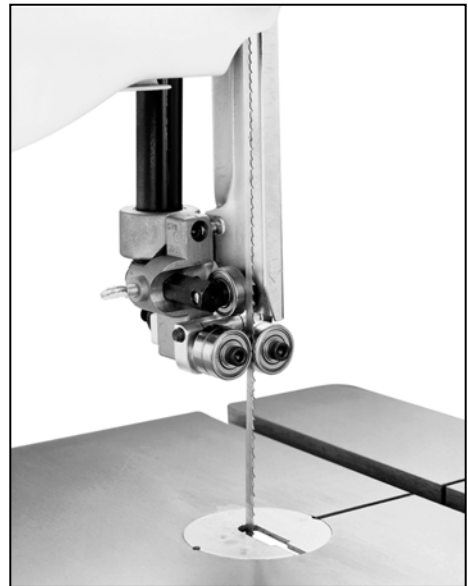


J E T[®]

WMH TOOL GROUP

Assembly Instructions JRBG-14 Roller Bearing Guides



Pre-Assembly

1. Disconnect the saw from the power source, unplug.
2. It is easier to install the new guides if you remove the band saw's table.
3. Remove the circular *table insert* found on the top of the table, and also the *table pin* found on the side of the table. The table can be removed by unscrewing the *lock knobs* found below the table trunnion.
4. Remove the existing *blade guides*.

Upper Bearing Guide

Referring to Figure 1:

1. Fit the *upper bearing guide* onto the *guide post* and tighten the hex cap screw.

Note: Model JWBS-14OS Band Saw requires *bushing* (Part No. 150214) shown in G, Fig. 2.

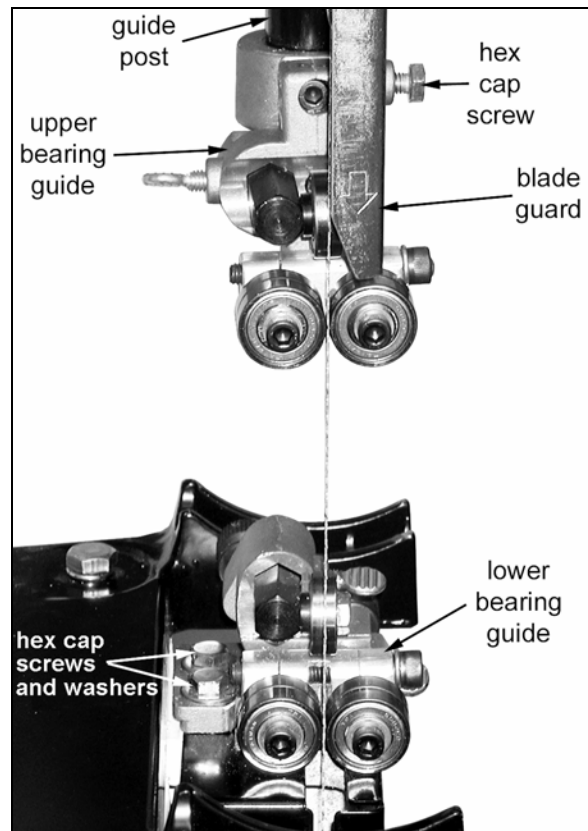


Figure 1

Referring to Figure 2:

2. Adjust the *back-up bearing* (Fig. 2) so that it is 0.003" away from the back of the blade, about the thickness of a piece of paper. To make this adjustment loosen *thumb screw* (F, Fig. 2) and turn the *adjusting screw* (E, Fig. 2) until the adjustment is correct. Tighten *thumb screw* (F, Fig. 2).
3. Loosen the *thumb screw* (C, Fig. 2) and turn the *adjusting screw* (D, Fig. 2) until the bearing guides rest just behind the gullet of the blade teeth.
4. Loosen the *socket head cap screw* (A, Fig. 2) and turn the *screw* (B, Fig. 2) clockwise or counter-clockwise until the *side-bearing* (Fig. 2) is 0.003" away from the side of the bearing, about the thickness of a piece of paper.
5. Adjust the opposite side bearing.
6. Tighten *socket head cap screw* (A, Fig. 2). Check to make sure the adjustments have not changed and the bearing guides do not pinch the blade.
7. Attach the blade guard.

