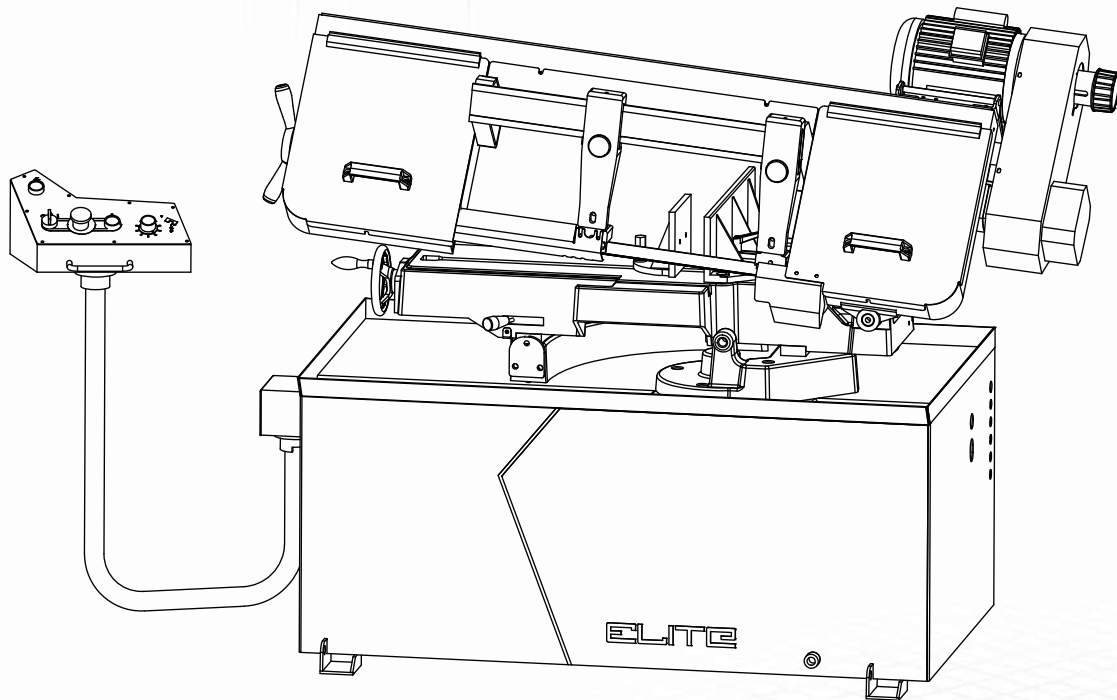




# ELITE

HIGH PERFORMANCE MACHINERY

Operating Instructions and Parts Manual  
8-in x 13-in Horizontal Cut-Off Bandsaw  
Models: EHB-8VS and EHB-8VSM



**JET®**

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Part No. M-891015  
REV C1 9/2018  
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## 1.0 WARRANTY AND SERVICE

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

### WARRANTY PERIOD

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website, [jettools.com](http://jettools.com).



### WHO IS COVERED?

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

### WHAT IS COVERED?

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

### HOW TO GET TECHNICAL SUPPORT

Please contact Technical Service by calling 1-855-336-4032. Please note that you will be asked to provide proof of initial purchase when calling. If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-855-336-4032 or use the Service Center Locator on the JET website.

### **MORE INFORMATION**

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

### **HOW STATE LAW APPLIES**

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

### **LIMITATIONS ON THIS WARRANTY**

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

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

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



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## 3.0 SAFETY WARNINGS

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

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

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

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

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

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



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

**⚠ CAUTION**

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

**⚠ WARNING**

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

## 4.0 INTRODUCTION

This manual is provided by JET® covering the safe operation and maintenance procedures for a JET Model EHB-8. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: [www.jettools.com](http://www.jettools.com). Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

## 5.0 SPECIFICATIONS

Model Number	EHB-8VS	EHB-8VSM
Stock Number	891015	891020
Capacity (in.):		
Rectangular Stock at 90° (in.)	13(W) x 5-1/4(H), 13-1/4(W) x 2(H)	
Rectangular Stock at 45° (in.)	8(W) x 8(H), 2(H) x 9-1/2(W)	8(W) x 8(H), 9-1/2(H) x 2(W)
Round Stock at 90° (in.)	8	
Round Stock at 45° (in.)	8	
Square Stock at 90° (in.)	8 x 8	
Speeds (FPM)	Variable 80~310	
Motor	TEFC< 1-1/2 Horsepower, Capacitor Start, 1725 RPM, 1 Phase, 115/230V (prewired 115V), 18/9A	
Blade Size (in.)	1 x 0.035 x 114.5	
Blade Type	Bi-metal	
Blade Guides	Tungsten carbide tip & ball bearing, eccentric shaft	
Material	Tungsten carbide inserts	
Sides	Eccentric shaft, ball bearings	
Blade Wheel (in.)	11-5/8 diameter, cast iron	
Bed Height (in.)	32	30
Dimensions (LxWxH) (in.)	62.5 x 22.4 x 48.4 (cutoff position)	
Net Weight - approx. (lbs.)	660	792
Shipping Weight - approx. (lbs.)	770	924
Vise	Rapid acting, screw tightening vise	
Coolant Pump	1/8 Horsepower, 1Phase, 115/230V	

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



## 6.0 MACHINE FEATURES

Figures 1 and 2 depict the main features of the Model EHB-8 Horizontal Cut-Off Bandsaw. The machine consists of a machine base onto which is installed a saw head.

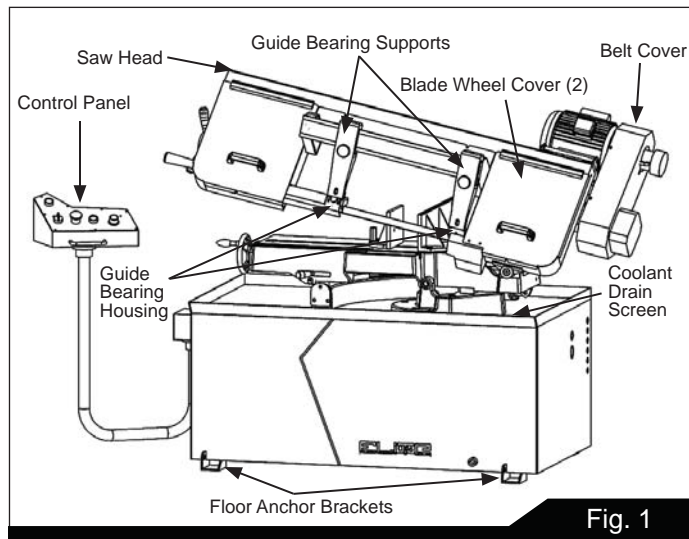
### 6.1 MACHINE BASE

The machine base consists of a coolant collection pan mounted on two panels that form the legs of the machine. A shelf is provided under the collection pan that supports a coolant tank.

The machine bed mounts on the top of the collection pan. The bed supports the vise and the vise-tightening lead screw.

The coolant tank is equipped with a pump/motor assembly. The pump/motor circulates coolant through tubing to cool and lubricate the saw blade, the blade guides, and the workpiece.

A drainpipe is provided to connect the collection pan to the coolant tank. A screen is provided in the collection pan to screen-out cutting debris as the coolant drains into the coolant tank. Coolant is added to the tank by pouring coolant into the collection pan. The tank is easily removed from its shelf for cleaning and maintenance.



### 6.2 SAW HEAD

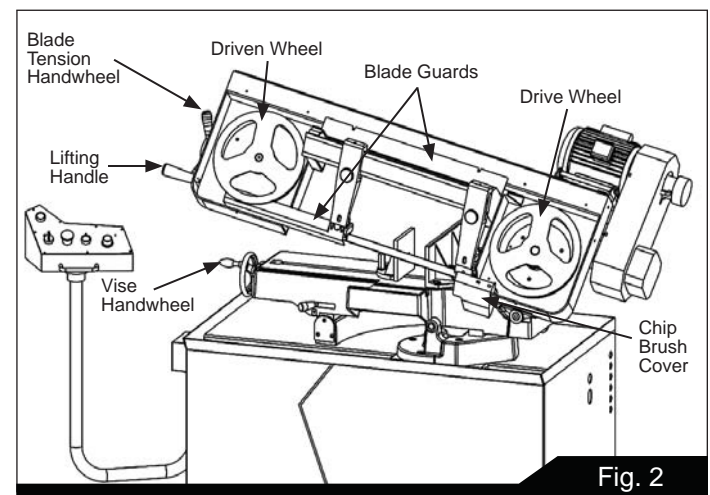
The saw head (Figure 2) consists of a drive motor, drive pulleys, gearbox, blade wheels, blade guides and supports, control panel, blade tension/blade tracking mechanism, wire brush, and the saw blade.

The drive motor is mounted on a pivoting plate that swings outward to provide drive belt tension. The motor is fitted with a step pulley; the drive belt connects to a second step pulley that is mounted on the input shaft of the gearbox.

A speed-reducing gearbox is mounted on the back side of the blade wheel box on the right side of the machine. The blade wheel (drive wheel) is installed on the output shaft of the gearbox.

A second blade wheel is located in a blade wheel box on the left of the machine. The blade wheel (driven wheel) is mounted on a shaft that is part of the blade tension/tracking mechanism. The blade tension mechanism is used to tighten the saw blade on the blade wheels.

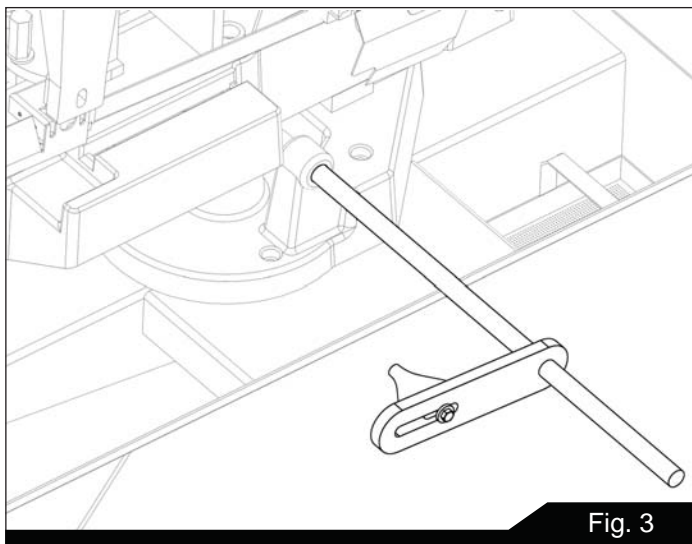
The mechanism also has adjustment screws that enable the saw blade to “track” evenly on the blade wheels. The adjustment screws change the angle of the driven blade wheel shaft so the wheels are aligned. Tracking adjustments are generally made after the saw blade is changed but may be required periodically due to wear over time.





### 6.3 WORK STOP

A work stop (refer to Figure 3) is provided with the machine to allow cutting multiple pieces of identical length (refer to Figure 12). The stop consists of a rod onto which is installed a stop bracket, a tapered stop, a clamping knob and a locking handle. The rod is installed in a bore in the front of the saw bed. The stop bracket is positioned on the rod with the tapered stop toward the end of the workpiece. The bracket is moved in or out on the rod to establish the length of the workpiece.



### 6.4 CONTROL PANEL

The control panel is mounted on a movable arm to the left of the saw. Refer to the *Controls and Indicators* section (section 9.0) for a description of the controls.

### 6.5 AUXILIARY COOLANT HOSE

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

## 7.0 UNPACKING AND ASSEMBLY

### 7.1 MACHINE SETUP

The cut-off saw has been pre-adjusted at the factory and several test pieces have been cut to verify cutting accuracy. Remove the saw from the shipping skid; discard any hold-down devices. Place the saw on the shop floor; secure the saw to the floor using mounting anchors secured through four holes in the machine base. (Refer to Figure 1 for floor anchor bracket location). If the saw will be used to cut long pieces of stock, allow plenty of room for the length of the stock.

