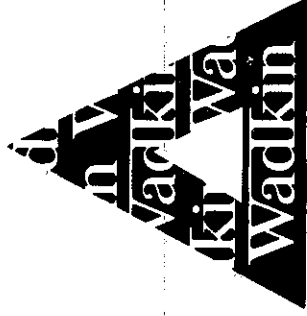


B7000/B8000 BANDSAWS

Instruction Manual



HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

WADKIN LTD., supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the user's responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.
2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.
3. Only personnel trained in the safe use of a machine should operate it.
4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.
5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

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B700/B800 BANDSAW

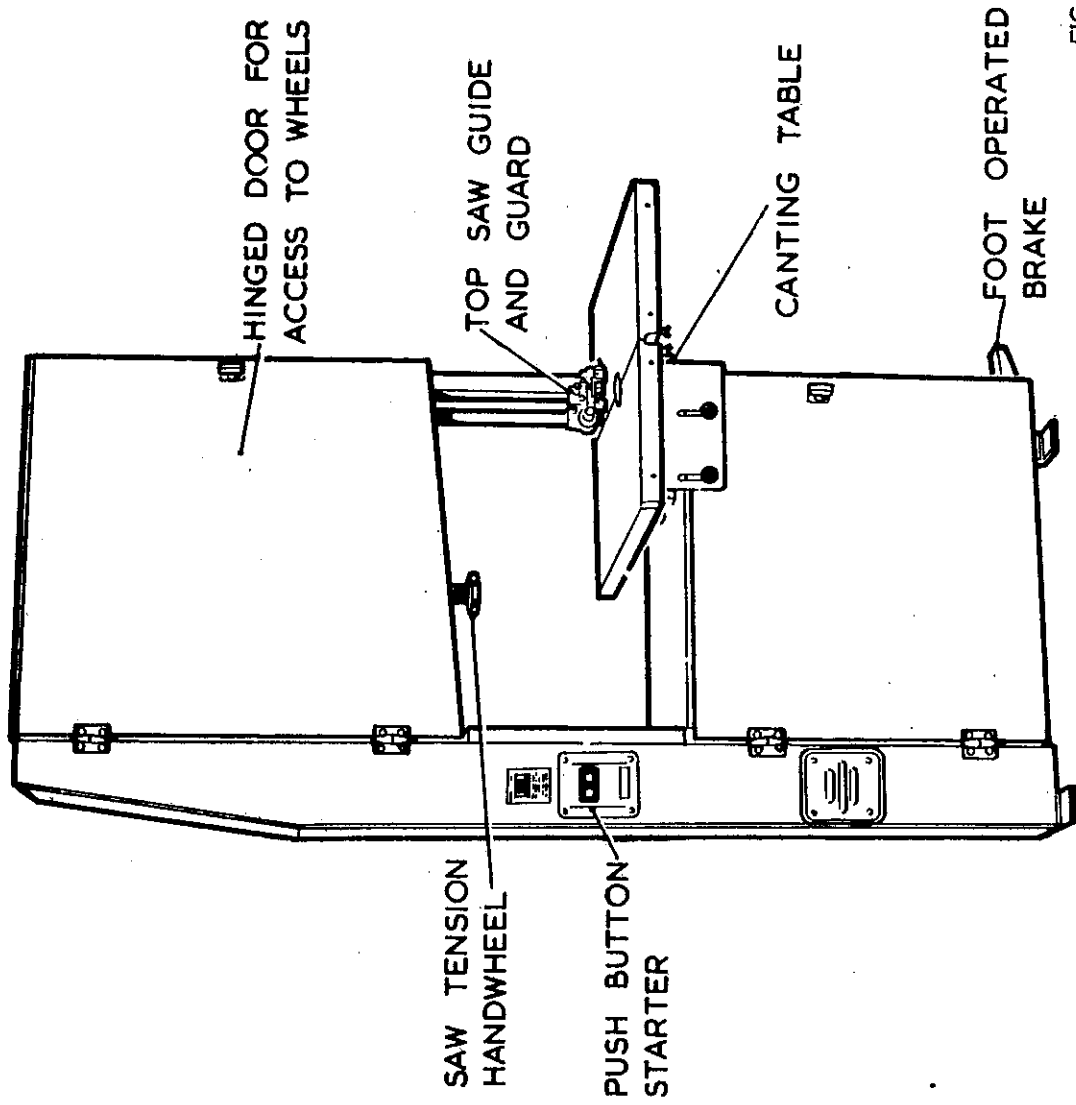


FIG. 1

SPECIFICATION

	8700	8800
Diameter of wheels	28" (700mm)	32" (800mm)
Width of wheels	1 1/2" (44mm)	1 3/4" (44mm)
Width of sawblade (max)	1 3/4" (32mm)	1 1/2" (38mm)
Length of saw (max)	16' - 4 1/2" (5000mm)	17' - 10 1/2" (5450mm)
Length of saw (min)	15' - 10" (4826mm)	17' - 4" (5285mm)
Depth under saw guide (max)	13 3/4" (346mm)	14" (355mm)
Distance of saw to body	27" (685mm)	30.5" (774mm)
Size of table	30 X 30" (762 X 762mm)	30" X 30" (762 X 762mm)
Table cants	45° to right 10° to left	45° to right 10° to left
Height of table from floor	37 1/2" (952mm)	39 1/2" (995mm)
Total height of machine	86 1/2" (2180mm)	92 1/2" (2350mm)
Speed of saw	5,500 ft/min (1676m/min)	5950 ft/min (1806 m/min)
Motor	3hp (2.2 kW)	5hp (3.7 kW) or 7.5hp (5.5 kW)
Speed of motor (50 Hz)	750 rev/min	700 rev/min
Speed of motor (60 Hz)	900 rev/min	850 rev/min
Net weight	760 lb (345 kg)	860 lb (390 kg)

INSTALLATION

Remove protective coating from bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

When the machine is cased for export the table is removed and packed individually. Remove and reassemble as shown in Fig.1.

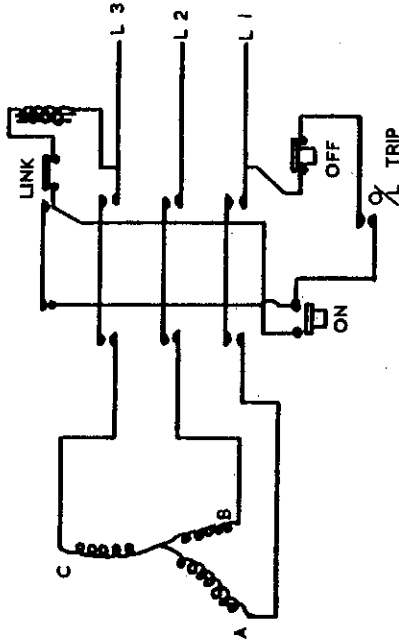


FIG.2
WIRING DIAGRAM FOR THREE PHASE SUPPLY

WIRING DETAILS

The motor and control gear have been all wired before despatch and all that remains is to connect the correct power supply to the starter.

Points to note when connecting power supply

1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
2. It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.
3. Check the main line fuses are the correct capacity. See table below.
4. Connect the line leads to the appropriate terminals. See Fig. 2 for three phase supply.
5. Check all connections are sound.
6. Check motor rotation for the correct direction. If this is incorrect, reverse any two of the line lead connections.

For single phase supply refer to booklet supplied with the starter for wiring details.

VOLTAGE	PHASE	S.W.G. TINNED COPPER WIRE	AMPS
3	3	25	15
3	3	25	15
3	3	22	24

LUBRICATION

It is advisable to keep all bright parts covered with a thin film of oil to prevent corrosion. Clean sawdust from inside main frame weekly. See Fig. 3 for lubrication points.

- OIL RECOMMENDED POWER ER.125.
- GREASE RECOMMENDED SHELL ALVANIA 3.

FOUNDATION

See Fig. 4 for bolt positions and clearance required. When installing the machine, level the table by packing under the base. Foundation bolts are not supplied with the machine except to special order.

DUST EXTRACTION

The machine has a built-in dust chute with a 32" (95mm) X 24" (64mm) rectangular exhaust outlet and can be connected to dust extraction plant if desired.

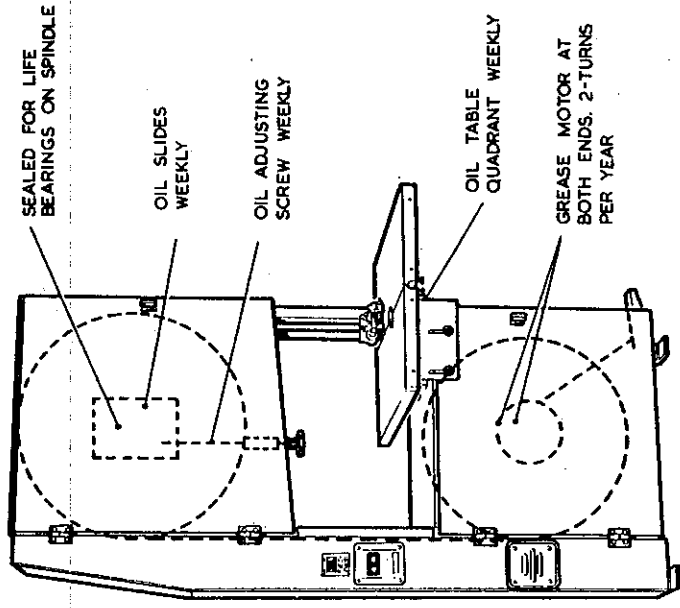


FIG.3
LUBRICATION CHART

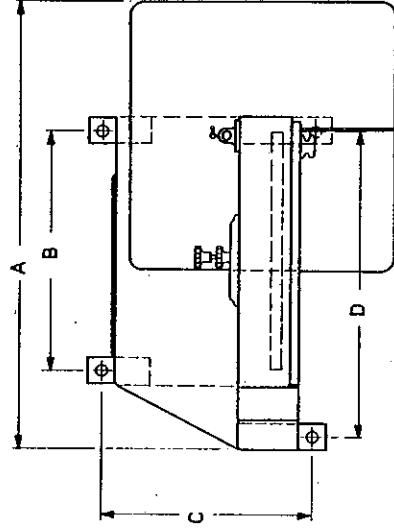


FIG.4

	8700	8800
A	51.3" (1302mm)	55" (1397mm)
B	27.7" (705mm)	31.75" (806mm)
C	24.2" (616mm)	26.5" (673mm)
D	35.38" (899mm)	39.38" (1000mm)

FITTING BANDSAW BLADES

Proceed as follows:

1. Open top and bottom doors of the main frame and ensure the table is in the horizontal position.
2. Loosen the wingnuts on the underside of the table directly below the slot at the front of the table. Swing table keep plate clear of the slot so the sawblade can be inserted.
3. Remove sawguard and move the top and bottom guides to the extreme rear position by loosening locking screws 'A' for top guide (Fig. 6) and 'A' for bottom guide (Fig. 8).
4. Lower top wheel assembly sufficient to allow the blade to be placed on both wheels easily.
5. Insert sawblade through slot in front of table and position blade on top and bottom wheels. Care should be taken to ensure that the blade is free in the guides. Check the cutting rake of teeth are positioned downwards at the cutting point. To reverse direction of cutting rake turn blade inside out.

