

15.0 Troubleshooting



WARNING

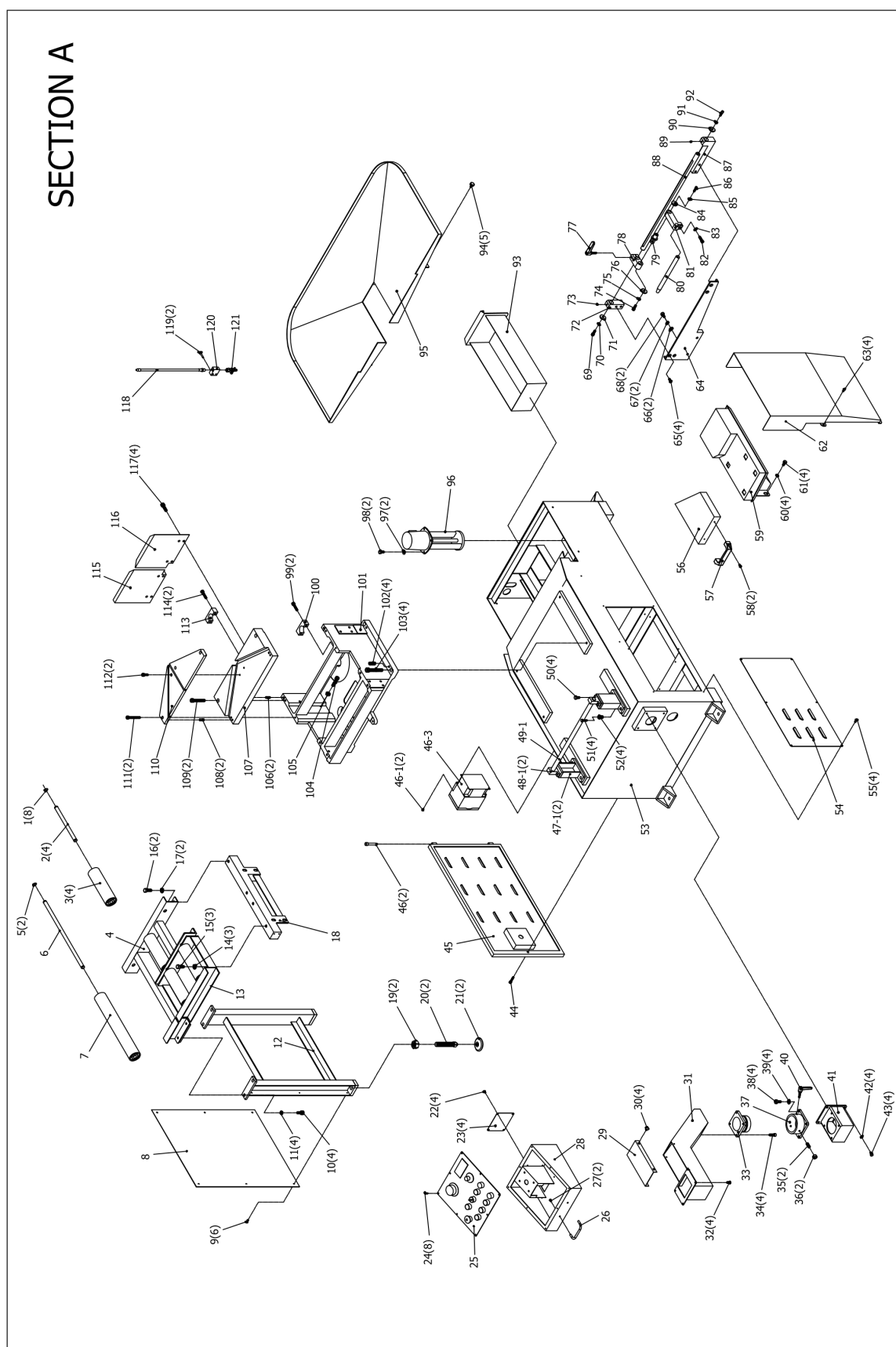
Make sure the electrical disconnect is OFF before working on the machine.

Table 15-1

Problem	Probable Cause	Remedy
Cut is not square vertically.	Carbide guide adjustment incorrect.	Adjust the carbide guide.
	Feed rate excessive.	Reduce the feed rate.
	Blade worn.	Replace blade.
	Guide arms too far apart.	Adjust guide arms.
	Blade pitch incorrect.	Change blade.
Cut is not square horizontally.	Angle is not set correctly.	Adjust angle again.
	Material is not square in vise.	Reset material.
	Angle pointer is out of adjustment.	Readjust it.
	Material is not secure in the vise.	Reset vise.
Head cylinder creeps: A) in hold B) in feed position	Cylinder cup seal defective. 3 position valve defective Hydraulic hose leaking	Replace cup seal Replace Change it Loosen jam nut and read just Pointer with feed rate at zero
Blade tracking incorrect	Improper tension. Tracking needs adjustment.	Adjust it.
	Wheel is worn or in poor condition.	Replace it.
Blade stalls in cut	More tension needed. Excessive feed rate.	Reduce feed rate.
	Blade pitch incorrectly.	Change blade.
Blade vibrating excessively	Blade speed too fast. More blade tension needed.	Slow blade speed.
	Guide arms too far apart.	Adjust it.
	Feed rate too slowly.	Increase feed rate.
	Carbide guides worn or loose.	Adjust or replace it.
Excessive blade breakage.	Excessive blade tension.	Reduce blade tension.
	Excessive feed rate.	Reduce feed rate.
	Top guides damaged.	Replace top guide.
No coolant flow.	No coolant.	Add the coolant.
	Check coolant ports for blockage Line blockage.	Blow out lines with compressed air.
	Coolant pump inoperable.	Replace it.
Blade will not start.	Lift head off limit switch.	Adjust it.
	Control fuse blown. Push reset button.	Replace fuse.
Machine stops before cut is complete.		Adjust saw bow down limit switch bolt or runs on after cut is completed.

