



Operating Instructions and Parts Manual

7" Zip-Miter Bandsaw

Model J-9180



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Warranty and Service

JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

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. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

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.

How State Law Applies

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

Limitations on This Warranty

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.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

| |
|--|
| 90 Days – Parts; Consumable items |
| 1 Year – Motors; Machine Accessories |
| 2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes |
| 5 Year – Woodworking Machinery |
| Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools |

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

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. 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.
15. 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.
16. Provide for adequate space surrounding work area and non-glare, overhead lighting.
17. Keep the floor around the machine clean and free of scrap material, oil and grease.
18. Keep visitors a safe distance from the work area. **Keep children away.**
19. Make your workshop child proof with padlocks, master switches or by removing starter keys.
20. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
21. 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.
22. 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 safer.
23. Use recommended accessories; improper accessories may be hazardous.

24. Maintain tools with care. Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
25. Make sure the work piece is securely clamped in the vise. Never use your hand to hold the work piece.
26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until the blade comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.

⚠ WARNING: This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm, and ethylbenzene which is known to the State of California to cause cancer. For more information go to <http://www.p65warnings.ca.gov>.

⚠ WARNING: Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated lumber

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as dust masks that are specifically designed to filter out microscopic particles. For more information go to <http://www.p65warnings.ca.gov/> and <http://www.p65warnings.ca.gov/wood>.

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 injury or possibly even death.

- - SAVE THESE INSTRUCTIONS - -

Introduction

This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model J-9180 zip-miter bandsaw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide consistent, long-term operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

The JET Model J-9180 bandsaw is designed for medium production cut-off work. Two cutting speeds and a hydraulic feed control allow the efficient cutting of virtually any material.

The Model J-9180 bandsaw is equipped with a coolant system which can greatly extend blade life and speed the cutting of a variety of materials which are best cut with cutting fluids and coolants.

Register your product using the mail-in card provided, or register online:

<http://www.jettools.com/us/en/service-and-support/product-registration/>

Specifications

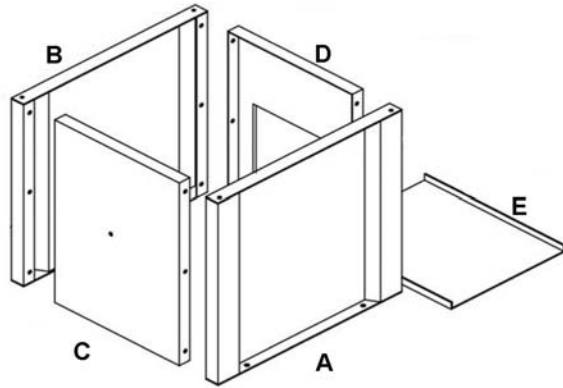
| | |
|--|----------------------------|
| Model..... | J-9180 |
| Stock Number | 414464 |
| Cutting Capacity | |
| Round at 90° (in.) | 7 |
| Round at 45° (in.) | 4-1/2 |
| Round at 60° (in.) | 2-3/4 |
| Rectangle at 90° (in.) | 7-7/8 x 6 |
| Rectangle at 45° (in.) | 4-7/8 x 4-5/16 |
| Rectangle at 60° (in.) | 2-3/4 x 2-3/4 |
| Blade Provided (in.)..... | 3/4" x0 .035 x 82" x 5/8VT |
| Blade Speeds (SFPM) | 157,314 |
| Blade Wheel Diameter (in.) | 10-1/2 |
| Coolant Capacity (qt.) | 10 |
| Bed Height (in.) | 35-7/8 |
| Motor | 1HP, 230V, 3Ph |
| Floor Space Required (L x W x H)(in.)..... | 44 x 22 x 29-1/2 |
| Net Weight (lbs.) | 375 |

The above specifications were current at the time this manual was published, 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.

Shipping Contents

Contents of the Carton

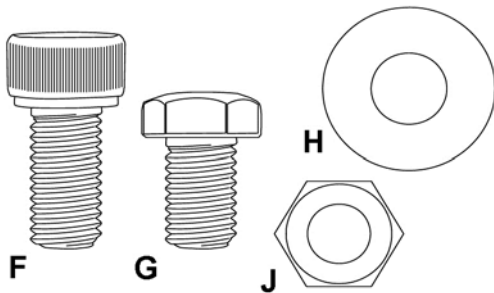
- 1 Band Saw (not shown)
- 1 Front Stand Panel (A)
- 1 Rear Stand Panel (B)
- 1 Left Stand Panel (C)
- 1 Right Stand Panel (D)
- 1 Bottom Plate (E)
- 1 Operating Instructions/Parts List
- 1 Warranty Card



Contents of the Carton

Hardware

- 4 M8 x 25 Socket Head Cap Screw (F)
- 12 M8 x 20 Hex Cap Screw (G)
- 28 M8 Flat Washer (H)
- 24 M8 Hex Nut (J)



Hardware (Actual Size)

Machine Features

Figure 1 depicts the main features of the Model J-9180 Bandsaw. The machine consists of a machine base onto which is installed a saw head.

Machine Base

The machine base consists of four panels that require assembly.

Saw Head

The saw head (Figure 1) consists of a drive motor, gearbox, blade wheels, blade guides and supports, control panel, blade tension mechanism, wire brush, and the saw blade.

The drive wheel is installed on the output shaft of the gearbox. The driven wheel is located on the left side of the machine and is mounted on a shaft that is part of the blade tension mechanism. The blade tension mechanism is used to tighten the saw blade on the blade wheels.

Blade tension generally requires adjustment only after the saw blade is changed, but the tension should be monitored with the convenient blade tension indicator.

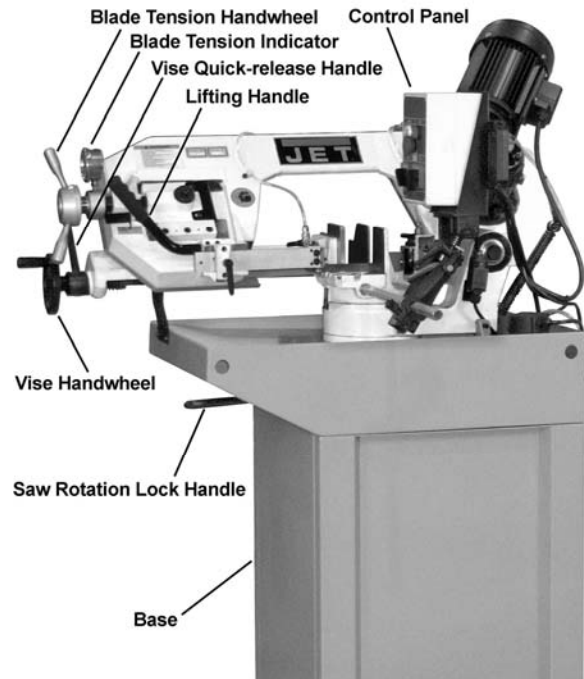


Figure 1

Work Stop

A work stop is provided with the machine to allow cutting multiple pieces of identical length (refer to Figure 5). The stop consists of a set rod onto which is installed a distance set bracket, stop rod assembly and two lock handles. The rod is installed in a bore in the front of the saw bed. The distance set bracket is moved in or out on the set rod to establish the length of the workpiece and the stop rod can be adjusted to accommodate workpieces of various widths.

Control Panel

The control panel is mounted on the top of the saw head. Refer to the *Controls and Indicators* section (page 9) for a description of the controls. Switches and fuses required for operation and protection of the drive motor are inside the box.

Assembly

Stand Assembly

Tools required for assembly:

Two 1/2-inch wrenches (**Note:** A ratchet wrench may speed assembly time.)

Referring to Figure 2:

1. Assemble the rear (D₁) and right side (E₁) panels with three M8 x 20 hex cap screws (A), six M8 flat washers (B₁, B₂) and three M8 hex nuts (C). Tighten the hex nuts.
2. Assemble E₂ and D₂ in the same manner.
3. Position bottom plate (F) in stand.
4. Finish assembling E₂ to D₁ and E₁ to D₂ in the same manner as above.

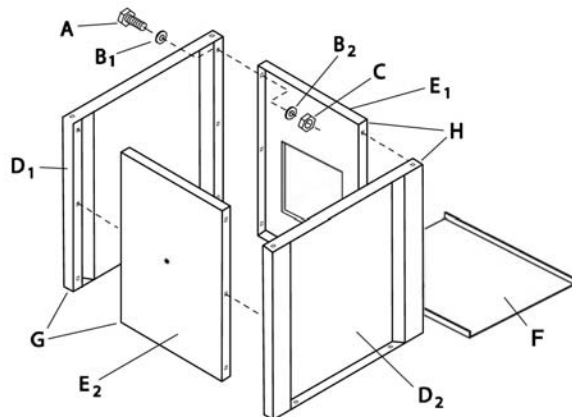


Figure 2

Mounting Saw to Stand

Tools required for assembly:

– 8mm hex wrench

Remove any plastic or holding straps from around the band saw. Areas of the machine have been given a protective coating at the factory. This should be removed using a soft cloth moistened with kerosene or a cleaner-degreaser. Do not use gasoline, paint thinner, or lacquer thinner as these will damage painted surfaces. Do not use an abrasive pad.

Determine the final location for the saw and allow for a sufficient work space around it.

CAUTION The saw is extremely heavy. Use a hoist to lift.

CAUTION When moving the saw/stand top assembly the cutting head, or “bow”, should be in the down position.

Referring to Figure 3:

1. The saw (A) and stand top (B) come as an assembled unit. Use a hoist to lift and place the saw onto the stand (C).

Note that the front of the saw faces the same direction as the indented panel of the stand.

2. Adjust the stand top (B) and stand (C) so the corner mounting holes (D) are aligned.
3. Secure the stand top (B) to the stand (C) with four each M8 hex socket head screws (E) with M8 flat washers (F). Tighten with an 8mm hex wrench.