Turn tensioning handwheel until blade is just held on the wheels.

TRACKING OF SAWBLADE ON WHEELS

Every sawblade has slightly different running characteristics on a bandsaw machine due to the condition of the steel ribbon it is made from, the blade joints and the tension in the blade-ribbon. This is compensated for by using a crowned or slightly curved rubber face on the wheels and providing the top wheel with a slight tilting movement.

To check the tracking of the sawblade the undermentioned procedure should be followed:

1. Rotate the top wheel slowly by hand in a clockwise direction and check the blade is running central on the wheels.
2. If not running central, loosen handwheel 'A' (Fig. 5) and adjust handwheel 'B' until the saw is tracking correctly i.e. in the centre of both wheels.
3. When tracking correctly, re-lock handwheel 'A'. This adjustment is most important as when the sawblade is tracking correctly it passes in a straight line between the top and bottom wheels and does not snake. When the latter occurs the back of the sawblade keeps hitting the back guide roller and causes damaged guides.

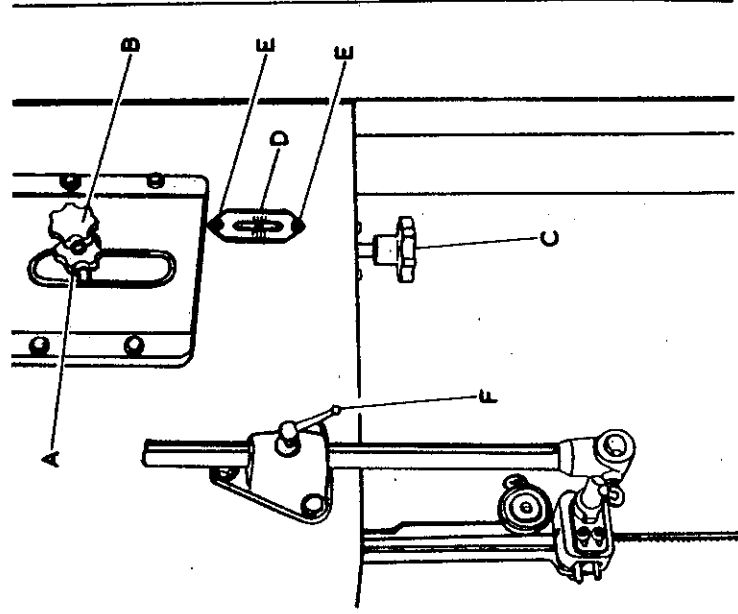


FIG.5

TENSIONING

To tension the sawblade turn handwheel 'C' in Fig. 5 until the correct tension is reached according to the scale 'D'. The scale gives the correct tension for the width of blade which is being used irrespective of the length of the blade.

Incorrect tension or tightness of the sawblade over the wheels will result in saw breakages. Always use the tension indicator to achieve maximum blade life.

The scale and pointer are accurately set before despatch from the works. Should this be displaced for any reason check the scale as follows:

1. Tension the sawblade as previously described until it can be pulled $\frac{1}{16}$ " (6mm) from its true line at a central point between the two wheels.
2. Check whether the scale indicates the correct sawblade width. If scale is incorrect, loosen two screws 'G' in Fig. 5 and position scale correctly. When set tighten all screws. After the scale has been set in this manner it will read correctly for any width of blade within the range of the machine without further alteration, even if the length of sawblade varies for any given width. For a $\frac{3}{4}$ " blade the pointer should read $\frac{3}{4}$ " etc.

If the machine is left standing e.g. overnight, the tension should be reduced, and the blade re-tensioned before putting the machine into operation again.

SETTING GUIDES

On this machine, guides of similar design are fitted above and below the table. Each guide is fitted with long life roller bearings. After the blade is tracking perfectly, proceed to set the guides as follows:

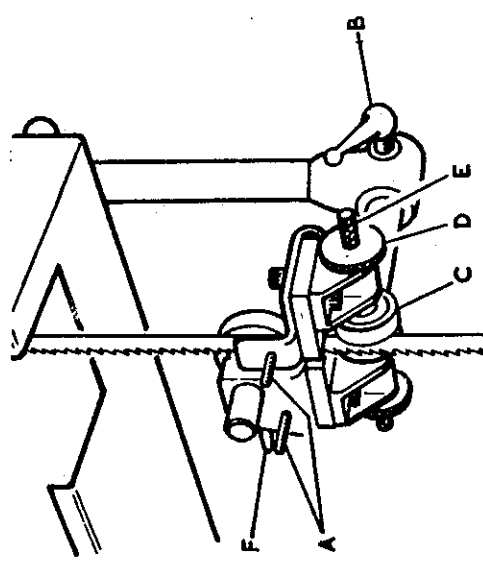
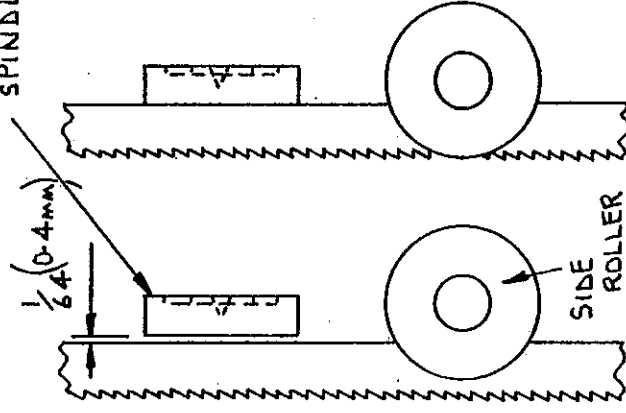


FIG.6

GUIDE RUNNER SPINDLE



CORRECT

INCORRECT

FIG.7

TOP GUIDE ASSEMBLY

1. Loosen 2 knurled nuts from studs 'A' in Fig. 6, then remove sawguard.
2. Bring guide assembly forward by loosening ball lever screw 'B' until side roller guides 'C' are positioned just behind the gullet of the sawblade as shown in Fig. 7. Re-lock complete guide assembly in this position.
3. Set the side roller guides 'C' just clear of the sawblade by loosening the knurled locknuts 'D' positioning guides by means of knurled adjusting screws 'E', then relock locknuts 'D'.

Positioning the side roller guides as above ensures that support is given to the sawblade but the guides do not nip the blade.

NOTE: Care should be taken when setting the guides so as not to displace the sawblade from its true vertical position.

4. Loosen thumbscrew 'F' and position rear roller guide 'G' to within $\frac{1}{64}$ " (0.4mm) from the back of the sawblade in its free position. Re-lock in position by thumbscrew 'F'.
5. Replace sawguard complete with 2 knurled nuts on studs 'A'.

BOTTOM GUIDE ASSEMBLY

1. Bring guide assembly forward by loosening ball lever screw 'A' in Fig. 8 until side roller guides 'B' are positioned just behind the gullet of the sawblade.

Relock complete guide assembly in this position.

2. Set the side roller guides 'B' just clear of the sawblade by loosening knurled locknuts 'C', positioning guides by means of the knurled adjusting screws 'D'. Relock locknuts 'D'.

Positioning the side roller guides as above ensures that support is given to the sawblade but the guides do not nip the blade.

NOTE: Care should be taken when setting the guides so as not to displace the sawblade from its true vertical position.

3. Loosen thumbscrew 'E' and position rear roller guide 'F' to within 1/64" (0.4mm) from the back of the sawblade in its free position. Relock in position by thumbscrew 'E'.

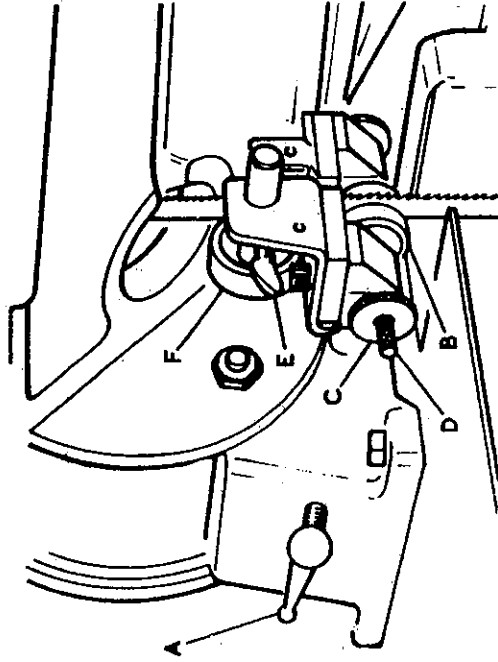


FIG.8

BRAKE

The brake is operated by depressing the foot pedal as shown in Fig. 1. This actuates the brake rod and forces the brake shoe against the bottom wheel hub.

The brake should only be applied after the stop button has been pressed.

TABLE

The table cants 45° to the right and 10° to the left.

FOR RIGHT HAND CANT

1. Loosen table locking lever 'A' in Fig. 9.
2. Cant table until required angle is reached. The locking lever locks both front and rear trunion plates simultaneously, this gives perfect rigidity to the table.

FOR LEFT HAND CANT

1. Loosen wingnut 'B' in Fig. 9 and swing the stop bracket clear of the stop screw in the table.
2. Loosen the table locking lever 'A' and cant table until required angle is reached. Lock table in position.

The table is set square to the sawblade, from front to rear, before despatch from the works. Should this setting be disturbed for any reason check by the undermentioned procedure.

1. Ensure the top and bottom guides are clear of the blade so that it is not restricted in any way.
2. Check the blade is tracking correctly, i.e. running in the centre of each wheel. (See instructions for 'Tracking of Sawblade').
3. Check the blade for squareness to the table by means of a steel square.