16.0 Replacement Parts

16.1.1 Dual Miter Semi-Automatic Band Saw Assembly – Exploded View A



16.1.2 Dual Miter Semi Automatic Band Saw Assembly – Parts List A

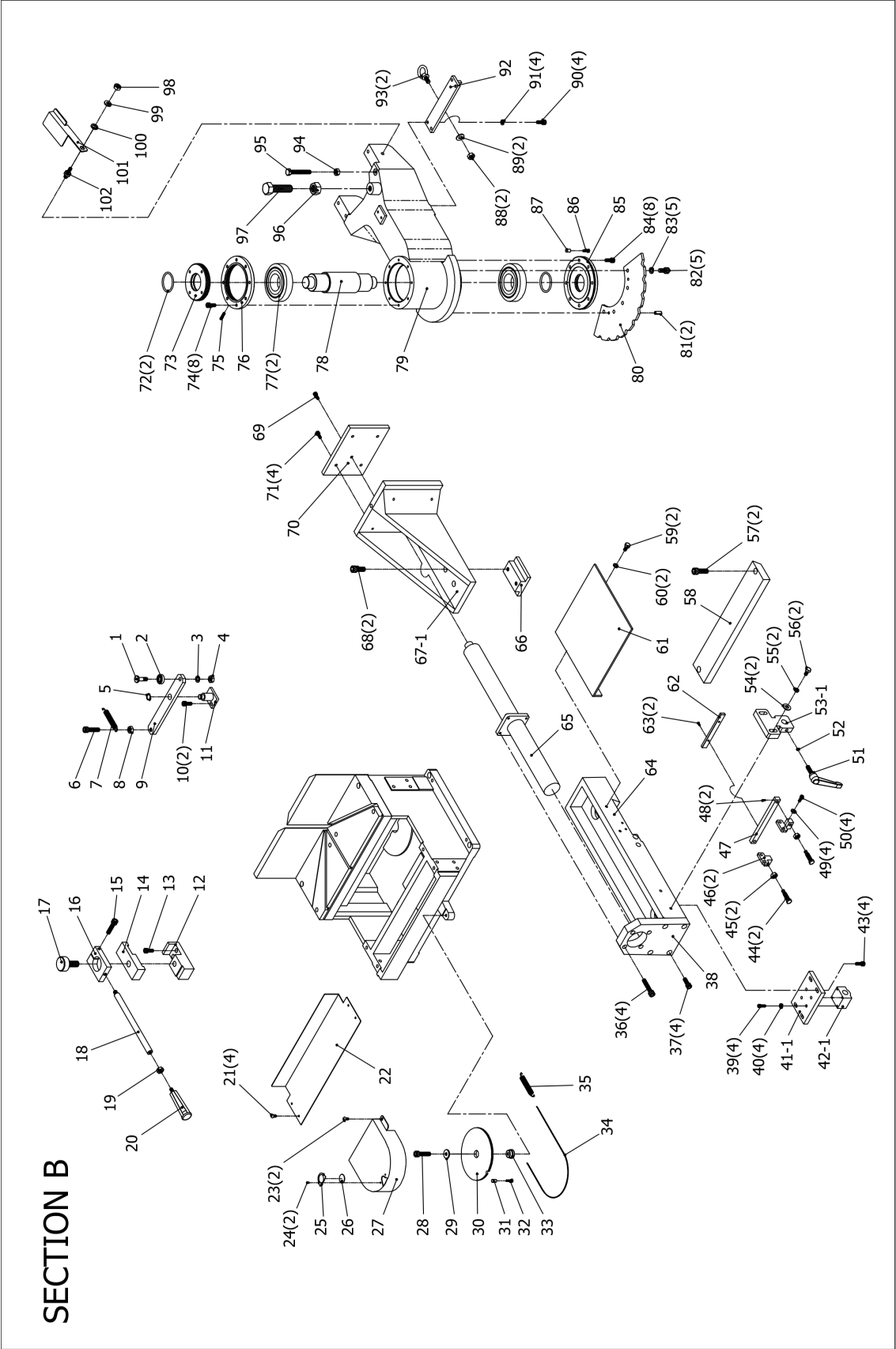
Index No.	Part No.	Description	Size	Qty.
1	JT9-F006045	C Ring	S17	8
2	BA1-6451	Short Roller Shaft	S20A2-04-A	4
3	BA1-6452	Short Roller	S20A2-04	4
4	BA1-6453	Roller Stand	S20A3-17	1
5	JT9-F006045	C Ring	S17	2
6	BA1-6454	Long Roller Shaft	S20A2-04-B	1
7	BA1-6455	Roller	S1380207-1	1
8	BA1-6456	Roller Stand Cover	S20A3-17-D	1
9	JT9-F009884	Button Head Socket Screw	M5x8L	6
10	JT9-TS-1506021	Socket Head Cap Screw	M12x25L	4
11	JT9-TS-2361121	Spring Washer	M12	4
12	BA1-6457	Stand	S20A3-17-C	1
13	BA1-6458	Roller Adjusting Plate	S20A3-17-B	1
14	JT9-TS-2361121	Spring Washer	M12	3
15	JT9-TS-1492011	Head Cap Screw	M12x25L	3
16	JT9-TS-1492011	Head Cap Screw	M12x25L	2
17	JT9-TS-2361121	Spring Washer	M12	2
18	BA1-6459	Position Bracket	S20A3-17-A	1
19	BA1-6460	Nut	M22	1
20	BA1-6461	Bolt	L25A2-31	2
21	**	Cushion		2
22	JT9-F009884	Button Head Socket Screw	M5x8L	4
23	BA1-6462	Control Panel Rear Cover	S20A3-06-A	1
24	JT9-F009884	Button Head Socket Screw	M5x8L	8
25	BA9-1232280	Control Panel	NPB-017	1
26	BA1-6463	Handle	A-42-C	1
27	JT9-TS-2246082	Button Head Socket Screw	M6x8L	2
28	BA1-6464	Control Panel Box	S20A3-06	1
29	BA1-6465	Control Box Bracket	S20A3-07-C	1
30	JT9-TS-2246082	Button Head Socket Screw	M6x8L	4
31	BA1-6466	Bracket Cover	S20A3-07-B	1
32	BA1-6467	Machine Screw	M5x8L	4
33	BA1-6468	Bracket Swiveling Shaft	331D1-18	1
34	CM9-TS-1503041	Socket Head Cap Screw	M6x16L	4
35	JT9-TS-1524051	Set Screw	M8x20L	2
36	JT9-TS-1540061	Nut	M8	2
37	BA1-6469	Shaft Bush	331D1-18-A	1
38	JT9-TS-1490021	Head Cap Screw	M8x16L	4
39	CM9-TS-2361081	Spring Washer	M8	4
40	BA1-6470	Handle	M8x35L	1
41	BA1-6471	Position Bracket	331D3-37	1
42	CM9-TS-2361081	Spring Washer	M8	4
43	JT9-TS-1490021	Head Cap Screw	M8x16L	4
44	JT9-TS-1504051	Socket Head Cap Screw	M8x25L	1
45	BA1-6472	Electrical Cabinet Cover	S20A3-01-D	1
46	**	Dowel Pin		2
46-1	JT9-TS-2244102	Button Head Socket Screw	M4x8L	2
46-3	BA1-6473	Inverter 3HP (220V)	L25A4-66	1
47-1	BA1-6474	Shaft Bracket	S20A3-18-A	2
48-1	BA1-6475	Shaft Position Bracket	SH-25A	2
49-1	BA1-6476	Long Shaft	SCF-25-600L	1
50	JT9-TS-1482041	Head Cap Screw	M6x20L	4
51	JT9-TS-1490081	Head Cap Screw	M8x45L	4
52	BA1-6477	Adjusting Screw	M16	4
53	**	Machine Base	S20A3-01-C	1
54	BA1-6478	Hydraulic Unit Cover	S20A3-01-E	1
55	JT9-F009884	Button Head Socket Screw	M5x8L	4
56	BA1-6479	Outlet Mobile Case	S20A3-04-B	1
57	BA1-6480	Handle	9160502	1

