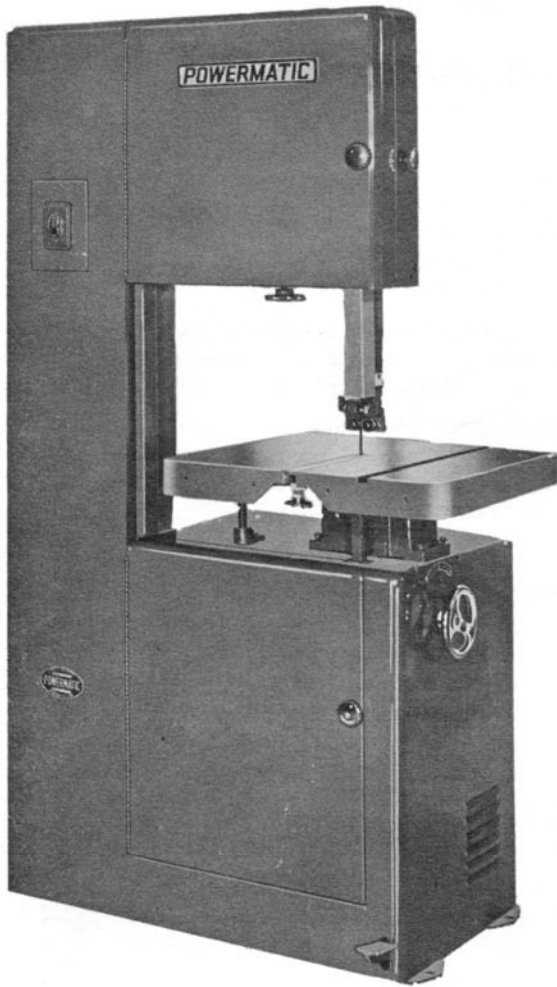


Model 81 Band Saw

ALL MACHINES PERFORMANCE-TESTED BEFORE SHIPMENT

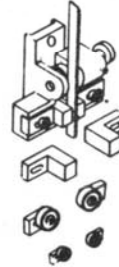
accuracy in every operation

Powermatic precision means *exacting* engineering and design to assure hair-line accuracy in every band saw job you do. Powermatic dependability means that you'll get years of rugged service on the production line or in the simplest fabrication. Built of thoroughly reinforced heavy-gauge steel plate, the Powermatic Model 81 has all moving parts enclosed to insure safety.



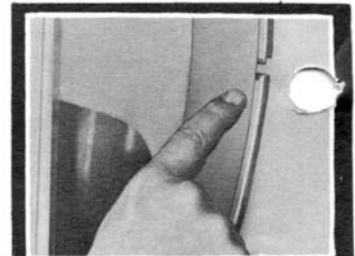
Standard Equipped
With ball bearing side guides
for 3/16" to 1/2" blade only.

Optional:
8100-29 hardened block
guide for 1/2" to 1" blade.
8100-30 hardened block
guide for 1/8" to 1/2" blade.

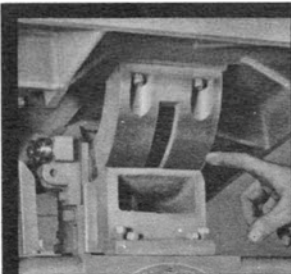


T.E.F.C. Motor Standard

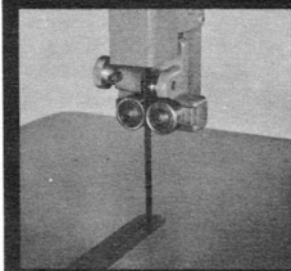
"Vulcanized" tire
eliminates frequent
change and loose
fitting tires.



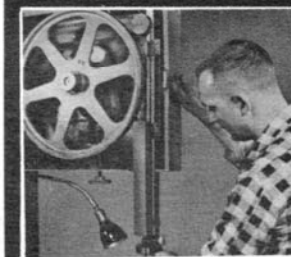
Heavy-Duty 6" Single-Action Trunnion affords maximum rigidity. Fast, sure table adjustment 45° right, 15° left, positive 90° stop.



Friction-Free Ball Bearing Guides top and bottom increase blade life, adjust to fit any type of blade.



Counter-Balanced Blade Arm means maximum safety for operator, stock and machine during fast change-overs.



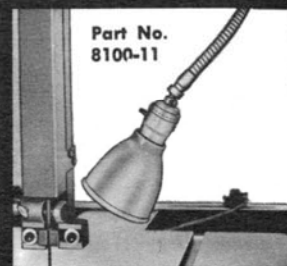
Part No. 8100-17

Miter Gauge
Precision cast aluminum miter gauge complete with stock rods for hairline accuracy.

Table Insert Quickly Removed for fast blade change. Note wide flange on precision-machined table for extreme rigidity.

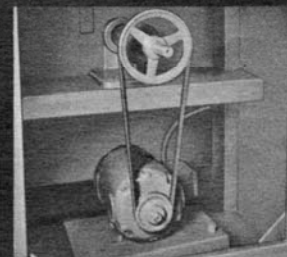


Part No. 8100-11



Lamp
Flexible work-lamp. Ideal for spotlighting working surface.

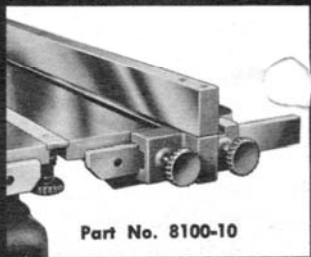
Fully Enclosed Motor and Drive assures longer motor life. Top and bottom wheels easily accessible through front doors.



Part No. 8100-35

Circle Cutter
For radius cuts in plastics, woods, and hardboards.

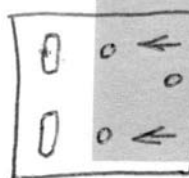
Simplified Rip Fence Mounting on machined and drilled front edge of table.



Part No. 8100-10

3P K182T 2 Groove 3V
6.5 - 3.35 - 3V425

56 frame
3 Pulley
~~4 L 4 30~~
4 L 4 30



Model 81 Band Saw

FEATURES

FRAME: Constructed of reinforced steel plate for maximum rigidity. All parts cast iron or steel, nothing die cast.

TABLE: 3" x 24" x 24"; made of finest grey iron castings, machine ground to precision tolerance. Mounted on heavy-duty trunnion to tilt 45° right, 15° left. Front edge machined and drilled for mounting rip fence.

WHEELS: Made of finest machine castings, dynamically balanced and fitted with easy-change rubber tires. Upper and lower wheels run in lubricated-for-life ball bearings.