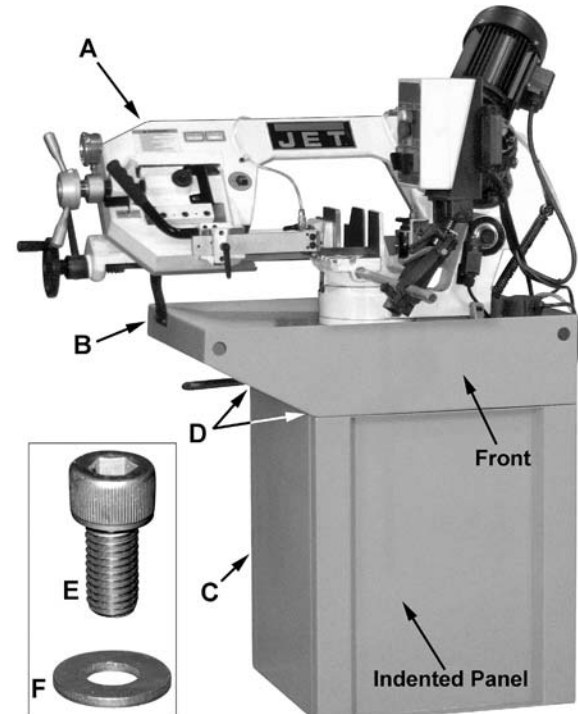


Figure 3

Electrical Connection

WARNING All electrical connections must be done by a qualified electrician. All adjustments or repairs must be done with the machine disconnected from the power source, unplugged. Failure to comply may result in serious injury!

The Model J-9180 bandsaw is rated at 230V.

This machine is not supplied with a plug. Use a plug and outlet rated at least 20amps. The circuit for the machine should also be protected by at least a 20 amp circuit breaker or fuse.

Make sure that the blade moves in the correct direction. If it does not, simply reverse two of the phase wires on the supply input.

The sawing machine is now ready for use.

Controls and Indicators

Control Panel

The operating controls for the bandsaw are located on the *control panel* (Figure 4) and consist of the following controls and indicators:

Emergency Stop Switch – by depressing this switch the user can quickly stop the machine when it is in operation; to restart, turn clockwise slightly to release then press Start switch

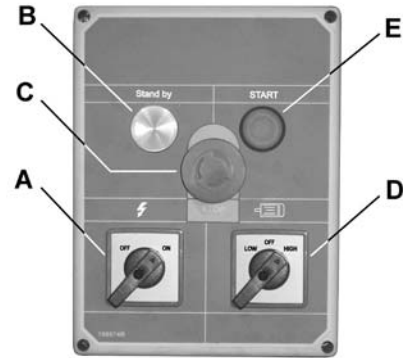
Feed Rate Control – used in conjunction with the Feed Rate Start/Stop Control (see below); this knob is used to set the downward head speed that is applied to the saw blade. The feed rate is proportional to the opening of the valve. When set to zero, the saw head is locked in position. Increasing the valve opening (counter-clockwise adjustment) increases the feed rate; decreasing the valve opening (clockwise adjustment) reduces the feed rate.

Motor Speed Selector – select Low for 137 SFPM, High for 275 SFPM; machine will not operate when Off is selected.

On/Off Switch – main power switch

Standby Lamp Indicator – indicates that power is present, i.e., machine is plugged in and On/Off Switch in set to ON.

Start Switch – press to start machine, also: set On/Off Switch to ON, select Motor Speed Selector to Low or High, Emergency Stop must be released.



- A – On/Off Switch
- B – Standby Lamp Indicator
- C – Emergency Stop Switch
- D – Motor Speed Selector
- E – Start Switch

Figure 4

Feed Rate Control

The Feed Rate Controls (Figure 5) are mounted on the hydraulic cylinder located below the control panel.

With the *Feed Rate Start/Stop* (F) lever in the locked position the saw head is prevented from descending; in the unlocked position the saw head will descend at the rate determined by the *Feed Rate Control* (G) setting.

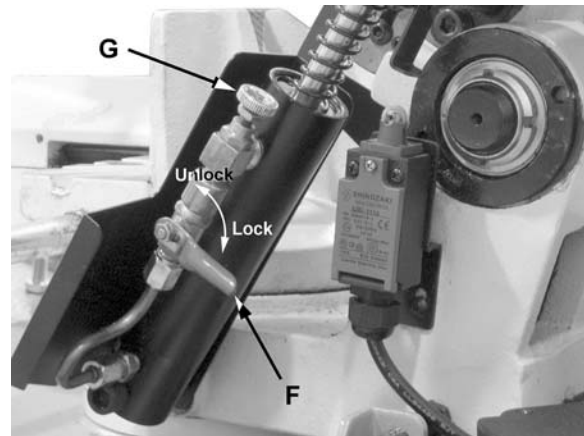


Figure 5

Blade Tension Indicator

The *Blade Tension Indicator* is located on the saw head (see Figure 1) – indicates the blade tension. To set blade tension refer to the *Changing Blades* section on page 15.

Blade Speeds

See *Motor Speed Selector* above.

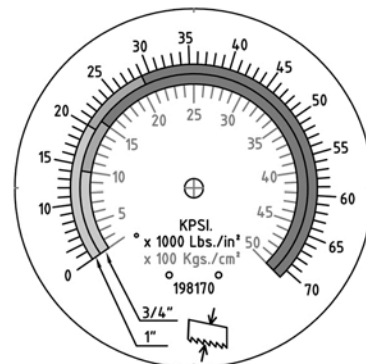


Figure 6

Blade Selection

The cut-off saw is delivered with a saw blade that is adequate for a variety of cut-off jobs on a variety of common materials. A general-purpose blade is provided as standard equipment with the machine. After-market blades can be acquired for specific cutting jobs.

A coarse blade could be used for a solid steel bar, but a finer tooth blade would be used on a thin-wall steel tube. In general, the blade choice is determined by the thickness of the material; the thinner the materials; the finer the tooth pitch.

A minimum of three teeth should be on the workpiece at all times for proper cutting. The blade and workpiece can be damaged if the teeth are so far apart that they straddle the workpiece.

For very high production on cutting of special materials, or to cut hard-to-cut materials such as stainless steel, tool steel, or titanium, call JET, for more specific blade recommendations. JET can provide you with very specific instructions regarding the best blade (and coolant or cutting fluid, if needed) for the material or shape supplied.

Blade Break-in Procedures

New blades are very sharp and, therefore, have a tooth geometry that is easily damaged if a careful break-in procedure is not followed. Consult the blade manufacturer's literature for break-in of specific blades on specific materials. However, the following procedure will be adequate for break-in of JET-supplied blades on lower alloy ferrous materials.

1. Clamp a section of round stock in the vise. The stock should be 2 inches or larger in diameter.
2. Operate the saw at low speed. Start the cut with a very light feed rate.
3. When the saw has completed 1/3 of the cut, increase the feed rate slightly and allow the saw to complete the cut.
4. Keep the hydraulic cylinder needle valve in the same position and begin a second cut on the same or similar workpiece.
5. When the blade has completed about 1/3 of the cut, increase the feed rate.

Watch the chip formation until cutting is at its most efficient rate and allow the saw to complete the cut (refer to *Evaluating Blade Efficiency* below). The blade is now considered ready for use.

Operations

Hydraulic Feed Control

The weight of the saw head provides the force needed to cut through the workpiece. The cut-off saw has a hydraulic cylinder that controls the feed rate of the saw.

The hydraulic feed control circuit consists of a single acting *hydraulic cylinder* and a *feed rate control*. The feed control cylinder resists motion in the downward direction to control the feed rate. The control cylinder offers no resistance when raised upward.

The *feed rate adjustment* (G, Fig. 4) controls the rate at which the saw head is lowered. The control knob (needle valve) controls the rate at which the hydraulic fluid is released from the hydraulic cylinder. When the needle valve is closed, the cylinder is locked. With the needle valve slightly open, the cylinder permits slow, or light, downward force. Opening the needle valve further increases the feed rate.

The needle valve is adjusted until the saw is operating efficiently. The efficiency of operation is usually evaluated by observing chip formation. Blade efficiency is further described below.

A *lever* (F, Fig. 5) is used to permit or stop the saw head from descending regardless of the *feed rate adjustment* (G, Fig. 5) setting.

Evaluating Cutting Efficiency

Is the blade cutting efficiently? The best way to determine this is to observe the chips formed by the cutting blade.

If the chip formation is powdery, then the feed is much too light or the blade is dull.

If the chips formed are curled, but colored – blue or straw colored from heat generated during the cut – then the feed rate is too high.

If the chips are slightly curled and are not colored by heat – the blade is sufficiently sharp and is cutting at its most efficient rate.

Setting the Work Stop

Referring to Figure 7:

The *work stop* is an accessory that is included with the JET J-9180 Bandsaw. It is used to set up the saw for making multiple cuts of the same length.

CAUTION Do not allow the blade to rest on the workpiece when the saw is not cutting.

Installation

1. Screw the threaded end of the *distance set rod* (A) into the hole at the front of the base (B) as shown.
2. Secure by tightening the *lock nut* (C) with a 22mm hex wrench.

Adjustment

3. The *distance set bracket* (D) is moved along the *distance set rod* (A) by loosening the *lock handle* (H). The *stop rod* (F) can be repositioned (G) by loosening *lock handle* (E) – also by loosening the *lock nut* (C) and rotating the *set rod* (A) to reposition the angle of the *bracket* (D).

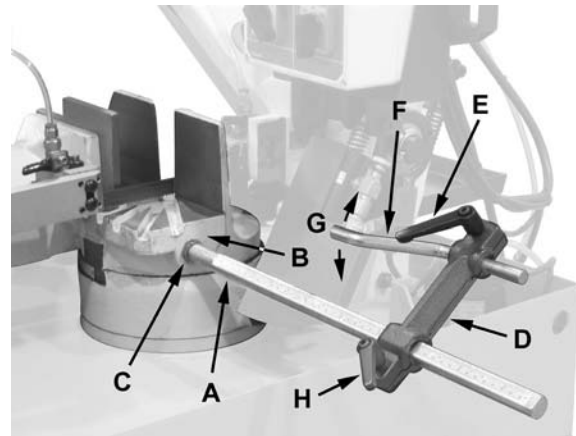


Figure 7

Quick Release Vise Operation

Referring to Figure 8:

The vise on the J-9180 bandsaw comes equipped with a quick-release handle that permits the workpiece to be rapidly repositioned or changed for a repeated cutting operation while requiring only one initial adjustment of the vise handwheel. This is done as follows:

1. Place the *quick-release handle* (A) in the up position as shown.
2. Turn the *handwheel* (B) counterclockwise until the workpiece can be placed in position.
3. Place the *workpiece* (C) in the *vise* (D) and against the *work stop* (E); turn the *handwheel* (B) until the vise begins to clamp onto the workpiece. Then back the handwheel off just enough to permit the workpiece to slide in and out of the vise.
4. Place the *quick-release handle* (A) in the down position. The workpiece is secure and ready for cutting.

