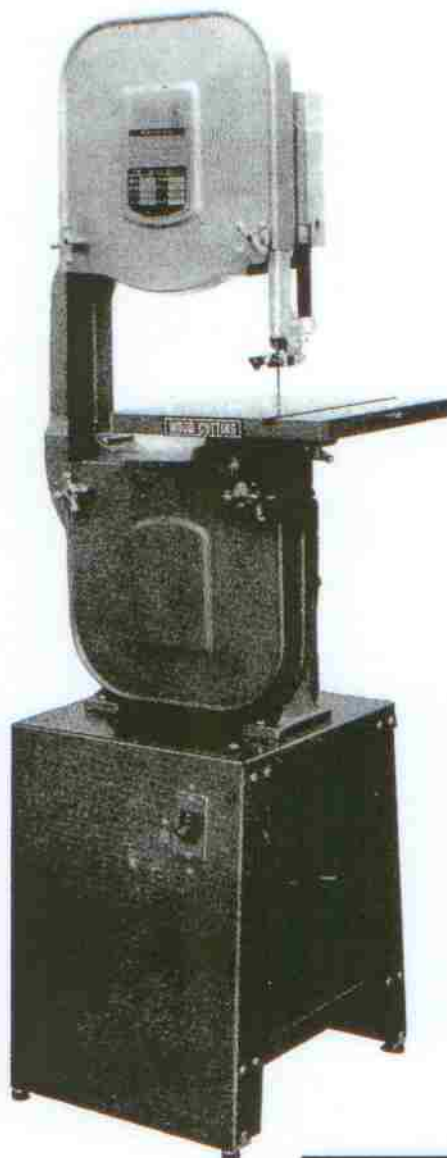


## INSTRUCTION MANUAL

(356mm)

Wood Cutting

# 14" Band Saw



This band saw can offer you a series of various speed from single, two to four that fits for different demands of working.

The Serial No./Model No. plate is attached to the right side of the base casting. Locate this plate and record the Serial No. and Model No. in your manual for future reference.

SERIAL NO. \_\_\_\_\_

MODEL NO. \_\_\_\_\_

**Before Using Be Sure To Read This Manual.**

This Machine is Suitable To Use Only From 12° C~35° C (53.6° F~95° F).

---

## **SAFETY RULES**

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet location, or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from work area.
6. **MAKE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE TOOL.** Don't force tool or attachment to do a job for which it was not designed.
8. **USE RIGHT TOOL.** It will do the job better and safer at the rate for which it was designed.
9. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
10. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
11. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
12. **DON'T OVERREACH.** Keep proper footing and balance at all times.
13. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
14. **DISCONNECT TOOLS** before servicing; when changing accessories such as blades.
15. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
16. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
17. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function—check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
20. **NEVER LEAVE TOOL RUNNING UNATTENDED.** **TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

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## **SPECIAL SAFETY RULES FOR BAND SAWS**

1. **ADJUST** the upper guide about 1/8" (3.2mm) above the material being cut.
2. **MAKE SURE** that blade tension and blade tracking are properly adjusted.
3. **STOP** the machine before removing scrap pieces from the table.
4. **ALWAYS** keep hands and fingers away from blade.
5. **CHECK** for proper blade size and type.
6. **DO NOT** attempt to saw stock that does not have a flat surface, unless a suitable support is used.
7. **HOLD** material firmly and feed into blade at a moderate speed.
8. **TURN OFF** machine if the material is to be backed out of an uncompleted cut.
9. **MAKE "relief" cuts** before cutting long curves.

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## GROUNDING INSTRUCTIONS

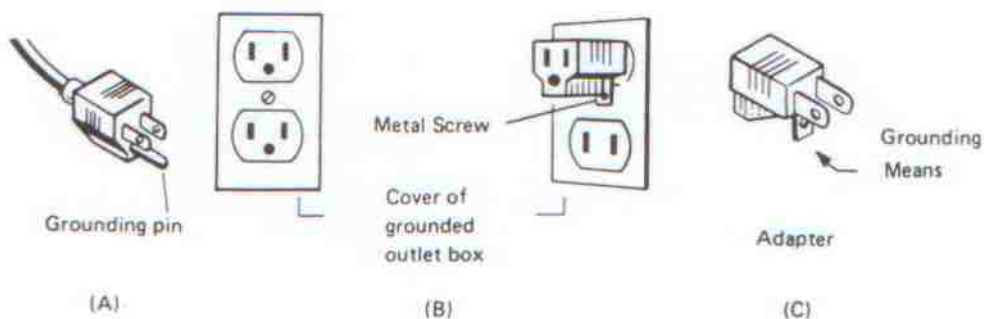
1. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.
2. Do not modify the plug provided it will not fit the outlet, have the proper outlet installed by a qualified electrician.
3. Improper connection of the equipment grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripe is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
4. Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
5. Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.
6. Repair or replace damaged or worn cord immediately.
7. This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch A. The tool has a grounding plug that looks like the plug illustrated in sketch A. A temporary adapter, which looks like the adapter illustrated in sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in sketch B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, etc. extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

### Note:

The type of electrical plug and receptacle differs from country to country.

### Caution:

In Canada only the grounding shown in figure (A) is acceptable. The extension cords should be CSA certified S.J.T. type or something better.



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## POWER CONNECTIONS

A separate electrical circuit should be used for the power tools. This circuit should not be less than No. 12 wire and should be protected with a 20 Amp. time lag fuse. Never use long extension cords. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tool plug. Before connecting the motor to the power line, be sure that the electric current is of the same characteristics as stamped on motor nameplate. All line connections should make good contact. Running on low voltage will damage the motor.

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## UNPACKING

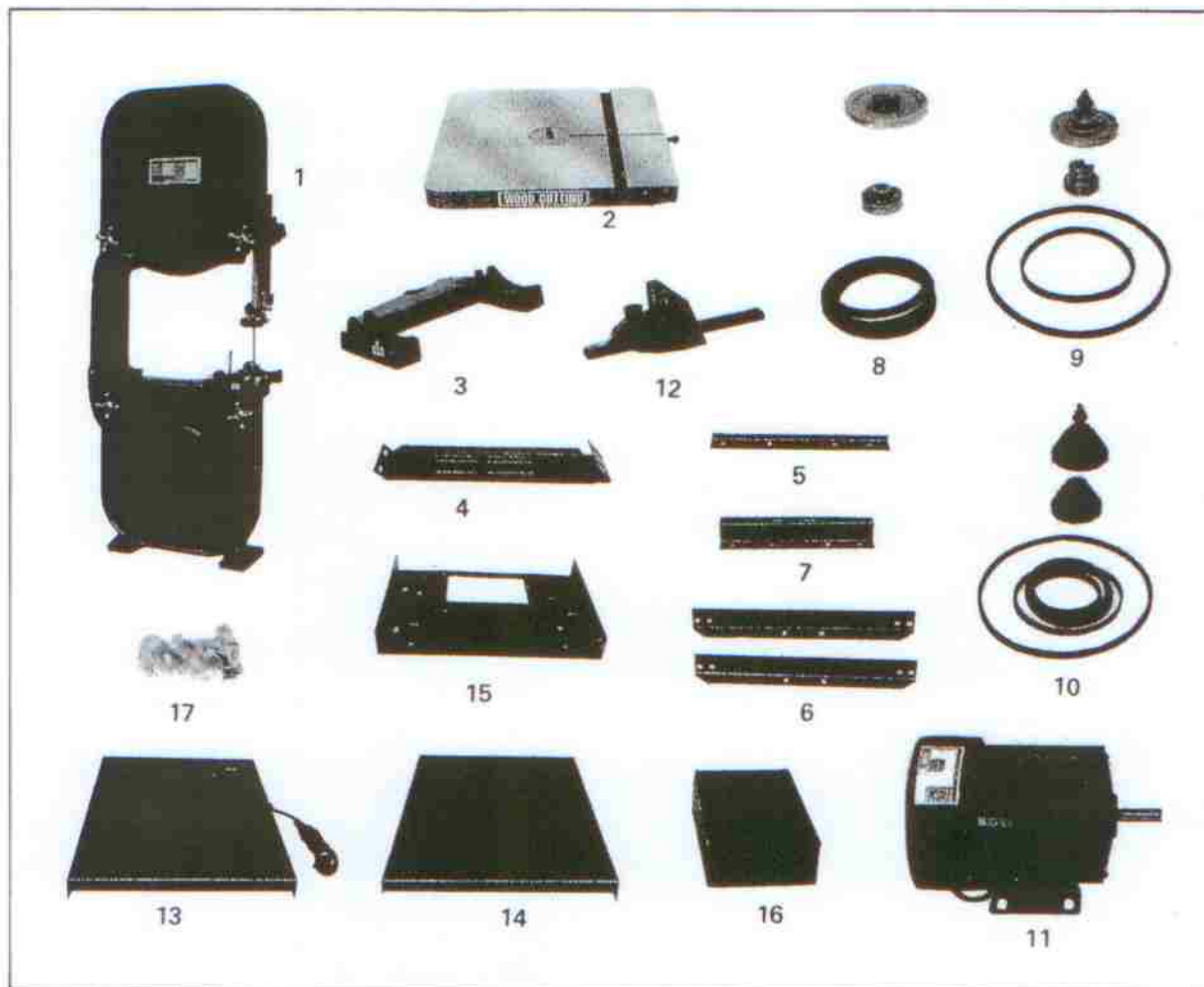


Fig. 1

Carefully unpack the band saw and check all items. Figure 1, illustrates the contents of the carton. Do not discard any packing material until the band saw is fully assembled operational.