DRIVE: Available either belted or direct. Belt driven model is powered by 1725 RPM motor mounted on adjustable motor base. Direct drive model has lower wheel mounted directly on motor shaft.

BRAKE: Standard with manually operated foot brake. Powermatic's exclusive brake interlock with switch (optional) with magnetic controls.

SAW BLADE ADJUSTMENT: Conveniently located hand-wheel for blade tension adjustment. Spring mechanism absorbs shock and maintains uniform tension on the blade.

SAW GUIDES: Top and bottom saw guides are ball bearing to assure minimum friction and increased blade life.

GUIDE ARM: Rugged, counter-balanced guide arm allows effortless adjustment of saw guides—yet maintains unsurpassed rigidity.

STANDARD EQUIPMENT

BAND SAW LESS MOTOR: Blade and wheel guards, 3/8" blade, set of wrenches, foot brake, dust chute, blade tension control, ball bearing blade guides, counterbalanced guide arm, motor mount bracket and driven pulley—Less motor, motor pulley, belt, switch and wiring.

BAND SAW WITH MOTOR: Blade and wheel guards, 3/8" blade, set of wrenches, foot brake, dust chute, blade tension control, ball bearing blade guides, counter-balanced guide arm, motor mount bracket and driven pulley, motor, motor pulley, belt, switch and wiring.

STANDARD MACHINES

- 8100-01—20" Band Saw, standard equipped with 3/8" blade, wrenches, less motor, switch and motor pulleys.
- 8100-02—Same as 8100-01, but with 1-HP, 3-phase motor, switch #3-25, 3/8" blade, ready to run.
- 8100-03—Same as 8100-02, except with 1-HP, 1-phase motor and switch, #1-21.
- 8100-04—Same as 8100-02, except with 1 1/2-HP, 3-phase motor and switch, #3-25.

- 8100-05—Same as 8100-02, except with 1 1/2-HP, 1-phase motor and switch, #1-21.
- 8100-06—Same as 8100-02, except with 2-HP, 3-phase motor and switch, #3-25.
- 8100-07—Same as 8100-02, except with 2-HP, 1-phase motor and switch, #1-21.
- 8100-08—20" Band Saw DIRECT DRIVE, standard equipped with 1-HP, 3-phase motor, 3/8" blade, switch #3-25, ready to run.

SPECIAL LISTINGS

- 8100-26—20" Band Saw, complete with 3/8" blade, 1-HP, 1-phase motor, manual switch with overload protection, cord and plug.
- 8100-27—20" Band Saw, complete with 3/8" blade, 1-HP,

3-phase motor, manual switch with overload protection.

- 8100-28—20" Band Saw, complete with 3/8" blade, 1-HP, 1- OR 3-phase motor, magnetic controls.

OPTIONAL ACCESSORIES

- 8100-10—Rip Fence, Wt. 22 lbs.
- 8100-11—Flexible Work Lamp, wt. 10 oz.
- 8100-12—1/4" wide Band Saw Blade, wt. 8 oz.
- 8100-13—3/8" wide Band Saw Blade, wt. 8 oz.
- 8100-14—1/2" wide Band Saw Blade, wt. 8 oz.
- 8100-15—3/4" wide Band Saw Blade, wt. 8 oz.
- 8100-16—1" wide Band Saw Blade, wt. 8 oz.
- 8100-17—Miter Gauge, 3 1/2 lbs.
- 8100-18—3-phase O/L Switch #3-27, wt. 1 lb.

- 8100-19—1-phase O/L Switch #1-23, wt. 3/4 lb.
- 8100-20—3" diameter motor pulley (order only when machine is purchased without motor).
- 8100-21—Magnetic 3 Ph. Switch #3-30 & 1-3-32, wt. 6 lbs.
- 8100-22—Magnetic 1 Ph. Switch #1-29 & 1-3-32, wt. 6 lbs.
- 8100-23—Foot brake interlock with switch to provide power shut-off (available if saw is equipped with magnetic starter).
- 8100-24—3-wire 8' cord, with attachment plug.

- 8100-25—4-wire 8' cord, with attachment plug.
- 8100-29—Hardened block guide for 1/2" to 1" blade, wt. 8 oz.
- 8100-30—Hardened block guide for 1/8" to 1/2" blade, wt. 8 oz.
- 8100-31—JIC Electricals for 1 or 3-phase, wt. 20 lbs.
- 8100-32—Belt for 1-HP motor—4L-390, wt. 8 oz.
- 8100-33—Belt for 1 1/2-HP motor—4L-380, wt. 8 oz.
- 8100-34—Belt for 2-HP motor—4L-360, wt. 8 oz.
- 8100-35—Circle cutting attachment, wt. 3 lbs.

SPECIFICATIONS

- Table Size.....3" x 24" x 24"
- Table in front of blade.....11 1/2"
- Table tilt.....15° left—45° right
- Wheel size.....1 1/4" x 20"
- Blade to column.....19 1/2"
- Maximum depth of cut under guide.....12 1/2"
- Maximum width blade recommended.....1"

- Maximum adjustment of blade.....2 1/2"
- Maximum length of blade.....12'7"
- Minimum length of blade.....12'5"
- Recommended wheel speed
900 RPM or 4500 SFM
- Motor power recommended,
(V-belt drive)...1 to 2-HP, 1725 RPM
- Overall height.....76"
- Table height from floor.....41 1/2"

- Weight, net.....770 lbs.
- Weight, domestic crated, less motor.....860 lbs.
- Weight, domestic crated, with motor.....895 lbs.
- Weight, export boxed, less motor (94.4 cu. ft.)...1050 lbs.
- Weight, export boxed, with motor (94.4 cu. ft.)...1090 lbs.

OPERATING INSTRUCTIONS AND PARTS LIST

Model 81 20" Band Saw

For Serial Numbers From 1000 Up

POWERMATIC INC.