Index No.	Part No.	Description	Size	Qty.
58	BA1-6481	Big Round Head Screw	M6x12L	2
59	BA1-6482	Outlet Case	S20A3-04	1
60	JT9-TS-2361121	Spring Washer	M12	4
61	JT9-F008871	Head Cap Screw	M12x20L	4
62	BA1-6483	Outlet Cover	S20A3-16	1
63	JT9-F009884	Button Head Socket Screw	M5x8L	4
64	BA1-6484	Outlet Side Plate	S20A3-04-A	1
64A	BA9-1232646	Material Stop Rod Kit (#64-92)		
65	BA1-6485	Flat Head Screw	5/16"x3/4"L	4
66	JT9-5051911	Washer	M10	2
67	JT9-TS-2361101	Spring Washer	M10	2
68	CM9-TS-1491031	Head Cap Screw	M10x25L	2
69	JT9-TS-0209051	Socket Head Cap Screw	3/8"x1"L	1
70	JT9-TS-0720091	Spring Washer	3/8"	1
71	BA1-6486	Washer	S1380221-3	1
72	BA1-6487	Position Block (Left)	S1380110	1
73	JT9-TS-0270021	Set Screw	5/16"x5/16"L	1
74	JT9-TS-0209051	Socket Head Cap Screw	3/8"x1"L	1
75	JT9-TS-0720091	Spring Washer	3/8"	1
76	BA1-6488	Washer	S1380221-3	1
77	BA1-6489	Handle	3/8x30L	1
78	BA1-6490	Adjusting Block	S1380110-B	1
79	BA1-6491	Position Bracket Shaft	S1380221-2	1
80	BA1-6492	Stopper Rod	460D2-64	1
81	BA1-6493	Position Bracket	S1380110-C	1
82	JT9-TS-0209051	Socket Head Cap Screw	3/8"x1"L	1
83	JT9-TS-0720091	Spring Washer	3/8"	1
84	BA1-6494	Washer	S1380221-3	1
85	JT9-TS-0720091	Spring Washer	3/8"	1
86	JT9-TS-0209051	Socket Head Cap Screw	3/8"x1"L	1
87	BA1-6495	Position Block (Right)	S1380110-A	1
88	BA1-6496	Length Scale Rod	S1380221	1
89	JT9-TS-0270021	Set Screw	5/16"x5/16"L	1
90	BA1-6497	Washer	S1380221-3	1
91	JT9-TS-0720091	Spring Washer	3/8"	1
92	JT9-TS-0209051	Socket Head Cap Screw	3/8"x1"L	1
93	BA1-6498	Chip Box	S20A3-08	1
94	BA1-6499	Thumb Screw	M8x16L	5
95	BA1-6500	Coolant Plate	S20A3-10	1
96	BA1-6501	Coolant Pump	1/6Hp 150L	1
97	CM9-TS-2361061	Spring Washer	M6	2
98	JT9-TS-1482021	Head Cap Screw	M6x12L	2
99	JT9-TS-1505051	Socket Head Cap Screw	M10x35L	2
100	BA1-6502	Position Block	331D2-04	1
101	BA1-6503	Cutting Table	331D1-01	1
102	JT1-1978	Set Screw	M12x30L	4
103	JT9-TS-1506111	Socket Head Cap Screw	M12x70L	4
104	JT9-TS-1505061	Socket Head Cap Screw	M10x40L	1
105	JT9-TS-1540071	Nut	M10	1
106	BA1-6504	Spring Pin	8x20L	2
107	**	Cutting Plate	331D1-02	1
108	BA1-6505	Spring Pin	8x20L	2
109	JT9-TS-1505101	Socket Head Cap Screw	M10x60L	2
110	BA9-1226995	Angle Cutting Table	S20A1-01	1
111	JT9-TS-1504111	Socket Head Cap Screw	M8x55L	2
112	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	2
113	BA1-6506	Fixing Block	331D2-04	1
114	JT9-TS-1505051	Socket Head Cap Screw	M10x35L	2
115	BA1-6507	Fixed Jaw (L)	331D2-23	1
116	BA1-6508	Fixed Jaw (R)	331D2-24	1
117	JT9-TS-1505041	Socket Head Cap Screw	M10x30L	4

Index No.	Part No.	Description	Size	Qty.
118	BA9-1021835	Hose	L25A4-14	1
119	BA1-6509	Wing Screw	M6x25L	2
120	BA1-6510	Hose Set	H46A2-39	1
121	BA1-6511	Coolant Switch		1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

