14" WOOD CUTTING AND METAL–WOOD CUTTING BAND SAW

A band saw requires a reasonable amount of care and attention in order to insure perfect performance and accurate work. No matter how good a machine a manufacturer may make, it will not do its best work unless the user takes the trouble to familiarize himself with the proper method of using the machine and setting the adjustments, and to learn what is necessary for best results. It takes but a few minutes to read these instructions, and it may save hours of trouble or delay later.

The gear case of the metal-wood cutting Band Saw contains a double clutch which permits instant change-over from gear drive to direct drive by simply shifting the clutch.

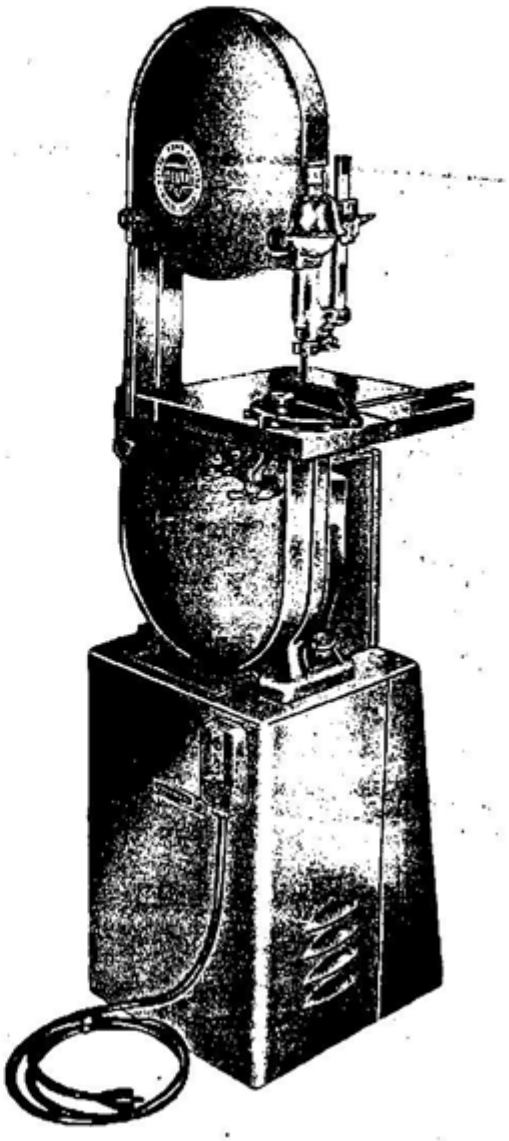


Figure 1

SETTING UP

METAL-WOOD & WOOD CUTTING MODELS

Remove the carton and weatherproof covering and place saw on stand or bench. Loosen table clamp and set table horizontal.

The table insert and the tapered pin for the table alignment hole at the end of the table slot, together with the hexagon wrench for the guides, will be found in the envelope attached to the saw. The table pin should be tapped into place with a hammer, striking lightly until the miter gage bar will slide easily in the table groove. DO NOT DRIVE THE PIN IN ANY FURTHER THAN NECESSARY, OR THE TABLE MAY BE BROKEN. The pin is very easily removed when changing blades simply by turning it with a wrench in the same manner as when removing a screw.

STAND

METAL-WOOD & WOOD CUTTING MODELS

Three stands are available with these Band Saws. They are the 886 Cast Iron Stand, the 50-891 Steel Stand, the 50-122 Totally Enclosed Steel Stand.

POWER REQUIRED

METAL-WOOD & WOOD CUTTING MODELS

We recommend a 1725 rpm motor for all applications. Only a constant speed motor should be used.

The wheels of the Band Saw should rotate in clockwise direction when viewed from the operator's side of the machine. If the motor turns the wrong way, turn it around if it is a double shaft, or reverse it in accordance with the makers instructions on the name plate.

CHANGING SPEEDS

METAL-WOOD CUTTING MODELS ONLY

One of the advantages of this saw lies in the fact that it can be changed over instantly from a slow-speed metal-cutting Band Saw to a standard high-speed Band Saw for wood.

Do not have the Band Saw running when changing from metal-cutting speed or vise-versa. When the shifter knob (b) Fig. 2, is pushed in or pulled out, it will usually be necessary to rotate the pulley, (a) manually (up to one quarter turn) to engage the lugs of the drive clutch.

To use the seven slow-speeds, be sure that the shifter knob (b) Fig. 2 is pushed in toward the pulley (a). Speeds of 40, 60, 85, and 115 fpm are obtained by having cone pulley No. 718 mounted on motor shaft and cone pulley No. 720 mounted on lower wheel shaft. By shifting the belt over the cone pulleys these speeds are obtained.

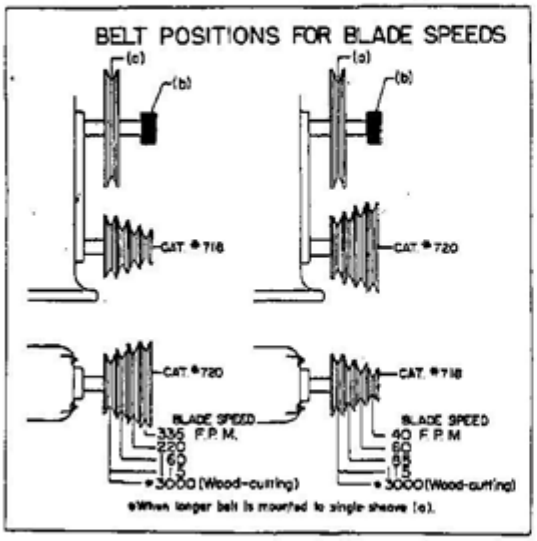


Figure 2

The remaining slow-speeds are obtained by reversing the cone pulleys No. 718 and 720, see Fig. 2. By shifting the belt positions, speeds of 115, 160, 220 and 335 fpm are obtained. Please note that the wood-cutting belt must be removed for obtaining the 115 fpm speed.