McMinnville, Tennessee

I. MACHINE DESCRIPTION & SPECIFICATIONS

FRAME:	Heavy, re-inforced steel plate, braced to give maximum rigidity.																								
TABLE:	3" x 24" x 24"; made of finest grey iron castings, machine ground to precision tolerance. Mounted on heavy duty trunion to tilt 45° to right, 15° to left. Front edge machined and drilled for rip-fence.																								
WHEELS:	Made of finest machine castings, dynamically balanced and fitted with easy-change rubber tires. Upper and lower wheels run in lubricated for life ball bearings.																								
GUARDS:	All moving parts are completely enclosed. Only the operating part of the blade is exposed.																								
DRIVE:	Available either belted or direct. Belt driven model is powered by 1800 RPM motor mounted on adjustable motor base. Direct drive model has lower wheel, mounted directly on motor shaft.																								
SAW BLADE ADJUSTMENT:	The blade tension is adjusted with conveniently located handwheel for blade tension adjustment. Spring mechanism absorbs shock and maintains uniform tension on the blade.																								
SAW GUIDES:	Top and bottom saw guides are ball bearing to assure minimum friction and increased blade life.																								
BRAKE:	The lower wheel is equipped with a foot brake conveniently located to the operator.																								
SPECIFICATIONS:	<table> <tr> <td>Table size</td> <td>3" x 24" x 24"</td> </tr> <tr> <td>Blade-to-column distance</td> <td>19$\frac{1}{2}$"</td> </tr> <tr> <td>Maximum depth of cut under guide</td> <td>12$\frac{1}{2}$"</td> </tr> <tr> <td>Wheel size</td> <td>20" x 1$\frac{1}{4}$"</td> </tr> <tr> <td>Table height (from floor)</td> <td>41$\frac{1}{2}$"</td> </tr> <tr> <td>Table tilt, right</td> <td>45°</td> </tr> <tr> <td>Table tilt, left</td> <td>15°</td> </tr> <tr> <td>Blade width (Usable maximum 1"; minimum $\frac{1}{16}$")</td> <td>$\frac{3}{8}$"</td> </tr> <tr> <td>Blade length</td> <td>12' 7"</td> </tr> <tr> <td>Blade speed, SFM</td> <td>4500</td> </tr> <tr> <td>Overall height</td> <td>76"</td> </tr> <tr> <td>Floor space required</td> <td>39" x 27"</td> </tr> </table>	Table size	3" x 24" x 24"	Blade-to-column distance	19 $\frac{1}{2}$ "	Maximum depth of cut under guide	12 $\frac{1}{2}$ "	Wheel size	20" x 1 $\frac{1}{4}$ "	Table height (from floor)	41 $\frac{1}{2}$ "	Table tilt, right	45°	Table tilt, left	15°	Blade width (Usable maximum 1"; minimum $\frac{1}{16}$ ")	$\frac{3}{8}$ "	Blade length	12' 7"	Blade speed, SFM	4500	Overall height	76"	Floor space required	39" x 27"
Table size	3" x 24" x 24"																								
Blade-to-column distance	19 $\frac{1}{2}$ "																								
Maximum depth of cut under guide	12 $\frac{1}{2}$ "																								
Wheel size	20" x 1 $\frac{1}{4}$ "																								
Table height (from floor)	41 $\frac{1}{2}$ "																								
Table tilt, right	45°																								
Table tilt, left	15°																								
Blade width (Usable maximum 1"; minimum $\frac{1}{16}$ ")	$\frac{3}{8}$ "																								
Blade length	12' 7"																								
Blade speed, SFM	4500																								
Overall height	76"																								
Floor space required	39" x 27"																								

II. GENERAL SET-UP AND ALIGNMENT

1. RECEIVING

Uncrate and check for shipping damage. Clean all coated and greased surfaces. Read instructions thoroughly. Locate all lubrication points; adjustments; methods of drive.

2. MOUNTING

Mount machine securely to solid foundation. Concrete base mounting preferred. Locate in clean, dry and well ventilated building if possible. Motor and electrical connections should be protected when not in operation or if exposed to weather elements.

3. INSPECTION

The above machine requires the minimum amount of attention in service. Periodic or regular inspections are recommended to insure machine is in proper adjustment, positive electrical connections; worn or loose "V" belts and bearings heating or loose.

4. BEFORE OPERATING

Check motor nameplate data or wiring diagram of motor and switch for proper voltage connection before wiring into line. Run motor without load to check the connections and direction of rotation. Always refer to motor nameplate for rotation connections.

OPERATING INSTRUCTIONS

The Powermatic Model 81 - 20" Band Saw is constructed of steel plate, braced to give maximum rigidity. Streamlined in appearance, all moving parts are completely guarded for safe operation. The top and bottom band wheels are easily accessible through large hinged doors on the front of the saw. Lower wheel is equipped with a foot brake that is convenient to the operator. Sealed dust chute keeps motor and drive free from cuttings and dust.

MOTOR AND WIRING: Electric wiring is connected to motor wiring in conduit box mounted on the side of the column. Motor should be inspected and checked for rotation before operating machine. Operate lower unit and check rotation before installing blade.

POWER DRIVE: The saw is driven with a motor mounted in the base of the machine. A 1 HP motor is sufficient for light and medium work and a 1½ or 2 HP for heavy work and resawing. On the belt driven machine, the motor is mounted on an adjustable hinge base. Two A section belts drive the lower band wheel. The direct drive model features the motor mounted direct to the lower band wheel, turning 900 RPM.

INSTALLING BLADE: To install band saw blade, remove table insert (1) fig. 1 from table; open top and bottom doors. Take the blade in both hands and slide through table slot and over band wheels. With the blade placed in the center of the band wheels, increase tension on upper wheel with tension screw (2) fig. 2, located under upper wheel. Set upper and lower saw guides so they will clear the saw blade. Turn band wheels by hand to see that saw blade tracks properly. For accurate work and maximum blade life it is important that the blade runs centered on the wheels. When the adjustment has been properly made, the blade will track; that is, it will run steadily in the same line.

BLADE GUIDE ADJUSTMENT: For proper operation, the saw blade must be supported by an upper and lower saw guide. The lower guide is mounted under the table and the upper guide on a counter-balanced bar (3) fig. 2 above the table. The purpose of the saw guide is to support the blade for cutting circles (See 2 & 3, fig. 1). It is very important that the guides be set in proper relation to the saw blade. To set the guides to saw blade, set tension on blade and start the saw to check tracking on band wheel. Set the side blocks or bearings (4) fig. 1 as close to the saw as possible without causing friction or binding. Guide blocks are held in place with socket head set screws (5) fig. 1. After blade clearance is set, the guide holder should be set so that edge of the guides are just behind saw teeth gullets. The back guide consists of a ball bearing mounted in an adjustable bar. The bearing is set 1/64" from the back edge of saw blade when blade is running not loaded. The back guide should be set at a slight angle to back of blade so that the edge of the blade will not cut a groove in back bearing guide. Back bearing is adjusted by turning knurled knob (6) fig. 1.

BLADE TENSION: Correct blade tension is very important for efficient operation. The wider and thicker blades require more tension than narrow blades. A tension indicator, graduated for different blade widths (1) fig. 2, is located inside the frame, behind upper wheel. Tension is regulated by a screw building pressure on tension spring. This spring is designed to give correct tension for standard gauge blades only. Tension may vary on heavier and/or thicker blades. Blade tension does not vary with different length blades.