16.1.3 Dual Miter Semi Automatic Band Saw Assembly – Exploded View B



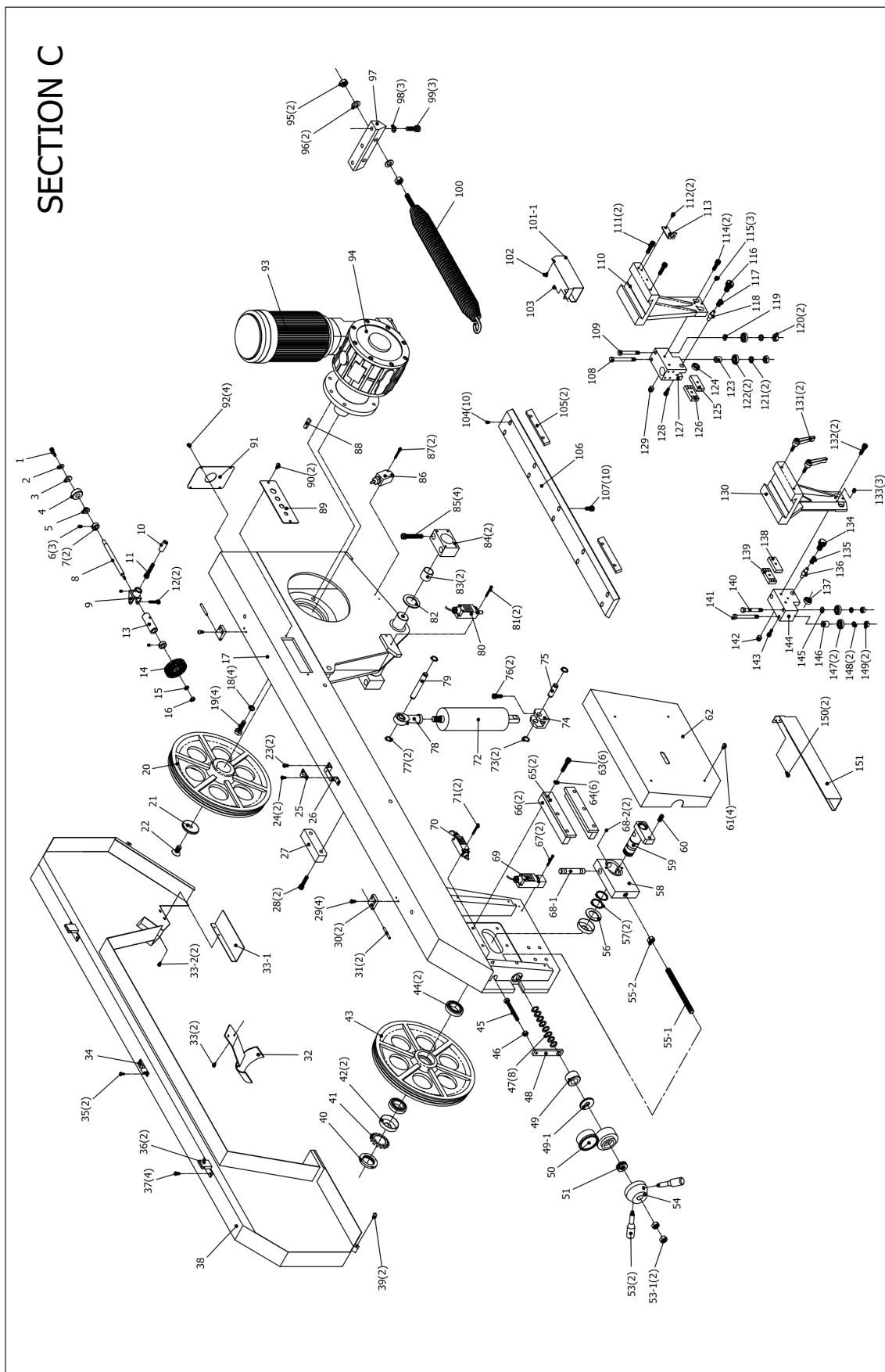
16.1.4 Dual Miter Semi-Automatic Band Saw Assembly – Parts List B

Index No.	Part No.	Description	Size	Qty.
1	**	Cam Shaft	331D2-31	1
2	JT1-1979	Ball Bearing	BB2136	1
3	JT9-TS-2361101	Spring Washer	M10	1
4	JT9-TS-1540071	Nut	M10	1
5	BA1-6513	C Ring	S16	1
6	JT9-TS-1505061	Socket Head Cap Screw	M10x40L	1
7	BA1-6514	Cam Spring	331D4-02	1
8	JT9-TS-1540071	Nut	M10	1
9	BA1-6515	Connecting Plate	331D2-32	1
10	JT9-TS-1505061	Socket Head Cap Screw	M8x25L	2
11	BA1-6516	Cam Bracket	331D2-30	1
12	BA9-1022731	Position Bracket	331D1-11	1
	BA9-1231554	BS20SADM-B12-20-Handle Assy		
13	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	1
14	BA9-BS20SADM-B14	Angle Setting Block	331D2-26	1
15	JT9-TS-1505081	Socket Head Cap Screw	M10x50L	1
16	BA9-1227737	Connecting Block	331D2-28	1
17	BA9-BS20SADM-B17	Set Bolt	331D2-27	1
18	BA9-1227738	Handle Shaft	331D2-29	1
19	JT9-TS-1540081	Nut	M12	1
20	BA1-6517	Handle	9160501	1
21	JT9-F009884	Socket Head Button Screw	M5x8L	4
22	BA1-6518	Cover	331D3-26-A	1
23	JT9-TS-2246082	Socket Head Button Screw	M6x8L	2
24	CM9-TS-1501011	Socket Head Cap Screw	M4x6L	2
25	BA9-BS20SADM-B25	Magnifier Holder	331D3-43	1
26	BA9-1227739	Angle Magnifier	331D4-09	1
27	BA1-6519	Cover	331D3-25	1
28	JT9-TS-1505061	Socket Head Cap Screw	M10x40L	1
29	JT9-5051911	Washer	M10	1
30	BA1-6520	Center Wheel	331D2-33	1
	**	Wire Fastener Assembly (including		
		B31, B33-B35)	331D2-35A	
31	BA1-6521	Wire Fastener	331D2-35	1
32	JT9-TS-1481041	Hex Cap Screw	M5x15L	1
33	BA1-6522	Bush	331D2-34	1
34	BA1-6523	Steel Rope		1
35	BA1-6524	Extend Spring	331D4-03	1
36	JT9-TS-1505061	Socket Head Cap Screw	M10x40L	4
37	JT9-TS-1506021	Socket Head Cap Screw	M12x25L	4
38	BA1-6525	Cylinder Plate	331D2-61	1
39	CM9-TS-1503061	Socket Head Cap Screw	M6x25L	4
40	CM9-TS-2361061	Spring Washer	M6	4
41-1	BA1-6526	Plate	S20A2-08-B	1
42-1	BA1-6527	Linear Bearing	LMA-25UU	1
43	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	4
44	BA1-6528	Adjusting Screw	H46D2-19-B	2
45	JT9-TS-1540081	Nut	M12	2
46	BA1-6529	Position Block	S20A2-10	2
47	BA1-6530	Vise Position Block	S20A2-10-A	1
48	JT9-TS-2235061	Socket Head Cap Screw	M5x6L	2
49	CM9-TS-2361081	Spring Washer	M8	4
50	PM9-TS-2228161	Hex Cap Screw	M8x16L	4
51	BA1-6531	Lock Handle	TRT80 M10x45L	1
52	BA1-6532	Lock Brass	H46D2-25	1
53-1	BA1-6533	Position Block	S20A2-08-C	1
54	JT9-5051911	Washer	M10	2
55	JT9-TS-2361101	Spring Washer	M10	2
56	JT9-TS-149105	Hex Cap Screw	M10x35L	2

