

INSTRUCTION MANUAL

QLD Schools / TAFE - BP-480
Wood Working Band Saw (240V)
465 x 310mm



K8810

W434

W434 BP-480 18/12/02

OPERATION MANUAL

19 INCH WOODWORKING BAND SAW

**FOR YOUR
SAFETY**
READ ALL
INSTRUCTIONS
CAREFULLY

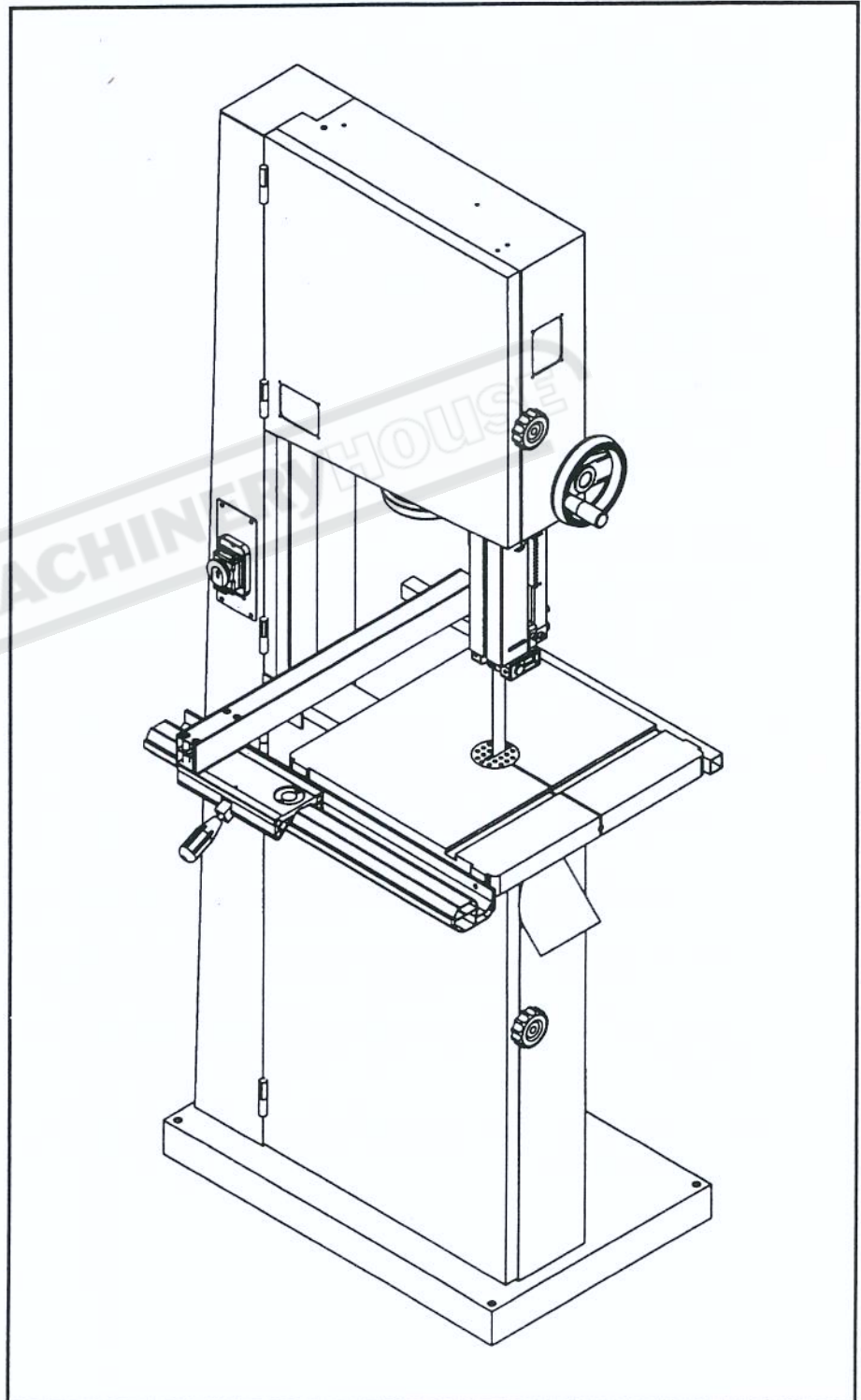


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GENERAL INFORMATION:

The 19"(480mm) band saw is a well designed industrial machine that provide variety of wood working functions to meet your higher needs of a Band Saw. Followings are the basic functions you will find in this machine:

1. *Quick Changed Saw Blade system* given you an easy way to replace saw blade to cut different quality wood materials.
2. *Adjustable Rip Fence* can assist you to cut desired shapes.
3. *Accurate Miter Gauge* can let you create any curves you desire.
4. *Effective Ball Bearing Guide System* will let the band saw blade run more smoother.
5. *Humanized Dust Chutes* collect extra wood-chips, and give you a better working environment.
6. *Extended 12" Height Space* provides you a bigger working space to cut wider and higher wood selections.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Stock Code: W434

Description: Vertical Bandsaw Model: BP-480 Brand: _____

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Australian Worksafe Standard for Plant(NOHSC:1010-1994)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
A	ENTANGLEMENT	HIGH	Eliminate, avoid loose clothing / Long hair etc.
B	CRUSHING	LOW	Secure & support Long / heavy material
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Blade guards should always be in the closed position before starting machine. Top blade guide system should be adjusted to suit material thickness. Isolate main power switch before changing blade, cleaning or adjusting. Use a push stick to remove off-cuts. If blade breaks do not open door until both wheels have stopped. Check blade tracking before starting.
D	SHEARING	MEDIUM	Make sure all guards are secured shut when machine is on.
F	STRIKING	LOW	Isolate power to machine prior to changing belts or maintenance. Support long heavy jobs. Remove all loose objects around moving parts. Wear safety glasses
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine.
M	HIGH TEMPERATURE	LOW	Machine should be installed & checked by a licensed Electrician.
O	OTHER HAZARDS, NOISE.	LOW	Wear appropriate protective clothing to prevent hot swarf / welded blades. Wear hearing protection as required.
Plant Safety Program to be read in conjunction with manufactures instructions			



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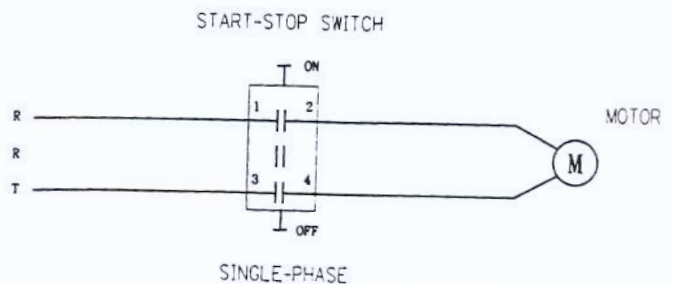
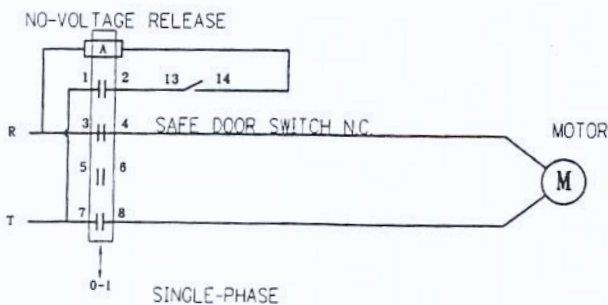
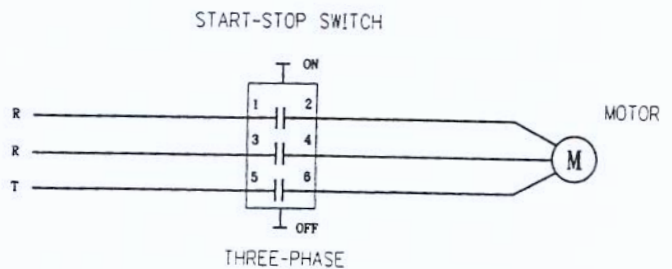
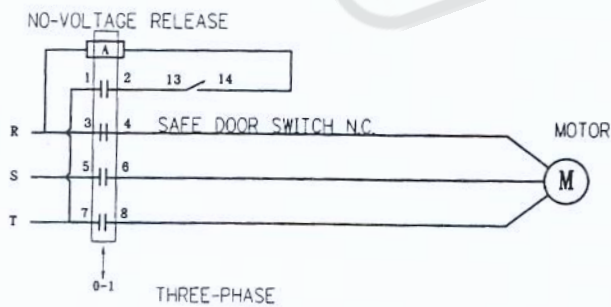
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Safety officer: _____
Manager: _____

Date: Mar-02

1. General Specifications

Horse Power	1.5HP or 2HP
Apperance	36" x 30" x 78"
Cutting Height	12"(300mm)
Max. Cutting Width	18-1/4"(462mm)
Max. Cutting (Rip Fence)	16-5/8"(422mm)
Saw Blade (L)	3614mm
Saw Blade (W)	1/8" to 1-1/4" (Standard 1/2")
CE Saw Blade Speed, Saw Blade Speed	(1500, 3200SFPM)
Table Size	19" x 19"(480x480mm)
Table Tilting	Left-10° / Right-45°
Wheel Size	19"(480mm)
Table Height From Ground	37.5"(950mm)
Dust Chute Diameter	D4" x 2
N.W/G.W.	145 / 174kgs
Packing Size (LxWxH)	34" x 20" x 85"(34CUFT)
CTN QTY / 20" / 40"	28SETS / 57SETS

WIRING DIAGRAMS:



2. WARNINGS



WARNING

- Misuse of this machine can cause serious injury.
- For safety, machine must be set up, used and serviced properly.
- Read, understand and follow instructions in the operator's and parts manual which was shipped with your machine.

When setting up machine:

- Always avoid using machine in damp or poorly lighted work areas.
- Always be sure machine is securely anchored to the floor.
- Always keep machine guards in place.
- Always put start switch in "OFF" position before plugging in machine.

When using Machine:

- Never operate with machine guards missing.
- Always wear safety glasses with side shields (See ANSI Z87.1)
- Never wear loose clothing or jewelry.
- Never overreach - you may slip and fall into the machine.

- Never leave machine running while you are away from it.
- Always shut off the machine when not in use. When servicing machine:
- Always unplug machine from electrical power while servicing.
- Always follow instructions in operators and parts manual when changing accessory tools or parts.
- Never modify the machine without consulting Wilton Corporation.

You- the stationary power tool user - hold the key to safety.

Read and follow these simple rules for best results and full benefits from your machine. Used properly, Wilson's machine is among the best in design and safety. However, any machine used improperly can be rendered inefficient and unsafe. It is absolutely mandatory that those who use our products be properly trained in how to use them correctly. They should read and understand the Operators and Parts Manual as well as all labels affixed to the machine. Failure in following one of these warnings can cause serious injuries.

