OPERATION AND MAINTENANCE INSTRUCTIONS WITH PARTS LIST FOR

CRAFTSMAN CONTINUOUS- BLADE POWER HACKSAW

MODEL NUMBER 108.22920

The above Model Number will be found on a plate attached to the tool bed. Always mention this Model Number when communicating with us or when ordering repair parts or replacements for your equipment.

HOW TO ORDER REPAIR PARTS

All parts listed herein may be ordered through SEARS, ROEBUCK AND CO. or SIMPSONS-SEARS LIMITED. When ordering parts by mail from the mail order house which serves the territory in which you live, selling prices will be furnished on request or parts will be shipped at prevailing prices and you will be billed accordingly.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN THIS LIST:

- 1. The PART NUMBER. 3. The MODEL NUMBER 108.22920
- 2. The PART NAME. 4. The NAME of item -

Continuous-Blade Power Hacksaw

SERVICE FROM SEARS FOR YOUR CRAFTSMAN POWER HACK SAW



SEARS, ROEBUCK AND CO. and SIMPSONS-SEARS LIMITED in Canada back up your investment with quick, expert mechanical service and genuine CRAFTSMAN replacement parts.

If and when you need repairs or service, callon us to protect your investment in this fine piece of equipment.

SEARS, ROEBUCK AND CO. - U.S.A. IN CANADA, SIMPSONS - SEARS LIMITED

Part No. CV-100 Printed in U.S.A.

OPERATION AND MAINTENANCE INSTRUCTIONS CONTINUOUS-BLADE POWER HACKSAW — MODEL NUMBER 108.22920

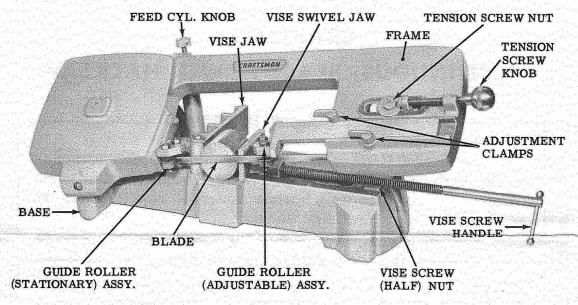


Figure 1

SETTING UP YOUR POWER HACKSAW

Your Craftsman Power Hacksaw is packaged completely assembled with a motor pulley, but without a motor. A 14-tooth raker-set blade suitable for average mild steel or cast iron such as angle iron, plates, etc. is mounted in the saw. For heavy sections like 2-1/2-in. rd. steel or iron use the 10-tooth blade, Part No. 91-2101. For non-ferrous metals (aluminum, copper, bronze) use the skip-tooth blade, Part No. 91-2103.

After unpacking, first remove the rust-preventive from all surfaces so treated by wiping them with a dry, lintless cloth. Then mount your saw with a motor, ready for use.

The motor must be a 1750 rpm type to obtain the proper blade speed of 135 ft. per min. travel required for smooth cutting. We recommend a minimum of 1/4 hp size. See your nearest Sears Retail or Mail Order Store for selection.

For stationary use, bolt the saw to a workbench in a position which will provide room for handling the longest stock you will cut. For portable use, bolt it to a suitable board (1 to 2-in. thick) on which the motor can also be mounted. In either case, shim under the feet as required to prevent twisting of the saw base when the bolts are tightened.

Mount the motor pulley on your motor, and mount the motor on the bench (or board) in a position which will align the motor pulley with the saw drive pulley — so that the V-belt ("A" section 1/2 in., not furnished) will run straight. When mounted, this belt must also have the proper tension. If it is too loose, it will slip and wear out; if too tight, it will damage the

motor and tool shaft bearings. We suggest mounting the motor on a motor rail or similar pivot-type mount which will allow the motor's weight to keep the belt at correct tension. Otherwise, provide some means of adjusting the belt tension, and adjust it so that finger pressure at its mid point will depress it approximately 1/2 inch.

OPERATING PRINCIPLES (FIG. 1)

Your saw is designed to cut through any metal stock which can be clamped between the Vise Jaw and the Vise Swivel Jaw, under the blade when the Frame is raised up.

The Vise Jaw has a slotted mount by which it is secured to the base — may be positioned straight (for a 90° cut-off), or at any angle up to 45°. Loosening of a single hollow-head screw permits setting it at the desired position.

The Vise Swivel Jaw (which swivels to adjust automatically to any position of the Vise Jaw) is mounted on a slide which permits it to be moved for opening or closing of the vise jaws. It can be moved freely when the Vise Screw Handle is raised up to lift the screw out of the Vise Screw (Half) Nut. When this handle is lowered to re-engage the screw with this half nut, the screw "locks-in" the nut — and the jaws can then be tightened to hold any workpiece firmly, simply by turning the Vise Screw Handle clockwise. The screw must be loosened before the handle can be raised up.

Cutting is accomplished by the continuous (band-saw type) blade mounted in the saw Frame. This

blade encircles a bevel gear (at its left end in the illustration) and an idler wheel (at its right end). The bevel gear is meshed with a small bevel gear mounted on the same shaft with the drive pulley—to drive the blade. The idler wheel is supported by a slide mounted in the frame and positioned by means of the Tension Screw Knob. When the Tension Screw Nut is loosened, turning this knob clockwise will slide the idler wheel outward, to increase blade tension. The blade is loosened (for removal) by turning the knob counterclockwise.

