



Operating Instructions and Parts Manual Semi-Automatic Band Saw

Model HBS-1321W



For serial no. 1711PI00576 and higher

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1.0 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 1-800-274-6846, 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.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

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. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **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 1-800-274-6846 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.

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.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

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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3.0 IMPORTANT SAFETY INSTRUCTIONS

1. Read and understand the entire instruction manual before attempting assembly or operation.
2. All JET band saws are 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 have been obtained.
3. Always wear approved safety glasses/face shields while using this machine.
4. Make certain the machine is properly grounded.
5. Before operating the machine, remove tie, rings, watches, other jewelry, and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. Do NOT wear gloves.
6. Keep the floor around the machine clean and free of scrap material, oil and grease.
7. Keep machine 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.
8. Do NOT over reach. Maintain a balanced stance at all times so that you do not fall or lean against blades or other moving parts.
9. Make all machine adjustments or maintenance with the machine unplugged from the power source.
10. Use the right tool. Don't force a tool or attachment to do a job which it was not designed for.
11. Replace warning labels if they become obscured or removed.
12. Make certain the motor switch is in the OFF position before connecting the machine to the power supply.
13. Give your work undivided attention. Looking around, carrying on a conversation, and "horse-play" are careless acts that can result in serious injury.
14. Keep visitors a safe distance from the work area.
15. Use recommended accessories; improper accessories may be hazardous.
16. Make a habit of checking to see that keys and adjusting wrenches are removed before turning on the machine.
17. Always keep hands and fingers away from the blade when the machine is running.
18. Never hand hold the material. Always use the vise and clamp it securely.
19. Keep belt guard, blade guards, and wheel covers in place and in working order.
20. Always provide adequate support for long and heavy material.
21. Use a sharp blade and keep machine clean for best and safest performance.
22. Failure to comply with all of these warnings may cause serious injury.

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 machine damage.

WARNING

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

4.0 Specifications

Model Number	HBS-1321W
Stock Number	414471
Capacity:	
Round at 90° (in)	13" (330 mm)
Round at 45° (in)	10-1/2" (268 mm)
Rectangle at 90° (in)	10" x 21" (254x533 mm) and 13" x 19" (330x483 mm)
Rectangle at 45° (in)	11-1/2" x 10-1/2" (292x268 mm)
Throat Depth (in)	13" (330 mm)
Blade Size (in)	1-1/4" x 0.042" x 161-1/2" (31.75x1.07x4102 mm)
Blade Wheel Diameter (in)	18" (457 mm)
Blade Speeds (SFPM)	80-260
Floor Space Required (in)	84" x 32-1/2" (2134x826 mm)
Bed Height (in)	32" (813 mm)
Motor	3 HP, 3 PH, 230/460V (Prewired 230V)
Coolant Motor	1/6 HP
Net Weight (approx.)	1,276 lb (579 kg)

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 Uncrating and cleanup

1. Read and understand the entire manual before attempting setup or operation.
2. Finish uncrating the saw and inspect for damage. If any damage has occurred, contact your local distributor.
3. Remove all bolts attaching machine to shipping base.
4. Leave packing material between vice clamps and saw head intact until band saw has been lifted to its final position.
5. Clean all rust protected surfaces with kerosene or diesel oil to remove protective coating. Do not use gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.
6. Lubricate all slideways with a light film of Mobil DTE® Oil Heavy Medium.

6.0 Installation

For best performance, the band saw should be located on a solid and level foundation. Allow room for servicing and for moving large stock around the band saw when deciding a location for the machine.

1. Using lifting straps of adequate lifting capacity, which are isolated from the band saw's finished surfaces, lift machine and place in desired location. See Figure 1 for strap placement.
2. Install four leveling bolts with lock nuts on both sides of the base.
3. Place a level on the bed surface and check side to side and front to back.
4. Adjust leveling screws until machine is level in both directions and tighten locking nuts.

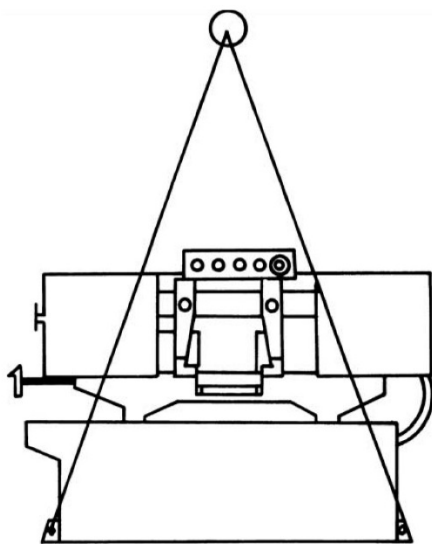


Figure 1

7.0 Assembly

1. Insert stop rod (A, Figure 2) into the base below the vise. Place stop bracket (B) onto stop rod and tighten lock knob (C). Attach the connecting plate (D) to stop bracket with hex cap bolt and washer (E) and tighten. Attach the work stop (F) to the connecting plate with lock handle (G), and tighten.

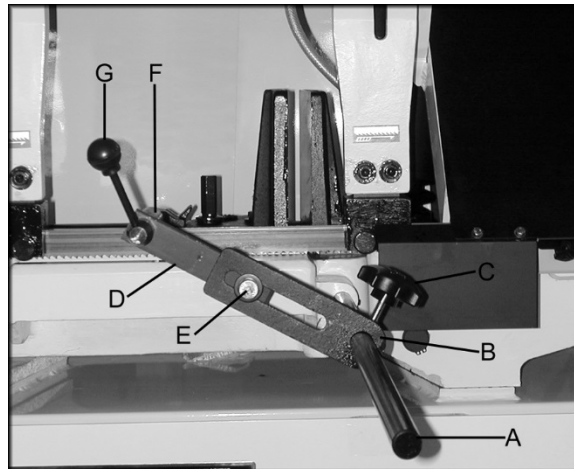


Figure 2

2. Slide the tensioning handle (A, Figure 3) onto the shaft and tighten the hex socket set screw.

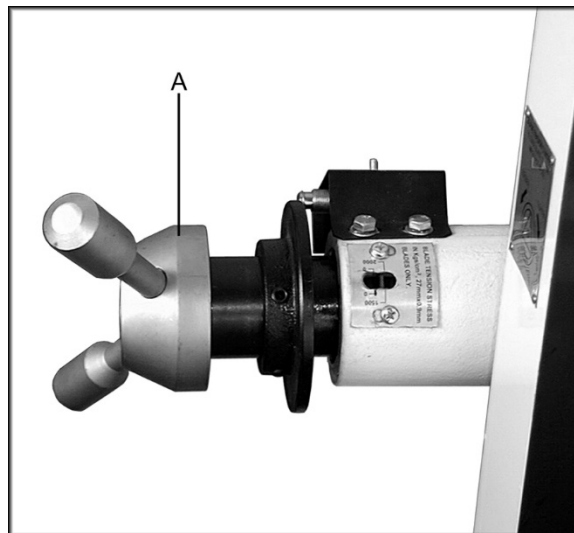


Figure 3

8.0 Electrical connections

⚠ WARNING All electrical connections must be made by a qualified electrician. Failure to comply may result in serious injury.

⚠ WARNING Disconnect machine from power source before changing any voltage components. Failure to comply may result in serious injury.

The HBS-1321W band saw is rated at 230/460V, 3-phase and is prewired 230 volt from the factory. Confirm power source available at the saw's location is the same as the saw is wired. To switch the HBS-1321W from 230V to 460V, the following items will have to be changed. **NOTE: Band saw must always be properly grounded.**

1. **Main Motor:** Follow diagram inside junction box cover.
2. **Coolant Pump:** Follow diagram inside junction box cover.
3. **Control Transformer:** Open electrical panel on rear of base and switch only the one 230V primary wire on transformer to the 460V position.
4. **Hydraulic Pump:** Remove access panel and follow diagram inside junction box cover.

9.0 Controls

Refer to Figure 4.

