

10" SEMI-AUTOMATIC HORIZONTAL BAND SAW

Study Carefully Before Operating
MODEL: UE-250S/UE-250SSA



SPECIFICATIONS

Speeds: 25 ~ 75MPM

Motor: 50HZ 2HP 1430RPM 3PHASE

Capacity: 90° ● 10" ■ 10" × 15" ■ 9" × 16"
90° ● 250mm ■ 250 × 385mm ■ 200 × 400mm
45° ● 8¹/₂" ■ 10" × 8¹/₂"
45° ● 215mm ■ 250 × 215mm

Blade:

1" × 0.032" × 130" (27mm × 0.9mm × 3300mm)

Dimension:

250S L71" × W30" (L:1800mm × W:760mm)

250SSA L74" × W30" (L:1880mm × W:760mm)

Blade Wheels: 14" (355mm) Diameter

Shipping Weight: 250S 430kgs/500kgs

250SSA 450kgs/520kgs



WARNING

1. Read and understand the entire instruction manual before operating machine.
2. Always wear approved safety glasses/face shields while using this machine.
3. Make certain the machine is properly grounded.
4. 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.
5. Keep the floor around the machine clean and free of scrap material, oil and grease.
6. 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.
7. 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.
8. Make all machine adjustments or maintenance with the machine unplugged from the power source.
9. Use the right tool. Don't force a tool or attachment to do a job which it was not designed for.
10. Replace warning labels if they become obscured or removed.
11. Make certain the motor switch is in the off position before connecting the machine to the power supply.
12. Give your work undivided attention. Looking around, carrying on a conversation, and "horse-play" are careless acts that can result in serious injury.
13. Keep visitors a safe distance from the work area.
14. Use recommended accessories, improper accessories may be hazardous.
15. Make a habit of checking to see that keys and adjusting wrenches are removed before turning on the machine.
16. Always keep hands and fingers away from the blade when the machine is running.
17. Never hold the material with the saw in the horizontal position. Always use the vise and clamp it securely.
18. Read and understand warnings posted on the machine.
19. Keep the belt guard 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.

Environment Requirements for Installation.

1. Be sure to provide sufficient light for operation according to the codes or regulations published for local area. If you do not get the information about lighting, a light intensity of 300 Lux is the least value to be supplied.
2. The place where machine is installed must be flat and big enough for the operation.

Noise Level

1. The noise level of this machine is about 75 db (A) during operation.
2. While taking provisions for the risk of noise, the noise level of working environment should be taken into consideration also.

Handling & Transportation of Machine

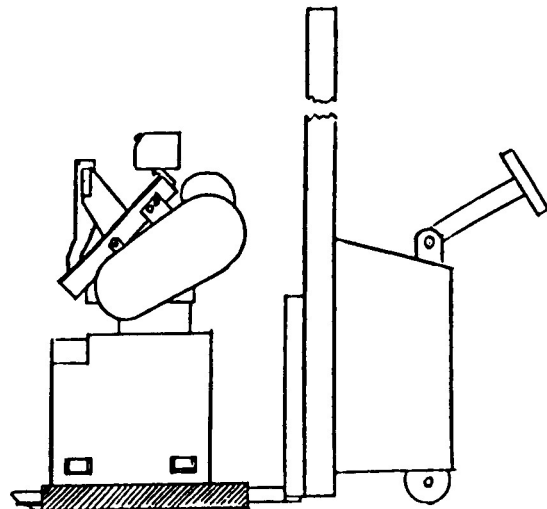
1. The total weight of this machine must be ensured before handling.
2. This machine can not be handled without help of lifting tools.

Transportation Methods



WARNING

1. Always keep balance of the machine in transportation. Watch the gravity !
2. Drive forklift slowly and carefully.



ELECTRICAL CONNECTION/DISCONNECTION.

FOR 3 PHASE

1. Electrical connection:

- a. A cable with four wires is equipped to connect your machine into the 3 phase power supply. Please connect your machine into the power supply with a hand-operated disconnecting device, which is in compliance with subclause 5.3 of EN 6024, such as a fuse breaker or plug/socket combination, if your machine is not equipped with this optional device on the door of control box.
- b. For the protection of control device, we recommend the operator to supply a fuse with appropriate current rating, and the total length between fuse and connection terminal shall not exceed 1.5 m.
- c. The power supply system is TN system.
- d. The exact power source voltage, frequency, and number of phase shall be checked according to the installation diagram and circuit diagram.
- e. The correct direction of saw blade should be checked after connecting.

2. Electrical disconnection:

- a. The disconnection is carried out by hand-operated disconnecting device, which is on the door of control box as an option or connected before the power source.
- b. Be sure to disconnect this machine from power source, when you want to stop the job, maintenance, and adjustment.

3. Grounding.

The grounding of this model is carried out by connecting the yellow/green terminal of supply cable to the grounding terminal of power source. Be sure to ground your machine before connecting machine to power source in any situation.

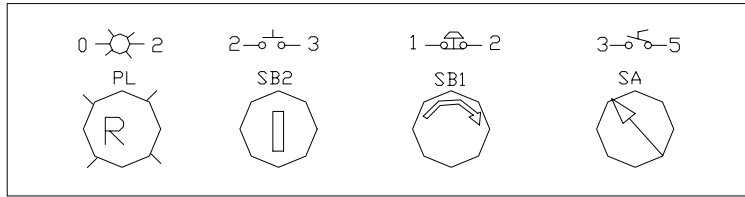
WARNING !

Do not disconnect grounding terminal before disconnecting power source.

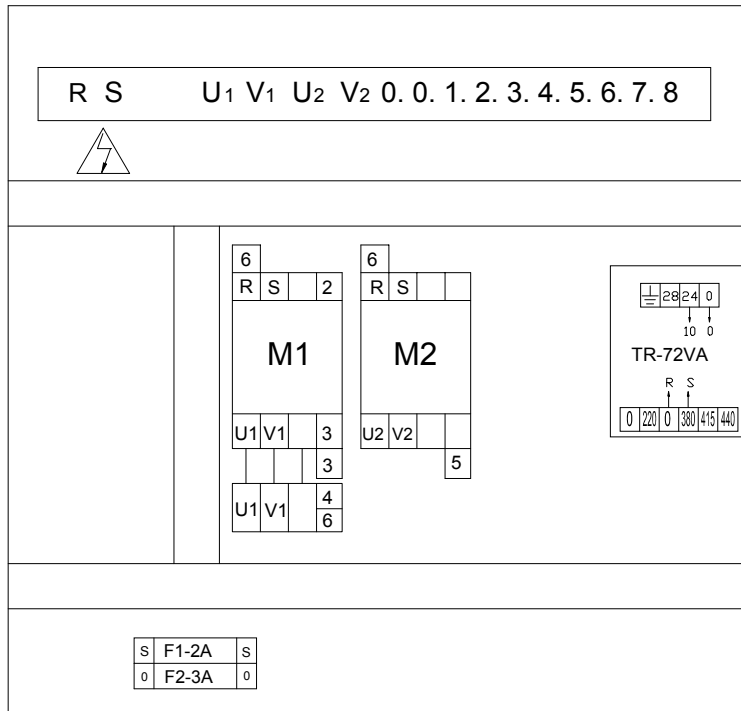
FOR SINGLE PHASE

1. If the power cable is not equipped with plug, please connect and disconnect your machine with power according to the same instruction of three phase. Otherwise, Please follow the following instruction (2~4).
2. The connection, disconnection, and grounding is carried out through the plug, equipped on the machine. For the safety reason, Do not change this plug into any other type in any situation.
3. For the protection of control device, we recommend the operator to supply a fuse with appropriate current rating, and the total length between fuse and connection terminal shall not exceed 1.5 m.
4. The exact power source voltage, frequency, and number of phase shall be checked according to the installation diagram and circuit diagram.

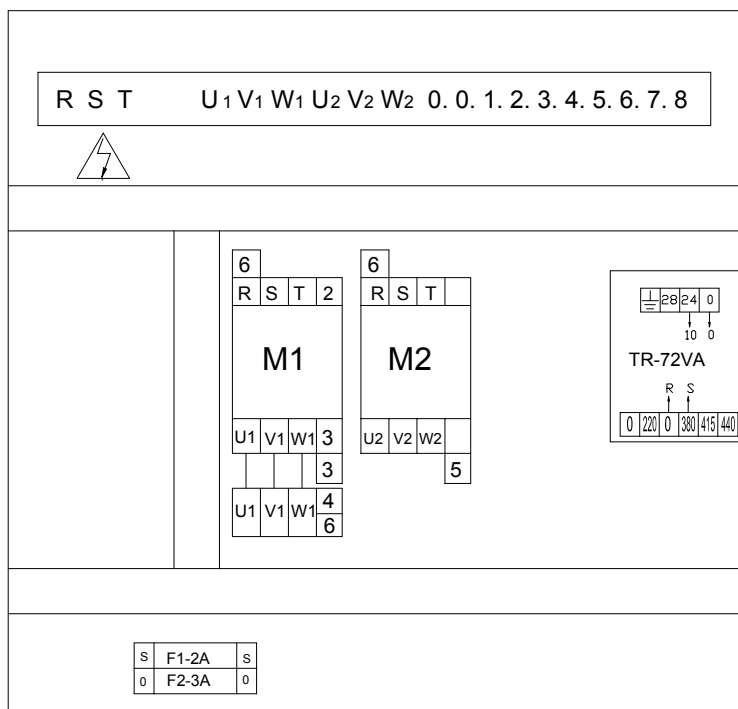
Electrical Schematic-Controls (250S)



