

FIELD LEVEL REMOVAL OF AIR OVER OIL FEED FOR MODEL #612 AND #1012 UPCUT SAWS

1. Shut off air and electrical supplies to saw.
2. The components of the regulator assembly on the side of the saw need to be rearranged. For an air over oil saw the arrangement is as follows - starting at the rear of the saw.

Air Over Oil = Main regulator, square manifold block, top cylinder regulator, oiler, elbow.

Reassemble the components to the following configurations.

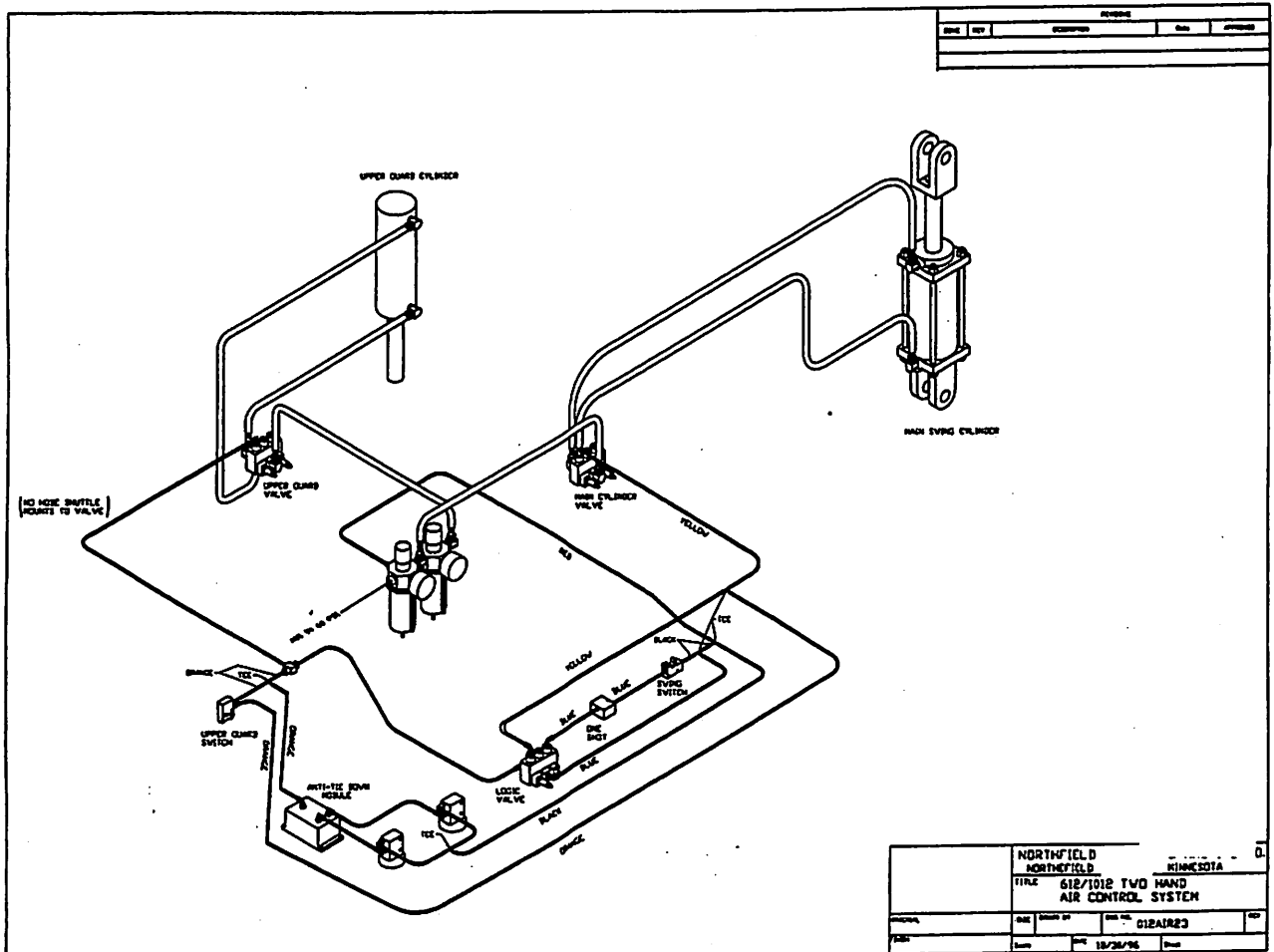
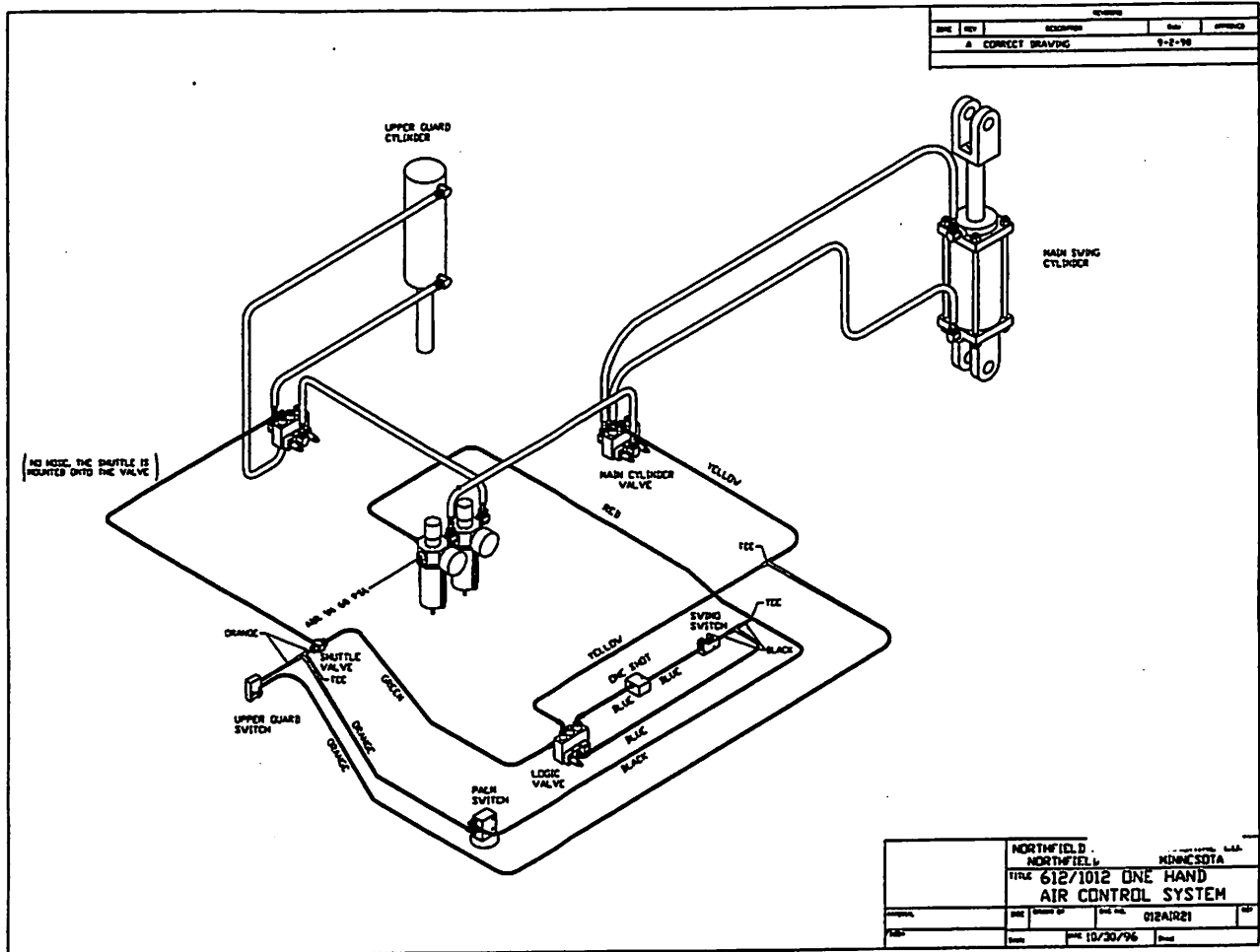
Air Only = Main regulator, oiler, square manifold block, top cylinder regulator, elbow.