The cutting portion of the blade (at the front of the frame) is held in a vertical position and is supported at each side of the workpiece by two Guide Roller Assemblies — a Stationary one and an Adjustable one. Loosening of the two Adjustment Clamps — which clamp its slide to the frame — permits re-setting of the adjustable assembly to accommodate various width workpieces.

A pivot mount attaches the frame (at its left end) to the base. Therefore, the right end can be elevated, to position the blade for starting a cut in a "tall" workpiece — and will "settle" back down as cutting progresses. The force with which it is allowed to "settle" consequently determines the amount of feed pressure being applied (automatically) to a cutting operation.

This force (or feed pressure) is controlled by a feed cylinder linked between the frame and the base. The cylinder contains a valve through which hydraulic fluid is metered from one chamber to another when the weight of the elevated frame is applied to it. A Feed Cyl. Knob, at the top of the cylinder, operates to close the valve, or to position it for various metering rates. That is, when the knob is rotated clockwise until the valve is closed, the frame will be held stationary at any position to which it has been elevated; then, as the knob is rotated counterclockwise (to open the valve), the amount of feed pressure applied to the blade will be increased ... until, with the valve fully open, the whole weight of the frame is used. Markings indicate each quarter turn of the knob, as a guide for setting the feed pressure. Maximum feed pressure is obtained when the valve is opened 1-1/2 turns of the knob.

OPERATING PROCEDURE

NOTE

Do *not* use any lubrication on the blade. This would cause the blade to slip on its drive mechanism.

- 1. Elevate frame enough to insert workpiece under the blade, and close the feed cylinder valve to hold it stationary.
- 2. Adjust vise jaw for 90° (or other desired angle) cut-off, and tighten the hollow-head screw that secures it.

NOTE

A protractor may be used for setting close angles other than 45° and 90° (which are at the respective ends of the slot).

3. Raise the vise screw handle to slide the vise swivel jaw against the workpiece, then lower the

screw back into its nut and tighten the screw to clamp the workpiece securely.

CAUTION

Solid clamping is essential to prevent blade breakage.

4. Slowly open the feed cylinder valve and allow the blade to settle almost — but not entirely — onto the workpiece.

CAUTION

If blade actually rests upon the workpiece before the motor is started (step 7, below) some teeth may be damaged ... and if blade is ever dropped rapidly onto workpiece it might be broken. Therefore, settle it down slowly, to where it is not quite touching.

5. Check the adjustable guide roller setting, and re-set it if necessary. Always have this assembly as close to the workpiece as practicable; but leave it at least 4 inches from the stationary roller assembly to prevent its lower end from contacting the base. Retighten the two adjustable clamps securely.

NOTE

Each guide roller assembly must hold the blade perpendicular to the workpiece. These are set at the factory; but can be readjusted if necessary. Refer to "Adjustments".

- 6. Check the blade tension. Refer to "Changing Blades".
 - 7. Start the motor.
- 8. Open the feed cylinder valve to the proper setting for this operation. "Proper" setting depends upon the type of material, the type of cross-section (amount of material), and the straightness of cut desired. Soft materials (like aluminum, brass, fiber) require less feed than hard ones (like steel or iron). Cross-sections having little material (like tain-wall tubing) require less feed than solid cross-sections. And, on the whole, reduced feed pressure will result in a straighter, more accurate cut. Experience will be your best guide; and the 1/4-turn markings provided will help you duplicate settings you have found to be desirable. Never over-feed, as this causes blade breakage and poor quality cuts. On the other hand, never underfeed, as this causes premature dulling of blade teeth. If in doubt, watch the cutting action a moment. The blade should cut smoothly, without bucking or jumping (too much feed) and without "squeeking" or skimming over the metal in the cut (too little feed).
- 9. When the cut is finished, turn off the motor. Now close the feed cylinder valve and elevate the frame ready for the next operation.

While the blade with which your saw is equipped is satisfactory for most cutting jobs, our finer (14-tooth) blade will allow more feed (and faster cutting) of thin-wall tubing, etc. Also, our skip-tooth blade is preferable for cutting aluminum. Refer to the Parts List for ordering information on all three blades.

CAUTION

Experience has proved that blades thicker than than .020 inch will soon break under the strain of turning around the pulleys. Many commercial blades are thicker. Avoid these ... you can always purchase correct blades from Sears as noted above!

CUTTING PROBLEMS AND CAUSES

NOTE

A blade should accomplish between 5 and 10 hours of cutting.

BLADE BREAKAGE AND/OR TEETH RIPPING OUT:

Four adjustments affect blade life:

1) Most important is the *Guide Rollers* (B, at right). If either pair of rollers pinches too much it will bend the blade to cause unnecessary blade flexing. Keep rollers clean, free-wheeling, and properly adjusted.

2) Second, avoid excessive blade tension.

3) Third, keep Guide Roller Assemblies (C, at right) straight and with the adjustable assembly set to support the blade perpendicular to the work.

4) Fourth, avoid too heavy a feed pressure during

operation.

5) Also, do not use too coarse a tooth blade. If any two teeth straddle a thin workpiece, teeth may be ripped off.

