

JET[®]

Operating Instructions and Parts Manual Horizontal/Vertical Bandsaw Model: HVBS-56M



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Warranty and Service

Walter Meier (Manufacturing) Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these Walter Meier Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION

Walter Meier is consistently adding new products to the line. For complete, up-to-date product information, check with your local Walter Meier distributor, or visit waltermeier.com.

WARRANTY

JET products carry a limited warranty which varies in duration based upon the product (MW = Metalworking, WW = Woodworking).

90 DAY WARRANTY	1 YEAR WARRANTY	Body Repair Kits Bottle Jacks Cable Pullers Cold Saws Hoists-Air Hoists-Electric Metal forming Mill/Drills Milling Machines MW Bandsaws MW Drill Presses MW Finishing Equipment MW Lathes MW Precision Vises	2 YEAR WARRANTY	Palet Trucks Rigging Equip. Service Jacks Stackers Surface Grinders Tapping Trolleys-Air Trolleys-Electric Web Slings Winches-Electric	3 YEAR WARRANTY	WW Benchtop Tools	5 YEAR WARRANTY	Beam Clamps Chain Hoist- Manual Lever Hoists Pullers-JCH Models Scissor Lift Tables Screw Jacks Trolleys-Gearred Trolleys-Plain Winches-Manual WW Air Filtration WW Bandsaws WW Buffers	WW Drill Presses WW Dust Collectors WW Dust Filters WW Dust Fittings WW Jointers WW Lathes WW Planers WW Sanders WW Shapers WW Tablesaws	LIFE LIFETIME WARRANTY	Fastening Tools Mechanics Hand Tools Striking Tools Vises (no -precision) Clamps
Warranty reverts to 1 Year Warranty if woodworking (WW) products listed above are used for industrial or educational purposes.											

WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?

This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?

The general JET warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?

Five Year Warranties do not cover woodworking (WW) products used for commercial, industrial or educational purposes. Woodworking products with Five Year Warranties that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE

The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option. We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the shipping and handling costs of the return.

HOW STATE LAW APPLIES

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY

WALTER MEIER (MANUFACTURING) INC., LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

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Warnings

Read and understand the entire instruction manual before operating machine.

This bandsaw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe use of a bandsaw, do not use until proper training and knowledge have been obtained.

“Warning: For you own safety read instruction manual before operating saw.”

- a) Wear eye protection.
 - b) Do not remove jammed cut off pieces until blade has stopped.
 - c) Maintain proper adjustment of blade tension, blade guides, and thrust bearing.
 - d) Adjust upper guide to just clear workpiece.
 - e) Hold workpiece firmly against table.
-
1. Keep guards in place and in working order.
 2. 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.
 3. Keep work area clean. Cluttered areas and benches invite accidents.
 4. Don't use in dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
 5. Keep children away. All visitors should be kept a safe distance from the work area.
 6. Make your workshop child proof with padlocks, master switches or by removing starter keys.
 7. Don't force tool. It will do the job better and more safely at the rate for which it was designed.
 8. 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.
 9. Use proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in voltage resulting in loss of power and overheating. Table 1 shows the correct size to use depending on cord length and nameplate ampere rating. If in double, use the next heavier gage. The smaller the gage number, the heavier the cord.
 10. Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
 11. Always wear approved safety glasses/face shields while using this bandsaw. Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are NOT safety glasses.
 12. Secure work. Use clamp or vise to hold work when practical. It is safer than using your hand and it frees both hands to operate tool.
 13. Don't overreach. Keep proper footing and balance at all times.
 14. Maintain tools with care. Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
 15. Disconnect tools before servicing; when changing accessories such as blades, bits, cutters, and the like.
 16. Reduce the risk of unintentional starting. Make sure switch is in off position before plugging in.
 17. Use recommended accessories. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
 18. Never stand on tool. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.

19. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, 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 face or dust masks that are specifically designed to filter out microscopic particles.
20. 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.
21. Feed work into a blade or cutter only against the direction of rotation of the blade or cutter.
22. Never leave tool running unattended. Turn power off. Don't leave tool until it comes to a complete stop.
23. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
24. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
25. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.

Minimum gage for cord

Ampere Rating		Volts	Total length of cord in feet			
		120V	25 ft.	50ft.	100ft.	150ft.
		240V	50ft.	100ft.	200ft.	300ft.
	Not	AWG				
More	More					
Than	Than					
0	6	18	16	16	14	
6	10	18	16	14	12	
10	12	16	16	14	12	
12	16	14	12	Not Recommended		
Only the applicable parts o the Table need to be included, For instance, a 120-volt product need not include the 240-volt heading						

Table 1

Grounding Instructions

Caution: This tool must be grounded while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

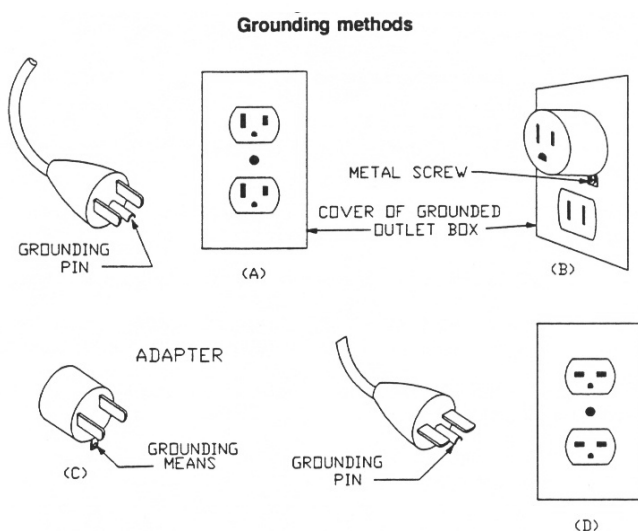
Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Repair or replace a damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch A. The tool has a grounding that looks like the plug illustrated in sketch A. A temporary adapter, which looks like the adapter illustrated in sketches B and C, may be used to connect this plug to a 2-pole receptacle as show in sketch B if a properly until a properly grounded outlet can be installed by a qualified electrician. (This adapter is not permitted in Canada) The green-colored rigid ear, lug, the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch D. The tool has a grounding that looks like the plug illustrated in sketch D. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel; and after reconnection, the tool should comply with all local codes and ordinances.



The conversion from 115V to 230V operation must be done by a qualified electrician.

