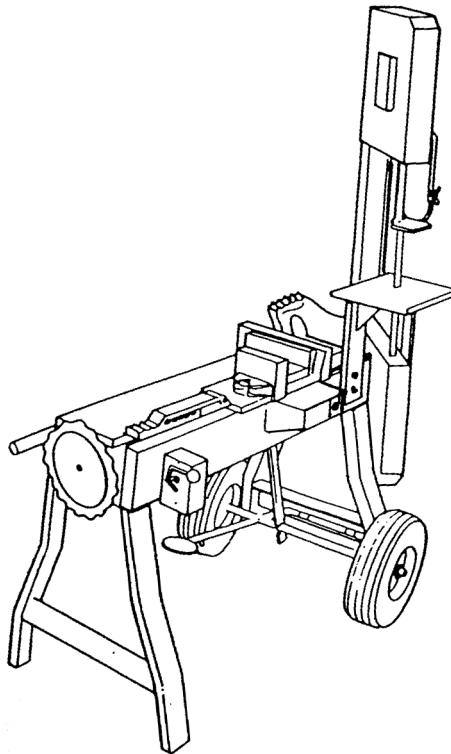




Current Tools

FOR THE PROFESSIONAL ELECTRICIAN

Bandsaw — Model #BSD-95



Operating, Maintenance, Safety, and Parts Manual

08/04 REV. 0



Read and understand this material before using the Bandsaw. Failure to understand how to safely operate this unit may result in serious injury or death.

This manual is free of charge. All personnel who operate the Bandsaw should have a copy of this manual and read and understand its contents. To request a copy, call or write to the address below.

CURRENTTOOLS • P. O. BOX 17026 GREENVILLE, SC 29606
800.230.5421 or 864.244.1201 • FAX 864.244.5860
www.currenttools.com

IMPORTANT

BLADE BREAK-IN INSTRUCTIONS

Modern bandsaw blades are too sharp to cut at full rate when “fresh out of the box” and require a short break-in period. The break-in time lightly hones the teeth and greatly improves their strength and life.

FAILING TO FOLLOW THE BREAK-IN PROCEDURE WILL GREATLY REDUCE THE BLADE LIFE AND INCREASE THE POSSIBILITY OF TOOTH STRIPPAGE.

REDUCE FEED RATE:

USE 1/3 TO 1/2 NORMAL FEED PRESSURE.

“HAND FEED” THE SAW IF NECESSARY.

BECAUSE OF THE REDUCED PRESSURE THE CUT SHOULD TAKE ABOUT TWO OR THREE TIMES AS LONG.

BLADE SPEED:

MAINTAIN NORMAL BLADE SPEED.

DO NOT SLOW BLADE DOWN FOR THE BREAK-IN.

BREAK-IN TIME:

Cut 50 TO 100 SQUARE INCHES OF MATERIAL FOR ADEQUATE BREAK-IN.

ONCE YOU HAVE CUT 50 TO 100 SQUARE INCHES OF MATERIAL GRADUALLY INCREASE THE FEED PRESSURE TO THE NORMAL RATE.

THE CORRECT BREAK-IN PROCEDURE IS ESSENTIAL TO REALIZING THE FULL CAPACITY OF MODERN HIGH PERFORMANCE BANDSAW BLADES. FOLLOW THIS BREAK-IN PROCEDURE ON EVERY NEW BLADE.

SAFETY INSTRUCTIONS

Know your machine, its safe and proper use!

DISCONNECT POWER before adjusting or servicing the saw or changing a blade.

STAY CLEAR of all moving parts. Keeps hands and fingers away from the saw blade.

WHEN MOVING SAW, with hinged frame (saw head), secure the head in its down position.

WHEN CUTTING MAGNESIUM, take special precautions. Use a sharp saw blade, make only dry cuts, prevent chip accumulation, and keep fire-fighting equipment nearby.

THIS SAW SHOULD BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRICAL SHOCK.

1. **CORD-CONNECTED TOOLS.** If the saw is equipped with an approved three-conductor cord and a three-prong grounding type plug it should only be connected to a properly equipped and grounded receptacle. The green conductor in the cord is the grounding wire. Never connect the green wire to a live terminal.

Use only a three-wire extension cord having a three-pronged receptacle, a three-pronged plug and ample amperage rating. Replace or repair a damaged or worn cord immediately.

2. **PERMANENTLY CONNECTED TOOLS.** The saw should be connected to a grounded, metal-enclosed wiring system or an equipment-grounding conductor should be run with the circuit conductors and connected to the saw's grounding terminal or lead.

To reset the manual starter after a power interruption, return the switch to OFF and press the RESET button before restarting

FOR ALL TOOLS

KEEP GUARDS IN PLACE and in working order.

REMOVE ADJUSTING KEYS AND WRENCHES. Form a habit. Check to see that all keys and wrenches are removed from the tool before turning the tool on.

KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.

AVOID DANGEROUS ENVIRONMENT. Do not use power tools in damp or wet locations. Keep your work area well lighted.

KEEP CHILDREN AWAY. All visitors should be kept a safe distance from work area.

MAKE WORKSHOP KID-PROOF with padlocks, master switches, or by removing starter keys from tools.

DON'T FORCE TOOL. It will do the job better and safer at the rate for which it was designed.

USE RIGHT TOOL. Don't use a tool or attachment to do a job for which it was not designed.

WEAR PROPER APPAREL. No loose clothing or jewelry to get caught in moving parts. Rubber-soled footwear is recommended for best footing.

USE SAFETY GLASSES. Also use face or dust mask if operation is dusty.

SECURE WORK. Use clamps or a vise to hold work. Provide adequate support to prevent injury from falling work pieces.

DON'T OVER REACH. Keep proper footing and balance at all times.

MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

DISCONNECT TOOLS before servicing or when changing accessories such as blades, bits, cutters, etc.

AVOID ACCIDENTAL STARTING. Make sure the switch is in OFF position before connecting power tools.

USE ONLY RECOMMENDED ACCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may be hazardous.

NEVER STAND ON A TOOL. Serious injury can occur if the tool is tipped or the cutting tool is accidentally contacted.

CHECK DAMAGED PARTS. Before further use of the tool, a guard, or other part that is damaged, should be carefully checked to ensure that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage, mounting and any other condition that may affect the tool's proper operation. Any guard or part that is damaged should be properly repaired or replaced.

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Although this excerpt from the survey report does not necessarily reflect the views and policies of OSHA, it is presented for your consideration in maintaining workplace safety.