PREMATURE BLADE DULLING:

1) Too coarse a tooth blade (refer to 5, above).

2) Too little feed pressure so that blade slips instead of cutting.

BLADE RUNNING OFF OF PULLEYS:

1) Too little tension. Refer to steps 3 and 5 under CHANGING BLADES, following.

2) Guide Rollers (B, at right) set too loose, do not

hold blade straight.

3) Guide Roller Assemblies (C, at right) not holding blade perpendicular. Also, if adjustable assembly is too far from workpiece, blade will tend to twist and not tract.

UNEVEN CUTS:

1) Work not clamped in vise securely.

2) One or both guide roller assemblies in need of readjustment to align rollers with the blade.

3). Adjustable guide roller assembly too far from workpiece to give proper support to the blade.

4) Too little blade tension.

5) Too much feed, causing blade to twist from its correct vertical position.

CHANGING BLADES (See Figure 1)

CAUTION

When changing blades do *not* scratch surface of the Valve Seat Assembly (part 9 on page 5). This seat moves through a rubber Quad-Ring (part 4), and scratches on its surface will tear the ring and cause the Feed Cylinder to leak.

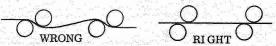
1. Raise the frame all the way up and close the feed cylinder valve to hold it.

- 2. Loosen the screw that holds the back edge of cover plate (part 54 on page 5). Swing plate aside.
- 3. Loosen the Tension Screw Nut just enough to allow movement of the Idler Wheel Support (part 44 on page 5) when the Tension Screw Knobisturned. If nut is loosened too much, the support (which it holds) will become cocked in the slot it rides in and will bind so that you cannot "feel" the blade tighten when knob is turned. Turn knob counterclockwise until blade is free.
- 4. Lift out the old blade and install new one, teeth at bottom.
- 5. Turn the Tension Screw-Knob clockwise until blade "feels" just taut. Do not use pliers or a wrench. Don't leave blade "loose"; but don't tighten excessively. Then tighten the Tension Screw Nut securely.
- 6. Replace the cover plate and tighten its holding screw.
- 7. Re-adjust the Guide Roller Assemblies, if necessary.

ADJUSTMENTS

FEED CYLINDER: If oil leaks out, an erratic feed will result. Re-fill as necessary with new SAE 20 oil to within 1/4 inch of top, by removing the Screw and Gasket (parts 1 and 2 page 5). Before pouring oil in, force the Leather Cup (part 11) to its lowest position to expell all air out hole where screw was. After filling replace the gasket and screw tightly.

page 5) of each Guide Roller Assembly can be moved toward or away from its companion Upper Guide Roller (part 22). Loosen the Nut (part 16) and shift the Guide Roller Shaft (part 21) — then securely retighten the nut. In each case position the lower roller so that the blade will simultaneously touch the lower roller and the companion upper roller ... but so that the blade will remain straight as it passes between the two rollers. If the rollers are too close they will bend the blade; if too far apart they will not support the blade.



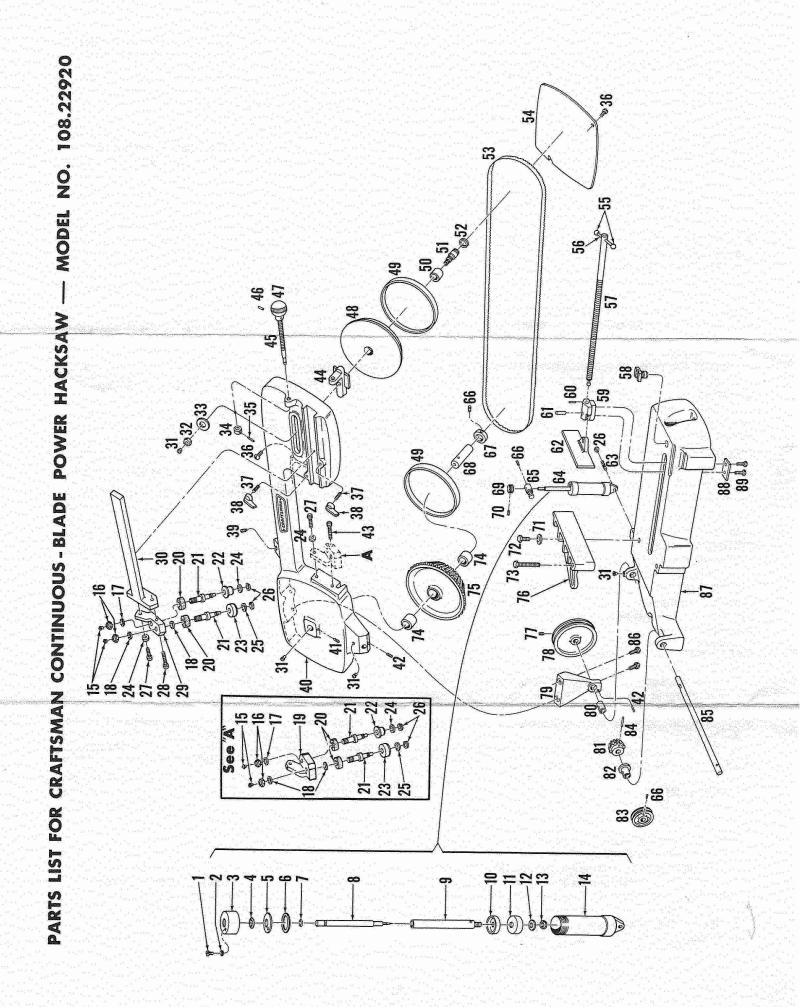
- GUIDE ROLLER ASSEMBLIES: If either guide assembly holds the blade so that it is not perpendicular to its cut, loosen the screw (part 27 page 5) that holds the bracket (part 19 or part 29), and tap the bracket to straighten the assembly. Retighten the screw securely.
- **D** BEVEL GEARS: Should play develop between the two bevel gears (parts 75 and 81 page 5), loosen the front set screw and tighten the rear set screw (part 42).

