

Parts Manual



SAWING PRODUCTS

3612-VH

Serial No: 570-04101 to

Band Sawing Machine

MACHINE SPECIFICATIONS

MODEL SERIAL NO.

VOLTAGE CYCLE PHASE

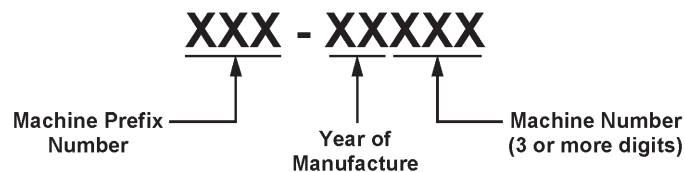
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is printed on a label or stamped on a plate attached to the machine frame.

Always specify model and serial numbers on all parts orders and correspondence concerning your machine. This will help avoid unnecessary delays and inconvenience during processing.

The specifications contained herein were in effect at the time this manual was approved for printing. The DoALL Company, whose policy is one of continuous product improvement, reserves the right to change specifications or design at any time without notice and without incurring obligations.

How to read your serial number:

Example: 500-001234



For Sales, Parts and Service, call 1-888-362-5572.



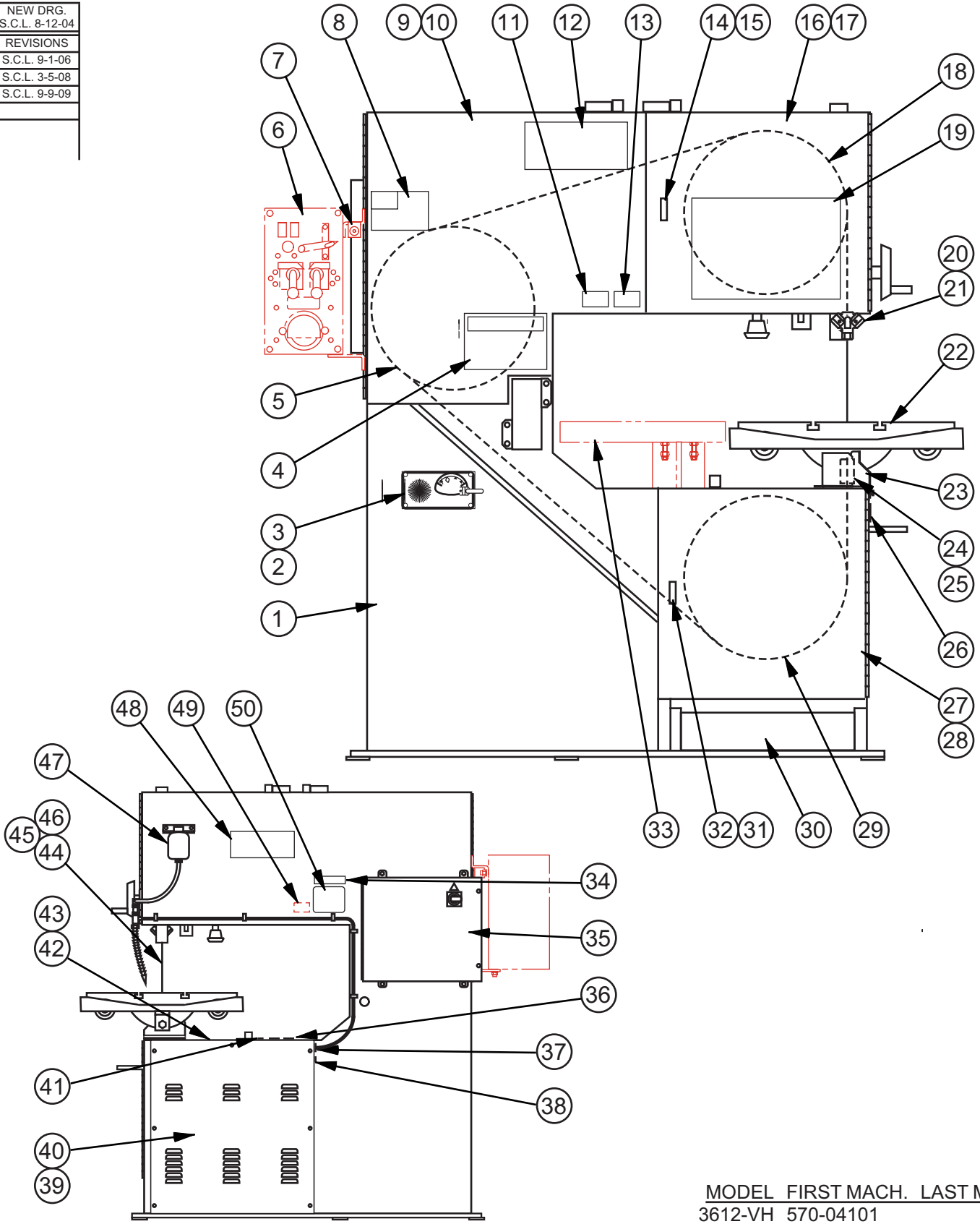
DoALL SAWING PRODUCTS
2375B TOUHY AVENUE
ELK GROVE, ILLINOIS 60007 U.S.A.

YOUR SERVICE REPRESENTATIVE:

Fiche No. B-23 Model 3612-VH Serial No. 570-04101 to _____

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NEW DRG.	S.C.L. 8-12-04
REVISIONS	
	S.C.L. 9-1-06
	S.C.L. 3-5-08
	S.C.L. 9-9-09



MODEL FIRST MACH. LAST MACH.
3612-VH 570-04101

FINAL ASSEMBLY

FINAL ASSEMBLY

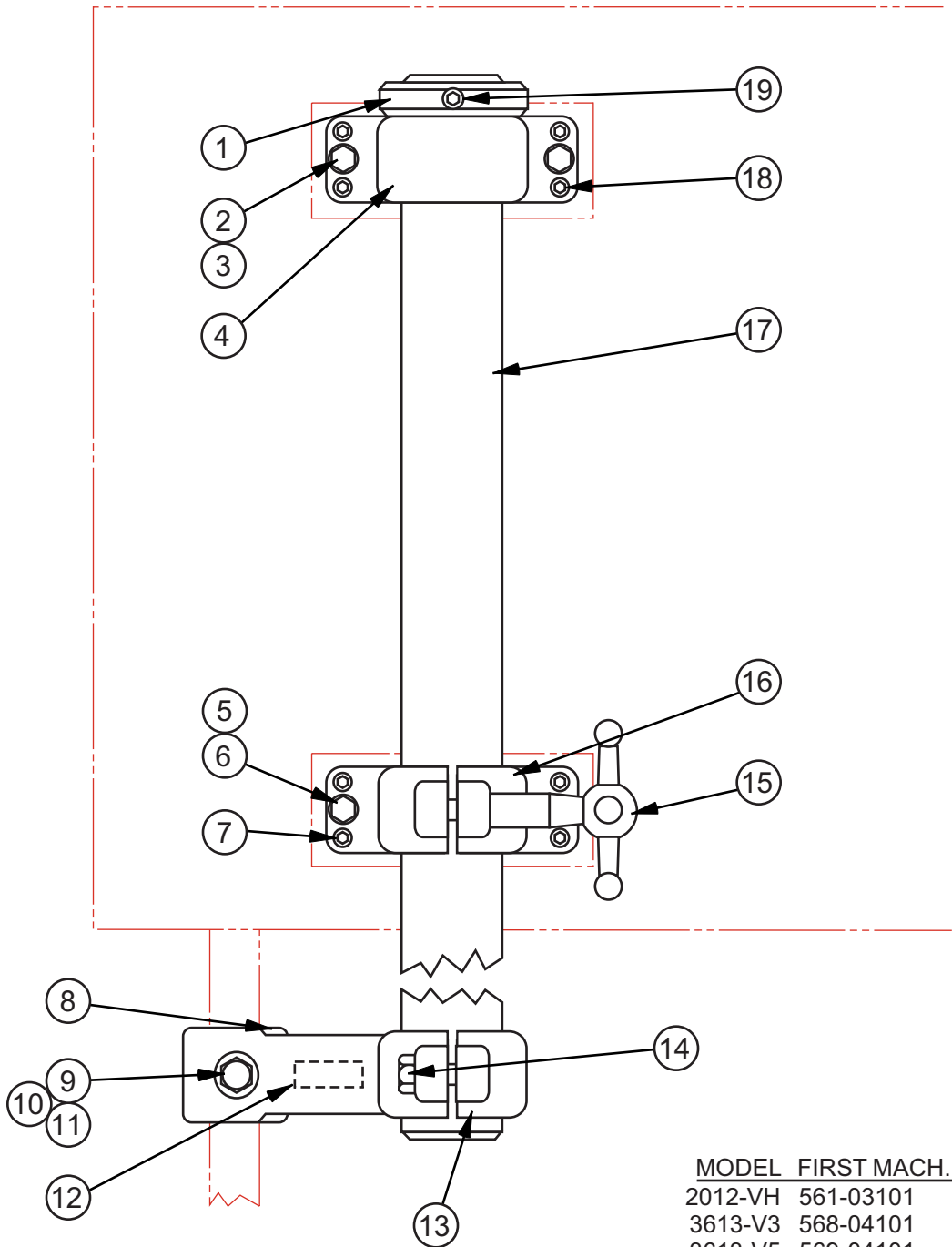
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	NO.	NO.	ASS'Y.
Ref.	290214	Final Assembly		37	203271	. Grommet (Large) 2
1*	521630	. Frame Weldment	1	38	133195	. Grommet (Small) 1
2	221189	. Hydraulic Assembly (See Detail)	1	39	420945	. Rear Drive Cover 1
3	202698	. Tag (Hydraulic System Purge)	1	40	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 7
4	404476	. Escutcheon (Warning)	1	41	015780	. Grommet 1
5	521623	. Idler Wheel Assembly (Third Wheel) (See Detail)	1	42	420954	. Top Drive Cover 1
6		. DBW-15 Butt welder Assembly (Optional) (See Separate Manual)	1	43	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 6
7	221216	. Welder Mounting Bracket Assembly (With Optional Butt welder) (See Detail)	1	44*	221228	. Saw Band (Silencer) 1
8	201469	. Decal (American Flag)	1	45	304525	. Saw Band Tag 1
9*	521740	. L.H. Upper Door Weldment	1	46	222563	. Tag (Installation Instructions) 1
10	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 8		47	221199	. Mist Coolant Assembly (See Detail) 1
11	136902	. Escutcheon (Caution) (English)	1	48	416163	. Label (DoALL) 1
	139493	. Escutcheon (Caution) (International) ... 1		49	206698	. CE Label 1
12	416163	. Label (DoALL)	1	50	1012541	. Label (Machine Specifications) 1
13	145882	. Escutcheon (Caution) (English)	1			
	149667	. Escutcheon (Caution) (International) ... 1				
14	172762	. Door Latch	1			
15	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8 .. 2				
16	420957	. R.H. Upper Door Weldment	1			
17	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 6				
18	521515	. Head Assembly (See Detail)	1			
19	515907	. Job Selector	1			
20	304843	. Saw Guide Assembly (Upper) (See Detail) 1				
21	018500	. Upper Saw Guide Holding Screw	2			
22	220747	. Hydraulic Table Assembly (See Detail) 1				
	220748	. Hydraulic Table Assembly (18" Stroke Option) (See Detail)	1			
23	221612	. Guard Assembly (Chip Baffle) (See Detail) 1				
24	304844	. Saw Guide Assembly (Lower) (See Detail) 1				
25	198246	. Screw, Soc. Hd. Cap 1/4-20NC x 1-3/4 2				
26	172654	. Escutcheon (Caution Hi/Low) (English) 1				
	172655	. Escutcheon (Caution Hi/Low) (Internat'l) 1				
27	521609	. Lower Door Weldment	1			
28	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 6				
29	220236	. Drive Assembly (See Detail)	1			
30	404522	. Chip Box Weldment (Standard)	1			
	414621	. Chip Box Assembly (Dust Spout Option) 1				
31	172762	. Door Latch	1			
32	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8 .. 2				
33	503536	. Secondary Table Assembly (Optional) (See Detail)	1			
34	222562	. Label (1-888-DoALL)	1			
35		. Electrical Assembly (See Detail)	1			
36	006291	. Plug Button (No Secondary Table)	4			

Following Not Shown:

222565	. Box of Extra Parts	1
222560	. . Saw Guide Insert Pack (1/4" to 1" Bands) 1	
003939	. . Saw Guide Insert (1/2")	4
010853	. . Wrench (For Table Tilt)	1
199568	. . Hex. Key (Saw Guides)	1
406871	. Instruction Tag	1
1012715	. Pallet	1
221201	. Documentation CD	1
203101	. Tag (Replace Plugs With...)	1
321275	. Lubrication Chart (Optional)	1

*NOTE: Also See Extra Work Height Assembly If Applicable.

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 4-4-07
S.C.L. 2-11-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	
2613-V3	589-09101	

AUXILIARY POST SUPPORT ASSEMBLY (EXTRA WORK HEIGHT)

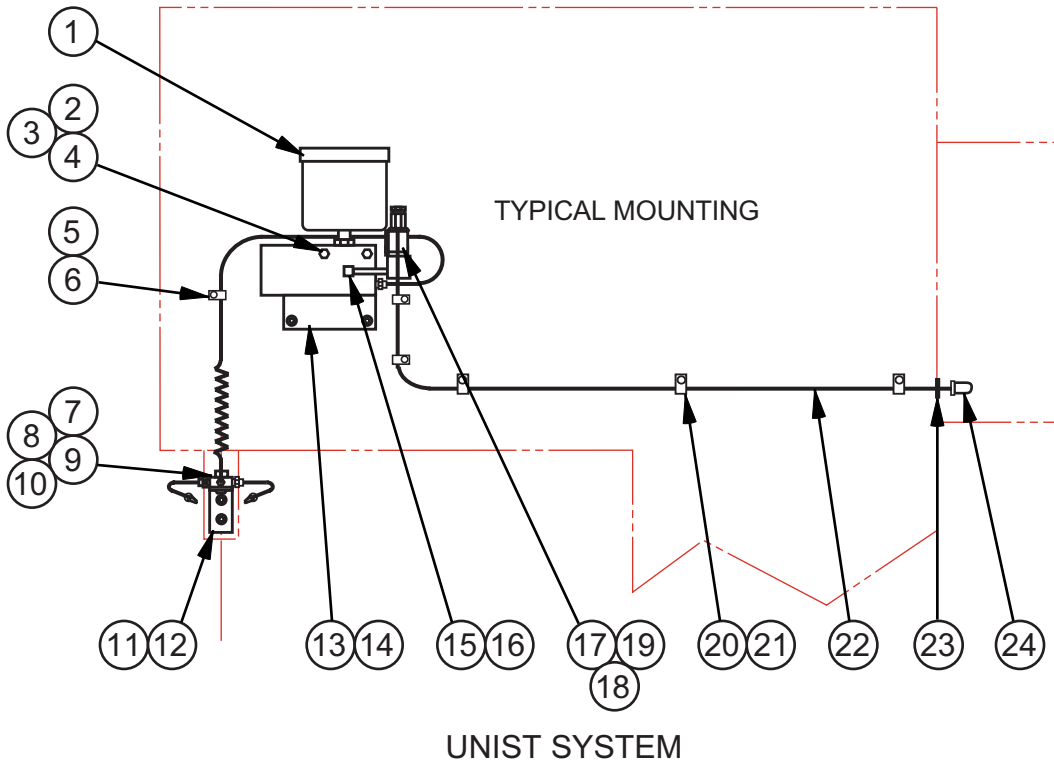
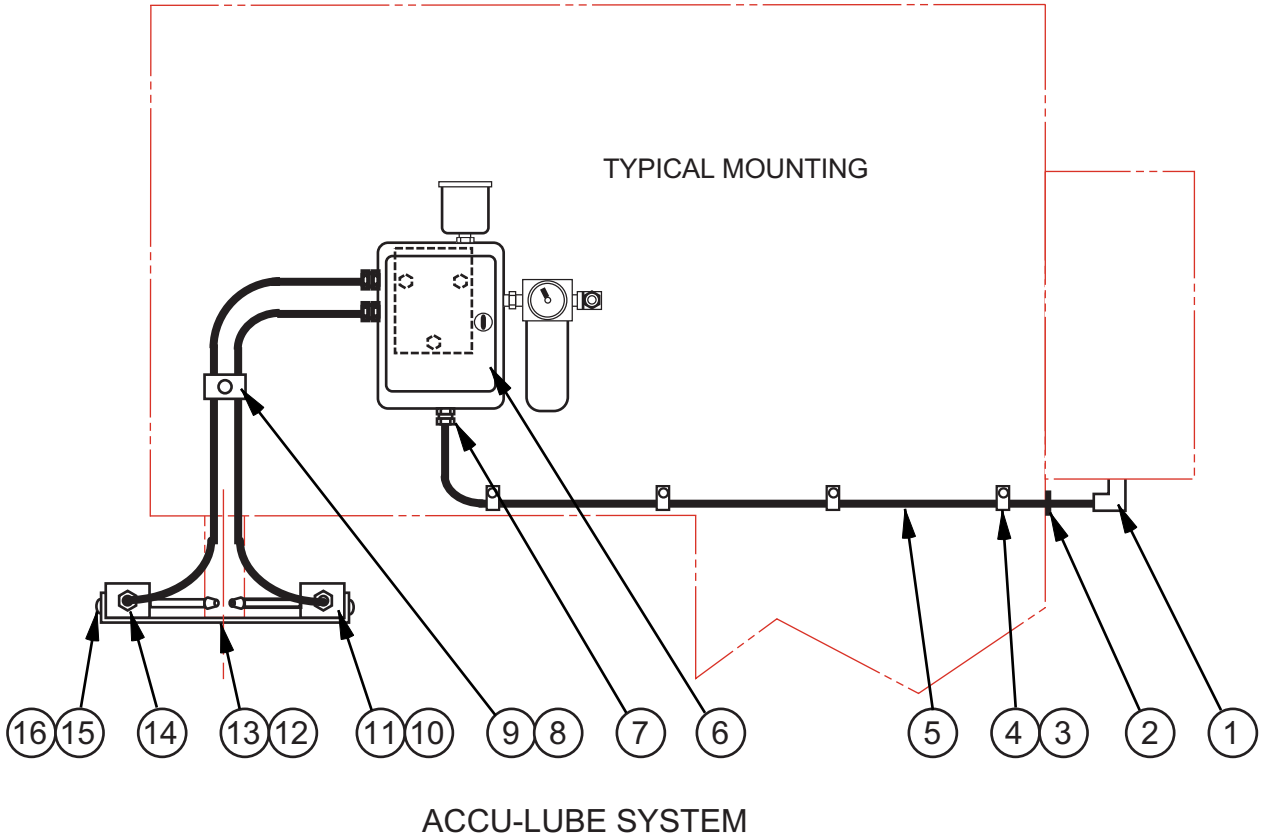
C - 2 - 118 CM - 2 - 132

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AUXILIARY POST SUPPORT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	506149	Auxiliary Post Support Assembly	
1	13-001423	. Post Collar	1
2	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/2	2
3	199325	. Washer, Lock 3/8 Std.	2
4	032463	. Upper Post Guide	1
5	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/2	2
6	199325	. Washer, Lock 3/8 Std.	2
7	198439	. Screw, Soc. Set 5/16-18NC x 3/4	4
8	13-001309	. Back-Up Pad	1
9	13-001419	. Back-Up Pad Screw 1/2-13NC x 4-1/8	1
10	199132	. Nut, Hex. Jam 1/2-13NC	1
11	35-009616	. Retaining Ring	1
12	203551	. Escutcheon (Remove Bracket)	1
13	024337	. Support Arm	1
14	198067	. Screw, Hex. Hd. Cap 1/2-13NC x 1-1/2	1
15	007629	. Starwheel Assembly	1
	6-001103	. . Starwheel	1
	004261	. . Spring Pin	1
	13-001422	. . Post Clamp Screw	1
16	032462	. Lower Post Guide	1
17	305659	. Auxiliary Post (24" Work Height)	1
	305660	. Auxiliary Post (30" Work Height)	1
18	198439	. Screw, Soc. Set 5/16-18NC x 3/4	4
19	198450	. Screw, Soc. Set 3/8-16NC x 5/8	1

NEW DRG.
S.C.L. 5-1-00
REVISIONS
S.C.L. 2-25-04
S.C.L. 8-16-06
S.C.L. 2-8-08



BAND LUBRICATOR ASSEMBLY

C - 8 - 30 CM - 8 - 52 Z - 8 - 26

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BAND LUBRICATOR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	520296	Band Lubricator Assembly (Accu-Lube System)	
1	320570	. 90° Cord Grip Connector (.125-.375)	1
2	133195	. Grommet	1
3	009955	. Tubing Clamp	4
4	199484	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2	4
5	197332	. Electrical Cord (#18-2 Conductor)	A.R.
6	204206	. Applicator Unit (Includes Hoses, Nozzles, etc.)	1
7	015139	. Cord Grip Connector (.250-.375)	1
8	313336	. Double Support	1
9	198276	. Screw, Soc. Hd. Cap 3/8-16NC x 1/2	1
10	216855	. Block	2
11	309004	. Male Connector	2
12	324404	. Mounting Bracket	1
13	198353	. Screw, Flat Hd. Soc. #6-32NC x 3/8	2
14	016001	. Barbed Insert	2
15	198207	. Screw, Soc. Hd. Cap #6-32NC x 3/8	4
16	199256	. Washer, Flat #6 S.A.E. Std.	4

Following Not Shown and Mounted on or Near the Control Box:

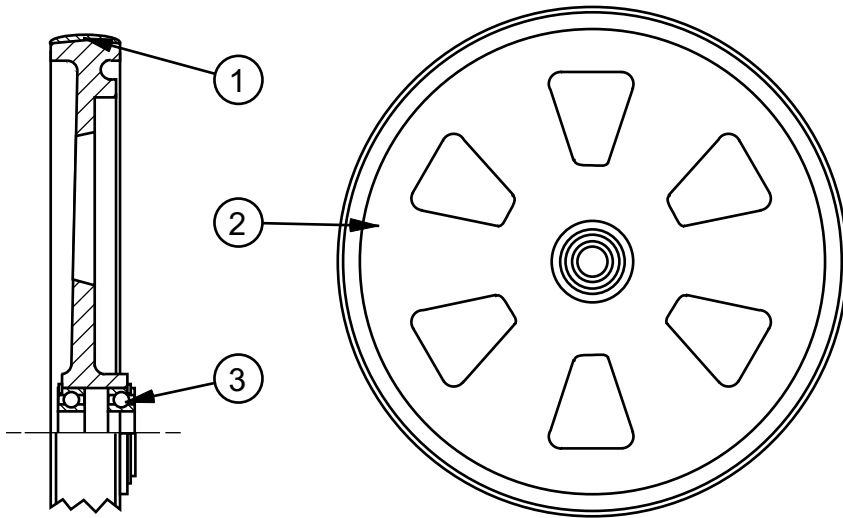
211111	. Selector Switch (2 Position)	1
217373	. Escutcheon (Mist Lube)	1

Ref.	1002498	Band Lubricator Assembly (Unist System)	
1	217359	. Applicator Unit (Includes Hose)	1
2	198015	. Screw, Hex. Hd. Cap 1/4-20NC x 2-1/4	2
3	199115	. Nut, Hex. 1/4-20NC	2
4	199321	. Washer, Lock 1/4 Std.	2
5	209458	. Hose Clamp (Half)	1
6	198321	. Screw, Button Hd. Soc. #10-24NC x 3/8	1
7	215821	. Nozzle Splitter	1
8	198360	. Screw, Button Hd. Soc. 1/4-20NC x 7/8	1
9	199114	. Nut, Hex. Jam 1/4-20NC	1
10	199321	. Washer, Lock 1/4 Std.	1
11	215917	. Mounting Bracket	1
12	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	2
13	214906	. Mounting Bracket	1
14	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	2
15	5-027506	. 90° Street Elbow	1
16	203144	. Pipe Nipple (Brass)	1
17	176829	. Solenoid Valve (3-Way)	1
18	177054	. Solenoid Plug Connector Kit	1
19	176811	. Vent Filter Breather	1
20	009955	. Tubing Clamp	5
21	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	5
22	197344	. Electrical Cord (#18-3 Conductor)	A.R.
23	133195	. Grommet (If Supplied)	1
24	201688	. Cord Grip Connector (.200-.394)	1

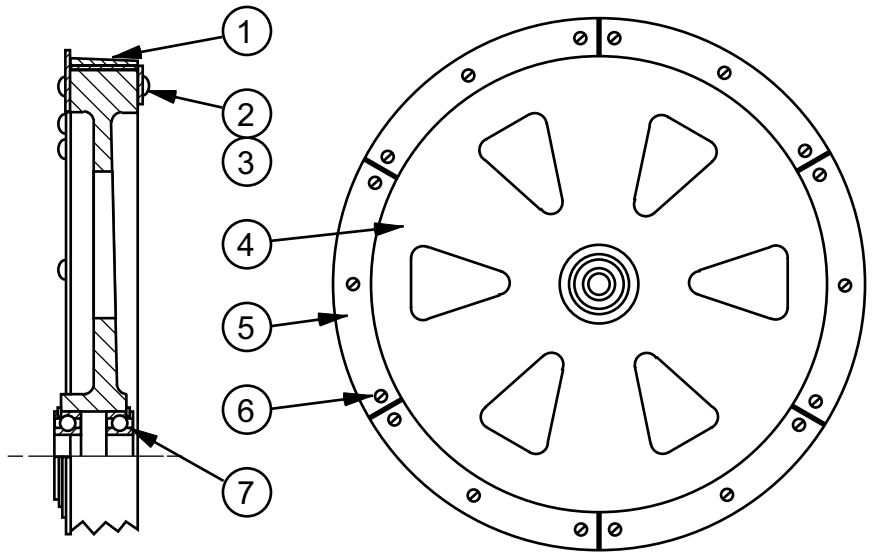
Following Not Shown and Mounted on or Near the Control Box on Selected Models:

211111	. Selector Switch (2 Position) (Includes Contact Blocks)	1
217373	. Escutcheon (Mist Lube)	1

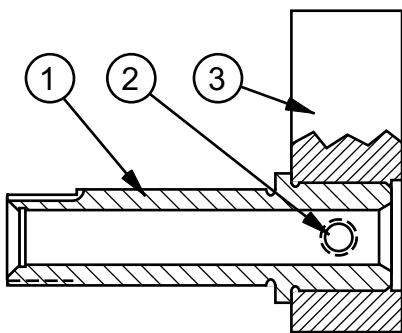
NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 4-4-07
S.C.L. 2-11-08



CROWNED BANDWHEELS



FLANGED BANDWHEELS



WHEEL HINGE ASSEMBLY

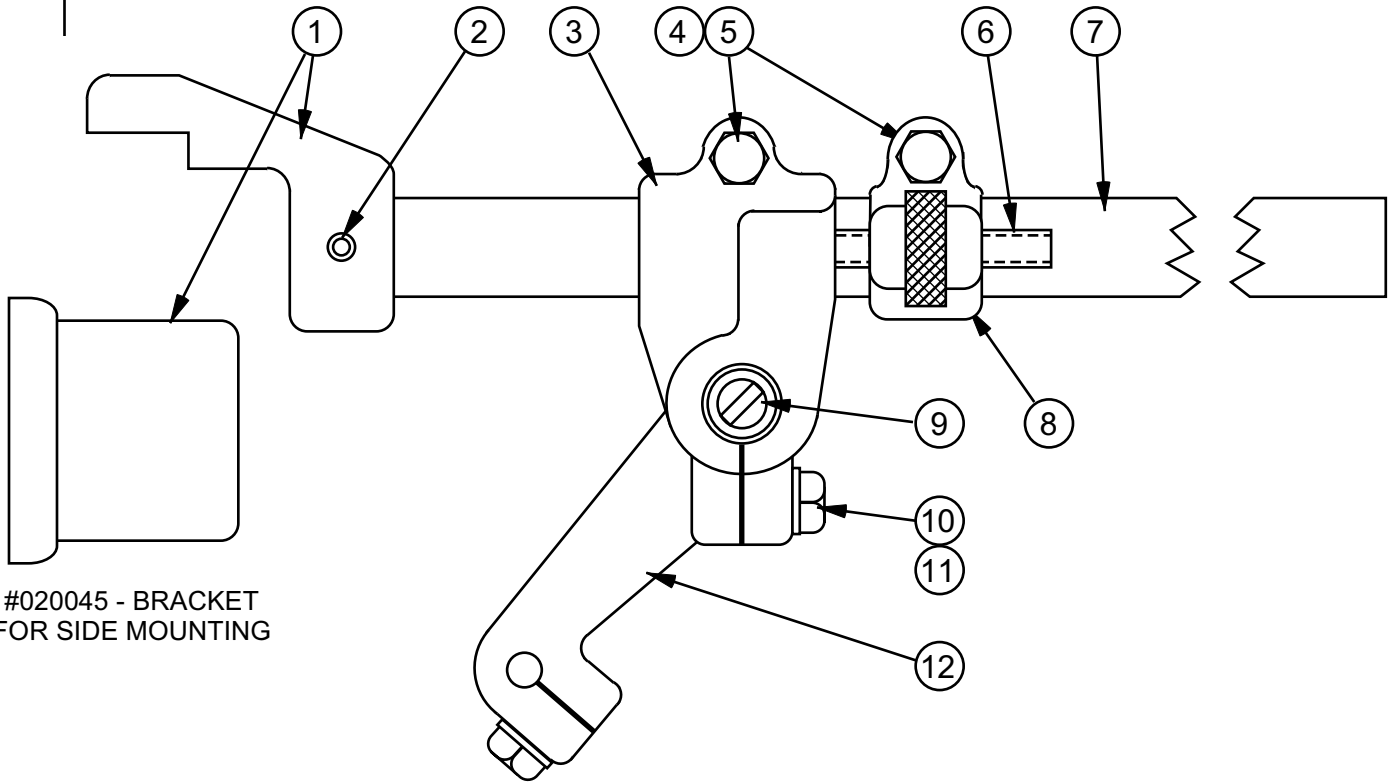
MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	

BANDWHEEL ASSEMBLIES

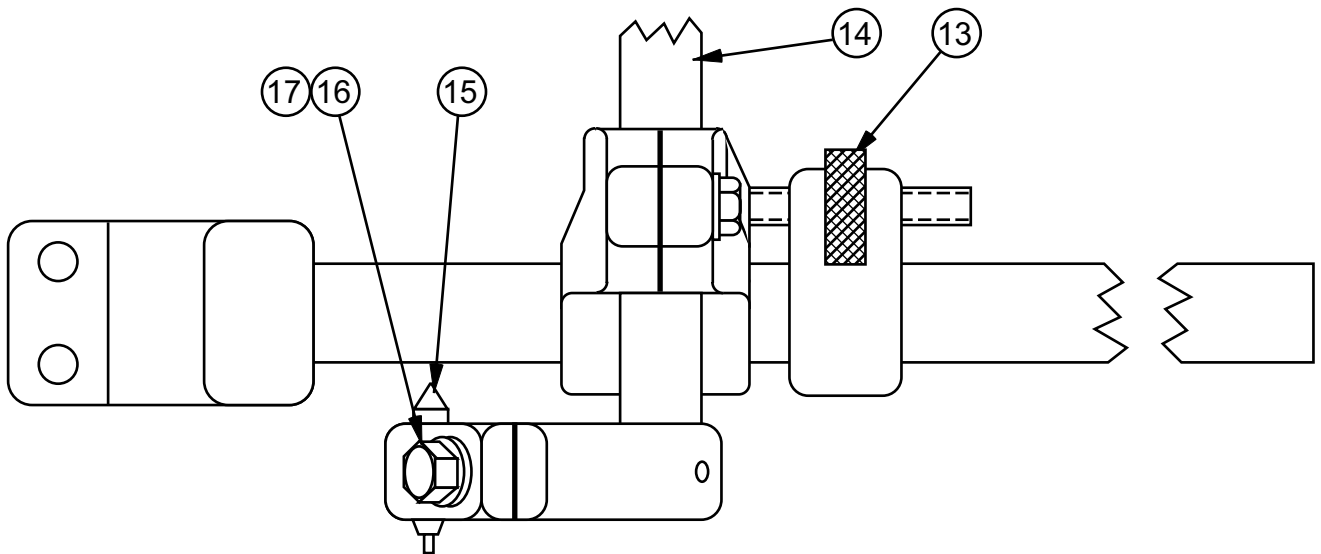
BANDWHEEL ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
<u>CROWNED BANDWHEELS</u>			
Ref.	402598	Bandwheel Assembly (Upper and Idler)	
Ref.	039712	Bandwheel Assembly (Lower)	
1	125357	. Tire	1
2	402597	. Bandwheel (Upper and Idler)	1
	402599	. Bandwheel (Lower)	1
3	5-001508	. Ball Bearing (Upper and Idler Bandwheels Only)	2
<u>FLANGED BANDWHEELS</u>			
Ref.	406558	Bandwheel Assembly (Upper and Idler)	
Ref.	408945	Bandwheel Assembly (Lower)	
1	305030	. Tire And Rim Assembly	1
2	004675	. Retainer	4
3	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	8
4	406458	. Bandwheel (Upper and Idler)	1
	408875	. Bandwheel (Lower)	1
5	304732	. Flange Segment	6
6	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	18
7	5-001508	. Ball Bearing (Upper and Idler Bandwheels Only)	2
Ref.	302346	Wheel Hinge Assembly	
1	5-001424	. Axis Stud	1
2	198423	. Screw, Soc. Set 1/4-20NC x 5/16	1
3	120624	. Block	1

NEW DRG.
S.C.L. 9-24-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-11-08



#020045 - BRACKET
FOR SIDE MOUNTING



DISC CUTTER ASSEMBLY

C - 10 - 2 CM - 9 - 1 Z - 9 - 4

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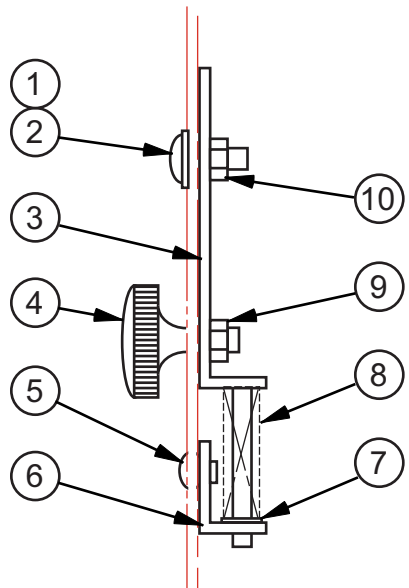
DISC CUTTER ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	402080	Disc Cutter Assembly (Rear Mounted)	
Ref.	040044	Disc Cutter Assembly (Side Mounted)	
1	039019	. Bracket (Rear Mounted)	1
	020045	. Bracket (Side Mounted)	1
2	004276	. Spring Pin (Rear Mounted)	1
	004275	. Spring Pin (Side Mounted)	1
3	35-003400	. Radius Arm Clamp	1
4	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
5	199325	. Washer, Lock 3/8 Std.	2
6	219409	. Adjustment Rod (w/ #202383 Adhesive)	1
7	35-003399	. Radius Arm	1
8	5-015109	. Adjustment Housing	1
9	004261	. Spring Pin	1
10	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	1
11	199325	. Washer, Lock 3/8 Std.	1
12	35-003402	. Center Pin Clamp	1
13	5-015412	. Adjustment Wheel	1
14	35-003401	. Center Adjusting Tube	1
15	5-015415	. Center Pin	1
16	198029	. Screw, Hex. Hd. Cap 5/16-18NC x 1	1
17	199323	. Washer, Lock 5/16 Std.	1

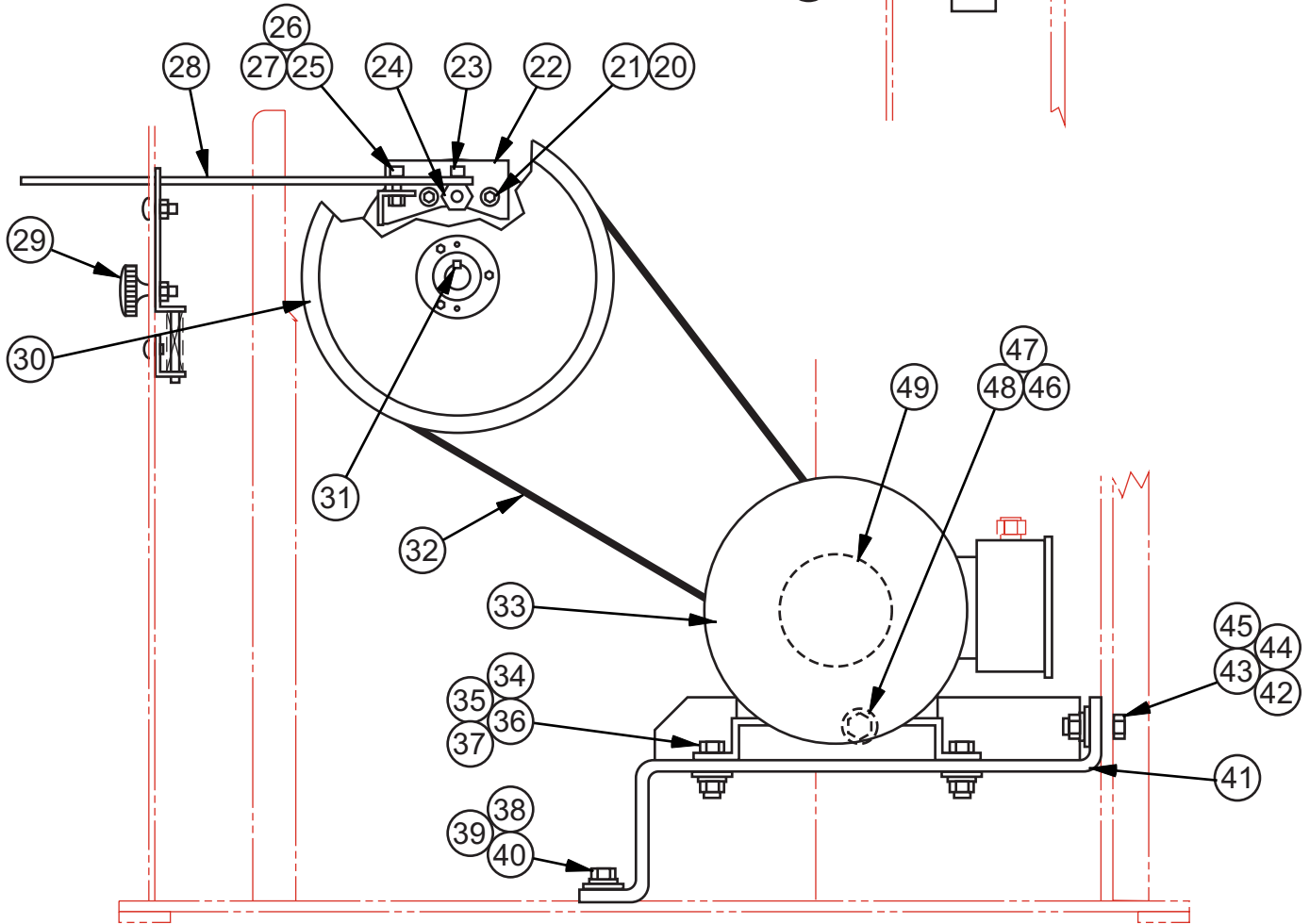
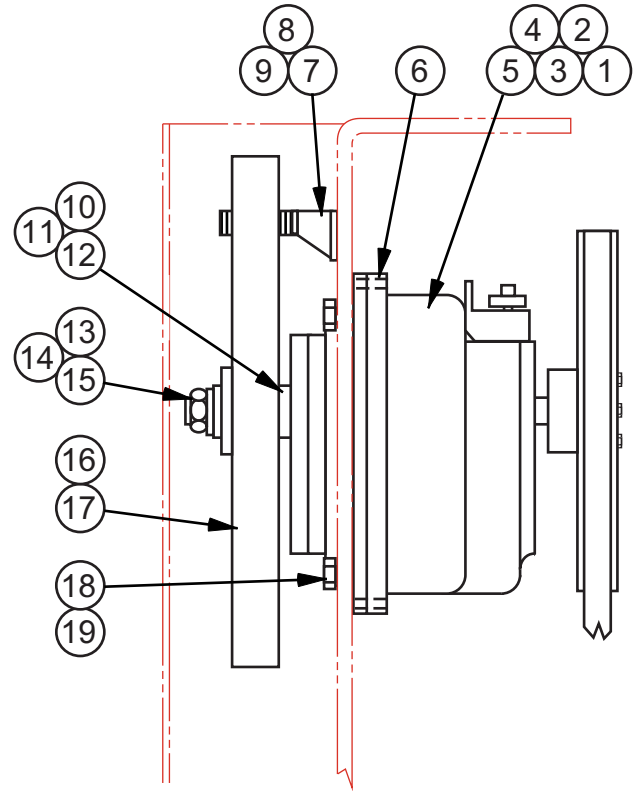
Following Not Shown and Used For Mounting to the Post:

198029	. Screw, Hex. Hd. Cap 5/16-18NC x 1 (Rear Mounted)	2
198031	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2 (Side Mounted)	2
199262	. Washer, Flat 5/16 S.A.E. Std.	2
199323	. Washer, Lock 5/16 Std.	2
131797	. Cloth Bag	1
34-020308	. Wrench (If Supplied)	1

NEW DRG.	S.C.L. 7-31-03
REVISIONS	
S.C.L. 2-25-04	
S.C.L. 3-17-08	
S.C.L. 9-9-09	



SHIFT LEVER LOCK ASSEMBLY



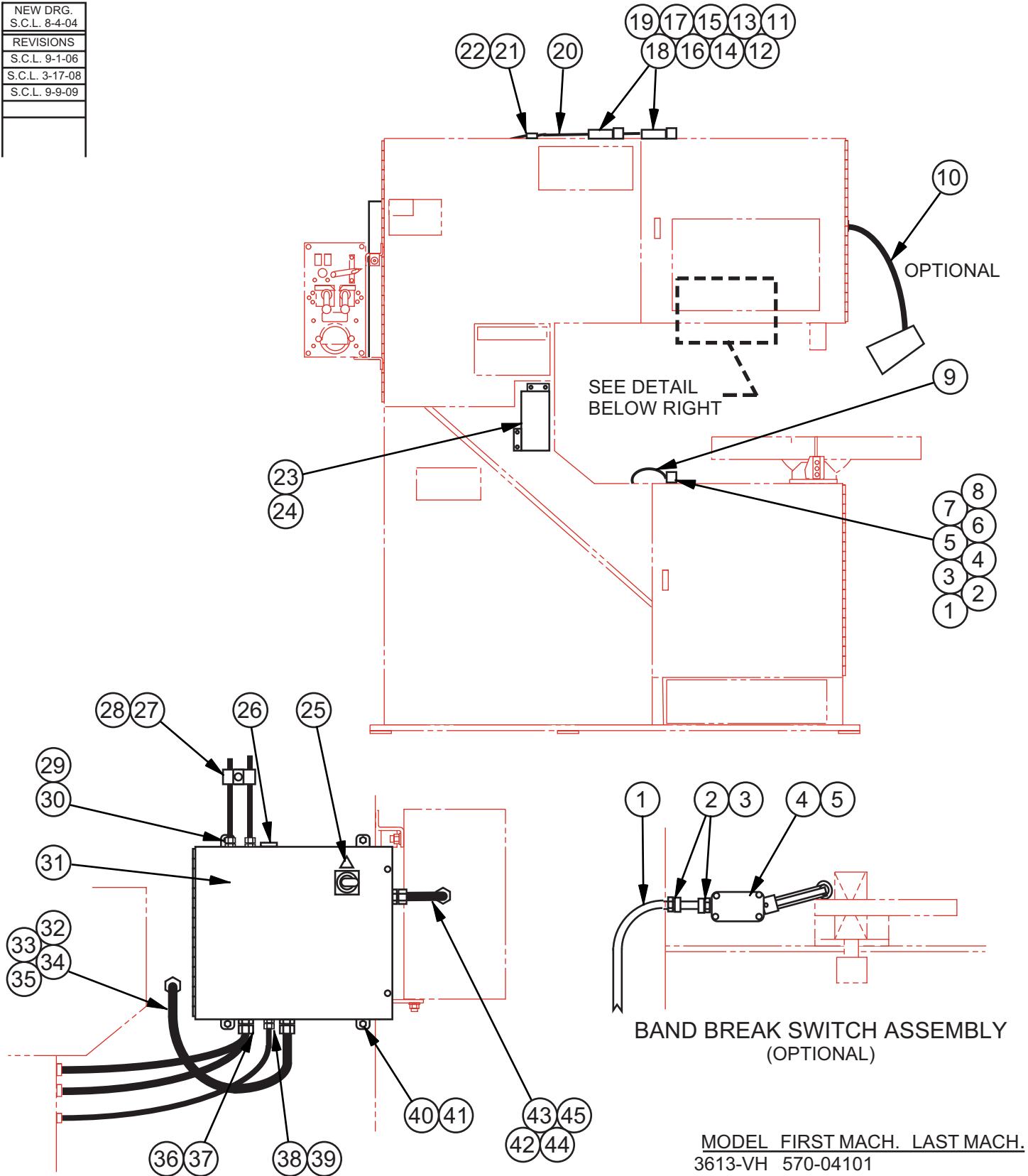
MODEL FIRST MACH. LAST MACH.
 2012-VH 561-03101
 3612-VH 570-04101

DRIVE ASSEMBLY

DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	220236	Drive Assembly	
1	506827	. Transmission Assembly (See Detail)	1
2	133570	. Shim (.005)	A.R.
3	133571	. Shim (.008)	A.R.
4	133572	. Shim (.010)	A.R.
5	133573	. Shim (.020)	A.R.
6	260380	. Dowel Pin	2
7	016664	. Brush Holder Weldment	1
8	016684	. Wheel Brush	1
9	199020	. Screw, Pan Hd. Mach. 1/4-20NC x 1/2	2
10	133316	. Spacer (.014/.016)	A.R.
11	133317	. Spacer (.028/.032)	A.R.
12	133318	. Spacer (.127/.143)	A.R.
13	199140	. Nut, Hex. Jam 3/4-10NC	1
14	199378	. Washer, Lock 3/4 Shakeproof Ext.	1
15	199268	. Washer, Flat 3/4 S.A.E. Std.	1
16	408945	. Bandwheel Assembly (See Detail)	1
17	5-004604	. Woodruff Key	1
18	198031	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2	4
19	199323	. Washer, Lock 5/16 Std.	4
20	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	2
21	199321	. Washer, Lock 1/4 Std.	2
22	315179	. Shift Arm Mounting Bracket	1
23	174055	. Screw, Soc. Hd. Shoulder 1/4-20NC x 3/8 (5/16 Dia.)	1
24	172399	. Adaptor	1
25	120796	. Screw, Soc. Hd. Shoulder 1/4-20NC x 3/8 (5/16 Dia.)	1
26	199321	. Washer, Lock 1/4 Std.	1
27	199176	. Nut, Hex. 1/4-20NC	1
28	314674	. Shift Lever	1
29	207684	. Shift Lever Lock Assembly (See Detail)	1
30	220219	. Pulley	1
31	7-001345	. Key	1
32	209500	. Timing Belt	1
33	209624	. Electric Motor (208V, 230V,460V)	1
	209625	. Electric Motor (575V)	1
	220272	. Electric Motor (220V, 440V; 50 Hz)	1
34	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	4
35	199325	. Washer, Lock 3/8 Std.	4
36	199264	. Washer, Flat 3/8 S.A.E. Std.	4
37	199126	. Nut, Hex. 3/8-16NC	4
38	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
39	199325	. Washer, Lock 3/8 Std.	2
40	199264	. Washer, Flat 3/8 S.A.E. Std.	2
41	518413	. Base Plate Weldment	1
42	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	4
43	199325	. Washer, Lock 3/8 Std.	4
44	199264	. Washer, Flat 3/8 S.A.E. Std.	4
45	199126	. Nut, Hex. 3/8-16NC	4
46	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	1
47	199325	. Washer, Lock 3/8 Std.	1
48	199264	. Washer, Flat 3/8 S.A.E. Std.	1
49	220218	. Motor Pulley	1
Ref.	207684	. Shift Lever Lock Assembly	
1	198368	. . Screw, Button Hd. Soc. 1/4-20NC x 3/4	1
2	199260	. . Washer, Flat 1/4 S.A.E. Std.	1
3	320835	. . Slide Plate and Pin Weldment	1
4	014910	. . Thumbscrew	1
5	198321	. . Screw, Button Hd. Soc. #10-24NC x 3/8	1
6	207682	. . Spring Support Bracket	1
7	199260	. . Washer, Flat 1/4 S.A.E. Std.	1
8	134024	. . Compression Spring	1
9	016809	. . Self-Locking Nut 5/16-18NC	1
10	100902	. . Self-Locking Nut 1/4-20NC	1