Machinery general safety warnings

1. Always wear protective eye wear when operating machinery. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specifications. Use of eye wear which does not comply with ANSI Z87.1 specifications could result in severe injury from breakage of eye protection.
2. Wear proper apparel. No loose clothing or jewelry which can get caught in moving parts. Rubber soled footwear is recommended for best footing.
3. Do not overreach. Failure to maintain proper working position can cause you to fall into the machine or cause your clothing to get caught-pulling you into the machine.
4. Keep guards in place and in proper working order. Do not operate the machine with guards removed.
5. Avoid dangerous working environments. Do not use stationary machine tools in wet or damp locations. Keep work areas clean and well lit. Special electricians should be used when working on flammable materials.
6. Avoid accidental starts by being sure the start switch is "OFF" before plugging in the machine.
7. Never leave the machine running while unattended. Machine shall be shut off whenever it is not in operation.
8. Disconnect electrical power before servicing. Whenever changing accessories or general maintenance is done on the machine, electrical power to the machine must be disconnected before work is done.
9. Maintain all machine tools with care. Follow all maintenance instructions for lubricating and the changing of accessories. No attempt shall be made to modify or have makeshift repairs done to the machine. This not only voids the warranty but also renders the machine unsafe.
10. Machinery must be anchored to the floor.
11. Secure work. Use clamps or a vise to hold work, when practical. It is safer than using your hands and it frees both hands to operate the machine.
12. Never brush away chips while the machine is in operation.
13. Keep work area clean. Cluttered areas invite accidents.
14. Remove adjusting keys and wrenches before turning machine on.
15. Use the right tool. Don't force a tool or attachment to do a job it was not designed for.
16. Use only recommended accessories and follow manufacturers instructions pertaining to them.
17. Keep hands in sight and clear of all moving parts and cutting surfaces.
18. All visitors should be kept at a safe distance from the work area. Make workshop completely safe by using padlocks, master switches, or by removing starter keys.
19. Know the tool you are using- its application limitations, and potential hazards.

Safe by using padlocks, master switches, or by removing starter keys.

General Electrical Cautions

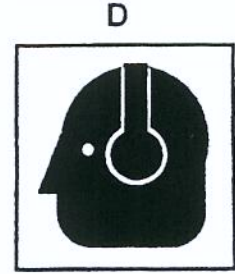
This saw should be grounded in accordance with the National Electrical Code and local codes and ordinances. This work should be done by a qualified electrician. The saw should be grounded to protect the user from electrical shock.

19. Know the tool you are using - its application, limitations, and potential hazards.

Caution : For circuits which are far away from the electrical service box, the wire size must be increased in order to deliver ample voltage to the motor. To minimize power losses and to prevent motor overheating and burnout, the use of wire sizes for branch circuits or electrical extension cords according to the following table is recommended.

3. SAFETY INSTRUCTIONS

1. Always wear leather gloves when handling saw blade. The operator shall not wear gloves when operating the machine.
2. All doors shall be closed, all panels replaced, and other safety guards in place prior to the machine being started or operated.
3. Be sure that the blades is not n contact with the workpiece when the motor is started. The motor shall be started and you should allow the saw to come up to full speed before bringing the saw blade into contact with the workpiece.
4. Keep hands away from the blade area. **See Figure A.**
5. Remove any cut off piece carefully while keeping your hands free of the blade area.
6. Saw must be stopped and electrical supply must be cut off before any blade replacement or adjustment of blade support mechanism is done, or before any attempt is made to change the drive belts or before any periodic service or maintenance is performed on the saw.
7. Remove loose performed on the unnecessary workpieces from area before starting machine.
8. Bring adjustable saw guides and guards as close as possible to the workpiece.
9. Always wear protective eye wear when operating, servicing, or adjusting machinery. Eyewear shall be impact resistant, protective safety glasses with side shields complying with ANSI Z787. 1 specifications. Use of eye wear which does not comply with ANSI 87. 1 specifications could result in severe injury from breakage of eye protection. **See Figure B.**
10. Nonslip footwear and safety shoes are recommended. **See Figure C.**
11. Wear ear protectors (plugs or muffs) during extended periods of operation. **See Figure D.**
12. The workpiece, or part being sawed, must be securely clamped before the saw blade enters the workpiece.
13. Remove cut off pieces carefully, keeping hands away from saw blade.
14. Saw must be stopped and electrical supply cut off or machine unplugged before reaching into cutting area.
15. Avoid contact with coolant, especially guarding your eyes.

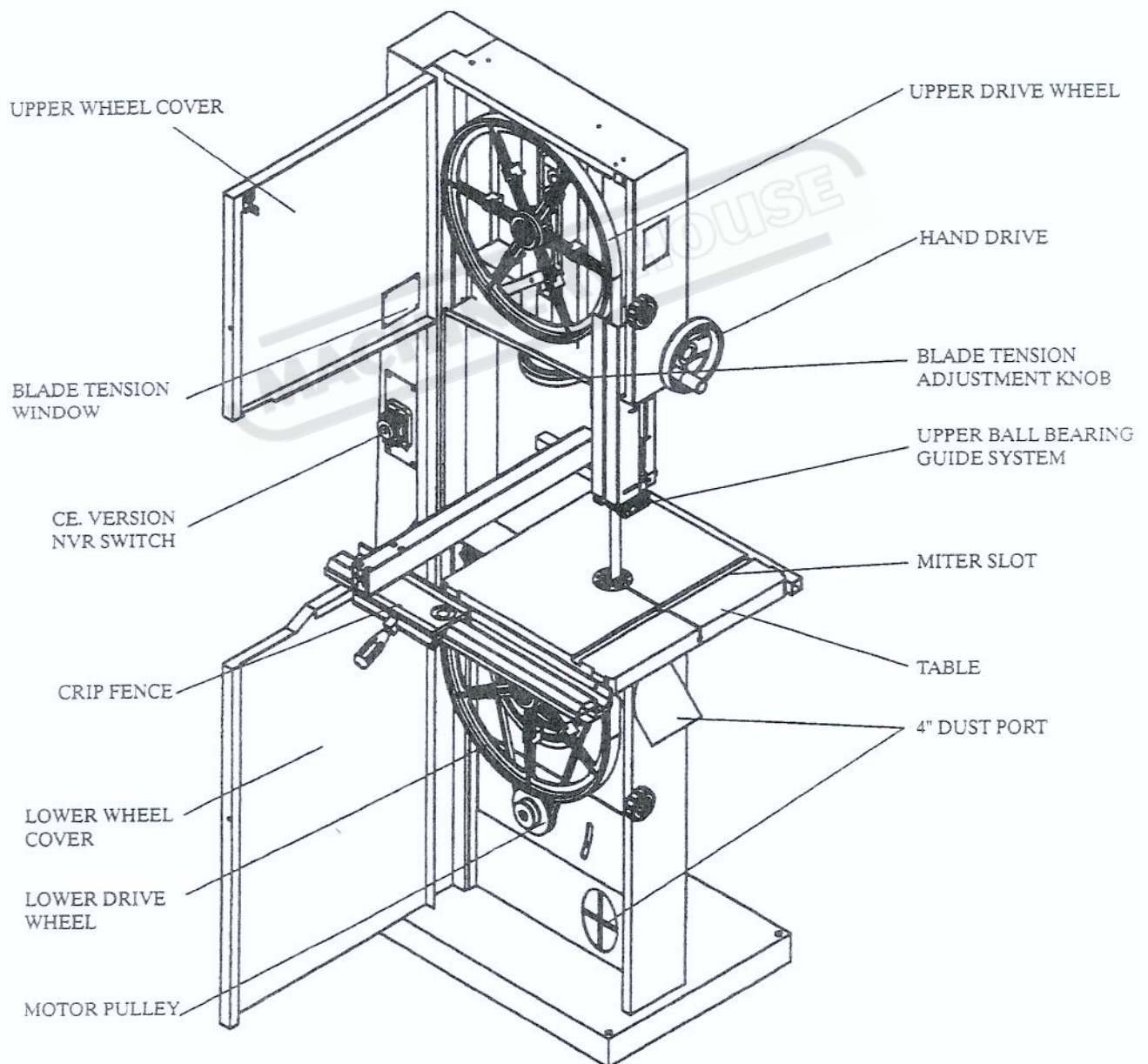


SAW NOMENCLATURE

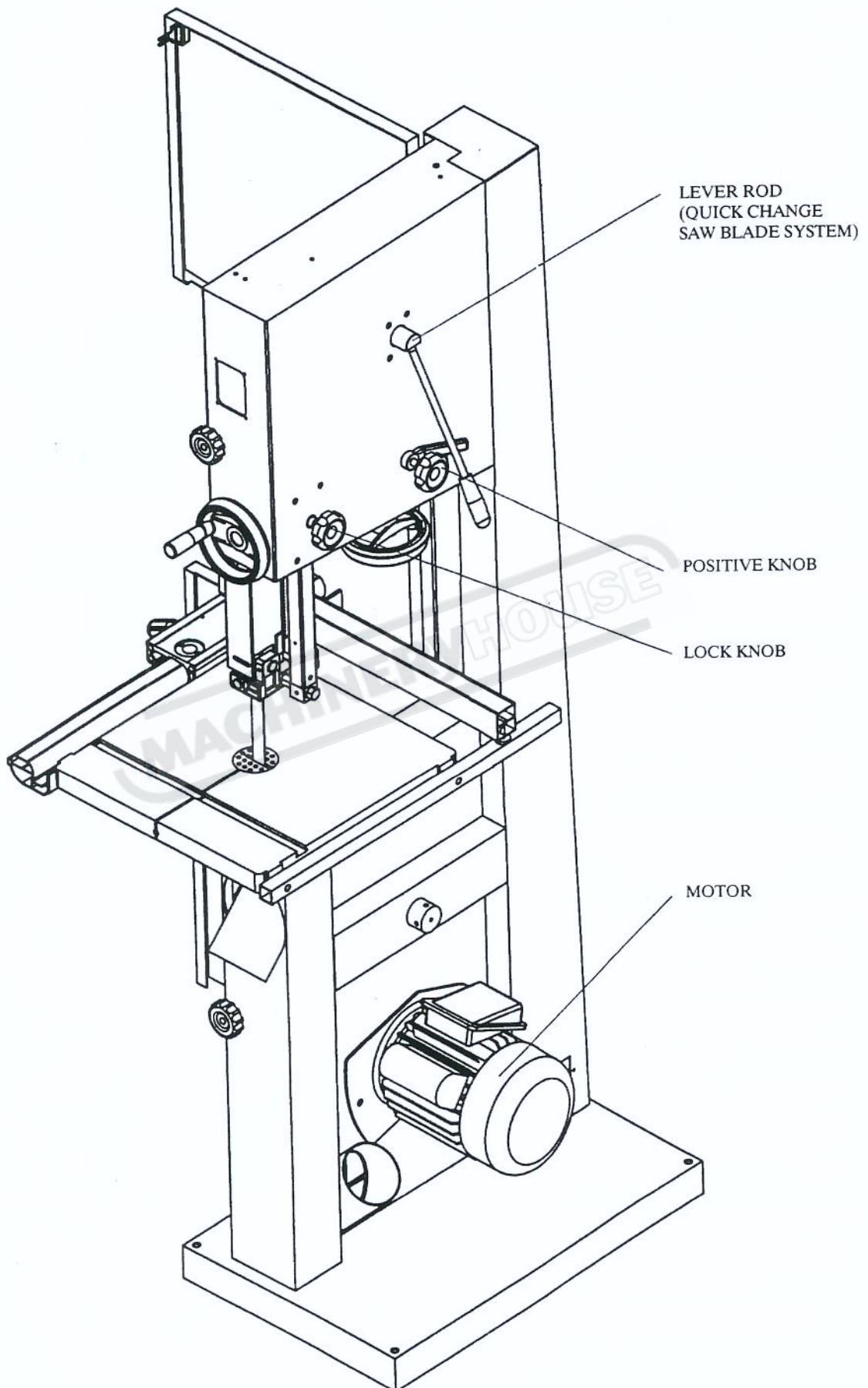
Throughout this document, we make reference to various systems and components on the saw. The two illustrations on these pages will provide you with an overall frame of reference for the location and position of the various components.