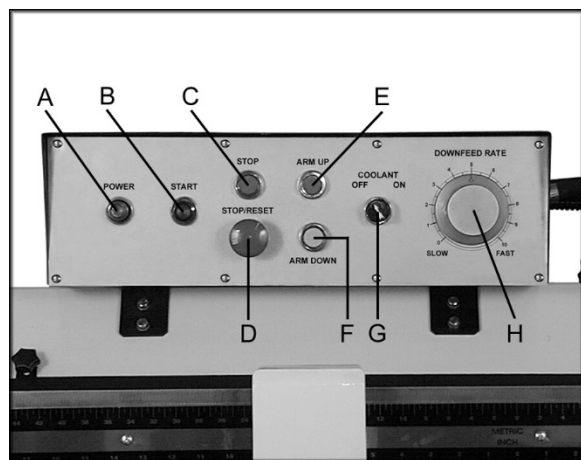


Figure 4

- A. **Power Indicator Light:** Lit whenever machine has power.
- B. **Start Button:** Depress to start band saw. Will not work if emergency button is depressed.
- C. **Stop Button:** Depress to stop band saw.
- D. **Emergency Stop Button:** Depress to immediately stop all machine functions.
- E. **Arm Up Button:** Depress to raise arm.

- F. **Arm Down Button:** Depress to lower arm.
- G. **Coolant Switch:** Turn arrow to ON starting flow of coolant. Turn arrow to OFF stopping flow of coolant. Blade must be circulating for coolant pump to work.
- H. **Downfeed Rate Knob:** Turn clockwise to increase down feed rate. Turn counterclockwise to decrease down feed rate. See sect. 11.7, *Adjusting feed rate*.

10.0 Prior to operation

1. All JET band saws are 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 have been obtained.
2. Check that blade tooth direction matches diagram on blade guides.
3. Check to see that blade is properly seated on wheels after applying correct tension (approximately 25,000 lbs.).
4. Check blade guides for proper adjustments. See sect. 11.9, *Blade guide adjustment*.
5. Position sliding blade guide arms as close to workpiece as possible.
6. Select proper speed and feed rate for material being cut. Refer to Machinery's Handbook or similar source for speed and feed charts.
7. Material to be cut must be securely held in the vise. See sect. 11.1 through 11.3.
8. Check to see that coolant level is adequate and turn on coolant pump if material to be cut requires it. See sect. 12.3, *Coolant pump*.
9. Do not start cut on a sharp edge.

11.0 Adjustments

⚠ WARNING With the exception of blade tracking, disconnect machine from the power source before making adjustments or changing vise position. Failure to comply may cause serious injury.

11.1 Adjusting vise square to blade (Position A, Figure 5)

1. Place a machinist's square on the bed against the blade and the vise. The square should lie along the entire length of the vise and blade without a gap.
2. If adjustment is necessary, loosen bolts (A, Figure 5) holding the vise and adjust vise so square lines up properly. Tighten bolts.

3. You may want to perform a test cut. Cut off the end of the stock. Make another cut so that you have an accurate section to measure. Measure thickness with calipers.

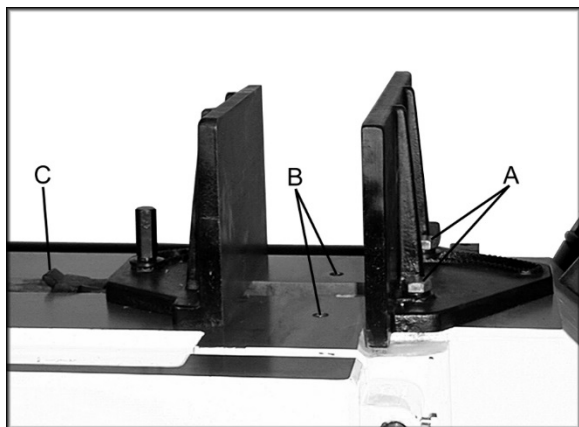


Figure 5

11.2 Adjusting vise for miter cuts

(Position B, Figure 5)

1. Move the vise into the second set of threaded holes (B, Figure 5) by removing hex cap bolts (A, Figure 5).
2. When angle has been set tighten bolts.
3. Adjust other jaw.
4. There is an angle label on the backside of the bed. This is for reference only. Check angles with a machinist's protractor.

For your own safety: only use position B for miter cuts. Vise square to the blade, in position B would expose more of the blade, right of the vise, than is necessary for the cut.

11.3 Positioning vise

To position the moveable vise:

1. Pull up on the rack block (C, Figure 5).
2. Move vise to desired location by sliding along bed.
3. Tighten vise by turning hand wheel, found at the left end of the bed, clockwise.
4. Loosen vise by turning hand wheel counterclockwise so you can pull up on the rack block.

11.4 Changing blade speeds

Adjust the variable blade speed only while the machine is running. The dial (A, Figure 6) sticking out of the belt cover (right side) controls the variable speeds between 66 FPM to 264 FPM.

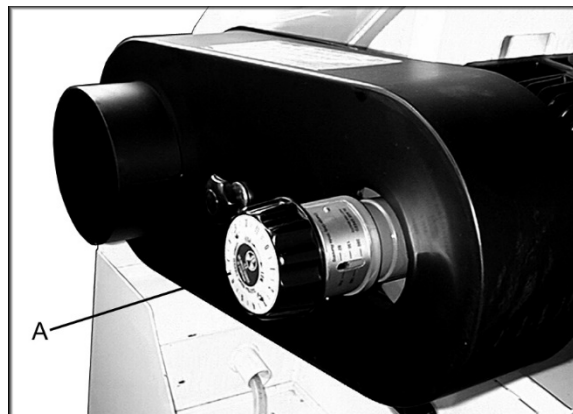


Figure 6

11.5 Semi-automatic arm

Preset the height, which the arm stops when it raises automatically. The height the arm raises depends upon the piece you want to cut. The limit switch is lowered or raised by loosening a locking handle (A, Figure 7). Tighten the locking handle when the limit switch has been properly adjusted.



Figure 7

11.6 Automatic shut-off

The blade will stop after the material has been cut, and the arm reaches its lowest position. The arm will automatically rise to the preset height.

11.7 Adjusting feed rate

Rate of downfeed is adjusted by turning the downfeed knob on the control panel. Rate of feed is important to band saw performance; excessive pressure may break the blade or stall the saw. Insufficient pressure rapidly dulls the blade.

Material chips or shavings are the best indicator of proper speed and downfeed. The ideal chip is thin, tightly curled, and warm to the touch. Chips that range from golden brown to black indicate excessive force. Blue chips indicate extreme heat from too high a band speed, which will shorten blade life. Thin or powdered chips indicate insufficient downfeed rate.

11.8 Changing blades

⚠ WARNING Disconnect machine from the power source before making any adjustments or repairs. Failure to comply may result in serious injury.

1. Raise the saw arm approximately 6".
2. Disconnect machine from power source.
3. Open both wheel covers and clean chips out of both wheel housings. Loosen lock knobs and remove upper and lower blade guides.
4. Release blade tension by turning blade tensioning handwheel (A, Figure 8) counterclockwise until blade is free.

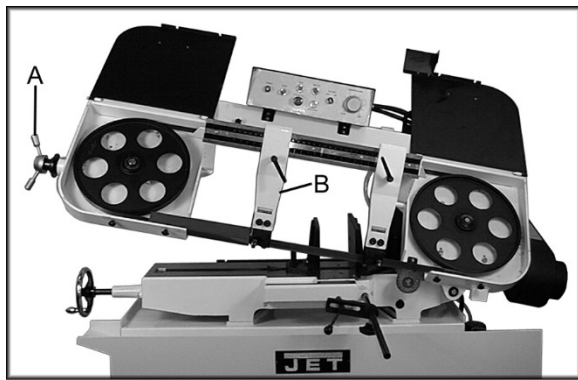


Figure 8

5. Loosen lock handle and slide left blade guide arm (B, Figure 8) to the right as far as possible. Remove old blade from both wheels and out of each blade guide.

