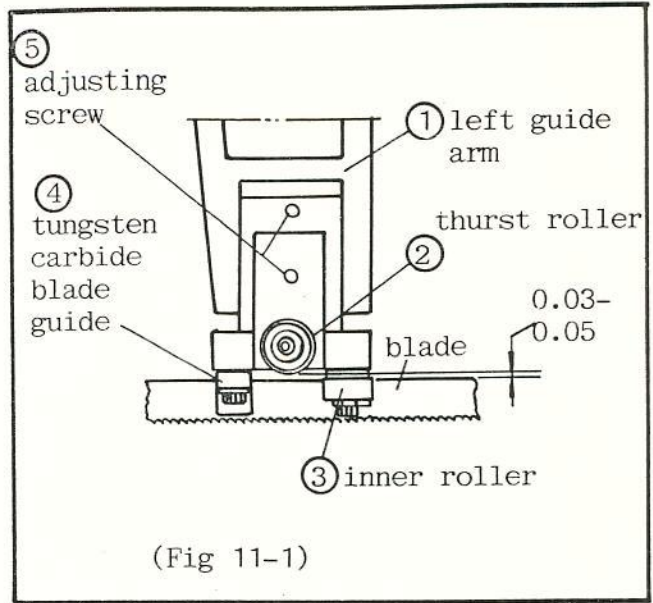
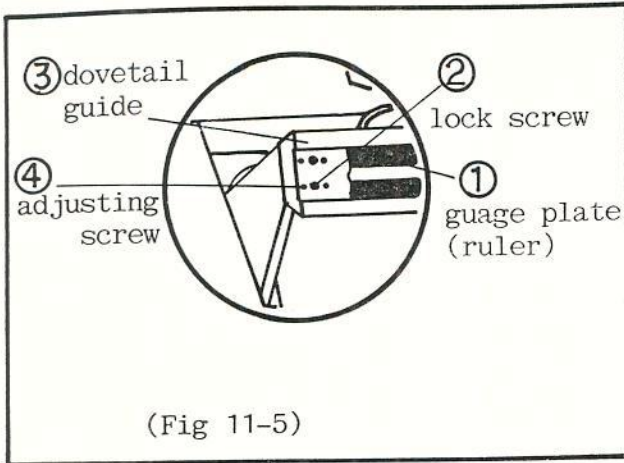
## BLADE TENSION

Turn blade tension hand wheel (1-65) clockwise to increase blade tension. Tension should be just enough that blade does not slip on drive wheel while cutting. Do not apply excessive tension.

Some of the uncommon problems may be encountered in band saw are described here with recommendation for correcting them.

## 1. Vibration on saw bow

- A. Cause(1):Dull blade or stripped blade.  
Remedy:Replace a new saw blade.

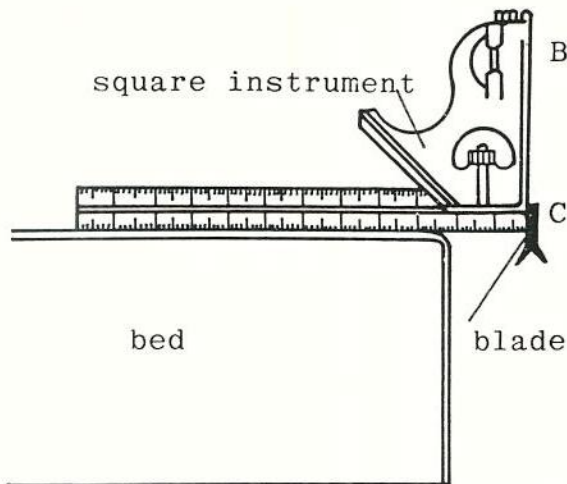


B.Cause(2): Too large clearance between saw blade and thrust roller (Fig 11-1-(2)).

- Remedy:
- Loosen the two screws (Fig 11-2-(2)).
  - Move guide seat (Fig 11-2-(5)) downward to adjust the clearance of 0.03-0.05mm between thrust roller (Fig 11-1-(2)) and saw blade.
  - Re-fasten the two screws (Fig 11-2-(2)).

2. An improper slant downward Y axis (Fig 11) cut-off work.

A.Cause(1): Improper blade tension.  
Remedy: Consult blade tension (P.11).



