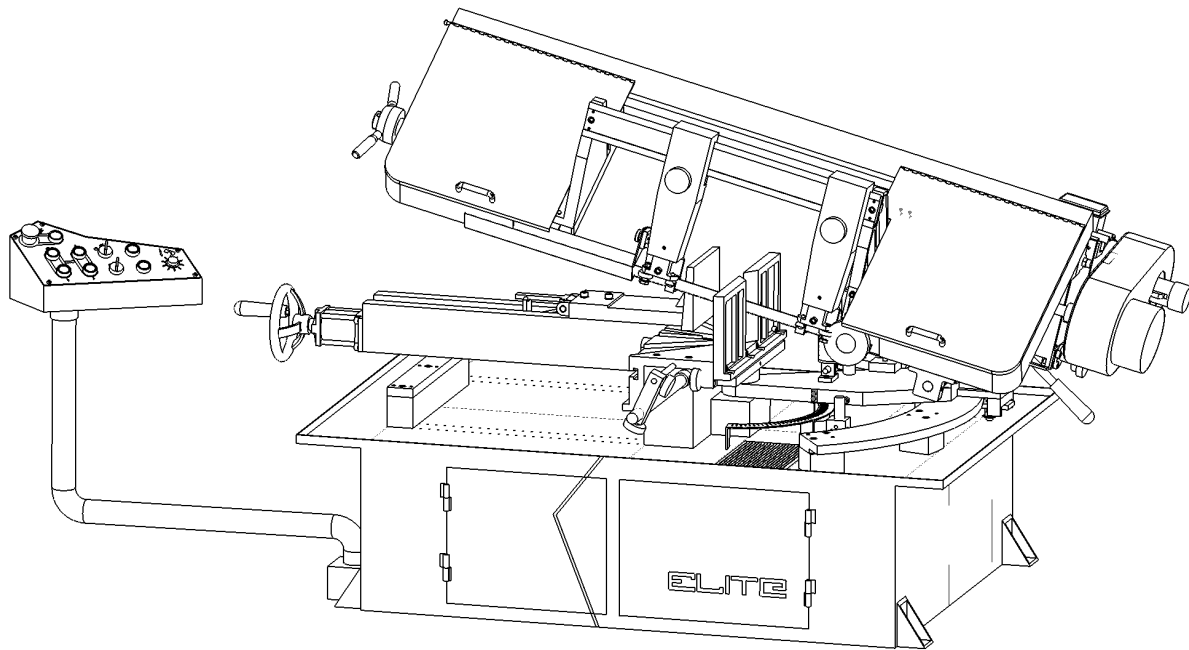




ELITE

HIGH PERFORMANCE MACHINERY

Operating Instructions and Parts Manual Horizontal Band Saw Models EHB-1018VM | EHB-1018VMH



JET®

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JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-855-336-4032, 8AM to 5PM CST, Monday through Friday.

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WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

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MORE INFORMATION

JET® is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website, jettools.com.

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This warranty gives you specific legal rights, subject to applicable state law.

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JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

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3.0 SAFETY WARNINGS

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge have been obtained.
5. Do not use this band saw for other than its intended use. If used for other purposes, JET[®], disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this band saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this band saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.

10. Make certain the switch is in the OFF position before connecting the machine to the power supply.
11. Make certain the machine is properly grounded.
12. Make all machine adjustments or maintenance with the machine unplugged from the power source.
13. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
14. Avoid contact with coolant, especially guarding your eyes.
15. Always keep hands and fingers away from the blade when the machine is running.
16. Never hand hold the material. Always use the vise and clamp it securely.
17. Always provide adequate support for long and heavy material.
18. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after maintenance is complete.
19. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
20. Do not use power tools in damp/wet locations or other dangerous environments. Do not expose them to rain. Keep work area well lighted. Provide for adequate space surrounding work area and non-glare overhead lighting.
21. Keep the floor around the machine clean and free of scrap material, oil and grease.
22. Keep visitors a safe distance from the work area. Keep children away. Workshop should be childproof; padlocks, master switches, remove starter keys.
23. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
24. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
25. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
26. Use recommended accessories; improper accessories may be hazardous.
27. Maintain tools with care. Keep blade sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
28. Maintain proper adjustment of blade tension, blade guides and thrust bearings.
29. Turn off the machine and disconnect from power before cleaning. Use a brush to remove chips or debris — do not use your hands.
30. Do not stand on the machine. Serious injury could occur if the machine tips over.
31. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
32. Be sure that the blade is not in contact with the workpiece when the motor is started. The motor shall be started and you should allow the saw to come up to full speed before bringing the saw blade into contact with the workpiece.
33. Adjust upper guide to clear workpiece. Hold workpiece firmly against table.
34. Direction of feed — feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
35. Installation work and electrical wiring must be done by qualified electrician in accordance with all applicable codes and standards.
36. Do not remove jammed pieces until blade has stopped.



Familiarize yourself with the following safety notices used in this manual:

CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

WARNING

This means that if precautions are not heeded, it may result in serious or even fatal injury.

4.0 INTRODUCTION

This manual is provided by JET® covering the safe operation and maintenance procedures for a JET Model EHB-1018VM or EHB-1018VMH. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site:

5.0 SPECIFICATIONS

Model Number	EHB-1018VM	EHB-1018VMH
Stock Number	891070	891080
Capacity (in.):		
Round at 90°	10	10
Round at 60°	6	6
Round at 45°	10	10
Rectangle at 90°	10x17	10x17
Rectangle at 60°	6x5	6x5
Rectangle at 45°	10x12	10x12
Square at 90°	10x10	10x10
Square at 60°	5-1/2x5-1/2	5-1/2x5-1/2
Square at 45°	10x10	10x10
Vise Swivel (°)	0	0
Head Movement (°)	60 R, 45 L	60 R, 45 L
Blade Size (in.)	1 x .035 x 144	1 x .035 x 144
Blade Wheel Diameter (in.)	14	14
Blade Wheel Speed (SFPM)	Variable 53-257	Variable 53-257
Bed Height (in.)	27	27
Motor (HP)	2 HP, 230/460V 3 Phase CSA/CUS Certified	2 HP, 230/460V 3 Phase CSA/CUS Certified
Overall Dimensions (in.)	85 x 40 x 44	85 x 40 x 44
Net Weight - approx. (lbs.)	1,166	1,210
Shipping Weight - approx. (lbs.)	1,276	1,320

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET, reserves the right to change specifications at any time and without prior notice, without incurring obligations.

6.0 UNCRATING AND ASSEMBLY

Note: Read and understand the entire manual before attempting setup or operation.

1. Finish uncrating the saw and inspect for damage. Should any have occurred, contact your local distributor.
2. Remove all bolts attaching machine to shipping base.
3. Leave packing material between vise clamps and saw head intact until band saw has been lifted to its final position.
4. Clean all rust protected surfaces with kerosene or diesel oil to remove protective coating. Do not use gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.
5. Lubricate all slideways with SAE 10W oil.

7.0 INSTALLATION

For best performance, the band saw should be located on a solid and level foundation. Allow room for servicing and for moving large stock around the band saw when deciding a location for the machine.

1. Using lifting straps that are isolated from the band saw's finished surfaces, lift machine and place in desired location. See Figure 1 for strap placement.
2. Install four leveling bolts with lock nuts on both sides of the base as shown in the parts breakdown on page 16, items 2 and 3.
3. Place a level on the table surface and check side-to-side and front-to-back.
4. Adjust leveling screws until machine is level in both directions and tighten locking nuts.

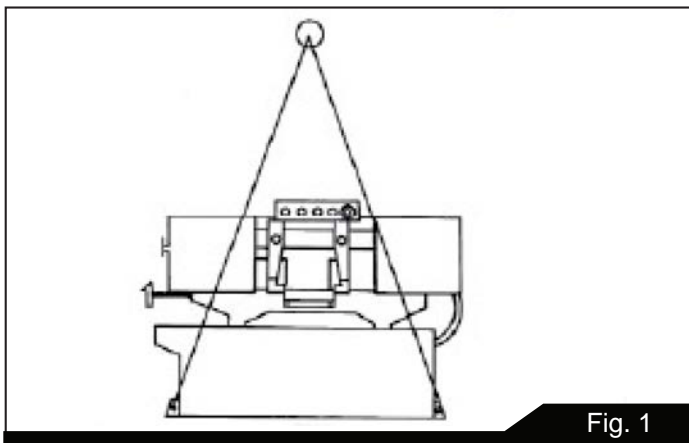


Fig. 1

8.0 ELECTRICAL CONNECTIONS

WARNING

All electrical connections must be done by a qualified electrician. All adjustments or repairs must be done with machine disconnected from power source. Failure to comply may cause serious injury.

The EHB-1018VM/VMH is rated at 230/460V, 3 phase. Confirm that power available at the saw's location matches that for which the saw is wired.

If the saw runs backward, disconnect from power and switch any two of the three power leads.

9.0 CONTROLS

Refer to Figure 2.

Power Indicator Light (A) – lit whenever machine is running.

Start Button (B) – press to start band saw.

Stop Button (C) – press to stop band saw.

Emergency Stop Button (D) – press to immediately stop all machine functions.

Blade Up Button (E) – when in automatic mode, press to raise saw head.

Blade Down Button (F) – when in Automatic mode, press to lower saw head.

Coolant Switch (G) – Turn arrow to "I" to turn on coolant flow. Turn arrow to "O" to stop coolant flow.

Manual/Auto Switch (H) – due to saw head weight, use the auto mode to raise and lower saw head.

Hydraulic Vise Closed Button (I) – press to close vise.

Hydraulic Vise Open Button (J) – press to open vise.

Saw Head Down Feed Speed Control (K) – this knob is used to set the amount of downward force that is applied to the saw blade. The feed rate is proportional to the opening of the valve. When set to zero, the saw head is locked in the raised position. Increasing the valve opening (counterclockwise adjustment) increases the feed rate; decreasing the valve opening (clockwise adjustment) reduces the feed rate.

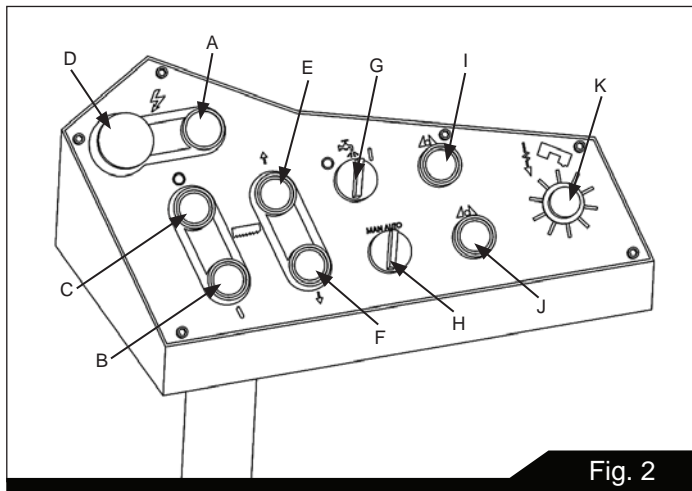


Fig. 2

10.0 AUXILIARY COOLANT HOSE

Your saw is equipped with an auxiliary coolant hose. This can be used when a large amount of coolant needs to be directed at the work piece.