Where detailed illustrations for various subsystems will be helpful, you will find these illustrations accompanying the specific test for each subsystem and its components.

FRONT SIDE OF BAND SAW



REAR OF BAND SAW



5. OPERATING INSTRUCTION

MOVING

- Use a 2000kgs wrecker hang up the machine on parts A (Fig. 1) to suitable space.
- To ensure sufficient upright stability of the machine and safety, you need to bolt the machine to floor on M10 screw.

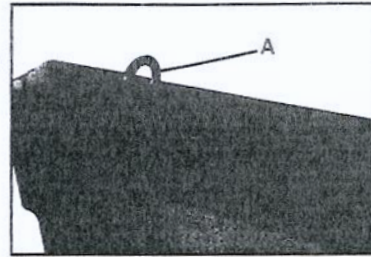


Fig. 1

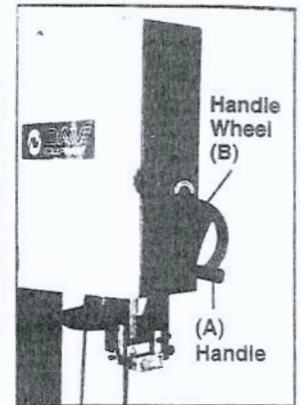


Fig. 2

ASSEMBLE THE MACHINE:

- Attach the handle (A, Fig. 2) to the hand wheel (B, Fig. 2), lock the screw then connect to the machine.
- To mount table, remove table insert and table pin from the table. Slide the table slot to the saw blade, slow moving to the center to table, make sure the table is located to the m8 hole (4 hole) and attach the spring washer, (Fig. 3) then replace table insert and table pin.
- Adjust the table until the saw blade in the center of table insert, then locked with screw.

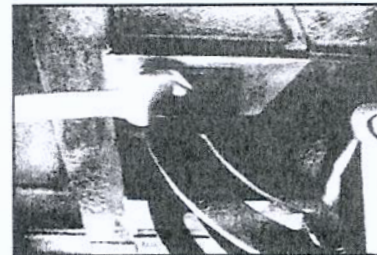


Fig. 3

ADJUSTING 90 DEGREE TABLE STOP

- Unplug power cord.
- Loosen the lock knobs (A, Fig. 4) and tilting table left until it rests against table stop bolt M8. (A, Fig. 5)
- Use a protractor placed on the table and against the blade, (A, Fig. 6) to see if the table is 90 degree to the table.
- If it is not 90 degree, you can use micro-adjust knob, please lock the lock knob.



Fig. 4

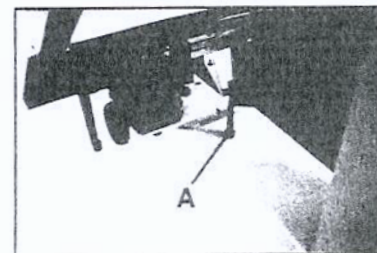


Fig. 5

RIP FENCE

- Setting the fixed base (A, Fig. 7) to the cast iron table with two hex head bolt m6x20, two spring washer m6.
- Setting the square tube (B, Fig. 7) to the table with 2 hex socket bolt m6x16.
- Setting the fence (A, Fig. 7) to the fence body, place the fence assembly on the fixed base, slide the fence on its guides until it is the required distance from the blade.
- Check the scale, make sure the distance between the edge of the miter slot and both the front and rear of the rip fence, adjust so both distances are equal.
- Lock the fence by pushing the locking handle.

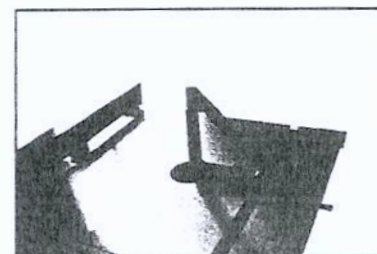


Fig. 6

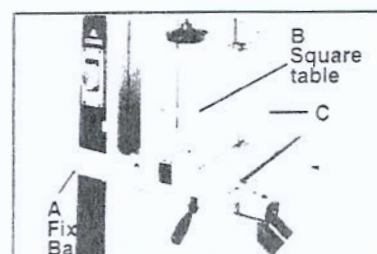


Fig. 7

BLADES CHANGING

1. Unplug power cord.
2. Remove the table insert and table pin.
3. Open upper & lower wheel cover.
4. Loosen the upper & lower blade guide system and bearing.
5. Loosen lever rod the knob (quick change saw blade system) on rear of band saw. (A, Fig. 8)
6. Remove the table to direct through slot in table.

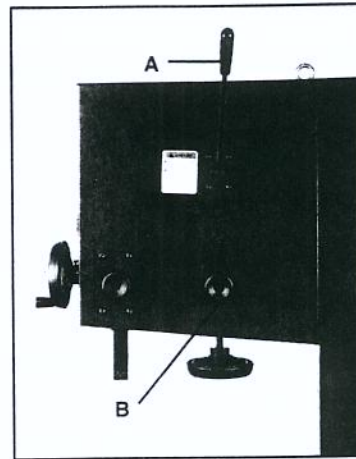


Fig. 8

Attention : the direction of new saw blade must be:

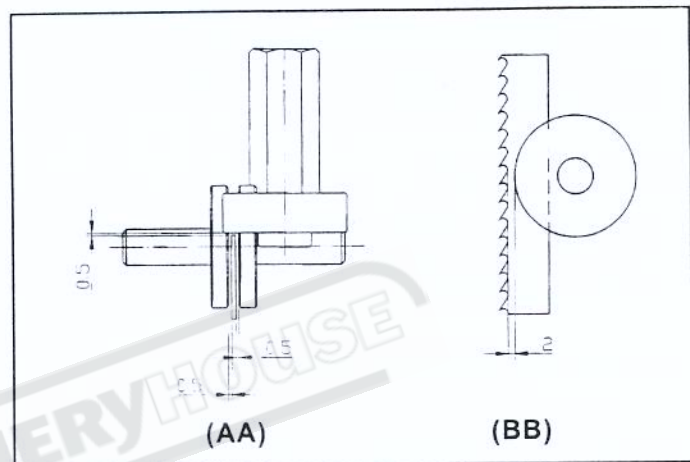


Fig. 9

7. Guide new blade through table slot, place blade in upper and lower ball bearing guide system.
8. Replace blade in the middle of the upper and lower wheel, if the saw blade is not in the right position, you must relax the fixed handle and adjust the positive knob. (B, Fig. 8)
9. Replace the table insert and table pin.
10. Adjust the blade tension and blade tacking if the blade width is different.

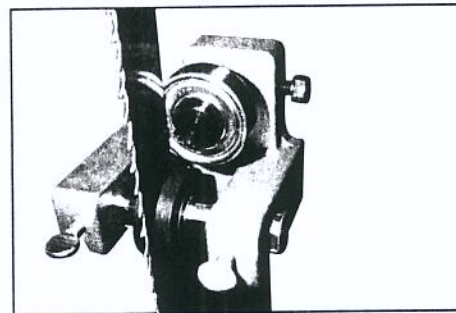


Fig. 10

ADJUSTING UPPER BLADE GUIDE ASSEMBLY

1. Set the bearing of upper & lower blade guide to within approx. 0.5mm of the blade, make sure the bearing the back of the blade approx. 0.5mm. (Fig.10,11) see follow instruction.(AA,BB)
2. Do not set the bearing too close, a the friction generates heat, which may have an adverse effect on the bearings and the saw blade as well.

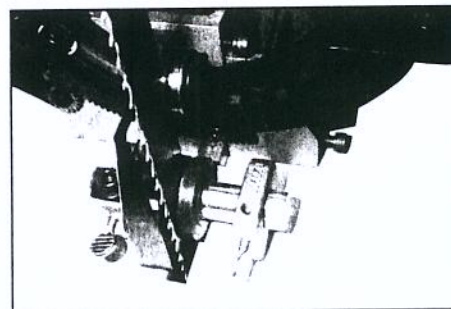


Fig. 11

ADJUSTING THE SPEED OF SAW BLADE

1. Loosen the two screw (A, B, Fig. 12), change the belt to the belt to the required belt solt.
2. Until the saw blade speed to 850m/min or 430m/min (3300SFPM, 1600SFPM)
3. Locked the two screw.



Fig.12

ADJUSTING THE TENSION OF THE BLADE

Blade tension is set by a spring loaded tension mechanism on the upper drive wheel. Check the level of the tension device before cutting. The tension for various blade widths as indicated on the window of upper wheel cover.

Turn the blade tension hand wheel (A, Fig. 13) and see the saw tension instruction (A, Fig. 14) indicated on the window of upper wheel cover.

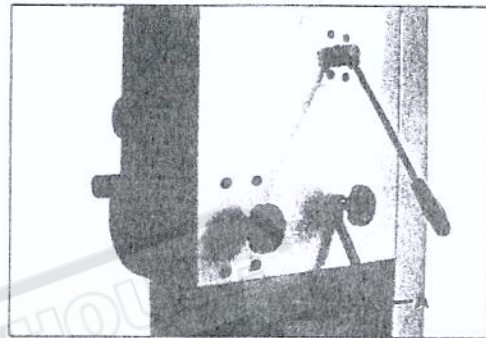


Fig.13

DUST COLLECTION

The hand saw is recommended to connected to dust collect, there are two 4" dust port (A, Fig. 15) to attach with 4" steel clamping.

SETTING THE CUTTING HEIGHT

The upper blade guide should always be set as closes practical against the work. To adjust, loosen the hand wheel (A, Fig. 2) at the side of housing and see the blade guide to the required height then tighten after setting.