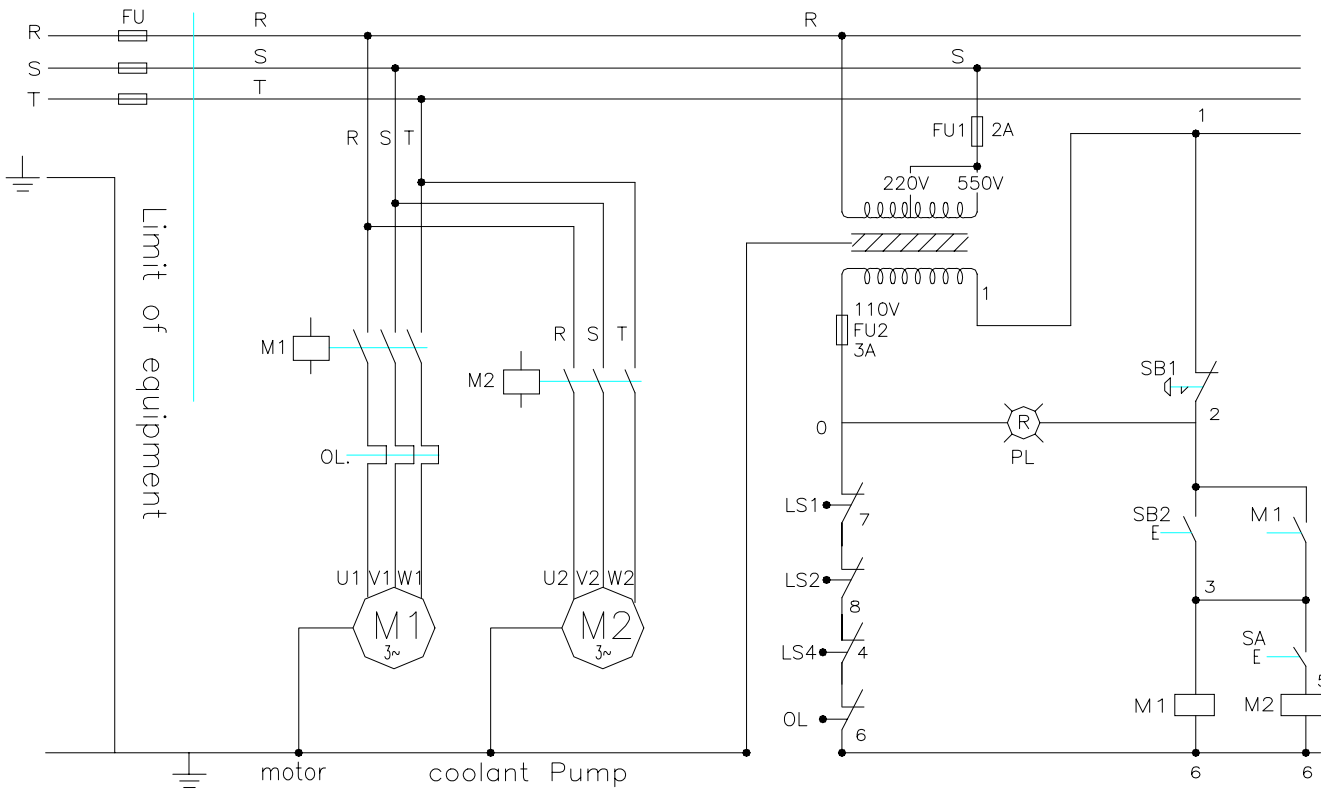
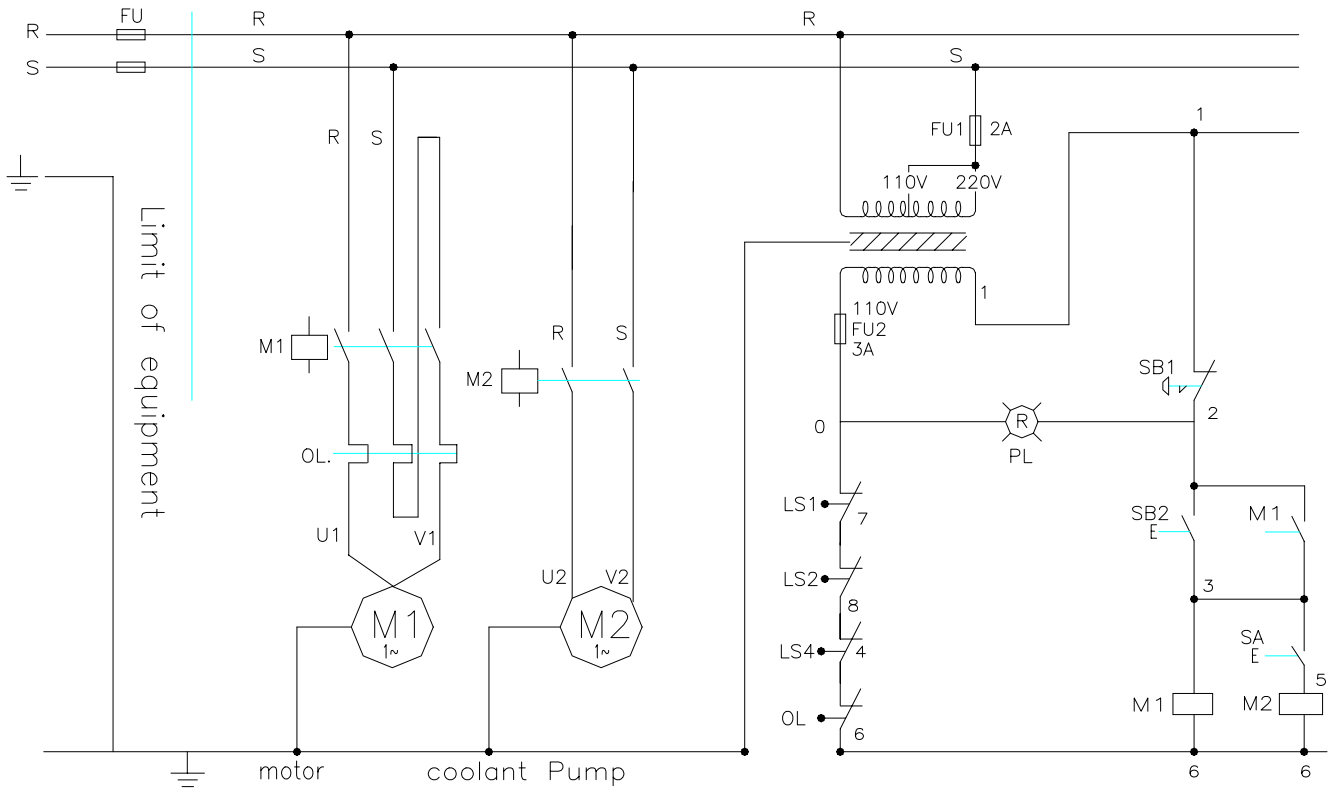
1 PHASE



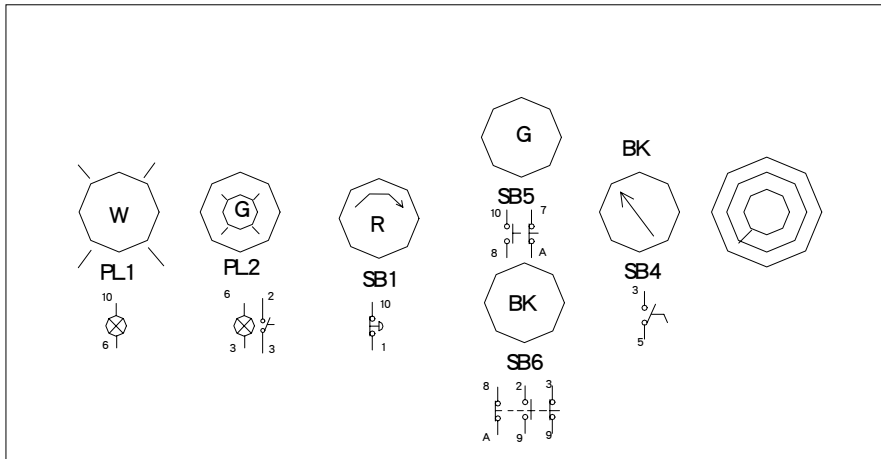
3 PHASE



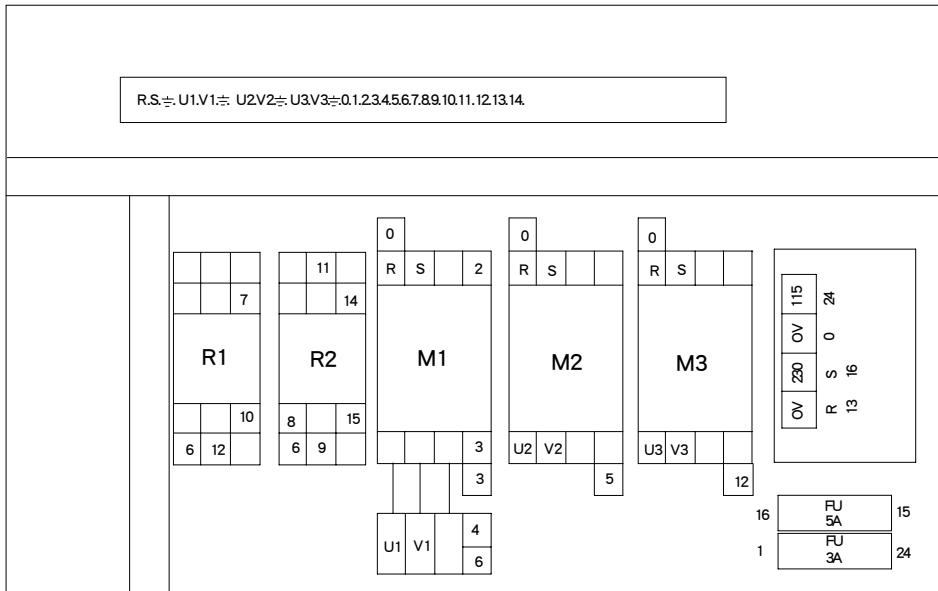
Electrical Schematic (250S)