## 8.0 ELECTRICAL CONNECTION

### **⚠ WARNING**

***Electrical connection must be made by a licensed electrician. The wiring methods and practices must comply with local electrical codes.***

### **⚠ WARNING**

***The machine uses high voltage electrical power that poses a significant risk of serious injury or death if proper precautions are not observed.***

Connect the machine to the electrical power branch circuit (refer to the *Wiring Diagram* section 19.0). Observe the following guidelines when connecting the saw to the power source:

1. Make sure the saw is disconnected from the electrical power branch circuit (trip the required circuit breakers or remove the required fuses).
2. Place a warning placard or tag on the service panel to prevent accidental electrical shock.
3. When installing the motor power cord into a receptacle, make sure the plug is compatible with the receptacle.
4. When using hard-wired connections, connect the wires as shown in the *Wiring Diagram* section.
5. Install the fuses or reset the breakers.  
Check operation of the saw.



## 9.0 CONTROLS AND INDICATORS

### 9.1 CONTROL PANEL

The operating controls for the cut-off saw are located on the control panel (Figure 4) and consist of the following controls and indicators:

**Coolant Pump Switch (A)** – turns coolant pump on and off.

**Emergency Stop Switch (B)** – press to stop the drive motor.

**Note: A micro switch also stops the motor when the workpiece is cut and the saw head is completely down.**

**Start Switch (C)** – press to start the drive motor. The saw head must be in the raised position.

**Power Light (D)** – indicates that machine is plugged in and the outlet circuit breaker is turned on. The machine does not need to be running for the power light to be on.

### ⚠ WARNING

*If the bulb is out, lamp will not light, but machine may still have power.*

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

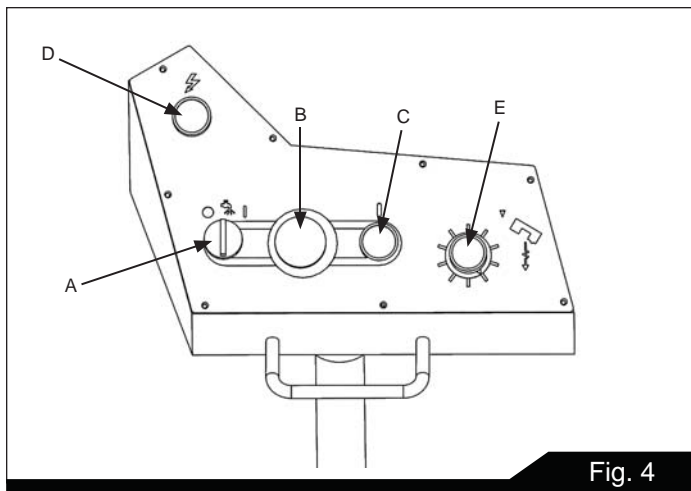


Fig. 4

### 9.2 BLADE SPEEDS

The Model EHB-8 horizontal cut-off bandsaw is equipped with electronic variable speed raging from 80-310 FPM. The speed change is completed by turning the speed control knob (Figure 5) located to the right of the machine on the main motor. Change blade speeds as follows:

1. Raise the saw head so that it is not in contact with a work piece.
2. Press the motor start button on the main control panel.
3. Adjust the speed to correspond with the material that you are cutting (Figure 6 on page 9) Note: speeds are approximate.

### ⚠ CAUTION

*Adjust speed dial only when machine is running.*

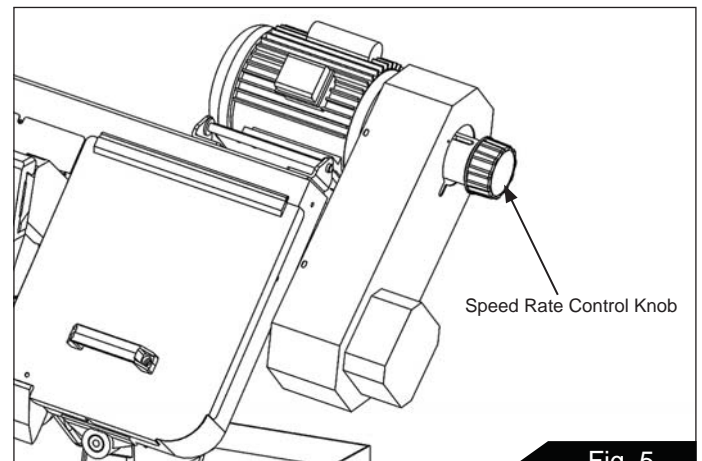


Fig. 5

Material to be Cut	Belt Speed	
	60 Hz	
	fpm	mpm
Tool Steel, Stainless Steel, Alloy Steel, Phosphor Bronze, Hard Bronze, Hard Cast Iron, Malleable Iron	~80	25
Mild Steel, Soft Cast Iron, Medium Hard Brass, Medium Hard Bronze	~130	40
Soft Brasses and Bronzes, Hard Aluminum, Plastics	~170	51
Plastics, Soft and Medium Aluminum, Wood, Other Light Materials	~235	71

Fig. 6

## 10.0 BLADE SELECTION

The cut-off saw is delivered with a saw blade that is adequate for a variety of cut-off jobs on a variety of common materials.

Refer to Figure 6 for the speeds recommended for various materials. These speeds, while appropriate for many common shop cutting needs, do not encompass the wide variety of special blade configurations (tooth pitch and set) and special alloys for cutting unusual or exotic materials.

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

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

For very high production on cutting of special materials, or difficult to cut materials such as stainless steel, tool steel, or titanium, you can ask your industrial distributor for more specific blade recommendations. The supplier that provides the workpiece material should be able to provide you with very specific instructions regarding the best blade (and coolant or cutting fluid, if needed) for the material or shape supplied.

### 10.1 BLADE BREAK-IN PROCEDURES

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

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

Watch the chip formation until cutting is at its most efficient rate and allow the saw to complete the cut

(refer to *Evaluating Cutting Efficiency* section 11.2).

The blade is now considered ready for use.

## 11.0 OPERATIONS

### 11.1 HYDRAULIC FEED CONTROL

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

The hydraulic feed control circuit consists of a single acting hydraulic cylinder (Figure 7) and a feed rate control (Figure 4). The feed control cylinder resists motion in the downward direction to control the feed rate. The control cylinder offers no resistance when raised upward.

The feed rate control knob (Figure 4) controls the rate at which the saw head is lowered. The control knob (needle valve) controls the rate at which the hydraulic fluid is released from the hydraulic cylinder. When the needle valve is closed, the cylinder is locked. With the needle valve slightly open, the cylinder permits slow, or light, downward force. Opening the needle valve further increases the feed rate and applies more force to the saw blade and workpiece.

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

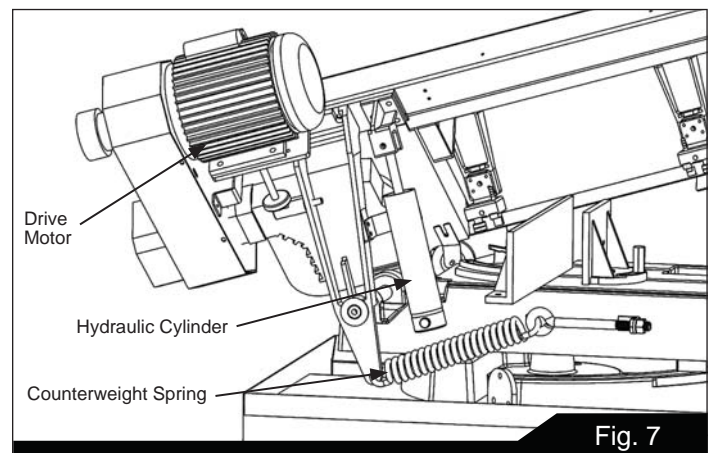


Fig. 7

## 11.2 EVALUATING CUTTING EFFICIENCY

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

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

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

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

## 11.3 WORK SETUP

Referring to Figure 8:

1. Set the feed rate control knob (C) to zero.
2. With the lifting handle (A) raise the saw head (B).
3. Turn the vise handwheel (D) counter clock-wise enough to free the moveable vise jaw (E). Then pull the moveable vise jaw away from the fixed vise jaw(H).
4. Place the workpiece (F) on the work table (G). For long workpieces, provide support at the other end. If necessary, provide additional downward clamping to hold the workpiece securely on the worktable.
5. Clamp the workpiece (F) in the vise by first pushing the moveable vise jaw (E) against the workpiece. Then rotate the vise handwheel (D) clockwise to secure the workpiece.

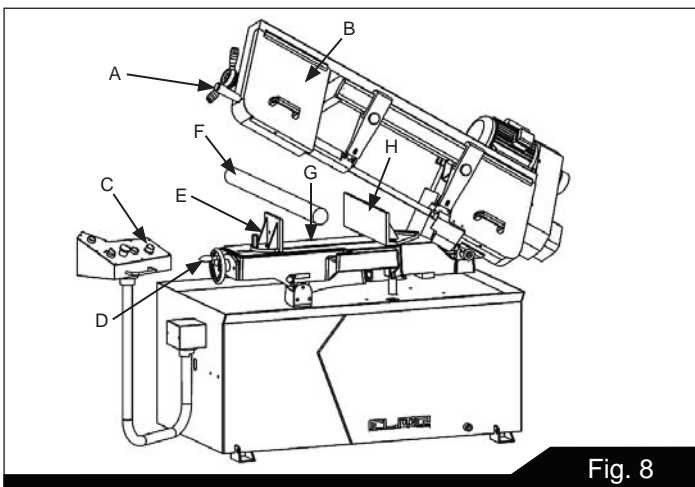


Fig. 8

## 11.4 SETTING THE VISE FOR ANGLE CUTS (NON-MITERING VERSION ONLY)

Referring to Figure 9, the vise can be adjusted through a 45-degree arc as follows:

1. Loosen the lock handle (E) that secures the fixed vise jaw (D).
  2. Rotate the fixed vise jaw (D) to the desired angle, setting it to the scale on the back edge of the table.
- For accurate cuts, use a variable protractor to set the position of the jaw, aligning one side of the protractor with the blade.
3. Tighten the lock handle (E).
  4. Loosen the hex head bolt (A) on the moveable vise jaw (C).
  5. Place the workpiece (B) between the vise jaws (C, D).
  6. Set the moveable vise jaw (C), pressing it against the side of the workpiece (B) and fixed vise jaw (D).
  7. Tighten the hex head bolt (A) on the moveable vise jaw to secure the jaw.

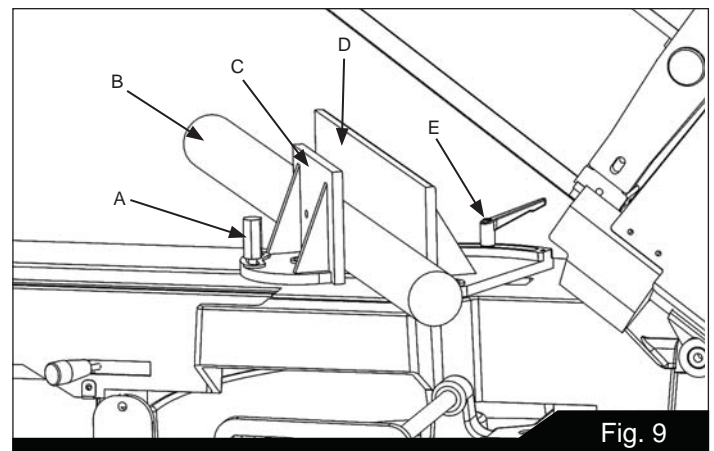


Fig. 9

## 11.5 SETTING THE VISE FOR SQUARE CUTS

The procedure for setting the vise for square cuts is identical to setting for angle cuts (above) except that a machinist's square is used to set the angle of the fixed vise jaw (A, Fig. 10). Align one side of the square with the side of the slot (B, Fig. 10) in the table.

