

OPERATING INSTRUCTIONS AND PARTS LISTS

Model 87-20" Metal Cutting Band Saw



For Serial Numbers From 2-2000 Up



POWERMATIC INC.

McMinnville, Tennessee

I. MACHINE DESCRIPTION & SPECIFICATIONS

FRAME:	Heavy, re-inforced steel plate, braced to give maximum rigidity.																								
TABLE:	3" x 24" x 24"; made of finest grey iron castings, machine ground to precision tolerance. Mounted on heavy duty trunnion to tilt 45° to right, 15° to left. Front edge machined and drilled for ripfence.																								
WHEELS:	Made of finest machine castings, dynamically balanced and fitted with easy-change rubber tires. Upper and lower wheels run in lubricated-for-life ball bearings.																								
GUARDS:	All moving parts are completely enclosed. Only the operating part of the blade is exposed.																								
DRIVE:	Available in belted drive model and powered by an 1800 RPM motor mounted on adjustable base.																								
SAW BLADE ADJUSTMENT:	The blade tension is adjusted with conveniently located handwheel for blade tension adjustment. Spring mechanism absorbs shock and maintains uniform tension on the blade.																								
SAW GUIDES:	Top and bottom saw guides are either ball bearing, or solid, to assure minimum friction and increased blade life.																								
SPECIFICATION:	<table> <tr> <td>Table size</td><td>3" x 24" x 24"</td></tr> <tr> <td>Blade-to-column distance</td><td>19½"</td></tr> <tr> <td>Maximum depth of cut under guide</td><td>12½"</td></tr> <tr> <td>Wheel size</td><td>20" x 1¼"</td></tr> <tr> <td>Table height (from floor)</td><td>41½"</td></tr> <tr> <td>Table tilt, right</td><td>45°</td></tr> <tr> <td>Table tilt, left</td><td>15°</td></tr> <tr> <td>Blade width (usable maximum 1"; minimum 1/16")</td><td>¾"</td></tr> <tr> <td>Blade length</td><td>12' 7"</td></tr> <tr> <td>Blade speed, SFM</td><td>40 to 4600</td></tr> <tr> <td>Overall height</td><td>76½"</td></tr> <tr> <td>Floor space required</td><td>39" x 27"</td></tr> </table>	Table size	3" x 24" x 24"	Blade-to-column distance	19½"	Maximum depth of cut under guide	12½"	Wheel size	20" x 1¼"	Table height (from floor)	41½"	Table tilt, right	45°	Table tilt, left	15°	Blade width (usable maximum 1"; minimum 1/16")	¾"	Blade length	12' 7"	Blade speed, SFM	40 to 4600	Overall height	76½"	Floor space required	39" x 27"
Table size	3" x 24" x 24"																								
Blade-to-column distance	19½"																								
Maximum depth of cut under guide	12½"																								
Wheel size	20" x 1¼"																								
Table height (from floor)	41½"																								
Table tilt, right	45°																								
Table tilt, left	15°																								
Blade width (usable maximum 1"; minimum 1/16")	¾"																								
Blade length	12' 7"																								
Blade speed, SFM	40 to 4600																								
Overall height	76½"																								
Floor space required	39" x 27"																								

II. GENERAL SET-UP AND ALIGNMENT

1. RECEIVING

Uncrate and check for shipping damage. Clean all coated and greased surfaces. Read instructions thoroughly. Locate all lubrication points; adjustments; methods of drive.

2. MOUNTING

Mount machine securely to solid foundation; concrete base mounting preferred. Locate in clean, dry and well ventilated building if possible. Motor and electrical connections should be protected when not in operation or if exposed to weather elements.

3. INSPECTION

The above machine requires the minimum amount of attention in service. Periodic or regular inspections are recommended to insure machine is in proper adjustment and with positive electrical connections; also, to correct worn or loose "V" belts and loose or heating bearings.

4. BEFORE OPERATING

Check motor nameplate data or wiring diagram of motor and switch for proper voltage connection before wiring into line. Run motor without load to check the connections and direction of rotation. Always refer to motor nameplate for rotation connections.

OPERATING INSTRUCTIONS

The Powermatic Model 87-20" Metal Cutting Band Saw is constructed of steel plate, braced to give maximum rigidity. Streamlined in appearance, all moving parts are completely guarded for safe operation. The top and bottom band wheels are easily accessible through large hinged doors on front of the saw. Sealed dust chute keeps motor and drive free from cuttings and dust.

MOTOR AND WIRING: Electric wiring is connected to a motor wiring in conduit box mounted on the side of the column. Motor should be inspected and checked for rotation before operating machine. Operate lower unit and check rotation before installing blade. Frame of machine should ALWAYS be grounded.

POWER DRIVE: The saw is driven with a motor fastened on an adjustable hinge base mounted in the base of the machine. A motor from 1½HP, single or 3-phase is available; 1½ HP for light work and 1½ HP to 3 HP for medium to heavy work is recommended. Two A section belts drive the lower band wheel.

INSTALLING BLADE: To install band saw blade: remove table insert (19) Fig. 1, from table; open top and bottom doors. Take the blade in both hands and slide through table slot and over band wheels. With blade placed in the center of the band wheels, increase tension on upper wheel with tension screw (16) Fig. 5, located under upper wheel. Set upper and lower saw guides so they will clear the saw blade. Turn band wheels by hand to see that saw blade tracks properly. It is important that the blade runs centered on the wheels for accurate work and maximum blade life. When the adjustment has been properly made, the blade will track; that is, it will run steadily in the same line.

BLADE TENSION: Correct blade tension is very important for efficient operation. The wider and thicker blades require more tension than narrow blades. A graduated tension indicator for different blade widths (17) Fig. 5, is located inside the frame and behind upper wheel. Tension is regulated by screw (16) Fig. 5, maintaining pressure on tension spring. The spring is designed to give correct tension only for standard gauge blades. Tension may vary for heavier and/or thicker blades. Blade tension does not vary with length of blade.

WHEEL ALIGNMENT: Band wheels are properly aligned at the factory and should operate correctly. However, in shipping, the original adjustments may have moved, necessitating realignment. The lower wheel housing is mounted on jack screws, two in the rear and two in the front. The shaft may be leveled by loosening the two bearings locking bolts and adjusting the two jack screws. Bearing bolts should be retightened after shaft is leveled.

BLADE GUIDE ADJUSTMENT: For proper operation, the saw blade must be supported by an upper and lower saw guide. The lower guide is mounted under the table and the upper guide on a counterbalanced bar above the table (18) Fig. 5. The purpose of the saw guides is to support the blade for cutting curve surfaces. It is very IMPORTANT for the guides to be adjusted in proper relation to saw blades. Before adjusting guides, adjust tension on blade, start motor and check tracking on band wheels. **Stop Motor**—take no chances. Adjust the side blocks or bearings (both upper and lower) to saw blades, leaving a little clearance on each side. The thickness of a piece of paper is a good clearance gauge (20) Fig. 2. Guide blocks or bearings are held in place with socket head set screws (9) Fig. 2 and can easily be adjusted. After blade clearance is set, the back guide holder should be adjusted with the knurled knob (8) Fig. 4 so the edge of the side guides is just behind saw teeth gullets (21) Fig. 4. The back guide consists of a ball bearing mounted on an adjustable bar (22) Fig. 4 and should be set 1/64", or thickness of a piece of paper, from back edge of the blade. The back guide is set at a slight angle to back of blade so the edge of the blade will not cut a groove in back bearing guide. For best operation, the LOWER saw guide (7) Fig. 1 should be set as CLOSE as possible to bottom of table. To adjust the lower guides, loosen guide bolts (6) Fig. 1 and raise the guide as close as possible to bottom of table. Tighten guide bolt.