WHEEL ALIGNMENT: Band wheels are properly aligned at the factory and should operate correctly. However, in shipping, the original adjustments may have moved necessitating realignment. The lower wheel housing is mounted on jack screws, two in the rear and two in the front. The shaft may be leveled by loosening the two bearing locking bolts and adjusting with the two jack screws. Bearing bolts should be retightened after shaft is leveled.

TABLE ADJUSTMENTS: The table is mounted on an extremely heavy duty single action trunion that rests on trunion base (9) fig. 1. The table may be tilted to the right 45 degrees and to the left 15 degrees. Table is locked in position with trunion handwheel mounted on side of machine base (7) fig. 1. To level table with blade, raise counter-balanced arm to highest position and place machinist square against side of blade. Set table stop (8) fig. 1 on side of table by adjusting screw on top of the stop. Stop bar may be removed for tilting table to the left.

LUBRICATION: The bearings on top and bottom shaft are sealed for life requiring no lubrication. The slides and adjusting screws should be lubricated at regular intervals to insure proper operation.

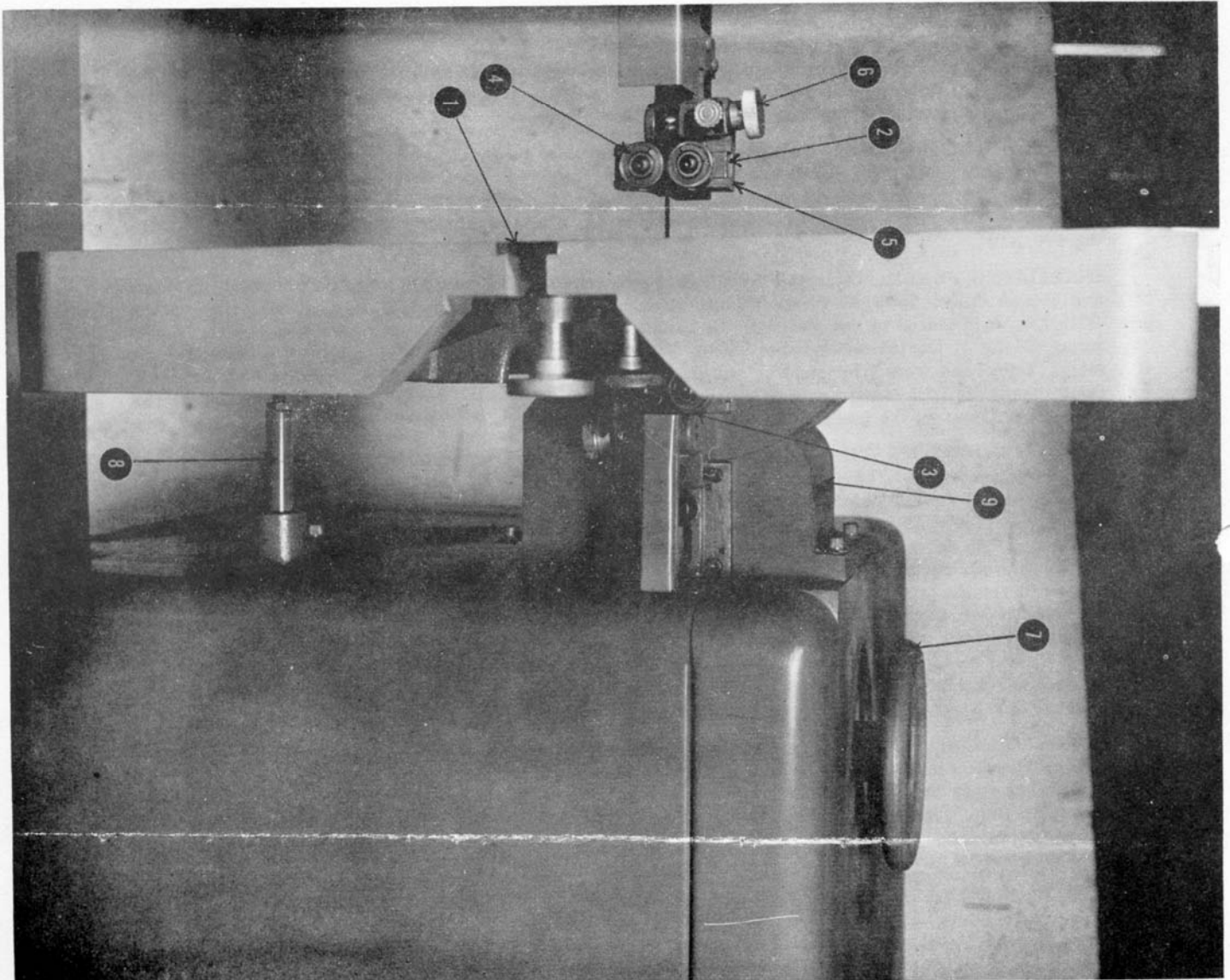


Fig. 1

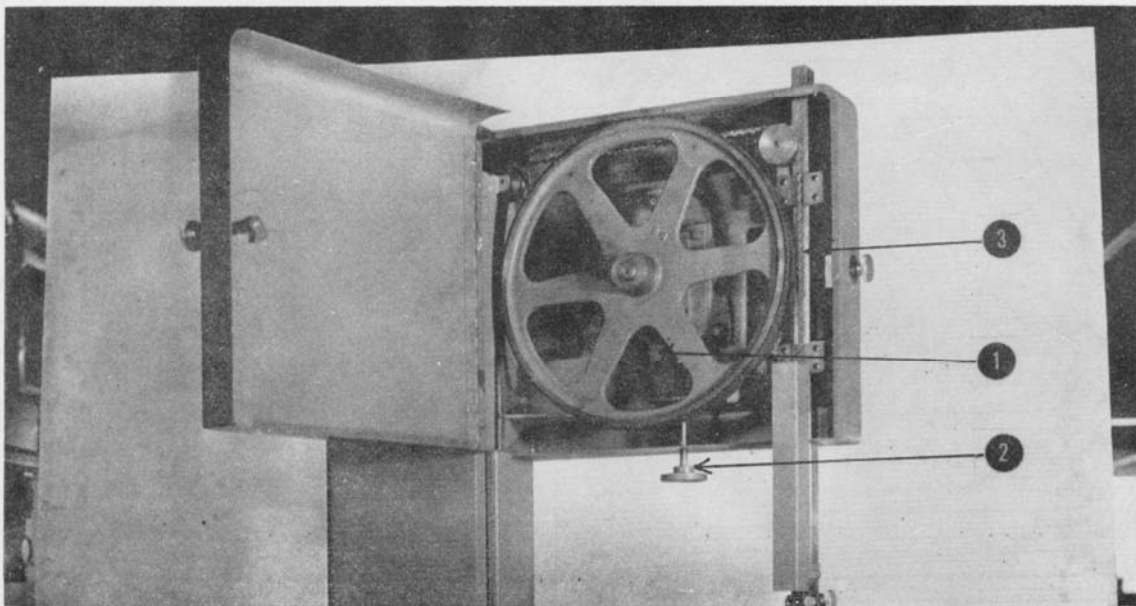
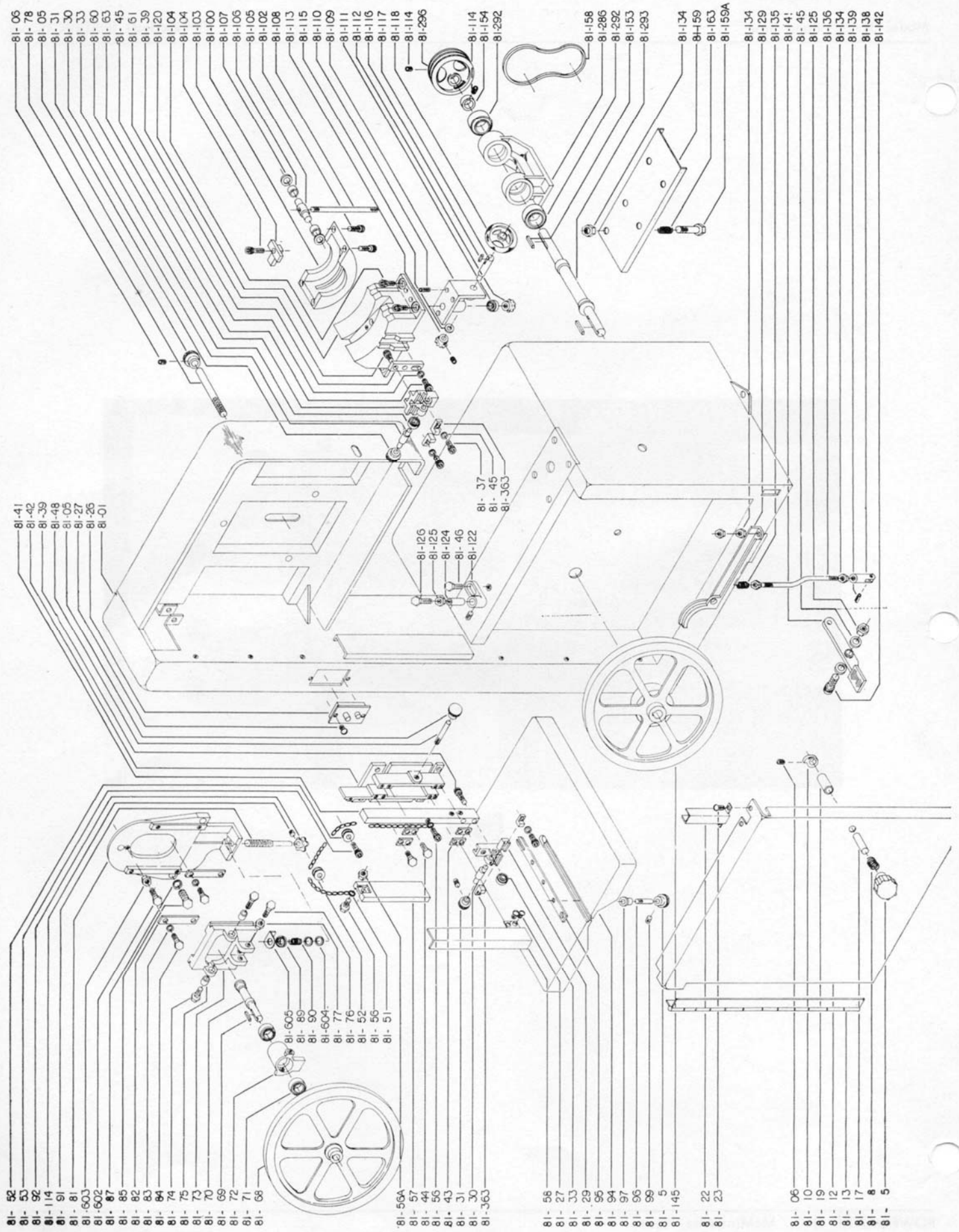


Fig. 2



MODEL 81 20" WOOD BAND SAW

STANDARD MACHINE (MANUFACTURED PARTS)

Part Nr.	Nomenclature	Qty Req'd
81-1	Body, Band Saw	1
81-2	Door, Upper	1
81-3	Hinge, Upper & Lower Door	2
81-7	Shaft, Upper Door Locking	1
81-9	Spacer, Upper Door Latch	1
81-10	Latch, Door B-12	2
81-12	Door, Lower	1
81-17	Shaft, Lower Door Locking Int. w/87-817 & 90-190A	1
81-20	Saw Guard, Lower Door	1
81-24	Door, Motor Drive	1
81-29	Guide Casting, Upper 48L	1
81-30	Shaft, Back Saw Guide Bearing	2