NEW DRG.	S.C.L. 8-4-04
REVISIONS	
	S.C.L. 9-1-06
	S.C.L. 3-17-08
	S.C.L. 9-9-09

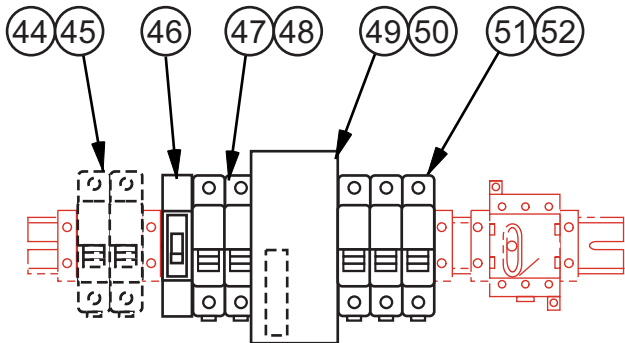
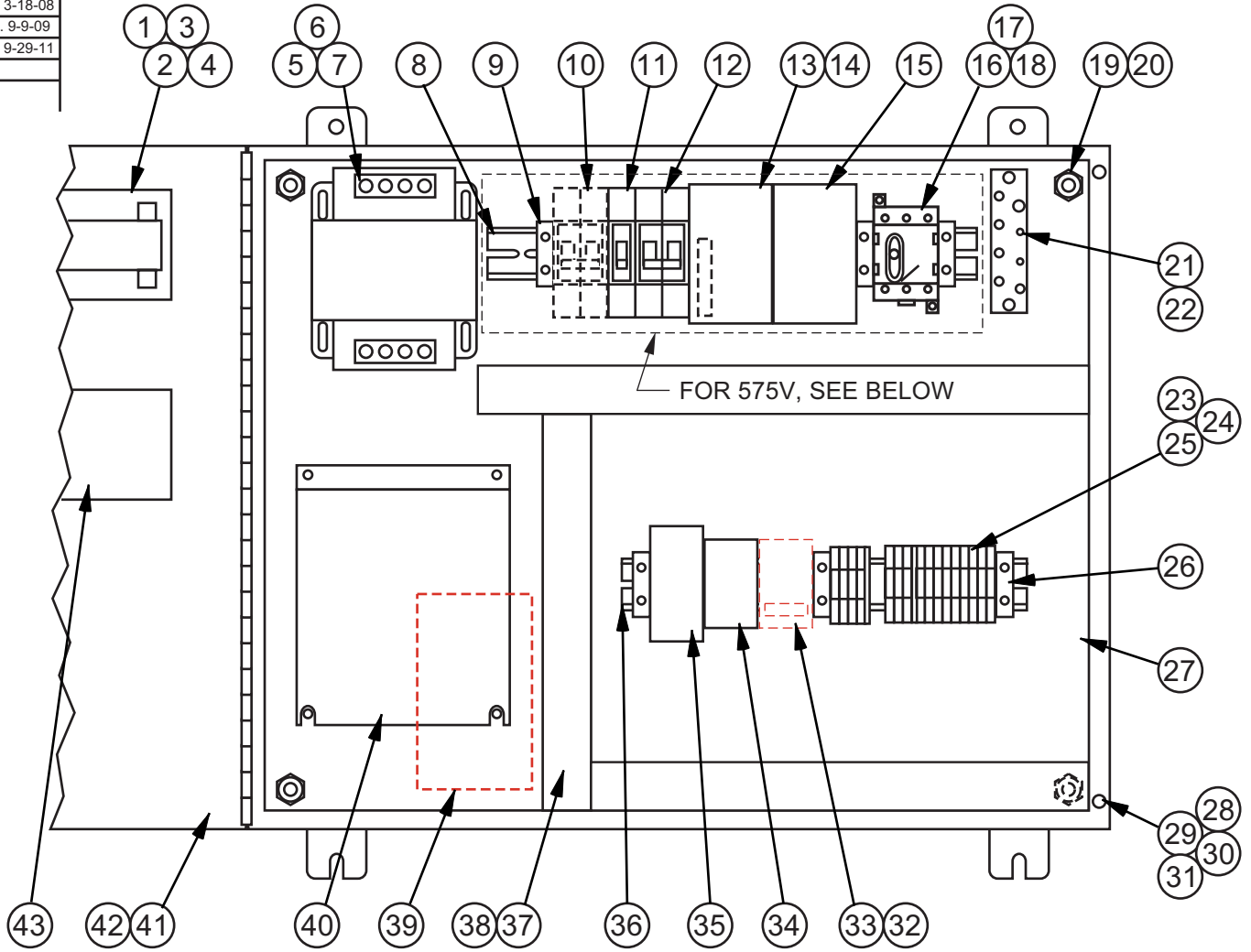


ELECTRICAL ASSEMBLY

ELECTRICAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Assembly	
1	215624	. Limit Switch (Door Interlock)	1
2	222553	. Shim (10 Ga.) (Limit Switch)	A.R.
3	199683	. Screw, Soc. Hd. Cap #6-32NC x 1-1/4	2
4	215619	. Cord Grip Connector (.236-.472)	1
5	221855	. Mounting Bracket	1
6	221854	. Shim (.032)	1
7	198210	. Screw, Soc. Hd. Cap #8-32NC x 3/8	2
8	198220	. Screw, Soc. Hd. Cap #10-24NC x 1/2	2
9	197332	. Electrical Cord (#18-2 Conductor)	A.R.
10	220670	. Worklamp Assembly (Optional) (See Detail)	1
11	215624	. Limit Switch (Door Interlock)	2
12	222553	. Shim (10 Ga.) (Limit Switch)	A.R.
13	199683	. Screw, Soc. Hd. Cap #6-32NC x 1-1/4	4
14	199273	. Washer, Flat #6 S.A.E. Std.	A.R.
15	215619	. Cord Grip Connector (.236-.472)	2
16	221855	. Mounting Bracket	2
17	221854	. Shim (.032)	2
18	198210	. Screw, Soc. Hd. Cap #8-32NC x 3/8	4
19	198220	. Screw, Soc. Hd. Cap #10-24NC x 1/2	4
20	197332	. Electrical Cord (#18-2 Conductor)	A.R.
21	009955	. Hose Clip	2
22	198346	. Screw, Button Hd. Soc. #8-32NC x 3/8	1
23		. Pushbutton Box Assembly (See Detail)	1
24	198349	. Screw, Button Hd. Soc. 1/4-20NC x 1/2	4
25	176528	. Label (Electrical Hazard)	1
26	135106	. Hole Seal (When No Worklamp Supplied)	1
27	009955	. Hose Clip	2
28	198346	. Screw, Button Hd. Soc. #8-32NC x 3/8	1
29	201688	. Cord Grip Connector (.200-.394)	2
30	197332	. Electrical Cord (#18-2 Conductor)	A.R.
31		. Electrical Control Box Assembly (See Detail)	1
32	014545	. Sealtite Connector	2
33	014411	. Flange Washer	2
34	019543	. Bond Nut	2
36	197218	. Electrical Cord (#14-4 Conductor)	A.R.
37	201687	. Cord Grip Connector (.545-.709)	2
38	201688	. Cord Grip Connector (.200-.394)	1
39	197332	. Electrical Cord (#18-2 Conductor)	A.R.
40	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	4
41	199323	. Washer, Lock 5/16 Std.	4
42	014545	. Sealtite Connector (Welder Option)	2
43	014411	. Flange Washer (Welder Option)	2
44	019543	. Bond Nut (Welder Option)	2
45	197156	. Sealtite Conduit 1/2 I.D. (Welder Option)	A.R.
Ref.	520002	Band Break Switch Assembly (Optional)	
1	197221	. Electrical Cord (#16-4 Conductor)	A.R.
2	010789	. Cord Grip Connector (.375-.500)	2
3	014411	. Flange Washer	2
4	026192	. Limit Switch (Band Break)	1
5	198351	. Screw, Soc. Hd. Cap #8-32NC x 1-1/2	4
		Following Not Shown:	
	009135	. Escutcheon (Limit Switch No.)	3
	199397	. Screw, Rd. Hd. Drive #2 x 1/4	6

NEW DRG.	S.C.L. 8-4-04
REVISIONS	
S.C.L. 9-1-06	
S.C.L. 3-18-08	
S.C.L. 9-9-09	
S.C.L. 9-29-11	



FOR 575V MACHINES

MODEL FIRST MACH. LAST MACH.
3612-VH 570-04101

ELECTRICAL CONTROL BOX ASSEMBLY

ELECTRICAL CONTROL BOX ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control Box Assembly		36	169674	. Mounting Channel	A.R.
1	208728	. Mounting Bracket	2	37	197208	. 1" Wiring Channel	A.R.
2*	1003545	. Resistor (60 Ohm) (208V, 220V, 230V)	1	38	197210	. 1" Wiring Channel Cover	A.R.
	1003546	. Resistor (250 Ohm) (400V, 460V)	1	39	221312	. Dynamic Brake Module (575V Only)	1
	1003547	. Resistor (350 Ohm) (575V).....	1	40	1009580	. Variable Speed Controller (208V, 220V, 230V)	1
3	208719	. Resistor Cover	1		1009581	. Variable Speed Controller (400V, 460V)	1
4	107777	. Plastic Rivet	2		1001718	. Variable Speed Controller (575V)	1
5	320079	. Transformer (208V)	1		222877	. Line Reactor (575V Only)	1
	323468	. Transformer (220V)	1	39	520139	. Enclosure Weldment	1
	320078	. Transformer (230V, 460V, 575V)	1	40	203925	. Gasket Strip	A.R.
	217753	. Transformer (400V)	1	41	324166	. Fuse/Overload Schedule	1
6	199202	. Nut, Hex. M5-0.8	4				
7	199348	. Washer, Lock M5	4				
8	169674	. Mounting Channel	A.R.				
9	200618	. End Stop	3				
10	1007405	. Circuit Breaker (Buttwelder Option)	1	42	215212	. Fuse Block (Buttwelder Option)	2
11	420356	. Circuit Breaker (208V, 220V, 230V, 460V)	1	43	203614	. Fuse (8 Amp)	2
	420358	. Circuit Breaker (400V)	1	44	420356	. Circuit Breaker	1
12	1007400	. Circuit Breaker (208V, 400V)	1	45	215212	. Fuse Block	2
	1007399	. Circuit Breaker (220V, 230V)	1	46	203158	. Fuse (1 Amp)	2
	1007397	. Circuit Breaker (460V)	1	47	220642	. Motor Starter Protector	1
13	220644	. Motor Starter Protector (208V, 220V, 230V)	1	48	220654	. Auxiliary Contact	1
	220642	. Motor Starter Protector (400V, 460V) ..	1	49	215213	. Fuse Block	1
14	220654	. Auxiliary Contact	1	50	203613	. Fuse (10 Amp)	3
15	220648	. Motor Starter Protector (208V, 230V) ..	1				
	220649	. Motor Starter Protector (220V)	1				
	220647	. Motor Starter Protector (400V, 460V) ..	1				
16**	1007435	. Disconnect Switch	1				
17**	1007439	. Disconnect Switch Shaft	1				
18**	1007440	. Disconnect Switch Handle	1				
19	199126	. Nut, Hex. 3/8-16NC	4				
20	199325	. Washer, Lock 3/8 Std.	4				
21	320740	. Grounding Bus	1				
22	141639	. Wire Terminal Lug	1				
23	200615	. Terminal Block	15				
24	200617	. End Section	3	2	207786	. Resistor (40 Ohm) (208V, 220V, 230V)	1
25	200994	. Terminal Block Marker Set	A.R.		219330	. Resistor (160 Ohm) (400V, 460V).....	1
26	200618	. End Stop	4				
27	520141	. Control Panel	1				
28	207525	. Rivet Nut 1/4-28NF	2				
29	207523	. Screw, Hex. Hd. Slotted M6-1.0 x 20 ...	2				
30	204152	. Nylon Washer	2				
31	204151	. Retainer	2				
32	220233	. Control Relay (575V Only)	1				
33	220234	. Suppressor (575V Only)	1				
34	207200	. Control Relay	1				
35	207206	. Control Relay	1				

For 575V Machines:

42	215212	. Fuse Block (Buttwelder Option)	2
43	203614	. Fuse (8 Amp)	2
44	420356	. Circuit Breaker	1
45	215212	. Fuse Block	2
46	203158	. Fuse (1 Amp)	2
47	220642	. Motor Starter Protector	1
48	220654	. Auxiliary Contact	1
49	215213	. Fuse Block	1
50	203613	. Fuse (10 Amp)	3

Following Not Shown:

	1003427	. U.L. Label	1
	1012541	. Label (Machine Specifications)	1
	197341	. Wire, #12 Black (19 Strand)	A.R.
	197196	. Wire, #16 Black (19 Strand)	A.R.
	197343	. Wire, #16 Green/Yellow (19 Strand)	A.R.
	197325	. Wire, #16 White (19 Strand)	A.R.
	197197	. Wire, #16 Red (19 Strand)	A.R.
	197205	. Wire, #18 Blue (16 Strand)	A.R.

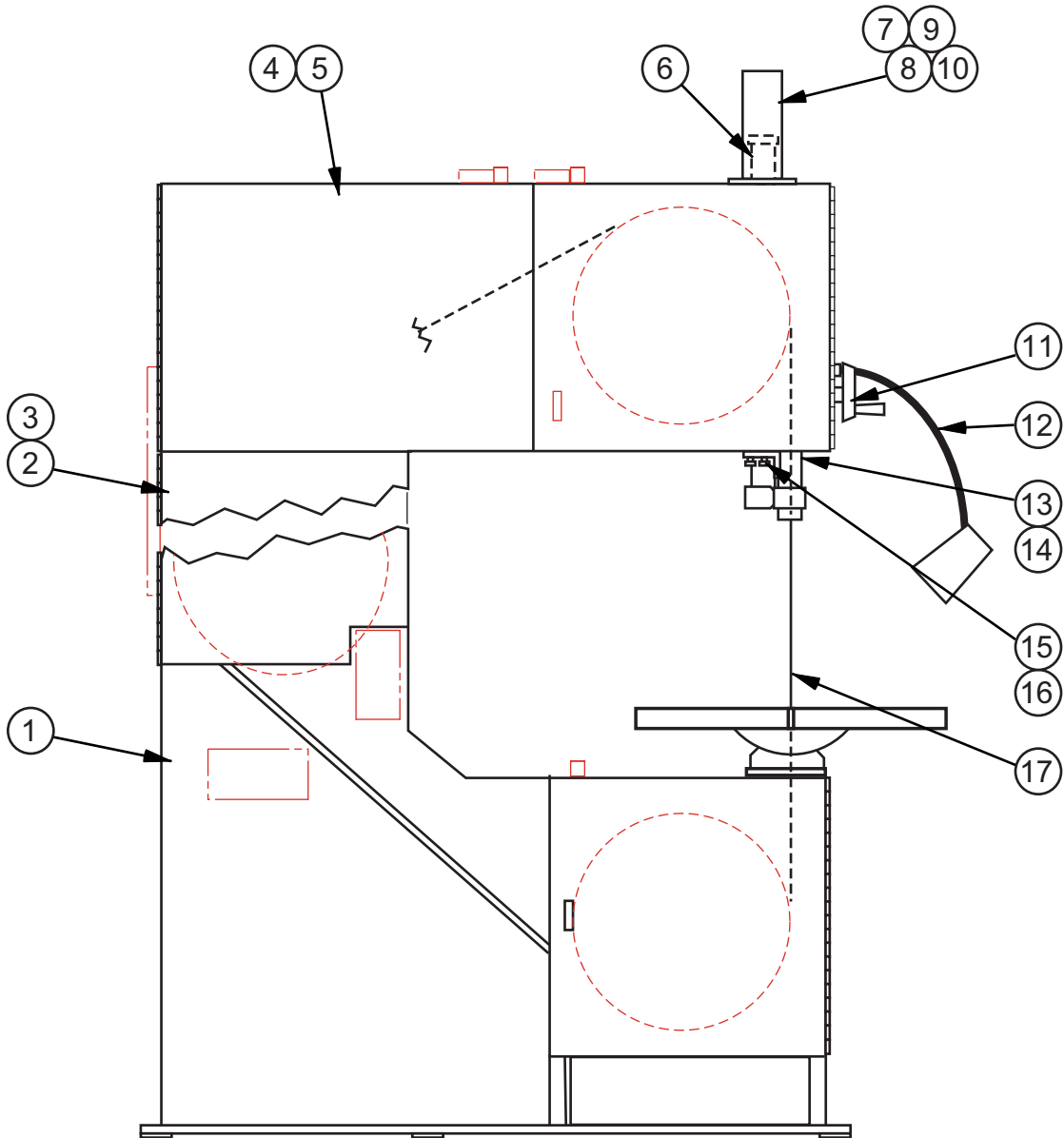
***NOTE: For Non Mitsubishi VFDs:**

2	207786	. Resistor (40 Ohm) (208V, 220V, 230V)	1
	219330	. Resistor (160 Ohm) (400V, 460V).....	1

****NOTE: Before Serial #570-09128:**

Order Disconnect Switch Service Kit - #1007554.
Otherwise, Use Part Numbers Listed.

NEW DRG. S.C.L. 7-8-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 2-27-08
S.C.L. 9-9-09



MODEL FIRST MACH. LAST MACH.

3613-1 577-04101

3613-V3 568-04101

3613-V5 569-04101

3612-VH 570-04101

EXTRA WORK HEIGHT ASSEMBLY

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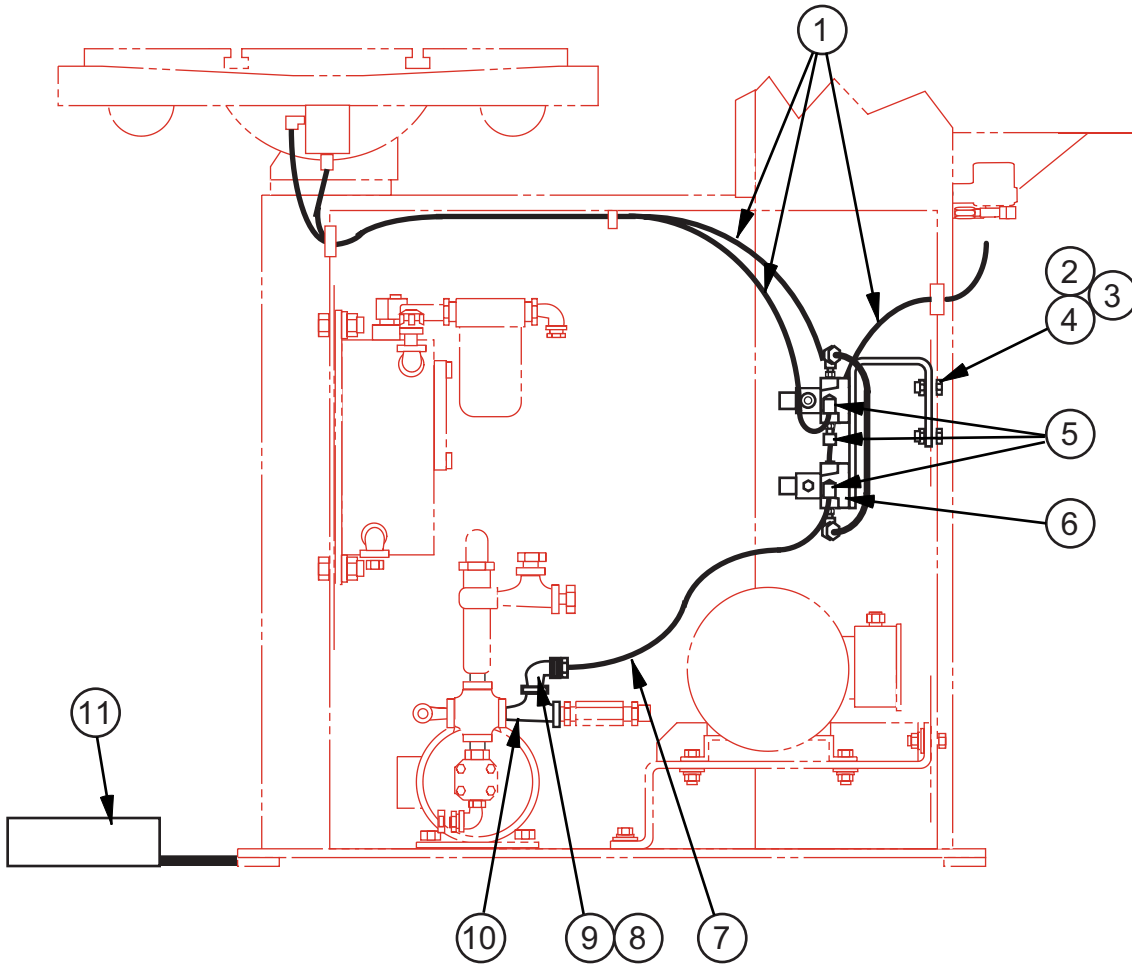
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EXTRA WORK HEIGHT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221234	19" Work Height Assembly (3619-1, 3619-V3, 3619-V5)	
Ref.	221195	18" Work Height Assembly (3618-VH)	
Ref.	221235	25" Work Height Assembly (3625-1, 3625-V3, 3625-V5)	
Ref.	221196	24" Work Height Assembly (3624-VH)	
Ref.	221236	31" Work Height Assembly (3631-1, 3631-V3, 3631-V5)	
Ref.	221197	30" Work Height Assembly (3630-VH)	
1	521631	. Frame Weldment (18" and 19" Work Heights)	1
	521632	. Frame Weldment (24" and 25" Work Heights)	1
	521633	. Frame Weldment (30" and 31" Work Heights)	1
2	420983	. Door Weldment (18" and 19" Work Heights)	1
	521638	. Door Weldment (24" and 25" Work Heights)	1
	521639	. Door Weldment (30" and 31" Work Heights)	1
3	199299	. Screw, Hex. Hd. Self-Drill M4.8 x 13	A.R.
4	420959	. Door Weldment	1
5	199299	. Screw, Hex. Hd. Self-Drill M4.8 x 13	6
6	506149	. Auxiliary Post Support Assembly (Work Heights Over 19") (See Detail)	1
7	326507	. Post Screw Cover Weldment (Work Heights Over 19")	1
8	198007	. Screw, Hex. Hd. Cap 1/4-20NC x 5/8	4
9	199321	. Washer, Lock 1/4 Std.	4
10	199115	. Nut, Hex. 1/4-20NC	4
11	407860	. Post Elevating Handwheel Assembly (18" and 19" Work Heights) (See Detail)	1
	407729	. Post Elevating Handwheel Assembly (24" and 25" Work Heights) (See Detail)	1
	407618	. Post Elevating Handwheel Assembly (30" and 31" Work Heights) (See Detail)	1
12	220671	. Worklamp Assembly (Optional) (See Detail)	1
13	306436	. Saw Band Guard Assembly (18" and 19" Work Heights)	1
	306312	. Saw Band Guard Assembly (24" and 25" Work Heights)	1
	305508	. Saw Band Guard Assembly (30" and 31" Work Heights)	1
	316926	. . Guard Weldment (18" and 19" Work Heights)	1
	316927	. . Guard Weldment (24" and 25" Work Heights)	1
	316923	. . Guard Weldment (30" and 31" Work Heights)	1
	316934	. . Guard Slide Cover	1
	133372	. . Thumb Screw	1
14	105304	. Spring Pin (Work Heights Up To 25" Only)	1
	004269	. Spring Pin (30" and 31" Work Heights Only)	1
15*	325695	. Guard Slide (Post) (6-5/8")	1
*	325696	. Guard Slide (Post) (12-5/8")	1
*	325697	. Guard Slide (Post) (18-5/8")	1
16	133372	. Thumb Screw	2
17	221229	. Saw Band (Super Silencer) (18" and 19" Work Heights)	1
	221230	. Saw Band (Super Silencer) (24" and 25" Work Heights)	1
	221231	. Saw Band (Super Silencer) (30" and 31" Work Heights)	1

*NOTE: Use These Interchangeable Guard Slides When Applicable.
 Use The Guard Slide That Will Cover Exposed Saw Band Completely.

NEW DRG. S.C.L. 8-22-06
REVISIONS
S.C.L. 3-17-08
S.C.L. 9-9-09



MODEL 2012-VH SHOWN.