- |                                   |                                  |
|-----------------------------------|----------------------------------|
| 1. Bandsaw Main Frame             | 10. Pulley & V-Belt (Four Speed) |
| 2. Table                          | 11. Motor                        |
| 3. Trunnion Bracket               | 12. Miter Gauge                  |
| 4. Motor Plate                    | 13. Stand Leg W/Switch Hole      |
| 5. Supporting Bar                 | 14. Stand Leg                    |
| 6. Supporting Plates, Stand       | 15. Top Of Stand                 |
| 7. Motor Supporting Bar           | 16. Pulley Guard                 |
| 8. Pulley & V-Belt (Single Speed) | 17. Hardware Package             |
| 9. Pulley & V-Belt (Two Speed)    |                                  |

### Caution

All No. 8, 9, 10 in Figure (1) is different accessories according to different Types of machines (single speed-four speed).

## ASSEMBLY OF LEG STAND

Using Fig. 2 as reference and the screws, nuts, washers in the hardware package to install the top of stand ( # 15 ) with the two stand legs ( # 13, # 14 ). Remember not to tighten them immediately and beware the position of the belt opener on top.

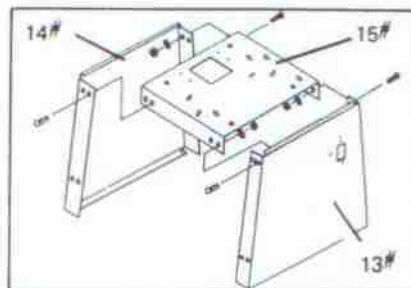


Fig. 2

Install the supporting plates ( # 6 ) on both sides of the stand leg bottom, do not tighten the nuts yet. Using Fig. 3 as reference.

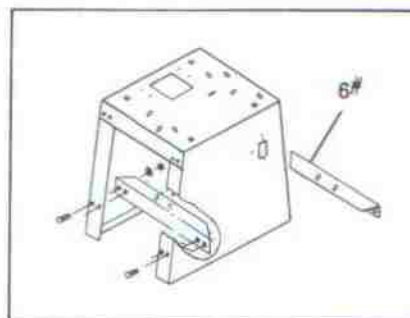


Fig. 3

Mount the supporting bar ( # 5 ) and the motor supporting bar ( # 7 ) inside the top of stand. Refer to Fig. 4.

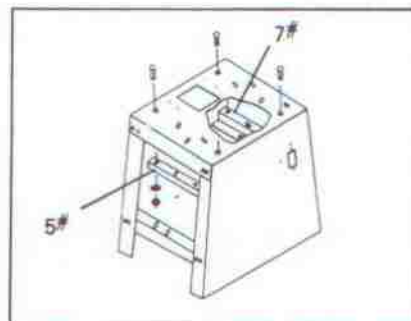


Fig. 4

Mount one end of the motor plate ( # 4 ) on the motor supporting bar ( # 7 ) and the other end on supporting plates ( # 6 ) then tighten all screws and nuts refer to Fig. 5.

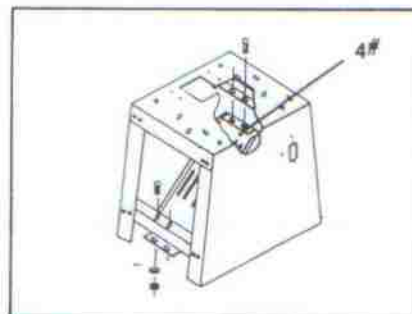


Fig. 5

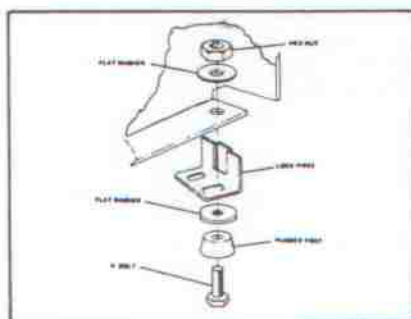


Fig. 6

Refer to direction of Fig. 6, mount the foot pads on four corners of the leg stand in order to increase the machine's stability.

## ASSEMBLY AND ADJUSTMENT

After assembly of the leg stand, please refer to Fig. 7 see if they are the same, check again if all nuts have been tightened.



Fig. 7

### Motor Assembly

Use four sets of screws, nuts and washers to assemble the motor on the motor plate. Do not tighten the nuts in order to be more convenient for belt adjustment afterwards refer to Fig. 8.



Fig. 8

After belt mounted, check if the V-belt is too loose or motor belt and body shaft belt is not in horizontal position, loose screws A or B as shown on Fig. 9 and shift the motor to proper position, then, tighten the screws.

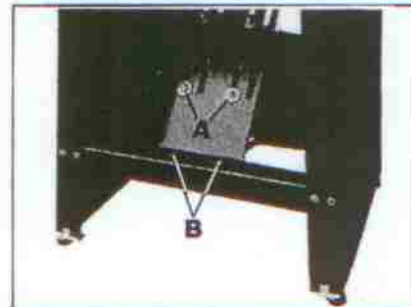


Fig. 9

To get appropriate tension, use 10 Lbs. pressure on the belt for the distance of 1/2" (13mm)  $\pm 10\%$ . Close pulley, stand covers. Fig. 10.

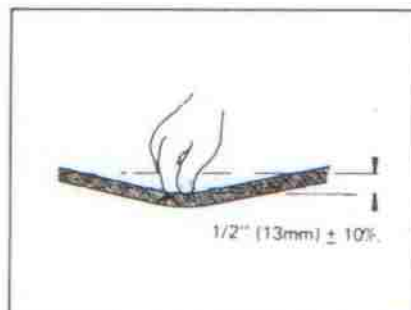


Fig. 10

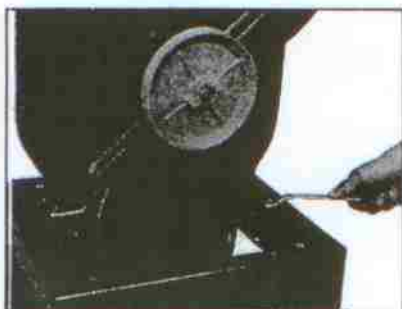


Fig. 11

### Bandsaw installation

Use four screws and washers to fix bandsaw base on the stand top. Fig. 11.

### Assembling Belt And Pulley Guard

Place the belt and pulley guard (B) Fig. 12, on the top shelf over the belt opening. Use the four round head screws (C), to fasten in place. Place door (D) Fig. 6, on hinges.

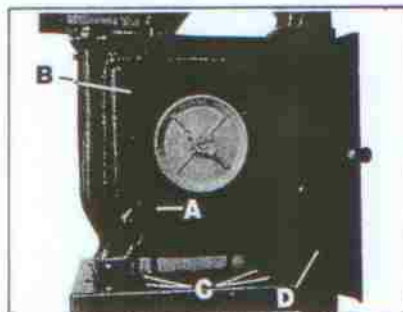


Fig. 12

### Table installation

Locate the assembled nut of the trunnion bracket (A) with two screws (B) and washers. Table supporting screw (C) is adjustable to support table properly. Fig. 13.

Table supporting screw (C) is packed in the hardware package bag. See Fig. 1 (17#).

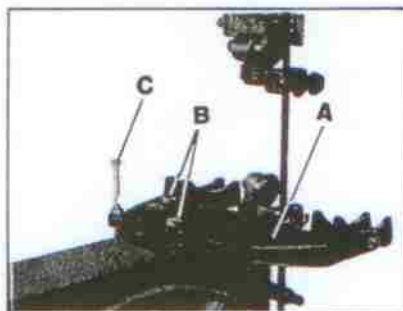


Fig. 13

### Table Insert

Place table insert (A) Fig. 14, in the hole provided in the table making sure the pin in the table engages one of the indents in the table insert.



