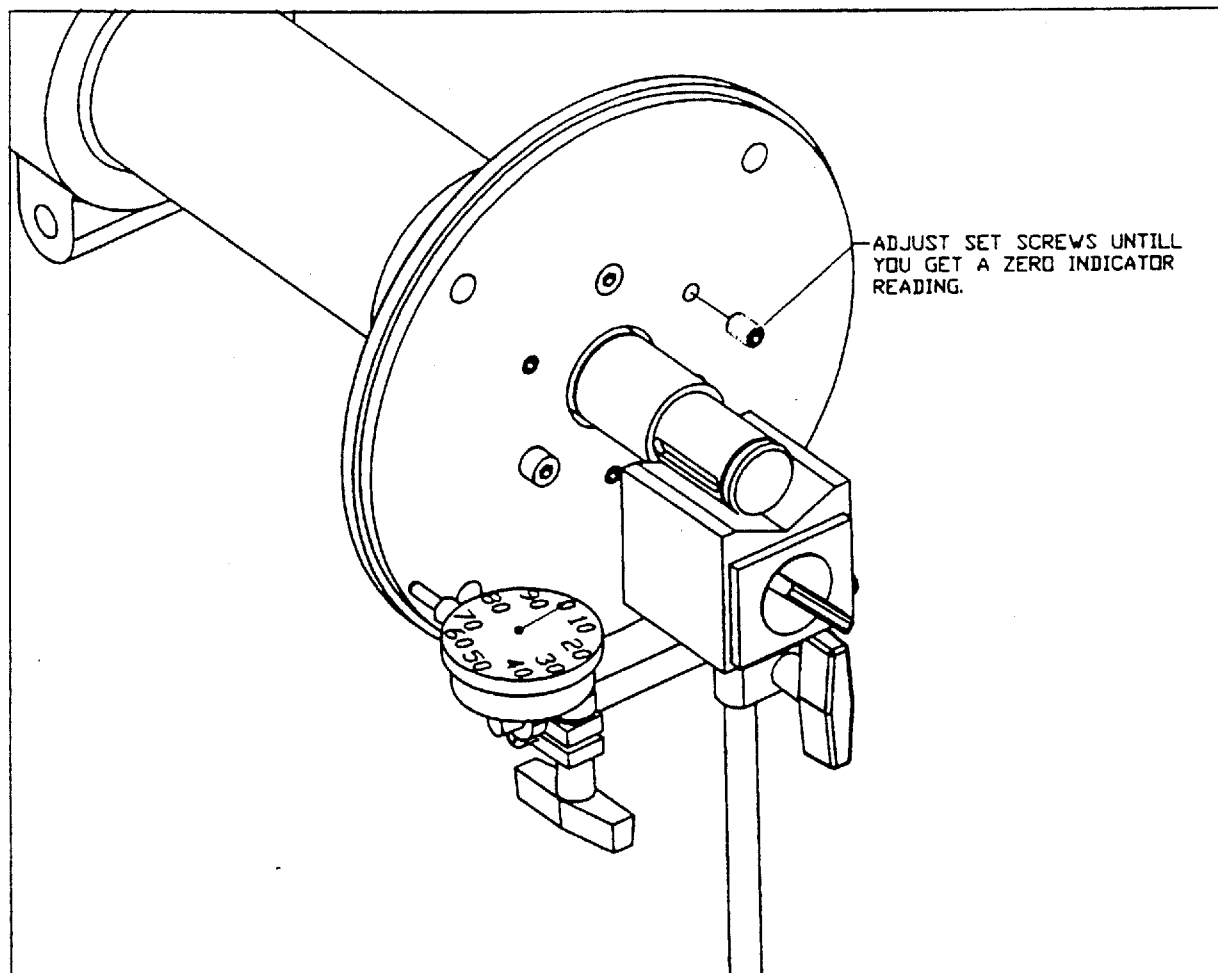


BANDSAW UPPER WHEEL BRAKE PLATE ALIGNMENT

If your upper wheel automatic electric brake is experiencing excessive brake chatter after you have replaced the rotating friction discs and or reset the magnet gap, try the following procedure. Your problem may be that the cast iron adapter plate that the brake assembly bolts to, is not perpendicular to the upper wheel shaft.

1. Shut off electrical power to the bandsaw, observing lockout/tagout procedures, release the blade tension and remove the blade from the wheels.
2. With the blade removed, grasp the upper wheel rim at the 9 & 3 o'clock positions, and check for any mechanical looseness caused by bad bearings, oversized bearing bores in the upper quill, undersized bearing journals on the upper wheel shaft or loose or missing bearing locks or covers. If any of these conditions are present, they will have to be repaired before proceeding.
3. With the brake and splined hub removed from the rear of the upper quill assembly, rig a dial indicator per the drawing off of the rear of the upper quill shaft. Position the indicator so that its plunger can sweep the outer perimeter of the cast iron adapter plate to see if you have a zero reading through a 360 degree sweep.



4. If the dial indicator reading shows that the brake adapter plate is not perpendicular to the upper quill shaft, the plate will have to be squared.

5. Squaring the adapter plate can be done two ways:

A. The adapter plate can be removed and set screws added in between the three existing mounting holes. Drill $17/64$ " and tap 5/16-18 on the bolt circle formed by the three mounting holes, with the set screws positioned equally between the mounting holes. The set screws can then be adjusted to square the adapter plate to get a zero indicator reading.

B. Metal shims can be added in between the adapter plate and the rear end of the upper quill castings. Add shims until you get a zero indicator reading.

6. With the adapter plate adjusted so that it provides a square surface for brake mounting, reassemble the brake to the upper quill, replace the blade and test.

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