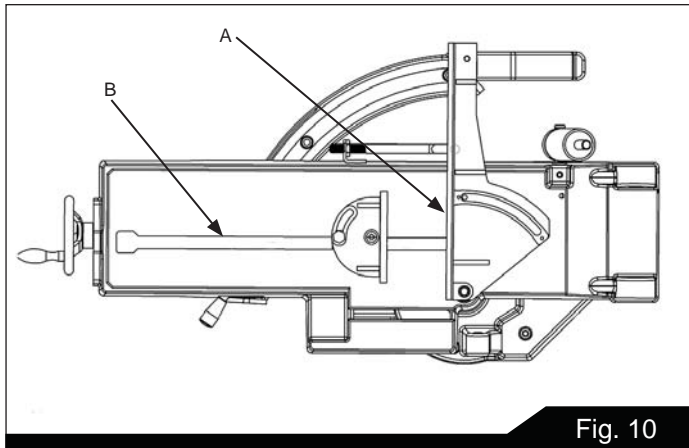


Fig. 10

## 11.6 SETTING BED FOR MITERING CUTS (MITERING VERSION ONLY)

The saw head can be adjusted through a 45-degree arc as follows:

1. Ensure that power is turned off and then loosen saw head miter lock.
2. Rotate the saw head to the approximate desired angle as specified on the miter angle gauge. Then verify the exact angle with Engineers square.
3. Lock the saw head miter lock. The miter locking lever extends through a slot in the front face of the saw bed. Rotate the lever to the right to tighten the lock and to the left to loosen.
4. Load the work piece and continue with steps below.

## 11.7 STARTING THE SAW

**Important:** The efficient operation of the cut-off saw is dependent upon the condition of the saw blade. If the performance of the saw begins to deteriorate, the first item that you should check is the blade.

If a new blade does not restore the machine's cutting accuracy and quality, refer to the *Troubleshooting* section (or the blade manufacturer's guide) for conditions to consider and adjustments that can be made to increase the life of the blade.

To change the blade, refer to the *Changing Blades* section on page 17.

### ⚠ WARNING

**Never operate the saw without blade covers in place.**

### ⚠ CAUTION

**Make sure the blade is not in contact with the workpiece when the motor is started. Do not drop the saw head on the workpiece or force the saw through the workpiece.**

To start the saw:

1. Clamp the workpiece in the vise. Refer to Figures 10 and 11 for examples of workpieces in the vise. Be sure the blade is not in contact with the workpiece when the motor is started.
2. Start the motor and allow the saw to come up to speed.
3. Slowly set the saw down onto the workpiece and adjust cutting speed with the speed control knob (described on page 9).
4. Do not drop the saw head or force the cut. Let the weight of the saw head provide the cutting force.
5. The saw will automatically shut off at the end of the cut.

## 11.8 COOLANT FLOW AND NOZZLE POSITION

### ⚠ CAUTION

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

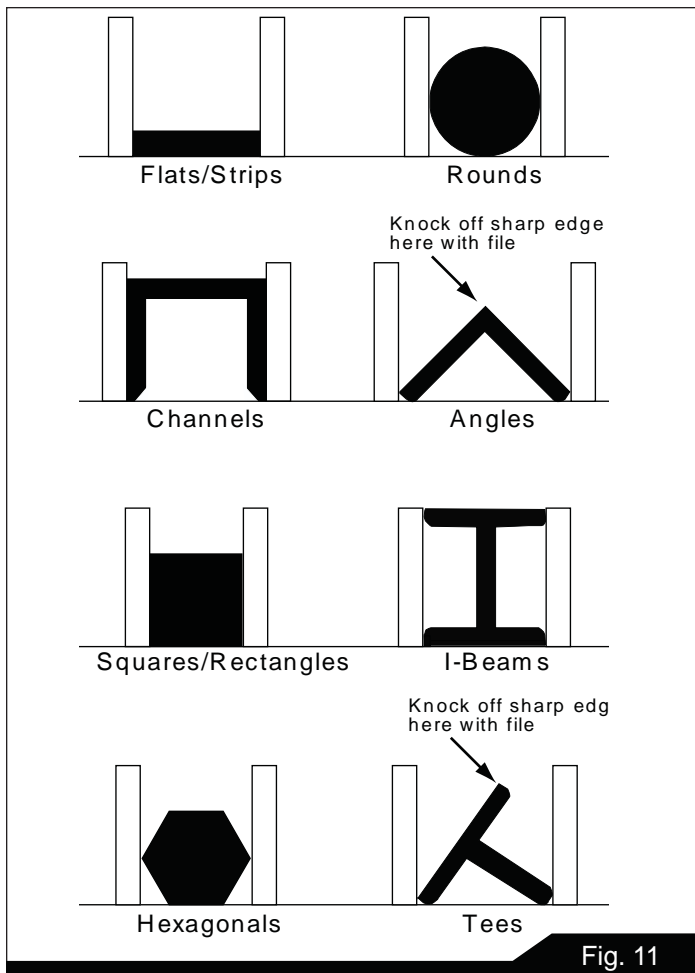
Adjust the coolant flow shut-off valves at the top of the saw head weldment. The flow should be no more than the saw blade can draw into the workpiece by the movement of the blade.

The coolant flow can be stopped in two ways:

- by the coolant selector switch (A, Fig. 4) on the control box (the preferred method)
- by closing the shut-off valves

**Note:** The coolant pump is self-circulating when the shut-off valves are closed.





### 11.9 SETTING THE WORK STOP

Referring to Figure 12:

The *work stop* is an accessory that is included with the Jet EHB-8 Bandsaw. It is used to set up the saw for making multiple cuts of the same length.

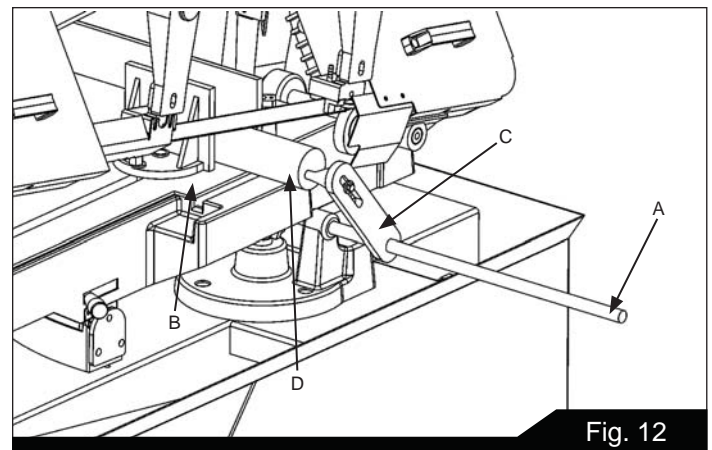
## ⚠ CAUTION

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

Thread the *stop rod* (A) into the threaded opening on the front of the saw bed (B) as shown.

Set the work stop as follows:

1. Loosen the *stop arm* (C).
2. Position the *stop arm* (C) on the *stop rod* (A) to obtain the desired length of cut on the *workpiece* (D).
3. Rotate the *stop arm* (C) so it contacts the end of the *workpiece* (D).
4. Secure the *stop arm*.



## 12.0 ADJUSTMENTS

### 12.1 BLADE TRACKING ADJUSTMENT

Refer to Figures 13 and 14.

Blade tracking has been set and tested at the factory. *Adjustment is rarely required* when the blade is used properly or if the blade is correctly welded.

If adjustment is needed:

1. Using the blade tension *handwheel* (D), make sure the blade is properly tensioned.  
Keep proper tension at all times.

**Note:** Blade tensioning is described in the *Changing Blades* section on page 17.

2. Raise the *saw head* (A) as shown.
3. Open the *wheel guards* (B).
4. Remove both of the *blade-guide bearing bracket assemblies* (C).
5. Loosen three *hex locking screws* (E) in the *head weldment* (G).

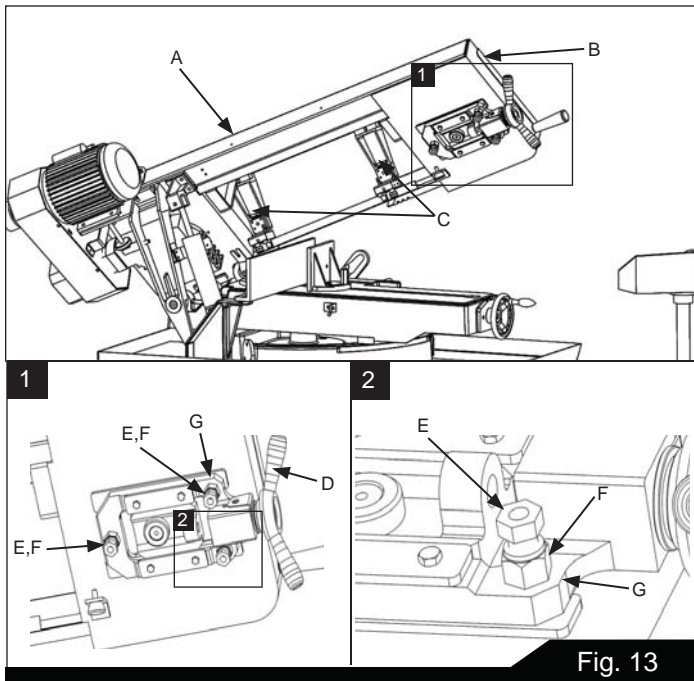


Fig. 13

**⚠ CAUTION**

**While performing the following, keep the blade from rubbing excessively on the shoulder of the wheel. Excessive rubbing will damage the wheel and/or the blade.**

6. Start the saw. Turn the *adjustment screws* (F) to tilt the idler wheel (Figure 14) until the blade is touching the shoulder of the idler wheel.

**Note:** As a general rule, make the same adjustment to the two adjustment screws on the right (F, Fig. 13). The single adjustment on the left is independent.

7. Next, turn the *adjustment screws* (F) so the blade starts to move away from the shoulder of the wheel then immediately turn the *adjustment screws* in the other direction so the blade stops – then moves slowly toward the shoulder.

**⚠ WARNING**

**Keep fingers clear of the blade and wheel to avoid injury.**

8. Turn the *adjustment screws* (F) to stop the motion of the blade on the wheel as it gets closer to the wheel shoulder.

Put a 6-inch length of paper (J, Fig. 14) between the blade and the wheel as shown (the saw is still turned on). The paper should not be cut as it passes between the wheel shoulder and the blade.

9. Turn the *adjustment screws* (F) slightly. Repeat the insertion of the paper between the wheel shoulder and the blade until the paper is cut in two pieces.

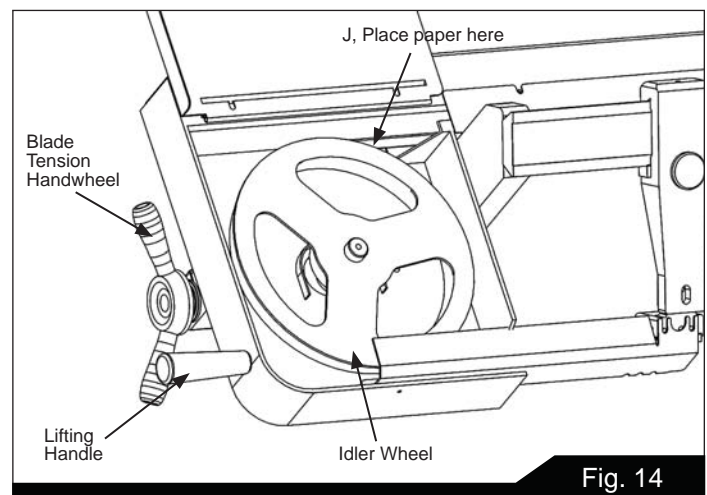


Fig. 14

**Note:** You may have to repeat the check with the paper several times before the blade and the shoulder cut the paper into two pieces. Do not hurry the adjustment. Patience and accuracy here will pay off with better, more accurate, quieter cutting and much longer machine and blade life.