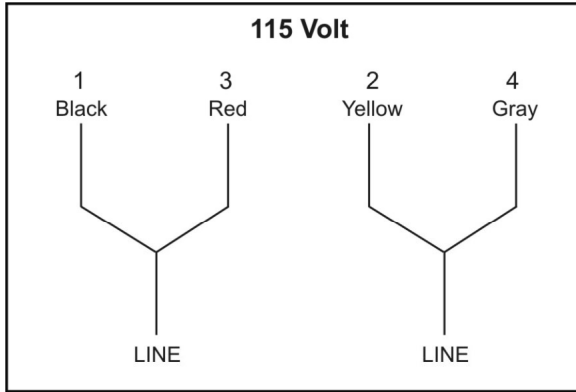


Chart 1

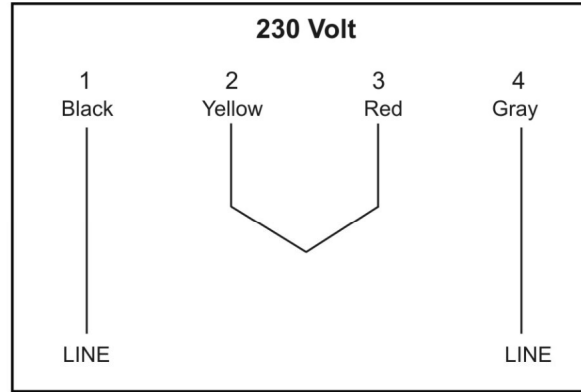


Chart 2

Specifications

Model Number	HVBS-56M
Stock Number	414458
Horizontal Capacity:	
Round @ 90°	5"
Round @ 45°	3"
Rectangle @ 90°	5"(H) x 5-3/4"(W), and 2"(H) x 6"(W)
Rectangle @ 45°	4-1/2"(H) x 3"(W)
Throat Depth	5"
Vertical Work Table Size	9-5/8" x 9-1/2"
Vise Swivels	45°
Blade Size	1/2" x 0.025" x 64-1/2"
Blade Wheel Diameter	7-3/8"
Speeds	80, 120, 200 SFPM
Bed Height	25-1/2"
Floor Space Required	16-1/4" x 42-1/2"
Motor (UL listed)	1/2 HP, 1 Ph, 115/230V, prewired 115V
Net Weight (approx.)	115 lbs.

The specifications in this manual are given as general information and are not binding. Walter Meier (Manufacturing) Inc., reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

Unpacking and Clean-Up

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

1. Remove all contents from the shipping carton.
2. Inspect contents for shipping damage and report any damage to your distributor.
3. Wipe bed and vise assembly with clean cloth to remove excess oil used to prevent rust.
4. Do not discard any packing material until saw has been assembled and is running properly.



Tools Supplied for Assembly

Wrench 12/14mm
4mm Angle Hex Wrench

Tools Required for Assembly

- #2 Cross Point Screwdriver
- 6-8" Adjustable Wrench or Wrench Set
- Pliers - Regular or Needle Nose
- Ratchet and Sockets will Speed Assembly

Assembly

1. With the help of another person turn the saw over so that it rests on the motor and saw bow, Figure 1. Place it on a piece of cardboard, or a surface that will not damage the saw.
2. Attach a cross brace (A, Fig. 1) to the motor side of the bed using three 5/16"x1" hex cap bolts, six 5/16" flat washers, and secure with three 5/16" hex nuts. **Hint:** Tighten the nut (B, Fig. 1) on the end of the bed first followed by the nuts on the sides.
3. Attach a leg to the cross brace using four 5/16"x3/4" carriage bolts, four 5/16" flat washers and four 5/16" hex nuts. Use a 12mm wrench to tighten. Repeat for other leg.
4. Remove the brace (C, Fig. 1) on the opposite end of the bed and bow using a 10mm wrench.

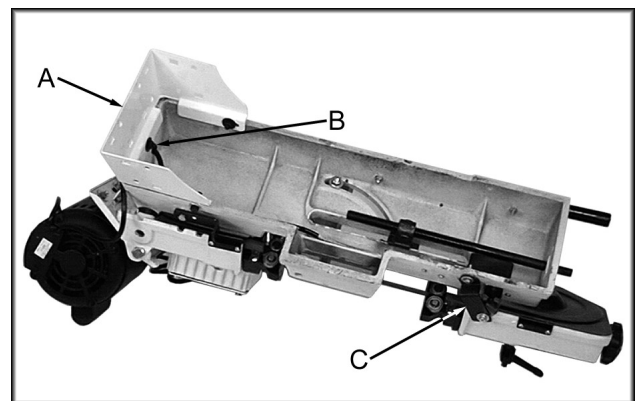


Fig. 1

5. Attach a cross brace to the opposite end of the bed using three 5/16"x1" hex cap bolts, six 5/16" flat washers, and secure with three 5/16" hex nuts. Tighten the nut on the end of the bed first followed by the nuts on the sides.

6. Attach a leg to the cross brace using four 5/16"x3/4" carriage bolts, four 5/16" flat washers and four 5/16" hex nuts. Use a 12mm wrench to tighten. Repeat for other leg.

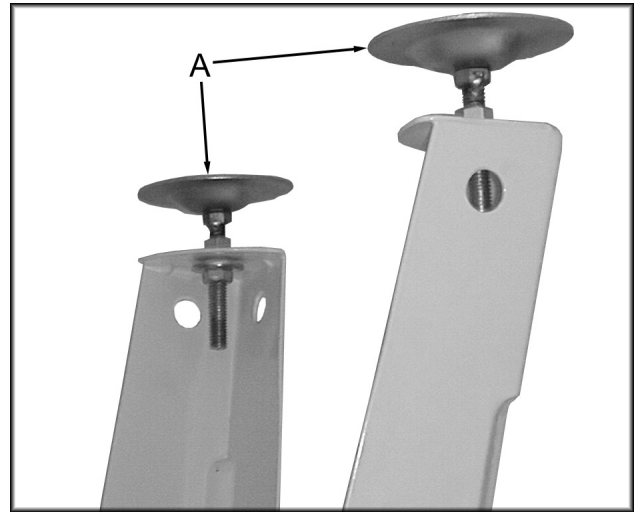


Fig. 2

7. Attach the adjustable feet (A, Fig. 2) to the legs opposite of the motor, using the provided hardware.

8. Slide the axle (A, Fig. 3) through the legs. Place a large flat washer (B, Fig. 3) on both sides of the wheels and place on the axle. Secure wheels with two split pins (C, Fig. 3).

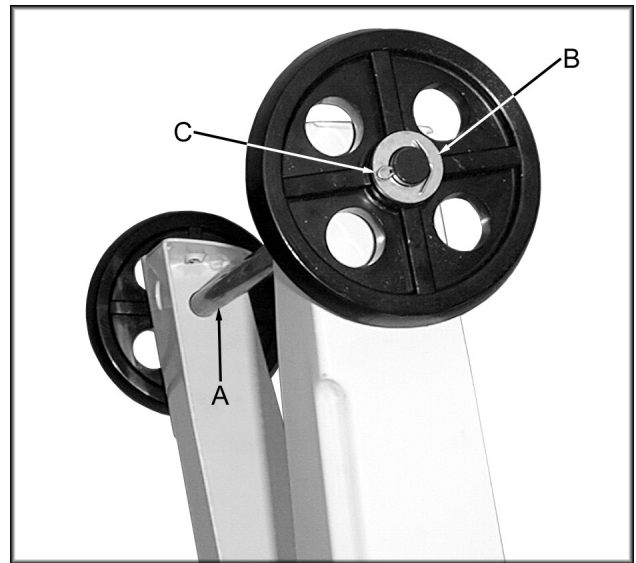


Fig. 3

9. Carefully turn the saw onto its stand and adjust the feet so the bed is level.

10. Put the handle (A, Fig. 4) through holes in the stand legs opposite of the wheel assembly and secure with split pins.