LUBRICATION

Lubricate regularly by putting 3 to 4 drops of SAE 30 oil into each of the eight oil holes. The holes have fitted covers (parts 15 and 31). Locations are:

One in the Tension Screw Nut (fig. 1). One at the top of the drive wheel shaft. One at each end of the pivot shaft.

Two at the top of each Guide Roller Assembly.



PARTS LIST FOR CRAFTSMAN

CONTINUOUS - BLADE POWER HACKSAW MODEL NO. 108.22920

PART NO. DESCRIPTION PART NO. DESCRIPTION NO.) P		
Page Scription No. Description Description No. Description Description No. Description	KEY		PART	KEY		PART	KEY		PART
*No. 10-24 x 1/4 Sight-Hid, Pan Screw 39. Guide Bracket Support GBF-547 59. Vise Silde Yase Silde Pan Screw Pan	NO.	DESCRIPTION	.oo	NO.	DESCRIPTION	NO.	Š Š	DESCRIPTION	NO.
Pead Cylinder Plage Gasket GBE-567 33 *1/2** Oll Role Cover (4 req.) 64**2103 65**2103 65**2104	-	*No. 10-24 x 1/4 Slot-Hd.		30	Guide Bracket Support	GBF-547	59	Vise Slide	GBF-541
Feed Cylinder Plug Casket GBF-567 22 **12-20 Truin Nut GBF-519 62 Savivel Jan 40 GBF-579 60 41.4 **12-20 Truin Nut GBF-510 64 Louis GBF-510 55 Savivel Jan 57-210 56-210 56-210 64 Feed Cylinder Assembly Feed Cylinder Seal Cover GBF-563 56 **10.2 **12-20 14.4 **12.8 **1		Pan Screw	53-2101	31	16" Oil Hole Cover (4	63-2101	09	Pin (1/8 x	56-2103
Peed Cylinder Bead GBF-510 3	7	Feed Cylinder Plug Gasket	GBF-567	32	*1/2-20 Thin Nut	54-2103	61	Roll Pin $(3/8 \times 1)$	56-2104
Peed Cyl. Hat. Casket Sac 2010 St. Tension Screw (Collar Peed Cylinder Assembly Feed Cyl. Hat. Casket Sac 2010 St. Tension Screw (2 req.) Screw (3 red.) Screw (က	Feed Cylinder Head	GBF-574	33	Idler Wheel Washer	GBF-519	62	Swivel Jaw	GBF-538
Freed Cyl. Hd. Caskert GBF-562 35 Roll Pin (1/8 x k)6) Freed Cyl. Hd. Caskert GBF-562 36 Roll Pin (1/8 x k)6) Freed Cyl. Hd. Caskert GBF-563 36 Foot (1/8 x k)6) Freed Cyl. Hd. Caskert GBF-563 37 Adv. Clamp Stud (2 req.) Freed Cyl. Hd. Caskert GBF-563 37 Adv. Clamp Stud (2 req.) Freed Cyl. Hd. Caskert GBF-563 37 Adv. Clamp Stud (2 req.) Freed Cyl. Hd. Caskert GBF-563 38 Advastment (2 req.) Freed Cyl. Hd. Caskert GBF-564 37 Adv. Clamp Stud (2 req.) Freed Cyl. Hd. Caskert GBF-564 37 Adv. Clamp Stud (2 req.) Freed Cyl. Hd. Caskert GBF-564 38 Advastment GBF-569 67 Assembly GBF-569 67 Asse	্বা	Quad-Ring (11/16x1/2)	57-2101	34	Tension Screw Collar	GBF-508	63	Feed Cyl. Connecting Stud	GBF-576
Freed Cyl. Hd. Gasket 36	വ	Feed Cylinder Seal Cover	GBF-562	35	Roll Pin $(1/8 \times 5/8)$	56-2101	64	Feed Cylinder Assembly	GBF-560
Peed Cyl. Valve Seat Assembly GBF-568 37 Adjustment Clamp (2 req.) GBF-568 38 Adjustment Clamp (2 req.) GBF-569 39 Adjustment Clamp (2 req.) GBF-569 40 Frank Seat Assembly GBF-569 40 Frank Seat Assembly GBF-669 40 Frank Seat Assembly GBF-669 40 Frank Seat Assembly GBF-670 40 Frank Seat Assembly GBF-570 40 Frank Seat Assembly 60 Frank Sear Assembly	တ	Feed Cyl. Hd. Gasket	GBF-575	36	*No. 10 x 24 x 1/2 Button-Hd.		65	Feed Cylinder Pivot	GBF-573
Page Cyl. Valve CBF-568 37	P	"0" Ring (3/8 x 1/4)	57-2102		Screw (2 req.)	53-2104	99	*1/4 x 1/4 Soc-Hd., Cone-Pt.	