Both the 3000 and the 115 fpm speeds can be obtained with either cone pulley on the motor, because the smallest step on pulley No. 720 is the same diameter as the largest step on pulley No. 718.

To change from metal-cutting speed to wood-cutting speed, open belt guard cover and pull the shifting knob (b), Fig. 2, out, away from the pulley (a). Turn on the motor. Except for the one speed of 115 fpm, both belts may be left on the machine regardless of the speed being used.

In order to obtain all eight available blade speeds a 3/4 inch bore must be specified for motor pulley No. 718, otherwise it cannot be interchanged with the 3/4 inch bore arbor pulley, No. 720, to obtain blade speeds of 160, 220 and 335 fpm. A 3/4" to 1/2" and a 3/4" to 5/8" reducing bushing are provided with the 14" Metal Cutting Band Saw, which permits the 720 arbor pulley with 3/4" bore or the 718 motor pulley with 3/4" bore, to be used on a 1/2" or 5/8" motor shaft.

CHANGING BLADES

METAL-WOOD AND WOOD CUTTING MODELS

When changing the blade on this saw, remove upper and lower wheel guards by unscrewing and removing the knurled knobs. Lower the upper wheel by turning the star wheel of the adjustment screw in a counter-clockwise direction until the blade is loose. Remove the table alignment pin and the table insert, then slip the blade off the wheel and guide it out through the slot in table. This can be done without removing the sliding guard with blades up to 3/8 inch wide. For 1/2 and 3/4 inch blades, it is better to remove the sliding guard as the screw holes are slotted for quick removal and installation of this guard, this operation takes but a minute to perform. To install a new blade, merely reverse the above procedure.

TENSION

METAL-WOOD AND WOOD CUTTING MODELS

On the back of the upper wheel slide bracket there is a series of graduations. These indicate the proper tension for various widths of blades. With the blade on the wheel, turn the star wheel to raise or lower the wheel until the red fiber washer comes to the proper graduation for the size of the blade being used.

TABLE I SUGGESTED SPEEDS AND BLADES

SUGGESTED METAL CUTTING BLADES AND SPEEDS

MATERIAL	THICKNESS OF MATERIAL: UNDER 1/4"		1/4" TO 1/2"		1/2" & UP	
STEELS	TEETH PER INCH	FEET PER MIN.	TEETH PER INCH	FEET PER MIN.	TEETH PER INCH	FEET PER MIN.
Angle Iron	24	150	14	150		
Armor Plate	18	40	14	40	10	40
Carbon Steel	24	85	14	60	14	40
Chromium Steel	24-18	85	14	60	14	40
Cold Rolled Steel	24-18	220	14	220	14	160
Drill Rod	14	85	14	60		
Graphite Steel	18	60	14	40	14	40
High Speed Steel	24	85	14	60	14	40
Machinery Steel	18	160	14	150	14	160
Molybdenum Steel	18	85	14	60	14	40
Nickel Steel	18	40	14	40	14	40
Silicon Manganese	18	85	14	85	14	60
Stainless Steel	24	40	14	40	10	40
Structural Steel	24	160	14	160	14	115
Tungsten Steel	18	40	14	40	10	40
FOUNDRY METALS						
Brass - Hard & Soft	18	335	14	335	10	335
Bronze - Aluminum	18	335	14	335	14	335
Bronze - Manganese	18	160	14	115	14	85
Bronze - Naval	18	160	14	115	14	85
Bronze - Phosphorus	18	335	14	335	14	220
Cast Iron - Gray	18	115	14	85	10	60
Cast Iron - Malleable	18	160	14	115	14	85
Cast Steel	18	160	14	115	14	85
Copper - Beryllium	18	160	14	85	10	40
Gunmetal	24	335	18	220	14	160
Meehanite	18	160	14	115	10	85
Monel	18	115	14	85	10	60
Nickel - Cold Rolled	14	60	10	40	10	40
Nickel Silver	18	220	14	220	14	220
Silver	24	220	18	220	14	220
NON-METALS						
Bakelite	10	335	10	220	10	160
Cork	10	3000	10	3000	10	3000
Fibre	14	3000	10	3000	10	3000
Hose-Canvas, Rubber	10	3000				
Hose-Metallic	24	220				
Mica	24	335	18	220	14	220

SUGGESTED METAL CUTTING BLADES AND SPEEDS (Cont.)

MATERIAL	THICKNESS OF MATERIAL: UNDER 1/4"		1/4" TO 1/2"		1/2" & UP	
NON-METALS	TEETH PER INCH	FEET PER MIN.	TEETH PER INCH	FEET PER MIN.	TEETH PER INCH	FEET PER MIN.
Plastics	14	3000	14	3000	10	3000
Porcelain	24	160	18	115		
Slate	24	335	18	220	14	160
Transite	24	335	18	220	14	85

SUGGESTED SKIP TOOTH BLADES AND SPEEDS

MISCELLANEOUS	THICKNESS OF MATERIAL: UNDER 1/4"		1/4" TO 1/2"		1/2" & UP	
	TEETH PER INCH	FEET PER MIN.	TEETH PER INCH	FEET PER MIN.	TEETH PER INCH	FEET PER MIN.
Aluminum	3	3000	3	3000	3	3000
Asbestos	4	3000	4	3000	4	3000
Babbit	4	3000	3	3000	3	3000
Brake Lining	6	3000	4	3000		
Carbon	4	3000	3	3000	3	3000
Copper - Drawn	6	3000	4	3000	4	3000
Duralumin	3	3000	3	3000	3	3000
Lead	6	3000	4	3000	4	3000
Magnesium	3	3000	3	3000	3	3000
Paper Board	6	3000	4	3000	4	3000
Rubber - Hard	6	3000	4	3000	4	3000
Zinc	6	3000	4	3000	4	3000
Plastics	See Note		4	3000	4	3000
Builders Board	6	3000	4	3000	4	3000
Hardwoods	6	3000	4	3000	4	3000
Plywoods	6	3000	4	3000	4	3000
Softwoods	6	3000	4	3000	4	3000