If adjustment is necessary, loosen the four bolts 'C' in Fig. 9 and adjust the two fine thread adjusters 'D' until table is correctly set. When set, tighten all screws.

To check the 90° positive stop proceed as follows:

1. Ensure the top and bottom guides are clear of the blade so that it is not restricted in any way.
2. Check the blade is square to the table by means of a steel square after first ensuring that the stop bracket is correctly positioned and the adjustable stop screw in the table is hard up against the bracket. If necessary, adjust the bolt in the table and re-check. When set, tighten all screws.

Check the pointer is correct to the graduated scale and adjust if necessary.

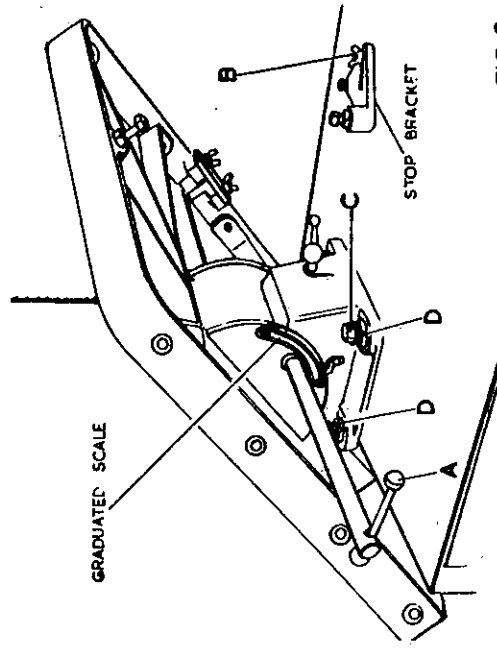


FIG.9

SAW WHEELS

A brush is provided (Fig. 10) on the bottom pulley to remove sawdust. The rubber on the top pulley should be cleared daily to prevent accumulation of sawdust which could cause the blade to run out of true.

The saw pulleys must be kept in accurate balance to avoid vibration. It is essential that the rubbers on the faces are kept at an even thickness by truing up occasionally. This is done by revolving the pulleys and holding a wooden block covered in emery cloth or sandpaper against them. Care should be taken to ensure that, after truing, the wheels have a curved surface with the highest point in the centre of the wheel rim. This is most important for correct tracking of the sawblade.

Badly worn pulleys should be replaced by new ones. If the machine is used with badly worn pulleys the saw will vibrate, resulting in bad sawing and saw breakages.

We have a service arrangement, which we recommend whereby newly rubbered pulleys can be supplied against the return of existing pulleys. An appropriate charge being made for re-rubbing only. To avail yourself to this service return existing pulleys to:

EVERWOOD ENGINEERING LIMITED
EVERWOOD
BISHOP AUCKLAND
ENGLAND

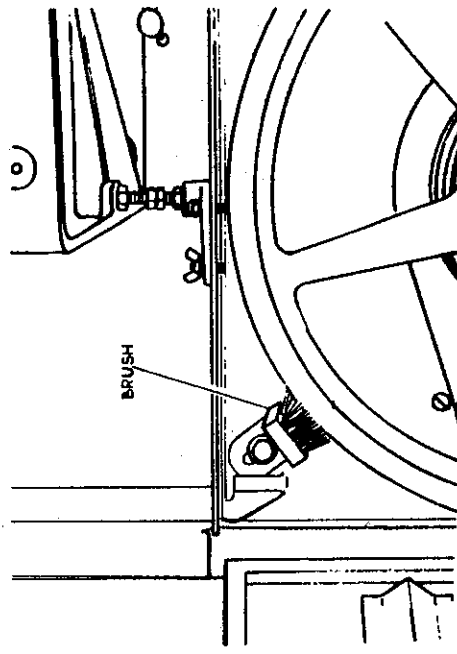


FIG.10

REMOVAL OF SAW WHEELS

The top and bottom wheels are identical. To remove a wheel for re-rubbing unscrew the four $\frac{3}{8}$ " whit. nuts around the hub and remove the wheel complete, leaving the hub on the machine.

MAINTENANCE OF BANDSAW BLADES

A properly sharpened bandsaw blade will give clean, accurate cutting and this is achieved by proper setting and sharpening of the teeth. Always set the teeth before sharpening.

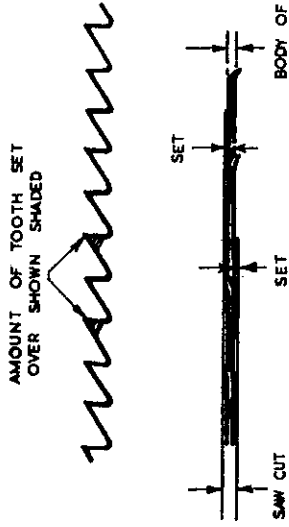


FIG. 11.

SETTING

In order to cut satisfactorily, bandsaw teeth must be set by bending the teeth alternately out of the line of the blade. This presents alternate pairs of teeth, wider than the thickness of the ribbon and prevents the ribbon rubbing in the wood being cut and getting hot.

There are two usual ways of setting bandsaw teeth depending generally upon the amount of work to be done.

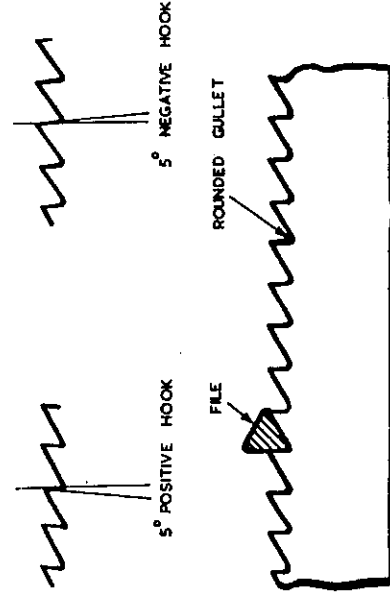
1. HAND SETTING

The points of the teeth are set by using a hand setting tool of the plier type. The points only of the teeth must be set and as a general rule the set on each side is 0.010 " (0.3mm). Set is applied in opposite directions for each alternate tooth.

Where hand setting is employed it cannot be ensured that all the teeth are cutting and in order to overcome this the teeth should be stoned occasionally. An ordinary fine grit stone is used and the back runner guides should be temporarily brought forward until it is in contact with the back of the blade. The blade should then be run and the stone carefully applied to the teeth each side of the blade. When the saw is subsequently sharpened it will be noted that each tooth has not been marked with the stone, and such teeth should only be filed very slightly. The remainder of the teeth which have actually been stoned should be filed in the normal manner until the flat caused by the stone disappears. Bandsaws may require stoning approximately once to every six sharpenings.

2. MACHINE SETTING

A setting attachment can be supplied to special order for fitting to a standard grinding machine as shown in Fig. 23. Also recommended is the separate inexpensive setting machine as shown in Fig. 25. A feature of this machine is that the strikers which push the teeth over are arranged on opposite sides of the blade, and strike adjacent teeth simultaneously. In this way the shock of the two strikers cancel each other out, and does not damage the body of the band ribbon.



POSITIONING OF FILE

FIG. 12.

SHARPENING

This is normally done by a triangular section file. Again this operation can be done by hand or machine.

HAND FILING

It is essential to employ an efficient and quick-acting vice and a round cornered triangular file, both illustrated in Fig. 20 and 21.

The face of each tooth should be filed across and with the same stroke the back of the following tooth should be filed at the same time. One stroke of the file should be sufficient to sharpen each tooth, and this stroke should be as light as possible in order to avoid producing a burr. The shape of the gullet is automatically maintained at 60° by the file, which the angle on the hook on the tooth is dependant on the position of the file. For general work approximately 5° of positive hook should be given. A greater or smaller hook should be applied for soft or harder woods respectively. In the case of particularly hard woods a negative rake may be necessary, while a wider tooth pitch than standard may be required for sawing timbers of an abrasive nature, and those containing gum.

Always sharpen square across the face of each tooth and NOT on the bevel, otherwise the saw will vibrate violently, which shatters the steel, and causes cracking and saw breakages.

Use a file with rounded corners and of triangular section. It is important to keep the gullet of each tooth rounded otherwise cracks will soon appear. Saws must be sharpened at regular intervals and should never be forced to cut with teeth which have become blunt.

NOTE: When reconditioning bandsaw blades it is necessary to set the teeth first before sharpening. This ensures that the face of the tooth is square. If sharpening is carried out first, the subsequent setting will result in an angular tooth shape being obtained.

MACHINE FILING

A sketch of the automatic machine for filing blades is given in Fig. 22. Further details of this machine will be forwarded on request.

GENERAL CAUSES OF SAW TROUBLE

1. Crystallisation of the ribbon, produced by the back of the saw rubbing against the back runner guide. The disc should revolve only by contact with the back edge of the saw when actually cutting.
2. Using a blade that is too wide for the radii being cut. In attempting to cut a small curve with a saw too wide the blade tends to twist against the guides causing friction and overheating which destroys the temper in the steel.
3. Not enough set.
4. Sharpening with a sharp cornered file. See Fig. 13.
5. Bad brazing due to dirty joints or badly prepared laps or incorrect positioning of the laps, causing a bump on the back of the blade at the joint.

See Fig. 24 for an efficient bandsaw brazer.

SMALLEST RADII WHICH MAY BE SAWN WITH GIVEN WIDTH OF BLADE

WIDTH OF BLADE	$\frac{1}{2}$ "	$\frac{3}{8}$ "	$\frac{1}{2}$ "	$\frac{3}{4}$ "	$\frac{1}{2}$ "
MINIMUM RADIUS	$\frac{1}{8}$ "	$\frac{1}{4}$ "	$\frac{1}{2}$ "	$\frac{3}{4}$ "	$1.7/16$ "
WIDTH OF BLADE	$\frac{3}{4}$ "	$\frac{1}{2}$ "	$\frac{3}{4}$ "	$\frac{1}{2}$ "	$1\frac{1}{2}$ "
MINIMUM RADIUS	$2\frac{1}{2}$ "	$3\frac{1}{2}$ "	$5.7/16$ "	$7\frac{1}{2}$ "	

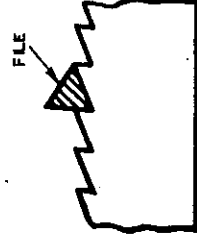


FIG. 13.

