



OPERATOR'S MANUAL

Metal Working



VERTICAL TILT BAND SAW MODEL: BSVT-18P

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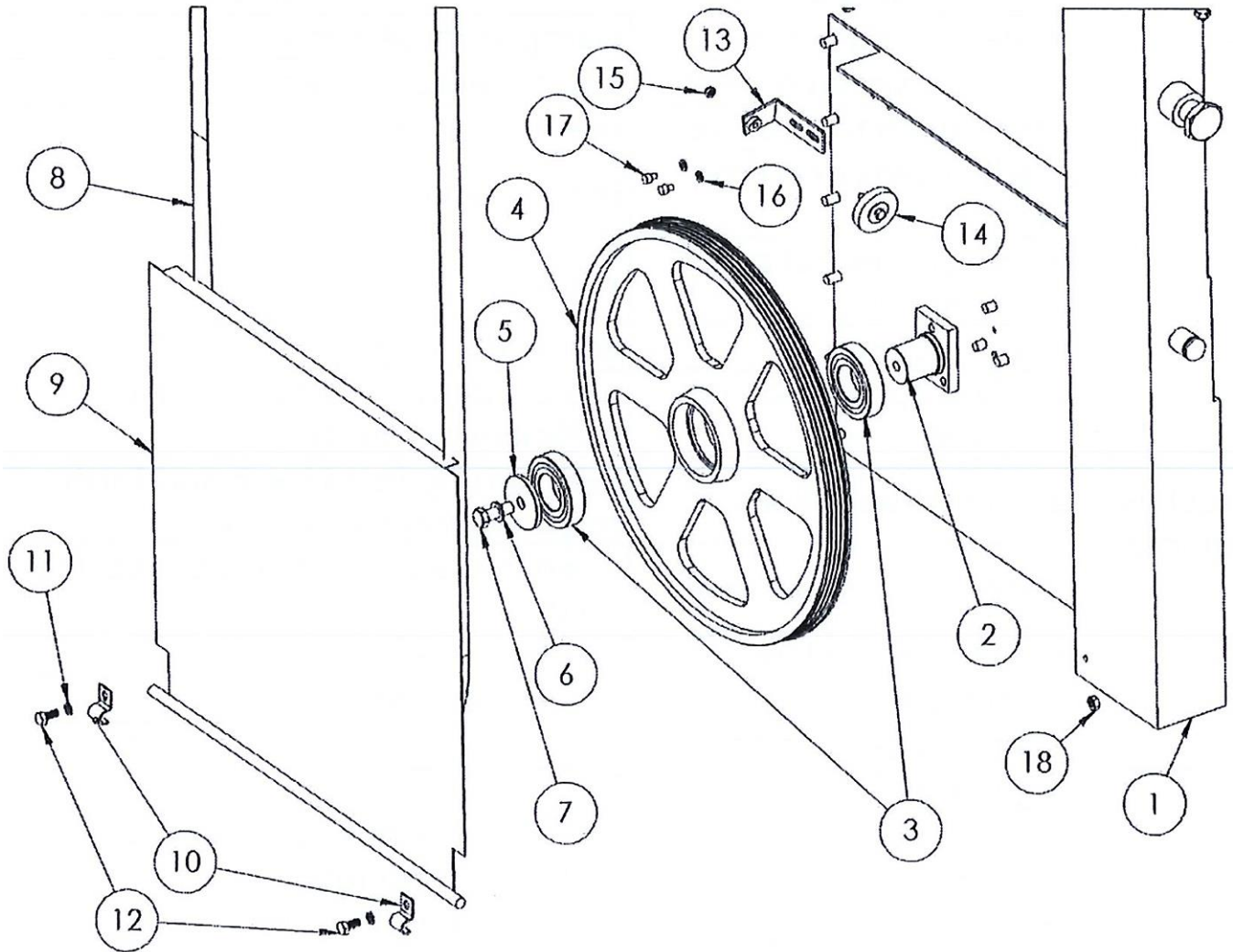