Index No.	Part No.	Description	Size	Qty.
57	JT9-TS-1506041	Socket Head Cap Screw	M12x35L	4
58	BA1-6534	Guide Plate	S20A2-09	1
59	JT9-TS-2208201	Hex Cap Screw	M8x20L	2
60	CM9-TS-2361081	Spring Washer	M8	2
61	BA1-6535	Cover	331D3-26	1
62	BA1-6536	Copper Plate	H46D2-19	1
63	JT9-TS-2245081	Socket Head Flat Screw	M5x8L	2
64	BA1-6537	Vise Table	331D1-04-A	1
65	BA9-1019417	Hydraulic Cylinder	B015-C201A	1
66	**	Vise Position Block	331D2-18-A	1
67-1	BA1-6538	Movable Vise	331D1-05-A	1
68	JT9-TS-1506021	Socket Head Cap Screw	M12x25L	2
69	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	1
70	BA1-6539	Attached Plate	331D2-22	1
71	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	4
72	BA1-6540	O Ring	L25A5-47	2
73	BA1-6541	Upper Cover	331D2-06-A	1
74	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	8
75	JT9-TS-1523071	Set Screw	M6x25L	1
76	BA1-6542	Upper Cover	331D2-06	1
77	JT1-1980	Taper Roller Bearing	BB2188	2
78	BA1-6543	Center Shaft	331D2-03	1
79	BA1-6544	Swiveling Base	331D1-06	1
80	BA9-1232147	Angle Plate	331D2-25	1
81	BA1-6545	Spring Pin	8x20L	2
82	JT9-TS-1505031	Socket Head Cap Screw	M10x25L	5
83	JT9-TS-2361101	Spring Washer	M10	5
84	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	8
85	BA1-6546	Lower Cover	331D2-05	1
86	JT9-TS-1481041	Hex Cap Screw	M5x15L	1
87	BA1-6547	Wire Fastener	331D2-35	1
88	BA1-6548	Nut	1/2"	2
89	JT9-TS-0720111	Spring Washer	1/2"	2
90	JT9-TS-1504051	Socket Head Cap Screw	M8x25L	4
91	CM9-TS-2361081	Spring Washer	M8	4
92	BA1-6549	Lower Bracket	331D1-17	1
93	BA1-6550	Ring Screw	1/2"	2
94	JT9-TS-1540071	Nut	M10	1
95	JT9-TS-1491101	Hex Cap Screw	M10x60L	1
96	JT9-TS-2310201	Nut	M20	1
97	BA1-6551	Hex Cap Screw	M20x65L	1
98	BA1-6552	Nylon Nut	M10	1
99	BA1-6553	POM Washer	S138F2-26-B	1
100	BA1-6554	Washer	S138F2-26-A	1
101	BA1-6555	Upper Contact Plate	S20A3-09	1
102	BA1-6556	Position Screw	S20A2-01	1

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16.1.5 Dual Miter Semi Automatic Band Saw Assembly – Exploded View C



16.1.6 Dual Miter Semi Automatic Band Saw Assembly – Parts List C

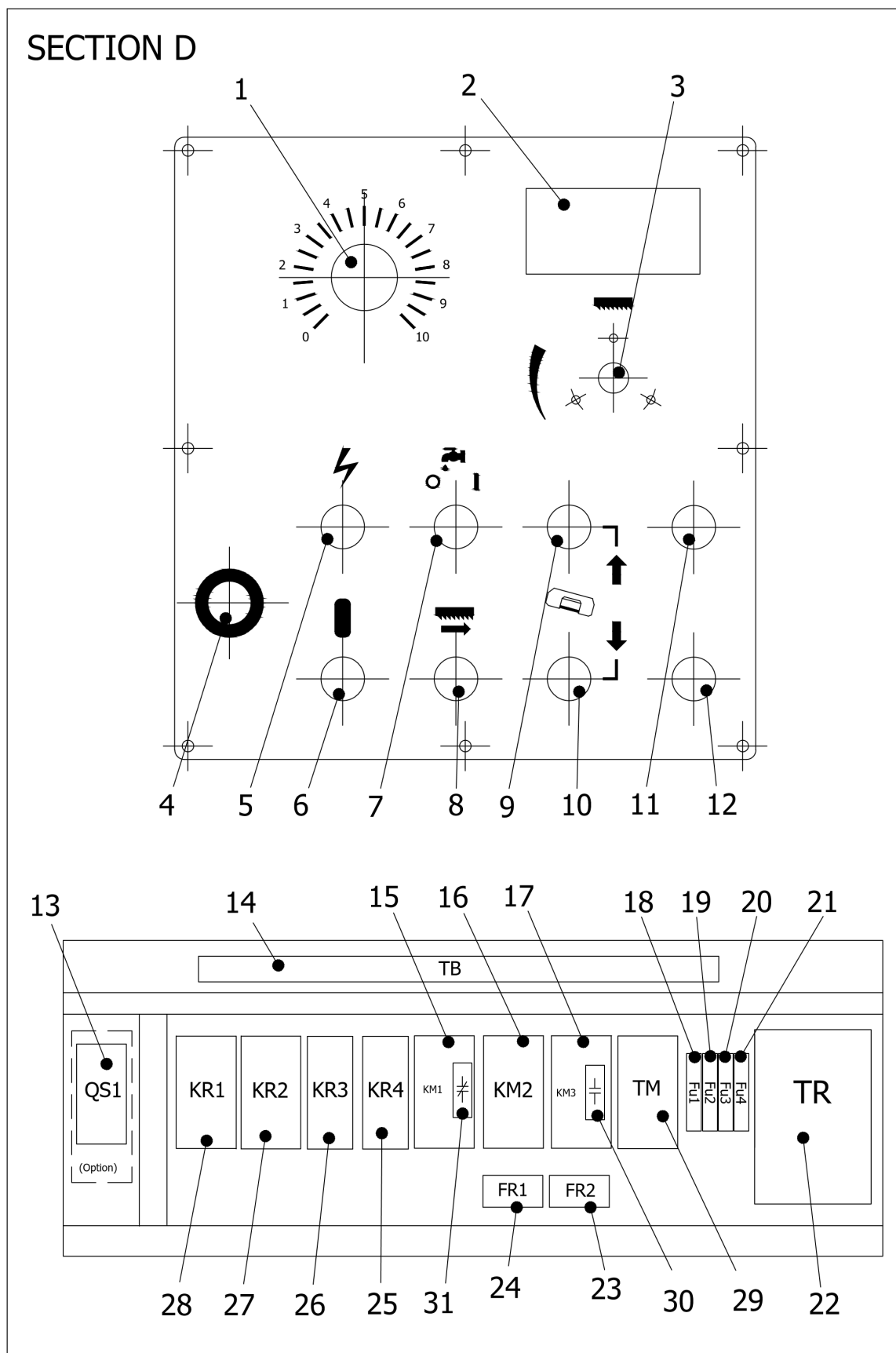
Index No.	Part No.	Description	Size	Qty.
1	CM9-TS-1503041	Socket Head Cap Screw	M6x16L	1
2	BA1-6557	Spring Washer	M6	1
3	BA1-6558	Shaft Bush	331D2-42-A	1
4	BA9-BS20SADM-C4	Brush Wheel	331D2-42	1
5	BA1-6559	Shaft Bush	331D2-42-A	1
6	JT9-TS-1523011	Set Screw	M6x6L	3
7	BA1-6560	Position Bush	331D2-41	2
8	BA9-1226296	Brush Shaft	331D2-40	1
9	BA1-6561	Position Bracket	331D3-17	1
10	BA9-BS20SADM-C10	Shaft	331D2-43	1
11	JT9-TS-1504091	Socket Head Cap Screw	M8x45L	1
12	JT9-TS-1503011	Socket Head Cap Screw	M6x8L	2
13	BA1-6562	Shaft Tube	331D2-39	1
14	BA1-6563	Brush	3"x6.35mm	1
15	BA1-6564	Spring Washer	M6	1
16	CM9-TS-2311061	Nut	M6	1
17	BA1-6565	Saw Bow	S20A3-02	1
18	BA1-6566	Spring Washer	M10	4
19	JT9-TS-1491061	Hex Cap Screw	M10x40L	4
20	BA1-6567	Drive Wheel	331D1-13	1
21	BA1-6568	Washer	331D2-49	1
22	JT1-1981	Socket Head Flat Screw	M12x25L	1
23	JT9-TS-2246122	Socket Head Button Screw	M6x12L	2
24	JT9-TS-1512011	Socket Head Flat Screw	M4x10L	2
25	BA1-6569	Brass Button	330S0419	1
26	BA1-6570	Lock Bracket	331D3-27	1
27	BA1-6571	Blade Guide Block	331D2-55	1
28	JT9-TS-1504081	Socket Head Cap Screw	M8x40L	2
29	JT9-TS-2246202	Socket Head Button Screw	M6x20L	4
30	BA9-1226997	Fixing Block	331D2-44	2
31	BA9-1226998	Pin	14x70L	2
32	BA1-6572	Protective Bracket	331D3-14	1
33	JT9-F009884	Socket Head Button Screw	M5x8L	2
33-1	**	Blade guard (Rear)	331D3-48B	1
33-2	JT9-F009884	Button Head Socket Screw	M5x8L	2
34	BA1-6573	Brass Button	330S0419	1
35	JT9-TS-1512011	Socket Head Flat Screw	M4x10L	2
36	BA1-6574	Cover Lock	331D2-45	2
37	JT9-TS-2246122	Socket Head Button Screw	M6x12L	4
38	BA1-6575	Wheel Cover	S20A3-05	1
39	JT9-F009884	Socket Head Button Screw	M5x8L	2
40	BA9-1231582	Nut	AN07(M35)	1
41	BA9-1013408	Teeth Washer	AW07(M35)	1
42	BA9-1013409	Cover	331D4-47A	2
43	BA9-1010902	Idle Wheel	331D1-12	1
44	BA9-1013410A	Taper Roller Bearing	BB2190	2
45	JT9-TS-1490111	Hex Cap Screw	M8x60L	1
46	JT9-TS-1540061	Nut	M8	1
47	BA1-6576	Disc Washer 361820	331D5-30	8
48	BA1-6577	Contact Plate	331D2-48	1
49	BA1-6578	Tension Gauge Spacer	331D2-16-A	1
49-1	BA1-6579	Slide Block Screw Rod Washer	331D2-16-B	1
50	BA9-1014060	Tension Gauge	331D5-00B	1
51	BA9-1021697	Thrust Bearing	BB2010	1
53	BA1-6580	Handle	331D2-63	2
53-1	JT9-TS-154010	Nut	M16	2
54	BA1-6581	Handle Wheel	331D2-63-A	1
55-1	BA1-3560	Tooth strip	M16	1
55-2	JT9-TS-154010	Nut	M16	1

