



Operating Instructions and Parts Manual Woodworking Band Saws

Model JWBS-15, JWBS-18, JWBS-20



JWBS-20 shown

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Part No. M-714600
Edition 2 08/2016
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1.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. Read and understand 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 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 shield while using this machine. (Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.)
7. Before operating 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. Keep work area clean. Cluttered areas and benches invite accidents.
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 line 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 doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.
10. Secure work. Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
11. Disconnect tools before servicing; when changing accessories, such as blade, bits, cutters and the like.
12. Direction of feed: Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
13. Maintain proper adjustment of blade tension, blade guides, and thrust bearings.
14. Adjust upper blade guides to just clear workpiece (approximately 1/8").
15. Make sure blade tension, tracking and blade guides are all properly adjusted.
16. Make relief cuts where possible, when cutting curved stock.
17. When feeding small work pieces into blade, always use push stick, fixture, or similar device to keep hands at a safe distance.
18. Hold stock firmly and flat against table.
19. Wear ear protectors (plugs or muffs) during extended periods of operation.
20. 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.
21. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
22. Make certain switch is in OFF position before connecting machine to power supply.
23. Make certain machine is properly grounded.
24. Do not back stock out of blade while blade is running.
25. Do not remove jammed cutoff pieces until blade has stopped.
26. 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.

27. Keep safety guards in place at all times when machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
28. Check damaged parts. Before further use of 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.
29. Keep floor around machine clean and free of scrap material, oil and grease.
30. Keep visitors a safe distance from work area. Keep children away.
31. Make your workshop child proof with padlocks, master switches or by removing starter keys.
32. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
33. Maintain a balanced stance at all times so that you do not fall into blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
34. 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.
35. Use recommended accessories; improper accessories may be hazardous.
36. Maintain tools with care. Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
37. Turn off machine before cleaning. Use a brush or compressed air to remove chips or debris — not your hands.
38. Do not stand on machine. Serious injury could occur if machine tips over.
39. Never leave machine running unattended. Turn power off and do not leave band saw until blade comes to a complete stop.
40. Remove loose items and unnecessary work pieces from area before starting machine.
41. Keep hands out of line of saw blade.
42. Don't use in dangerous environment. Do not expose machine to rain or use in wet or damp locations. Keep work area well lighted.
43. Remove safety key from switch whenever band saw is turned “OFF”, and keep safety key out of reach of unauthorized persons or children.

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 possibly even fatal, injury.

SAVE THESE INSTRUCTIONS

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3.0 About this manual


This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model JWBS-15, JWBS-18 and JWBS-20 Band Saw.

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.

This manual is not intended to be an exhaustive guide to band saw operational methods, use of jigs or after-market accessories, choice of stock, etc. Additional knowledge can be obtained from experienced users or trade articles. Whatever accepted methods are used, always make personal safety a priority.

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.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

 WARNING Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

4.0 Specifications

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.

4.1 Specifications for JWBS-15

| | | |
|-----------------------------|----------------|------------------|
| Model number | JWBS-15 | JWBS-15-3 |
| Stock number | 714600 | 714650 |
| Band saw nominal size | 15 in. | 15 in. |

Motor and electricals:

| | | |
|---|---|-------------------------------|
| Motor type | totally-enclosed fan-cooled, induction, capacitor start | |
| Horsepower | 1.75 HP | 3 HP |
| Phase | single | single |
| Voltage | 115/230V (prewired 115V) | 230V |
| Cycle | 60Hz | 60Hz |
| Listed FLA (full load amps) | 15/7.5A | 12A |
| Starting amps | 75A | 52A |
| Running amps (no load) | 5.1A | 2.4A |
| Start capacitor | 300MFD 250VAC | 300MFD 250VAC |
| Run capacitor | 40µF 250VAC | 60µF 300VAC |
| Power transfer | poly v-belt | poly v-belt |
| On/off switch | push button with paddle stop | push button, magnetic starter |
| Motor speed | 1720 RPM | 1720 RPM |
| Power cord length | 6 ft. (183 cm) | 6 ft. (183 cm) |
| Power plug installed | 115V | 230V |
| Recommended circuit size ¹ | 20A | 20A |
| Sound emission ² | 75 dB at 40" (1000mm) from blade, without load | |

Capacities and speeds:

| | | |
|---|-------------------------------------|----------------------------------|
| Wheel diameter | 14-3/4 in. (375 mm) | 14-3/4 in. (375 mm) |
| Resaw capacity (cutting height) | 14 in. (356 mm) | 14 in. (356 mm) |
| Throat capacity | 14-1/8 in. (359 mm) | 14-1/8 in. (359 mm) |
| Maximum rip left of blade with fence | 12-3/8 in. (316 mm) | 12-3/8 in. (316 mm) |
| Maximum rip right of blade with fence | 2-7/8 in. (73 mm) | 2-7/8 in. (73 mm) |
| Blade length | 133 in. (min. 131.8; max. 133.5) | 133 in. (min. 131.8; max. 133.5) |
| Minimum blade width | 1/8 in. | 1/8 in. |
| Maximum blade width | 1 in. | 1 in. |
| Blade speed | 3100 FPM | 3100 FPM |
| Blade provided | Hook, 1/2" x 0.0256 thk 6 TPI | |

Main Materials:

| | | |
|--------------------|---------------------|---------------------|
| Table | ground cast iron | ground cast iron |
| Trunnion | cast iron | cast iron |
| Frame | steel | steel |
| Band wheels | cast iron | cast iron |
| Tires | yellow polyurethane | yellow polyurethane |
| Blade guides | ball bearing | ball bearing |
| Resaw fence | extruded aluminum | extruded aluminum |
| Paint finish | powder coating | powder coating |

Table, fence, miter gauge:

| | | |
|-------------------------------|---|------------------------|
| Table dimensions | 21-1/2 x 16 x 2 in. (546 x 406 x 51 mm) | |
| Table tilt | Left 5°, Right 45° | Left 5°, Right 45° |
| Table height from floor | 35 in. (889 mm) | 35 in. (889 mm) |
| Miter T-slot | 3/4 in. W x 0.35 in. H | 3/4 in. W x 0.35 in. H |
| Resaw fence size LxWxH | 18-1/8 x 1-3/4 x 6 in. | 18-1/8 x 1-3/4 x 6 in. |
| Miter gauge angle | Left 45°, Right 45° | Left 45°, Right 45° |

Dimensions:

| | |
|------------------------------------|--|
| Footprint (base size), LxWxH | 25-1/2 x 21-5/8 x 2 in. (648 x 549 x 51 mm) |
| Overall dimensions, LxWxH | 29-1/2 x 32 x 74 in. (750 x 812 x 1880 mm) |
| Shipping package dimensions | 30 x 24-1/2 x 79-1/2 in. (760 x 625 x 2020 mm) |

Dust collection:

| | | |
|--|-------------------|-------------------|
| Dust port outside diameter | 4 in. (100mm) x 2 | 4 in. (100mm) x 2 |
| Minimum extraction volume required | 400 CFM | 400 CFM |

Weights:

| | | |
|----------------|------------------|------------------|
| Net | 382 lbs (174 kg) | 382 lbs (174 kg) |
| Shipping | 446 lbs (203 kg) | 446 lbs (203 kg) |

¹ Subject to local/national electrical codes. ² The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

4.2 Specifications for JWBS-18

| | | |
|-----------------------------|----------------|------------------|
| Model number | JWBS-18 | JWBS-18-3 |
| Stock number | 714700 | 714750 |
| Band saw nominal size | 18 in. | 18 in. |