Fig. 14

### Tilting the Table

The table on your band saw can be tilted 45 degrees to the right and 10 degrees to the left. To tilt the table, loosen the two star wheels (A) Fig. 15, tilt the table to the desired angle and tighten the two star wheels (A).

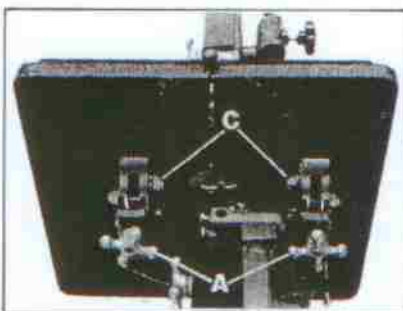
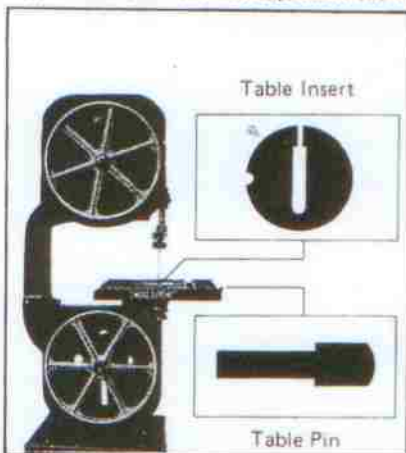


Fig. 15

### Assembling Table

Move table when place table insert (A) Fig. 14 to make sure the blade be in the center of (A).

Tighten the Six Hex. Hd. Cap screw (C) Fig. 15.



6 Fig. 16

### How to Change Blade (Fig. 16)

Take off table insert, pin. Remove wheels guards (upper and lower). Release blade tension completely. Take off blade carefully. Replace with new blade. Beware of the direction of the blade, the teeth should be facing operator and point downward. (See Fig. 16-1 on page 7) Adjust blade tracking and tension.



Replace with new blade. Beware of the direction of the blade, the teeth should be facing operator and point downward.  
Adjust blade tracking and tension. See "Adjustments"

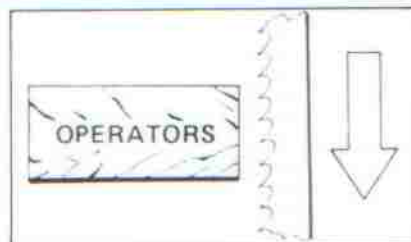


Fig. 16-1

#### 90 Degree Table Adjustment

Your band saw is equipped with an adjustable stop to insure that the table is at 90 degrees to the blade. (Fig. 17)

To adjust:

Tilt the table to the right slightly.

Place the stop, on the adjusting screw.

Tilt the table until it is at 90 degree to the blade, making sure by placing a square on the table and against the blade.

When the table is at 90 degrees to the blade, the stop should come into contact with the bottom of the table. If an adjustment is necessary, loosen nut, and turn adjusting screw until the stop contacts the table.

It is necessary to remove the stop, when tilting the table to the left.

#### Adjusting Blade Tension

On the back of the upper wheel there is a slide bracket to get the proper tension for various widths of blades with the blade on the wheels, turn the star wheel (A) Fig. 18 to raise or lower the wheel until you provide the right tension to your blade. Correct belt tension is obtained when there is approximately 1" (25.4mm) deflection in the center span of the pulleys with light finger pressure. Over straining is a common cause of blade breakage and other unsatisfactory blade performance. Relax the tension when the machine is not in use.

#### Tracking The Blade

After tension has been applied to the blade, revolve the wheels slowly forward by hand and watch the blade (A) Fig. 19 to see that it travels in the center of the upper tire. If the blade begins to creep toward the front edge, turn the knob to the left and this will tilt the top of the wheel toward the back of the machine and will draw the blade toward the center of the tire. If the blade creeps toward the back edge, turn the knob to the right. Adjust the knob (B) only a fraction of a turn at a time. Never track the blade while the machine is running.

#### Adjusting Upper Blade Guide Assembly

The upper blade guide assembly (D) Fig. 19, should always be set as close as possible to the top surface of the material being cut by loosening lock handle (C) and moving the guide assembly (D) to the desired position.

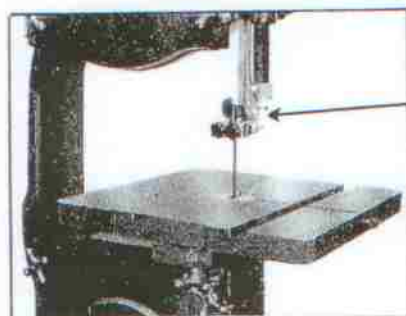
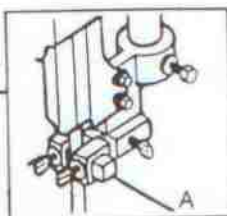


Fig. 20



The upper blade guide assembly should also be adjusted so that the blade guides (A) Fig. 20, are flat with the blade.

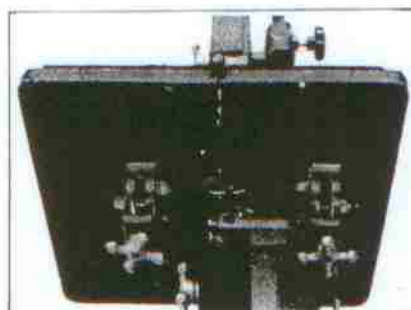


Fig. 17



Fig. 18

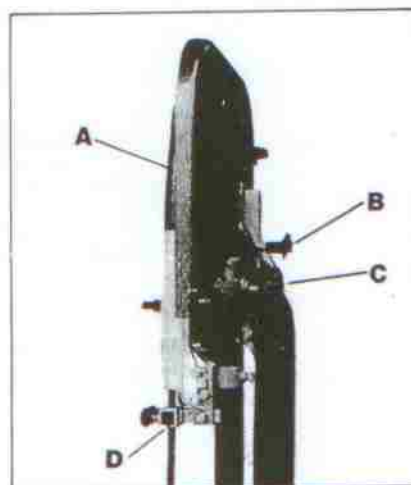


Fig. 19



### Adjusting Upper Blade Guides And Blade Support Bearing

The upper blade guides and blade support bearings are adjusted only after the blade is tensioned and tracking properly. To adjust proceed as follows:

The upper blade guides (A) Fig. 21, are held in place by means of the set screws (B). Loosen the set screws (B) to move the guides (A) as close as possible to the side of the blade, being careful not to pinch the blade. Then tighten the knob screw (B).

The upper blade support bearing (C) Fig. 21, prevents the blade from being pushed too far to the back which could damage the set in the saw teeth. The support bearing (C) should be set  $1/64''$  (0.4m/m) behind the blade by loosening screw (D) to move the support bearing (C) in or out.

The blade support bearing (C) should also be adjusted so the back edge of the blade overlaps the outside diameter of the ball bearing by about  $1/16''$

(1.6m/m). The bearing (C) is set on an eccentric and to change position remove screw (D) and bearing (C) Fig. 21. Loosen screw (D), and reposition shaft that bearing (C) is attached to.

### Adjusting Lower Blade Guide And Blade Support Bearing

The lower blade guides and blade support bearing should be adjusted at the same time as the upper guides and bearing as follows:

Loosen the two screws (B) Fig. 22, and move the guides (A) as close as possible to the side of the blade, being careful not to pinch the blade. Then tighten screws (B).

The lower blade support bearing (C) Fig. 22, should be adjusted so it is about  $1/64''$  (0.4m/m) behind the back of the blade by turning the hex screw (D).

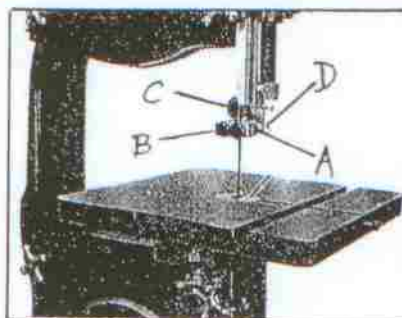


Fig. 21



Fig. 22

## CHANGING BLADES

To change blades, proceed as follows:

1. Remove the upper and lower wheel guards.
2. Release tension on the band saw blade.
3. Remove the table adjustment pin and table insert.
4. Slip the blade off the wheel and guide it out through the slot in the table.
5. To install a new blade, reverse the above procedure.

## BAND SAW BLADES

A band saw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain long use from a band saw blade if you give it fair treatment. Be sure you use blades of the proper thickness, width and temper for the various types of material to be cut.