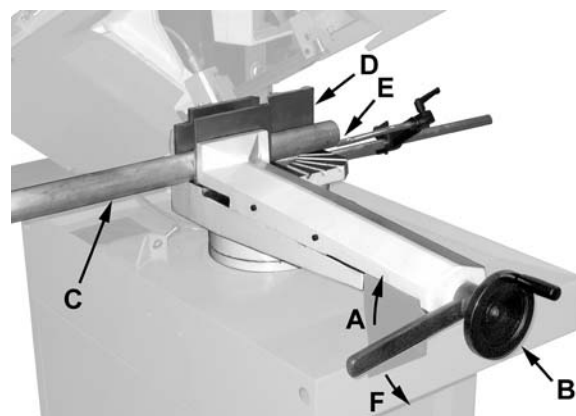


Figure 8

The vise is now set up for a repeated cutting operation. Simply raise the quick-release handle, reposition or replace the workpiece and reset the handle down again.

Miter Cuts

Referring to Figure 9, the J-9180 bandsaw is capable of making angle cuts from 0–60°. The vise remains stationary while the saw head is adjusted as follows:

1. Place the *saw head* (F) in the raised position so the blade doesn't catch in the table slots.
2. Set the *lock handle* (A) to the *unlock* position as indicated by the arrows.
3. Using *handles* (B and C), rotate the *saw head* (F) to any desired angle within a range of 0° (square cut) to 60°, setting it to the *scale* (D) on the base.
4. Set the *lock handle* (A) to the *lock* position.

Note: Two miter stops (E) on either side of the saw base set the miter range of 0–60°. Adjust only if necessary so the saw travel stops at 0° and 60°.

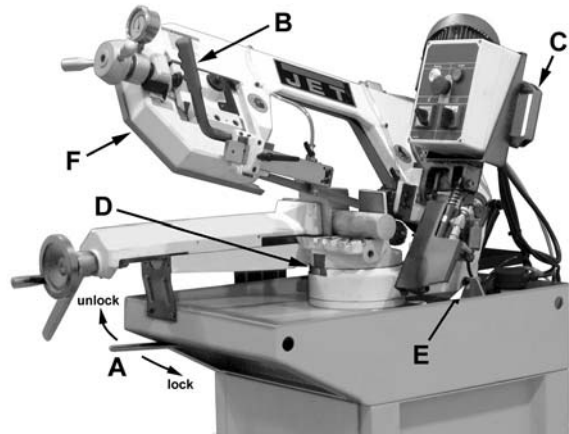


Figure 9

Coolant Flow Control

CAUTION The coolant pump must be submerged before operating to prevent damage to the pump.

A coolant pump, which provides coolant to the workpiece, runs at all times when the machine is turned on.

Two *coolant flow control valves* (A, Fig. 10), located on the top of the bearing blocks, control the amount of flow from the nozzles. Coolant flow should be adjusted to be no more than the saw blade can draw into the workpiece by the movement of the blade. To stop coolant flow, turn the control valves fully counterclockwise.

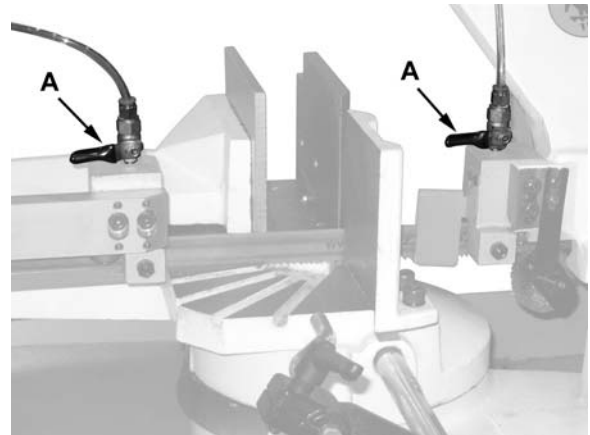


Figure 10

Adjustments

Blade Guide Adjustment

Refer to Figure 11. The J-9180 Bandsaw has two blade guide assemblies; one is stationary (A) and mounted to the body of the saw head. The other, consisting of a *blade guide support* or *bracket* (B) and *blade guide* (C), is adjustable.

The position of the blade guides is important in order to make accurate cuts and prolong blade life and is determined by the size of the workpiece. Adjustment is made as follows:

1. Place the *workpiece* (D) in the *vise* (E) and clamp tightly.
2. Loosen the *lock handle* (F).
3. Slide the *guide support* (B) left or right so that it just clears the piece to be cut (D).
4. Tighten the *lock handle* (F).

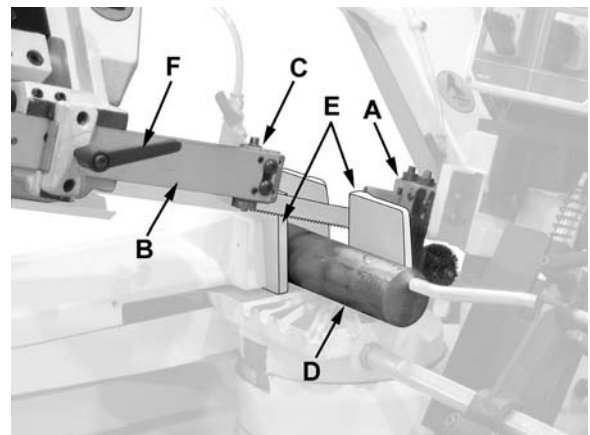


Figure 11

Guide Bearing Adjustment

Referring to Figure 12:

Guide bearings are located on either side of the saw blade and provide stability for the blade when the saw is in operation. These bearings rotate on an eccentric shaft so the distance from the blade can be adjusted for optimal performance.

Guide bearings are initially adjusted at the factory and should rarely require adjustment.

It is always better to try a new blade when cutting performance is poor. If performance remains poor after changing the blade, check the blade guides for proper guide bearing spacing. For most efficient operation and maximum accuracy, clearance between the blade and the guide bearings should be 0.001-inch. The bearings will still turn freely with this clearance. If the clearance is incorrect, the blade may track off the drive wheel.

⚠WARNING Disconnect the bandsaw from its electrical power source.

If required, adjust *guide bearings* on one assembly then the other as follows:

1. Using a 14mm wrench loosen two *lock nuts* (A) that secure the *eccentric bushings* (B) while maintaining the positions of the eccentric bushings with a 6mm wrench.
2. Position the *bearings* (B) by adjusting the *bushings* (C) with the 6mm wrench. Set the clearance between the *bearings* (B) and *blade* (D) at approximately 0.001 inch.

Note: Only the bearing towards the front is mounted on an eccentric bushing. Make adjustments on this bearing.

When properly adjusted, the blade should be in a vertical position between the bearings as shown in Figure 13.

3. While maintaining the new position of the bushings with the 6mm wrench, secure the settings by tightening the *lock nuts* (A).

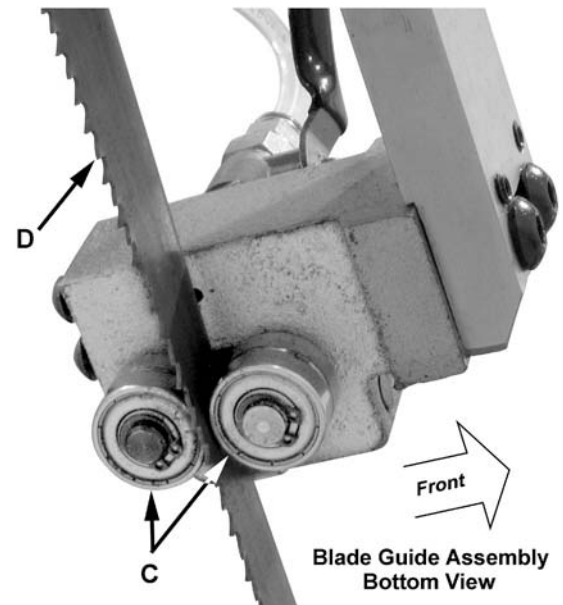
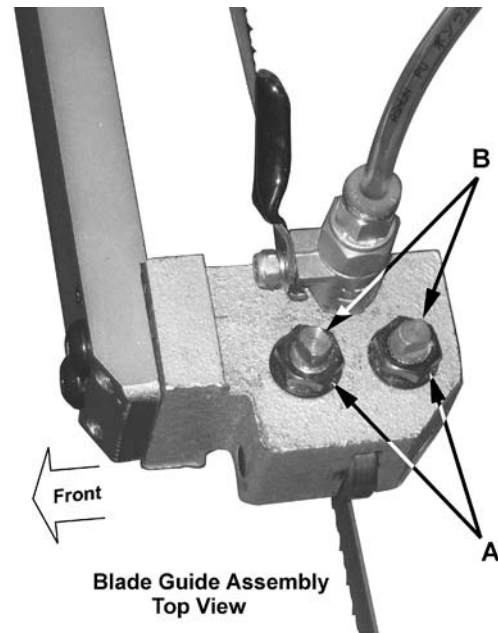


Figure 12

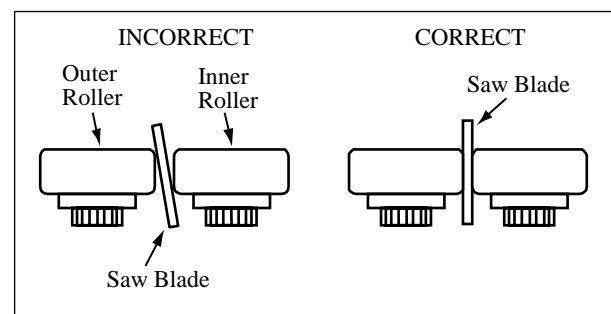


Figure 13

Blade Tension

Blade tension is covered in the *Changing Blades* section on page 15.