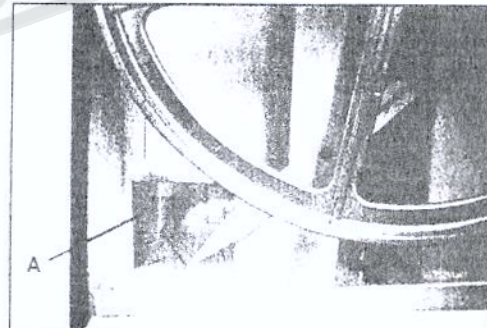
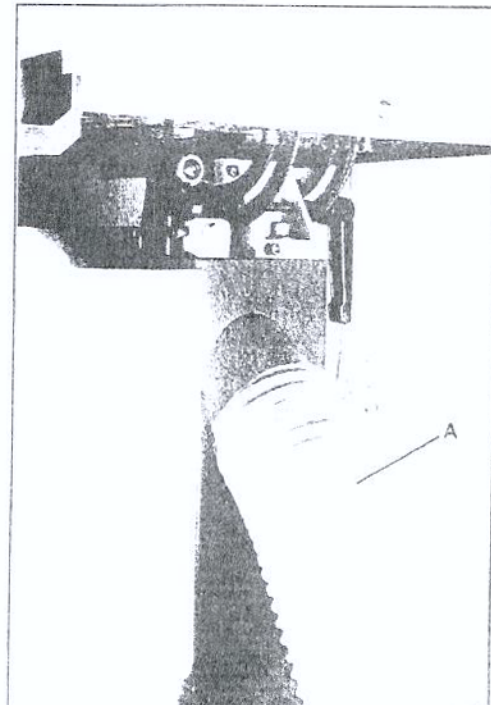


Fig.14



MITER GAUGE ADJUSTMENT (optional)

1. Plate the miter gauge in the table slot.
2. Loosen the clamp screw on the miter gauge.
3. Adjust to the desired angle of cutting on miter gauge.
4. Tighten the clamp screw (Fig. 16).

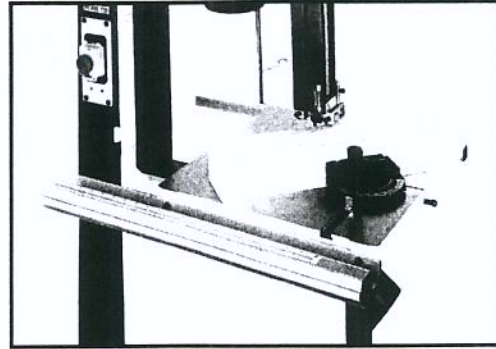


Fig. 16

MACHINERYHOUSE

Parts List For 19 Inch Band Saw Model No. SBW-4800 A

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
1				
2				
3				
4	995101	RING	M10	1
5	136101	MACHINE BODY		1
6	SS050100	SET BOLT	M5x5	1
7	135067	BUSHING		1
8	WF061310	FLAT WASHER	M6x ϕ 13	2
9	IC135005	POWER CORD		1
10	NH061000	NUT	M6	1
11	135040	POINTER		1
12	135073	STEP SCREW		1
13	135012	UPPER SHAFT		1
14	PS053500	SPRING PIN	ϕ 5x35	1
15	135017	UPPER WHEEL SHAFT HINGE		1
16	135066	UPPER WHEEL SHAFT		1
17	135039	BUSHING		3
18	BB620403	BALL BEARING	6204LLU	4
19	136002	UPPER WHEEL	ϕ 19"	1
20	RR470000	RETAINING RING	R47	4
21	WF083030	FLAT WASHER	M8x ϕ 30	2
22	SR089400	HEX SOCKET BOLT	M8X16	2
23	136010	SAW BLADE	143"x3/4"X0.5mm	1
24	WS080000	SPRING WASHER	M8	2
25	SR060600	HEX SOCKET BOLT	M6x30	6
26	135048	TIRE		2
27	136003	LOWER WHEEL	ϕ 19"	1
28	135007	IDLE PULLEY		1
29	NH633801	NUT	1"-14 UNF	1
30	WS630000	SPRING WASHER	1"	1

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
31	IM135002	MOTOR CORD		1
32	135032	SPRING		1
33	PS031600	PIN	φ 3X16	1
34	135042	LOCATE BLOCK		1
35	994301	BEARING	51201	1
36	994542	SWITCH		1
37	135002	HANDLE WHEEL		1
38	136007	ADJUSTING BOLT		1
39	SF050200	PAN HEAD BOLT W/FLANGE	M5X10	8
40	WE050000	STAR WASHER	M5	4
41	SF059400	PAN HEAD BOLT W/FLANG	M5X16	2
42	NH050800	NUT	M5	4
43	135027	SWITCH PLATE		1
44	SR089400	HEX SOCKET BOLT	M8x16	2
45	WF083030	FLAT WASHER	M8x φ 30	2
46	135016	UPPER WHEEL SLIDING BRACKET		1
47	SR061000	HEX SOCKET BOLT	M6x50	1
48	BR000041	RIVET	φ 3.2x6	8
49	SR060200	HEX SOCKET BOLT	M6x10	1
50	135004	LIMPID PIECE		2
51				
52				
53				
54				
55	136008	UPPER WHEEL COVER		1
56	SHO60500	HEX HEAD BOLT	M6x25	2
57	WF061310	FLAT WASHER	M6x φ 13	2
58	135051	BRUSH		2
59	SR060500	HEX SOCKET BOLT	M6x25	1
60	135041	KNOB		2

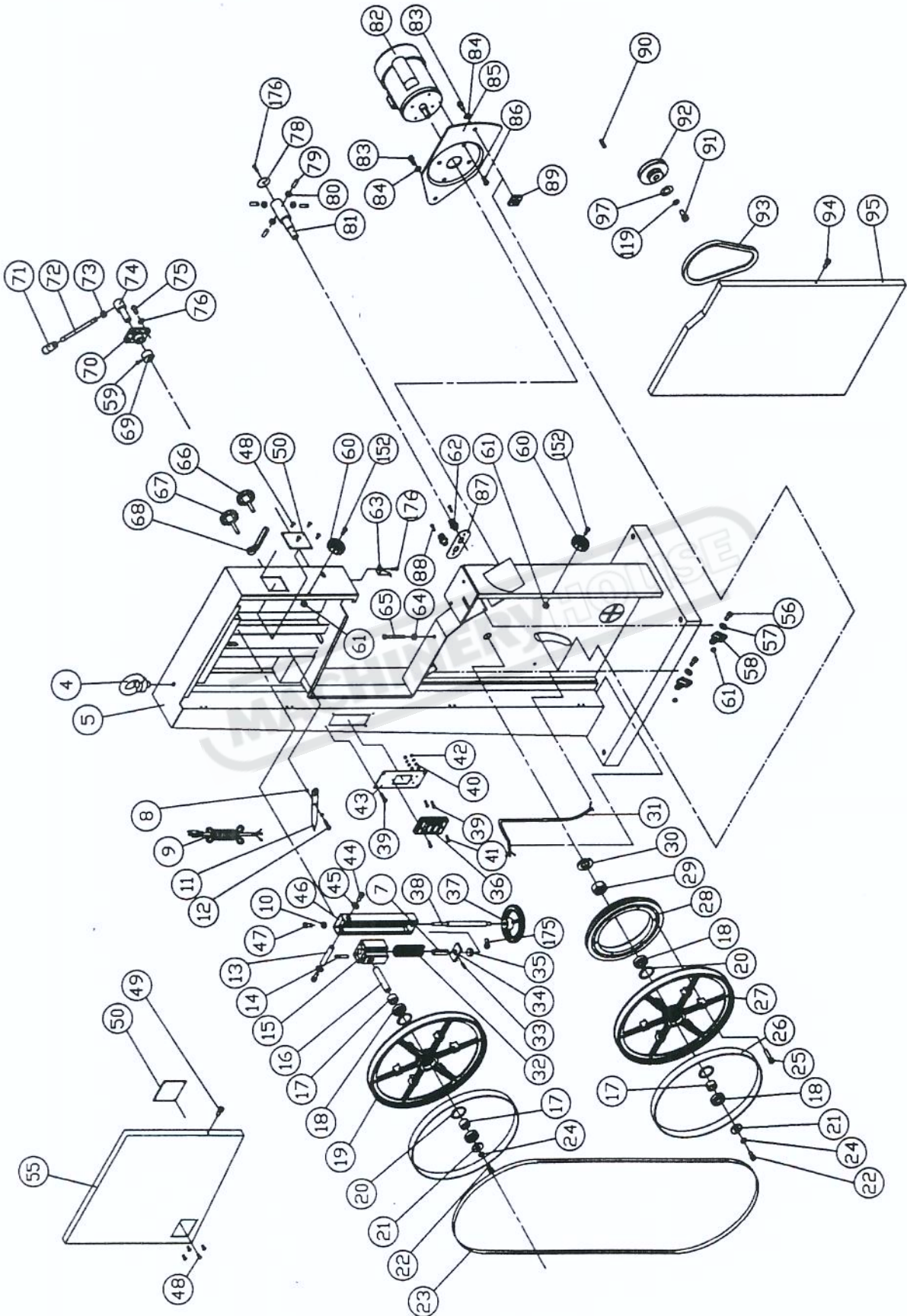
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
61	NL061000	NYLON NUT	M6	4
62	709416	STRAIN RELIEF	M16	2
63	135011	HEIGHT POINTER		1
64	NH081300	NUT	M8	1
65	SH081800	HEX HEAD LOLT	M8x90	1
66	135022	KNOB SCREW		1
67	135020	KNOB SCREW		1
68	135028	LOCATE HANDLE	M10	1
69	135030	CAM		1
70	135038	LOCATE BLOCK		1
71	620021	KNOB		1
72	620020	LEVER ROD		1
73	NH121900	NUT	M12	1
74	135036	SHAFT		1
75	SJ080400	HEX SOCKET BOTTOM HEAD SCREW	M8x20	4
76	WS080000	SPRING WASHER	M8	4
77	WS060000	SPRING WASHER	M6	2
78	135013	COVER		1
79	SS080400	SET SCREW	M8x20	4
80	NH081300	NUT	M8	4
81	135005	LOWER WHEEL SHAFT		1
82	MH135004	MOTOR	1.5 HP	1
83	SR100500	HEX HEAD BOLT	M10x25	2
84	WS100000	SPRING WASHER	M10	2
85	135064	MOTOR BRACKET		1
86	SJ080400	HEX SOCKET BOTTOM HEAD HEAD SCREW	M8x20	4
87	135056	PLATE		1
88	SF050200	PAN HEAD BOLT W/FLANGE	M5x10	2
89	135065	LOCATE BLOCK		1
90	KS050535	KEY	5x5x35	1

