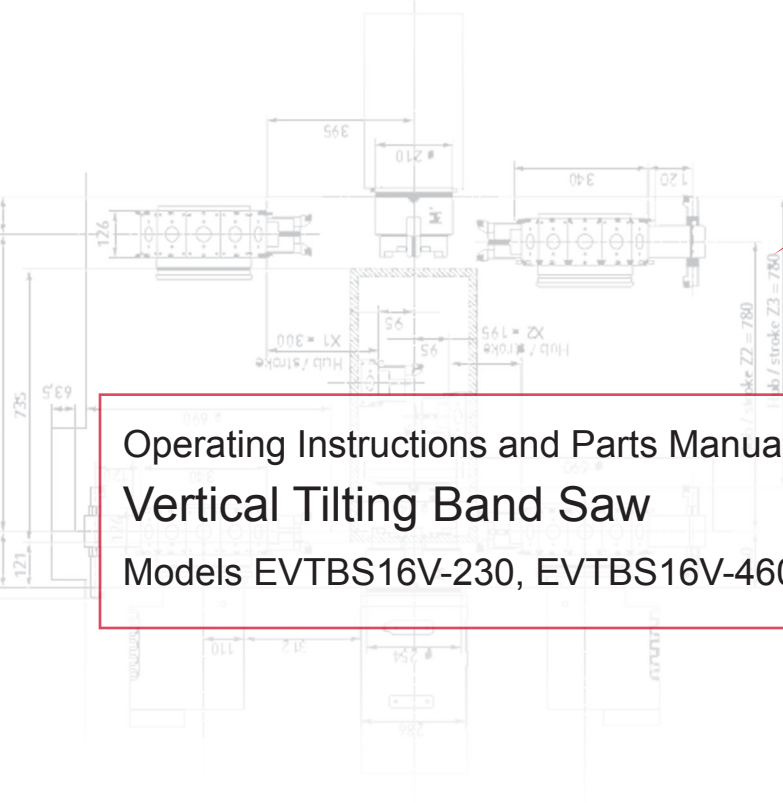




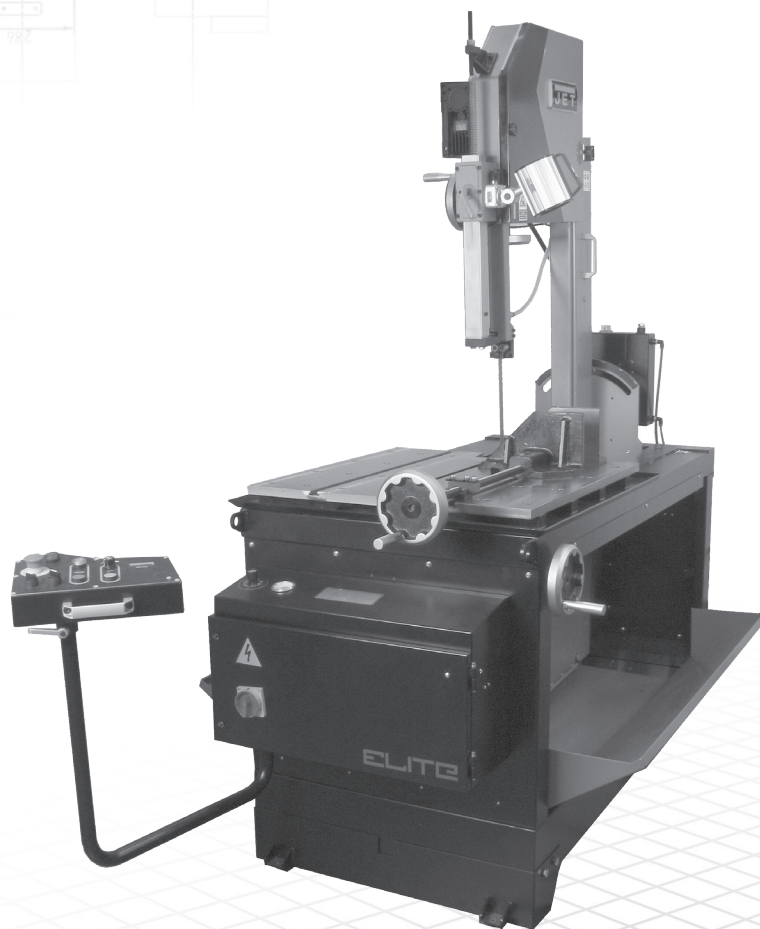
ELITE

HIGH PERFORMANCE MACHINERY

Operating Instructions and Parts Manual

Vertical Tilting Band Saw

Models EVTBS16V-230, EVTBS16V-460



JET®

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Part No. M-891200
EDITION 2 05/2022
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2.0 IMPORTANT SAFETY INSTRUCTIONS

Read and understand the entire instruction manual before operating machine.

This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge has been obtained.

WARNING – To reduce risk of injury:

1. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
2. Replace the warning labels if they become obscured or removed.
3. Do not use this band saw for other than its intended use. If used for other purposes, JET®, disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
4. Always wear approved safety glasses/face shields while using this band saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
5. Before operating this band saw, remove your tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
6. Wear ear protectors (plugs or muffs) during extended periods of operation.
7. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
8. Make certain the switch is in the OFF position before connecting the machine to the power supply.
9. Make certain the machine is properly grounded.
10. Make all machine adjustments or maintenance with the machine unplugged from the power source.
11. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
12. Avoid contact with coolant, especially guarding your eyes.
13. Always keep hands and fingers away from the blade when the machine is running.
14. Never hand hold the material. Always use the vise and clamp it securely.
15. Deburr sharp edges before handling or cutting.
16. Always provide adequate support for long and heavy material.
17. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after maintenance is complete.
18. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. Do not use power tools in damp/wet locations or other dangerous environments. Do not expose them to rain. Keep work area well lit. Provide for adequate space surrounding the work area and non-glare overhead lighting.
20. Keep the floor around the machine clean and free of scrap material, oil and grease.
21. Keep visitors a safe distance from the work area. Keep children away. Workshop should be childproof; padlocks, master switches, remove starter keys.



22. Give your work your undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep the blade sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Maintain proper adjustment of blade tension, blade guides and thrust bearings.
28. Turn off the machine and disconnect from power before cleaning. Use a brush to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Be sure that the blade is not in 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.
32. Adjust upper guide to clear workpiece. Hold workpiece firmly against the table.
33. Direction of feed — feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
34. Installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.
35. Do not remove jammed pieces until blade has stopped.
36. Do not bypass or defeat safety interlock systems.

⚠ WARNING: This product can expose you to chemicals including titanium dioxide which is known to the State of California to cause cancer, and lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

⚠ WARNING: Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated lumber

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as dust masks that are specifically designed to filter out microscopic particles. For more information go to <http://www.p65warnings.ca.gov/> and <http://www.p65warnings.ca.gov/wood>.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠ WARNING

This means that if precautions are not heeded, it may result in serious or even fatal injury.

2.1 Warning Labels



Replace warning labels if they become obscured or removed.

- Keep hands and other body parts away from a running blade.
- Do not open the blade cover while machine is running.
- Do not store combustible materials near or around machine.
- Always wear approved safety glasses/face shields while using this machine.
- Keep machine guards in place at all times.
- Do not wear gloves.
- Remove loose clothing and confine long hair.
- Keep the work area clean and free of miscellaneous objects.



3.0 INTRODUCTION

This manual is provided by JET® covering the safe operation and maintenance procedures for a JET Model EVTBS16V Tilting Band Saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com/us/en/elite.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

Mail in the provided registration card, or register online:

<http://www.jettools.com/us/en/service-and-support/warranty/registration/>

NOTE: Illustrations in this manual may not always show your exact model.

4.0 SPECIFICATIONS

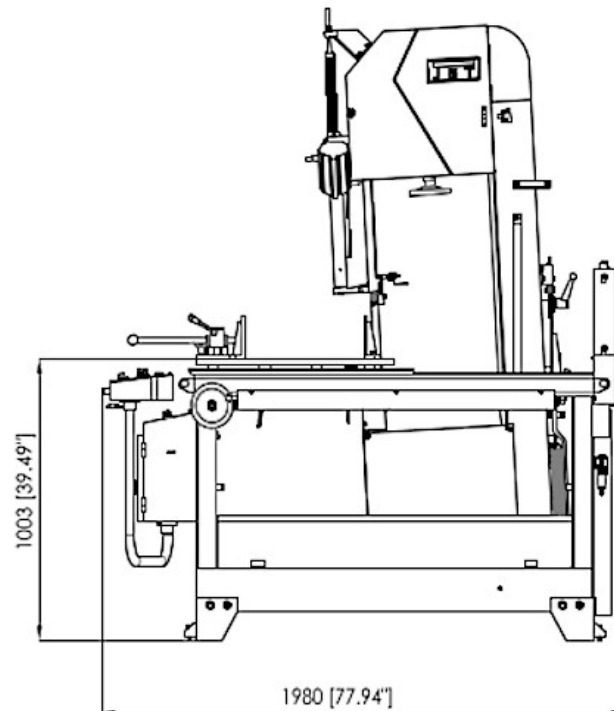
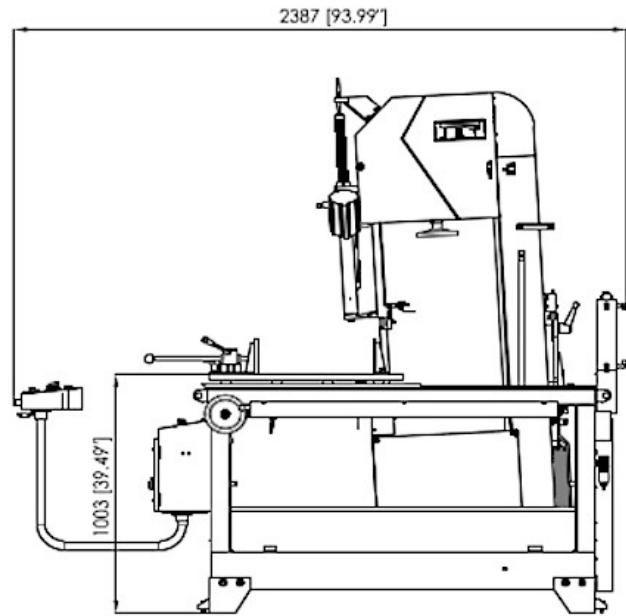
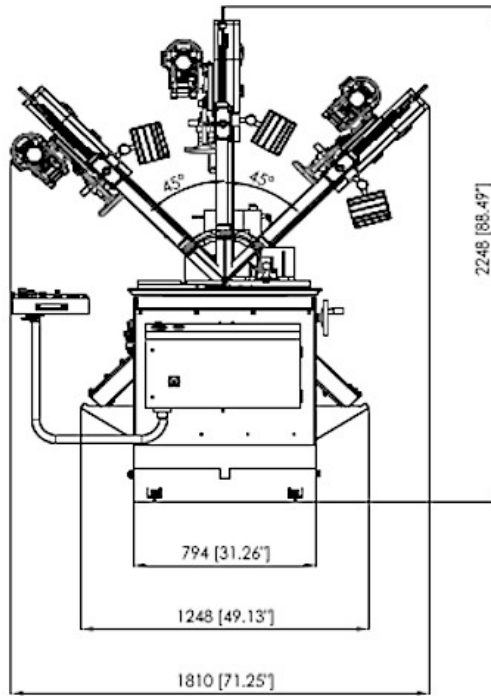
Model Number		EVTBS16V-230	EVTBS16V-460
Stock Number		891200	891210
Motor and Electricals			
Main motor type		Totally enclosed, fan-cooled, AC induction	
Horsepower		2 HP (1.5kW)	
Phase		3 phase	
Voltage		rewired 230V	rewired 460V
Cycle		60 Hz	
Listed FLA (full load amps)		6.5 A	3.25 A
Starting amps/inrush current		23 A	12.5 A
Running amps, no load		1.1 A	0.6 A
Motor speed		1720 RPM	
On/off switch		magnetic, pushbutton with E-stop	
Power transfer		Gear reducer	
Gearbox ratio		1:30	
Power cable		(unattached) 14AWGx3C, 6 ft., no plug	
Recommended circuit size		15 A	
Sound emission		70 dB at 3 ft. from machine	
Coolant pump		32W, 230V 1PH, 2P, 2800RPM, 0.25A	
Capacities			
Round	90 deg.	16 in. (406mm)	
	45 deg. (R)	13-1/4 in. (337mm)	
	45 deg. (L)	11-1/2 in. (292mm)	
Square (WxH)	90 deg.	16 x 16 in. (406 x 406mm)	
	45 deg. (R)	13-1/4 x 13-1/4 in.(337 x 337mm)	
	45 deg. (L)	11-1/2 x 11-1/2 in. (292 x 292mm)	
Rectangle (WxH)	90 deg.	20 x 16 in. (508 x 406mm)	
	45 deg. (R)	13-1/4 x 16 in.(337 x 406mm)	
	45 deg. (L)	11-1/2 x 16 in. (292 x 406mm)	
Blade (WxTxL)		1-1/16 x 0.035 x 168-1/2" 4/6T Lenox	
Blade wheel size (Dia. x W)		18.11"(460mm)	
Blade speed (SFPM)		variable within 76~430	
Cutting fluid/coolant tank		60 L	
Main materials			
Stand		Steel	
Bow		Steel	
Blade wheels		Cast iron	
Bed		Cast iron	
Vise jaws		Cast iron	



	EVTBS16V-230	EVTBS16V-460
General dimensions		
Height of bed from floor	39-3/8”(1000mm)	
Overall dimensions (LxWxH)	94.5 x 49.2 x 90.55 in. (2400 x 1250 x 2300mm)	
Shipping dimensions (LxWxH)	83.5 x 38.18 x 92.91 in. (2120L x 970W x 2360Hmm)	
Weights		
Net weight (approx.)	1408 lbs (640kg)	
Shipping weight (approx.)	1584 lbs (720kg)	

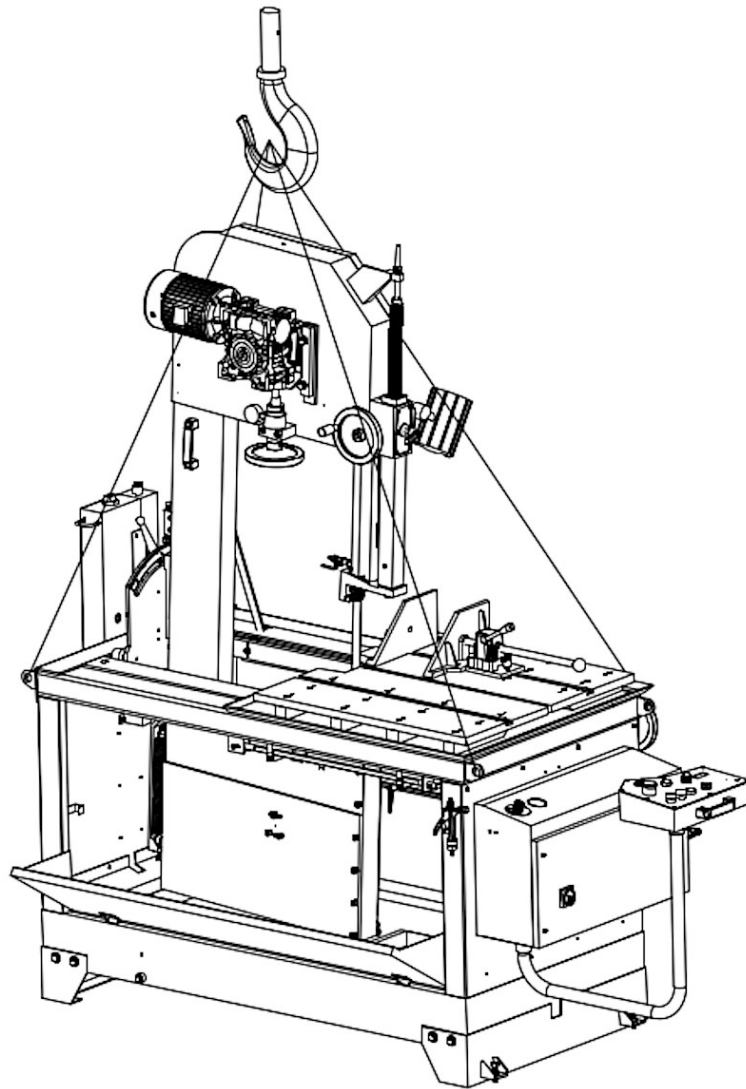
The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET®, reserves the right to change specifications at any time and without prior notice, without incurring obligations.