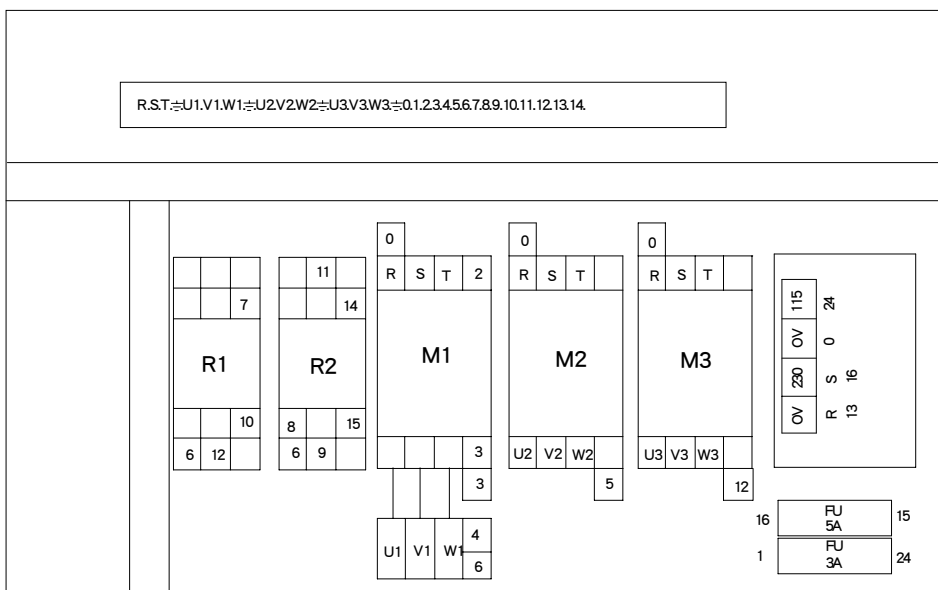
Electrical Schematic-Controls (250SSA)



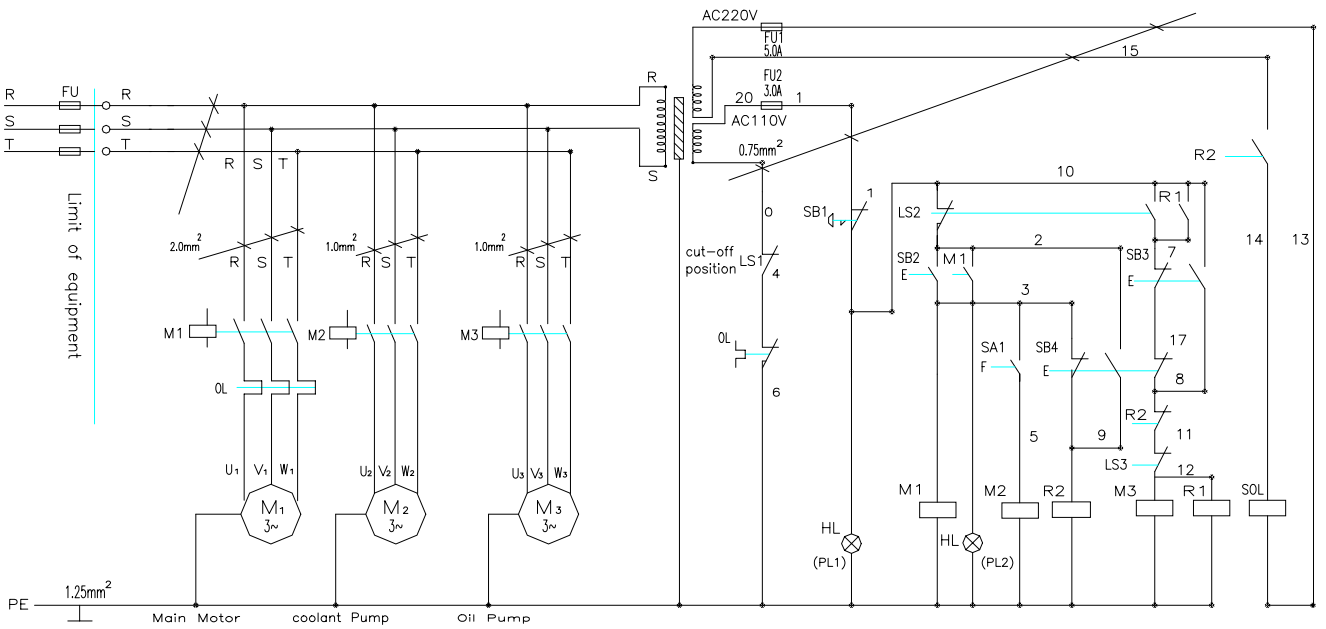
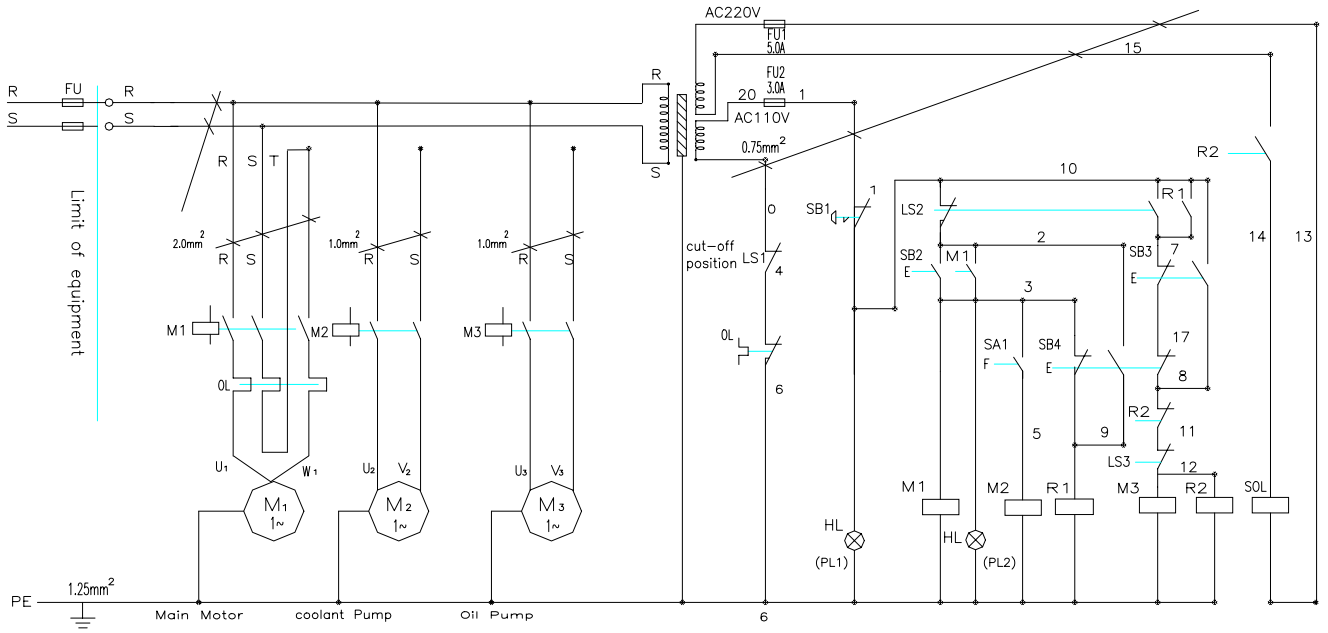
1 PHASE



3 PHASE



Electrical Schematic (250SSA)



Electrical Connections

⚠ WARNING

All electrical connections must be done by a qualified electrician! Failure to comply may result in serious injury !

⚠ WARNING

Disconnect machine from the power source before changing any voltage components ! Failure to comply may cause serious injury !

- **Main Motor** – follow diagram inside junction box cover.
- **Coolant Pump** – Remove access panel on right side of saw, remove junction box cover on pump, and follow diagram inside junction box cover. See Fig.1
- **Control Transformer** – Open electrical panel on rear of base and switch primary wire on transformer from 230V to 460V.

Machine must always be correctly grounded.

Note: The power cord end will have to be changed to one that is rated 460V when changing voltage.

Controls – Figure 2 & 3

1. **Power indicator Light (A)** – lit whenever machine is running.
2. **Start Button (B)** – depress to start bandsaw.
3. **Emergency Stop Button (C)** – depress to immediately stop all machine functions.
4. **Coolant Switch (D)** – Turn arrow to “I” to turn on flow of coolant. Turn arrow to “O” to stop flow of coolant.
5. **Cutting Pressure Control (E)** – turn clockwise to decrease cutting pressure. Turn counter-clockwise to increase cutting pressure.
6. **Hydraulic On-Off Valve (F)** – turn hydraulic cylinder on and off.
7. **Arm Lift Up Button (G)** – Depress to lift the saw arm up.
8. **Arm Descent Button (H)** – Depress to send the saw arm down.

