



Operating Instructions and Parts Manual

10-inch Band Saw

Model JWBS-100S



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Part No. M-707200
Revision A1 12/09
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Warranty and Service

Walter Meier (Manufacturing) Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these Walter Meier Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION

Walter Meier is consistently adding new products to the line. For complete, up-to-date product information, check with your local Walter Meier distributor, or visit waltermeier.com.

WARRANTY

JET products carry a limited warranty which varies in duration based upon the product (MW stands for Metalworking, WW stands for Woodworking).

90 DAY WARRANTY	1 YEAR WARRANTY	Body Repair Kits Bottle Jacks Cable Pullers Cold Saws Hoists-Air Hoists-Electric Metal forming Mill/Drills Milling Machines MW Bandsaws MW Drill Presses MW Finishing Equipment MW Lathes MW Precision Vises	2 YEAR WARRANTY	Palet Trucks Rigging Equip. Service Jacks Stackers Surface Grinders Tapping Trolleys-Air Trolleys-Electric Web Slings Winches-Electric	3 YEAR WARRANTY	WW Benchtop Tools	5 YEAR WARRANTY	Beam Clamps Chain Hoist-Manual Lever Hoists Pullers-JCH Models Scissor Lift Tables Screw Jacks Trolleys-Geared Trolleys-Plain Winches-Manual WW Air Filtration WW Bandsaws WW Buffers	WW Drill Presses WW Dust Collectors WW Dust Filters WW Dust Fittings WW Jointers WW Lathes WW Planers WW Sanders WW Shapers WW Tablesaws	LIFE LIFETIME WARRANTY	Fastening Tools Mechanics Hand Tools Striking Tools Vises (no -precision) Clamps
<i>Warranty reverts to 1 Year Warranty if woodworking (WW) products listed above are used for industrial or educational purposes.</i>											

WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?

This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?

The general JET warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?

Three Year, Five Year and Lifetime Warranties do not cover products used for industrial or educational purposes. Products with Three Year, Five Year or Lifetime Warranties that are used for industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE

The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option. We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the shipping and handling costs of the return.

HOW STATE LAW APPLIES

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY

WALTER MEIER (MANUFACTURING) INC., LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WALTER MEIER 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.

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Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge have been obtained.
5. Do not use this band saw for other than its intended use. If used for other purposes, Walter Meier (Manufacturing) Inc., disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this band saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this band saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint.
 - Crystalline silica from bricks, cement and other masonry products.
 - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the OFF position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. **Keep children away.**



Warnings

20. Make your workshop child proof with padlocks, master switches or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.

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

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

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

- - SAVE THESE INSTRUCTIONS - -

Introduction

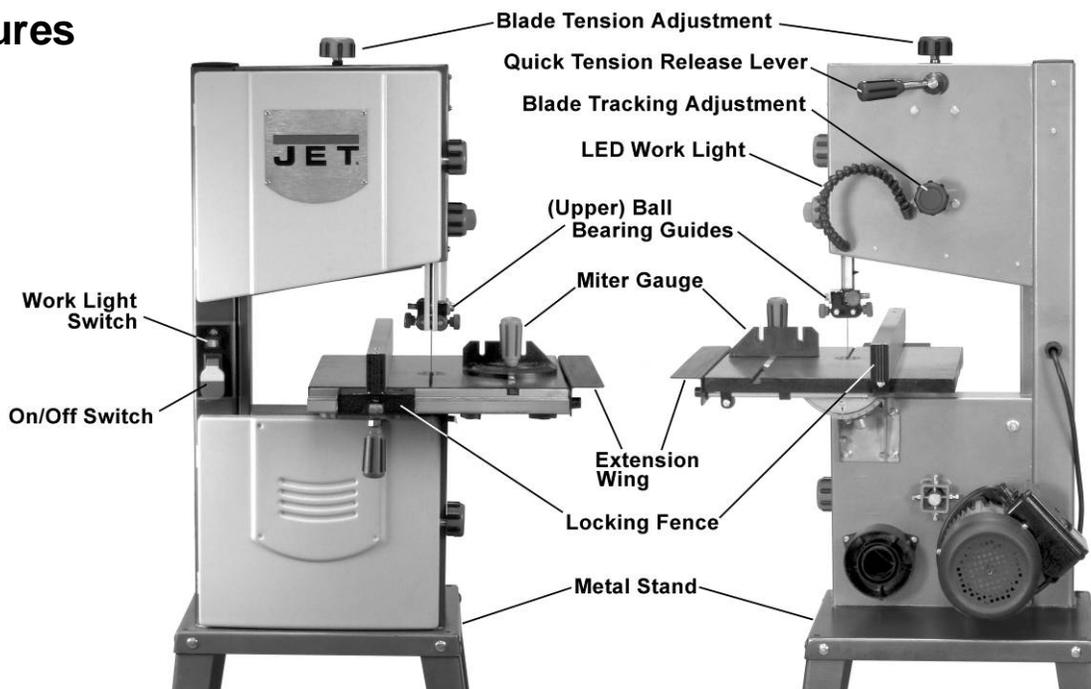
This manual is provided by Walter Meier (Manufacturing) Inc., covering the safe operation and maintenance procedures for the JET model JWBS-100S band saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or Walter Meier can also be reached at our web site: www.waltermeier.com.

Specifications

Model Number.....	JWBS-100S
Stock Number	707200
Band Saw Size (in.)	10
Cutting Capacity (height) (in.)	4-1/8
Cutting Capacity (width) (in.).....	9-1/2
Maximum Rip Left of Blade w/Fence (in.)	5
Maximum Rip Right of Blade w/Fence (in.)	5
Blade Length (in.)	67.5
Blade Speed (FPM)	2750
Minimum Blade Width (in.)	1/8
Maximum Blade Width (in.).....	1/2
Table Size (in.)	13-1/8 x 13-3/8
Table Size with Extension (in.).....	13-1/8 x 19
Table Tilt (degrees).....	0° to 45°
Table Height from Floor (in.).....	42-1/2
Wheel Diameter (in.)	10
Dust Chute Diameter (in.).....	4
Overall Dimensions (HxWxD) (in.).....	74 x 41-1/2 x 39
Motor.....	1/2 HP, 1Ph, 115V
Net Weight (approx.) (lbs.)	71
Shipping Weight (approx.) (lbs.).....	75

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Walter Meier reserves the right to change specifications at any time and without prior notice, without incurring obligations.