When the paper is cut:

10. Turn the *adjustment screws* (F) slightly in the counter-clockwise direction. This ensures that the blade is not touching the shoulder of the wheel.
11. Shut off the saw.
12. Tighten the *hex locking screws* (E).
13. Install the *blade-guide bearing bracket assemblies* (C, Fig. 13).
14. Position the guides so the top bearing just touches the blade (see *Blade Guide Bearing Adjustment* on page 16) .
15. Close the *wheel covers* (K, Fig. 15).



## 12.2 BLADE GUIDE ADJUSTMENT

Referring to Figure 15:

The EHB-8 Bandsaw has two adjustable blade guide assemblies, each consisting of the *blade guide support* or bracket (B, H) and *blade guide* (A).

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

### Left Blade Guide

1. Place the *workpiece* (G) in the *vise* (F) and clamp tightly (refer to *Work Setup* on page 8).
2. Loosen the left *lock knob* (C) only.
3. Slide the *guide support* (D) left or right so that it just clears the piece to be cut (G).
4. Tighten the *lock knob* (C).

### Right Blade Guide

The right blade guide assembly is set at the factory and rests against the *stop* (E). It normally does not require adjustment, except to provide clearance for workpieces to be cut at a great angle. If adjustment is required, the procedure is the same as for the left blade guide adjustment.

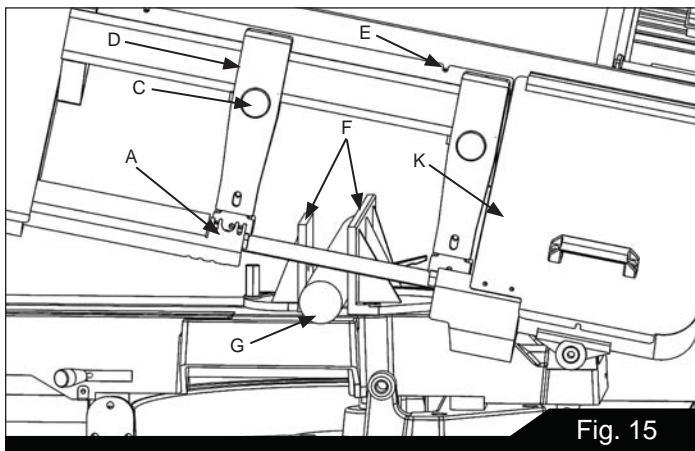


Fig. 15

## 12.3 BLADE GUIDE BEARING ADJUSTMENT

Referring to Figure 16:

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

*Blade guides* provide blade support.

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

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

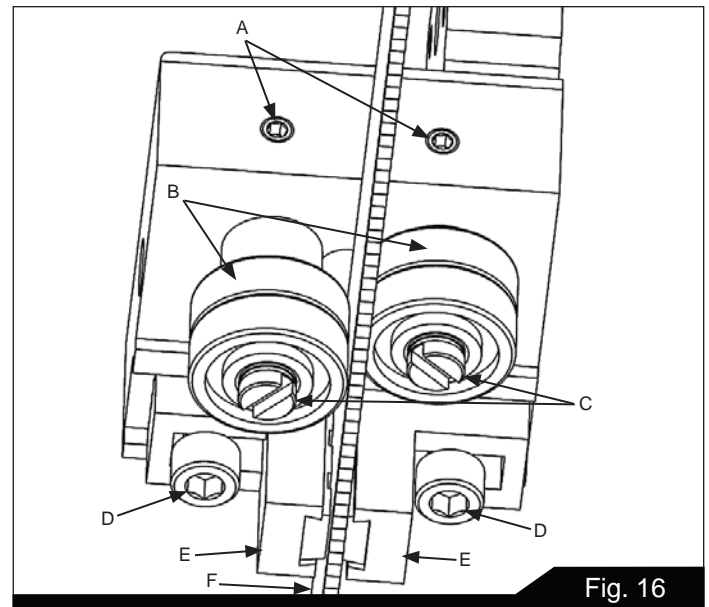


Fig. 16

### ⚠ WARNING

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

### ⚠ CAUTION

**Check the blade to make sure the welded section is the same thickness as the rest of the blade. If the blade is thicker at the weld, the guide bearings may be damaged.**

If required, adjust first one *guide bearing* and *blade guide assembly* then the other as follows:

1. Using a 3mm hex wrench, loosen two *set screws* (A) securing the eccentric bushings.
2. Using a 5mm hex wrench, loosen two *socket head cap screws* (D) securing the *carbide blade guides* (E).
3. Position the *bearings* (B) by turning the *bushings* (C) with a flat-head screwdriver. Set the clearance between the *bearings* (B) and *blade* (F) at approximately 0.001 inch.

When properly adjusted, the blade should be in a vertical position between the bearings as shown in Figure 17.

4. Tighten the *set screws* (A).
5. Adjust the *blade guides* (E) so they support the blade without pinching and tighten the *socket head cap screws*.
6. When the adjustment is correct, the guide bearings should rotate freely with slight pressure of the finger (blade stopped).

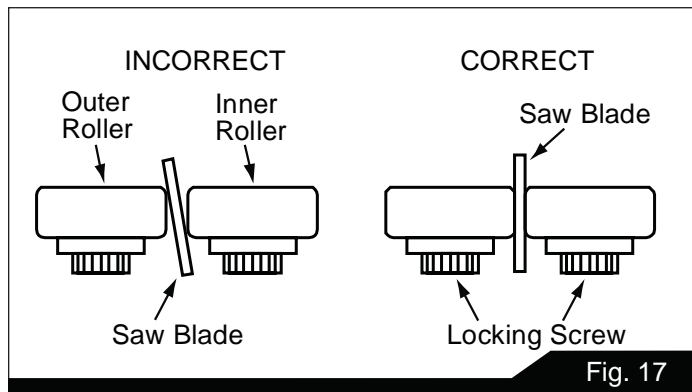


Fig. 17

## 12.4 DRIVE BELT TENSION ADJUSTMENT

The *drive belt* will stretch with use and may occasionally require tension adjustment. To adjust see the *Changing Drive Belt* section (page 18) steps 1, 2, 6, and 7.

## 12.5 VERIFYING ADJUSTMENT ACCURACY

Refer also to Figure 18.

Test cuts can be used to determine whether or not you have adjusted the blade accurately. Use 2 inch round bar stock to perform these test cuts, as follows:

1. With the bar stock securely clamped in the vise, make a cut through the bar stock.
2. Mark the top of the bar stock.
3. Move the bar stock about 1/4 inch past the blade so you can begin a second cut.
4. Rotate the bar stock 180 degrees so the mark you made is now at the bottom of the cut.
5. Make a cut through the bar stock.
6. Use a micrometer to measure the thickness variation between the top and bottom of the disk you have cut from the bar stock.

The saw blade can be considered correctly adjusted when the variation measured is no more than 0.012 inch across the face of the disk. If you do not have a piece of 2-inch bar stock available for a test cut, use a larger diameter test workpiece rather than a smaller one. The maximum thickness variation on any test piece should be no more than 0.006 in. per inch of stock diameter.

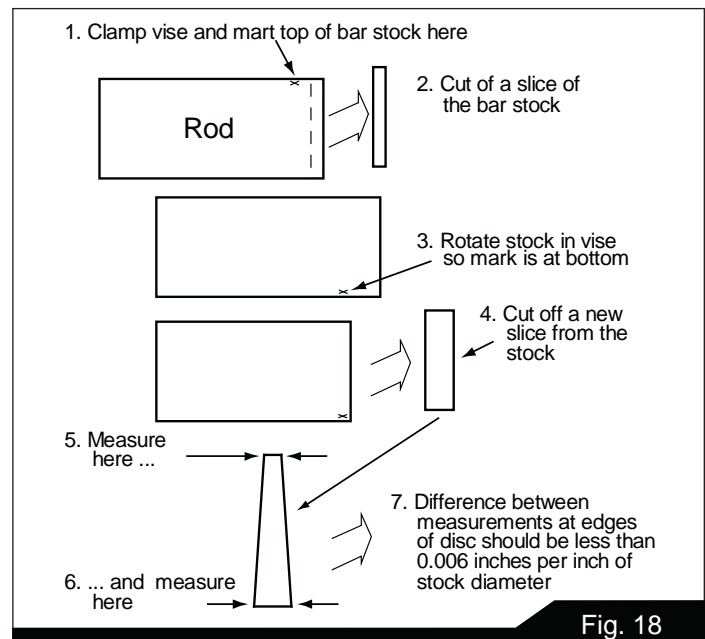


Fig. 18

## 12.6 LIMIT SWITCH ADJUSTMENT

### **⚠ WARNING**

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

Referring to Figure 19:

Loosen the *jam nut* and set the *adjustment screw* so that the *limit switch* will actuate to the off position when the saw has cut through the workpiece.

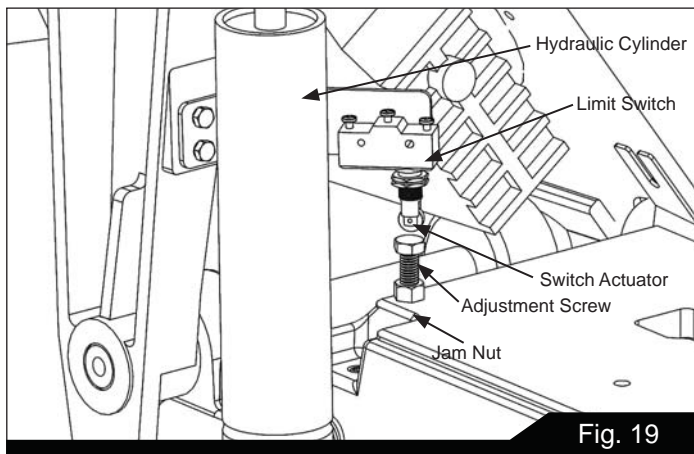


Fig. 19

## 12.7 COUNTERBALANCE SPRING TENSION

### **⚠ WARNING**

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

The *counterbalance spring* is located on the rear of the saw table (refer to Figure 20). The counterbalance spring is used to adjust the amount of down force the saw arm puts on the workpiece when the hydraulic control cylinder is fully open.

If adjustment is needed:

1. Raise the saw arm to its full upright position and lock it in position.
2. Set the spring tension by adjusting the nut until 1-1/4

to 1-1/2 inches are exposed on the right side of the eyebolt mount.

The saw can now be returned to service.

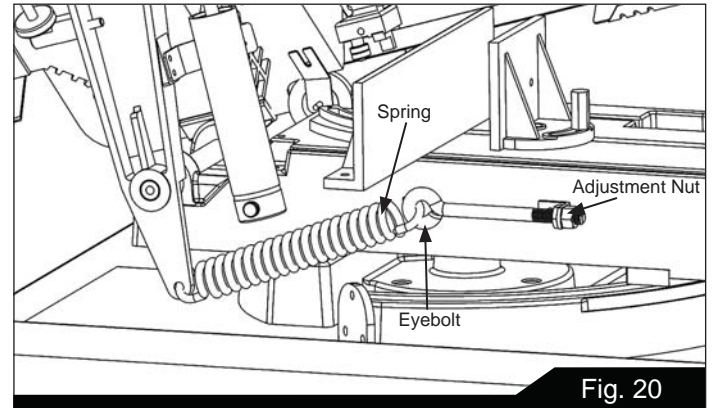


Fig. 20

## 13.0 MAINTENANCE

### 13.1 CHANGING BLADES

### **⚠ WARNING**

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

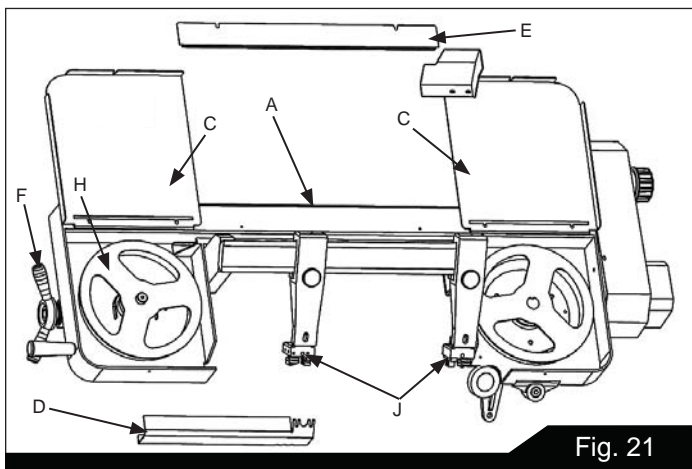
### **⚠ WARNING**

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

Referring to Figure 21 (pg. 18):

1. Raise the saw head (A). Set the feed rate control knob to zero to lock the hydraulic cylinder, which will hold the saw head in place.
2. Open two hinged blade wheel covers (C).
3. Remove the blade guard (D) and column blade cover (E).
4. Turn the blade tension handle (F) counter-clockwise until the blade hangs loose.