Note - Some types of plastics lend themselves to more pronounced results with the regular hard saw blades.
Stocks under 1/4" thickness and tubing under 1/4" wall thickness are not adapted to skip tooth blades

SUGGESTED WOOD CUTTING BLADES (3000 F.P.M.)

USE BLADE WIDTH TO SUIT DESIRED RADIUS

WIDTH	MIN. CUTTING RADIUS	WIDTH	MIN. CUTTING RADIUS
1/8"	1/4"	1/2"	1"
3/16"	3/8"	3/4"	1 1/2"
1/4"	1/2"		

Figure 3

The graduations will be found correct for average work, and are not affected by re-brazing of the saw blade. We urge you to use these graduations until have become familiar enough with the operation of the Band Saw to vary the tension a trifle for different kinds of blades or work. Over-straining is a common cause of blade breakage and other unsatisfactory blade performance. Relax the tension when the machine is not is use.

TILTING TABLE ADJUSTMENTS

METAL-WOOD AND WOOD CUTTING MODELS

The table of these Band Saws may be tilted 45 degrees to the right and 10 degrees to the left. To tilt, loosen star wheel (22) Page 7, under each trunnion seat, and re-tighten after table has been tilted to the desired angle. To tilt the table to the left, first tilt it slightly to the right, remove the stop pin (12) from stop screw (25), then table may be tilted 10 degrees to the left. The screw (25) is set at the factory to bring the table square with the blade, but this should be checked before the machine is used to insure that the setting has not been disturbed in shipping. Turning the screw up or down enables the table to be set square; when set, it is locked with the (26) nut. Always set the set the table square with the stop pin in place on the screw . When the table is set, adjust the movable pointer (19) to the zero mark on the tilt angle scale on the front trunnion, and it will then indicate the correct tilt in degrees.

BLADES

METAL-WOOD AND WOOD CUTTING MODELS

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, 3/16, 1/4, 3/8, 1/2 and 3/4 inches.

Blades for metal cutting should be selected for the particular job they are to do. Blades for cutting thin metal, for example, should be selected so that there will always be at least two teeth in contact with the edge of the work. If the teeth are allowed to straddle the work they will be torn off and the blade ruined. Generally speaking, thick stock requires larger teeth and a slower cutting speed than thin stock. See table 1 for recommendations of Delta blades and cutting speeds, for different materials and thicknesses.

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 re-sharpened after 4 hours of operation.

It is not practical to re-sharpen either the skip tooth blades or the regular hard-edge flexible-back metal cutting saw blades.

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 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 inch Band Saw are 93½ inches long. The adjustment will accommodate blades up to a maximum length of 94 inches and to a minimum length of 91½ inches. When equipped with the No. 894 Height Attachment, new blades should be 105 inches long; maximum and minimum lengths are 106 and 103½ inches.

CENTERING BLADE

METAL-WOOD AND WOOD CUTTING MODELS

After the tension has been adjusted, revolve the wheels slowly FORWARD by hand, and watch the blade to see that it travels in the center of the upper tire. There are, a thumb screw, (126), Page 9, and wing nut, (125), on the rear of the upper-wheel bracket which are used to regulate the tilt of the upper wheel in order to make the blade "track". If, when turning the wheels by hand, the blade begins to creep toward the front edge, loosen the wing nut and tighten the thumb screw. This will tilt the top of the wheel toward the back of the machine and will draw the blade toward the center of the wheel rim. If the blade creeps toward the back of the rim, turn the thumb screw in the opposite direction. Adjust the thumb screw only a fraction of a turn at a time. NEVER ADJUST THE BLADE WHILE THE MACHINE IS RUNNING. After blade has been "tracked" in the center of the wheel rims, tighten the wing nut that locks the adjusting thumb screw. Now check the blade setting by running the saw under power.

SETTING THE GUIDES

METAL-WOOD AND WOOD CUTTING MODELS

Before attempting to set the guides, loosen the hexagon socket screws, (55) Page 7, that hold the guide blocks, and pull the blocks back entirely clear of the blade, so that they will not affect the centering of the blades on the wheel. Loosen all the thumb screws that lock the blade support and guide block brackets, and run the ball bearing blade supports and guide blocks as far back as they will go, so that the blade is completely free of all interference, ready for tensioning and centering.

The brackets carrying the guide blocks should now be adjusted forward by means of their knurled knobs until the front edges of the guide blocks will be just behind the gullets of the teeth.

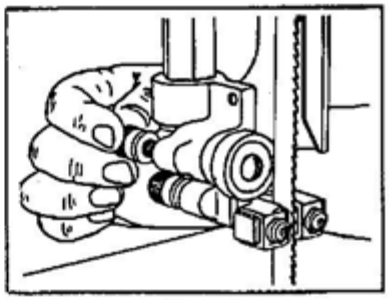


Figure 4

TURNING THE UPPER KNOB AS ABOVE ADJUSTS THE BLADE SUPPORT. THE LOWER KNOB ADJUSTS THE BLADE GUIDE BLOCKS.