11.0 PRIOR TO OPERATION

1. Check that blade tooth direction matches diagram on blade guides.
2. Check to see that blade is properly seated on wheels after applying correct tension (approximately 25,000 lbs.).
3. Set blade holder guides for approximately .003" to .005" clearance between guides and blade.
4. Check for slight clearance between back up rollers and back of blade.
5. Position blade guides as close to workpiece as possible.
6. Select proper speed and feed rate for material being cut.
7. Material to be cut must be securely held in vise.
8. Check to see that coolant level is adequate and turn on coolant pump if material to be cut requires it. Machine should be filled with four gallons of the proper coolant mixture. Follow the directions on the product maker's label and fill the coolant tank through the chip tray area.
9. Do not start cut on a sharp edge.
10. Keep machine lubricated. See "Lubrication" section.

12.0 OPERATING CONTROLS AND ADJUSTMENTS

12.1 REMOVING AND INSTALLING THE BLADE

1. Disconnect the machine from the power source.
2. Raise the saw frame about 6" and close the feed rate lever by turning it clockwise as far as it will go.
3. Open both wheel covers and clean the swarf out of the machine.
4. Release blade tension by turning the blade tension handwheel (C) Fig. 3 counterclockwise.
5. Remove the blade from both wheels and out of each blade guide.
6. Make sure the teeth of the new blade are pointing in the direction of travel. If necessary, turn the blade inside out.
7. Place the blade in place on the wheels (A) and through the upper blade guard (B) Fig. 3 is shown with the wheel covers removed for clarity.
8. Work the blade (F) all the way up into the blade guide roller bearings (D) with the back of the blade against the back-up bearing (E), as shown in Fig. 4.

NOTE: If roller bearings need adjusting refer to the section ADJUSTING BLADE GUIDE ROLLER BEARINGS.

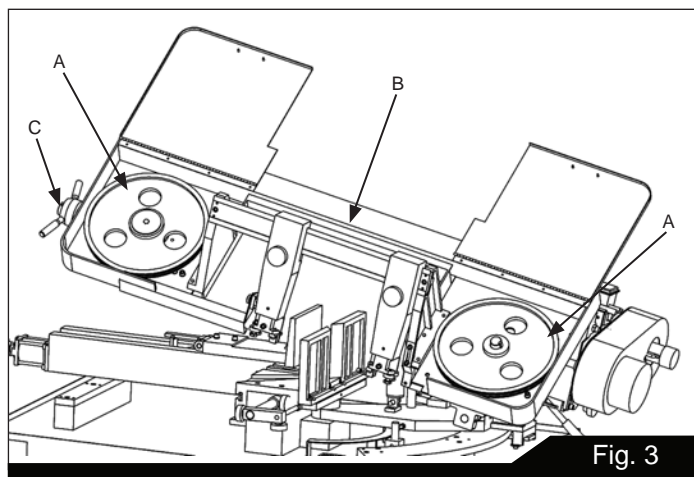


Fig. 3

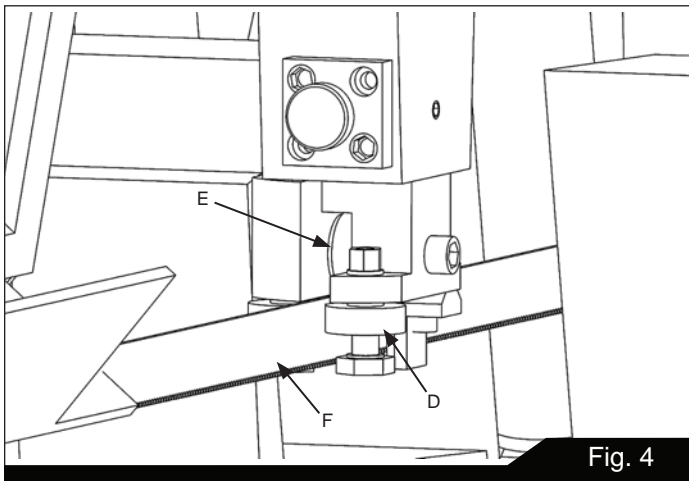


Fig. 4

9. Put light tension on the blade and work it on both wheels, as shown in Fig. 5.

MAKE SURE THAT THE BACK OF THE BLADE IS AGAINST THE WHEEL FLANGES OF BOTH WHEELS. THIS IS VERY IMPORTANT.

10. When you are sure the back of the blade is against the wheel flanges of both wheels and properly inserted into the guides, finish putting tension on the blade.
11. Jog the power “on” and “off” to be sure the blade is in place and tracking properly.
If blade is not tracking properly refer to the section “Tracking the Blade”.

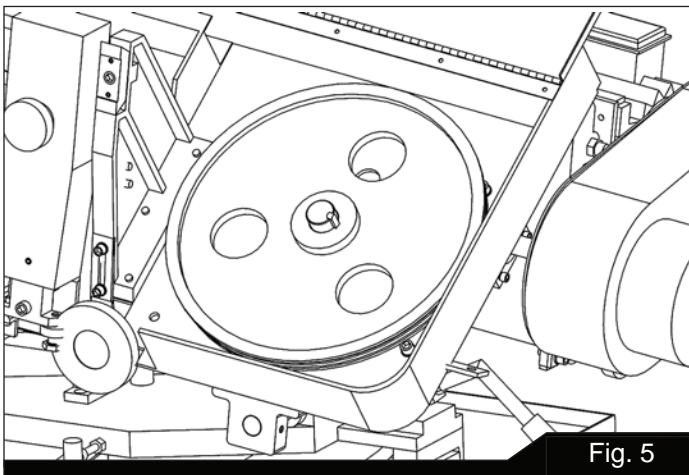


Fig. 5

12.2 ADJUSTING BLADE GUIDE BRACKETS

The blade guides should be set as close to the vise jaw as possible. The right blade guide bracket (A) Fig. 6, is not adjustable and is set at the factory to clear the right hand vise jaw. The left blade guide bracket (B) can be moved to the left or right depending on the position of the left hand vise jaw (C).

To move the left blade guide bracket (B), loosen hand knob (D), position blade guide bracket (B) and tighten hand knob (D).

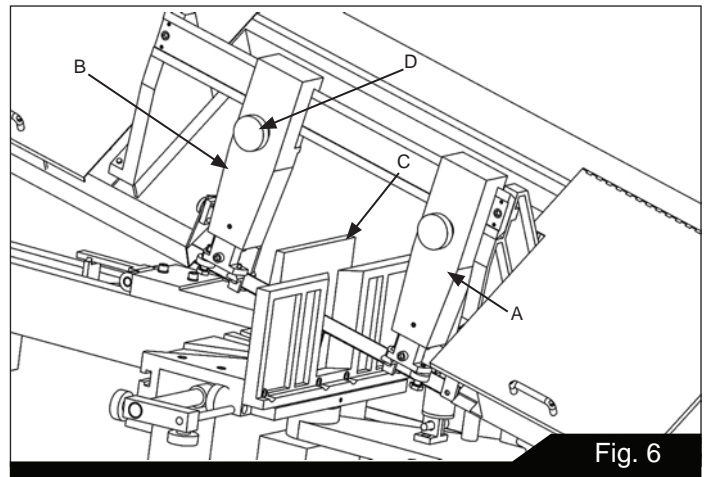


Fig. 6

12.3 ADJUSTING BLADE GUIDE ROLLER BEARINGS

The back of the blade (A) Fig. 7, should ride against the back-up support bearing (B) which is positioned at an angle so as to provide greater bearing support, eliminating bearing wear and extending blade life.

The saw blade (A) should also ride between the two roller bearings (C) and (D) Fig. 7.

The rear bearing (C) on the left hand blade guide can be easily adjusted to suit blade thickness by loosening nut (E). The bearing (C) is on an eccentric which enables it to be adjusted for blade thickness in the same manner with the exception that the adjustable roller bearing is in the forward position.

Part (F) shown Fig. 8 is a tungsten carbide block, after completing the adjustments shown in Fig. 7, tighten the Part (F) onto the surface of the saw blade.

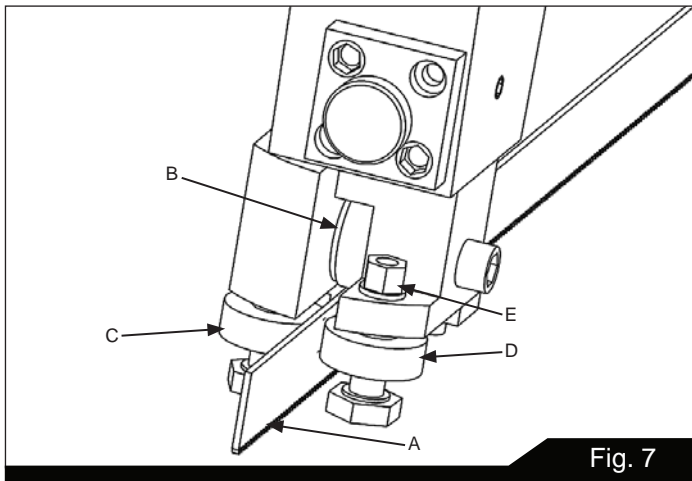


Fig. 7

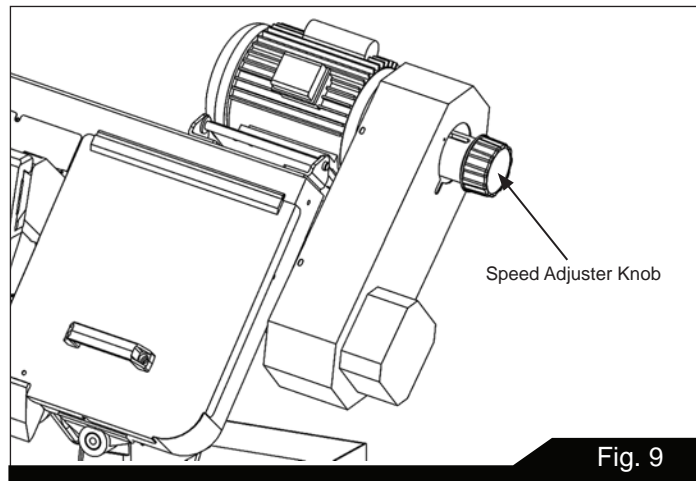


Fig. 9

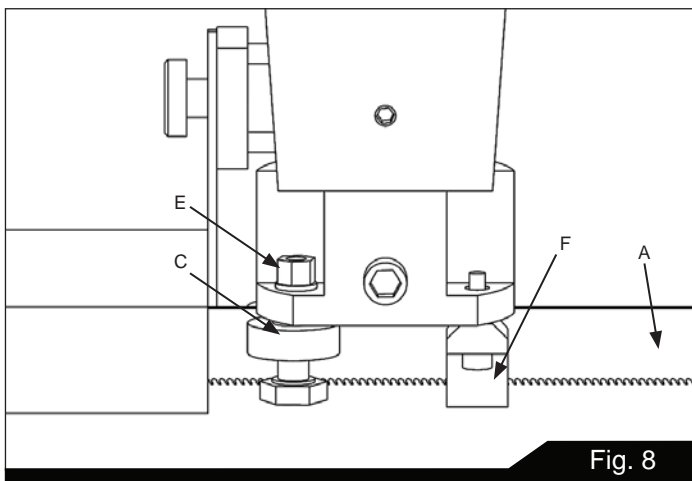


Fig. 8

12.4 CHANGING BLADE SPEED

WARNING

Only adjust speed with power on and blade turning.

