



OPERATOR'S MANUAL

3SP-14 THREE SPEED KIT

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3SP-14 Installation Instructions (WBS-14CS only)

Contents of the Shipping Container

- 1 Middle pulley assembly
- 1 3-Step motor pulley
- 1 VB-A22 V-belt
- 1 VB-A38 V-belt
- 3 M8x25 hex cap bolt
- 3 5/16" flat washer
- 3 5/16" lock washer

Tools Required for Installation

Metric hex wrench set
Adjustable wrench
#1 cross point screwdriver
Combination wrench set (1/4"-1")

Assembly



WARNING

**Disconnect the bandsaw from the power source
before making any repair or adjustment!
Failure to comply may cause serious injury!**

1. **Disconnect the bandsaw from the power source.**
2. Remove the pulley cover from the stand top and open the stand door. See figure 1.
3. Remove the V-belt. See figure 2.
4. Loosen the set screw on the bandsaw's large pulley and push pulley toward the saw body. Do not tighten at this time. See figure 3.
5. Place the small V-belt (VB-A22) around the smallest diameter slot on the middle pulley assembly and around the large pulley on the bandsaw.
6. Bolt the middle pulley assembly to the saw body, as shown, using two M8 x 25 hex cap bolts, two 5/16" flat washers, and two 5/16" lock washers. Do not tighten at this time. See figure 4.