Fig. 4

11. Slide pulley cover (A, Fig. 5) around motor shaft and worm gear shaft. Secure with two hex cap screws and washers (B, Fig. 5).
12. Lift motor with one hand while the other hand places V-belt (C, Fig.5) on both pulleys.
13. Attach the tension bracket (D, Fig. 5) to the saw bow with one 5/16"x3/4" hex head bolt and flat washer (E, Fig. 5).
14. Connect the two tension brackets with one 5/16"x3/4" carriage bolt, one 5/16" flat washers and one 5/16" hex nut (F, Fig. 5).
Hint: Insert the carriage bolt from the inside so the hex nut is easy to access with a wrench.
15. Tension belt by pressing down on the motor while tightening hex nut (F, Fig. 5) until finger pressure on the belt between the two pulleys causes approximately 1/2" deflection. Close pulley cover. Don't over tighten the belt.
16. Insert stop rod (A, Fig. 6) into bed and tighten set screw (B, Fig. 6). Slide stock stop (C, Fig. 6) onto rod and tighten set screw (D, Fig. 6) to hold in place.
17. Slide handwheel (E, Fig. 6) onto shaft and secure by tightening set screw (F, Fig. 6). Make sure set screw seats on flat portion of shaft.

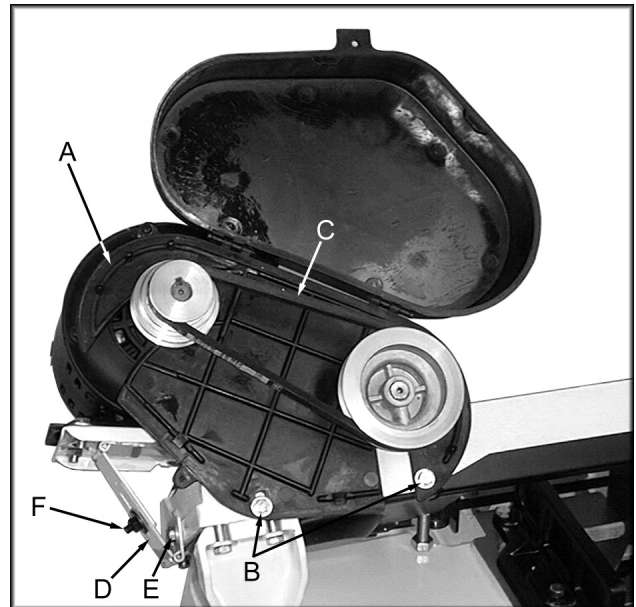


Fig. 5

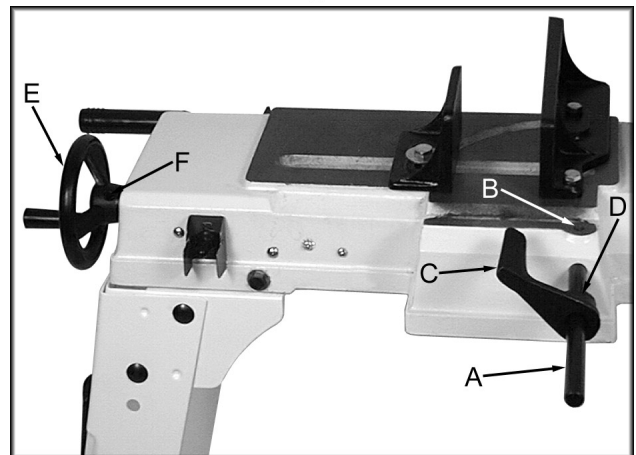


Fig. 6

Vertical Cutting Plate Assembly

Note: These steps are only necessary when using the bandsaw in the vertical mode.

⚠ WARNING

Disconnect the bandsaw from the power source before making any repairs or adjustments!

Failure to comply may cause serious injury!

1. **Disconnect the bandsaw from the power source.**
2. Raise the arm to the vertical position and lock in place with lever (A, Fig. 7).
3. Loosen bolt (B, Fig. 7) and insert bracket (C, Fig. 7). Tighten bolt just enough to hold the bracket in place.

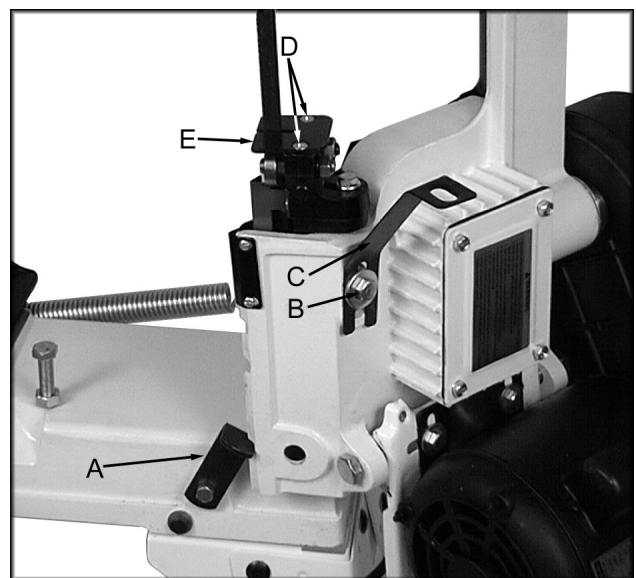


Fig. 7

4. Remove two screws (D, Fig. 7) and plate (E, Fig. 7).
5. Guide blade through slot in table (A, Fig. 8) and fasten table with two screws (B, Fig. 8).
6. Fasten support bracket to underside of table using screw (C, Fig. 8) and hex nut.
7. Tighten bolt (B, Fig 7).

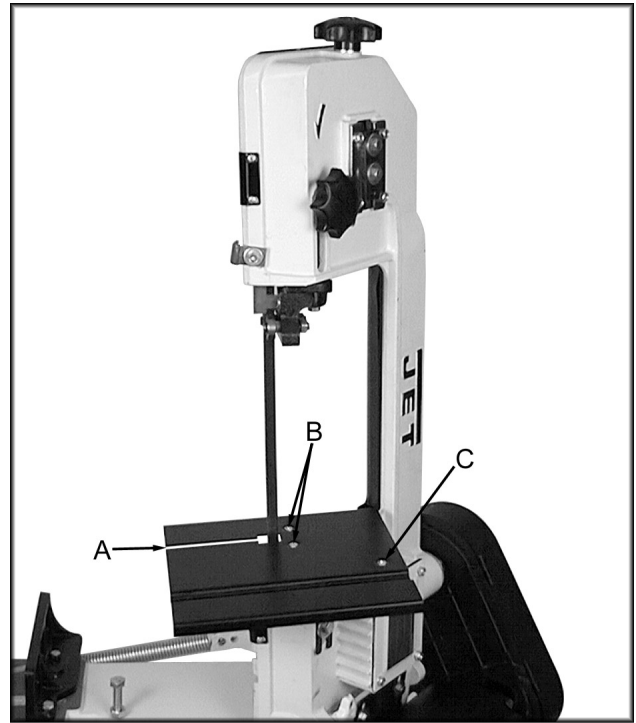


Fig. 8

Electrical Connections

⚠ WARNING
All electrical connections must be completed by a qualified electrician.
Failure to comply may cause serious injury!