Always use the widest blade possible. Use the narrow blades only for sawing small, abrupt curves and for fine delicate work. This will save blades and will produce better work. Band saw blades may be purchased, welded, set and sharpened ready for use. For cutting wood and similar materials we can supply them in widths of 1/8" (3.2m/m), 3/16" (4.8m/m), 1/4" (6.4m/m), 3/8" (9.5m/m), 1/2" (12.7m/m), 3/4" (19m/m).

File and set the wood cutting blades whenever you find it requires pressure to make them cut. If a blade is broken it can be brazed or welded; however, if it has become badly work-hardened it will soon break in another place. If you are not equipped to file, set and braze or weld blades take them to a saw filer for reconditioning. Under average conditions, blades should be resharpened after 4 hours of operation.

Any one of a number of conditions may cause a band saw blade to break. Blade breakage is, in some cases, unavoidable, being the natural result of the peculiar stresses to which such blades are subjected. It is, however, often due to avoidable causes, most often to lack of care or judgment on the part of the operator in mounting or adjusting the blade or guides. The most common causes of blade breakage are: (1) faulty alignments and adjustments of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding too fast, (4) dullness of the teeth or absence of sufficient set, (5) excessive tightening of the blade, (6) top guide set too high above the work being cut, (7) using a blade with a lumpy or improperly finished braze or weld and, (8) continuous running of the saw blade when not in use for cutting.

New blades for the standard 14" (356m/m) Band Saw are 93 1/2" (2375m/m) long. The adjustment will accommodate blades up to a maximum length of 94" (2388m/m) and to a minimum length of 91 1/2" (2324m/m). When equipped with the No. 28-984 Height Attachment, new blades should be 105" (2667m/m) long; maximum and minimum lengths are 106" (2692m/m) and 103 1/2" (2629m/m).

## OPERATING THE BAND SAW

Before starting the machine, see that all adjustments are properly made and the guards are in place. Turn the pulley by hand to make sure that everything is correct BEFORE turning on the power.

Keep the top guide down close to the work at all times. Do not force the material against the blade too hard. Light contact with the blade will permit easier following of the line and prevent undue friction, heating and work-hardening of the blade at its back edge.

**KEEP THE SAW BLADE SHARP** and you will find that very little forward pressure is required for average cutting. Move the stock against the blade steadily and no faster than will give an easy cutting movement.

Avoid twisting the blade by trying to turn sharp corners. Remember you must saw around corners.

## CUTTING CURVES

When cutting curves, turn the stock carefully so that the blade may follow without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, either a narrow blade is needed or a blade with more set is required. The more set a blade has, the easier it will allow the stock to be turned, but the cut is usually rougher than where a medium amount of set is used. In withdrawing the piece being cut, in order to change the cut, or for any other reason, the operator must be careful that he does not accidentally draw the blade off the wheels. In most cases it is easier and safer to turn the stock and saw out through the waste material, rather than try to withdraw the stock from the blade.





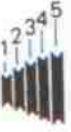



## HOW TO ORDER REPLACEMENT PARTS

Even quality built tools such as the power tool you have purchased, might need occasional replacement parts to maintain it in good working condition over the years. To order replacement parts, contact or write your distributor.

Please give the following information:

1. Model No. and Serial No. and all specifications shown on the Model No./Serial No. plate.
2. Part number or numbers as shown in the Replacement Parts list supplied with your power tool.
3. A brief description of the trouble with the power tool.

# **TECHNICAL DATA**

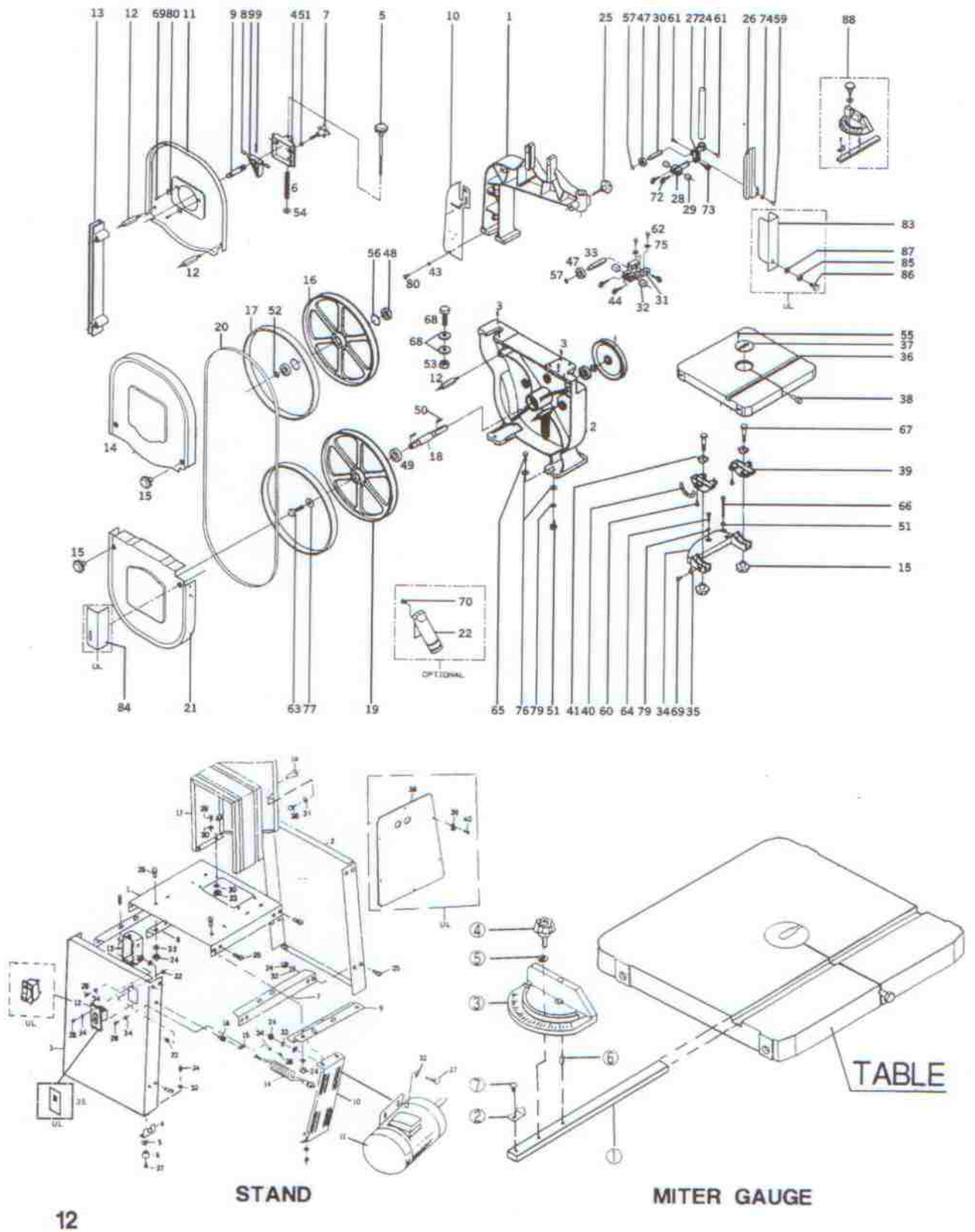
SPEED		SINGLE	TWO	FOUR
SPINDLE PULLEY (A)				
	MIDDLE PULLEY (B)			
	MOTOR PULLEY (C)			
SPINDLE SPEED R.P.M. (60 Hz)		753	210	170.5
			774	289.5
				459.2
				703.5
SAW BLADE m/min • ft/min		908 • 2760	253 • 770	190.5 • 625.1
			993 • 2837	323.5 • 1061.3
				513.1 • 1683.2
				786 • 2578.4
BELT		A-C (A55)	A-B1, B2-C1 (A22, A44)	A-B1 B5-C1 (A22, A42)
			A-C2 (A55)	A-B1 B4-C2 (A22, A42)
				A-B1 B3-C3 (A22, A42)
				A-B1 B2-C4 (A22, A42)