5. Using leather gloves to prevent cuts and scratches, pull the blade off the drive wheels (H) and out of the blade guides (J). Store the removed blade carefully before proceeding.
6. Slide the new blade into the blade guides (J), then loop the blade around the drive wheels (H) such that the teeth face towards the back and the smooth side faces towards the front.  
This will permit the vertical side of the teeth to contact the workpiece first.
7. Push the blade so it is seated against the shoulders of the wheels (H).  
When it is seated against the shoulder, turn the blade tension handle (F) clockwise to increase the tension. Do not over-tension the blade; tighten it just enough so it does not slip while cutting.
8. When the blade is properly tensioned, reconnect the saw to the electrical power source.
9. Check and adjust the tracking of the blade. Refer to Blade Tracking Adjustment (on page 14) if necessary.
10. Close the wheel covers (C).
11. Put 2 to 3 drops of oil on the blade.



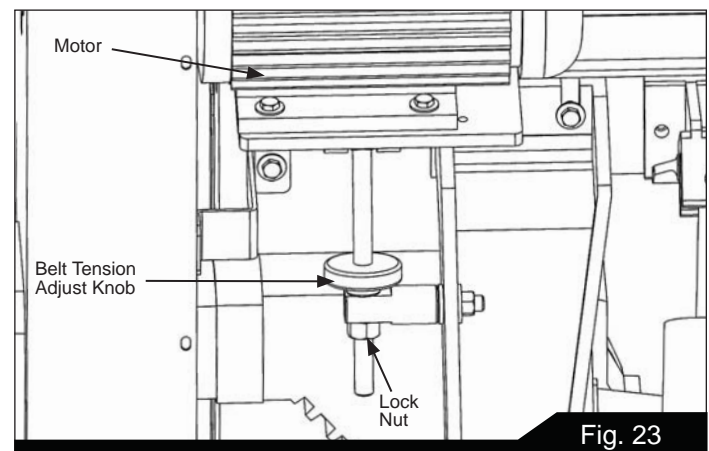
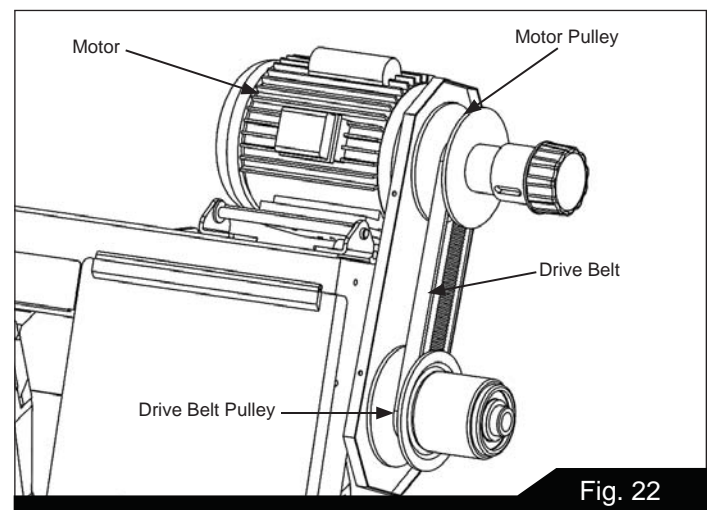
### 13.2 CHANGING THE DRIVE BELT

Referring to Figures 22 and 23:

#### WARNING

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

1. Set the arm at the full horizontal position.
2. Open the drive *belt cover* to expose the *drive belt* and *pulleys*.
3. Loosen the *belt tension adjust knob* located in the rear under the motor (see Figure 23 for knob direction). Lift the *motor* upward to loosen the belt.
4. Remove the worn *drive belt*.
5. Put the replacement *drive belt* in the pulley position for the speed you require (refer to the *Blade Speeds* section on page 9).
6. Tighten the drive belt by turning the belt tension adjustment knob (see Figure 23). The belt must be secure enough it does not slip when the machine is running. Do not over tighten. This will cause premature wear on belt and pulley bearings.
7. Reinstall drive belt cover and install knob.





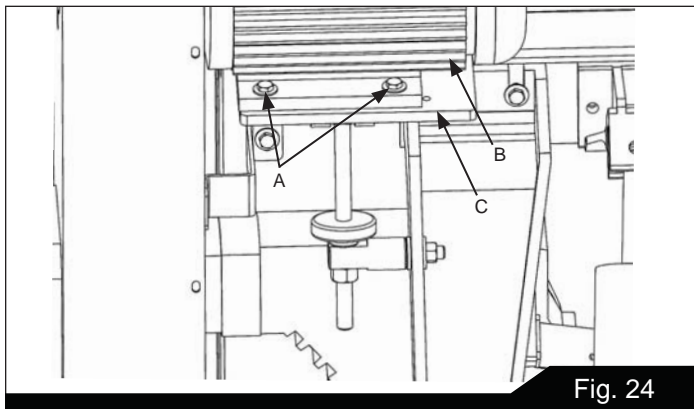
### 13.3 REPLACING THE DRIVE MOTOR

#### **⚠ WARNING**

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

Referring to Figure 24:

1. Remove the drive belt (see *Changing the Drive Belt* above).
2. Open the motor junction box and disconnect the power cord wires from their terminals.
3. Remove four screws and washers (A) that secure the motor (B) to the mounting plate (C).
4. Installation of a new motor is a reversal of the above steps. Also, refer to *Changing the Drive Belt* (page 18) to complete tensioning of the drive belt.



### 14.0 CLEANING

1. Clean off any preservative on machine surfaces. After cleaning:
2. Coat machined surfaces of the cutoff saw with a medium consistency machine oil. Reapply the oil coating at least every six months.
3. Clean up accumulated saw cuttings after use. Make sure the lead screw and rapid nut are kept free from saw cuttings and other material that would cause damage.

4. Clean the chip sludge from the coolant tank. The frequency should be determined by how often the saw is used.

### 15.0 LUBRICATION

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

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

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

*Upper Wheel Bushing* – six to eight drops of oil each week.

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

### 16.0 COOLANT

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

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

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



## 17.0 TROUBLESHOOTING

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



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



## 18.0 REPLACEMENT PARTS EHB-8VS/VSM

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

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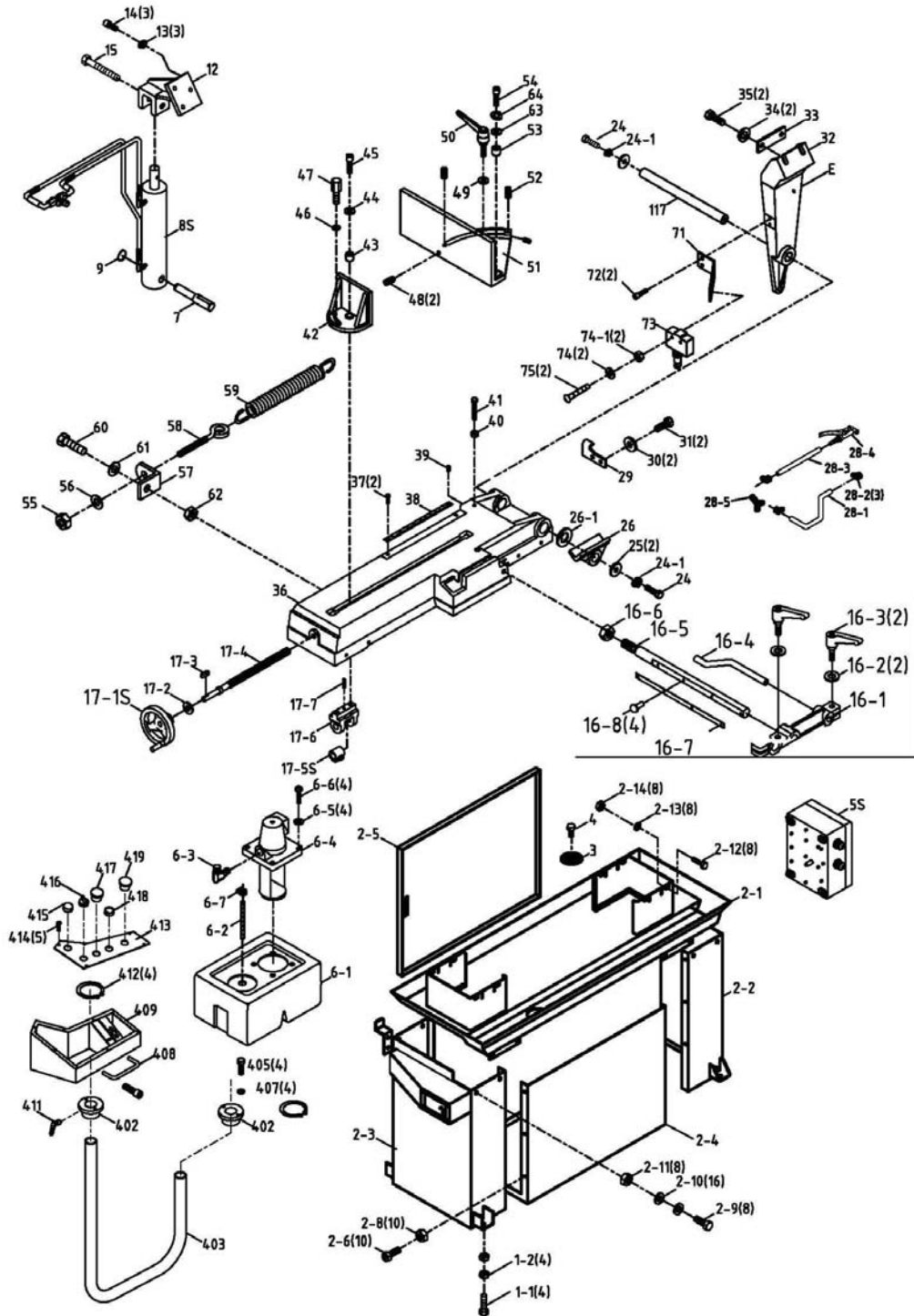
427 New Sanford Road

LaVergne, Tennessee 37086

[www.jettools.com](http://www.jettools.com)