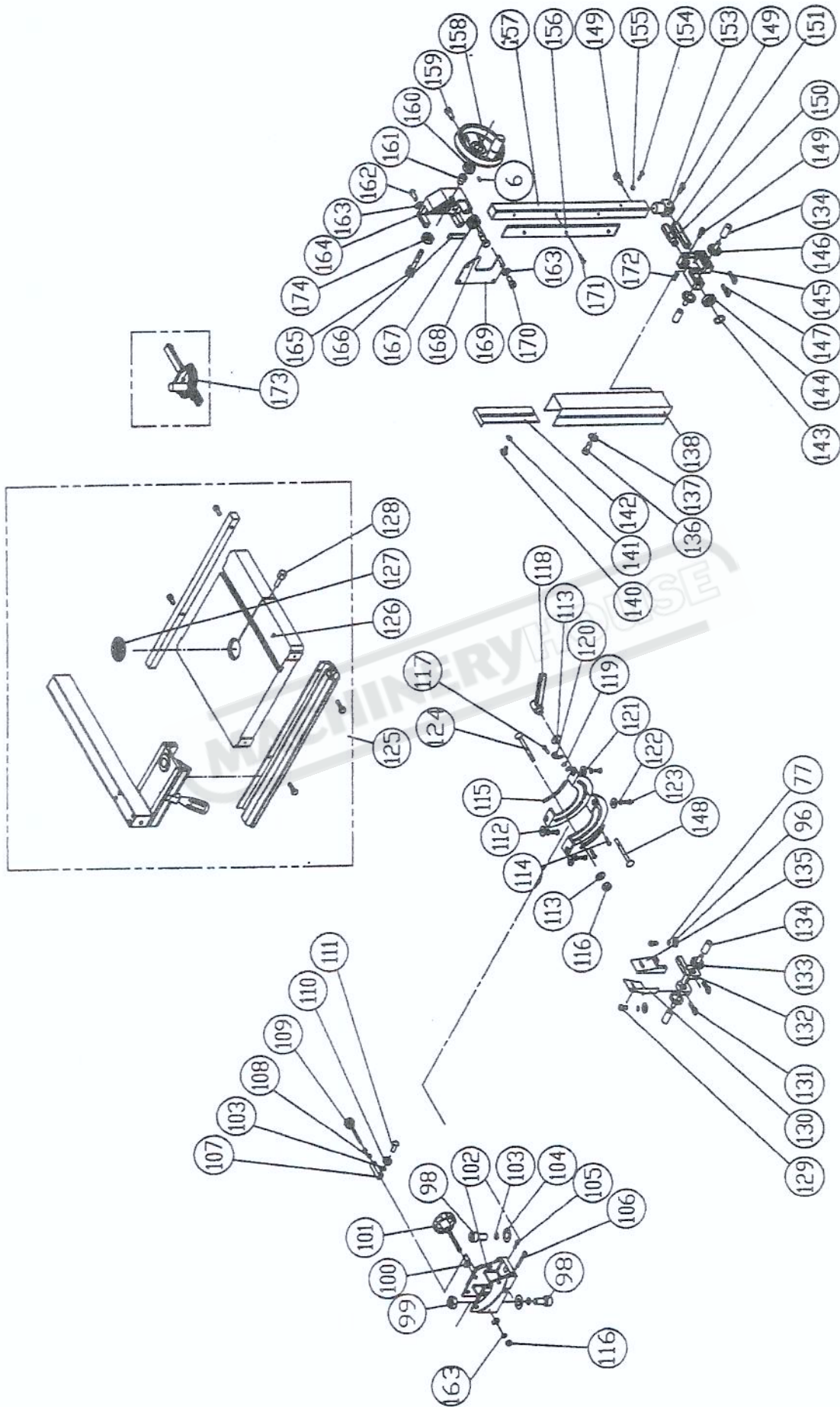
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
91	SH080402	HEX HEAD BOLT	M8x20(L.H)	1
92	135008	MOTOR PULLEY		1
93	LA420000	V-BELT	A42	1
94	SR060200	HEX SOCKET BOLT	M6x10	1
95	136006	LOWER WHEEL COVER		1
96	WF061310	FLAT WASHER	M6x13	2
97	WF083030	FLAT WASHER	M8x30	1
98	SR100700	HEX SOCKET BOLT	M10x35	2
99	NH101700	NUT	M10	1
100	135061	SMALL GEAR		2
101	135063	KNOB SCREW		1
102	135021	TRUNNION SUPPORT BRACKET		1
103	WS100000	SPRING WASHER	M10	3
104	WF102325	FLAT WASHER	M10x φ 23	2
105	SR069400	HEX SOCKET BOLT	M6x16	1
106	SR060900	HEX SOCKET BOLT	M6x45	1
107	135045	ADJUST BLOCK		1
108	NH061000	NUT	M6	2
109	135009	ADJUST BOLT	M6	1
110	BB600002	BALL BEARING	6000ZZ	1
111	SJ100400	HEX SOCKET BOTTOM HEAD SCREW	M10x20	1
112	WF081820	FLAT WASHER	M8x φ 18	4
113	WF081820	FLAT WASHER	M8x φ 18	2
114	SP049100	PAN HEAD BOLT	M4x6	4
115	135052	GEAR PLATE		2
116	NL081300	NYLOW NUT	M8	2
117	SP049100	PAN HEAD BOLT	M4x6	1
118	135044	HANDLE		1
119	WF040808	FLAT WASHER	M4x φ 8	2
120	135078	POINTER		1

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
121	135025	TRUNNION PLATE		2
122	WS080000	SPRING WASHER	M8	4
123	SH089400	HEX HEAD BOLT	M8x16	4
124	SC081600	CARRIAGE BOLT	M8x80	1
125	AB198003	18" FENCE SET		1
	198002	ADJUST BASE		1
	198003	FIXED SHAFT		2
	198004	FIXED LUMP		1
	198005	SHAFT		1
	198006	SPRING PIECE		1
	198007	CONVEX		1
	198008	BRACKET		1
	198010	SPACE BUSHING		2
	198012	ADJUST SCREW		1
	198013	HANDLE		1
	198014	GUARD PIECE		2
	198015	GUARD PIECE		2
	135016	PLUG		2
	198022	FIXED BASE	L-710	1
	198023	SQUARE TUBE	L=710	1
	198024	SUPPORT TUBE	L=640	1
	LM000539	SCALE		1
	SF040200	PAN HEAD BOLT W/FLANGE	M4x10	1
	SH060400	HEX HEAD BOLT	M6x20	2
	SR069400	HEX SOCKET BOLT	M6x16	2
	NH061000	NUT	M6	2
	ST039200	TAPPING SCREW	3.5x8	4
	SF049100	PAN HEAD BOLT W/FLANGE	M4x6	2
	NH081300	NUT	M8	1
	SR061100	HEX SOCKET BOLT	M6x55	4

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
	WS060000	SPRING WASHER	M6	2
126	136004	TABLE	19"x19"	1
127	135010	TABLE INSERT		1
128	100038	TABLE PIN		1
129	SR069100	HEX SOCKET BOLT	M6x6	2
130	135031	LEFT COVER		1
131	150013	THUMB SCREW	M6x16	2
132	135059	LOWER BLADE GUIDE SUPPORT		1
133	135058	GUIDE RING		2
134	135018	LOWER ADJUST SHAFT		4
135	135035	RIGHT COVER		1
136	SR050200	HEX SOCKET BOLT	M5x10	2
137	WF051210	FLAT WASHER	M5x \varnothing 12	2
138	135034	PROTECT COVER (ASM)		1
139				
140	135073	STEP SCREW		1
141	135054	FLAT WASHER		1
142	135037	SLIDING PLATE		1
143	RS150000	RETAINING RING	S15	1
144	BB620202	BALL BEARING	6202ZZ	1
145	135055	UPPER BLADE GUIDE SUPPORT		1
146	135058	GUIDE RING		2
147	150013	THUMB SCREW	M6x16	2
148	SC081700	CARRIAGE BOLT	M8x85	1
149	SR069400	HEX SOCKET BOLT	M6x16	3
150	135053	ADJUST BAR		1
151	135060	UPPER SPACING SLEEVE		1
152	SR060400	HEX SOCKET BOLT	M6x20	2
153	135057	UPPER GUIDE SUPPORT BLOCK		1
154	SP040200	PAN HEAD BOLT	M4x10	1

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
155	NH040700	NUT	M4	1
156	135029	RACK		1
157	135047	UPPER GUIDE TUBE		1
158	135006	HANDLE WHEEL		1
159	SR060400	HEX SOCKET BOLT	M6x20	1
160	135015	LOCATE BUSHING		1
161	135043	BUSHING		1
162	SJ080400	HEX SOCKET BOTTOM HEAD SCREW	M8x20	4
163	WS080000	SPRING WASHER	M8	9
164	135050	GUIDE BRACKET		1
165	135033	WORM CYLINDER		1
166	135062	FIXED PLATE		1
167	135049	GEAR		1
168	016320	FIXED BOLT		1
169	135046	COVER		1
170	SR089400	HEX SOCKET BOLT	M8x16	4
171	SN049200	COUNTER SUNK BOLT	M4x8	3
172	SS069400	SET BOLT	M6x16	1
173	AB198101	MITER GAUGE ASS'Y		1
	198101	GUIDE BAR		1
	198102	GUIDE		1
	198103	POINTER		1
	198104	NYLON WASHER		1
	198105	HANDLE	1/4"	1
	198106	MITER GAUGE BODY		1
	198107	SHAFT		1
	SN069200	COUNTER SUNK BOLT	M6x6	1
	SF059200	PAN HEAD BOLT W/FLANGE	M5x8	1
174	135079	BUSHING		1
175	SR060400	HEX SOCKET BOLT	M6X20	1
176	SF050200	PAN HEAD BOLT W/FLANGE	M5X10	2





Parts List For 19 Inch Band Saw Model No SBW-4800 CE

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
1	130040	SWITCH COVER		1
2	NH040700	NUT	M4	2
3	709416	STRAIN RELIEF	M16	1
4	995101	RING	M10	1
5	136001	MACHINE BODY		1
6	SS050100	SET BOLT	M5X5	2
7	IC135002	SWITCH CORD		1
8	WF061310	FLAT WASHER	M6x ϕ 13	2
9	IC135001	POWER CORD		1
10	NH061000	NUT	M6	1
11	135040	POINTER		1
12	135073	STEP SCREW		1
13	135012	UPPER SHAFT		1
14	PS053500	SPRING PIN	ϕ 5x35	2
15	135017	UPPER WHEEL SHAFT HINGE		1
16	135066	UPPER WHEEL SHAFT		1
17	135039	BUSHING		3
18	BB620403	BALL BEARING	6204LLU	4
19	136002	UPPER WHEEL	ϕ 19"	1
20	RR470000	RETAINING RING	R47	4
21	WF083030	FLAT WASHER	M8x ϕ 30	2
22	SR089400	HEX SOCKET BOLT	M8X16	2
23	136010	SAW BLADE	143"x3/4"X0.5mm	1
24	WS080000	SPRING WASHER	M8	2
25	SR060600	HEX SOCKET BOLT	M6x30	6
26	135048	TIRE		2
27	136003	LOWER WHEEL	ϕ 19"	1
28	135007	IDLE PULLEY		1
29	NH633801	NUT	1"-14 UNF	1
30	WS630000	SPRING WASHER	1"	1