Index No.	Part No.	Description	Size	Qty.
56	BA1-3554	Washer	331D2-12-C	1
57	BA1-3555	C Ring	S35	2
58	BA1-3556	Slide	331D2-13	1
59	BA9-1226943	Idle Wheel Shaft Set	331D2-12	1
60	JT9-TS-1526041	Set Screw	M12x25L	1
61	JT9-F009884	Socket Head Button Screw	M5x8L	4
62	BA1-6582	Wheel Cover	S20A3-12	1
63	BA1-6583	Socket Head Cap Screw	M10x55L	6
64	BA1-6584	Spring Washer	M10	6
65	BA1-6585	Slide Plate	331D2-15	2
66	BA1-6586	Slide Guide	331D2-14	2
67	JT9-TS-1501091	Socket Head Cap Screw	M4x35L	2
68-1	BA1-6587	Slide Block Solid Pin	331D2-11	1
68-2	JT9-TS-2276081	Set Screw	M6x8L	2
69	BA1-6588	Limit Switch	EK-1-15-R	1
70	BA1-6589	Limit Switch	AZD-1001T	1
71	JT9-TS-1501091	Socket Head Cap Screw	M4x35L	2
72	BA9-1010516	Hydraulic Cylinder		1
73	BA1-6590	C Ring	S16	2
74	BA1-6591	Lower Bracket	331D2-36	1
75	BA1-6592	Cylinder Support Rod	331D2-37	1
76	JT9-TS-1504041	Socket Head Cap Screw	M8x20L	2
77	BA1-6593	C Ring	S16	2
78	BA9-BS20SADM-C78	Eye Bearing	B015-C206	1
79	BA1-6594	Cylinder Support Rod	331D2-38	1
80	BA9-BS20SADM-C80	Limit Switch	AZD-1001T	1
81	JT9-TS-1501091	Socket Head Cap Screw	M4x35L	2
82	BA1-6595	Washer	331D2-01-A	1
83	BA1-6596	Oilless Bearing 4040	BB2062	2
84	BA1-6597	Bush Seat	331D2-02-A	2
85	BA1-6598	Socket Head Cap Screw	M12x65L	4
86	BA1-6599	Limit Switch	ED1-3-32	1
87	JT9-TS-1501091	Socket Head Cap Screw	M4x35L	2
88	BA1-6600	Key	14x8x50	1
89	BA1-6601	Wire Plate	S20A3-02-C	1
90	JT9-TS-2246082	Socket Head Button Screw	M6x8L	2
91	BA1-6602	Wire Plate	S20A3-02-B	1
92	JT9-F009884	Socket Head Button Screw	M5x8L	2
93	BA9-1224684	Motor	3HP	1
94	BA9-1021837	Reducer	100#1/40	1
95	JT9-JWS25-202	Nut	1/2"	2
96	BA1-6603	Spring Washer	1/2"	2
97	BA1-6604	Spring Holder	S20A1-03	1
98	BA1-6605	Spring Washer	M10	3
99	JT9-TS-1505031	Socket Head Cap Screw	M10x25L	3
100	BA1-1281	Spring	331D4-01-A	1
101-1	BA9-1022301A	Blade Guard (Rear)	331D3-48A	1
102	JT9-F009884	Socket Head Button Screw	M5x8L	1
103	BA1-3578	Spring Pin	4x12L	1
104	JT9-TS-1525031	Set Screw	M10x16L	10
105	BA1-6606	Plate	331D2-07-A	2
106	BA1-6607	Bracket Guide	331D2-07	1
107	JT9-TS-1505021	Socket Head Cap Screw	M10x20L	10
108	BA9-1230824	Bearing Shaft (Long)	331D2-10	1
109	BA9-1230825	Bearing Shaft (Short)	331D2-10-A	1
110	BA1-6608	Guide Post (Rear)	331D1-08	1
111	JT9-TS-1504061	Socket Head Cap Screw	M8x30L	2
112	JT9-TS-2246082	Socket Head Button Screw	M6x8L	2
113	BA1-6609	Fixing Bracket	331D3-22	1
114	JT9-TS-1505061	Socket Head Cap Screw	M8x25L	2