Ph.: 855-336-4032

**EHB-8VS SAW STAND & BED - PARTS BREAKDOWN**





## EHB-8VS SAW STAND & BED PARTS LIST

Index No.	Part No.	Description	Size	Qty.
1-1	TS-1499141	Hex Cap Screw	M12x80	4
1-2	TS-1540081	Hex Nut	M12	4
	EHB8VS-2A	Stand Assembly (Index 2-1 thru 2-5)		1
2-1	EHB8VS-2-1	Coolant Pan		1
2-2	EHB8VS-2-2	Right Leg		1
2-3	EHB8VS-2-3	Left Leg		1
2-4	EHB8VS-2-4	Front Panel/Shelf		1
2-5	EHB8VS-2-5	Back Door/Shelf		1
2-6	TS-0050031	Cross Head Hex Cap Screw	1/4"-20x3/4	10
2-8	TS-0561011	Hex Nut	1/4"-20	10
2-9	TS-0060051	Hex Cap Screw	3/8"-16x1	8
2-10	TS-0680041	Flat Washer	3/8"	16
2-11	TS-0561031	Hex Nut	3/8"-16	8
2-12	TS-1490071	Hex Cap Screw	M8x40	8
2-13	TS-0680031	Flat Washer	5/16"	8
2-14	TS-1540061	Hex Nut	M8	8
3	EHB8VS-3	Filter		1
4	TS-2246102	Button Head Socket Screw	M6x10	1
5S	EHB8VS-5S	Electrical Box Assembly (Reference Only)		1
6-1	EHB8VS-6-1	Coolant Tank		1
6-2	EHB8VS-6-2	Hose	13x19-350mm	1
6-3	EHB8VS-6-3	Elbow	PT1/2x1/4	1
6-4	EHB8VS-6-4	Coolant Pump	1/8HP,115/230V,1Ph	1
6-5	TS-0680021	Flat Washer	1/4"	4
6-6	TS-081F052	Pan Head Machine Screw	1/4"-20x3/4	4
6-7	EHB8VS-6-7	Hose Clamp		1
7	EHB8VS-7	Pivot Shaft		1
8S	EHB8VS-8S	Cylinder Assembly		1
9	EHB8VS-9	Ext. Retaining Ring	S18	1
12	EHBS8VS-12	Cylinder Upper Bracket		1
13	TS-0720081	Lock Washer	5/16"	3
14	TS-1504061	Socket Head Cap Screw	M8x30	3
15	TS-1505081	Socket Head Cap Screw	M10x50	1
16S	EHB8VS-16S	Stock Stop Assembly (Index 16-1 thru 16-8) not shown		1
16-1	EHB8VS-16-1	Bracket		1
16-2	TS-1550061	Flat Washer	M8	2
16-3	EHB8VS-16-3	Lock Handle		2
16-4	EHB8VS-16-4	Distance Set Rod		1
16-5	EHB8VS-16-5	Shaft		1
16-6	TS-154010	Hex Nut	M16 x P2.0	1
16-7	EHB8VS-16-7	Scale		1
16-8	TS-1540071	Rivet		4
17-1S	EHB8VS-17-1S	Hand wheel Assembly		1
17-2	TS-0680051	Flat Washer	7/16"	1
17-3	EHB8VS-17-3	Key	5x5x15L	1
17-4	EHB8VS-17-4	Acme Lead screw		1
17-5S	EHB8VS-17-5S	Acme Nut Assembly		1

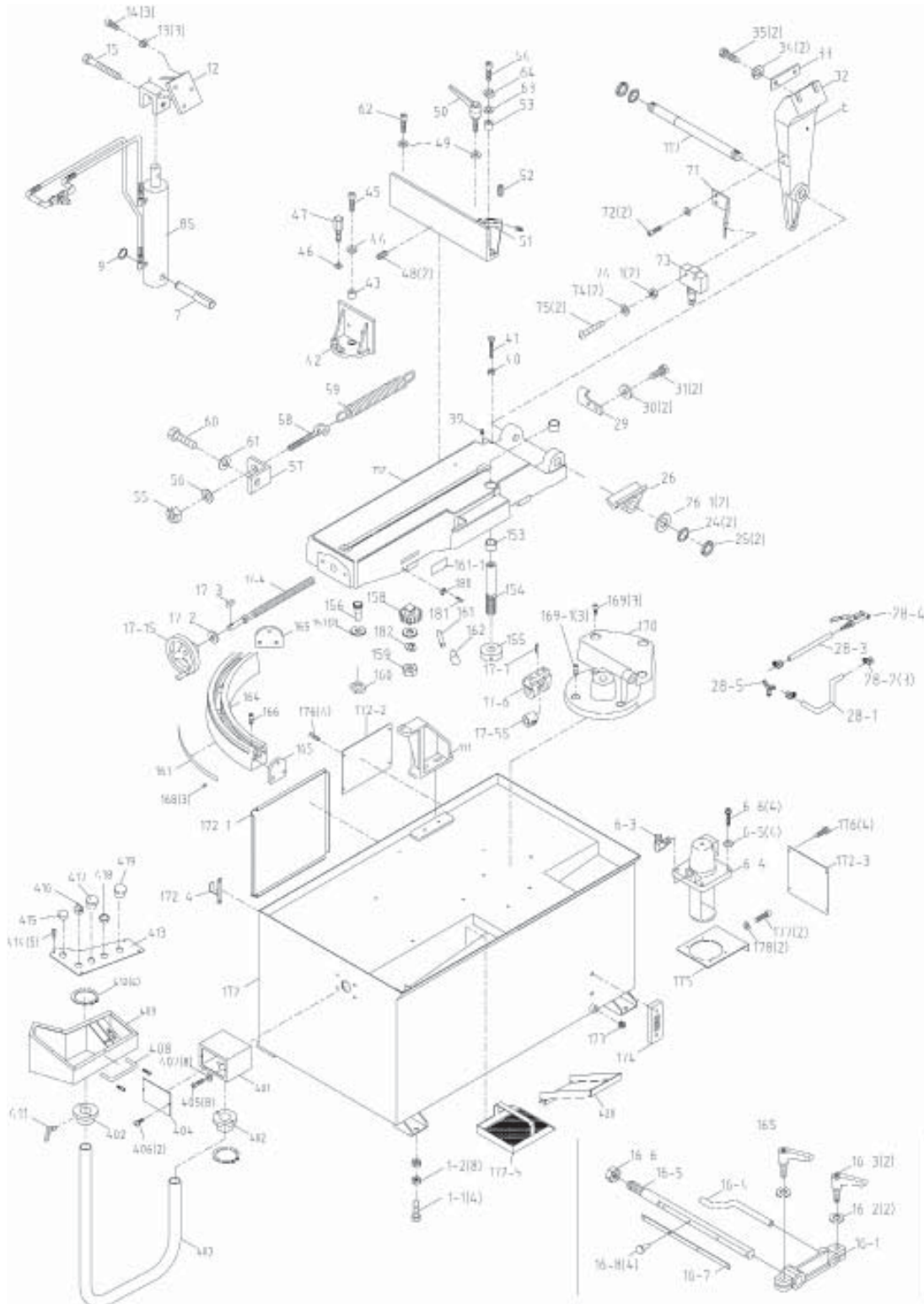
Index No.	Part No.	Description	Size	Qty.
17-6	EHB8VS-17-6	Bracket		1
17-7	EHB8VS-17-7	Pin		1
24	TS-1505031	Socket Head Cap Screw	M10x25	2
24-1	TS-2361101	Lock Washer	M10	2
25	EHB8VS-25	Pivot Shaft Washer		2
26	EHB8VS-26	Support Bracket		1
26-1	EHB8VS-26-1	Gap Ring		2
28-1	EHB8VS-28-1	Tube	ID1/2"x2.8tx126cm	1
28-2	EHB8VS-28-2	Hose Clamp	Ø19mm	3
28-3	EHB8VS-28-3	Tube	ID1/2"x2.8tx320cm	1
28-4	EHB8VS-28-4	Spray Gun		1
28-5	EHB8VS-28-5	3 Way Connector	PT1/2"	1
29	EHB8VS-29	Position Set Bracket		1
30	TS-0680031	Flat Washer	5/16"	2
31	TS-1490031	Hex Cap Screw	M8x20	2
32	EHB8VS-32	Rear Pivot Bracket		1
33	EHB8VS-33	Plate		1
34	TS-2361101	Lock Washer	M10	2
35	TS-149105	Hex Cap Screw	M10x35	2
36	EHB8VS-36	Bed		1
37	TS-2245102	Button Head Socket Screw	M5x10	2
38	EHB8VS-38	Angle Scale		1
39	TS-1524021	Socket Set Screw	M8x10	1
40	TS-1540061	Hex Nut	M8	1
41	TS-1490081	Hex Cap Screw	M8x45	1
42	EHB8VS-42	Front Moveable Vise Jaw		1
43	EHB8VS-43	Bushing		1
44	TS-1550071	Flat Washer	M10	1
45	TS-1505051	Socket Head Cap Screw	M10x35	1
46	EHB8VS-46	Washer	ø10.5xø27xt3mm	1
47	EHB8VS-47	Bolt		1
48	EHB8VS-48	Socket Set Screw	M8x30	2
49	EHB8VS-46	Washer	ø10.5xø27xt3mm	1
50	EHB8VS-50	Locking Handle	M10x37	1
51	EHB8VS-51	Rear Fixed Vise Jaw		1
52	TS-1523031	Socket Set Screw	M6x10	1
53	EHB8VS-53	Bushing		1
54	TS-1506041	Socket Head Cap Screw	M12x35	1
55	TS-0561031	Hex Nut	3/8"-16	1
56	TS-0680041	Flat Washer	3/8"	1
57	EHB8VS-57	Spring Bracket		1
58	EHB8VS-58	Spring Eye Bolt		1
59	EHB8VS-59	Spring		1
60	TS-0081031	Hex Cap Screw	5/16"-18x3/4"	1
61	TS-0680031	Flat Washer	5/16"	1
62	TS-1505051	Socket Head Cap Screw	M10x35	1
63	TS-2360121	Flat Washer	M12	1
64	TS-2361011	Spring Washer	M12	1



Index No.	Part No.	Description	Size	Qty.
71	EHB8VS-71	Limit Switch Holder		1
72	TS-1534042	Pan Head Machine Screw	M6x12	2
73	EHB8VS-73	Limit Switch		1
74	TS-1550021	Flat Washer	M4	2
74-1	TS-1540021	Hex Nut	M4	2
75	TS-2284302	Pan Head Machine Screw	M4x30	2
117	EHB8VS-117	Pivot Shaft		1
402	EHB8VS-402	Swivel Bushing		2
403	EHB8VS-403	Control Column		1
405	TS-1490011	Hex Cap Screw	M8 x 12	4
407	TS-1550061	Flat Washer	M8	4
408	EHB8VS-301	Handle		1
409	EHB8VS-409	Control Box		1
411	EHB8VS-411	Lock Handle	M8 x 20	1
412	EHB8VS-412	C-Ring	S-36	4
413	EHB8VS-413	Control Panel		1
414	TS-2244102	Socket Head Button Screw	M4 x 10	5
415	EHB8VS-415	Electric Lamp		1
416	EHB8VS-416	Start Switch		1
417	EHB8VS-417	Emergency Stop Switch		1
418	EHB8VS-418	Coolant Pump Switch		1
419	EHB8VS-419	Hydraulic Feed Control Knob		1