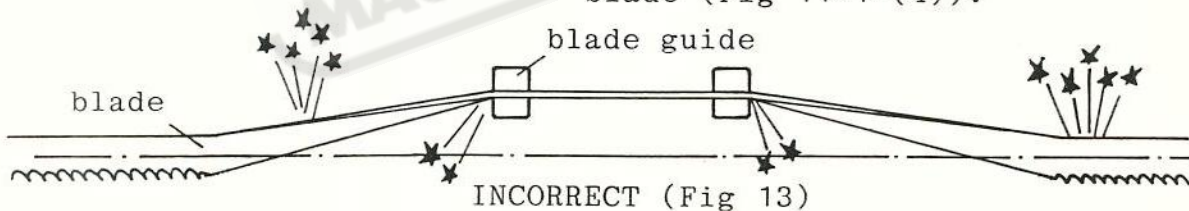
B.Cause(2): Incorrect alignment between rollers (outer, inner) and saw blade (Fig 11-3, left).

C. Remedy:

- Loosen the tungsten carbide blade guide (Fig 11-1-(4)).
- Loosen locking screws (Fig 11-4) by hex. wrench.
- Adjust eccentric bushing (Fig 11-4) by a spanner to make saw blade 90° against bed surface (Fig 12).

(Fig 12)

D. After finishing the adjustment, tighten the locking screws (Fig 11-4) and make sure the face of tungsten carbide blade guide contacts completely against alongside the saw blade (Fig 11-1-(4)).



**CAUTION** THE ADJUSTING SCREW (FIG 11-1-(5)) IS FACTORY FIXED. PLEASE DO NOT TRY TO ADJUST IT UNLESS THE MACHINE IS SERIOUSLY IMPACTED BY AN ACCIDENT AS TO LOST THE ACCURACY.

**NOTE** After finishing all the adjustment, be sure to double check the saw blade must not be in twisted condition. (Fig 13).

3. An improper tilt inward or toward X axis (Fig 11) cut-off work.

Cause: Incorrect alignment between fixed vise jaw and saw blade.  
Remedy: Adjust the vise 90° against saw blade. (Consult P.9, Fig 7).

4. Fig 11-5

The dovetail guide is factory accurately fixed. Please do not try to adjust it unless the machine is seriously impacted by an accident. If adjustment is necessary, pls follow the procedures.

- (1) Take off the arm guides.
- (2) Take off the guage plate (which is adhered to dovetail with glue), you will find there are 4 adjusting screws on each end of left and right side.
- (3) Replace the arm guides.
- (4) Make fine adjustment on these adjusting screws.

#### MAINTENANCE

**WARNING** ALWAYS DISCOUNNECT POWER CORD WHEN PERFORMING ANY MAINTENANCE. KEEP THE BAND SAW AND MOTOR CLEAN, FREQUENTLY BLOW OUT ANY CHIPS OR DUST.

#### LUBRICATION

All ball bearings are permanently lubricated and sealed. They require no further lubrication(except pivot hole).

The gear box lubricant does not have to be changed unless it becomes contaminated. Normally, after 300 hrs of primary operation, drain away the oil and clean the internal of the machine, then put in new oil. Do so hereafter every 2500 hrs of operation.

LUBRICANT: 90 MOBIL OR THE EQUIVALENT

To check "transmission-lubricant-level" place head in horizontal position and allow unit to set a few minutes to allow oil to drain down.

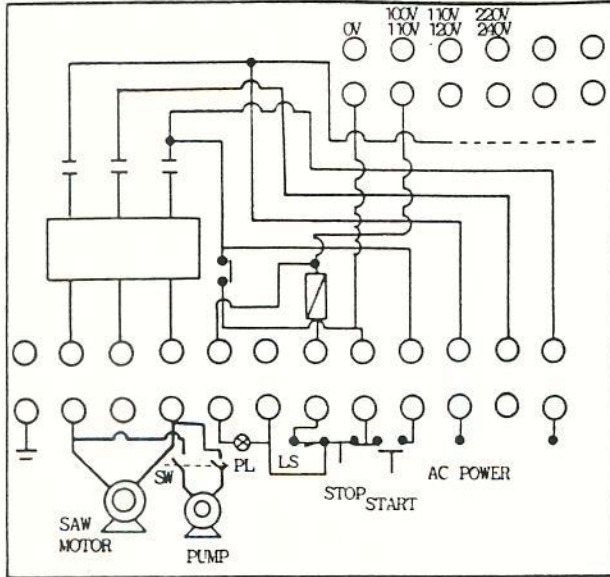
All other moving parts should be lubricated regularly to insure ease of operation. Use light machine oil.