FOLDING BANDSAW BLADES

Bandsaw blades are folded in thirds. This is done by holding the blade firmly in both hands with the palms upwards as shown in Fig. 14(b). Don't let the blade slip or turn in the hands. The blade will almost automatically fall into three loops.

The blade should be kept in a safe, dry place.

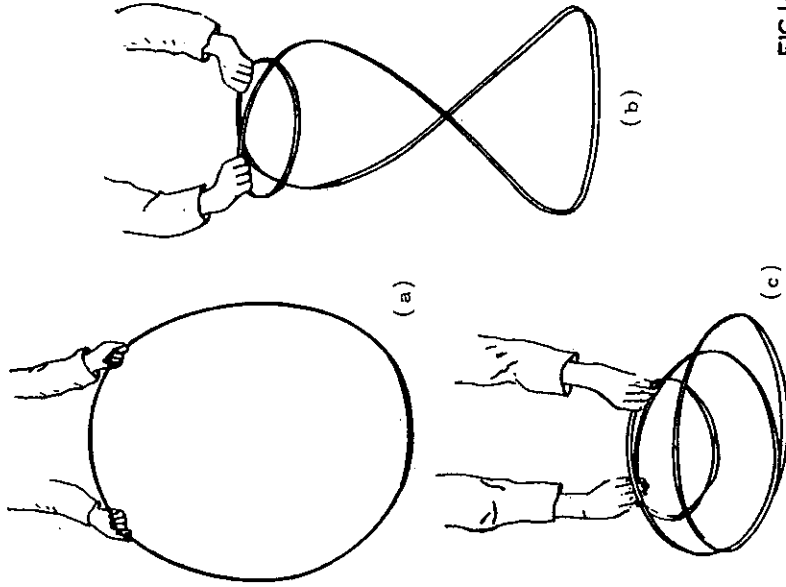


FIG. 14.

HINTS ON CUTTING

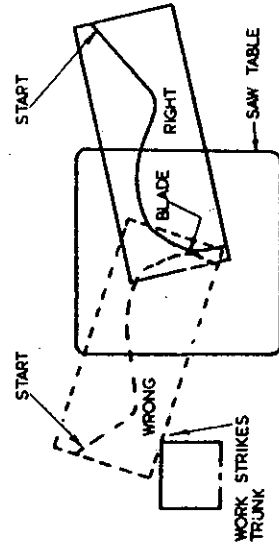


FIG. 15.

(a) **WATCH FEED DIRECTIONS** - See Fig. 15.

Mentally follow the path of the cut before actually cutting the work. If not started properly many pieces of work will foul against the trunk of the machine.

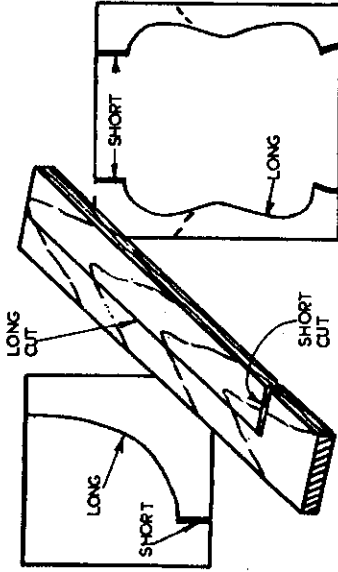


FIG. 16.

(b) **MAKE SHORT CUTS FIRST** - See Fig. 16.

When a choice of starting points is offered always make short cuts first. Back tracking out of a short cut can be done much more quickly than backing out of a long cut.

(c) **BACKTRACK ON CORNERS** - See Fig. 17.

Very narrow grooves must be nibbled as shown at A,B,C. On other inside corners, cut to the corner and then backtrack to lead the blade over to second line.

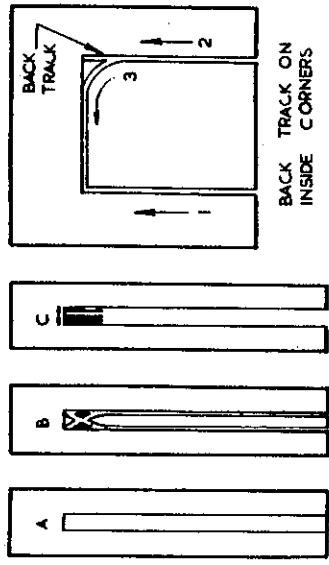


FIG. 17.

PLAIN FENCE (TO SPECIAL ORDER)

The fence can be used on either side of the saw depending on the position of the slide bars and is provided with rapid or micro-adjustment.

For rapid adjustment unlock lever 'A', lock thumbscrew B. In Fig. 18; the fence can then be moved to the position required. Re-lock fence by locking lever 'A' and thumbscrew 'B'.

For micro-adjustment, unlock lever 'A' and thumbscrew 'B'. Turn Handwheel 'C' until the required position is reached and re-lock fence in position.

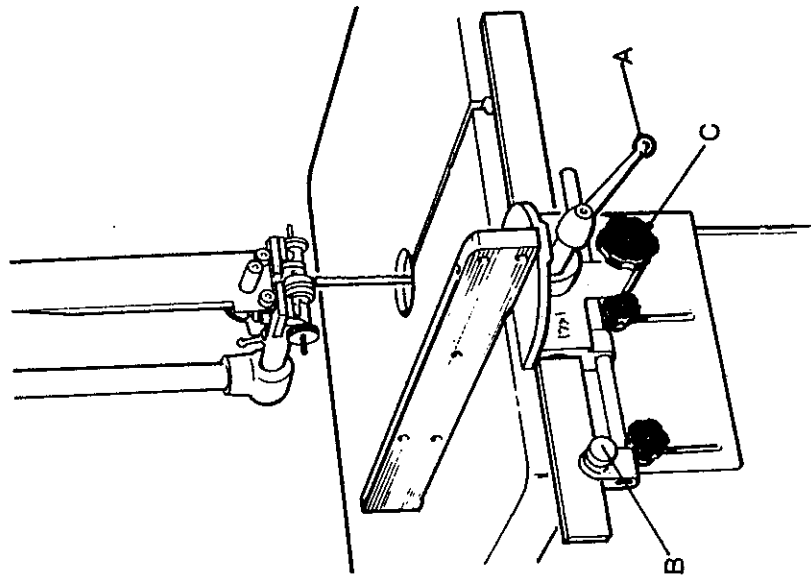


FIG. 18.

BANDSAW BLADES

Spare bandsaw blades of the correct length, ready set and sharpened for wood cutting are available from stock. Where it is preferred, bandsaw blading in strip form can be supplied for customers to make up their own blades. This bandsaw strip is offered either toothed only, or toothed, sharpened and set.

In addition to woodcutting we can supply bandsaw blades for plastics, bonded wood, non-ferrous metals, meat, etc. provided that the correct machine speeds are available.



FIG. 20.

TAPER TRIANGULAR FILES FOR HAND USE

LENGTH 6", 8", 10".

The edges of these files have rounded corners to produce the round gullet which prevents saw cracks.

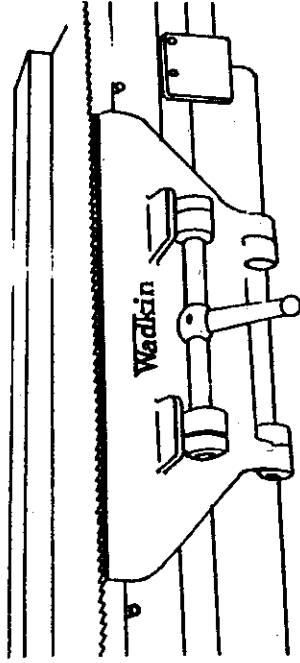


FIG. 21.

BANDSAW FILING VICE

A specially designed vice for holding band or fret saws and also handsaws. Jaws are 17" (430mm) long and will take saws up to 2½" (64mm) wide. Jaws open instantaneously by lever handle.

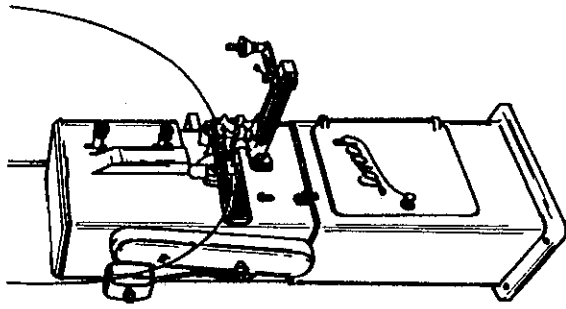


FIG. 22.

WADKIN 'LOROCH' BANDSAW GRINDER TYPE 'HR'

This machine is fully automatic and ensures that each tooth is sharpened to the correct shape and depth.

Any length of saw can be filed up to a maximum width of 2.8" (60mm) with teeth up to 1.3/16" (30mm) pitch and ¾" (19mm) deep.

A setting attachment can be supplied to special order for fitting to the machine as shown in Fig. 23. Bandsaws of any length up to 2" (50mm) wide and ¾" (16mm) pitch can be set using this attachment.

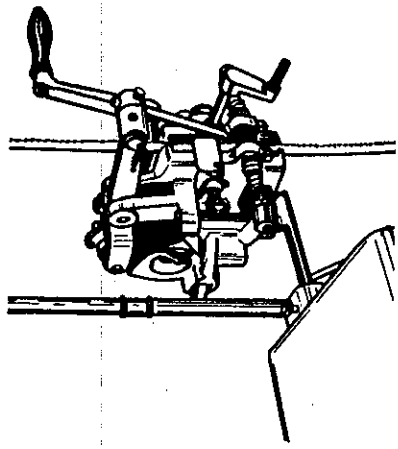


FIG. 23.

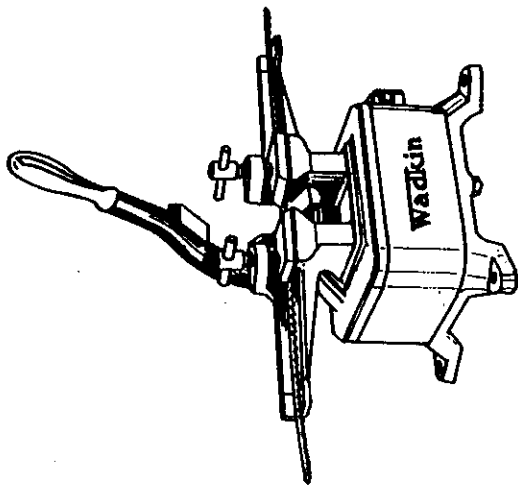


FIG. 24.