**EHB-8VSM SAW STAND & BED - PARTS BREAKDOWN**





## EHB-8VSM SAW STAND & BED PARTS LIST

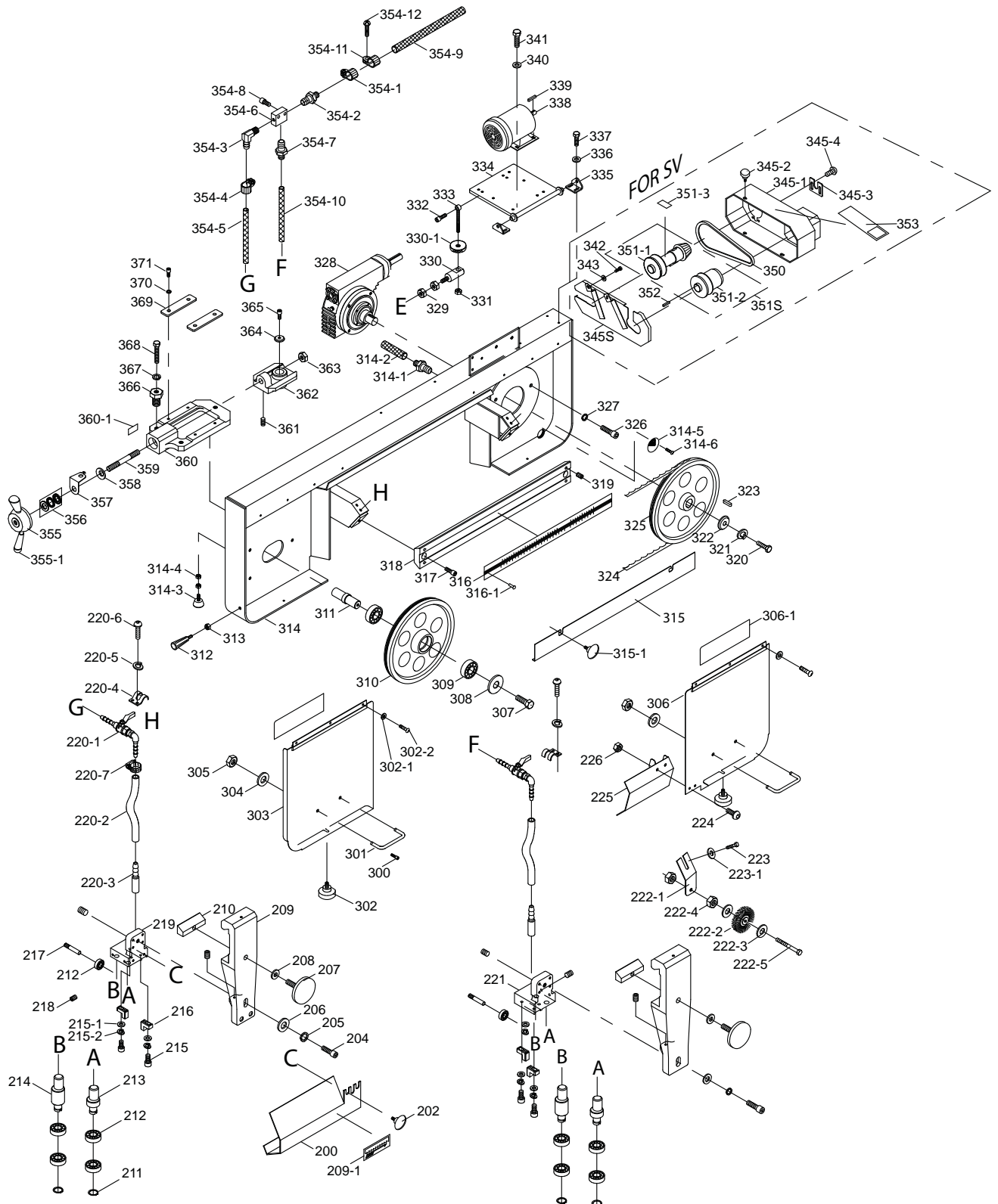
Index No.	Part No.	Description	Size	Qty.
1-1	TS-1499141	Hex Cap Screw	M12x80	4
1-2	TS-1540081	Hex Nut	M12	8
6-3	EHB8VSM-6-3	Elbow	PT1/2x1/4	1
6-4	EHB8VS-6-4	Coolant Pump	1/8HP,115/230V,1Ph	1
6-5	TS-0680021	Flat Washer	1/4"	4
6-6	TS-081F052	Pan Head Machine Screw	1/4"-20x3/4	4
7	EHB8VS-7	Pivot Shaft		1
8S	EHB8VS-8S	Cylinder Assembly		1
9	EHB8VS-9	Ext. Retaining Ring	S18	1
12	EHS8VS-12	Cylinder Upper Bracket		1
13	TS-0720081	Lock Washer	5/16"	3
14	TS-1504061	Socket Head Cap Screw	M8x30	3
15	TS-1505081	Socket Head Cap Screw	M10x50	1
16S	EHB8VS-16S	Stock Stop Assembly (Index 16-1 thru 16-8)		1
16-1	EHB8VS-16-1	Bracket		1
16-2	TS-1550061	Flat Washer	M8	2
16-3	EHB8VS-16-3	Lock Handle		2
16-4	EHB8VS-16-4	Distance Set Rod		1
16-5	EHB8VS-16-5	Shaft		1
16-6	TS-154010	Hex Nut	M16-2.0	1
16-7	EHB8VS-16-7	Scale		1
16-8	TS-1540071	Rivet		4
17-1S	EHB8VS-17-1S	Handwheel Assembly		1
17-2	TS-0680051	Flat Washer	7/16"	1
17-3	EHB8VS-17-3	Key	5x5x15L	1
17-4	EHB8VS-17-4	Acme Lead screw		1
17-5S	EHB8VS-17-5S	Acme Nut Assembly		1
17-6	EHB8VS-17-6	Bracket		1
17-7	EHB8VS-17-7	Pin		1
24	EHB8VSM-24	Locking Washer	AW05	2
25	EHB8VSM-25	Locking Nut	AN05	2
26	EHB8VS-26	Support Bracket		1
26-1	EHB8VS-26-1	Gap Ring		2
28-1	EHB8VS-28-1	Tube	ID1/2"x2.8tx126cm	1
28-2	EHB8VS-28-2	Hose Clamp	Ø19mm	3
28-3	EHB8VS-28-3	Tube	ID1/2"x2.8tx320cm	1
28-4	EHB8VS-28-4	Spray Gun		1
28-5	EHB8VS-28-5	3 Way Connector	PT1/2"	1
29	EHB8VS-29	Position Set Bracket		1
30	TS-0680031	Flat Washer	5/16"	2
31	TS-1490031	Hex Cap Screw	M8x20	2
32	EHB8VS-32	Rear Pivot Bracket		1
33	EHB8VS-33	Plate		1
34	TS-2361101	Lock Washer	M10	2
35	TS-149105	Hex Cap Screw	M10x35	2
39	TS-1524021	Socket Set Screw	M8x10	1
40	TS-1540061	Hex Nut	M8	1

Index No.	Part No.	Description	Size	Qty.
41	TS-1490081	Hex Cap Screw	M8x45	1
42	EHB8VS-42	Front Moveable Vise Jaw		1
43	EHB8VS-43	Bushing		1
44	TS-1550071	Flat Washer	M10	1
45	TS-1505051	Socket Head Cap Screw	M10x35	1
46	EHB8VS-46	Washer	ø10.5xø27xt3mm	1
47	EHB8VS-47	Bolt		1
48	EHB8VS-48	Socket Set Screw	M8x30	2
49	EHB8VS-46	Washer	ø10.5xø27xt3mm	1
50	EHB8VS-50	Locking Handle	M10x37	1
51	EHB8VSM-51	Rear Fixed Vise Jaw		1
52	TS-1523031	Socket Set Screw	M6x10	1
53	EHB8VS-53	Bushing		1
54	TS-1506041	Socket Head Cap Screw	M12x35	1
55	TS-0561031	Hex Nut	3/8"-16	1
56	TS-0680041	Flat Washer	3/8"	1
57	EHB8VS-57	Spring Bracket		1
58	EHB8VS-58	Spring Eye Bolt		1
59	EHB8VS-59	Spring		1
60	TS-0081031	Hex Cap Screw	5/16"-18x3/4"	1
61	TS-0680031	Flat Washer	5/16"	1
62	TS-1505051	Socket Head Cap Screw	M10x35	1
63	TS-2360121	Flat Washer	M12	1
64	TS-2361011	Spring Washer	M12	1
71	EHB8VS-71	Limit Switch Holder		1
72	TS-1534042	Pan Head Machine Screw	M6x12	2
73	EHB8VS-73	Limit Switch		1
74	TS-1550021	Flat Washer	M4	2
74-1	TS-1540021	Hex Nut	M4	2
75	TS-2284302	Pan Head Machine Screw	M4x30	2
71	EHB8VS-71	Limit Switch Holder		1
72	TS-1534042	Pan Head Machine Screw	M6x12	2
73	EHB8VS-73	Limit Switch		1
74	TS-1550021	Flat Washer	M4	2
74-1	TS-1540021	Hex Nut	M4	2
75	TS-2284302	Pan Head Machine Screw	M4x30	2
117	EHB8VSM-117	Pivot Shaft		1
152	EHB8VSM-152	Base		1
153	EHB8VSM-153	Bushing		2
154	EHB8VSM-154	Shaft		1
155	EHB8VSM-155	Block	M30-1.5	1
156	EHB8VSM-156	Idle Gear		1
157	EHB8VSM-157	Special Washer		1
158	EHB8VSM-158	Gear		1
159	TS-1540081	Hex Nut	M12	1
160	TS-2310181	Hex Nut	M18-2.5	1
161	EHB8VSM-161	Handle Bar		1
161-1	EHB8VSM-161-1	Instruction Label		1



Index No.	Part No.	Description	Size	Qty.
162	EHB8VSM-162	Handle		1
164	EHB8VSM-164	Slide Base		1
165	EHB8VSM-165	Stop Bracket		2
166	EHB8VSM-166	Socket Head Cap Screw	M10x40	3
167	EHB8VSM-167	Scale		1
168	EHB8VSM-168	Rivet	M2x5	3
169	TS-1505131	Socket Head Cap Screw	M10x80	3
169-1	TS-1505041	Socket Head Cap Screw	M10x30	3
170	EHB8VSM-170	Rotation Base		1
171	EHB8VSM-171	Bracket		1
172	EHB8VSM-172	Base		1
172-1	EHB8VSM-172-1	Door		1
172-2	EHB8VSM-172-2	Back Cover		1
172-3	EHB8VSM-172-3	Side Cover		1
172-4	EHB8VSM-172-4	Hook		1
172-5	EHB8VSM-172-5	Chip Tray		1
173	EHB8VSM-173	Plug		1
174	EHB8VSM-174	Coolant Gauge		1
175	EHB8VSM-175	Bracket		1
176	EHB8VSM-176	Round Head Cross Screw	M5x10	8
177	TS-1503041	Socket Head Cap Screw	M6x15	2
178	TS-1550041	Flat Washer	M6	2
180	EHB8VSM-180	Pointer		1
181	EHB8VSM-181	Round Head Cross Screw	M6x10	1
182	TS-2361121	Lock Washer	M12	1
401	EHB8VSM-401	Tube Bracket		1
402	EHB8VS-402	Swivel Bushing		2
403	EHB8VSM-403	Control Column		1
404	EHB8VSM-404	Cover		1
405	TS-1490011	Hex Cap Screw	M8 x 12	8
406	EHB8VSM-406	Round Head Cross Screw	M5x8	2
407	TS-1550061	Flat Washer	M8	8
408	EHB8VS-301	Handle		1
409	EHB8VS-409	Control Box		1
411	EHB8VS-411	Lock Handle	M8 x 20	1
412	EHB8VS-412	C-Ring	S-36	4
413	EHB8VS-413	Control Panel		1
414	TS-2244102	Socket Head Button Screw	M4 x 10	5
415	EHB8VS-415	Electric Lamp		1
416	EHB8VS-416	Start Switch		1
417	EHB8VS-417	Emergency Stop Switch		1
418	EHB8VS-418	Coolant Pump Switch		1
419	EHB8VS-419	Hydraulic Feed Control Knob		1
420	EHB8VSM-420	Water Tray		1