ELECTRICAL PREFIX 6:---

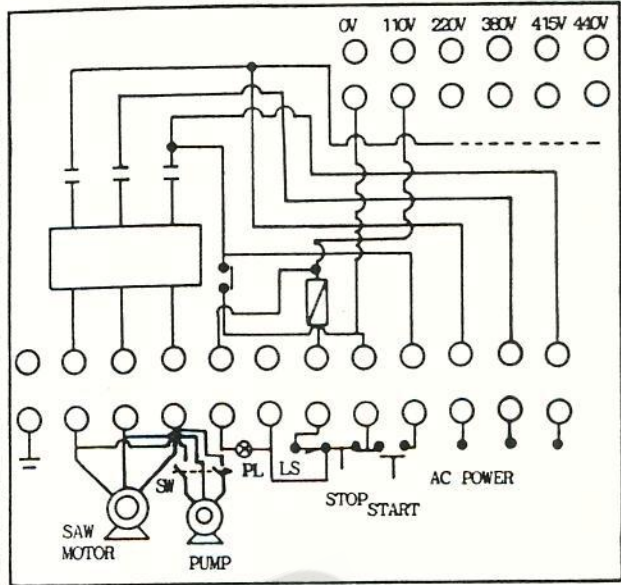
WIRING DIAGRAM

**NOTE** THE WIRING DIAGRAM IN YOUR BAND SAW IS ATTACHED WITH ( )

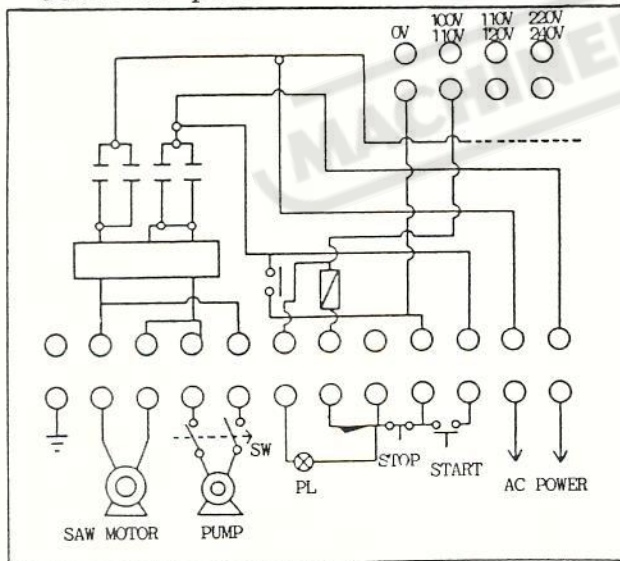
A.1 phase with control panel



B.3 phase with control panel



C.1 phase, 110V, 1.5HP with control panel



## TROUBLE SHOOTING CHART - GENERAL

**WARNING** DISCONNECT POWER CORD TO MOTOR BEFORE ATTEMPTING ANY REPAIR OR INSPECTION

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Motor Stalls	Excessive belt tension	Adjust belt tension so that belt does not slip on drive pulley while cutting ( $\frac{1}{2}$ "Min. deflection of belt under moderate pressure.)
	Excessive head pressure	Reduce head pressure. Refer to Operating Instructions "Adjusting Feed".
	Excessive blade speed	Refer to Operating Instructions "Speed Selection".
	Improper blade selection	Refer to Operating Instructions "Blade Selection".
Cannot make Square Cut	Dull blade	Replace blade.
	Guide rollers not adjusted properly	Refer to Adjustments "Page 13-2, 13-3."
	Rear vise jaw not adjusted properly	Set fixed vise jaw 90° to blade
	Excessive head pressure	Reduce head pressure. Refer to Operating Instructions, "Adjusting Feed."
Increased Cutting time	Dull blade	Replace blade
	Insufficient head pressure	Increase head pressure. Refer to Operating Instructions "Adjusting Feed."
	Reduced blade speed	Refer to Operating Instructions "Speed Selection."
Will not cut	Motor running in wrong direction	Reverse rotation of motor (Motor rotation C.C.W. pully end.)
	Blade teeth pointing in wrong direction	Remove blade, turn blade inside out. Rein-stall blade. (Teeth must point in direction of travel.)
	Hardened material	Use special alloy blades (Consult your Industrial Distributor for recommendation on type of blade required.)