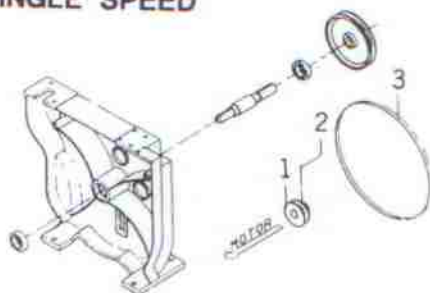
## TROUBLE SHOOTING GUIDE

Problem: Motor won't start.	<ul style="list-style-type: none"> <li>(a) Band Saw is not plugged in.</li> <li>(b) Household circuit has blown fuse or open circuit breaker</li> <li>(c) Power cord is damaged. Replace.</li> <li>(d) Switch is not in "on" position.</li> <li>(e) Motor requires service.</li> </ul>
Band Saw blade does not move although motor is running.	<ul style="list-style-type: none"> <li>(a) Blade tension knob is not tight. Turn motor off. Tighten knob. Restart band saw.</li> <li>(b) Blade has slipped off pulley wheel. Open cover housing and check.</li> <li>(c) Blade is broken. Replace blade.</li> </ul>
Blade will not cut or cuts slowly.	<ul style="list-style-type: none"> <li>(a) Teeth have been dulled by contact with hardened steels or long usage. Replace blade.</li> <li>(b) Use higher speed setting (for wood).</li> <li>(c) Blade mounted backwards.</li> </ul>
Sawdust fills up inside of band saw.	<ul style="list-style-type: none"> <li>(a) This is normal – clean out periodically.</li> <li>(b) Remove cover housing. Use vacuum cleaner to remove sawdust.</li> </ul>
Sawdust in motor housing.	<ul style="list-style-type: none"> <li>(a) Use vacuum cleaner nozzle on air intake and exhaust grilles.</li> <li>(b) Keep workplace cleaner. Clean up excess sawdust frequently.</li> </ul>
Unable to get blade to track in driver of wheel.	<ul style="list-style-type: none"> <li>(a) Backing bearing not properly adjusted.</li> <li>(b) Tension wheel not properly adjusted.</li> <li>(c) Bad blade, Replace blade.</li> </ul>

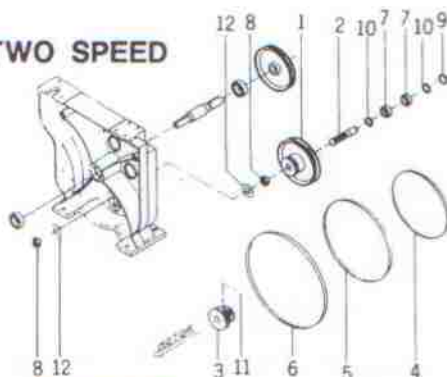
# ASSEMBLY DIAGRAM & PARTS LIST



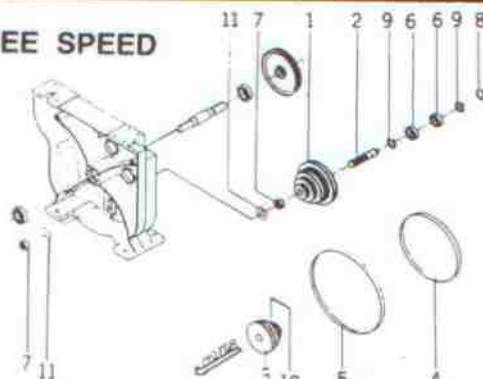
## SINGLE SPEED



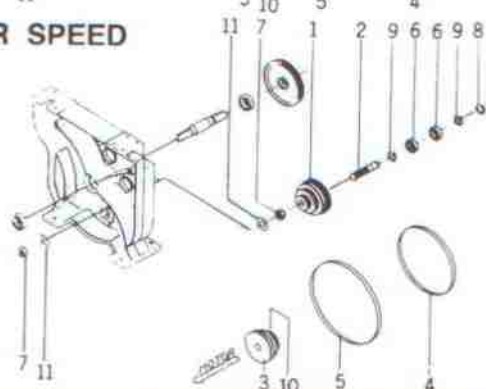
## TWO SPEED



## THREE SPEED



## FOUR SPEED



## SAW BODY

Key No.	Part No.	Description	Size	Q'ty	Key No.	Part No.	Description	Size	Q'ty
1	110001	Upper Frame Arm		1	45				
2	110034	Base		1	46				
3	150031	Pin		4	47	BB620002	Bearing	6200ZZ	2
4	100016	Upper Wheel Sliding Bracket		1	48	BB620201	Bearing	6202Z	2
5	100014	Blade Adjusting Screw		1	49	BB620401	Bearing	6204Z	2
6	100015	Coil Spring		1	50	KP050520	Key	5x5x20	2
7	990633	Knob-Bolt	M8 x 45	1	51	NH081300	Nut	M8	6
8	100021	Steel Pin		2	52	NH121901	Nut	M12x1.25	1
9	A100019	Upper Wheel Shaft Hinge (Assem) #		1	53	NH162400	Nut	M16	1
10	160226	Side cover (UL)		1	54	150090	Square Nut	M10	1
11	100028	Upper Wheel Guard (Inner)		1	55	PS030800	Spring Pin	φ3x8	1
12	100027	Stud		4	56	RR350000	Retaining Ring	R35	2
13	110070	Blade Guard (L)		1	57	RS100000	Retaining Ring	S10	2
14	100029	Upper Wheel Guard (Outer)		1	58	RS200000	Retaining Ring	S20	1
15	100030	Knob	M10	6	59	SH060200	Hex Head Bolt	M6x10	2
16	198240	Upper Wheel		1	60	SH069300	Hex Head Bolt	M6x12	6
17	100025	Wheel Tire		2	61	SH069400	Hex Head Bolt	M6x16	2
18	110065	Lower Wheel Shaft		1	62	SH060400	Hex Head Bolt	M6x20	2
19	198670	Lower Wheel		1	63	SH080402	Hex Head Bolt	M8x20(L)	1
20	100036	Saw Blade 6TPI 92.5" x 3/8" x 0.5mm		1	64	SH080800	Hex Head Bolt	M8x30	2*
21	100069	Lower Wheel Guard		1	65	SH081600	Hex Head Bolt	M8x40	4*
22	142055	Dust Chute (OPTIONAL) \$		1	66	SH081600	Hex Head Bolt	M8x80	1*
23	100063	Belt Pulley		1	67	SH101003	Hex Head Bolt	M10x50	2
24	110004	Guide Post		1	68	SH161100	Hex Head Bolt	M16x55	1
25	990644	Knob-Bolt	M10 x 25	1	69	SF059100	Pan Head Bolt W/Flange	M5x6	3
26	100002	Blade Guard (R)		1	70	SF069200	Pan Head Bolt W/Flange	M6x8	2*
27	110007	Guide Supportor Bracket		1	71	SS060200	Set Screw	M6x10	1
28	100006	Blade Guide Supportor		1	72	150014	Thumb Bolt	M6x12	2
29	150011	Blade Guide		2	73	150013	Thumb Bolt	M6x16	1
30	100007	Upper Spacing Sleeve		1	74	WF061310	Flat Washer	M6xφ13	2
31	110055A	Lower Guide Supportor		1	75	WF061620	Flat Washer	M6xφ16	2*
32	150011	Blade Guide		2	76	WF081818	Flat Washer	M6xφ18	8*
33	100007	Spacing Sleeve (Lower)		1	77	WF083030	Flat Washer	M8xφ30	1
34	110045	Trunnion Support Bracket		1	78	WF164030	Flat Washer	M16xφ40	2
35	110049	Pointer		1	79	WS080000	Spring Washer	M8	6*
36	198390	Table \$		1	80	SP050200	Pan Head Bolt	M5x10	1
37	199037P	Table Insert \$		1	81				
38	100038	Table Pin		1	82				
39	100042	Trunnion		1	83	113075	Upper Guide Cover (UL)		1
40	100051	Scale		1	84	113080	Lower Guide Cover (UL)		1
41	100041	Trunnion Clamp Shoe		2	85	NH101700	Nut (UL)	M10	1
42	AB100083	Miter Gauge (Assem.) #		1	86	SH100400	Hex. Head Bolt (UL)	M10x20	1
43	WF051210	Flat Washer		1	87	WF102025	Flat Washer (UL)	M10xφ20	1
44									