If the guide blocks are too far forward, the teeth of the blade will be damaged; if they are too far back, the blade will not be adequately supported. Fig. 4 shows how the upper blade guide is adjusted.

When the brackets have been properly adjusted, set the guide blocks inward until they are as close as possible to the blade, but without binding it, then tighten the set screws that hold the blocks and adjust the ball-bearing blade supports in toward the back of the blade. The back edge of the blade should overlap the outside diameter of the ball bearing by about 1/16". The bottom roller is set at the factory and is fixed, but the top roller is mounted on an eccentric shaft and can be adjusted if required. The supports should be adjusted so they will be about 1/64" clear of the back of the blade whenever the blade is running free without cutting. The blade should bear against the support ONLY WHEN IT IS ACTUALLY CUTTING. If the blade is allowed to run hard against the supports at all times, the back will become work-hardened, and this will cause eventual breakage. The proper adjustments are very important for the correct operation of the saw.

Be sure to re-adjust the guides every time you change a blade, especially if you use blades of varying widths.

After considerable use, the guide blocks will be worn at their front edges, causing a tendency to bind on the rear of the blade. Original accuracy may be obtained by reversing ends. When both ends are worn, grind them square or install new guide blocks.

OPERATING THE BAND SAW

METAL-WOOD AND WOOD CUTTING MODELS

Before starting the machine, see that all adjustments are properly made and the guards are in place. Turn the pulley be 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

METAL-WOOD AND WOOD CUTTING MODELS

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.

LUBRICATION

METAL-WOOD CUTTING MODELS ONLY

The gear case is filled at the factory with 1½ quarts of oil. It should be drained after 1500 to 2000 hours of operation and refilled with a good grade of heavy adhesive gear oil.

All models are equipped with a ⅛ inch street elbow, (148), Page 9, and pipe oil gage.

Check the level of the oil in the gear case from time to time and keep it filled to insure proper gear lubrication.

The wheels of the band saw are carried on sealed for life ball bearings, which require no lubrication. Ball bearing blade supports are of the same type. Oil of every kind should be kept away from the blade supports.

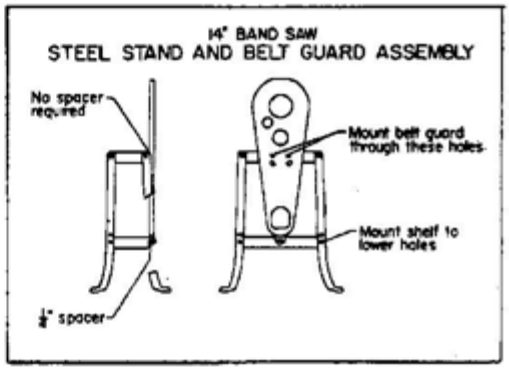


Figure 5

INSTALLING BELT GUARD TO 50-891 STEEL STAND

METAL-WOOD CUTTING MODELS ONLY

After mounting metal Band Saw to the stand, remove the cone pulley from the lower arbor and the large single groove pulley from the upper arbor, by removing the knob (167) Page 9, and pulley.

Mount the guard, Cat. No. 883 to the stand using the holes for the top shelf of the steel stand as shown in Fig. 5. The single bottom hole in the guard requires a ¼ inch spacer which is provided, to correctly space it from the bottom shelf. No spacers are necessary between guard and top shelf of steel stand. When mounting guard to cast iron stand, use ¼ inch spacer provided when fastening to bottom hole. No spacer necessary for top hole.

After guard has been mounted, replace all pulleys, key, dog clutch and snap rings. Place cone pulley No. 718 on motor shaft when speeds of 40, 60, 85 and 115 or 3000 fpm are desired. See drawings for correct installation, mount the two belts provided.

RIP-FENCE ATTACHMENT

METAL-WOOD AND WOOD CUTTING MODELS

Due to the short distance between guides on the saw, ripping is done very successfully with the addition of No. 28-843 rip-fence attachment. To attach this, the shoulder screws that come with the attachment are screwed into the tapped holes provided on front and rear edges of the table, the guide rails are slipped over screws and tightened in place.

The rip fence may be used on either side of the blade, as it can be slipped onto the guide rails from either end. Attachment No. 28-843 has 18-inch guide rails, and permits ripping up to the limits of the table. Attachment No. 28-845 has 32-inch guide rails, for cuts up to 23 inches.

WOOD CUTTING MODELS

For the wood cutting models which do not have the metal cutting feature, follow the above instructions except as listed below.

SPEED

WOOD CUTTING MODELS ONLY

A blade speed of 3000 fpm is obtained by using a 1725 rpm motor, No. 5275 motor pulley, No. 49-173 "V" Belt, and No. 5600 Arbor pulley. (The No. 5600 pulley is furnished as part of basic equipment.)

LUBRICATION

WOOD CUTTING MODELS ONLY

All bearings used in the wood cutting models are sealed for life, therefore, requiring no lubrication.

INSTALLING BELT GUARD TO 50-891 STEEL STAND

WOOD CUTTING MODELS ONLY

Assemble stand as explained above for Metal-Wood Cutting Band Saw. Be sure to use the lower mounting holes for the bottom pan.