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INNER SIDE OF LOWER FRAME



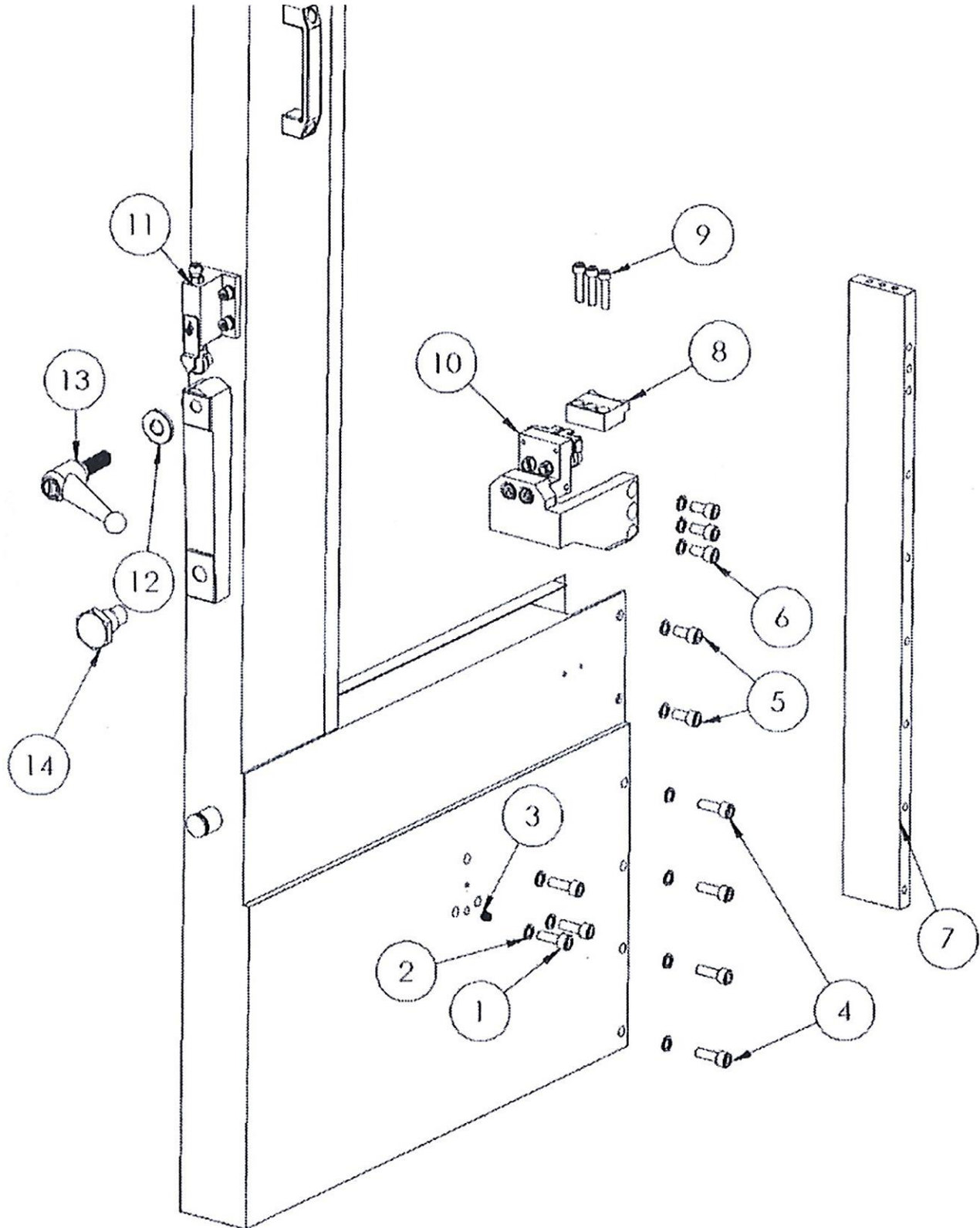


Inner Side of Lower Frame

Item	Description	Size	Qty
1	Frame-Cutting Head		1
2	Shaft-Lower Wheel		1
3	Bearing-Lower Wheel	6208-ZZ	2
4	Lower Wheel		1
5	Blade Wheel Washer		1
6	Spring Washer	M12	1
7	Bolt, Hex Head	M12 x 35L	1
8	Band Saw Blade	1-1/16" x 0.035" x 14'0.5"	1
9	Cover-Lower Wheel Housing		1
10	Hinge-Lower Cover		2
11	Flat Washer	M8	2
12	Bolt, Hex Head	M8 x 16L	2
13	Wire Brush Mount		1
14	Wire Brush	2"	1
15	Hex Nut	M6, nylon insert	1
16	Flat Washer	M6	2
17	Bolt, Socket Head	M6 x 8L	2
18	Hex Nut	M8	1



OUTER SIDE OF LOWER FRAME



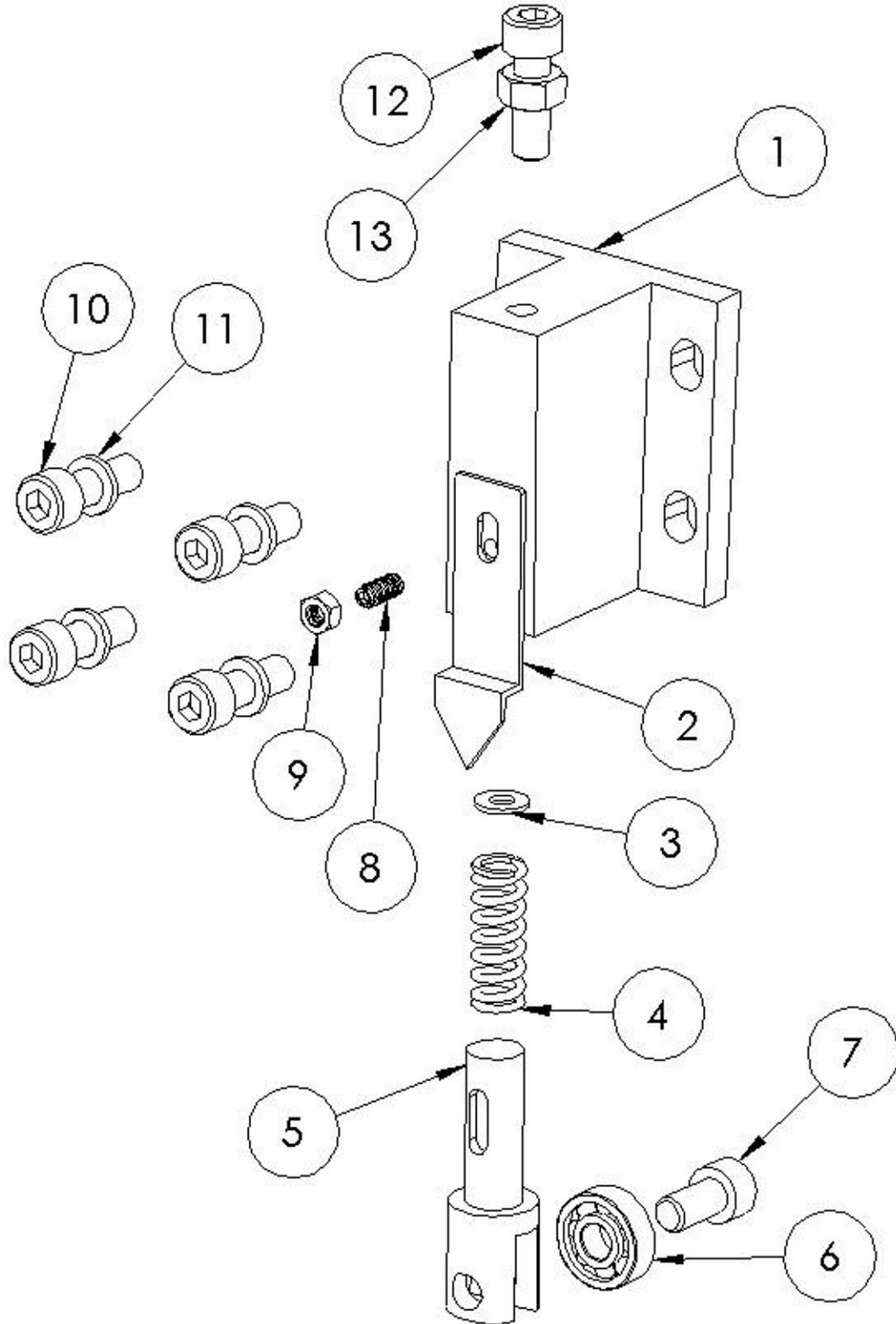


Outer Side of Lower Frame

Item	Description	Size	Qty
1	Bolt, Socket Head	M10 x 25L	3
2	Spring Washer	M10	12
3	Set Screw	M10 x 15L	1
4	Bolt, Socket Head	M10 x 30L	4
5	Bolt, Socket Head	M10 x 20L	2
6	Bolt, Socket Head	M10 x 20L	3
7	Bracket-Swivel Plate		1
8	Swivel Plate		1
9	Bolt, Socket Head	M8 x 35L	3
10	Lower Blade Guide Assembly		1
11	Angle Indicator Assembly		1
12	Washer, Angle Adjustment	M10 x 20L	2
13	Locking Handle	M16	2
14	Bolt, Pivot		1