TABLE ADJUSTMENTS: The table is mounted on an extremely heavy duty single action trunnion that rests on trunnion base (23) Fig. 1. The table may be tilted to the right 45 degrees and to the left 15 degrees. Table is locked in position with trunnion handwheel mounted on side of machine base (5) Fig. 1. To tilt table, turn handwheel to left about ½ turn, and tilt the table to the desired angle—tighten trunnion. To level table with blade, raise counterbalanced arm to highest position and place machinist square against side of blade. Set table stop (24) Fig. 6, on side of table by adjusting screw on top of the stop. Stop bar should be removed for tilting table to the left.

LUBRICATION: The bearings on top and bottom shaft are sealed for life, requiring no lubrication. The slides and adjusting screws should be lubricated at regular intervals to insure proper operation. Variable speed transmission is filled with 3½ quarts of 40 or 50 weight motor oil—DO NOT use transmission grease—keep oil to top of elbow on oil filler pipe.

TRANSMISSION OPERATION: To change speed range of transmission, turn variable speed hand wheel (15) Fig. 6 to slow speed. Pull the lock pin shifting handle (13) Fig. 6 to the right for slow speed, left for high speed and center for neutral. To obtain maximum variable speed range, the variable sheaves must be properly adjusted. To adjust belt, set hand wheel (15) Fig. 6 to slow range and remove bolt (1) Fig. 3. Turn turnbuckle (2) Fig. 3 to right to raise belt in upper variable speed pulley and to left to lower. When belt is properly adjusted, it will ride flush with the top of the upper pulley in the slow speed range and flush with the top of the lower pulley in the high speed range.

POWER FEED OPERATION: To operate power feed, push foot pedal down until latched. Place material to be cut against feed block and push up to blade. The material does not have to be "squared" in relation to material guide. Fasten the chain hook, Part 87-615, to the chain 87-616, place chain in chain segments 87-609. The cables and chain can be adjusted for various sizes by adjusting the power feed wheels (10) Fig. 7 either in or out. The two power feed wheels can be adjusted independently. To change feed rate, move weight toward linkage to increase feed rate, toward hinge pin to decrease feed rate. Start the saw and release the latch on foot pedal.