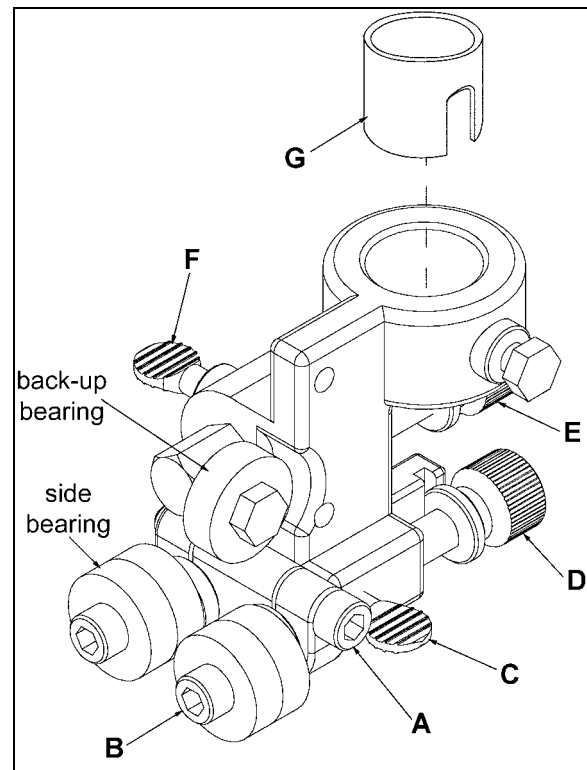


Figure 2

Lower Bearing Guide

1. Attach the *lower bearing guide* (Fig. 1) with two *hex cap screws and washers* (Fig. 1).

Referring to Figure 3:

2. Adjust the *back-up bearing* so that it is 0.003" away from the back of the blade, about the thickness of a piece of paper. To make this adjustment loosen *thumb screw* (A, Fig. 3) and turn the *adjusting screw* (B, Fig. 3) until the adjustment is correct. Tighten *thumb screw* (A, Fig. 3).
3. Loosen the *thumb screw* (C, Fig. 3) and turn the *adjusting screw* (D, Fig. 3) until the bearing guides rest just behind the gullet of the blade teeth.
4. Loosen the *socket head cap screw* (E, Fig. 3) and turn the *screw* (F, Fig. 3) clockwise or counter-clockwise until the bearing is 0.003" away from the side of the bearing, about the thickness of a piece of paper.
5. Adjust the opposite side bearing.
6. Tighten *socket head cap screw* (E, Fig. 3). Check to make sure the adjustments have not changed and the bearing guides do not pinch the blade.

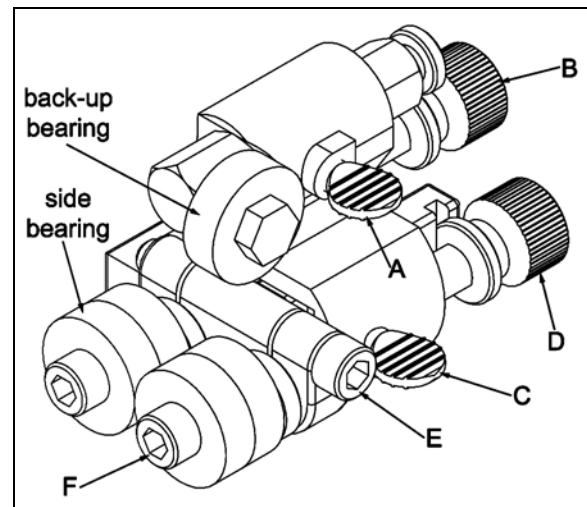


Figure 3