## TROUBLE SHOOTING CHART - MOTOR

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Motor will not start	Magnetic switch open, or protector open.	Reset protector by pushing red button (inside electric box.)
	Low voltage	Check power line for proper voltage.
	Open circuit in motor or loose connections.	Inspect all lead terminations on motor for loose or open connections.
Motor will not start, fuse or circuit breakers "blow"	Short circuit in line, cord or plug.	Inspect line, cord and plug for damaged insulation and shorted wire.
	Short circuit in motor or loose connections	Inspect all lead terminations on motor for loose or shorted terminals or worn insulation on wires.
	Incorrect fuses or circuit breakers in powerline.	Install correct fuses or circuit breakers.
Motor fail to develop full power. (Power output of motor decreases rapidly w/decrease in voltage at motor terminals.)	Power line overloaded with lights, appliances and other motors.	Reduce the load on the power line.
	Undersize wires or circuit too long.	Increase wire sizes, or reduce length of wiring.
	General overloading of power company's facilities.	Request a voltage check from the power company.
Motor overheats	Motor overloaded.	Reduce load on motor.
	Air circulation through the motor restricted.	Clean out motor to provide normal air circulation through motor.
Motor stalls (Resulting in blown fuses or tripped circuit breakers)	Short circuit in motor or loose connections.	Inspect terminals in motor for loose or shorted terminals or worn insulation on lead wires.
	Low voltage	Correct the low line voltage conditions.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses circuit breakers.
	Motor overloaded	Reduce motor load
Frequent opening of fuses or circuit breakers.	Motor overloaded	Reduce motor load
	Incorrect fuses or circuit breakers.	Install correct fuses or circuit breakers.

If the trouble cannot be isolated and corrected using the above trouble shooting chart, bring the motor to a qualified electrician or motor service center for examination.