81-34	Plate, Saw Guide Bearing Mounting	4
81-41	Guide Bar	1
81-42	Holder, Guide Bar B-35	1
81-43	Plate, Guide Bar Holder	4
81-48	Screw, Guide Bar Locking	1
81-52	Balance Wheel	2
81-57	Bar, Balance B-84	1
81-58	Guard Bar	1
81-60	Guide Casting, Lower 48R	1
81-61	Bar, Lower Guide Mounting	1
81-68	Wheel, Upper Band Saw B-3	1
81-69	Key, Upper Wheel Shaft $\frac{1}{4} \times \frac{1}{4} \times 2"$	1
81-70	Shaft, Upper Wheel	1
81-72	Bearing Housing, Upper Shaft B-8	1
81-73	Bracket, Upper Bearing Housing B-7	1
81-78	Screw, Upper Wheel Aligning	1
81-81	Mounting Bracket, Upper Bearing Slide B-6	1
81-82	Slide Shim, Upper Bearing Housing Bracket	2
81-91	Screw, Tension Adjusting	1
81-94	Table, Band Saw B-2-A	1
81-95	Insert, Saw Table	1
81-96	Screw, Insert Locking	2
81-100	Trunion, Table Tilting MB-2	1
81-103	Guide, Table Tilting Trunion	1
81-105	Holder, Trunion Lock Roller	1
81-106	Roller, Trunion Lock	2
81-108	Lock Screw, Trunion	1
81-109	Bracket, Trunion Lock Screw & Gear B-36	1
81-112	Bevel Gear, Trunion Lock Screw	1
81-113	Bevel Gear, Trunion Lock Screw Shaft	1
81-116	Key, Trunion Lock Bevel Gear $3/16 \times 3/16 \times 1"$	1
81-117	Shaft, Trunion Lock Screw	1
81-118	Handwheel, Trunion Lock Screw Shaft 12-0	1
81-119A	Pointer	1
81-120	Bracket, Table Tilting Trunion MB-3	1
81-122	Bracket, Table Stop 12-13	1
81-124	Pin, Table Stop Bracket	1
81-129	Shoe, Brake B-15	1
81-133	Plate, Pivot Screw	1
81-136	Brake Rod	1
81-141	Pedal, Brake B-14	1
81-145	Wheel, Lower Band Saw B-3	1
81-148	Key, Lower Band Saw Wheel $\frac{1}{4} \times \frac{1}{4} \times 2"$	1
81-149	Shaft, Lower Drive	1
81-150	Bearing Housing, Lower Drive Shaft B-50	1
81-153	Key, Lower Shaft Drive Sheave $3/16 \times 3/16 \times 1\frac{1}{2}$	1
81-154	Collar Lower Shaft	1
81-159	Base, Motor	1
81-160	Rod, Motor Base	1