Features



Shipping Contents

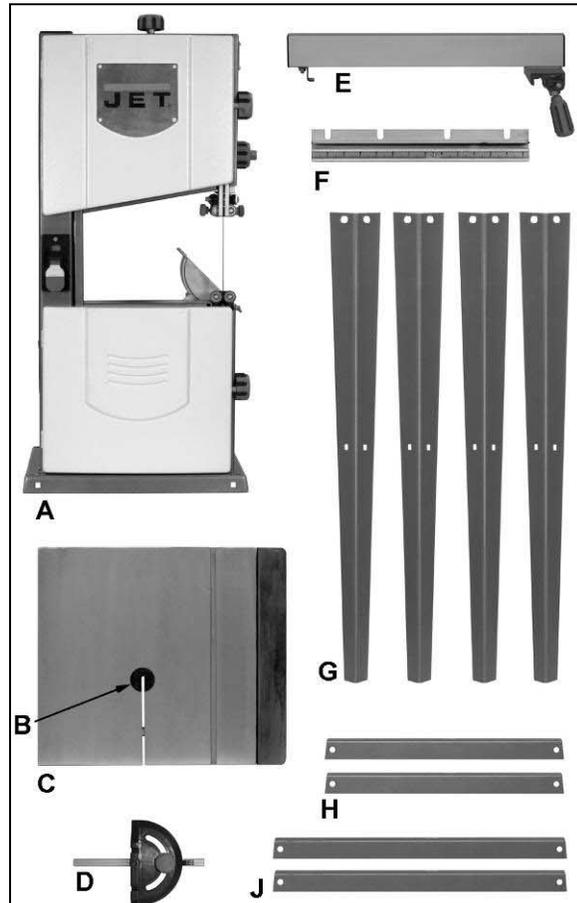
Remove all contents from the shipping carton. Do not discard the carton or packing material until the band saw is assembled and is running satisfactorily.

Compare the contents of the carton against the list of parts in *Contents of Shipping Container* (below). The *letter identification* in the list corresponds to the items shown at right. This is your key for identifying the parts used throughout the *Assembly* section for easy reference.

Remove the protective coating that is applied to the table with a house hold grease and spot remover.

Contents of Shipping Container

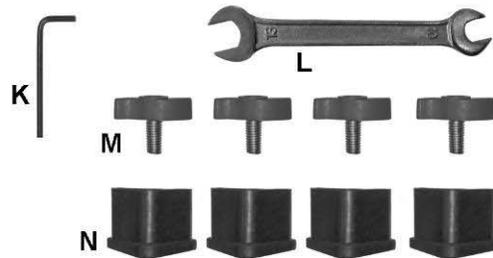
- 1 Band Saw (A)
- 1 Table Insert (B)
- 1 Table (C)
- 1 Miter Gauge (D)
- 1 Fence (E)
- 1 Rail Guide (F)
- 4 Stand Leg (G)
- 2 Short Support Plate (H)
- 2 Long Support Plate (J)
- 1 Owner's Manual (not shown)
- 1 Warranty Card (not shown)
- 1 Hardware Bag (see below for contents)



Contents of the Shipping Container

Contents of Hardware Bag

- 1 Hex Wrench 3mm (K)
- 1 Combination Wrench 10/13mm (L)
- 4 Rail Lock Knob (M)
- 04 Rubber Foot (N)
- 01 M6x32 Hex Cap Screw (O)
- 04 M6x12 Hex Cap Screw (P)
- 16 M8x16 Carriage Bolt (Q)
- 20 M8 Flat Washer (R)
- 16 M8 Hex Nut (S)
- 01 M6 Hex Nut (T)
- 04 M6 External Tooth Lock Washer (U)



Hardware and Tools (reduced)

Tools Required for Assembly & Adjustments

The tools listed below are not included but are required for assembly.

- 2 14mm Open End Wrench
- 1 Cross Point Screw Driver
- 1 Combination Square



Hardware (actual size)

Shipping Contents

Assembly

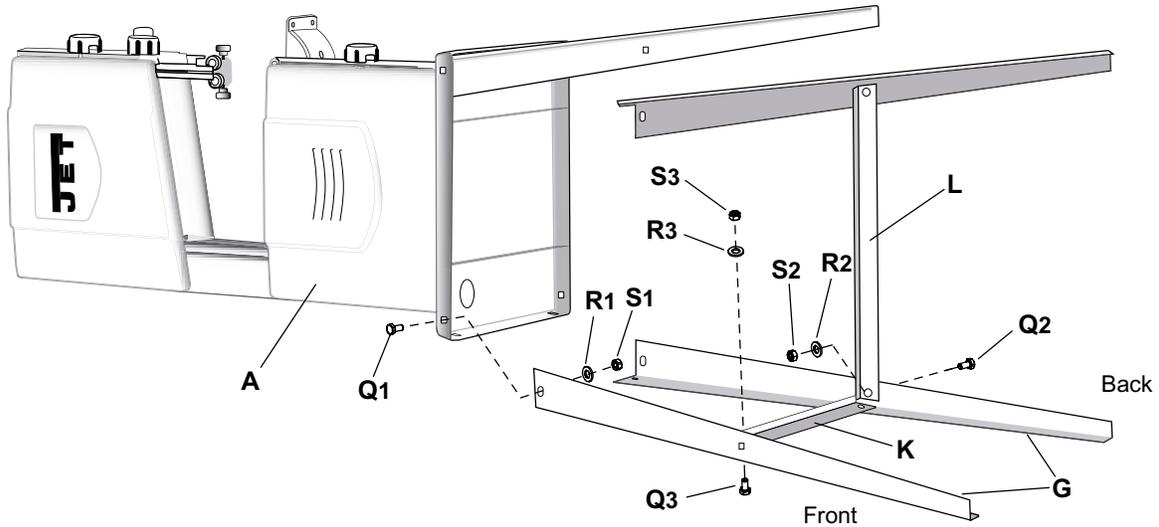


Figure 1

Stand

Referring to Figure 1:

1. Place the *band saw* (A) on its back as shown above, either on the floor or preferably on a workbench.
2. Assemble four *legs* (G) to the inside of the base of the bandsaw, securing each leg with two ea. M8x16 *carriage bolts* (Q1), M8 *flat washers* (R1) and M8 *hex nuts* (S1). Hand-tighten only at this time.
3. Attach a *long plate* (L) to the *rear legs* as shown in Figure 1. Secure with 2 ea M8x16 *carriage bolts* (Q2), M8 *flat washers* (R2), and M8 *hex nuts* (S2). Hand-tighten only at this time.
4. Attach the remaining long plate to the front legs in the same manner described above, hand-tightening only
5. Attach two *short plates* (K) to the right legs and left legs in the same manner. Secure each leg with 2 ea M8x16 *carriage bolts* (Q3), M8 *flat washers* (R3), and M8 *hex nuts* (S3). Hand-tighten only at this time.
6. Slip *rubber feet* (Figure 2) onto the ends of the stand legs.



Figure 2

7. Place the saw and stand upright on a level surface. Make sure that all four legs are contacting the surface.

8. Tighten all nuts with a 13mm socket or wrench.

Table Installation

Referring to Figure 3:

1. Loosen *lock knob* (C2) and pull *extension* (C1) out from the *table* (C).
2. Orient the *table* (C) as shown, then maneuver to allow the *saw blade* (A2) to pass through the *slot* (C3) to the center.
3. Line up four threaded mounting holes underneath the *table* (C) with the four mounting through-holes on the *trunnion* (A1).

Important: Adjust table so *miter slot* (C4) is parallel with *saw blade* (A2).

4. Secure with four each M6x12 *hex cap screws* (P) and M6x12 *external tooth lock washers* (U).
5. Tighten the *screws* (P) with a 13mm wrench.