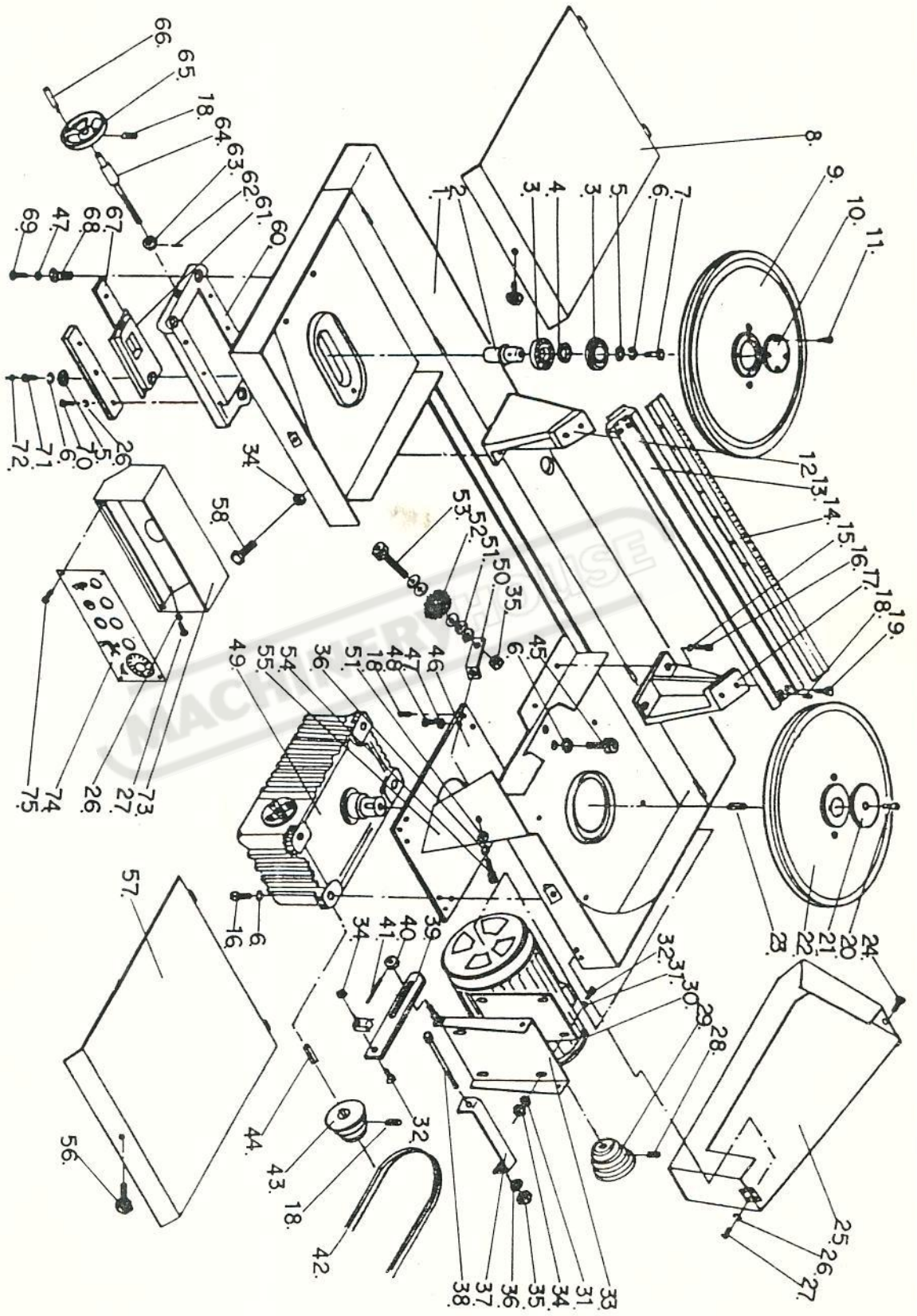
## TROUBLE SHOOTING CHART - BLADE

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Teeth strip- page	Too few teeth per inch	Use finer tooth blade
	Loading of gullets	Use coarse tooth blade or cutting lubricant.
	Excessive feed	Decrease feed
	Work not secured in vise	Clamp material securely
Blade breakage	Teeth too coarse	Use a finer tooth blade
	Misalignment of guides	Adjust saw guides.
	Dry cutting	Use cutting lubricant
	Excessive speed	Lower speed. See Operating Instructions "Speed selection."
	Excessive feed	Reduce feed pressure. Refer to Operating Instructions "Adjusting Feed."
Run-out and run-in	Excessive tension	Tension blade to prevent slippage on drive wheel while cutting.
	Wheels out of line	Adjust wheels
	Guides out of line	For a straight and true cut, realign guides, check bearings for wear.
	Excessive pressure	Conservative pressure assures long blade life and clean straight cuts.
	Support of blade insufficient	Move saw guides as close to work as possible.
	Material not properly secured in vise	Clamp material in vise, level and securely.
Blade twisting	Blade tension, improper	Loosen or tighten tension on blade.
	Blade not in line with Guide bearings	Check bearings for wear and alignment.
	Excessive blade pressure	Decrease pressure and blade tension.
Premature tooth wear	Blade binding in cut	Decrease feed pressure
	Dry cutting	* Use lubricant on all materials, except cast iron.
	Blade too coarse	Use finer tooth blade
	Not enough feed	Increase feed so that blade does not ride in cut
	Excessive speed	Decrease speed

\* Lubricant can be safely used on all materials. For best results, cut dry on cast iron, or use a good quality stick wax, applied to the blade before, and during cutting.

Elect Prefix 6:---

1. SAW BOW



## 1. SAW BOW (A)

INDEX NO.	PARTS NAME	TYPE	Q'TY	NOTE
1- 1	saw bow		1	
1- 2	idle wheel shaft		1	
1- 3	bearing	6205Z	2	
1- 4	bearing washer		1	
1- 5	washer	1/2	2	
1- 6	spring washer	1/2	12	
1- 7	bolt	1/2-12Wx3/4	1	
1- 8	wheel cover (left)		1	
1- 9	idler wheel		1	
1-10	washer (A)		1	
1-11	screw	1/4-20UNCx1/4	4	
1-12	bracket (left)		1	
1-13	dovetail guide		1	
1-14	guage plate (ruler)		1	
1-15	spring washer	M13	4	
1-16	bolt	1/2-12Wx1 1/4	8	
1-17	bracket (right)		1	
1-18	set screw	5/16-18UNCx3/4	10	
1-19	screw	3/8-16UNCx1 1/4	4	
1-20	screw	5/16-18UNCx1/4	1	
1-21	washer (B)		1	
1-22	drive wheel		1	
1-23	key	10x8x20L (mm)	1	
1-24	screw	1/4-20UNCx3/4	1	
1-25	pulley cover		1	
1-26	spring washer	1/4	14	
1-27	screw	1/4-20UNVx1/2	8	
1-28	set screw	5/16-18UNVx3/8	1	
1-29	motor pulley		1	
1-30	motor	1½HP	1	
1-31	washer	3/8	8	
1-32	screw	3/8-16UNCx3/4	5	
1-33	motor mounting plate		1	
1-34	nut	3/8	6	
1-35	nut	5/16	2	
1-36	spring washer	5/16	2	