From

“Machine Guarding - Assessment of Need”

HEW publication No. (OSHA) 75-173

SUMMARY:

The previous information has discussed specific machines and their inherent characteristics and hazards. All machines, however, require proper power installation and maintenance. High-speed, rotating cutting tools must be properly sharpened and well balanced to eliminate vibration. Saw blades must be properly sharpened and set to eliminate

binding and ensure clean cuts. Any cutting tool that is cracked or chipped must be discarded.

The work area should be neat, well lighted, properly ventilated and free of pedestrian or vehicle traffic. Ample room is needed for stock handling and storage, the floors must be free of slipping or tripping hazards as many machines have exposed tooling that can be fallen on.

These items, though they are not specific machine guard needs, are equally important.

It is also interesting to note that operators observed and questioned by the survey representatives and employed on some woodworking and metalworking equipment are often new hires with little or no experience in machine operation. This is substantiated by the finding that proper training programs are almost absent from industry (Field Supplement, page 8) and by the fact that the highest percentage of accidents occurs at a young age (see Field Survey Supplement, page 8). The best example of this is with operators of saws where the operation seems self-explanatory through observation. Perhaps the operation is basically simple; nevertheless, operators should be carefully trained and enthusiastically motivated to perform safely.

A final observation found through field surveys has to do with the size of the company versus the number of unguarded machines (see Field Survey Supplement, page 2). The smaller the company in number of employees, the larger the percentage of unguarded machines observed. This illustrates a further need for machine guards.

The age of the operator, the size of the company, and the lack of training programs, along with the investigation of specific machines to identify inherent hazards, establishes a definite need for machine guarding. The fact that a hazard exists and a worker performs in proximity to that hazard will undoubtedly result in an injury. Because of this, the use of machine guards to divorce the operator from the hazard to the highest possible degree is not only desirable but needed. It is the moral responsibility of the employer and expected benefit to the employee to be able to manufacture goods without occupational injuries.

Operation & Maintenance

READ CAREFULLY

The MODEL 58B METAL CUTTING BAND SAW is designed for efficient performance. With proper care, it will give you many years of dependable service. READ THIS MANUAL CAREFULLY BEFORE OPERATING YOUR NEW SAW.

After final assembly, each saw is inspected and tested. No adjustment should be needed.

This manual has been prepared to assist you in the operation and maintenance of your new saw. If you desire additional information or assistance, please contact your dealer's service representative.

INSTALLATION

Uncrate and check all parts. Report any damage to your carrier and file a Proof of Loss Claim with the carrier.

Be sure motor specifications correspond with your power source.

Place the saw so that each leg is carrying its share of the load. The 58B Saw can be operated both horizontally and vertically. For vertical operation, place frame in upright position, attach the vertical work table, and operate switch manually.

OPERATION

Do not apply too much feed rate. Start cut carefully and the new blade will last much longer. Make sure all four legs are in solid contact with the floor. Keep blade guide as close to the work as possible.

PLACING BLADE ON SAW

1a. Dry Cutting Machine! Release from safety latch bar and swing frame into vertical position.

1b. Machine with Wet Cutting System! Remove chip pan, then follow instructions in 1a.

2. Open idler wheel hinged guard.

3. Remove blade guard

4. Turn blade tension wing screw to lower the idler wheel and slide block assembly.

5. Uncoil a 1/2" x 93" blade.

6. When facing cut-off side of machine, blade must travel toward the motor end.

7. Be sure blade teeth point in this direction. If not, twist blade band inside-out.

8. Install blade as follows:

a. Place blade between guide bearings and brushes

b. Insert blade into slot between frame and guard.

c. Slide blade onto the drive and idler wheels.

d. Turn tension wing screw until blade is taut.

e. Make sure blade is completely on band wheel but not riding on either wheel flange.

9. Briefly start and stop motor a few times to make sure blade is riding correctly on band wheels, then tighten blade to proper operating tension.

10. Replace blade guard.

11. Lower frame for horizontal cutting.

12. Check safety latch bar. Be sure it is in proper position to prevent frame from being raised beyond maximum position when used as a horizontal cut-off saw.

QUICK ACTION VISE

The sliding vise jaw is equipped with a ratchet dog arm for quick action and a hand wheel for tightening work in the vise. Excessive pressure is not required to hold material securely in the vise.

FIXED JAW VISE

Two pins in the fixed vise jaw assist in the quick relocation of the fixed vise jaw for 90° cutting. For final and accurate adjustment, the blade should be squared with the vise jaw by placing machinists's square head lightly against the side of the blade and the square's blade against the machined face of the vise jaw.

NOTE: These pins must be removed before fixed vise jaw can be turned. For angle cutting, use the clamp bolts to hold fixed vise jaw.

Loosen sliding vise jaw and push against fixed vise jaw, then cap screw tightened, leaving vise vise jaws parallel.

MAXIMUM VISE CAPACITY & 45 DEGREE ANGLE ADJUSTMENT

1. Remove blade brush assembly from blade guide arm.

2. Remove the two 5/16" cap screws holding guide arm to the frame.

3. Move guide arm back to the next two holes. Replace cap screws and tighten in place.

4. Remove vise jaw pins in fixed vise.

5. Remove 1/2" cap screw from quadrant.

6. Loosen cap screw in center of vise jaw and slide vise toward motor end of machine about 2 1/4".

7. Replace 1/2" cap screw in tapped holes and tighten lightly.

8. With saw frame in cut-off position, place head of machinist's square lightly against slot in bed with the blade of square against machined face of vise jaw. Tap lightly with lead hammer until vise jaw is parallel to blade of square. Tighten cap screws. Use a protractor for angle adjustment.

DASH POT

Wellsaws are equipped with a dash pot (frame check) to stabilize the downward travel of the saw frame to protect the saw blade from damage. The action is hydraulic. The flow of fluid being bypassed through an orifice controls the downward stroke of the saw frame.

Fill dash pot to within 1" of top of the bottom cylinder with Cities Service "Amplex 05" Hydraulic Oil or equivalent.

FRAME WEIGHT ADJUSTMENT

The position of the collar in relation to the spring on the dash pot acts as the frame weight adjustment

The proper frame weight is approximately 10 lbs. and is obtained by positioning the collar 3 3/4" down from the top edge of the *upper* cylinder to the top edge of the collar. For less frame weight, loosen collar and move downward toward tension spring. Reverse procedure for more frame weight.

Too much frame weight will cause the blade to cut crookedly.

SWITCH AND MOTOR

This saw is equipped with a start-stop switch that automatically shuts off the motor at the completion of a cut when the wheel guard contacts the switch control rod. If adjustment is necessary, adjust the switch control lever to the desired position for proper shut-off.

