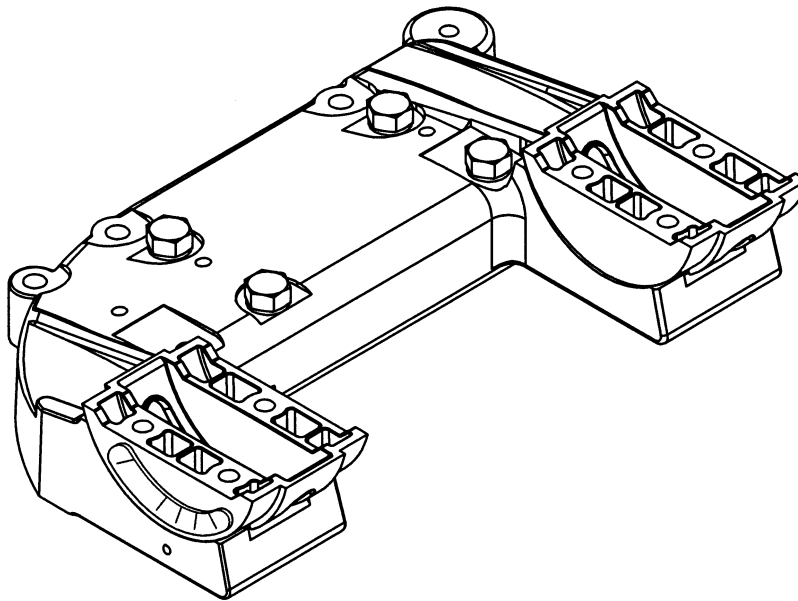




Assembly Instructions and Parts List

Band Saw Trunnion Retrofit

Model JWBS-TR



WMH TOOL GROUP

2420 Vantage Drive
Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com

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Unpacking

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Trunnion Retrofit Assembly has been installed on the band saw and is working properly.

Compare the contents of your container with the parts list on page 4 to make sure all parts are intact. Missing parts, if any, should be reported to your distributor.

Assembly

Tools required for assembly (not provided):

1/2" and 9/16" wrenches
cross point (Phillips) screwdriver
set of hex wrenches

The JWBS-TR Trunnion Bracket is designed to be retro-fitted to an 18" or 20" JET bandsaw. No drilling will be necessary. Some fasteners used on the old trunnion bracket will be re-used on the new trunnion bracket. Proceed as follows:

1. **Disconnect band saw from power source.**
2. Remove any accessories from the band saw table such as fence and rails, miter gauge, etc.
3. Remove the insert and the pin from the band saw table.
4. Remove the blade.
5. Unscrew and remove the two lock knobs below the trunnions, and remove the table from the band saw. NOTE: You may need an assistant to help remove the table.
6. Remove the old trunnions from the table by unscrewing the six hex cap screws.
7. Remove the four hex cap screws and lock washers holding the old trunnion bracket to the band saw, and remove the old trunnion bracket.

(NOTE: It is not necessary to remove the blade guides – these items are not shown in the Figures for purposes of clarity.)

8. Set the new trunnion bracket into place on the band saw, and insert four 5/16 x 1-1/2 hex cap screws with four 5/16 lock washers (Figure 1). Tighten the screws.