MODEL FIRST MACH. LAST MACH.
 2012-VH 561-03101
 3612-VH 570-04101

FOOT SWITCH ASSEMBLY (3-WAY)

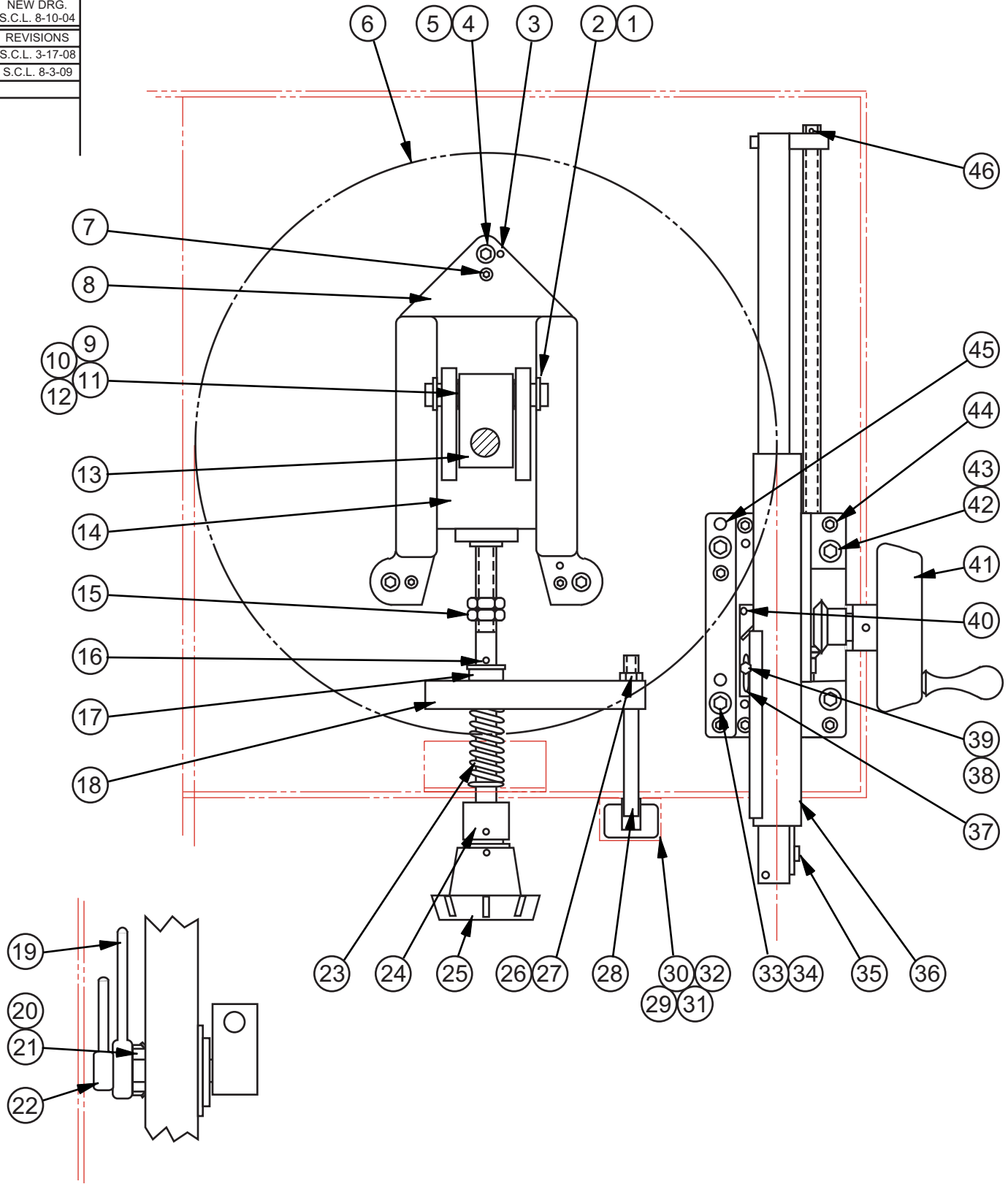
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FOOT SWITCH ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Foot Switch Assembly (3-Way)	
1	220746	. Hydraulic Hose	3
2	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	4
3	199323	. Washer, Lock 5/16 Std.	4
4	199122	. Nut, Hex. 5/16-18NC	4
5	008254	. 90° Street Elbow	5
6	420269	. Valve Manifold Assembly (Foot Switch) (See Detail)	1
7	220746	. Hydraulic Hose	1
8	5-011513	. 90° Street Elbow	1
9	5-011517	. Reducer Bushing	1
10	35-000982	. Service Tee	1
11	132927	. Foot Switch Assembly	1
	132926	. . Foot Switch	1
	129888	. . Escutcheon (Reverse)	1
	129887	. . Escutcheon (Forward)	1
	199396	. . Screw, Rd. Hd Drive #2 x 3/16	8

NEW DRG.
S.C.L. 8-10-04
REVISIONS
S.C.L. 3-17-08
S.C.L. 8-3-09



MODEL FIRST MACH. LAST MACH.
 2012-VH 561-03101
 3612-VH 570-04101

HEAD ASSEMBLY

HEAD ASSEMBLY

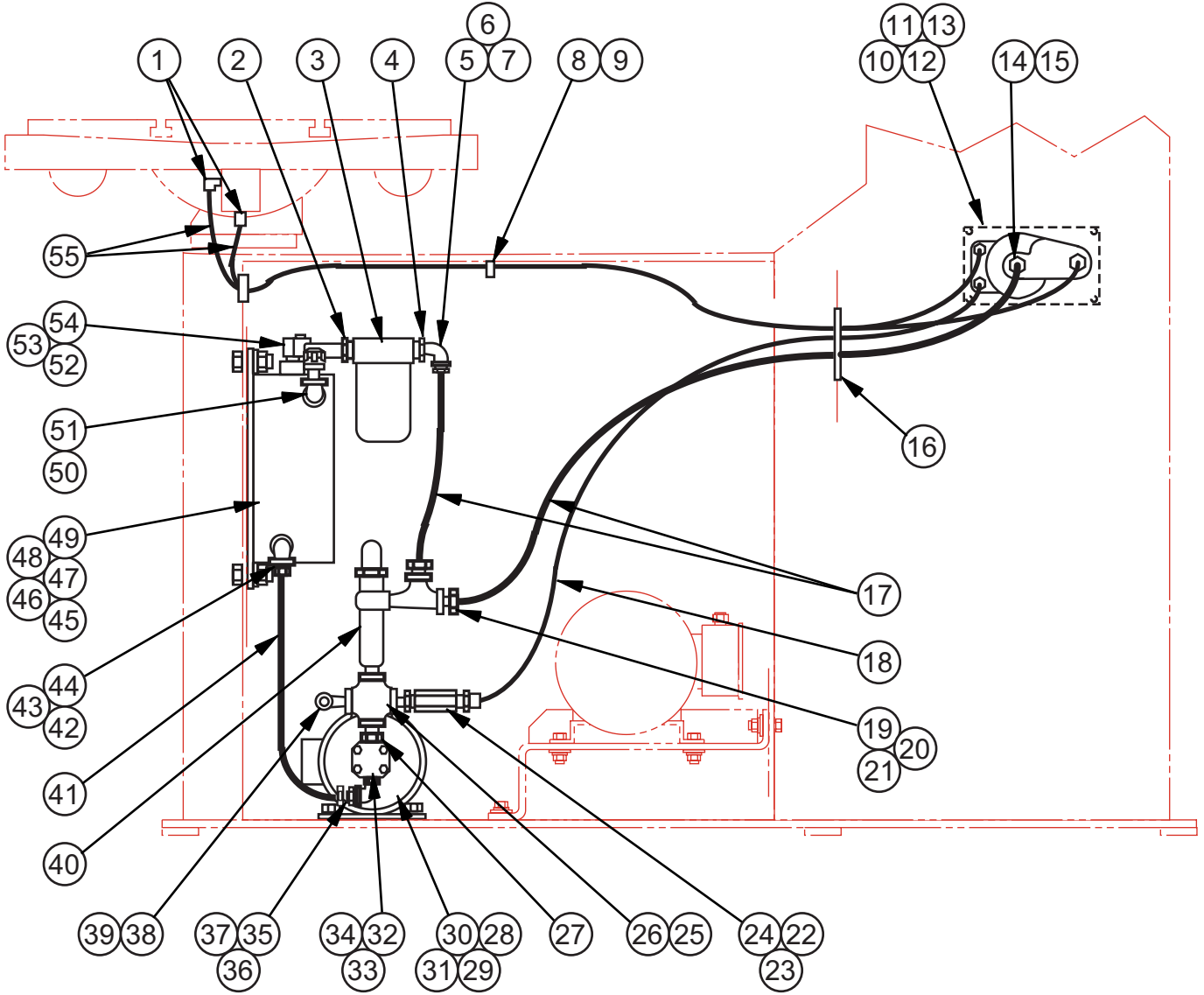
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	521515	Head Assembly	
1	120627	. Pin	1
2	35-009613	. Retaining Ring	2
3	004265	. Spring Pin	2
4	198264	. Screw, Soc. Hd. Cap 5/16-18NC x 2	3
5	199323	. Washer, Lock 5/16 Std.	3
6	406558	. Bandwheel Assembly (Upper) (See Detail)	1
7	198613	. Screw, Soc. Set 5/16-18NC x 1 (Half Dog Point)	3
8	504621	. Head Casting	1
9	133310	. Shim (.035)	A.R.
10	133311	. Shim (.0149)	A.R.
11	133312	. Shim (.005)	A.R.
12	133313	. Shim (.003)	A.R.
13	302346	. Wheel Hinge Assembly (See Detail)	1
14	407384	. Head Slide Weldment	1
15	199136	. Nut, Hex. Jam 5/18-11NC	2
16	004263	. Spring Pin	1
17	35-008615	. Thrust Ball Bearing	1
18	144060	. Angle	1
19	319252	. Lock Handle	1
20	5-001507	. Bearing Lockwasher	1
21	5-001506	. Bearing Locknut	1
22	319251	. Tilting Screw Handle (w/Stud)	1
23	100405	. Compression Spring	1
24	143397	. Band Tension Screw Assembly	1
	143294 Adaptor	1
	004261 Spring Pin	1
	305918 Screw	1
	6-004415 Set Screw Collar	1
	198424 Screw, Soc. Set 1/4-20NC x 3/8	1
25	009400	. Knob Assembly	1
	023916 Knob	1
	004792 Steel Ball	1
	113766 Spring	1
26	199123	. Nut, Hex. Jam 5/16-18NC	2
27	163080	. Retaining Compound (Loctite #271)	A.R.
28	142250	. Band Tension Pointer	1
29	139122	. Bracket (If Not Weded)	1
30	199465	. Screw, Rd. Hd. Self-Tap #10-24NC x 3/8	2
31	199320	. Washer, Lock #10 Std.	2
32	161533	. Escutcheon (Band Tension) (Inch/English)	1
	131424	. Escutcheon (Band Tension) (Metric/International)	1
33	198281	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/2	2
34	199325	. Washer, Lock 3/8 Std.	2
35	198698	. Screw, Fill. Hd. Mach. #10-24NC x 1/2	2
36*	306057	. Saw Band Guard Assembly (Standard)	1
	316925 Guard Weldment	1
	316934 Guard Slide Cover	1
	133372 Thumb Screw	1
37	142425	. Guard Stop Assembly	1
38	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	1
39	199258	. Washer, Flat #10 S.A.E. Std.	1
40	004223	. Spring Pin	1
41*	404971	. Post Elevating Handwheel Assembly (Standard) (See Detail)	1
42	198287	. Screw, Soc. Hd. Cap 3/8-16NC x 3	2
43	005150	. Washer, Lock 3/8 Hi-Collar	2
44	198459	. Screw, Soc. Set 3/8-24NF x 1	4
45	013122	. Dowel Pin	2
46	004231	. Spring Pin	1

*NOTE: Also See Extra Work Height Assembly If Applicable.

Following Not Shown:

148368	. Escutcheon (Post Elevating) (International)	1
199396	. Screw, Rd. Hd. Drive #2 x 3/16	3

NEW DRG.
S.C.L. 8-15-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 3-18-08
S.C.L. 9-9-09



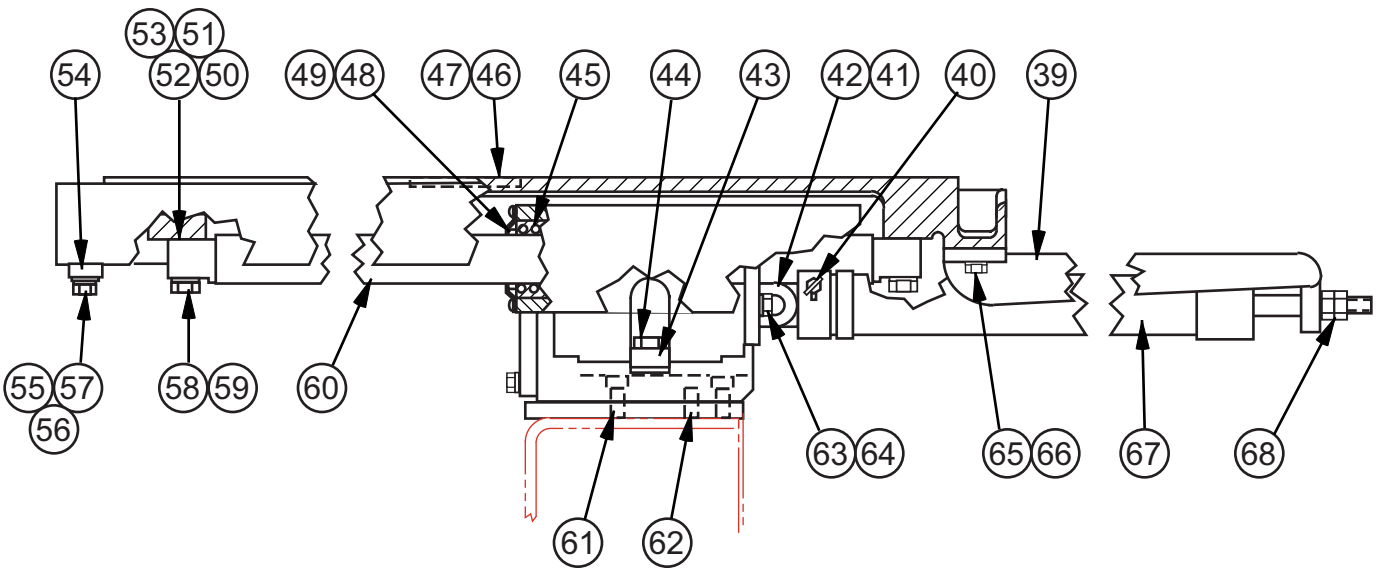
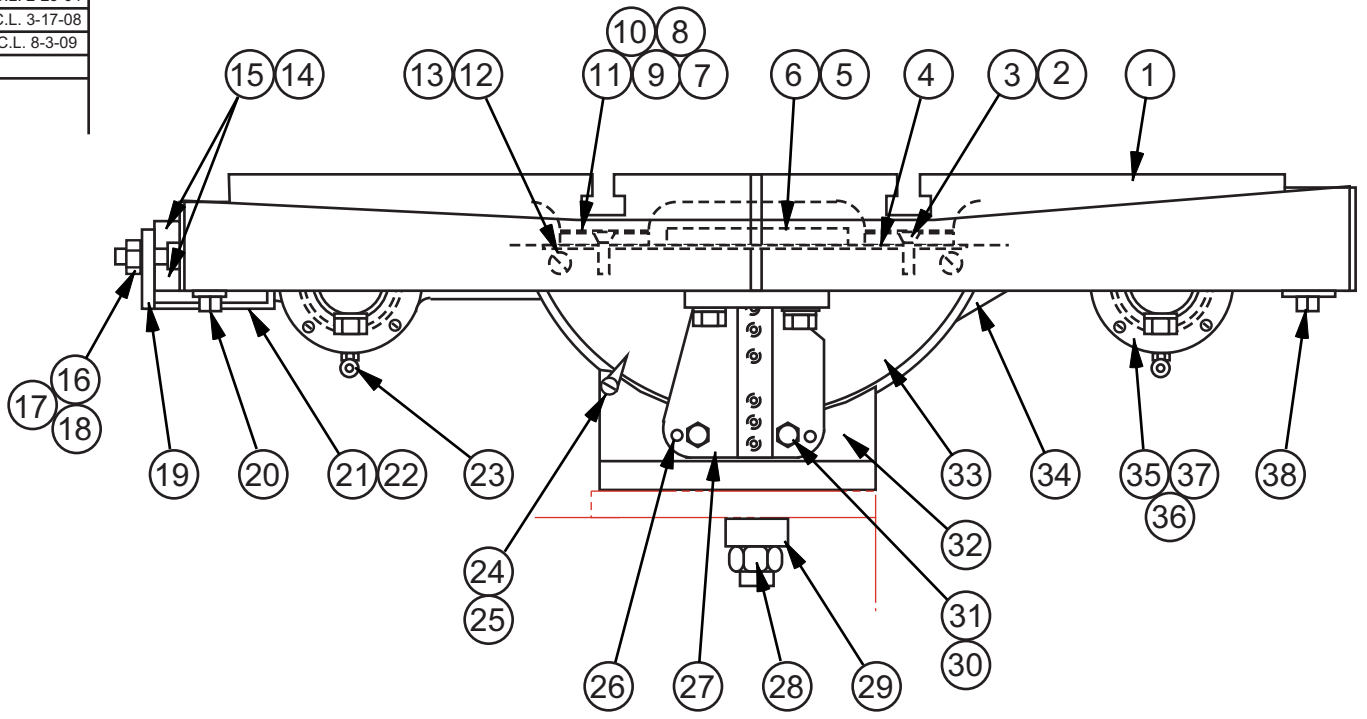
MODEL FIRST MACH. LAST MACH.
 3612-VH 570-04101

HYDRAULIC ASSEMBLY

HYDRAULIC ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	220743	Hydraulic Assembly	
1	105053	. 90° Street Elbow	2
2	35-003509	. Reducer Bushing	1
3	202652	. Oil Filter (Fairey Arlon)	1
	202653	. Filter Element	1
4	017546	. Reducer Bushing	1
5	601709	. 90° Street Elbow	1
6	014928	. Barbed Insert	1
7	017902	. Hose Clamp	1
8	206222	. Tube Clip	1
9	198005	. Screw, Hex. Hd. Cap 1/4-20NC x 3/8	1
10	043323	. Table Control Valve Assembly (See Detail)	1
11	198007	. Screw, Hex. Hd. Cap 1/4-20NC x 5/8	4
12	199321	. Washer, Lock 1/4 Std.	4
13	199115	. Nut, Hex. 1/4-20NC	4
14	014928	. Barbed Insert	1
15	017902	. Hose Clamp	1
16	197022	. Nylon Edging	A.R.
17	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
18	221583	. Hydraulic Hose	1
19	35-000982	. Service Tee	1
20	014928	. Barbed Insert	1
21	017902	. Hose Clamp	1
22	5-011517	. Reducer Bushing	1
23	14-003507	. Close Nipple	1
24	303418	. Orifice (.0625) (If Supplied)	1
25	002028	. Pipe Cross	1
26	35-001127	. Close Nipple	1
27	601369	. Pipe Adaptor	1
28	221031	. Electric Motor (.25 H.P.)	1
	610685	. Electric Motor (.5 H.P.) (575V Only)	1
29	198027	. Srew, Hex. Hd. Cap 5/16-18NC x 3/4	4
30	199262	. Washer, Flat 5/16 S.A.E. Std.	4
31	199323	. Washer, Lock 5/16 Std.	4
32	610173	. Gear Pump	1
33	198184	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
34	199325	. Washer, Lock 3/8 Std.	2
35	601365	. 90° Street Elbow	1
36	120904	. Barbed Insert	1
37	121288	. Hose Clamp	1
38	601709	. 90° Street Elbow	1
39	6-033518	. Pipe Plug	1
40	123783	. Relief Valve	1
41	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
42	14-000347	. 90° Street Elbow	1
43	120904	. Barbed Insert	1
44	121288	. Hose Clamp	1
45	967683	. Reservoir Weldment	1
46	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	4
47	199122	. Nut, Hex. 5/16-18NC	4
48	199323	. Washer, Lock 5/16 Std.	4
49	974291	. Sight Gauge Assembly	1
50	002973	. 90° Street Elbow	1
51	600100	. Filter Breather	1
52	133540	. Street Tee	1
53	113737	. Pipe Plug	1
54	14-011545	. Pipe Nipple	1
55	221583	. Hydraulic Hose	2
Following Not Shown:			
	203101	. Instruction Tag	1
	201030	. Transmission Fluid	A.R.
	201180	. Escutcheon (ATF Specifications)	1

NEW DRG.
S.C.L. 7-30-03
REVISIONS
S.C.L. 2-25-04
S.C.L. 3-17-08
S.C.L. 8-3-09



MODEL FIRST MACH. LAST MACH.
 2012-VH 561-03101
 3612-VH 570-04101

HYDRAULIC TABLE ASSEMBLY

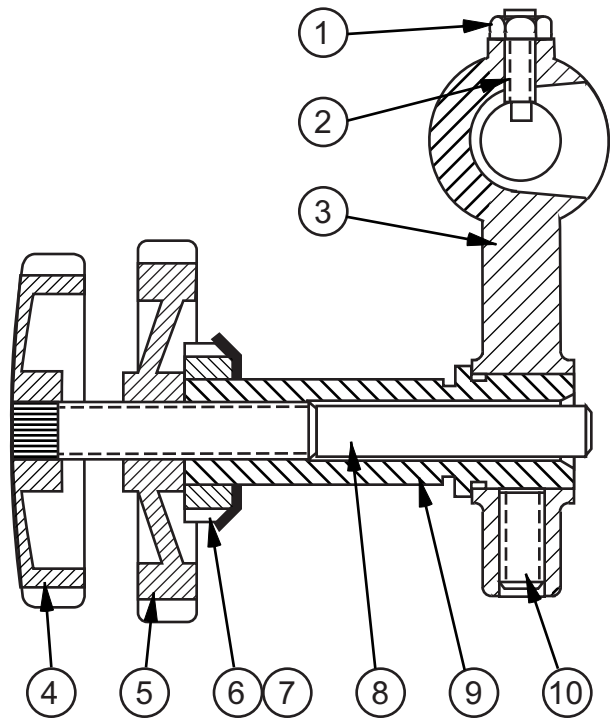
CM - 3 - 103

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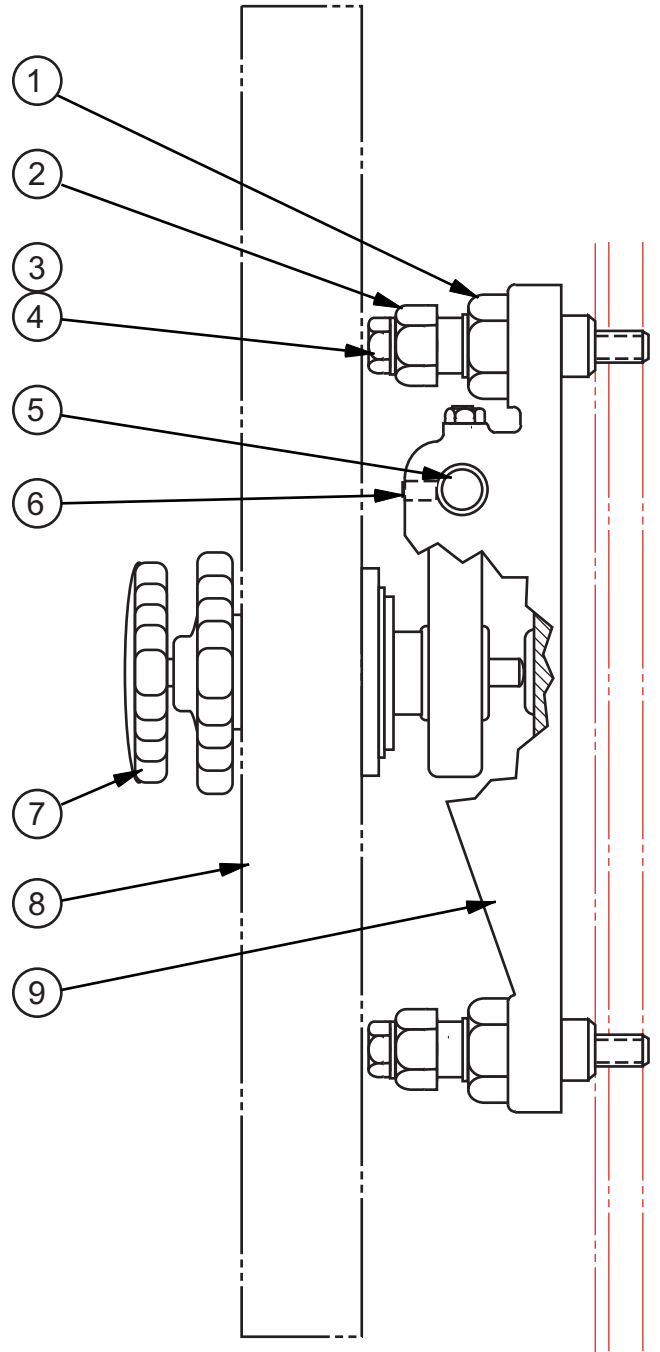
HYDRAULIC TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	220747	Hydraulic Table Assembly		46	010490	. Center Plate	1
Ref.	220748	Hydraulic Table Assembly (18" Stroke Option)		47	004209	. Spring Pin	1
1	501380	. Table	1	48	165507	. Rod Wiper	4
	518044	. Table (18" Stroke Option)	1	49	260468	. O-Ring	4
2	034229	. Way Bar	4	50	133310	. Shim (.035)	A.R.
3	198320	. Screw, Flat Hd. Soc. 1/4-20NC x 3/4 ...	4	51	133311	. Shim (.0149)	A.R.
4	034212	. Cover	1	52	133312	. Shim (.005)	A.R.
5	041072	. Pan	1	53	133313	. Shim (.003)	A.R.
	518292	. Sliding Pan Assembly (18" Stroke Option)	1	54	004599	. Clamp	1
6	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8	4	55	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
7	111552	. Shim (.003)	A.R.	56	199325	. Washer, Lock 3/8 Std.	2
8	111553	. Shim (.005)	A.R.	57	199264	. Washer, Flat 3/8 S.A.E. Std.	1
9	111554	. Shim (.008)	A.R.	58	198069	. Screw, Hex. Hd. Cap 1/2-13NC x 2	4
10	111555	. Shim (.0149)	A.R.	59	199327	. Washer, Lock 1/2 Std.	4
11	111556	. Shim (.002)	A.R.	60	021612	. Guide Rod	2
12	198893	. Screw, Rd. Hd. Mach. 1/4-20NC x 3/8	2		321738	. Guide Rod (18" Stroke Option)	2
13	199356	. Washer, Lock 1/4 Shakeproof	2	61	198291	. Screw, Soc. Hd. Cap 1/2-13NC x 3/4 ...	4
14	023967	. Slide Bar	2	62	35-000445	. Dowel Pin (1-1/2" Long)	1
	321369	. Slide Bar (18" Stroke Option)	2		016351	. Dowel Pin (1" Long)	1
15	198221	. Screw, Soc. Hd. Cap #10-24NC x 5/8	10	63	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	2
16	009392	. T-Bolt 5/16-18NC	2	64	199323	. Washer, Lock 5/16 Std.	2
17	199323	. Washer, Lock 5/16 Std.	2	65	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4 ..	4
18	199122	. Nut, Hex. 5/16-18NC	2	66	199325	. Washer, Lock 3/8 Std.	2
19	009504	. Dog	2	67	325801	. Table Feed Cylinder	1
20	6-033518	. Pipe Plug	1		325802	. Table Feed Cylinder (18" Stroke Option)	1
21	009503	. Stop	1	68	199134	. Nut, Hex. Jam 1/2-20NF	2
22	198895	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2	2				
23	008790	. 90° Grease Fitting	2				
24	34-003315	. Pointer	1				
25	198838	. Screw, Rd. Hd. Mach. #6-32NC x 1/4 ..	1				
26	133875	. Dowel Pin	2				
27	024241	. Keeper Block	1				
28	199141	. Nut, Hex. 3/4-16NF	1				
29	010501	. Spacer	1				
30	198047	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/4	2				
31	199325	. Washer, Lock 3/8 Std.	2				
32	040903	. Cradle	1				
33	021621	. Trunnion Plate	1				
34	050791	. Trunnion	1				
35	005176	. Retainer	4				
36	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8	16				
37	199319	. Washer, Lock #10 Std.	16				
38	35-006580	. Pipe Plug	1				
39	041061	. Cylinder Bracket	1				
	418499	. Cylinder Bracket Weldment (18" Stroke Option)	1				
40	110063	. Drain Valve	1				
41	021594	. Swivel Base	1				
42	005130	. Pin	1				
43	039464	. Head	1				
44	198106	. Screw, Hex. Hd. Cap 3/4-16NF x 5	1				
45	003647	. Ball Bushing	4				