1. Raise cutting head approximately six inches above work piece and turn feed rate knob to zero.
2. Turn power on and turn speed adjuster knob (as in Figure 9) to match appropriate material.

12.5 OPERATING VISE

The workpiece is placed between the vise jaws with the required amount to be cut-off extending out past the blade. To position the moveable vise jaw (B) instantly, simply turn vise handknob (A) Fig. 10, counterclockwise 1/2 turn and move the vise jaw (B) to the desired position.

Then tighten vise by turning the knob (A) clockwise. The vise can be adjusted to cut any angle from 0° to 45° by loosening the two bolts (C) Fig. 10, on each vise jaw. Position the vise jaws to the desired angle and tighten the bolts. It is also necessary, when angle cutting, to move the right hand vise jaw (D) to the left until the workpiece and right hand vise jaw clears the right hand guide arm.

12.5.1 HYDRAULIC VISE

The 1018VMH is equipped with a hydraulic vise. This feature allows the operator to make repeated cuts much quicker than saws with manual vise.

To use the hydraulic vise, load material as normal and manually advance the mobile vise jaw against the work piece then use the vise close and open functions located on the control panel.

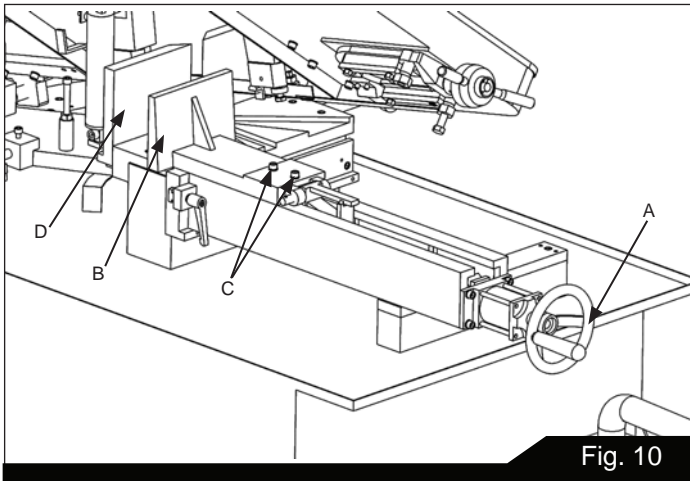


Fig. 10

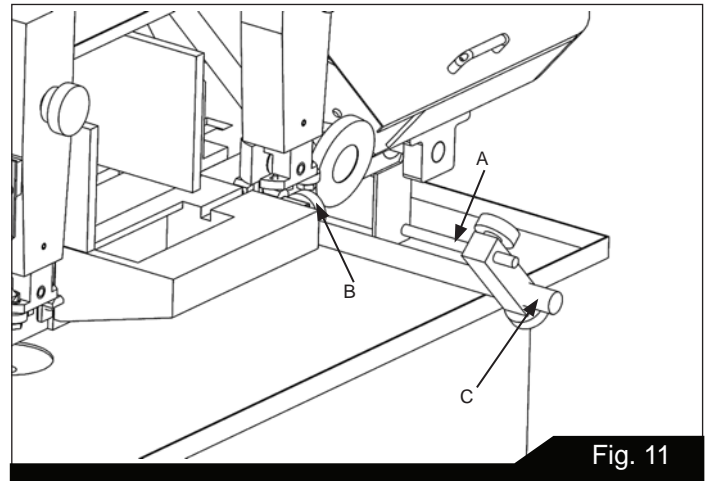


Fig. 11

12.6 BOW WEIGHT ADJUSTMENT

Bow weight is one of the most important adjustments of the saw. If the bow weight is not set properly, one can expect poor performance, crooked cuts, tooth stripping, stalling, and the blade popping off the blade wheels. The hydraulic feed rate unit will not compensate for improper bow weight. Bow weight has been set at the factory and should not need any adjustment. If adjustment becomes necessary:

1. Disconnect machine from power source.
2. Turn on hydraulic valve (F, Figure 2).
3. Turn cutting pressure control valve (E, Figure 2) counterclockwise until it stops.
4. Place one end of a fish-type scale under the blade tension handle and lift the saw with the other end. The scale should indicate approximately 22-24 lbs. for the EHB-1018VM/VMH.
5. Adjust tension to approximately 22-24 lbs. by turning the adjustable C-bolt found at the end of the coil spring on the rear of the band saw.
6. Connect the machine to the power source.

12.7 ADJUSTING STOCK ADVANCE STOP

The Stock Advance Stop is used mainly when more than one piece is to be cut to the same length. Simply position the stop block (A) Fig.11, the desired distance away from the blade.

The stop may be repositioned by loosening screw (B) and moving the rod (C) accordingly. To move the stop block (A) out of the way simply push it to the down position.

12.8 SETTING UP THE MACHINE FOR OPERATION

1. Select the proper speed and blade for the type of material you are cutting.
2. Make sure blade tension is adjusted properly.
3. Lift the saw frame up and turn the feed rate knob to zero.
4. Place the stock between the vise jaws, set the stock for the desired width of cut and tighten the vise.
5. Make sure the left blade guide bracket (A) is adjusted as close as possible to the left vise jaw (B) Fig. 12.
6. Turn the machine on adjust coolant flow by turning knob (G) Fig. 2.
7. Turn the feed rate control (K) Fig 2, counterclockwise until the saw blade begins to lower the desired rate of speed.
8. Proceed to cut throughout the workpiece, as shown in Fig. 12. The machine will turn off at the completion of the cut.

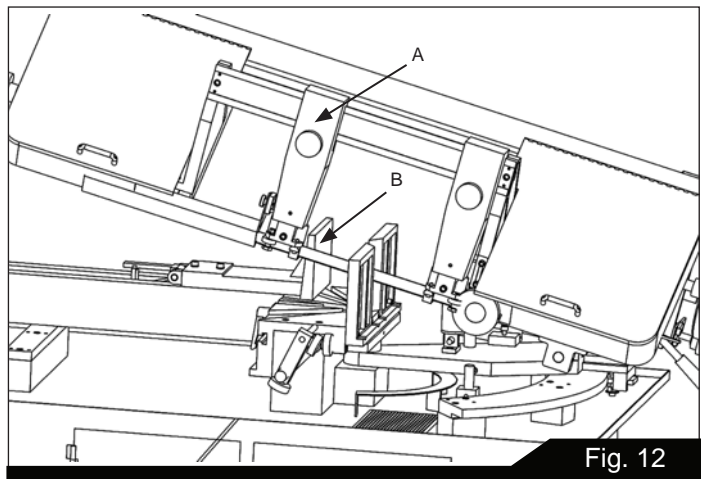


Fig. 12

12.9 AUTOMATIC SHUT-OFF

Each machine and any accessories which are wired into the electrical system are controlled by the start-stop buttons. The machine will automatically shut off when the cut is completed. The lever (A) Fig. 13, for the automatic shut-off, contacts the top of the hydraulic cylinder (B) and shuts off the machine.

LUBRICATION OF HYDRAULIC SYSTEM

If it is necessary to fill the hydraulic cylinder with oil, proceed as follows:

1. Lift the saw frame slightly (about 15°), place a block underneath the saw frame to hold it.
2. Turn cover (B) shown in Fig. 13 counterclockwise, then fill hydraulic oil or equivalent until it is full.

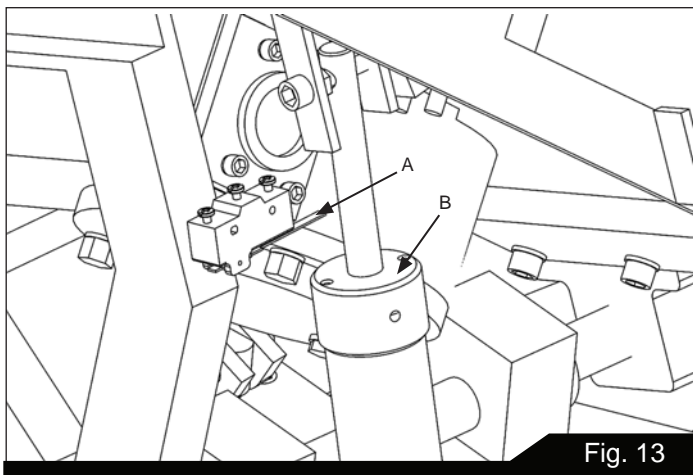


Fig. 13

12.10 GEAR CASE

After the first 50 hours of use the gear case should be drained and refilled. Remove drain plug (A) Fig. 14 drain all of the oil out of the gearbox. Remove oil filler plug located underneath the right wheel and fill the gear case with 850ml of multi-function gearbox oil or equivalent.

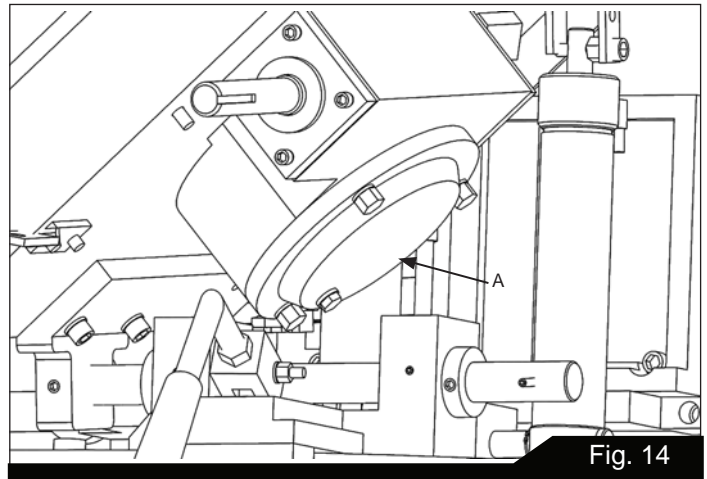


Fig. 14

12.11 ADJUST BLADE TENSION & BLADE TRACKING ADJUSTMENT

Blade tension has been preset at the factory; however if the tension should need to be increased, this can be accomplished by turning the handwheel (A) clockwise until the tension limiter (B) slips. Please note that one does not need to press the handwheel, simply turn. For purposes of proper blade tracking, the back of the blade should be located against the flange of the blade wheel. If it is not, the tracking can be adjusted by loosening the screw (C) in Fig. 15, and adjusting screw (D) in Fig. 15, until the blade is tracking properly. When adjustment is complete, retighten screw (C).