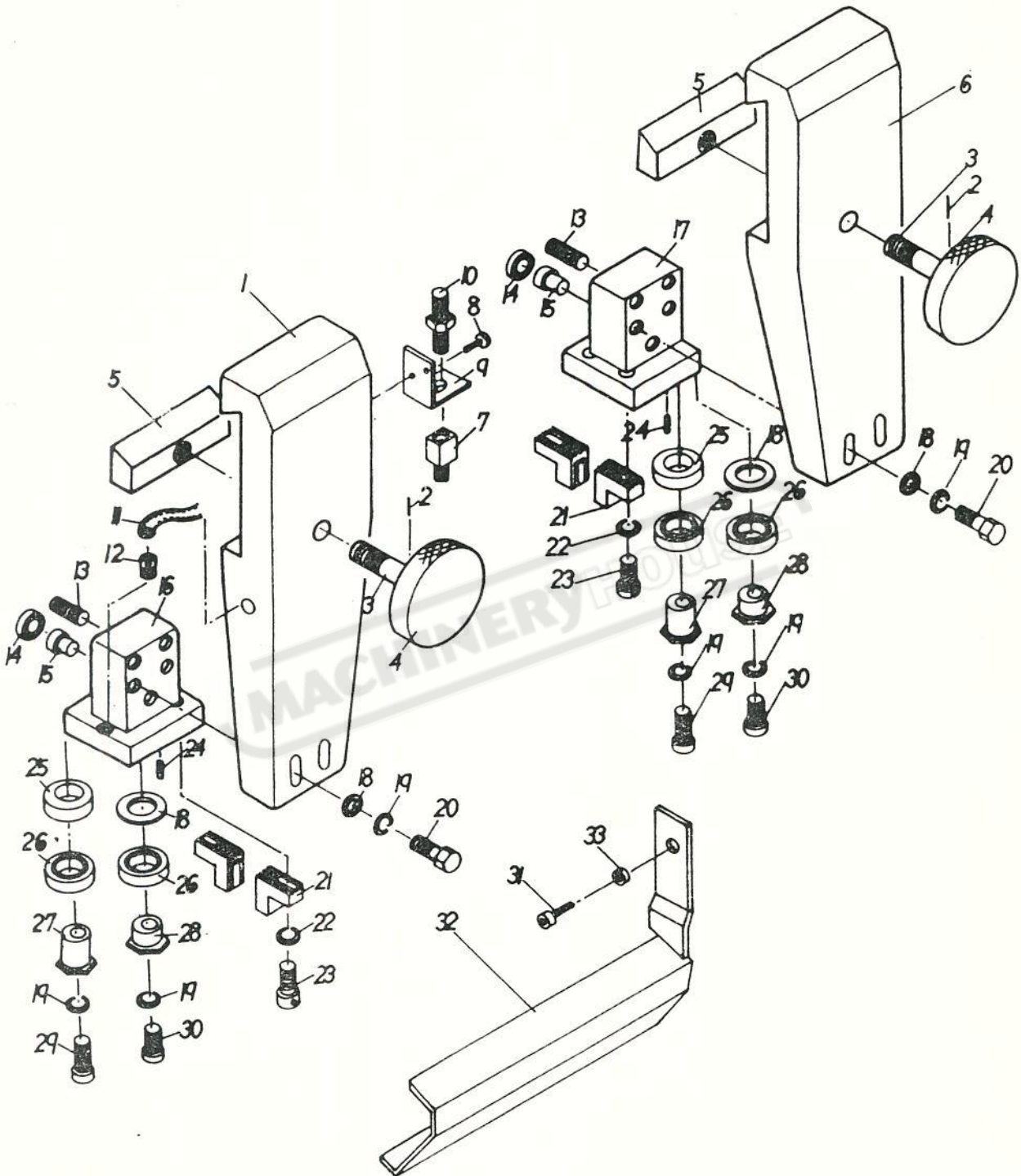
## 1. SAW BOW (B)

INDEX NO.	PARTS NAME	TYPE	Q'TY	NOTE
1-37	bracket		1	
1-38	lock screw		1	
1-39	adjusting plate		1	
1-40	lock nut	5/8	1	
1-41	lever		1	
1-42	V Belt	A37	1	
1-43	transmission pulley		1	
1-44	key	7x7x25 (mm)	1	
1-45	bolt	1/2-12Wx1½	6	
1-46	gear box bracket		1	
1-47	spring washer	3/8	7	
1-48	screw	3/8-16UNCx1	4	
1-49	gear box		1	
1-50	bracket		1	
1-51	washer	5/16	6	
1-52	wire brush		1	
1-53	screw	5/16-18UNCx11/4	1	
1-54	screw	5/16-18UNCx1/2	1	
1-55	wire brush cover		1	
1-56	knob		2	
1-57	wheel cover (right)		1	
1-58	screw	3/8-16UNCx1	1	
1-59	spring		1	deleted
1-60	tension plate		1	
1-61	adjusting slide		1	
1-62	spring pin	ø3x25 (mm)	1	
1-63	collar		1	
1-64	blade tensioning screw		1	
1-65	hand wheel		1	
1-66	handle		1	deleted
1-67	guide plate		2	
1-68	adjusting bolt	5/8-11UNCx1½	3	
1-69	screw	3/8-16UNCx2	3	
1-70	screw	1/4-20UNCx1	6	
1-71	bolt	1/2-12Wx1	1	
1-72	nipple	1/4"	1	