ANGLE INDICATOR ASSEMBLY



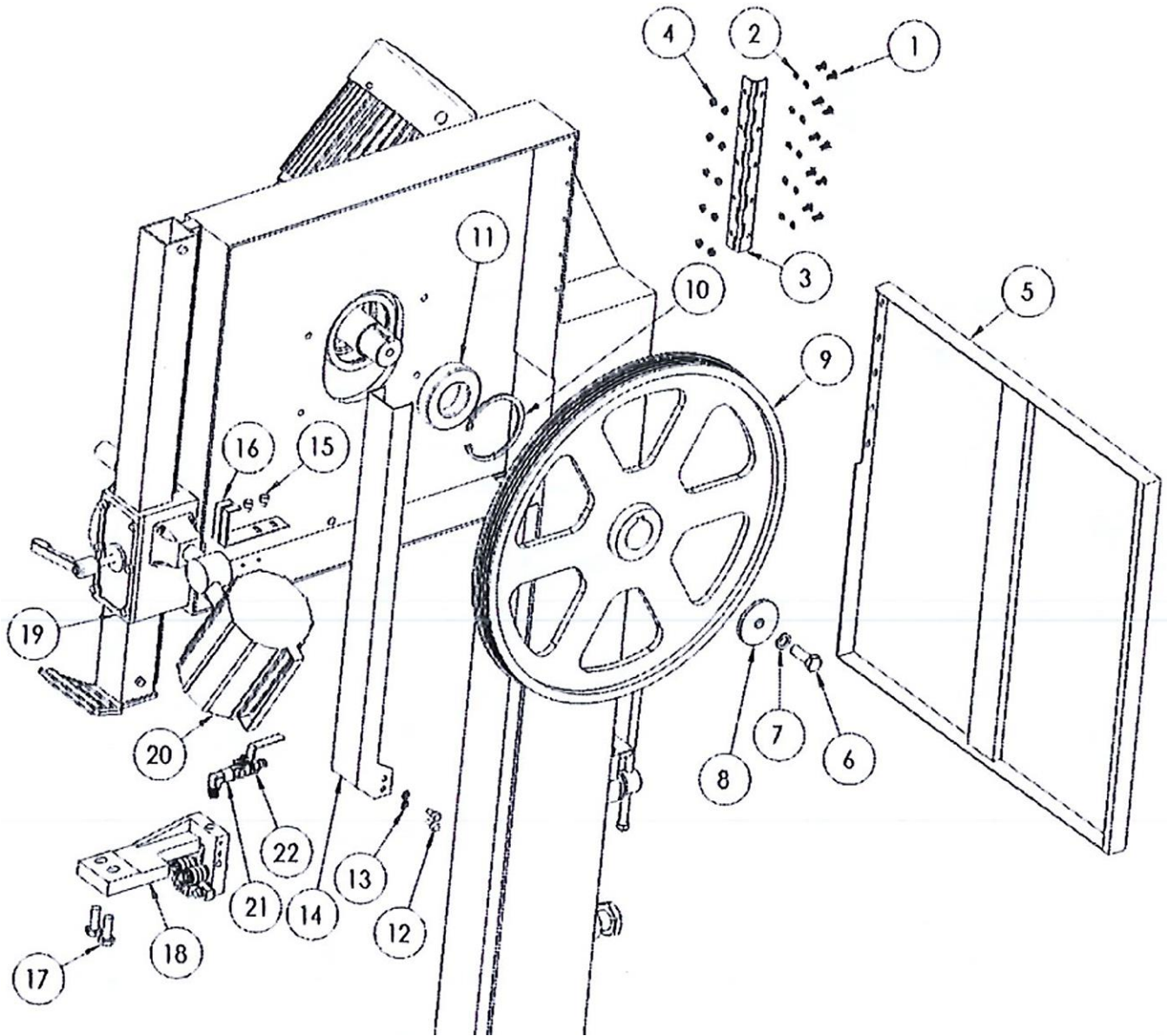


Angle Indicator

Item	Description	Size	Qty.
1	Block-Indicator		1
2	Indicator		1
3	Flat Washer	M5	1
4	Spring-Indicator Block		1
5	Shaft-Indicator Block		1
6	Bearing	608ZZ	1
7	Bolt, Socket Head	M8 x 16L	1
8	Set Screw	M5 x 12L	1
9	Nut	M5	1
10	Bolt, Socket Head	M8 x 25L	4
11	Spring Washer	M8	4
12	Bolt, Socket Head	M8 x 25L	1
13	Nut	M8	1