The HVBS-56M bandsaw is rated at 115/230V and comes from the factory prewired 115V.

To switch to 230V operation, follow the wiring diagram found on the inside of the motor junction box. The plug on the end will have to be replaced with a plug that is rated at 230V.

This bandsaw is designed for use on a circuit with an outlet that looks like (A, Fig. 9). The bandsaw has a grounding prong as illustrated in (B, Fig. 9). A temporary adapter (C, Fig. 9) may be used to connect the plug to a two pole receptacle (D, Fig. 9) if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. The green colored lug must be securely fastened to the cover plate screw.

Before hooking up to the power source, be sure the switch is in the off position.

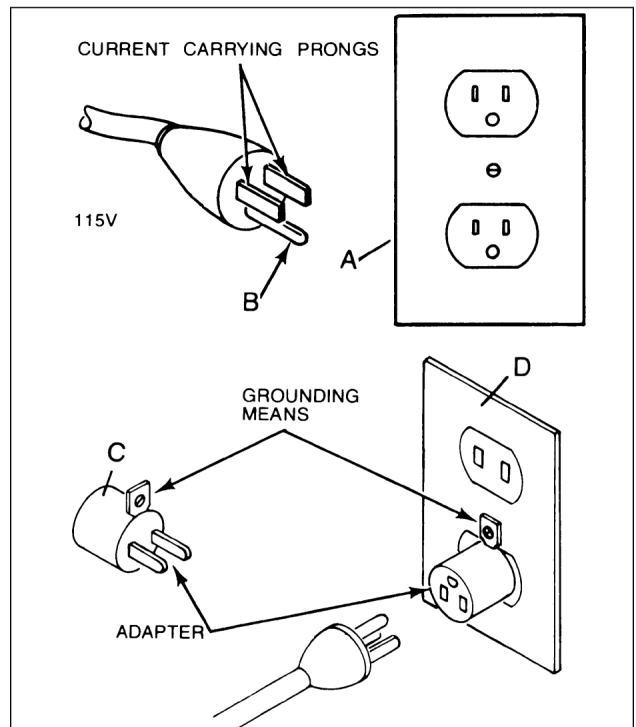


Fig. 9

Changing Blade Speed

1. **Disconnect the machine from the power source.**
2. Place saw arm in the horizontal position.
3. Loosen tensioning plate hex nut (A, Fig. 10).
4. Open pulley cover (B, Fig. 10). Lift motor with one hand while placing the belt (C, Fig. 10) on the desired pulley combination.
5. Tension belt by pressing down on the motor while tightening hex nut (A, Fig. 10) until finger pressure on the belt between the two pulleys causes approximately 1/2" deflection. Close pulley cover. Don't over tighten the belt.
6. Close pulley cover and connect to power source.

The general rule for band saw blade speed is the harder the material being cut, the slower the blade speed. Reference Figure 11 for a guide to blade speed for a type of material being cut.

the blade guide assemblies as far apart as possible. Lock in place.

4. Depress blade. Finger pressure should cause approximately .004" deflection. Turn blade tension knob (B, Fig. 12) until the proper tension is achieved. Re-position guides for cutting material.

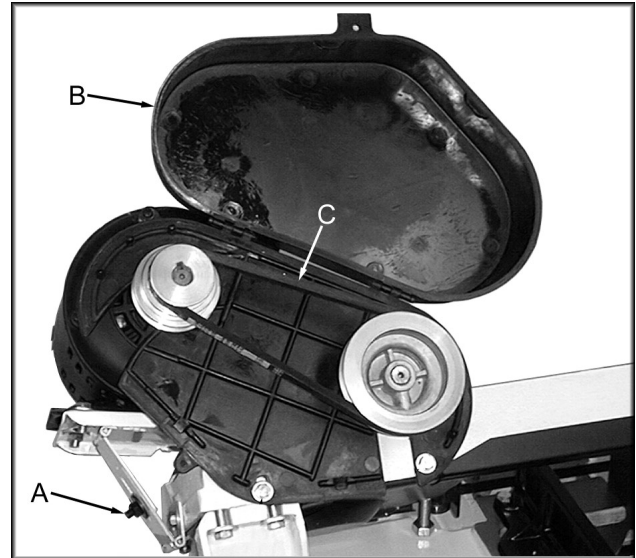


Fig. 10

Adjusting Blade Guides

1. **Disconnect machine from the power source.**
2. Loosen knob (A, Fig. 12) and slide blade guide assembly (B, Fig. 12), as close as possible without interference to the material being cut. Tighten knob.
3. Loosen bolt (C, Fig. 12) and slide blade guide assembly (D, Fig. 12), as close as possible without interference to the material being cut. Tighten bolt

Material	Speed	Motor Pulley	Saw Pulley
Tool, Stainless, or Alloy Steel, Bearing Bronzes	80 FPM	Small	Large
Mild Steel, Hard Brass, or Bronze	120 FPM	Medium	Medium
Soft Brass, Aluminum, or other light materials	200 FPM	Large	Small

Fig. 11

Adjusting Blade Tension

1. **Disconnect machine from the power source.**
2. Open blade cover and observe the position of the blade on the wheel. If the blade is not next to the wheel flange, adjust blade tracking following the steps under "Adjusting Blade Tracking".
3. If the blade is next to the wheel flange, loosen the blade guide assembly lock knob and hex head bolt (A & C, Fig. 12) and slide

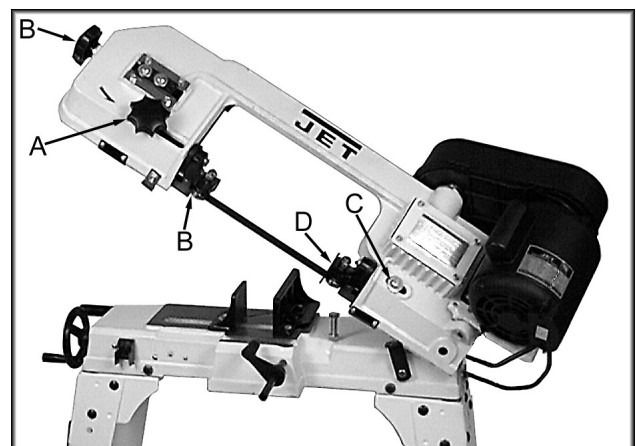
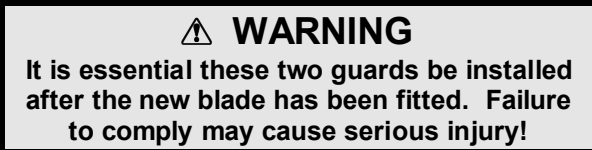


Fig. 12

Changing Blades

1. **Disconnect machine from the power source.**
2. Raise the saw arm to the vertical position and lock in place with lock lever.
3. Open blade cover by removing the small knob found on the topside of the bow.
4. Remove red blade guards by removing two screws.