Motor and electricals:

| | | |
|---|---|-------------------------------|
| Motor type | totally-enclosed fan-cooled, induction, capacitor start | |
| Horsepower | 1.75 HP | 3 HP |
| Phase | single | single |
| Voltage | 115/230V (prewired 115V) | 230V |
| Cycle | 60Hz | 60Hz |
| Listed FLA (full load amps) | 15/7.5 A | 12 A |
| Starting amps | 75A | 53A |
| Running amps (no load) | 5.1A | 2.4A |
| Start capacitor | 300MFD 250VAC | 300MFD 250VAC |
| Run capacitor | 40µF 250VAC | 60µF 300VAC |
| Power transfer | poly v-belt | poly v-belt |
| On/off switch | push button with paddle stop | push button, magnetic starter |
| Motor speed | 1720 RPM | 1720 RPM |
| Power cord length | 6 ft. (183 cm) | 6 ft. (183 cm) |
| Power plug installed | 115V | 230V |
| Recommended circuit size ¹ | 20A | 20A |
| Sound emission ² | .75 dB at 40" (1000 mm) from blade, without load | |

Capacities and speeds:

| | | |
|---|--------------------------------|--------------------------------|
| Wheel diameter | 18-1/2 in. | 18-1/2 in. |
| Resaw capacity (cutting height) | 16 in. | 16 in. |
| Throat capacity | 18 in. | 18 in. |
| Maximum rip left of blade with fence | 16 in. | 16 in. |
| Maximum rip right of blade with fence | 4-1/2 in. | 4-1/2 in. |
| Blade length | 150 in. (max. 150.9; min. 149) | 150 in. (max. 150.9; min. 149) |
| Blade width | 1/8 to 1-1/4 in. | 1/8 to 1-1/4 in. |
| Blade provided | Hook, 3/4" x 0.0256 thk 6 TPI | Hook, 3/4" x 0.0256 thk 6 TPI |
| Blade speed | 2300 and 3800 FPM | 2300 and 3800 FPM |

Main Materials:

| | | |
|--------------------|-------------------|-------------------|
| Table | ground cast iron | ground cast iron |
| Trunnion | cast iron | cast iron |
| Frame | steel | steel |
| Band wheels | cast iron | cast iron |
| Tires | polyurethane | polyurethane |
| Blade guides | ball bearing | ball bearing |
| Resaw fence | extruded aluminum | extruded aluminum |
| Paint finish | powder coating | powder coating |

Table, fence, miter gauge:

| | | |
|-------------------------------|-------------------------|-------------------------|
| Table dimensions | 27-1/4 x 20 x 1-5/8 in. | 27-1/4 x 20 x 1-5/8 in. |
| Table tilt | Left 5°, Right 45° | Left 5°, Right 45° |
| Table height from floor | 37 in. (940 mm) | 37 in. (940 mm) |
| Miter T-slot | 3/4 in. W x 0.375 in. H | 3/4 in. W x 0.375 in. H |
| Resaw fence size LxWxH | 22-1/2 x 1-3/4 x 6 in. | 22-1/2 x 1-3/4 x 6 in. |
| Miter gauge angle | Left 45°, Right 45° | Left 45°, Right 45° |

Dimensions:

| | |
|------------------------------------|---|
| Footprint (base size), LxWxH | 29-1/2 x 21-5/8 x 2 in. (750 x 550 x 50.8 mm) |
| Overall dimensions, LxWxH | 36 x 34 x 80 in. (914 x 864 x 2032 mm) |
| Shipping package dimensions | 31 x 26 x 85 in. (780 x 660 x 2168 mm) |

Dust collection:

| | | |
|--|-------------------|-------------------|
| Dust port outside diameter | 4 in. (100mm) x 2 | 4 in. (100mm) x 2 |
| Minimum extraction volume required | 400 CFM | 400 CFM |

Weights:

| | | |
|----------------|------------------|------------------|
| Net | 502 lbs (228 kg) | 502 lbs (228 kg) |
| Shipping | 572 lbs (260 kg) | 572 lbs (260 kg) |

¹ Subject to local/national electrical codes. ² The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

4.3 Specifications for JWBS-20

| | | |
|-----------------------------|------------------|------------------|
| Model number | JWBS-20-3 | JWBS-20-5 |
| Stock number | 714800 | 714850 |
| Band saw nominal size | 20 in. | 20 in. |

Motor and electricals:

| | | |
|---|---|-------------------------------|
| Motor type | totally-enclosed fan-cooled, induction, capacitor start | |
| Horsepower | 3 HP | 5 HP |
| Phase | single | single |
| Voltage | 230V | 230V |
| Cycle | 60Hz | 60Hz |
| Listed FLA (full load amps) | 12A | 22A |
| Starting amps | 54A | 99A |
| Running amps (no load) | 2.9A | 8.1A |
| Start capacitor | 300MFD 250VAC | 300MFD 250VAC |
| Run capacitor | 60µF 300VAC | 45µF 450VAC |
| Power transfer | poly v-belt | poly v-belt |
| On/off switch | push button, magnetic starter | push button, magnetic starter |
| Motor speed | 1720 RPM | 1720 RPM |
| Power cord length | 6 ft. (183 cm) | 6 ft. (183 cm) |
| Power plug installed | 230V | 230V |
| Recommended circuit size ¹ | 20A | 30A |
| Sound emission ² | 75 dB at 40" (1000mm) from blade, without load | |

Capacities and speeds:

| | | |
|---|---------------------------------|---------------------------------|
| Wheel diameter | 20-1/4 in. (514 mm) | 20-1/4 in. (514 mm) |
| Resaw capacity (cutting height) | 16 in. (406.4 mm) | 16 in. (406.4 mm) |
| Throat capacity | 20 in. (508 mm) | 20 in. (508 mm) |
| Maximum rip left of blade with fence | 18-1/2 in. (470 mm) | 18-1/2 in. (470 mm) |
| Maximum rip right of blade with fence | 4-1/2 in. (114 mm) | 4-1/2 in. (114 mm) |
| Blade length | 158 in. (max 158.9; min. 157.1) | 158 in. (max 158.9; min. 157.1) |
| Blade width | 1/8 to 1-1/2 in. | 1/8 to 1-1/2 in. |
| Blade speed | 2530 and 4850 FPM | 2530 and 4850 FPM |
| Blade provided | Hook, 1" x 0.035 thk 3 TPI | Hook, 1" x 0.035 thk 3 TPI |

Main Materials:

| | | |
|--------------------|-------------------|-------------------|
| Table | ground cast iron | ground cast iron |
| Trunnion | cast iron | cast iron |
| Frame | steel | steel |
| Band wheels | cast iron | cast iron |
| Tires | rubber | rubber |
| Blade guides | ball bearing | ball bearing |
| Resaw fence | extruded aluminum | extruded aluminum |
| Paint finish | powder coating | powder coating |

Table, fence, miter gauge:

| | | |
|---|-------------------------|-------------------------|
| Table dimensions | 27-1/4 x 20 x 1-3/4 in. | 27-1/4 x 20 x 1-3/4 in. |
| Table tilt | Left 5°, Right 45° | Left 5°, Right 45° |
| Table height from floor at 90 degrees | 37 in. (940 mm) | 37 in. (940 mm) |
| Miter T-slot | 3/4 in. W x 0.35 in. H | 3/4 in. W x 0.35 in. H |
| Resaw fence size LxWxH | 22-1/2 x 1-3/4 x 6 in. | 22-1/2 x 1-3/4 x 6 in. |
| Miter gauge angle | Left 45°, Right 45° | Left 45°, Right 45° |

Dimensions:

| | | |
|------------------------------------|--|-----------------------|
| Footprint (base size), LxWxH | 31-1/2 x 21-5/8 x 2 in. (800 x 550 x 50.8mm) | |
| Overall dimensions, LxWxH | 37 x 33-1/8 x 88 in. | 37 x 32-1/4 x 88 in. |
| | (940 x 842 x 2235 mm) | (940 x 819 x 2235 mm) |

Dust collection:

| | | |
|--|-------------------|-------------------|
| Dust port outside diameter | 4 in. (100mm) x 2 | 4 in. (100mm) x 2 |
| Minimum extraction volume required | 400 CFM | 400 CFM |