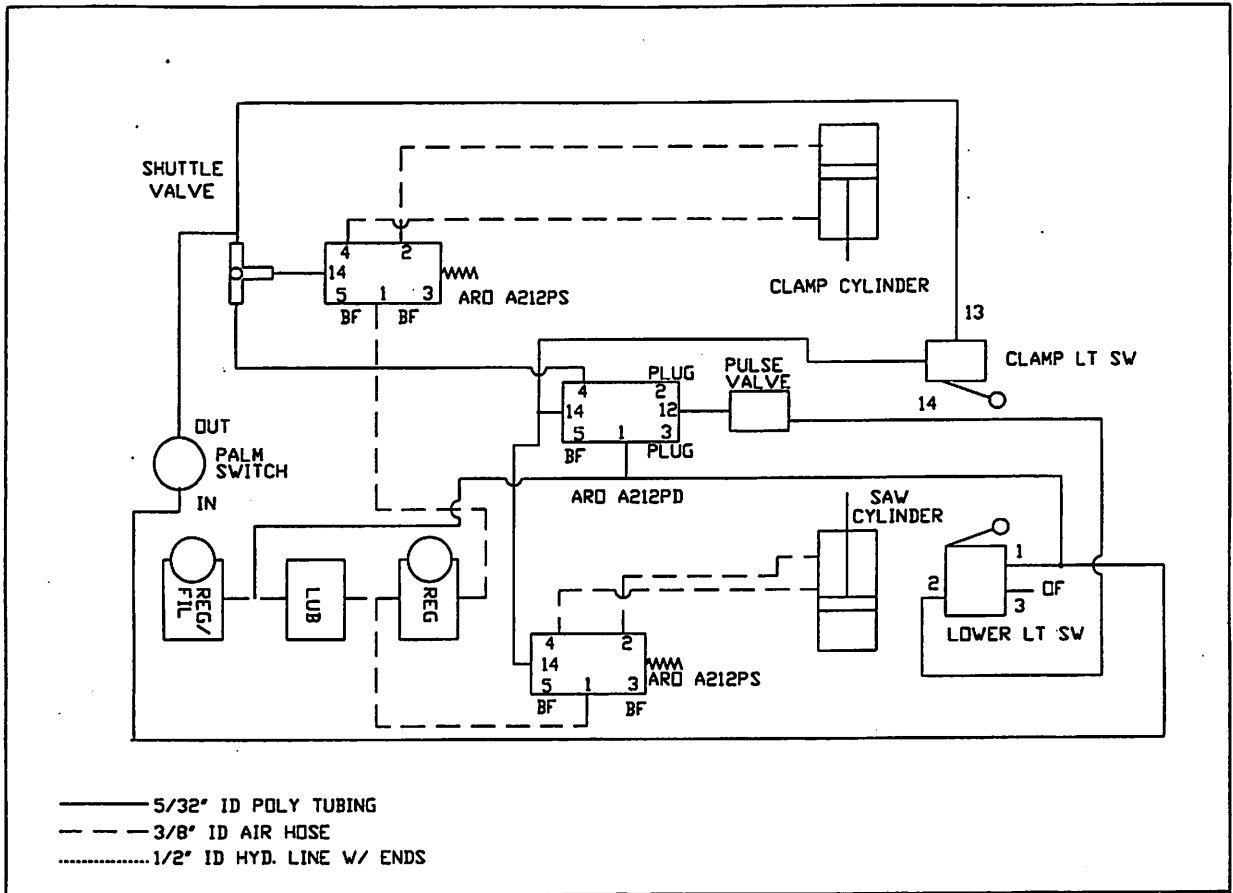
You may have to drill a 1" hole for the air line that goes to the repositioned square manifold block.

3. Cut the 3/8 line from the top of the oil reservoir. Remove the external knob from the flow control valve, remove the clamp or clamps that hold the flow control to the inner face of the front panel. Cut any ty-wraps that may attach the 1/2" hydraulic hoses to the machine frame or other hoses.
4. Remove 3/8-16 full nut from bottom of oil reservoir bracket, remove 1/2" hydraulic hose from steel street ell on bottom port of swing cylinder. A piece of duct tape over the hose end will minimize oil leakage. Lift the oil reservoir off of the reservoir bracket and pull the oil reservoir hoses and flow control out the front panel access hole. Remove reservoir bracket from front panel.
5. Remove the 1/2" steel street ell from the bottom port of the swing cylinder. Replace with brass reducer, street ell and barb fitting. Use Teflon tape on the threads, and tighten so barb fitting points to rear of saw.