5. Release tension on the blade by turning tensioning knob (B, Fig. 12), and remove the blade.
6. Place new blade between the blade guide assemblies and around each wheel. Make sure blade teeth are pointing in the proper direction, Figure 13. Tension enough to hold in place.
7. Install red blade guards with two screws.
8. Tension blade fully, see "Adjusting Blade Tension".
9. Place two to three drops of lightweight oil on the blade.
10. Connect machine to the power source.
11. Run saw and make sure blade is tracking properly, see "Adjusting Blade Tracking".

As a general rule, the thinner the material to be cut, the more teeth per inch on the blade. A minimum of three teeth should be in contact with the material at all times during the cut. If the teeth straddle the material, severe damage can result to the material and the blade.

Adjusting Blade Guide Bearings

1. **Disconnect machine from the power source.**
2. Loosen bolt (A, Fig. 14) and adjust assembly so that back roller bearing is approximately .002" - .003" from the back of the blade. Tighten bolt.

3. Loosen nut (B, Fig. 14) and turn nut (C, Fig. 14) to adjust eccentric bearing to a clearance of .001". Tighten nut (B, Fig. 14) to lock.
4. Connect machine to power source.

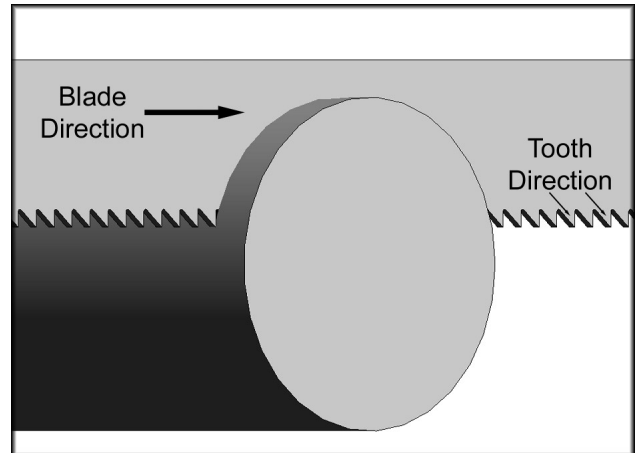


Fig. 13

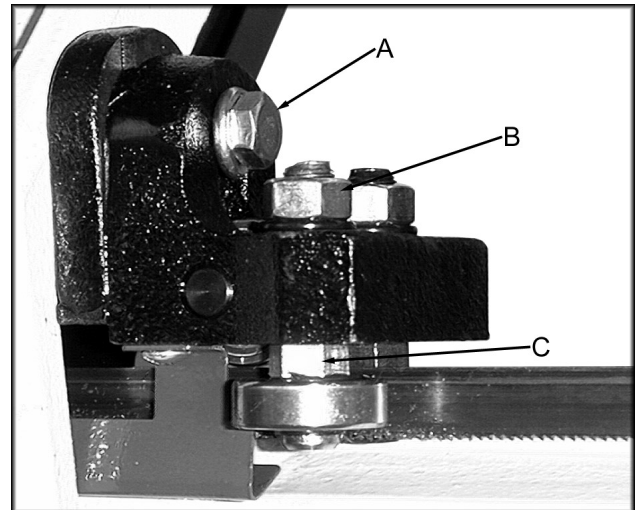


Fig. 14

Adjusting Blade Tracking

WARNING

Blade tracking adjustment requires running the saw with the back cover open! This adjustment must be completed by qualified persons only! Failure to comply may cause serious injury!

Blade tracking has been set at the factory and should not need immediate adjustment. If blade tracking should ever require adjustment:

1. Confirm that blade tension is set properly. To adjust, see section titled "Adjusting Blade Tension".
2. Make sure the saw is in its slowest speed, see "Changing Blade Speeds".
3. Move saw arm to the vertical position and lock in place with the lock lever.
4. Confirm that blade tension is set properly. To adjust, see section titled "Adjusting Blade Tension".
5. Open blade cover by removing the knob found on the top side of the bow.
6. Run saw and observe blade. Blade should run next to but not tightly against wheel flange.
7. Loosen bolts (A, Fig. 15).
8. Turn set screw (B, Fig. 15) while observing blade tracking on wheel. Turn set screw clockwise to track closer to wheel flange. Turn set screw counter-clockwise to track away from the wheel flange. **Hint:** start with $\frac{1}{4}$ turns on the set screw. The tracking is sensitive.
9. Once tracking is set, tighten bolts (A, Fig. 15).

Adjusting Feed Pressure

1. Turn handle (A, Fig. 16) clockwise to decrease cutting pressure and counter-clockwise to increase cutting pressure.

A good indication of proper feed pressure is the color and shape of the cutting chips. If the chips are thin or powdered, increase the feed pressure. If the chips are burned and heavy, decrease the

feed pressure. If they are still burned and heavy, reduce the blade speed. Optimum feed pressure has been set when the chips are curled, silvery, and warm.

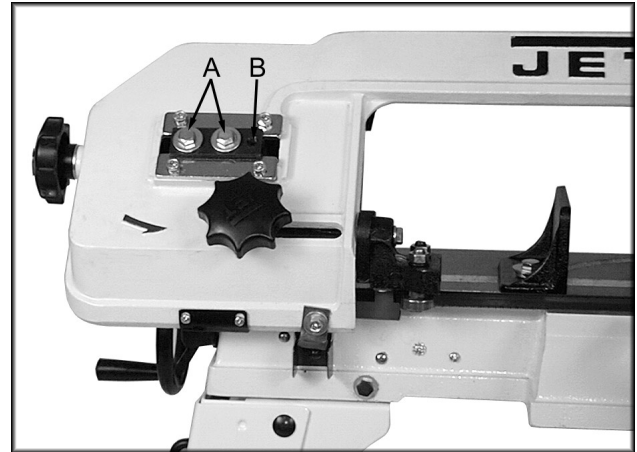


Fig. 15

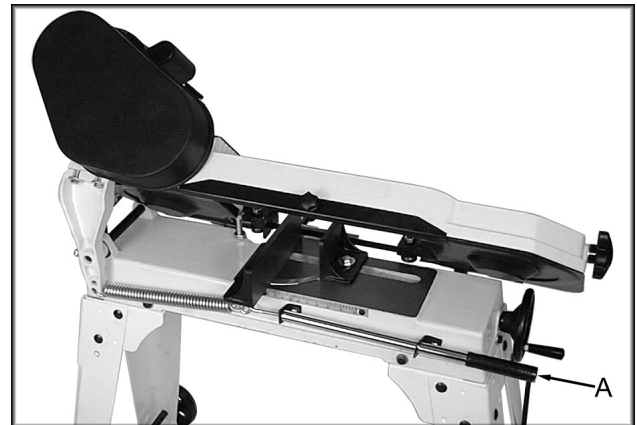


Fig. 16

Blade-Table Squareness

1. The band saw blade must be perpendicular to the table to ensure a straight cut. This setting should be checked. Special blade setting gauges can be purchased for this type of inspection; however, it can also be done using more common shop items, as follows.
2. First “extend” the surface of the blade by clamping a straight, flat object to the blade. (Figure 16a uses a small, lightweight aluminum ruler.) Use a lightweight clamp.
3. Place a square on the table and against the ruler. The square should lie flat against the ruler without a gap.
4. If there is a gap, loosen the bolt (Figure 16b) on each blade guide assembly and rotate the blade guide assembly until there is no more gap between the square and the ruler.
5. Re-tighten the bolts.
6. After making this adjustment, be sure to re-check other blade adjustments as noted in your manual.