5.0 MACHINE DIMENSIONS



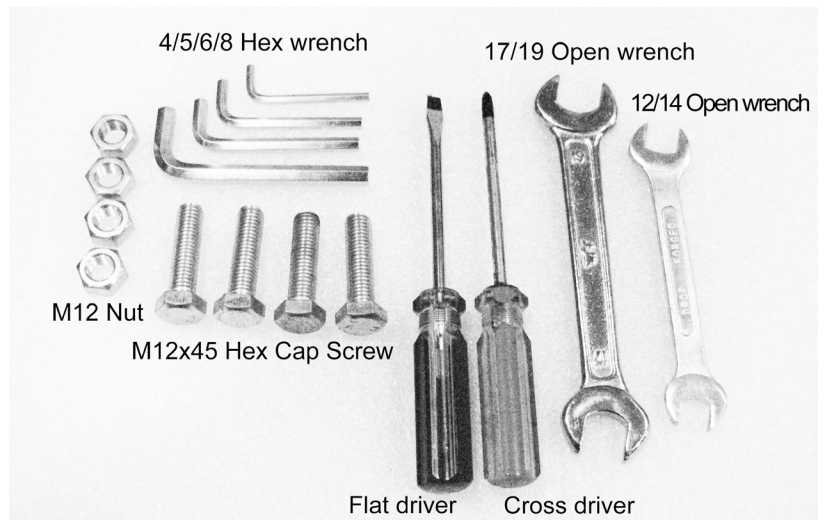
6.0 MACHINE TRANSPORT

Note: DO NOT use alternate lift points.



6.1 Shipping Contents

Item	Description
Cross driver	1 piece
Flat driver	1 piece
17/19 Open wrench	1 piece
12/14 Open wrench	1 piece
4/5/6/8 Hex wrench	1 piece
M12x45 Hex Cap Screw	4 pieces
M12 Nut	4 pieces



7.0 SPOTTING AND INSTALLATION

Note: Read and understand the entire manual before attempting setup or operation.

1. Finish uncrating the saw and inspect for damage. Should any damage have occurred, immediately contact your local distributor and shipping agent.
2. Remove the four (4) nuts and washers holding the band saw to the pallet.
3. Use the four lifting rings to lift the band saw to its permanent location. See section 6.0. For best performance, the machine should be located on a solid and level concrete foundation. Allow room for servicing and for moving large stock around the band saw when deciding a location for the machine.
4. Attach the base frame cover (Fig. 1). Install the M12 nuts (4pcs). Install the hex head screws and flat washers into the saw base, then tighten using a 19mm wrench.

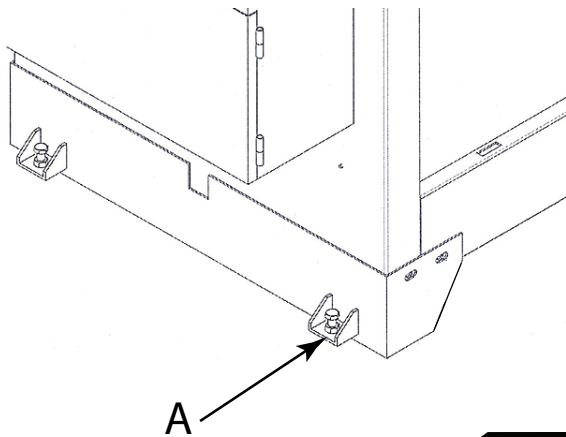


Fig. 1

5. To level the machine, place a level on the table and observe in both directions.
6. Anchoring the machine to the concrete floor is highly advised (B, Fig. 1A).
7. An alternative to anchoring is to use metal plates or shims. Use a metal shim under each leveling bolt (Fig. 1A).
8. To level, adjust the bolts on each corner (A, Fig. 1) until the unit is level in both directions. Tighten the jam nuts against the mounting foot.

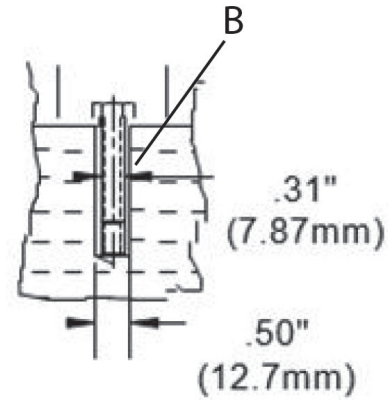


Fig. 1A

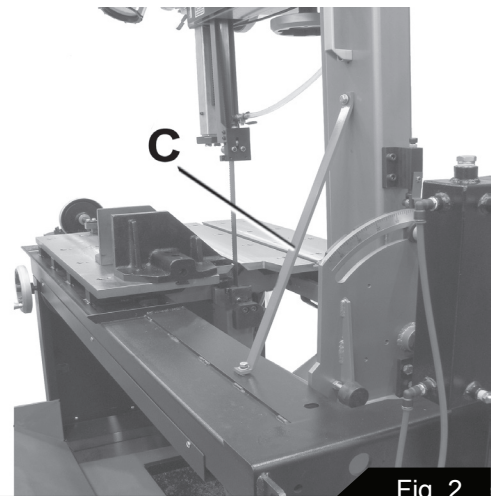


Fig. 2

9. Remove the red shipping bracket (C, Fig. 2).
10. Loosen the two (2) set screws underneath the table preventing the carriage from sliding during shipment (D, Fig. 3). Loosen these with a 6mm hex wrench.
11. Remove any preservatives from exposed metal surfaces with a cleaner/degreaser. Do not use gasoline, paint thinner, or any cellulose-based product, as these will damage painted surfaces.

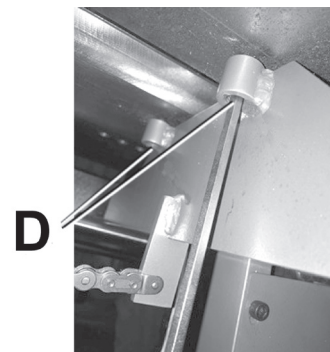
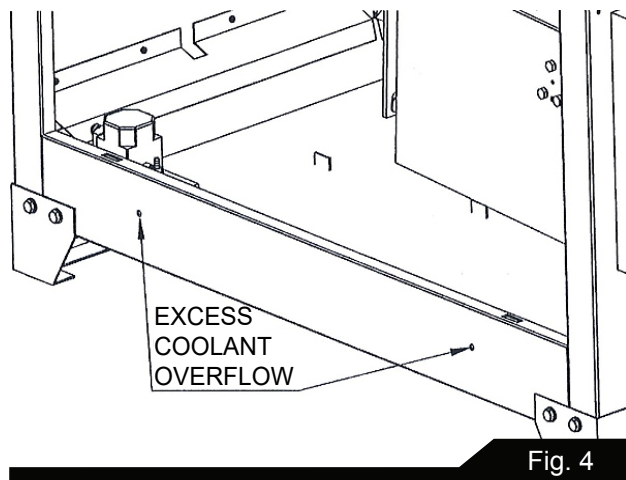


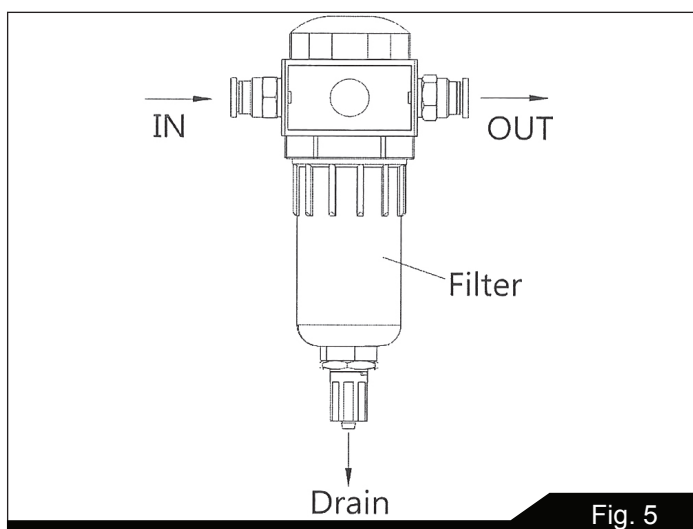
Fig. 3

7.1 Equipment Setting

1. Fill the coolant reservoir with 18 gallons of the appropriate coolant.



2. A compressed air line should be connected to the filter at the back of the saw (Fig. 5).
3. Use clean dry air regulated from 0.5 – 1.0CFM @ 80 – 100psi (.55 – .69MPa), supply air to the air filter through the 1/4" NPT inlet port.
4. Drain any accumulated moisture within the filter at least monthly.
5. Reference section 17.0, *Pneumatics / Hydraulics* for the compressed air diagram.



8.0 ELECTRICAL CONNECTIONS

WARNING

All electrical connections must be done by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent serious or fatal injury.

The EVTBS16V is wired for 3-phase, 230V, or 3-phase 460V, depending on your model.

This tool should be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. The band saw must be grounded. A qualified electrician can make the proper electrical connections and confirm that the power on site is compatible with the saw.

Before connecting to the power source, make sure the switch is in the OFF position.

8.1 Three-Phase Test Run

After wiring the band saw, you should check that the wires have been connected properly. Connect the machine to the power source and turn it on for an instant to watch the direction of the blade movement.

If the blade runs upward instead of downward, disconnect the machine from the power, and switch any two of the three leads in the motor junction box (see section 16.0, *Wiring Diagram*).

9.0 CONTROL PANEL DESCRIPTION

Reference Figure 6

A: EMERGENCY STOP SWITCH:

Press to immediately stop all machine functions. To restart machine, twist it clockwise (CW) until the button disengages.

B: LIGHT SWITCH:

Turn work light on and off.

C: COOLANT SWITCH:

Turn arrow to "I" to turn on coolant flow. Turn arrow to "O" to stop coolant flow.

D: STOP BUTTON:

Press to stop band saw blade.

E: BLADE FEED SWITCH:

Press the switch to follow blade feed action.

F: BLADE SPEED READOUT:

Identifies blade speed in surface feet per minute.

G: BLADE SPEED CONTROL KNOB:

Turn this knob clockwise (CW) to increase blade speed.

H: START BUTTON:

Press to start band saw blade.

I: POWER INDICATOR LIGHT:

Illuminates whenever machine is powered On.



Fig. 6

10.0 SET UP AND OPERATION PREPARATIONS

⚠ WARNING

All adjustments or repairs to machine must be done with power off and machine disconnected from power source. Failure to comply may cause serious injury.

10.1 Blade Installation

1. Make certain the cutting head is locked in the vertical position.
2. Unlock the clamps on both the upper and lower blade wheel housings and open the covers.
3. Uncoil a blade. Route the blade around the blade wheels, through each of the guards, and through both blade guide assemblies.
4. Slide the blade on the wheels so the back edge of the blade is approximately 1/32" from the back flange of the wheel. Check the teeth on the portion of the blade between the upper and lower blade guides to see that they point down toward the table (Fig. 7).
5. Tension the blade by turning the tension handle counterclockwise (CCW). (The factory set is 1400 kgs/cm2.) Before proceeding, make sure all guards and covers are in place and secured.

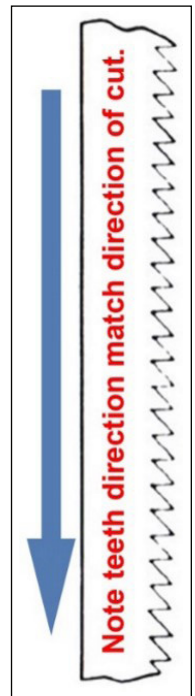


Fig. 7

6. Turn the feed force to "0". Push the START button on control panel and let the blade spin several times around the blade wheels.
7. Push the STOP button on the control panel. Check to see if the back edge of the blade has maintained an approximate 1/32" gap from the flange on the back of blade wheels. If the blade rides against the flange or is more than 1/32" away from the flange, adjust the lower wheel tilt angle as follows (use hex wrenches to adjust the three M10 set screws).
8. Once the blade has been installed, tensioned and tracked properly on the wheels, close the upper and lower covers. Lock the clamps and secure all guards in place.

10.2 Blade Tracking Adjustment

Typically, the blade should track with the back edge of the blade maintaining an approximate 1/32" gap from the flange on the back of blade wheels.

1. Loosen the three (3) hex head mounting bolts (A, Fig. 8) on the back side of the lower wheel housing 1 to 1-1/2 turns.
2. Adjust the set screw (B, Fig. 8) to change the tracking of the blade.
3. When the tracking is correct, evenly tighten the three (3) hex head screws.
4. Check the tracking again.

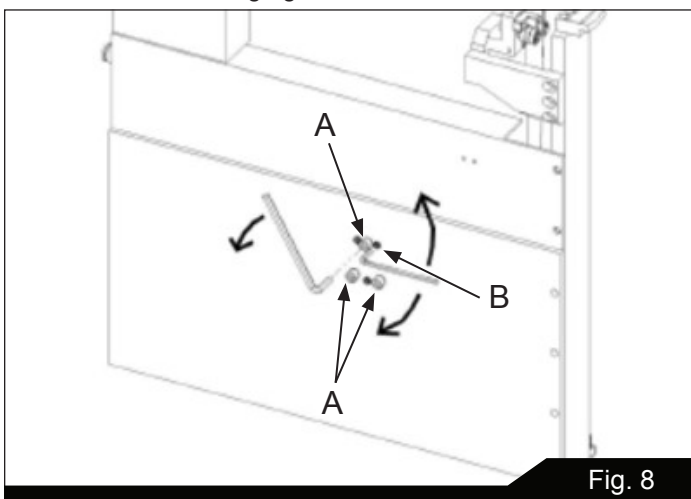


Fig. 8

10.3 Head Tilt Adjustment

1. The cutting head is adjustable to make angled cuts from -45° to $+45^{\circ}$. Be sure the upper blade guide will clear any obstructions on the table before adjusting the cutting head angle.

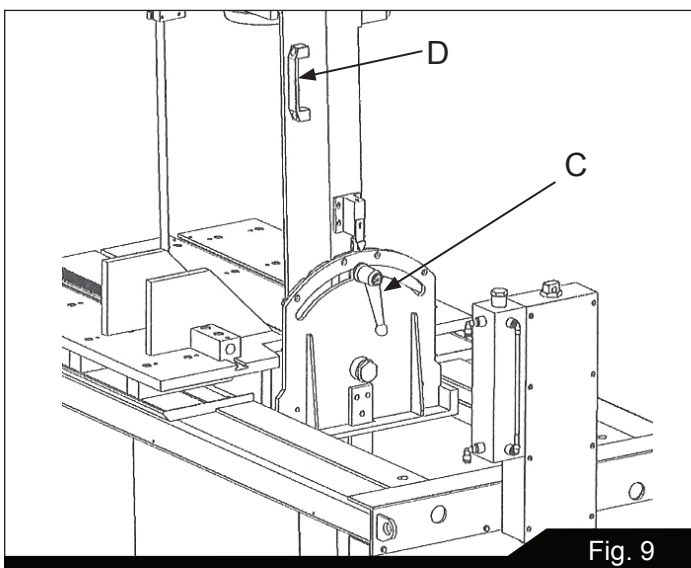


Fig. 9

2. To adjust the cutting head angle, turn the lock handle counterclockwise (CCW) (C, Fig. 9).
3. Holding the cutting head handle, tilt the head to desired angle (D, Fig. 9).
4. When the desired angle is obtained, turn the lock handle clockwise (CW) to secure the cutting head for operation.

10.4 Vise Plate Positioning

Reference Figures 10 and 11.

The vise system consists of two (2) interchangeable vise plates and a quick clamp. One vise plate is mounted as the stationary (rear) vise plate (E) and the other is mounted as the movable (front) vise plate (F). The quick clamp is mounted in the T-slot inline with and attached to the front vise plate.

The vise plates may be mounted on either side of the blade and with either the square or angled edge toward the blade. The quick clamp is moved to align with the plate which is being used as the movable (front) plate.