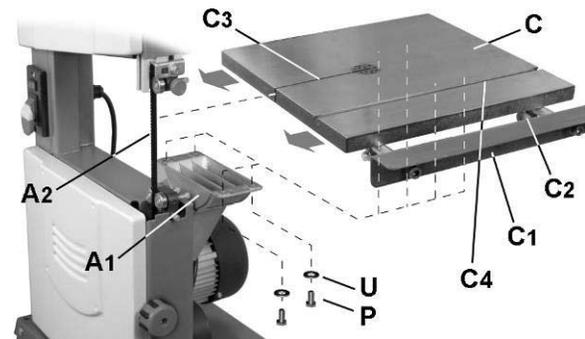


Figure 3

90° Table Stop

Referring to Figure 4:

1. Slightly loosen the *lock knob* (C4) and tilt the *table* (C) up as shown.
2. Thread the M6 *hex nut* (T) approximately half way onto the M6x32 *hex cap screw* (O). Then thread the screw half way into the threaded *mounting hole* (C5) underneath the table. Adjustment will be made later.

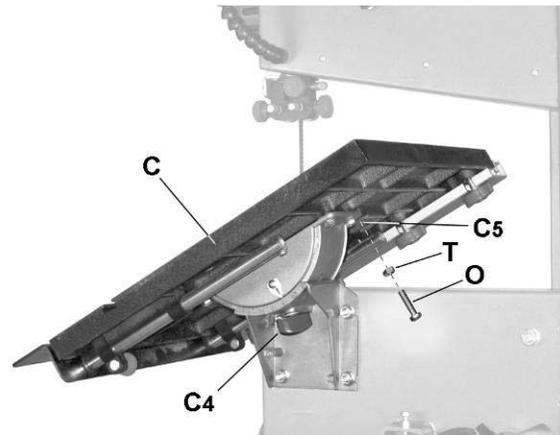


Figure 4

Rail Guide and Fence

Installation

1. Attach the *rail guide* (F, Fig. 5) to the front of the *table* (C). Secure with four *lock knobs* (M).

Referring to Figure 6:

2. Place *fence assembly* (E, Fig. 6) onto the *table* (C) at the miter slot.

The *rear hook* should engage the rear of the table. The *fence body* should engage the *rail guide* (F).

If the fence is not parallel to the miter slot:

3. Loosen two *socket head cap screws* (S1) with a 4mm hex wrench. *End cap* (S2) may need to be removed.
4. Adjust the *fence* so it is parallel to the *miter slot*.
5. Lock the *fence handle*, securing it to the rail guide (F), and verify that the *fence* is still parallel to the *miter slot*.
6. Re-tighten two *screws* (S1) to secure the *fence* to the *fence body* and replace *end cap* (S2).

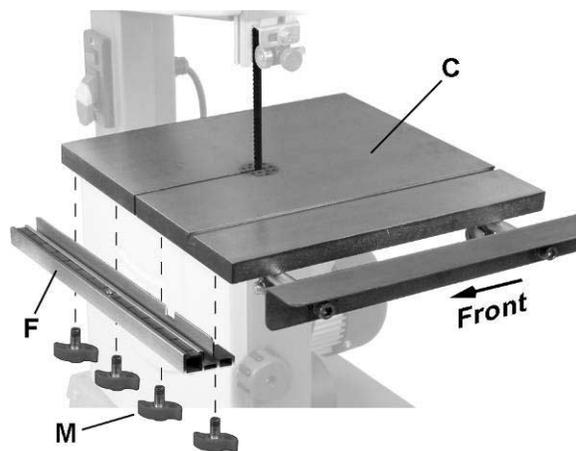


Figure 5

This completes the rail guide and fence installation.

Fence scale adjustment

Referring to Figure 6:

1. Place *fence assembly* (E) onto the *table* (C) **against** the *saw blade* and lock.

If the hairline on the *scale indicator* does not point to zero:

2. Remove *fence assembly* (E).
3. Loosen the *screw* (S3) that secures the *scale* to the *rail guide* (F).
4. Repeat step 1, then slide the *scale* until the hairline on the *scale indicator* points to zero.
5. Being careful not to move the *scale*, unlock and lift fence from the table.
6. Tighten *screw* (S3) to secure *scale*.

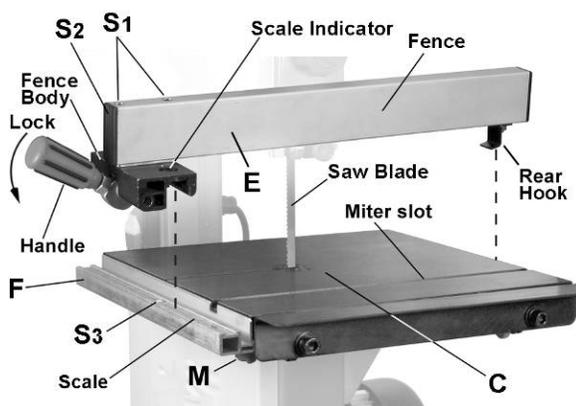


Figure 6

If further adjustment is needed, *lock knobs* (M) can be loosened to allow adjustment of the *rail guide* (F).

Adjustments

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

Tilting the Table

Referring to Figure 7:

1. Loosen the *lock knob* (A).
2. Tilt *table* (C) up to 50 degrees maximum to the right or down 5 degrees to the left. The angle can be read on the *scale* (B) on the trunnion bracket.

Note: Table perpendicular (90°) to the blade corresponds to a scale indication of 0°.

3. Tighten the *lock knob* (A).

Note: The *table stop* (E) must be adjusted to permit the table to tilt to the left.

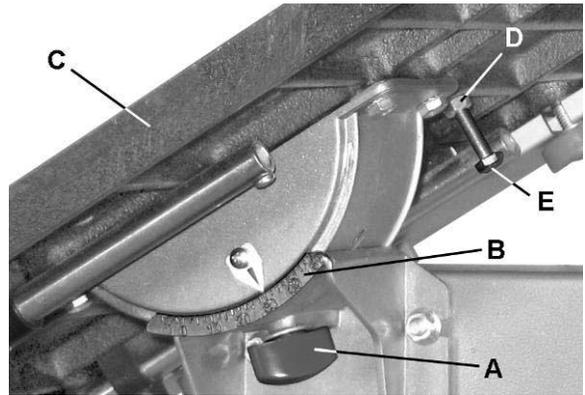


Figure 7

90° Table Stop Adjustment

Adjusting the table stop

The *table stop* (E, Fig. 7) is typically set to stop the table at 90° (perpendicular) with the blade.

1. Disconnect machine from power source.
2. Loosen *lock knob* (A, Fig. 7); then tilt the *table* (C, Fig. 7) down, bringing it to rest against the *table stop* (E, Fig. 7).
3. Use a *square* (J, Fig. 8) placed on the *table* (C, Fig. 8) and against the *blade* (H, Fig. 8) to see if the table is 90° to the blade.
4. If an adjustment is necessary, tilt the *table* up to access the *table stop* (E, Fig. 7).
5. Loosen the *jam nut* (D, Fig. 7) and turn the *table stop* (E, Fig. 7) in or out to raise or lower the stop. Tighten the *jam nut* to hold the *table stop* in place.
6. Tilt the table back to level, letting it rest against the stop and confirm table is 90° with the blade as described in step 3.

For left tilt down to 5°, the table stop (E, Fig. 7) must be adjusted further.