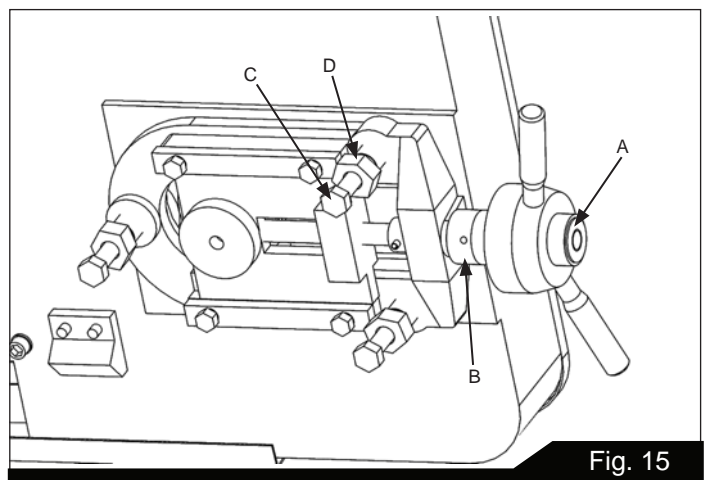


Fig. 15

12.12 SAFETY DEVICE FOR BROKEN SAW BLADE

When the saw blade breaks during operation, the limit switch shown in Fig. 16, will automatically shut the machine off.

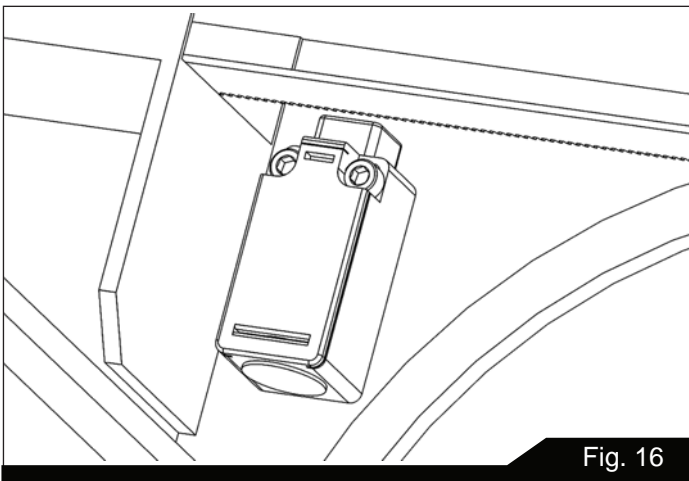


Fig. 16

12.13 CLAMPING VISE POSITION LOCKING LEVER

Due to the mitering function of this saw, the vise can be moved fore and aft. Make sure to tighten both workpiece levers (A) in Fig. 17, before clamping the workpiece.

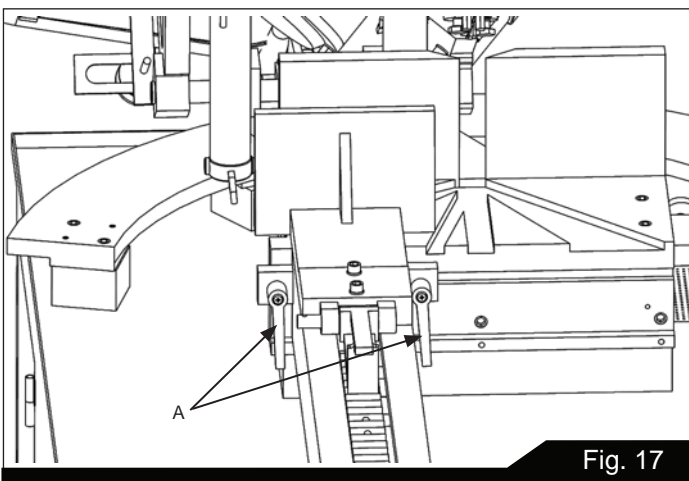


Fig. 17

12.14 MITER ANGLE ADJUSTMENT

In order to use the mitering function of this saw, first you must release the tension on lever (A) Fig. 18 by pulling the lever up. Then remove the 90 deg pin (A) Fig. 19 to allow the frame to swing. Set the indicator (B) Fig. 19 to the desired angle on the scale (C) Fig. 19. After the proper angle has been set, push the lever down to hold the saw in place. If the lever does not adequately hold the saw, the tension can be adjusted by tightening the bolt (B) under the lever.

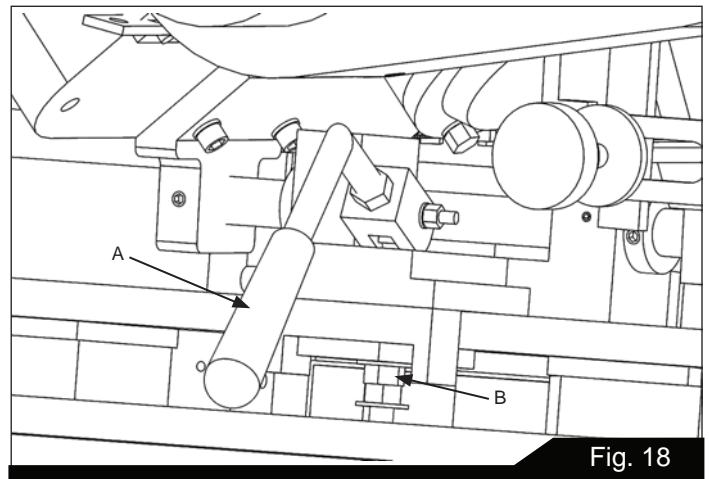


Fig. 18

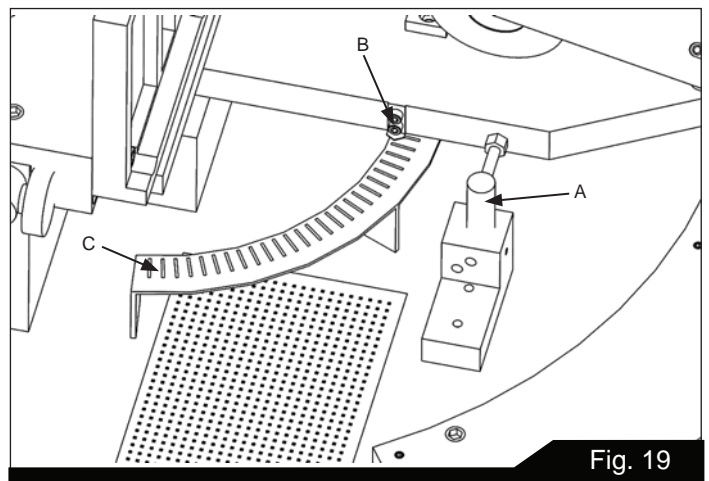


Fig. 19



13.0 MAINTENANCE

WARNING

Before doing maintenance on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Failure to comply may cause serious injury.

Keep the band saw and the motor clean.
If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

14.0 LUBRICATION

All ball bearings are permanently lubricated and sealed. They require no further attention.

The gear box lubricant should be changed after the first 50 hours of operation. Change lubricant from then on every 250 hours of operation.

To check level of gear box lubricant, place saw arm in down position and allow a few minutes to pass so that oil drains down. Check level in sight glass on side of gear casing. Correct level is the dot in the middle of sight glass.

To change gear box lubricant:

1. Disconnect the machine from the power source.
2. Open drain plug and allow lubricant to drain completely. Drain plug may be found on lower front of gear case under right wheel cover. Remove drain plug with a hex wrench.
3. Replace drain plug.
4. Remove filler cap (A, Figure 12) and fill gear box with Mobil DTE® Oil Heavy Medium until level reaches dot in middle of sight glass.
5. Replace filler cap.
6. Connect machine to the power source.

Use a light machine oil to lubricate all other moving parts as needed.

15.0 REPLACEMENT PARTS — EHB 1018VM and EHB 1018VMH

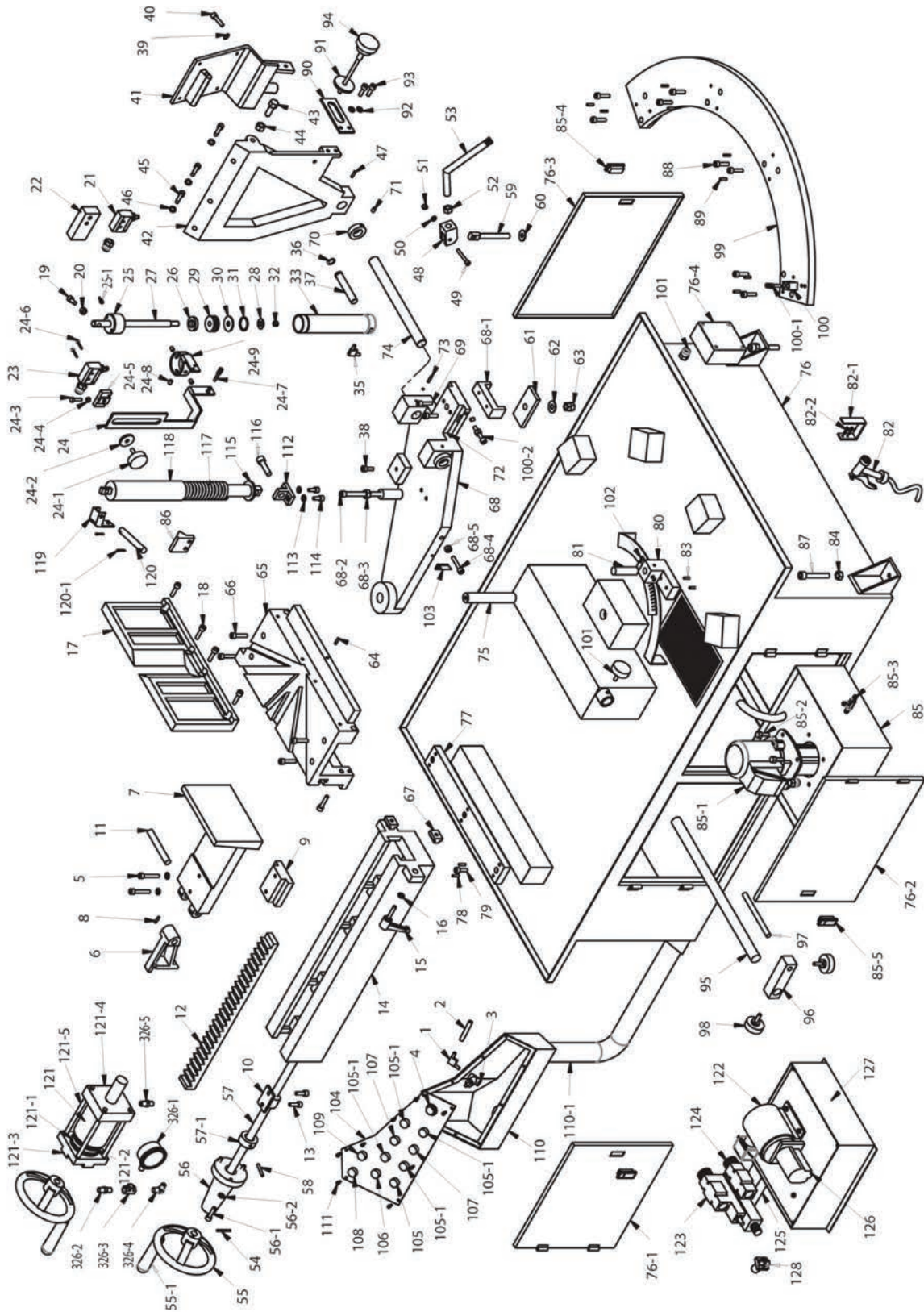
Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-855-336-4032, Monday through Friday (see our website for business hours, www.jettools.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