Limit Switch Adjustment

Refer to Figure 14.

The J-9180 bandsaw should shut off automatically when a cut is completed. If not, the *limit switch* (A) located below the *control panel* (Figure 1) probably needs to be adjusted as follows:

⚠WARNING Disconnect the cut-off saw from its electrical power source.

1. Place the saw in the lowered position to represent the completion of a cutting operation.

The *microswitch wheel* (E) should be pressed against the *plate* (F) which is attached to the *hydraulic cylinder bracket* (G). If this is not the case, make a note of how much the *switch assembly* (A) should be repositioned upwards.

2. Using a crosspoint screwdriver, remove two screws (C) and the *switch* (A) from its *mounting plate* (B).
3. With a 3mm hex wrench, loosen two screws (D) and reposition the mounting plate (B) as determined in step 1.
4. Tighten the mounting plate screws (D) and reinstall the switch assembly (A).
5. Test to verify that the bandsaw shuts off when a cut is completed. If it does not, repeat above steps.

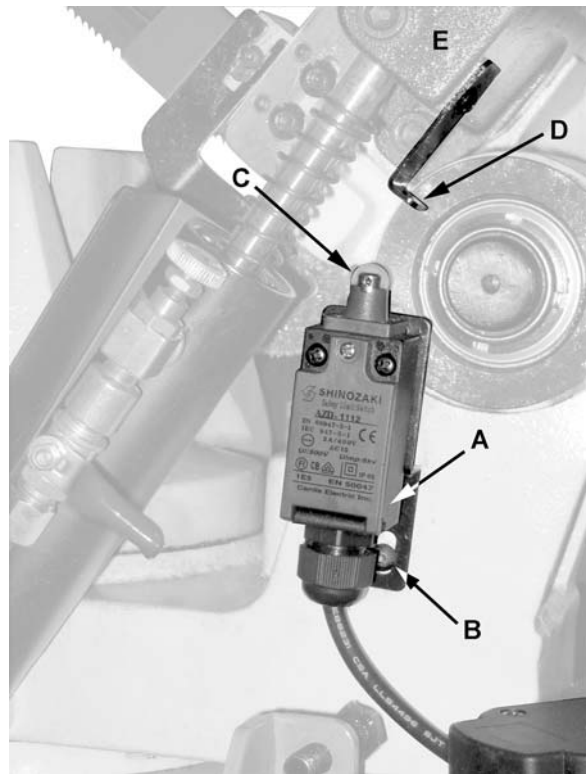


Figure 14

Maintenance

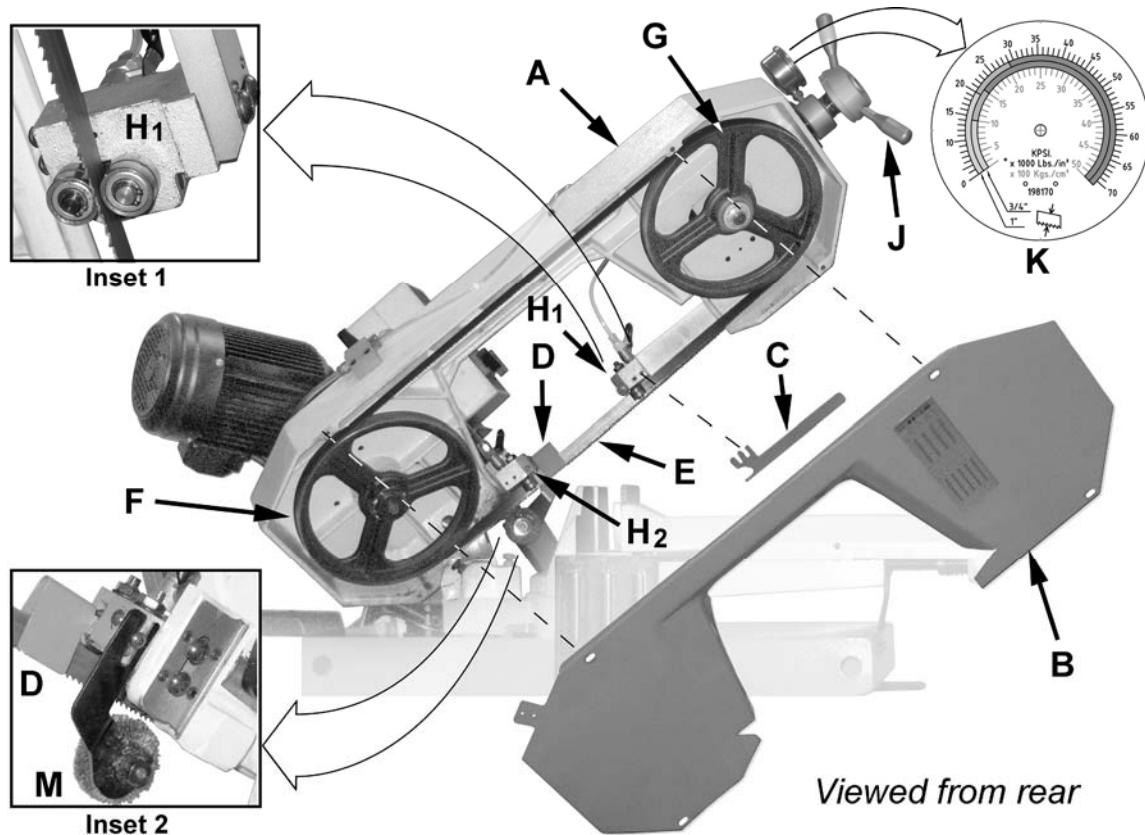


Figure 15

Changing Blades

Refer to Figure 15 except where specified otherwise.

⚠ WARNING Use leather gloves when changing the saw blade to protect your hands from cuts and scratches. Use protective eye wear that meets ANSI Specification Z87.1

⚠ WARNING Disconnect the cut-off saw from its electrical power source.

Tools required:

- 3mm, 4mm and 5mm hex wrenches
- 12mm wrench

Removing the Blade

1. Lock the hydraulic cylinder that controls the descent of the saw head with the *feed rate start/stop control* (F, Fig. 5). Raise the saw head (A) about half way up.
2. Remove the *wheel cover* (B) and *blade guards* (C, D) and brush (Inset 2 - M).
3. Turn the *blade tension handle* (J) counter-clockwise until the *blade* (E) hangs loose.

4. Pull the *blade* (E) off the *drive wheel* (F) and *idler wheel* (G) and out of the *blade guides* (H₁, H₂). Store the removed blade carefully before proceeding.

Installing New Blade

5. Slide the new blade into the *blade guides* (H₁, H₂, Inset 1), then loop the blade (E) around the *drive wheel* (F) and *idler wheel* (G) such that the teeth face towards the rear of the saw and the smooth side faces towards the front.
6. Push the blade so it seats against the shoulders of the *wheels* (F, G).

Adjusting the proper Blade Tension

7. When it is seated against the shoulder, turn the *blade tension handle* (J) clockwise to increase the tension until the scale for the 3/4" blade tension measures 14–21KPSI (green zone) on the tension indicator (K).
8. Replace the *wheel cover* (B) and *blade guards* (C, D) and *brush* (M).
9. Reconnect the saw to the electrical power source.

Cleaning

Clean off any preservative on machine surfaces.

After cleaning:

1. Coat machined surfaces of the cutoff saw with a medium consistency machine oil. Reapply the oil coating at least every six months.
2. Clean up accumulated saw cuttings after use. Make sure the lead screw and rapid nut are kept free from saw cuttings and other material that would cause damage.
3. Clean the chip sludge from the coolant tank. The frequency should be determined by how often the saw is used.

Lubrication

Lubricate the following components at the specified frequencies and using the lubricants defined as follows:

Ball Bearings – the bearings are lubricated and sealed – periodic lubrication is not required.

Blade Guide Bearing – the bearings are lubricated and sealed – periodic lubrication is not required.

Wheel Bushings – six to eight drops of oil each week.

Pivot Points, Shafts, and Bearing areas – six to eight drops of oil each week.

Coolant

Change coolant with a frequency appropriate to the type of coolant being used. Oil based coolants can sour. Refer to the coolant supplier's instructions for change frequency.

The general-purpose coolant is a mixture of water-soluble oil or synthetic based coolant and water. Mix one part of coolant to ten parts of water (one quart of oil to ten quarts water). Ten quarts of coolant is the amount required for the coolant pump to operate properly.

There are numerous coolants on the market that are formulated for special applications. Consult your local distributor for details in the event you have a long range production task, or are required to cut some of the more exotic materials.