Valve Seat Assembly GBF-563 38 Adjustment Clamp (2 req.) GBF-509 67 Drive Wheel Shaft CBF-78 69 Prame Cap Assembly CBF-501 41.4 x 5/8 soc-Hd., Set Screw (special) 63-2105 69 Freed Cylinder Knob 70 <td>œ</td> <td>Feed Cyl. Valve</td> <td>GBF-566</td> <td>37</td> <td>Adj. Clamp Stud (2 req.)</td> <td>GBF-511</td> <td></td> <td>Set Screw (3 req.)</td> <td>53-2108</td>	œ	Feed Cyl. Valve	GBF-566	37	Adj. Clamp Stud (2 req.)	GBF-511		Set Screw (3 req.)	53-2108
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Leather Cup	10	Feed Cyl. Seal Support	GBF-568	39	Soc-Hd. Set Screw (special)	53-2105	68	Drive Wheel Shaft	GBF-522
#7/8 x 5/64 Washer 59–2101 41 *1/4 x 5/8 Soc-Hd, Cone-Pt. 53–2115 70 Cone-Pt. Set Screw End Cap Assembly GBF-570 42 Soc-Hd, Cone-Pt. 53–2115 71 *7/8 x 3/8 x 1/16 Washer 54–2102 43 *1/4 x 1-3/4 Fil-Hd. Mach. 53–2116 71 *7/8 x 3/8 x 1/16 Washer 59–2104 45 Teach.) #8/8 x 24 Thin Nut (4 req.) 54–2102 43 *1/4 x 1-3/4 Fil-Hd. Mach. 53–2106 73 *3/8 x 1/16 Washer 59–2104 45 Teach.) #8/8 x 24 Thin Nut (4 req.) 54–2102 43 *1/4 x 1-3/4 Fil-Hd. Mach. 53–2106 73 *3/8 x 1/16 Washer 59–2104 45 Teach.) #8/8 x 24 Thin Nut (4 req.) 59–2104 45 Teach Screw Knob GBF-507 75 Drive Wheel Shaft Bushing Glafe Roller Dust Shield GBF-554 46 Teach Wheel Shaft Bushing Glafe Roller Dust Shield GBF-554 50 Idler Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft Bushing Glafe Roller - Loper (2 req.) GBF-555 51 Glafer Wheel Shaft (2 req.) GBF-555 51 Glafer Wheel Shaft Glafer Glafer Glafer Glafer Glafer Glafer Glafer Glafer Glafer Wheel Shaft Glafer Gla	I	Leather Cup	69-2101	40	Frame	GBF-501	69	Feed Cylinder Knob	GBF-569
#\$\text{fig x 18 Thin Nut} \te	12	*7/8 x 5/16 x 5/64 Washer	59-2101	41	4 x 5/8 Soc-Hd.,		70	*No. 10-24 x 5/16 Soc-Hd.,	
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3/16" Oil Hole Cover 63-2102 43 *1/4 x 1-3/4 Fil-Hd. Mach. 53-2114 72 *3/8 x 1 Soc-Hd. Cap Screw *3/8 x 24 Thin Nut (4 req.) 53-2102 42-2102 41 Idler Wheel Support 63-2104 73 *1/4 x 1/32 Washer 74 Dr. Wheel Shaft Bushing 74 Dr. Wheel Shaft Bushing 75 Serew 75 Serew 76 Serew 77 Serew 76 Serew 77 Serew 77 Serew 77 Serew 77 Serew 77 Serew 78 Serew 78 Serew 77 Serew 77 Serew 77 Serew 77 Serew 78	14	End Cap Assembly	GBF-570	42	Screw		11	*7/8 x 3/8 x 1/16 Washer	59-2105
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*5/8 x 3/8 x 1/16 Washer 44 Idler Wheel Support GBF-517 (2 req.) 75 Drive Wheel *5/8 x 1/32 Washer 59-2102 (4 req.) 45 Tension Screw (and e Pale) GBF-517 (2 req.) 77 *3/8 x 5/16 Soc-Hd., Cone-Pt. (36-2102) *5/8 x 1/32 Washer 59-2102 (4 req.) 47 Tension Screw (and e Poller Shaft (4 req.) GBF-539 (2 req.) 77 *3/8 x 5/16 Soc-Hd., Cone-Pt. (36-2102) Saw Guide Boller Dust Shield (a Peq.) GBF-554 (3 req.) 48 Friction Band (2 req.) GBF-514 (3 req.) 77 *3/8 x 5/16 Soc-Hd., Cone-Pt. (36-2102) Guide Roller Dust Shield (a Peq.) GBF-554 (3 req.) GBF-554 (3 req.) GBF-554 (3 req.) GBF-554 (3 req.) GBF-514 (3 req.) 77 *3/8 x 5/16 Soc-Hd., Cone-Pt. (36-2102) 81 *3/8 x 1/1/8 80 *3/8 x 1/1/8	16	*3/8 x 24 Thin Nut (4 req.)	54-2102		Screw	53-2106	74	Dr. Wheel Shaft Bushing	