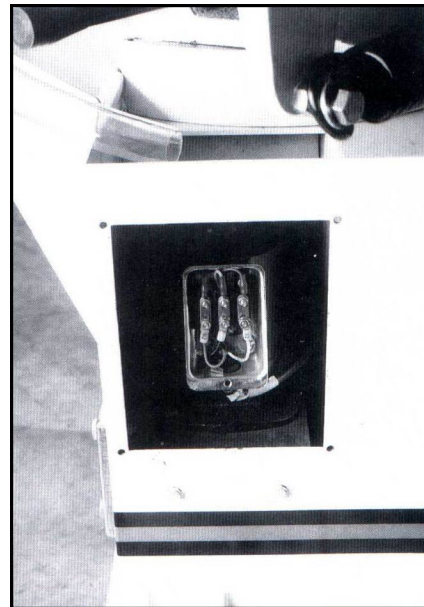


Fig. 1

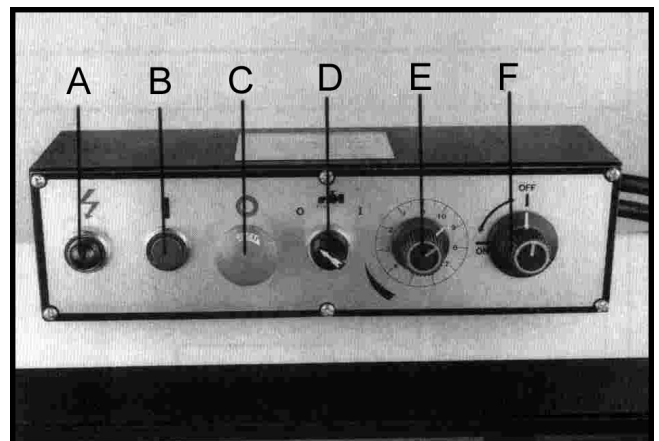


Fig. 2

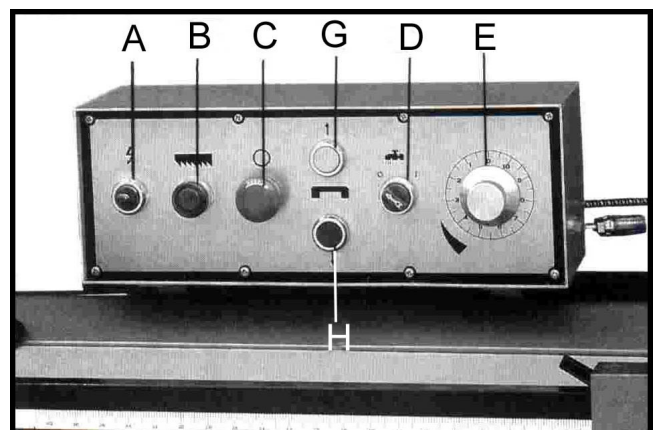


Fig. 3

Prior to Operation

1. Check blade tooth direction matches diagram on blade guides.
2. Check to see that blade is properly seated on wheels after applying correct tension (approximately 25,000 lbs.)
3. Set blade holder guides for approximately 0.003" to 0.005" clearance between the guides and blade.
4. Check for slight clearance between back up rollers and back of blade.
5. Position blade guides as close to work piece as possible.
6. Select proper speed and feed rate for material being cut.
7. Material to be cut must be securely held in vise.
8. Check to see that coolant level is adequate and turn on coolant pump if material to be cut requires it. Machine should be filled with four gallons of the proper coolant mixture. Follow the directions on the product makers label and fill the coolant tank through the chip tray area.
9. Do not start cut on a sharp edge.
10. Keep machine lubricated. See "Lubrication" section.

Adjusting Vise Square to the Blade

1. Disconnect the machine from the power source.
2. Place a machinist's square on the table against the blade and the vise. The square should lie along the entire length of the vise and blade without a gap.
3. If adjustment is necessary, loosen bolts holding the vise and adjust vise so square lines up properly. Tighten bolts.
4. Connect machine to the power source.

Adjust the Variable Speed

1. Raise saw arm approximately about 6".
2. Start machine by depressing start button (B, Fig.2).
3. Rotate the governor (A, Fig.4) forward or backward until the pointer reaches the correct read on speed scale (from 25M - 75M) (B, Fig.4) you need for the material to be cut.
4. Stop machine by depressing start button (B, Fig.2)

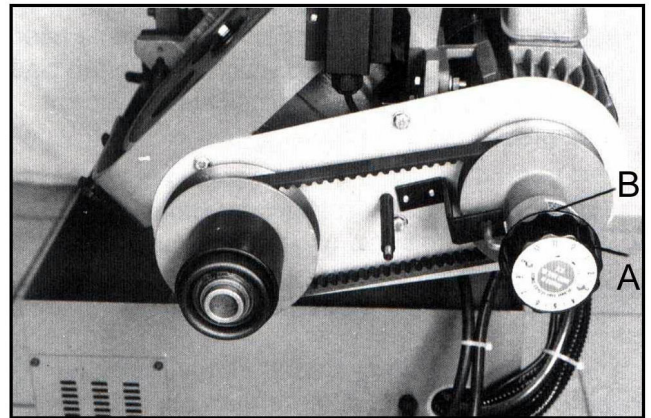


Fig. 4

Automatic Shut-Off Adjustment

The motor should shut off immediately after the blade has cut through the material and just before the head comes to rest on the horizontal stop bolt. If the machine continues to run after the workpiece has been fully cut, locate and adjust the micro switch mounting plate down. If the machine shuts off before the workpiece has been completely cut, move the micro switch mounting plate up.

Adjusting Feed Rate


Rate of feed is adjusted by turning the cutting pressure control knob on the control panel. Rate of feed is important to bandsaw 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 pressure. 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 feed pressure.

Changing Blades

 **WARNING**

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

1. Disconnect machine from power source.
2. Raise saw arm approximately 6". Hold saw arm in place by closing cutting pressure control valve.
3. Open both wheel covers and clean chips out of both wheel housings. Loosen two lock knobs below the control panel and remove upper blade guard.
4. Loosen set screw (A, Fig.5) and lower the blade cleaning brush.
5. Release blade tension by turning blade tensioning handwheel (A, Fig.6) counter-clockwise until blade is free.
6. Loosen lock knob (A, Fig.7) and slide left blade guide arm (B, fig.7) to the right as far as possible,
7. 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 bandsaw blades!
8. Install new blade making sure teeth are pointed downward in the proper cutting direction. If necessary, turn blade inside out.
9. Position blade on band 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.
10. Tension blade to approximately 25,000 lbs. of blade tension, as indicated on the blade tension indicator found on the tension wheel shaft housing.
11. Raise wire brush and tighten set screw to hold brush in place.
12. Close all covers and guards and fasten securely. Connect machine to power and run freely for approximately two minutes.
13. 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.

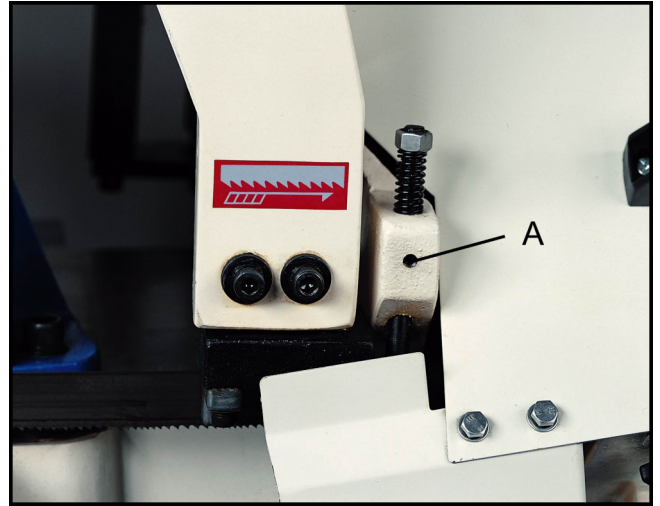


Fig. 5

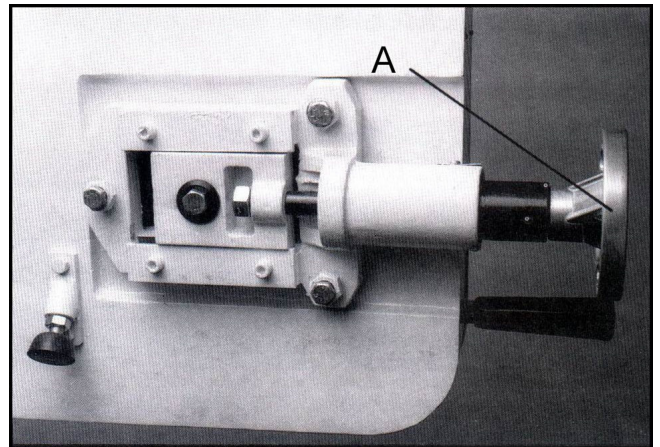


Fig. 6

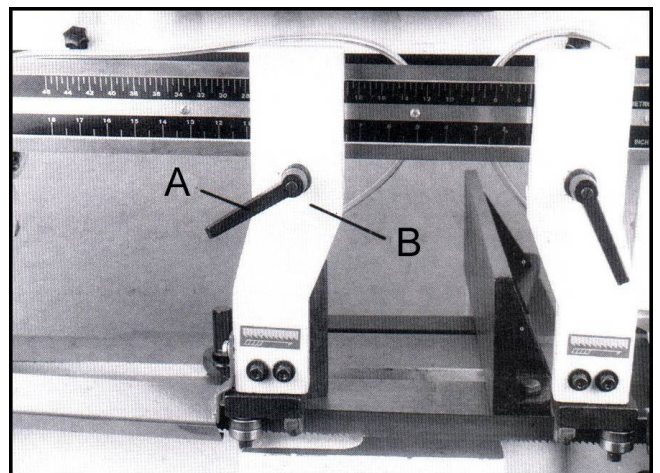


Fig. 7

Blade Tracking Adjustment

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 so as not to come into contact with the blade!

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.

1. Disconnect machine from the power source.
2. Raise saw arm to its highest position and close cutting pressure control valve to hold saw arm in place.
3. Locate tracking adjustment plate on the back side of the driven blade wheel.
4. Loosen the three bolts (A, fig.8) located on the top of the tracking nuts.
5. Tracking adjustment is accomplished by either loosening or tightening three adjusting nuts (B, Fig.8).
6. 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 wheel and blade.
7. Tighten locking bolts (A, Fig.8) once proper tracking is completed.