WADKIN ELECTRIC BANDSAW BRAZER TYPE 'HE'

This machine efficiently brazes bandsaws, from ¾" (6mm) to 1" (25mm) wide which have been broken. The two ends of the saw are firmly held by the clamps, and controlled heat applied electrically. A small quantity of solder and brazing compound are supplied with the machine. The actual brazing takes from 25 to 45 seconds according to the width of blade. Before brazing the ends of the sawblade must be carefully bevelled.

A separate instruction chart is issued with the brazer.

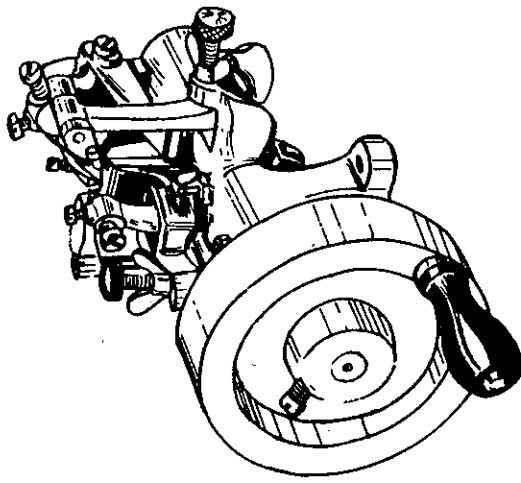
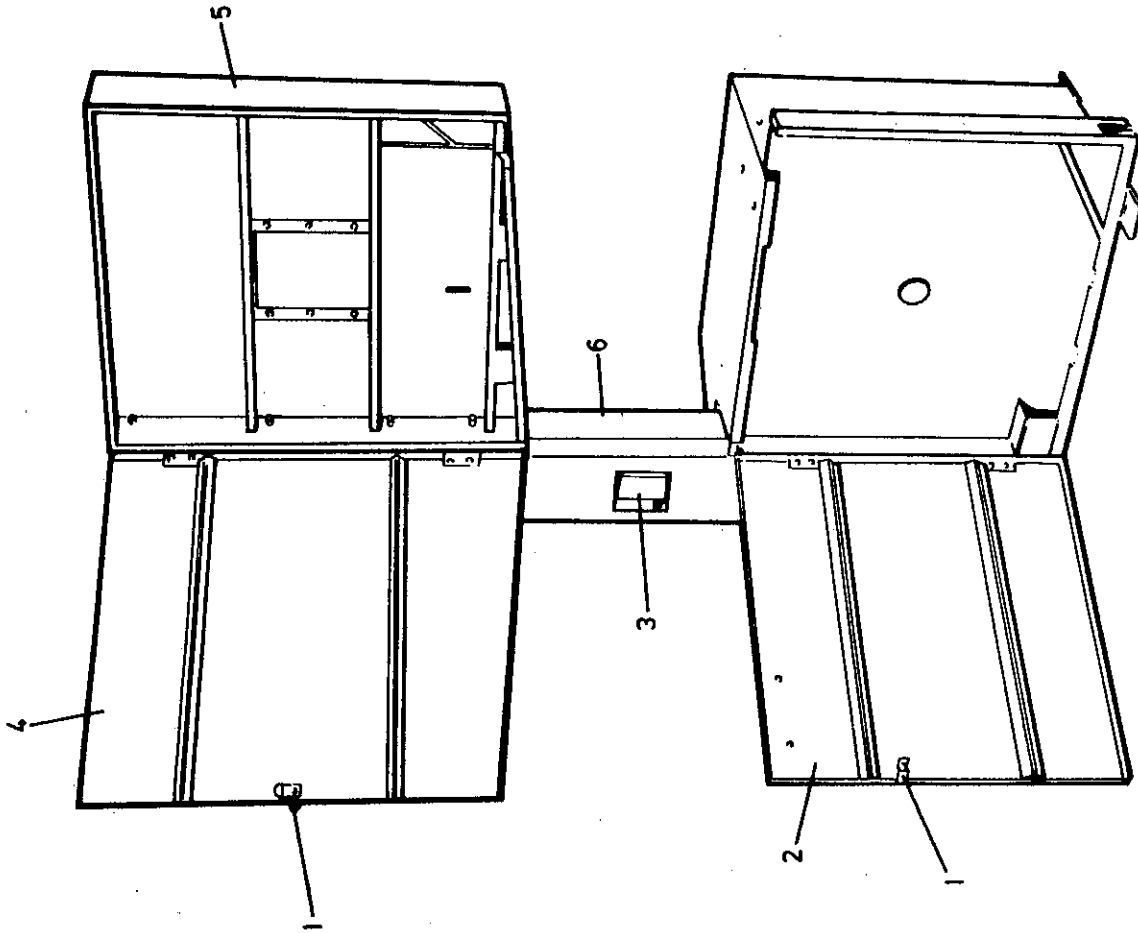


FIG. 25.

WADKIN BANDSAW SETTING MACHINE TYPE 'B/SS'

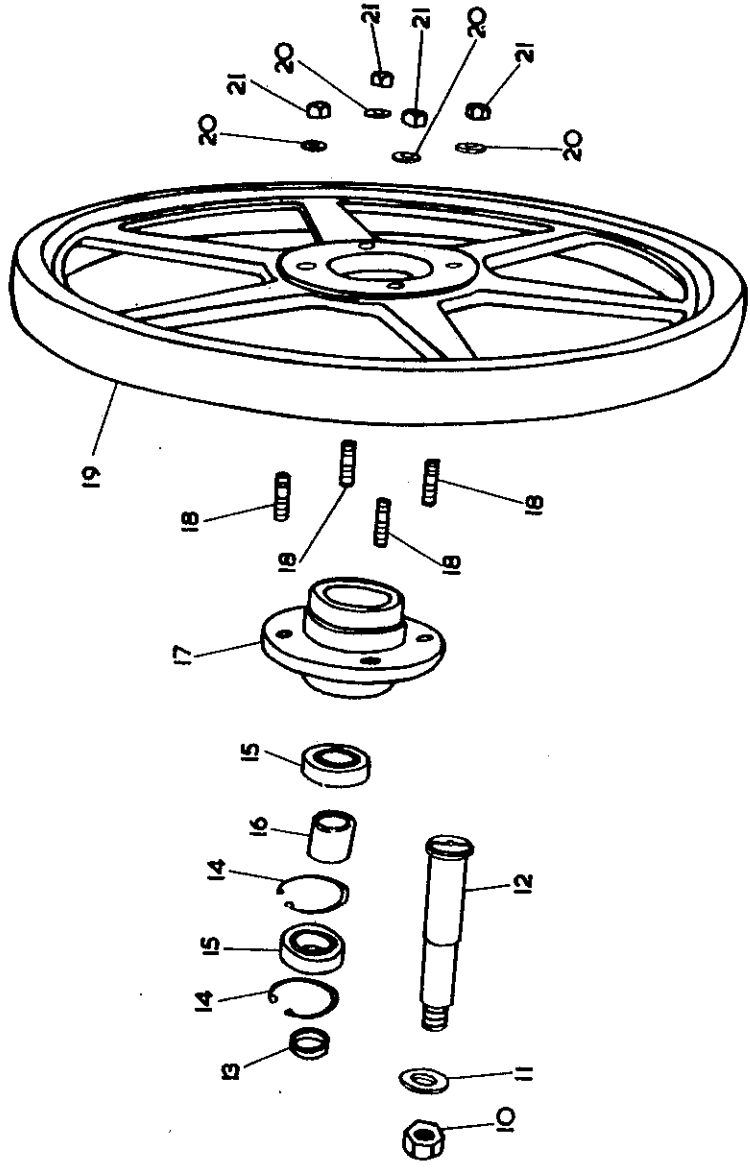
For bandsaws up to 1¾" (32mm) wide x ¾" (19mm) pitch.

All adjustments are quickly and easily made to this robust and thoroughly practical tool. It is usually operated by hand and setting is at the rate of two teeth per revolution of wheel. When preferred the machine may be power driven by a flat belt on the pulley face of the handwheel.



MAIN FRAME ASSEMBLY

<u>REF. NO</u>	<u>PART NO.</u>	<u>NO. OF</u>	<u>DESCRIPTION</u>
1	T44A/RE	2	door handle (top & bottom)
2		1	Bottom door
3		1	Starter
4		1	Top door
5	1062/2 (8700) 1064/1 (8800)	1	Main frame
6		1	Cover for saw

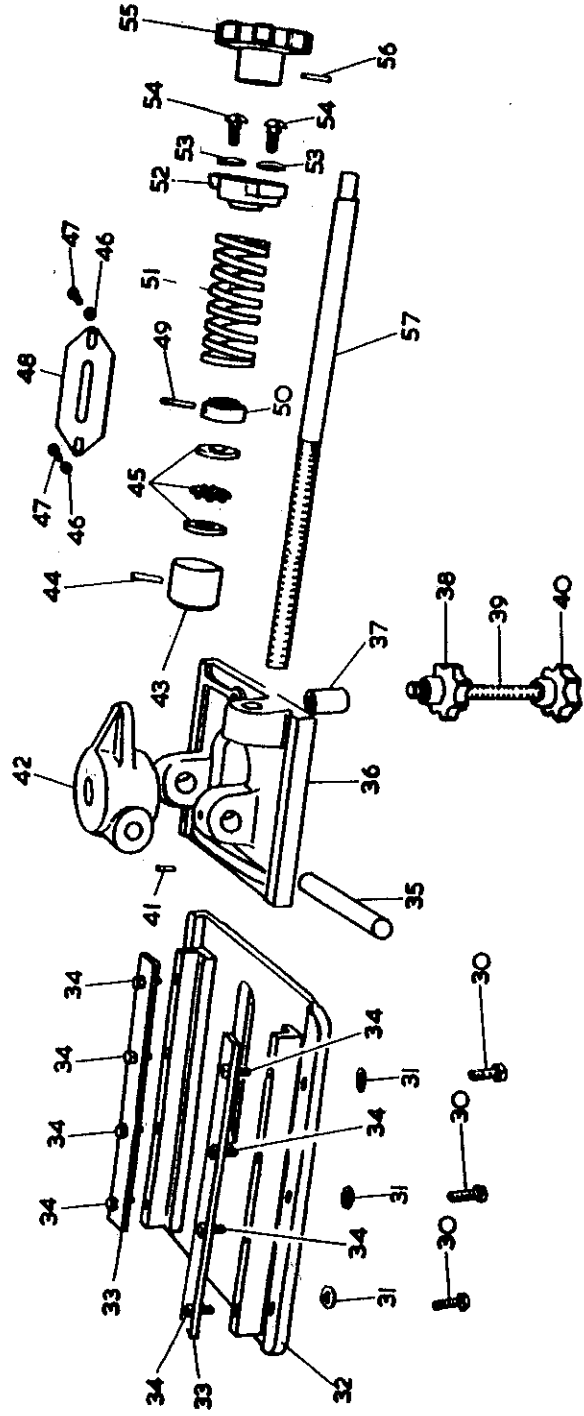


TOP WHEEL ASSEMBLY

NOTE:

When ordering replacement parts, quote Part No. and Serial No. of machine.