⚠ CAUTION Even dull blades are sharp to the skin. Use extra caution handling band saw blades.

6. Install a new blade making sure teeth are pointed downward in the proper cutting direction.
7. Position blade on wheels and tighten just enough to hold blade on wheels. Make sure back of blade rests lightly against the wheel flange of both wheels. Twist blade slightly to allow it to slip into guides.
8. Tension blade to approximately 25,000 lbs. Blade tension is indicated on the tension wheel shaft housing (left side).

9. Install all guards, close covers and fasten securely. Connect machine to power and run freely for approximately two minutes.
10. Turn power off and re-check blade tension and wire brush adjustment. If further adjustment is necessary, disconnect saw from power source, make adjustments, and re-connect to power.

11.9 Blade guide adjustment

11.9.1 Bearing guides

The bearings come pre-adjusted from the factory. If adjustment is needed follow the below steps.

Refer to Figure 9.

1. Disconnect machine from power source.
2. Loosen two hex socket cap screws (A, Figure 9).
3. Move guide seat (B) up or down until an approximate clearance of .003" between blade and bearing is obtained, (C).
4. Tighten two hex socket cap screws (A).

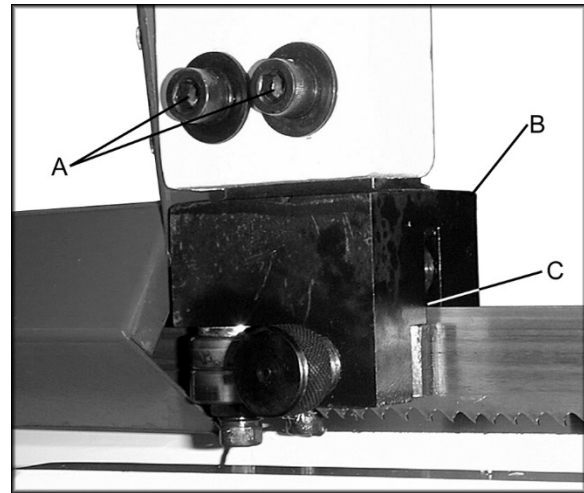


Figure 9

Refer to Figure 10:

5. Adjust the eccentric bearings (A, Figure 10) by loosening hex socket cap screw (B) about one full turn.
6. With a 19mm wrench turn hex nut (C) until the ball bearings are approximately .003" from blade. Note: Do not pinch the blade.
7. Tighten the hex socket cap screw (B) while holding the hex nut (C) in place.
8. Repeat for other blade guide assembly.
9. Connect machine to power source.

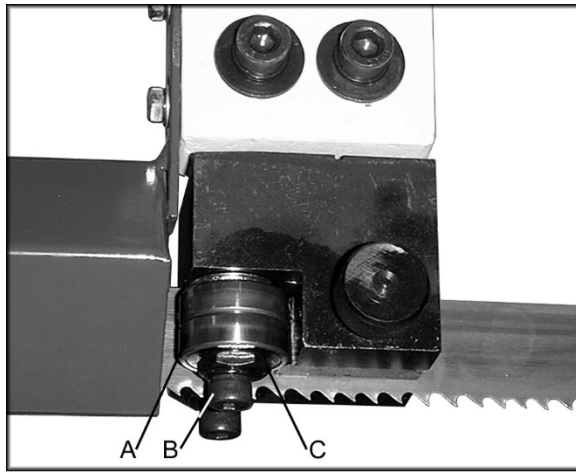


Figure 10

11.9.2 Stationary guides

The stationary blade guides come pre-adjusted from the factory. If adjustment is needed, follow the below steps.

Refer to Figure 11.

1. Disconnect machine from power source.
2. Adjust spring loaded blade guide (A, Figure 11) by loosening or tightening the guide adjustment screw (B).
3. The blade guide should place a light pressure on the blade.
4. Connect machine to the power source.

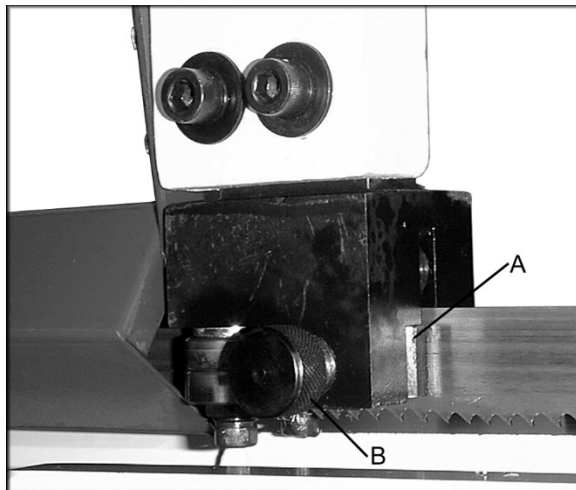


Figure 11

11.10 Blade tracking adjustment

Since tracking can only be adjusted while machine is running, it is suggested that this adjustment be accomplished by qualified personnel that are familiar with this type of adjustment and the dangers associated with it.

Blade tracking has been set at the factory and should require no adjustment. If a tracking problem occurs, adjust the machine as follows:

⚠ WARNING

Tracking adjustment is done with the wheel covers open to observe the blade. Use extreme caution to prevent coming into contact with the blade.

1. Raise saw arm to its highest position.
2. Locate tracking adjustment plate on the backside of the idle wheel.
3. Loosen the three bolts (A, Figure 12) located on the top of the tracking nuts.
4. Tracking adjustment is accomplished by either loosening or tightening three adjusting nuts (B, Figure 12).
5. Tracking is set properly when the back of the blade lightly touches the wheel flange. Note: over-tracking (allowing blade back to rub hard against wheel flange) will damage the blade wheels and blade.
6. Tighten locking bolts (A) once proper tracking is completed.

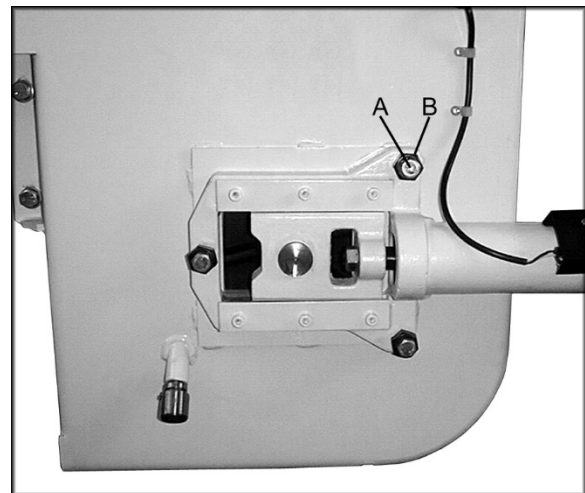


Figure 12

12.0 Maintenance

12.1 Lubrication and gearbox

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

The gearbox lubricant should be changed after the first 3 months of operation. Use Mobil SHC 634, or equivalent. Change lubricant from then on every year.

To check level of gear box lubricant, place arm in down position and allow a few minutes to pass so that oil drains down. Check level in sight glass on side of gear casing. Correct level is the dot in the middle of sight glass.

To change gear box lubricant:

1. Disconnect machine from power source.
2. Remove drain plug and allow lubricant to drain completely. The drain plug is located on lower front of gear case under right wheel cover. Remove drain plug with a hex wrench.
3. Reinstall drain plug.
4. Remove filler cap and fill gearbox with Mobil SHC 634 until level reaches dot in middle of sight glass.
5. Reinstall filler cap.
6. Use Mobil DTE® Oil Heavy Medium to lubricate all other moving parts as needed.

12.2 Hydraulic pump

Remove cap (A, Figure 13) to add hydraulic fluid to the tank. Add Mobil DTE® 24 until the sight glass shows full.

Note: If a significant amount of oil must be added, check for oil leaks in pump components, lines, and hydraulic cylinder. Correct source of leakage before operating saw.

It is recommended that the hydraulic fluid be drained and replaced every 1 to 2 years, or 3,000 operating hours, whichever comes first.