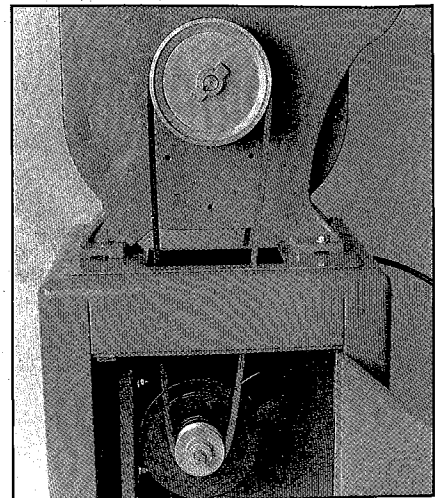


Fig. 1

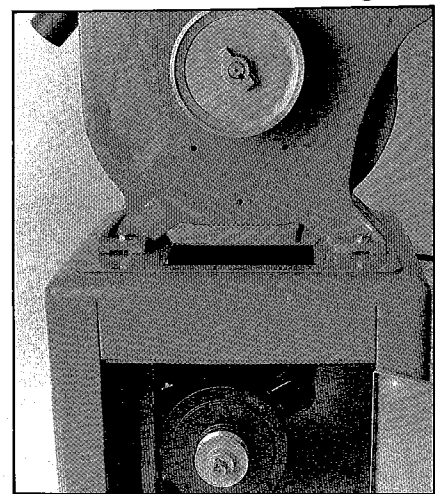


Fig. 2

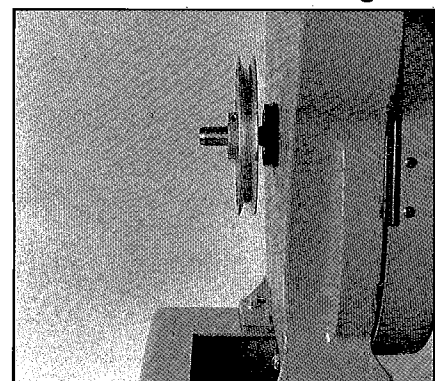


Fig. 3

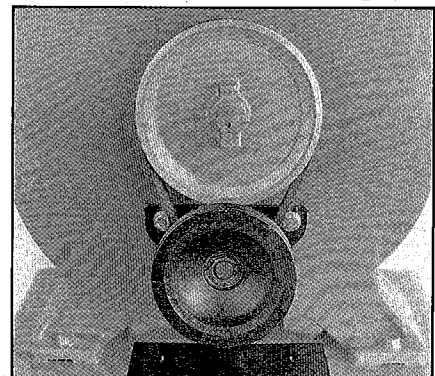


Fig. 4

7. Line up the large pulley on the bandsaw with the smallest diameter pulley on the middle pulley assembly by moving the large pulley, if necessary. Check to make sure the key engages the pulley before tightening the set screw.
8. Push down on middle pulley assembly to tension belt. Tighten the three hex bolts. Belt is properly tensioned when finger pressure on the belt half way between the large pulley and the middle pulley assembly causes approximately 1/4" deflection.
9. Loosen the set screw on the motor pulley and remove the pulley from the motor shaft.
10. Slide the three step motor pulley onto the motor shaft, as shown in Fig. 5. Be sure the key engages the motor shaft and the new step pulley. Tighten the motor pulley set screw.
11. Loosen the four motor mount bolts. Place the larger V-belt (VB-A38) around the motor pulley and the middle pulley assembly. See figures 6 and 7. See figure 8 (next page) for the desired speed selection.
12. Tension the larger V-belt by pushing down on the motor and tightening the motor mount nuts. Be sure motor is still level after tightening nuts. Belt is properly tensioned when finger pressure on the belt half way between the motor pulley and the middle pulley assembly causes approximately 1/2" deflection.
13. Open the top wheel cover and rotate the wheel by hand. Observe belt positioning to make sure it doesn't come into contact with the stand when belt is on the end most pulley setting. If belt rubs the stand, loosen the motor pulley set screw and move pulley toward the motor and tighten set screw. Operation will not be affected if the larger V-belt is not perfectly aligned.
14. Close top wheel cover, close the stand door, and replace the pulley cover. Connect to the power source.

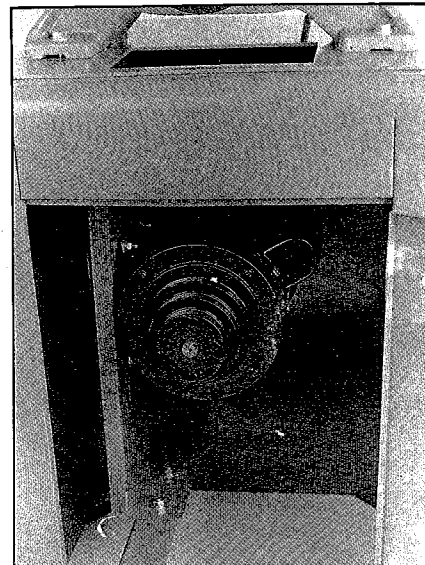


Fig. 5

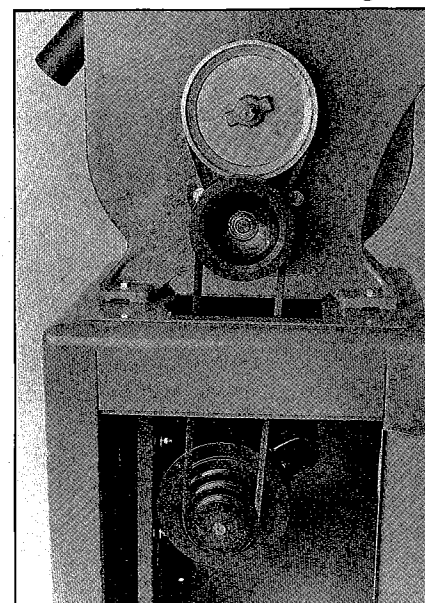


Fig. 6

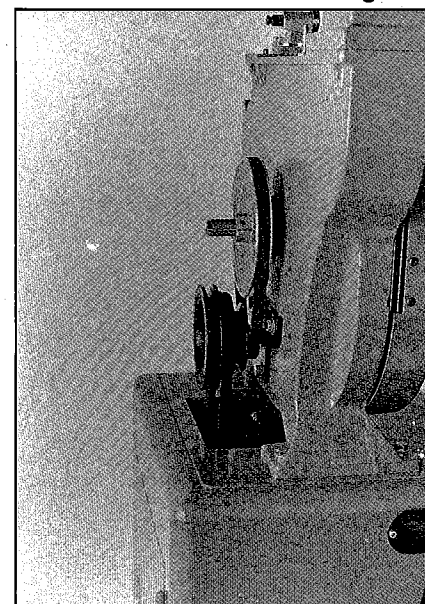


Fig. 7

Changing Speeds (reference Fig. 8)

1. **Disconnect the machine from the power source.**
2. Remove the belt guard and open the stand door.
3. Move the belt between the middle pulley and the motor pulley to the desired location. (Note: Belt D [Fig. 8] always remains in this position). Position A is 735 sfpm. Position B is 1470 sfpm. Position C is 2350 sfpm. All speed are approximate.
4. Always move the belt to the same location on both pulleys. Do not run the machine with the belt on mixed pulley locations.
5. It may be necessary to loosen the motor mount bolts to move the belt. However, if moving the belt from position A to B or C, try moving the belt off the middle pulley first, then the motor pulley. If moving the belt from position C to A or B, remove the belt from the motor pulley first and then the middle pulley.
6. Replace the belt guard, close the stand door, and connect to the power source.