NEW DRG. S.C.L. 7-8-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09



WHEL HINGE ASSEMBLY



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

IDLER BANDWHEEL ASSEMBLY (THIRD WHEEL)

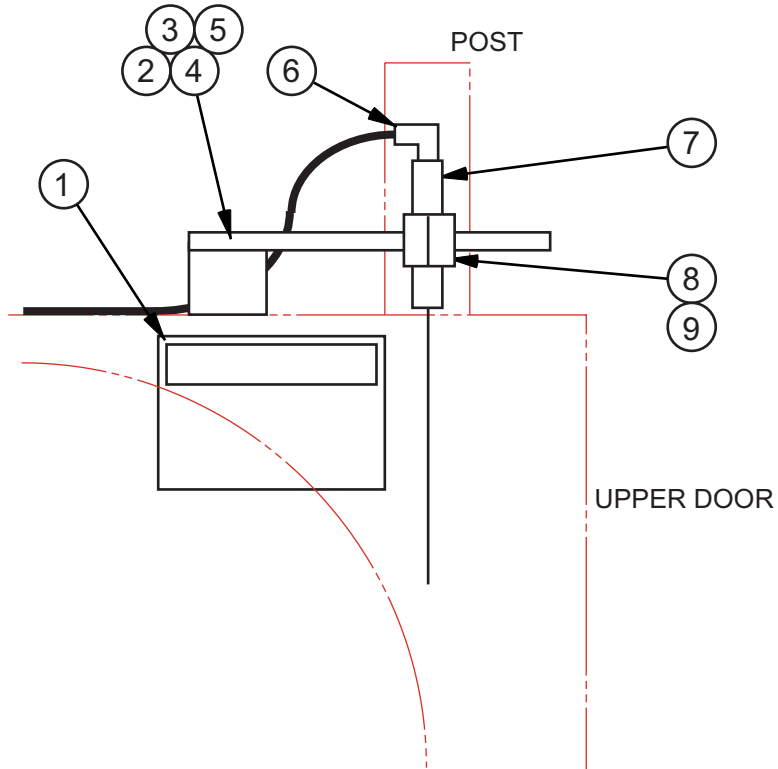
C - 2 - 120 CM - 2 - 133

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IDLER BANDWHEEL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	521622	Idler Bandwheel Assembly (Third Wheel) (Crowned Bandwheels)	
Ref.	521623	Idler Bandwheel Assembly (Third Wheel) (Flanged Bandwheels)	
1	199142	. Nut, Hex. Jam 3/4-16NF	3
2	208549	. Adjustable Screw	3
3	198053	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4	3
4	199325	. Washer, Lock 3/8 Std.	3
5	35-008610	. Hinge Pin	1
6	198428	. Screw, Soc. Set 1/4-20NC x 1	2
7	021547	. Wheel Hinge Assembly (Idler) (See Detail)	1
8	402598	. Bandwheel Assembly (Idler) (Crowned Bandwheels) (See Detail)	1
	406558	. Bandwheel Assembly (Idler) (Flanged Bandwheels) (See Detail)	1
9	041264	. Bracket	1
Ref.	021547	. Wheel Hinge Assembly (Idler)	
1	199114	. . Nut, Hex. Jam 1/4-20NC	1
2	003862	. . Screw, Soc. Set 1/4-20NC x 3/4 (Dog Pt.)	1
3	021546	. . Wheel Hinge	1
4	5-001108	. . Tilting Screw Knob	1
5	5-001109	. . Tilting Locknut	1
6	5-001506	. . Bearing Locknut	1
7	5-001507	. . Bearing Lockwasher	1
8	5-001425	. . Tilting Screw	1
9	5-001424	. . Wheel Axis Stud	1
10	198451	. . Screw, Soc. Set 3/8-16NC x 3/4	1

NEW DRG. S.C.L. 3-17-09
REVISIONS



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
ZV-3620	565-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	

LASER LINE GENERATOR ASSEMBLY

C - 10 - 65 CM - 10 - 45 Z - 10 - 33

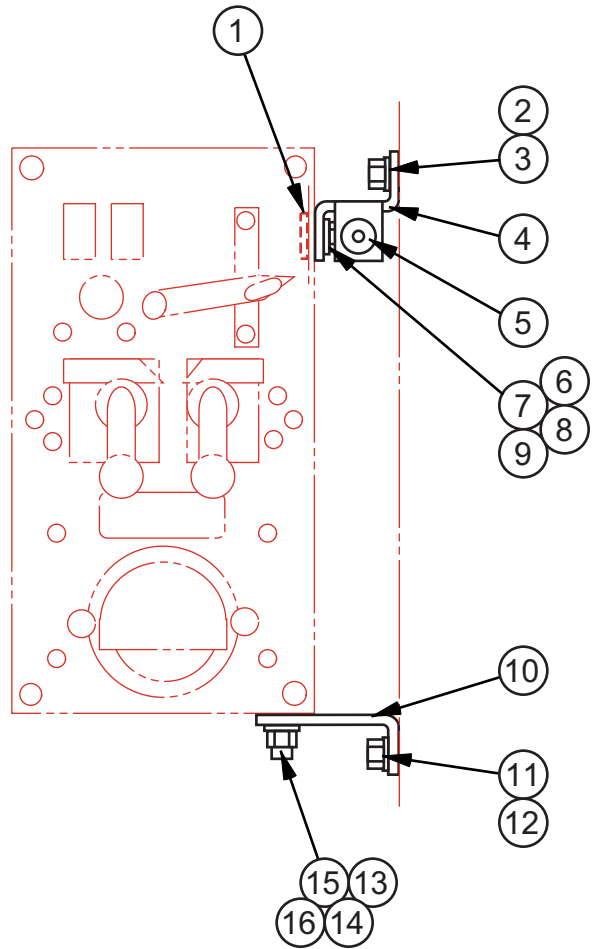
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LASER LINE GENERATOR ASSEMBLY

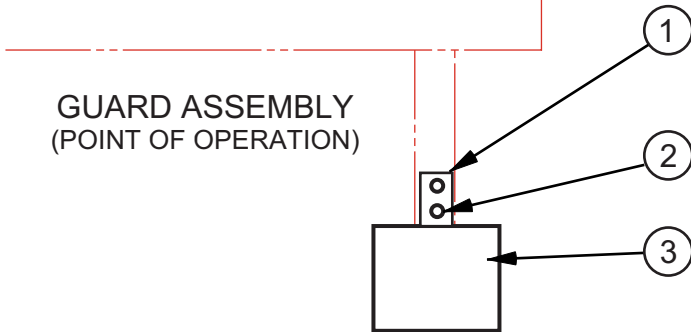
INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Laser Line Generator Assembly	
1	212884	. Label (Caution - Laser)	1
2	326740	. Laser Mounting Bracket Weldment	1
	322740	. Laser Mounting Bracket Weldment (ZV-3620 Only)	1
3	199923	. Screw, Soc. Hd. Cap M6-1.0 x 10	2
4	199965	. Washer, Flat M6	2
5	199347	. Washer, Lock M6	2
6	222859	. Laser Cordset	1
7	223548	. Laser Line Generator (Red) (24VDC)	1
8	322650	. Laser Holder	1
9	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	2

NEW DRG. S.C.L. 8-5-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09

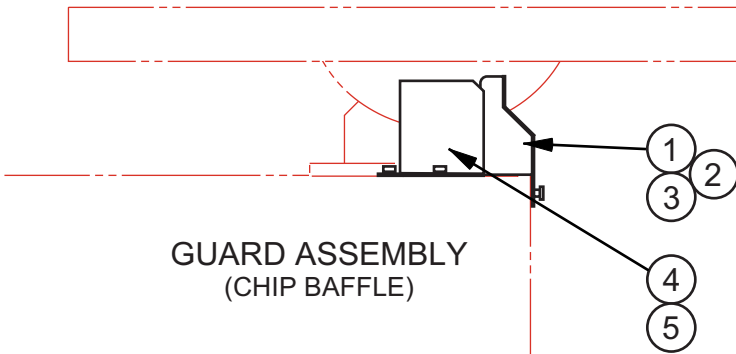
WELDER MOUNTING
BRACKET ASSEMBLY



GUARD ASSEMBLY
(POINT OF OPERATION)



GUARD ASSEMBLY
(CHIP BAFFLE)



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

MISCELLANEOUS ASSEMBLIES

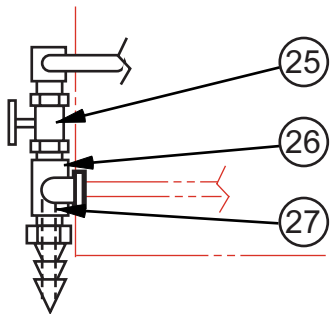
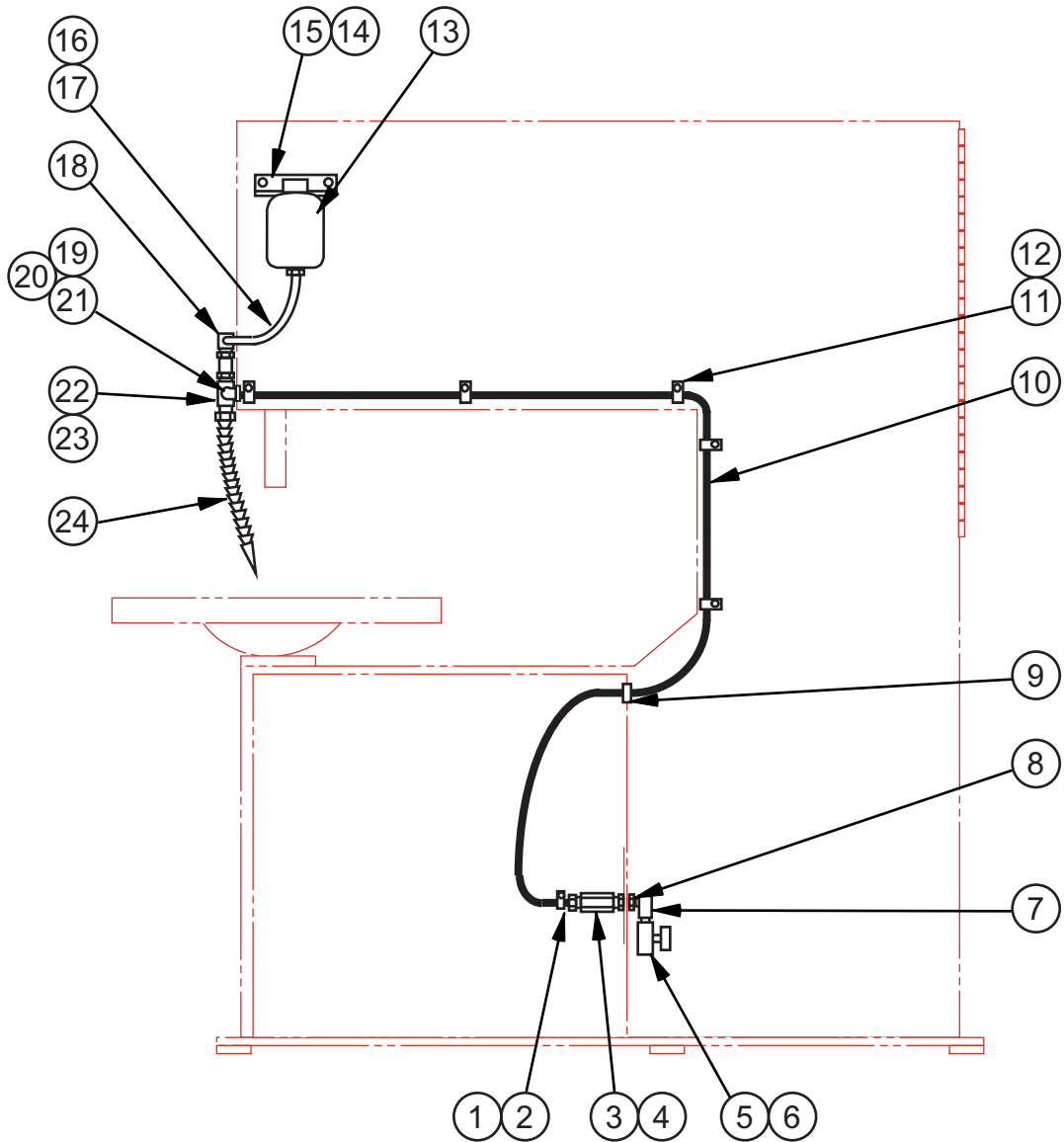
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MISCELLANEOUS ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221216	Welder Mounting Bracket Assembly (With Optional Buttwelder)	
1	172397	. Bar	1
2	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
3	199325	. Washer, Lock 3/8 Std.	2
4	325921	. Upper Mounting Bracket	1
5	012235	. Rubber Grommet	1
6	198184	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
7	199325	. Washer, Lock 3/8 Std.	2
8	199264	. Washer, Flat 3/8 S.A.E. Std.	2
9	199126	. Nut, Hex. 3/8-16NC	2
10	325920	. Lower Mounting Bracket	1
11	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
12	199325	. Washer, Lock 3/8 Std.	2
13	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
14	199325	. Washer, Lock 3/8 Std.	2
15	199264	. Washer, Flat 3/8 S.A.E. Std.	2
16	199126	. Nut, Hex. 3/8-16NC	2
Ref.	320639	Guard Assembly (Point of Operation) (Optional)	
1	213713	. Guard Mounting Plate	1
2	146046	. Thumb Screw Assembly	2
	131086	. . Knob	1
	198219	. . Screw, Soc. Hd. Cap #10-24NC x 3/8	1
2	203546	. Spacer	2
3	319337	. Upper Guard (Plexiglas)	1
Ref.	221612	Guard Assembly (Chip Baffle)	
1	326062	. Side Guard Weldment	1
2	133438	. Thumb Screw	2
3	164686	. Escutcheon (Remove Guard...) (English)	1
	163694	. Escutcheon (Remove Guard...) (International)	1
4	326063	. Door Guard	1
5	199299	. Screw, Hex. Hd. Self-Drill M4.8 x 13	2

NEW DRG. S.C.L. 7-2-04
REVISIONS
S.C.L. 3-18-08



COOLANT MANIFOLD DETAIL

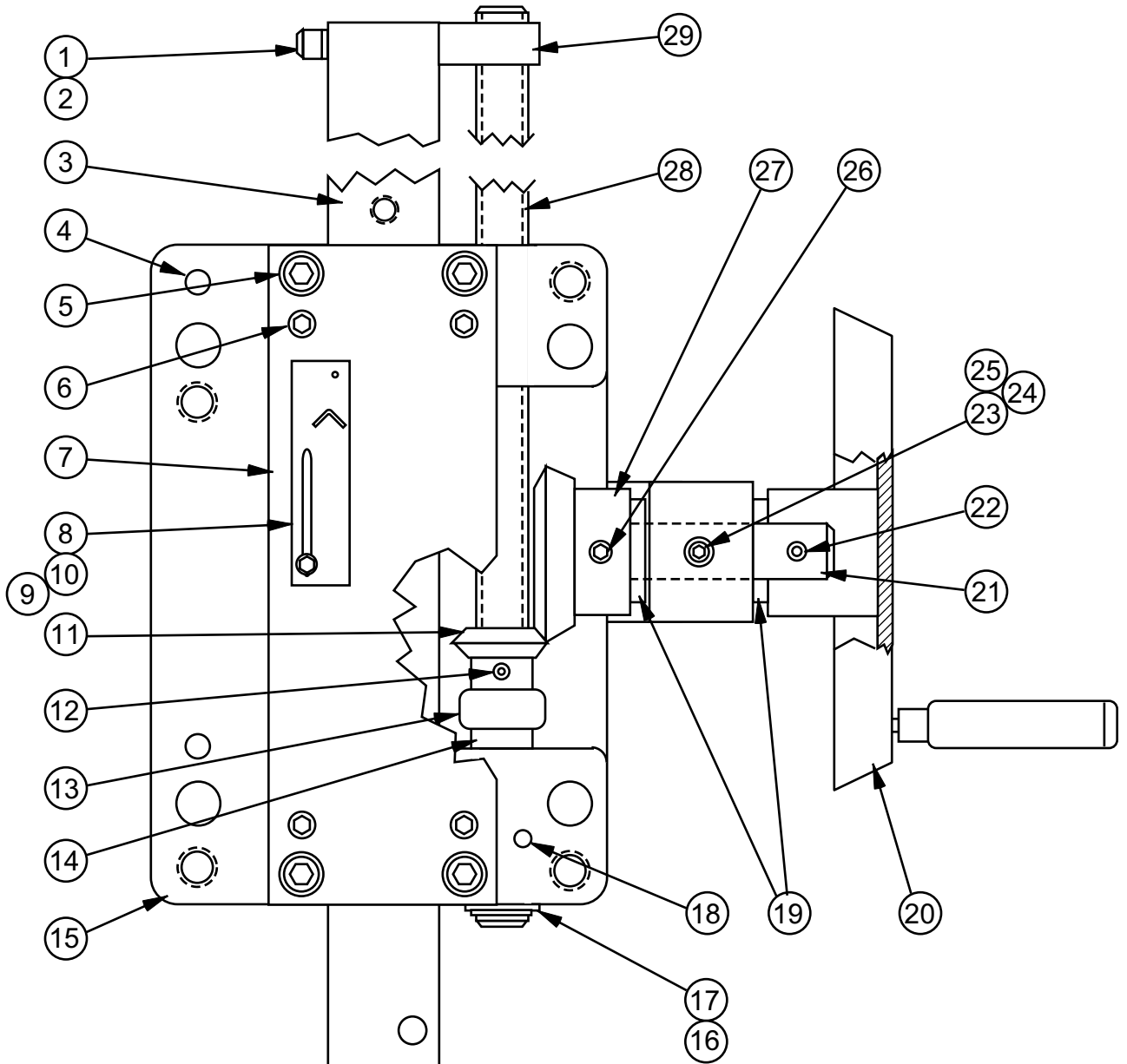
MODEL FIRST MACH. LAST MACH.
3613-VH 570-04101

MIST COOLANT ASSEMBLY

MIST COOLANT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221199	Mist Coolant Assembly	
1	002004	. Barbed Insert	1
2	35-006888	. Hose Clamp	2
3	319526	. Orifice (.038 Dia.) (Brass)	1
4	201746	. Close Nipple (Brass)	1
5	178934	. Ball Valve	1
6	201746	. Close Nipple (Brass)	1
7	008254	. 90° Street Elbow	1
8	203818	. Anchor Connection	1
9	006803	. Grommet	1
10	198094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
11	115652	. Tubing Clamp	5
12	199484	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2	5
13	136918	. Bottle Assembly	1
14	303956	. Bracket	1
15	199484	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2	2
16	197144	. Plastic Tubing 3/8 O.D. (Clear)	A.R.
17	104713	. Hose Clamp	2
18	108116	. 90° Barbed Insert	1
19	5-004520	. 90° Street Elbow	1
20	128179	. Barbed Insert	1
21	017902	. Hose Clamp	1
22	199483	. Screw, Rd. Hd. Mach. #10-24NC x 1-1/2	2
23	038303	. Coolant Manifold Assembly (Standard)	1
	038304	. Coolant Manifold Assembly (18" Work Height)	1
	307334	. Coolant Manifold Assembly (24" Work Height)	1
	311565	. Coolant Manifold Assembly (30" Work Height)	1
24	172530	. . Coolant And Air Hose (Standard)	1
	172531	. . Coolant And Air Hose (18" Work Height)	1
	172532	. . Coolant And Air Hose (24" Work Height)	1
	172533	. . Coolant And Air Hose (30" Work Height)	1
	172529	. . . Connector	1
	197322	. . . Segmented Hose (Specify Length)	A.R.
	172528	. . . Nozzle	1
25	5-027507	. . Sight Feed Valve	1
26	119910	. . Manifold	1
27	121061	. . Coolant Tube Assembly (Cut to Length)	1
	197140	. . . Nylon Tubing .089 O.D. (Specify Length)	A.R.
	136893	. . . Glue (Meta Grip #3802)	A.R.
	119912	. . . Pipe Plug	1

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 8-16-06
S.C.L. 4-4-07
S.C.L. 2-11-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	
2613-V3	589-09101	

POST ELEVATING HANDWHEEL ASSEMBLY

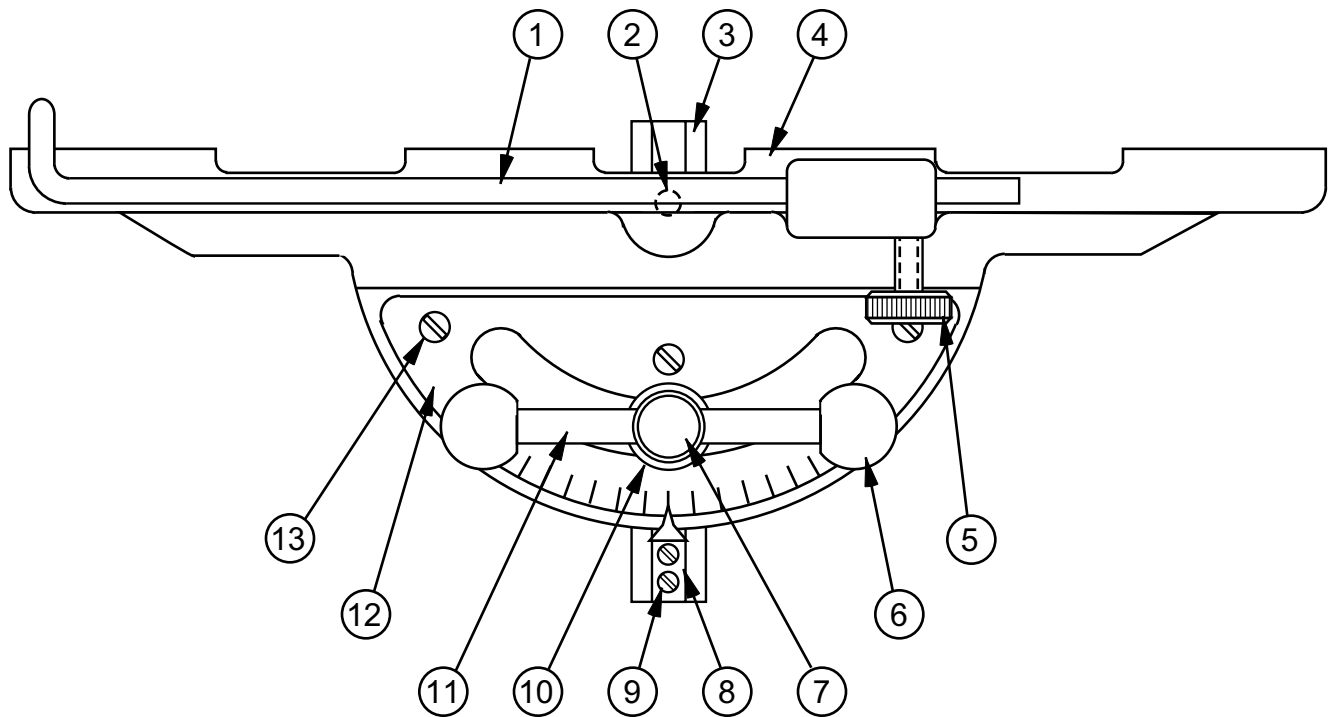
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POST ELEVATING HANDWHEEL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	404971	Post Elevating Handwheel Assembly (Standard)	
Ref.	407860	Post Elevating Handwheel Assembly (18" and 19" Work Heights)	
Ref.	407729	Post Elevating Handwheel Assembly (24" and 25" Work Heights)	
Ref.	407618	Post Elevating Handwheel Assembly (30" and 31" Work Heights)	
1	198245	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/2	2
2	199374	. Washer, Lock 1/4 Shakeproof	2
3	303029	. Post (25.94") (Standard)	1
	306242	. Post (31.94") (18" and 19" Work Heights)	1
	306243	. Post (37.94") (24" and 25" Work Heights)	1
	306244	. Post (43.94") (30" and 31" Work Heights)	1
4	013122	. Dowel Pin	2
5	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1	4
6	198576	. Screw, Soc. Set 5/16-18NC x 3/4 (Flat Pt.)	4
7	303030	. Cover	1
8	142425	. Guard Stop Weldment	1
9	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	1
10	199258	. Washer, Lock #10 S.A.E. Std.	1
11	125566	. Bevel Gear	1
12	004240	. Spring Pin	1
13	016063	. Thrust Ball Bearing	1
14	133113	. Tubing	1
15	404970	. Housing	1
16	317286	. Retaining Ring	1
17	5-013309	. Spacer	A.R.
18	004263	. Spring Pin	1
19	120922	. Bearing	2
20	216098	. Handwheel	1
21	123901	. Pin	1
22	004259	. Spring Pin	1
23	198422	. Screw, Soc. Set 1/4-20NC x 1/4	1
24	003971	. Compression Spring	1
25	140765	. Friction Plug	1
26	004259	. Spring Pin	1
27	125567	. Bevel Gear	1
28	132667	. Shaft (21.88") (Standard)	1
	143983	. Shaft (27.88") (18" and 19" Work Heights)	1
	143984	. Shaft (33.88") (24" and 25" Work Heights)	1
	143985	. Shaft (39.88") (30" and 31" Work Heights)	1
29	132666	. Nut	1

NEW DRG. S.C.L. 9-18-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-11-08



USED ON T-SLOT TABLES.