ELeet Prefix 6-

2. BLADE GUIDE ARMS

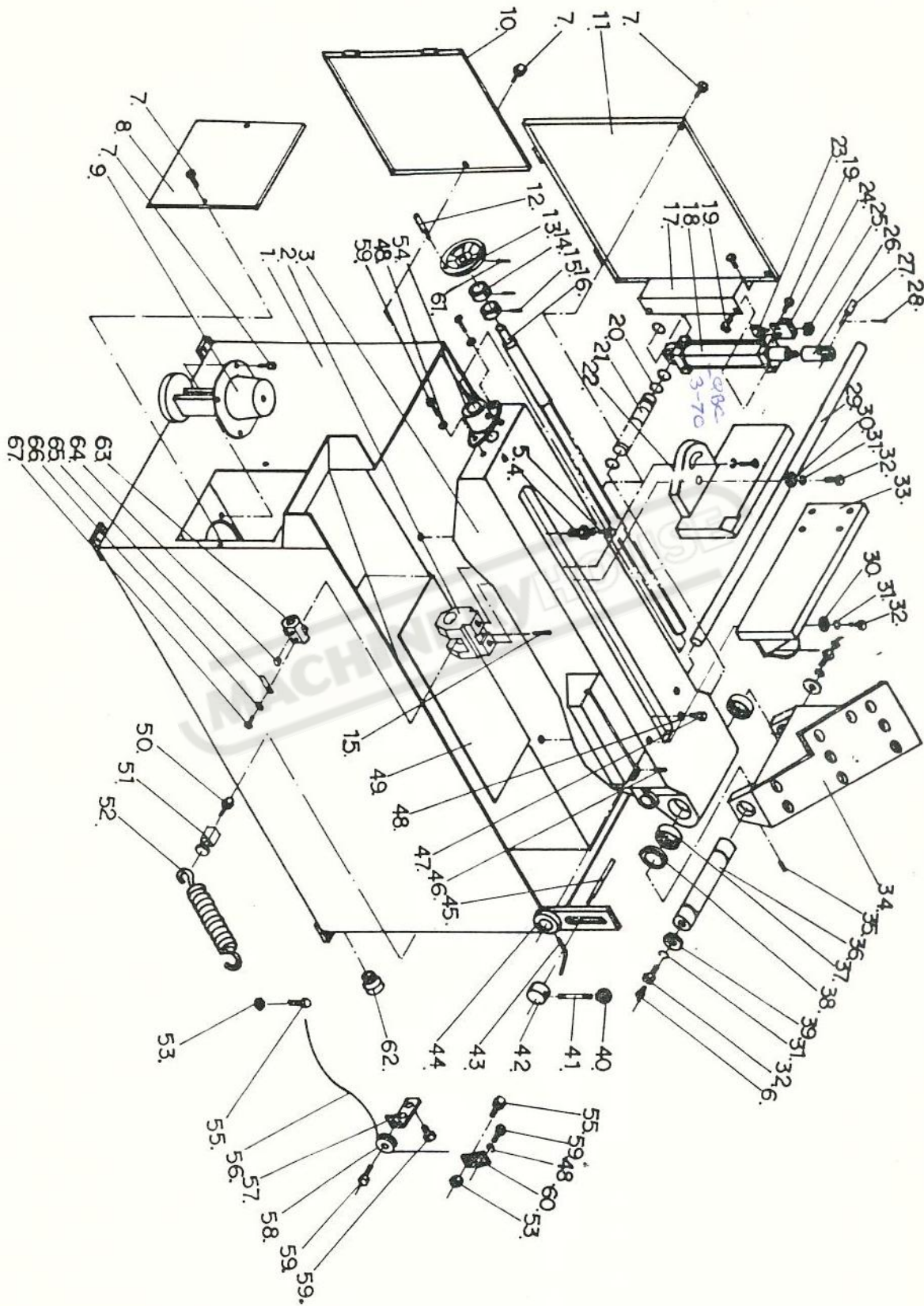


## 2. BLADE GUIDE ARMS

INDEX NO.	PARTS NAME	TYPE	Q'TY	NOTE
2- 1	guide arm (left)		1	
2- 2	spring pin	ø3x30L (mm)	2	
2- 3	bolt	1/2-20UNFx2 3/8	2	
2- 4	knob		2	
2- 5	clamping block		2	
2- 6	guide arm (right)		1	
2- 7	coolant valve		1	
2- 8	screw	3/16-24UNCx3/8	2	
2- 9	bracket		1	
2-10	fitting	PT 1/8"	1	
2-11	coolant nozzle	5/16"	1	
2-12	hose		1	
2-13	set screw	1/4-20UNCx1/2	6	
2-14	guide bearing	608ZZ	2	
2-15	bearing shaft		2	
2-16	guide seat (left)		1	
2-17	guide seat (right)		1	
2-18	washer	5/16	6	
2-19	spring washer	5/16	8	
2-20	screw	5/16-18UNCx11/4	4	
2-21	tungsten carbide blade guide		4	
2-22	spring washer	1/4	4	
2-23	screw	1/4-20UNCx1	4	
2-24	set screw	1/4-20UNCx1/4	2	
2-25	washer		2	
2-26	guide bearing	6202ZZ	4	
2-27	eccentric bushing (long)		2	
2-28	eccentric bushing (short)		2	
2-29	screw	5/16-18UNCx1½	2	
2-30	screw	5/16-18UNCx1	2	
2-31	screw	1/4-20UNCx3/8	2	
2-32	blade guard		1	
2-33	washer		1	

Elect Prefix 6...

3. BASE ASSEMBLY AND BED



## 3. BASE ASSEMBLY AND BED (A)

INDEX NO.	PARTS NAME	TYPE	Q'TY	NOTE
3- 1	base		1	
3- 2	vise sliding bracket		1	
3- 3	bed		1	
3- 4	bolt	5/8-11UNCx1 1/2	2	
3- 5	screw	3/8-16UNCx2 1/2	2	
3- 6	nipple	1/4"	2	
3- 7	screw	1/4-20UNCx1	9	
3- 8	pump cover		1	
3- 9	pump	1/8 Hp	1	
3-10	electric cabinet door		1	
3-11	cover		1	
3-12	handle		1	
3-13	hand wheel		1	