It is necessary to raise the saw frame clear of the switch control lever before the saw can be started.

Thermal overload protection is provided in the motor. Should the motor stop for other than normal reasons, it may be due to overload. After the problem has been corrected, the motor may be reset by following the instructions on the motor name plate.

SPEED SELECTION

Saws are equipped with step pulleys that provide three speeds: 76, 141 and 268 blade feet-per-minute. Change blade speed by loosening wing screw close to the motor pivot. Place belt in desired position, tighten wing screw until belt is snug and lock wing screw with wing nut.

FAST speed to cut thin-wall metal, tubing, thin brass or any metal that will not burn teeth.

MEDIUM speed on general cutting such as cold rolled machine steels or any metals which require a slow speed on a lathe.

Use beeswax when cutting brass. Brass should always be cut with a new blade. If teeth wear unusually fast, use slower speed. Always keep the blade in proper tension.

MAINTENANCE

BEFORE MAKING ANY ADJUSTMENTS, ALWAYS TRY A NEW BLADE TO MAKE SURE THE CAUSE OF THE PROBLEM IS NOT A WORN BLADE.

Blade guides are provided to hold the blade in both horizontal and vertical alignment.

Accuracy of cut depends on proper adjustment of the blade bearings. Check their condition for wear or a tendency to stick. When the blade is moved sideways or with a twisting action, the movement should stop at the bearings and not be transferred beyond this point

An eccentric axle is provided on each blade guide. By rotating this axle, the bearing is drawn away from or toward the blade.

ADJUSTMENT OF GUIDES

(See Page 13)

BLADE BRUSHES

Brushes should be cleaned frequently with kerosene or a good solvent. To take advantage of both rows of bristles, invert blade brushes and install them on the opposite side of the blade.

For best results, replace worn, filled or sticky brushes. In bolting brushes to the mounting angles, be sure wire bristles are turned in the same direction that the blade travels.

LUBRICATION

Correct and adequate lubrication is a very important to achieve maximum service. It is imperative that all dust and dirt be removed before lubricating.

Marfak Grade "O" Grease, or equivalent, is used in the gear case. Other parts of the saw may be lubricated as follows.

1. Vise adjusting screw. Use a heavy oil or light grease.
2. Keep internal ring gear and pinion well lubricated with a good quality, medium grade, fibrous grease.
3. Wheel ball bearings are sealed and permanently lubricated.
4. Apply a few drops of machine oil to the frame pivot bar
5. For proper motor lubrication, follow the motor manufacturers instructions

LUBRICATION SUMMARY

GEAR CASE: Service interval; inspect after 3 years and annually thereafter.

Lubricant: Texaco Marfak Grade 'O' or equivalent.

Viscosity: SUS @ 100°F = 4125

Military Specification: None

WISE SCREW, EXTERNAL PLASTIC GEAR,

PINION: Inspect monthly.

Lubricant: Lubriplate 130-A or equivalent.

Viscosity: SUS @ 100°F = 750-800 Military

Specification: MIL-G-46003

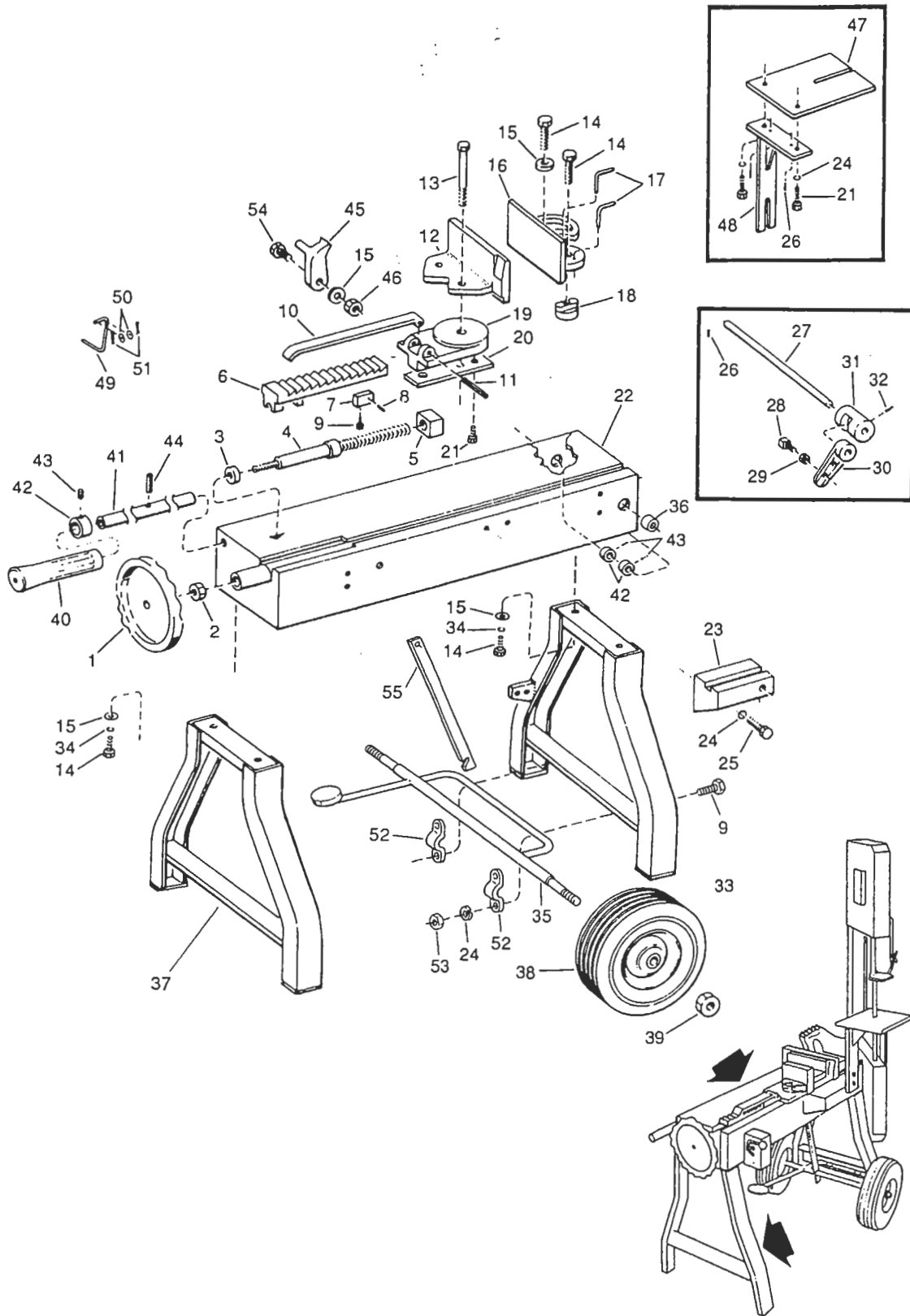
HELPFUL SUGGESTIONS

1. To select the proper blade, consider the type of material to be cut as well as to its size and shape. The SELECT-O-CHART is a handy reference guide.
2. Use the correct blade speed and correct pressure for each type of material cut.
3. Always maintain proper blade tension.
4. Lower saw frame carefully so that the blade will start cutting before full frame feed pressure is applied to the blade.
5. Reduce feeding pressure for the first two or three cuts with a new blade.
6. Keep the adjustable blade guide as close as possible to the material being cut.
7. Keep blade brushes in contact with the blade teeth a all times.