3. Adjust the blade guides so they are as close as possible to the material without interfering.
4. There is a scale on the back side of the bed to aid in setting up the vise for 90° cuts or a particular miter. **Hint:** Always check the vise setup with a combination square, against the blade and vise, so that you can verify the vise setting is correct.

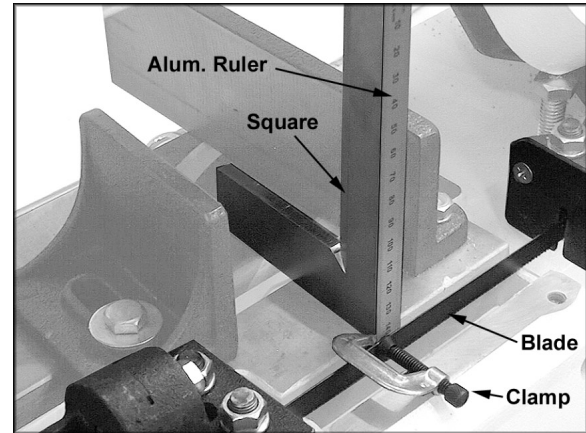


Fig. 16a

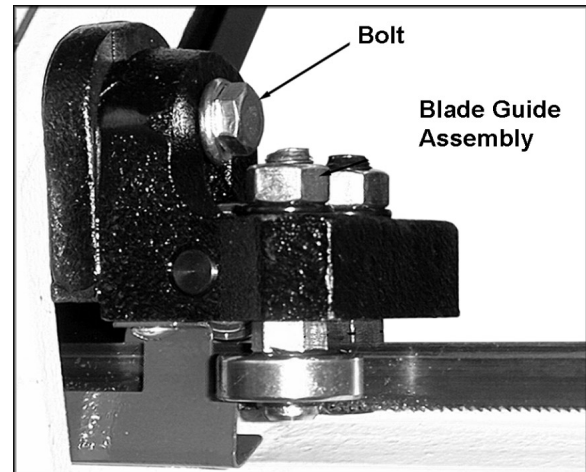


Fig. 16b

Adjusting Automatic Shut-Off

The saw should stop after the cut has been completed:

- If the saw completes the cut and continues to run, adjust the stop tip (A, Fig. 17) down.
- If the saw shuts off before the cut is complete, adjust the stop tip (A, Fig. 17) up.
- If the saw stops cutting but continues to run, adjust the stop bolt (B, fig. 17) down.

The saw is properly adjusted when the saw shuts off just after the blade has finished the cut.

Adjusting the Vise

1. To open and close the vise use the handwheel (C, Fig. 17).
2. The vise can be adjusted for square and miter cuts. Loosen the hex cap bolts and adjust the vise for the cut.

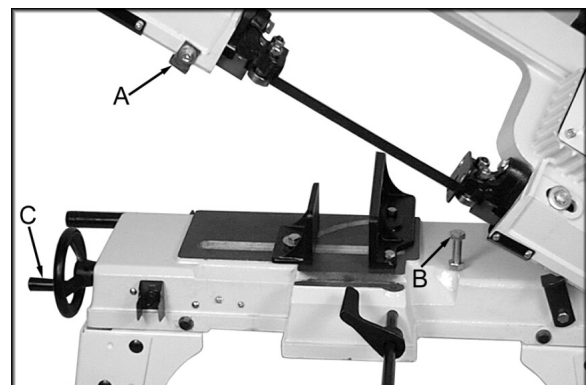


Fig. 17

Lubrication

Ball bearings on the blade guide assemblies and the blade wheels are permanently sealed and require no lubrication.

Lubricate the vise lead screw as needed with #2 tube grease.

Gear box oil will have to be changed after 90 days of operation. Thereafter, change every six months.

To change the gear box oil:

1. **Disconnect machine from the power source.**
2. Place saw arm in the horizontal position.
3. Remove screws (A, Fig. 18) from the gear box and remove cover plate and gasket.
4. Hold a container under the lower right corner of the gear box with one hand while slowly raising the saw arm with the other. Drain completely.

5. Place arm in the horizontal position. Wipe out remaining oil with a rag.
6. Fill gear box with approximately 1/2 pint of MOBIL SHC 634.
7. Replace gasket and cover. Fasten cover with bolts.