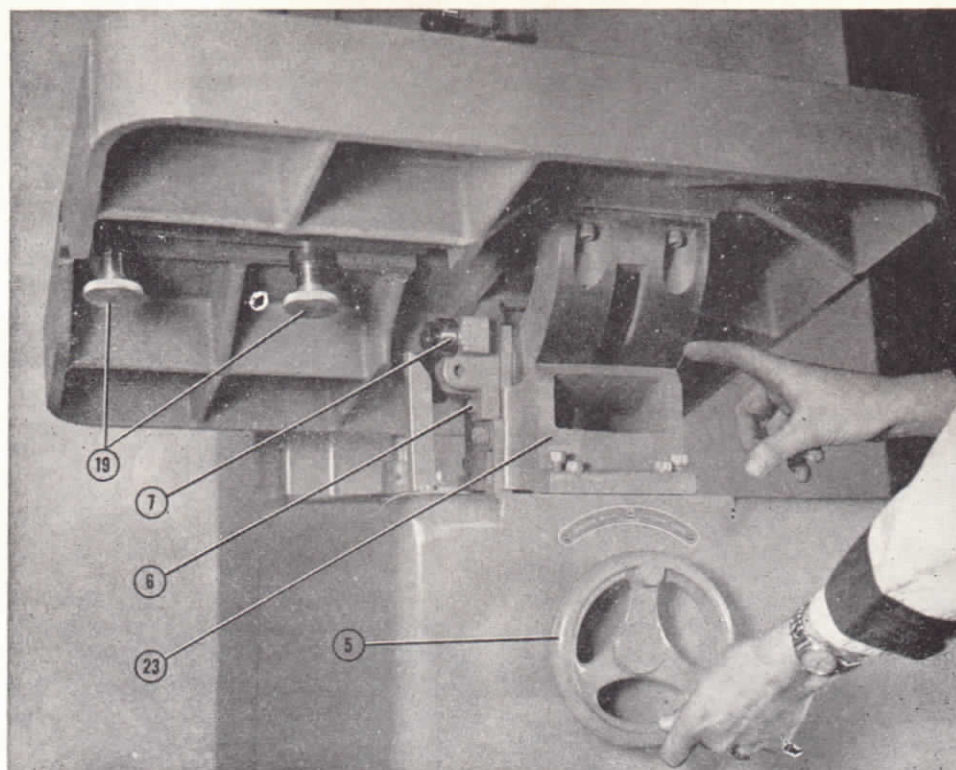


Fig. 1

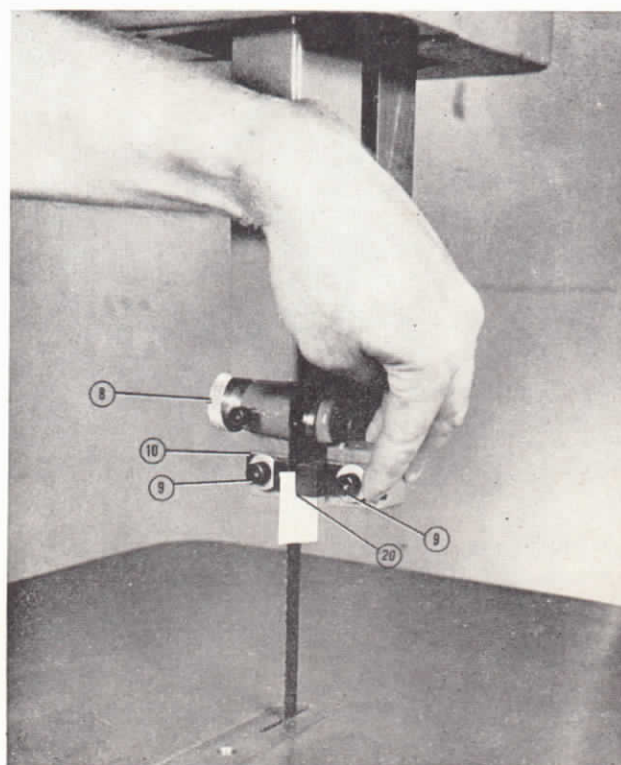


Fig. 2

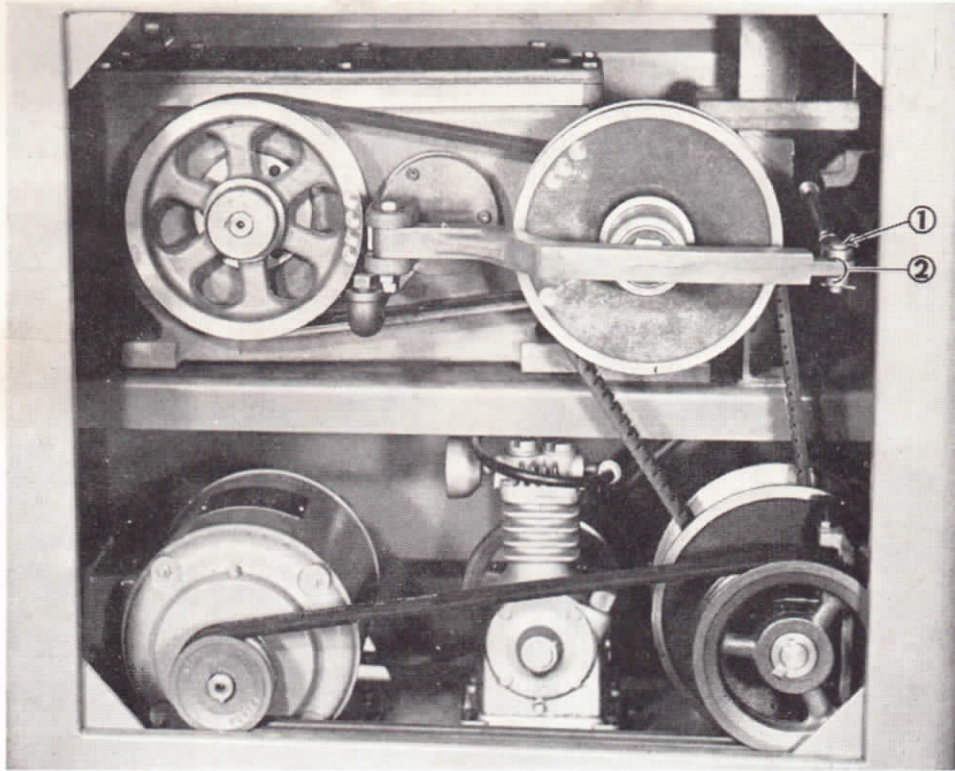


Fig. 3

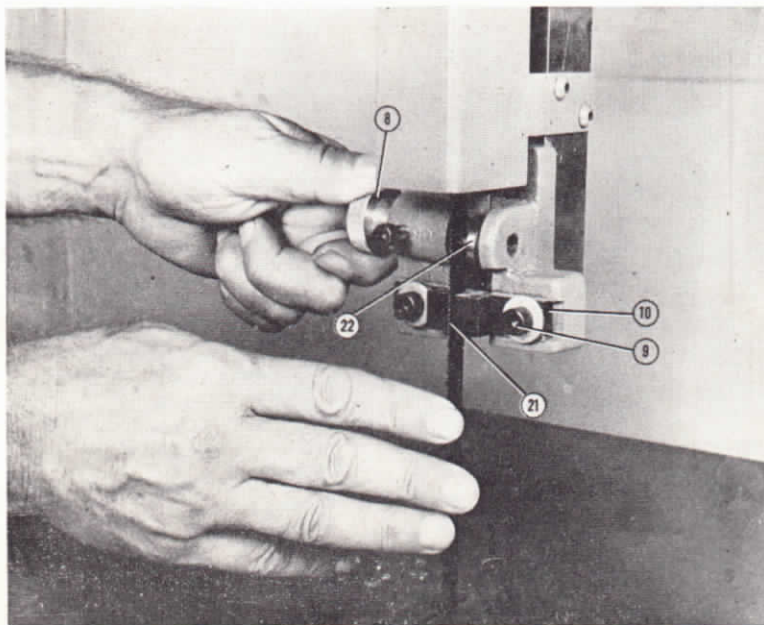


Fig. 4

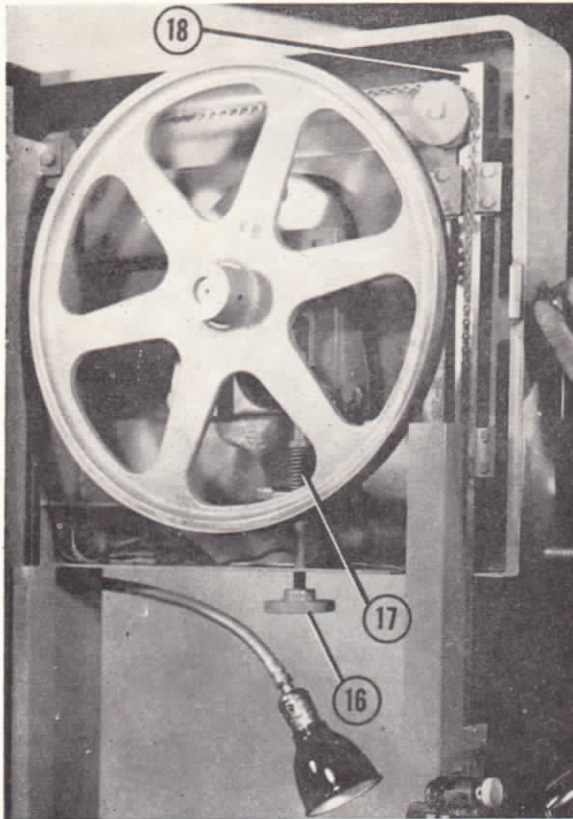


Fig. 5

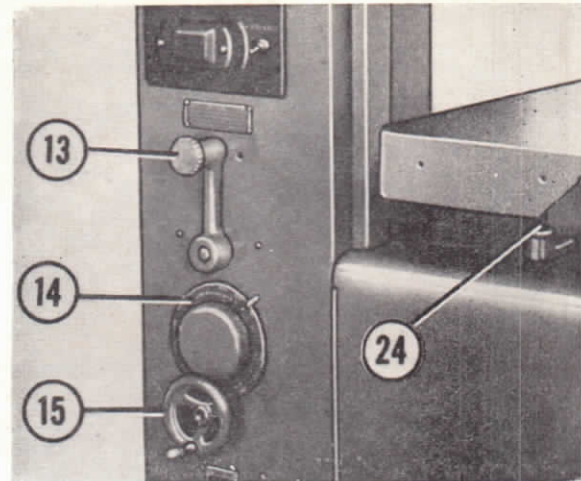


Fig. 6

To shift transmission from low to high or high to low speeds, turn variable speed handwheel to slow speed. Pull the lock pin shifting handle to the right for high speed and to the left for slow speed. Center position of lock pin shifting handle is Neutral.

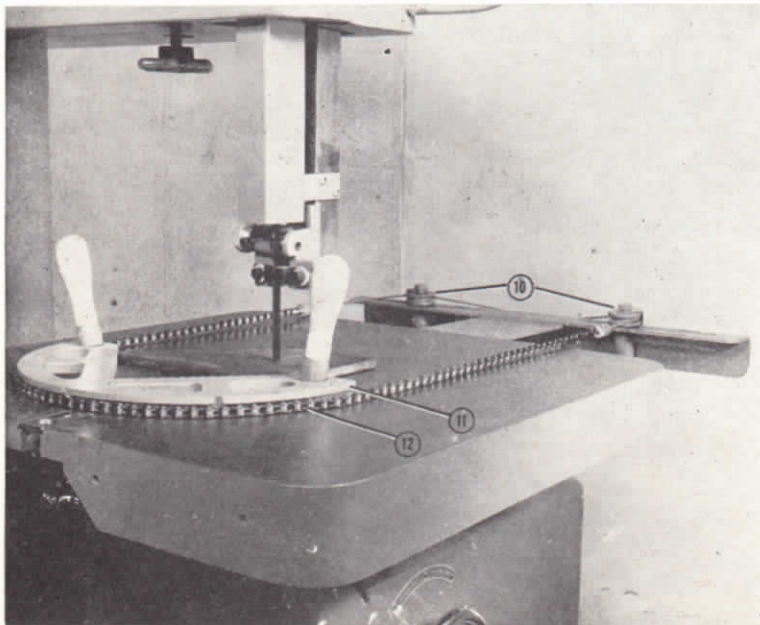


Fig. 7

To operate power feed, push pedal down until latched. Place material against feed block and push against saw blade. Fasten chain hook to chain, place in chain segments and adjust to the material with the adjusting feed wheels. Start saw and release the latch on foot pedal.