Recommended Service Kit For Insurance Against Downtime

2 Years		
100406-001	Bearing	6 req'd.
100066-002	"V" Belt	1 req'd.
M-426	Blade Brush	2 req'd.

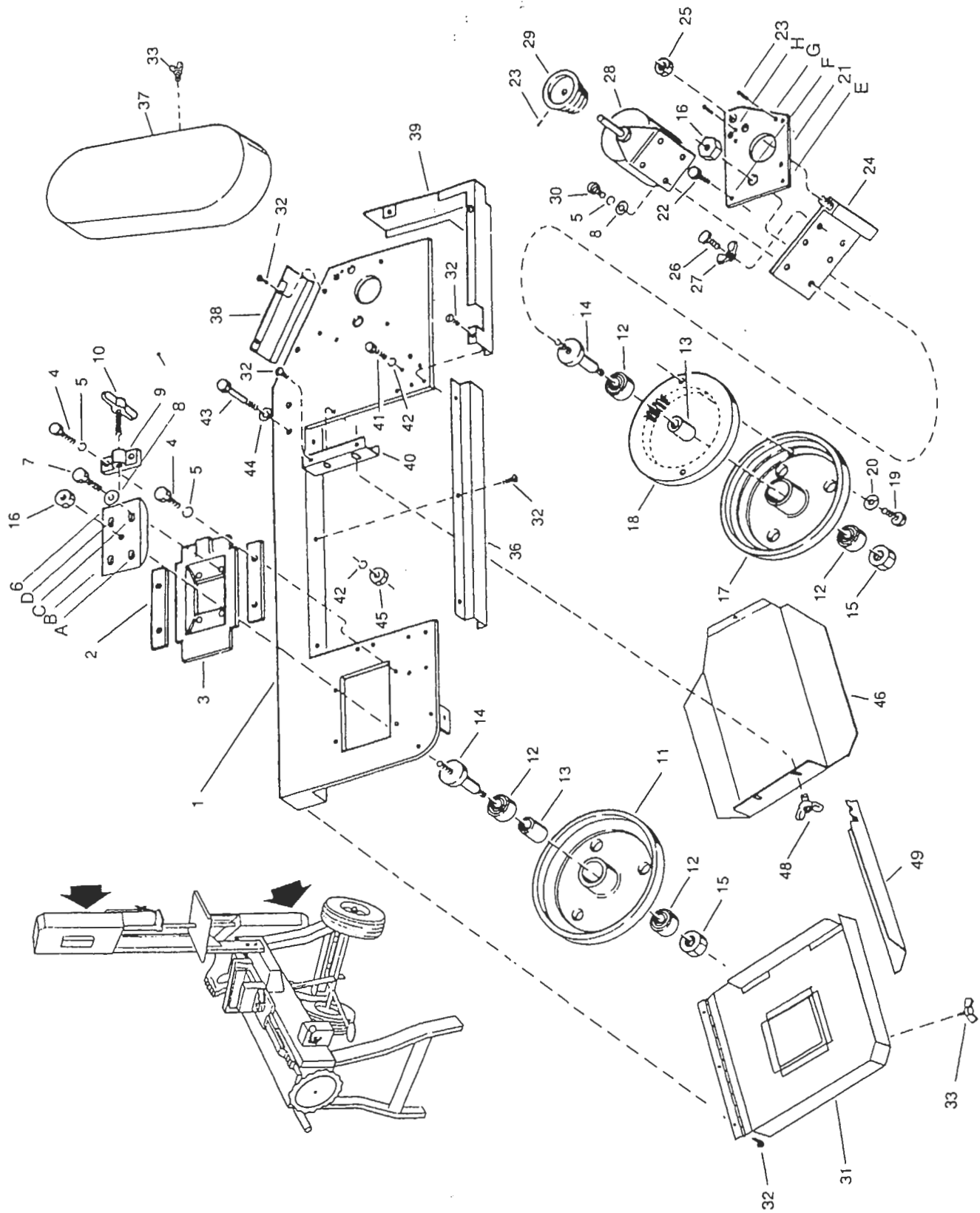
Bed & Leg Details



Bed & Leg Details

1	A-016	Hand Wheel
2	100019-008	Hex Jam Nut, 3/4 -10
3	100402	Thrust Collar
4	102889	Vise Screw
5	M-061	Vise Screw Nut
6	102890	Vise Ratchet
7	102957	Clamp Block
8	100053-005	Roll Pin 3/16 x 1
9	100004-020	Cap Screw, Hex Hd, 5/16-18 x 1-1/4
10	102891	Vise Ratchet Dog
11	100053-002	Roll Pin 3/8 x 2-1/2
12	105847	Movable Vise Jaw
13	100004-039	Cap Screw, Hex Hd, 1/2-13 x 2-1/2
14	100004-037	Cap Screw, Hex Hd, 1/2-13 x 1-1/2
15	155107	Flat Washer 1/2
16	A-031	Stationary Vise Jaw
17	M-065	Locating Pin
18	A-151	Clamp Nut
19	105839	Vise Slide Block
20	105840	Vise Slide Block Guide
21	100004-015	Cap Screw, Hex Hd, 5/16-18 x 3/4
22	105845	Bed
23	101750	Tip-Off Block
24	100025-002	Lock Washer. 5/16
25	100004-063	Cap Screw, Hex Hd. 5/16-18 x 3/4
26	100034-003	Set Screw, 5/16-18 x 3/8
27	A-062	Stop Bar
28	100033-023	Set Screw, 3/8-16 x 2-1/2
29	100017-003	Hex Nut, 3/8-16
30	A-013	Stop Arm
31	A-036	Stop Arm Housing
32	100035-011	Set Screw. 5/16-18 x 7/8
33	120209	Leg, Drive End
34	100025-005	Lock Washer, 1/2
35	102932	Wheel Axle
36	100419-007	Bushing, 2 each
37	120210	Leg, Idle End
38	102938	Wheel
39	100023-005	Nut. Self-Locking, 5/8-11
40	105826	Handle Grip
41	105818	Handle Rod
42	102886	Collar
43	100034-001	Set Screw, 1/4-20 x 3/16
44	100053-005	Roll Pin. 3/16 x 1
45	102887	Ratchet Dog
46	100019-005	Hex Jam Nut. 1/2-13
47	102923	Table Plate
47A	100064-001	Cap Screw, Washer Hd, 5/16-10 x 1
48	102924	Table Support
49	102955	Stop Latch
50	100030-004	Flat Washer, 5/16
51	100050-003	Cotter Pin, 1/8 x 1
	102922	Table Assembly. Includes items 21, 24, 26, 47, 48.
	101709	Stock Stop Assembly. Includes items 26 thru 32°
52	120201	Axle Mounting Strap (2 req'd)
53	101300	Hex Nut, 5/16 x 18
54	100008-010	Cap Screw, Socket Hd, 1/2-13 x 2-1/2
55	120033	Latch