<u>REF. NO.</u>	<u>PART NO.</u>	<u>NO. OFF</u>	<u>DESCRIPTION</u>
10		1	3/4" Whit nut
11		1	3/4" Whit washer
12	1062/12	1	Top wheel spindle
13	1042/20	1	Top wheel distance piece (3/4" long)
14		2	52m/m internal circlip
15	DN.205	2	Fischer sealed bearings
16	1042/20	1	Top wheel distance piece (1 1/4" long)
17		1	Top wheel hub
18	1042/9	4	3/4" Whit. X 1 1/4" long stud
19	1062/3/8700 1064/1/8800	1	Wheel
20		4	Wheel
21		4	3/4" Washer
		4	3/4" Whit. nut

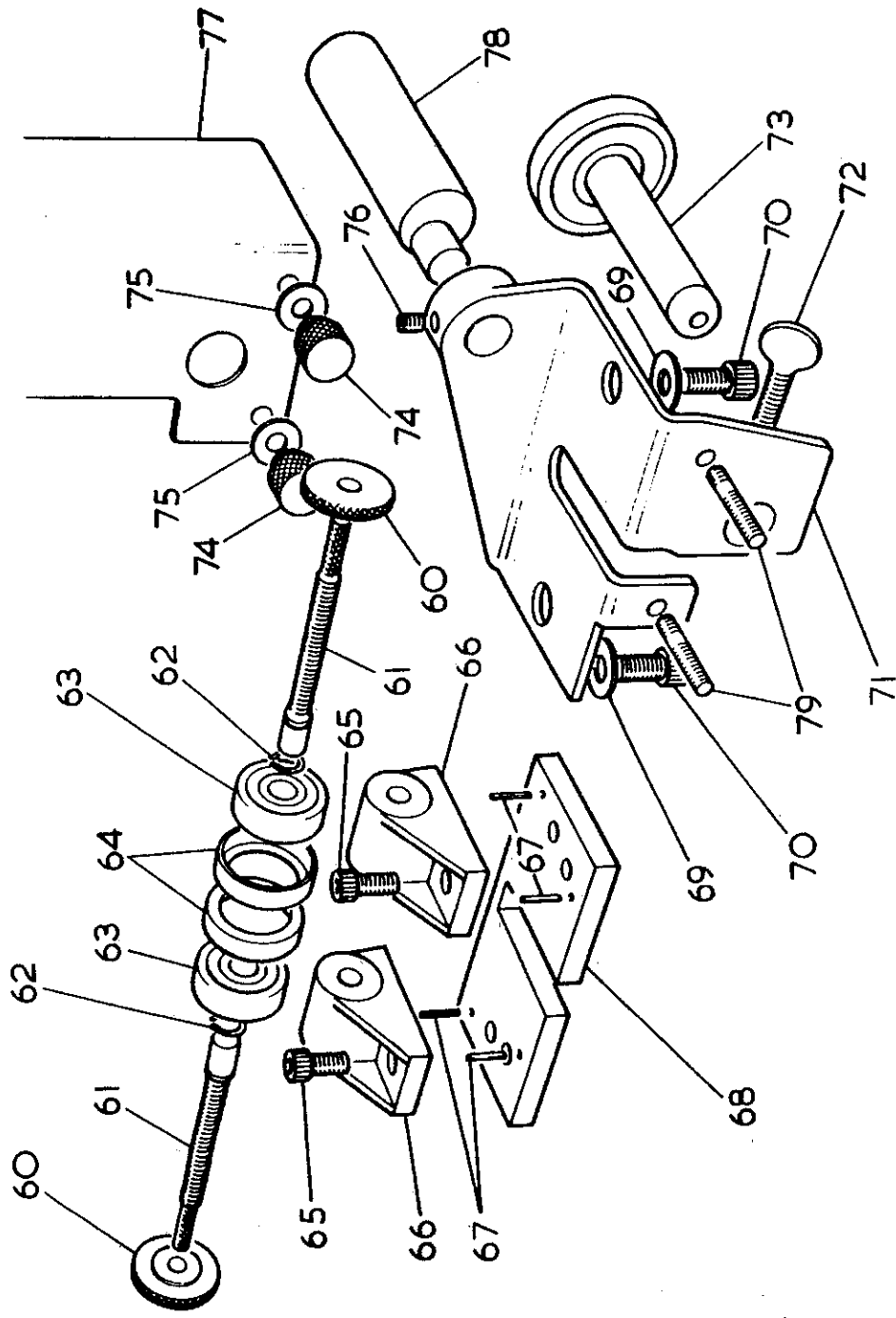


SLIDE ASSEMBLY

NOTE:

When ordering replacement parts, quote Part No. and Serial No. of machine.

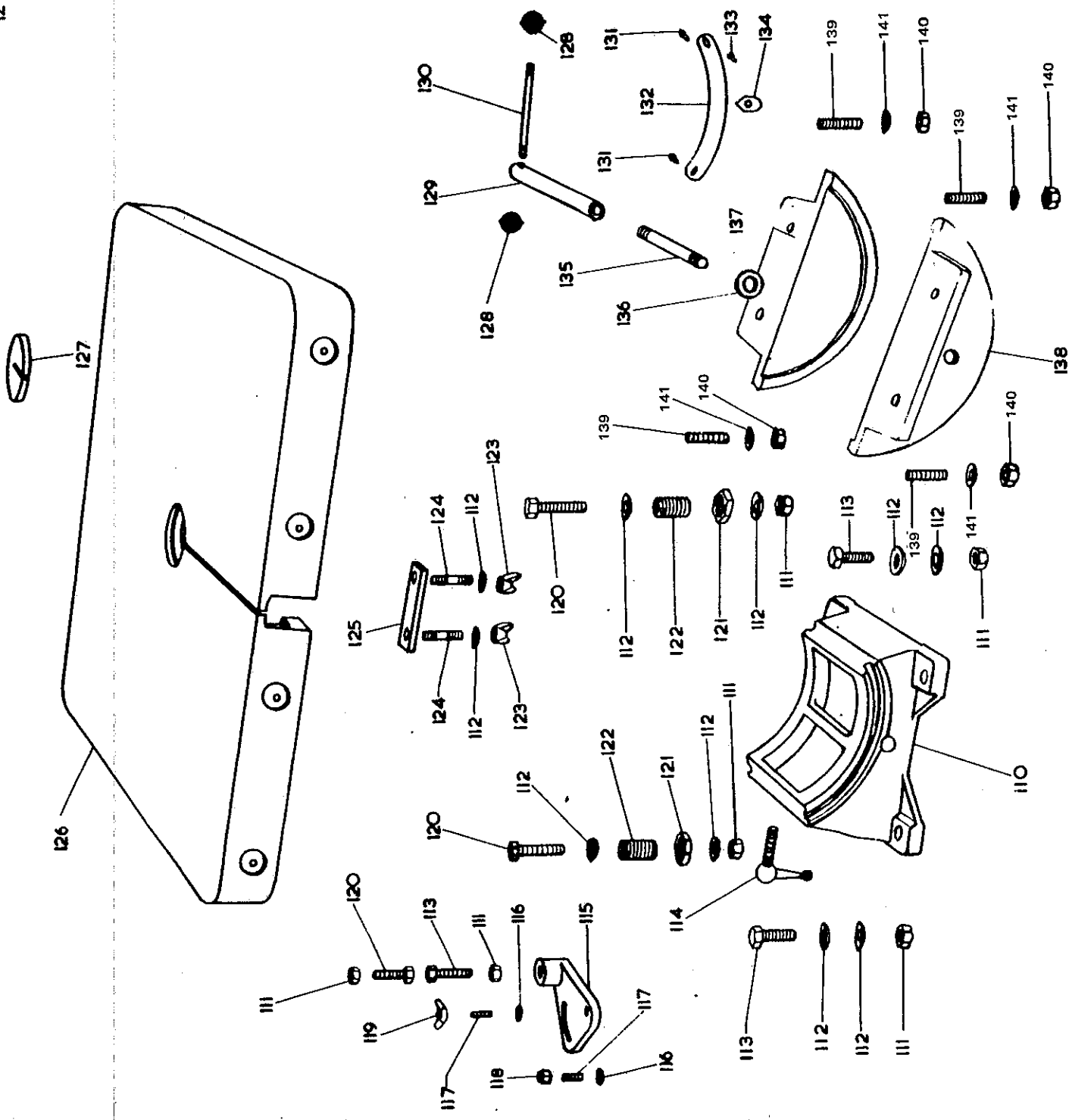
REF. NO.	PART NO.	NO. OFF	DESCRIPTION
30		6	5/16" whit. X 1" long hexagon head bolt
31		6	5/16" washer
32	D-1042/36	1	Top wheel slide frame
33	D-1797/32	2	Top wheel slide strip
34		8	3/8" whit. X 3/4" long hexagon head bolt.
35	D-1797/29	1	Top wheel pivot shaft
36	D-1797/5	1	Tracking and tension slide
37	D-1797/47	1	Tracking distance piece.
38	Patt. No. 14	1	2" dia. plastic handwheel 3/8" whit. TRT.
39	D-1797/31	1	Saw tracking screw
40	Patt. No. 14	1	2" dia. plastic handwheel, 3/8" whit.
41		1	3/8" whit. X 3/4" long socket head grub screw.
42	D-1797/4	1	Tracking boss.
43	A-1042/60	1	Tension screw shroud
44		1	3/16" dia. X 1 1/4" long groverlok dowel.
45	W. 3/8"	1	Hoffman Thrust Race
46		2	3/16" washer
47		2	3/16" whit. X 3/4" long round head screw.
48	1062/43	1	Saw tension indicator plate (standard).
	1062/57	1	Saw tension indicator plate (metric).
49	A-1042/70	1	Saw tension indicator pin
50	A-1042/61	1	Saw tension spring seating
51	A-1024/35B	1	Saw tension spring.
52	B-1042/63	1	Saw tension screw bearing 3/8" washer
53		2	3/8" whit. X 1" long round head screw.
54		2	3" dia. plastic handwheel 3/8" bore
55	Patt. No. 14	1	No. 3 taper pin.
56	1062/13/8700	1	Saw tension screw
57	1064/6/8800	1	Saw tension screw

**NOTE:**

When ordering replacement parts, quote Part No. and Serial No. of machine.