To Disassemble Transmission

First—Remove set screws from lower Band Wheel (868), and remove wheel. Remove (3) hex head bolts behind lower wheel, releasing front of transmission box from Band Saw frame. From rear of machine, remove variable speed arm bolt (8134). Swing variable speed arm (8266) out of way. Remove (4) cap screws from base of transmission box. Remove all drive belts. Remove set screws holding variable speed pulley (8903) to shaft (8216). Remove variable speed pulley (8903). Remove set screw (8212) from clutch shift arm (8215) and disengage clutch shift arm from clutch shift shaft (8230). Remove Transmission box from cabinet.

To remove clutch or wheel shaft, first remove top of Transmission box, (8252) and pour out oil. Loosen set screw (8475) and remove clutch shift shaft (8230) and clutch shift fork (8232). Remove bearing cap (8187) and bearing cap gasket (8480.) Remove cap screws (8468) and remove variable speed arm bracket (8263). Put sliding clutch in neutral position and with screwdriver or punch remove wheel shaft lock ring (8457). Lock ring is located between clutch (8197) and high speed clutch assembly (8901). Shaft cannot be removed without removal of this lock ring. Remove wheel shaft from Transmission box by tapping with a wooden block. Shaft is driven out from rear of transmission toward front.

Reverse above procedure for re-assembly.

To remove main shaft (8171), first remove solid bearing cap (8173 and bearing cap gasket (8480). Remove bearing cap (8187) and bearing cap gasket (8480). Loosen allen screws from high speed main shaft sprocket (8174) and low speed main shaft sprocket (8900). With wood block drive main shaft (8171) out from rear of transmission box toward front.

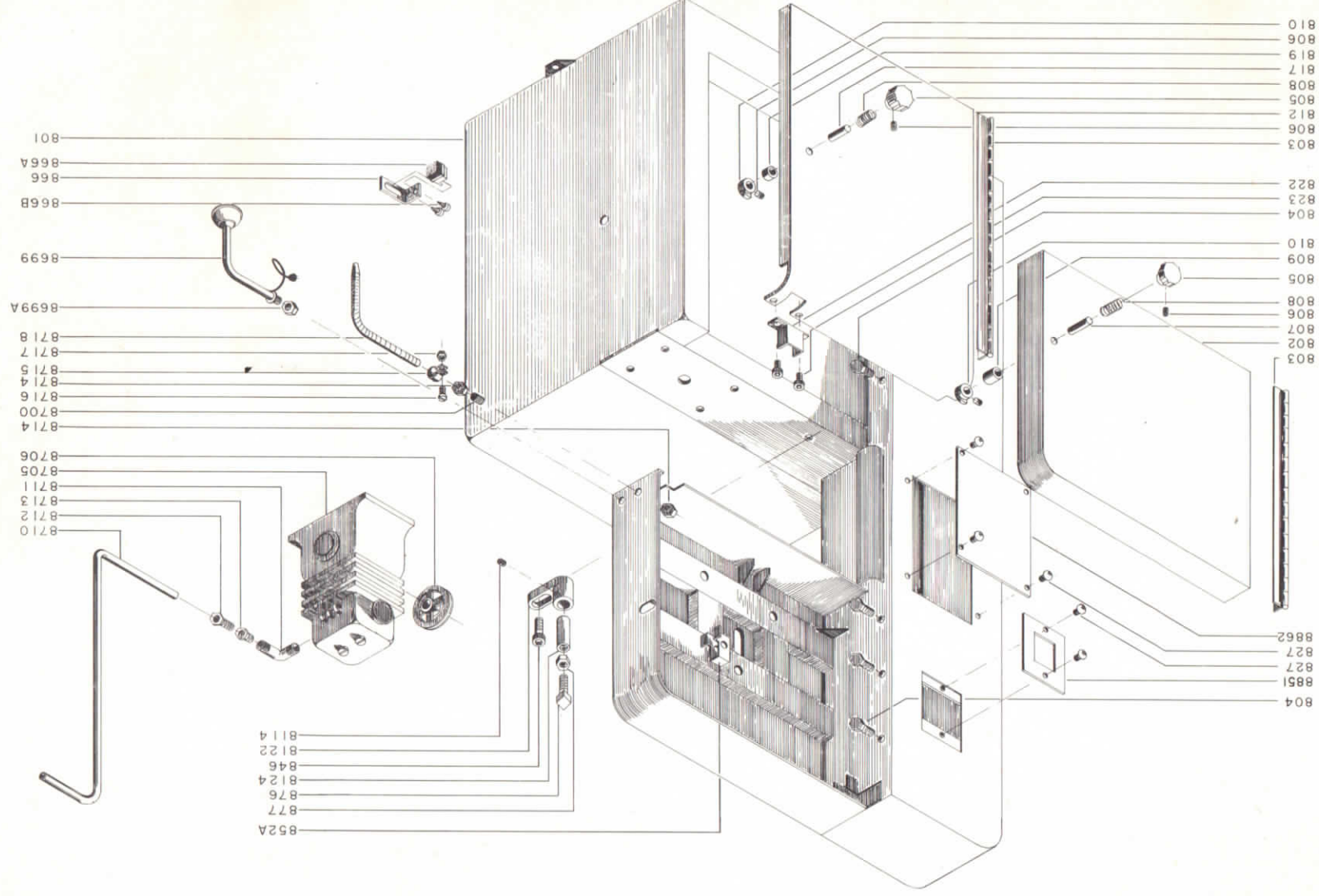
Reverse above procedure for re-assembly.