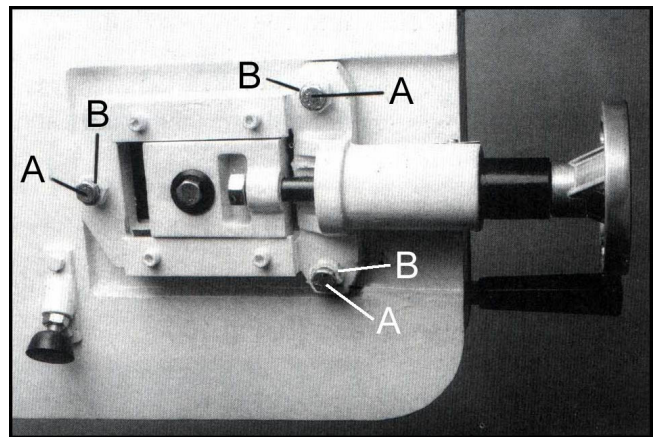


Fig. 8

Thrust Roller Adjustment

1. Disconnect machine from the power source.
2. Loosen two hex socket cap screws (A-Fig.9).
3. Move guide seat (B – Fig.9) up or down until a clearance of 0.003” to 0.005” between back of blade and thrust roller is obtained.
4. Tighten two hex socket cap screws (A – Fig.9).
5. Repeat for other blade guide assembly.
6. **Connect machine to power source.**

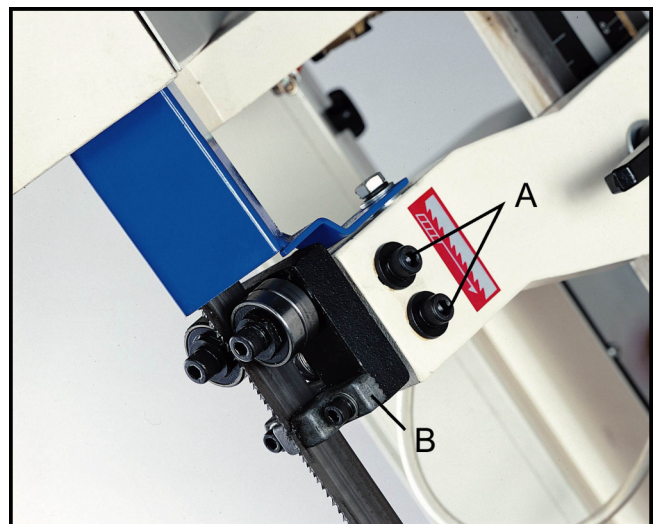


Fig. 9

Guide Roller Adjustment

1. Disconnect machine from the power source.
2. Loosen blade guides (A – Fig.10) by loosening screws (B). Slide blade guides away from blade.
3. Loosen locking screws (C) by using a hex wrench.
4. Adjust the eccentric bushings with a combination wrench until the ball bearings are snug to the blade. Note: blade should travel freely up and down between the ball bearings. Do not pinch the blade.
5. Tighten locking screws (C).
6. Slide blade guides back into contact with blade and tighten screws (B).
7. **Connect machine to the power source.**

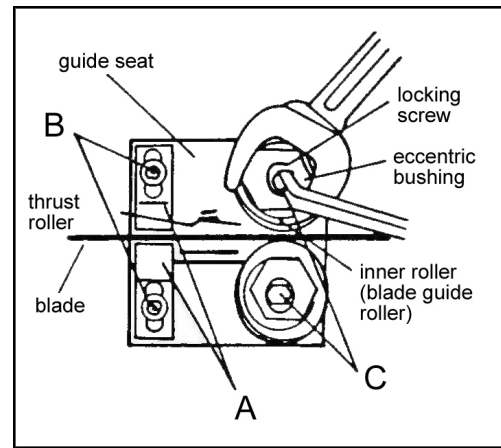


Fig. 10

Bow Weight Adjustment

Bow weight is one of the most important adjustments of the saw. If the bow weight is not set properly, one can expect poor performance, crooked cuts, tooth stripping, stalling, and the blade popping off the blade wheels. The hydraulic feed rate unit will not compensate for improper bow weight. Bow weight has been set at the factory and should not need any adjustment. If adjustment is necessary:

1. Disconnect the machine from the power source.
2. Turn hydraulic valve to on position (G, Fig.2).
3. Turn cutting pressure control valve (F, Fig.2) counter-clockwise until it stops.
4. Place one end of a fish-type scale under the blade tension handle and lift the saw with the other end. Scale should indicate approximately 15 lbs.
5. Adjust tension to approximately 15 lbs. by turning the adjustable C-bolt found at the end of the coil spring on the rear of the bandsaw. See figure 11.
6. Connect the machine to the power source.

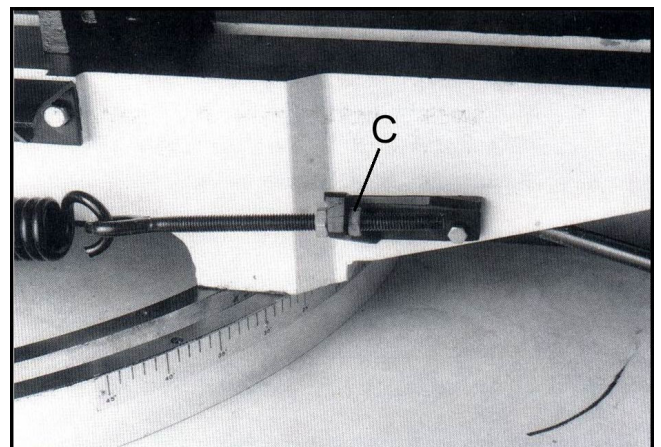


Fig. 11

Angle Adjustment

To swivel the saw arm up to a 45° angle:

1. Disconnect the machine from the power source.
2. Pull the handle (A, Fig.12) toward the front of the saw.
3. Rotate the upper assembly to the desire angle.
4. Push the handle back toward the rear of the saw to lock the upper assembly.

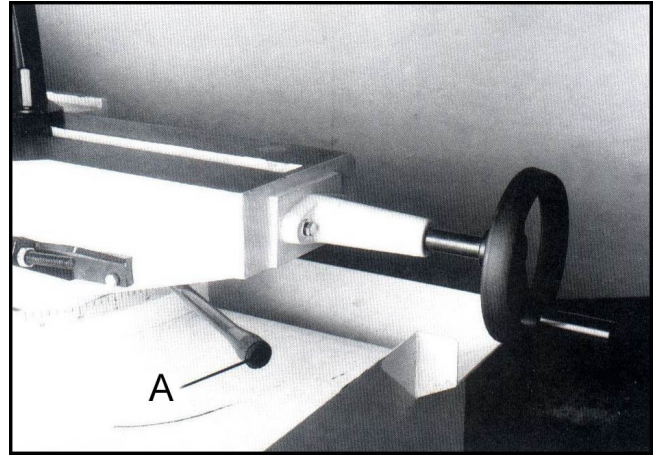


Fig. 12

To adjust the 90° stop:

1. Disconnect the machine from the power source.
2. Lower saw arm completely.
3. Pull the lock lever toward the front of the saw and pull the saw arm assembly against the 90° stop.
4. Place a 90° square on the blade and the fixed vise jaw.
5. Loosen the lock nut (A, Fig.13).
6. Adjust the hex cap screw (B, Fig.13) until the blade is at a 90° angle to the fixed vise jaw.
7. Tighten the lock nut (A, Fig.13).

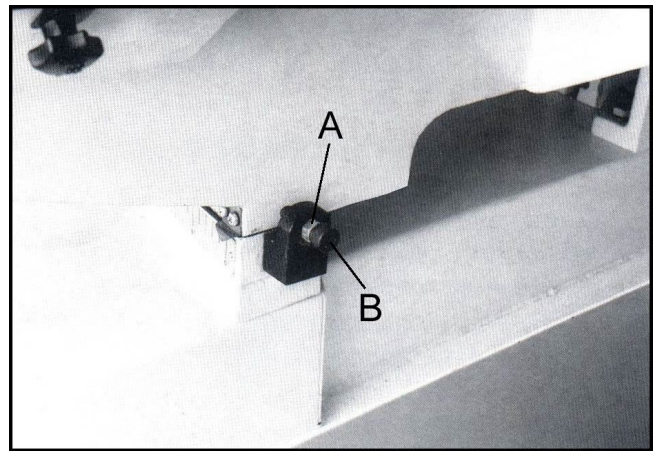


Fig. 13

To adjust the 45° stop:

1. Disconnect the machine from the power source.
2. Lower saw arm completely.
3. Pull the lock lever toward the front of the saw and push the saw arm assembly against the 45° stop.
4. Place a 45° angle square on the blade and the fixed vise jaw.
5. Loosen the lock nut (A, Fig.14).
6. Adjust the hex cap screw (B, Fig.14) until the blade is at a 90° angle to the fixed vise jaw.
7. Tighten the lock nut (A, Fig.14).

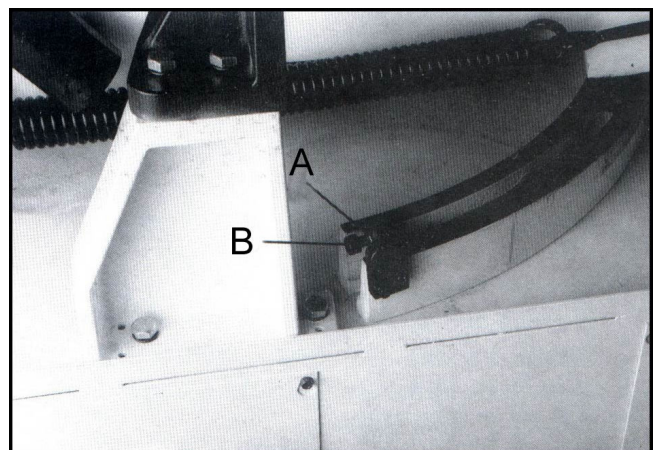


Fig. 14

Vise Adjustment

To position the moveable vise jaw:

1. Turn vise handwheel (A, Fig.15) counter-clockwise 1/2 revolution.
2. Move vise (B, Fig.15) to desired location by sliding along bed.

