

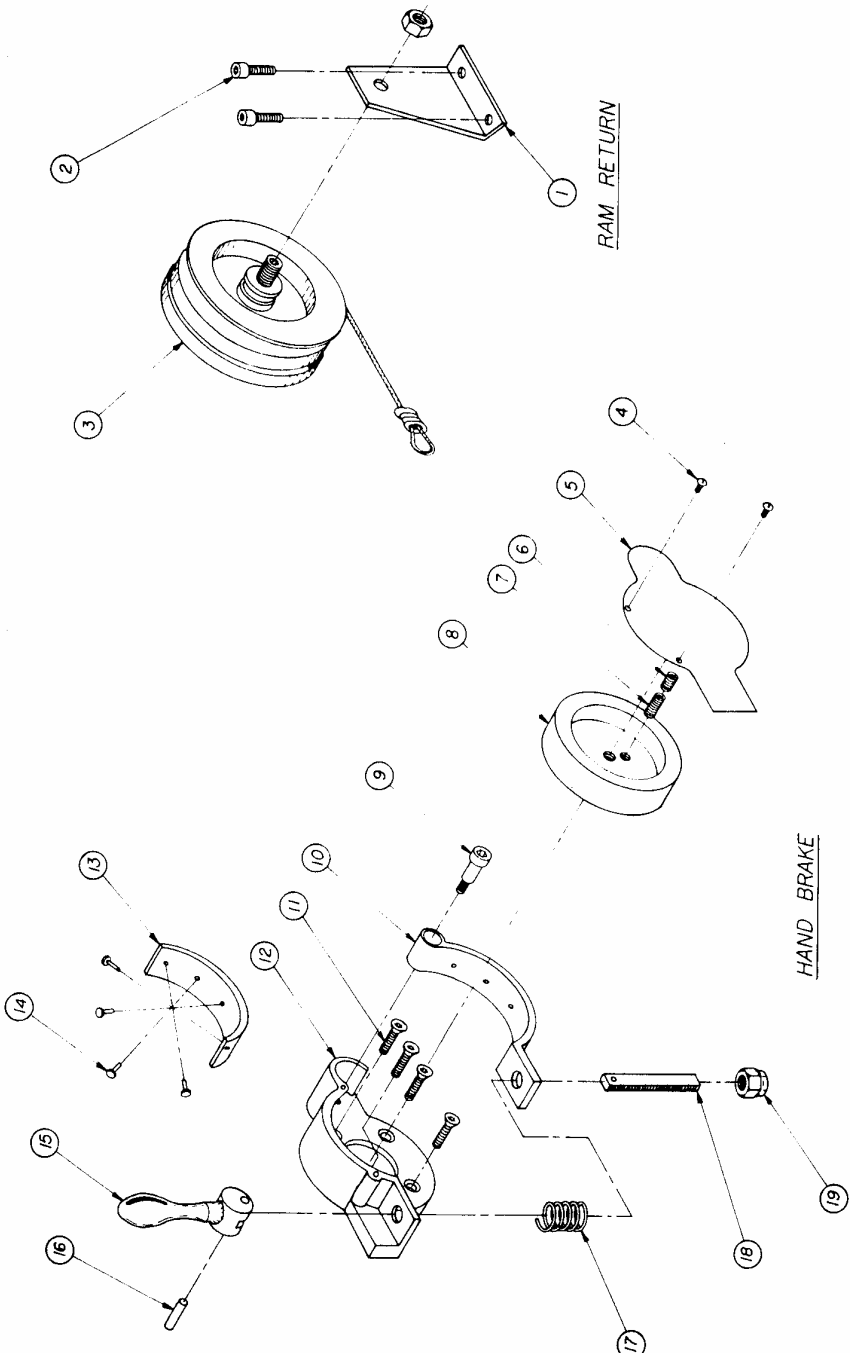
**UNI-POINT RADIAL SAW
FIELD LEVEL HAND BRAKE INSTALLATION**

1. Remove arbor motor from motor plate on machine.
2. Disassemble motor. If a large enough swing lathe is available, only the fan cover, fan and bolts need be removed.
3. Run the arbor motor shaft between centers and machine the fan end of the shaft to a diameter of .875 and to a depth of .557 from the edge.
4. Press the brake drum onto the motor shaft.
5. Line up in drill press on the tight or loose saw collar so that the arbor is parallel to the drill spindle.
6. Using a letter 17/64 drill, drill a holes on the scribed circle inside the brake drum approximately 1-1/2" deep. If the drum spins on the shaft, use a small machinist's vise to lamp the hub of the drum to the shaft.
7. Blow the chips out, and hand tap a 5/16-18 thread to the bottom of the hole. Then remove th drum from the shaft. The 3/8-16 hole in the center can be used as a puller for this. Put a 60° point on the end of a bolt to use this.
8. Take the fan cover and position the brake shoe and handle assembly so that the handle will sit in an upright position when installed on the machine. Clamp these two together and drill four 13/64 holes through the the countersunk holes in the shoe assembly. When this is complete, tap these four holes with a 1/4-20 thread, and install the flat head screws.
9. Reassemble the motor on a flat plate with the machined feet sitting squarely on it, being sure that the end of the arbor shaft is centered in the fan cover.
10. Push the brake drum back on the end of the motor shaft until it bottoms, and turn a 5/16-18 set screw into the hole you drilled until it bottoms.
11. Install the brake drum cover.
12. Rebolt the motor to the motor plate and line the motor to the fence as per instructions in the X36-AF instruction manual.

Encl. Motor shaft drawing std.
Brake drum drawing 800-N
Mtg. brake drum drawing

Nov 1976 – NORTHFIELD FOUNDRY & MACHINE CO

REV	DATE	BY	CHKD



RAM RETURN

HAND BRAKE

QTY	PART NO.	DESCRIPTION	UNIT
1	NUT 2-20		
1	18N-2085	ADJUSTMENT BOLT	
1	17NF-31	SPRING	
1	16N-2090	HANDLE PIN	
1	15N-2123	BRAKE HANDLE	
4	14	POP RIVET NO. 4	
1	13	BRAKE LINING	
1	12795-N	BRAKE PLATE	
4	11	CAP SCREW 1/2-20 x 1/2	
1	10796-N	BRAKE SHOE	
1	9	SHOULDER BOLT 1/2-16 x 1/2	
1	81800-N	BRAKE DRUM	
1	7	SET SCREW 1/2-18 x 1/2	
1	6	SET SCREW 3/8-18 x 1/2	
1	5N-2062	HAND BRAKE COVER	
1	4	MACH SCREW 10-24 x 3/8	
2	3	RAM RETURN M1-1849	
2	2	CAP SCREW 1/2-20 x 1 1/2	
1	1D-1684	SUPPORT BRACKET	
1	1	DESCRIPTION	

UNIFORM PARTS		UNIFORM PARTS	
SYMBOL	DESCRIPTION	SYMBOL	DESCRIPTION
1	UNI-POINT	2	UNIFORM PART
2	RAM RETURN & BRAKE	3	UNIFORM PART
3	UNIFORM PART	4	UNIFORM PART
4	UNIFORM PART	5	UNIFORM PART
5	UNIFORM PART	6	UNIFORM PART
6	UNIFORM PART	7	UNIFORM PART
7	UNIFORM PART	8	UNIFORM PART
8	UNIFORM PART	9	UNIFORM PART
9	UNIFORM PART	10	UNIFORM PART
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17	UNIFORM PART	18	UNIFORM PART
18	UNIFORM PART	19	UNIFORM PART