JET®

427 New Sanford Road
LaVergne, Tennessee 37086
www.jettools.com

Phone: 855-336-4032

SAW STAND AND BED ASSEMBLY — EHB 1018VM, 1018VMH





PARTS LIST EHB-1018VM, EHB-1018VMH

Index No.	Part No.	Description	Size	Qty.
1	EHB916V-64	Fitting		2
2	EHB916V-65	Tubing	5/16" x 65"	2
3	EHB1018VM-66	Valve		1
4	EHB1018VM-67	Feed Knob		1
5	TS-0209071	Socket Head Cap Screw	3/8 x 1-1/2"	2
6	EHB1018VM-191	Rack block		1
7	EHB1018VM-192	Vise jaw Bracket		1
8	TS-0267041	Set Screw	1/4-20 x 3/8"	1
9	EHB1018VM-194	Rack block		1
10	EHB1018VM-195	Acme Nut Assembly		1
11	EHB1018VM-196	Fixed Pin		1
12	EHB1018VM-197	Rack		1
13	TS-0081031	Hex Cap Screw	5/16-18 x 3/4"	2
14	EHB1018VM-199	Moveable Bed		1
15	EHB1018VM-200	Adjustable Handle		1
16	TS-0680041	Flat Washer	3/8"	1
17	EHB1018VM-202	Vise Jaw Bracket (fixed)		1
18	TS-0208071	Socket Head Cap Screw	5/16"-18 x 1-1/4"	4
19	TS-0060081	Hex Cap Screw	3/8-16 x 1-3/4"	1
20	TS-0561031	Hex Nut	3/8"	1
21	EHB916V-206	Limit Switch		1
22	EHB1018VM-207	Limit Switch Seat(Ser No.13080024 and lower)		1
	EHB1018VM-207N	Limit Switch Seat(Ser No.xxxx0025 and higher)		1
23	EHB1018VM-208	Limit Switch		1
24	EHB1018VM-209	Bracket		1
24-1	EHB916V-209-1	Knob		1
24-2	EHB916V-191	Special Washer		1
24-3	EHB1018VM-209-3	Screw		1
24-4	TS-0561011	Nut		1
24-5	EHB1018VM-209-5	Block		1
24-6	EHB1018VM-209-6	Screw		2
24-7	EHB1018VM-209-7	Screw		2
24-8	EHB916V-225	Screw		3
24-9	EHB1018VM-209-9	Ring		1
	EHB1018VM-OHCA	Oil Hydraulic Cylinder Assembly (includes # 25-33,35)		1
25	EHB916V-210	Cap		1
25-1	EHB1018VM-25-1	Air Flow Brass		
26	EHB916V-211	Oil Seal	20.35.7	1
27	EHB1018VM-213	Rod		1
28	TS-0680031	Flat Washer	5/16"	1
29	EHB1018VM-215	Piston		1
30	EHB916V-216	Seal		1
31	EHB1018VM-217	O-Ring		1
32	TS-0561021	Hex Nut	5/16" x 18T	2
33	EHB1018VM-219	Tube Assembly		1

Index No.	Part No.	Description	Size	Qty.
35	EHB916V-222	Tube Fitting		1
36	EHB916V-223	Retaining Ring	S-17	1
37	EHB1018VM-224	Pivot Shaft		1
38	EHB916V-225	Socket Set Screw	3/8"-16T x 3/8"	1
39	TS-0680031	Flat Washer	5/16"	4
40	TS-0051051	Hex Cap Screw	5/16 x 1"	4
41	EHB916V-232	Motor Plate		1
42	EHB1018V-233	Rear Pivot Bracket		1
43	EHB916V-234	Socket Set Screw	1/2" x 2"	2
44	EHB916V-235	Hex Nut	1/2"-12	2
45	TS-0209081	Socket Head Cap Screw	3/8"-16T x 1-3/4"	3
46	TS-0680041	Flat Washer	3/8"	3
47	TS-0271051	Set Screw	3/8"-16 x 1/2"	1
48	EHB1018VM-241	Eccentric		1
49	TS-0051081	Hex Cap Screw	5/16 x 1-3/4"	1
50	TS-0680031	Flat Washer	5/16"	1
51	TS-0561021	Hex Nut	5/16 x 18T	1
52	TS-0561071	Hex Nut.	5/8"	1
53	EHB1018VM-247	Handle		1
54	EHB916V-248	Pin (not show)		1
55	EHB916V-249	Hand Wheel		1
55-1	EHB916V-249-1	Handle		1
56	EHB1018VM-250	Seat (1018VM only)		1
56-1	TS-0051051	Hex Cap Screw (1018VM only)	5/16"-18 x 1"	2
56-2	TS-0720081	Lock Washer (1018VM only)	5/16"	2
57	EHB1018VM-252	Acme Screw(1018VM only)		1
57	EHB1018VMH-252	Acme Screw(1018VMH only)(not shown)		1
57-1	EHB916V-252-1	Collar		1
58	EHB916V-253	Roll Pin	6 ø x30 ø	1
59	EHB1018VM-254	Locking screw		1
60	EHB1018VM-255	Special Washer		1
61	EHB1018VM-256	Locking pieces		1
62	TS-0680061	Flat Washer	1/2"	1
63	TS-0561051	Hex Nut.	1/2"-12	2
64	TS-0267121	Socket Set Screw	1/4 x 3/4"	1
65	EHB1018VM-260	Table		1
66	TS-0208061	Socket Head Cap Screw	5/16" x 1"	4
67	EHB1018VM-262	Block		1
68	EHB1018VM-263	Swiveling Seat		1
68-1	EHB1018VM-263-1	Support Seat		1
68-2	TS-0070161	Hex Cap Screw	1/2 x 5-1/2	1
68-3	TS-0640111	Hex Nut	1/2"	1
68-4	TS-0060071	Hex Cap Screw	3/8 x 1-1/2	1
68-5	TS-0570031	Hex Nut.	3/8"-16	1
69	TS-0050031	Hex Cap Screw	1/4" x 3/4"	2
70	EHB916V-265	Collar		2
71	TS-0271031	Socket Set Screw	3/8-16T x3/8"	4
72	EHB916V-267	Copper		2