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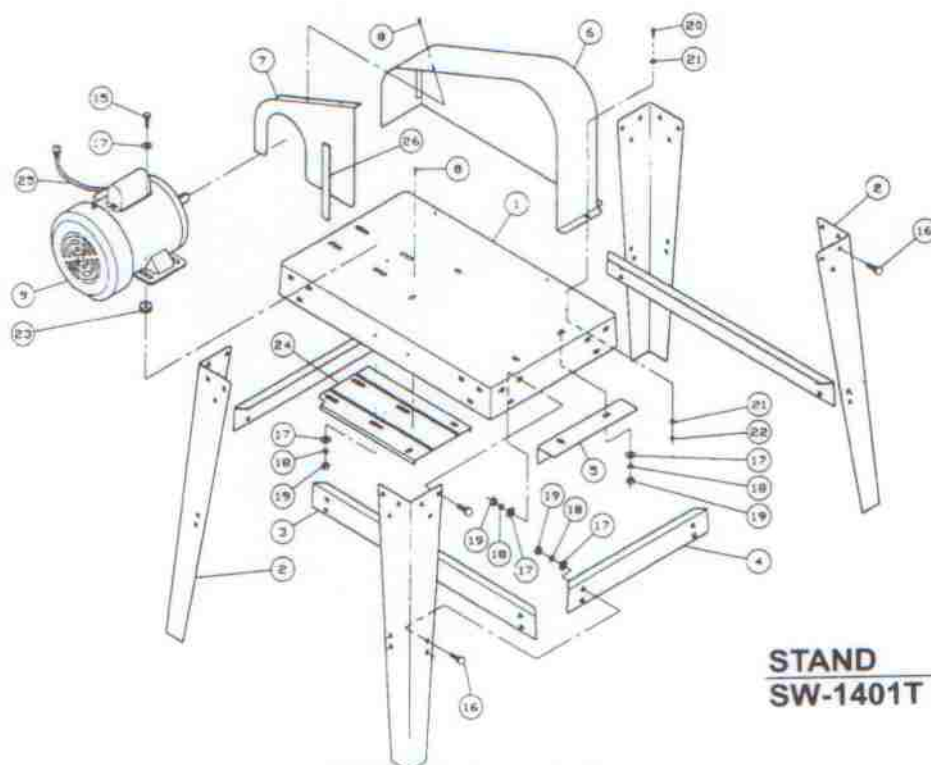
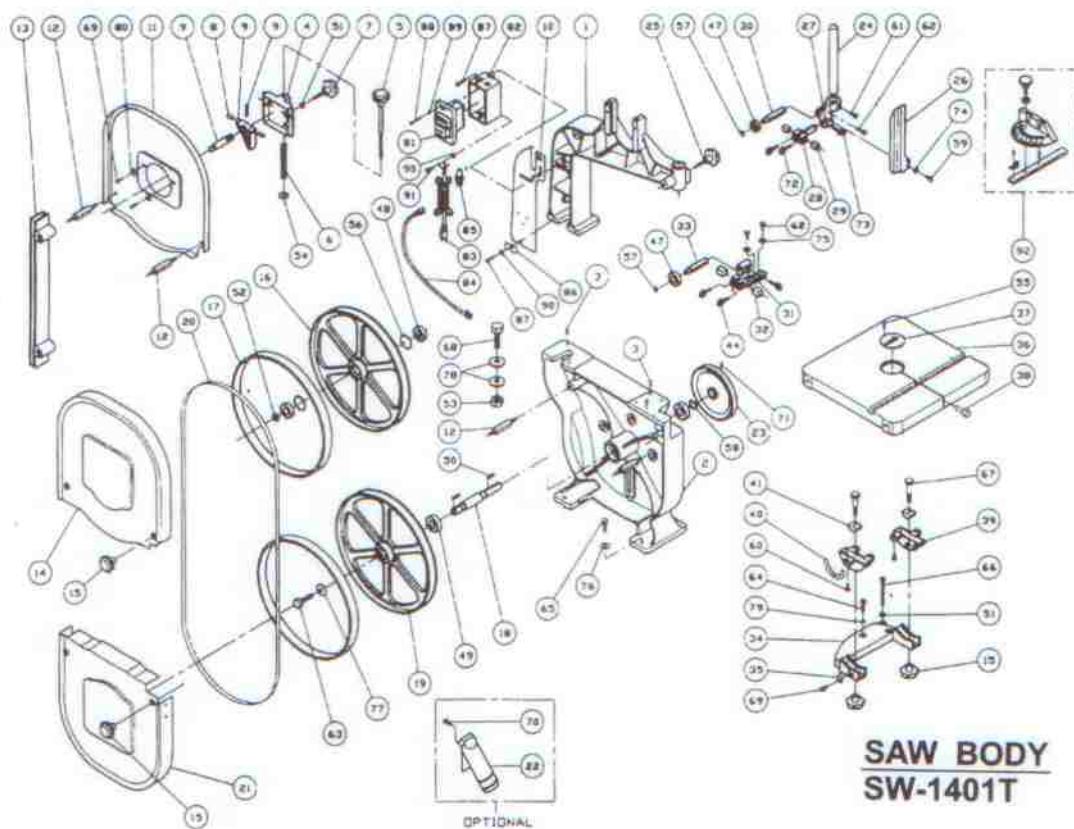


# STAND

Key No.	Part No.	Description	Size	Q'ty	Key No.	Part No.	Description	Size	Q'ty
1	113101	Face Plate		1	21				
2	113102	Stand(Front)		1	22	991213	Nut	3/16"	2
3	113103	Stand(Back)		1	23	991110	Nut	M5	4 *
4	998529	Lock Piece		4	24	991112	Nut	M8	32 *
5	991705	Washer(Special)		4	25	991516	Carriage Bolt	M8×16	24 *
6	998632	Rubber Pad		4	26	990112	Hex Head Bolt	M6×12	1 *
7	600104	Support Plate		2	27	990133	Hex Head Bolt	M8×25	8 *
8	600108	Stiffening Plate		1	28	990855	Pan Head bolt	3/16"×1/2"	6
9	600109	Motor Plate Bracket		1	29	990825	Pan Head Bolt	M5×12	4 *
10	600107	Motor Plate		1	30	991710	Flat Washer	M5×φ10	8 *
11		Motor	\$	1	31	991731	Flat Washer	M6×φ16	1 *
12	994532	Switch (UL)	\$	1	32	991743	Flat Washer	M8×φ18	36 *
	998639(UL)	Switch Enclose	\$	1	33	991931	Lock Washer	M8	4 *
13	998638	Switch Enclose	\$	1	34	991881	Star Washer	M5	6 *
14		Power cord	\$	1	35	998526	Switch Plate(UL)\$		1
15	998625	Wire Clip		1	36				
16					37				
17	AB100111	Pulley Case		1	38	679113	Side Panel (UL)		2
18	998634	Knob		1	39	998640	Relief Stop (UL)		12
19					40	990811	Tapping Screw (UL)	M3.5×12	12
20									

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KeyNo.	Part No.	Description	Size	Q'ty	KeyNo.	Part No.	Description	Size	Q'ty
<b>SINGLE SPEED</b>					8	992522	Retaining Ring	R35	1
1	600013	Motor Pulley		1	9	992545	Stop Ring	S15	2
2	993021	V-Belt	A55	1	10	990721	Set Screw	M6×10	1
3	990721	Set Screw	M6×10	1	11	991851	Flat Washer	M16×φ40	2
<b>TWO SPEED</b>					<b>FOUR SPEED</b>				
1	120209	Middle Pulley		1	1	140409	Middle Pulley		1
2	120203	Middle Pulley Shaft		1	2	120203	Middle Pulley Shaft		1
3	120210	Motor Pulley		1	3	140410	Motor Pulley		1
4	993011	V-Belt	A22	1	4	993011	V-Belt	A22	1
5	993019	V-Belt	A44	1	5	993017	V-Belt	A42	1
6	993021	V-Belt	A55	1	6	994011	Bearing	62022	2
7	994011	Bearing	62022	2	7	991411	Nut	M16	2
8	991411	Nut	M16	2	8	992522	Retaining Ring	R35	1
9	992522	Retaining Ring	R35	1	9	992545	Stop Ring	S15	2
10	992545	Stop Ring	S15	2	10	990721	Set Screw	M6×10	1
11	990721	Set Screw	M6×10	1	11	991851	Flat Washer	M16×φ40	2
12	991851	Flat Washer	M16×φ40	2	<b>MITER GAUGE (ASSEM)</b>				
<b>THREE SPEED</b>					<b>AMG - 110</b>				
1	153009	Middle Pulley		1	1	100082	Guide Bar		1
2	120203	Middle Pulley Shaft		1	2	100085	Pointer		1
3	153010	Motor Pulley		1	3	100083	Gauge Body		1
4	993011	V-Belt	A22	1	4	990621	Knob	1/4"×3/4"	1
5	993017	V-Belt	A42	1	5	990867	Pan Head Bolt	#8×1/4"	1
6	994011	Bearing	62022	2	6	991732	Flat Washer	M6×φ16	1
7	991411	Nut	M16	2					