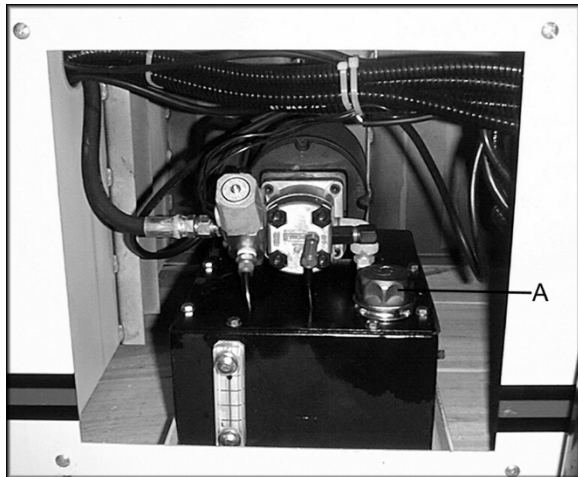


Figure 13

12.3 Coolant pump

The coolant tank should be filled with 6 gallons of a cutting coolant. Fill by pouring coolant into the chip tray. Add coolant in the same manner when coolant is low. To drain coolant, remove hex cap screw (A, Figure 14). Follow all coolant manufacturer's instructions for safety, mixing disposal, etc.

The spray nozzle (B, Figure 14) enables the user to wash chips out of the way. There are three ball valves that control the coolant distribution to the spray nozzle and each blade guide.

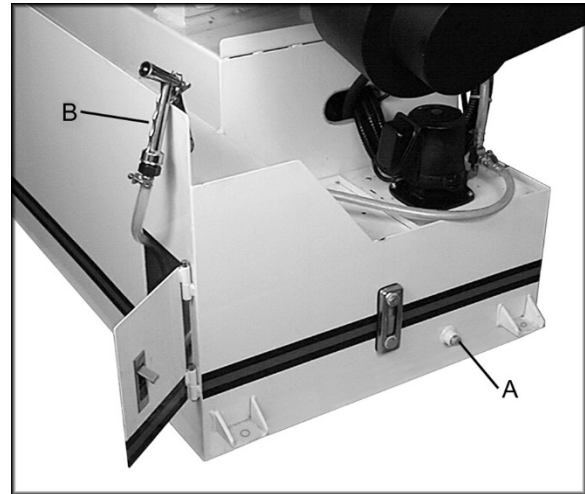


Figure 14

12.4 Replacing variable speed belt

1. Disconnect the machine from power source.
2. Take the belt cover off by removing the knob and washer.
3. Loosen tension on the belt by turning the variable speed dial (A, Figure 15) to the lowest setting. This will allow you to remove the belt (B, Figure 15).
4. When installing the new belt, turn the pulley by hand while increasing variable speed dial setting.
5. After running the machine, additional adjustment of the variable speed dial may be needed.



Figure 15

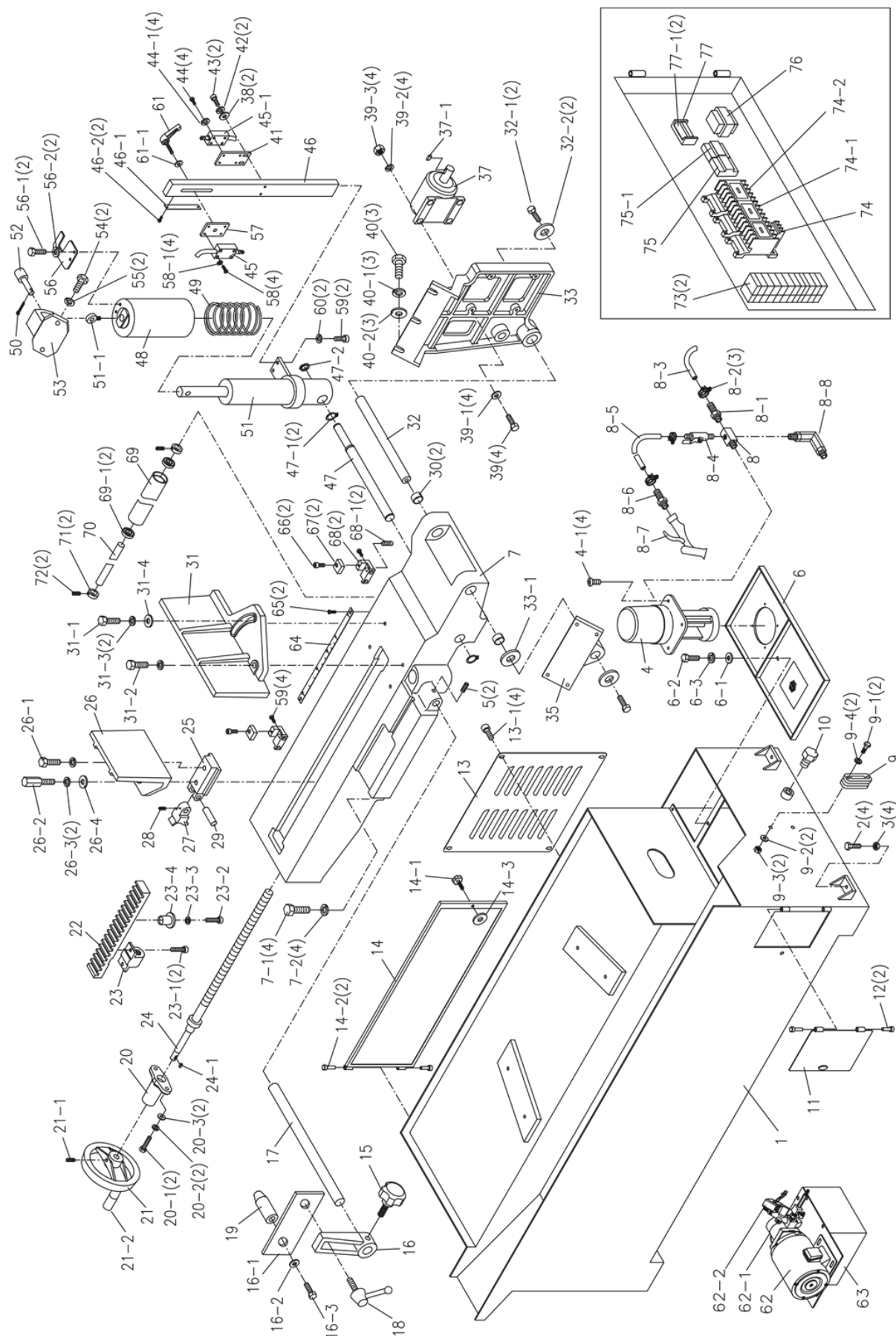
13.0 Replacement parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 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.