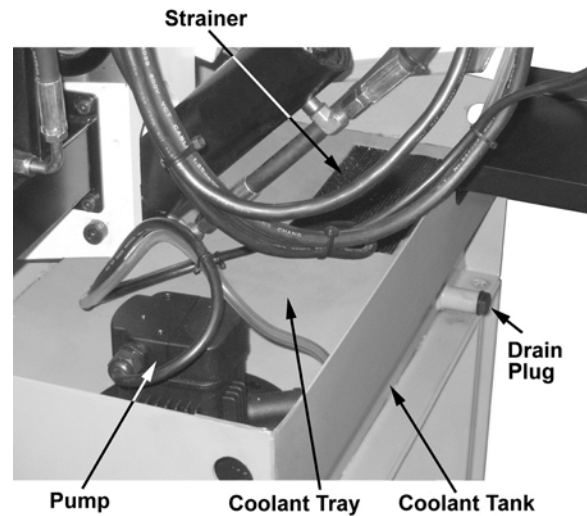


Figure 16

Troubleshooting

| Fault | Probable Cause | Suggested remedy |
|---------------------------------|--|--|
| Excessive blade breakage | <ol style="list-style-type: none"> 1. Material loose in vise. 2. Incorrect speed or feed. 3. Teeth too coarse for material. 4. Incorrect blade tension. 5. Saw blade is in contact with work-piece before the saw is started. 6. Misaligned guides. 7. Cracking at weld. | <ol style="list-style-type: none"> 1. Clamp work securely. 2. Check Machinist's Handbook for speed/feed appropriate for the material being cut. 3. Check Machinist's Handbook for recommended blade type. 4. Adjust blade tension to the point where the blade just does not slip on the wheel. 5. Start the motor before placing the saw on the workpiece. 6. Adjust guides. 7. Longer annealing cycle. |
| Premature blade dulling | <ol style="list-style-type: none"> 1. Blade teeth too coarse. 2. Blade speed too high. 3. Inadequate feed pressure. 4. Hard spots in workpiece or scale on/in workpiece. 5. Work hardening of material (especially stainless steel). 6. Insufficient blade tension. 7. Operating saw without pressure on workpiece. | <ol style="list-style-type: none"> 1. Use a finer tooth blade. 2. Try a lower blade speed. 3. Decrease spring tension. 4. Increase feed pressure (hard spots). Reduce speed, increase feed pressure (Scale). 5. Increase feed pressure by reducing spring tension. 6. Increase tension to proper level. 7. Do not run blade at idle in/on material. |
| Bad cuts (crooked) | <ol style="list-style-type: none"> 1. Workpiece not square with blade. 2. Feed pressure too fast. 3. Guide bearings not adjusted properly. 4. Inadequate blade tension. 5. Span between the two blade guides too wide. 6. Dull blade. 7. Incorrect blade speed. 8. Blade guide assembly is loose. 9. Blade guide bearing assembly loose. 10. Blade track too far away from wheel flanges. 11. Guide bearing worn. | <ol style="list-style-type: none"> 1. Adjust vise so it is square with the blade. (Always clamp the workpiece tightly in the vise.) 2. Decrease pressure. 3. Adjust guide bearing clearance to 0.001 inch (0.002 inch maximum). 4. Gradually increase blade tension. 5. Move blade guide bracket closer to work. 6. Replace blade. 7. Check blade speed. 8. Tighten blade guide assembly. 9. Tighten blade guide bearing assembly. 10. Adjust blade tracking. 11. Replace worn bearing. |

Troubleshooting

| Fault | Probable Cause | Suggested remedy |
|---|---|--|
| Bad cuts (rough) | <ol style="list-style-type: none"> 1. Blade speed too high for feed pressure. 2. Blade is too coarse. | <ol style="list-style-type: none"> 1. Reduce blade speed and feed pressure. 2. Replace with finer blade. |
| Blade is twisting | <ol style="list-style-type: none"> 1. Blade is binding in the cut. 2. Blade tension too high | <ol style="list-style-type: none"> 1. Decrease feed pressure. 2. Decrease tension on Blade |
| Unusual wear on side/back of blade | <ol style="list-style-type: none"> 1. Blade guides worn 2. Blade guide bearings not adjusted. 3. Blade guide bearing bracket is loose. | <ol style="list-style-type: none"> 1. Replace blade guides. 2. Adjust blade guide bearings. 3. Tighten blade guide bearing bracket. |

Parts

Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

Saw Assembly – Parts

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------|--------------------------|--------------------|-----|
| 1 | J-9180-01G | Body Frame | | 1 |
| 2 | J-9180-02G | Anchor Block | | 1 |
| 2A | 9180-02A | Anchor Plate | | 1 |
| 2B | TS-2245102 | Button Head Socket Screw | M5x10 | 2 |
| 3 | 9180-03 | Shaft | | 1 |
| 4 | TS-1504041 | Socket Head Cap Screw | M8x20 | 1 |
| 5 | 9180-05 | Bearing Cover | | 2 |
| 6 | 9180-06 | Tapered Bearing | | 2 |
| 7 | 9180-07 | Washer | | 1 |
| 10-1 | 9180-10-1 | Blade Tension Gauge | | 1 |
| 11 | 9180-11 | Bearing | | 1 |
| 12 | 9180-12 | Handle | | 2 |
| 13 | 9180-13 | Hub | | 1 |
| 14 | 9180-14 | Spring Washer | øID16.3xø31.5x1.8t | 10 |
| 15 | 9180-15 | Lead Screw | | 1 |
| 16 | TS-154010 | Hex Nut | M16 | 1 |
| 17 | TS-1504051 | Socket Head Cap Screw | M8x25 | 3 |
| 18 | 9180-18G | Fixed Block | | 1 |
| 19 | 9180-19 | Pin | ø 5x40 | 2 |
| 20 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 21 | 9180-21 | Fixed Block | | 1 |
| 22 | TS-2248252 | Button Head Socket Screw | M8x25 | 2 |
| 23 | TS-1523051 | Set Screw | M6x16 | 2 |
| 23-1 | TS-1523061 | Set Screw | M6x20 | 6 |
| 24 | 9180-24 | Locking Handle | M8x30 | 1 |
| 25 | 9180-25 | Blade Adjust Bar | | 1 |
| 26 | TS-1524021 | Set Screw | M8x10 | 2 |
| 27 | TS-1503021 | Socket Head Cap Screw | M6x10 | 1 |
| 28 | 9180-28 | Lift Handle | | 1 |
| 29 | 9180-29 | Handle Grip | | 1 |
| 30 | 9180-30 | Fixed Plate | | 1 |
| 36-1 | TS-1505081 | Socket Head Cap Screw | M10x60 | 1 |
| 37 | 9180-37 | Bearing Shaft | | 2 |
| 38 | 9180-38 | Guide Block (Front) | | 1 |
| 39-1 | TS-1551071 | Lock Washer | M10 | 1 |
| 40 | 9180-40 | Hose Clip | ø8 | 3 |
| 41 | TS-1504031 | Socket Head Cap Screw | M8x16 | 3 |
| 43 | 9180-43 | Eccentric Guide | | 2 |
| 44 | BB-608ZZ | Bearing | 608ZZ | 10 |
| 45 | 9180-45 | C-Retainer Ring | ø8 | 4 |
| 46 | 9180-46 | Eccentric Guide | | 2 |
| 47 | TS-2245122 | Button Head Socket Screw | M5x12 | 2 |
| 48 | J-9180-48 | Blade Guard (Front) | | 1 |
| 50 | TS-1550031 | Flat Washer | M5 | 2 |
| 51 | 9180-51 | Hex Nut | M10xP1 | 4 |
| 52 | TS-2361101 | Lock Washer | M10 | 4 |
| 53 | J-9180-53 | Deflector Plate | | 1 |
| 54 | 9180-54 | Guide Block (Rear) | | 1 |
| 56 | 9180-56 | Button Head Socket Screw | M8x35 | 2 |
| 58S | 9180-58S | Brush Assembly | | 1 |
| 58-1 | 9180-58-1 | Brush Support | | 1 |
| 58-2 | 9180-58-2 | Brush | | 1 |
| 58-3 | TS-1482061 | Hex Cap Screw | M6x30 | 1 |
| 58-4 | 9180-58-4 | Washer | ø6.5xø18xT1.5mm | 1 |
| 58-6 | TS-1540041 | Hex Nut | M6 | 1 |

Saw Assembly – Parts

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------|--------------------------|---------------------|-----|
| 61 | 9180-61 | Cover | | 1 |
| 62 | TS-2248162 | Button Head Socket Screw | M8x16 | 2 |
| 64 | TS-1524041 | Set Screw | M8x16 | 1 |
| 65 | 9180-65 | Frame Pivot Shaft | | 1 |
| 67 | 9180-67 | Tapered Bearing | | 2 |
| 69 | 9180-69 | Cover | | 2 |
| 70 | 9180-70 | Washer | | 2 |
| 71 | 9180-71 | Motor | 1HP, 3Ph, 230V | 1 |
| 72 | TS-1482051 | Hex Cap Screw | M6x25 | 4 |
| 73 | TS-2361061 | Lock Washer | M6 | 4 |
| 74GA | 9180-74GA | Gear Box | 3Ph, 1:28 | 1 |
| 75 | TS-1551071 | Lock Washer | M10 | 4 |
| 76 | TS-1505031 | Socket Head Cap Screw | M10x25 | 4 |
| 77 | 9180-77 | Hose | ø6x750L | 1 |
| 78 | 9180-78 | Hose Fitting | ø8x1/4"PT | 1 |
| 79 | TS-1503041 | Socket Head Cap Screw | M6x16 | 2 |
| 80 | 9180-80 | Coolant Block | | 1 |
| 81 | 9180-81 | Hose | ø6x240L | 1 |
| 82 | 9180-82 | Valve | 1/8" | 2 |
| 83 | 9180-83 | Hose Fitting | ø6x1/8"PT | 4 |
| 84 | 9180-84 | Bushing | | 1 |
| 85 | TS-1505031 | Socket Head Cap Screw | M10x25 | 1 |
| 86 | 9180-86 | Washer | | 1 |
| 87 | 9180-87 | Round Head Key | 8x7x50 | 1 |
| 88 | 9180-88 | Output Shaft | | 1 |
| 89 | 9180-89 | Round Head Key | 7x7x30 | 1 |
| 90 | 9180-90 | Bearing | | 1 |
| 91 | 9180-91 | Spring | | 1 |
| 92 | 9180-92 | Spring | | 1 |
| 96 | 9180-96 | Idler Wheel | | 1 |
| 99 | 9180-99 | Nut | M20xP1 | 1 |
| 100 | | Blade (local purchase) | 3/4"x.035x82"x5/8VT | 1 |
| 101 | 9180-101 | Drive Wheel | | 1 |
| 102 | 9180-102 | Drive Shaft Washer | | 1 |
| 103 | TS-1491031 | Hex Cap Screw | M10x25 | 1 |
| 104 | 9180-104 | Frame Back Cover | | 1 |
| 105 | TS-1503041 | Socket Head Cap Screw | M6x16 | 4 |
| 106 | TS-1550041 | Flat Washer | M6 | 4 |
| 111 | TS-2245162 | Button Head Socket Screw | M5x16 | 2 |
| 112 | TS-1550031 | Flat Washer | M5 | 2 |
| 113 | TS-1550031 | Flat Washer | M5 | 1 |
| 114 | TS-2245122 | Button Head Socket Screw | M5x12 | 1 |
| 161 | 9180-161 | Scale | | 1 |
| 162 | 9180-162 | Rivet | ø2X6 | 2 |
| 165S | 9180-165 | Stock Stop Assembly | | 1 |
| 165-1 | 9180-165-1 | Stop Block | | 1 |
| 165-2 | TS-1550061 | Flat Washer | M8 | 2 |
| 165-3 | 9180-165-3 | Locking Handle | | 2 |
| 165-4 | 9180-165-4 | Stock Stop Rod | | 1 |
| 165-5 | 9180-165-5 | Distance Set Rod | | 1 |
| 165-6 | TS-2310142 | Hex Nut | M14xP1.5 | 1 |
| 165-7 | 9180-165-7 | Scale | | 1 |
| 165-8 | 9180-165-8 | Rivet | ø2 | 4 |
| 170 | 9180-170 | Hand Wheel | | 1 |
| 171 | 9180-171 | Pin | ø5x35 | 1 |