INNER SIDE OF UPPER FRAME



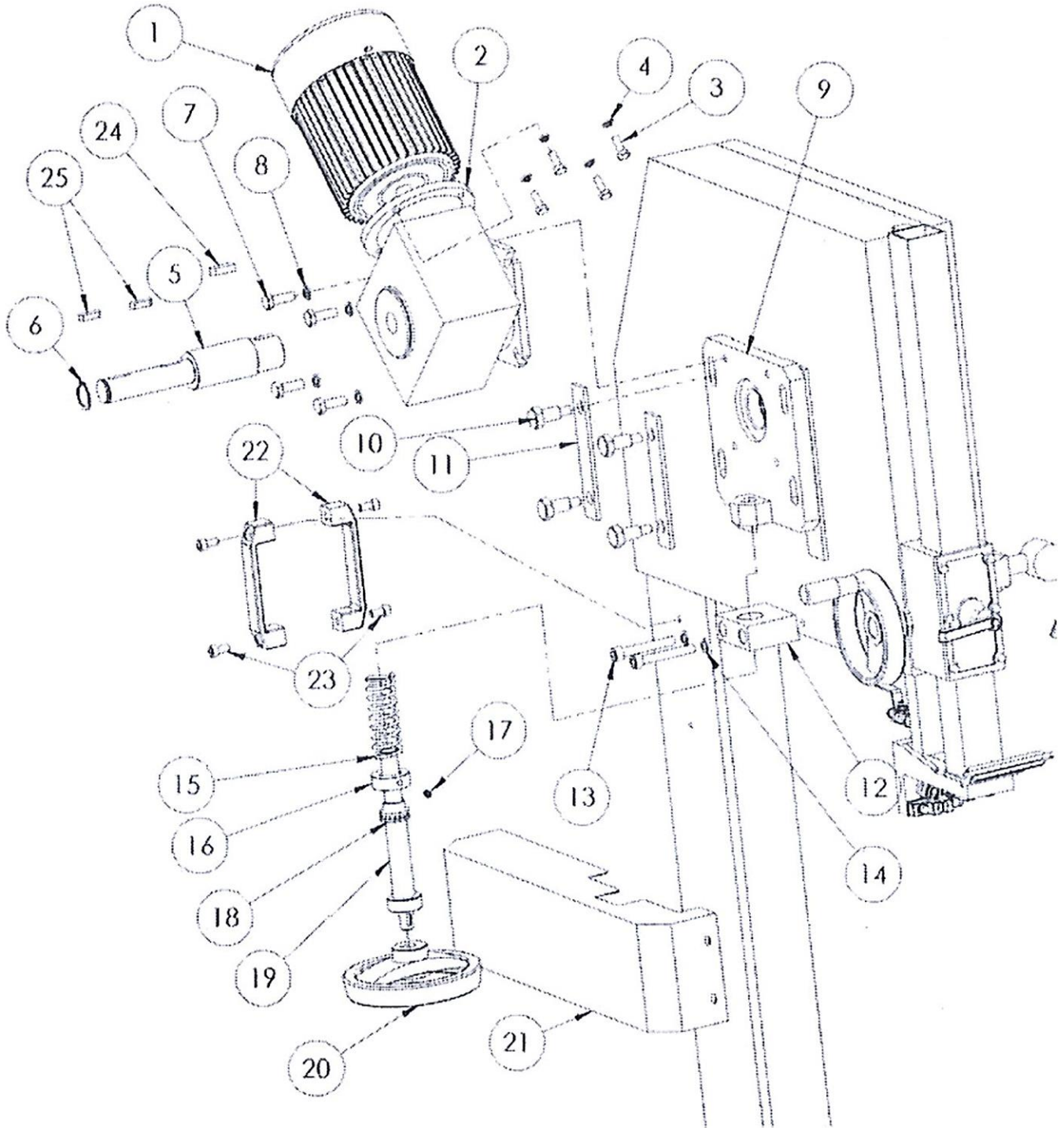


Inner Side of Upper Frame

Item	Description	Size	Qty
1	Bolt, Philips Round Head	M5 x 10L	10
2	Spring Washer	M5	10
3	Hinge-Upper Cover		1
4	Hex Nut	M5	10
5	Cover-Upper Wheel Housing		1
6	Bolt, Hex Head	M12 x 35L	1
7	Spring Washer	M12	1
8	Blade Wheel Washer		1
9	Upper Wheel		1
10	Retaining Ring	R85	1
11	Bearing-Upper Wheel	6209ZZ	1
12	Bolt, Socket Head	M6 x 12L	2
13	Flat Washer	M6	2
14	Blade Guard		1
15	Bolt, Socket Head	M6 x 8L	2
16	Bracket-Blade Guard		1
17	Bolt, Hex Head	M10 x 30L	2
18	Upper Blade Guide Bracket		1
19	Upper Blade Guide Arm		1
20	Work Lamp	70w	1
21	Fitting	1/4NPT	1
22	Petcock		1



OUTER SIDE OF UPPER FRAME



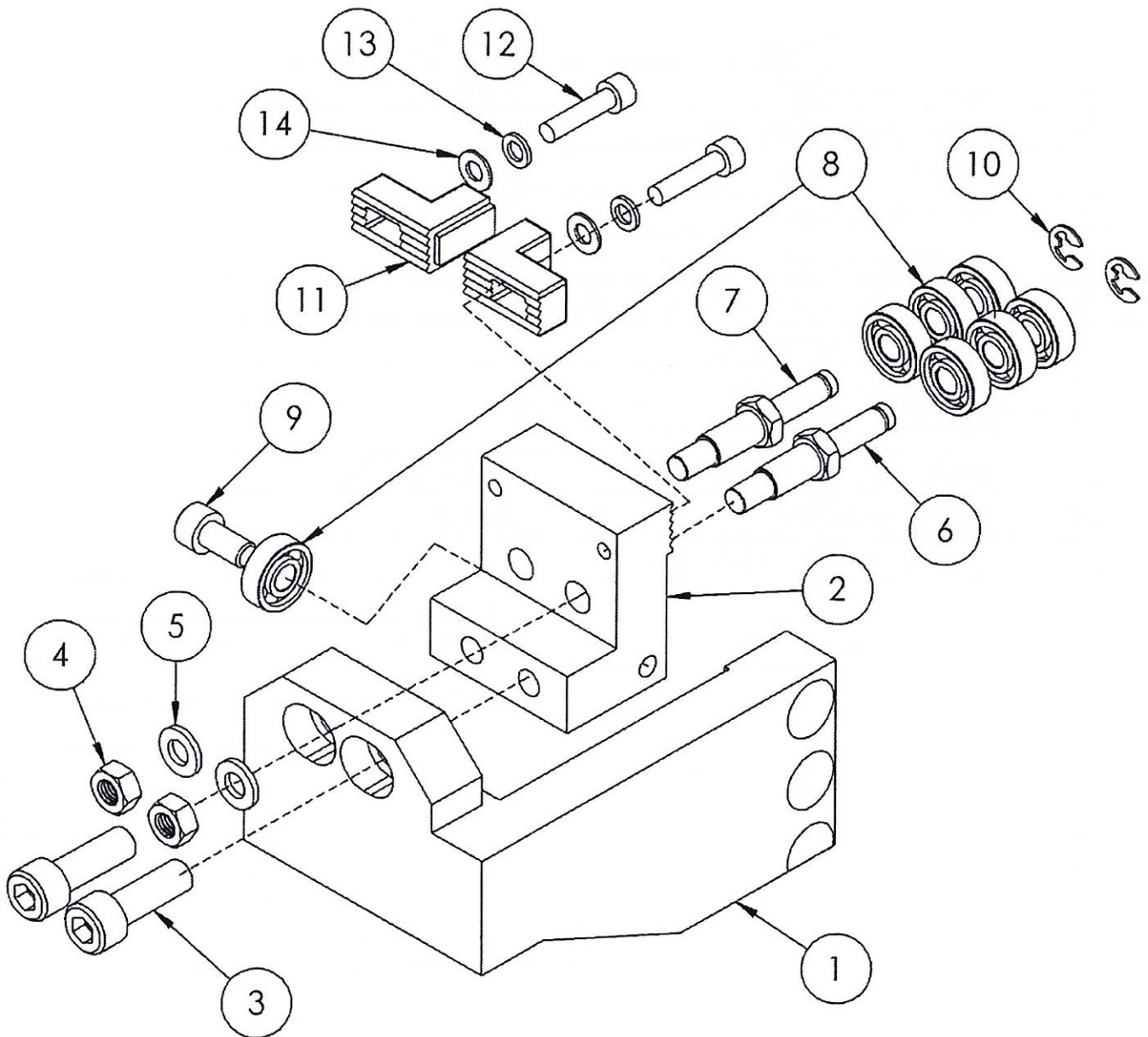


Outer Side of Upper Frame

Item	Description	Size	Qty
1	Motor	2HP, 230V, 3-Phase	1
2	Gear Reducer	1/30	1
3	Bolt, Hex Head	M8 x 22L	4
4	Spring Washer	M8	4
5	Axle-Gear Reducer		1
6	Retaining Ring	S28	1
7	Bolt, Hex Head	M10 x 30L	4
8	Spring Washer	M10	4
9	Blade Tension Sliding Plate		1
10	Shoulder Screw-Gib		4
11	Gib-Sliding Plate		2
12	Bracket-Tension Screw		1
13	Bolt, Socket Head	M10 x 70L	2
14	Spring Washer	M10	2
15	Compression Spring		1
16	Collar-Tensioning		1
17	Set Screw	M8 x 8L	1
18	Trust Bearing	51105	1
19	Blade Tension Screw		1
20	Handle Wheel	6-1/2"	1
21	Cover Sliding Plate		1
22	Pull Handle		2
23	Bolt, Socket Head	M8 x 16L	4
24	Key, Single Round	10 x 8 x 30L	1
25	Key, Double Round	8 x 7 x 28L	2