MODEL 81 20" WOOD BAND SAW

STANDARD MACHINE (PURCHASED PARTS)

Part Nr.	Nomenclature	Qty	Req'd
81-4	Bolt 5/16—18 x 5/8 Hex. Head	1	6
81-4A	Washer 5/16 I.D. Flat Washer	1	10
81-5	Knob, 3/8 Bore 1000—8 x 3/8	1	7
81-5A	Knob, 1/2 Bore 1000—8 x 1/2	1	1
81-6	Setscrew 1/4 x 20 x 1/4	1	12
81-8	Spring, Door Locking Shaft AS18325	1	2
81-19	Spacer, Lower Door Shaft 700-65A 3/8 x 1/2 lg.	1	1
81-23	Screw, Saw Guard 10—24 x 3/8 Socket Head	1	2
81-26	Switch Box & Cover	1	1
81-27	Screw, 1/4—20 x 3/8 Socket Round Head	1	2
81-31	Knob, Saw Guide Bearing Shaft 1-10	1	2
81-33	Bearing, Back Saw Guide 37PP3 FAFNIR	1	2
81-35	Bearing, Saw Guide 200PP FAFNIR	1	4
81-37	Screw 5/16—18 x 3/8 Hex. Hd.	1	4
81-38	Screw, 3/8—24 x 1 Socket Round Hd.	1	4
81-31A	Screw, 3/8—24 x 3/8 Socket Round Hd.	1	4
81-39	Screw, 5/16—18 x 1 1/2 Socket Hd.	1	6
81-39A	Screw, 5/16—18 x 3/4 Socket Hd.	1	2
81-40	Screw, Back Saw Guide Bear. Shaft Locking 1/4—20 x 1/2 Wing Screw	1	2
81-44	Screw, Guide Bar Holder Plate 1/4—20 x 5/8 Hex. Hd. (Lock)	1	8
81-45	Washer 3/8 Flat	1	13
81-46	Screw 3/8—16 x 1 1/2 Socket Hd.	1	5
81-47	Pin 1/4 x 1 1/4 Split Pin	1	2
81-49	Setscrew 3/8—16 x 3/4 Setscrew	1	8
81-51	Chain, Guide & Balance Bar #40 Sash Chain	1	1
81-53	Screw, Balance Wheel 5/16—18 x 1 3/4 Hex. Hd.	1	2
81-56	Screw 1/4—20 x 3/4 Socket Hd.	1	1
81-56A	Screw 6—32 x 3/4 Fillister Hd.	1	1
81-56B	Nut 6—32 Hex.	1	1
81-63A	Lock Washer 3/8 I.D.	1	9
81-71	Bearing, Upper & Lower Wheel Shaft 206 FAFNIR	1	4
81-74	Pivot Screw, Upper Bearing Housing 3/8—16 x 3/8 Socket Hd.	1	6
81-75	Bushing, Pivot Screw 3/8 x 5/8 x 1/2 Lg. 700-65A	1	2
81-76	Guide Screw 3/8—16 x 1 1/2 Square Head	1	3
81-77	Nut 3/8 Hex.	1	4
81-80	Setscrew, Bandsaw Wheel 3/8—16 x 3/8	1	2
81-84	Bolt 3/8—16 x 3/4 Hex. Hd.	1	4
81-85	Bolt 3/8—16 x 2 Hex. Hd.	1	3
81-89	Bearing, Tension Adjusting Screw NICE 603 1/4	1	1
81-90	Spring, Tension Adj. Screw 16136	1	1
81-97	Spacer, Insert Locking Screw 86-87-97	1	2
81-107	Washer 1/2 Flat Washer	1	5
81-110	Screw 5/16—18 x 3/4 Hex Hd.	1	7
81-111	Thrust Bearing, Trunion Lock Screw NICE 605	1	1
81-114	Setscrew 5/16—18 x 5/16	1	4
81-115	Washer 5/8 Flat Washer	1	1
81-104	Bolt 5/16—18 x 1 1/2 Socket Hd.	1	4
81-104A	Bolt 3/8—16 x 1" Socket Hd.	1	5
81-119	Dial, Trunion Tilting	1	1
81-119B	Screw, #4 x 3/16 Drive Screw	1	3
81-130	Lining, Brake Shoe 1/4 x 1" Lining	1	1
81-131	Bolt, Brake Shoe Pivot 1/2—13 x 2 1/2 Hex Hd.	1	1
81-134	Nut 1/2 Hex	1	5
81-135	Spring, Brake Rod LP75	1	1
81-137	Nut, Yoke 1/2—20 Hex	1	1
81-138	Yoke, Brake Shoe Rod #6 Yoke	1	1
81-139	Pin, Yoke Pur. w/Yoke	1	1
81-140	Cotter Key, Yoke Pin Pur. w/Yoke	1	1
81-142	Pivot Bolt, Brake Pedal 3/8—16 x 1 3/4 Socket Head	1	1
81-147	See 81-71		
81-156	Sheave, Lower Shaft Drive 1 H. P. AK64 1 1/2 H.P. or Over D2650	1	1
81-158	Belt, Drive 1 H.P. 4L430 1 1/2 H.P. 4L420	1	1
81-150B	Setscrew 5/16—18 x 3/8	1	4
81-161	Cotter Key, Motor Base Rod 1/8 x 1"	1	2
81-162	Bolt, Motor Base 3/8—16 x 3" Carriage Bolt	1	1
81-163	Spring, Motor Base Bolt 12103	1	1
81-162A	Nut, 3/8—16 Square	1	1