PROTRACTOR WORK STOP AND ALIGNING GAGE ASSEMBLY

C - 10 - 42 CM - 10 - 7

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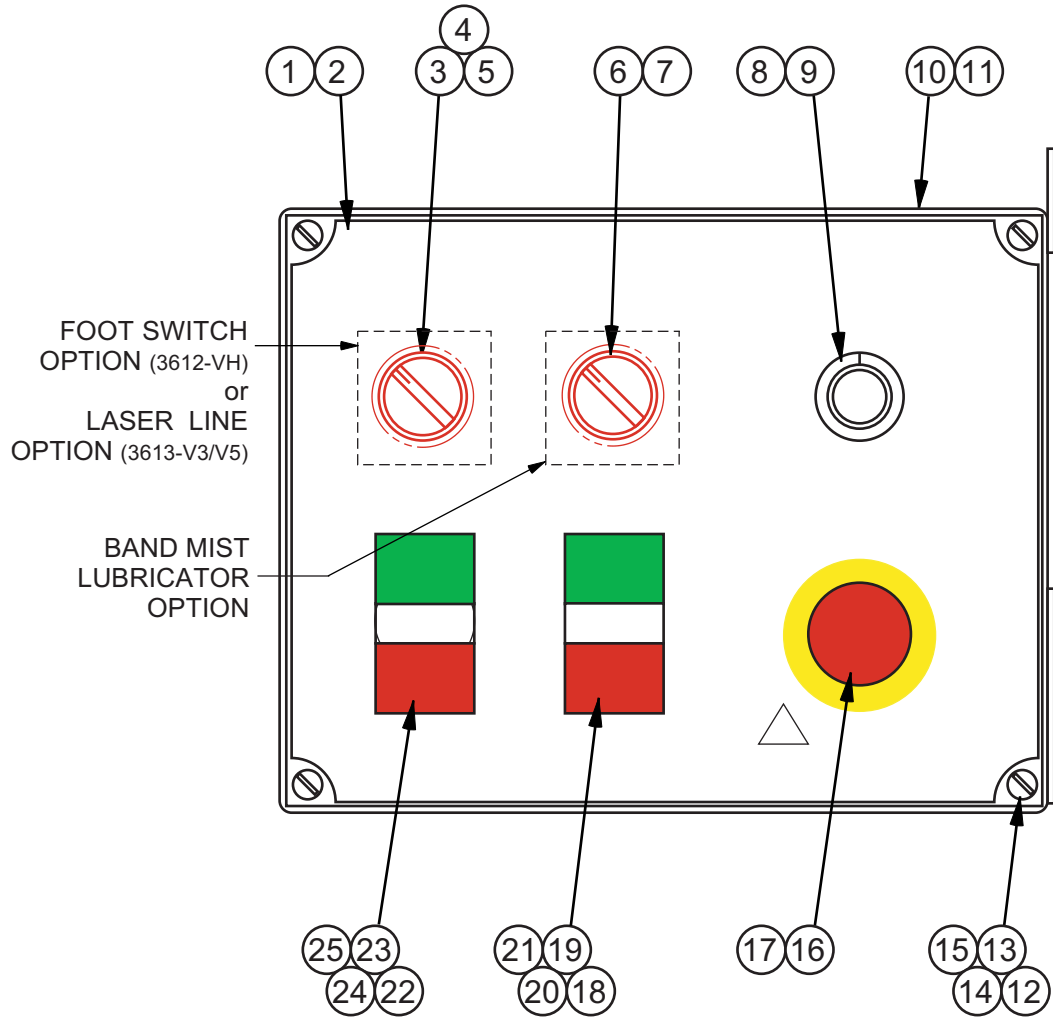
**PROTRACTOR WORK STOP
and
ALIGNMENT GAGE ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.*	051495	Protractor Work Stop And Aligning Gage Assembly	
1	35-001976	. Gage Rod.....	1
2	14-000473	. Dowel Pin	1
3*	025302	. T-Nut	1
4	051496	. Miter Head	1
5	34-017401	. Thumbnut	1
6	133971	. Knob	2
7*	011635	. Stud	1
8	011633	. Pointer	1
9	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	2
10	199265	. Washer, Flat 7/16 S.A.E. Std.	1
11	011634	. Shaft	1
12	35-001614	. Protractor Plate	1
13	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8	3

*NOTE: For Model 26-HB2

Ref.	054758	Protractor Work Stop And Aligning Gage Assembly	
3	029162	. T-Nut	1
7	101118	. Stud	1

NEW DRG. S.C.L. 7-21-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 2-28-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

PUSHBUTTON BOX ASSEMBLY

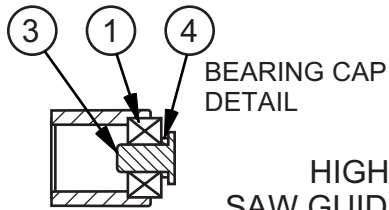
C - 6 - 23 CM - 6 - 30

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PUSHBUTTON BOX ASSEMBLY

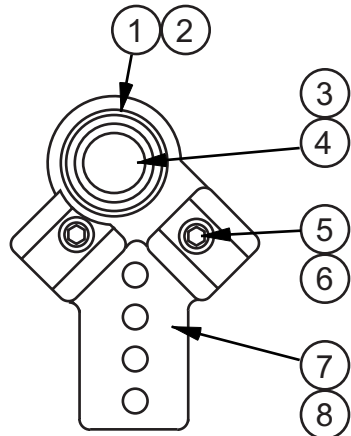
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221383	Pushbutton Box Assembly	
1	325980	. Backer Plate	1
2**	325979	. Escutcheon (Standard)	1
	326639	. Escutcheon (Foot Switch Option)	1
3**	135106	. Hole Seal (Standard)	1
	207182	. Selector Switch (3 Position) (Foot Switch Option)	1
4**	207185	. Contact Block (1-NO) (Foot Switch Option)	1
5	211501	. Contact Block (2-NC) (Foot Switch Option)	1
6	135106	. Hole Seal (Standard)	1
	207181	. Selector Switch (2 Position) (Mist Lubricator Option)	1
7	207185	. Contact Block (1-NO) (Mist Lubricator Option)	1
8*	223553	. Potentiometer (Mitsubishi VFD)	1
9	178146	. Knob	1
10	531680	. Pushbutton Enclosure	1
11	215267	. Gasket Strip	A.R.
12	207171	. Rivet Nut M5-0.8	4
13	207170	. Screw, Hex. Hd. Slotted M5-0.8 x 20	4
14	204150	. Retaining Ring	4
15	204152	. Nylon Washer	4
16	207191	. Pushbutton Operator (Red Mushroom)	1
17	207186	. Contact Block (1-NC)	1
18	221140	. Double Pushbutton Operator (Red/Green)	1
19	207185	. Contact Block (1-NO)	1
20	207186	. Contact Block (1-NC)	1
21	221385	. Seal Boot	1
22	135106	. Hole Seal (3613-V3, 3613-V5)	1
	221140	. Double Pushbutton Operator (Red/Green) (3612-VH Only)	1
23	207185	. Contact Block (1-NO) (3612-VH Only)	1
24	207186	. Contact Block (1-NC) (3612-VH Only)	1
25	221385	. Seal Boot (3612-VH Only)	1
*NOTE: For Machines With Safronic VFDs:			
8	178275	. Potentiometer	1
**NOTE: For Machines With Laser Line Generator:			
2	1003970	. Escutcheon (Laser Line Option)	1
3	207181	. Selector Switch (2 Position)	1
4	207185	. Contact Block (1-NO)	1

NEW DRG.	S.C.L. 9-25-97
REVISIONS	
S.C.L. 2-20-04	
S.C.L. 2-11-08	

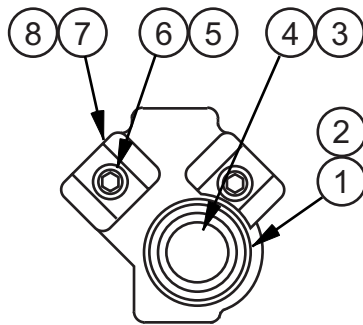


BEARING CAP
DETAIL

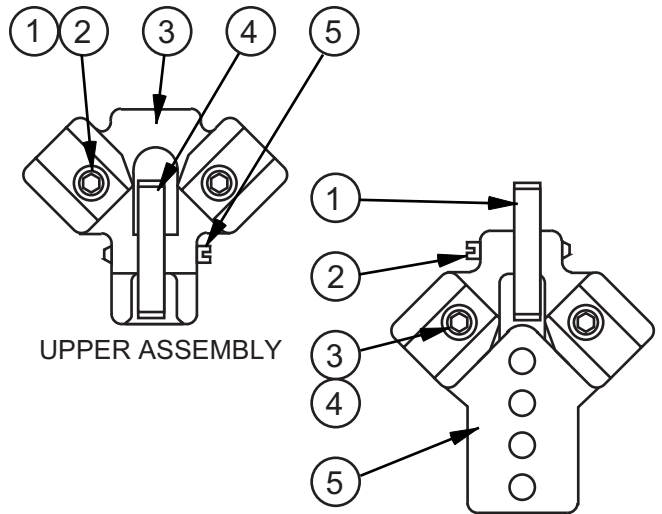
HIGH SPEED
SAW GUIDE ASSEMBLY
(CROWNED BANDWHEELS)
(1/16" - 1/2" SAW BANDS)



LOWER ASSEMBLY



UPPER ASSEMBLY



UPPER ASSEMBLY

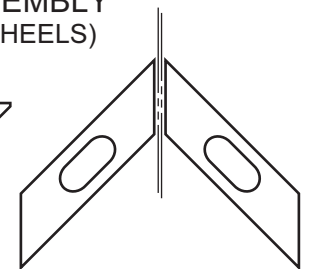
LOWER ASSEMBLY

SAW GUIDE ASSEMBLY
(FLANGED BANDWHEELS)

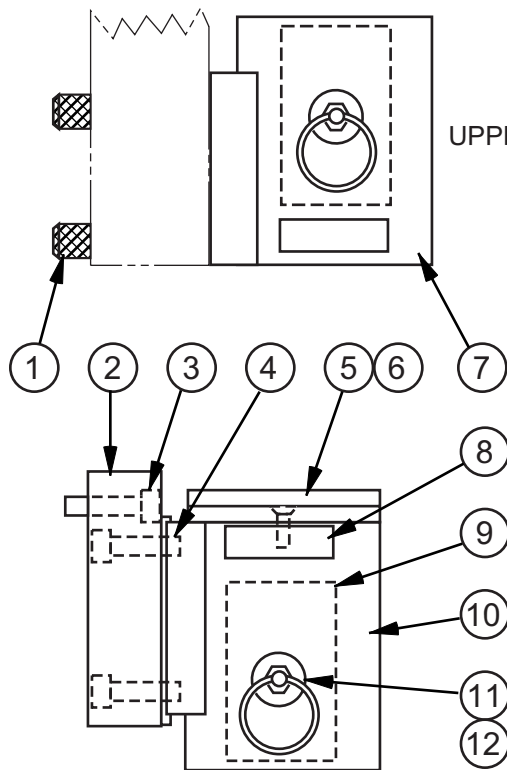
STANDARD



SAW GUIDE
INSERT GAGE

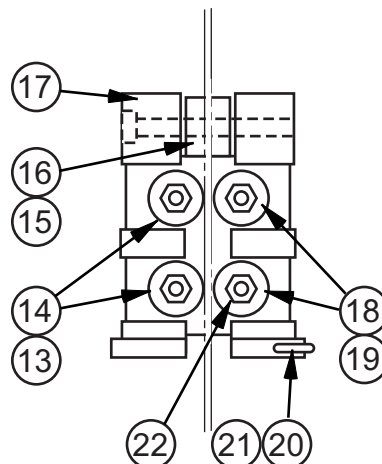


SAW GUIDE INSERTS



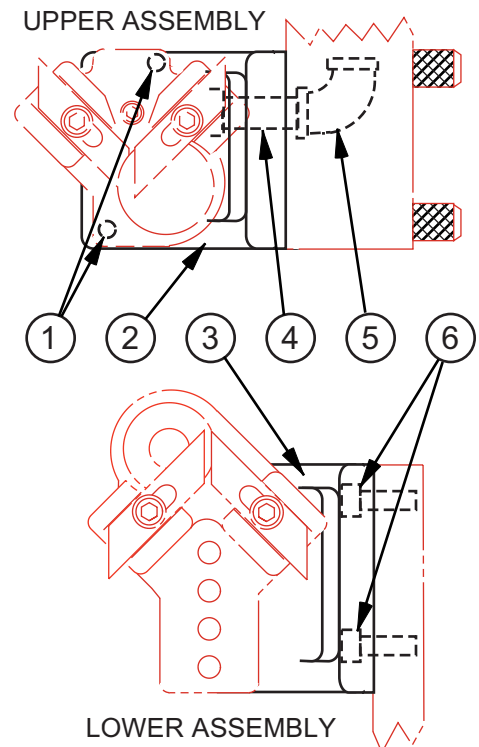
UPPER ASSEMBLY

LOWER ASSEMBLY



TYPICAL FOR
BOTH GUIDES

ADJUSTABLE ANGLE SAW GUIDE ASSEMBLY



UPPER ASSEMBLY

LOWER ASSEMBLY
90° SAW GUIDE ASSEMBLY

SAW GUIDE ASSEMBLIES
(STANDARD and SPECIAL APPLICATION)

SAW GUIDE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	028081	Upper Saw Guide Assembly (High Speed) (1/16"-1/2")	
1*	011529	. Ball Bearing	1
2	011541	. Retaining Ring (If Supplied)	1
3*	018415	. Bearing Cap	1
4*	176845	. Spacer	1
5	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 ..	2
6	34-008502	. Insert Washer	2
7	027981	. Upper Saw Guide Block	1
8	137339	. Hole Plug (If Supplied)	1

Ref.	028082	Lower Saw Guide Assembly (High Speed) (1/16"-1/2")	
1*	011529	. Ball Bearing	1
2	011541	. Retaining Ring (If Supplied)	1
3*	018415	. Bearing Cap	1
4*	176845	. Spacer	1
5	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 ...	2
6	34-008502	. Insert Washer	2
7	027983	. Lower Saw Guide Block	1
8	137339	. Hole Plug (If Supplied)	1

*NOTE: When ordering any of the marked items, ordering #085369 - Bearing Replacement Kit is recommended.

STANDARD FOR FLANGE BANDWHEELS

Ref.	304843	Upper Saw Guide Assy (Carbide Insert).	
1	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2
2	34-008502	. Insert Washer	2
3	406430	. Upper Saw Guide Block	1
4	121210	. Back-Up Insert	1
5	140204	. Pivot Bolt	1

Ref.	304844	Lower Saw Guide Assy (Carbide Insert).	
1	121210	. Back-up Insert	1
2	140204	. Pivot Bolt	1
3	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2
4	34-008502	. Insert Washer	2
5	406768	. Lower Saw Guide Block	1

90° SAW GUIDE ASSEMBLY

Ref.	416651	90° Saw Guide Assy (26" Table)	
Ref.	044804	90° Saw Guide Assy (30" Table)	
1	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1	2
2	027597	. 90° Upper Angle Saw Guide Bracket....	1
3	027596	. 90° Lower Angle Saw Guide Bracket....	1
4	011658	. Pipe Nipple	1
5	35-003647	. 90° Elbow	1
6	198239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 ..	2
	317853	. Center Plate (Oval) (Not Shown)	1
	029261	. Center Plate (Round)(Not Shown).....	1
	416371	. Chip Baffle (If Supplied) (Not Shown)..	1
	133372	. Thumb Screw (Not Shown)	1

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	205025	Adjustable Angle Saw Guide Set (26" Table)	
Ref.	205114	Adjustable Angle Saw Guide Set (30" Table)	
1	018500	. Upper Saw Guide Holding Screw	2
2	319704	. Adaptor Bar	1
3	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1 ..	1
4	198241	. Screw, Soc. Hd. Cap 1/4-20NC x 7/82	
5	205024	. Cap	1
6	198739	. Screw, Flat Hd. Mach. #6-32NC x 3/8	2
7	417525	. Upper Saw Guide Housing	1
8	205818	. Label (Logo)	1
9	205802	. Label (Warning)	1
10	417522	. Lower Saw Guide Housing	1
11	205020	. Spring Plunger	1
12	205399	. Split Ring	1
13	205022	. Roller Bearing	2
14	319979	. Eccentric Stud	2
15	205022	. Roller Bearing	1
16	35-000328	. Dowel Pin	1
17	417524	. Upper Saw Guide	1
	417523	. Lower Saw Guide	1
18	205022	. Roller Bearing	2
19	320173	. Concentric Stud	2
20	205817	. Sleeve Cap	1
21	004219	. Spring Pin	1
22	017655	. Locknut #10-24NC	4

Following Not Shown:

204909	. Gage	1
319939	. Saw Band Guard Assembly	1
319930	. Guard Weldment	1
316934	. Sliding Guard	1
133372	. Thumb Screw	1
317592	. Center Plate (26" Table)	1
120128	. Center Plate (30" Table)	1

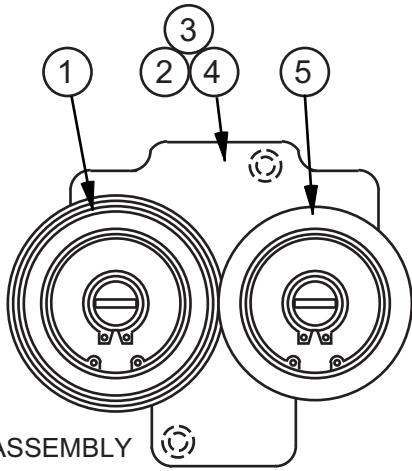
SAW GUIDE INSERT GAGE

34-008320	. Insert Gage (.025)	1
13-008303	. Insert Gage (.032)	1
13-009307	. Insert Gage (.035)	1
34-008506	. Box (For Inserts and Gages)	1

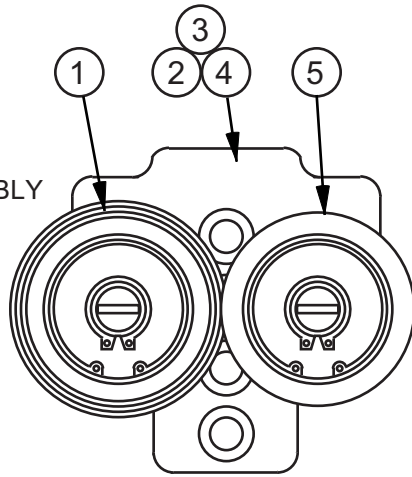
SAW GUIDE INSERT SELECTION

<u>STEEL</u>	<u>SIZE</u>	<u>CARBIDE</u>
004499	1/16"	
004498	3/32"	
004497	1/8"	141759
004496	3/16"	
004495	1/4"	016168
003960	3/8"	016170
003959	1/2"	013291
003958	5/8"	105894
003957	3/4"	013292
003956	1"	008982

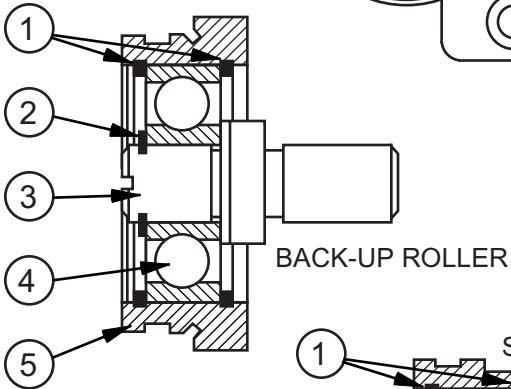
NEW DRG.
S.C.L. 9-30-97
REVISIONS
S.C.L. 2-20-04
S.C.L. 2-11-08



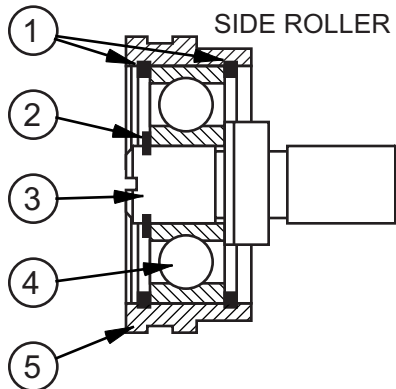
UPPER ASSEMBLY



LOWER ASSEMBLY

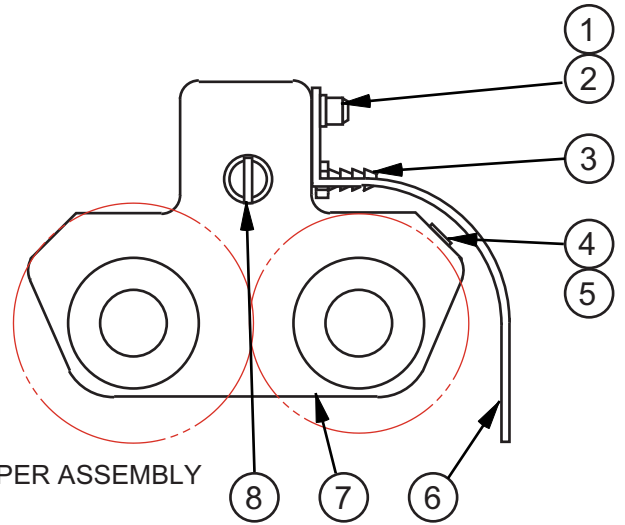


BACK-UP ROLLER

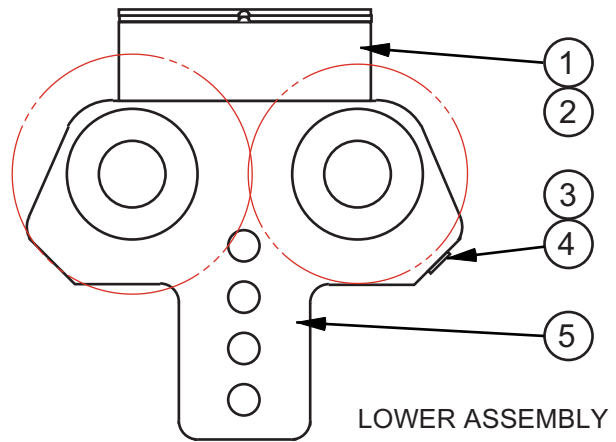


SIDE ROLLER

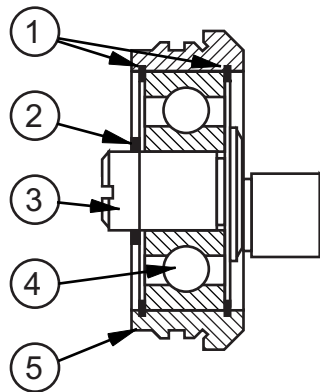
TYPE I - ROLLER SAW GUIDE ASSEMBLY



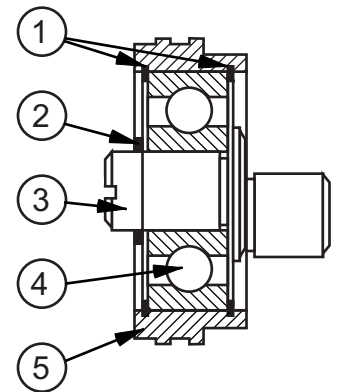
UPPER ASSEMBLY



LOWER ASSEMBLY



BACK-UP ROLLER



SIDE ROLLER

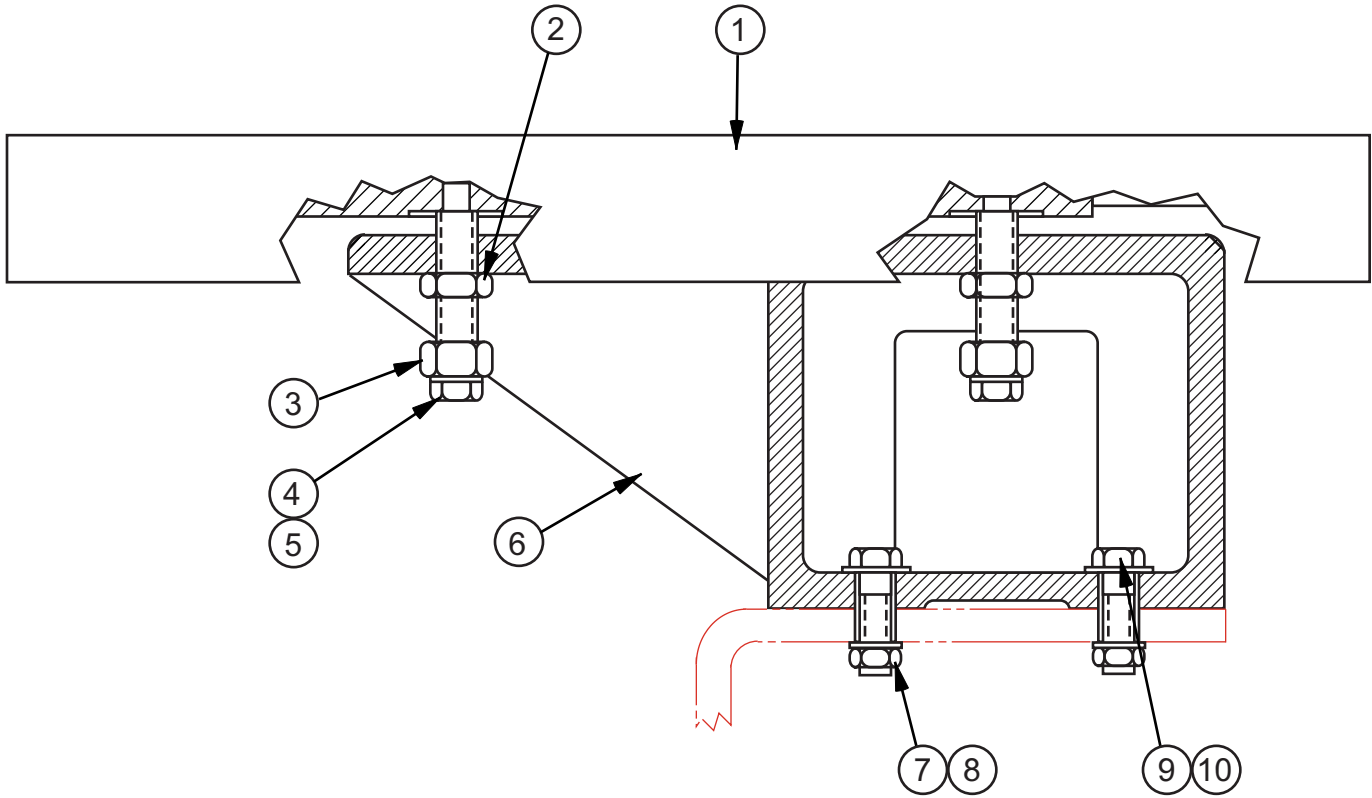
TYPE II - ROLLER SAW GUIDE ASSEMBLY

SAW GUIDE ASSEMBLIES (ROLLER TYPE)