LOWER BLADE GUIDE ASSEMBLY



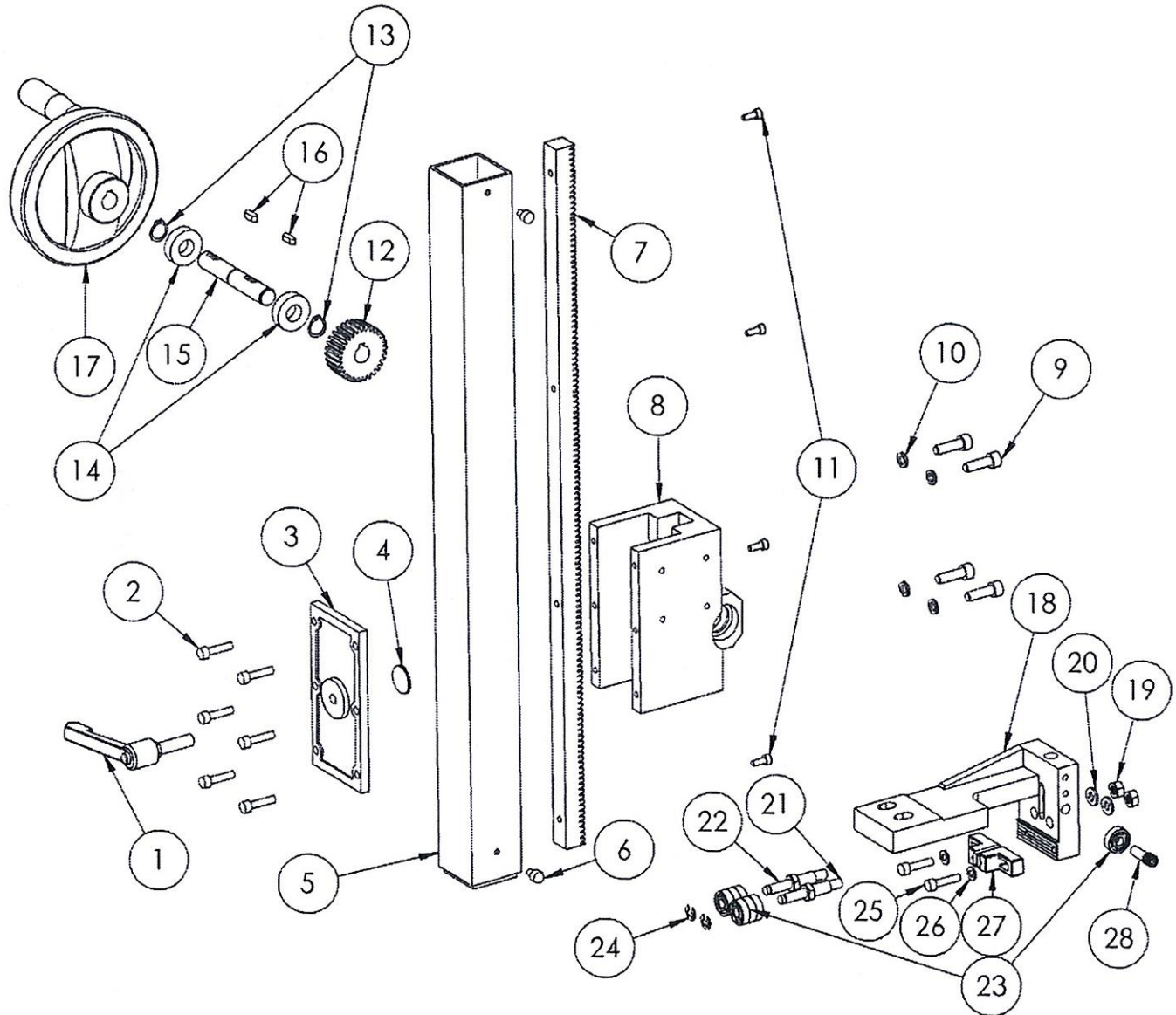


Lower Blade Guide Assembly

Item	Description	Size	Qty
1	Arm-Lower Blade Guide		1
2	Lower Blade Guide Block		1
3	Bolt, Socket Head	M10 x 30L	2
4	Hex Nut	M8	2
5	Spring Washer	M8	2
6	Eccentric Roller Shaft		1
7	Concentric Roller Shaft		1
8	Bearing	608ZZ	7
9	Bolt, Socket Head	M8 x 16L	1
10	Retaining Ring	E7	2
11	Carbide Guide		2
12	Bolt, Socket Head	M6 x 15L	2
13	Spring Washer	M6	2
14	Flat Washer	M6	2