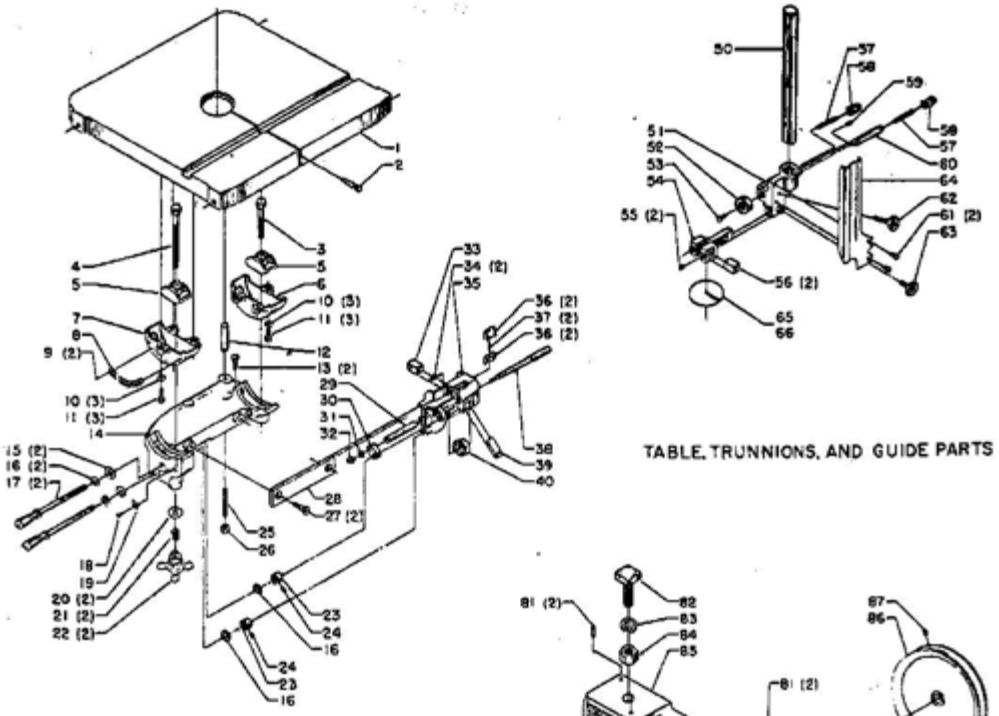
When using 6 inch frame Delta motors a 1¼" riser block must be used between the bottom pan and the motor feet. The riser blocks are supplied with the Delta motor. The 8⅝ inch frame motor is mounted on four rubber washers which are furnished with the band saw.

Remove No. 5600 arbor pulley and assemble guard as explained for the Metal-Wood Cutting Model.