The following gives only one example of how the vise plates can be mounted to the saw table.

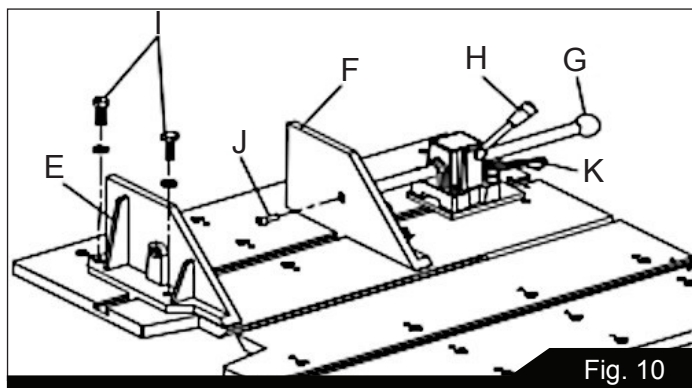


Fig. 10

1. Place the rear vise plate in the T-slot and at a position on the table so that the hold down bolts (I) are aligned with the threaded mounting holes in the tabletop.
2. Use a hex key to secure the rear vise plate to the tabletop with the hold down bolts (I).
3. Place the front vise plate in the T-slot, opposite the rear vise plate. This will be vise plate flat surface to flat surface.
4. Place the quick clamp assembly into the T-slot aligned with the front vise plate with the flat threaded end against the vise plate and the ball knob (G) outward for the operator. This assembly may be positioned as needed to allow for clamping and releasing the vise plate.
5. Insert the M8 x25 socket head screw (J) through the plate and into the slide bar for the quick clamp.

6. The lock handle (K, Fig. 10) secures the clamp assembly to the table T-slot.
7. Pulling the release handle (H, Fig. 10) unlocks the slide bar, allowing the front plate to be moved to clamp or unclamp the material. Pushing the release handle forward presses the slide bar forward slightly, locking the slide bar.

⚠ CAUTION

The lock handle (K) must be tight and the workpiece clamped with the release handle (H) locked during any cutting to prevent unintended movement.

8. Figure 11 shows an optional clamping procedure to use when working with large diameter pieces. Use the vise plates to support and align the workpiece. Then use the ratchet straps (L, Fig. 11) hooked on the edge of the table to secure the workpiece and prevent unintended movement.

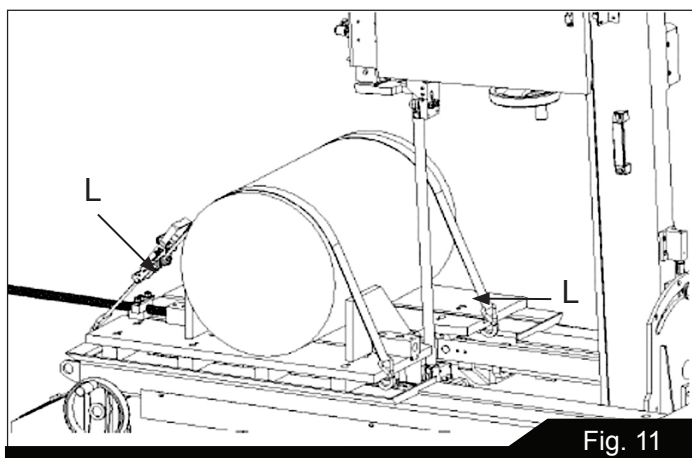


Fig. 11

10.5 Feeding Stroke

Reference Figures 12, 13, and 14.

11.5.1 Saw Head Movement - Manual

The cutting head can be fed forward or backwards manually by rotating the feed handle (M, Fig. 12) counterclockwise (CCW) or clockwise (CW), respectively.

10.5.2 Saw Head Movement - Automatic

1. The saw also can be fed forward automatically by adjusting the feed force. Pull upward on the knob (N, Fig. 13) and rotate clockwise (CW) or counterclockwise (CCW) until the desired feed is obtained.
2. Observe the chips to determine when the feed is correct.
3. Press down on the adjustment knob to lock the setting.

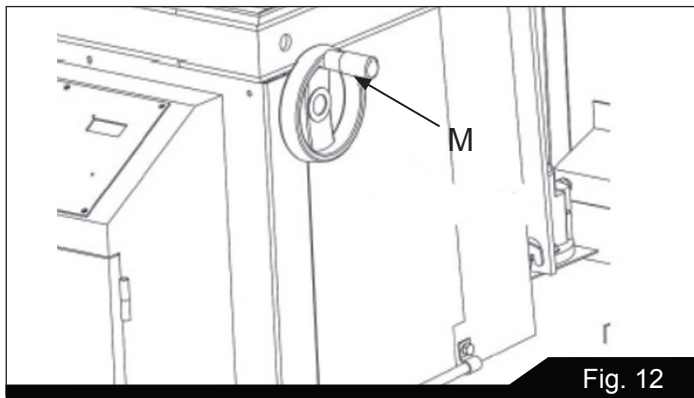


Fig. 12

10.5.3 Saw Head Movement - Travel Limits

1. The travel stops are generally used when cutting multiple pieces to the same length.
2. The contact block (O, Fig. 14) contacts and actuates the travel limit switches.
3. The retract travel stop (P, Fig. 14) is set at the factory and is not normally adjusted.
4. The forward stop (Q, Fig. 14) should be adjusted about 1/8" - 1/4" past the point where the blade exits a cut.

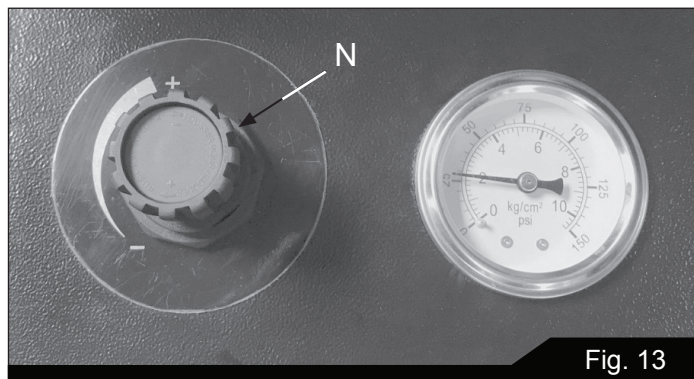
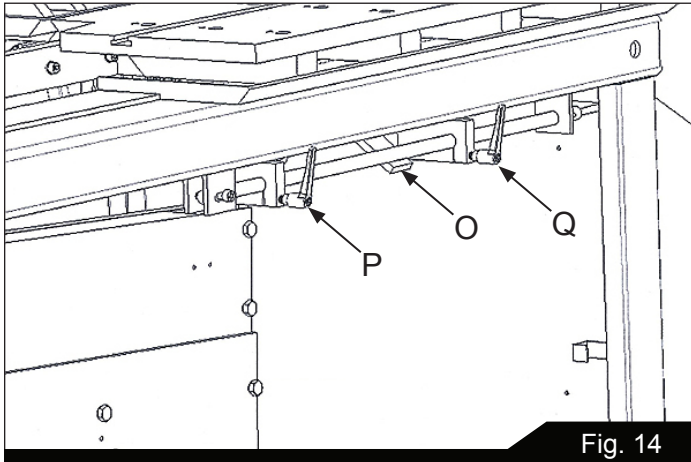


Fig. 13

To adjust:

1. Loosen the forward travel adjustment handle (Q, Fig. 14) and slide the adjustment block forward to allow the saw head to travel forward to simulate the complete cut plus 1/8" - 1/4".
2. Using the manual saw head feed handwheel, move the saw head forward until the teeth of the blade are forward far enough to have cut the material plus 1/8" - 1/4". This will ensure that the material is cut complete.



3. Hold the saw head in this position and slide the forward stop back until it firmly contacts the contact block.
4. During normal cutting, when the contact block (O, Fig. 14) contacts the forward stop (Q, Fig. 14), the cutting head will automatically stop its forward movement, the blade will shut off, and the saw head will retract to the start position.
5. The retract stop should be adjusted so that the saw head stops at a position that has the blade retracted out of the cut area and before it reaches the full retracted physical limits.

10.6 Blade Speed Adjustment

1. Always set the feed force to "0" before adjusting the blade speed.
2. Push the START button on the control panel.
3. If the carriage still moves forward, adjust the feed force knob counterclockwise (CCW) until it remains stationary.
4. Push the STOP button. You are now ready to adjust the blade speed.
5. The blade speed readout on the control panel displays the blade speed in surface feet per minute. Choice of blade speed depends on the type and thickness of metal being cut. Reference Table 1 for the recommended blade speeds.

6. Push the START button on the control panel. Twist the blade speed control knob clockwise (CW) to increase the blade speed, counterclockwise (CCW) to reduce blade speed.
7. Once the proper blade speed is obtained, push the STOP button on the control panel. Both blade speed and feed force may be adjusted as necessary while the blade is cutting.

Recommended Speed for Cutting Various Materials	
SPEED FPM	MATERIAL TO BE CUT
76 – 100	TOOL STEEL, STAINLESS STEEL, HARD BRONZE, HARD CAST IRON
100 – 150	MILD STEEL, SOFT CAST IRON, MEDIUM HARD BRASS AND BRONZE
150 – 250	SOFT BRASSES AND BRONZES, HARD ALUMINUM, PLASTIC
250 – 430	PLASTICS, SOFT ALUMINUM, WOOD, OTHER LIGHT MATERIALS

Table 1

10.7 Feed Force Adjustment

1. Feed force is indicated by the dial gauge above the feed force knob.

RECOMMENDED FEED FORCE

Speed FPM	Material (solid)	Feed Force (PSI)
76-100	up 5"	15-20
100-150	5" to 8"	25-50
150-250	9"to 10"	50-60
250-430	over 10"	60-70

Table 2

2. Reference Table 2 for recommended feed force settings. Twist the feed force knob to increase or decrease the feed force setting.

10.8 Upper Blade Guide Adjustment

The upper blade guide assembly should be adjusted down as close to the workpiece as possible without interfering with the workpiece or vice clamps.

1. To adjust the arm up or down, grasp the handwheel of the upper blade guide.
2. Loosen the locking handle (R, Fig. 15) and rotate the handwheel (S, Fig. 15) to lift or lower the guide to the desired height.
3. Hold the guide in this position and tighten the locking handle (R, Fig. 15).

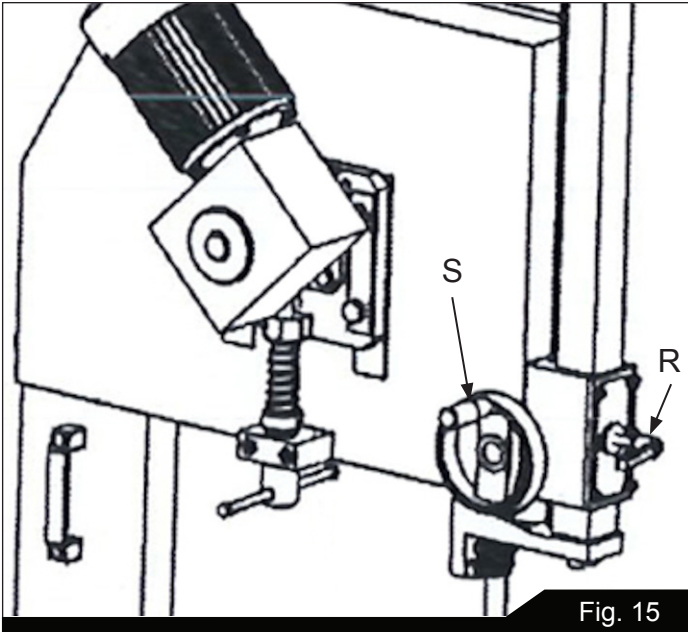


Fig. 15

10.9 Adjusting Cutter Head Weight

Adjusting the weight of the cutter head helps provide support of the head during tilting.

Use the manual handwheel to move the cutting head forward to the stop limit. If additional space is needed, adjust the forward stop limit to allow travel fully forward.

Tightening the M12 x 90L bolt (T, Fig. 16) will increase the tension on the springs which will thereby decrease the balance weight of the cutting head.

Loosening the M12 x 90L bolt (T, Fig. 16) will decrease the tension on the springs which will thereby increase the balance weight of the cutting head.

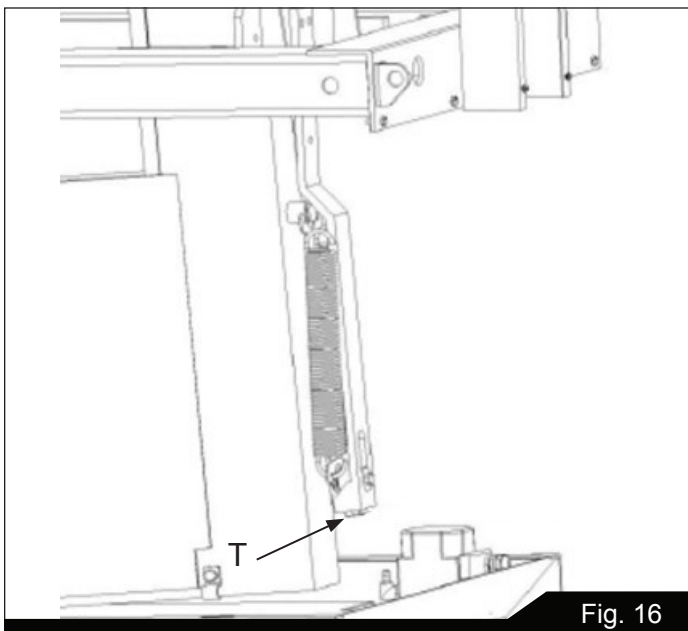


Fig. 16

10.10 Alignment Blade Squareness:

1. To check, move the upper blade guide to its uppermost position.
2. Use a square (U, Fig. 17) to check that the blade is perpendicular to the tabletop.
3. If alignment is necessary, loosen the two (2) bolts (V, Fig. 17) holding the lower blade guide assembly.
4. Move the lower blade guide block (W, Fig. 17) to the left or right as necessary.
5. Retighten the two (2) bolts loosened in Step 3.

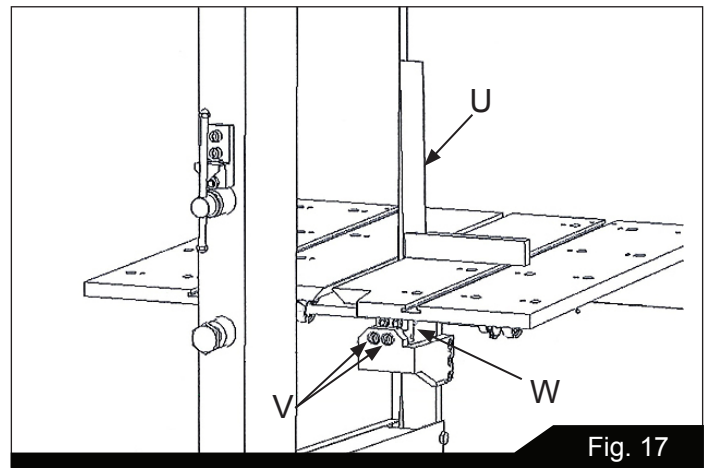


Fig. 17

10.11 Blade Guide Bearings Adjustment

Reference Figure 18.

⚠ CAUTION

Blade guides must be properly adjusted or damage may occur to the blade and/or guides.

For this procedure, "Left" and "Right" are based upon standing in front of the saw looking directly at the teeth of the saw blade. Similar to the angle shown in Fig. 18.

1. From the angle shown in Fig. 18, the guide to the left of the blade is on a concentric shaft. The guide to the right of the blade is on an eccentric shaft. The eccentric shaft (right) is the shaft that will be adjusted.
2. Loosen the lock nut (X, Fig. 18) with a 12 mm open end wrench while holding the adjuster with a 14 mm open end wrench.

3. Turn the adjuster (Y, Fig. 18) to adjust the bearing. The bearing should barely touch the blade (0.003"). This clearance can be measured with a piece of thin paper which should just fit into the gap between the bearing and the blade.
4. Tighten the lock nut (X, Fig. 18).
5. Set the lower blade guide bearing in the same manner.
6. When correct guide bearing adjustment is done, the blade runs smoothly and evenly without twisting or snagging anywhere along its path.