Weights:

| | | |
|----------------|------------------|--------------------|
| Net | 544 lbs (247 kg) | 588.5 lbs (267 kg) |
| Shipping | 617 lbs (280 kg) | 661 lbs (300 kg) |

¹ Subject to local/national electrical codes. ² The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

4.4 Base Hole Centers

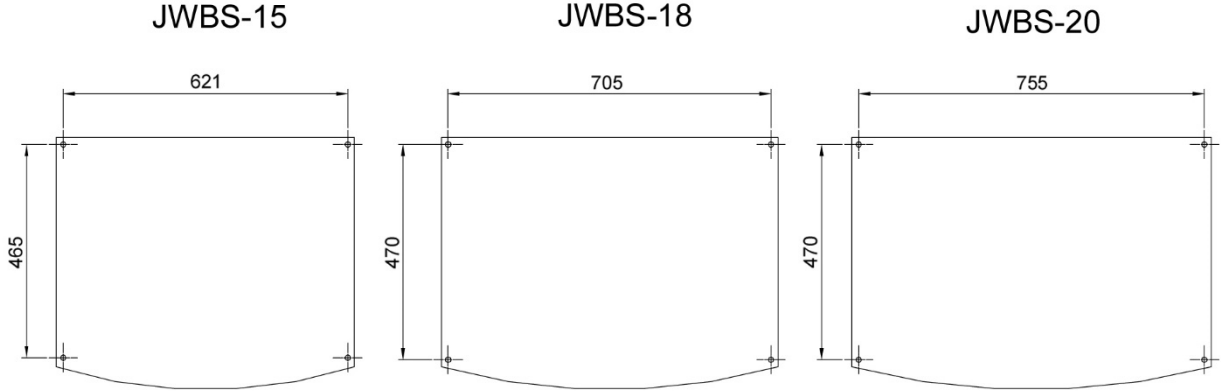


Figure 4-1: base hole centers (millimeters)

⚠WARNING Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

5.0 Setup and assembly

5.1 Shipping contents

Refer to Figure 5-1.

- 1 Band saw (not shown)
- 1 Fence body – A
- 1 Resaw fence – B
- 1 Table – C
- 1 Table insert – D
- 1 Guide rail – E
- 1 Lifting ring – F
- 1 Handwheel with handle – G
- 1 Miter gauge assembly – H
- 1 Bracket (*model JWBS-20 only*) – J
- 1 Owner's manual (not shown)
- 1 Warranty card (not shown)
- 1 Hardware package containing:
 - 2 Socket hd button screws – HP1
 - 2 Flat washers – HP2
 - 4 Hex cap screws – HP3
 - 4 Lock washers – HP4
 - 4 Flat washers – HP5
 - 1 Table slot handle assembly – HP6

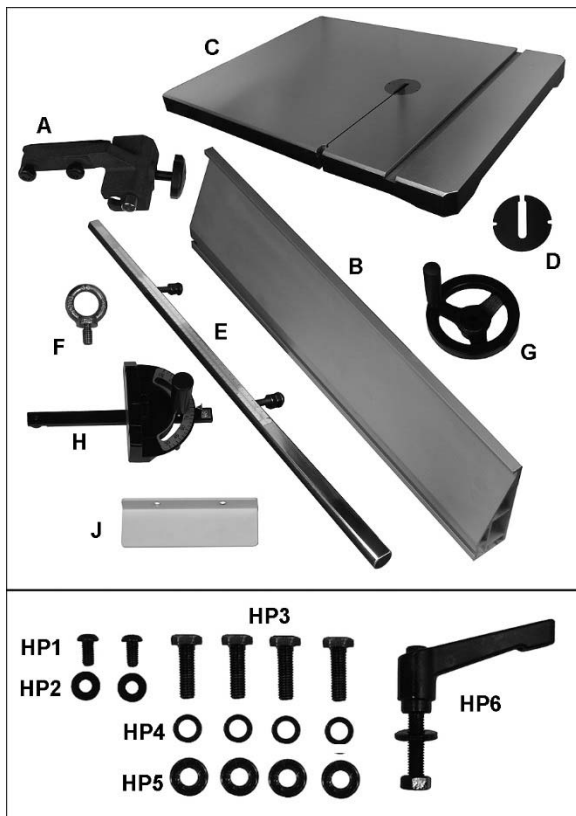


Figure 5-1: contents

5.2 Tools required for assembly

The tools listed below are not included but are required for assembly.

- 1 2.5mm hex key
- 1 3mm hex key
- 1 straight edge
- 1 17mm wrench
- 1 13mm wrench

5.3 Unpacking and cleanup

Remove crate and packing material from band saw except for the transport skid on the bottom. Inspect the machine for damage. Report any damage to your distributor and shipping agent. Do not discard packing material until machine is assembled and running satisfactorily.

Move the saw to its permanent working location. The site should be dry, well lit, and have enough room to handle long stock and servicing or adjustment of the machine from any side.

Install lifting ring atop band saw, and use hoist to move saw off skid. Clean all rust protected surfaces with a mild solvent or diesel fuel and a soft cloth. Do not use lacquer thinner, paint thinner, or gasoline, as these will damage painted surfaces.

5.4 Assembly

⚠WARNING Band saw must be disconnected from power source during assembly procedures. Failure to comply may cause serious injury.

5.5 Handwheel

Install handwheel (G, Figure 5-2) onto shaft, and tighten two set screws with 3mm hex key.



Figure 5-2

5.6 Installing and aligning table

⚠CAUTION Table is heavy. Mounting with the help of another person is recommended.

Refer to Figures 5-3 through 5-4:

- 1. Slide table so that saw blade passes through slot (A).

2. Line up table to trunnions, and insert four hex cap screws with lock washers and flat washers (Figure 5-4). Hand tighten screws only.
3. Check that table is parallel to blade: Move blade tension lever to *Full Tension* position (shown in Figure 7-9), and place a long straightedge flush against blade, making sure it contacts both front and back of blade. See Figure 5-5. (Do not deflect blade by pushing into it.)
4. Use a gauge to carefully measure distance from miter slot to straight edge. Take measurements at both front and back of table – these should be identical.
5. If miter slot is not parallel to blade, shift table as needed.
6. Tighten the four screws (Figure 5-4) securely.
7. Install table insert (D, Figure 5-3). (See sect. 7.5 to level insert with table.)
8. Install slot handle assembly (HP6), and tighten.

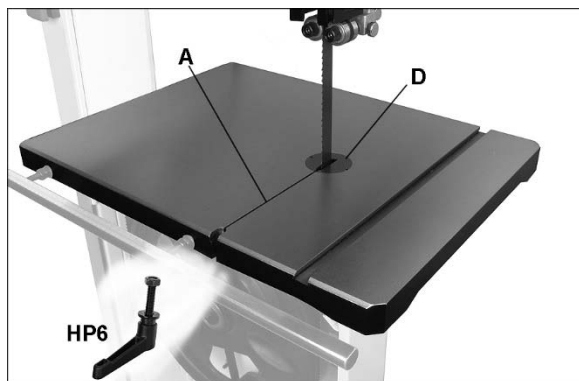


Figure 5-3



Figure 5-4

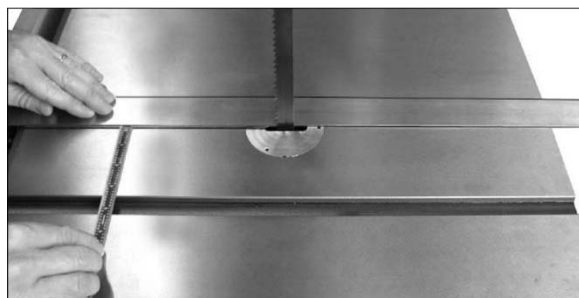


Figure 5-5

5.7 Installing guide rail

Refer to Figure 5-6.