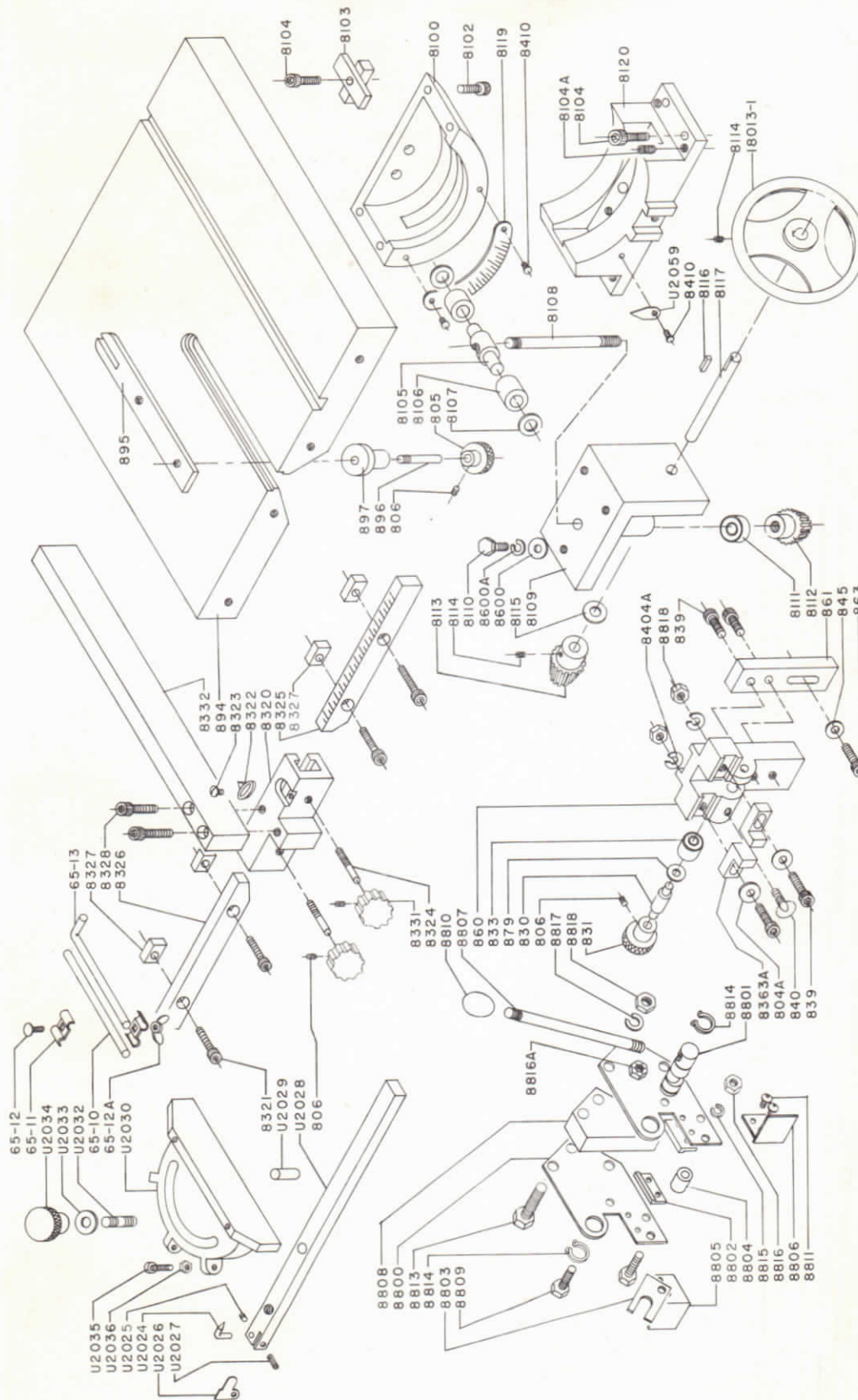
Drive chains may be removed or replaced in transmission box without removing any shaft or sprocket. To remove chain, rotate sprockets until master link appears. Remove master link locking clip. Chain will come apart readily. Transmission box uses 4 drive chains, 3 #40ASA chains 33 links or 66 pitch long and one (1) short chain #40ASA 26 links or 52 pitches long.

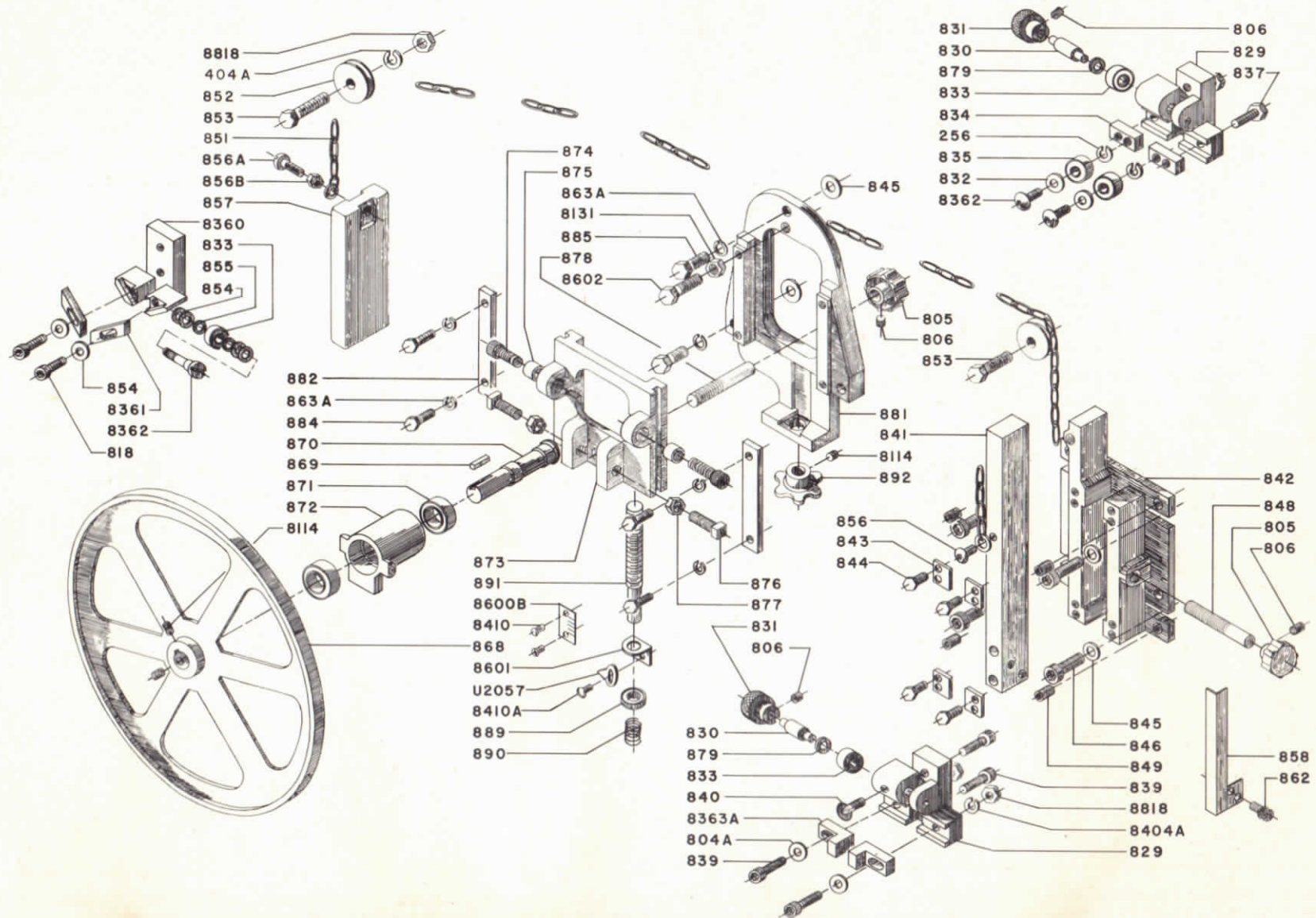
When replacing transmission, transmission box must be leveled to assure proper alignment of drive on lower wheel. Transmission Box feet are equipped with leveling screws for easy adjustment . . .