6. Reroute the 3/8" airline that was cut from the top of the oil reservoir to the newly installed barb fitting on the lower port of the swing cylinder. Cut off excess line and push onto barb fitting.
7. Remove the two sintered brass mufflers on the ARO 4-way valve in the rear of the saw and replace them with the new adjustable baffles. Open the baffles approximately 1-1/2 turns from the closed position and lock the jam nuts. Once the saw is in operation, you can fine tune the baffles for your desired cut and retract speeds.
8. This should complete the retrofit. Power the air back up and test the cycle activation, check for leaks and replace all access panels.

Northfield Machinery Builders, Inc.
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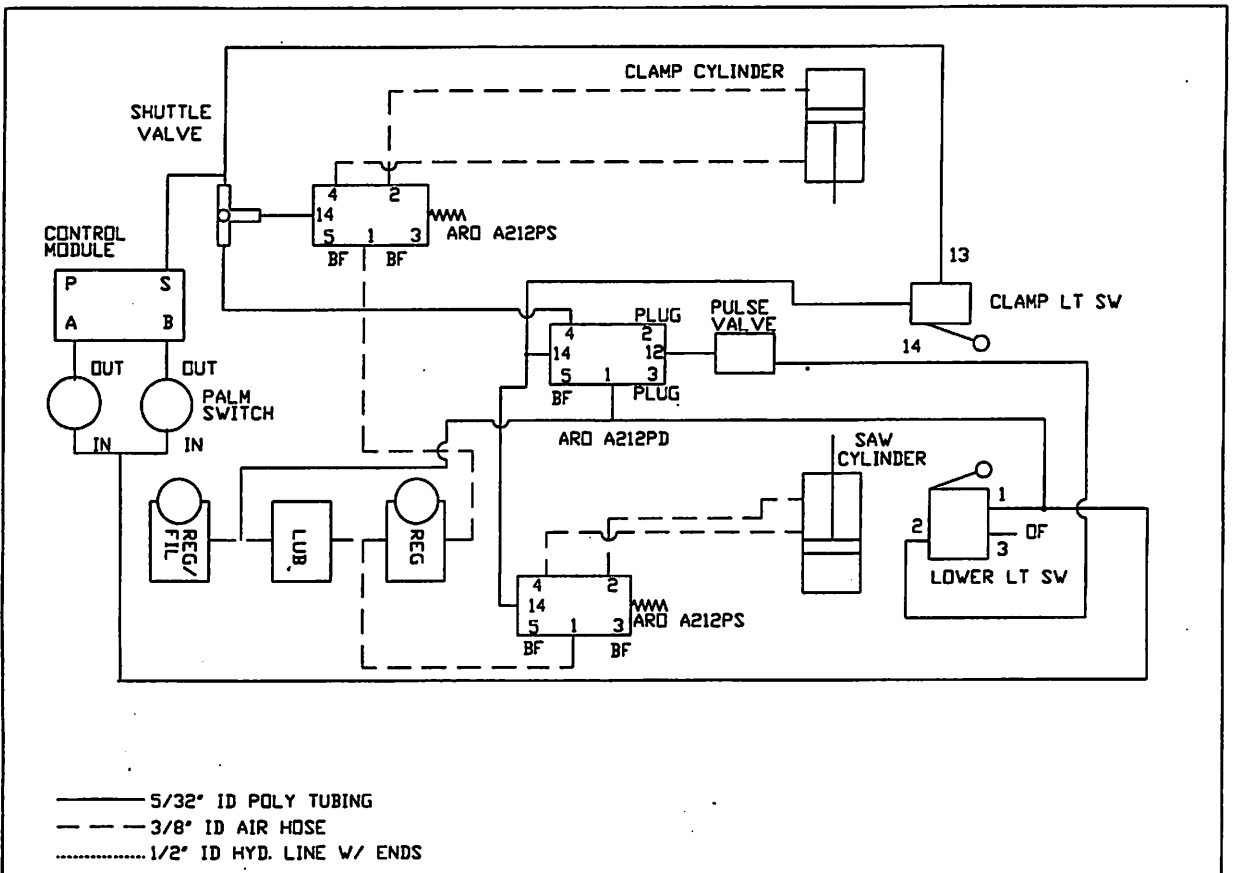
NORTHFIELD

REV	DATE	BY	CHK

 612/1012 AIR CONTROLS
ONE PALM SWITCH

REV	DATE	BY	CHK

 012AIR1



NORTHFIELD

REV	DATE	BY	CHK

 612/1012 AIR CONTROLS
TWO PALM SWITCHES

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 012AIR3