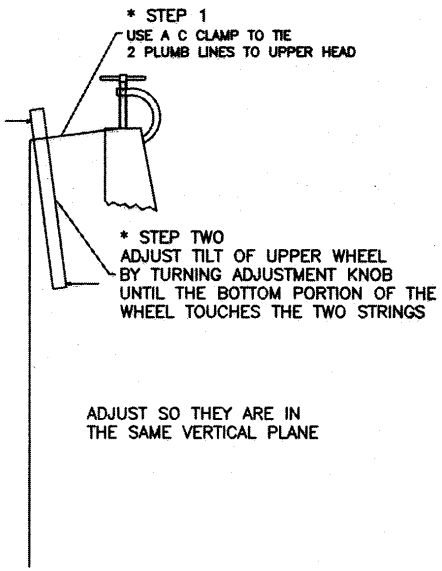
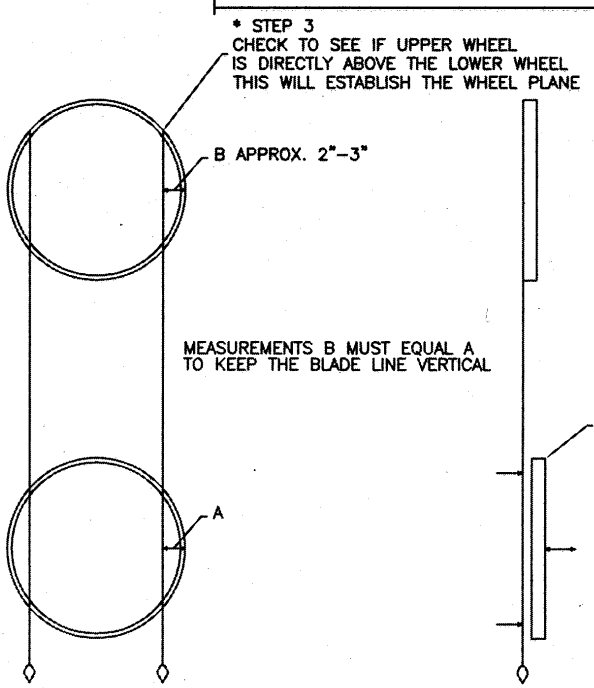
Field Level Retargeting Lower Wheel/Quill Assembly

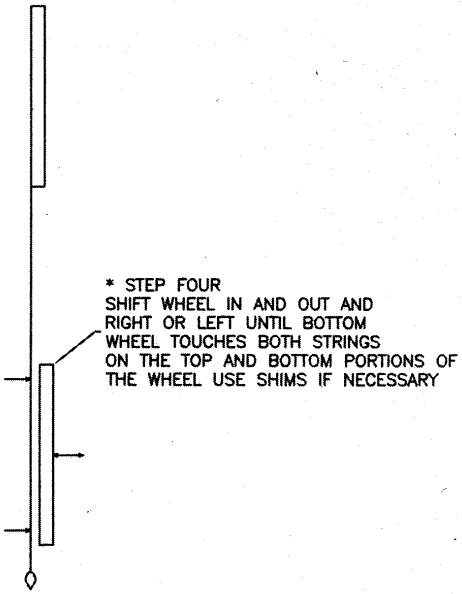
1. Remove upper & lower guards, table, & upper quill slide assembly
2. Using a small spirit level, shim the base under the four feet with steel or paper shims so that the ways in the upper quill/slide head are sitting vertically in **BOTH** planes.
3. Reassemble the upper quill/slide assembly and mount the upper wheel. Adjust the blade tracking hand knob so that the top of the upper wheel overhangs the bottom on the operator side of the saw.
4. Attach a small C. Clamp to the top of the frame slide head. Attach two Dacron fish line plumb bobs to the C Clamp and position them so they hang over the top of the upper wheel. Position the lines so that they sit approx. 2"-3" in from the 3 o'clock & 9 o'clock positions. Make sure the plumb bob weights hang below where the lower wheel will be positioned.
5. Slowly straighten up the upper wheel to the vertical position until the plumb bob lines just kiss the bottom portion of the wheel rim face. When this is done, you have established the wheel plane the lower wheel must be targeted too.
6. Slide the lower wheel/quill assembly toward the plumb lines and shim to bring the wheel into plane with them.
7. Using a 6" ruler, measure from the outer edge of the neoprene tire of the upper wheel at the 3 o'clock position, to the right hand plumb line. Note – this dimension. Shift the lower wheel quill assembly left or right until you have the same dimension on the lower wheel. Being careful not to disturb your wheel plane alignment.
8. At this point mark the holes in the lower quill assembly onto the frame. Remove the lower quill/wheel assembly and drill and tap your mounting holes onto the frame.
9. Reassemble the lower quill/wheel assembly onto the frame and add steel shims to realign the lower wheel to the plumb lines. **Note:** Shifting the lower wheel in and out on the shaft can be used to fine tune the lower wheel alignment.
10. Reassemble machine.
11. Other parameters to be observed:
    a. The upper guide square sliding bar should be parallel with the blade line in both planes.
    b. The top of the table rocker where the table bolts on, should be perpendicular to the blade line. – this can be checked with a carpenters square –
    c. The center line of the table rocker where it rotates should be on the blade line. This is normally the center of the middle table bolt hole.
    d. The face of the table rocker should also be parallel with the wheel plane. This can be checked by holding a straight edge up to the backside of the plumb lines and measuring to the machined faces of the rocker facing the operator side of the machine.

    Note: As you are dealing with a used machine, you may have to make some compromises due to wear in the rocker trunnion and guide bar ways.

REVISIONS				
ZONE	REV	DESCRIPTION	Date	APPROVED







TOLERANCES UNLESS OTHERWISE SPECIFIED +/–.XX .03 +/–.XXX.005 FRACTION +/– 1/32 ANGULAR +/– 1/2 DEG.	NORTHFIELD FOUNDRY & MACHINE CO. NORTHFIELD MINNESOTA		
	TITLE BAND SAW WHEEL ALIGNMENT		
MATERIAL	SIZE A	DRAWN BY N.L.	DWG NO. BSAW–ALIGN / REV A
FINISH AS SPEC.	Scale 1:1	DATE 3–12–04	Sheet 1 OF 1