Wheel & Frame Details



Wheel & Frame Details

WHEEL PITCH ADJUSTMENT

If the blade runs too low on wheels, it may be because of too much blade tension. Loosen the blade by turning the T handle (10) counter-clockwise (CCW). The blade must be reasonably tight.

If this adjustment does not correct the problem, adjust the wheel pitch. Usually, adjusting the idler wheel will correct the problem. However, if it doesn't, both idler and drive wheels will have to be adjusted as follows.

1. Loosen blade tension until the blade is slack by turning the T handle CCW.
2. Raise the frame into the vertical position. See diagram.
3. Loosen cap screws 7A and 7B 1/2 turn. Then tighten cap screws 7C and 7D 1/2 turn.
4. Tighten blade by turning the T handle CW. If the blade then runs in proper position on both wheels, no further adjustment is necessary.

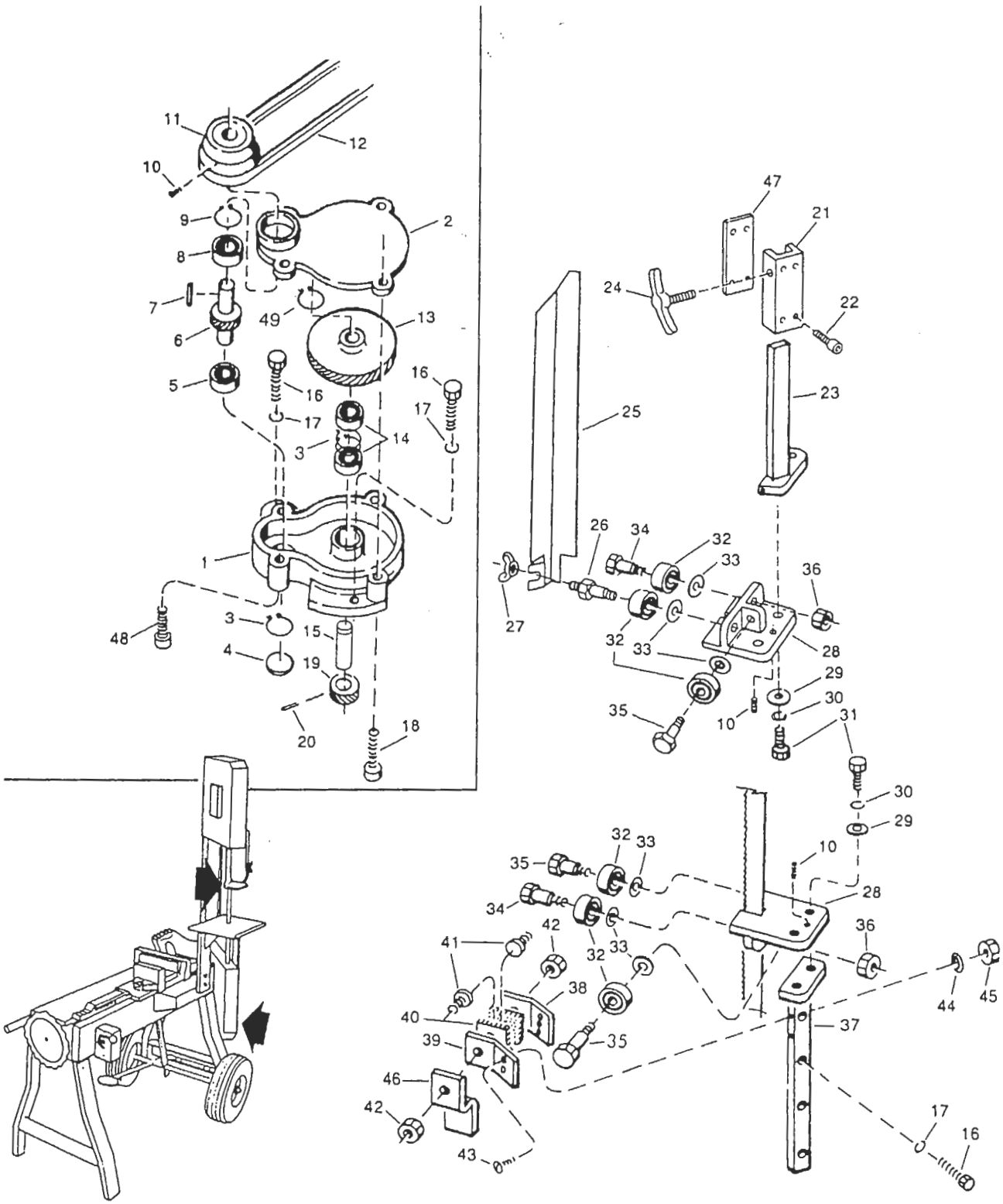
If the blade runs back to the flange of the idler wheel and not on the drive wheel, make the following adjustment.

1. Loosen the two cap screws, 22E and 22F, at the motor end of the wheel plate.
2. Tighten the two Allen screws, 22G and 22H, about 1/2 turn.
3. Tighten all four cap screws.
4. Start the motor to see if the blade runs back to the flange of the wheel.

CAUTION: Too much pitch will wear the wheel flanges and roll over the back of the blade! This problem can usually be determined by the noise of the blade rubbing against the flange. To check further, place a piece of paper between the blade and the wheel. Start the saw. The blade should not shear the paper but just fold it over. If it shears the paper, back off the adjustment a little at a time until proper adjustment is reached.