1. Attach guide rail (E) to table by inserting the two threaded studs into the table edge. Secure with the included fasteners (see inset). Do not fully tighten yet until fence adjustments have been made in the following section.



Figure 5-6

5.8 Fence assembly and alignment

Refer to Figure 5-7.

1. Slide fence body (A, Figure 5-7) onto guide rail and move fence body to right of blade.
2. Install resaw fence (B) and tighten with two knobs (A₁).
3. Slide resaw fence against edge of miter slot, as shown, and tighten handle (A₂) to lock position. The fence should align parallel to miter slot along entire length of fence.

If adjustment is needed:

4. Loosen and rotate hex nuts on guide rail studs (A₃) as needed, until resaw fence is parallel to miter slot.
5. Tighten nuts on guide rail studs.

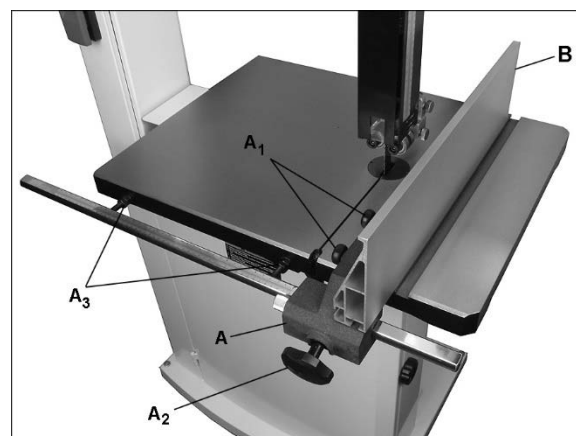


Figure 5-7

5.9 Table bracket (JWBS-20 only)

Install bracket (J, Figure 5-8) to back edge of table. Level with top surface of table and tighten screws.

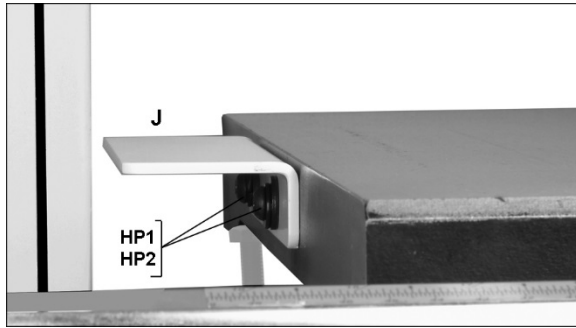


Figure 5-8

5.10 Miter gauge

Refer to Figure 5-9.

1. Slide miter gauge into table slot.
2. Use a square to verify that miter gauge face is square to blade.
3. If miter gauge is not square to blade, loosen lock knob (H₁, Figure 5-9) and adjust to proper setting. Tighten lock knob.
4. If pointer is not at 90 degrees, loosen screw (H₂) and shift pointer to 90 degrees.
5. Tighten screw.

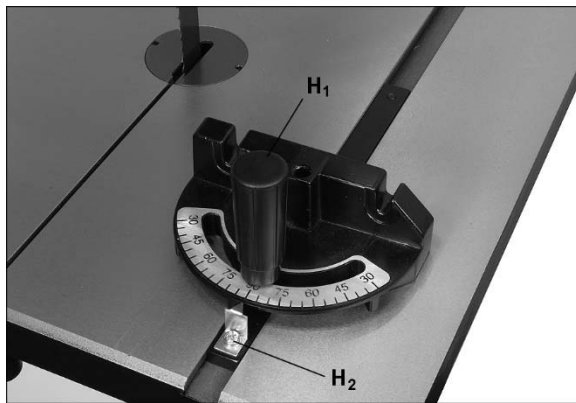


Figure 5-9

6.0 Electrical connections

⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

6.1 GROUNDING INSTRUCTIONS

This machine must be grounded. 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.

Before connecting to power source, be sure the switch is in *off* position.

⚠WARNING 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. Failure to comply may cause serious or fatal injury.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

6.2 Models JWBS-15, JWBS-18

Model JWBS-15 and JWBS-18 Band Saws are wired from the factory for 115 volt operation, but can be rewired for 230 volts.

115 Volt Operation

The JWBS-15 and JWBS-18 Band Saw are for use on a nominal 115-V circuit, and have a grounded plug that looks like the plug illustrated in sketch A in Figure 6-1. A temporary adaptor that looks like the adaptor illustrated in sketches B and C may be used to connect this plug to a 2-pole receptacle as shown in sketch B if a properly grounded outlet is not available. The temporary adaptor should be used only until a properly grounded outlet can be installed by a qualified electrician. The green colored rigid ear, lug, or the like extending from the adaptor must be connected to a permanent ground such as a properly grounded outlet box cover. Whenever the adaptor is used, it must be held in place by a metal screw.

In Canada, the use of a temporary adaptor is not permitted by the Canadian Electrical Code, C22.1.

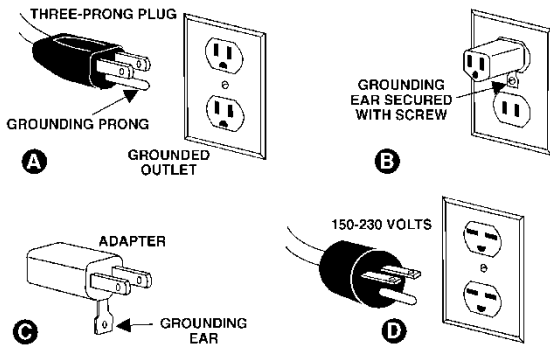


Figure 6-1

230 Volt Operation

To convert the JWBS-15 or JWBS-18 from 115V to 230V, single phase operation, the following is strongly recommended:

Contact your local Authorized JET Service Center or qualified electrician for proper procedures to install the plug. The band saw must comply with all local and national codes after the 230V plug is installed.

1. Switch the motor lead wires inside the motor junction box, according to the diagram found inside the junction box cover.
2. The 115V attachment plug supplied with the band saw (A, Figure 6-1) must be replaced with a UL/CSA listed plug suitable for 230V operation (D, Figure 6-1).

The band saw with a 230V plug should only be connected to an outlet having the same configuration (D, Figure 6-1). No adapter is available or should be used with the 230V plug.

Important: In all cases (115 or 230 volts), make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.

6.3 Models JWBS-15-3, JWBS-18-3, JWBS-20-3, JWBS-20-5

Band saw models JWBS-15-3, JWBS-18-3, JWBS-20-3, and JWBS-20-5 are wired from the factory for 230 volt operation only. Refer to *Specifications* for phase and HP ratings.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in **D**, Figure 6-1. The tool has a grounding plug that looks like the plug illustrated in **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.

6.4 Circuit Information (all models)

The Band Saw should be connected to a dedicated circuit with a circuit breaker or time delay fuse rated "D" with the appropriate amperage rating. See Table 1 for recommended circuit sizes. **Local codes take precedence over recommendations.**

| Model | Voltage | Recommended Circuit* |
|-------------------|---------|----------------------|
| 714600, JWBS-15 | 115 V | 20A |
| 714650, JWBS-15-3 | 230 V | 20A |
| 714700, JWBS-18 | 115 V | 20A |
| 714750, JWBS-18-3 | 230 V | 20A |
| 714800, JWBS-20-3 | 230 V | 20A |
| 714850, JWBS-20-5 | 230 V | 30A |

* Local codes take precedence over recommendations.

Table 1

6.5 Extension cords

The use of extension cords is discouraged; try to position your machine within reach of the power supply. If an extension cord becomes necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Use the chart in Table 2 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Recommended Gauges (AWG) of Extension Cords

| Ampere Rating | | Volts | Total length of cord in feet | | | |
|---------------|---------------|-------|------------------------------|-----|-----------------|-----|
| More Than | Not More Than | 120 | 25 | 50 | 100 | 150 |
| | | 240 | 50 | 100 | 200 | 300 |
| | | | AWG | | | |
| 0 | 6 | | 18 | 16 | 16 | 14 |
| 6 | 10 | | 18 | 16 | 14 | 12 |
| 10 | 12 | | 16 | 16 | 14 | 12 |
| 12 | 16 | | 14 | 12 | Not Recommended | |

Table 2

7.0 Adjustments

7.1 Aluminum resaw fence

Refer to Figures 7-1 and 7-2.