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
31	IM135001	MOTOR CORD		1
32	135032	SPRING		1
33	PS031600	PIN	φ 3X16	1
34	135042	LOCATE BLOCK		1
35	994301	BEARING	51201	1
36	170245	CE SWITCH	JD3	1
37	135002	HANDLE WHEEL		1
38	136007	ADJUSTING BOLT		1
39	SF050200	PAN HEAD BOLT W/FLANGE	M5X10	8
40	WE050000	STAR WASHER	M5	4
41	135067	BUSHING		1
42	NH050800	NUT	M5	4
43	135070	SWITCH PLATE		1
44	SR089400	HEX SOCKET BOLT	M8x16	2
45	WF083030	FLAT WASHER	M8x φ 30	2
46	135016	UPPER WHEEL SLIDING BRACKET		1
47	SR061000	HEX SOCKET BOLT	M5x50	1
48	BR000041	RIVET	φ 3.2x6	8
49	SR060200	HEX SOCKET BOLT	M6x10	1
50	135004	LIMPID PIECE		2
51	SF040600	PAN HEAD BOLT W/FLANGE	M4x30	2
52	136012	DOOR LATCH SWITCH (ASM)		1
53	SF050200	PAN HEAD BOLT W/FLANGE	M5x10	4
54	136009	SWITCH BUSHING		1
55	136005	UPPER WHEEL COVER		1
56	SR060500	HEX SOCKET BOLT	M6x25	2
57	WF061310	FLAT WASHER	M6x φ 13	2
58	135051	BRUSH		2
59	SR060500	HEX SOCKET BOLT	M6x25	1
60	135041	KNOB		2

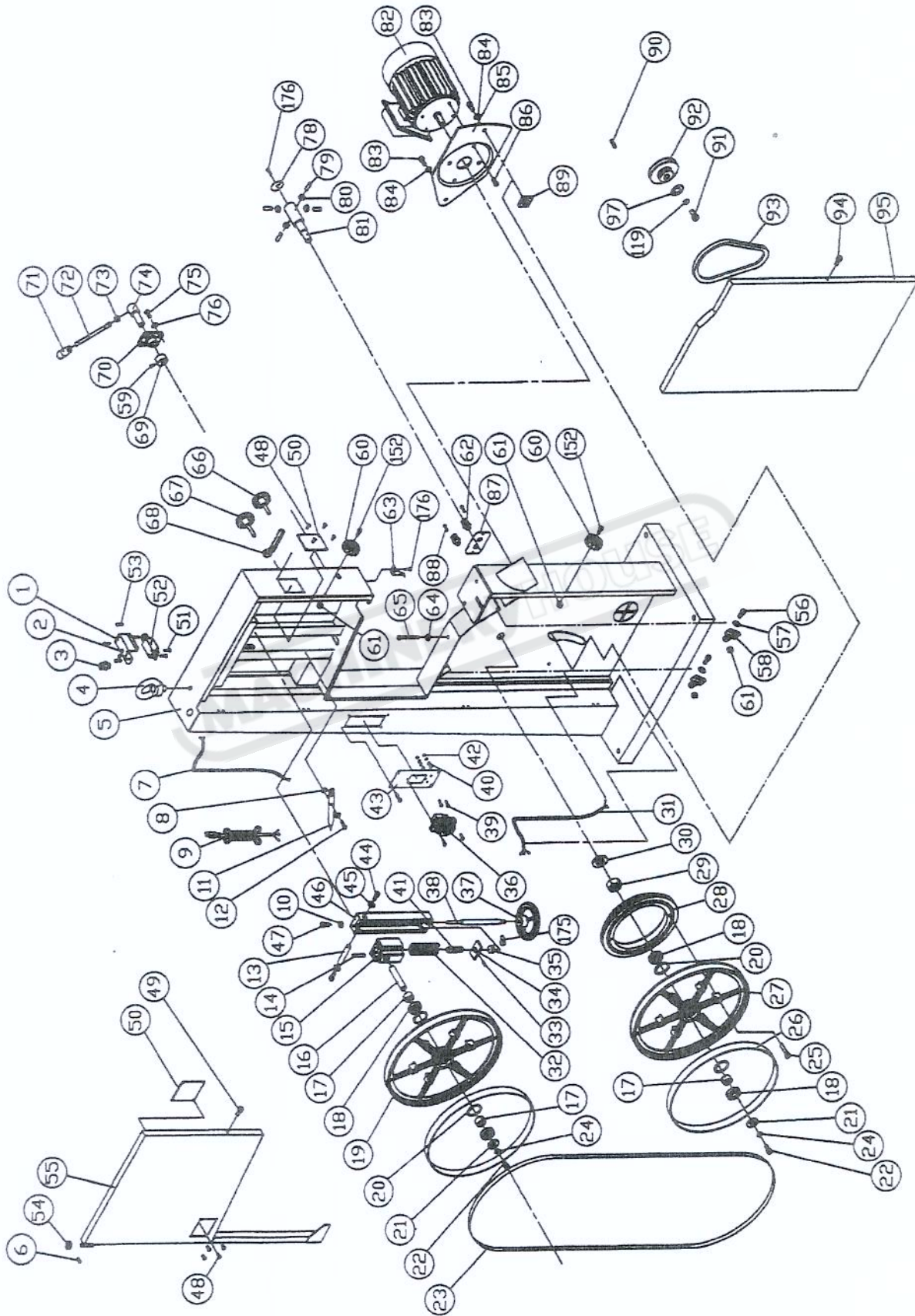
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
61	NL061000	NYLON NUT	M6	4
62	709416	STRAIN RELIEF	M16	2
63	135011	HEIGHT POINTER		1
64	NH081300	NUT	M8	1
65	SH081800	HEX HEAD LOLT	M8x90	1
66	135022	KNOB SCREW		1
67	135020	KNOB SCREW		1
68	135028	LOCATE HANDLE	M10	1
69	135030	CAM		1
70	135038	LOCATE BLOCK		1
71	620021	LEVER ROD		1
72	620020	KNOB		1
73	NH121900	NUT	M12	1
74	135036	SHAFT		1
75	SJ080400	HEX SOCKET BOTTOM HEAD SCREW	M8x20	4
76	WS080000	SPRING WASHER	M8	4
77	WS060000	SPRING WASHER	M6	2
78	135013	COVER		1
79	SS080400	SET SCREW	M8x20	4
80	NH081300	NUT	M8	4
81	135005	LOWER WHEEL SHAFT		1
82	MH135004	MOTOR	1.5 HP	1
83	SR100500	HEX HEAD BOLT	M10x25	2
84	WS100000	SPRING WASHER	M10	2
85	135064	MOTOR BRACKET		1
86	SJ080400	HEX SOCKET BOTTOM HEAD SCREW	M8x20	4
87	135056	PLATE		1
88	SF050200	PAN HEAD BOLT W/FLANGE	M5x10	2
89	135065	LOCATE BLOCK		1
90	KS050535	KEY	5x5x35	1

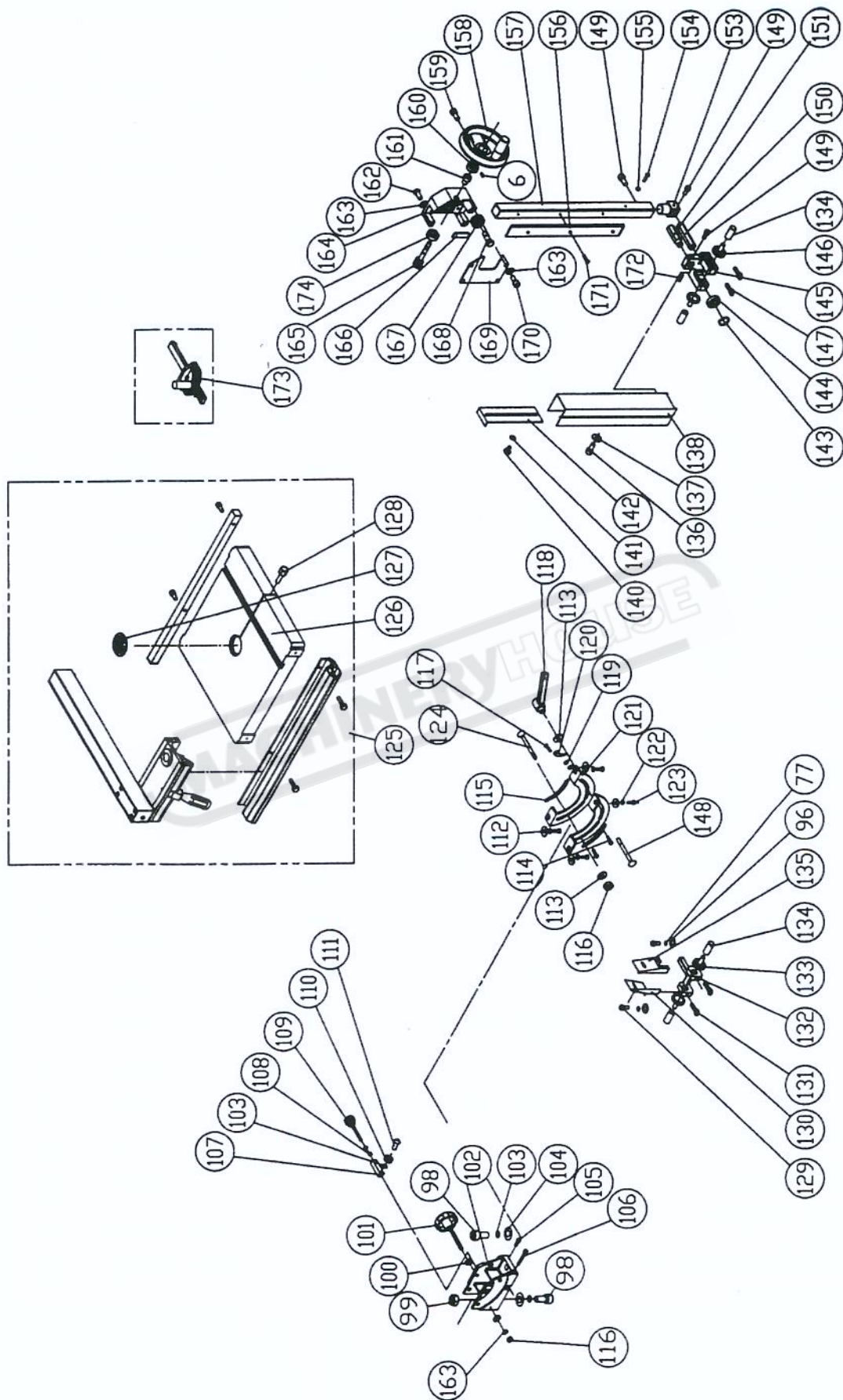
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
91	SH080402	HEX HEAD BOLT	M8x20(L.H)	1
92	135008	MOTOR PULLEY		1
93	LA440000	V-BELT	A44	1
94	SR060200	HEX SOCKET BOLT	M6x10	1
95	136006	LOWER WHEEL COVER		1
96	WF061310	FLAT WASHER	M6x13	2
97	WF083030	FLAT WASHER	M8x30	1
98	SR100700	HEX SOCKET BOLT	M10x35	2
99	NH101700	NUT	M10	1
100	135061	SMALL GEAR		2
101	135063	KNOB SCREW		1
102	135021	TRUNNION SUPPORT BRACKET		1
103	WS100000	SPRING WASHER	M10	3
104	WF102325	FLAT WASHER	M10x \varnothing 23	2
105	SR069400	HEX SOCKET BOLT	M6x16	1
106	SR060900	HEX SOCKET BOLT	M6x45	1
107	135045	ADJUST BLOCK		1
108	NH061000	NUT	M6	2
109	135009	ADJUST BOLT	M6	1
110	BB600002	BALL BEARING	6000ZZ	1
111	SJ100400	HEX SOCKET BOTTOM HEAD SCREW	M10x20	1
112	WF081820	FLAT WASHER	M8x \varnothing 18	4
113	WF081820	FLAT WASHER	M8x \varnothing 18	2
114	SP049100	PAN HEAD BOLT	M4x6	4
115	135052	GEAR PLATE		2
116	NL081300	NYLON NUT	M8	2
117	SP049100	PAN HEAD BOLT	M4x6	1
118	135044	HANDLE		1
119	WF040808	FLAT WASHER	M4x \varnothing 8	2
120	135078	POINTER		1