Adjusting the table tilt indicator

1. Set the table at 90° with the blade.
2. Confirm that the *table tilt indicator* (F, Fig. 8) points to zero.

If adjustment is required:

3. Slightly loosen screw securing indicator, adjust indicator to point to zero; then re-tighten screw.

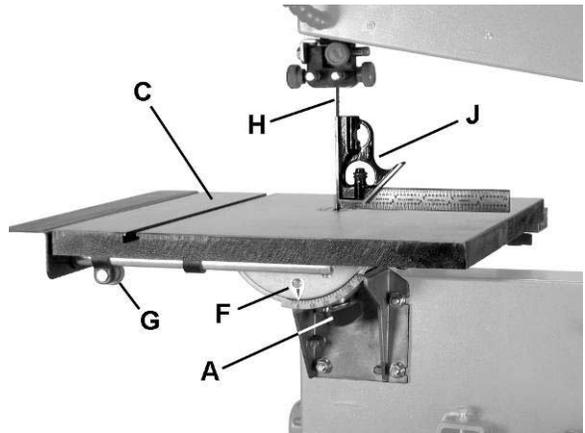


Figure 8

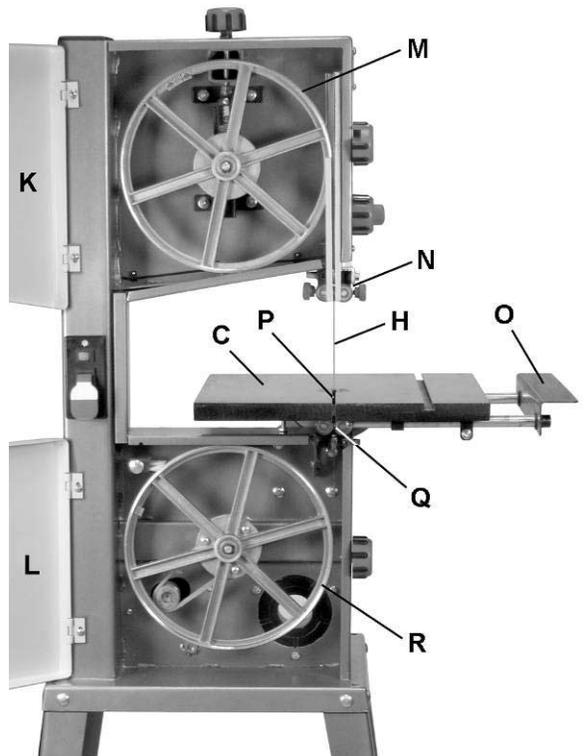


Figure 9

Changing Blades

⚠WARNING Blade teeth are sharp! Use care when handling the saw blade. Failure to comply may cause serious injury.

Note: The JWBS-120S Band Saw comes equipped with a 67.5"x.375"x.014"x6TPI blade (Part No. JWBS100S-8) factory installed.

1. Disconnect machine from power source.
2. Open both *wheel covers* (K, L, Fig. 9).
3. Loosen *lock knob* (G, Fig. 8) and pull *extension* (O, Fig. 9) away from the *table* (C).
4. Remove *rail guide* (F, Fig. 5).
5. Release *tension* on the blade by moving the *tension handle* (V, Fig. 10) to the right.

Referring to Figure 9:

6. Remove *blade* (H) from *upper* and *lower wheels* (M, R) and from between the *upper* and *lower blade guides* (N, Q).
7. Remove the blade through the *slot* (P) in the table.
8. Guide the *new blade* through table *slot* (P) leading with the smooth edge. Place it around the upper and lower wheels and into the *upper* and *lower blade guides* (N, Q).

Note: The blade teeth should face the operator, and they should point down toward the table.

9. Position the blade to track in the middle of the rubber tires on the *wheels* (M, R).
10. Engage *tension* on the blade by moving the *quick tension handle* (V, Fig. 10) to the left.
11. Replace *rail guide* (F, Fig. 5).

Before operating the saw, check that the blade is tracking and has proper tension as described in *Adjusting Blade Tension* and *Adjusting Blade Tracking* below.

Adjusting Blade Tension

Referring to Figure 10:

1. Disconnect machine from power source.
The *blade tension knob* (T) is used to adjust blade tension.
- Note 1:** The *quick tension lever* (V) must be engaged before making tension adjustments with *knob* (T).
- Note 2:** All bearings on upper and lower guides must be clear of blade (see *Blade Guide* and *Guide Bearing* adjustments on following page).
2. Apply just enough tension to take the slack out of the blade.
 3. Turn one wheel a few times to allow the blade to position itself in the center of the tire.

Note: If blade does not center see *Adjusting Blade Tracking* section (this page).

A *scale* (X) directly behind the *upper wheel* (M) indicates the approximate tension according to

the width of the blade.

4. Set the blade tension with *knob* (T) to correspond to the blade width as marked on the *gauge* (X).

Note: A meter is recommended to precisely set tension the blade for the size of blade used.

Note 1: As you become more experienced with the saw, you may find it necessary to change the blade tension from the initial setting. Changes in blade width and the type of material being cut will have an effect on blade tension.

Note 2: Keep in mind that too little or too much blade tension can cause blade breakage.

Adjusting Blade Tracking

Referring to Figure 10:

⚠WARNING Disconnect machine from the power source! Never adjust blade tracking with the machine running! Failure to comply may cause serious injury!

Tracking refers to how the blade is situated upon the wheels while in motion. The blade *should track in the center of both wheels*.

The blade must be slightly tensioned (see previous section) before adjusting blade tracking. Make sure *blade guides and bearings* (N, Q, Fig. 9) do not interfere with the blade. If blade tracking is required, blade guide adjustment is described on the following page.

1. Open the top and bottom wheel covers. Rotate the wheel forward by hand, and observe the position of the blade on the wheel through the *window* (S). It should be in the center of the wheel.

If adjustment is necessary:

2. Loosen the *wing nut* (U) and make adjustment with *tracking knob* (W) while rotating wheel by hand.
3. Tightening the tracking knob slightly will move the blade so it tracks towards the rear of machine. Loosening the tracking knob slightly will cause the blade to track toward the front of the machine.
4. After blade is tracking in the center of the wheel, tighten the *wing nut* (U).

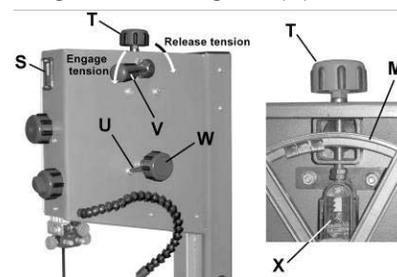


Figure 10

Upper Blade Guide Positioning

Referring to Figure 11:

The upper blade guide assembly (C) should be adjusted to just above the material being cut. To adjust:

Loosen *lock knob* (B) and raise or lower the upper blade guide assembly (C) by turning the *height adjustment knob* (A).

Blade Guide Adjustment

Overview

The blade guide assembly consists of two roller guides (bearings) positioned on each side of the blade to provide blade stability. A third guide (thrust bearing) is positioned behind the blade to provide blade support.

There are two blade guide assemblies – an upper assembly and lower assembly (see Figure 12).

Adjustments are performed in the same manner for each assembly. Each assembly must be adjusted in turn using the adjustment procedures outlined below.