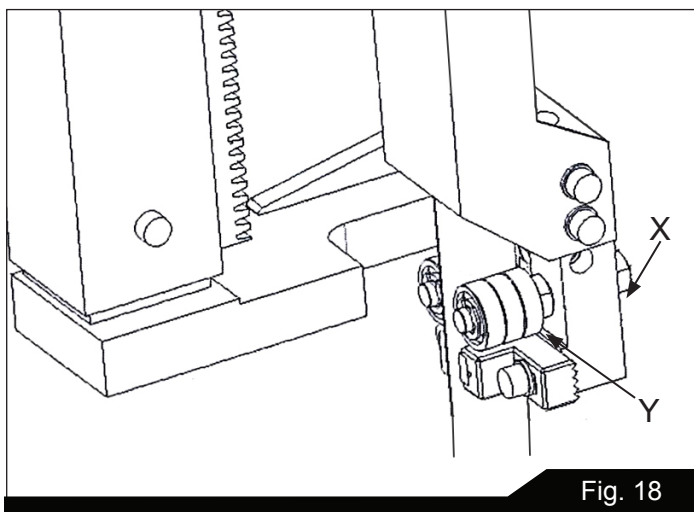


Fig. 18

11.0 BAND SAW OPERATION

Consult Section 9.0 for identification of the controls.

11.1 Blade Break-In Procedure

New blades are very sharp and therefore have a tooth geometry that is easily damaged if a careful break-in procedure is not followed. Consult the blade manufacturer's literature for break-in of specific blades on specific materials. The following procedure will be adequate, however, for break-in of JET-supplied blades on lower alloy ferrous materials.

1. Use a section of round stock.
2. Operate the saw at low speed. Start the cut with a very light feed rate.
3. When the saw has completed about 1/3 of the cut, increase the feed rate slightly and allow the saw to complete the cut.
4. Keep the feed rate at the same setting and begin a second cut on the same or similar workpiece.
5. When the saw has completed about 1/3 of the cut, increase the feed rate while watching the chip formation until cutting is at its most efficient rate (reference Section 11.4 - "Evaluating Cutting Efficiency"). Allow the saw to complete the cut.
6. The blade is now considered ready for use.

11.2 Pre-Operation Checklist

The following items should be checked at the beginning of each shift and by each new operator. This checklist is designed to maintain peak saw performance, increase blade life, reduce saw repairs, and provide a safe machine for the operator.

- Guards and covers in place and closed securely.
- Check the hydraulic fluid level - fill as necessary.
- Remove any unnecessary tools and equipment from the work surfaces and work area.
- Inspect blade-wheels and blade guides - be sure to remove chips. Check that the blade cleaning brush is aligned with the blade. Replace the blade brush if worn.
- Inspect the blade - replace if worn or if missing teeth.
- Check that the proper blade is installed.
- Check the blade tension - adjust if needed.
- Visually inspect the saw for damage or leaks. REPAIR BEFORE OPERATING.
- Check cutting fluid - add as necessary, change if contaminated.

11.3 Operation Procedure

Operation of this band saw is quite simple once the function of each control and feature is understood.

CAUTION

Material longer than the table must be properly supported to prevent unintended movement.

WARNING

Never operate band saw without blade and wheel covers in place and secured.

1. Turn the main disconnect switch to On and allow the system to boot up.
 2. Twist and release the Emergency Stop Switch.
 3. Turn the LAMP ON/OFF switch to the ON position.
 4. Raise the guide arm high enough to clear the material. If tilting the bow to the left. This will also need to clear the vise.
 5. Determine the angle of the cut. Use the lock lever to loosen the saw bow and manually tilt the bow from 45° left tilt to 45° right tilt. Never rely solely on the scale markers for the correct tilt angle. Always verify the angle with a protractor.
 6. Mark the material for the location and angle of the cut.
 7. Place the material between the vise plates. The vise may be positioned on either side of the cut and has other forward and aft adjustments.
 8. Align the cut mark with the saw blade.
 9. Close the vise to clamp the material.
 10. Turn the coolant switch to On to start the coolant flow. Adjust the flow at the nozzle using the ball valve located at the nozzle.
 11. Press the START switch to start the saw blade and advance the saw bow into the cut.
- NOTE: Reference Table 4 - Speed and Pitch chart in Section 14.0. Select the speed setting for the material to be cut.
12. Adjust the saw blade speed using the adjustment knob on the right side of the console and monitoring the speed using the blade speed indicator. Set the speed so that the speed is ± 5 SFPM of the desired setting. Getting an exact match will be difficult.
 13. Set the feed pressure to a pressure as recommended in pressure chart, Table 2 - Recommended Feed Force.
 14. Press the "STOP" button to stop the bow movement if necessary. The saw bow will advance until the forward stop limit switch is engaged. The saw blade will then stop, the frame will retract to the home position and wait for the next cut cycle.
 15. Slowly turn the feed speed knob counterclockwise (CCW) until the feed speed is set. This value is the "Cutting Rate" from the Cutting Chart. It is listed in Surface Inches Per Minute (SIPM).
 16. Once the feed rate and pressure cutting rate are set, lightly tighten the lock knobs to hold these setting. This will keep the settings for as long as the same material is to be cut.
 17. When the cut is complete, (either by the feed stroke limits or by the operator pressing the STOP button) the saw blade will stop and the saw bow will retract to the start position.
 18. Once the saw frame has returned to the home position, the saw may be set for the next cut. This will be determined by each specific project to be sawed.
- NOTE: It is recommended to check the first cut for accuracy. Make any adjustments before cutting the remaining stock. If the saw frame is not set at 0° the saw will not cut squarely.
19. When the saw is not in operation, power the saw down by pressing the E-Stop. If leaving the saw unattended, turn the main disconnect to the Off position.

11.4 Evaluating Cutting Efficiency

The best way to determine whether a blade is cutting efficiently is to observe the chips formed by the cutting.

- If chip formation is powdery, then the feed rate is too light, or the blade is dull.
- If the chips formed are curled, but colored – blue or straw colored from heat generated during the cut – then feed rate is excessive.
- If chips are slightly curled and not colored by heat, then the blade is sufficiently sharp and is cutting at its most efficient rate.



12.0 MAINTENANCE

WARNING

Before doing maintenance on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch. Failure to comply may cause serious injury.

The maintenance jobs listed in this section, are divided into daily, weekly, and monthly intervals. If the following operations are neglected, the result will be premature wear of the machine and poor performance.

Use a brush to loosen the accumulated chips and debris. Use a shop vacuum to remove the debris. Make sure the chip brush on the lower band wheel is properly adjusted.

If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

Wipe off the rubber tires, and clean the tables after each day's use.

12.1 Inspection and Service Schedule

12.1.1 Daily

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- Give general cleaning to the machine to remove accumulated shavings.
- Clean the lubricating coolant drain hole to avoid excess fluid.
- Top off the level of lubricating coolant.
- Check blade for wear.
- Drain any water buildup from the air filter.
- Check functionality of the shields and emergency stops.

12.1.2 Weekly

- Lubricate threaded components and sliding devices.
- Lubricate the feed chain with SAE 30 oil.
- Apply rust inhibitive lubricant to all non-painted surfaces.
- Thoroughly clean the machine to remove shavings, especially from the coolant tank.
- Removal of pump from its housing, cleaning of the suction filter and suction zone.
- Clean the filter of the pump suction head and the suction area.

- Use compressed air to clean the blade guides (guide bearings and drain hole of the lubricating and cooling tank).
- Clean flywheel housings and the race of the flywheels.
- Check and add coolant.
- Check the hydraulic fluid level. Move the cutting head all the way forward and check the fluid level indicator.

12.1.3 Monthly

- Check that the blade guide bearings on the heads are in perfect running condition.
- Lubricate the lower blade guide pivot with a molybdenum disulfide grease.
- Lubricate cutting head pivot collar (grease fitting attached on the carriage assembly) with a molybdenum disulfide grease.
- Check the tightness of the screws for the motor, pump, and accident protection guards.

12.1.4 Three Months

- Lubricate the blade tensioner screw and blade tension sliding plate with a molybdenum disulfide grease.
- Replace the coolant.

12.1.5 Yearly

- Replace the hydraulic fluid. Siphon fluid out and replace with SAE 10W hydraulic fluid while the cutting head is all the way forward. **Oil Disposal.** Used oil products must be disposed of in a proper manner following your local regulations.
- Check blade alignment.

12.2 Lubrication Schedule

Upper Blade Guide Shaft – lightly grease weekly. Clean after each day's use.

Speed Change Handle – grease monthly with a light film on teeth and threads.

Variable Pulley - insert a light weight grease into the grease fitting located on the end of the pulley shaft.

Blade Tension Screw – grease monthly.

All ball bearings are permanently lubricated and sealed. They require no further lubrication.

12.3 Accessing and Cleaning the Coolant System

Clean the drain screens on the machine base and the drains on the ends of the table.

- Drain and wash out the dirt and debris from the reservoir.
- Thoroughly clean the pump and pump inlet.
- Fill the tank with coolant solution.

12.3.1 Oils for Lubricating Coolant

Any 10:1 (water to coolant) solution will work; however, we recommend a 20:1 (water to coolant) biodegradable metal cutting fluid. It has excellent cooling and heat transfer characteristics, is non-flammable, and extends tool and machine life. Each gallon of concentrate makes 21 gallons of coolant.

12.4 Pneumatic Care

- Start with clean and dry air. Follow your compressor manufacturer's instructions for proper maintenance, filtering, and moisture control and removal.
- Use a 10W pneumatic air tool oil in an oiler set at the lowest setting to provide enough oil to the system to maintain good lubrication. Once started, do not allow the air system to run dry.



13.0 TROUBLESHOOTING

13.1 Operating Problems

Table 3

Trouble	Probable Cause	Remedy
Excessive blade breakage	Material loose in vise.	Clamp work securely.
	Incorrect speed or feed.	Adjust speed or feed.
	Blade pitch too coarse.	Use finer pitch.
	Blade tensioned too high.	Reduce tension.
	Blade guides out of adjustment.	Adjust guides.
	Poor tracking.	Adjust tracking.
	Coolant application incorrect.	Use properly mixed coolant in sufficient amounts.
Blade rushes forward into workpiece	Air in hydraulic lines.	Feed cutting head back and forth manually 5 to 6 times.
	Water in hydraulic lines.	Drain hydraulic system and replace fluid.
Blade squeals	Feed force too low.	Increase feed.
	Poor tracking.	Adjust tracking.
	Blade guides out of adjustment.	Adjust guides.
	Coolant application incorrect.	Use properly mixed coolant in sufficient amounts.
Blade stalls in workpiece	Feed force too high.	Reduce feed.
	Blade pitch too coarse.	Use finer pitch.
	Motor worn or defective.	Check the motor or electrical component.
	Blade guides too tight against blade.	Adjust blade guides.
Blade wears on side	Blade guides worn.	Replace.
	Blade guides out of adjustment.	Adjust guides.
Oil in cylinder air line	Air cylinder piston seal is leaking.	Replace cylinder.
Bad, crooked or rough cuts	Feed force too high.	Reduce feed.
	Blade guide bearings not properly adjusted.	Adjust blade guide bearings.
	Inadequate blade tension.	Adjust blade tension.
	Blade is dull.	Replace.
	Incorrect speed.	Check for recommended speed.
	Upper blade guide positioned incorrectly.	Adjust arm as close to workpiece as possible.
	Blade guide assembly is loose.	Tighten it.
	Blade pitch too coarse.	Use finer pitch.

13.2 Mechanical and Electrical Problems

Table 3 (cont.)

Trouble	Probable Cause	Remedy
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	No incoming power.	Verify machine is connected to power source. Make sure START button is pushed in completely, and STOP button is disengaged.
	Cord damaged.	Replace cord.
	Overload automatic reset has not reset.	When the band saw overloads on the circuit breaker built into the motor starter, it may take time for the machine to cool down before re-start. Allow unit to adequately cool before attempting restart. If problem persists, check amp setting on the motor starter.
	Band Saw frequently trips.	One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to reduce feed pressure into the blade. If too heavy a cut is not the problem, then check the amp setting on the overload relay. Match the full load amps on the motor as noted on the motor plate. If amp setting is correct then there is probably a loose electrical lead.
	Building circuit breaker trips or fuse blows.	Verify that band saw is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead.
	Switch or motor failure (how to distinguish).	If you have access to a voltmeter, you can separate a starter failure from a motor failure by first, verifying incoming voltage at 220+/-10% and second, checking the voltage between starter and motor at 220+/-10%. If incoming voltage is incorrect, you have a power supply problem. If voltage between starter and motor is incorrect, you have a starter problem. If voltage between starter and motor is correct, you have a motor problem.
	Motor overheated.	Clean motor of dust or debris to allow proper air circulation. Allow motor to cool down before restarting.
	Motor failure.	If electric motor is suspect, you have two options: Have a qualified electrician test the motor for function or remove the motor and take it to a qualified electric motor repair shop and have it tested.



13.2 Mechanical And Electrical Problems (cont.)

Table 3 (cont.)

Trouble	Possible Cause	Remedy
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses (cont.)	Miswiring of the unit.	Double check to confirm all electrical connections are correct. Reference the appropriate wiring diagrams to make any needed corrections.
	Switch failure.	If switch is suspect, you have two options: Have a qualified electrician test the switch for function, or purchase a new start switch and establish if that was the problem on changeout.
Band saw does not come up to speed.	Extension cord is too light or too long.	Replace with adequate weight and length cord.
	Low current.	Contact a qualified electrician.

14.0 SPEED AND PITCH CHART

Table 4

Material	Thickness	Sawing speed (Ft/min) for specified Material and thickness					Pitch (No. of teeth/inch)				
		~1/4	1/4~1	1~3	3~6	6~	~1/4	1/4~1	1~3	3~6	6~
High carbon steel		70	60	60	45	45	18	14	10	6	4
Free cutting steel		60	45	40	30	30	18	14	12	6	4
Ordinary tool steel		40	30	30	25	20	24	18	14	8	4
High speed steel		30	25	20	20	20	24	14	12	8	4
Stainless steel		25	20	20	20	20	18	14	10	8	4
Thick iron plate		45	30	20	20	20	18	14	10	8	4
Cast iron		45	40	30	25	20	18	14	12	8	4
Aluminum 108, A108		365	275	180	120	60	18	10	6	3	3
A132, C133		365	275	180	120	60	18	10	6	3	3
13,43,85,4032,6151		550	425	245	150	90	18	10	6	3	3
113,138,152,B-195		550	380	275	180	90	18	10	6	3	3
B-214,312,333		550	380	275	180	90	18	10	6	3	3
212,355,356,360,380		550	380	275	180	90	18	10	6	3	3
142,195,750		915	825	735	670	610	18	10	6	3	3
2014,2018,2025		915	825	735	670	610	18	10	6	3	3
6053,7075		915	825	735	670	610	18	10	6	3	3
6061,6063		1500	1220	1065	915	770	18	10	6	3	3
122,214,218,220		1500	1385	1220	1065	915	18	10	6	3	3
1100,2011,2017,3003,3004		1500	1500	1500	1385	1220	18	10	6	3	3
2024,5052		1500	1500	1500	1500	610	18	10	6	3	3
Magnesium bronze		125	75	40	25	20	14	8	6	3	3
Leaded commercial bronze		915	610	450	305	150	14	8	6	3	3
Commercial bronze		150	105	60	30	20	14	8	6	3	3
Free cutting brass		1220	915	610	450	300	14	8	6	3	3
Forging brass		610	460	335	245	150	14	8	6	3	3
High leaded brass		1065	825	565	410	260	14	8	6	3	3
Leaded brass		610	460	275	215	150	14	8	6	3	3
Low loaded brass		455	305	150	60	20	14	8	3	3	3
Leaded copper		765	550	360	240	120	14	8	3	3	3
Cadmium copper		90	60	30	25	20	14	8	3	3	3
Magnesium		1500	1385	1220	915	610	14	8	3	3	3
Cadmium		1220	1065	915	915	760	14	8	6	3	3
Manganese		60	45	30	25	20	24	14	6	3	3
Nickel		55	40	30	25	20	18	14	6	3	3
Bdellium		55	45	40	35	25	18	14	6	3	3
Chrome		50	40	25	20	20	18	14	6	3	3
Silicon		55	30	30	20	20	18	14	6	3	3
Carbon (8~35)		1220	1065	915	765	610	10	6	3	3	3
Carbon (35~65)		615	245	90	45	20	14	10	6	3	3
Carbon (1008~1095)		60	45	30	25	20	24	14	6	3	3
Rubber		460	155	90	60	45	18	14	10	8	6
Plastics		1500	1065	765	550	455	10	8	3	3	3
Resimene		1500	1375	1065	915	765	10	8	6	3	3
Leather		1220	1065	915	855	795	14	10	6	4	3
Corkboard		1500	1375	1220	1065	915	18	14	8	6	3



15.0 REPLACEMENT PARTS — EVTBS16V

Replacement parts are listed on the following pages.