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
121	135025	TRUNNION PLATE		2
122	WS080000	SPRING WASHER	M8	4
123	SH089400	HEX HEAD BOLT	M8x16	4
124	SC081600	CARRIAGE BOLT	M8x80	1
125	AB198003	18" FENCE SET		1
	198002	ADJUST BASE		1
	198003	FIXED SHAFT		2
	198004	FIXED LUMP		1
	198005	SHAFT		1
	198006	SPRING PIECE		1
	198007	CONVEX		1
	198008	BRACKET		1
	198010	SPACE BUSHING		2
	198012	ADJUST SCREW		1
	198013	HANDLE		1
	198014	GUARD PIECE		2
	198015	GUARD PIECE		2
	198016	PLUG		2
	198022	FIXED BASE	L=710	1
	198023	SQUARE TUBE	L=710	1
	198024	SQUARE TUBE	L=640	1
	LM000539	SCALE		1
	SF040200	PAN HEAD BOLT W/FLANGE	M4x10	1
	SH060400	HEX HEAD BOLT	M6x20	2
	SR069400	HEX SOCKET BOLT	M6x16	2
	NH061000	NUT	M6	2
	ST039200	TAPPING SCREW	3.5x8	4
	SF049100	PAN HEAD BOLT W/FLANGE	M4x6	2
	NH081300	NUT	M8	1
	SR061100	HEX SOCKET BOLT	M6x55	4

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
	WS060000	SPRING WASHER	M6	2
126	136004	TABLE	19"x19"	1
127	135010	TABLE INSERT		1
128	100038	TABLE PIN		1
129	SR069100	HEX SOCKET BOLT	M6x6	2
130	135031	LEFT COVER		1
131	150013	THUMB SCREW	M6x16	2
132	135059	LOWER BLADE GUIDE SUPPORT		1
133	135058	GUIDE RING		2
134	135018	LOWER ADJUST SHAFT		4
135	135035	RIGHT COVER		1
136	SR050200	HEX SOCKET BOLT	M5x10	2
137	WF051210	FLAT WASHER	M5x ϕ 12	2
138	135034	PROTECT COVER (ASM)		1
139				
140	135073	STEP SCREW		1
141	135054	FLAT WASHER		1
142	135037	SLIDING PLATE		1
143	RS150000	RETAINING RING	S15	1
144	BB620202	BALL BEARING	6202ZZ	1
145	135055	UPPER BLADE GUIDE SUPPORT		1
146	135058	GUIDE RING		2
147	150013	THUMB SCREW	M6x16	2
148	SC081700	CARRIAGE BOLT	M8x85	1
149	SR069400	HEX SOCKET BOLT	M6x16	3
150	135053	ADJUST BAR		1
151	135060	UPPER SPACING SLEEVE		1
152	SR060400	HEX SOCKET BOLT	M6x20	2
153	135057	UPPER GUIDE SUPPORT BLOCK		1
154	SP040200	PAN HEAD BOLT	M4x10	1

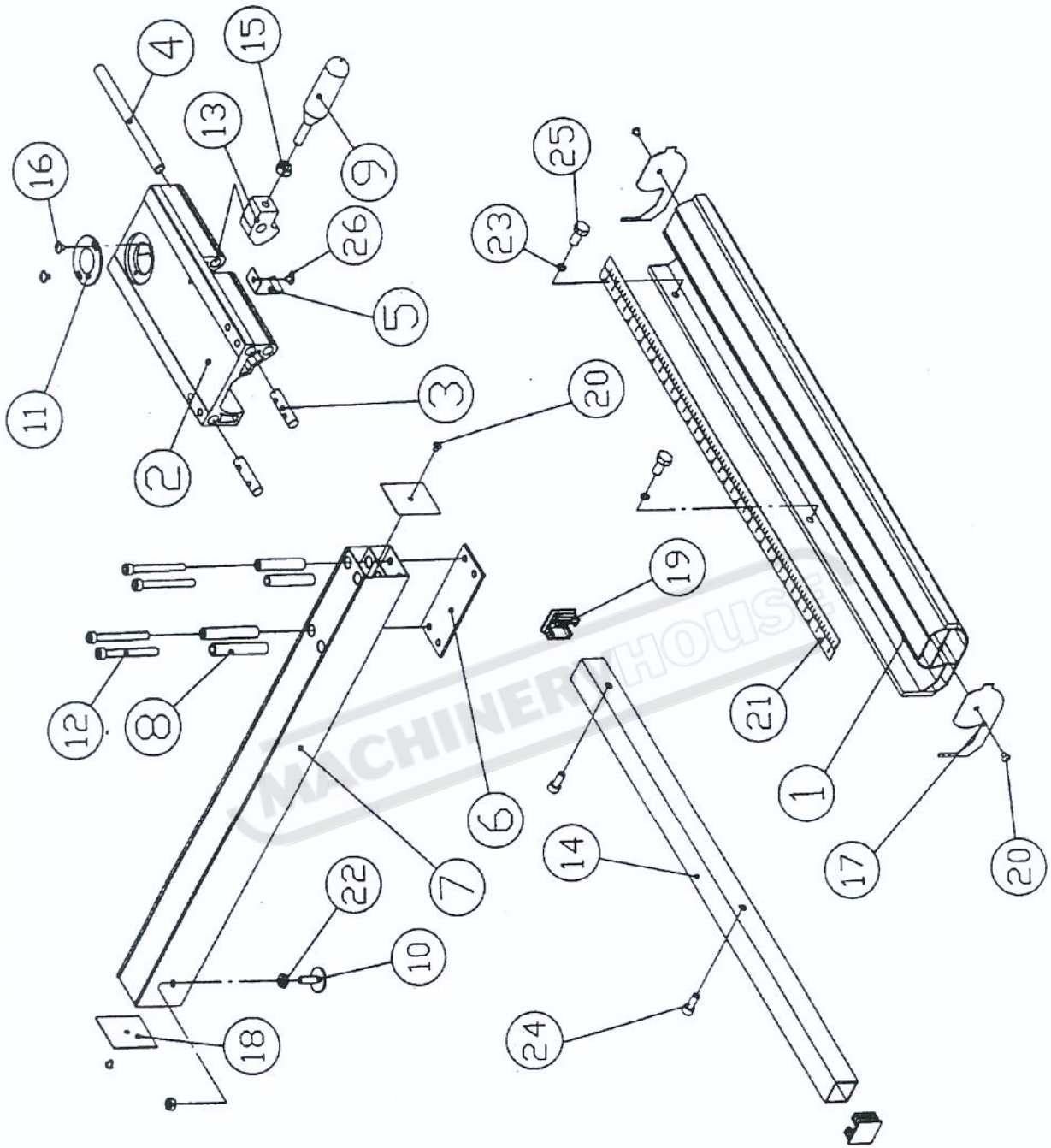
KEY NO.	PARTS NO.	DESCRIPTION	SIZE	QTY
155	NH040700	NUT	M4	1
156	135029	RACK		1
157	135047	UPPER GUIDE TUBE		1
158	135006	HANDLE WHEEL		1
159	SR060400	HEX SOCKET BOLT	M6x20	1
160	135015	LOCATE BUSHING		1
161	135043	BUSHING		1
162	SJ080400	HEX SOCKET BOTTOM HEAD SCREW	M8x20	4
163	WS080000	SPRING WASHER	M8	9
164	135050	GUIDE BRACKET		1
165	135033	WORM CYLINDER		1
166	135062	FIXED PLATE		1
167	135049	GEAR		1
168	016320	FIXED BOLT		1
169	135046	COVER		1
170	SR089400	HEX SOCKET BOLT	M8x16	4
171	SN049200	COUNTER SUNK BOLT	M4x8	3
172	SS069400	SET BOLT	M6x16	1
173	AB198101	MITER GAUGE ASS'Y		1
	198101	GUIDE BAR		1
	198102	GUIDE		1
	198103	POINTER		1
	198104	NYLON WASHER		1
	198105	HANDLE	1/4"	1
	198106	MITER GAUGE BODY		1
	198107	SHAFT		1
	SN069200	COUNTER SUNK BOLT	M6x6	1
	SN059200	PAN HEAD BOLT W/FLANGE	M5x8	1
174	135079	BUSHING		1
175	SR060400	HEX SOCKET BOLT	M6x20	1
176	SF050200	PAN HEAD BOLT W/FLANGE	M5x10	2