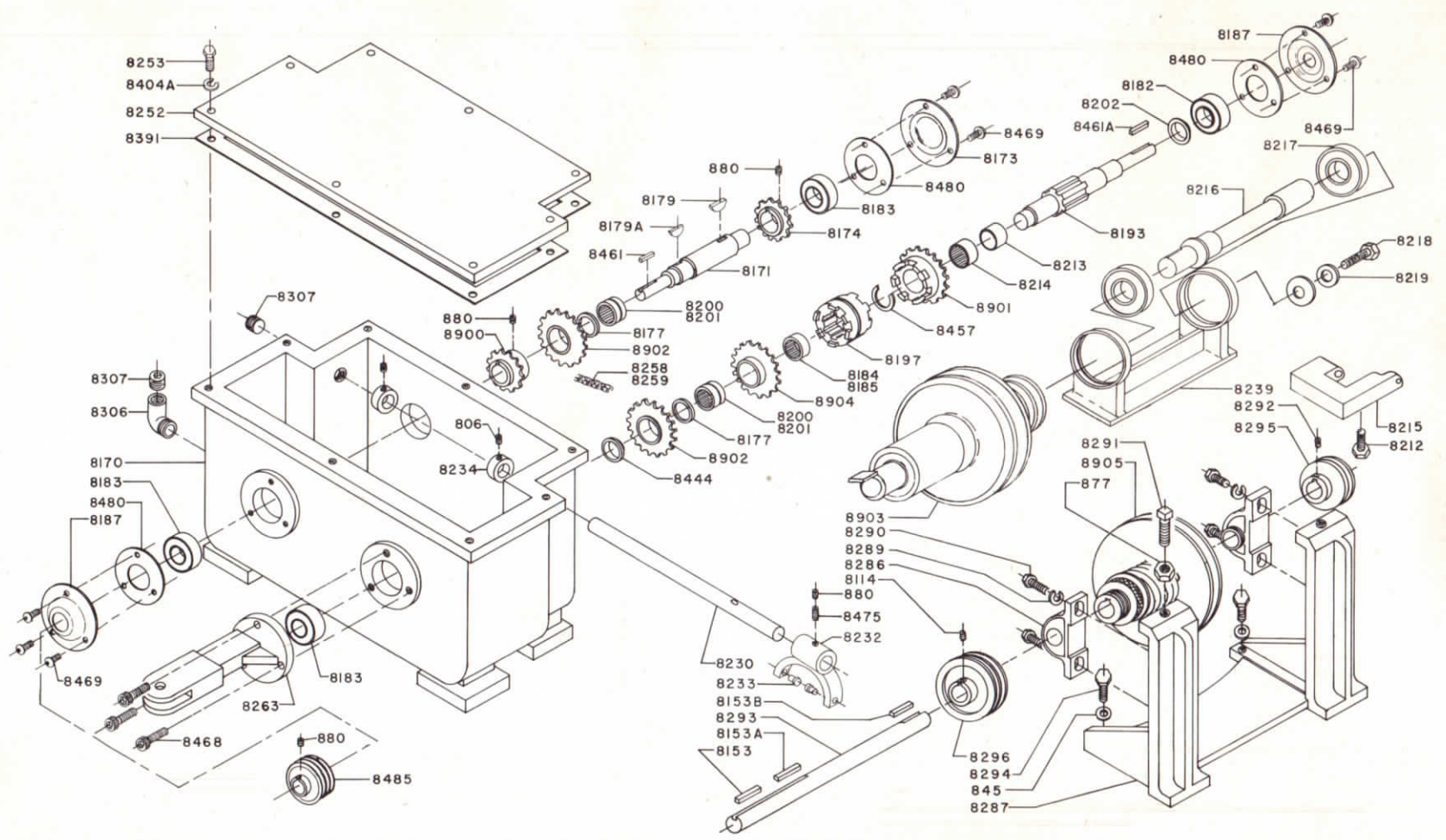
Disassembly Of Speed Adjusting Mechanism

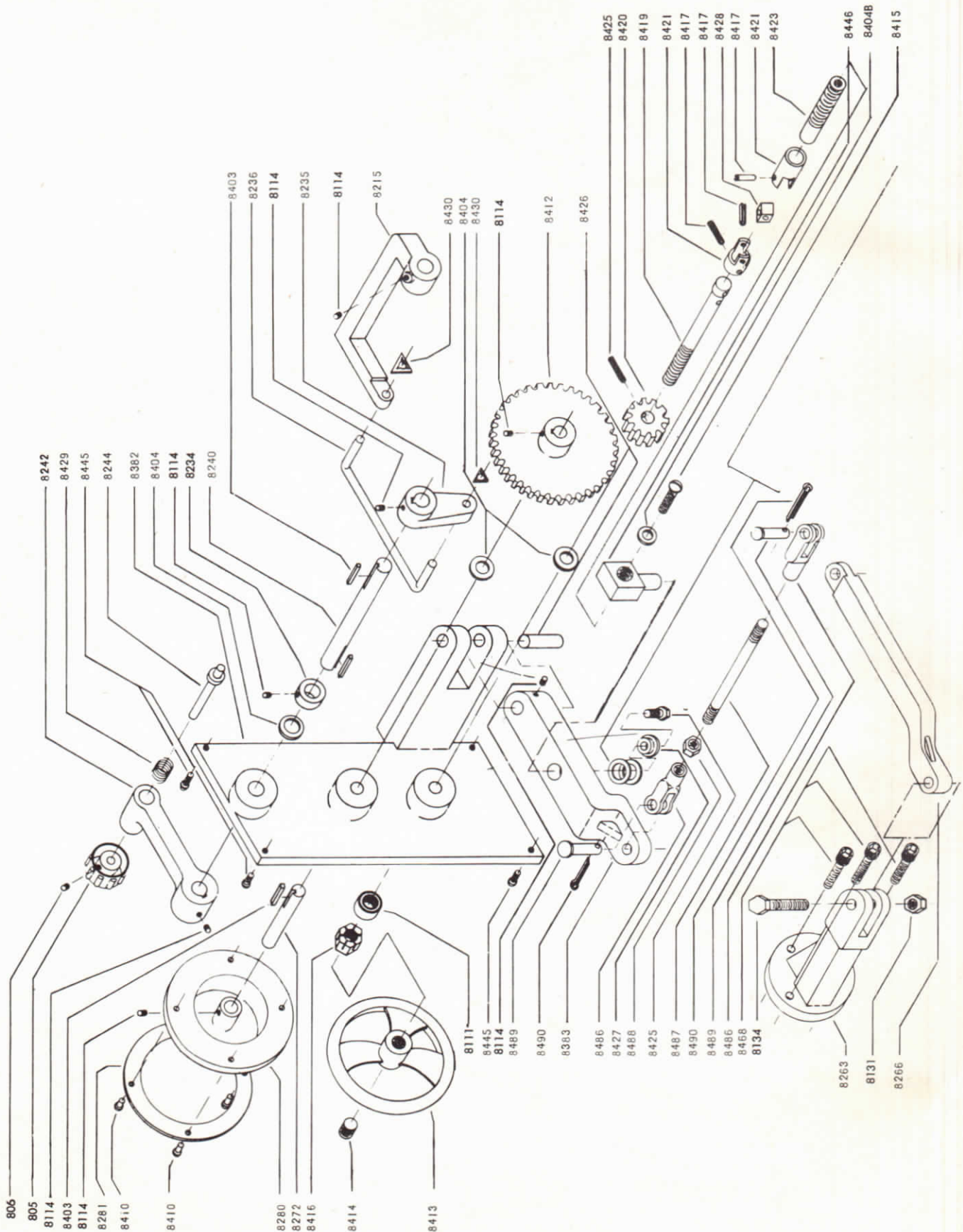
In sequence remove 8414, 8413, 8415, 8418, 8409, 8280, 8401, 8400, 8409, 8404, 8242, 8429, 8444. Remove 8490, 8489 and 8430, disengage 8236 from 8235. Remove (4) bolts and take out. Lift assembly out through electric welder access hole.