TOP OR BOTTOM SAW GUIDE ASSEMBLY

REF. NO.	PART NO.	NO. OFF	DESCRIPTION	REF. NO.	PART NO.	NO. OFF	DESCRIPTION
60	A-1062/32	1	Guide locknut (right hand)	70		2	5/16" whit X 3/4" long socket head capscrew
61	A-1062/27	1	Guide locknut (left hand)	71	C-1062/25	1	Saw guide bracket
		1	Saw guide side roller spindle (right hand)	72		1	5/16" whit X 1 1/4" long thru-screw
		1	Saw guide side roller spindle (left hand)	73	A-1062/52	1	Runner Spindle Assembly
62		2	Truarc External Circlip No. 5100-39	74	A-1042/66	2	Knurled knob for saw guide Assembly
63		2	Fischer DN200 Sealed for life bearing	75		1	3/4" washer (Top Guide Assembly)
64	A-1062/30	2	Guide side roller shroud	76		1	5/16" dia. X 3/4" long socket head grub-screw
65		2	5/16" whit X 3/4" long socket head capscrew	77	1062/41	1	Saw guard (Top Guide Assembly)
66	A-1062/26	2	Saw guide adjustment block	78	A-1062/37	1	Top guide shaft
67		4	3/4" dia. X 3/4" long grover-lok spring dowel	A-1042/80		1	Bottom guide shaft
68	A-1062/42	1	Packing piece for guide			2	3/4" whit X 1" long stud (Top Guide Assembly)
69		2	5/16" washer				

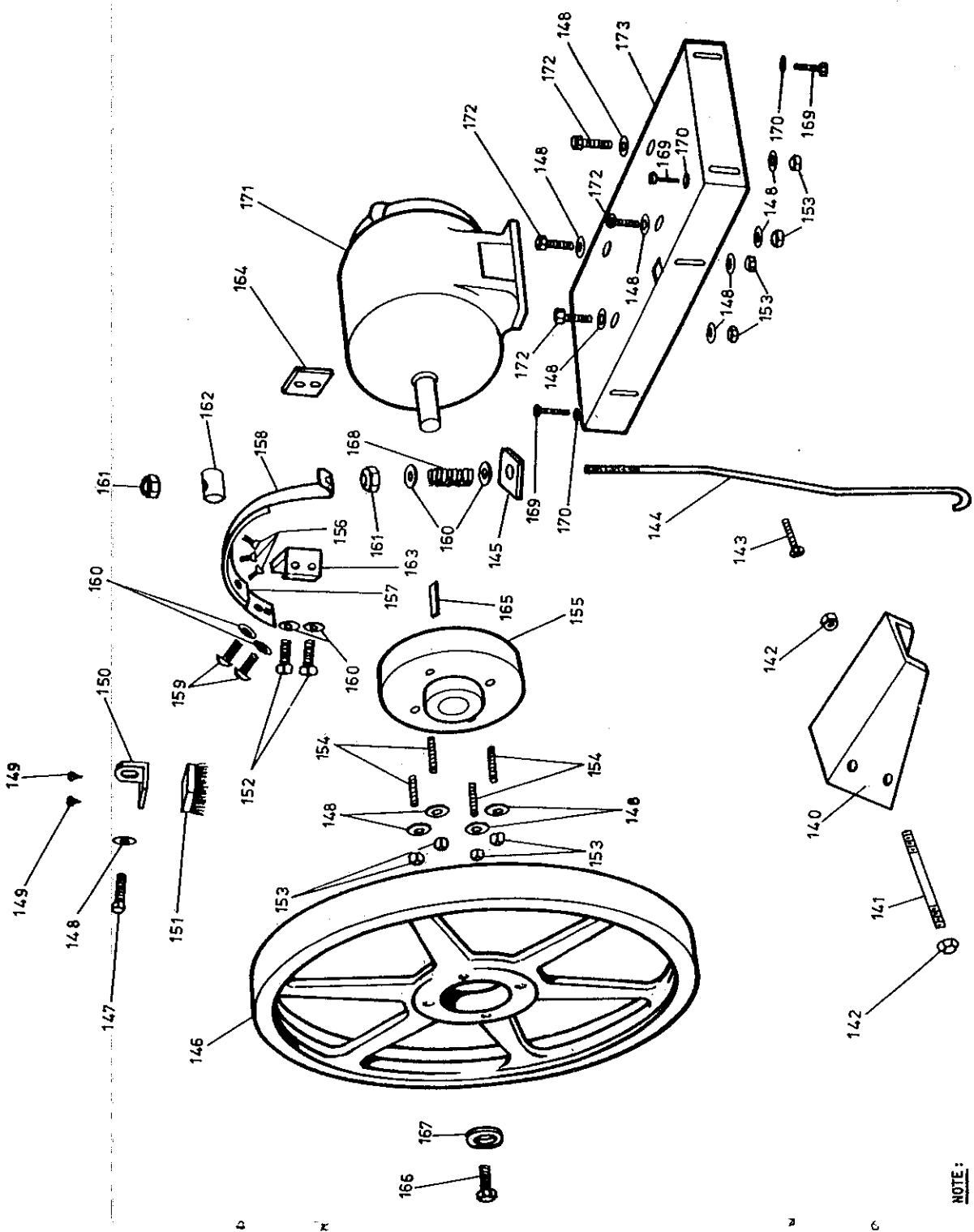


NOTE:

When ordering replacement parts, quote Part No. and Serial No. of machine.

TABLE ASSEMBLY

REF. NO.	PART NO.	NO. OFF	DESCRIPTION	REF. NO.	PART NO.	NO. OFF	DESCRIPTION
110	D-1042/4	1	Table quadrant slide Bracket.	126	1062/3	1	Table insert
111		6	3/8" whit. nut.	127	1062/38	1	3/8" dia. plastic ball 5/16" whit.
112		10	3/8" washer.	128	Patt. No. 30	2	Whit.
113		3	3/8" whit. X 1" long hexagon head bolt.	129	A-1042/25	1	Quadrant locking handle
114	B-5-1-B	1	3/8" whit. ball lever screw	130	A-1042/30	1	Toggle bar for quadrant lock
115	A-1042/15	1	Stop bracket for table	131		2	3/8" dia. X 3/4" long fluted rivet
116		2	3/8" washer	132	8-1042/16	1	Table angle indicator rule
117		2	3/8" whit. X 1 1/4" long stud.	133		1	3/8" whit. X 3/4" long round head screw.
118		1	3/8" whit. aerotight nut.	134	A-1026/72	1	Quadrant locking stud
119		1	3/8" whit. wingnut	135	A-1042/24	1	3/8" washer
120		3	3/8" whit. X 1 1/2" long hexagon head bolt	136	1062/62	1	Quadrant side plate (17/32" dia. hole)
121		2	3/8" simplex nut	137	1062/62	1	Quadrant side plate (3/4" whit.)
122	A-1031/95	2	3/8" simplex adjuster	138	1062/62	1	Quadrant locking stud
123		2	3/8" whit. wingnut	139		4	M12 x 45mm. long stud
124		2	3/8" x 1" long stud	140		4	M12 Nut
125	1062/54	1	Keep plate.	141		4	M12 Washers

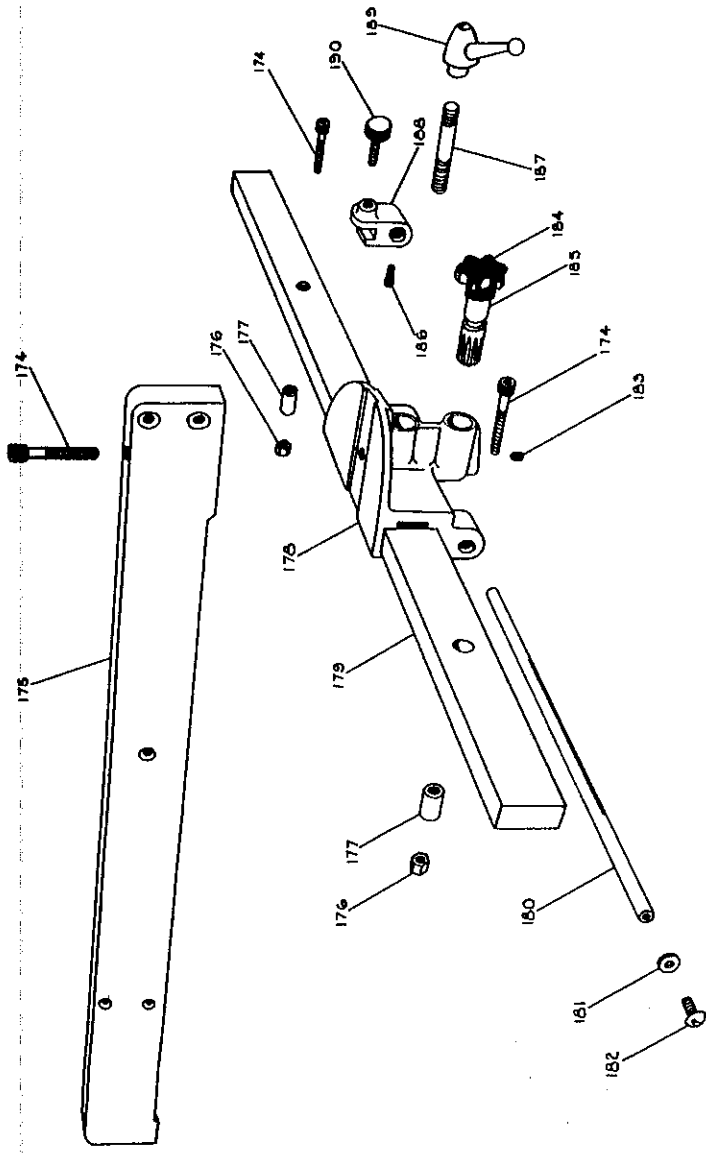


NOTE:

When ordering replacement parts, quote Part No. and Serial No. of machine.