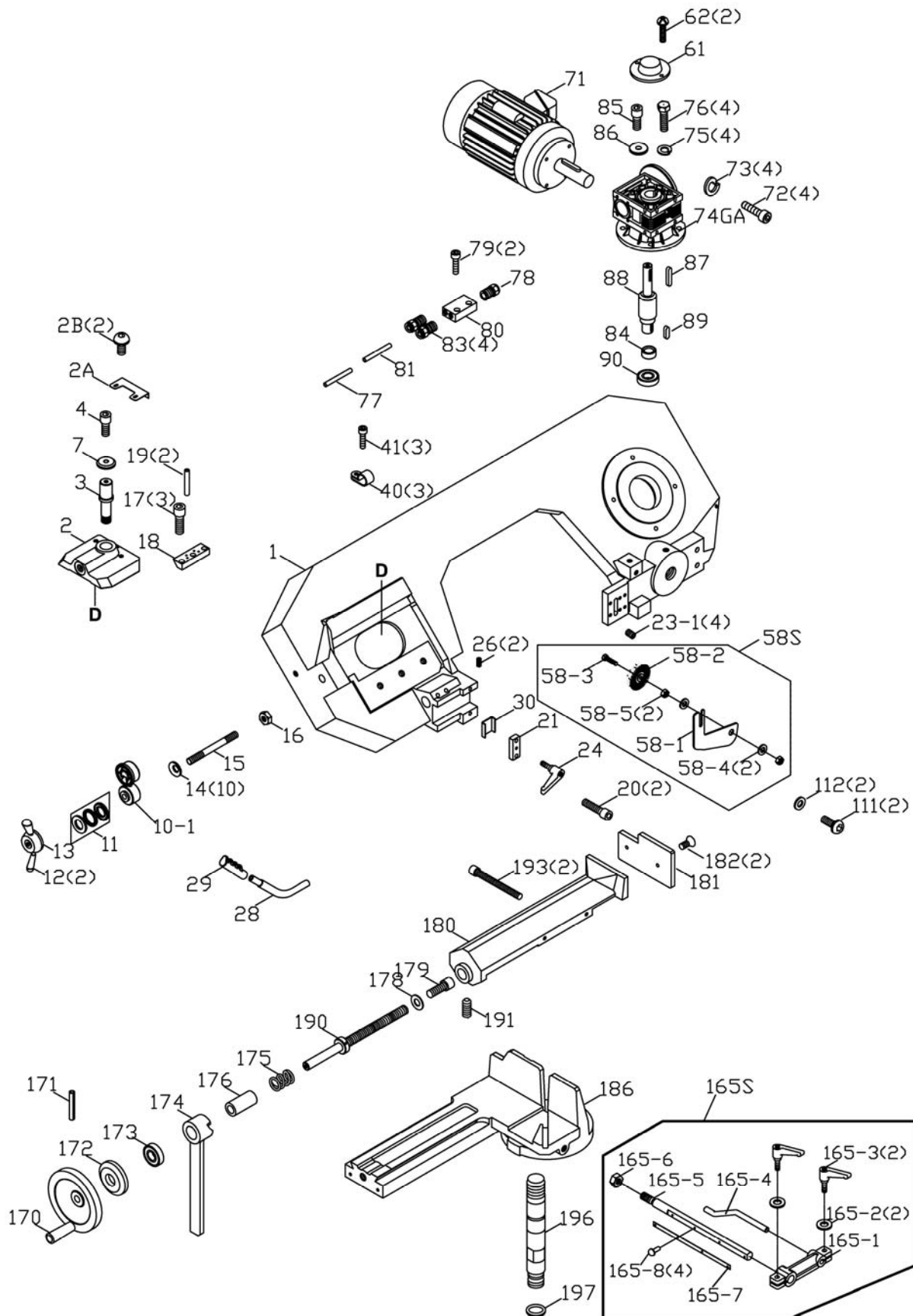
Saw Assembly – Parts

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|--|-------------|-----|
| 172 | 9180-172 | Bearing Cover | | 1 |
| 173 | 9180-173 | Bearing | ø30xø47x3.5 | 1 |
| 174 | 9180-174 | Vise Handle | | 1 |
| 175 | 9180-175 | Spring | | 1 |
| 176 | 9180-176 | Bushing | | 1 |
| 178 | 9180-178 | Washer | | 1 |
| 179 | TS-1503041 | Socket Head Cap Screw | M6x16 | 1 |
| 180 | J-9180-180G | Front Moveable Vise Jaw | | 1 |
| 181 | 9180-181 | Vise Jaw Insert | | 1 |
| 182 | TS-1514011 | Flat Head Socket Screw | M6x12 | 2 |
| 186 | J-9180-186G | Rear Stationary Vise Jaw | | 1 |
| 190 | 9180-190 | Lead Screw | | 1 |
| 191 | TS-1524051 | Set Screw | M8x20 | 1 |
| 193 | TS-2236911 | Socket Head Cap Screw | M6x100 | 2 |
| 194 | J-9180-194G | Swivel Arm | | 1 |
| 195 | TS-1540071 | Hex Nut | M10 | 2 |
| 196 | 9180-196 | Vise Swivel Rod | | 1 |
| 197 | 9180-197 | O-Retainer Ring | ø19.8xø2.4 | 1 |
| 198 | TS-2210451 | Hex Cap Screw | M10x45 | 2 |
| 200 | 9180-200 | Bushing | | 1 |
| 201 | 9180-201 | Nut | | 1 |
| 202 | 9180-202 | Spring Eye Bolt | | 1 |
| 202-1 | TS-1540071 | Hex Nut | M10 | 1 |
| 203 | 9180-203 | Cylinder Assembly | | 1 |
| 204 | TS-2360121 | Flat Washer | M12 | 2 |
| 205 | TS-1506131 | Socket Head Cap Screw | M12x80 | 1 |
| 207 | TS-1523051 | Set Screw | M6x16 | 2 |
| 208 | TS-1540081 | Hex Nut | M12 | 1 |
| 210 | 9180-210 | Cylinder Cover | | 1 |
| 214 | 9180-214 | Control Box Label | | 1 |
| 215 | | Electrical Control Box Assembly (Reference Only) | | 1 |
| 216 | 9180-216 | Hex Socket Plug | 3/8"PT | 1 |
| 216-1 | 9180-216-1 | Washer | | 1 |
| 218 | 9180-218 | O-Retainer Ring | ID170x5.7W | 1 |
| 219 | TS-1551071 | Lock Washer | M10 | 6 |
| 220 | TS-1505021 | Socket Head Cap Screw | M10x20 | 6 |
| 221 | J-9180-221G | Stand Top | | 1 |
| 221-1 | 9180-221-1G | Swivel Arm Base | | 1 |
| 222 | 9180-222 | Screen | | 1 |
| 223 | TS-2284082 | Pan Head Screw | M4x8 | 2 |
| 224 | 9180-224 | Stop Bolt | M10x50 | 1 |
| 224-1 | 9180-224-1 | Stop Bolt | M10x100 | 1 |
| 225 | TS-1540071 | Hex Nut | M10 | 2 |
| 227 | TS-1491031 | Hex Cap Screw | M10x25 | 2 |
| 228 | TS-2361101 | Lock Washer | M10 | 2 |
| 229 | 9180-229 | Fixed Plate | | 1 |
| 230 | TS-2246102 | Button Head Socket Screw | M6x10 | 2 |
| 231 | TS-1505051 | Socket Head Cap Screw | M10x35 | 1 |
| 232 | 9180-232 | Nut | | 1 |
| 233 | 9180-233 | Swivel Lock Handle | | 1 |
| 234 | TS-1550071 | Flat Washer | M10 | 4 |
| 235 | TS-1505021 | Socket Head Cap Screw | M10x20 | 4 |
| 240 | 9180-240 | Pump | 1/8HP | 1 |
| 241 | TS-1534052 | Pan Head Screw | M6x16 | 2 |
| 242 | TS-2361061 | Lock Washer | M6 | 2 |
| 243 | 9180-243 | Elbow | 3/8"X3/8" | 1 |
| 245 | 9180-245 | Hose | ø8x1300L | 1 |