13.1.1 HBS-1321W – Bed and Base Assembly – Exploded View



13.1.2 HBS-1321W – Bed and Base Assembly – Parts List

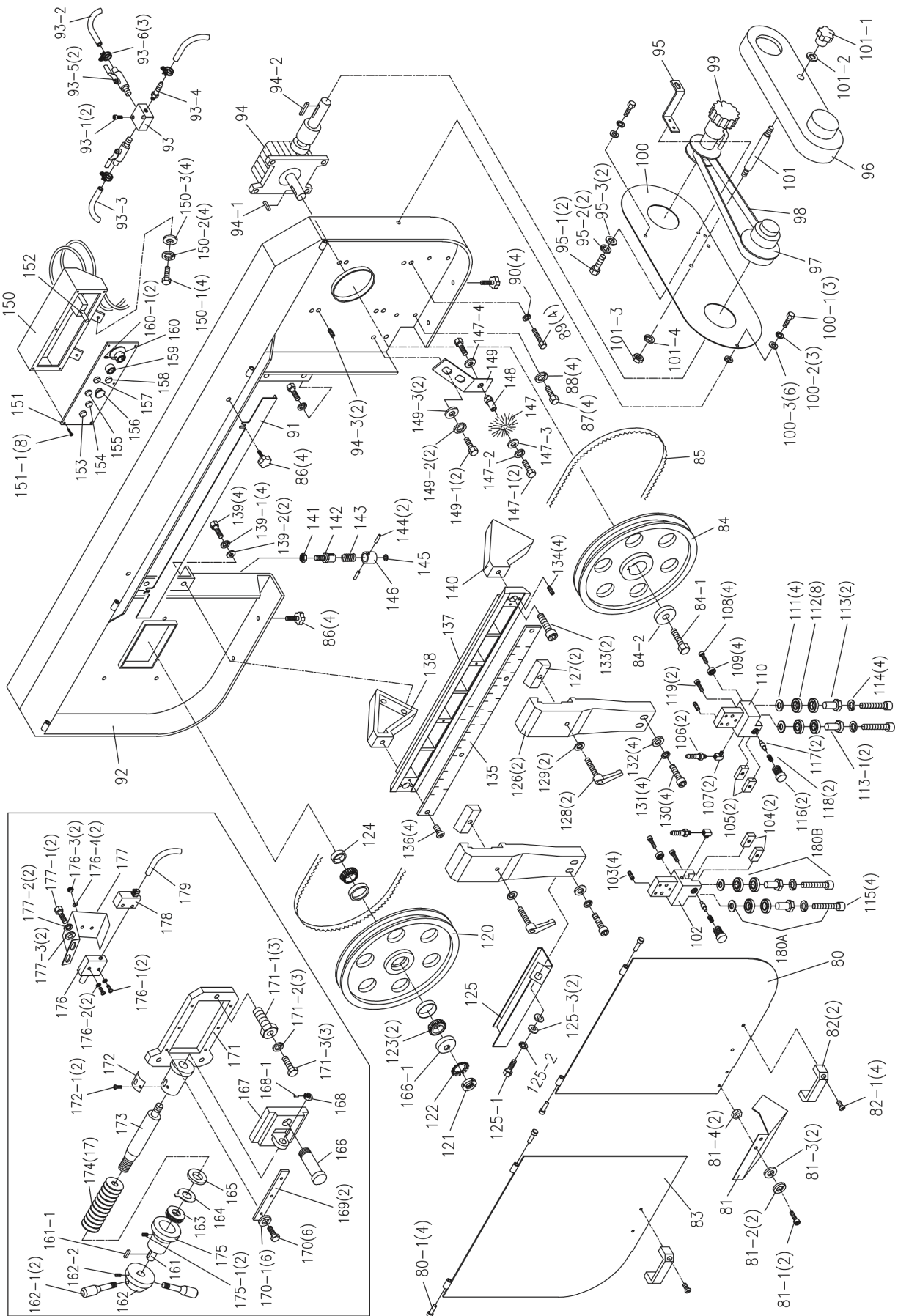
Index No	Part No	Description	Size	Qty
1	JT9-1321W-01G	Base		1
2	JT9-TS-0051071	Hex Cap Bolt	5/16"x1-1/2"	4
3	JT9-TS-1540081	Hex Nut	M12	4
4	JT9-1321W-04	Coolant Pump	1/6HP	1
4-1	JT9-1321W-04-1	Cross Point Screw	M6x15	4
5	JT9-TS-1524041	Set Screw	M8x16	2
6	JT9-1321W-06G	Coolant Tank Cover		1
6-1	CM9-TS-1550041	Washer	M6	1
6-2	CM9-TS-1503031	Hex Socket Cap Screw	M6x12	1
6-3	JT9-TS-1551041	Spring Washer	M6	1
7	JT9-1321W-07G	Bed		1
7-1	**	Hex Cap Bolt	M12x50	4
7-2	**	Spring Washer	M12	4
8	**	Connector		1
8-1	JT9-1321W-08-1	Hose Fitting	3/8Px3/8	1
8-2	**	Hose Clamp		3
8-3	**	Hose	3/8"x1200	1
8-4	JT9-1321W-08-4	On/Off Valve	3/8PTx3/8	1
8-5	JT9-1321W-08-5	Hose	3/8"x2800	1
8-6	**	Hose Fitting		1
8-7	JT9-1321W-08-7	Coolant Nozzle		1
8-8	**	Connector		1
9	JT9-1321W-09	Coolant Gauge		1
9-1	JT9-TS-1491041	Pan Head Screw	M10x30	2
9-2	JT9-5051911	Washer	M10	2
9-3	JT9-TS-1540071	Hex Nut	M10	2
9-4	**	Spring Washer	M10	2
10	CM9-1321W-10	Drain Plug		1
11	JT9-1321W-11G	Front Door w/Latch		1
12	JT9-1321W-12	Hinge Pin		2
13	JT9-1321W-13G	Panel Cover		1
13-1	**	Round Cross Cap Screw	M6x12	4
14	JT9-1321W-14G	Electrical Panel Plate		1
14-1	**	Knob		1
14-2	JT9-1321W-14-2	Hinge Pin		2
14-3	**	Hex Nut	M6	1
15	JT9-1321W-15	Lock Knob		1
16	JT9-1321W-16	Stop Bracket		1
16-1	JT9-1321W-16-1	Connecting Plate		1
16-2	JT9-1321W-16-2	Lock Washer		1
16-3	JT9-1321W-16-3	Hex Cap Bolt		1
17	JT9-1321W-17	Stop Rod		1
18	JT9-1321W-18	Lock Handle		1
19	JT9-1321W-19	Work Stop		1
20	JT9-1321W-20G	Lead Screw Seat		1
20-1	JT9-TS-1504061	Hex Socket Cap Screw	M8x30	2
20-2	JT9-TS-1551081	Spring Washer	M8	2
20-3	JT9-TS-1550061	Washer	M8	2
21	JT9-1321W-21	Handle Wheel Assembly		1
21-1	JT9-TS-0270031	Set Screw	3/8"x3/8"	1
21-2	JT1-454	Handle		1
22	JT9-1321W-22	Rack		1
23	JT9-1321W-23	Lead Screw Seat		1
23-1	JT9-TS-1504041	Hex Socket Cap Screw	M8x20	2
23-2	JT9-TS-1504051	Hex Socket Cap Screw	M8x25	1
23-3	**	Spring Washer	M8	1
23-4	**	Bushing		1

Index No	Part No	Description	Size	Qty
24	JT9-1321W-24	Lead Screw		1
24-1	JT9-1321W-24-1	Key		1
25	JT9-1321W-25	Slide Bracket		1
26	JT9-1321W-26	Vise Jaw - Left		1
26-1	JT9-TS-1492041	Hex Cap Bolt	M12x40	1
26-2	JT9-1321W-26-2	Locking Bolt	M12x45	1
26-3	JT9-TS-1551081	Spring Washer	M12	2
26-4	JT9-TS-1550061	Washer	M12x35x5W	1
27	JT9-1321W-27	Rack Block		1
28	JT9-TS-2276081	Set Screw	M6x8	1
29	JT9-1321W-29	Pin		1
30	JT9-1321W-30	Needle Bearing	CB3020	2
31	JT9-1321W-31	Vise Jaw - Right		1
31-1	JT9-1321W-31-1	Hex Cap Bolt	M16x50	1
31-2	JT9-1321W-31-2	Hex Cap Bolt	M16x40	1
31-3	JT9-1321W-31-3	Spring Washer	M16	2
31-4	JT9-1321W-31-4	Washer	M16x35x5W	1
32	**	Pivot Shaft		1
32-1	**	Hex Cap Bolt	M12x20	2
32-2	JT9-TS-1550081	Washer	M12	2
33	JT9-1321W-33G	Pivot Bracket		1
33-1	JT9-1321W-33-1	Spacer		1
35	JT9-1321W-35G	Support Bracket Seat		1
37	JT9-1321W-37	Motor	3HP, 3Ph	1
37-1	**	Key	8x7x50	1
38	CM9-TS-1550041	Flat Washer	M6	2
39	**	Hex Cap Bolt	M10x45	4
39-1	JT9-5051911	Flat Washer	M10	4
39-2	**	Spring Washer	M10	4
39-3	JT9-TS-1540071	Hex Nut	M10	4
40	JT9-TS-1492051	Hex Cap Bolt	M12x50	3
40-1	JT9-TS-1551081	Spring Washer	M12	3
40-2	JT9-TS-1550081	Washer	M12	3
41	JT9-1321W-41	Switch Mounting Plate		1
42	JT9-TS-1551041	Spring Washer	M6	2
43	JT9-TS-1482041	Hex Cap Bolt	M6x20	2
44	**	Cross Point Screw	M5x35	4
44-1	**	Spring Washer	M5	4
45	JT9-1321W-45	Limit Switch	5101	1
45-1	JT9-1321W-45-1	Roller Limit Switch	5102	1
46	CM9-1321W-46	Adjusting Bracket		1
46-1	**	Scale Plate		1
46-2	**	Rivet		2
47	**	Cylinder Support Rod		1
47-1	**	C-Clip	S32	2
47-2	**	C-Clip	S28	1
48	**	Cylinder Cover		1
49	**	Spring		1
50	**	Retaining Pin		1
51	JT9-1321W-51	Cylinder Assembly		1
51-1	**	Holder		1
52	CM9-1321W-52	Cylinder Pin		1
53	**	Top Mounting Plate		1
54	JT9-TS-1492031	Hex Cap Bolt	M12x35	2
55	JT9-TS-1551081	Spring Washer	M12	2
56	**	Plate		1
56-1	JT9-TS-1482021	Hex Cap Bolt	M6x12	2
56-2	JT9-TS-1551041	Spring Washer	M6	2
57	**	Switch Mounting Plate		1