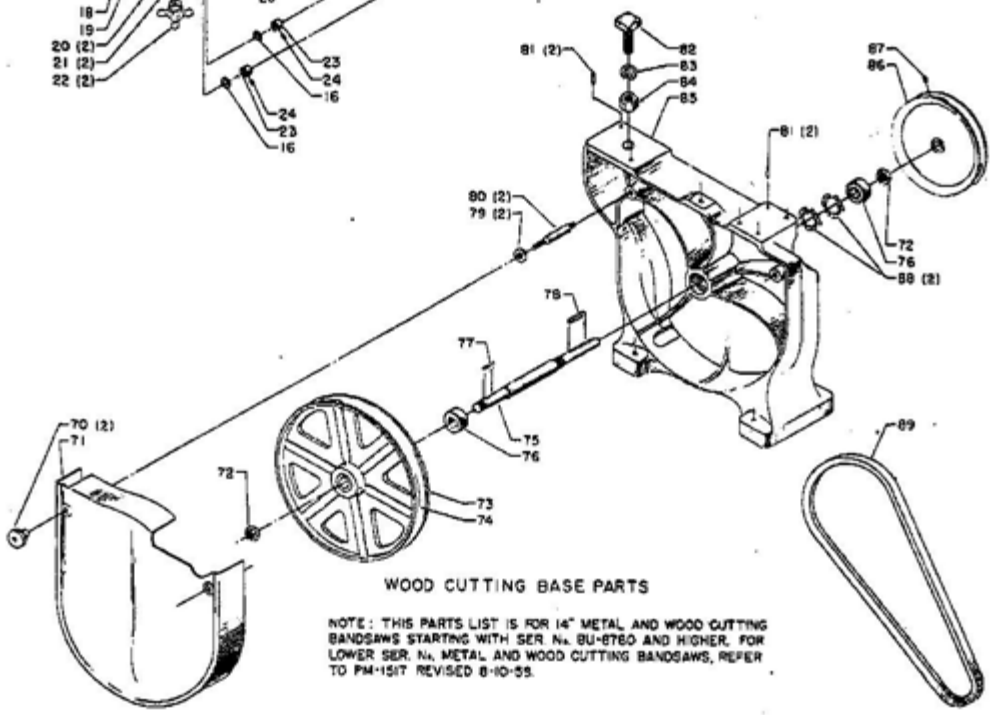
ACCESSORIES

Cat. #718	4 Step Motor Pulley, specify bore
Cat. #720	4 Step Arbor Pulley, specify bore
Cat. #865	Clamp Attachment for Miter Gage
Cat. #873	Clamp Screw and Block
Cat. #882	Lamp Attachment
Cat. #883	Belt Guard
Cat. #886	Cast Iron Stand
Cat. #1032	1/8" W. x 7 Teeth Blade, 93 1/2" long
Cat. #1033	3/16" W. x 7 Teeth Blade, 93 1/2" long
Cat. #1034	1/4" W. x 7 Teeth Blade, 93 1/2" long
Cat. #1036	3/8" W. x 6 Teeth Blade, 93 1/2" long
Cat. #1038	1/2" W. x 6 Teeth Blade, 93 1/2" long
Cat. #1040	3/4" W. x 4 Teeth Blade, 93 1/2" long
Cat. #1045	1/8" W. x 7 Teeth Blade, 105" long
Cat. #1046	3/16" W. x 7 Teeth Blade, 105" long
Cat. #1047	1/4" W. x 7 Teeth Blade, 105" long
Cat. #1048	3/8" W. x 6 Teeth Blade, 105" long
Cat. #1050	1/2" W. x 6 Teeth Blade, 105" long
Cat. #1052	3/4" W. x 4 Teeth Blade, 105" long
Cat. #1058	1/2" W. x 10 Teeth Blade, 93 1/2" long (metal cutting)
Cat. #1060	1/2" W. x 14 Teeth Blade, 93 1/2" long (metal cutting)
Cat. #1062	1/2" W. x 18 Teeth Blade, 93 1/2" long (metal cutting)
Cat. #1064	1/2" W. x 24 Teeth Blade, 93 1/2" long (metal cutting)
Cat. #5215	Motor Pulley, specify bore
Cat. #28-463	Band Saw Blade Butt Welders (115 Volt)
Cat. #28-464	Band Saw Blade Butt Welders (230 Volt)
Cat. #28-810	Sanding Attachment
Cat. #28-836	Sanding Belt, 80 Grit, Fine, 91" long
Cat. #28-837	Sanding Belt, 40 Grit, Med., 91" long
Cat. #28-843	Rip Fence with 18" Guide Bars
Cat. #28-845	Rip Fence with 32" Guide Bars
Cat. #28-852	Screw Feed Attachment
Cat. #28-884	1/4" W. x 6 Teeth, Skip Tooth Blade, 93 1/2" long
Cat. #28-885	3/8" W. x 4 Teeth, Skip Tooth Blade, 93 1/2" long
Cat. #28-886	1/2" W. x 4 Teeth, Skip Tooth Blade, 93 1/2" long
Cat. #28-887	3/4" W. x 3 Teeth, Skip Tooth Blade, 93 1/2" long
Cat. #49-111	Matched V-Belt, Set of Two
Cat. #49-263	Retractable Caster Set
Cat. #50-122	Totally Enclosed Steel Stand
Cat. #50-884	Auto-Set Miter Gage
Cat. #50-891	Steel Stand

Note: 93 1/2" long blades are standard length, 105" long blades are for use with No. 894 height attachments.



TABLE, TRUNNIONS, AND GUIDE PARTS



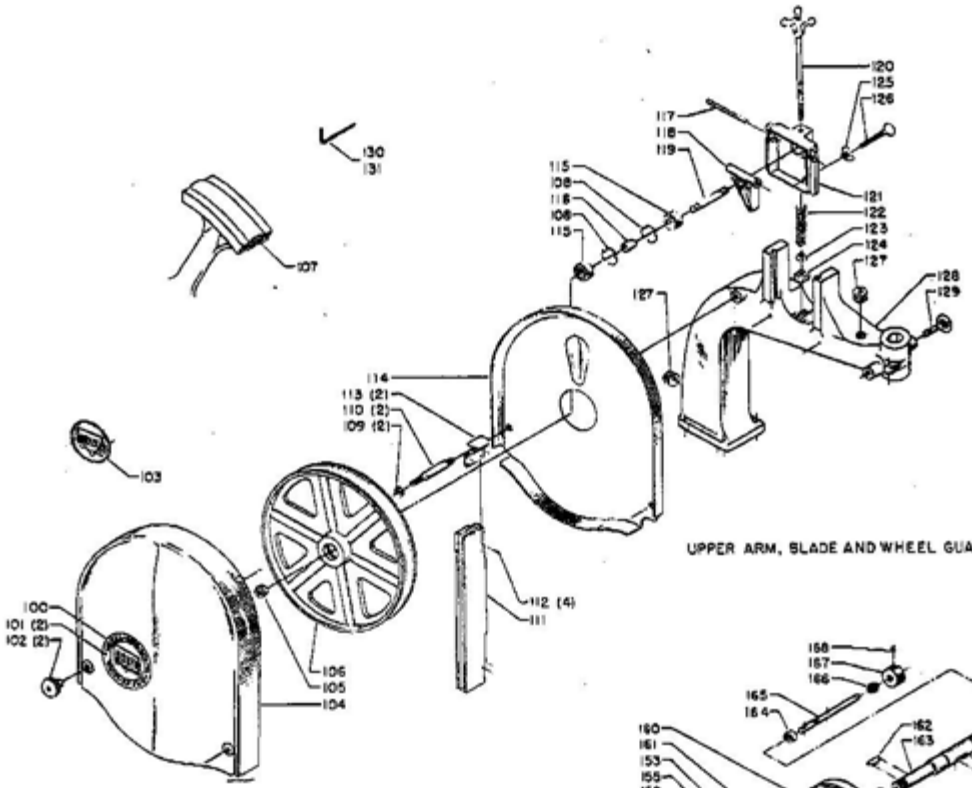
WOOD CUTTING BASE PARTS

NOTE: THIS PARTS LIST IS FOR 14" METAL AND WOOD CUTTING BANDSAWS STARTING WITH SER No. BU-6760 AND HIGHER. FOR LOWER SER. No. METAL AND WOOD CUTTING BANDSAWS, REFER TO PM-151T REVISED 8-10-55.