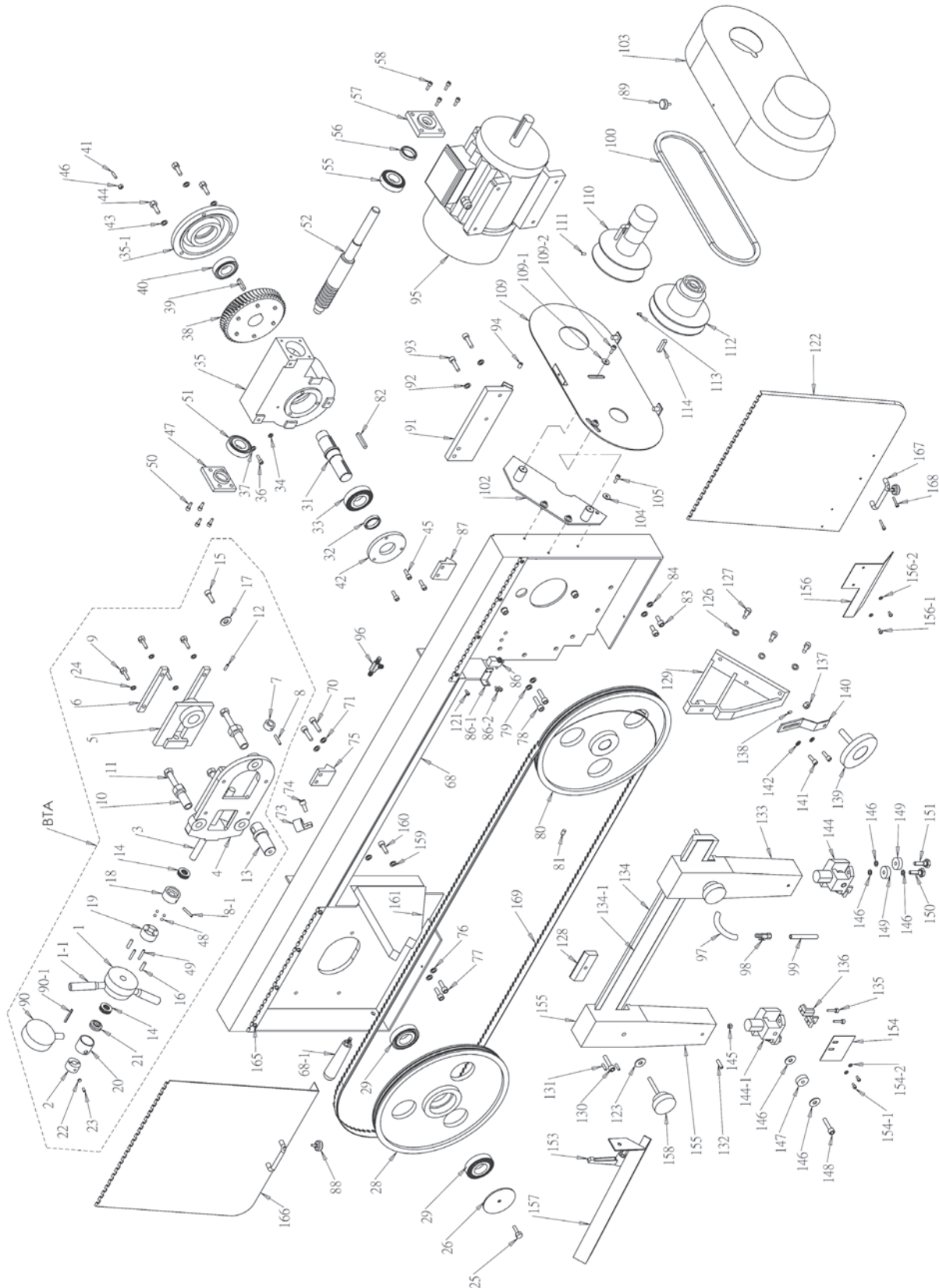


Index No.	Part No.	Description	Size	Qty.
73	TS-0271031	Socket Set Screw	3/8-16T x3/8"	2
74	EHB916V-269	Pivot Shaft		1
75	EHB1018VM-270	Spindle		1
76	EHB1018VM-271	Base Assembly		1
76-1	EHB1018VM-271-1	Base Lid		1
76-2	EHB1018VM-271-2	Base Lid		1
76-3	EHB1018VM-271-3	Door		1
76-4	EHB1018VM-271-4	Wiring box		1
77	EHB1018VM-272	Sliding Surface		1
78	TS-0267071	Socket Set Screw	1/4-20 x 3/4"	6
79	TS-0208061	Socket Head Cap Screw	5/16"-18 x 1"	3
80	EHB1018VM-276	Seat		1
81	EHB1018VM-277	Movable Pin		1
82	EHB916V-278	Gun Set		1
82-1	EHB916V-278-1	Hook		1
82-2	EHB916V-278-2	Hex Cap Screw		2
83	TS-0051051	Hex Cap Screw	5/16"-18 x 1"	2
84	TS-0561051	Hex Nut	1/2"-12T	4
85	EHB1018VM-281	Coolant Tank		1
85-1	EHB1018VM-281-1	Coolant Pump		1
85-2	EHB916V-281-2	Pan Head Machine Screw		4
85-3	EHB916V-96	3 Way Coolant Block		1
85-4	EHB916V-281-4	Lock W/Key		1
85-5	EHB916V-281-5	Lock W/o Key		2
86	EHB1018VM-282	Bracket		1
87	TS-0070051	Hex Cap Screw	1/2"-12 x 2"	4
88	TS-0208071	Socket Head Cap Screw	5/16' x 1-1/4"	8
89	TS-0267071	Set Screw	1/4"-20 x 3/4"	8
90	EHB1018VM-286	Strap		1
91	EHB916V-26	Special Washer		1
92	TS-0680021	Flat Washer	1/4"	2
93	TS-0050031	Hex Cap Screw	1/4"-20 x 3/4"	2
94	EHB916V-245	Knob		1
	EHB1018VM-SA	Adj. Stock Stop Assembly (includes #95-98,#101)		1
95	EHB1018V-258	Shaft	7/8"	1
96	EHB1018VM-292	Stop Bracket		1
97	EHB1018V-260	Bar		1
98	EHB916V-257	Knob		2
99	EHB1018VM-295	Arch Seat		1
100	EHB1018VM-296	Support Block		1
100-1	EHB1018VM-296-1	Socket Head Cap Screw		2
100-2	EHB1018VM-296-2	Screw w/Nut		1
101	EHB916V-257	Knob		1
102	EHB1018VM-298	Scale		1
103	EHB1018VM-299	Indicator		1
104	EHB1018VM-300	Nameplate		1
105	EHB1018VM-301	Start Switch		1

Index No.	Part No.	Description	Size	Qty.
105-1	EHB1018VM-301-1	Raise/Lower/Vise Clamp/Vise Unclamp Switch		4
106	EHB1018VM-302	Stop Switch		1
107	EHB1018VM-303	Selection Switch		2
108	EHB1018VM-304	Emergency Switch		1
109	EHB916V-305	Indication Light For Power		1
110	EHB1018VM-306	Control Box		1
110-1	EHB1018VM-306-1	Tube		1
111	EHB1018VM-307	Screw	3/16" x 3/8"	9
112	EHB1018VM-311	Acme Leadscrew Seat		1
113	TS-0680031	Flat Washer	5/16"	2
114	TS-0208061	Socket Head Cap Screw	5/16-18 x 1"	2
115	EHB1018VM-314	Fixing Rod for Spring		1
116	TS-0211071	Socket Head Cap Screw	1/2" x 1-1/2"	1
117	EHB1018VM-316	Spring		1
118	EHB1018VM-317	Spring Cover		1
119	EHB1018VM-318	Bracket		1
120	EHB1018VM-319	Spindle		1
120-1	EHB1018VM-319-1	Open Pin	1/8" x 1"	2
121	EHB1018VMH-320	Hydraulic Vise Assembly (includes #121-1~121-5) (1018VMH only)		1
121-1	EHB1018VMH-320-1	O-Ring	40.46	2
121-2	EHB1018VMH-320-2	Oil Scraping Ring	UHS70	2
121-3	EHB1018VMH-320-3	Upper Cap		1
121-4	EHB1018VMH-320-4	Lower Cap		1
121-5	EHB1018VMH-320-5	Special Screw	M10	4
122	EHB1018VM-321	Hydraulic Motor	1/4 HP	1
123	EHB1018VMH-322	Direction Valve (1018VMH only)		1
124	EHB1018VMH-323	Reducing Valve (1018VMH only)		1
125	EHB1018VMH-324	Manifold Block (1018VMH only)		1
126	EHB1018VM-325	Hydraulic Pump		1
127	EHB1018VM-326	Oil Box		1
128	EHB1018VM-327	Solenoid Valve		1
129	EHB1018VM-129	Sight Glass (not shown)		1
326-1	EHB1018VMH-326-1	Vise Pressure Gauge (1018VMH only)		1
326-2	EHB1018VMH-326-2	Fitting (1018VMH only)		1
326-3	EHB1018VMH-326-3	Fitting (1018VMH only)		1
326-4	EHB1018VMH-326-4	Fitting (1018VMH only)		1
326-5	EHB1018VMH-326-5	Fitting (1018VMH only)		1
	EHB1018VM-25-1	Air Flow Brass (not shown)		1



SAW ARM ASSEMBLY — EHB 1018VM, 1018VMH



PARTS LIST SAW ARM — EHB 1018VM, 1018VMH

Index No.	Part No.	Description	Size	Qty.
1	EHB916V-01	Handwheel		1
1-1	EHB916V-01-1	Handwheel handle		2
2	EHB916V-20	Lock Nut		1
3	EHB916V-03	Shaft		1
4	EHB916V-04	Bracket		1
5	EHB916V-05	Slide		1
6	EHB916V-06	Gib		2
7	EHB916V-07	Collar		1
8	EHB916V-08	Roll pin	5x30	2
8-1	EHB916V-08-1	Roll pin	5x40	1
9	TS-0081031	Hex Cap Screw	5/16 x 3/4	4
10	EHB916V-10	Adjusting Screw	3/4 x 1-1/2	1
11	TS-0060111	Hex Cap Screw	3/8 x 2-1/2	1
12	TS-0271031	Set Screw	3/8" x 3/8	1
13	EHB916V-13	Spindle		1
14	BB-51103	Thrust bearing	BB51103	2
15	TS-0060061	Hex Cap Screw	3/8 x 1-1/4	1
16	EHB916V-16	Roll Pin	5 x 30	1
17	TS-0732061	Lock Washer	3/8"	1
18	EHB916V-18	Driven		1
19	EHB916V-19	Thrust Bearing Housing		1
20	EHB916V-02	Collar		1
21	EHB916V-21	Disc Spring		6
22	EHB916V-22	Copper		1
23	TS-0267041	Set Screw	1/4 x 3/8	1
24	TS-0720081	Lock Washer	5/16"	1
25	TS-0060051	Hex Cap Screw	3/8" x 1"	1
26	EHB916V-26	Special Washer		1
28	EHB916V-28	Wheel L.H.		1
29	BB6306ZZ	Bearing	BB6306ZZ	2
31	EHB916V-31	Output Shaft		1
32	EHB916V-32	Oil Seal	32.42.7	1
33	BB-30207	Bearing		1
34	EHB916V-34	Oil Plug	1/4"	1
35	EHB916V-35	Gear Box Housing	1	
35-1	EHB916V-35-1	Cover	1	
	EHB916V-GBCA	Gear Box Cover Assembly (includes 35, 35-1)	1	
36	TS-0060081	Hex Cap Screw	3/8-16 x 3/4"	3
37	TS-0732061	Lock Washer	3/8"	3
38	EHB916V-38	Worm Gear		1
39	EHB916V-39	Key	7 x 7 x 35	1
40	BB-30206	Bearing		1
41	TS-0267121	Set Screw	1/4" x 3/4"	3
42	EHB916V-42	Cap		1
43	TS-0732061	Lock Washer	3/8"	3