Index No	Part No	Description	Size	Qty
58	**	Cross Point Screw	5/32"x1-1/2"	4
58-1	**	Spring Washer	M5	4
59	JT9-TS-1504051	Hex Socket Cap Screw	M8x25	6
60	JT9-TS-1551081	Spring Washer	M8	2
61	JT9-1321W-61	Handle		1
61-1	JT9-5051911	Washer	M10	1
62	JT9-1321W-62	Hydraulic Pump Motor		1
62-1	JT9-1321W-62-1	Pump		1
62-2	JT9-1321W-62-2	Solenoid Valve		1
62-3	**	Hydraulic Fill Cap		1
63	JT9-1321W-HPCA	Hydraulic Pump Complete Assembly		1
64	JT9-1321W-64	Scale		1
65	JT9-1321W-65	Rivet		2
66	CM9-TS-1503031	Hex Socket Cap Screw	M6x12	2
67	**	Plate		2
68	JT9-1321W-68G	Roller Seat		2
68-1	JT9-TS-1525021	Set Screw	M10x12	2
69	JT9-1321W-69	Support Roller		2
69-1	**	Ball Bearing	6004ZZ	2
70	**	Rod		1
71	**	Knob		2
72	JT9-TS-2276081	Set Screw	M6x8	2
73	JT9-1321W-73	Terminal Strip		2
74	JT9-1321W-74	Magnetic Switch (w/Overload)		1
74-1	JT9-1321W-74-1	Magnetic Switch		1
74-2	JT9-1321W-74-2	Magnetic Switch		1
75	JT9-1321W-75	Relay		1
75-1	JT9-1321W-75-1	Relay		1
76	JT9-1321W-76	Transformer		1
77	JT9-1321W-77	Fuse Case		1
77-1	JT9-1321W-77-1	Fuse (3A)		2

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

13.2.1 HBS-1321W – Arm Assembly – Exploded View



13.2.2 HBS-1321W – Arm Assembly – Parts List

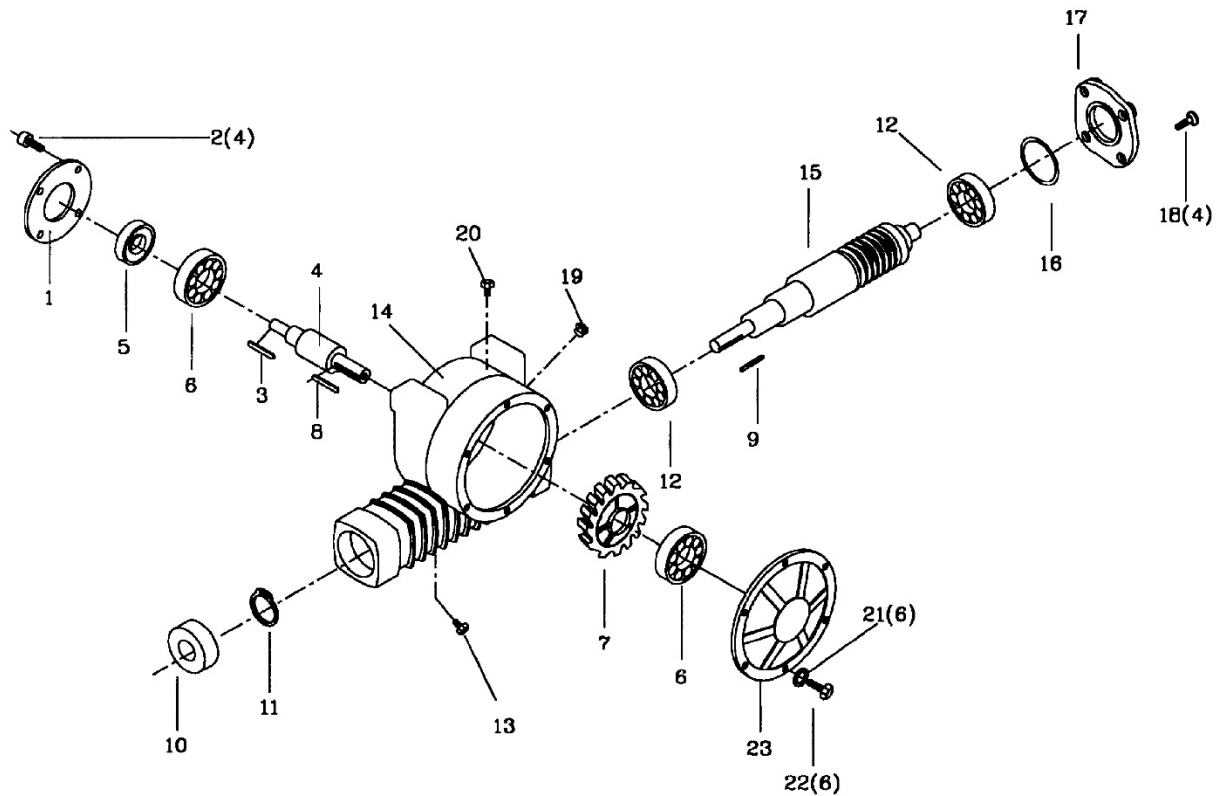
Index No	Part No	Description	Size	Qty
80	JT9-1321W-80G	Blade Wheel Cover - R		1
80-1	JT9-1321W-80-1	Hinge Pin		4
81	JT9-1321W-81	Brush Cover		1
81-1	JT9-TS-1482021	Hex Cap Bolt	M6x12	2
81-2	JT9-TS-1551041	Spring Washer	M6	2
81-3	CM9-TS-1550041	Flat Washer	M6	2
81-4	CM9-TS-2311061	Nut	M6	2
82	JT9-1321W-82	Handle		2
82-1	**	Cross Point Screw	M6x12	4
83	JT9-1321W-83G	Blade Wheel Cover - L		1
84	JT9-1321W-84	Drive Wheel		1
84-1	**	Hex Cap Bolt	M12x20	1
84-2	JT9-TS-2360121	Washer	M12	1
85	JT9-414314	Saw Blade	1-1/4" x .042" x 161-1/2"	1
86	JT9-1321W-86	Knob		8
87	JT9-TS-1491041	Hex Cap Bolt	M10x30	4
88	JT9-TS-1551071	Spring Washer	M10	4
89	JT9-TS-1492031	Hex Cap Bolt	M12x35	4
90	JT9-TS-1551081	Spring Washer	M12	4
91	JT9-1321W-91G	Blade Guard		1
92	JT9-1321W-92G	Blade Wheel Box Assembly		1
93	JT9-1321W-93	Connector		1
93-1	**	Hex Socket Cap Screw	M6x20	2
93-2	**	Hose		1
93-3	**	Hose		1
93-4	**	Hose Fitting	1/4Px3/8	1
93-5	**	On/Off Valve	1/4PTx5/16	2
93-6	**	Hose Clamp		3
94	JT9-1321W-94G	Gear Box Assembly		1
94-1	JT9-1321W-94-1	Key	12x8x32	1
94-2	JT9-1321W-94-2	Key	7x7x40	1
94-3	JT9-TS-1525041	Set Screw	M10x12	2
95	JT9-1321W-95	Plate		1
95-1	JT9-TS-1482021	Hex Cap Bolt	M6x12	2
95-2	JT9-TS-1551041	Spring Washer	M6	2
95-3	CM9-TS-1550041	Washer	M6	2
96	JT9-1321W-96	Pulley Cover		1
97	JT9-1321W-97	Input Pulley		1
98	JT9-1321W-98	Belt	1922V443	1
99	JT9-1321W-99	Output Pulley Assembly		1
100	**	Cover Plate		1
100-1	JT9-TS-1490021	Hex Cap Bolt	M8x16	3
100-2	JT9-TS-1551081	Spring Washer	M8	3
100-3	JT9-TS-1550061	Washer	M8	6
101	JT9-1321W-101	Shaft		1
101-1	JT9-1321W-101-1	Knob		1
101-2	**	Washer	5/16"	1
101-3	**	Nut	5/16"	1
101-4	**	Spring Washer	M8	1
102	JT9-1321W-102	Guide Bracket - L		1
103	JT9-TS-1524041	Set Screw	M8x16	4
104	JT9-1321W-104	Blade Guide Assembly-L		2
105	JT9-1321W-105	Blade Guide Assembly-R		2
106	JT9-1321W-106	Connector		2
107	JT9-1321W-107	Cu Connector		2
108	JT9-TS-1490051	Hex Socket Cap Screw	M8x30	4
109	**	Ball Bearing	608Z	4
110	JT9-1321W-110	Guide Bracket - R		1
111	JT9-TS-1550061	Flat Washer	M8	4
112	JT9-BB-6201VV	Ball Bearing	6201RS	8