To order parts or reach our service department, call 1-855-336-4032, Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

JET®

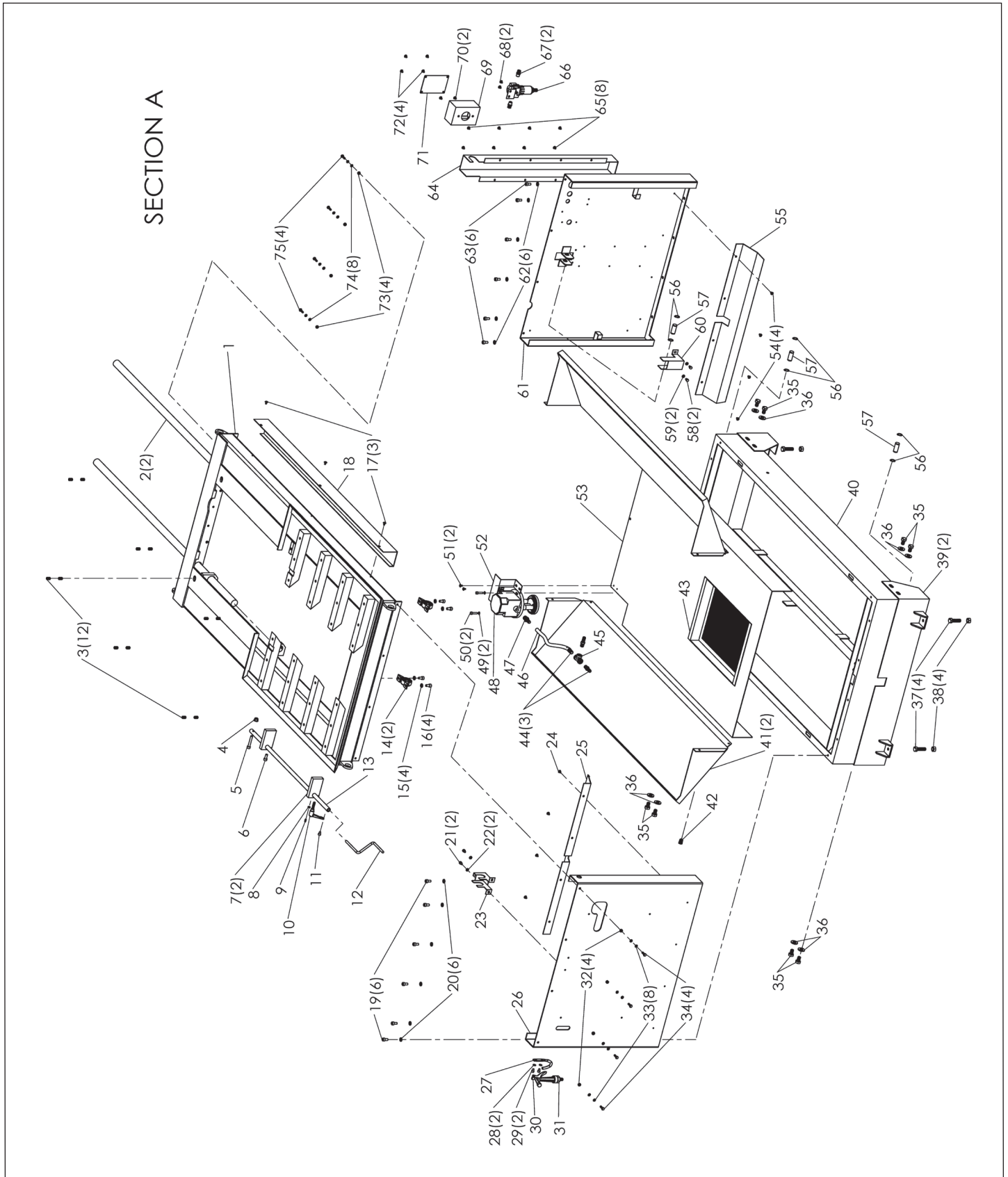
427 New Sanford Road

LaVergne, Tennessee 37086

www.jettools.com

Phone: 855-336-4032

CABINET ASSEMBLY — EVTBS16V





CABINET ASSEMBLY PARTS LIST — EVTBS16V

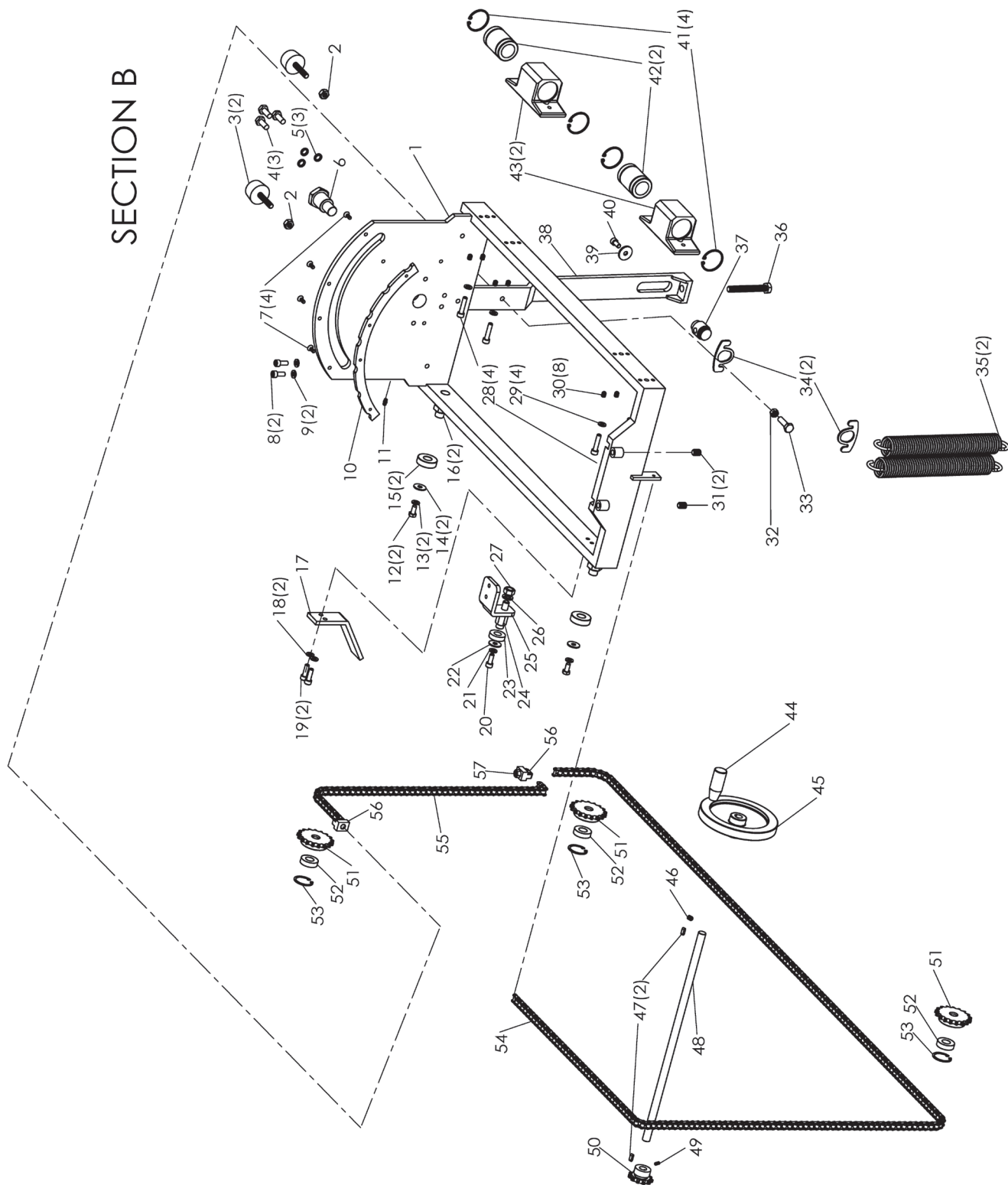
Index No.	Part No.	Description	Size	Qty.
1	EVTBS16V-A1	Base Frame-Table Top		1
2	EVTBS16V-A2	Rod-Carriage Way		2
3	TS-1525031	Set Screw	M10 x 16L	12
4	TS-1541031	Nylon Lock Hex Nut	M8, Nylon Insert	1
5	TS-1504101	Socket Hd Cap Screw	M8 x 50L	1
6	TS-1504041	Socket Hd Cap Screw	M8 x 20L	1
7	EVTBS16V-A7	Block-Limit Switch		2
8	TS-1540041	Hex Nut	M5	1
9	TS-1522041	Set Screw	M5 x 12L	1
10	EVTBS16V-A10	Locking Handle	M8 x 25L	1
11	TS-1503011	Socket Hd Cap Screw	M6 x 8L	1
12	EVTBS16V-A12	Bent Rod-Limit Switch		1
13	EVTBS16V-A13	Rod-Limit Switch		1
14	EVTBS16V-A14	Mounted Ball Bearings	Shaft Dia. 15 mm	2
15	TS-2361081	Lock Washer	M8	4
16	TS-1504031	Socket Hd Cap Screw	M8 x 16L	4
17	TS-1513011	Socket Head Flat Screw	M5 x 10L	3
18	EVTBS16V-A18	Cover - Cables and Tubes		1
19	TS-1504031	Socket Hd Cap Screw	M8 x 16L	6
20	TS-2361081	Lock Washer	M8	6
21	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2
22	TS-2361061	Lock Washer	M6	2
23	EVTBS16V-A23	Guard-Front Sprocket	RS40 10T	1
24	TS-1513011	Socket Head Flat Screw	M5 x 10L	4
25	EVTBS16V-A25	Drip Cover		1
26	EVTBS16V-A26	Machine Base Weldment-Front		1
27	EVTBS16V-A27	Hook		1
28	TS-2361061	Lock Washer	M6	2
29	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2
30	EVTBS16V-A30	Nozzle, Coolant Spray		1
31	EVTBS16V-A31	Nozzle Joint		1
32	TS-1541021	Nylon Lock Hex Nut	M6, Nylon Insert	4
33	TS-1550041	Flat Washer	M6	8
34	TS-1482041	Hex Cap Screw	M6 x 20L	4
35	F008871	Hex Cap Screw	M12 x 20L	8
36	TS-2360121	Flat Washer	M12	8
37	TS-2211451	Hex Cap Screw	M12 x 45L	4
38	TS-1540081	Hex Nut	M12	4
39	EVTBS16V-A39	Stand Weldment		2
40	EVTBS16V-A40	Coolant Tank		1
41	EVTBS16V-A41	Splash Guard		2
42	EVTBS16V-A42	Plug	3/8" NPT	1
43	EVTBS16V-A43	Chip Tray		1
44	EVTBS16V-A44	Fitting	For Hose ID 3/8", 1/4" NPT	3
45	EVTBS16V-A45	Tee Connector	1/4" NPT Female	1
46	EVTBS16V-A46	Hose	ID 3/8"	1

CABINET ASSEMBLY PARTS LIST — EVTBS16V (cont.)

Index No.	Part No.	Description	Size	Qty.
47	EVTBS16V-A47	Fitting	For Hose ID 3/8", 3/8" NPT	1
48	EVTBS16V-A48	Coolant Pump	32W	1
49	TS-1550041	Flat Washer	M6	2
50	TS-1503061	Socket Hd Cap Screw	M6 x 25L	2
51	TS-1513011	Socket Head Flat Screw	M5 x 10L	2
52	EVTBS16V-A52	Pump Splash Guard		1
53	EVTBS16V-A53	Cover-Coolant Tank		1
54	TS-1513011	Socket Head Flat Screw	M5 x 10L	4
55	EVTBS16V-A55	Drip Cover		1
56	F006045	C-Retaining Ring, Ext	S17	6
57	EVTBS16V-A57	Shaft	For Sprocket RS40 T17	3
58	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2
59	TS-2361061	Lock Washer	M6	2
60	EVTBS16V-A60	Guard-Rear Sprocket	RS40 17T	1
61	EVTBS16V-A61	Machine Base Weldment-Rear		1
62	TS-2361081	Lock Washer	M8	6
63	TS-1504031	Socket Hd Cap Screw	M8 x 16L	6
64	EVTBS16V-A64	Guard-Air Cylinder		1
65	TS-1513011	Socket Head Flat Screw	M5 x 10L	8
66	EVTBS16V-A66	Filter	1/4" Tube Fitting	1
67	EVTBS16V-A67	Tube Fitting	For Tube OD 8 mm, 1/4" NPT	2
68	TS-1513011	Socket Head Flat Screw	M5 x 10L	2
69	EVTBS16V-A69	Outlet Box		1
70	TS-1513011	Socket Head Flat Screw	M5 x 10L	2
71	EVTBS16V-A71	Outlet Box Cover		1
72	TS-1513011	Socket Head Flat Screw	M5 x 10L	4
73	EVTBS16V-A73	Nylon Nut	M6, Nylon Insert	4
74	TS-1550041	Flat Washer	M6	8
75	TS-1482041	Hex Cap Screw	M6 x 20L	4

