

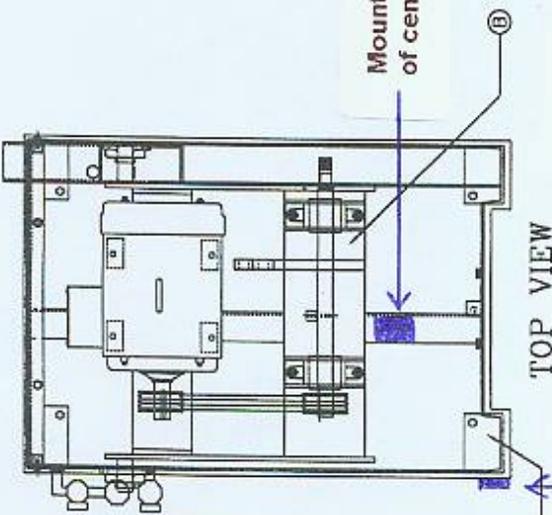
MODEL 612 & 1012 DOUBLE PALM BUTTON ANTI TIE DOWN FIELD LEVEL RETROFIT

1. Remove electrical power & compressed air from saw. Observe lockout procedures before proceeding.
2. Mount the 410-1032 palm button block on the side of the saw base opposite the blade side. The block is mounted flush with the front of the saw base and 1" down from the table top. The block is attached with two 1/4-20 x 1 SHCS. You will have to drill 13/64" and tap 1/4-20 thread. The weld in that area may have to be ground down to make the block sit flat. You also need to drill a 1/2" hole for the 5/32" air lines to feed through. This hole is located 2" from the front of the saw base and 1" down from the table top. The palm button can then be attached to the palm button block.
3. Mount the anti tie down module on top of the center angle inside the 612-1025 front access door. Position the module between the rubber bumper and the one shot valve. The module mounts with 10-24 screws so you will have to drill 5/32" and tap 10-24.
4. Remove the black 5/32 line from the original palm button and pull it thru the steel tube into the base frame interior. Install a tee onto this existing line, cut a 1 foot piece of black tubing and connect it from the new tee back thru the steel tube and connect the other end to the original palm button.
5. Run another piece of black tubing from the remaining part on the new tee to the top port of the palm button.
6. Remove the existing orange line from the original palm button and pull it thru the steel tube and connect it to the output port of the module.
7. Run an orange line from the middle port of the palm buttons to the inputs on the module.
8. When you rotate the lines keep them away from the moving swing mechanism and secure them.

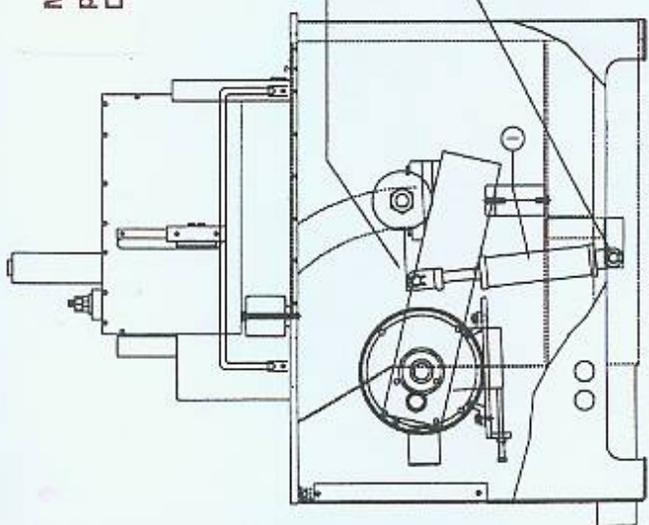
Northfield Foundry & Machine Company

4/2006

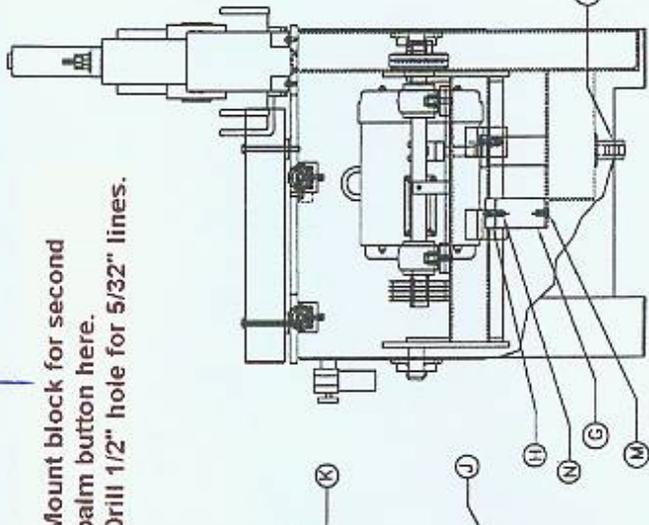
ITEM	PART NO.	DRAWING DESCRIPTION	QTY
N		FTMS 1/2-13UNC X 1" LONG	1
M		HHCS 1/2-13UNC X 1" LONG (612 ONLY)	1
L	612-1301	TABLE TOP	1
K		1" PIN AND CLIPS	1
J		1" PIN AND CLIPS	1
I	612-1019	SWING CYLINDER	4
H	410-1007	RUBBER BUMPER	1
G	612-1107	BUMPER PEDESTAL (612 ONLY)	2
F	CONBALL FACTORY	LOWER SWING CYLINDER MOUNT	1
E	CONBALL FACTORY	MOUNTING PLATES	1
D	CONBALL FACTORY	DUST CHUTE ASSEMBLY	1
C	SEE PRINT	CLAMP ASSEMBLY	1
B	SEE PRINT	SWING ASSEMBLY	1
A	612-1202	FRAME WELDMENT RH	1



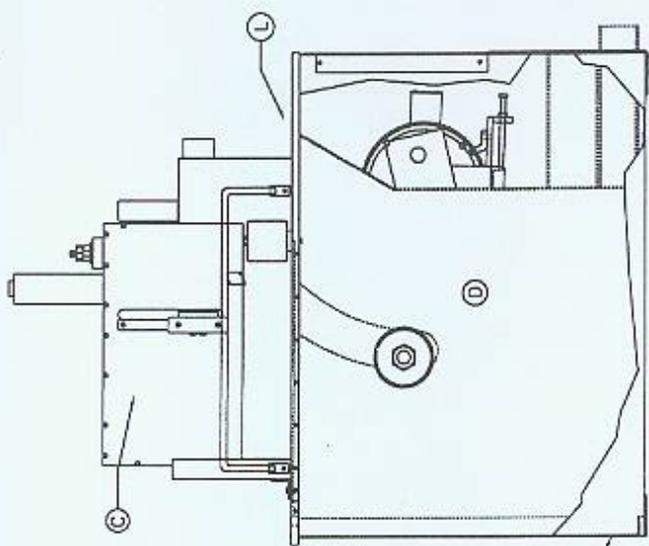
Mount anti tie down module on top of center angle in front of swing bumper



LEFT SIDE VIEW



FRONT VIEW



RIGHT SIDE VIEW

INTERNAL FEATURES 612/1012 RH SAWS

NORTHFIELD FOUNDRY MACHINE, CO.	REV. 0	DATE	BY	CHKD	DATE
					11/18/96
					612-RXX2

612 / 1012 DOUBLE PALM DIAGRAMS