Index No.	Part No.	Description	Size	Qty.
115	JT9-TS-1524041	Set Screw	M8x16L	3
116	BA1-6610	Adjusting Screw	3300209	1
117	BA9-BS20SADM-C117	Adjusting Spring	3300405	1
118	BA9-BS20SADM-C118	Pin	331D2-59	1
119	BA9-1230826	Washer	331D2-10-C	1
120	JT9-TS-1540071	Nut	M10	2
121	BA1-6611	Spring Washer	M10	2
122	**	Bearing 6200	BB2149	2
123	BA9-1230827	Shaft Bush	331D2-10-B	1
124	BA9-1021098	Bearing 6000	BB2136	1
125	BA9-1021099	Adjusting Carbide (No Grooved)	331D2-09-A	1
126	BA9-1021100	Fixed Carbide (No Grooved)	331D2-08-A	1
127	BA1-6612	Bearing Set (Rear)	331D1-10	1
	**	Rear Blade Guide Bracket		
128	CM9-TS-1503041	Socket Head Cap Screw	M6x16L	1
129	BA9-BS20SADM-C129	Set Screw	M12x10L	1
130	BA1-6614	Guide Post (Front)	331D1-07	1
131	BA1-1651	Lock Handle	M8x30L	2
132	JT9-TS-1505061	Socket Head Cap Screw	M8x25L	2
133	JT9-TS-1524041	Set Screw	M8x16L	3
134	BA1-6615	Adjusting Screw	3300209	1
135	BA1-6616	Adjusting Spring	3300405	1
136	BA1-6617	Pin	331D2-59	1
137	JT1-1979	Bearing 6000	BB2136	1
138	BA9-1021101	Adjusting Carbide (Grooved)	331D2-09	1
139	BA9-1021102	Fixed Carbide (Grooved)	331D2-08	1
140	BA1-6618	Bearing Shaft (Short)	331D2-10-A	1
141	BA1-6619	Bearing Shaft (Long)	331D2-10	1
142	BA1-6620	Set Screw	M12x10L	1
143	CM9-TS-1503041	Socket Head Cap Screw	M6x16L	1
144	BA1-6621	Bearing Set (Front)	331D1-09	1
	BA9-1228870	Front Blade Guide Bracket		
145	BA1-6622	Washer	331D2-10-C	1
146	BA1-6623	Shaft Bush	331D2-10-B	1
147	JT1-1979	Bearing 6200	BB2149	2
148	BA1-6624	Spring Washer	M10	2
149	JT9-TS-1540071	Nut	M10	2
150	JT9-F009884	Socket Head Button Screw	M5x8L	2
151	BA9-1022302	Blade Guard (Front)	331D3-12-A	1
	Multiple Tpi/ Sku's Offered	Blade (not show)	34x1.1x4130mm HSS 3/4T	1
	BA9-1230471	Oil Filter MF-04 (not show)		