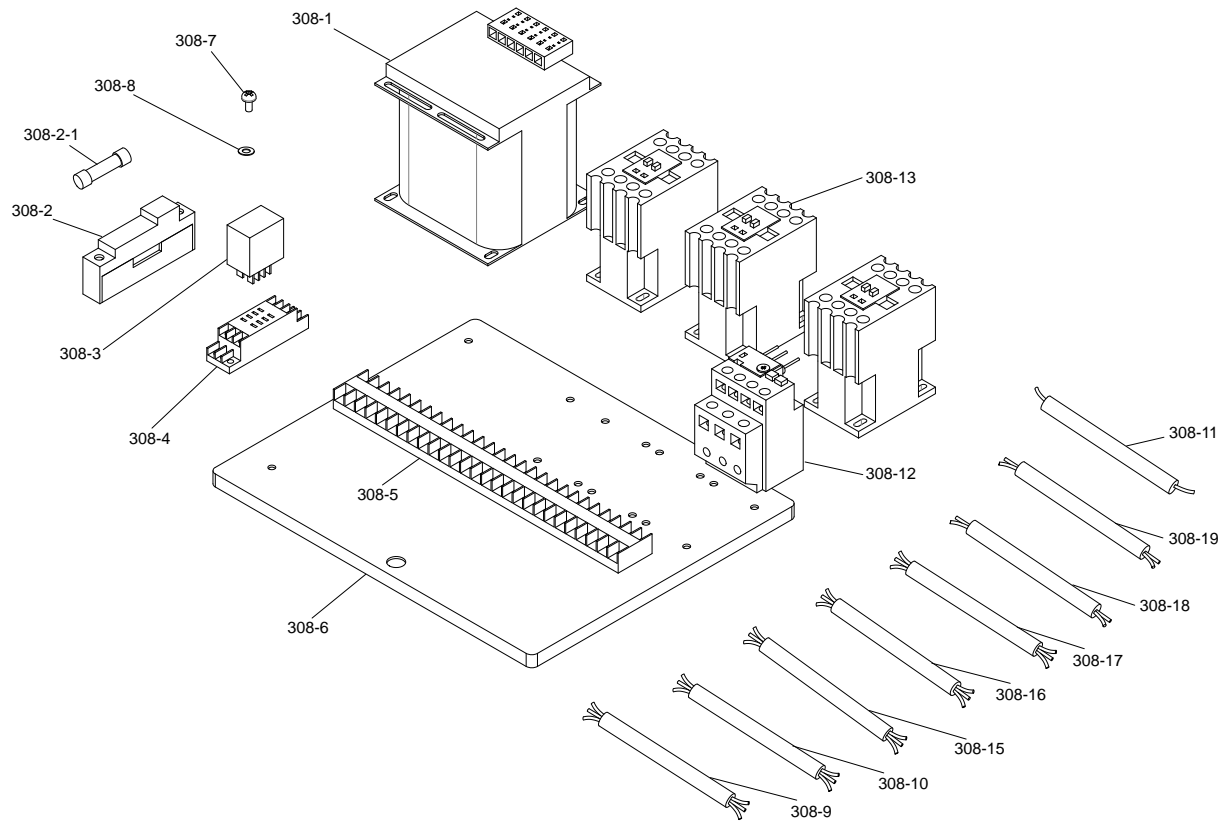
Index No.	Part No.	Description	Size	Qty.
44	TS-0060071	Hex Cap Screw	3/8"-16 x 1-1/2"	3
45	TS-0207021	Socket Head Cap Screw	1/4"-20 x 5/8"	3
46	TS-0561011	Hex Nut	1/4"	3
47	EHB916V-47	Cap		1
48	SB-3/16	Steel Ball	3/16"	2
49	TS-0270061	Set Screw	5/16"-18 x 5/8"	1
50	TS-0207021	Socket Head Cap Screw	1/4"-20 x 5/8"	4
51	BB-6004	Bearing	BB6004	1
52	EHB916V-52	Input Shaft		1
55	BB-3205	Bearing	3205	1
56	EHB916V-56	Oil Seal	25.35.7	1
57	EHB916V-57	Cap		1
58	TS-0207021	Socket Head Cap Screw	1/4"-20 x 5/8"	4
68	EHB1018VM-68	Bow Frame		1
68-1	EHB916V-68-1	Frame Handle		1
70	TS-0081031	Hex Cap Screw	5/16" x 3/4"	2
71	TS-0680031	Flat Washer	5/16"	2
73	EHB916V-73	Tube Retainer		2
74	EHB916V-74	Round Head Screw	3/16" x 3/8"	2
75	EHB916V-75	Bracket		1
76	TS-0680031	Flat Washer	5/16"	2
77	TS-0081031	Hex Cap Screw	5/16" x 3/4"	2
78	TS-0081031	Hex Cap Screw	5/16" x 3/4"	2
79	TS-0680031	Flat Washer	5/16"	2
80	EHB916V-80	Drive Wheel.		1
81	TS-0271032	Socket Set Screw	3/8-24 x3/8"	1
82	EHB916V-82	Key	7 x 7 x 40	1
83	TS-0081031	Hex Cap Screw	5/16-18 x3/4"	2
84	TS-0720081	Lock Washer	5/16"	2
86	EHB916V-86	Sensor		1
86-1	EHB916V-86-1	Sensor seat		1
86-2	EHB916V-86-2	Screw		2
87	EHB916V-75	Bracket		1
88	EHB916V-88	Knob		2
89	EHB916V-88	Knob		1
90	EHB916V-90	Blade Tension Gauge		1
BTA	EHB916-BTA	Blade Tension Assembly (includes 1~24, 48~49, 90~90-1)		1
90-1	EHB916V-90-1	Pin		1
91	EHB1018V-91	Front Pivot Bracket		1
92	TS-0732061	Lock Washer	3/8"	3
93	TS-0060081	Hex Cap Screw	3/8-16 x3/4"	3
94	TS-0271051	Socket Set Screw	3/8-16 x1/2"	1
95	EHB1018VM-95	Motor	2Hp,230/460V	1
96	EHB916V-96	3 Way Coolant Block		1
97	EHB1018VM-97	Hose		2

Index No.	Part No.	Description	Size	Qty.
98	EHB916V-98	Valve		2
99	EHB1018V-99	Hose Clamp		2
100	EHB1018VM-100	Belt (for 1018VM/1018VMH)		1
101	EHB916V-101	Cable Glands(not show)	PG-11	5
102	EHB1018VM-102	Pulley Fixed Plate		1
103	EHB916V-103	Upper Guard		1
104	TS-0680021	Flat Washer	1/4"x19x2.0	3
105	TS-0207031	Socket Head Cap Screw	1/4"x20x5/8"	3
109	EHB916V-109	Lower Guard		1
109-1	TS-0680021	Flat Washer	1/4"x19x2.0	2
109-2	TS-0207031	Socket Head Cap Screw	1/4"x20x5/8"	2
110	EHB916V-110	Motor Pulley		1
111	TS-0270021	Socket Set Screw	5/16-18 x5/16"	1
112	EHB916V-112	Pulley		1
113	TS-0270021	Socket Set Screw	5/16-18 x5/16"	1
114	EHB916V-114	Key	5 x 5 x 40	1
121	EHB916V-121	Round Head Screw	10-3/16 x3/8"	4
122	EHB1018VM-122	Cover R.H.		1
123	TS-0680041	Lock Washer	3/8"	4
126	TS-0680041	Lock Washer	3/8"	3
127	TS-0060081	Hex Cap Screw	3/8 x16 x3/4"	3
128	EHB1018V-128	Stationary plate		2
129	EHB1018V-129	Bracket		1
130	TS-0209061	Socket Head Cap Screw	3/8"-16 x1-1/4"	2
131	TS-0267071	Set Screw	1/4"-20 x3/4"	4
132	TS-0270061	Set Screw	5/16"-18 x5/8"	1
133	EHB1018V-133	Bracket-R.H.		4
134	EHB1018VM-134	Slide		1
134-1	EHB916V-134-1	Scale		1
135	EHB916V-135	Screw	3/16"-24 x 7/8"	4
136	EHB916V-136	Carbide Guide		4
137	EHB1018V-137	Collar		2
138	TS-0267021	Set Screw	1/4"x1/4"	2
139	EHB916V-139	Wire Brush		1
140	EHB1018V-140	Bracket		1
141	TS-0207021	Socket Head Cap Screw	1/4"-20 x 5/8"	2
142	TS-0680021	Flat Washer	1/4" x 19 x 2.0	2
144	EHB916V-144	Guide, Right		1
	EHB916V-144-1	Guide, Left		1
145	TS-0561021	Hex Nut	5/16"-18T	2
146	TS-0680041	Flat Washer	3/8"	4
147	BB6200ZZ	Bearing	6200 ZZ	1
148	EHB916V-148	Special Screw	M10 x 30	1
149	BB6200ZZ	Bearing	6200 ZZ	2
150	EHB916V-150	Special Screw		1
151	EHB916V-151	Special Screw		1
153	EHB916V-153	Adjustable Handle		1



Index No.	Part No.	Description	Size	Qty.
154	EHB916V-154	Guide Cover		1
154-1	EHB916V-154-1	Screw	3/16" x 3/8"	2
154-2	TS-0680011	Washer		2
155	EHB1018V-155	Bracket-L.H.		4
156	EHB916V-156	Bladecover		1
156-1	EHB916V-156-1	Screw		2
156-2	TS-0680011	Washer		2
157	EHB916V-157	Blade cover		1
158	EHB916V-158	Special Knob		2
159	TS-0680041	Flat Washer	3/8"	1
160	TS-0060031	Hex Head Screw	3/8 x 16 x 3/4"	3
161	EHB1018V-161	Bracket		1
165	EHB916V-165	Round Head Screw	3/16 x 3/8"	4
166	EHB916V-166	Cover L.H.		1
167	EHB916V-167	Handle		2
168	TS-081F051	Phillips Screw	1/4"-20 x 3/4"	4
169	891097	Blade	1 "x0.035"x 144" (4/6T)	1

ELECTRICAL BOX ASSEMBLY — EHB 1018VM

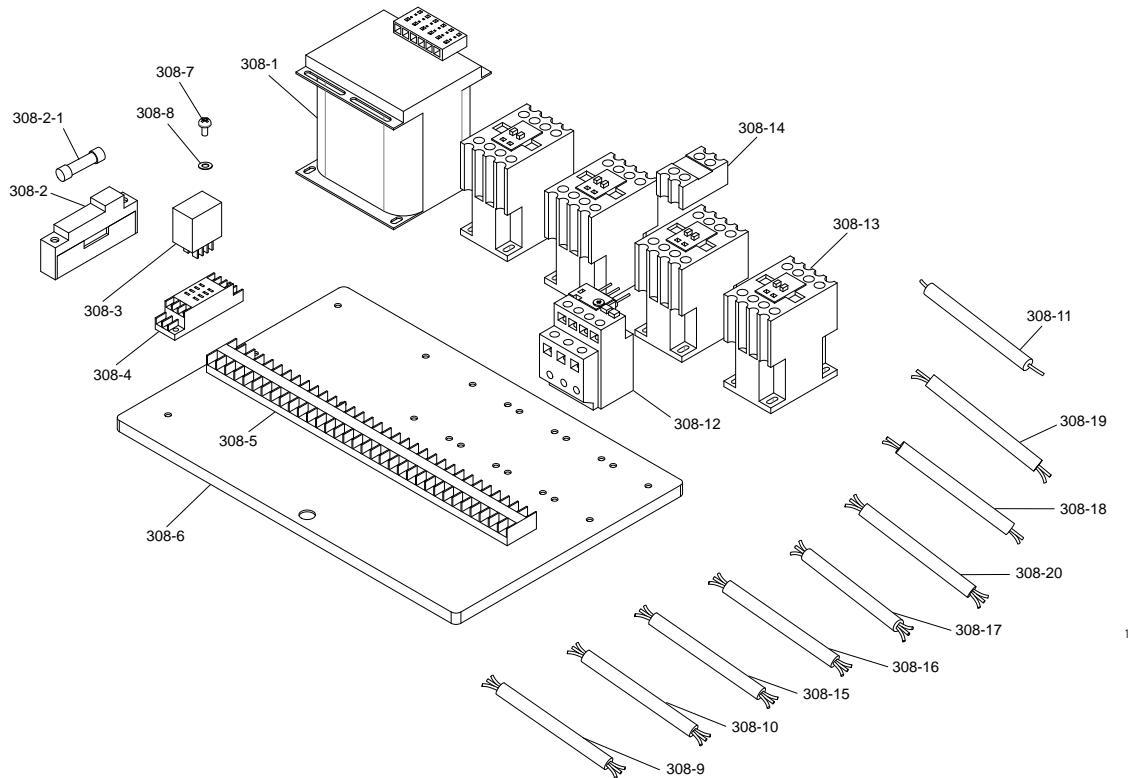


PARTS LIST ELECTRICAL BOX — EHB 1018VM

Index No.	Part No.	Description	Size	Qty.
308-1	EHB1018VM-308-1	Transformer	230/460/12/24/110V	1
308-2	EHB1018VM-308-2	Fuse Blocks	32A 600V	1
308-2-1	EHB1018VM-308-2-1	Fuse (240V)	5A	1
308-2-1	JT9-HB916V-308-2-1	Fuse (460V)	3A	1
308-3	EHB1018VM-308-3	Relay	250V 10A	1
308-4	EHB1018VM-308-4	Relay Socket		1
308-5	EHB1018VM-308-5	Terminal Block		9
308-6	EHB1018VM-308-6	Electrical Plate		1
308-7	EHB1018VM-308-7	Round Head Screw	3/16" x 3/8"	54
308-8	TS-0680011	Washer	3/16"	54
308-9	EHB1018VM-308-9	Power Cable		1
308-10	EHB1018VM-308-10	Control Wire		1
308-11	EHB1018VM-308-11	Ground Cable	Yellow/Green	1
308-12	EHB1018VM-308-12	Overload Relay (4.5-6.5A) (240V)	RHU-10K1	1
308-12	1018VM-308-12	Overload Relay (2.9-4A) (460V)	RHU-10/4K1	1
308-13	EHB1018VM-308-13	Magnetic Contactor	CU-11 110V	3
308-15	EHB1018VM-308-15	Motor Cable		1
308-16	EHB1018VM-308-16	Pump Cable		1
308-17	EHB1018VM-308-17	Hydraulic Cable		1
308-18	EHB1018VM-308-18	Limit Switch Cable		1
308-19	EHB1018VM-308-19	Limit Switch Cable		1