(2 req.) 59-2104 45 Tension Screw GBF-507 75 Drive Wheel *5/8 x 3/8 x 1/32 Washer 59-2104 46 Roll Pin (1/8 x 3/4) 56-2102 76 77 82 x 5/16 Soc-Hd., Cone-Pt. Saw Guide Bracket — Left GBF-549 48 Idler Wheel GBF-513 78 8 x 5/16 Soc-Hd., Cone-Pt. Saw Guide Roller Dust Shield GBF-554 48 Idler Wheel Shaft GBF-554 78 Drive Pulley Guide Roller Dust Shield GBF-554 50 77 82 x 5/16 Soc-Hd., Cone-Pt. Set Screw Guide Roller Dust Shaft (4 req.) GBF-554 50 78 78 Drive Pulley Guide Roller - Upper (2 req.) GBF-554 51 Idler Wheel Shaft GBF-518 79 Pivot Shaft Bashing Guide Roller - Lower (2 req.) GBF-552 52 174 x 1/3 x 60-In. Saw Blade (.020 172 x 1/4 x 1/2 x 60-In. Saw Blade (.020 174 x 1/2 x 60-In. Saw Blade (.020 174 x 1/2 x 1/4 x 1/3 x 1/4 x 1/3 x 60-In. Saw Blade (.020 174 x 1/4	11	*5/8 x 3/8 x 1/16 Washer		44	Idler Wheel Support	GBF-517		(2 req.)	GBF-525
*5/8 x 3/8 x 1/32 Washer 46 Roll Pin (1/8 x 3/4) 56-2102 77 Vise Jaw 4 req.) Saw Guide Bracket — Left GBF-549 48 Idler Wheel Shaft Bushing GBF-524 77 *3/8 x 5/16 Soc-Hd., Cone-Pt. Saw Guide Roller Dust Shield GBF-554 GBF-554 GBF-564 GBF-674 79 Drive Pulley Guide Roller Dust Shield GBF-554 GBF-554 GBF-675 GBF-672 GBF-676 GBF-676 GBF-676 GBF-676 GBF-676 <td></td> <td>(2 req.)</td> <td>59-2104</td> <td>45</td> <td>Tension Screw</td> <td>GBF-507</td> <td>5</td> <td>Drive Wheel</td> <td>GBF-521</td>		(2 req.)	59-2104	45	Tension Screw	GBF-507	5	Drive Wheel	GBF-521
(4 req.) 59-2102 47 Tension Screw Knob GBF-506 77 *3/8 x 5/16 Soc-Hd., Cone-Pt. Saw Guide Bracket - Left GBF-513 Respective Relations of GBF-513 Tension Screw Knob GBF-513 Respective Responsible of GBF-514 79 Pivot Shaft Bracket GBF-514 70 70 70	18			46	Roll Pin $(1/8 \times 3/4)$	56-2102	92	Vise Jaw	
Saw Guide Bracket — Left GBF-549 48 Idler Wheel GBF-513 Set Screw Guide Roller Dust Shield GBF-554 50 Idler Wheel Shaft Bushing GBF-514 79 Prive Pulley Guide Roller Shield GBF-551 51 Idler Wheel Shaft Bushing GBF-518 79 Prive Shaft Bushing Guide Roller – Upper (2 req.) GBF-552 52 Truarc Retaining Ring 67-2102 81 Bevel Gear Guide Roller – Lower (2 req.) GBF-552 53 +1/2 x 60-In. Saw Blade (.020 82 Pivot Shaft Flanged Bushing *1/2 x 1/4 x 1/16 Washer 59-2106 Thick; 10 Teeth per in.) 91-2101 84 Roll Pin (1/8 x 1-1/8) *1/2 x 60-In. Saw Blade (.020 Thick; 14 Teeth per in.) 91-2102 85 Pivot Shaft *1/2 x 61 59-2103 Trick; 14 Teeth per in.) 91-2102 86 *1/4 x 1/2 Soc-Hd. Cap *1/2 x 60-In. Saw Blade (.020 Truarc Retaining Ring 67-2104 86 *1/4 x 1/2 Soc-Hd. Cap *1/2 x 6q.) 59-2103 Trick; Skip-Tooth) GBF-581 88 Vise Screw Handle Soll		(4 req.)	59-2102	47	Tension Screw Knob	GBF-506	77	*3/8 x 5/16 Soc-Hd., Cone-Pt.	te em Te em
Guide Roller Dust Shield 49 Saw Friction Band (2 req.) GBF-524 (4 req.) 78 Drive Pulley (4 req.) GBF-554 (3 req.) GBF-555 (3 req.) GBF-554 (3 req.) GBF-555 (3 req.) GBF-555 (3 req.) GBF-555 (3 req.) GBF-553 (3 req.) Truarc Retaining Ring (3 req.) GBF-518 (3 req.) Bevel Gear (3 req.)	13	Saw Guide Bracket - Left	GBF-549	48	Idler Wheel	GBF-513		Set Screw	53-2109
(4 req.) GBF-554 50 Idler Wheel Shaft Bushing GBF-514 79 Pivot Shaft Bracket Guide Roller Shaft (4 req.) GBF-551 51 Idler Wheel Shaft GBF-518 80 Pivot Shaft Bushing Guide Roller - Upper (2 req.) GBF-553 52 Truarc Retaining Ring 67-2102 81 Bevel Gear Guide Roller - Upper (2 req.) GBF-553 53-2103 Truarc Retaining Ring 7	20	Guide Roller Dust Shield		49	Saw Friction Band (2 req.)	GBF524	78	Drive Pulley	GBF-505