SAW GUIDE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
<u>TYPE I – ROLLER SAW GUIDE ASSEMBLY</u>				<u>TYPE II ROLLER ASSEMBLIES</u>			
Ref.	029256	1/4" Upper Roller Saw Guide Assembly		Ref.	020798	1/4" Back-Up Roller Assembly	
Ref.	029258	3/8" Upper Roller Saw Guide Assembly		Ref.	020808	3/8" Back-Up Roller Assembly	
Ref.	029506	1/2" Upper Roller Saw Guide Assembly		Ref.	020295	1/2" Back-Up Roller Assembly	
1	See Below	. Back-Up Roller Assy (See Detail)	1	Ref.	021071	5/8" Back-Up Roller Assembly	
2	028960	. Upper Guide Block	1	Ref.	020296	3/4" Back-Up Roller Assembly	
3	198239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 ..	2	Ref.*	028968	1" Back-Up Roller Assembly	
4	199321	. Washer, Lock 1/4 Std.	2	1	001303	. Retaining Ring	2
5	See Below	. Side Roller Assy (See Detail)	1	2	001568	. Retaining Ring	1
Ref.	029257	1/4" Lower Roller Saw Guide Assembly		3	013530	. Spindle	1
Ref.	029259	3/8" Lower Roller Saw Guide Assembly		4	001779	. Ball Bearing	2
Ref.	029505	1/2" Lower Roller Saw Guide Assembly		5	013532	. 1/4" Back-Up Roller	1
1	See Below	. Back-Up Roller Assy (See Detail)	1	Ref.	013541	. 3/8" Back-Up Roller	1
2	028961	. Lower Guide Block	1	013534	. 1/2" Back-Up Roller	1	
3	199239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 ..	2	013543	. 5/8" Back-Up Roller	1	
4	199321	. Washer, Lock 1/4 Std.	2	013536	. 3/4" Back-Up Roller	1	
5	See Below	. Side Roller Assy (See Detail)	1	100757	. 1" Back-Up Roller	1	
<u>TYPE I – ROLLER ASSEMBLIES</u>				Ref.	020799	1/4" Side Roller Assembly	
Ref.	028982	1/4" Back-Up Roller Assembly		Ref.	020807	3/8" Side Roller Assembly	
Ref.	028978	3/8" Back-Up Roller Assembly		Ref.	020292	1/2" Side Roller Assembly	
Ref.	028976	1/2" Back-Up Roller Assembly		Ref.	021072	5/8" Side Roller Assembly	
1	100046	. Retaining Ring	2	Ref.	020293	3/4" Side Roller Assembly	
2	011541	. Retaining Ring	1	Ref.*	028967	1" Side Roller Assembly	
3	018296	. Shaft	1	1	001303	. Retaining Ring	2
4	011529	. Ball Bearing	2	2	001568	. Retaining Ring	1
5	028983	. 1/4" Back-up Roller	1	3	013530	. Spindle	1
	028979	. 3/8" Back-up Roller	1	4	001779	. Ball Bearing	2
	028977	. 1/2" Back-up Roller	1	5	013531	. 1/4" Side Roller	1
Ref.	028984	1/4" Side Roller Assembly		Ref.	013540	. 3/8" Side Roller	1
Ref.	028980	3/8" Side Roller Assembly		013533	. 1/2" Side Roller	1	
Ref.	028974	1/2" Side Roller Assembly		013542	. 5/8" Side Roller	1	
1	100046	. Retaining Ring	2	013535	. 3/4" Side Roller	1	
2	011541	. Retaining Ring	1	100758	. 1" Side Roller	1	
3	018296	. Shaft	1	*NOTE: To Be Used With Flanged Rubber-Tired Wheels Using 1/4", 1/2", 3/4" or 1" Bands. Also Used With Steel Flanged or Rubber Crowned Wheels Using 1" Band Only.			
4	011529	. Ball Bearing	2				
5	028985	. 1/4" Side Roller	1				
	028981	. 3/8" Side Roller	1				
	028975	. 1/2" Side Roller	1				
<u>TYPE II – ROLLER SAW GUIDE ASSEMBLY</u>							
Ref.	109517	Upper Saw Guide Block Assembly					
1	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2 ..	1				
2	199321	. Washer, Lock 1/4 Std.	1				
3	016001	. Barbed Insert	1				
4	198448	. Screw, Soc. Set 3/8-16NC x 3/8	2				
5	001741	. Plug	2				
6	033636	. Coolant Guard	1				
7	033517	. Upper Saw Guide Block	1				
8	033509	. Coolant Nozzle	1				
Ref.	017215	Lower Saw Guide Block Assembly					
1	002140	. Chip Deflector	1				
2	198235	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8 ..	2				
3	198449	. Screw, Soc. Set 3/8-16NC x 1/2	2				
4	001741	. Plug	2				
5	027743	. Lower Saw Guide Block	1				
Not Shown (For Both Upper and Lower Guides):							
	131798	. Cloth Bag	1				

NEW DRG. S.C.L. 7-5-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

SECONDARY TABLE ASSEMBLY

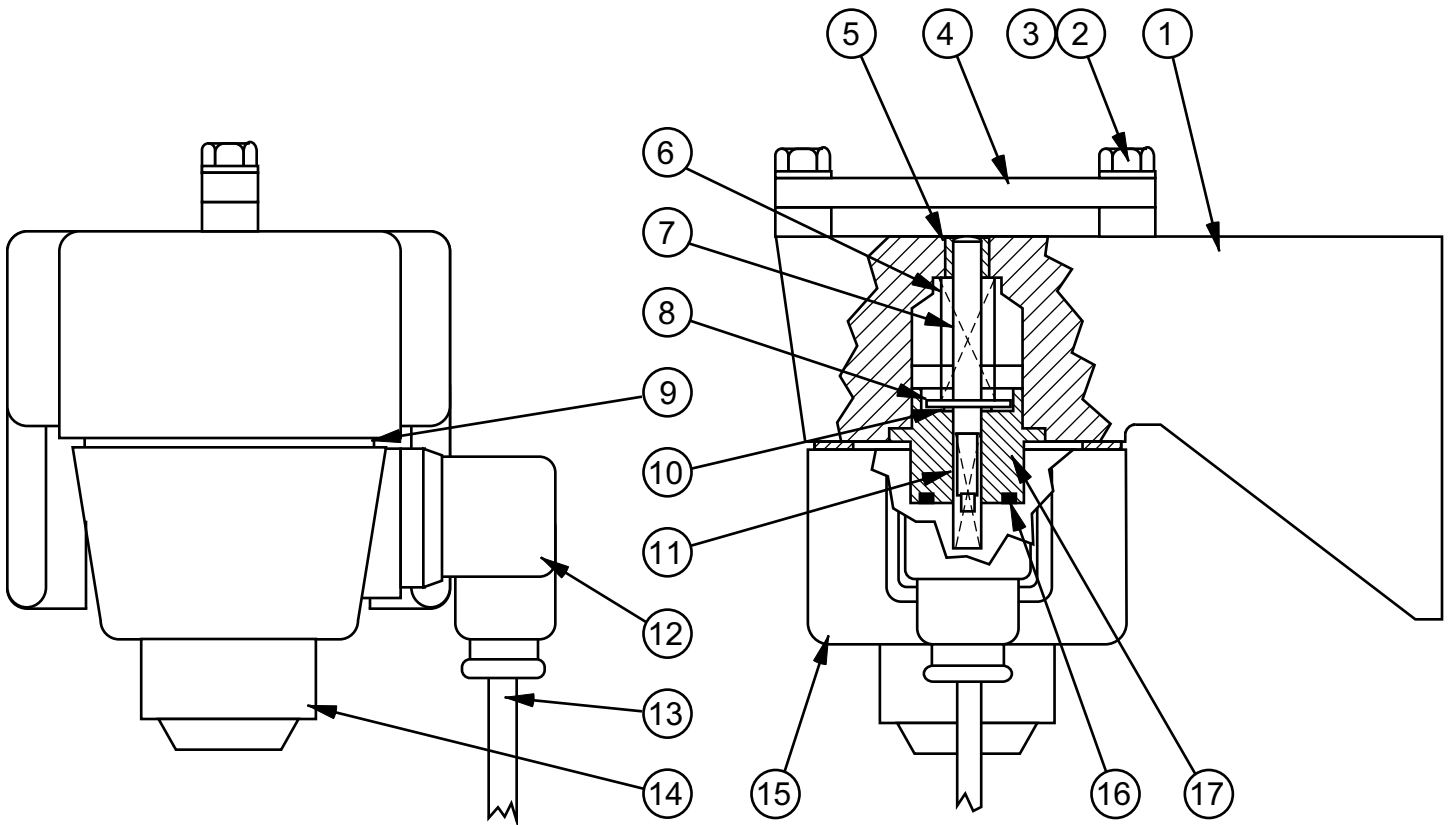
C - 3 - 94 CM - 3 - 92

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SECONDARY TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	050369	Secondary Table Assembly (Used With Fixed or Glide Tables)	
Ref.	503536	Secondary Table Assembly (Used With Air or Hydraulic Tables)	
1	11-003106	. Secondary Table	1
2	199136	. Nut, Hex. Jam 5/18-11NC	4
3	11-003404	. Support Stud	4
4	198053	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4 (Used With Fixed or Glide Tables)	4
	198054	. Screw, Hex. Hd. Cap 3/8-16NC x 3 (Used With Air or Hydraulic Tables)	4
5	199358	. Washer, Lock 3/8 Shakeproof	4
6	020827	. Secondary Table Support (Used With Fixed or Glide Tables)	1
	048045	. Secondary Table Support (Used With Air or Hydraulic Tables)	1
7	199131	. Nut, Hex. 1/2-13NC	4
8	199327	. Washer, Lock 1/2 Std.	4
9	198067	. Screw, Hex. Hd. Cap 1/2-13NC x 1-1/2	4
10	199304	. Washer, Flat 1/2 Wrought	4

NEW DRG. S.C.L. 10-22-97
REVISIONS
S.C.L. 6-29-01
S.C.L. 2-14-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-VH	570-04101	
2013-V3	572-04101	
2613-V3	589-09101	

SHIFT LOCK ASSEMBLY (ELECTRICAL)

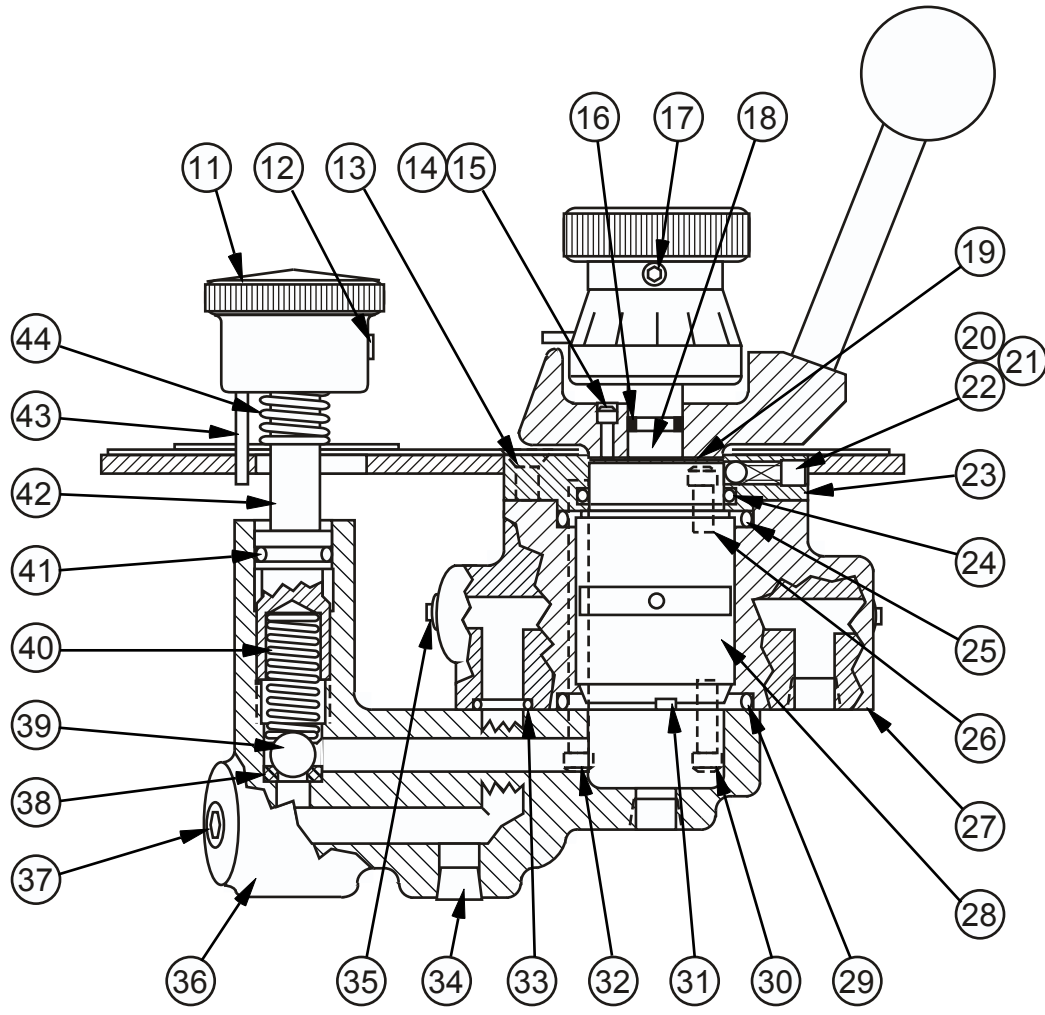
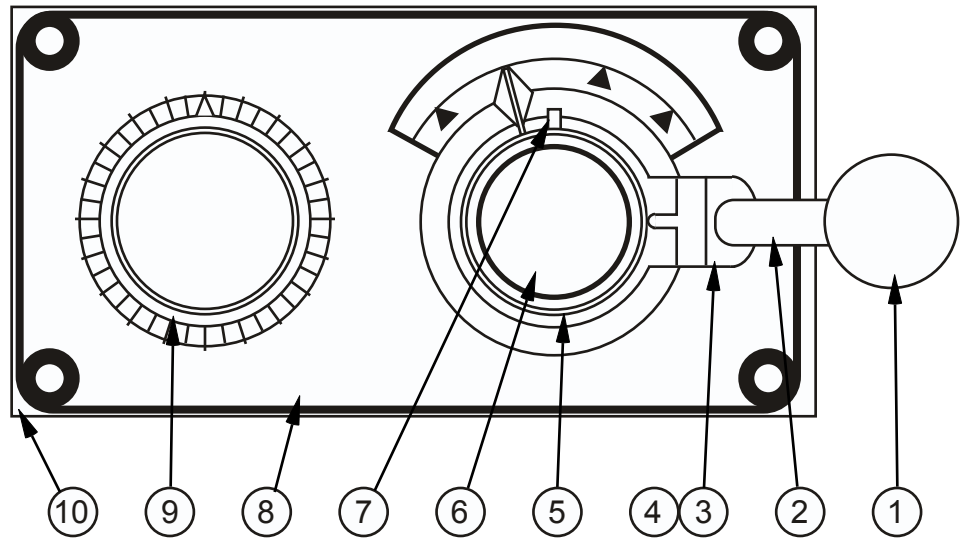
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SHIFT LOCK ASSEMBLY
(Electrical)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	315351	Shift Lock Assembly (110/120V, 50/60 Hz)	
Ref.	315352	Shift Lock Assembly (220/240V, 50/60 Hz)	
1	414422	. Bracket	1
2	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	2
3	199323	. Washer, Lock 5/16 Std.	2
4	172652	. Bar	1
5	147309	. Sleeve Bearing	1
6	155792	. Compression Spring	1
7	155453	. Locking Pin	1
8	014984	. Copper Washer	1
9	141389	. Solenoid Gasket	1
10	155962	. Retaining Ring	1
11	155791	. Compression Spring	1
12	165639	. Solenoid DIN Connector	1
13	197220	. Electrical Cord (#16-3 Conductor)	A.R.
14	250635	. Retainer	1
15	307253	. Coil (110/120V, 50/60 Hz)	1
	307252	. Coil (220/240V, 50/60 Hz)	1
16	260384	. O-Ring	1
17	307528	. Core Sub-Assembly	1

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 3-17-08
S.C.L. 7-8-13



MODEL FIRST MACH. LAST MACH.
 2012-VH 561-03101
 ZV-3620 565-03101
 3612-VH 570-04101

TABLE CONTROL VALVE ASSEMBLY

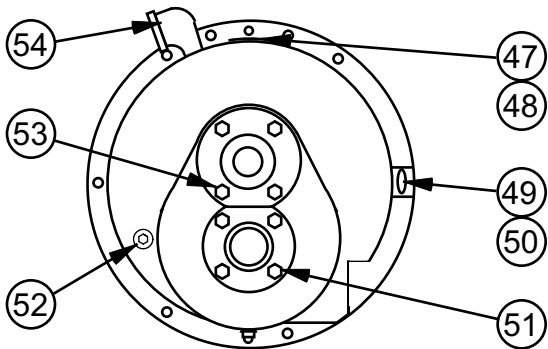
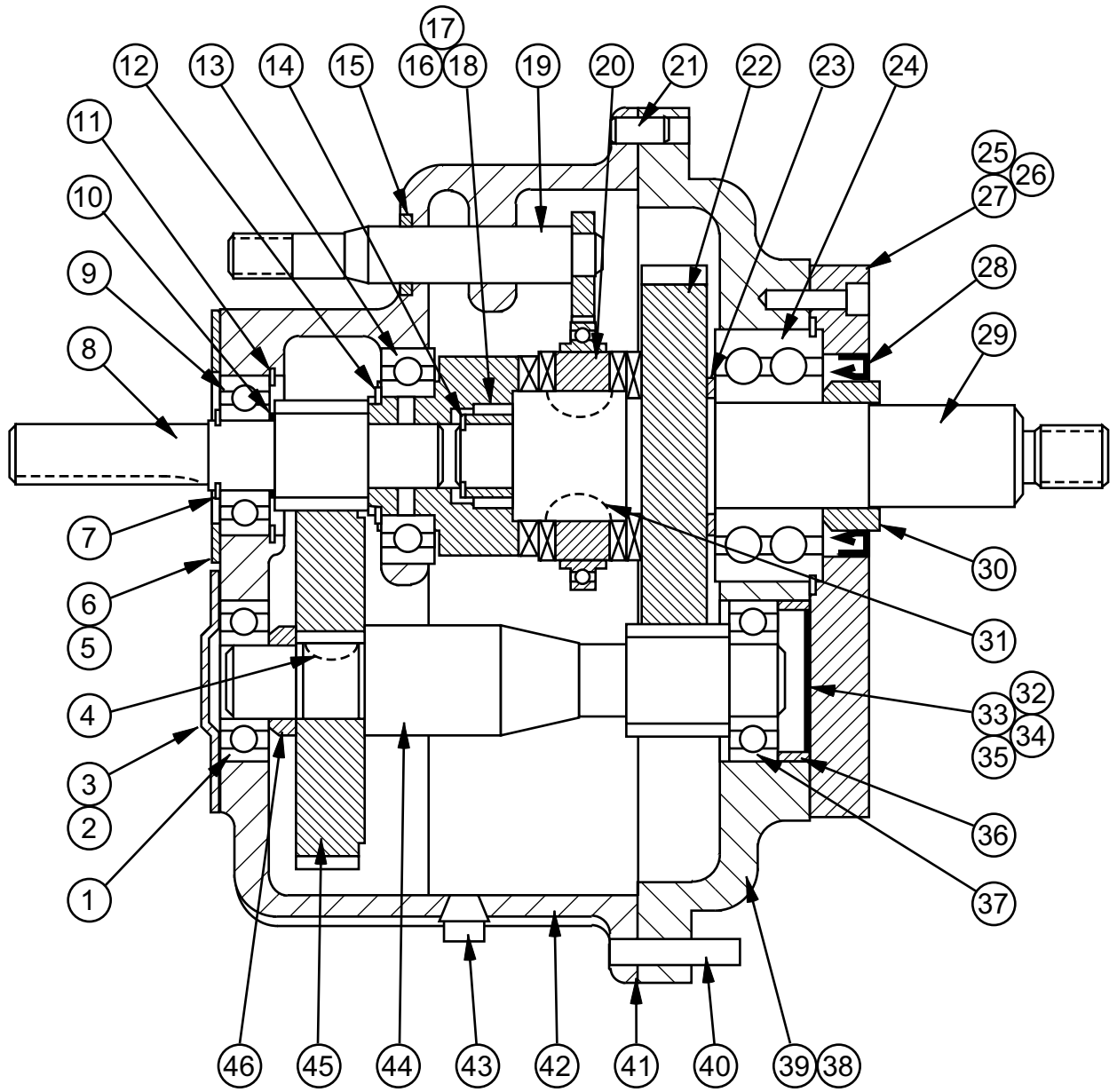
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TABLE CONTROL VALVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	043323	Table Control Valve Assembly	
1	34-013508	. Shift Lever Knob	1
2	011378	. Lever Rod	1
3	024757	. Knob	1
4	004229	. Spring Pin	1
5	010652	. Knob	1
6	010662	. Knob Escutcheon	1
7	004229	. Spring Pin	1
8	025186	. Dial Plate	1
9	005191	. Pointer	1
10	025185	. Valve Panel	1
11	007154	. Knob	1
12	198425	. Screw, Soc. Set 1/4-20NC x 1/2	1
13	198758	. Screw, Flat Hd. Mach. 1/4-20NC x 3/8	4
14	198214	. Screw, Soc. Hd. Cap #8-32NC x 3/4	3
15	002238	. Washer, Lock #8 Hi-Collar	3
16	260425	. O-Ring	1
17	198424	. Screw, Soc. Set 1/4-20NC x 3/8	2
18	1014746	. Vernier Spool	1
19	010375	. Gasket	1
20	114465	. Screw, Soc. Set 1/4-20NC x 3/8 (Nylock)	1
21	14-000250	. Spring	1
22	260358	. Steel Ball	1
23	025179	. Valve Cap	1
24	35-009859	. O-Ring	1
25	001508	. O-Ring	1
26	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	1
27	043309	. Control Valve Housing	1
28	024755	. Valve Spool	1
29	001508	. O-Ring	1
30	198239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4	1
31	004251	. Spring Pin	1
32	198250	. Screw, Soc. Hd. Cap 1/4-20NC x 2-3/4	3
33	003370	. O-Ring	1
34	123328	. Pipe Plug	1
35	120369	. Pipe Plug	4
36	056679	. Pressure Valve Housing	1
37	123328	. Pipe Plug	1
38	114747	. Ball Seat	1
39	260412	. Steel Ball	1
40	35-009173	. Spring	1
41	260411	. O-Ring	1
42	009884	. Valve Screw	1
43	004236	. Spring Pin	1
44	005193	. Spring	1

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 2-12-08
S.C.L. 9-9-09



VIEW IN DRIVE COMPARTMENT

MODEL FIRST MACH. LAST MACH.