PARTS LIST ON MODEL 81--20" BAND SAW

FRAME ASSEMBLY AND PARTS

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO.</u>	<u>PRICE</u>
81-1	Body assembly, Band Saw	1	
81-2	Door, Upper	1	
81-3	Hinge, Upper door	1	
81-4	Bolt, Upper door hinge--1/4"--20 x 3/4		
	Stove bolt	3	.10 Ea.
81-5	Knob, Upper door locking	1	.50
81-6	Set screw, Upper door knob	1	.10
81-7	Shaft, Upper door locking	1	.20
81-8	Spring, Upper door locking shaft	1	.10
81-9	Spacer, Upper door latch	1	.10
81-10	Latch, Upper door	1	.20
81-6	Set screw, Upper door latch--1/4"--20 x 1/4"	1	.10
81-12	Door, Lower	1	6.00
81-13	Hinge, Lower door	1	2.00
81-4	Bolt, Lower door hinge- 1/4"--20 x 3/4"		
	Stove bolt	3	.10 Ea.
81-5	Knob, Lower door locking	1	.50
81-6	Set screw, Lower door knob-1/4"--20 x 1/4"	1	.10
81-17	Shaft, Lower door locking	1	.20
81-8	Spring, Lower door locking shaft	1	.10
81-19	Spacer, Lower door latch	1	.10
81-10	Latch, Lower door	1	.20
81-6	Set screw, Lower door latch-1/4"--20 x 1/4"	1	.10
81-22	Saw guard, Lower door	1	.90
81-23	Screw, Lower door saw guard - 10-24 x 1/2		
	St. Bolt Nut	2	.10 Ea.
81-24	Door, Motor drive	1	3.00
81-25	Screw, Motor drive door - 1/4"--20 x 1" -		
	Button Head	4	.10 Ea.
81-26	Switch box and cover	1	.75
81-27	Screw, Switch box and cover - 1/4" -20 x 1 1/2"		
	Button head	2	.10 Ea.

GUIDE ASSEMBLY

81-29	Guide casting, Upper	1	4.50
81-30	Shaft, Back saw guide bearing	2	2.50 Ea.
81-31	Knob, Saw guide bearing shaft	2	.40 Ea.
81-6	Set screw, Saw guide bearing shaft knob -		
	1/4" - 20 x 1/4"	2	.10 Ea.
81-33	Bearing, Back saw guide	2	1.50 Ea.
81-34	Plate, Saw guide bearing mounting	4	.50 Ea.
81-35	Bearing, Saw guide	4	1.50 Ea.
81-37	Screw, Saw guide bearing - 3/8"-24 x 7/8"-		
	Button Head	4	.20 Ea.
81-38	Screw, Saw guide bearing mounting plate-		
	5/16"-24 x 7/8"	4	.20 Ea.
81-39	Screw, Upper guide mounting - 5/16"-18 x 1"		
	Socket Head	2	.25 Ea.

GUIDE ASSEMBLY, Cont'd)

PART NO.	DESCRIPTION	NO.	PRICE
81-40	Screw, Back saw guide bearing shaft locking--1/4"--20 x 1/2"	2	.10 Each
81-41	Guide bar	1	6.50
81-42	Guide bar holder	1	7.50
81-43	Plate, Guide bar holder	4	.25 Each
81-44	Screw, Guide bar holder plate--1/4"--20 x 3/4"--Hex Head	8	.10 Each
81-45	Washer, Guide bar holder mounting--3/8" Flat Washer	4	.10 Each
81-46	Screw, Guide bar holder mounting--3/8"--16 x 1 1/4"--Hex Head	4	.25 Each
81-47	Pin, Guide bar holder mounting--3/16"--1 Split Pin	1	.10
81-48	Screw, Guide bar locking	1	.75
81-49	Bolt, Guide bar holder adjusting--3/8"--16 x 3/4"--Set Screw	4	.15 Each
81-5	Knob, Guide bar locking screw	1	.60
81-6	Set screw, Guide bar locking screw knob--1/4"--20 x 1 1/4"	1	.10
81-51	Chain, Guide and balance bar	1	.60
81-52	Balance wheel	2	.50 Each
81-53	Screw, Balance wheel--5/16"--18 x 2" Hex Head	2	.25 Each
81-56	Screw, Chain mounting--1/4"--20 x 3/4"--Socket Head	2	.20 Each
81-57	Bar, Balance	1	3.00
81-58	Guard, Bar	1	1.50
81-27	Screw, Bar guard mounting--3/4"--20 x 1/2"--Button head	2	.10 Each
81-60	Guide casting, Lower	1	4.50
81-61	Bar, Lower guide mounting	1	2.00
81-45	Washer, Lower guide bar mounting--3/8" Flat washer	1	.10
81-63	Screw, Lower guide bar mounting--3/8"--16 x 1"--Socket Head	1	.30
81-39	Screw, Lower guide mounting--5/16"--18 x 1"--Socket Head	2	.25 Each
81-65	Guides, Lower guide bar	2	2.00 Each
81-56	Screw, Lower guide bar guide--1/4"--20 x 3/4"--Socket head	4	.20 Each
81-47	Pin, Lower guide bar guide--3/16" x 1" split pin	4	.10 Each

UPPER DRIVE ASSEMBLY

81-68	Wheel, Upper band saw	1	16.00
81-69	Key, Upper wheel shaft	1	.25
81-70	Shaft, Upper wheel	1	6.50
81-71	Bearing, Upper wheel shaft	2	3.25 Each
81-72	Bearing housing, Upper shaft	1	7.50