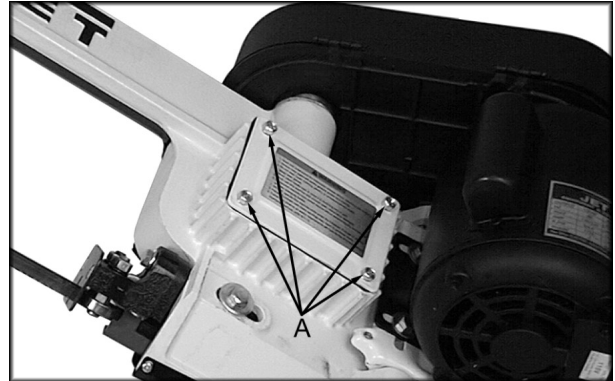
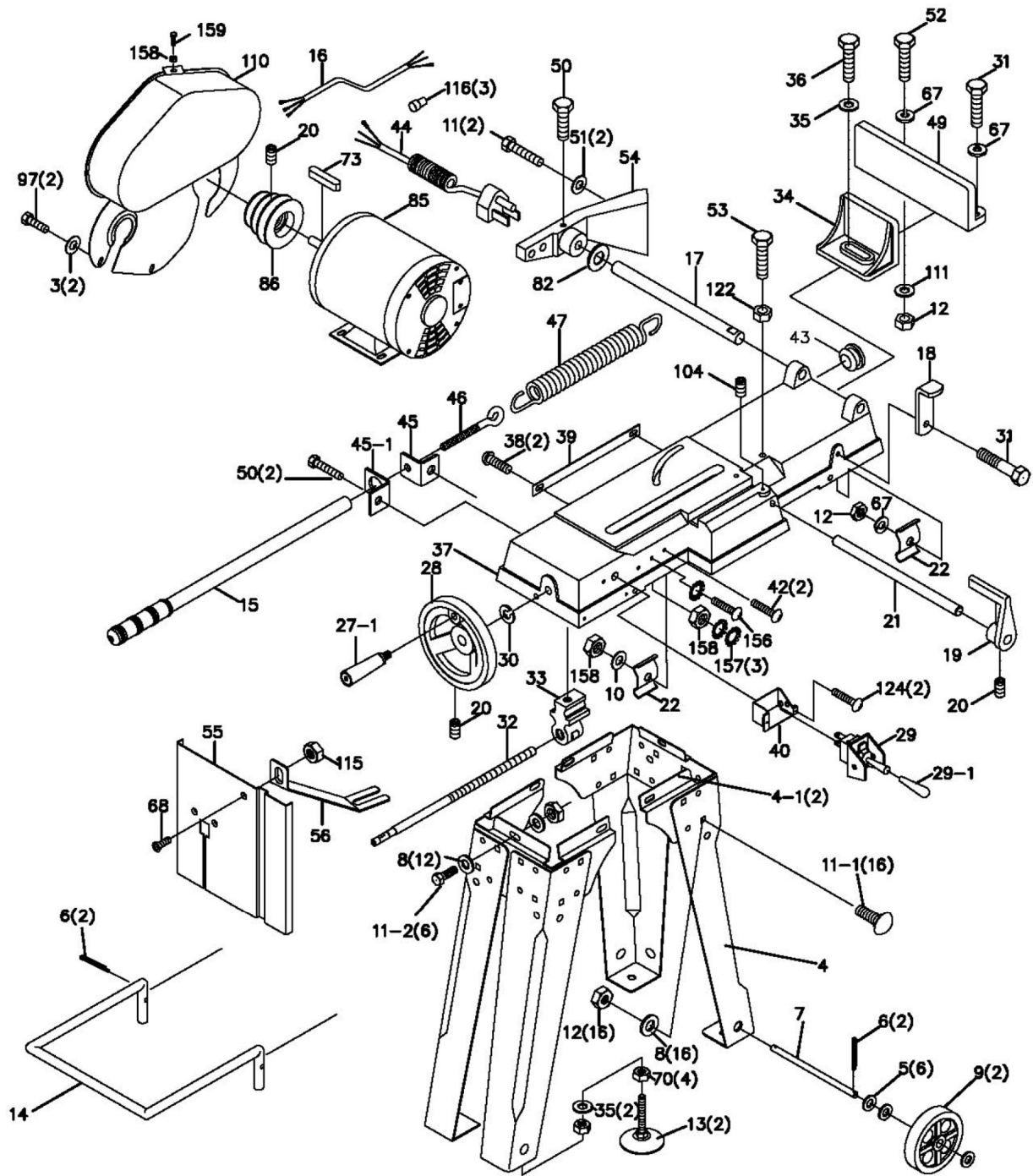


Fig. 18

Breakdown for Base Assembly



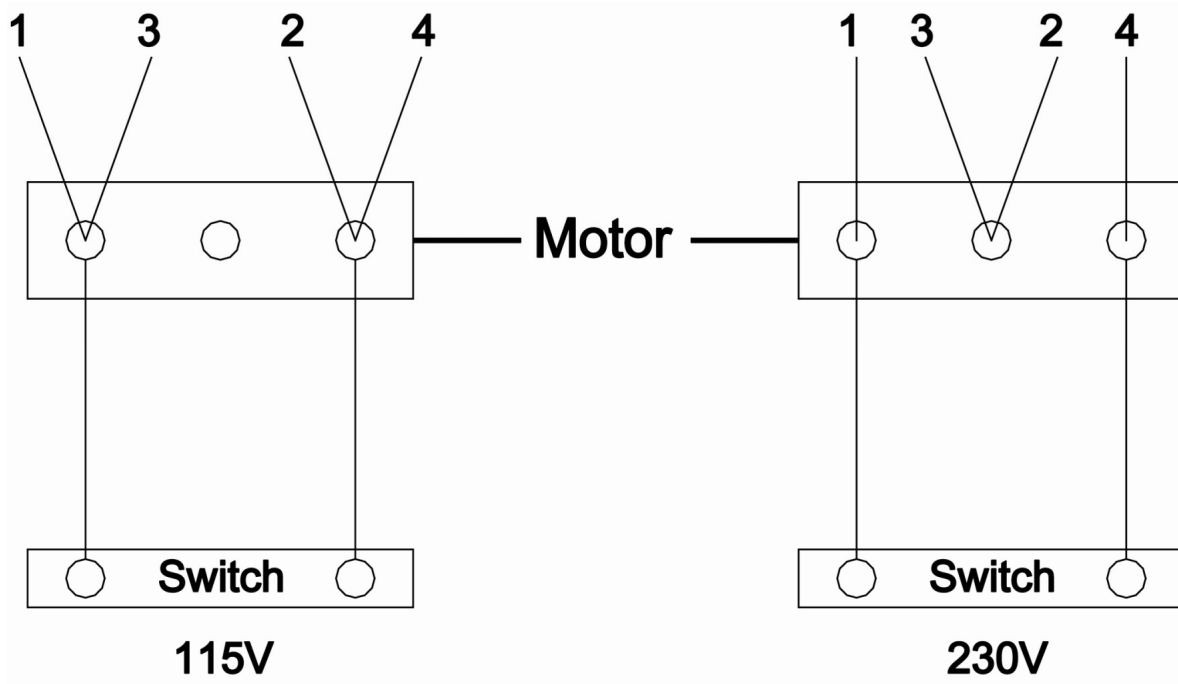
Parts List for the HVBS-56M Bandsaw

Index No.	Part No.	Description	Size	Qty.
1	TS-0051031	Hex Cap Bolt	5/16"x3/4"	4
2	TS-0561011	Hex Nut	1/4"	1
3	TS-0680021	Flat Washer	1/4"	4
4	HVBS56M-04	Stand Leg		4
4-1	HVBS56M-04-1	Cross Brace		2
5	HVBS56M-05	Washer		6
6	HVBS462-006	Cotter Pin	1/8"x1"	4
7	HVBS56M-07	Axle		1
8	TS-0680031	Flat Washer	5/16"	38
9	HVBS56M-09	Wheel		2
10	HVBS56M-010	Washer	1/4"x5/8"	1
11	TS-0051051	Hex Cap Bolt	5/16"x1"	4
11-1	HVBS56M-11-1	Carriage Bolt	5/16"x3/4"	16
11-2	TS-0051051	Hex Cap Bolt	5/16"x1"	6
12	TS-0561021	Hex Nut	5/16"	22
13	HVBS56M-013	Adjustable Foot		2
14	HVBS462-014	Floor Stand Handle		1
15	HVBS462-015	Adjusting Rod		1
16	HVBS462-016	Electric Cord		1
17	HVBS462-017	Pivoting Rod		1
18	HVBS462-018	Support Plate		1
19	HVBS462-019	Stock Stop		1
20	TS-0270021	Socket Set Screw	5/16"x5/16"	4
21	HVBS462-021	Stock Stop Rod		1
22	HVBS462-022	Wire Relief Retainer		2
25	TS-0051031	Hex Cap Bolt	5/16"x3/4"	1
27	HVBS462-027	Wheel Handle		1
28	HVBS462-028	Hand Wheel		1
29	HVBS56M-029	Toggle Switch Assembly		1
29-1	HVBS56M-029-1	Plastic Cover		1
30	HVBS462-030	E-Ring	E10	1
31	HVBS462-031	Screw	5/16"x1"	3
32	HVBS462-032	Lead Screw		1
33	HVBS462-033	Vise Nut		1
34	HVBS462-034	Moveable Vise Plate		1
35	TS-0680041	Flat Washer	3/8"x1"	4
36	TS-0090061	Hex Cap Bolt	3/8"x1-1/4"	1
37	HVBS462-037	Bed		1
38	HVBS462-038	Cross Round Head Screw	3/16"x3/8"	2
39	HVBS462-039	Scale		1
40	HVBS462-040	Electric Cord Clip		1
42	HVBS56M-042	Screw	M4x16	2
43	HVBS462-043	Rubber Ring		1
44	HVBS462-044	Electric Cable		1
45	HVBS462-045	Nut Plate		1
45-1	HVBS56M-045-1	Spring Handle Bracket		1
46	HVBS462-046	Spring Adjusting Screw		1
47	HVBS462-047	Spring		1
48	HVBS462-048	Cross Round Head Screw	3/16"x3/8"	4
49	HVBS462-049	Mitering Vise Plate		1
50	TS-0081031	Hex Cap Bolt	5/16"x3/4"	6