UPPER BLADE GUIDE ASSEMBLY



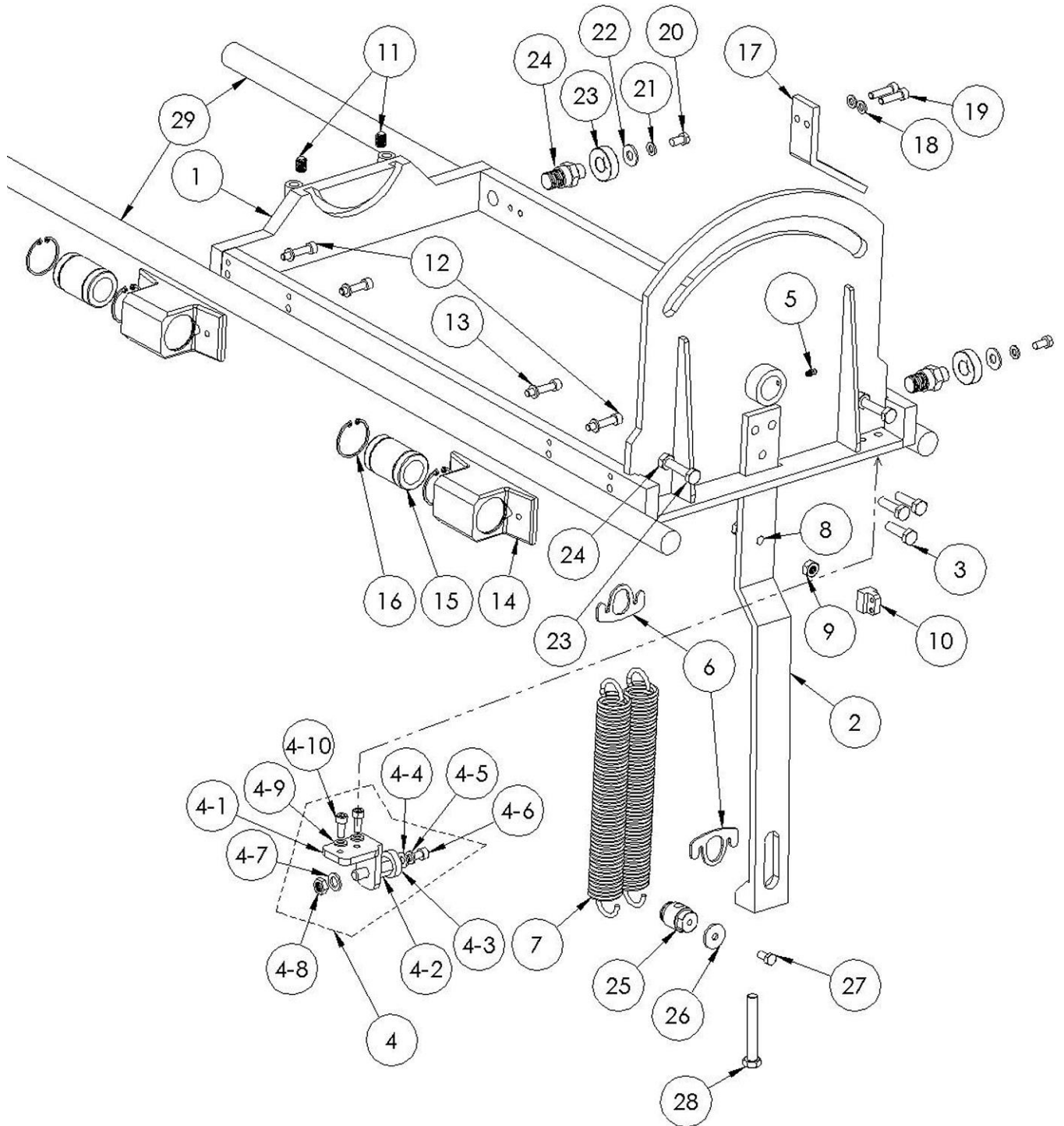


Upper Blade Guide Assembly

Item	Description	Size	Qty
1	Locking Handle	M10	1
2	Bolt, Socket Head	M6 x 25L	6
3	Cover-Upper Guide Arm		1
4	Washer-Upper Guide		1
5	Upper Guide Arm		1
6	Bolt, Socket Head	M6 x 8L	2
7	Gear Rack		1
8	Bracket-Upper Guide Arm		1
9	Bolt, Socket Head	M8 x 25L	4
10	Spring Washer	M8	4
11	Bolt, Socket Head	M5 x 12L	4
12	Gear		1
13	Retaining Ring	S15	2
14	Bearing	6002ZZ	2
15	Shaft-Upper Guide		1
16	Key-Double Round	5 x 5 x 15L	1
17	Hand Wheel	6-1/2"	1
18	Bracket-Upper Guide Bearing		1
19	Hex Nut	M8	2
20	Spring Washer	M8	2
21	Concentric Roller Shaft		1
22	Eccentric Roller Shaft		1
23	Bearing	608ZZ	7
24	Retaining Ring	E8	2
25	Bolt, Socket Head	M6 x 25L	2
26	Spring Washer	M6	2
27	Carbide Guide		2
28	Shaft-Back Roller Bearing		1



CARRIAGE ASSEMBLY



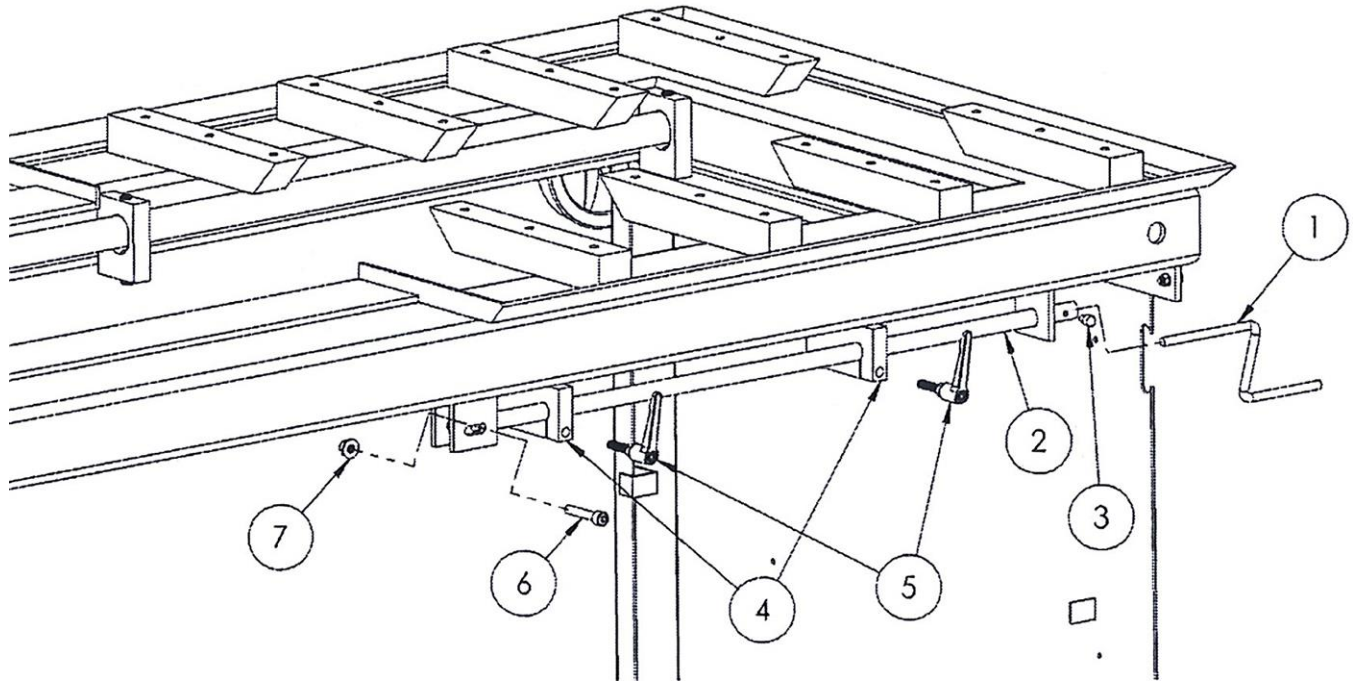


Carriage Assembly

Item	Description	Size	Qty
1	Weldment-Carriage		1
2	Arm-Extension Spring		1
3	Bolt, Hex Head	M10 x 30L	3
4	Hex Nut	M10 nylon insert	3
5	Grease Fitting	1/4"	1
6	Yoke-Extension Spring		2
7	Extension Spring		2
8	Bolt, Socket Head	M10 x 40L	1
9	Hex Nut	M10	2
10	Bracket-Feed Chain		1
11	Set Screw	M12 x 15L	2
12	Bolt, Socket Head	M8 x 40L	4
13	Spring Washer	M8	4
14	Bracket-Linear Bearing		2
15	Linear Bearing	LM30UU	2
16	Retaining Ring	R45	4
17	Carriage Stop Bracket		1
18	Spring Washer	M8	2
19	Bolt, Socket Head	M8 x 30L	2
20	Bolt, Hex Head	M8 x 16L	2
21	Spring Washer	M8	2
22	Flat Washer	7/16"	2
23	Bearing	6203ZZ	2
24	Shaft-Bearing Mount		2
25	Shaft-Lower Yoke		1
26	Washer	ID8.2 x OD30 mm	1
27	Bolt, Hex Head	M8 x 16L	1
28	Bolt, Hex Head	M12 x 90L	1
29	Carriage Way Rod		2