UPPER DRIVE ASSEMBLY, Cont'd

PART NO.	DESCRIPTION	NO.	PRICE
81-73	Bracket, Upper Bearing housing	1	4.50
81-74	Pivot screw, Upper bearing housing	2	.40 Each
81-75	Bushing, Pivot screw	2	.30 Each
81-76	Guide screw, Upper bearing housing	2	.30 Each
81-77	Nut, Upper bearing housing guide screw	2	.10 Each
81-78	Screw, Upper wheel aligning	1	.30
81-5	Knob, Upper wheel aligning screw	1	.50
81-80	Set screw, Upper band saw wheel	1	.10
81-6	Set screw, Upper wheel aligning screw knob--1/4"--20 x 1/4"	1	.10
81-81	Mounting bracket, Upper bearing slide	1	12.50
81-82	Slide shim, Upper bearing housing bracket	2	.50 Each
81-83	Washer, Slide shim	2	.10 Each
81-84	Bolt, slide shim mounting	4	.15 Each
81-85	Bolt, Upper bearing slide mounting bracket	3	.15 Each
81-86	Rubber washer, Mounting bolt	3	.10 Each
81-87	Bushing, Mounting bolt	3	.10 Each
81-88	Nut, Mounting bolt	3	.10 Each
81-89	Bearing, Tension adjusting screw	1	1.50
81-90	Spring, Tension adjusting screw	1	.50
81-91	Screw, Tension adjusting	1	2.00
81-92	Knob, Tension adjusting screw	1	.50
81-114	Set screw, Tension adjusting screw knob--5/16"--18 x 5/16"	1	.10

TABLE AND TILTING ASSEMBLY

81-94	Table, Band saw	1	90.00
81-95	Insert, Saw table	1	2.00
81-96	Screw, Table insert locking	2	.25 Each
81-97	Spacer, Table insert locking screw	2	.25 Each
81-5	Knob, Table insert locking screw	2	.50 Each
81-99	Pin, Table insert locking screw knob --3/16" x 3/4" Split pin	2	.10 Each
81-100	Trunion, Table tilting	1	8.50
81-102	Bolt, Table tilting trunion mounting --3/8"--16 x 3/4"	4	.20 Each
81-103	Guide, Table-tilting trunion	1)
81-104	Screw, Table tilting trunion guide --5/16" x 1 1/2"--Hex head	2)
81-105A	Trunion lock assembly	1	----- 3.50) Set
81-105	Holder, Trunion lock roller	1)
81-106	Roller, Trunion lock	2)
81-107	Washer, Trunion lock roller holder --1/2" Flat washer	2)
81-108	Lock Screw, Trunion	1)
81-109	Bracket, Trunion lock-screw and gear	1	3.00
81-110	Screw, Trunion lock screw and gear bracket--5/16"--18 x 3/4"	3	.10 Each

TABLE AND TILTING ASSEMBLY, Cont'd.

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO.</u>	<u>PRICE</u>	
81-111	Thrust bearing, Trunion lock-screw	1	1.60	
81-112	Bevel gear, Trunion lock-screw	1	4.00	
81-113	Bevel gear, Trunion lock-screw shaft	1	4.00	
81-114	Set screw, Trunion lock bevel gear - 5/16" - 18 x 5/16"	1	.10	
81-115	Washer, Trunion lock bevel gear	1	.10	
81-116	Key, Trunion lock bevel gear - 3/16" x 3/16" x 1"	1	.10	
81-117	Shaft, Trunion lock-screw	1	1.00	
81-118	Handwheel, Trunion lock-screw shaft	1	.75	
81-114	Set screw, Trunion lock-screw shaft handwheel	1	.10	
81-120	Bracket, Table-tilting trunion	1	12.50	
81-104	Bolt, Table tilting trunion - 5/16" x 1 1/2" Hex hd.	4	.25	Ea.
81-122	Bracket, Table stop	1	.60	
81-6	Set screw, Table stop bracket - 1/4"-20 x 1/4"	1	.10	
81-124	Pin, Table stop bracket	1	.25	
81-125	Lock nut, Table stop screw	1	.15	
81-126	Screw, Table stop-Square head set, 3/8" x 1 1/2"	1	.25	
81-45	Washer, Table stop bracket - 3/8" Flat Washer	1	.10	
81-46	Bolt, Table stop bracket - 3/8" - 16 x 1 1/4" Hex head	1	.20	
81-49	Set screws (LEVEL) - 3/8"-16 x 3/4"	4	.15	Ea.
81-101	Washer, Table tilting trunion mounting	4	.10	Ea.
81-119	Dial, Table tilting trunion mounting	1	.50	

LOWER WHEEL BRAKE ASSEMBLY

81-129	Shoe, Brake	1	3.00	
81-130	Lining, Brake Shoe	1	.75	
81-131	Pivot screw, Brake shoe - 1/2"-13 x 2 1/2" Hex head	1	.25	
81-132	Washer, Brake shoe pivot screw	2	.10	Ea.
81-133	Plate, Brake shoe pivot screw	1	.10	
81-134	Nut, Brake shoe rod - 1/2" Nut	4	.20	Ea.
81-135	Spring, Brake rod	1	.20	
81-136	Brake rod	1	1.25	
81-134	Nut, Turn bucket, 1/2" Nut	1	.25	
81-138	Turn buckle, Brake shoe rod	1	1.00	
81-139	Pin, Turn buckle	1	.25	
81-140	Cotter Key, Turn buckle pin	2	.05	Ea.
81-141	Pedal, Brake	1	3.50	
81-142	Pivot bolt, Brake pedal	1	.25	
81-45	Washer, Brake pedal pivot bolt - 3/8" Flat Washer	2	.10	E
81-125	Nut, Pivot bolt - 3/8" Nut	1	.20	

LOWER DRIVE ASSEMBLY

PART NO.	DESCRIPTION	NO.	PRICE
81-145	Wheel, Lower band saw	1	15.00
81-49	Set screw, Lower band saw--3/8"--16 x 3/4"	1	.15
81-147	Bearing, Lower shaft	2	3.50 Each
81-69	Key, Lower drive shaft--1/4" x 1/4" x 1 7/16"	1	.20
81-149	Shaft, Lower drive	1	5.50
81-150	Bearing housing, Lower drive shaft	1	8.50
81-110	Bolt, Lower drive shaft bearing housing --5/16"--18 x 3/4"	4	.20 Each
81-152	Washer, Lower drive shaft bearing housing --5/16" Flat washer	4	.10 Each
81-153	Key, Lower shaft drive sheave--3/16" x 3/16" x 1 1/2"	1	.10
81-154	Set collar, Lower shaft	1	.60
81-114	Set screw, Lower shaft set collar--5/16" --18 x 5/16"	1	.10
81-156	Sheave, Lower shaft drive	1	7.50
81-114	Set screw, Lower shaft drive sheave --5/16"--18 x 5/16"	1	.25
81-158	Belt, Drive	1	1.75

MOTOR BASE ASSEMBLY

81-159	Base, Motor	1	2.00
81-160	Rod, motor base	1	.25
81-161	Cotter, key, motor base rod	2	.20 Each
81-162	Bolt, Motor base	1	.20
81-163	Spring, Motor base bolt	1	.25
81-134	Nut, Motor base bolt--1/2" Nut	1	.15