Loosen knobs (A₁) until lock bar protrudes enough on which to slide the aluminum fence plate from one end, as shown in Figure 7-1. Retighten knobs.

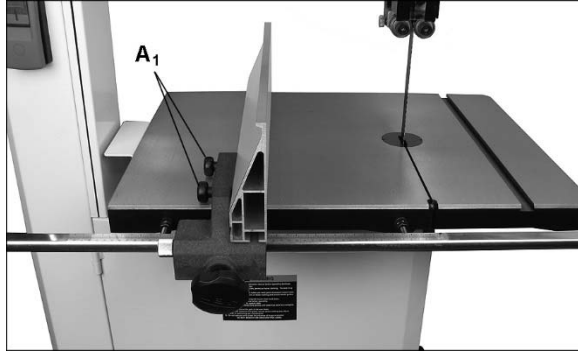


Figure 7-1: vertical position

The aluminum fence plate can be installed in one of two positions; vertically (resaw position), as shown in Figure 7-1; or horizontally as shown in Figure 7-2.

Horizontal position is useful for smaller workpieces. (Zero setting of cursor cannot be used with horizontal fence position.)

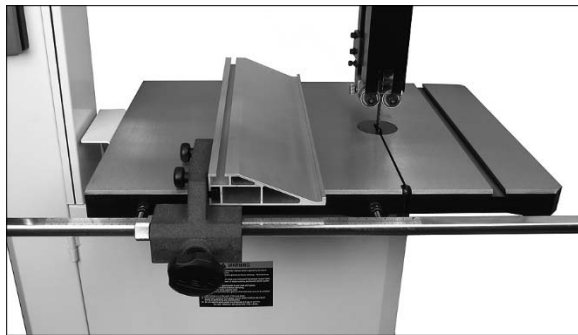


Figure 7-2: horizontal position

7.2 Fence fine adjust

Refer to Figure 7-3.

1. Loosen fence lock knob (A, Figure 7-3).
2. Loosen knob (B).
3. Slide fence to approximate position, based on the scale measurement aligning with the right side of resaw fence.
4. Tighten knob (B).
5. Rotate knurled knob (C) to achieve fine adjustment.
6. When setting is reached, tighten fence lock knob (A).

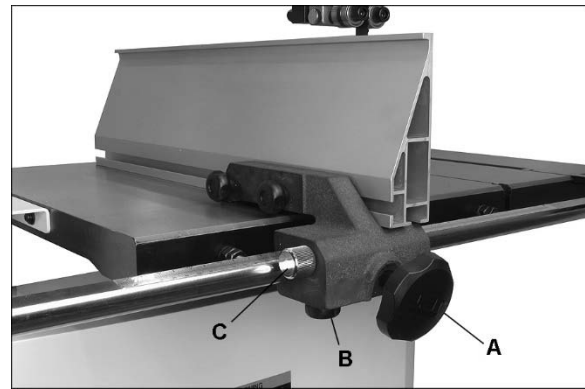


Figure 7-3

7.3 Table tilt

Refer to Figure 7-4.

1. Disconnect machine from power source.
2. Loosen lock handle (D).
3. Tilt table up to 45 degrees to the right (as viewed from operator side), or up to 5 degrees to the left.
4. Tighten lock handle.

Note: Table stop bolt (F, Figure 7-4) must be pivoted out of the way to tilt table to the left.

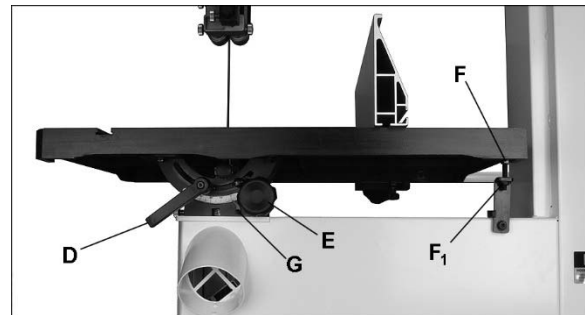


Figure 7-4

7.4 Adjusting 90-degree table stop

Before adjusting the 90° table stop, the blade tension must be properly adjusted (see sect. 7.7)

To adjust 90° table stop:

1. Loosen lock handle (D, Figure 7-4) and use knob (E) to tilt table until it rests against table stop bolt (F). Retighten lock handle.
2. Use a square (Figure 7-5) placed on table and against blade to verify that table is 90 degrees to blade.
3. If an adjustment is necessary, loosen lock handle (D). Tilt table until it is square to blade; then retighten lock handle.
4. Loosen lock nut (F₁) and turn table stop bolt (F) until it contacts table. Tighten lock nut to hold table stop in place. When tightening the nut hold the table stop bolt in place with a wrench to prevent movement.

- If necessary, adjust pointer (G, Figure 15) to zero.

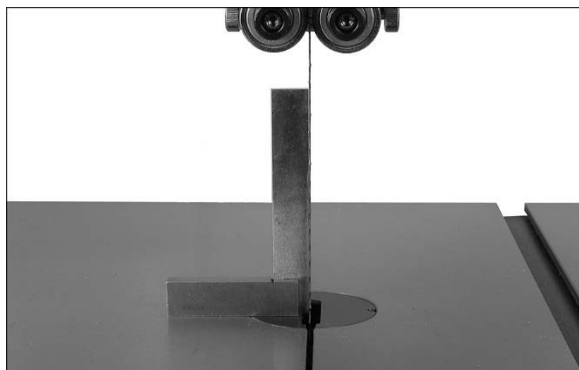


Figure 7-5

7.5 Leveling table insert

Remove table insert to expose set screws in the table ledge. Rotate screws as needed (2mm hex key) until insert sits flush with table surface.

7.6 Installing/changing blades

CAUTION Wear gloves when handling blades. New blades are usually packaged in coiled position; to prevent injury uncoil them slowly and carefully while wearing work gloves and safety glasses.

See sect. 4.0 for specific blade sizes for your model Band Saw.

Refer to Figures 7-6, 7-7 and 7-8.

- Disconnect machine from power source.
- Loosen handle and remove it from table (see HP6, Figure 5-3).
- Adjust upper and lower blade guides away from blade (see sections 7.11 through 7.13).
- Move quick tension lever to “Full Release (Blade Change)” position.
- Open upper and lower doors by rotating door knobs.
- Pivot guide post cover out of the way (Figure 7-6).
- Swing lower guard (H, Figure 7-7) to the left. Tilt table slightly if more clearance is needed to swing guard.
- Remove dust block (J, Figure 7-8).
- Carefully remove blade from top wheel, then from between upper and lower blade guides and lower wheel. Slide blade out through slot in table.
- Guide new blade through table slot. Place blade loosely in upper and lower blade guides. Make sure blade teeth point down toward table, and toward front of saw.

(If the teeth will not point down, no matter how you orient blade, then blade is inside-out. Twist it into correct position and re-install it.)