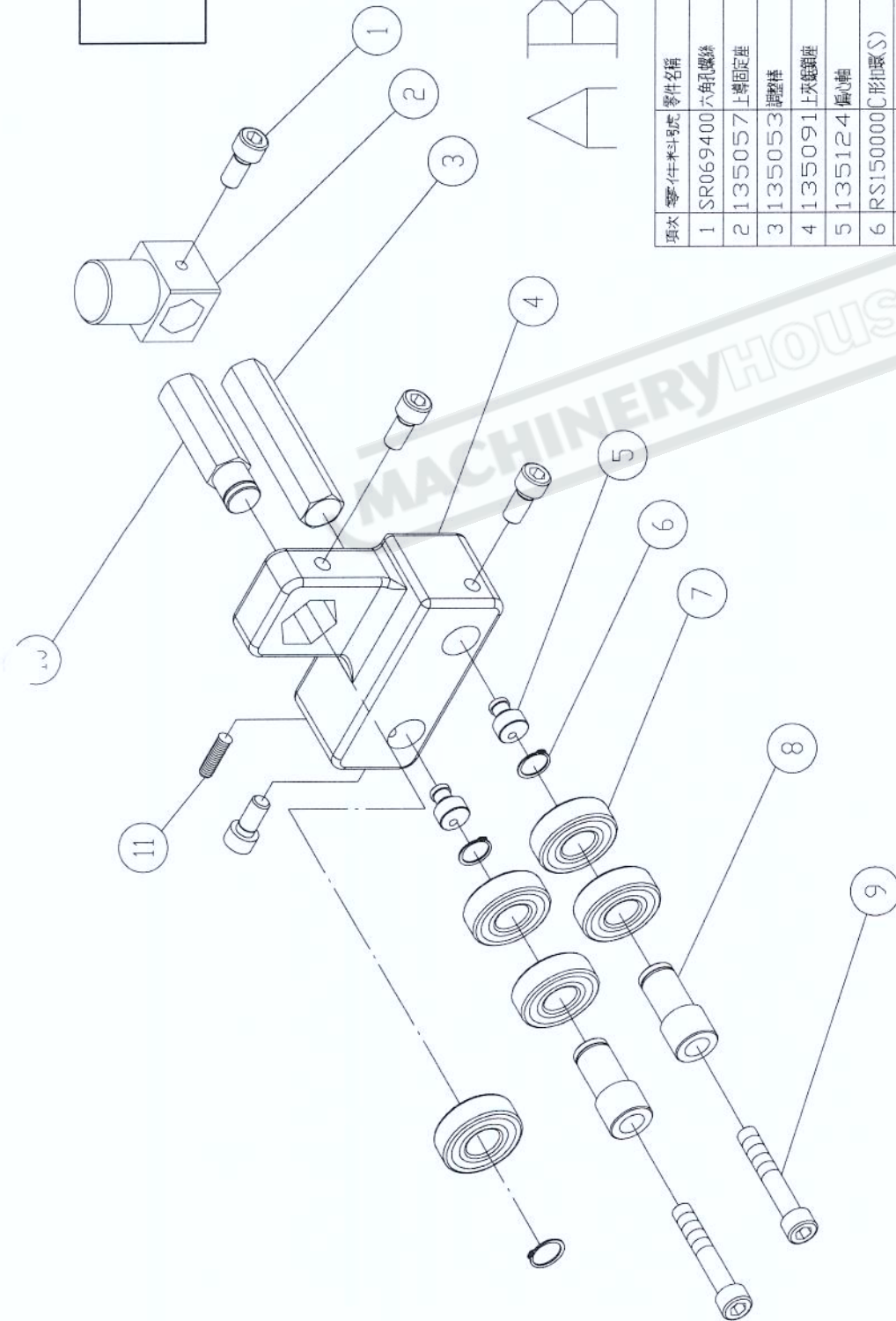
**Parts List For 19 Inch Band Saw
Model No.. QF198003
Rip Fence**

KEY NO.	PARTS NO.	DESCRIPTION	SIZE	Q'TY
1	198022	FIXED BASE	710	1
2	198002	ADJUST BASE		1
3	198003	FIXED SHGAFT		2
4	198005	SHAFT		1
5	198006	SPRING PIECE		1
6	198008	BRACKET	T=3	1
7	198024	SUPPORT TUBE	690	1
8	198010	INTERVAL SHEATH		4
9	198013	HANDLE		1
10	198012	ADJUST SCREW		1
11	198007	CONVEX		1
12	SR061103	HEX SOCKET BOLT	M6x55	4
13	198004	FIXED LUMP		1
14	198023	SQUARE TUBE	710	1
15	NH081300	NUT	M8	1
16	SF049100	PAN HEAD BOLT W/FLANGE	M4x6	2
17	198014	GUARD PIECE		2
18	198015	GUARD PIECE		2
19	198016	PLUGGED		2
20	ST039200	TAPPING SCREW	3.5x8	4
21	LM000539	SCALE		1
22	NH061000	NUT	M6	2
23	WS060000	SPRING WASHER	M6	2
24	SR069400	HEX SOCKET BOLT	M6x16	2
25	SH060400	HEX HEAD BOLT	M6x20	2
26	SF040200	PAN HEAD BOLT W/FLANGE	M4x10	1



TOP GUIDE ASSEMBLY

AB135092

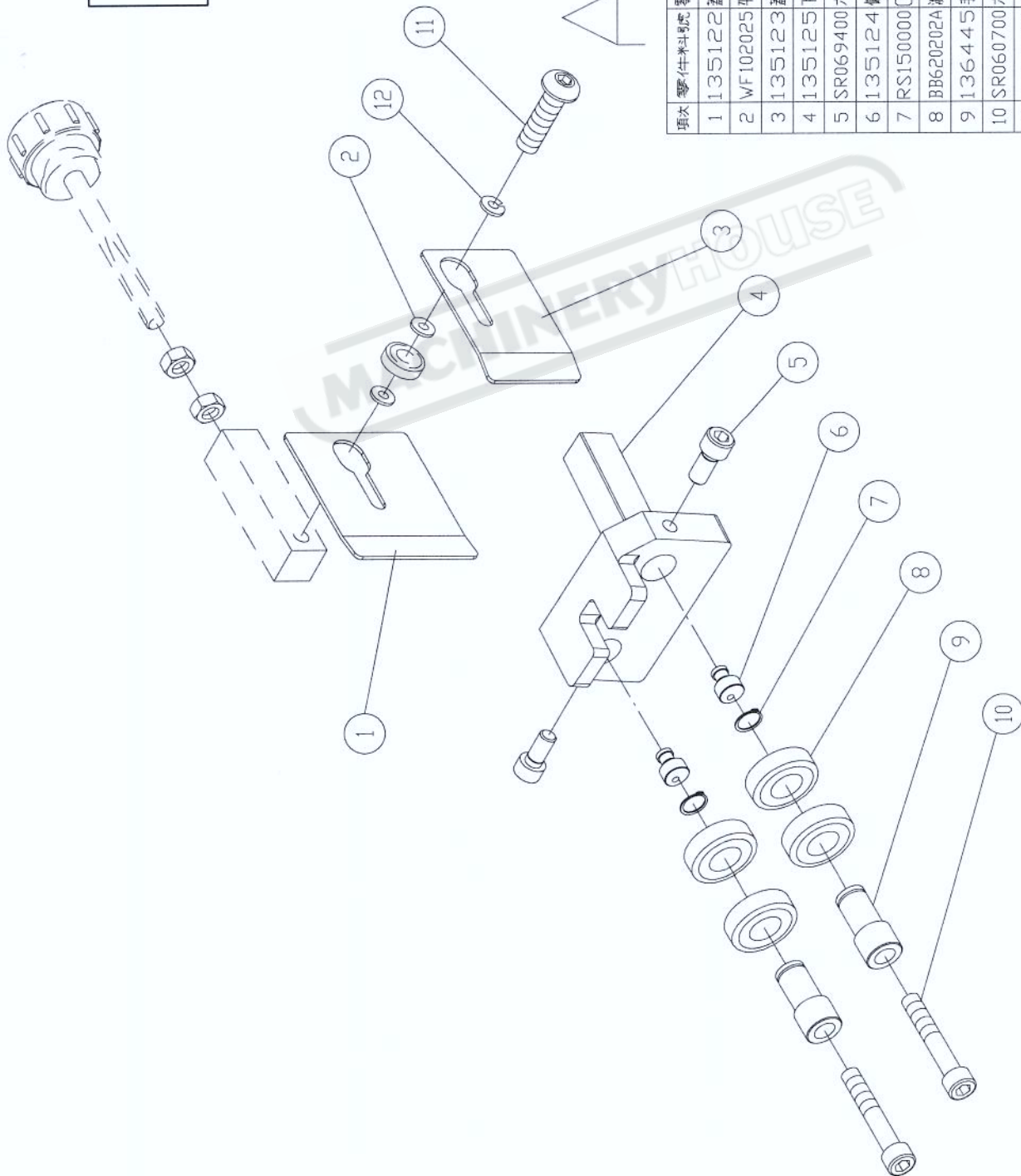


項次	零件料號	零件名稱	PARTS NAME	規格	用量	備註
1	SR069400	六角孔螺絲	HEX SOCKET BOLT	M6x16	4	電黑
2	135057	上導固定座	UPPER GUIDE SUPPORT BLOCK		1	
3	135053	調整棒	ADJUST BAR		1	
4	135091	上夾鐵固定座	UPPER BLADE GUIDE SUPPORT		1	
5	135124	偏心軸	BIAS SHAFT		2	
6	RS150000	C形扣環(S)	ERTAINING RING	S15	3	
7	BB620202A	滾珠軸承	BALL BEARING	6202ZZ	5	
8	136445	手轉套	HANDLE BUSHING		2	
9	SR060700	六角孔螺絲	HEX SOCKET BOLT	M6x35	2	(特)電黑
10	135060	軸承套	UPPER SPACING SLEEVE		1	
11	SS060200	止付螺絲	SET BOLT	M6x10	1	電黑

W433 BP-430 W434 BP-480

NEW BEARING BLADE GUIDES FITTED FROM JULY 2006

BOTTOM GUIDE ASSEMBLY



AB135095

項次	零件半導品號	零件名稱	PARTS NAME	規格	用量	備註
1	135122	蓋板(左)	LEFT COVER		1	
2	WF102025	平華司	WASHER	M10×Ø20	2	電氣(H)
3	135123	蓋板(右)	RIGHT COVER		1	
4	135125	下夾板鎖座	LOWER BLADE GUIDE SUPPORT		1	
5	SR069400	六角孔螺絲	HEX SOCKET BOLT	M6×16	2	電氣
6	135124	偏心軸	BIAS SHAFT		2	
7	RS150000	C形扣環(S)	ERTAINING RING	S15	2	電氣
8	BB620202A	滾珠軸承	BALL BEARING	6202ZZ	4	
9	136445	手轉套	HANDLE BUSHING		2	
10	SR060700	六角孔螺絲	HEX SOCKET BOLT	M6×35	2	(特)電氣
11	SJ100500	六角孔螺絲	HEX SOCKET BOTTOM HEAD SCREW	M10×25	1	電氣(H)
12	WS100000	彈簧華司	SPRING WASHER	M10	1	電氣(H)

W433 BP-430 W434 BP-480

NEW BEARING BLADE GUIDES FITTED FROM JULY 2006