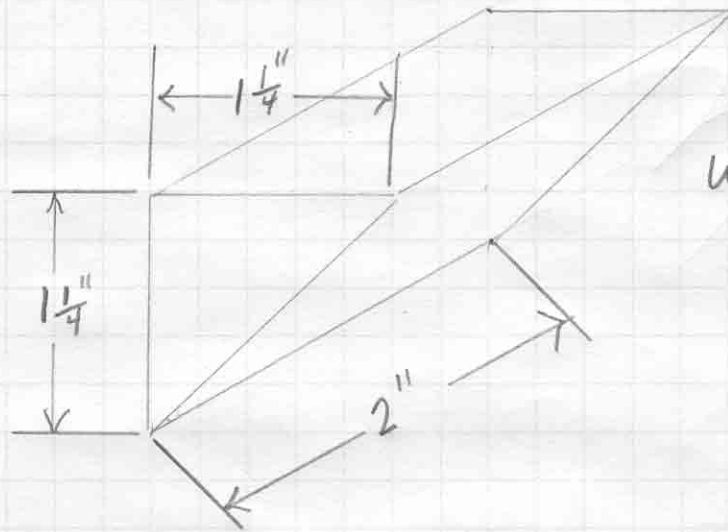


REPOURING BABBITT THROATS IN OLDER BANDSAW TABLES

Older Northfield Bandsaws, approximately pre 1955, did not have a replacable aluminum table insert. The throat plate was molten babbitt poured into the table opening. The following instructions will allow you to refurbish your older saw throats.

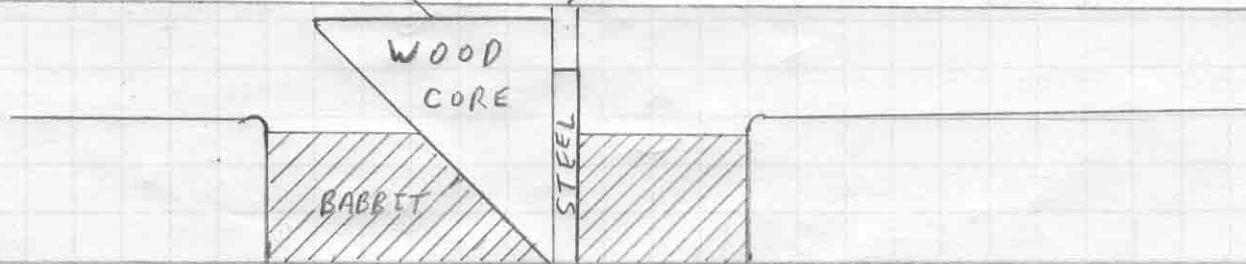
1. Remove cast iron table from machine by unbolting from rocker.
2. Remove old babbitt from center hole - either by hammer and chisel or oxy-acetylene torch to melt it out.
3. Lay cast iron table face down on a flat steel plate.
4. Insert a piece of 1/8" x 1" x 4" cold finished steel into the blade slot so that it projects 2" into the throat hole.
5. Cut a piece of wood 1-1/4" square x 2" long. Cut a 45 degree angle on the 1-1/4" corner to corner along the 2" length. The purpose of this wood core is to provide clearance for the blade when the table is tilted.
6. With the table slot facing you place the wood core point down on the left hand side of the 1/8" steel bar stuck in the blade slot. Stabilize this piece with a bar of steel to keep it standing upright and also to provide enough down pressure so that the molten babbitt will not float it up.
7. Melt your babbitt, skim it off, and pour it in the center hole until it is flush with the casting web.
8. Let the babbitt solidify and cool. Remove the wood core and steel slot bar.
9. Use a file to remove any flash in slot area and reinstall table on bandsaw.



WOOD CORE
DETAIL

WOOD CORE STABILIZED
WITH BAR OF STEEL
FROM TABLE EDGE

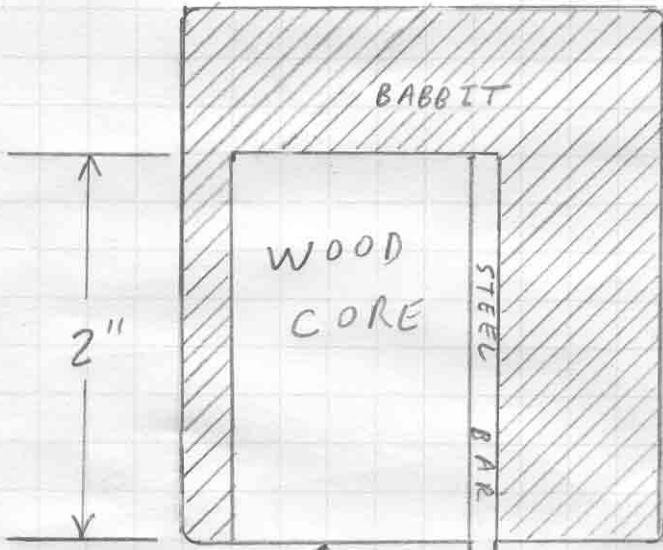
BLADE SLOT IN TABLE



↑
TABLE
TOP

STEEL PLATE

LOOKING AT BOTTOM OF TABLE



CORE FLUSH TO
FRONT OF THROAT HOLE

BLADE SLOT

FRONT OF TABLE