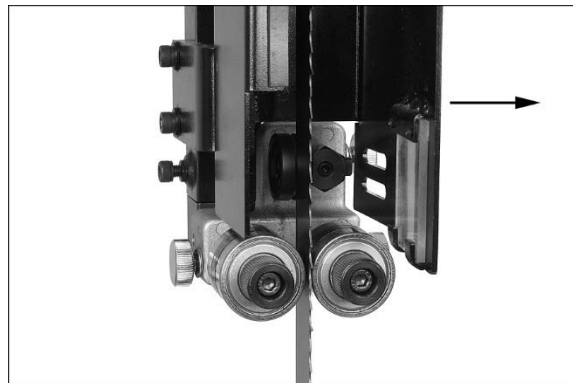


Figure 7-6

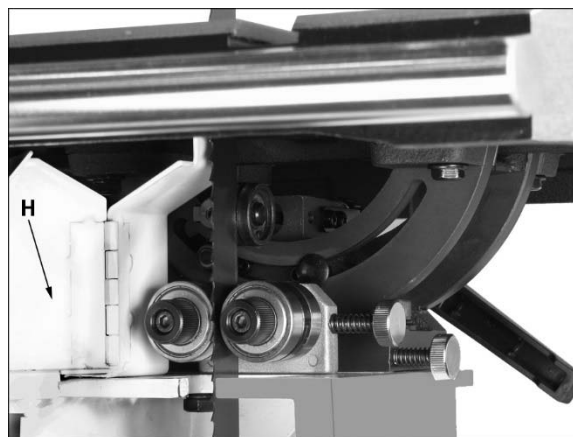


Figure 7-7



Figure 7-8

- Position blade at center of upper and lower wheels.
- Reinstall dust block (J, Figure 7-8) and table slot handle (HP6, Figure 5-3).
- Before operating band saw, the new blade must be tensioned and tracked, in that order. Find instructions for tensioning and tracking the blade in sections 7.7 and 7.9.
- The blade guides must also be set properly according to instructions in sections 7.11 through 7.13.

7.7 Blade tension

Blade tension is set with the blade tension handwheel (L, Figure 7-10) and is performed following blade replacement and periodically as the blade stretches from use.

⚠WARNING Disconnect machine from power source before making any adjustments.

Refer to Figures 7-9 and 7-10.

1. Place tension lever (K, Figure 7-9) in *Full Tension* position.
2. Set blade tension by rotating handwheel (L) according to the arrow directions shown in Figure 7-10, clockwise to tighten, counterclockwise to loosen.
3. The gauge (M) indicates approximate tension according to the width of the blade in inches. Initially, set the blade tension to correspond to the width of your blade.

As you become familiar with the saw, you may find it necessary to change the blade tension from the initial setting.

Keep in mind that too little or too much blade tension can cause blade breakage and/or poor cutting performance.

Tip: When the band saw is not being used, place tension lever to *Partial Tension* position – this will prolong the blade's life.



Figure 7-9

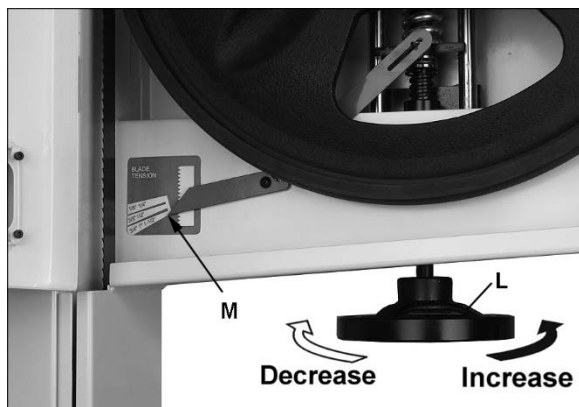


Figure 7-10

7.8 Adjusting blade tension lever

The blade tension lever has an adjustment screw or stop bushing that allows you to adjust how much tension is released when lever is used.

To adjust tension lever:

1. Disconnect machine from power source.
2. Move lever to *Blade Release* position and remove blade.
3. Move tension lever to *Full Tension* position.
4. **Models JWBS-15 and JWBS-18:** Turn adjustment screw (Figure 7-11) until gap between screw and wheel shaft hinge is 1/8 to 3/16 in.

Model JWBS-20: Move stop bushing (Figure 7-12) until gap between stop bushing and wheel shaft hinge is 1/8 to 3/16 in.

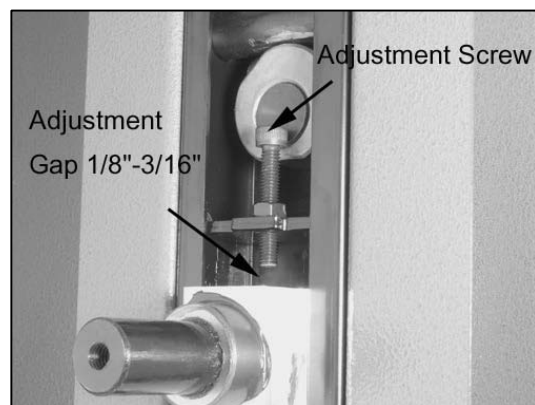


Figure 7-11



Figure 7-12

7.9 Blade tracking

Refer to Figures 7-13 and 7-14.

After proper tensioning, the blade must be tracked. "Tracking" refers to position of blade on the wheels while machine is in operation. Tracking should be checked periodically, and is mandatory after every blade change. Blade tracking is done by hand with machine disconnected from power.

1. Disconnect machine from power source.
2. Blade must be correctly tensioned (*sect. 7.7*).

3. Make sure blade guides and other parts of machine will not interfere with blade movement. Use handwheel (N) to lower guide post until you can see blade through tracking window (O, Figure 7-13).
4. Set blade tension lever initially to *Partial Tension-Idle/Tracking* position.



Figure 7-13

5. Open upper door to expose wheel.
6. Rotate wheel by hand, observing position of blade through tracking window. As you rotate wheel, move tension lever to *Full Tension* position. The blade should continue to ride upon center of tire (Figure 7-14).

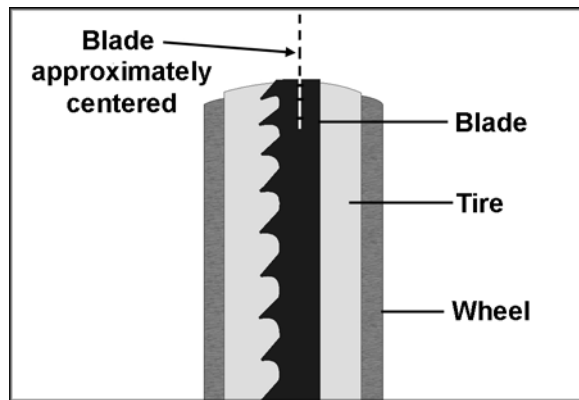


Figure 7-14

7. If blade tends to move toward edge of wheel, set lever to *Partial Tension-Idle/Tracking*.
8. Loosen locking handle (P, Figure 7-13) and slightly rotate tracking knob (R) with your right hand while continuing to rotate wheel with your left. Observe blade through tracking window. Rotating knob clockwise will cause blade to move toward rear edge of wheel. Rotating knob counterclockwise will cause blade to move toward front edge of wheel.

IMPORTANT: This adjustment is sensitive; perform in small increments and give blade time to react to changes.

9. When blade is tracking in center of wheel, re-tighten locking handle (P), and close upper door.
10. Move tension lever to *Full Tension* position, and connect band saw to power. Turn it on for a brief

time to observe blade in action through tracking window.

11. If further adjustments are needed, disconnect from power and repeat above procedure.

7.10 Overview – bearing adjustments

Thrust (back support) *bearings* are located behind saw blade and provide support to back of blade when saw is in operation.

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

7.11 Upper blade guides

⚠WARNING Unplug machine from power source before making any adjustments! Blade teeth are sharp – use care when working near blade. Failure to comply may cause serious injury.

The bearing guides should be set so that contact between blade and guides will occur only when blade is under pressure from a workpiece. To adjust upper bearing guides for proper blade control, proceed as follows.

Refer to Figures 7-15 and 7-16.

1. Disconnect machine from power source.
2. Blade must already be tensioned and tracking correctly. Place tension handle in *Full Tension* position.
3. Lower guide post until upper guide bearings are a few inches off table. (The reason for this will be evident later in sect. 7.15)
4. Loosen lock knob (A, Figure 7-15).