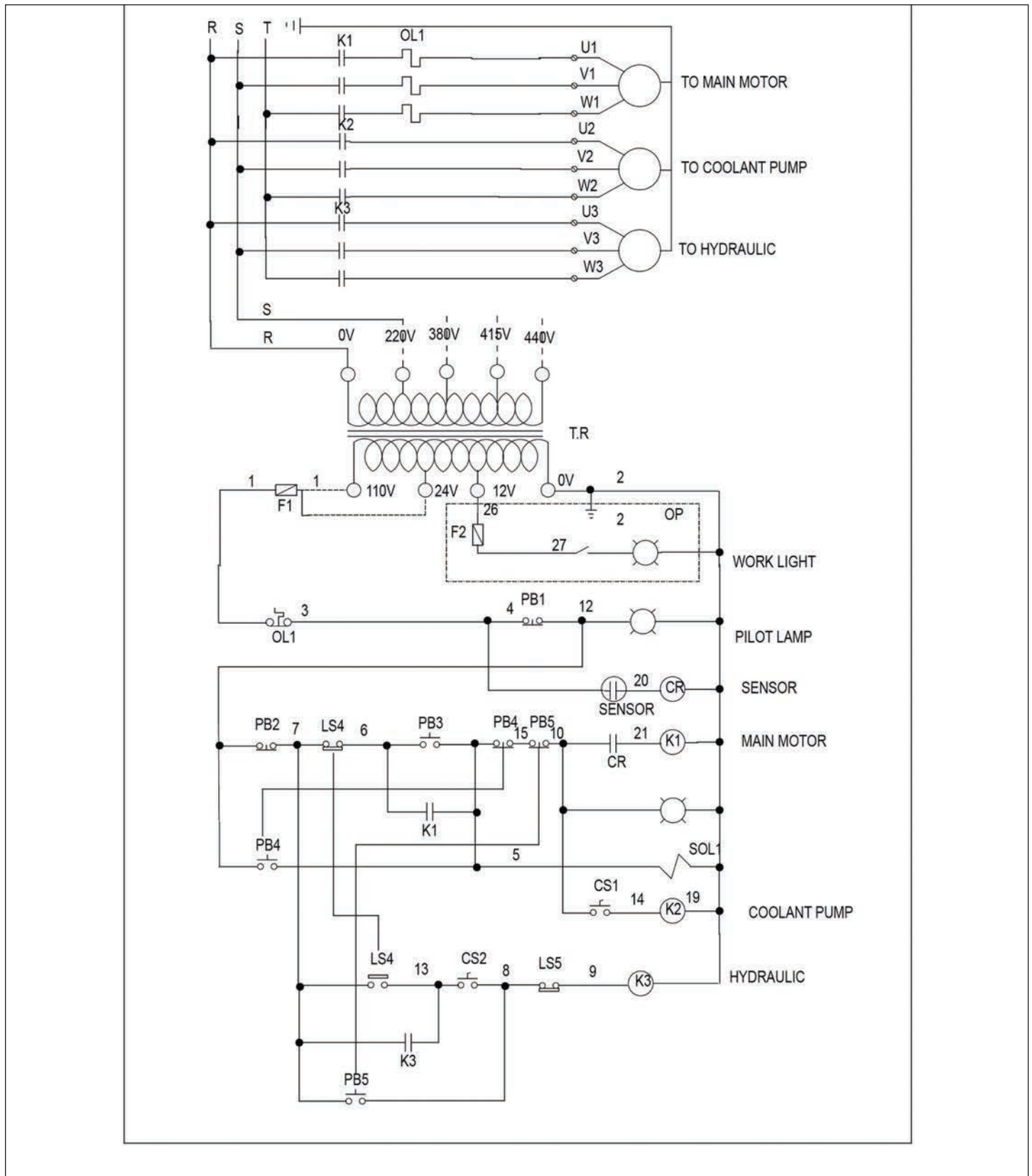
ELECTRICAL BOX ASSEMBLY — EHB 1018VMH



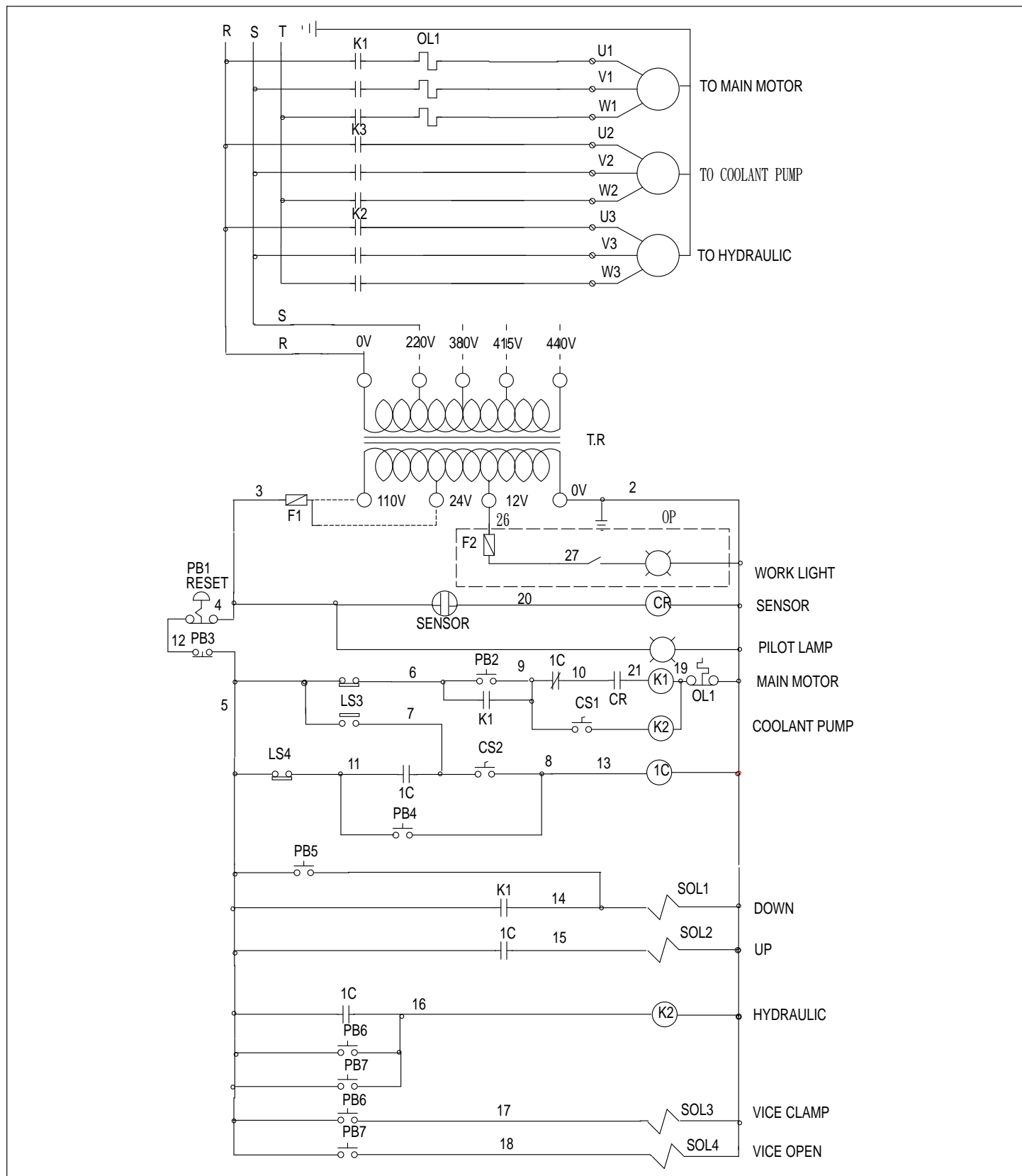
PARTS LIST ELECTRICAL BOX — EHB 1018VMH

Index No.	Part No.	Description	Size	Qty.
308-1	EHB1018VM-308-1	Transformer	230/460/12/24/110V	1
308-2	EHB1018VM-308-2	Fuse Blocks	32A 600V	1
308-2-1	EHB1018VM-308-2-1	Fuse (240V)	5A	1
308-2-1	JT9-HB916V-308-2-1	Fuse (460V)	3A	1
308-3	EHB1018VM-308-3	Relay	250V 10A	1
308-4	EHB1018VM-308-4	Relay Socket		1
308-5	EHB1018VM-308-5	Terminal Block		11
308-6	EHB1018VMH-308-6	Electrical Plate		1
308-7	EHB1018VM-308-7	Round Head Screw	3/16" x 3/8"	62
308-8	TS-0680011	Washer	3/16"	62
308-9	EHB1018VM-308-9	Power Cable		1
308-10	EHB1018VM-308-10	Control Wire		1
308-11	EHB1018VM-308-11	Ground Cable	Yellow/Green	1
308-12	EHB1018VM-308-12	Overload Relay (4.5-6.5A) (240V)	RHU-10K1	1
308-12	1018VM-308-12	Overload Relay (2.9-4A) (460V)	RHU-10/4K1	1
308-13	EHB1018VM-308-13	Magnetic Contactor	CU-11 110V	4
308-14	EHB1018VMH-308-14	Terminal		1
308-15	EHB1018VM-308-15	Motor Cable		1
308-16	EHB1018VM-308-16	Pump Cable		1
308-17	EHB1018VM-308-17	Hydraulic Cable		1
308-18	EHB1018VM-308-18	Limit Switch Cable		1
308-19	EHB1018VM-308-19	Limit Switch Cable		1
308-20	EHB1018VM-308-20	Hydraulic Cable		1

16.0 WIRING DIAGRAM — EHB 1018VM



WIRING DIAGRAM — EHB 1018VMH



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