To adjust the vise for angle cutting:

1. Loosen bolts (A, Fig.16) and move vise jaw to desired angle.
2. Tighten bolts.

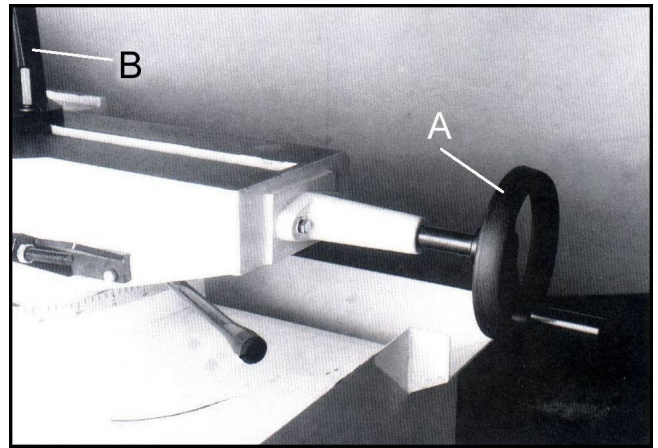


Fig. 15

Maintenance

Keep the band saw and motor clean.

Lubrication

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

The gear box lubricant should be changed after the first 50 hours of operation. Change lubricant from then on every 250 hours of operation.

To check level of gear box lubricant, place saw 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.

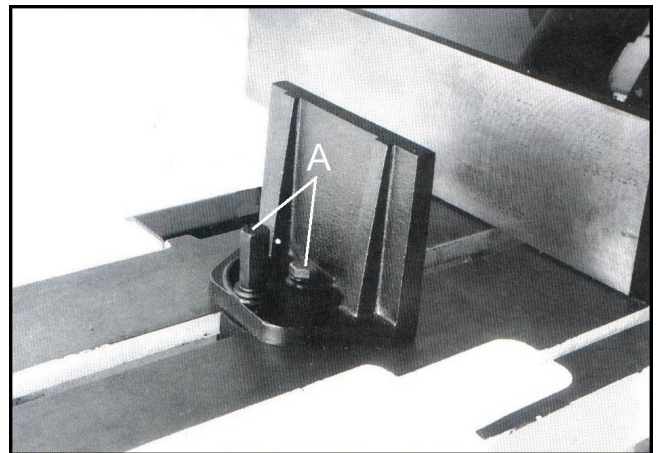


Fig. 16

To change gear box lubricant:

1. Disconnect machine from the power source.
2. Open drain plug and allow lubricant to drain completely. Drain plug may be found on lower rear of gear case. Remove drain plug with a hex wrench.
3. Replace drain plug.
4. Remove filler cap (A, Fig.17) and fill gear box with 50 weight gear oil until level reaches dot in middle of sight glass.
5. Replace filler cap.
6. Connect machine to the power source.

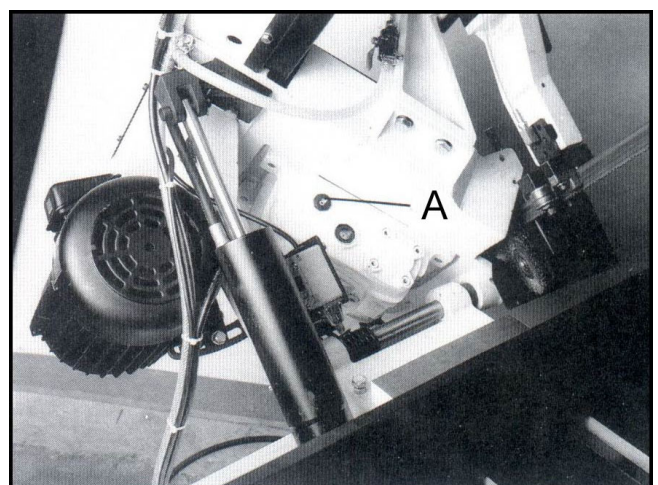


Fig. 17

Use a light machine oil to lubricate all other moving parts as needed.

Hydraulic System

The hydraulic system controls saw arm descending. If the magnetic valve (A, Fig. 18) contains sediment, the saw arm may not go down regularly. To solve the problem is to keep the inside net filter clean.

1. Disconnect machine from power source.
2. Open magnetic valve, take the net filter out, and remove sediment carefully.
3. Replace the net filter and magnetic valve.

To refill oil

1. Disconnect machine from power source.
2. Open oil inlet (C, Fig. 18) and fill oil (Mobil 1405 or Hydran LG 10) until level reaches the read in middle of oil gauge (B, Fig. 18)
3. Replace oil inlet.

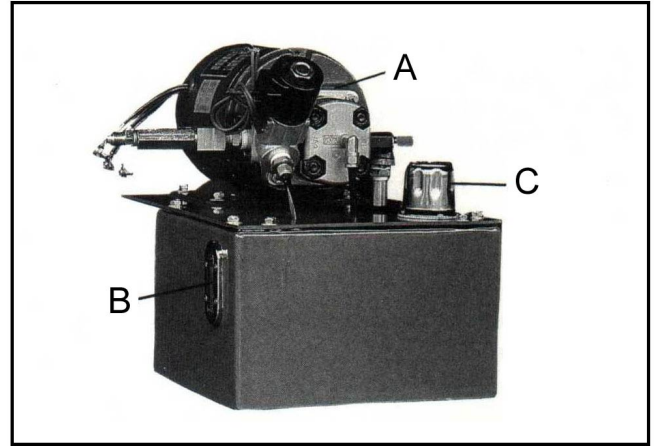


Fig. 18

Adjust Saw Arm Starting Position Set

1. Raise saw arm by depressing arm lift up button (G, Fig.3) to allow work piece to be loaded.
2. Adjust the distance to about 1.5" between blade and work piece by depressing arm descent button (H, Fig.3).
3. Loosen set screw (A, Fig.19), push down the limit switch (B, Fig.19) against the plate on hydraulic cylinder.
4. Tighten set screw (A, Fig.19)