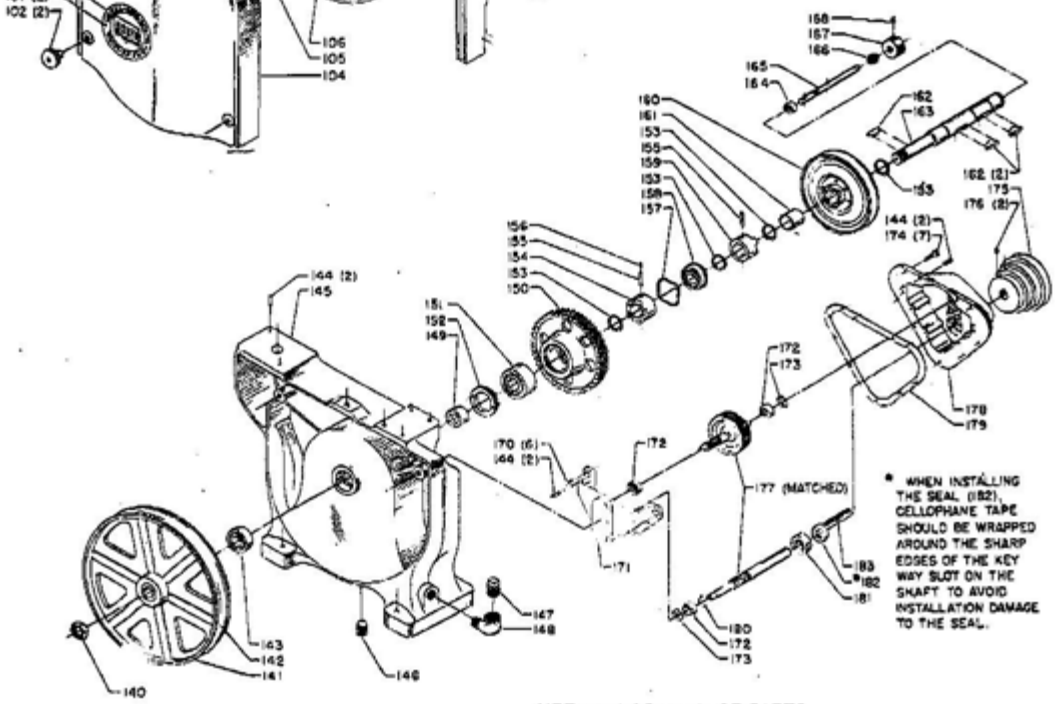
Replacement Parts

Ref. No.	Part No.	Description
1	LBS-58	Table
2	LBS-55	Tapered Table Pin
3	SP-625	7/16-14 x 2 1/4"Hex. Hd. Cap Scr.
4	SP-631	7/16-14 x 4"Hex. Hd. Cap Scr.
5	LBS-61	Trunnion Clamp Shoe
6	LBS-60	Trunnion
7	LBS-60-S	Trunnion, Including:
8	LBS-62	Scale
9	LBS-63	Brass Rivet
10	SP-1603	1/4 x 9/16 x 3/64"Steel Washer
11	SP-612	1/4-20 x 5/8"Hex. Hd. Cap Scr.
12	LBS-4	Removable Base Table Stop
13	SP-702	5/16-18 x 3/4"Fil. Hd. Cap Scr.
14	LBS-10	Trunnion Support Bracket
15	BM-45	13/32 Spring Washer
16	LBS-170	25/64" Fiber Washer
17	LBS-167-S	Adjusting Screw w/ Knob
18	SP-552	#10-32 x 5/16 Rd. Hd. Scr.
19	SBS-46	Pointer
20	SP-1606	7/16 x 1 x 5/64"Steel Washer
21	NCS-33	Spring
22	NCS-32	Hand Knob
23	LBS-169-S	Set Collar, Including:
24	SP-101	1/4-20 x 1/4"Headless Set Scr.
25	SP-105	5/16-18 x 2"Headless Set Scr.
26	SP-5435	5/16"-18 Hex. Jam Nut
27	SP-408	5/16-18 x 3/4"Flat Hd. Scr.
*	LBS-160-S	Lower Blade Guide, Consisting of:
28	LBS-165	Rail for Lower Guide Bracket
29	LBS-164	Spacing Sleeve
30	LBS-162	Adj. Link for Support Bracket
31	SP-1603	1/4 x 9/16 x 3/64"Stl. Washer
32	SP-1029	1/4"-20 Hex. Nut
33	LBS-132	Blade Guide Block
34	SP-225	5/16-18 x 1/4"Soc. Hd. Set Scr.
35	LBS-160	Support Bracket for Lower Guide
36	LBS-161	Wedge for Lower Guide Bracket
37	LBS-166	Coil Spring
38	LBS-163	Shaft for Lower Support Bearing
39	LBS-152	Angle Guide Block
40	SP-5352	Bearing
50	LBS-126	7/8 x 10" Hex. Guide Post
*	LBS-127-S	Upper Blade Guide, Consisting of:
51	LBS-127	Bracket
52	SP-5352	Bearing
53	SP-509	1/4-20 x 1/2"Rd. Hd. Scr.
*	LBS-131-S	Bracket w/Guide Blocks, Consisting of:
54	LBS-131	Guide Block Bracket
55	SP-225	5/16-18 x 1/4"Soc. Hd. Set Scr.
56	LBS-132	Blade Guide Block
57	LBS-129	Headless Set Scr.
58	LBS-130	Knurled Nut
59	SP-201	5/16-18 x 5/16"Soc. Hd. Set Scr.
60	LBS-128	Hex. Shaft
61	SP-514	1/4-20 x 3/8"Rd. Hd. Scr.
62	SP-1528	5/16-18 x 1"Thumb Scr.
63	SP-1520	5/16-18 x 1/2"Thumb Scr.
64	LBS-180	Sliding Blade Guard
65	LBS-56	Aluminum Insert (Wood Cutting Model)
66	LBS-265	Steel Insert (Metal Cutting Model)
70	LBS-282	Knob
71	LBS-166	Lower Wheel Guard
72	LBS-86	Hex. Jam Nut
73	LBS-304-S	Lower Wheel, Including:
74	LBS-81	Tire
75	LBS-85	Shaft
76	SP-5338	Bearing
77	SP-2603	#705 Hi-Pro Key
78	SP-2650	5/16 x 3/16 x 1 3/8"Key
79	BM-46	25/64" Steel Washer
80	LBS-283	Stud
81	SBS-8	Tapered Dowel Pin
82	SP-2352	3/4-10 x 2"Sq. Hd. Bolt
83	SP-1707	3/4" Lockwasher
84	SP-1027	3/4"-10 Hex. Nut
85	LBS-5	Base
86	Cat. #5600-C	Pulley, Including:
87	SP-201	5/16-18 x 5/16"Soc. Hd. Set Scr.
88	SP-7353	Bearing Loading Spring
89	Cat. #49-173	V-Belt
*	Cat. #1034	Band Saw Blade