Index No	Part No	Description	Size	Qty
113	JT9-1321W-113	Sleeve		2
113-1	JT9-1321W-113-1	Eccentric Sleeve		2
114	JT9-TS-1551081	Spring Washer	M8	4
115	JT9-TS-1490081	Hex Socket Cap Screw	M8x45	4
116	JT9-1321W-116	Adjusting Knob		2
117	JT9-1321W-117	Small Shaft		2
118	JT9-1321W-118	Spring		2
119	JT9-1321W-119	Hex Socket Cap Screw	M6x16	2
120	JT9-1321W-120	Idle Blade Wheel		1
121	JT9-1321W-121	Jam Nut		1
122	JT9-1321W-122	Star Washer		1
123	JT9-BB-30206	Taper Roller Bearing	30206	2
124	JT9-1321W-124	Spacer		1
125	JT9-1321W-125	Blade Guard		1
125-1	JT9-TS-1490021	Hex Cap Bolt	M8x16	1
125-2	JT9-TS-1551041	Spring Washer	M8	1
125-3	CM9-TS-2361081	Washer	M8	2
126	JT9-1321W-126G	Adjusting Bracket Mount		2
127	JT9-1321W-127	Lock Block		2
128	JT9-1321W-128	Handle		2
129	JT9-5051911	Washer	M10	2
130	JT9-TS-1505051	Hex Socket Cap Screw	M10x40	4
131	JT9-TS-1551071	Spring Washer	M10	4
132	JT9-5051911	Washer	M10	4
133	JT9-TS-1550081	Hex Socket Cap Screw	M12x25	2
134	JT9-TS-1524041	Set Screw	M8x16	4
135	JT9-1321W-135	Scale Plate		1
136	**	Cross Point Screw		4
137	JT9-1321W-137G	Slide Bracket		1
138	JT9-1321W-138G	Blade Bracket - L		1
139	JT9-TS-1492021	Hex Cap Bolt	M12x30	4
139-1	JT9-TS-1551081	Spring Washer	M12	4
139-2	JT9-TS-2361121	Washer	M12	2
140	JT9-1321W-140G	Blade Bracket - R		1
141	**	Hex Nut	M12	1
142	JT9-1321W-142	Stop Support		1
143	JT9-1321W-143	Spring		1
144	**	Pin		2
145	JT9-1321W-145	Rubber Pad		1
146	**	Stop Block		1
147	JT9-5714111	Brass Wire Brush		1
147-1	JT9-TS-1482021	Hex Cap Bolt	M6x12	2
147-2	JT9-TS-1551041	Spring Washer	M6	1
147-3	CM9-TS-1550041	Washer	M6	1
147-4	JT9-TS-0720071	Washer	1/4"	1
148	JT9-1321W-148	Bushing		1
149	JT9-1321W-149	Brush Bracket		1
149-1	JT9-TS-1482031	Hex Cap Bolt	M6x16	2
149-2	JT9-TS-1551041	Spring Washer	M6	2
149-3	CM9-TS-1550041	Washer	M6	2
150	JT9-1321W-150	Control Box		1
150-1	JT9-TS-1482021	Hex Cap Bolt	M6x12	4
150-2	JT9-TS-1551041	Spring Washer	M6	4
150-3	CM9-TS-1550041	Washer	M6	4
151	JT9-1321W-151	Control Panel		1
151-1	JT9-1321W-151-1	Cross Point Screw	M5x10	8
152	JT9-1321W-152	Downfeed Valve Assembly		1
153	JT9-1321W-153	Power Indicator Light		1
154	JT9-1321W-154	Start Button		1
155	JT9-1321W-155	Stop Button		1
156	JT9-1321W-156	Emergency Switch		1
157	JT9-1321W-157	Arm Up Switch		1

Index No	Part No	Description	Size	Qty
158	JT9-1321W-158	Arm Down Switch		1
159	JT9-1321W-159	On/Off Coolant Switch		1
160	JT9-1321W-160	Downfeed Control Knob		1
160-1	JT9-TS-1523061	Set Screw	M6x20	2
161	JT9-1321W-161	Extension Bar		1
161-1	JT9-1321W-161-1	Key	5x5x30	1
162	JT9-1321W-162	Handle Base		1
162-1	JT9-1321W-162-1	Handle		2
162-2	JT9-TS-1524021	Set Screw	M8x10	1
163	JT9-1321W-163	Thrust Bearing	51105	1
164	JT9-1321W-164	Indicator Washer		1
165	JT9-1321W-165	Spacer		1
166	JT9-1321W-166	Blade Wheel Bracket Shaft		1
166-1	JT9-1321W-166-1	Cover		1
167	JT9-1321W-167G	Slide Bracket		1
168	JT9-1321W-168	Adjusting Nut		1
168-1	JT9-TS-2276081	Set Screw	M6x8	1
169	JT9-1321W-169	Slide Plate		2
170	JT9-TS-1504041	Hex Socket Cap Screw	M8x20	6
170-1	JT9-TS-1551061	Spring Washer	M8	6
171	JT9-1321W-171G	Extension Bracket		1
171-1	JT9-1321W-171-1	Sleeve	M20x35	3
171-2	JT9-TS-1551081	Spring Washer	M12	3
171-3	JT9-1321W-171-3	Hex Cap Bolt	M12x70	3
172	JT9-1321W-172	Blade Extension Scale		1
172-1	JT9-1321W-172-1	Cross Point Screw	M5x8	2
173	JT9-1321W-173	Spring Support Shaft		1
174	JT9-1321W-174	Belleville Spring	W=2.5mm	17
175	JT9-1321W-175	Stop Flange		1
175-1	JT9-1321W-175-1	Set Screw	M8x20	2
176	JT9-1321W-176	Limit Switch	1307	1
176-1	JT9-1321W-176-1	Cross Point Screw	5/32"x1-1/4"	2
176-2	**	Spring Washer	M4	2
176-3	JT9-TS-1540021	Nut	M4	2
176-4	JT9-TS-1551021	Washer	M4	2
177	JT9-1321W-177	Cover		1
177-1	JT9-TS-1482021	Hex Cap Bolt	M6x12	2
177-2	JT9-TS-1551041	Spring Washer	M6	2
177-3	CM9-TS-1550041	Washer	M6	2
178	JT9-1321W-178	Relief Bushing		1
179	JT9-1321W-179	Electrical Wire	0.5/2Cx430cm	1
180A	JT9-1321W-180A	Eccentric Sleeve Assembly (#111,112,113-1,114,115)		2
180B	JT9-1321W-180B	Sleeve Assembly (#111,112,113,114,115)		2
	JT9-JET-254	JET Logo (not shown)	254x105mm	1
	JT9-1321W-181C1	New Laser Guide Assembly		1
	**	(Including 1321W-181C2 & 1321W-181C3) (not shown)		
	CM9-1321W-181C2	Seat Assembly of Laser Guide w/o Laser (not shown)		1
	CM9-1321W-181C3	Laser Guide and Transformer with Power Cord (not shown)		1