3-14	collar		2	
3-15	spring pin	φ6x30 (mm)	3	
3-16	vise lead screw		1	
3-17	cylinder cover		1	
3-18	cylinder		1	
3-19	screw	1/4-20UNCx3/4	6	
3-20	retainer	φ22 (mm)	4	
3-21	cylinder pivot		1	
3-22	movable vise jaw		1	
3-23	limit switch		1	
3-24	switch bracket		1	
3-25	lock nut	M12x1.75	1	
3-26	piston head		1	
3-27	hinge shaft		1	
3-28	cotter pin	φ3x30 (mm)	1	
3-29	depth bar (length bar)		1	
3-30	washer	1/2	3	
3-31	spring washer	1/2	5	
3-32	bolt	1/2-12Wx1½	5	
3-33	fixed vise jaw		1	
3-34	saw bow bracket		1	
3-35	set screw	1/4-20UNCx1/2	2	
3-36	pivot		1	

## 3. BASE ASSEMBLY AND BED (B)

INDEX NO.	PARTS NAME	TYPE	Q"TY	NOTE
3-37	needle bearing	HK2820	2	
3-38	oil seal	28x38x5.5 (mm)	1	
3-39	washer		2	
3-40	plastic ball		1	
3-41	stopper handle		1	
3-42	lock nut		1	
3-43	fastening bolt		1	
3-44	stopper bracket		1	
3-45	stopper		1	
3-46	set screw	1/4-20UNCx3/8	1	
3-47	screw	3/8-16UNCx2	2	
3-48	spring washer	3/8"	7	
3-49	filter plate		1	
3-50	screw	5/16-18UNCx3/4	1	
3-51	bracket		1	
3-52	spring		1	
3-53	nut	3/8	2	
3-54	lead screw seat		1	
3-55	lock screw	3/8-16UNCx1	2	
3-56	wire rope	3 (mm)	1	
3-57	bracket		1	
3-58	wire rope guide wheel		1	
3-59	screw	3/8-16UNCx1	5	
3-60	bracket (B)		1	
3-61	spring pin	∅6x40 (mm)	1	
3-62	plug		1	
3-63	lead screw nut		1	
3-64	screw nut rotating pin		1	
3-65	spring piece		1	
3-66	washer	3/16	1	
3-67	screw	3/16-24UNCx1/4	1	

October, 1985