Thrust Bearing Adjustment

⚠WARNING Disconnect machine from the power source! Never make adjustments with the machine running! Failure to comply may cause serious injury!

Referring to Figure 12:

1. Disconnect machine from power source.

Note: Blade must already be tensioned and tracking properly (*Adjusting Blade Tension*, page 10).

2. For the upper thrust bearing, loosen *thumbscrew* (B). For the lower blade guide, loosen *setscrew* (B) with the 3mm hex wrench provided.
3. Slide the *adjustment shaft* (C) so the blade is positioned in the middle of the *thrust bearing* (A).

The *thrust bearing* (A) is mounted on a *concentric shaft* (C). When the shaft is rotated, the relative position of the bearing to the back of the blade can be changed.

4. Rotate the *adjustment shaft* (C) so the *thrust bearing* (A) just clears the back of the saw blade.
5. Tighten *thumbscrew/setscrew* (B).

If a blade is being replaced with a new one of a different size, the adjustment described above may fall out of range and further adjustment may be required as follows:

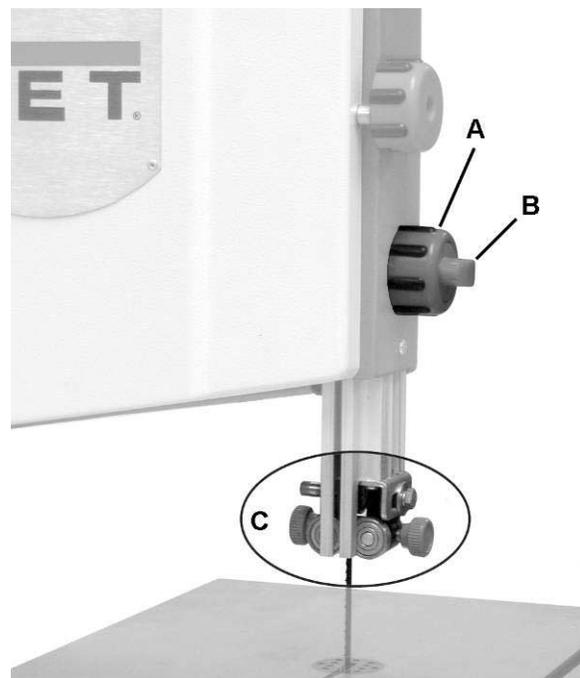


Figure 11

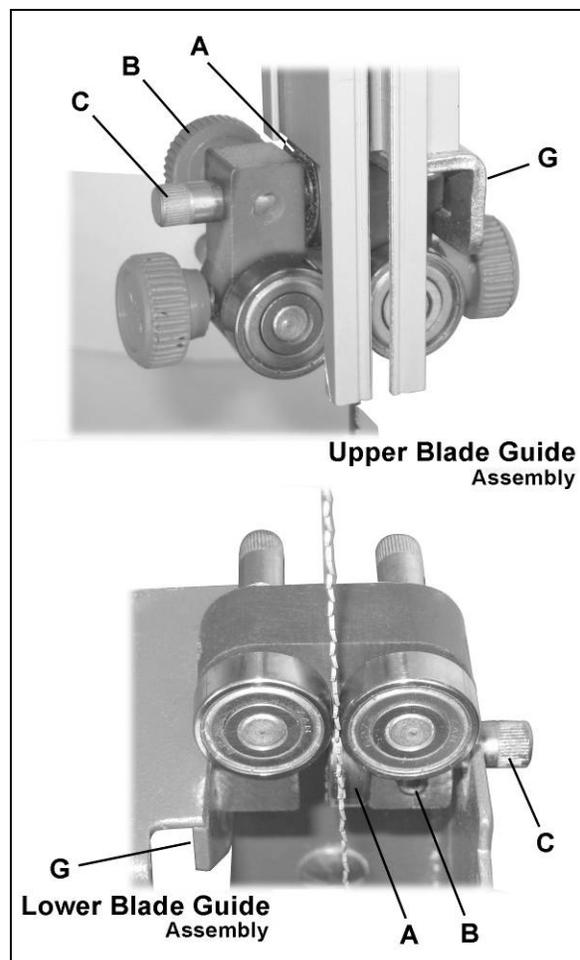


Figure 12

Loosen the *hex cap screw* (G, not visible) with a 10mm wrench and adjust the entire assembly back or forth to just clear the back of the saw blade. Tighten *screw* (G), then fine tune the adjustment by repeating the first part of this step.

6. Secure the *roller guide* (A) by tightening the *thumbscrew* (B, upper guide) or *setscrew* (B, lower guide).

Guide Bearing Adjustment

⚠WARNING Disconnect machine from the power source! Never make adjustments with the machine running! Failure to comply may cause serious injury!

Referring to Figure 13:

1. Disconnect machine from power source.

Note: Blade must already be tensioned and tracking properly (*Adjusting Blade Tension*, page 11).

2. For the upper blade guide, loosen two *thumbscrews* (E). For the lower blade guide, loosen two *setscrews* (E) with the 3mm hex wrench provided.
3. Slide the *adjustment shaft* (F) to position each roller guide (D) approximately 1/16" behind the gullets of the saw blade.

The *roller guide* (D) is mounted on a *concentric shaft* (F). When the shaft is rotated, the relative position of the guide to the blade can be changed.

4. Rotate each *adjustment shaft* (F) to position the *guides* (D) within 1/32" of the saw blade.
5. Secure the *roller guides* (D) by tightening *thumbscrews* (E, upper guide) or *setscrews* (E, lower guide).

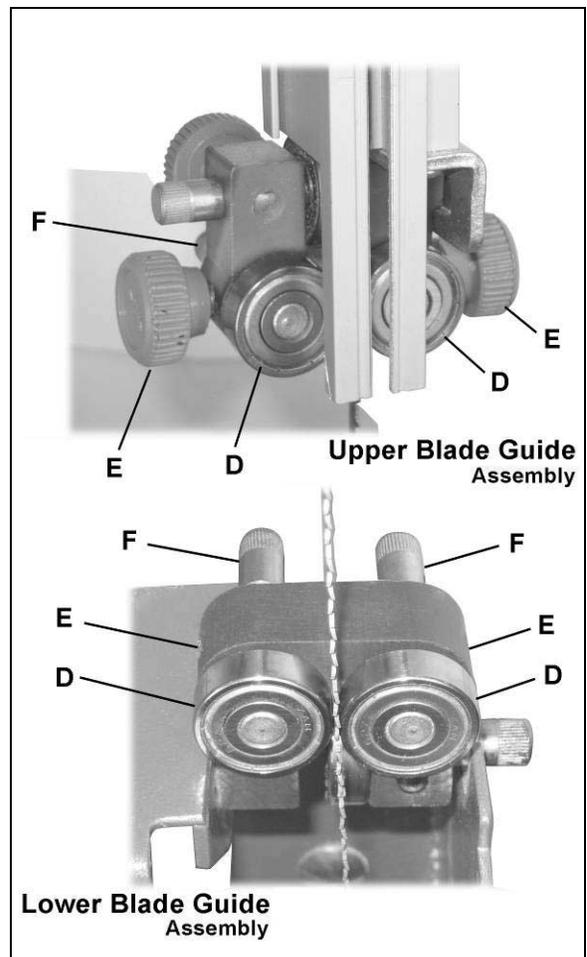


Figure 13

Operating Controls

On/Off Switch – located on front of machine: pull switch out to start; push switch in to stop. When yellow safety key is removed, machine will not start.