TURNING BRACKET ASSEMBLY — EVTBS16V

SECTION B



TURNING BRACKET ASSEMBLY PARTS LIST — EVTBS16V

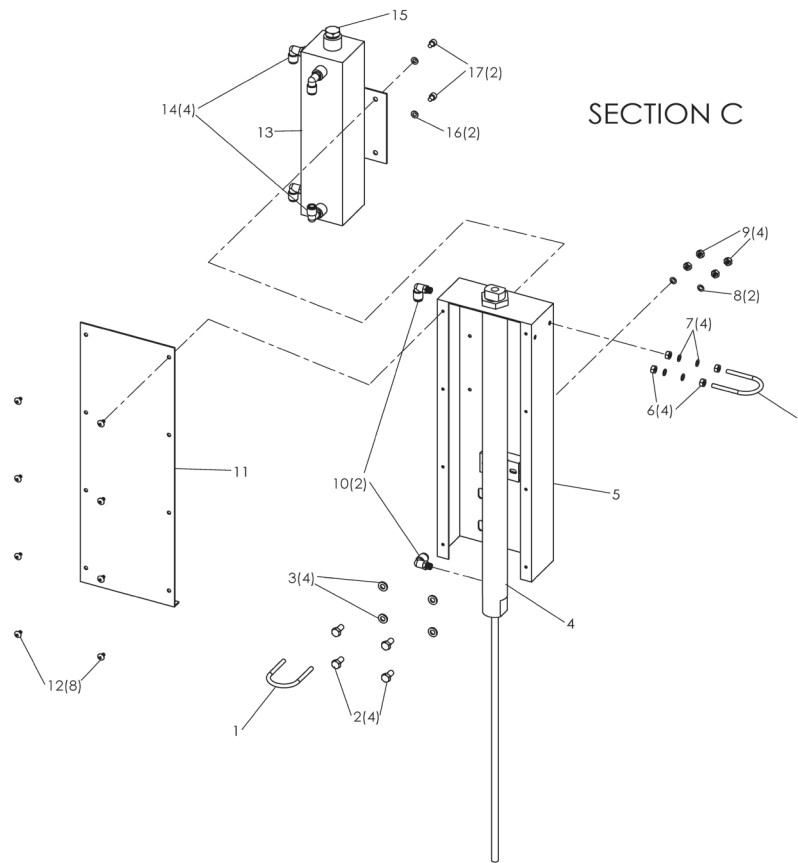
Index No.	Part No.	Description	Size	Qty.
1	EVTBS16V-B1	Carriage Weldment		1
2	TS-2311101	Hex Nut	M10	2
3	EVTBS16V-B3	Carriage Bumper		2
4	TS-1491031	Hex Cap Screw	M10 x 25L	3
5	TS-2361101	Lock Washer	M10	3
6	EVTBS16V-B6	Bolt, Bow Pivot		1
7	TS-2246101	Socket Head Flat Screw	M6 x 16L	4
8	TS-1504041	Socket Hd Cap Screw	M8 x 20L	2
9	TS-2361081	Lock Washer	M8	2
10	EVTBS16V-B10	Positioning Plate-Bow Pivot		1
11	EVTBS16V-B11	Grease Fitting	1/4"-28	1
12	TS-2228161	Hex Cap Screw	M8 x 16L	2
13	TS-2361081	Lock Washer	M8	2
14	TS-1550061	Flat Washer	M8(Dia. 25 mm)	2
15	BB-6203ZZ	Ball Bearing	6203ZZ	2
16	EVTBS16V-B16	Shaft-Bearing Mount		2
17	EVTBS16V-B17	Carriage Stop Bracket		1
18	TS-2361081	Lock Washer	M8	2
19	TS-1504051	Socket Hd Cap Screw	M8 x 25L	2
20	TS-1504041	Socket Hd Cap Screw	M8 x 20L	1
21	TS-2361081	Lock Washer	M8	1
22	TS-1550061	Flat Washer	M8(Dia. 25 mm)	1
23	BB-6002ZZ	Ball Bearing	6002ZZ	1
24	EVTBS16V-B24	Eccentric Shaft		1
25	EVTBS16V-B25	Bracket-Rear Carriage		1
26	TS-2361121	Lock Washer	M12	1
27	TS-1540081	Hex Nut	M12	1
28	TS-1504061	Socket Hd Cap Screw	M8 x 30L	4
29	TS-2361081	Lock Washer	M8	4
30	TS-1524021	Set Screw	M8 x 10L	8
31	TS-1526021	Set Screw	M12 x 16L	2
32	TS-2311101	Hex Nut	M10(P1.25)	1
33	TS-149105	Hex Cap Screw	M10 x 35L(P1.25)	1
34	EVTBS16V-B34	Yoke-Extension Spring		2
35	EVTBS16V-B35	Extension Spring		2
36	TS-1492091	Hex Cap Screw	M12 x 90L	1
37	EVTBS16V-B37	Shaft-Lower Yoke		1
38	EVTBS16V-B38	Bracket-Extension Spring		1
39	TS-1550061	Flat Washer	M8(Dia. 30 mm)	1
40	TS-1504031	Socket Hd Cap Screw	M8 x 16L	1
41	F006036	C-Retaining Ring, Int	R45	4
42	EVTBS16V-B42	Linear Bearing	LM30UU	2
43	EVTBS16V-B43	Bracket-Linear Bearing		2
44	EVTBS16V-B44	Handle-Handwheels		1
45	EVTBS16V-B45	Handwheel		1
46	TS-1524021	Set Screw	M8 x 10L	1
47	KF2R5515	Key, Dbl Rd Hd	5x5x15L	2



TURNING BRACKET ASSEMBLY PARTS LIST (cont.)

Index No.	Part No.	Description	Size	Qty.
48	EVTBS16V-B48	Shaft	For Sprocket RS40 T10	1
49	TS-1522041	Set Screw	M5 x 12L	1
50	EVTBS16V-B50	Sprocket	RS40 T10	1
51	EVTBS16V-B51	Sprocket	RS40 T17	3
52	BB-6003ZZ	Ball Bearing	6003ZZ	3
53	F006054	C-Retaining Ring, Ext	R35	3
54	EVTBS16V-B54	Chain	RS40 x 225 Pitch	1
55	EVTBS16V-B55	Chain	RS40 x 49 Pitch	1
56	EVTBS16V-B56	Bracket-Feed Chain		2
57	TS-2311101	Hex Nut	M10(P1.25)	1

AIR CYLINDER ASSEMBLY — EVTBS16V



Index No.	Part No.	Description	Size	Qty.
1	EVTBS16V-C1	U-Bolts	1-1/4 x 1/4"	2
2	TS-2228161	Hex Cap Screw	M8 x 16L	4
3	TS-2361081	Lock Washer	M8	4
4	EVTBS16V-C4	Air Cylinder		1
5	EVTBS16V-C5	Channel Weldment		1
6	TS-0561011	Hex Nut	1/4"-20	4
7	TS-1550041	Flat Washer	M6	4
8	TS-1550041	Flat Washer	M6	2
9	TS-0561011	Hex Nut	1/4"-20	4
10	EVTBS16V-C10	Tube Fitting(90° Elbow)	For Tube OD 8 mm, 1/8" NPT	2
11	EVTBS16V-C11	Cover-Air Cylinder		1
12	TS-1513011	Socket Head Flat Screw	M5 x 10L	8
13	EVTBS16V-C13	Air-Hydro Converter		1
14	EVTBS16V-C14	Tube Fitting(90° Elbow)	For Tube OD 8 mm, 1/4" NPT	4
15	EVTBS16V-C15	Plug	1/2" NPT	1
16	TS-2361061	Lock Washer	M6	2
17	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2

TABLE ASSEMBLY — EVTBS16V

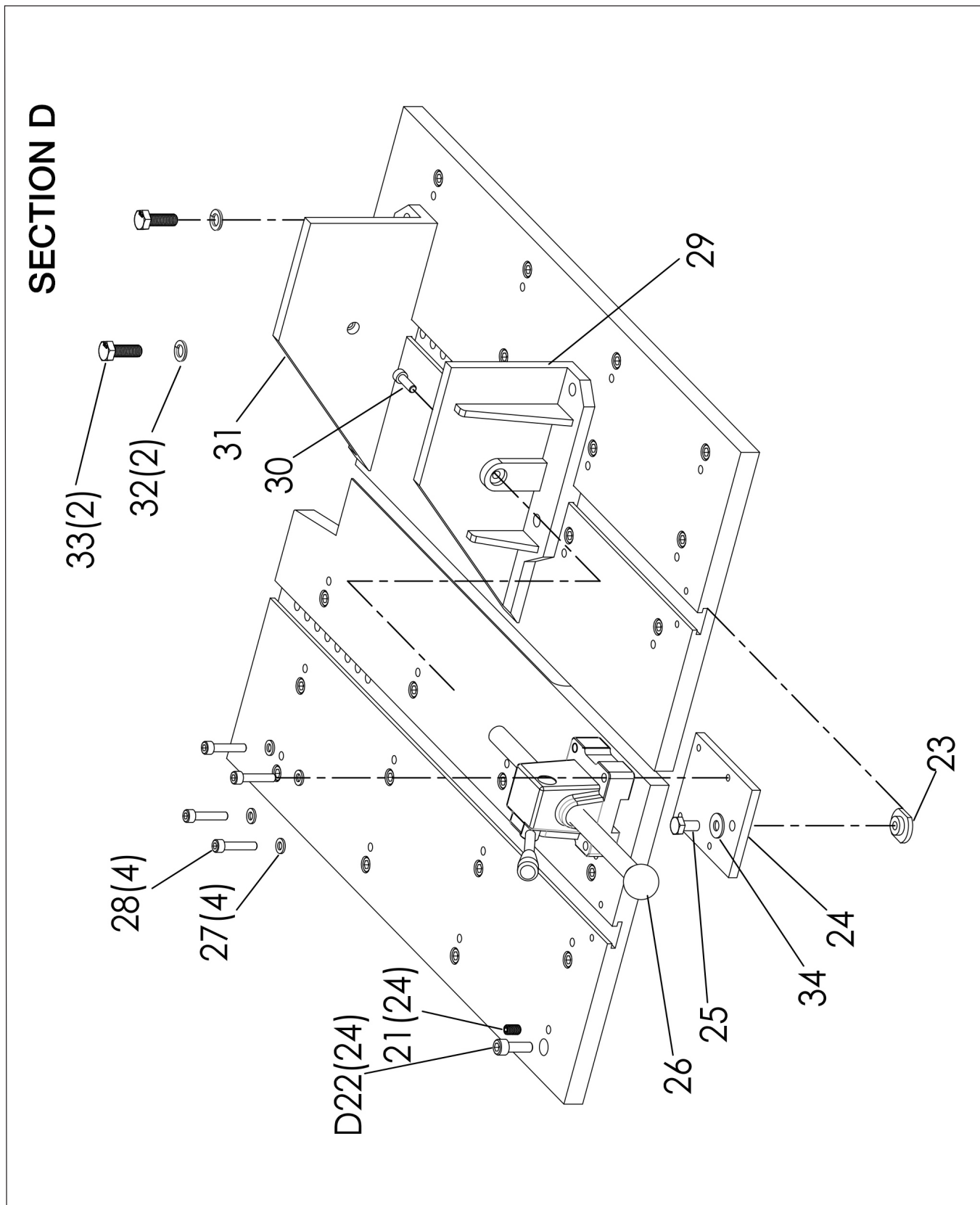
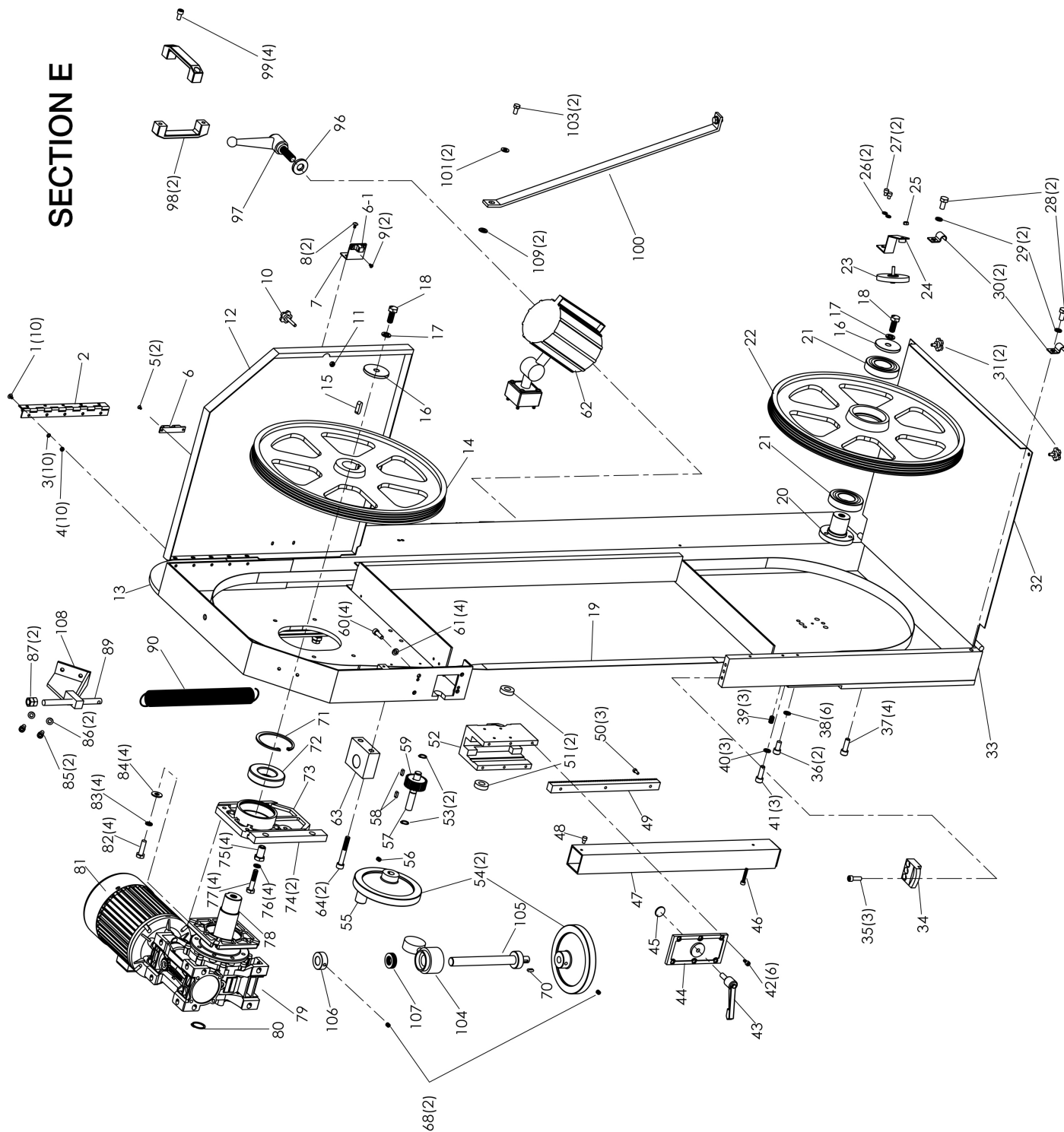


TABLE ASSEMBLY PARTS LIST — EVTBS16V

Index No.	Part No.	Description	Size	Qty.
19	EVTBS16V-D19	Right Table		1
20	EVTBS16V-D20	Left Table		1
21	TS-1525031	Set Screw	M10 x 16L	24
22	TS-1505041	Socket Hd Cap Screw	M10 x 30L	24
23	EVTBS16V-D23	T-Slot Nut	M10	1
24	EVTBS16V-D24	Base - Quick Action Clamp		1
25	EVTBS16V-D25	Hex Nut	M10 x 20L	1
26	EVTBS16V-D26	Quick Locked and Released Clamp		1
27	TS-2361081	Lock Washer	M8	4
28	TS-1504081	Socket Hd Cap Screw	M8 x 40L	4
29	EVTBS16V-D29	Front Vise		1
30	TS-1504051	Socket Hd Cap Screw	M8 x 25L	1
31	EVTBS16V-D31	Rear Vise		1
32	TS-2361121	Lock Washer	M12	2
33	TS-1492031	Hex Cap Screw	M12 x 35L	2
34	TS-2360121	Flat Washer	M12	1

BOW ASSEMBLY — EVTBS16V

SECTION E



BOW ASSEMBLY PARTS LIST — EVTBS16V

Index No.	Part No.	Description	Size	Qty.
1	TS-1513011	Socket Head Flat Screw	M5 x 10L	10
2	EVTBS16V-E2	Hinge-Upper Wheel Housing		1
3	TS-2361051	Lock Washer	M5	10
4	TS-1540041	Hex Nut	M5	10
5	TS-1512011	Socket Head Flat Screw	M4 x 8L	2
6	EVTBS16V-E6	Cover Stop (2 pcs)		1
7	EVTBS16V-E7	Bracket-Cover Stops		7
8	TS-1513011	Socket Head Flat Screw	M5 x 10L	2
9	TS-1512011	Socket Head Flat Screw	M4 x 8L	2
10	EVTBS16V-E10	Knob Screw	M6 x 40	1
11	TS-1540041	Hex Nut	M6	1
12	EVTBS16V-E12	Cover-Upper Wheel Housing		1
13	EVTBS16V-E13	Bow		1
14	EVTBS16V-E14	Upper Blade Wheel		1
15	5508675	Key, Dbl Rd Hd	10x8x30L	1
16	EVTBS16V-E16	Blade Wheel Washer		2
17	TS-2361121	Lock Washer	M12	2
18	TS-1492021	Hex Cap Screw	M12 x 30L	2
19	EVTBS16V-E19	Band Saw Blade	1-1/16 x 0.035 x 168-1/2"	1
20	EVTBS16V-E20	Shaft-Lower Blade Wheel		1
21	BB-6208ZZ	Ball Bearing	6208ZZ	2
22	EVTBS16V-E22	Lower Blade Wheel		1
23	EVTBS16V-E23	Wire Brush	Dia. 3"	1
24	EVTBS16V-E24	Wire Brush Mount		1
25	TS-1541021	Nylon Lock Hex Nut	M6, Nylon Insert	1
26	TS-2361061	Lock Washer	M6	2
27	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2
28	TS-1491021	Hex Cap Screw	M10 x 20	2
29	TS-2361101	Lock Washer	M10	2
30	EVTBS16V-E30	Hinge-Lower Wheel Housing		2
31	EVTBS16V-E31	Knob Screw	M6 x 15L	2
32	EVTBS16V-E32	Cover-Lower Wheel Housing		1
33	EVTBS16V-E33	Bracket-Swivel Plate		1
34	EVTBS16V-E34	Swivel Plate		1
35	TS-1504051	Socket Hd Cap Screw	M8 x 25L	3
36	TS-1505021	Socket Hd Cap Screw	M10 x 20L	2
37	TS-1505041	Socket Hd Cap Screw	M10 x 30L	4
38	TS-2361101	Lock Washer	M10	6
39	TS-1525031	Set Screw	M10 x 16L	3
40	TS-2361101	Lock Washer	M10	3
41	TS-1505041	Socket Hd Cap Screw	M10 x 30L	3
42	TS-1503031	Socket Hd Cap Screw	M6 x 12L	6
43	EVTBS16V-E43	Locking Handle	M10 x 25L	1
44	EVTBS16V-E44	Cover-Upper Blade Guide Arm		1
45	EVTBS16V-E45	Washer-Upper Blade Guide Arm		1
46	TS-1503111	Socket Hd Cap Screw	M6 x 50	1