1	102874	Frame
2	A-046	Wheel Slide Block
3	A-012	Slide Block
4	100004-014	Cap Screw, Hex Hd, 5/16-18 x 5/8
5	100025-002	Lock Washer, 5/16
6	A-010	Wheel Adjusting Block
7	100004-018	Cap Screw, Hex Hd, 5/16-18 x 1
8	100029-003	Flat Washer, 5/16
9	A-009	Wing Screw Block
10	102896	Wing Screw
11	A-017B	Band Wheel, Idle End
12	100414-003	Ball Bearing
13	105415	Spacer
14	105420	Wheel Axle
15	100019-006	Hex Jam Nut, 5/16-18
16	100065-007	Hex Nut, 5/16-18
17	A-017A	Band Wheel, Drive End
18	A-086	Ring Gear
19	100004-053	Cap Screw, Hex Hd, 1/4-20 x 1
20	100025-001	Lock Washer, 1/4-20
21	102900	Wheel Plate
22	100004-063	Cap; Screw, Hex. Hd, 5/16-18 x 3/4
23	100034-003	Set Screw, 5/16-18 x 3/8
24	102903	Motor Support
25	100023-005	Nut, Self Locking, 5/8 x 11
26	100042-010	Thumb Screw
27	100024-001	Wing Nut, 1/4-20
28	100846-016	1/2 HP Motor, 115/60/1
	100846-010	3/4 HP Motor, 220/60/3, Optional
29	101238	Pulley, Motor
30	100004-012	Cap Screw, Hex. Hd, 5/16-18 x 1/2
31	102876	Wheel Guard
32	100000-017	Machine Screw. Rd. Hd, 10-32 x 1/4
33	100063	Thumb Screw
36	103877	Blade Guard
37	105530	Belt Guard
38	105811	Angle Wheel Guard
39	105810	Wheel Guard, Drive End
40	102879	Wheel Guard, Short
41	100004-026	Cap Screw, Hex. Hd, 3/8-16 x 7/8
42	100025-003	Lock Washer, 3/8
43	100004-067	Cap Screw, Hex. Hd, 3/8-16 x 3
44	100029-004	Flat Washer, 3/8
45	100017-003	Hex Nut, 3/8 x 16
	105423	Wheel Assembly, Complete, Idle End, Includes Items 11, 12, 13, 14 & 15.
	105422	Wheel Assembly, Complete, Drive End, Includes Items 12 thru 15, 17, 18, 19 & 20.
46	105615	Drive Wheel Guard
48	100024-005	Wing Nut, 1/4-20
49	105856	Moveable Blade Guard
	105858	Wheel & Blade Guard Assembly, Includes Items 31 & 49

Blade Guide & Gear Box Details



Blade Guide & Gear Box Details

1	M-013	Gear Case			
2	101291	Gear Case Cover			
3	100068-001	Snap Ring, 3 req'd.			
4	100072-001	Expansion Plug			
5	100404-002	Ball Bearing			
6	101343	Pulley Shaft & Pinion			
7	100056-001	Key, 3/16 x 3/16 x 1			
8	100414-003	Ball Bearing			
9	100068-002	Snap Ring			
10	100034-003	Set Screw, 5/16-18 x 3/8 (Not Used After SN 23053)			
11	101292	Pulley	36	100300	Eccentric Axle Nut
12	100066-002	"V" Belt	37	105830	Guide Bracket, Drive End
13	101286	Driven Gear	38	105842	Blade Brush Angle, Long
14	100404-001	Ball Bearing	39	105844	Blade Brush Angle, Short
15	101644	Drive Shaft	40	M-426	Blade Brush
15A	100056-001	Key For Drive Shaft. 1/8 x 1/8 x 3/4 (Not illustrated)	41	100073-003	Weld Bolt, 1/4-20 x 1/2
16	100004-017	Cap Screw, Hex Hd. 5/16-18 x 7/8	42	100017-001	Hex Nut, 1/4-20
17	100025-002	Lock Washer, 5/16	43	100000-057	Machine Screw, Rd Hd, 10-32 x 1-1/8
18	100008-061	Cap Screw, Socket Hd, 1/4-20 x 1-1/2	44	100027-003	Lock Washer. #10
19	101645	Drive Pinion	45	100015-008	Hex Nut, 10-32
20	100053-005	Roll Pin, 3/16 x 1	46	102949	Stationary Blade Guard
21	JK-057	Slide Block	47	105855	Shim
22	100008-003	Cap Screw, Socket Hd, 1/4-20 x 3/4	48	100008-086	Cap Screw. Socket Hd, 1/4-20 x 2
23	105853	Guide Bracket, Idle End	102901		Gear Box Assembly, Includes Items 1 thru 9 & 13 thru 20
24	102898	Wing Screw	101643		Drive Shaft & Pinion, Includes Items 15, 19 & 20
25	105856	Moveable Blade guard	105941		Blade Brush Assy., Inside, Includes Items 38 thru 40 & 42
26	105860-001	Roller Axle, Idle End	105843		Blade Brush Assy., Outside, Includes Items 39 thru 45
27	100024-005	Wing Nut, 1/4-20	101322		Roller Support Assy., Drive End, Include Items 10,28, 32 thru 36
28	101297	Roller Support	105591		Roller Support Assy., Idle End, Includes Items 10, 26, 28, 32 thru 36 & 47
29	100029-002	Flat Washer, 1/4	49	100069-003	Snap Ring
30	100025-001	Lock Washer, 1/4			
31	100004-053	Cap Screw. Hex Hd, 1/4-20 x 1			
32	100406-001	Ball Bearing			
33	100097-001	Flat Washer			
34	101299	Eccentric Roller Axle			
35	101298	Roller Axle			

BLADE GUIDE ADJUSTMENT

1. Check the blade fit between guide bearings by grasping the blade between the guide and the band wheel. 2. Twist blade back and forth.

3. If too much clearance is found, rotate the eccentric axle (34) until the bearing (32) is snug against blade and all clearance has been removed.

4. Check guide bearing (32) with thumb by applying force against beating. It should be possible to rotate the beating while it is snug against the blade and all clearance has been removed.

5. When looseness had been corrected, make another cut. If the cut is not straight, further adjustment must be made.

6. Place a square on the cut. Determine if the blade is cutting toward or away from the bed or if it is out of square with the vise.