Work Lamp Switch – located on front of machine above On/Off switch. Turns LED work lamp on and off.

Replacing the Poly V-Belt

⚠WARNING Disconnect machine from the power source! Never make adjustments with the machine running! Failure to comply may cause serious injury!

1. Unplug the machine from the power source.
2. Open the upper and lower wheel cover doors.
3. Remove the saw blade as described in *Changing Blades* on page 11.
4. Remove tension on the *drive belt* (D) by loosening the *hex cap screw* (13mm wrench required) on the back of the cabinet that secures the motor.

Referring to Figure 14:

5. Using snap ring pliers, remove the *snap ring* (E) that secures the *lower wheel* (B) to the *shaft* (A).
6. Slide the lower wheel assembly off the *shaft* (A) which will dislodge the *belt* (D) and discard the old belt.
7. Place the new belt onto the lower wheel pulley.
8. Reinstall lower wheel assembly by sliding it back onto the *shaft* (A).
9. Replace *snap ring* (E).
10. Place the new *belt* (D) partially around the *motor pulley* (C) to get it started, then turn the *wheel* (B) by hand until the *belt* (D) is completely seated on the *motor pulley* (C).
11. Push the motor down to add tension to the *belt* (E).

The belt is properly tensioned when *moderate* finger pressure on the belt between the two pulleys causes a 1/2" deflection.

12. Tighten the *hex cap screw* on the back of the cabinet that secures the motor.

Re-install the blade as described in *Changing Blades* on page 11.

Adjusting Poly V-Belt Tension

⚠WARNING Disconnect machine from the power source! Never make adjustments with the machine running! Failure to comply may cause serious injury!

Referring to Figure 14:

1. Unplug the machine from the power source.
2. With a 13mm wrench, loosen the *hex cap screw* on the back of the cabinet that secures the motor.
3. Push the motor down to add tension to the *belt* (D).

The belt is properly tensioned when *moderate* finger pressure on the belt between the two pulleys causes a 1/2" deflection.

4. Tighten the *hex cap screw* that secures the motor.

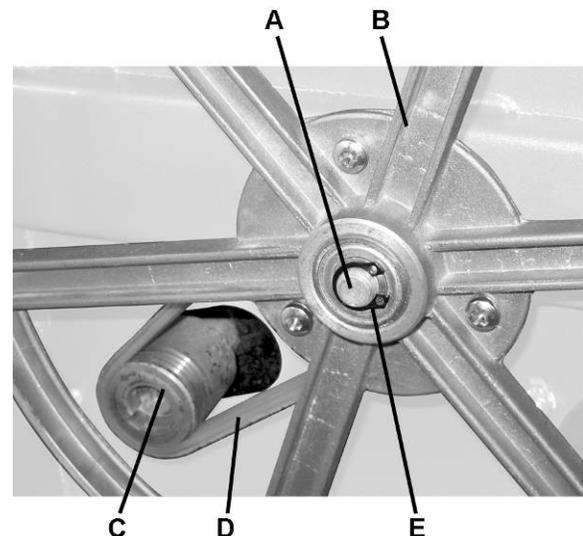


Figure 14

Grounding Instructions

General Information

⚠️WARNING This Band Saw must be grounded while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug that looks similar to the plug in Figure 15. The plug must be inserted into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

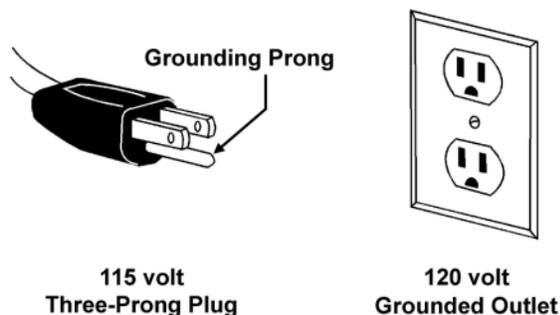


Figure 15

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Repair or replace a damaged or worn cord immediately.

115 Volt Operation

As received from the factory, your bandsaw is ready to run at 115-volt operation. This bandsaw is intended for use on a circuit that has an outlet and a plug that looks like the one illustrated in Figure 4. An adapter with a grounding ear (Figure 16) may be used temporarily to connect this plug to a two-pole receptacle as shown

(Figure 11), if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. This adapter is not applicable in Canada. The green colored rigid ear, lug, or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box, as shown in Figure 5.

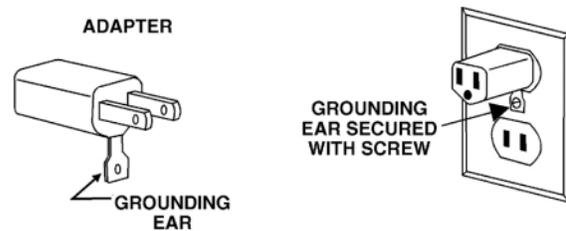


Figure 16

Extension Cords

Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Make sure the cord is in good condition and heavy enough to carry the current your band saw will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Table 1 shows the correct size to use depending on cord length and the ampere rating on your machine's nameplate. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Repair or replace a damaged or worn cord immediately.

Power		Extension Cord	
Current (Amps)	Line voltage	Cord length in feet	Cord gauge (AWG)
0-6	120	0 to 25	18
		25 to 50	16
		50 to 100	16
		over 100	14
6-10	120	0 to 25	18
		25 to 50	16
		50 to 100	14
		over 100	12
10-12	120	0 to 25	16
		25 to 50	16
		50 to 100	14
		over 100	12
12-16	120	0 to 25	14
		25 to 50	12
		over 50	not recommended

Table 1

Troubleshooting

Trouble	Probable Cause	Remedy
Saw stops or will not start	Saw unplugged	Check plug connections
	Fuse blown, or circuit breaker tripped	Replace fuse, or reset circuit breaker
	Cord damaged	Replace cord
Does not make accurate 45° or 90° cuts	Stop not adjusted correctly	Check blade with square and adjust stop (see <i>Adjusting Table Stop</i> on page 10).
	Angle pointer not set accurately	Check blade with square and adjust pointer (see <i>Adjusting Table Stop</i> on page 10).
Blade wanders during cut	Fence not aligned with blade	Check and adjust fence
	Warped wood	Select another piece of wood
	Excessive feed rate	Reduce feed rate
	Incorrect blade for cut	Change blade to correct type
	Blade tension not set properly	Set blade tension according to blade size
	Guide bearings not set properly	Review guide bearing adjustment.
Saw makes unsatisfactory cuts	Dull blade	Replace blade
	Blade mounted wrong	Teeth should point down
	Gum or pitch on blade	Remove blade and clean
	Incorrect blade for cut	Change blade to correct type
	Gum or pitch on table	Clean table
Blade does not come up to speed	Extension cord too light or too long	Replace with adequate size and length cord
	Low shop voltage	Contact your local electric company
Saw vibrates excessively	Base on uneven floor	Reposition on flat, level surface
	Bad v-belt	Replace v-belt
	Motor mount is loose	Tighten motor mount hardware
	Loose hardware	Tighten hardware