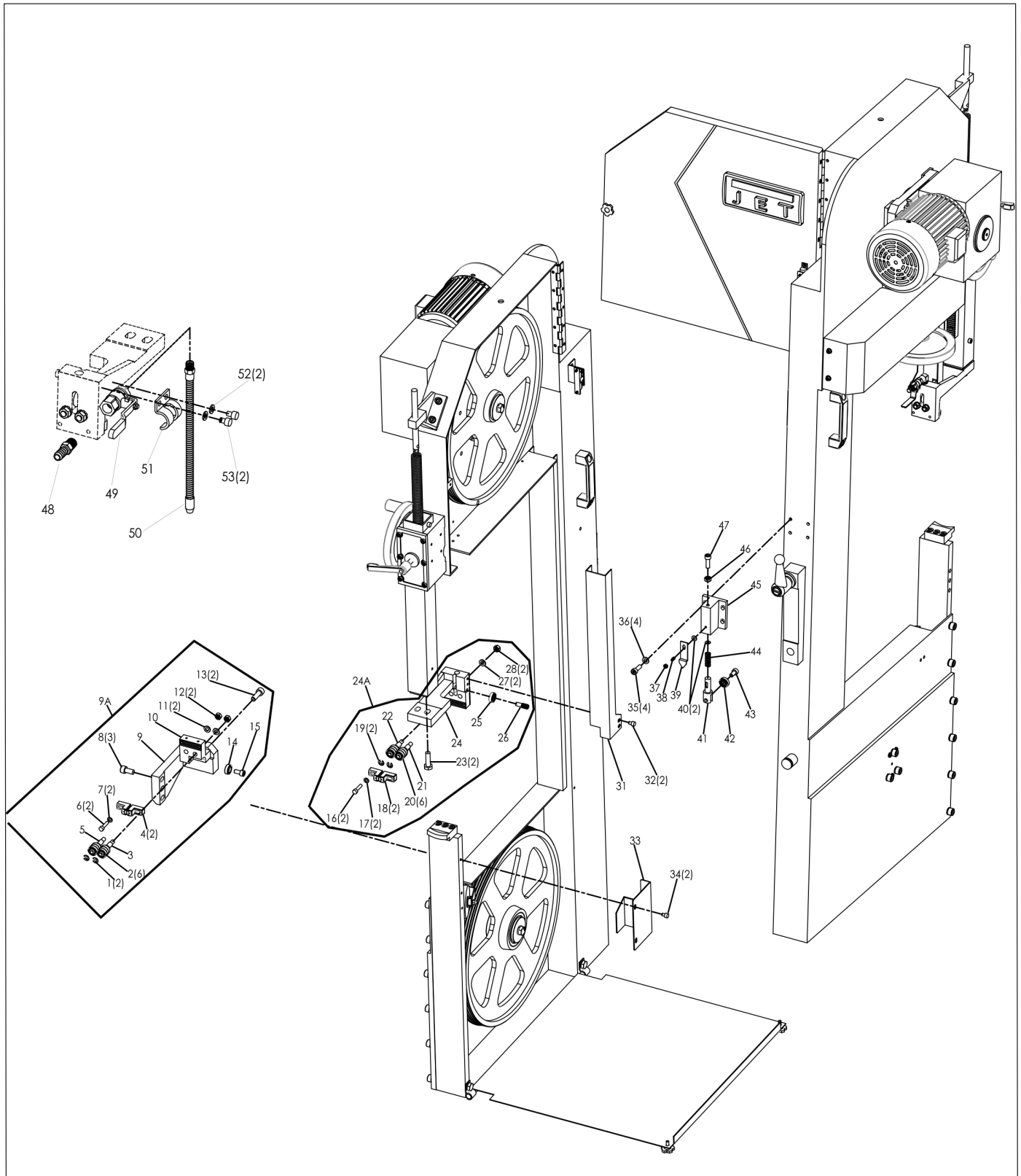
BOW ASSEMBLY PARTS LIST (cont.)

Index No.	Part No.	Description	Size	Qty.
47	EVTBS16V-E47	Upper Blade Guide Arm		1
48	TS-1503011	Socket Hd Cap Screw	M6 x 8L	1
49	EVTBS16V-E49	Gear Rack	3/4" M2	1
50	TS-1502031	Socket Hd Cap Screw	M5 x 12L	3
51	BB-6002ZZ	Ball Bearing	6002ZZ	2
52	EVTBS16V-E52	Bracket-Upper Blade Guide Arm		1
53	F006043	C-Retaining Ring, Ext	S15	2
54	EVTBS16V-E54	Handwheel		2
55	EVTBS16V-E55	Handle-Handwheels		1
56	TS-1524021	Set Screw	M8 x 10L	1
57	EVTBS16V-E57	Shaft-Upper Blade Guide		1
58	KF2R5515	Key, Dbl Rd Hd	5x5x15L	2
59	EVTBS16V-E59	Gear	M2	1
60	TS-1504051	Socket Hd Cap Screw	M8 x 25L	4
61	TS-2361081	Lock Washer	M8	4
62	EVTBS16V-E62	Work Lamp	9W	1
63	EVTBS16V-E63	Bracket-Tension Screw		1
64	TS-1505111	Socket Hd Cap Screw	M10 x 70L	2
68	TS-1524021	Set Screw	M8 x 10L	2
70	KF2R5515	Key, Dbl Rd Hd	5x5x15L	1
71	F006093	C-Retaining Ring, Int	R85	1
72	BB-6209ZZ	Ball Bearing	6209ZZ	1
73	EVTBS16V-E73	Sliding Plate-Blade Tension		1
74	EVTBS16V-E74	Sliding Plate Guide		2
75	EVTBS16V-E75	Sliding Plate Adjuster		4
76	TS-2361081	Lock Washer	M8	4
77	TS-1490091	Hex Cap Screw	M8 x 50L	4
78	EVTBS16V-E78	Output Shaft		1
79	EVTBS16V-E79	Gear Box Assembly	1/30	1
80	F006051	C-Retaining Ring, Ext	S28	1
81	EVTBS16V-E81	Motor	2HP, 230/460V, 3-Phase	1
82	TS-1491041	Hex Cap Screw	M10 x 30L	4
83	TS-2361101	Lock Washer	M10	4
84	TS-1550071	Flat Washer	M10	4
85	TS-1504031	Socket Hd Cap Screw	M8 x 16L	2
86	TS-2361081	Lock Washer	M8	2
87	TS-1540081	Hex Nut	M12	2
89	EVTBS16V-E89	Screw-Adjusting Damper		1
90	EVTBS16V-E90	Extension Spring-Adjusting Damp- er		1
96	EVTBS16V-E96	Washer-Bow Pivot		1
97	EVTBS16V-E97	Locking Handle	M16 x 30L	1
98	EVTBS16V-E98	Handle-Bow Pivot		2
99	TS-1504031	Socket Hd Cap Screw	M8 x 16L	4
100	EVTBS16V-E100	Shipping Brace		1
101	TS-1550061	Flat Washer	M8(Dia. 18 mm)	2

BOW ASSEMBLY PARTS LIST (cont.)

Index No.	Part No.	Description	Size	Qty.
103	TS-2228161	Hex Cap Screw	M8 x 16L	2
104	EVTBS16V-E104	Blade-Tension Gauge		1
105	EVTBS16V-E105	Blade-Tension Screw		1
106	EVTBS16V-E106	Collar-Tension Screw		1
107	EVTBS16V-E107	Truist Bearing	51104	1
108	EVTBS16V-E108	Bracket-Adjusting Damper		1
109	EVTBS16V-E109	Bonded Washer		2

GUIDE POST ASSEMBLY — EVTBS16V



GUIDE POST ASSEMBLY PARTS LIST — EVTBS16V

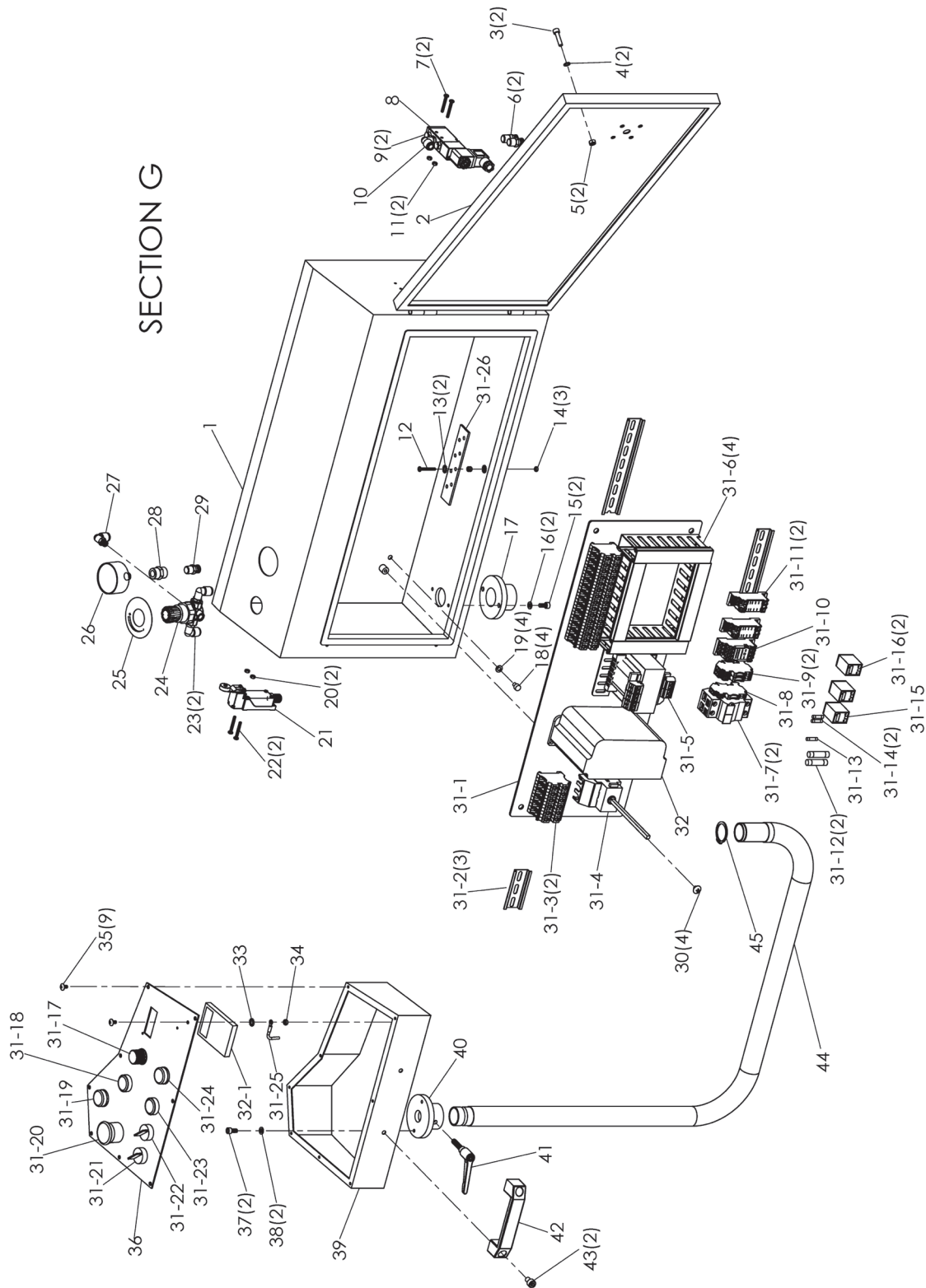
Index No.	Part No.	Description	Size	Qty.
9A	EVTBS16V-F9A	Lower Guide Assembly (F1-F15)		1
1	F006090	E-Retaining Ring	E7	2
2	BB-608ZZ	Ball Bearing	608ZZ	6
3	EVTBS16V-F3	Eccentric Roller Shaft		1
4	EVTBS16V-F4	Carbide Guide		2
5	EVTBS16V-F5	Concentric Roller Shaft		1
6	TS-1503061	Socket Hd Cap Screw	M6 x 25L	2
7	TS-2361061	Lock Washer	M6	2
8	TS-1505021	Socket Hd Cap Screw	M10 x 20L	3
9	EVTBS16V-F9	Arm-Lower Blade Guide		1
10	EVTBS16V-F10	Lower Blade Guide Block		1
11	TS-2361081	Lock Washer	M8	2
12	TS-1540061	Hex Nut	M8	2
13	TS-1505041	Socket Hd Cap Screw	M10 x 30L	2
14	BB-608ZZ	Ball Bearing	608ZZ	1
15	TS-1504031	Socket Hd Cap Screw	M8 x 16L	1
24A	EVTBS16V-F24A	Upper Guide Post Assembly		1
16	TS-1503061	Socket Hd Cap Screw	M6 x 25L	2
17	TS-2361061	Lock Washer	M6	2
18	EVTBS16V-F18	Carbide Guide		2
19	EVTBS16V-F19	Retaining Ring	E7	2
20	BB-608ZZ	Ball Bearing	608ZZ	6
21	EVTBS16V-F21	Eccentric Roller Shaft		1
22	EVTBS16V-F22	Concentric Roller Shaft		1
23	TS-1491041	Hex Cap Screw	M10 x 30L	2
24	EVTBS16V-F24	Upper Blade Guide Block		1
25	BB-608ZZ	Ball Bearing	608ZZ	1
26	EVTBS16V-F26	Shaft-Back Roller Bearing		1
27	TS-2361081	Lock Washer	M8	2
28	TS-1540061	Hex Nut	M8	2
31	EVTBS16V-F31	Upper Blade Guard		1
32	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2
33	EVTBS16V-F33	Lower Blade Guard		1
34	TS-1503011	Socket Hd Cap Screw	M6 x 8L	2
35	TS-1504051	Socket Hd Cap Screw	M8 x 25L	4
36	TS-2361081	Lock Washer	M8	4
37	TS-1540041	Hex Nut	M5	1
38	TS-1522041	Set Screw	M5 x 12L	1
39	EVTBS16V-F39	Indicator-Pivot Gauge		1
40	TS-1550031	Flat Washer	M5	2
41	EVTBS16V-F41	Shaft-Indicator Block		1
42	BB-608ZZ	Ball Bearing	608ZZ	1
43	TS-1504031	Socket Hd Cap Screw	M8 x 16L	1
44	EVTBS16V-F44	Spring-Indicator Block		1
45	EVTBS16V-F45	Pivot Indicator Block		1
46	TS-1540061	Hex Nut	M8	1
47	TS-1504071	Hex Nut	M8 x 35L	1



GUIDE POST ASSEMBLY PARTS LIST (cont.)