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

16.1.7 Dual Miter Semi Automatic Band Saw Assembly – Exploded View D

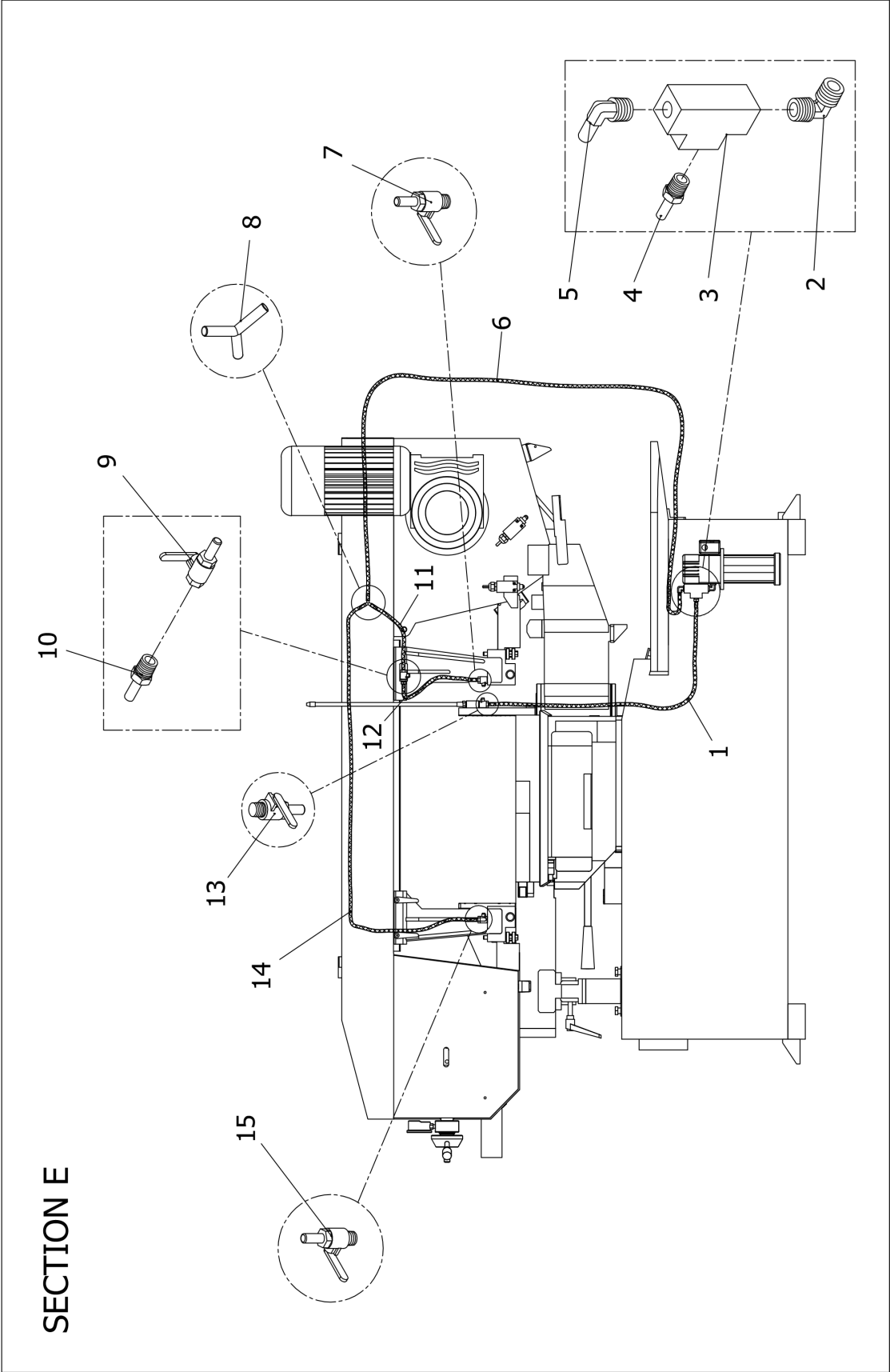


16.1.8 Dual Miter Semi Automatic Band Saw Assembly – Parts List D

Index No.	Part No.	Description	Size	Qty.
1	BA9-1226944	Flow Regulator		1
2	**	Blade Speed Readout		1
3	**	Blade Speed Control Knob VR	Blade Speed Adjust Knob	1
4	**	Emergency Stop Button		1
5	BA1-6625	Power Indicator Light		1
6	BA1-6626	Plug	CSA	1
7	**	Coolant Pump ON/OFF Switch		1
8	**	Blade Start Button		1
9	**	Bow Up Button		1
10	**	Bow Down Button		1
11	**	Vise Open Button		1
12	**	Vise Close Button		1
14	BA1-6627	Terminal Block		1
15	**	Blade Motor Contactor	KM1	1
16	**	Coolant Pump Contactor	KM2	1
17	**	Hydraulic Motor Contactor	KM3	1
18	BA1-6628	Fuse	2A	1
19	BA1-6629	Fuse	2A	1
20	BA1-6630	Fuse	4A	1
21	BA1-6631	Fuse	2A	1
22	BA9-1021765	Transformer	0.25KVA	1
23	BA1-6632	Oil Motor Overload Relay(220V)	NTH4(2.9-4A)	1
	BA1-6633	Oil Motor Overload Relay(440V)	NTH1.9(1.4-1.9A)	1
24	BA1-6634	Coolant Pump Overload Relay(220V)	NTH-0.5(0.35-0.5A)	1
	BA1-6635	Coolant Pump Overload Relay(440V)	NTH-0.5(0.35-0.5A)	1
25	BA1-6636	Relay	KR4	1
26	BA1-6637	Relay	KR3	1
27	BA1-6638	Relay	KR2	1
28	BA1-6639	Relay	KR1	1
29	**	Timer	option	1
30	**	Sub-Connector	only for CE	1
31	**	Sub-Connector	only for CE	1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

16.1.9 Dual Miter Semi Automatic Band Saw Assembly – Exploded View E

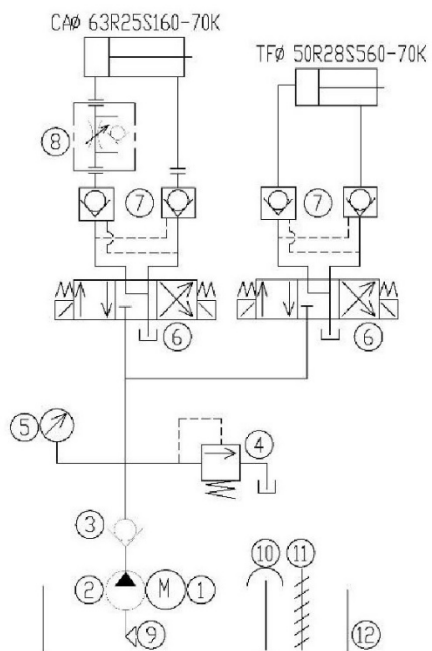
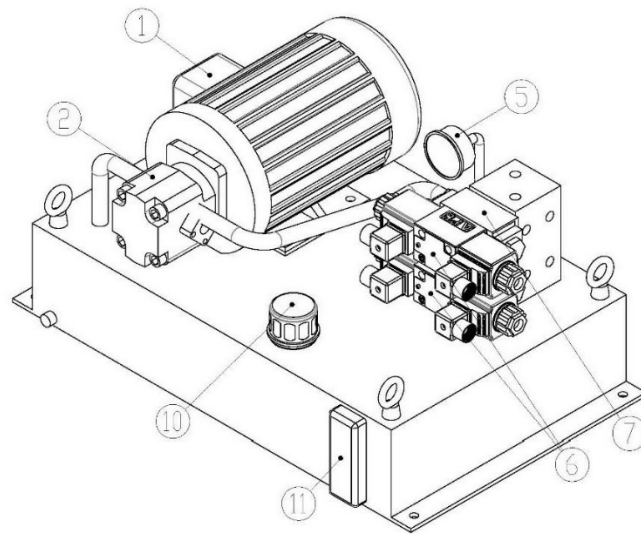


16.1.10 Dual Miter Semi Automatic Band Saw Assembly – Parts List E

Index No.	Part No.	Description	Size	Qty.
1	**	Hose	1/4"x1800mm	1
2	BA1-6640	90° Elbow	1/2*3/8"	1
3	BA1-6641	T- joint	3/8PT	1
4	BA1-6642	Fitting	3/8*1/4"	1
5	BA1-6643	90° Elbow	3/8*1/4"	1
6	**	Hose	1/4"	1
7	BA1-6644	Cock	1/4PT*1/4"	1
8	BA1-6645	Y- joint	1/4	1
9	BA1-6646	Cock	1/4PT*1/4"	1
10	BA1-6647	Fitting	1/4PT*1/4"	1
11	**	Hose	1/4"x900mm	1
12	**	Hose	1/4"x500mm	1
13	BA1-6648	Cock	1/4PT*1/4"	1
14	**	Hose	1/4"x2000mm	1
15	BA1-6649	Cock	1/4PT*1/4"	1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

16.1.11 Dual Miter Semi Automatic Band Saw Assembly – Exploded View F



16.1.12 Dual Miter Semi Automatic Band Saw Assembly – Parts List F

Index No.	Part No.	Description	Size	Qty.
1	**	Motor	1HP 230/ 440V 3Ph 4P	1
2	BA1-6651	Coolant Pump	1/6HP 220/ 440V 2P	1
3	BA1-6652	Check Valve		1
4	BA1-6653	Pressure Regulator		1
5	BA1-6654	Pressure Gauge		1
6	BA1-6655	Solenoid Valve		2
7	BA1-6656	Pilot Check Valve		2
8	BA1-6657	Flow control Valve		1
9	BA1-6658	Oil Filter	MF-04	1
10	BA1-6659	Oil Input Cover	TOYO-30-SR	1
11	BA1-6660	Oil Level	LS-3"	1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

17.0 Wiring Diagram

17.1 Electrical Schematic