Optional Accessories

10" Band Saw Blades

Stock No.	Application	Length	Width	Thickness	TPI
707201	Scrollwork	67.5"	0.125"	0.025"	18TR
707202	Resaw	67.5"	0.5"	0.032"	4HK
707203	General Purpose	67.5"	0.5"	0.025"	6HK
707204	General Purpose	67.5"	0.25"	0.025"	6SK

Parts

Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:30 a.m. and 5:30 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

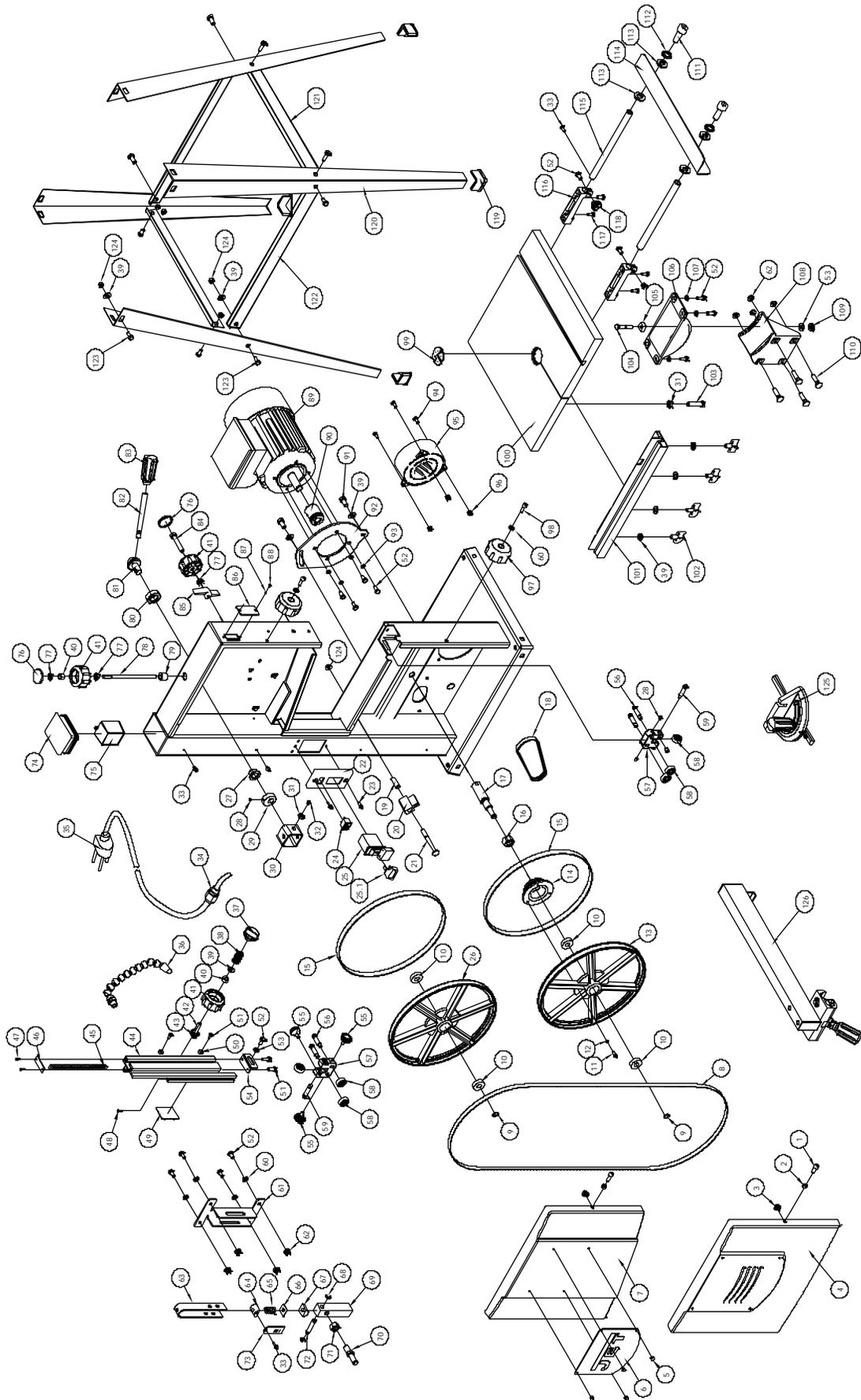
Parts List

Index No.	Part No.	Description	Size	Qty
1	TS-1503041	Socket Head Cap Screw	M6x16	2
2	JWBS10OS-2	Spacer		2
3	TS-1541021	Nylon Insert Lock Nut	M6	2
4	JWBS10OS-4	Lower Door		1
5	JWBS10OS-5	Rivet	2.5x5	4
6	JWBS10OS-6	JET Nameplate		1
7	JWBS10OS-7	Upper Door		1
8	JWBS10OS-8	Blade	67.5 x .375 x .014, 6TPI	1
9	JWBS10OS-9	Retaining Ring	10	2
10	BB-6000ZZ	Ball Bearing	6000ZZ	4
11	TS-1533032	Pan Head Machine Screw	M5x10	3
12	TS-2361051	Lock Washer	M5	3
13	JWBS10OS-13	Lower Wheel		1
14	JWBS10OS-14	Pulley		1
15	JWBS10OS-15	Tire		2
16	JWBS10OS-16	Nut	M20	1
17	JWBS10OS-17	Lower Wheel Shaft		1
18	JWBS10OS-18	Belt		1
19	JWBS10OS-19	Spacer Bushing		1
20	JWBS10OS-20	Brush		1
21	JWBS10OS-21	Carriage Bolt	M8x70	1
22	JWBS10OS-22	Switch Plate		1
23	TS-2284121	Flat Head Machine Screw	M4x12	2
24	JWBS10OS-24	LED Lamp Switch		1
25	JWBS10OS-25	Start/Stop Switch		1
25-1	JWBS10OS-25-1	Switch Safety Key		1
26	JWBS10OS-26	Upper Wheel		1
27	JWBS10OS-27	Sleeve		1
28	TS-1523011	Socket Set Screw	M6x6	5
29	JWBS10OS-29	Eccentric Block		1
30	JWBS10OS-30	Square Housing		1
31	TS-1540041	Hex Nut	M6	2
32	TS-1523041	Socket Set Screw	M6x12	1
33	TS-2171012	Pan Head Machine Screw	M4x6	10
34	JWBS10OS-34	Strain Relief		2
35	JWBS10OS-35	Cord with Plug		1
36	JWBS10OS-36	LED Lamp Assembly		1
37	JWBS10OS-37	Locking Knob		1
38	JWBS10OS-38	Spring		1
39	TS-1550061	Flat Washer	M8	23
40	JWBS10OS-40	Nut		2
41	JWBS10OS-41	Knob		3
42	JWBS10OS-42	Shaft		1
43	JWBS10OS-43	Gear		1
44	JWBS10OS-44	Blade Guard		1
45	JWBS10OS-45	Rack		1
46	JWBS10OS-46	Dust Cover		1
47	JWBS10OS-47	Self-Tapping Screw	ST3.5x9.5	2