CARRIAGE STOP ASSEMBLY

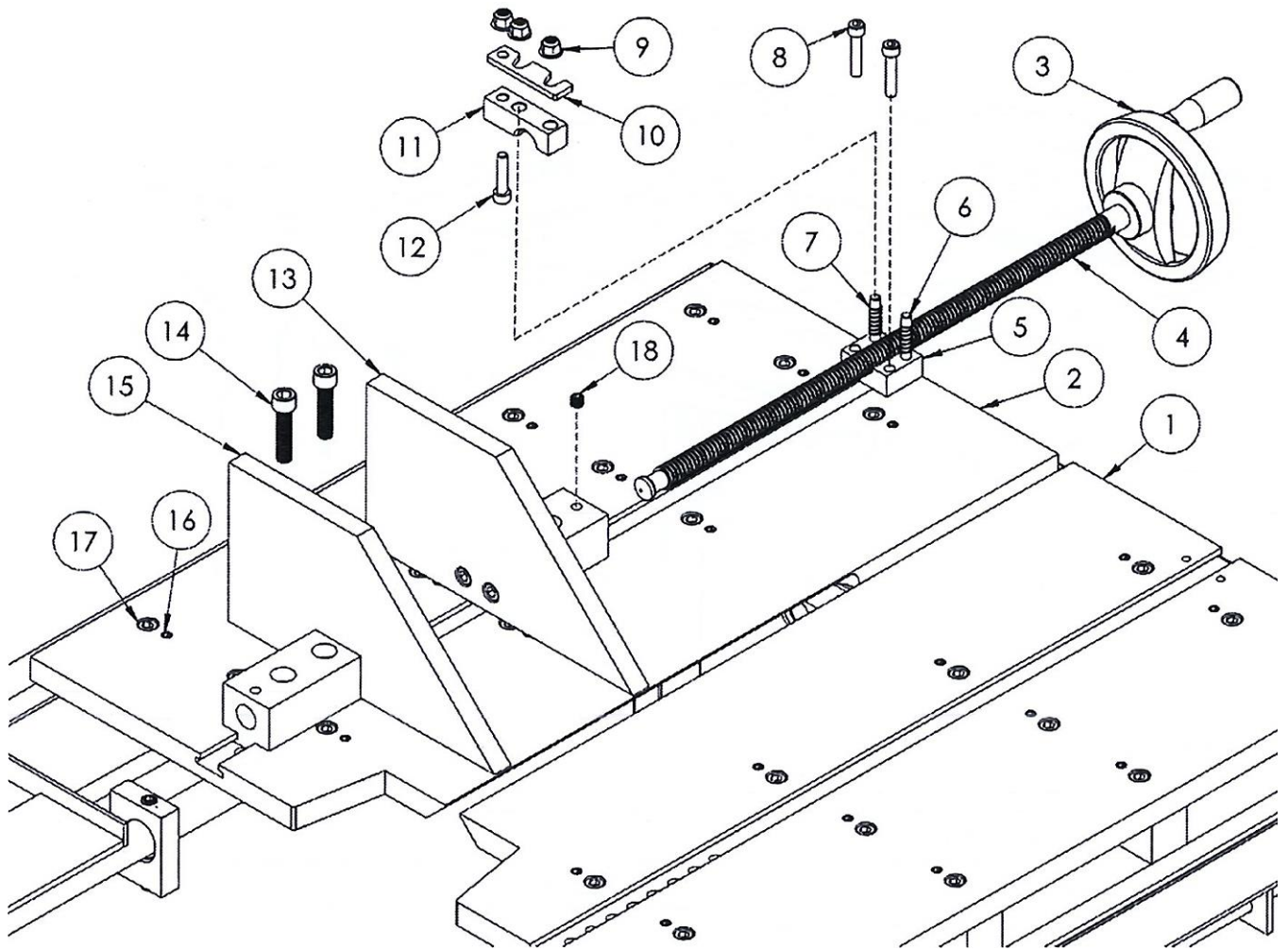


Carriage Stop Assembly

Item	Description	Size	Qty
1	Bent Rod-Limit Switch		1
2	Rod-Limit Switch		1
3	Bolt, Socket Head	M6x 8L	1
4	Block-Limit Switch		2
5	Locking Handle	M8	2
6	Bolt, Socket Head	M8 x 45L	1
7	Hex Nut	M8, Nylon Insert	1