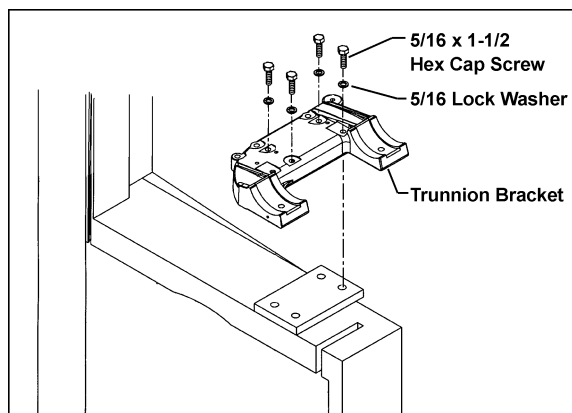


Figure 1

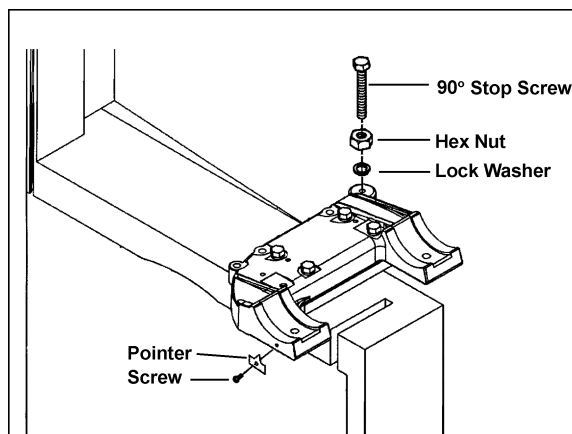


Figure 2

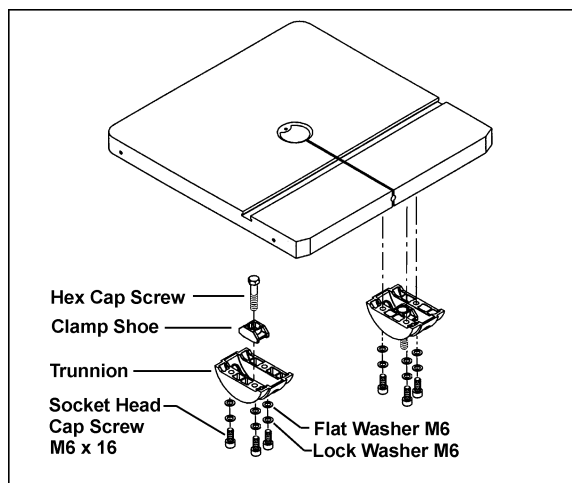


Figure 3

9. Remove the 90-degree stop screw with hex nut and lock washer (Figure 2) from the old trunnion bracket, and install them on the new trunnion bracket.
10. Remove the pointer and screw (Figure 2) from the old trunnion bracket and install them on the new trunnion bracket.
11. The trunnion clamp shoe and hex cap screw that were used previously, should be placed inside the new trunnions (Figure 3).
12. Mount the two trunnions to the bottom of the table, using three M6 x 16 socket head cap screws, M6 lock washers, and M6 flat washers, in each trunnion. See Figure 3.
13. Mount the table to the trunnion bracket, making sure the screws in the trunnions are inserted through the holes in the bracket (Figure 4).
14. Install the two lock knobs (Figure 4) onto the two trunnion screws, and tighten the lock knobs.
15. Install the blade.
16. Install the insert and pin on the table.
17. Place a square on the table and against the back edge of the blade (Figure 5). If the table is not 90 degrees to the back edge of the blade, use one of the set screws (Figure 6) to adjust the level of the trunnion bracket. Loosen the two hex cap screws nearest the set screw that needs adjusting, and turn the set screw with a hex wrench as needed.
18. When the table is square with the back edge of the blade, tighten the hex cap screws in the trunnion bracket.
19. Adjust the 90-degree stop screw as needed (see your band saw manual for instructions). Install any accessories on the table such as fence and rails, miter gauge, etc.

NOTE: Before using the band saw with the new trunnion bracket, you should be thoroughly familiar with the operating and safety instructions found in your band saw manual.

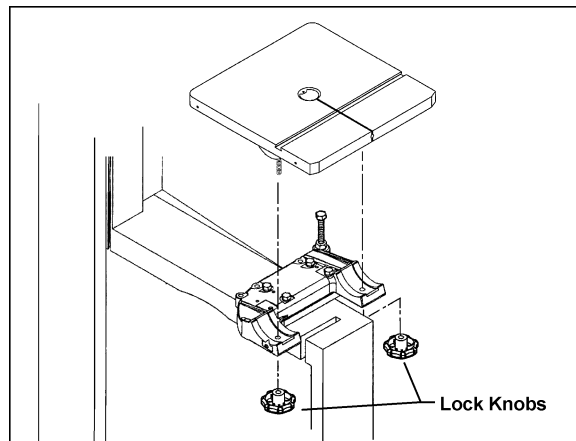


Figure 4

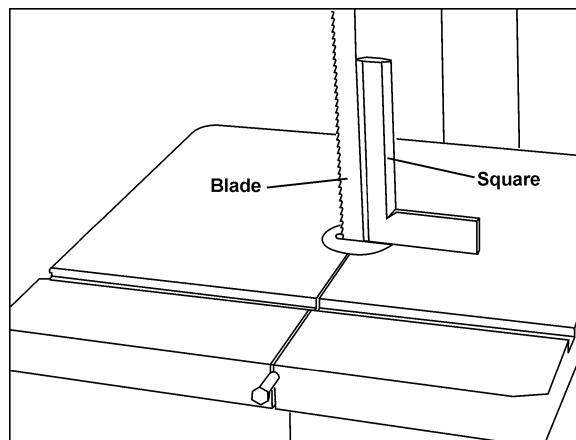


Figure 5

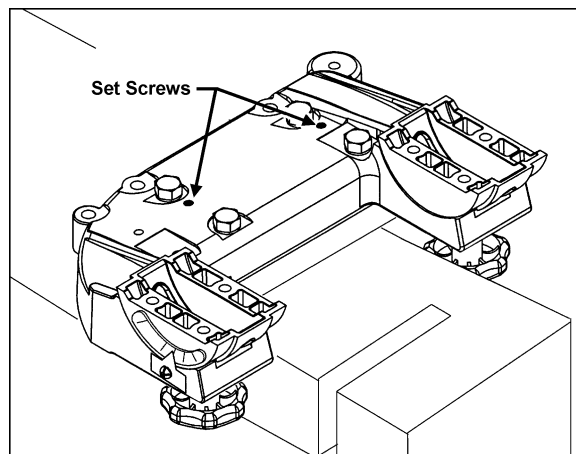


Figure 6

Replacement parts are listed on page 4. To order parts or reach our service department, call 1-800-274-6848 between 7:00 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the model number and serial number of your machine available when you call will allow us to serve you quickly and accurately.

Parts List: JWBS-TR Retrofit 710750TR

Index No.	Part No.	Description	Size	Qty
1	JWBS18X-408	Trunnion Support Bracket		1
2	TS-0051071	Hex Cap Screw	5/16 x 1-1/2	4
3	TS-0720081	Lock Washer	5/16	4
4	TS-0270061	Socket Set Screw	5/16 x 5/8	2
5	JWBS18X-416	Trunnion		2
6	TS-1503041	Socket Head Cap Screw	M6 x 16	6
7	JWBS18-420	Scale		1
8	TS-2361061	Lock Washer	M6	6
9	TS-1550041	Flat Washer	M6	6

(For replacement parts not identified here, consult your band saw manual.)