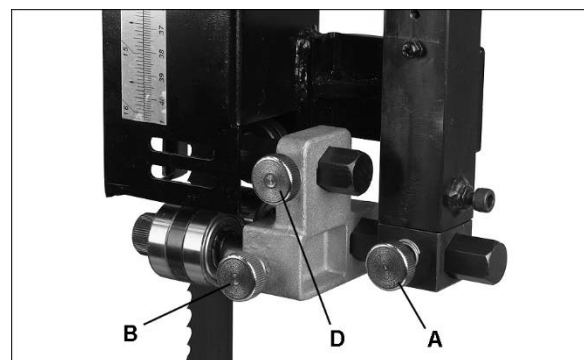


Figure 7-15

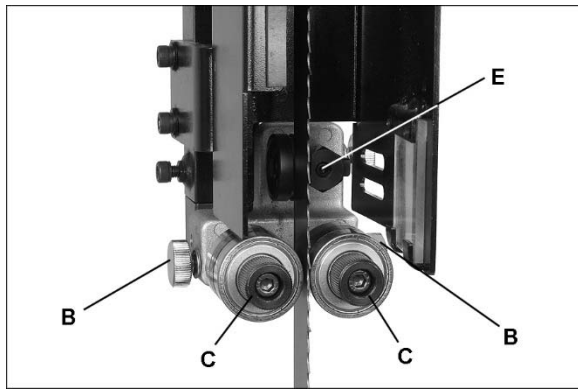


Figure 7-16

- Slide entire guide bracket until front of guide bearings are about 0.015" (1/64") behind the blade's gullet (curved area at base of tooth). See Figure 7-17.

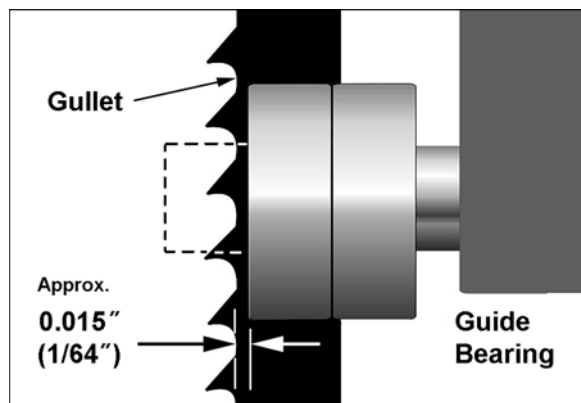


Figure 7-17

- Tighten lock knob (A) to secure this position.
 - Loosen lock knob (B) for either of the front guide bearings.
 - The guide bearing rotates on an eccentric shaft. Adjust guide bearing by rotating the knurled knob (C) until guide bearing is approximately 0.004" from blade. A quick way to achieve this spacing is by placing a single thickness of a crisp dollar bill (a dollar bill is approximately 0.004" thick) between blade and guide bearing. Adjust guide bearing until it just lightly grips the dollar bill.
- NOTE: Do not force guide bearing against side of blade. It should generally only make contact with blade when there is pressure from the cutting operation.
- Tighten lock knob (B).
 - Repeat process for opposite guide bearing.

7.12 Upper thrust bearing

Refer to Figures 7-15 and 7-16.

The thrust bearing prevents backward deflection of blade during cutting. A groove in the bearing surface helps stabilize the moving blade.

- Loosen lock knob (D) and slide thrust bearing up to back of blade.
- Adjust thrust bearing until space between groove bottom and back edge of blade is approximately 0.015" (1/64"). Tighten lock knob (D).
- If lateral adjustment of bearing is needed to align groove with blade, loosen set screw (E) at front of bearing assembly, and shift bearing as needed. Retighten set screw.
- Make sure all lock knobs on upper guide bearing assembly are tightened when adjustments are finished.

7.13 Lower blade guides

WARNING Unplug machine from power source before making any adjustments! Blade teeth are sharp - use care when working near saw blade. Failure to comply may cause serious injury.

Refer to Figures 7-18 and 7-19.

- Disconnect band saw from power source.
- Open lower door and swing lower guard out of the way.
- Adjust lower guide bearings and lower thrust bearing below table in similar manner to that of upper guide and thrust bearings.
- Movement summary: Loosen lock knob (F) to move entire guide bearing assembly. Loosen lock knob (G) and rotate knob (H) to adjust guide bearing in relation to blade. Thrust bearing is controlled by locking knob (J) and lateral adjustment by set screw (K).
- Make sure all knobs and handles are tightened after adjustments are complete.

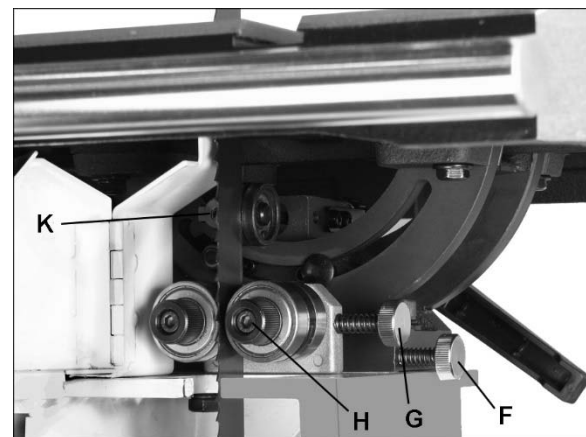


Figure 7-18

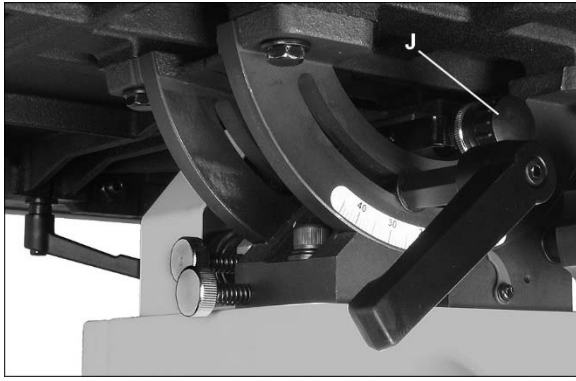


Figure 7-19

7.14 Guide post

Refer to Figure 7-20.

1. Disconnect band saw from power source.
2. Loosen lock knob (L) and raise or lower guide post using handwheel (M).

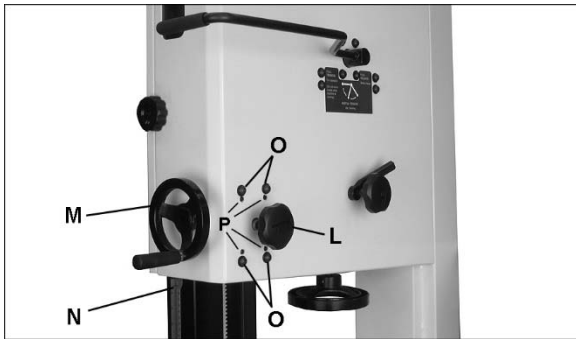


Figure 7-20

3. Position blade guide assembly so that bottom of guide bearings are about 1/8" above material to be cut. Or, simply lower guide post until scale pointer (N) indicates height of your workpiece. This provides minimal clearance between workpiece and bottom of guide bearings, which will minimize blade deflection as well as enhance operator safety.
4. Tighten lock knob (L).

7.15 Guide post parallelism

The guide post should be parallel to blade throughout vertical travel of the guide post; thus the guide bearings will maintain their relationship to blade at any height from the table and won't require re-setting each time guide post is moved. This setting has been accurately made by the manufacturer and should not require immediate attention, but may be checked in future as follows:

1. Disconnect band saw from power source.
2. Move blade tension lever to *Full Tension* position.
3. The guide bearings in low position should already be set in relation to blade (see sect.

7.11). Also, the table must be square with blade (see sect. 7.4).