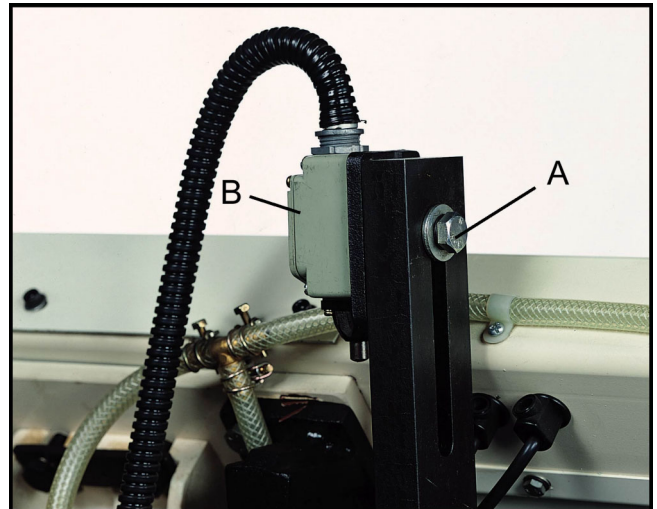


Fig. 19

PART LIST

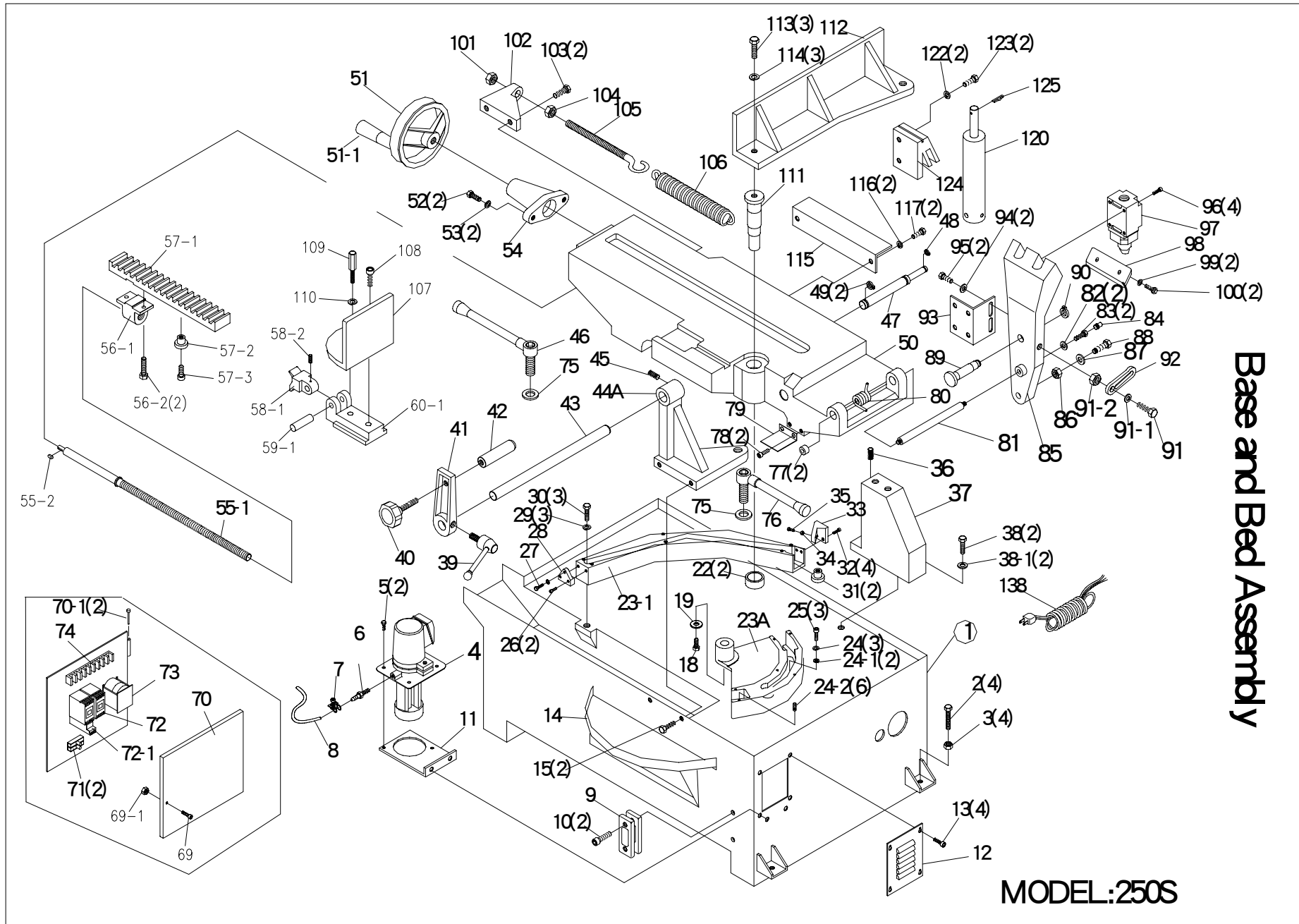
Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
1	Base		1	55-2	Key	5x20	1
2	Hex. Cap Bolt	M12x70	4	56-1	Lead Screw Bracket		1
3	Nut	M12	4	56-2	Hex. Socket Cap Screw	M8x25	2
4	Coolant Pump (1PH/3PH)		1	57-1	Rack		1
5	Round Head Screw	M6x16	2	57-2	Lock Bushing		1
6	Hose Fitting		1	57-3	Hex. Socket Cap Screw	M6x25	1
7	Hose Clamp		1	58-1	Rack Block		1
8	Hose		1	58-2	Set Screw	M6x8	1
9	Coolant Gauge		1	59-1	Pin		1
10	Hex. Cap Bolt	M10x30	2	60-1	Slide Bracket		1
11	Coolant Pump Bracket		1	61	Hex. Socket Cap Screw	M6x30	1
12	Panel Cover		1	61-1	Nut	M6	1
13	Hex. Socket Cap Screw	M6x8	4	62	Electric Cabinet Box		1
14	Coolant and Chip Tray		1	63	Magnetic Switch		3
15	Hex. Cap Bolt	M8x16	2	63-1	Overload Relay		1
18	Hex. Cap Bolt	M8x16	1	63-2	Relay		2
19	Washer		1	64-1	Fuse		2
22	Thrust Bearing		2	65	Transformer		1
23A	Turning Slide (short)		1	66	Pin		2
23-1	Turning Slide (long)		1	67	Terminal Strip		1
24	Spring Washer	M10	3	69	Hex. Socket Cap Screw	M6x30	1
24-1	Washer	M10	2	69-1	Nut	M6	1
24-2	Set Screw	M8x10	6	70	Electrical Panel Cover		1
25	Hex. Cap Bolt	M10x40	3	70-1	Pin		2
26	Hex. Socket Cap Screw	M6x20	2	71	Fuse		2
27	Hex. Socket Cap Screw	M6x20	1	72	Magnetic Switch (1PH/3PH)		1
28	Bracket		1	72-1	Overload Relay		1
29	Washer	M10	3	73	Transformer (1PH/3PH)		1
30	Hex. Cap Bolt	M10x40	3	74	Terminal Strip		1
31	Slide		2	75	Washer	M16	2
32	Hex. Socket Cap Screw	M6x20	4	76	Adjustable Handle		1
33	Bracket		1	77	Needle Bearing		2
34	Nut	M10	1	78	Hex. Cap Bolt	M6x12	2
35	Hex. Socket Cap Screw	M10x25	1	79	Guide Plate		1
36	Set Screw	M8x16	1	80	Torsion Spring		1
37	Bracket		1	81	Pivot Shaft		1
38	Hex. Cap Bolt	M12x35	2	82	Washer	M12	2
38-1	Lock Washer	M12	2	83	Bolt W/Zerk Fitting		2
39	Lock Handle		1	84	Brass Fitting		1
40	Lock Knob		1	85	Pivot Bracket		1
41	Stop Bracket		1	86	Nut	M12	1
42	Work Stop		1	87	Washer	M12	1
43	Stop Rod		1	88	Hex. Cap Bolt	M12x40	1
44A	Support		1	89	Torsion Spring Shaft		1
45	Set Screw	M8x10	1	90	C-Ring	S-22	1
46	Adjustable Handle		1	91	Hex. Cap Bolt	M8x25	1
47	Cylinder Pin		1	91-1	Flat Washer	M8	1
48	C-Ring	S-20	1	91-2	Nut	M8	1
49	C-Ring	S-25	2	92	Motor Tilt Plate		1
50	Bed		1	93	Limit Switch Plate		1
51	Hand Wheel		1	94	Washer	M8	2
51-1	Handle		1	95	Hex. Cap Bolt	M8x10	2
52	Hex. Cap Bolt	M8x30	2	96	Hex. Cap Bolt	M6x12	4
53	Lock Washer	M8	2	97	Limit Switch	5102	1
54	Lead Screw Seat		1	98	Plate		1
55-1	Lead Screw	530mm	1	99	Washer	M12	2

PART LIST

Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
100	Hex. Cap Bolt	M12x50	2	151	Wheel Box-Left		1
101	Nut	1/2"	1	152	Handle (For 250S)		1
102	Spring Bracket		1	153	Nut	M12	1
103	Hex. Cap Bolt	M8x30	2	154	Handle		2
104	Nut	1/2"	1	155	Round Head Screw	M6x16	4
105	Adjustable C-Bolt		1	156	Washer	M6	4
106	Spring		1	157	Lock Knob		4
107	Vise Jaw-Left		1	158	Blade Wheel Cover-Left		1
108	Hex. Cap Bolt	M12x35	1	159	Hex. Socket Cap Screw	M6x8	12
109	Lock Knob		1	160	Hex. Cap Bolt	M12x25	2
110	Lock Washer	M12	1	161	Washer	M12	1
111	Cutter Pin		1	162	Ball Bearing		3
112	Fixed Vise Jaw		1	163	Idler Wheel		1
113	Hex. Cap Bolt	M12x40	3	164	Hex. Cap Bolt	M6x12	2
114	Lock Washer	M12	3	165	Lock Washer	M6	2
115	Spring Cover		1	166	Washer	M6	2
116	Lock Washer	M10	2	167	Wire Brush Guard		1
117	Hex. Cap Bolt		2	168	Blade Wheel Cover-Right		1
118	Hex. Socket Cap Screw	M8x30	2	169	Washer		1
119	Spring		1	170	Drive Wheel		1
120	Hydraulic Cylinder Assembly		1	171	Bushing		1
121	Spring Cover		1	172	Blade Wheel Box-Right		1
122	Lock Washer	M10	2	173	Round Head Screw	M5x10	2
123	Hex. Cap Bolt	M10x30	2	174	Filter Screen		1
124	Hydraulic Mounting Plate-Top		1	175	Connector		1
125	Cutter Pin		1	176	Lock Washer	M12	4
126	Cylinder Pin-Top		1	177	Hex. Cap Bolt	M12x35	4
127	Hex. Cap Bolt	M6x12	2	V178	Pulley Cover Plate		1
128	Lock Washer	M6	2	V178-1	Hex. Cap Bolt	M8x16	3
129	Metal Sheet Small		1	V178-2	Lock Washer	M8	3
130	Hex. Cap Bolt	M6x12	4	V178-3	Washer	M8	6
131	Rod of Micro Switch for Length		1	179	Hose Clamp		1
132	Limit Switch	5101	1	180	Hose	1"	1
133	Limit Switch Plate		1	V181	Pulley Cover		1
134	Hex. Cap Bolt	M8x50	1	V181-1	Knob	3/8"	1
135	Nut	M8	1	V181-2	Washer	M10	1
136	Washer	M10	1	V181-3	Support Shaft		1
137	Hex. Cap Bolt	M10x25	1	V181-4	Lock Washer	M8	1
138	Power Cord (1PH/3PH)		1	V181-5	Nut	5/16"	1
139	Hydraulic Pump Set		1	V182	Gear Box Pulley		1
139-1	Motor		1	V183	V-Belt	400mm	1
139-2	Pump		1	V184	Variable Speed Adjustable		1
139-3	Solenoid Valve		1	V184-1	Support Rack		1
140	Door		1	V184-2	Washer	M6	2
141	Hex. Socket Cap Screw	M6x8	4	V184-3	Lock Washer	M6	2
142	Column		1	V184-4	Hex. Cap Bolt	M6x12	2
143	Hex. Socket Cap Screw	M12x20	6	185	Gear Box Assembly		1
144	Hex. Cap Bolt	M12x30	4	186	Key	7mm	1
145	Lock Washer	M12	4	186-1	Key	8mm	1
145-1	Washer	M12	2	187	Support Shaft		1
146	Stand Bolt	M12x50	1	188	Motor Mount Bracket		1
147	Nut	M12	1	189	Hex. Cap Bolt	M12x30	2
148	Lock Knob		2	190	Washer	M12	1
149	Blade Guard		1	191	Nut	M12	1
150	Blade Guard-Down		1	192	Hose		1