Guide Roller Shaft (4 req.) GBF-551 51 Idler Wheel Shaft GBF-518 80 Pivot Shaft Bushing Guide Roller – Upper (2 req.) GBF-553 52 Truarc Retaining Ring 67-2102 81 Bevel Gear Guide Roller – Lower (2 req.) GBF-553 53 +1/2 x 60-In. Saw Blade (.020 91-2101 82 Pivot Shaft Flanged Bushing *1/2 x 1/4 x 1/32 Washer 59-2106 Thick; 10 Teeth per in.) 91-2102 84 Roll Pin (1/8 x 1-1/8) *1/2 x 1/4 x 1/16 Washer 59-2103 Thick; 14 Teeth per in.) 91-2102 85 Pivot Shaft Flanged Bushing *1/2 x 1/4 x 1/16 Washer 59-2103 Thick; 14 Teeth per in.) 91-2102 86 *1/4 x 1/2 Soc-Hd. Cap Truarc Retaining Ring 67-2104 54 Cover Plate Cover Plate 86 *1/4 x 1/4 x 1/2 Soc-Hd. Cap.) *1/4 x 1-3/8 Fill-Hd. Mach. 53-2102 56 Vise Screw Handle 6BF-581 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fill-Hd. Mach. 53-2103 57 Vise Screw GBF-542 Chot illustrated) Screw <		(4 reg.)	GBF-554	20	Idler Wheel Shaft Bushing	GBF-514	79	Pivot Shaft Bracket	GBF-529
Guide Roller — Upper (2 req.) GBF-553 52 Truarc Retaining Ring 67-2102 81 Bevel Gear Guide Roller — Lower (2 req.) GBF-552 53 +1/2 x 60-In. Saw Blade (.020 91-2101 82 Pivot Shaft Flanged Bushing *1/2 x 1/4 x 1/3 washer 59-2106 Thick; 10 Teeth per in.) 91-2101 84 Roll Pin (1/8 x 1-1/8) *1/2 x 1/4 x 1/16 washer 59-2103 Thick; 14 Teeth per in.) 91-2102 85 Pivot Shaft *1/2 x 1/4 x 1/16 washer 59-2103 Thick; 14 Teeth per in.) 91-2102 86 *1/4 x 1/2 Soc-Hd. Cap *1/2 x 1/4 x 1/16 washer 59-2103 Thick; 14 Teeth per in.) 91-2102 86 *1/4 x 1/2 Soc-Hd. Cap Truarc Retaining Ring Forear, Blade (.020 91-2103 Screw (2 req.) Screw (2 req.) Screw (2 req.) *1/4 x 5/8 Fill-Hd. Mach. 55 Vise Screw Handle Ball GBF-1204 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fill-Hd. Mach. 53-2103 57 Vise Screw Handle GBF-1204 Screw (2 req.) *1/4 x 1-3/8 Fill-Hd. Wach. 53-2103 Vise Screw (2 req.)	21	Guide Roller Shaft (4 req.)	GBF-551	21	Idler Wheel Shaft	GBF-518	8	Pivot Shaft Bushing	GBF-528
Guide Roller — Lower (2 req.) GBF-552 53 +1/2 x 60-In. Saw Blade (.020 4 req.) 82 Pivot Shaft Flanged Bushing Rung (4 req.) *1/2 x 1/4 x 1/32 Washer (4 req.) 59-2106 Thick; 10 Teeth per in.) 91-2101 83 Motor Pulley Roll Pin (1/8 x 1-1/8) *1/2 x 1/4 x 1/16 Washer (2 req.) 59-2106 Thick; 14 Teeth per in.) 91-2102 85 Pivot Shaft Flanged Bushing Roll Roll Pin (1/8 x 1-1/8) *1/2 x 1/4 x 1/16 Washer (2 req.) 59-2103 Thick; 14 Teeth per in.) 91-2102 86 *1/4 x 1/2 Soc-Hd. Cap Screw (2 req.) *1/2 x 1/4 x 5/8 Fil-Hd. Mach. Screw (2 req.) 57-2104 57-2104 57-2104 58-2102 86 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. Screw (2 req.) 53-2102 56 Vise Screw Handle Ball GBF-542 GBF-129A GBF-542 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. Screw (2 req.) 53-2103 57 Vise Screw (2 req.) GBF-542 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. Screw (2 req.) 53-2103 57 Vise Screw (2 req.) GBF-542 *1/4 x 5/8 Cap Screw (2 req.)	22	Guide Roller - Upper (2 req.)	GBF-553	52		67-2102	81	Bevel Gear	GBF-512
*1/2 x 1/4 x 1/32 Washer 59-2106	23	Guide Roller - Lower (2 req.)	GBF-552	53			82	Pivot Shaft Flanged Bushing	GBF-527