2012-VH	561-03101
3613-V3	568-04101
3612-VH	570-04101
2013-V	571-04101
2013-V3	572-04101
3613-1	577-04101
2613-V3	589-09101

TRANSMISSION ASSEMBLY

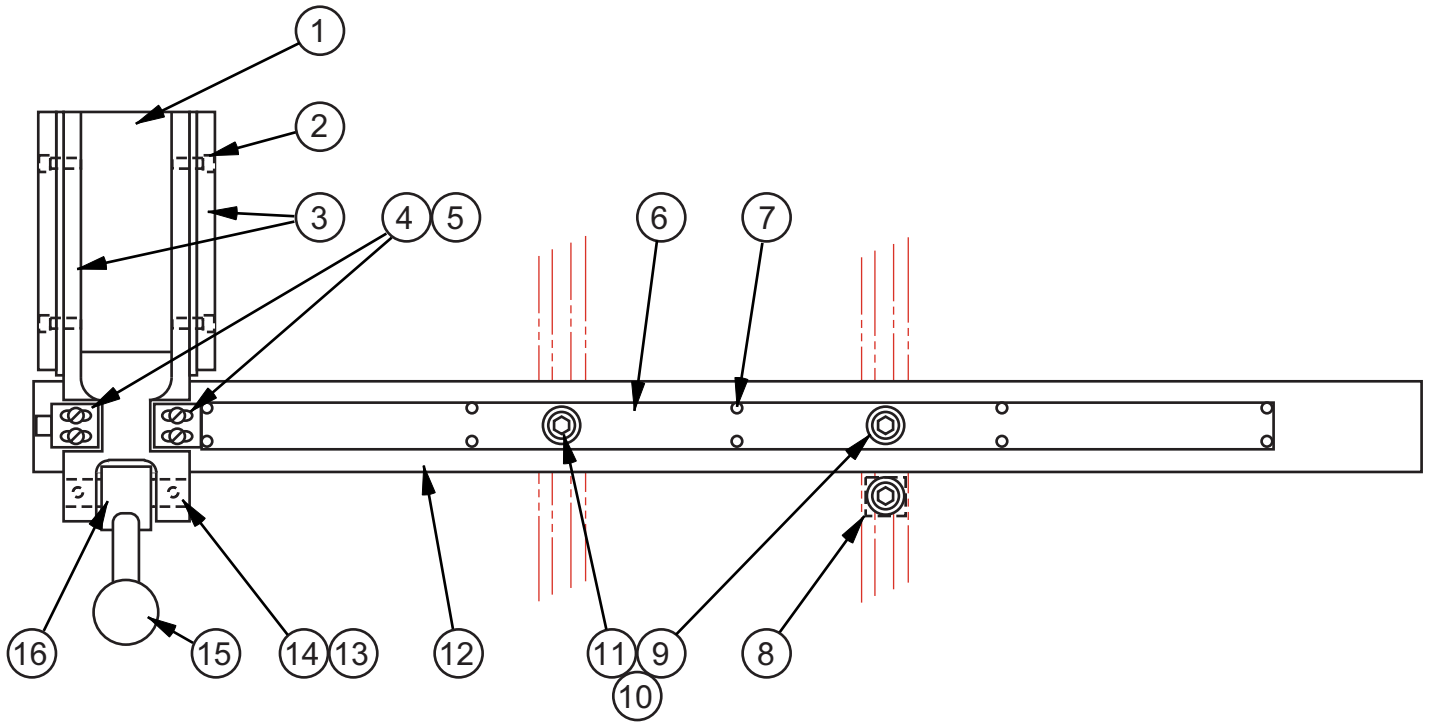
C - 4 - 47 CM - 4 - 147

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TRANSMISSION ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	506827	Transmission Assembly	
1	108557	. Bearing	1
2	5-004303	. Countershaft Bearing Cover	1
3	5-004309	. Gasket	1
4	5-004602	. Woodruff Key	1
5	323106	. Bearing Cover	1
6	213598	. Shaft Seal	1
7	35-008664	. Retaining Ring	1
8	307343	. Input Shaft Assembly	1
	031737	. . Input Shaft And Clutch	1
	004283	. . Spring Pin	1
	307344	. . Clutch	1
9	100122	. Ball Bearing	1
10	175651	. Flinger (If Supplied)	1
11	35-008189	. Retaining Ring	1
12	35-007538	. Retaining Ring	1
13	002273	. Ball Bearing	1
14	111692	. Snap Ring	1
15	214190	. Shaft Seal	1
16	164548	. Needle Bearing	1
17	164547	. Inner Race	1
18	143391	. Grease (Union 76 Unoba EP 2)	A.R.
19	111449	. Shifter Fork Weldment	1
20	111451	. Shifter Clutch Assembly	1
	048621	. . Shifter Clutch	1
	111450	. . Ball Bearing	1
	004209	. . Spring Pin	3
21	35-000443	. Dowel Pin	1
22	6-004421	. Clutch Gear	1
23	147522	. Spacer	1
24	147523	. Ball Bearing	1
25	408641	. Bearing Cover Plate	1
26	198239	. Screw, Soc. Hd Cap 1/4-20NC x 3/4	5
27	212668	. Black Silicon (Super Flex 598)	A.R.
28	147524	. Oil Seal	1
29	408637	. Output Shaft	1
30	147521	. Seal Ring	1
31	35-007192	. Woodruff Key	2
32	152085	. Shim (.005)	A.R.
33	152086	. Shim (.010)	A.R.
34	152087	. Shim (.032)	A.R.
35	152088	. Shim (.060)	A.R.
36	147622	. Bearing Spacer	1
37	108557	. Ball Bearing	1
38	506828	. Transmission Cover	1
39	198257	. Screw, Soc. Hd. Cap 5/16-18NC x 5/8	4
40	013122	. Dowel Pin	1
41	5-004311	. Gasket	1
42	054871	. Transmission Case	1
43	152157	. Magnetic Plug	1
44	313681	. Countershaft And Pinion	1
45	5-004424	. Gear	1
46	103235	. Spacer	1
47	160149	. Escutcheon (If Supplied)	1
48	199396	. Screw, Rd. Hd. Drive #2 x 3/16	2
49	113737	. Pipe Plug	1
50	138442	. Gear Oil	A.R.
51	198005	. Screw, Hex. Hd. Cap 1/4-20NC x 3/8	4
52	120369	. Pipe Plug (1/8 NPT)	1
53	159133	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2 (Low Head)	4
54	17-013521	. 90° Street Elbow	1

NEW DRG.
S.C.L. 9-18-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-12-08



USED ON T-SLOT TABLES.

UNIVERSALLY CALIBRATED WORK FIXTURE ASSEMBLY

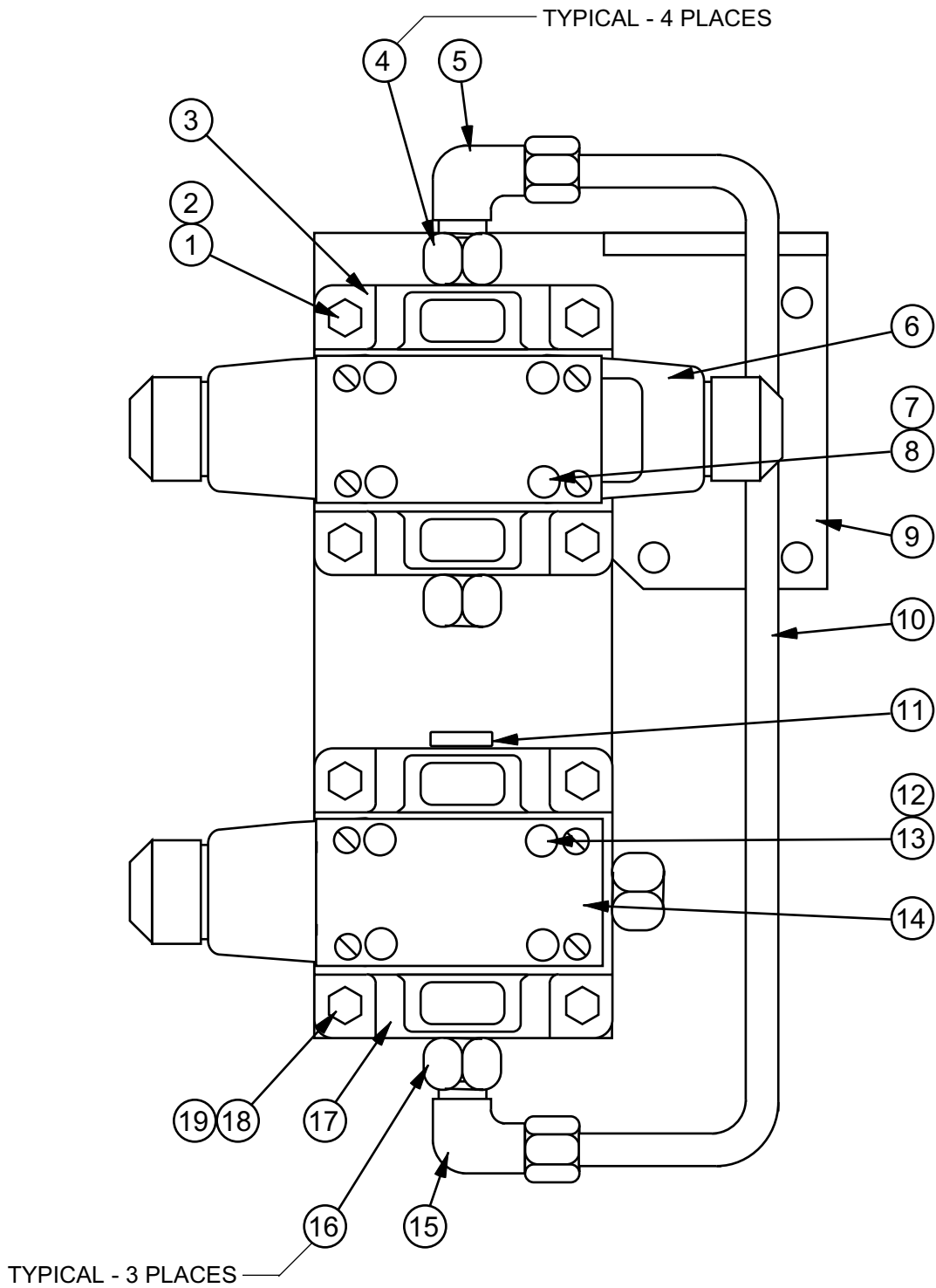
C - 10 - 43 CM - 10 - 9

PRINTED IN U.S.A.

UNIVERSALLY CALIBRATED WORK FIXTURE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	045083	Universally Calibrated Work Fixture Assembly (11" Scale)	
Ref.	404907	Universally Calibrated Work Fixture Assembly (28 cm Scale)	
Ref.	045084	Universally Calibrated Work Fixture Assembly (16" Scale)	
Ref.	404817	Universally Calibrated Work Fixture Assembly (41 cm Scale)	
1	045085	. Head	1
2	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	4
3	018390	. Wear Strip	2
4	018392	. Pointer	2
5	199005	. Screw, Truss Hd. Mach. #6-32NC x 1/4	4
6	045088	. Scale (11" - 0" - 11")	1
	047500	. Scale (28cm - 0cm - 28cm)	1
	045089	. Scale (16" - 0" - 16")	1
	047499	. Scale (41cm - 0cm - 41cm)	1
7	198833	. Screw, Rd. Hd. Mach. #5-40NC x 1/8	10
8	101117	. Collar (For Angle Cutting)	1
9	198281	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/2	2
10	199264	. Washer, Flat 3/8 S.A.E. Std.	2
11	003855	. T-Slot Nut	2
12	045086	. Bar (11" and 28 cm Scales)	1
	045087	. Bar (16" and 41 cm Scales)	1
13	018391	. Pin	1
14	198417	. Screw, Soc. Set #10-32NF x 1/4	2
15	34-013508	. Knob	1
16	028892	. Cam Assembly	1
	100702	. . Cam	1
	002579	. . Handle	1

NEW DRG.
S.C.L. 8-24-06
REVISIONS
S.C.L. 3-17-08
S.C.L. 9-9-09



MODEL FIRST MACH. LAST MACH.
 2012-VH 561-03101
 3612-VH 570-04101

VALVE MANIFOLD ASSEMBLY (FOOT SWITCH)

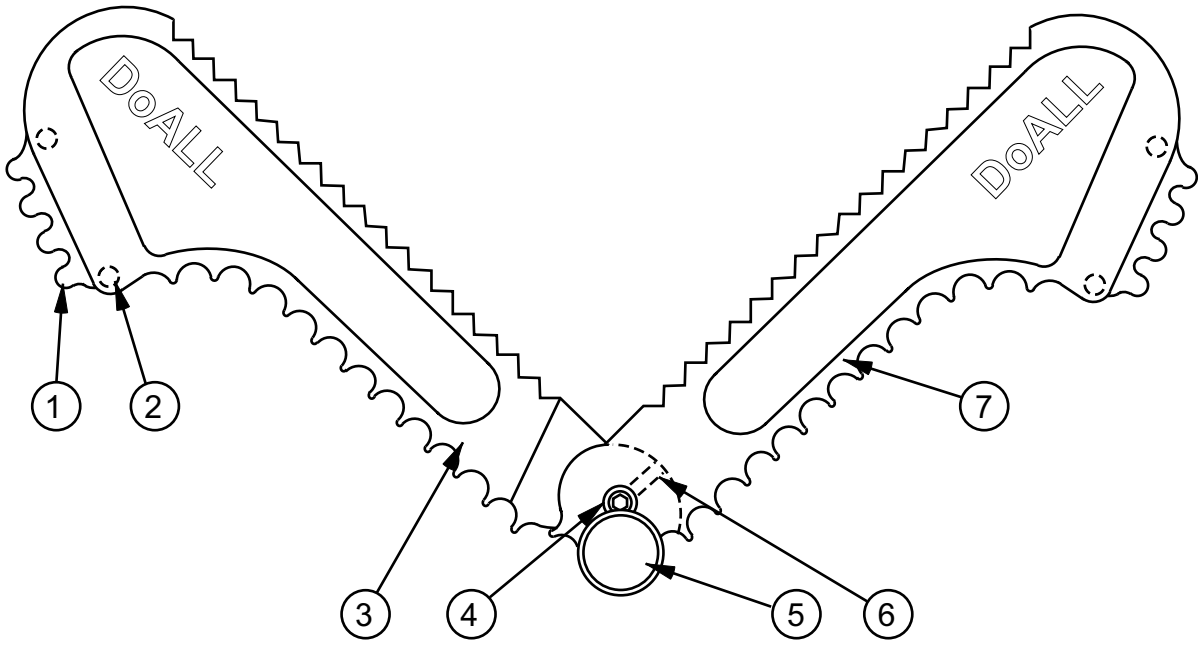
CM - 4 - 47

PRINTED IN U.S.A.

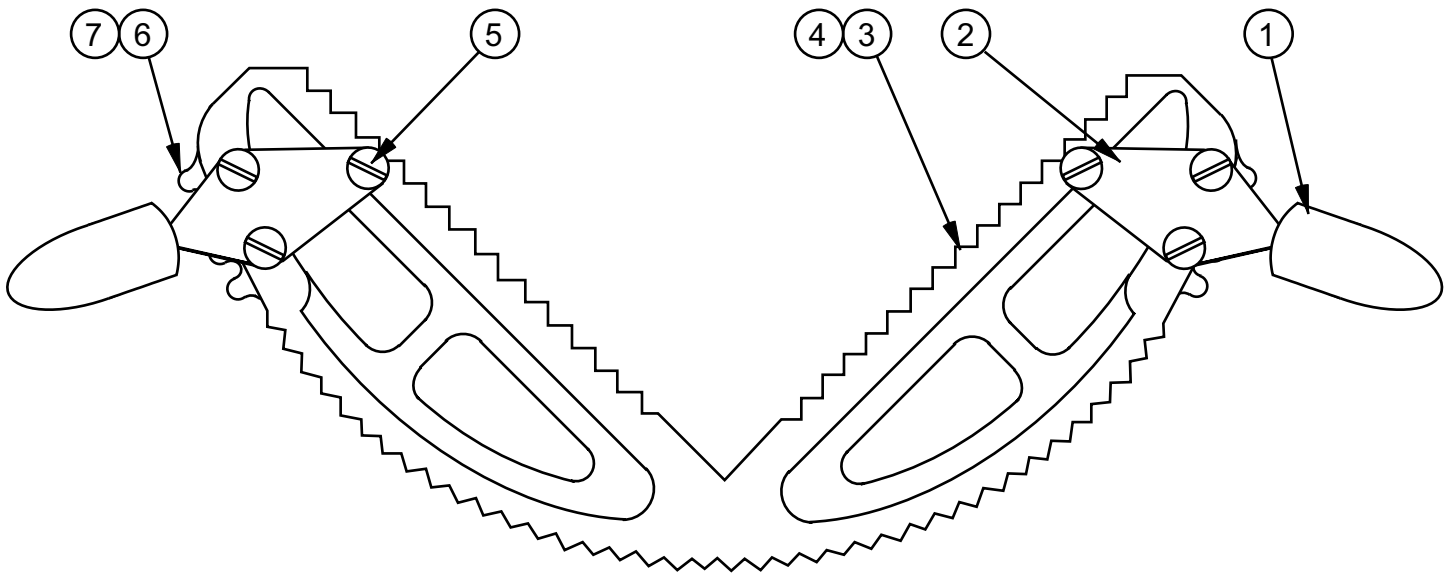
VALVE MANIFOLD ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	420269	Valve Manifold Assembly (Foot Switch)	
1	198009	. Screw, Hex. Hd. Cap 1/4-20NC x 7/8	4
2	199321	. Washer, Lock 1/4 Std.	4
3	265801AI	. Sub-Plate	1
4	158995	. Female Pipe Adaptor	4
5	309057	. 90° Male Elbow	1
6	1003595	. Directional Control Valve	1
7	198225	. Screw, Soc. Hd. Cap #10-24NC x 1	4
8	199319	. Washer, Lock #10 Std.	4
9	406267	. Bracket	1
10	197130	. Steel Tubing 3/8 O.D.	A.R.
11	169511	. O-Ring Plug	1
12	198225	. Screw, Soc. Hd. Cap #10-24NC x 1	4
13	199319	. Washer, Lock #10 Std.	4
14	1003590	. Directional Control Valve	1
15	309057	. 90° Male Elbow	1
16	158995	. Female Pipe Adaptor	3
17	265801AI	. Sub-Plate	1
18	198009	. Screw, Hex. Hd. Cap 1/4-20NC x 7/8	4
19	199321	. Washer, Lock 1/4 Std.	4

NEW DRG.
S.C.L. 9-18-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-12-08



WORK HOLDER ASSEMBLY
040262



WORK HOLDING JAW ASSEMBLY
5-013007

WORK HOLDING JAW ASSEMBLIES

WORK HOLDING JAW ASSEMBLIES

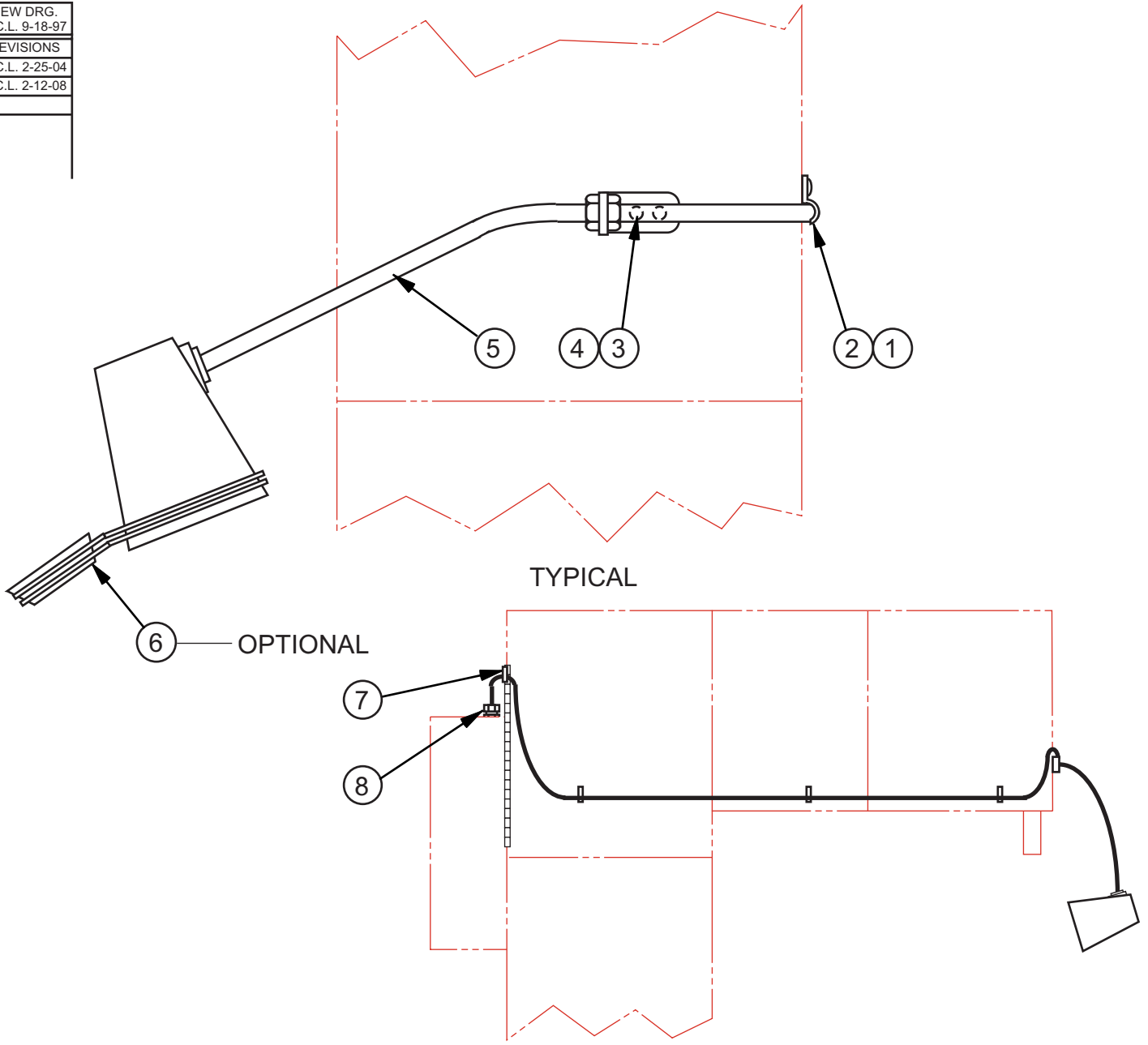
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	040262	Work Holder Assembly	
1*	5-013313	. Sprocket	2
2	198698	. Screw, Fill. Hd. Mach. #10-24NC x 1/2	4
3	020386	. Left Arm	1
4	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	1
5	002162	. Knurled Screw	1
6	198410	. Screw, Soc. Set #10-24NC x 1/4	2
7	020385	. Right Arm	1

*NOTE: Before 2-12-44 On Hydraulic Machines, Use #6-023337 Sprocket With 3/16" Pitch; Specify Pitch of Chain When Ordering.

Ref.	5-013007	Work Holding Jaw Assembly	
1	5-013512	. Jaw Handle	2
2	5-013318	. Bracket	2
3	040678	. Work Holding Jaw Sub-Assembly	1
4	5-013110	. . Work Holding Jaw	1
5	198892	. . Screw, Rd. Hd. Mach. 1/4-20NC x 5/16	6
6	5-013313	. . Sprocket	2
7	199015	. . Screw, Truss Hd. Mach. #10-24NC x 3/8	4

Ref. 34-003107 Work Holding Jaw (Ratchet And Screw Feed Options)

NEW DRG.
S.C.L. 9-18-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-12-08

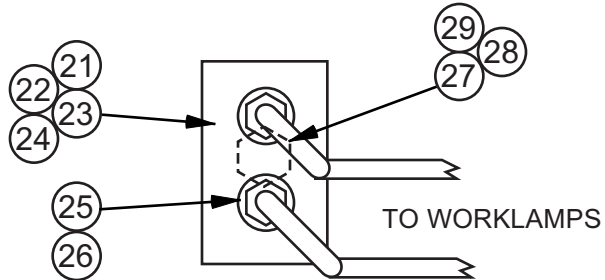


TYPICAL

OPTIONAL

O.S.H.A. REQUIREMENT:
 WIRE DIRECTLY TO CONTROL BOX.
 SEE ELECTRICAL SCHEMATIC FOR
 CONNECTIONS AND/OR MORE
 INFORMATION.

OPTIONAL ON ALL MACHINES.



FOR MACHINES WITH 2 WORKLAMPS
 (2613-3, 2618-4, 6013-H3)

WORKLAMP ASSEMBLY

WORKLAMP ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	220670	Worklamp Assembly (Standard)	
Ref.	220671	Worklamp Assembly (Extra Work Height)	
1	018172	. Tubing Clamp	A.R.
2	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8	A.R.
3	198892	. Screw, Rd. Hd. Mach. 1/4-20NC x 5/16	2
4	199321	. Washer, Lock 1/4 Std.	2
5	221545	. Worklamp (Includes Bracket)	1
	221546	. Worklamp (Includes Bracket) (Extra Work Height)	1
6	138436	. Magnifier (Optional)	1
7	009955	. Nylon Tubing Clamp	1
	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8	1
8	201688	. Cord Grip Connector (.200-.394)	1
Ref.	406094	Worklamp Assembly (2 Worklamps) (2613-3, 6013-H3)	
21	100506	. Outlet Box Assembly	1
	002992	. Junction Box (2618-4 Only)	1
22	137173	. Box Cover	1
23	137172	. Gasket	1
24	133826	. Wire Connector	A.R.
25	015139	. Cord Grip Connector	2
26	014411	. Flange Washer	2
27	197156	. Sealtite Conduit 1/2 I.D.	A.R.
28	014545	. Sealtite Connector	2
29	014411	. Flange Washer	2

Use Worklamps Listed Above; Quantity of 2.