* Not Shown



UPPER ARM, SLADE AND WHEEL GUARD



METAL-CUTTING BASE PARTS

Replacement Parts

Ref. No.	Part No.	Description
100	LBS-284	Nameplate (Metal Cutting Model)
101	LBS-68	Brass Rivet
102	LBS-282	Knob
103	LBS-283	Nameplate (Wood Cutting Model)
104	LBS-187	Upper Wheel Guard
105	SP-1227	1/2-20 Hex. Jam Nut
106	LBS-290-R	Upper Wheel, Including:
107	LBS-81	Tire
108	LBS-108	Bearing Retainer
109	BM-46	25/64" Steel Washer
110	LBS-283	Stud
111	LBS-191-S	Wooden Guard, Including:
112	SP-2006	#5 x 1/2 Rd. Hd. Wood Scr.
113	LBS-179	Guard Mounting Bracket
114	LBS-189	Upper Wheel Guard Pan
115	SP-5336	Bearing
116	LBS-109	Spacing Sleeve
*	LBS-102-S	Sliding Bracket, Consisting of:
117	LBS-103	Steel Pin
118	LBS-101	Upper Wheel Shaft Hinge
119	LBS-110	Upper Wheel Shaft
120	LBS-104-S	Blade Tension Screw with Star Wheel
121	LBS-102	Upper Wheel Sliding Bracket
122	LBS-105	Coil Spring
123	LBS-112	13/32" Fiber Washer
124	LBS-111	Sq. Nut
125	SP-1403	5/16-18 Wing Nut
126	LBS-106	5/16-18 x 2 1/4"Thumb Scr.
127	LBS-27	Rubber Grommet
128	LBS-26	Upper Frame Arm
129	SP-1631	7/16-14 x 1 1/4"Thumb Scr.
130	Cat. #194	5/32" Hex. Wrench
131	Cat. #1535	3/16" Hex. Wrench
140	BS-224	L.H. Hex. Nut
141	LBS-289-S	Lower Wheel, Including:
142	LBS-81	Tire
143	SP-5398	Bearing
144	SBS-8	Tapered Dowel Pin
145	LBS-287	Base
146	SP-2438	1/8" Pipe Plug
147	SP-2437	1/2" Pipe Plug
148	SP-3545	1/2 x 1/2 x 90° Street Elbow
149	LBS-293	Spacer
*	LBS-292-S	Gear, Consisting of:
150	LBS-292	Gear
151	SP-5397	Bearing
152	LBS-299	Retainer Nut
153	SP-7420	Retaining Ring
154	LBS-294	Clutch
155	SP-2782	5/32 x 1" Roll Pin
156	901-04-150-9417	#10-32 x 3/16 Soc. Hd. Set Scr.
157	LBS-301	Washer
158	SP-5399	Bearing
159	LBS-295	Clutch
160	LBS-296-S	Drive Pulley, Including:
161	LBS-303	Bushing
162	SP-2640	#808 Hi-Pro Key
163	LBS-291	Shaft
164	426-03-017-0003	Felt Bushing
165	LBS-297	Shifter Rod
166	LBS-300	Threaded Bushing
167	LBS-298	Knob
168	SP-261	5/16-18 x 5/16"Soc. Hd. Set Scr.
170	SP-559	#10-32 x 1/2 Rd. Hd. Scr.
171	LBS-274	Cover
172	SP-5375	Bearing
173	SP-7554	Bearing Loading Spring
174	SP-626	1/4-20 x 3/4"Hex. Hd. Cap Scr.
175	Cat. #720	Pulley, Including:
176	SP-201	5/16-18 x 5/16"Soc. Hd. Set Scr.
177	LBS-272-S	Intermediate Gear w/Shaft (Matc
178	LBS-275	Gear Housing
179	LBS-305	Gasket
180	SP-7047	Retaining Ring
181	SP-5974	Bearing
182	SP-5253	Seal
183	SP-2651	3/16 x 3/16 x 2 1/8" Key
*	LBS-279	7/16 x 1 1/4 x 5/16"Rubber Wash
*	426-03-017-0002	3/4 to 1/2" Reducing Bushing
*	426-03-017-0004	3/4 to 5/8" Reducing Bushing
*	Cat. #1062	Band Saw Blade
*	Cat. #49-111	V-Belt (Matched Set of 2 Belts)
*	Not Shown	

ROCKWELL GUARANTEE

Rockwell is proud of the quality of the power tools which it sells. The component parts of our tools are inspected at various stages of production, and each finished tool is subjected to a final inspection before it is placed in its specially designed carton to await shipment. Because of our confidence in our engineered quality, we agree to repair or replace any part or parts of Rockwell Power Tools or Rockwell Power Tool Accessories which examination proves to be defective in workmanship or material. In order to take advantage of this guarantee, the complete portable power tool or accessory, or in the case of machinery, the part must be returned prepaid to the appropriate factory, factory branch, or authorized service station for our examination. This guarantee, of course, does not include repair or replacement required because of misuse, abuse, or normal wear and tear. Repairs made by other than our factory, factory branch, or authorized service station, relieves Rockwell of further liability under this guarantee. This guarantee is made expressly in place of all other guarantees expressed or implied with respect to fitness, merchantability or quality.