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

13.3.1 HBS-1321W – Gear Reducer Box Assembly – Exploded View

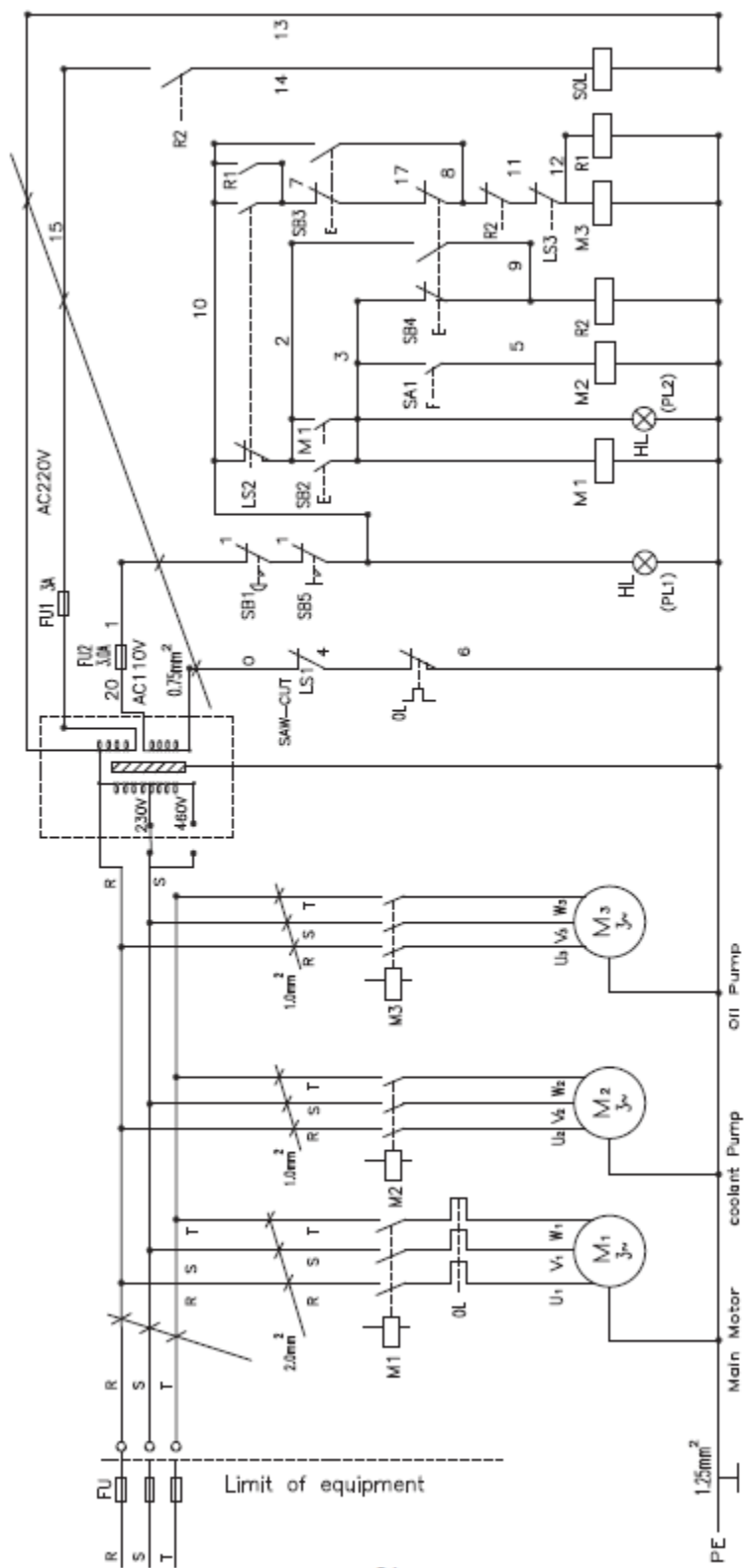


13.3.2 HBS-1321W – Gear Reducer Box Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	**	Output Shaft Cover.....		1
2	JT9-TS-1482031	Hex Socket Cap Screw.....	M6x16	4
3	JT9-1321W-94-03K	Key	12x8x30 mm	1
4	JT9-1321W-94-44	Output Shaft with Bearings (s/n 1711PI00576 and higher)		1
5	JT9-1321W-94-05	Oil Seal	TC50X70X10	1
6	**	Roller Bearing (RE:#4)	BNJ210	2
7	JT9-1321W-94-07	Worm		1
8	JT9-1321W-94-08K	Key	16x10x75 mm	1
9	CM9-KS-7750	Key	7x7x50 mm	1
10	JT9-1321W-94-10	Oil Seal	SC30x62x7	1
11	**	C-Clip.....	R62	1
12	JT9-1321W-94-12	Taper Roller Bearing	30206	2
13	JT9-1321W-94-13	Drain Plug.....	1/4"PT	1
14	**	Gear Box		1
15	JT9-1321W-94-15	Worm Shaft.....		1
16	JT9-1321W-94-16	Gasket		1
17	**	Input Shaft Cover.....		1
18	JT9-TS-1504041	Hex Socket Cap Screw.....	M8x20	4
19	JT9-1321W-94-19	Clear Oil Glass	25	1
20	JT9-1321W-94-20	Fill Oil Plug	3/8"PT	1
21	JT9-TS-1551071	Spring Washer.....	M10	6
22	JT9-TS-1491041	Hex Cap Bolt	M10x30	6
23	**	Worm Shaft Cover		1

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14.0 Electrical Connections – HBS-1321W



14.1 Wiring Diagram Symbol Glossary

Index No	Part No	Description	Size	Qty
LS1	JT9-1321W-45	Cut off Limit Switch		
LS2	JT9-1321W-45-1	Roller Limit Switch		
SB1	JT9-1321W-156	Emergency Switch		
SB2	JT9-1321W-154	Start Switch		
SB3	JT9-1321W-158	rm Down Switch.....		
SB4	JT9-1321W-157	rm Up Switch		
SB5	JT9-1321W-155	Stop Switch.....		
HL.....	JT9-1321W-153	Power Indicator Light.....		
TC	JT9-1321W-76	Control Transformer		
FU1	JT9-1321W-77-1	3 Fuse.....		
FU2	JT9-1321W-77	3 Fuse.....		
M1	JT9-1321W-74	Magnetic Switch (w/OL).....		
M2	JT9-1321W-74-1	Magnetic Switch		
M3	JT9-1321W-74-2	Magnetic Switch		
R1.....	JT9-1321W-75	rm Up Relay.....		
R2.....	JT9-1321W-75-1	rm Down Relay		
SA1	JT9-1321W-159	Coolant Pump On / Off Switch.....		
SOL	JT9-1321W-152	SOL Valve		



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