Index No.	Part No.	Description	Size	Qty.
49	HVBS462-049	Mitering Vise Plate		1
50	TS-0081031	Hex Cap Bolt	5/16"x3/4"	6
51	TS-0680031	Flat Washer	5/16"	3
52	TS-0081071	Hex Cap Bolt	5/16"x1-1/2"	1
53	TS-0091071	Hex Cap Screw	7/16"x2"	1
54	HVBS56M-054	Pivot Bracket		1
55	HVBS462-055	Vertical Cutting Plate		1
56	HVBS462-056	Stand for Vertical Cutting Plate		1
57	HVBS56M-057	Adjustable Bracket LH		1
57A	HVBS56M-057A	Adjustable Bracket Assembly LH		1
58	HVBS462-058	Knob	1/4"	1
59	HVBS56M-380	Blade Back Safety Cover		1
60	HVBS462-060	C-Clip	S10	4
61	BB-6000ZZ	Ball Bearing	6000ZZ	6
62	HVBS462-062	Guide Pivot		2
62A	HVBS462-062A	Center Shaft Assembly (Includes: #60-62)		1
62-1	HVBS462-062-1	Centrifugal Guide Pivot		2
62-1A	HVBS462-062-1A	Eccentric Shaft Assembly (Includes: #60,61,62-1)		1
63	HVBS462-063	Bearing Shaft Pin		2
64-1	HVBS462-064-1	Blade Seat Left		1
64-2	HVBS462-064-2	Blade Seat Right		1
65	HVBS56M-065	Adjustable Bracket-RH		1
65A	HVBS56M-065A	Adjustable Bracket-Assembly RH		1
66	HVBS56M-066	Lock Knob		1
67	TS-0720081	Lock Washer	5/16"	3
68	TS-0813051	Flat Head Machine Screw	1/4"X3/4"	3
69	HVBS462-069	Bearing Guard		1
70	TS-0561031	Hex Nut	3/8"	4
71	HVBS462-071	Blade Wheel Drive		1
72	HVBS462-072	Bearing Cover		2
73	HVBS462-073	Key	5x5x25	2
74	HVBS56M-060	C-Clip	S15	1
75	HVBS462-075	Hex Cap Bolt (w/Washer)	1/4"x1/2"	8
76	HVBS462-076	Switch Cut Off Trip		1
77	HVBS462-077	Idle Blade Wheel		1
78	TS-0680031	Flat Washer	5/16"	2
79	HVBS462-079	Blade Tension Knob	3/8"	1
80	HVBS462-080	Spring		1
81	HVBS56M-081	Saw Bow		1
82	HVBS56M-082	Washer		1
83	TS-0070031	Cap Screw	1/2"x1-1/2"	2
84	HVBS56M-084	Motor Mount Plate		1
84-1	HVBS56M-084-1	Tension Bracket		1
85	HVBS463-085	Motor	1/2 HP, 1Ph	1
	HVBS463-085-01	Capacitor Cover (not shown)		1
	HVBS462-085-02	Capacitor (not shown)		1
86	HVBS462-086	Motor Pulley		1
87	BB-6202ZZ	Ball Bearing	6202ZZ	6
88	HVBS462-088	Bearing Bushing		1
89	OS-15375	Oil Seal		2
90	HVBS462-090	Transmission Wheel Shaft		1
91	HVBS462-091	Worm Gear		1
92	HVBS462-092	Gear Box Gasket		1
93	HVBS462-093	Gear Box Cover		1

Index No.	Part No.	Description	Size	Qty.
94	HVBS462-094	Worm Gear (w/Shaft)		1
95	HVBS462-095	Spring Pin		1
96	HVBS462-096	Bearing Bushing		1
97	TS-0050011	Hex Cap Bolt	1/4"x1/2"	3
98	HVBS56M-098	Clamp		2
99	HVBS462-099	Spacer		1
100	HVBS462-100	Flat Cross Head Screw	5/32"x3/8"	8
101	HVBS462-101	Worm Gear Pulley		1
102	TS-0720081	Lock Washer	5/16"	2
103	HVBS462-103	Blade Tension Sliding Plate		1
104	TS-0270051	Socket Set Screw	5/16"x1/2"	3
105	HVBS462-105	Spring Pin		1
106	HVBS462-106	Sliding Plate Draw Block		1
107	HVBS462-107	Blade Wheel Shaft		1
108	HVBS462-108	Shaft Block		1
109	HVBS462-109	Blade Tension Sliding Guide		2
110	HVBS462-110	Motor Pulley Cover Assembly		1
111	TS-0680031	Flat Washer	5/16"	1
112	VB-A22	V-Belt	A22	1
113	414301	Blade		1
114	TS-0680041	Flat Washer	3/8"	4
115	TS-0561011	Hex Nut	1/4"	1
116	HVBS463-170	Wire Plug		3
117	HVBS463-171	Hex Screw	3/8"x1-1/4"	1
120	HVBS462-120	Bushing		1
122	TS-0561041	Hex Nut	7/16"	1
123	TS-0050031	Cap Screw	1/4"x3/4"	1
124	HVBS463-124	Machine Screw	3/16"x3/4"	2
126	HVBS462-126	Bushing		1
132	HVBS462-132	Blade Guard-Right		1
132-1	HVBS462-132A	Blade Guard-Left		1
156	HVBS462-156	Round Head Screw	3/16"x3/4"	1
157	HVBS462-157	Star Washer	3/16"	3
158	HVBS463-158	Hex Nut	3/16"	2
159	HVBS463-159	Round Cross Head Screw	3/16"x1/2"	1
	HVBS56M-BS	Blade Speed Label (not shown)		1
	HVBS56M-ID	I.D. Label (not shown)		1
	HVBS56M-WL	Warning Label (not shown)		1
	JM-56M	Stripe Decal (not shown)		1

Wiring Diagram



Notes



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