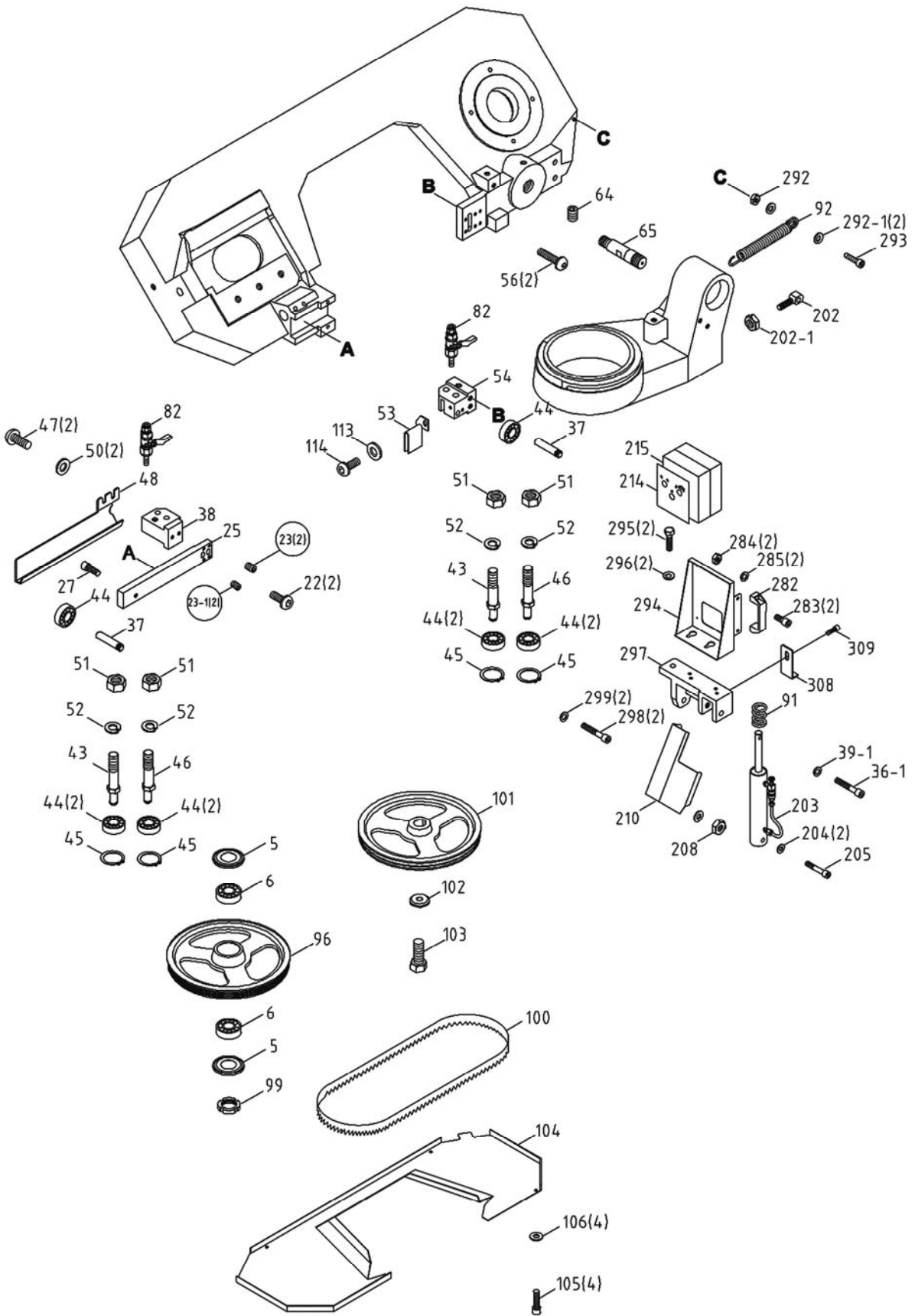
Saw Assembly – Parts

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|---|-------------|---------|
| 241 | TS-1534052 | Pan Head Screw | M6x16 | 2 |
| 242 | TS-2361061 | Lock Washer | M6 | 2 |
| 243 | 9180-243 | Elbow | 3/8"X3/8" | 1 |
| 245 | 9180-245 | Hose | ø8x1300L | 1 |
| 248 | 9180-248 | Tray | | 1 |
| 249 | 9180-249 | Feed Support | | 1 |
| | J-9180-250AG | Stand Panel Set (Index #250-1 thru 250-5) | | 1 |
| 250-1 | J-9180-250-1G | Rear Stand Panel | | 1 |
| 250-2 | J-9180-250-2G | Right Stand Panel with door | | 1 |
| 250-3 | J-9180-250-3G | Front Stand Panel with JET logo | | 1 |
| 250-4 | J-9180-250-4G | Left Stand Panel with hook | | 1 |
| 250-5 | J-9180-250-5G | Bottom Plate | | 1 |
| 253 | TS-1490031 | Hex Cap Screw | M8x20 | 12 |
| 254 | TS-1550061 | Flat Washer | M8 | 24 |
| 255 | TS-1540061 | Hex Nut | M8 | 12 |
| | 9225-256 | Hook Assembly (includes #256-1 thru #256-3) | | 1 |
| 256-1 | 9225-193 | Socket Head Cap Screw | M6x110L | 1 |
| 256-2 | TS-1541021 | Nylon Lock Hex Nut | M6 | 2 |
| 256-3 | TS-1550041 | Washer | M6 | 2 |
| 258 | 9180-258 | Bracket | | 1 |
| 259 | TS-1550031 | Flat Washer | M5 | 2 |
| 260 | TS-1502021 | Socket Head Cap Screw | M5x10 | 2 |
| 282 | 9180-282 | Handle | | 1 |
| 283 | TS-1504031 | Socket Head Cap Screw | M8x16 | 2 |
| 284 | TS-1540061 | Hex Nut | M8 | 2 |
| 285 | TS-2361081 | Lock Washer | M8 | 2 |
| 292 | TS-1540071 | Hex Nut | M10 | 1 |
| 292-1 | TS-2360121 | Flat Washer | M10 | 2 |
| 293 | TS-1505061 | Socket Head Cap Screw | M10x40 | 1 |
| 294 | 9180-294 | Control Box Base | | 1 |
| 295 | TS-1490031 | Hex Cap Screw | M8x20 | 2 |
| 296 | TS-1550061 | Flat Washer | M8 | 2 |
| 297 | 9180-297 | Cylinder Bracket | | 1 |
| 304 | TS-1503041 | Socket Head Cap Screw | M6x16 | 2 |
| 305 | TS-1551041 | Lock Washer | M6 | 2 |
| 306 | TS-1550041 | Flat Washer | M6 | 2 |
| 307 | TS-1540041 | Hex Nut | M6 | 2 |
| 308 | 9180-308 | Plate | | 1 |
| 309 | TS-1502021 | Socket Head Cap Screw | M5x10 | 1 |
| | JETLOGO-1 | JET Logo Plate (not shown) | 2-3/4" x 8" | 1 |
| | STRIPE-1-3/4 | Stripe (not shown) | 1-3/4"W | per ft. |

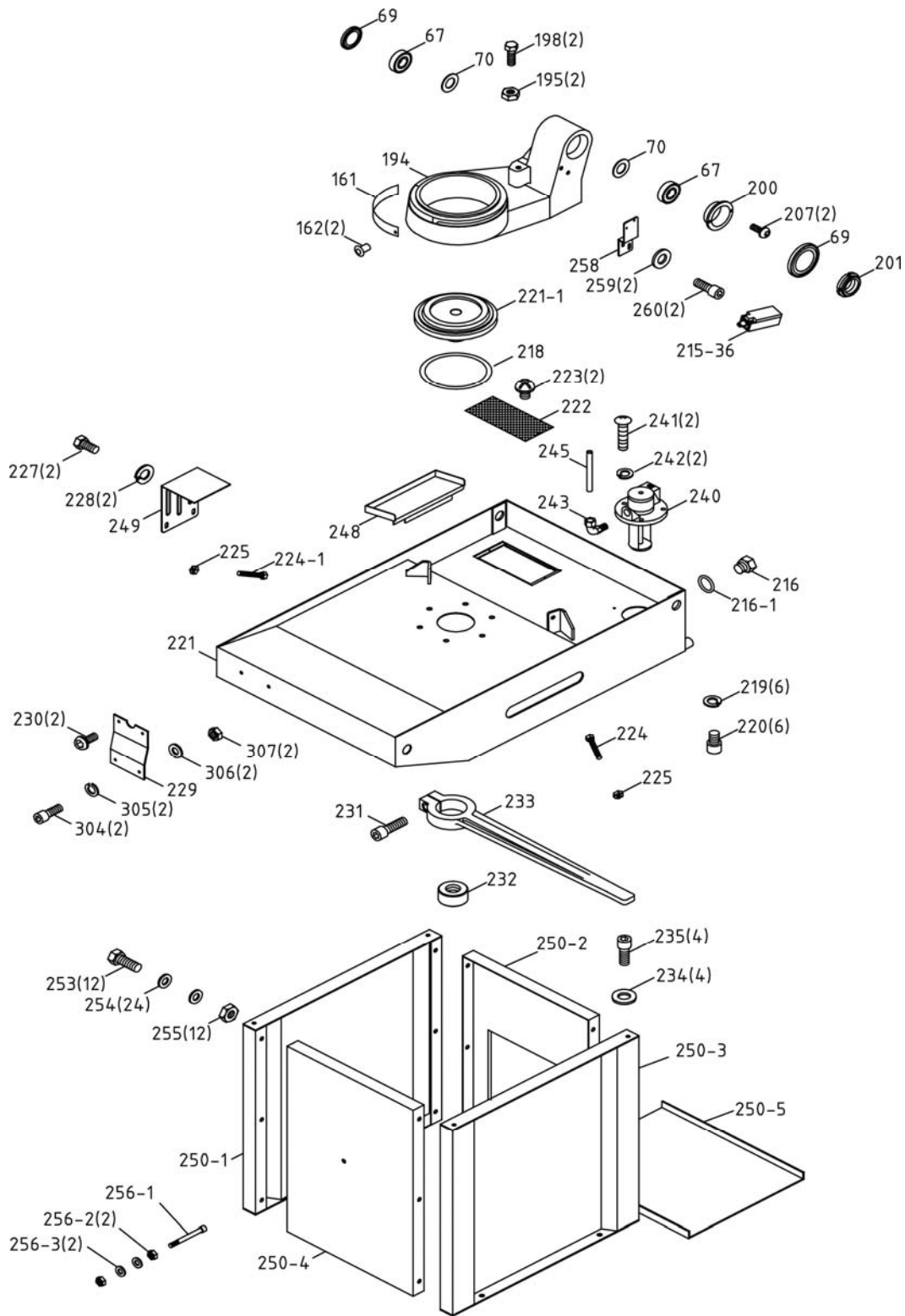
Saw Assembly Drawing (1 of 3)