MODEL 87 20" METAL CUTTING BAND SAW

Part Number	PART DESCRIPTION	Quantity Required
801	Body Assembly	1
802	Door, Upper	1
803	Hinge, Door (upper & lower)	2
804	Screw, Door Hinge H.H. 5/16-18 x 5/8	6
804A	Washer, Flat 5/16	10
805	Knob 3/8	8
805A	Knob 1/2	1
806	Set screw 1/4-20 x 1/4	13
807	Shaft, Upper Door Lock	1
808	Spring, Lock Shaft	3
809	Spacer, Upper Door Latch	1
810	Latch, Door	3
812	Door, Lower	1
817	Shaft, Door Locking	2
818	Screw, Socket Cap 1/4-20 x 3/4	2
819	Spacer, Door Shaft	2
822	Blade Guard, Lower Door	1
823	Screw, Saw Guard	2
824	Door, Motor Drive	1
826	Switch Box & Cover	1
827	Screw, Switch Box Mounting, Round Head 1/4-20 x 3/8	2
829	Upper Guide Bracket	1
830	Shaft, Blade Guide Bearing	2
831	Knob, Blade Guide Bearing Shaft	2
832	Washer, Flat Thin 3/8	4
833	Bearing, Blade Guide Fafnir 37PP3 or equal	2
834	Plate, Saw Guide Bearing, Mounting	1
835	Bearing, Saw Guide 200 PP	
837	Screw, Saw Guide Bearing 5/16-24 x 7/8	4
838	Screw, Saw Guide Bearing, Socket Head Cap Screw 3/8-24 x 1	4
838A	Screw, Saw Guide Bearing, Socket Head Cap Screw 3/8-24 x 7/8	4
839	Screw, Socket Cap 5/16-18 x 1 1/2	14
839A	Screw, Socket Cap 5/16-18 x 3/4	2
840	Screw, Thumb 1/4-20 x 1/2	2
841	Guide Bar	1
842	Holder, Guide Bar	1
843	Plate, Guide Bar Holder	4
844	Screw, Guide Bar Holder Plate 1/4-20 x 5/8	8
845	Washer, Flat 3/8	21
846	Screw, Socket Cap 3/8-16 x 1 1/2	5
847	Splitpin, Guide Bar Holder 1/4-20 x 1 1/4	2
848	Screw, Guide Bar Locking	1
849	Screw, Socket Set 3/8-16 x 3/4	10
851	Chain, Guide Bar	1
852	Balance Wheel	2
852A	Bracket, balance wheel	2
853	Screw, balance wheel HH 5/16-18 x 1 3/4	2
854	Washer, Flat Thin 1/4	6
855	Washer, Flat 1/4 Special	2

Always give Serial Number of Machine when ordering parts.

Part Number	PART DESCRIPTION	Quantity Required
856	Screw, Chain Mounting 1/4-20 x 3/4, Button Head Socket	1
856A	Screw, Filister Head 6-32 x 5/8	1
856B	Nut, Hex 6-32	2
857	Bar, Balance	1
858	Guard Bar, Saw Blade	1
860	Lower Guide Bracket	1
861	Bar, Lower Guide Mounting	1
862	Screw, Guard Bar Mounting, Button Head Socket 1/4-20 x 1/2	2
863A	Washer, Lock 3/8	17
866	Holder, Wheel Cleaning Brush	1
866A	Brush, Wheel Cleaning	1
866B	Screw, Brush	2
868	Wheel, Band Saw	2
869	Key, Band Saw Wheel	2
870	Shaft, Upper Wheel	1
871	Bearing, Upper Wheel Shaft Fafnir 206	2
872	Bearing, Housing, Upper Wheel Shaft	1
873	Bracket, Upper Bearing Housing	1
874	Pivot Screw, Socket Cap Screw 3/8-16 x 7/8	6
875	Bushing, Pivot Screw 3/8 x 5/8 x 1/2 long	4
876	Screw, Square Head 3/8-16 x 1 1/2	3
877	Nut Hex 3/8-16	7
878	Screw, Upper Wheel Aligning	1
879	Washer Flat 1/4	1
880	Screw, Socket Set 3/8-16 x 3/8	4
880A	Plug, Setscrew 5/16	1
881	Mounting Bracket, Upper Bearing Slide	1
882	Slide Shim, Upper Bearing Housing Bracket	2
884	Screw, H.H. 3/8-16 x 3/4	4
885	Screw, Upper Bearing Slide Bracket, Mounting 3/8-16 x 2	3
889	Bearing, Tension Adjusting Screw, Nice 603	1
890	Spring, Tension Adjusting Screw	1
891	Screw, Tension Adjusting	2
892	Knob, Tension Adjusting	1
894	Table, Band Saw	1
895	Insert, Table	1
896	Screw, Insert Locking	2
897	Spacer, Insert Locking Screw	2
8100	Trunnion, Table Tilting	1
8103	Guide, Trunnion	1
8104A	Screw, Socket Cap 3/8-16 x 1	5
8105	Holder, Trunnion Lock Roller	1
8106	Roller, Trunnion Lock	2
8107	Washer, Flat 1/2	2
8108	Lockscrew, Trunnion	1
8109	Bracket, Trunnion Lockscrew & Gear	1
8110	Screw, Bracket H. H. 5/16-18 x 3/4	7
8111	Bearing, Lockscrew Nice 605	2
8112	Bevel Gear, Lockscrew	1
8113	Bevel Gear, Lockscrew Shaft	1
8114	Screw, Socket Set 5/16-18 x 5/16	11
8115	Washer, Bevel Gear Flat 5/8	1

Always give Serial Number of Machine when ordering parts.

Part Number	PART DESCRIPTION	Quantity Required
8116	Key, Trunnion Lock Shaft.....	1
8117	Shaft, Trunnion Lock Screw.....	1
8119	Dial, Trunnion Tilt.....	1
8120	Bracket, Table Trunnion.....	1
8122	Bracket, Table Stop.....	1
8124	Pin, Table Stop Bracket.....	1
8131	Nut, Hex 1/2-13.....	3
8134	Screw, Variable Speed Arm 1/2-13 x 3.....	1
8153	Key, Lower Countershaft 3/16 x 1 1/2.....	1
8153A	Key, Lower Countershaft 3/16 x 3.....	1
8153B	Key, Lower Countershaft 3/16 x 1.....	1
8170	Box, Transmission.....	1
8170A	Panel, Transmission.....	1
8171	Main Shaft.....	1
8173	Bearing Cap w/o Hole.....	1
8174	Sprocket, High Speed Main Shaft.....	1
8175	Is a V. S. Sheave sold in a unit.....	
8177	Spacer, Inner Transmission.....	2
8179	Woodruff Key #810.....	1
8179A	Woodruff Key #608.....	1
8181	Is a Sheave Sold in a unit.....	
8181A	Is a Bronze Bushing sold in a unit.....	
8182	Bearing Fafnir 5306.....	1
8183	Bearing Fafnir 306.....	3
8184	Bearing, Inner Race I.R. 7315 R.B.C.....	1
8185	Bearing, Outer Race S.J. 7315 R.B.C.....	1
8187	Bearing Cap, With Hole.....	2
8193	Wheel Shaft.....	1
8196	Hub, sold in a unit Assy #8901.....	
8197	Clutch, Center Sliding.....	1
8200	Bearing, Inner Race I.R. 7275, 2C RBC.....	2
8201	Bearing, Outer Race ESJ, 7275, 2CRBC.....	2
8202	Spacer, High Speed Wheel Shaft.....	1
8211	Lock Ring 5133-118.....	1
8212	Screw, Socket Set 5/16-18 x 5/16.....	2
8213	Bearing, Inner Race IR 7315 RBC.....	1
8214	Bearing, Outer Race SJ 7315 RBC.....	1
8215	Clutch, Shift Arm.....	1
8216	Upper Countershaft.....	1
8217	Bearing, Upper Countershaft SKF 6206 2RS.....	2
8225	Pulley & Sheave sold in a unit.....	
8225A	Bushing, sold in a unit.....	
8226	Sheave, V. S., sold in a unit.....	
8230	Shaft, Clutch Shift.....	1
8232	Clutch, Shift Fork.....	1
8233	Pin, Clutch Fork.....	2
8234	Collar, Clutch Shaft.....	3
8235	Arm, Shift.....	1
8236	Rod, connecting.....	1
8237	Is a Sprocket sold in a unit.....	
8238	Nut, sold only in a unit.....	
8239	Bracket, Upper Countershaft.....	1