PART LIST

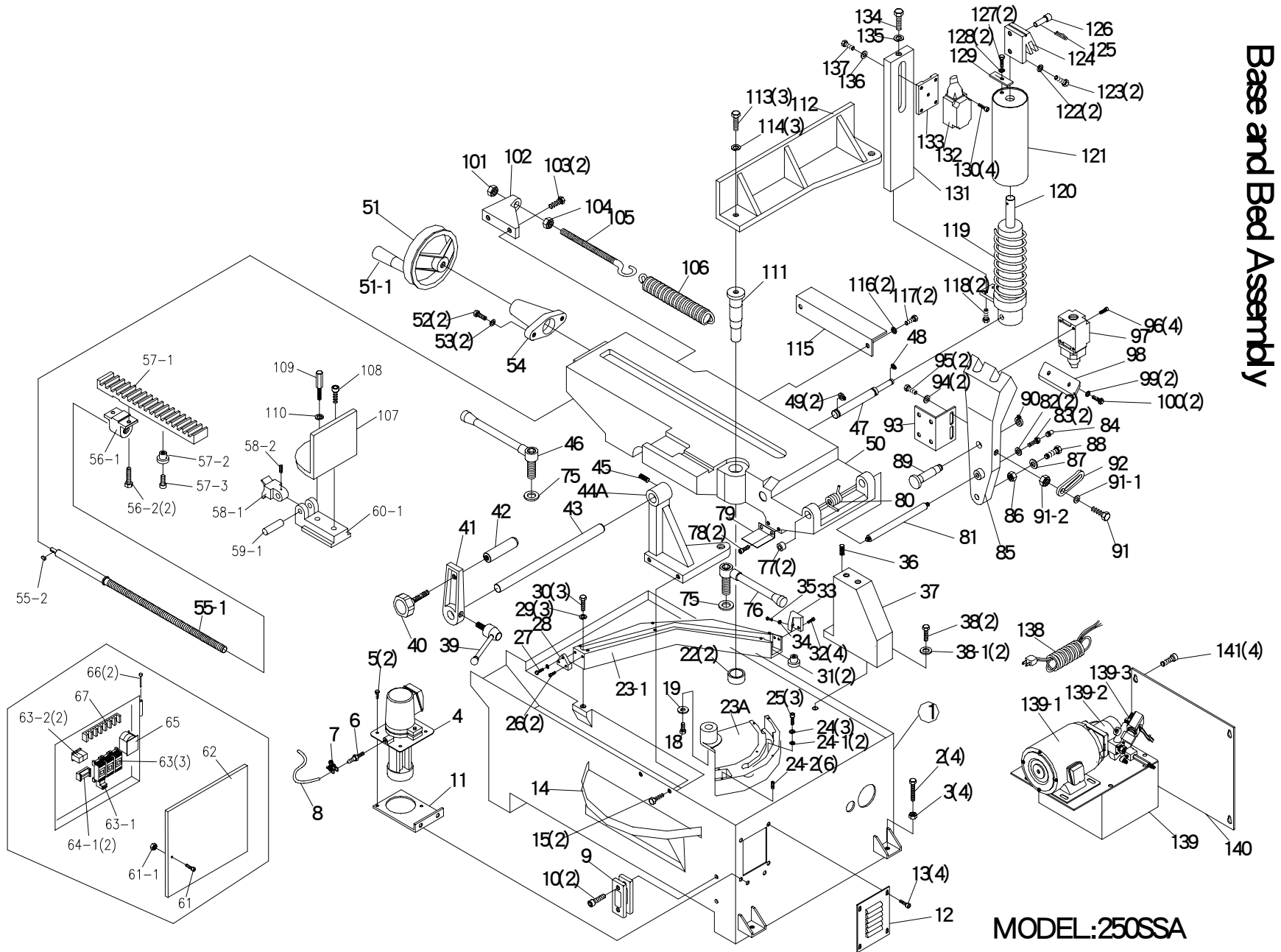
Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
192-1	Hose		1	247	Guide Bracket-Right		1
193	Connecting Tube		1	248	Connector		2
194	Hose Clamp		5	249	Hose		1
195	Hex. Cap Bolt	M8x25	1	250	Blade Bracket-Right		1
196	Washer	M8	1	251	Round Head Screw	M5x10	6
197	Hex. Cap Bolt	M8x45	4	251-1	Round Head Screw	M5x10	8
198	Washer	M8	4	252	Control Panel		1
199	Motor Mount Plate		1	253	Power Indicator Light		1
200	Motor		1	254	Start Switch		1
201	Washer	M8	4	255	Emergency Stop Switch		1
202	Lock Washer	M8	4	257	Bow Up Switch		1
203	Nut	M8	4	258	Bow Down Switch		1
204	Key	7mm	1	259	Pump Start Switch		1
205	Hex. Cap Bolt	M6x10	1	260	Feed Control-Hydraulic On/Off Valve		1
206	Washer	M6	1	260-1	Feed Control-Hydraulic On/Off Valve		1
207	Wire Brush		1	261	Control Box		1
208	Wire Brush Rod		1	262	Slide Bracket		1
209	Set Screw	M6x8	1	263	Indicator Scale		1
210	Spring		1	264	Round Head Screw	M5x10	2
211	Nut	M10	1	265	Hex. Cap Bolt		3
212	Blade Guard		1	266	Lock Washer		3
213	Hex. Cap Bolt	M8x16	1	267	Screw Assembly		3
214	Lock Washer	M8	1	268	Wheel Shaft		1
215	Washer	M8	1	269	Slide		1
216	Knob		2	270	Washer	M12	1
217	Washer	M10	2	271	Hex. Socket Cap Screw	M8x25	1
218	Hex. Socket Cap Screw	M8x40	4	272	Hex. Socket Cap Screw	M8x25	4
219	Lock Washer	M8	4	273	Gib		2
220	Washer	M8	4	274	Nut	M12	1
221	Adjustable Bracket-Left		1	275	Set Screw	M6x8	1
222	Scale		1	276	Tension Shaft		1
223	Hex. Socket Cap Screw	M10x25	2	277	Extension Bar		1
224	Set Screw	M8x10	4	278	Key	5mm	1
225	Slide		1	279	Handwheel		1
226	Blade (Local Purchase)		1	280	Set Screw	M8x10	1
227	Blade Bracket-Left		1	281	Thrust Bearing	51104	1
228	Clamp		2	282	Tension Indicator		1
229	Adjusting Valve		2	283	Flat Steel Washer		1
230	Clamp		2	284	Disc Spring		13
231	Lock Washer	M6	4	289	Pulley Cover		1
232	Hex. Cap Bolt	M6x12	4	290	Lock Knob	1/4"	1
233	Hose		1	291	Gear Box Pulley		1
234	Guide Bracket-Left		1	292	Belt	A-39	1
235	Set Screw	M8x16	6	293	Motor Pulley		1
236	Washer	M8	4	294	Set Screw	M8x10	1
237	Ball Bearing		8	295	Washer	M8	2
238	Eccentric Sleeve		2	296	Lock Washer	M8	2
238-1	Centric Sleeve		2	297	Hex. Cap Bolt	M8x16	2
239	Lock Washer	M8	4	298	Speed Chart Label		1
240	Hex. Socket Cap Screw	M8x45	4				
241	Hex. Socket Cap Screw	M6x30	4				
242	Washer	M6	8				
243	Blade Guide		4				
244	Ball Bearing	608ZZ	2				
245	Hex. Socket Cap Screw	M8x20	1				
246	Adjustable Bracket-Right		1				



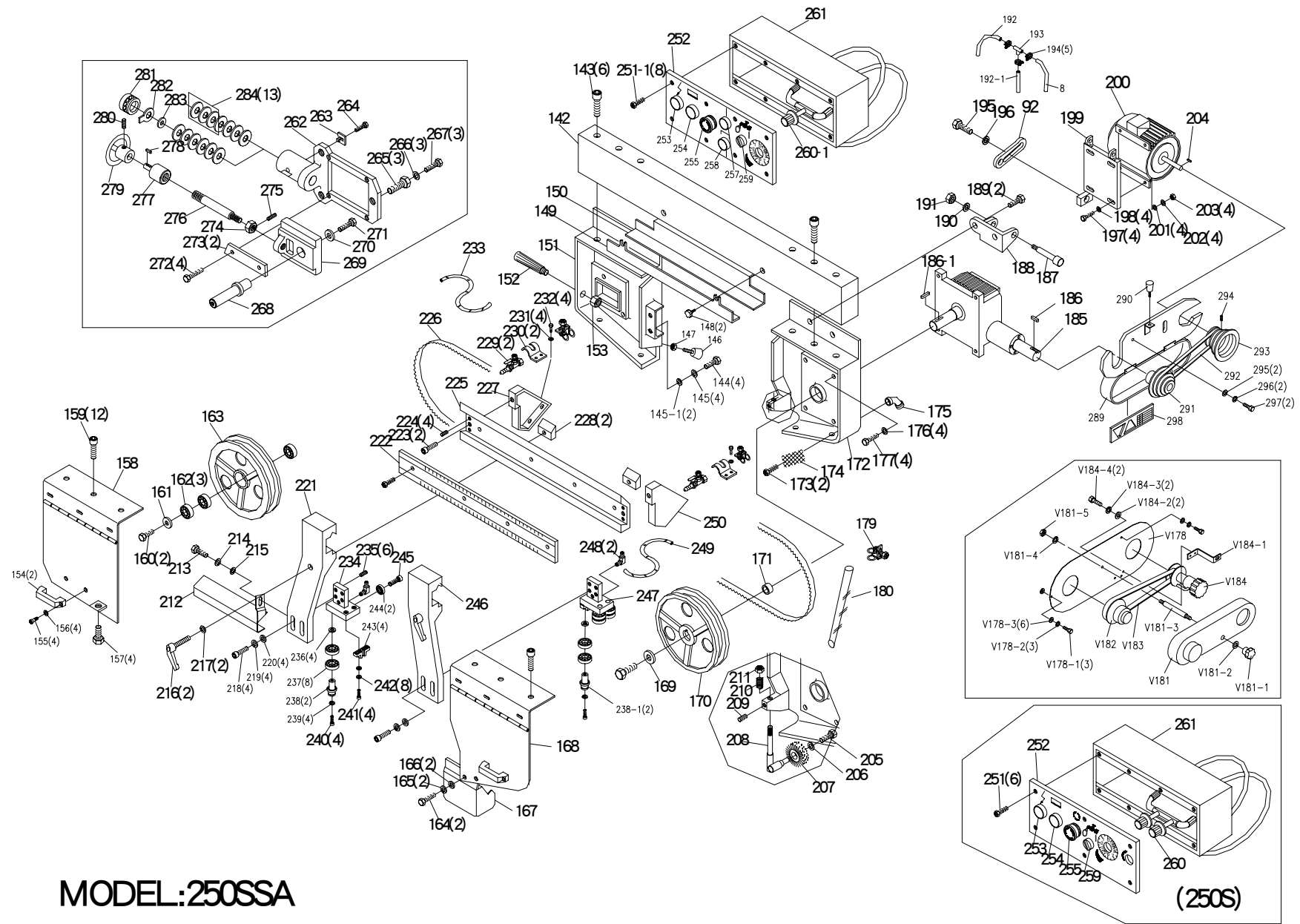
Base and Bed Assembly

MODEL:250S

Base and Bed Assembly



Saw Arm Assembly



MODEL:250SSA