KeyNo.	Part No.	Description	Size	Qty	KeyNo.	Part No.	Description	Size	Qty
<b>SAW BODY</b>					47	BB620002	BEARING	6200ZZ	2
1	110001	UPPER ERAME ARM		1	48	BB620201	BEARING	6202Z	2
2	110034	BASE		1	49	BB620401	BEARING	6204Z	2
3	150031	PIN		4	50	KP050520	KEY	5X5X20	2
4	100016	UPPER WHEEL SLIDING BRACKET		1	51	NH081300	NUT	M8	2
5	100014	BLADE ADJUSTING BRACKET		1	52	NH121901	NUT	M12X1.25	1
6	100015	COIL SPRING		1	53	NH162400	NUT	M16	1
7	990633	KNOB-BOLT	M8X45	1	54	150090	SQUARE NUT	M10	1
8	100021	STEEL PIN		2	55	PS030800	SPRING PIN	3X8	1
9	AB100019	UPPER WHEEL SHAFT HINGE (ASM)		1	56	RR350000	RETAINING RING	R35	2
10	160226	SIDE COVER		1	57	RS100000	RETAINING RING	S10	2
11	100028	UPPER WHEEL GUARD (INNER)		1	58	RS200000	RETAINING RING	S20	1
12	100027	STUD		4	59	SH060200	HEX HEAD BOLT	M6X10	2
13	110070	BLADE GUARD (L)		1	60	SH069300	HEX HEAD BOLT	M6X12	6
14	100029	UPPER WHEEL GUARD (OUTER)		1	61	SH069400	HEX HEAD BOLT	M6X16	2
15	100030	KNOB	M10	6	62	SH060400	HEX HEAD BOLT	M6X20	2
16	198240	UPPER WHEEL		1	63	SH080402	HEX HEAD BOLT	M8X20(LH)	1
17	100025	WHEEL TIRE		2	64	SH080600	HEX HEAD BOLT	M8X30	2
18	110065	LOWER WHEEL SHAFT		1	65	SH080800	HEX HEAD BOLT	M8X40	4
19	198670	LOWER WHEEL		1	66	SH081600	HEX HEAD BOLT	M8X80	1
20	100036	SAW BLADE	6TPH 92.5"X18"X10.5MM	1	67	SH101003	HEX HEAD BOLT	M10X50	2
21	100069	LOWER WHEEL GUARD		1	68	SH161100	HEX HEAD BOLT	M16X55	1
22	142055	DUST CHUTE		1	69	SF059100	PAN HEAD BOLT W/FLANGE	M5X6	3
23	100063	BELT PULLEY		1	70	SF069200	PAN HEAD BOLT W/FLANGE	M6X8	2
24	110004	GUIDE POST		1	71	SS060200	SET SCREW	M6X10	1
25	990644	KNOB-BOLT	M10X25	1	72	150014	THUMB BOLT	M6X12	2
26	100002	BLADE GUARD (L)		1	73	150013	THUMB BOLT	M6X16	1
27	110007	GUIDE SUPPPORTER BRACKET		1	74	WF061310	FLAT WASHER	M6X13	2
28	100006	BLADE GUIDE SUPPORTOR		1	75	WF061620	FLAT WASHER	M6X16	2
29	150011	BLADE GUIDE		2	76	WF081818	FLAT WASHER	M6X18	4
30	100007	UPPER SPACING SLEEVE		1	77	WF083030	FLAT WASHER	M6X30	1
31	110055A	LOWER GUIDE SUPPORTOR		1	78	WF164030	FLAT WASHER	M6X40	2
32	150011	BLADE GUIDE		2	79	WS080000	SPRING WASHER	M8	2
33	100007	UPPER SPACING SLEEVE		1	80				
34	110045	RUNNNION SUPPORT BRACKET		1	81	994542	SWITCH		1
35	110049	POINTER		1	82	523028	SWITCH ENCLOSE		1
36	198390	TABLE		1	83	999910	POWER CORD		1
37	113037	TABLE INSERT		1	84	995003	POWER CORD (SWITCH TO MOTOR)		1
38	100038	TABLE PIN		1	85	998654	WIRE CLIP		2
39	100042	TRUNNION		2	86	170244	STRAIN RELIEF		1
40	100051	SCALE		1	87	SP059300	PAN HEAD BOLT	M5X12	3
41	100041	TRUNNION CLAMP SHOE		1	88	ST030404	TAPPING SCREW	M3.5X19 (AB)	2
42					89	WF040808	FLAT WASHER	M6X8	2
43					90	WE050000	STAR WASHER (EXTERNAL)	M5	2
44	150014	THUMB SCREW	M6X12	3	91	SP059100	PAN HEAD BOLT	M5X6	1
45					92	AB100083	MITER GAUGE (ASM)		1
46									



Key No.	Part No.	Description	Size	Q'ty	Key No.	Part No.	Description	Size	Q'ty
<b>STAND</b>					<b>SINGLE SPEED</b>				
1	150602	Face Plate		1	1	600013	Motor Pulley		1
2	150624	Support Bracket		1	2	993014	V-Belt	A39	1
3	150603	Leg		4	3	990721	Set Screw	M6×10	1
4	150604	Support Brace(Long)		2	<b>TWO SPEED</b>				
5	150605	Support Brace(Short)		2	1	120209	Middle Pulley		1
6	150606	Support Plate(Top)		1	2	120203	Middle Pulley Shaft		1
7	150607	Pulley Case		1	3	120210	Motor Pulley		1
8	150608	Pulley Case (Inner)		1	4	993011	V-Belt	A22	1
9	150627	Pad		1	5	993019	V-Belt	A44	1
10	M110	Motor		1	6	993014	V-Belt	A39	1
11	995004	Motor Cord		1	7	994011	Bearing	6202Z	2
12	150623	Rubber Mount		4	8	991411	Nut	M16	2
13					9	992522	Retaining Ring	R35	1
14					10	992545	Stop Ring	S15	2
15					11	990721	Set Screw	M6×10	1
16	991110	Nut	M5	3 *	12	991851	Flat Washer	M16×φ40	2
17	991112	Nut	M8	44 *	<b>THREE SPEED</b>				
18	991516	Carriage Bolt	M8×16	40 *	1	153009	Middle Pulley		1
19	990135	Hex Head Bolt	M8×35	4 *	2	120203	Middle Pulley Shaft		1
20	990825	Pan Head Bolt	M5×12	3 *	3	153010	Motor Pulley		1
21	990804	Tapping Screw	M4×10	5	4	993011	V-Belt	A22	1
22	991710	Flat Washer	M5×φ10	6 *	5	993017	V-Belt	A38	1
23	991743	Flat Washer	M8×φ18	48 *	6	994011	Bearing	6202Z	2
24	991931	Lock Washer	M8	44 *	7	991411	Nut	M16	2
25					8	992522	Retaining Ring	R35	1
26					9	992545	Stop Ring	S15	2
27					10	990721	Set Screw	M6×10	1
28					11	991851	Flat Washer	M16×φ40	2
29									
30									

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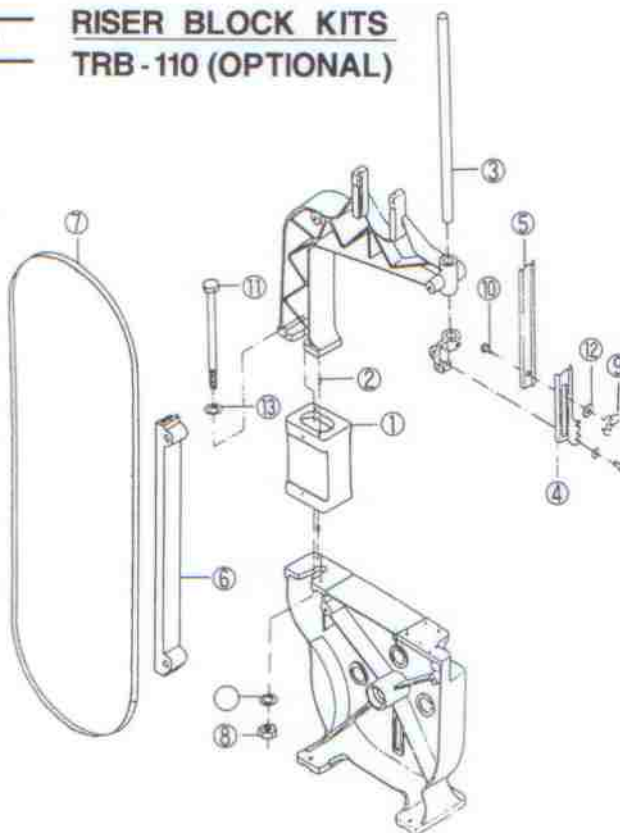
Key No.	Part No.	Description	Size	Q'ty
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## RISER BLOCK KITS TRB - 110 (OPTIONAL)