Always give Serial Number of Machine when ordering parts.

Part Number	PART DESCRIPTION	Quantity Required
8240	Shaft, Shift Lever	1
8241	U-C-Shaft Adjusting Bracket welded to frame	1
8242	Lever, Shift	1
8244	Shaft, Handle	1
8252	Top, Gear Box	1
8253	Screw, H.H. 5/16-18 x 1	8
8256	Screw, H.H. 3/8-16 x 1/4	8
8258	Chain #40 51 Links & 1 connecting Link	1
8259	Chain #40 64 Links & 1 connecting Link	3
8263	Bracket, Speed Arm	1
8266	Speed Arm	1
8272	Shaft, Dial Wheel	1
8280	Dial Wheel	1
8281	Dial, Speed Adjusting	1
8286	Pillow Block PB200 7/8 Bore	2
8287	Bracket, Lower Countershaft	1
8289	Washer	4
8290	Screw, Pillow Block Mounting	4
8291	Screw, Pillow Block Adjusting, Sq. Hd. 3/8-16 x 1 1/2	2
8292	Screw, Socket Set comes w/8295	1
8293	Lower Countershaft	1
8294	Screw, Bracket Mounting HH 3/8-16 x 1	4
8295	Pulley, Compressor AK64 x 3/4	1
8296	Pulley, 2 Groove D2650 x 7/8	1
8297	Compressor Strap, Optional w/Chipblower	1
8298	Belt, Compressor	1
8298A	Belt, 1 1/2 or 2HP Motor 4L530	2
8298B	Motor Holddown Strap	2
8299	Belt, Transmission 4L489	3
8299A	Belt, Variable Speed 2322V441	1
8305	Oil Pipe	1
8306	Ell, Pipe	1
8307	Plug, Pipe	2
8308	Bearing MRC-R-16-ZZ	1
8309	Bearing Holder	1
8361	45° Guide Optional	1
8382	Plate, Speed Adjusting	1
8383	Lever, Hinge	1
8391	Gasket, Transmission	1
8403	Key 3/16 x 1	2
8404	Spacer, Plastic	1
8404A	Washer, Lock 5/16	2
8404B	Washer, Speed Adjusting Screw	2
8410	Screw, Dial & Pointer	9
8412	Spur Gear, Dial Adjusting	1
8413	Handwheel	1
8414	Screw, Socket Set 5/8-11 x 1/2	1
8415	Bolt, Feed Screw HH 5/16-18 x 1/2	2
8416	Nut, Handwheel Shaft 5/8-11 self lock	1
8417	Splitpin 3/16 x 1 1/8	3
8417A	Splitpin 3/16 x 1/2	2
8419	Shaft, Handwheel	1

Always give Serial Number of Machine when ordering parts.

Part Number	PART DESCRIPTION	Quantity Required
8420	Pinion, Spur Gear	1
8421	Universal Joint	2
8423	Feed Screw	1
8425	Screw, Socket Set 10-24 x 3/16	1
8426	Pin, Hinge Lever	1
8428	Block, Universal	1
8429	Spring, Handle Shaft	1
8430	Lock Ring 5305-25	1
8437	Hub, Low Speed Main Shaft	1
8442	Spacer, High Speed, Main Shaft	1
8444	Spacer, Low Speed, Wheel Shaft	1
8446	Nut, Feed Screw	1
8457	Lock Ring, Wheel Shaft	1
8459	Key V. S. Pulley, sold in units only	
8461	Key, Main Shaft 3/16 x 1 1/2	2
8461A	Key, Wheel Shaft 1/4 x 2	1
8468	Screw, Socket Cap 1/4-20 x 1 1/2	3
8468A	Washer, Lock 1/4	3
8469	Screw, Button Head 1/4-20 x 3/8	9
8475	Screw, Socket Set 3/8-16 x 1	1
8480	Gasket, Bearing Cap	4
8484	See 8307	
8485	Pulley, 3 Groove	1
8486	Clevis, Tie Rod	2
8487	Tie Rod	1
8488	Nut, Hex 1/2-20	1
8489	Clevis Pin	2
8490	Cotter Key	2
8491	Nut, Spring Cap, sold in units	
8492	Cap, Spring, sold in units	
8493	Spring V. S., sold in units only	
8494	Bearing 3/4 Steel Ball	1
8495	Plate, Bearing Holder	1
8600	Pointer	1
8600B	Scale, Tension Adjusting	1
8601	Bracket, Tension Adjusting Screw	1
8602	Screw, Upper Bearing Housing Stop H.H. 1/2-13 x 2	1
8699	Lamp, Work	1
8699A	Nut, Hex	1
8700	Stud, Plastic Hose Mounting 9/16-12 x 1	1
8705	Compressor	1
8706	Pulley, Compressor AK64	1
8710	Plastic Tubing	1
8711	Ell 1/4 x 1/8	1
8712	Adaptor 1/4	1

Always give Serial Number of Machine when ordering parts.

Part Number	PART DESCRIPTION	Quantity Required
8713	Fitting, Plastic Tube	2
8714	Nut, Hex 9/16	2
8715	Clamp, Hose	2
8716	Screw, Filister Head 6-32 x 5/8	2
8717	Nut, Hex 6-32	2
8718	Air Line, Flexible, 24" Long	1
8816A	Nut, Hex Self Lock 1/4-20	1
8851	Plate, Switch Box Mounting	1
8862	Plate, Welding Cover	1
8900	Sprocket, Low Speed Main Shaft	1
8901	Clutch, High Speed	1
8902	Sprocket, Low Speed	2
8903	Variable Speed Pulley Assembly, Upper C'Shaft	1
8904	Clutch, Low Speed	1
8905	Lower Variable Speed Pulley Assy.	1
8907	Bearing, Plug Assembly (shown with 8903)	1
18013-1	Handwheel	
U2059	Pointer	
8915	Hand Filing Attachment Assembly	1

Always give Serial Number of Machine when ordering parts.