Index No.	Part No.	Description	Size	Qty.
48	EVTBS16V-F48	Fitting	For Hose ID 3/8", 1/4" NPT	1
49	EVTBS16V-F49	Coolant Valve Switch	Female x Female, 1/4" NPT	1
50	EVTBS16V-F50	Metal Coolant Hose	1/4" NPT	1
51	EVTBS16V-F51	Valve Holder		1
52	TS-2361061	Lock Washer	M6	2
53	TS-1503011	Socket Head Cap Screw	M6x8	2

ELECTRICAL BOX ASSEMBLY — EVTBS16V





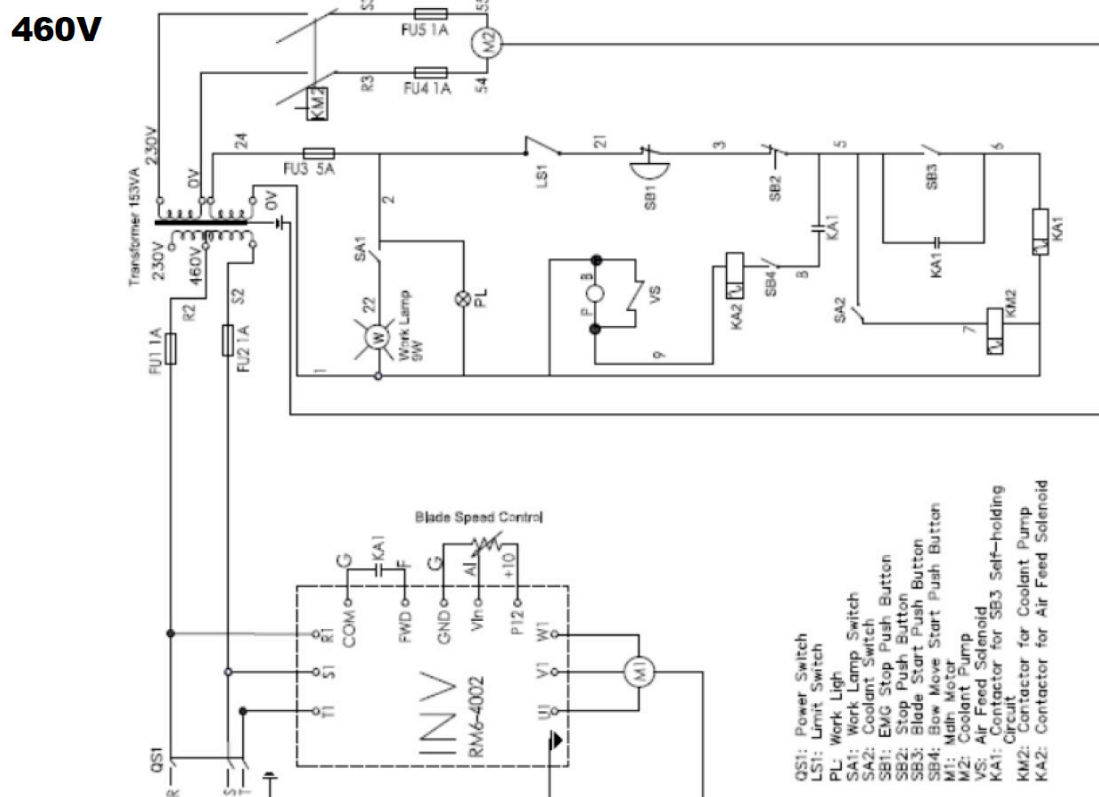
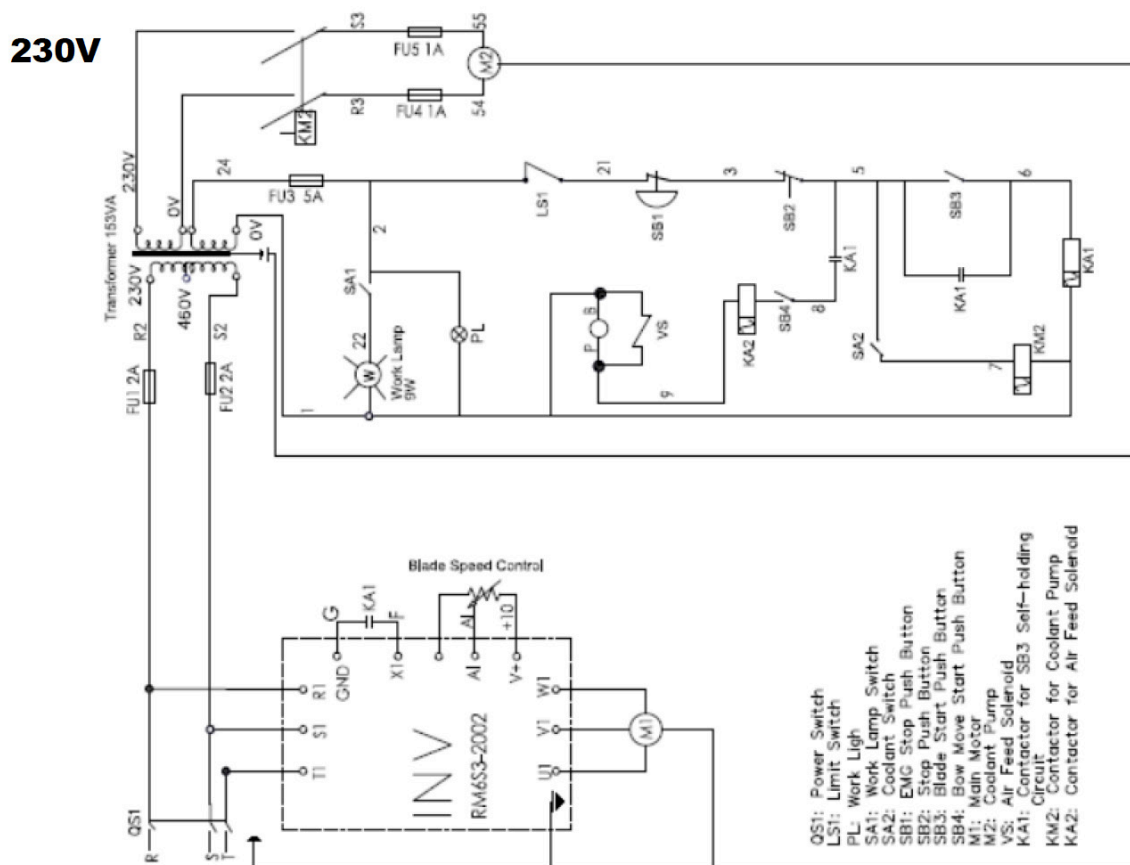
ELECTRICAL BOX ASSEMBLY PARTS LIST — EVTBS16V

Index No.	Part No.	Description	Size	Qty.
1	EVTBS16V-G1	Electrical Box Weldment		1
2	EVTBS16V-G2	Electrical Box Cover		1
3	TS-1503061	Socket Hd Cap Screw	M6 x 25L	2
4	TS-1550041	Flat Washer	M6	2
5	TS-1540041	Hex Nut	M6	2
6	EVTBS16V-G6	Tube Fitting	For Tube OD 8 mm, 1/4" NPT	2
7	TS-1501081	Socket Head Cap Screw	M4 x 30L	2
8	EVTBS16V-G8	Solenoid Valve		1
9	EVTBS16V-G9	Breather Vent		2
10	EVTBS16V-G10	Tube Fitting (90° Elbow)	For Tube OD 8 mm, 1/4" NPT	1
11	TS-1540021	Hex Nut	M4	2
12	F010991	Socket Head Flat Screw	M4 x 30L	1
13	EVTBS16V-G13	Tooth Washer	M5	2
14	TS-1540021	Hex Nut	M4	3
15	TS-1513031	Socket Hd Flat Screw	M5 x 10L	2
16	TS-2361061	Lock Washer	M6	2
17	EVTBS16V-G17	Lower Bushing-Control Box Support		1
18	TS-1503011	Socket Hd Cap Screw	M6 x 8L	4
19	TS-2361061	Lock Washer	M6	4
20	TS-1540021	Hex Nut	M4	2
21	EVTBS16V-G21	Limit Switch		1
22	F010991	Socket Head Flat Screw	M4 x 30L	2
23	EVTBS16V-G23	Tube Fitting (90° Elbow)	For Tube OD 8 mm, 1/4" NPT	2
24	EVTBS16V-G24	Compressed Air Regulator		1
25	EVTBS16V-G25	Decrease or Increase Decal		1
26	EVTBS16V-G26	Pressure Gauge		1
27	EVTBS16V-G27	Tube Fitting (90° Elbow)	For Tube OD 8 mm, 1/8" NPT	1
28	EVTBS16V-G28	Connector	1/4" Female	1
29	EVTBS16V-G29	Tube Fitting	For Tube OD 8 mm, 1/4" NPT	1
30	TS-1503011	Socket Head Cap Screw	M6 x 8L	4
31-1	EVTBS16V-G31-1	Electrical Plate		1
31-2	EVTBS16V-G31-2	Rail		3
31-3	EVTBS16V-G31-3	Terminal Block	50A/600V	2
31-4	EVTBS16V-G31-4	Main Power Switch		1
31-5	EVTBS16V-G31-5	Transformer	153VA/ 230/460V-24V	1
31-6	EVTBS16V-G31-6	Wiring Duct		4
31-7	EVTBS16V-G31-7	Fuse Block	10x38	2
31-8	EVTBS16V-G31-8	Fuse Block	5x10	1
31-9	EVTBS16V-G31-9	Fuse Block	5x10	2
31-10	EVTBS16V-G31-10	Relay Socket	PYF-14AE	1
31-11	EVTBS16V-G31-11	Relay Socket	PYF-08AE	2

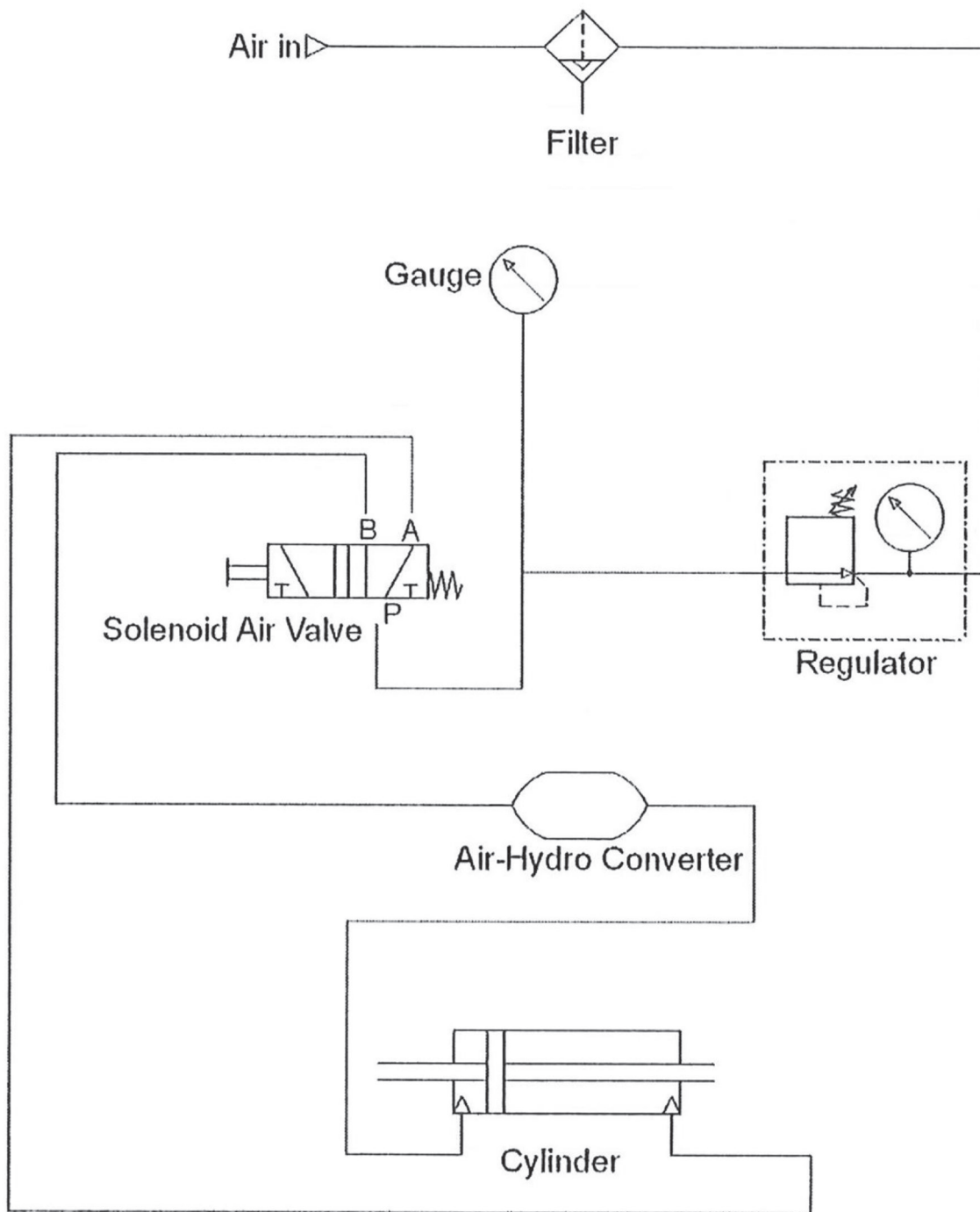
ELECTRICAL BOX ASSEMBLY PARTS LIST — EVTBS16V (cont.)

Index No.	Part No.	Description	Size	Qty.
31-12	EVTBS16V-G31-12	Fuse for 460V	10x38 mm (1A)	2
	EVTBS16V-FU2A	Fuse for 230V	10x38 mm (2A)	2
31-13	EVTBS16V-G31-13	Fuse	5x10 mm (5A)	1
31-14	EVTBS16V-G31-14	Fuse	5x10 mm (1A)	2
31-15	EVTBS16V-G31-15	Relay	BMY5-4C5	1
31-16	EVTBS16V-G31-16	Relay	BMY5-2C5	2
31-17	EVTBS16V-G31-17	Potentiometer	RV24YN	1
31-18	EVTBS16V-G31-18	Pushbutton Switch With Light	NLB22-F10GA	1
31-19	EVTBS16V-G31-19	Pilot Light(Red)	NLD22-R	1
31-20	EVTBS16V-G31-20	E-Stop Button	NPB22-T01R	1
31-21	EVTBS16V-G31-21	Selector Switch	NSS22-S210B	1
31-22	EVTBS16V-G31-22	Selector Switch	NSS22-S210B	1
31-23	EVTBS16V-G31-23	Pushbutton Switch(Red)	NPB22-F01R	1
31-24	EVTBS16V-G31-24	Pushbutton Switch(Red)	NPB22-F01G	1
31-25	EVTBS16V-G31-25	Ground Wire-Control Box		1
31-26	EVTBS16V-G31-26	Ground Copper Bar		1
32	EVTBS16V-G32	AC Motor Controller		1
	EVTBS16V-G32/4	AC Motor Controller	460V / 3Ph	1
32-1	EVTBS16V-G32-1	Keypad (Blade Speed Readout)	KP601A	1
	EVTBS16V-G32-1-4	Keypad (Blade Speed Readout)	KP603	1
33	EVTBS16V-G33	Tooth Washer	M5	1
34	TS-1540041	Hex Nut	M5	1
35	TS-1513011	Socket Head Flat Screw	M5 x 10L	9
36	EVTBS16V-G36	Control Panel		1
37	TS-1503031	Socket Hd Cap Screw	M6 x 12L	2
38	TS-2361061	Lock Washer	M6	2
39	EVTBS16V-G39	Control Box		1
40	EVTBS16V-G40	Upper Bushing-Control Box Support		1
41	EVTBS16V-G41	Locking Handle	M8 x 25L	1
42	EVTBS16V-G42	Handle-Control Box		1
43	TS-1504021	Socket Hd Cap Screw	M8 x 12L	2
44	EVTBS16V-G44	Control Box Support		1
45	F006053	C-Retaining Ring, Ext	S32	1

16.0 WIRING DIAGRAM — EVTBS16V



17.0 HYDRAULICS / PNEUMATICS — EVTBS16V





18.0 WARRANTY AND SERVICE

JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-855-336-4032, 8AM to 5PM CST, Monday through Friday.

WARRANTY PERIOD

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website, jettools.com.



WHO IS COVERED?

This warranty covers only the initial purchaser of the product from the date of delivery.

WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

HOW TO GET TECHNICAL SUPPORT

Please contact Technical Service by calling 1-855-336-4032. Please note that you will be asked to provide proof of initial purchase when calling. If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-855-336-4032 or use the Service Center Locator on the JET website.

MORE INFORMATION

JET® is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website, jettools.com.

HOW STATE LAW APPLIES

This warranty gives you specific legal rights, subject to applicable state law.

LIMITATIONS ON THIS WARRANTY

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.



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