**SAW HEAD (BOTH MODELS) - PARTS BREAKDOWN**





## SAW HEAD (BOTH MODELS) PARTS LIST

Index No.	Part No.	Description	Size	Qty.
200	EHB8VS-200	Blade Guard		1
202	EHB8VS-202	Knob	M6-1.0Px10L	2
204	TS-1504051	Socket Head Cap Screw	M8x25	2
205	TS-1551061	Lock Washer	M8	2
206	TS-1550061	Flat Washer	M8	2
207	EHB8VS-207	Knob		2
208	TS-1550071	Flat Washer	M10	2
209	EHB8VS-209	Blade Guide Support Arm		2
209-1	EHB8VS-209-1	Blade Direction Label		2
210	EHB8VS-210	Gib		2
211	EHB8VS-211	Ext. Retaining Ring	ø8	4
212	BB-608ZZ	Bearing	608ZZ	10
213	EHB8VS-213	Eccentric Guide		2
214	EHB8VS-214	Eccentric Guide		2
215	TS-1503051	Socket Head Cap Screw	M6x20	4
215-1	TS-1550041	Flat Washer	M6	4
215-2	TS-2361061	Lock Washer	M6	4
216	EHB8VS-216	Carbide Guide		4
217	EHB8VS-217	Bearing Shaft		2
218	TS-1523011	Socket Set Screw	M6x6	4
219	EHB8VS-219	Guide Bracket (Left)		1
220-1	EHB8VS-220-1	Valve		2
220-2	EHB8VS-220-2	Hose	ø6	2
220-3	EHB8VS-220-3	Straight Connector		2
220-4	EHB8VS-220-4	Hold Down Clamp		2
220-5	TS-2361061	Lock Washer	M6	2
220-6	TS-2246122	Button Head Socket Screw	M6x12	2
220-7	EHB8VS-220-7	Horse Clamp		2
221	EHB8VS-221	Right Guide Bracket		1
	EHB8VS-222S	Brush Assembly (Index 222-1 thru 222-5)		1
222-1	EHB8VS-222-1	Brush Holder		1
222-2	EHB8VS-222-2	Blade Brush		1
222-3	TS-1550041	Flat Washer	M6	2
222-4	TS-1540041	Hex Nut	M6	2
222-5	TS-1482071	Hex Cap Screw	M6x35	1
223	TS-2246102	Socket Head Button Screw	M6x10	1
223-1	TS-2361061	Lock Washer	M6	1
224	TS-2246122	Socket Head Button Screw	M6x12	2
225	EHB8VS-225	Blade Brush Guard		1
226	TS-1540041	Hex Nut	M6	2
300	TS-1503051	Socket Head Cap Screw	M6-1.0Px20L	6
301	EHB8VS-301	Handle		2
302	EHB8VS-302	Knob		2
302-1	TS-1550031	Flat Washer	M5	6
302-2	TS-2245102	Button Head Socket Screw	M5x10	6
303	EHB8VS-303	Left Blade Wheel Cover		1
304	TS-2361061	Lock Washer	M6	4

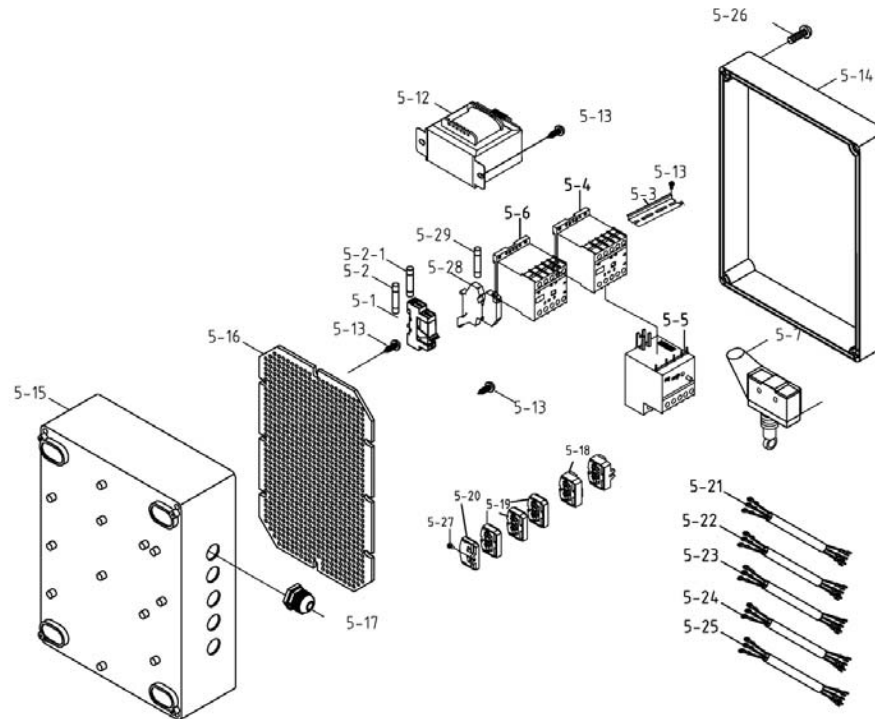


Index No.	Part No.	Description	Size	Qty.
305	TS-2311061	Hex Nut	M6-1.0P	4
306	EHB8VS-306	Right Blade Wheel Cover		1
306-1	EHB8VS-306-1	Padding Strip		2
307	TS-1490031	Hex Cap Screw	M8x20	1
308	EHB8VS-308	Washer	ø16xø30xt3mm	1
309	BB-6205VV	Bearing	6205-2RS	2
310	EHB8VS-310	Idler Wheel		1
311	EHB8VS-311	Shaft		1
312	EHB8VS-312	Handle		1
313	TS-0561031	Hex Nut	3/8"-16	2
314	EHB8VS-314	Body Frame		1
314-1	EHB8VS-314-1	Connector	PT1/2"	1
314-2	EHB8VS-314-2	Hose	18x24-190mm	1
314-3	EHB8VS-314-3	Stop Bolt		1
314-4	TS-1540061	Hex Nut	M8	2
314-5	EHB8VS-314-5	Screen		1
314-6	EHB8VS-314-6	Round Head Screw	M5-0.8Px10L	1
315	EHB8VS-315	Cover		1
315-1	EHB8VS-315-1	Knob		2
316	EHB8VS-316	Scale		1
316-1	EHB8VS-316-1	Rivet	ø2x5L	2
317	TS-1506011	Socket Head Cap Screw	M12x20	2
318	EHB8VS-318	Slide Bar		1
319	TS-1524051	Socket Set Screw	M8x20	4
320	TS-1492021	Hex Cap Screw	M12x30	1
321	TS-2361121	Lock Washer	M12	1
322	EHB8VS-322	Drive Shaft Washer		1
323	EHB8VS-323	Key	7x7x30L	1
324	891091	Blade (Standard)	1x.035x114.5" - 5/8T	1
325	EHB8VS-325	Drive Wheel	Key Slot 7mm	1
326	TS-1505021	Socket Head Cap Screw	M10x20	3
327	TS-1551071	Lock Washer	M10	3
328	EHB8VS-328	Gear Box Assembly	1:30	1
329	TS-1541041	Nylon Nut	M10	2
330	EHB8VS-330	Shaft		1
330-1	EHB8VS-330-1	Knurled Disc		1
331	TS-1540081	Hex Nut	M12	1
332	TS-1505101	Socket Head Cap Screw	M10x60	1
333	EHB8VS-333	Motor Adjusting Screw		1
334	EHB8VS-334	Motor Mount Plate		1
335	EHB8VS-335	Motor Mount Plate Bracket		2
336	TS-1550041	Flat Washer	M6	4
337	TS-1482041	Hex Cap Screw	M6x20	4
338	EHB8VS-338	Motor	1.5HP,115/230V,1Ph	1
339	EHB8VS-339	Key	8x7x35L	1
340	TS-1550061	Flat Washer	M8	4
341	TS-1490021	Hex Cap Screw	M8x16	4
342	TS-1482011	Hex Cap Screw	M6x10	2
343	TS-1550041	Flat Washer	M6	2



Index No.	Part No.	Description	Size	Qty.
345	EHB8VS-345	Pulley Guard		1
345-1	EHB8VS-345-1	Pulley Cover		1
345-2	EHB8VS-345-2	Knob		2
345-3	EHB8VS-345-3	Bracket		1
345-4	EHB8VS-345-4	Cross Head Screw	M5x8	2
350	EHB8VS-350	Belt	V-330	1
351S	EHB8VS-351S	Variable Speed Pulley Set		1
351-1	EHB8VS-351-1	Motor Pulley		1
351-2	EHB8VS-351-2	Gear Box Pulley		1
351-3	EHB8VS-351-3	Speed Chart		1
352	EHB8VS-352	Key	7x7x37L	1
353	EHB8VS-353	Speed Chart Label		1
354-1	EHB8VS-354-1	Hose Clamp	ø12	2
354-2	EHB8VS-354-2	Straight Connector	PT1/4"x1/4"	1
354-3	EHB8VS-354-3	Elbow	PT1/4"x1/4"	1
354-4	EHB8VS-354-4	Hose Clamp	ø19	1
354-5	EHB8VS-354-5	Hose	ID1/4"x2.2tx80cm	1
354-6	EHB8VS-354-6	3 Way Coolant Block		1
354-7	EHB8VS-354-7	Straight Connector	PT1/4"x1/4"	1
354-8	TS-1503071	Socket Head Cap Screw	M6x30	2
354-9	EHB8VS-354-9	Hose	ID1/4"x2.2tx143cm	1
354-10	EHB8VS-354-10	Hose	ID1/4"x2.2tx32cm	1
354-11	EHB8VS-354-11	Hose Clamp		2
354-12	EHB8VS-354-12	Cross Head Screw		2
355	EHB8VS-355	Hub		1
355-1	EHB8VS-355-1	Blade Tension Handle		2
356	BB-51203	Thrust Bearing	51203	1
357	EHB8VS-357	Tension Indicator		1
358	EHB8VS-358	Lock Washer Tension	ID16.3x31.5x1.8t	10
359	EHB8VS-359	Tension Shaft		1
360	EHB8VS-360	Tension Slide Base		1
360-1	EHB8VS-360-1	Tension Scale		1
361	TS-1523051	Socket Set Screw	M6x16	1
362	EHB8VS-362	Tension Slide Block		1
363	TS-154010	Hex Nut	M16	1
364	EHB8VS-364	Washer		1
365	TS-1490031	Hex Cap Screw	M8x20	1
366	EHB8VS-366	Screw		3
367	TS-2361101	Lock Washer	M10	3
368	TS-1491101	Hex Cap Screw	M10x60	3
369	EHB8VS-369	Plate		2
370	TS-2361081	Lock Washer	M8	4
371	TS-1490011	Hex Cap Screw	M8x12	4
372	TS-2246122	Button Head Socket Screw	M6x12	2
373	TS-0680021	Flat Washer	1/4"	2
374	EHB8VS-374	Control Box		1
375	TS-2286121	Flat Head Machine Screw	M6x12	2
376	EHB8VS-376	Control Box Front Panel	5 Hole	1
377	TS-1533032	Pan Head Machine Screw	M5x8	4

## ELECTRIC ASSEMBLY



Index No.	Part No.	Description	Size	Qty.
5-1	EHB8VS-5-1	Fuse Base		2
5-2	EHB8VS-5-2	Fuse	220V 1A	1
5-2-1	EHB8VS-5-2-1	Fuse	110V 2A	1
5-3	EHB8VS-5-3	Aluminum Rail		1
5-4	EHB8VS-5-4	Magnetic Contactor	CU-18	1
5-5	EHB8VS-5-5	Overload Relay	RHU-10K1	1
5-6	EHB8VS-5-6	Pump Contactor		1
5-7	EHB8VS-5-7	Limit Switch	TM1309	1
5-12	EHB8VS-5-12	Transformer	110/220/24V	1
5-13	EHB8VS-5-13	Pan Head Machine Screw	3/16 x 3/8	15
5-14	EHB8VS-5-14	Electrical Control Box Cover		1
5-15	EHB8VS-5-15	Electrical Control Box Base		1
	EHB8VS-ECB	Electrical Control Box compound( included 5-14,5-15)	1	
5-16	EHB8VS-5-16	Net Plate		1
5-17	EHB8VS-5-17	Cable Glands	PG11	5
5-18	EHB8VS-5-18	Terminal Block	264-336	2
5-19	EHB8VS-5-19	Terminal Block	264-326	3
5-20	EHB8VS-5-20	Terminal Block	266-306	1
5-21	EHB8VS-5-21	Motor Cable		1
5-22	EHB8VS-5-22	Limit Switch Cable		1
5-23	EHB8VS-5-23	Power Cable		1
5-24	EHB8VS-5-24	Control Wire		1
5-25	EHB8VS-5-25	Pump Cable		1
5-26	EHB8VS-5-26	Pan Head Machine Screw	M4 x 15	4
5-27	EHB8VS-5-27	Pan Head Machine Screw	M3 x 15	2
5-28	EHB8VS-5-28	Fuse Base		1
5-29	EHB8VS-5-29	Fuse	2A	1

## 19.0 WIRING DIAGRAM EHB-8