7. If the vise is out of square, correct this by squaring the vise with the slot in the saw bed.

8. If the cut is out of square on the vertical dimension, correct this by moving the guides either away from or toward the saw bed. This is accomplished as follows;

a. Loosen the two cap screws (31) which hold the guide (28) to the guide bracket (23 & 37). Hold the guide from twist-

ing and tap it in the desire direction until the blade is square with the saw bed. To do this:

b. Place a spacer between the frame wheel guard and the switch box raising the blade teeth just above the saw bed.

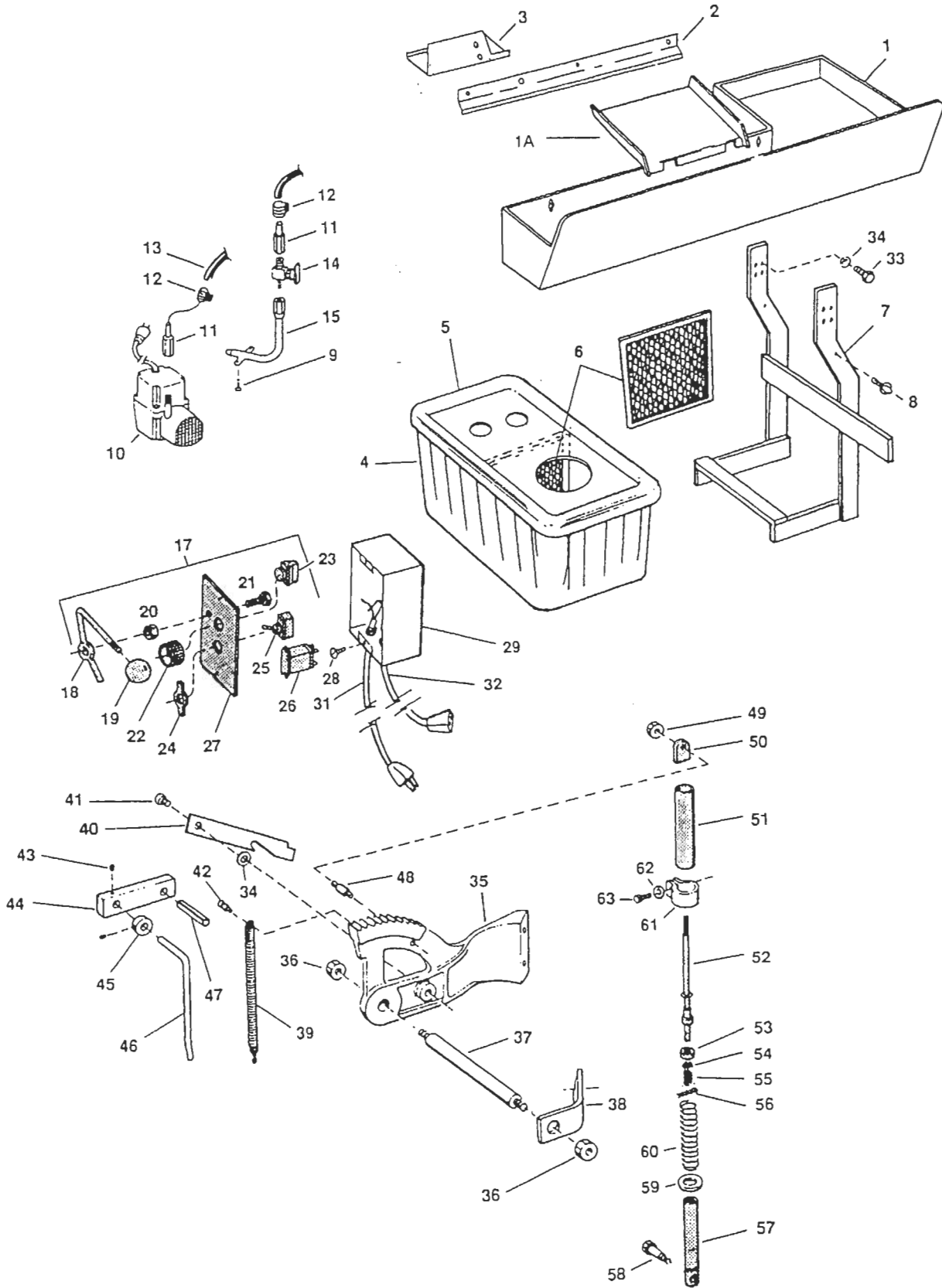
c. Place a machinists square on the saw bed and move it to touch the body of the saw blade — making sure it does not touch the blade teeth.

d. Use a feeler gauge, .002" or less, to see that the blade is square from top to bottom. If further adjustment is needed, loosen cap screws on one blade guide and rotate guide so the feeler gauge will not enter at top or bottom. Do not move guide sideways. This may move the blade out-of-square with the vise. Tighten cap screws.

3/4" Blade Guide Option

32	100416-00	Side Bearing, 4 req'd.
35	B-043	Roller Axle, 1 req'd.
26	120234	Roller Axle. 1 req'd
34	B-109	Eccentric Roller Axle, 2 req'd.

Coolant, Switch & Dash Pot Details



Coolant Switch & Dash Pot Details

1	120064	Chip Pan
1A	120041	Splash Guard
2	120231	Drip Edge
3	120230	Drip Pan
4	120160-001	Coolant Tank
5	120162	Coolant Tank Cover
6	101565-009	Screen
9	100000-017	Machine Screw, Rd Hd, 10-32 x 1/4
10	100249-010	Coolant Pump
11	102617	Adapter
12	100219-001	Hose Clamp, 3/8
13	100220-020	Coolant Hose, 3/8 x 96"
14	100226	Needle Valve, (Not Used After SN 23053)
	100226-005	Valve (Use After SN 23053)
15	102984	Coolant Nozzle (Not Used After SN 23053)
	100335-003	Elbow, 900 (Use After SN 23053)
	100332-009	Close Nipple (Use After SN 23053)
16	120229	Switch Box Assembly, Includes Items 17 thru 31
17	120228	Switch Assembly, Includes Items 18 thru 27
18	105584	Switch Lever
19	106408-003	Control Knob
20	100017-001	Hex Nut, 1/4-20
21	100004-053	Cap Screw, Hex Hd, 1/4-20 x 1
22	100851-001	Reset Guard
23	100805-001	Reset Switch
24	100804-001	Indicator Plate
25	100674-006	Toggle Switch
26	100866	Relay
27	105959	Switch Box Cover
28	100000-017	Machine Screw, Rd Hd, 10-32 x 1/4
29	105889	Switch Box
30	100597-001	Connector, TB3302, Not Shown
31	105961	Cord & Plug
32	100755-001	Cord Set, 115V For Coolant
33	100004-098	Cap Screw, Hex Hd, 5/16-18 x 1
34	100030-004	Flat Washer, 5/16
35	105828	Frame Ratchet
36	100017-007	Hex Nut, 5/8-11
37	102885	Pivot Bar
38	105829	Frame Pivot Bracket
39	105881	Spring with "S" Hook
40	120134	Latch
41	102895	Stud
42	101311	Frame Spring Anchor
43	100034-025	Set Screw, 1/4-20 x 3/8
44	120133	Stop Block
45	M-107	Collar with Set Screw
46	120135	Release Lever
47	100053-010	Roll Pin 3/8 x 1-1/2
	M-301	Dash Pot Assembly. Includes Items 50 thru 57
	101526	Piston Rod Assembly, complete. Includes Items 52 thru 56
48	M-155	Dash Pot Upper Stud
49	100017-003	Hex Nut, 3/8-16
50	M-144	Piston Rod End
51	101524	Outside Tube
52	101527	Piston Rod