Index No.	Part No.	Description	Size	Qty
48	JWBS10OS-48	Self-Tapping Screw	ST2.2x6.5	1
49	JWBS10OS-49	Sliding Plate		1
50	JWBS10OS-50	Guide Block		2
51	JWBS10OS-51	Self-Tapping Screw	ST4.2x13	4
52	TS-1482021	Hex Cap Screw	M6x12	11
53	JWBS10OS-53	Washer		2
54	JWBS10OS-54	Guide Seat		1
55	JWBS10OS-55	Lock Knob		3
56	JWBS10OS-56	Bearing Shaft		4
57	JWBS10OS-57	Bearing Bracket		2
58	JWBS10OS-58	Ball Bearing	627ZZ	6
59	JWBS10OS-59	Bearing Shaft		2
60	TS-1550041	Flat Washer	M6	4
61	JWBS10OS-61	Guide Plate		1
62	JWBS10OS-62	Hex Flange Nut	M6	8
63	JWBS10OS-63	U-Bracket		1
64	JWBS10OS-64	Semi-Sphere Segment		1
65	JWBS10OS-65	Spring		1
66	JWBS10OS-66	Tension Scale Pointer		1
67	JWBS10OS-67	Nut		1
68	JWBS10OS-68	E-Clip	6	2
69	JWBS10OS-69	Upper Wheel Axis Seat		1
70	JWBS10OS-70	Upper Wheel Shaft		1
71	TS-1540071	Hex Nut	M10	1
72	JWBS10OS-72	Shaft		1
73	JWBS10OS-73	Tension Scale		1
74	JWBS10OS-74	Plug		1
75	JWBS10OS-75	Voltage Adapter		1
76	JWBS10OS-76	Knob Cover		1
77	JWBS10OS-77	Hex Jam Nut		5
78	JWBS10OS-78	Fastening Shaft		1
79	JWBS10OS-79	Tension Sleeve		1
80	JWBS10OS-80	Nut	M14x1.5P	1
81	JWBS10OS-81	Hub		1
82	JWBS10OS-82	Handle		1
83	JWBS10OS-83	Handle Grip		1
84	TS-1490081	Hex Cap Screw	M8x45	1
85	JWBS10OS-85	Wing Nut		1
86	JWBS10OS-86	Blade Tracking Window		1
87	TS-1550021	Flat Washer	M4	2
88	JWBS10OS-88	Pan Head Machine Screw	M4x5	2
89	JWBS10OS-89	Motor	1/2HP, 1Ph, 115V	1
	JWBS10OS-89-1	Capacitor (not shown)	25µF/250V	1
90	JWBS10OS-90	Motor Pulley		1
91	TS-1490021	Hex Cap Screw	M8x16	2
92	JWBS10OS-92	Motor Mount		1
93	TS-2361061	Lock Washer	M6	4
94	TS-1533042	Pan Head Machine Screw	M5x12	3
95	JWBS10OS-95	Dust Chute		1
96	TS-1540031	Hex Nut	M5	3
97	JWBS10OS-97	Door Lock Knob		2
98	TS-1503061	Socket Head Cap Screw	M6x25	2
99	JWBS10OS-99	Table Insert		1
100	JWBS10OS-100	Table		1
101	JWBS10OS-101	Fence Guide Rail		1
102	JWBS10OS-102	Wing Screw		4
103	TS-1482071	Hex Cap Screw	M6x35	1
104	JWBS10OS-104	Carriage Bolt	M6x30	1
105	JWBS10OS-105	Slide Block		1
106	JWBS10OS-106	Trunion		1

Index No.	Part No.	Description	Size	Qty
107	JWBS10OS-107	External Tooth Lock Washer	M6	4
108	JWBS10OS-108	Support Bracket		1
109	JWBS10OS-109	Knob		1
110	JWBS10OS-110	Carriage Bolt	M6x16	4
111	TS-1505011	Socket Head Cap Screw	M10x16	2
112	TS-1551071	Lock Washer	M10	2
113	TS-1550071	Flat Washer	M10	4
114	JWBS10OS-114	Extension Wing		1
115	JWBS10OS-115	Extension Rod		2
116	JWBS10OS-116	Extension Bracket		2
117	TS-1533032	Pan Head Machine Screw	M5x10	4
118	JWBS10OS-118	Lock Knob		1
119	JWBS10OS-119	Rubber Foot		4
120	JWBS10OS-120	Stand Leg		4
121	JWBS10OS-121	Short Support Plate		2
122	JWBS10OS-122	Long Support Plate		2
123	JWBS10OS-123	Carriage Bolt	M8x16	16
124	TS-1540061	Hex Nut	M8	16
125	JWBS10OS-125	Miter Gauge		1
126	JWBS10OS-126	Complete Fence Assembly		1

Assembly Drawing

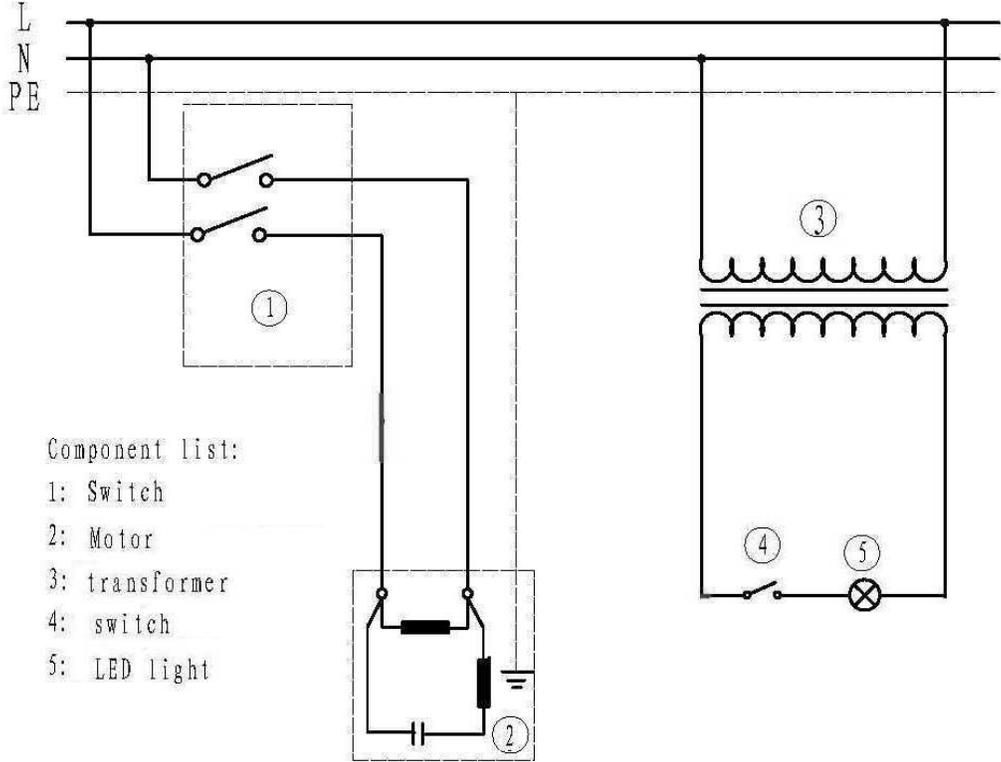


Electrical Connections

1 3/4 HP, 1Ph, 115V

Band Saw Model No.: JWBS-100s

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