### RISER BLOCK KIT

#### TRB - 110

1	199189	Riser Block		1
2	150031	Pin		2
3	199198	Guide Post		1
4	199102	Upper Wheel Blade Guard(U)		1
5	199199	Upper Wheel Blade Guard (L)		1
6	173106	Blade Guard		1
7	199196	Saw Blade	6TPI 3/8"×105"×0.5mm	1
8	991415	Nut	5/8"×11UNC	1
9	998496	Wing Nut	M8	1
10	991516	Carriage Bolt	M8×16	1
11	990265	Hex Head Bolt	5/8"×11UNC×8-1/2"	1
12	991743	Flat Washer	M8×φ18	1
13	991851	Flat Washer	M16×φ40	2



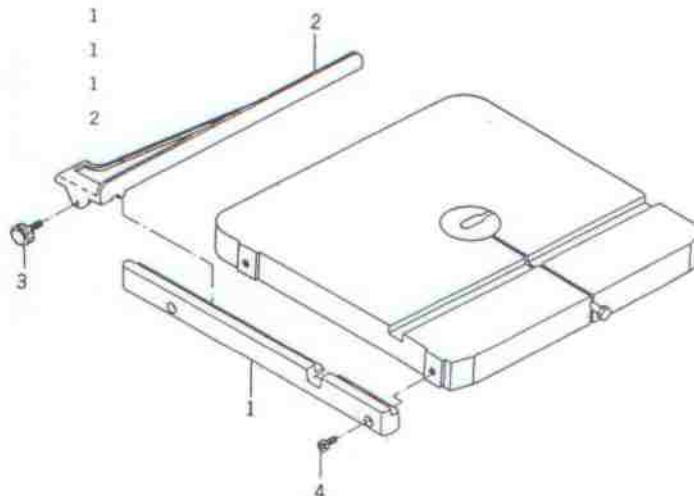
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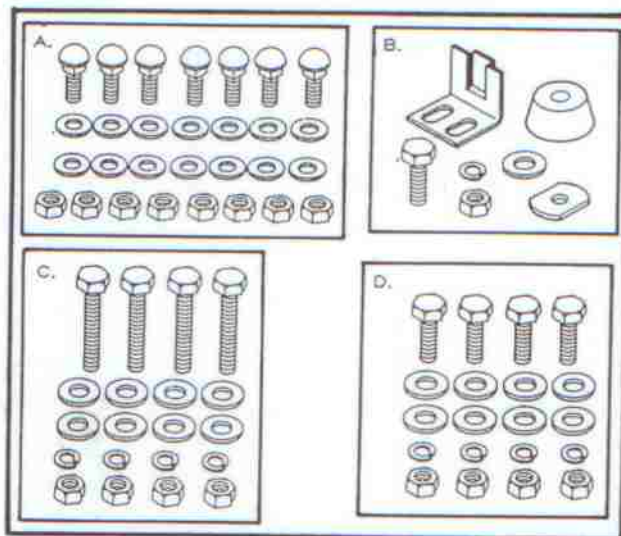
## RIP FENCE - A TRF - 110 (OPTIONAL)

### RIP FENCE-A

#### TRF - 110

1	199184	Guide Bar		1
2	199185	Fence		1
3	990671	Knob-Bolt	M6×20	1
4	990323	Hex. Socket Bolt	M6×20	2





A. Stand Assembly (partial quantity show)

- 24—M8×16 carriage bolts
- 24—M8 washers
- 24—M8 nuts

B. Stand Assembly—Rubber Pads (partial quantity show)

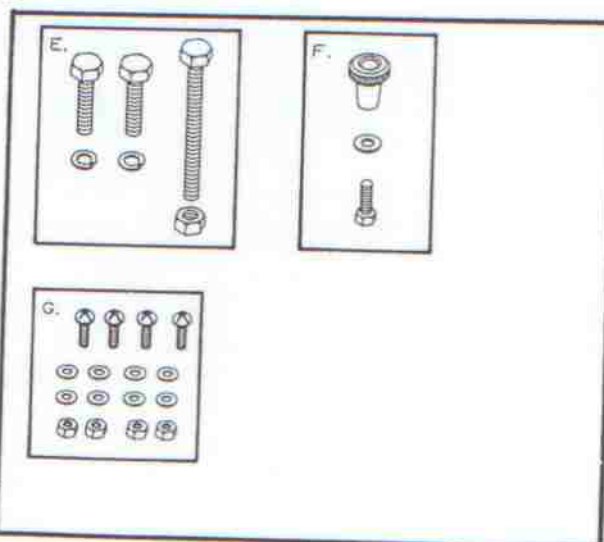
- 4—Lock pieces
- 4—Rubber Pads
- 4—M8×25 Hex Bolts
- 4—M8 Washers
- 4—M8 Spring Washers
- 4—Flat Washers

C. Install Saw Body To Stand

- 4—M8×40 Hex Bolts
- 4—M8 Nuts
- 4—M8 Spring Washer
- 8—M8 Washers

D. Install Motor To Stand

- 4—M8×25 Hex Bolts
- 4—M8 Nuts
- 4—M8 Spring Washers
- 8—M8 Washers



- E. Install Trunnion Bracket To Saw Body
- 2—M8×30 Hex Bolts
  - 2—M8 Spring Washers
  - 1—M8×80 Hex Bolt (Table Stop Bolt)
  - 1—M8 Nut (For Table Stop Bolt)

F. Knob To Pulley Case Door

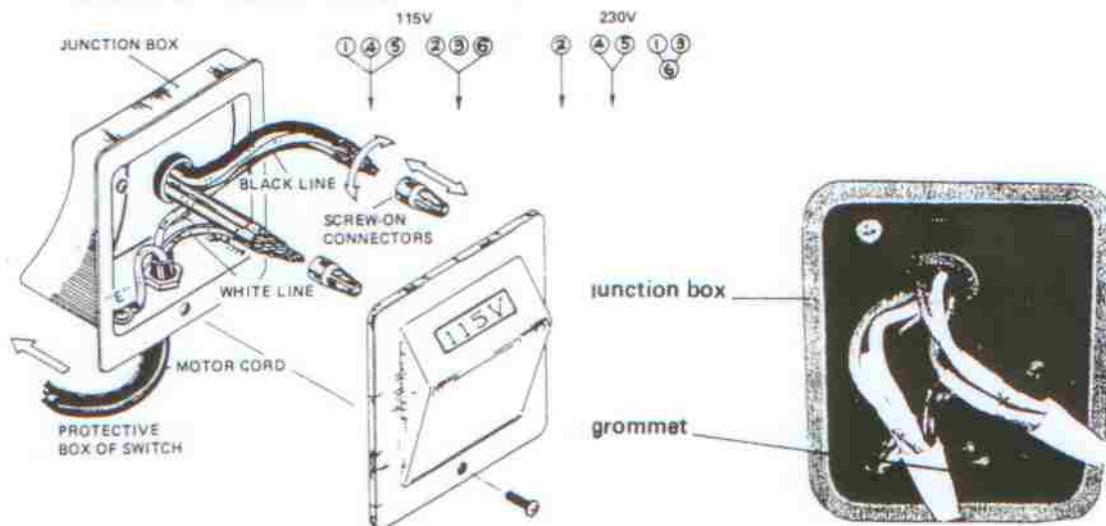
- 1—M6 Knob
- 1—M6 Washer
- 1—M6×12 Hex Bolt

G. Install Pulley Case To Stand

- 4—M×15 Pan Head Screw
- 8—M55 Washers
- 4—M5 Nuts



## PICTURE OF MOTOR LEAD



### Trouble Shooting Guide

1. Problem: Motor won't start.  
Possible Causes or Solutions:
  - (a) Band Saw is not plugged in.
  - (b) Household circuit has blown fuse or open circuit breaker.
  - (c) Power cord is damaged. Replace.
  - (d) Switch is not in "on" position.
  - (e) Motor requires service.
2. Band Saw blade does not move although motor is running.
  - (a) Blade tension knob is not tight. Turn motor off. Tighten knob. Restart band saw.
  - (b) Blade has slipped off pulley wheel. Open cover housing and check.
  - (c) Blade is broken. Replace blade.
3. Blade will not cut or cuts slowly.
  - (a) Teeth have been dulled by contact with hardened steels or long usage. Replace blade.
  - (b) Use higher speed setting (for wood).
  - (c) Blade mounted backwards.
4. Sawdust fills up inside of band saw.
  - (a) This is normal-clean out periodically.
  - (b) Remove cover housing. Use vacuum cleaner to remove sawdust.
5. Sawdust in motor housing.
  - (a) Use vacuum cleaner nozzle on air intake and exhaust grilles.
  - (b) Keep workplace cleaner. Clean up excess sawdust frequently.
6. Unable to get blade to track in driver of wheel.
  - (a) Backing bearing not properly adjusted.
  - (b) Tension wheel not properly adjusted.