53	M-166	Cup Leather
54	100070	Cup Washer
55	M-148	Spring
56	100050-002	Cotter Pin, 3/32 x 3/4
57	101523	Inside Tube
58	M-147	Dash Pot Lower Stud
59	101777	Lasher, Large
60	102918	Spring, Large
61	101776	Clamp
62	100025-002	Lock Washer, 5/16
63	100004-016	Cap Screw, Hex Hd, 5/16-18 x 7/8
64	098049-001	Dash Pot Oil (Fill to 1" from Top)

Coolant System
For Field Installation:
Order Part Number
120218

This kit includes all parts to convert
 Model B58-BD to B58-BW

Service Parts Changes

ELECTRICALS

Before 17240 to 21035

Begin 20855

Begin 21036

Use 100670-1 (Switch Only) or 102888 Switch Box Assembly.

Use 105869 Safe Start Plus and Cord Set.

120228 Switch Assembly & 100846-16 Motor.

BLADE GUIDES

To Serial Number 11751

Frame Ratchet 102858

Guide Bracket 102908 Idle End

Guide Bracket 102912 Drive End

Roller Guide Assembly 101322

From Serial Number 11752

Frame Ratchet 105828

Guide Bracket 105832 Idle End

Guide Bracket 105830 Drive End

Roller Guide Assembly 101322

BLADE GUARDS

To Serial Number 11885

Blade Guard 102963 Idle End

Blade Guard 102949 Drive End

Pivot Rod 102961

Current Idle Wheel Guard Assembly could replace old assembly using the following parts.

Idle Wheel Guard Assembly 105868

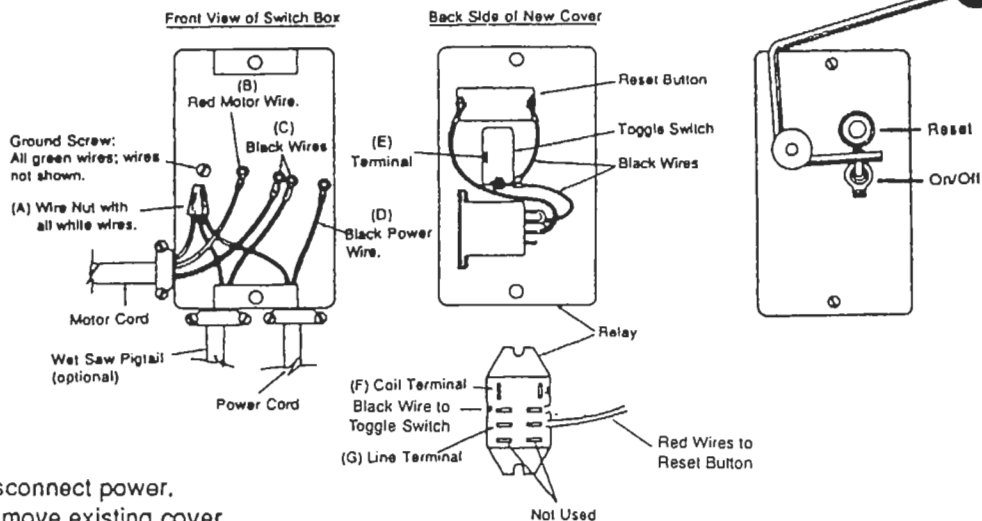
Roller Axle 105860

WHEEL KITS

To Serial Number 22020

Wheel and Handle Kit for field installation, 102931

120229 Switch Box Assembly



- 1 Disconnect power.
- 2 Remove existing cover
- 3 Remove wire nut (A) and add white pigtail with push connector.
- 4 Cut off red motor wire (B) from both ends of motor cord.
- 5 Connect black wire (C) from motor and wet saw pigtail (C) to toggle switch terminal (E).
- 6 Cut off existing terminal on black power wire (D) and replace with push terminal supplied.
- 7 Connect new white pigtail to relay coil terminal (F).
- 8 Connect black power wire (D) with new push terminal to relay line terminal (G).
- 9 Install cover on switch box.
- 10 Saw operation. Push reset button only after loss of power. Normal saw operation is by toggle switch.

Trouble Shooting

For Greater Service and Efficiency Careful Operation - Blade Consideration

DIFFICULTY	REASON	REMEDY
Cutting out of line	Too heavy a feed or worn blade.	Reduce feed rate by adjusting frame weight or replace the blade. Replace worn guide bearings when they begin to show excessive wear.
	Guides in wrong position.	Set as close to work as possible.
	Guides out of alignment.	Follow adjustment instructions.
	Set worn on one side of blade.	Keep brushes clean. Avoid teeth rubbing in cut by applying enough weight so that each tooth is cutting a good chip.
	Starting cut on odd shape where blade does not contact flat surface.	Retard feed until blade has a good start in the material.
Stripping teeth	Blade teeth too coarse.	Be sure that two or more blade teeth are in contact with material being cut.
	Hard spots on material.	Rotate stock, if possible. Do not put new blade in cut at same angle.
Breaking	Guides out of alignment.	Follow adjustment instructions.
	Blade twisting.	Adjust guides as close to work as possible. Be sure material being cut is held firmly.
	Lack of blade tension.	Always keep blade tight.
	Dash Pot Malfunction	Check hydraulic fluid level and/or condition of cup leather.
Excessive wear	Blade speed too fast.	Follow recommended cutting speeds.
Blade running off wheel	Lack of blade tension	Always keep blade tight.
	Improper wheel pitch adjustment	See instructions for wheel pitch adjustment.

Always use a light feed on new blades!