Saw Assembly Drawing (2 of 3)



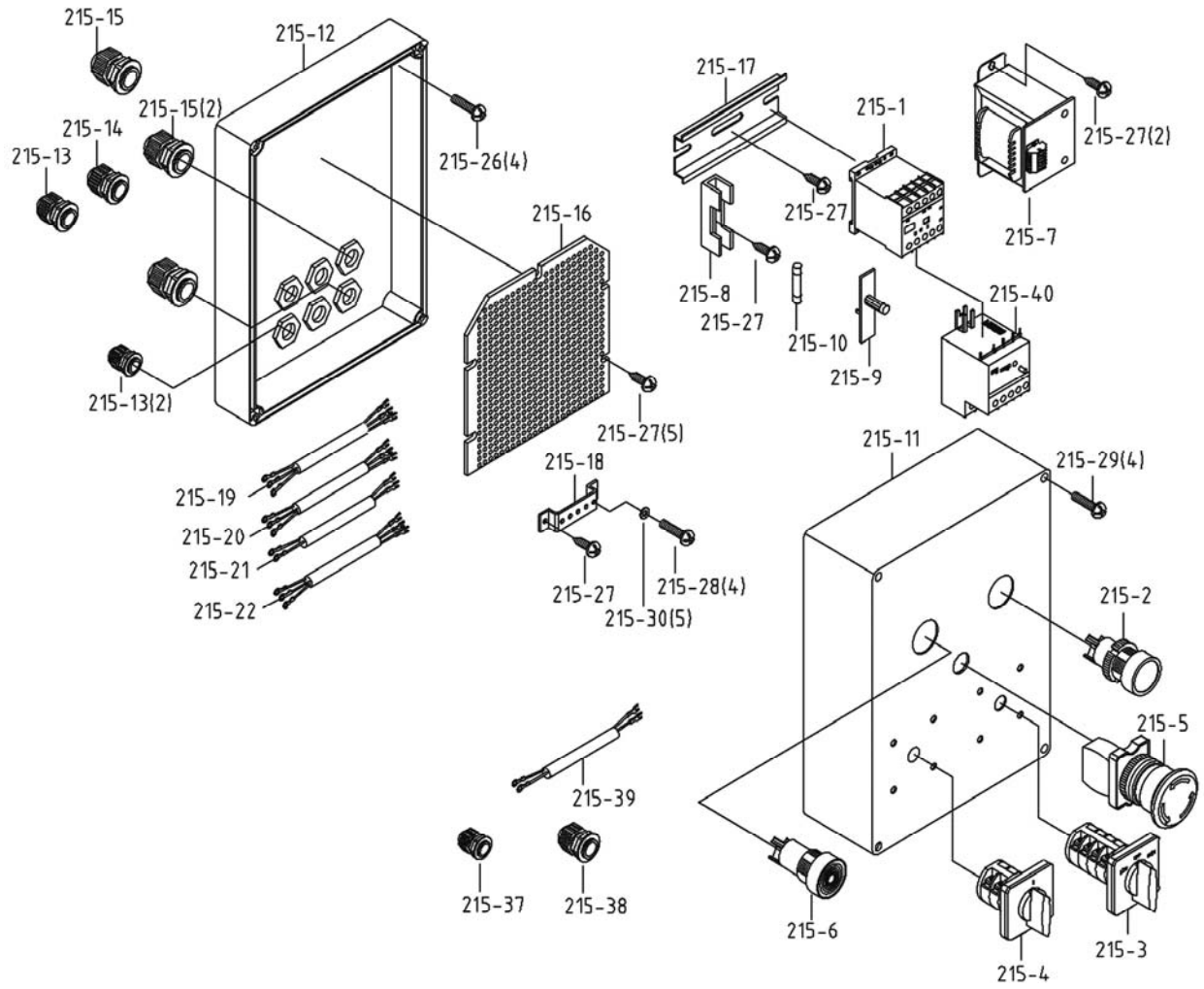
Saw Assembly Drawing (3 of 3)



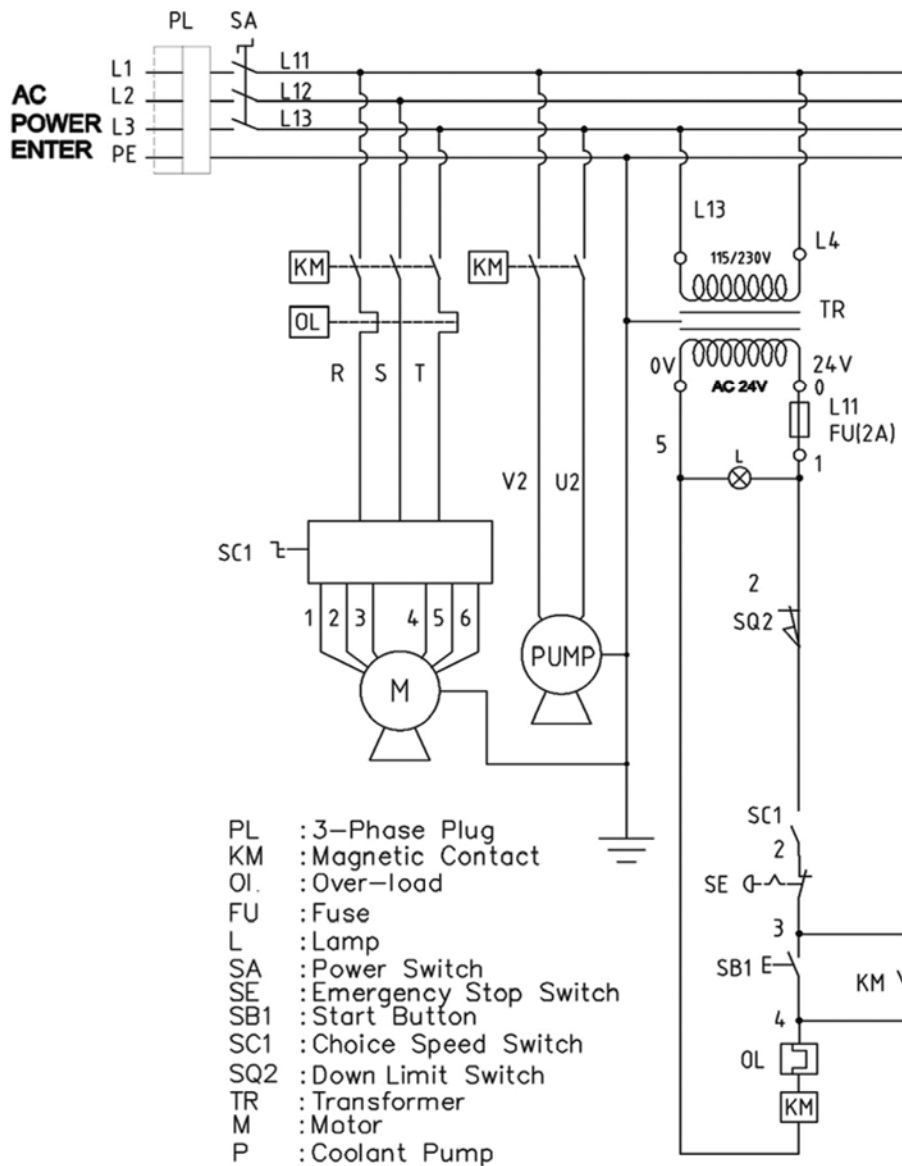
Electrical Box Assembly – Parts

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|---|------------|-----|
| 215 | | Electrical Control Box Assembly: 3Ph (Reference Only) | | 1 |
| 215-1 | 9180-215-1 | Magnetic Contactor | | 1 |
| 215-2 | 9180-215-2 | Push Button Start Switch | | 1 |
| 215-3 | 9180-215-3 | Speed Switch | | 1 |
| 215-4 | 9180-215-4 | On/Off Switch | | 1 |
| 215-5 | 9180-215-5 | Emergency Stop Switch | | 1 |
| 215-6 | 9180-215-6 | Power Lamp | | 1 |
| 215-7 | 9180-215-7 | Transformer | | 1 |
| 215-8 | 9180-215-8 | Fuse Base | | 1 |
| 215-9 | 9180-215-9 | Fuse Lid | | 1 |
| 215-10 | 9180-215-10 | Fuse | 2A | 1 |
| 215-11 | J-9180-215-11 | Electrical Box Cover | | 1 |
| 215-12 | J-9180-215-12 | Electrical Box | | 1 |
| 215-13 | 9180-215-13 | Cable Relief | | 3 |
| 215-14 | 9180-215-14 | Cable Relief | | 1 |
| 215-15 | 9180-215-15 | Cable Relief | | 3 |
| 215-16 | 9180-215-16 | Net Plate | | 1 |
| 215-17 | 9180-215-17 | Rail | | 1 |
| 215-18 | 9180-215-18 | Bracket | | 1 |
| 215-19 | 9180-P4C15 | Power Cable (for 3Ph) | 4cx1.5mm | 1 |
| 215-20 | 9180-M4C15 | Motor Cable (for 3Ph) | 4cx1.5mm | 1 |
| 215-21 | 9180-215-21 | Limit Cable | | 1 |
| 215-22 | 9180-215-22 | Pump Cable | | 1 |
| 215-26 | TS-1533032 | Pan Head Screw | M5x10 | 4 |
| 215-27 | 9180-215-27 | Tapping Screw | M4x8 | 11 |
| 215-28 | 9180-215-28 | Screw | M4x6 | 4 |
| 215-29 | TS-1532052 | Pan Head Screw | M4x16 | 4 |
| 215-30 | 9180-215-30 | Washer | M5 | 5 |
| 215-36 | 9180-215-36 | Limit Switch | | 1 |
| 215-37 | 9180-215-37 | Cable Relief | | 1 |
| 215-38 | 9180-215-38 | Cable Relief | | 1 |
| 215-39 | 9180-215-39 | Wire | | 1 |
| 215-40 | 9180-OL-3 | Overload (for 3Ph) | 2.6 - 3.7A | 1 |

Electrical Box Assembly



Wiring Diagram



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