(4 req.) 59-2106 1/2 x 60-In. Saw Blade (.020) 84 Roll Pin (1/8 x 1-1/8) *1/2 x 1/4 x 1/16 Washer 59-2103 Thick; 14 Teeth per in.) 91-2102 85 Pivot Shaft (2 req.) 1/2 x 60-In. Saw Blade (.020) 86 *1/4 x 1/2 Soc-Hd. Cap Truarc Retaining Ring 67-2104 54 Cover Plate 91-2103 Screw (2 req.) *1/4 x 5/8 Fil-Hd. Mach. 53-2102 55 Vise Screw Handle Ball GBF-581 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. 53-2102 56 Vise Screw Handle GBF-129A 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. 53-2103 57 Vise Screw Handle GBF-129A 90 Parts List and Instructions (not illustrated) Screw 53-2103 57 Vise Screw Cover Nut GBF-543 (not illustrated)	24	$*1/2 \times 1/4 \times 1/32$ Washer			Thick; 10 Teeth per in.)	91-2101	83		GBF-583
*1/2 x 1/4 x 1/16 Washer		(4 reg.)	59-2106		1/2 x 60-In. Saw Blade (.020		84		56-2105
(2 req.) 59-2103 1/2 x 60-In. Saw Blade (.020) 86 *1/4 x 1/2 Soc-Hd. Cap Truarc Retaining Ring 67-2104 54 Cover Plate Cover Plate GBF-581 87 Base *1/4 x 5/8 Fil-Hd. Mach. 53-2102 55 Vise Screw Handle Ball GBF-130A 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. 53-2103 57 Vise Screw Handle GBF-129A 90 Parts List and Instructions (GBF-542) Screw 53-2103 57 Vise Screw Nut GBF-543 (not illustrated) Saw Guide Bracket — Right GBF-543 (abf-543)	25	$*1/2 \times 1/4 \times 1/16$ Washer				91-2102	85		GBF-526
Truarc Retaining Ring G7-2104 Thick; Skip-Tooth) 91-2103 Screw (2 req.) (5 req.) 67-2104 54 Cover Plate GOver Plate GBF-581 87 Base *1/4 x 5/8 Fil-Hd. Mach. 53-2102 (2 req.) 89 Vise Screw Handle Ball GBF-130A 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. 56 Vise Screw Handle GBF-129A 90 Parts List and Instructions (GBF-542) Screw 53-2103 57 Vise Screw Nut GBF-542 (not illustrated) Saw Guide Bracket — Right GBF-543 (not illustrated)		(2 req.)	59-2103				98		
(5 req.) 67-2104 54 Cover Plate GBF-581 87 Base *1/4 x 5/8 Fil-Hd. Mach. 53-2102 55 Vise Screw Handle Ball GBF-130A 88 Vise Slide Plate *1/4 x 1-3/8 Fil-Hd. Mach. 53-2103 56 Vise Screw Handle GBF-129A 90 Parts List and Instructions Screw 53-2103 57 Vise Screw Nut GBF-542 (not illustrated) Saw Guide Bracket — Right GBF-548 58 Vise Screw Nut GBF-543	26	Truarc Retaining Ring			Inick; Skip-Tooth)	91-2103		Screw (2 req.)	53-2113
*1/4 x 5/8 Fil-Hd. Mach. 53-2102 55 Vise Screw Handle Ball 88 Vise Slide Plate 88 Vise Slide Plate 88 Vise Screw (2 req.) 53-2102 56 Vise Screw Handle 6BF-129A 90 Parts List and Instructions 57 Vise Screw 57 Vise Screw 58 Vise Screw			67-2104	4. 4.	Cover Plate	GBF-581	<u>~</u>	Base	GBF-502
Screw (2 req.) 53-2102 (2 req.) (2 req.) GBF-130A 89 *1/4 x 5/8 Cap Screw (2 req.) *1/4 x 1-3/8 Fil-Hd. Mach. 56 Vise Screw Handle GBF-129A 90 Parts List and Instructions Screw 53-2103 57 Vise Screw GBF-542 (not illustrated) Saw Guide Bracket — Right GBF-548 58 Vise Screw Nut GBF-543	27		stand	22	Vise Screw Handle Ball		alas s	Vise Slide Plate	1000
*1/4 x 1-3/8 Fil-Hd. Mach. 53-2103 57 Vise Screw Handle GBF-129A 90 Parts List and Instructions Screw Screw GBF-542 (not illustrated) Saw Guide Bracket — Right GBF-548 58 Vise Screw Nut GBF-543		Shift is	53-2102		(2 req.)	GBF-130A		*1/4 x 5/8 Cap Screw (2 req.)	
Screw 53–2103 57 Vise Screw GBF-542 (not illustrated) Saw Guide Bracket — Right GBF-548 58 Vise Screw Nut GBF-543	28	•		26	Vise Screw Handle	GBF-129A	liniuma	Parts List and Instructions	
Saw Guide Bracket — Right GBF-548 58 Vise Screw Nut		Screw	53-2103	21	Vise Screw	GBF-542	in the same	(not illustrated)	CV-100
	29	Saw Guide Bracket - Right	GBF-548	28	Vise Screw Nut	GBF-543	SUSSE CONTRACTOR OF THE PARTY O		

^{*} Standard hardware items - may be procured locally.