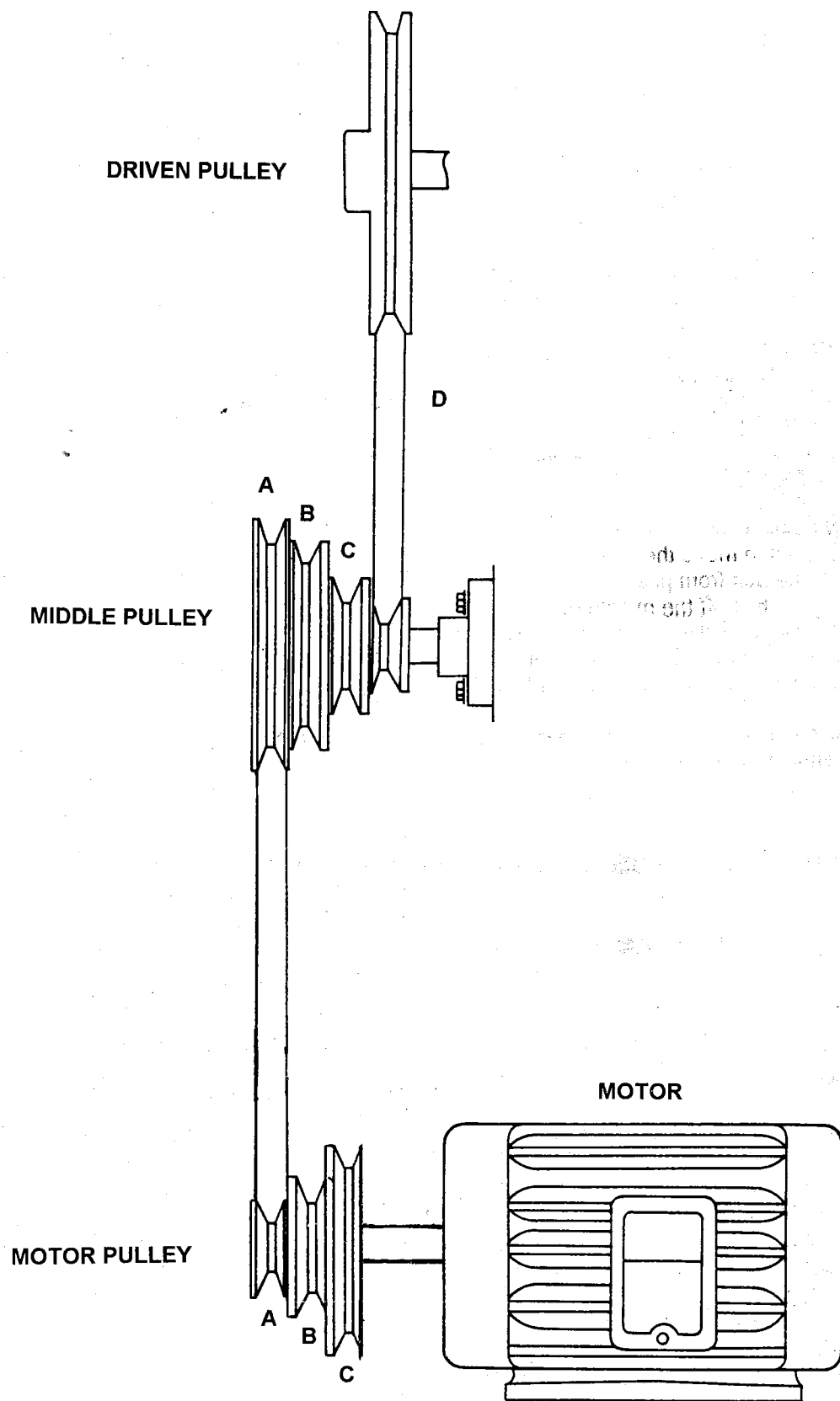
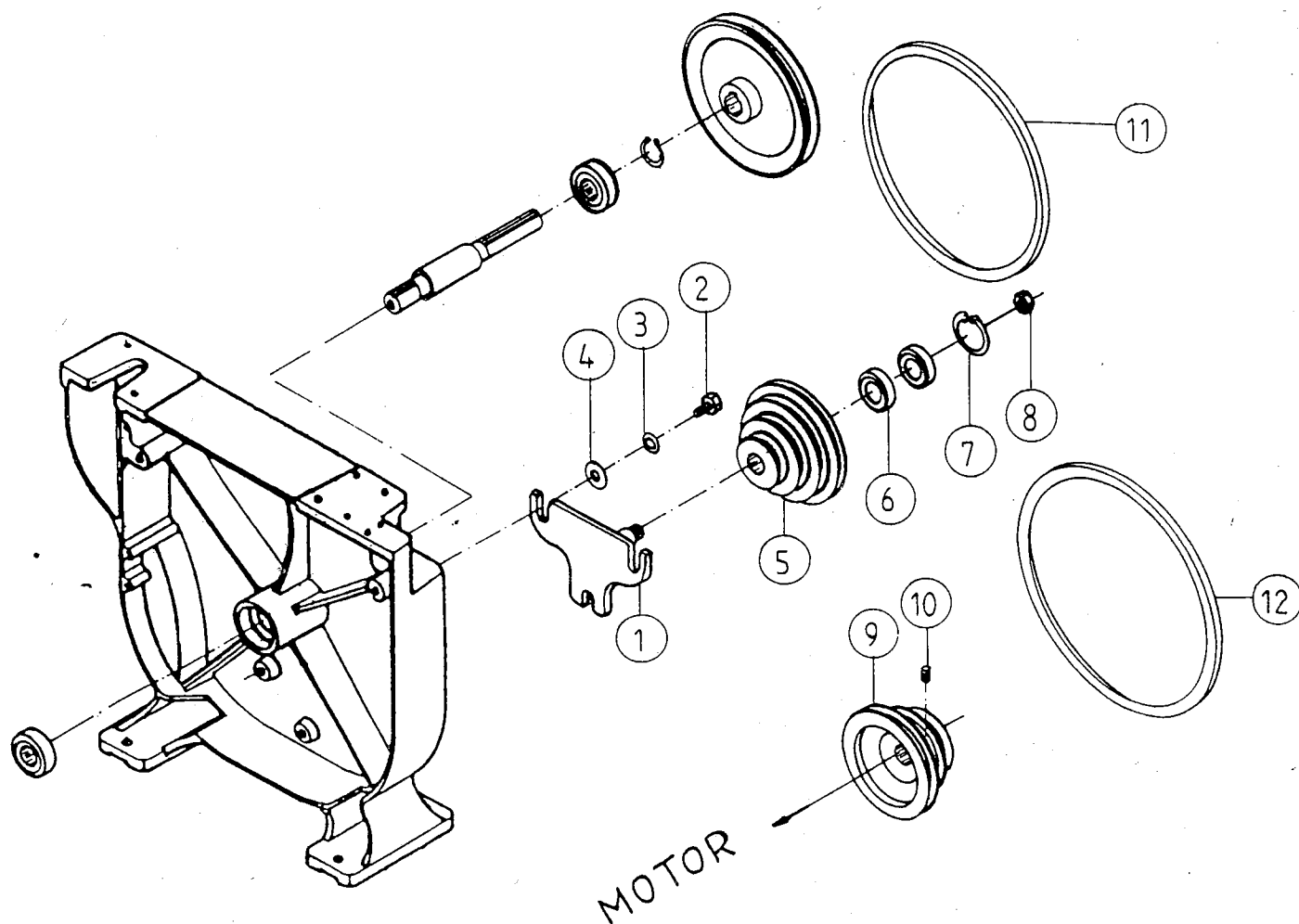


FIG. 8



PARTS LIST FOR THE 3SP-14 THREE SPEED CONVERSION KIT

PLEASE ORDER BY PART NUMBER ONLY

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY.
1	150201	PULLEY BRACKET		1
2	TS-1490041	HEX CAP BOLT	M8x25	3
3	TS-0561021	LOCK WASHER	5/16	3
4	TS-0680031	WASHER	5/16	3
5	153009	PULLEY		1
6	BB-6202ZZ	BALL BEARING		2
7	992522	RETAINING RING	R-35	1
8	TS-1540081	NUT	M12	1
9	153010	MOTOR PULLEY		1
10	TS-1523011	SET SCREW	M6x6	1
11	VB-A22	V-BELT		1
12	VB-A38	V-BELT		1