MOTOR MOUNTING

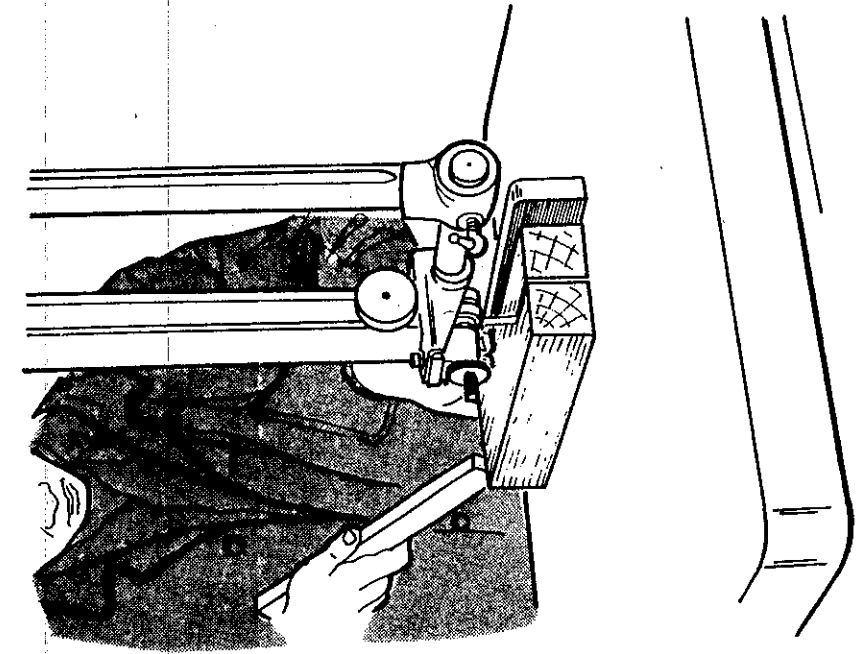
REF. NO.	PART NO.	NO. OFF	DESCRIPTION	REF. NO.	PART NO.	NO. OFF	DESCRIPTION
140	1062/5	1	Brake pedal	161		2	3/4" Whit. nuts
141	1062/17	1	Brake pivot pin	162	1037/55	1	Block for brake cable
142		2	3/4" Whit. Aerotight nuts	163	1037/53	1	Locking angle for brake
143		1	3/32" dia. X 3/4" Long Splitpin	164	1064/9	1	Packing piece for brake angle
144		1	Brake spring plate	165	Key		For D132S 2.2KW " D132M 3.7KW " D160M 5.5KW " D160L 7.5KW
145	1062/16	1	Brake rod	166		1	3/4" Whit. X 1 1/2" long hex head left hand thread
146	1064/10	1	Wheel	167	1042/88	1	Bottom wheel hub washer
147	8700-1062/1, 8800-1064/3	1	3" Whit X 3/4" long hex. head bolt	168	1062/18	1	Spring for brake
148		14	2" Bright washer	169		4	3/4" Whit. X 1 1/2" long square head bolt
149		2	No. 8 X 3/4" long round head wood screws	170		4	3/4" Whit. Locknut
150	1062/61	1	Bracket for brush	171		1	Motor type:-
151		1	Brush	172		4	3/4" Whit X 1 1/2" long hex head bolt
152		2	3" Whit X 3/4" long hex. head bolt	173	1064/2	:-	8800. Standard Motor Platform
153		7	3/4" Whit. nut		Special	:-	8800 Motor Platform for 5.5 and 7.5 KW Motor
154		4	3/4" Whit X 1 1/2" long stud		.062/7	:-	8700. Standard Motor Platform
155		1	Bottom wheel hub		Special	:-	" Motor Platform for 5.5 and 7.5 KW Motor
156	1062/11	3	3/16" Dia. countersunk head copper rivet				
157		1	Ferrodo brake lining				
158	1037/54	1	Band brake				
159		2	3/4" Whit X 3/4" long round head machine screw				
160		6	3/4" Bright washer				

NOTE:

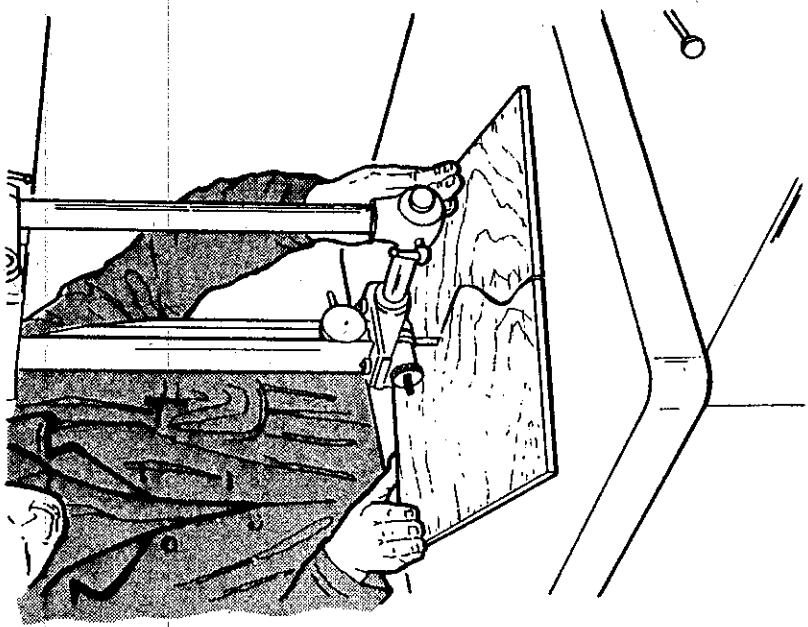
When ordering replacement parts, quote Part No. and Serial No. of machine.

PLAIN FENCE ASSEMBLY

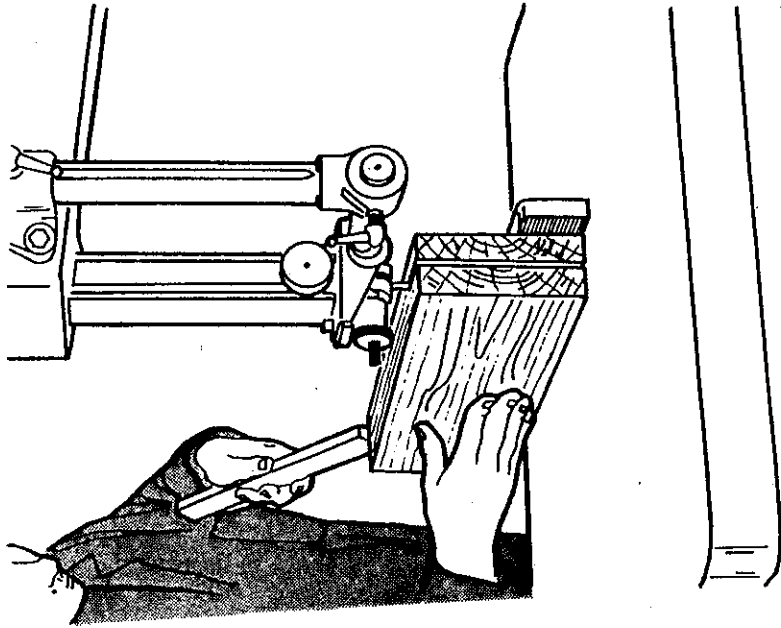
<u>REF. NO.</u>	<u>PART NO.</u>	<u>NO. OFF</u>	<u>DESCRIPTION</u>
174	-	3	$\frac{3}{8}$ " Whit X 2" long socket head capscrew
175	1024/75	1	Ripping fence
176	-	2	$\frac{3}{8}$ " Whit nut
177	1024/74	2	Rip fence slide bar bush
178	1007/14	1	Ripping fence casting
179	1062/39	1	Fence slide bar
180	1007/19	1	Fence rack
181	-	1	$\frac{3}{8}$ " Bright washer
182	-	1	$\frac{3}{8}$ " Whit X $\frac{1}{2}$ " long round head machine screw
183	-	1	5/16" Whit X $\frac{3}{8}$ " long socket head grub screw
184	6687/7/AL	1	$\frac{1}{2}$ " X 2" Ream blind (black)
185	1007/18	1	Fence pinion
186	-	1	3/16" Whit X $\frac{1}{2}$ " long socket head cap screw
187	1062/57	1	Fence lock stud
188	1007/16	1	Ripping fence thrust bracket
189	-	1	$\frac{3}{8}$ " Whit. kip handle
190	1007/17	1	Fence thrust bracket



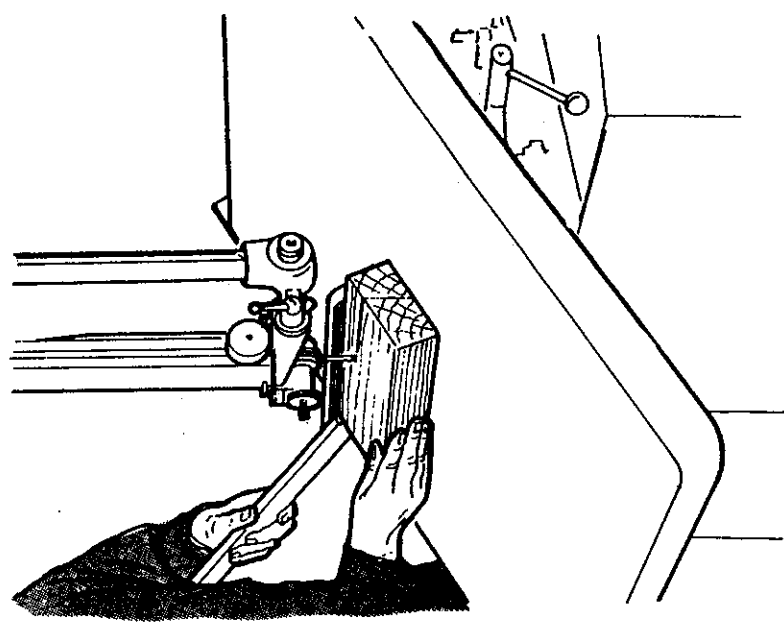
CUTTING WITH FENCE



SHAPED CUTTING



CUTTING DEEP STOCK



ANGLED CUTTING