TABLETOP



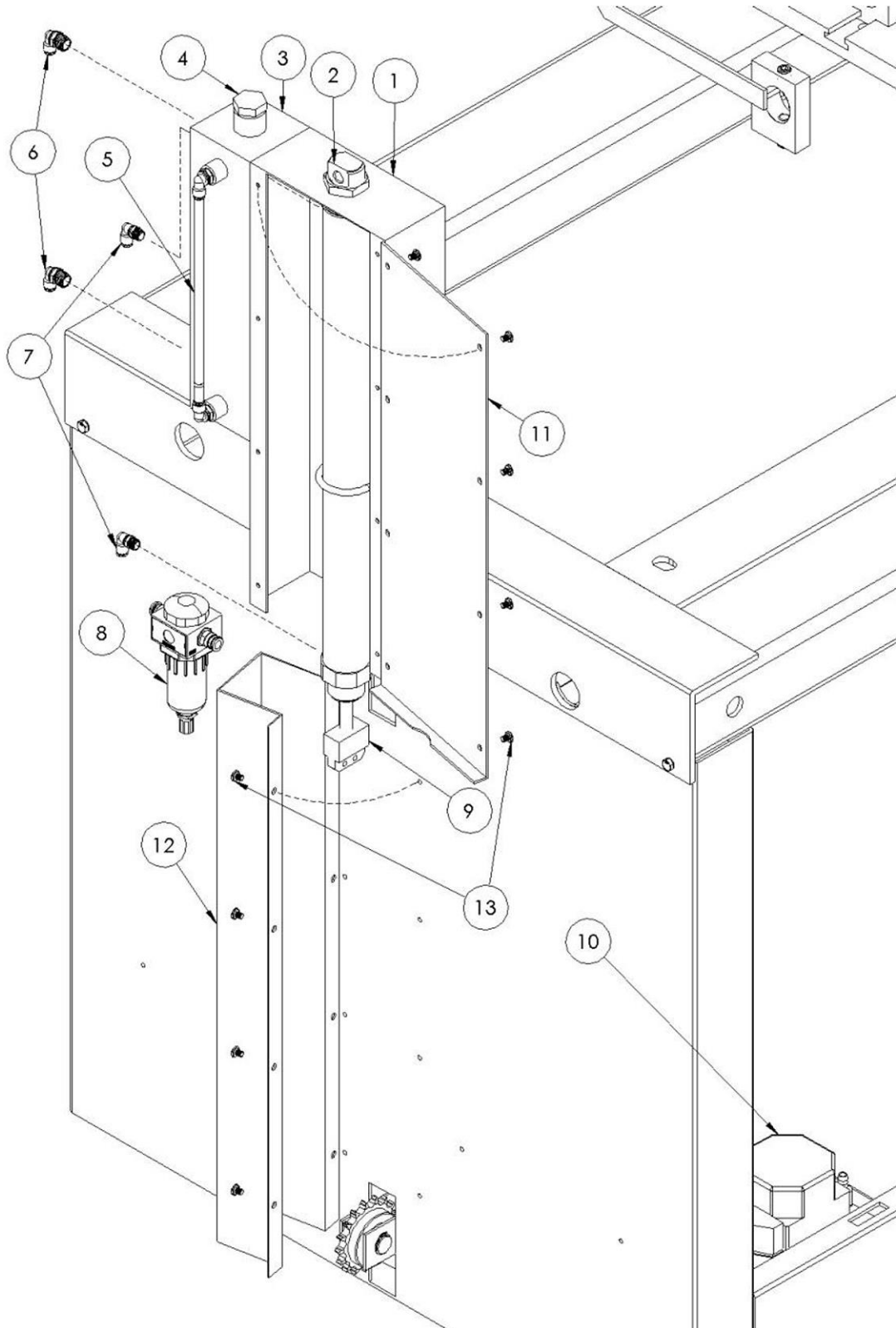


Tabletop

Item	Description	Size	Qty
1	Left Table		1
2	Right Table		1
3	Hand Wheel	6-1/2"	1
4	Lead Screw		1
5	Half Nut		1
6	Bolt, Socket Head	M8 x 50L	2
7	Spring		2
8	Bolt, Socket Head	M8 x 40L	2
9	Hex Nut	M8, Nylon Insert	3
10	Gib Lock		1
11	Gib		1
12	Bolt, Socket Head	M8 x 35L	1
13	Front Vise Plate		1
14	Bolt, Socket Head	M12 x 50L	2
15	Rear Vise Plate		1
16	Set Screw	M10 x 15L	24
17	Bolt, Socket Head	M10 x 30L	24
18	Set Screw	M8 x 20L	1



CYLINDER AND AIR-HYDRO CONVERTER



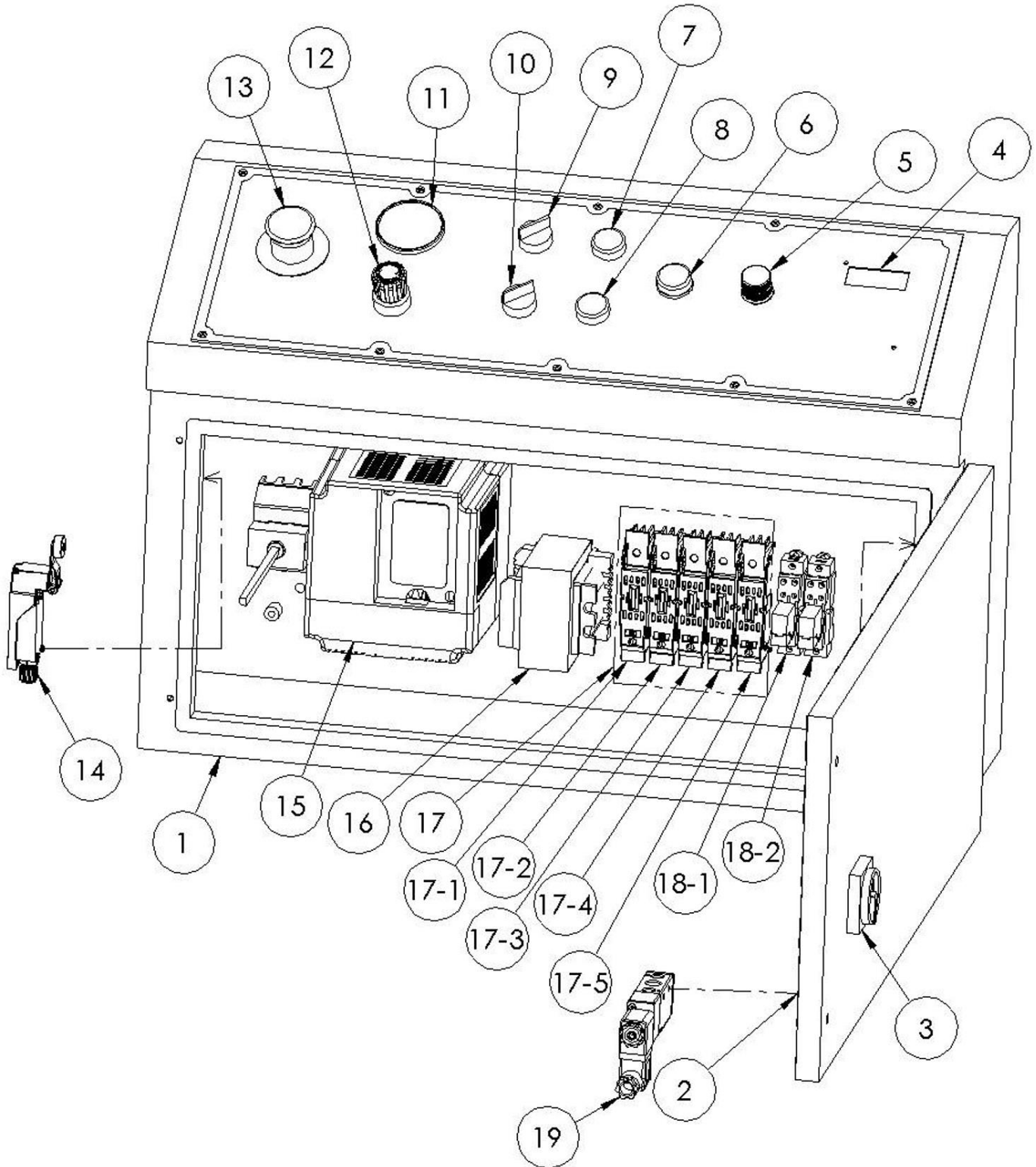


Cylinder and Air-Hydro Converter

Item	Description	Size	Qty
1	Channel Weldment		1
2	Cylinder		1
3	Air-Hydro Converter		1
4	Plug	1/2"	1
5	Fluid Level Indicator		1
6	Fitting	1/4"	2
7	Breather Vent	1/8"	2
8	Filter	1/4" tube fitting	1
9	Bracket-Feed Chain		1
10	Coolant Pump	32w	1
11	Cover-Channel Weldment		1
12	Guard-Cylinder		1
13	Bolt, Phillips Round Head	M5 x 10L	16



ELECTRICAL BOX ASSEMBLY





Electrical Box Assembly

Item	Description	Size	Qty
1	Chain-Top	RS40 x 49 pitch	1
2	Chain-Bottom	RS40 x 225 pitch	1
3	Sprocket	RS40 10T	1
4	Sprocket	RS40 17T	3
5	Bearing	6003ZZ	3
6	Retaining Ring	R35	3



NOTES



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