4. Loosen lock knob (L, Figure 7-20) and raise guide post to a high position.
5. Confirm that guide post travels straight up and down, and guide bearings maintain their relationship to blade.
6. If guide post does not go straight up and down (blade begins deflecting when guide post is raised), slightly loosen the screws (O) and turn any of the set screws (P) as needed to bring guide post into line.
7. When finished adjusting, securely tighten the four screws (O).
8. Verify the setting by raising and lowering guide post.

7.16 Changing blade speed

WARNING Disconnect machine from power source before making any adjustments.

The JWBS-18 and JWBS-20 band saws have two blade-speed options which is determined by the position of the pulley drive belt. Refer to sect. 4.0 for speed specifications.

1. Loosen lock handle (A, Figure 7-21).

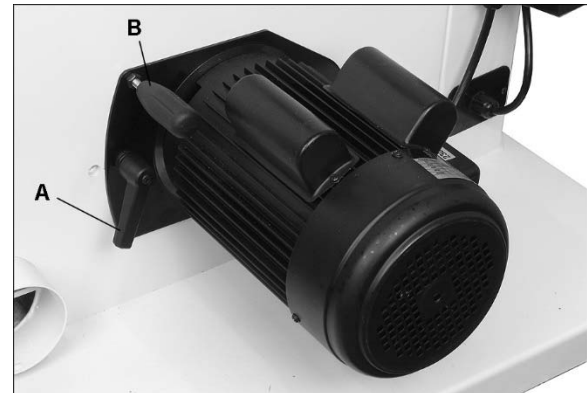


Figure 7-21

2. Release belt tension by pulling handle (B) up, then tighten lock handle (A) to maintain raised position.
3. Open lower wheel door.
4. Refer to Figure 7-22:

For higher blade-speed – place poly V-belt in inner position on spindle and motor pulleys as shown.

For lower blade-speed – place poly V-belt in outer position on pulleys.

After repositioning belt:

5. Loosen lock handle (A, Figure 7-21). Apply belt tension by slightly pushing down handle (B).

- Tighten lock handle (A) to secure motor position.

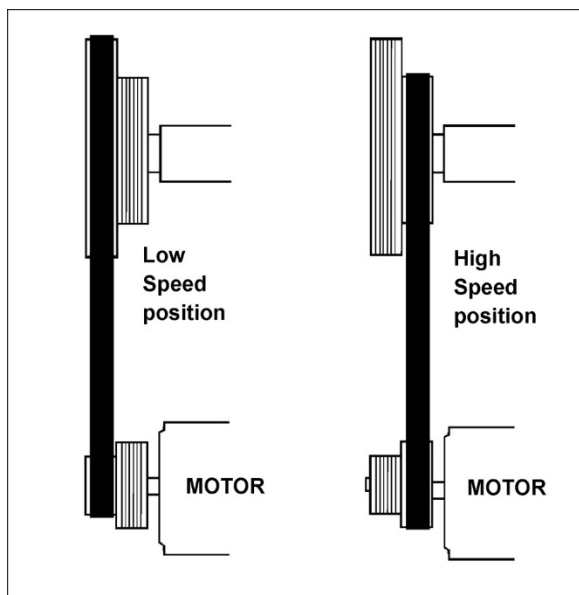


Figure 7-22

7.17 Drive belt replacement and tensioning

The drive belt and pulleys are properly adjusted by the manufacturer. However, belt tension should be occasionally checked when the band saw is new, as a new belt may stretch slightly during the breaking-in process.

⚠ WARNING Disconnect machine from power source before making any adjustments.

If belt becomes worn, cracked, frayed or glazed, it should be replaced as follows:

- Disconnect machine from power source.
- Open upper and lower doors and remove blade.
- Loosen motor lock handle (A, Figure 7-21).
- Raise motor lift handle (B) and retighten lock handle (A) to hold motor in raised position.
- Open lower wheel door. Remove bolt and washers, and remove wheel. If lower wheel does not come off easily you may need to use a pulley puller to remove it.
- Remove old belt from around motor pulley, and then from around lower wheel pulley.
- Install new belt, making sure it seats properly in pulley grooves. **Note:** See sect. 7.16 for speed positioning.
- Check pulley alignment. Refer to sect. 7.18, then return here to step 9.
- Reinstall lower wheel, bolt and washers, and tighten.
- Loosen motor lock handle (A, Figure 7-21) and allow motor to lower. Check tension by pushing

with moderate pressure on the belt halfway between the pulleys. An adequately tensioned belt will deflect about 1/2". If tension isn't strong enough, push down on motor.

- Tighten motor lock handle (A).
- Install blade, and verify blade tension and tracking before operating (sect 7.7 and 7.9).

7.18 Pulley alignment

Pulley alignment is done in conjunction with poly V-belt replacement.

If you are just beginning the alignment, start with sect. 7.17.

If you were directed here, proceed as follows:

- Place a straight edge against wheel pulley and motor pulley. If straight edge does not sit flush against both pulleys, alignment is necessary.

If alignment is necessary:

- Loosen two set screws on motor (lower) pulley with 4mm hex wrench.
- Adjust motor pulley by sliding in or out.
- Confirm alignment of poly V-belt using the straight edge.
- Retighten the two set screws on the motor pulley.

7.19 Brushes

An adjustable brush is located in the lower wheel housing. It should remain in constant contact with blade and wheel to prevent buildup of gum and debris. Loosen screw and adjust as needed, then retighten screw.

8.0 Operating controls

8.1 Start/stop switch

Press the green *on* button (A, Figure 8-1) to start. Press the red *stop* button (B) to stop.

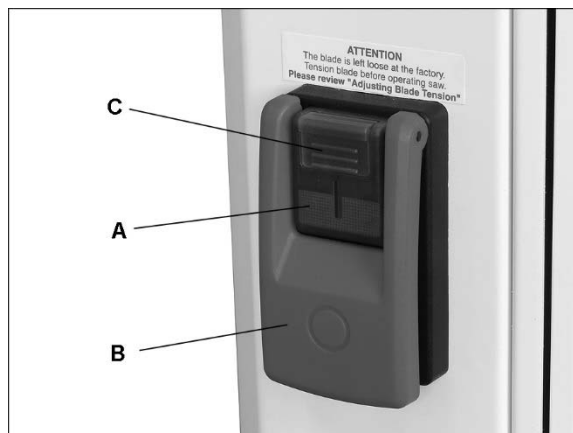


Figure 8-1 – Start/Stop Switch

On 3- and 5-horsepower models, the *on* button will light up when it is pushed and saw is operating. (There is no light on 1-3/4 HP models.)

The switch has a safety feature that prevents unauthorized or accidental starting of the machine. With band saw turned off, slide safety key (C, Figure 8-1) up and remove it from switch. This piece must be re-inserted before band saw can operate.

9.0 Operation

The following section contains basic information, and is not intended to cover all possible applications or techniques using the band saw. Consult published sources of information, acquire formal training, and/or talk to experienced band saw users to gain proficiency and knowledge of band saw operations.

(The following figures may or may not show your specific band saw, but procedures are the same.)

9.1 General procedure

1. Make sure the blade and upper and lower bearings are properly adjusted for tension and tracking.
2. Adjust blade guide assembly so that the guide bearings are just above workpiece (about 3/16") allowing minimum exposure to blade. See Figure 9-1.
3. If using the fence, move it into position and lock it to the guide rail. If you are using the miter gauge for a crosscut, the fence should be moved safely out of the way.
4. Turn on band saw and allow a few seconds for the machine to reach full speed.

▲WARNING Whenever possible, use a push stick, hold-down, power feeder, jig, or similar device while feeding stock, to prevent your hands getting too close to the blade.

5. Place the straightest edge of the workpiece against the fence, and push the workpiece slowly into the blade. Do not force the workpiece into the blade.

▲CAUTION When cutting, do not overfeed the blade; overfeeding will reduce blade life and may cause the blade to break.

6. When cutting long stock, the operator should use roller stands, support tables, or an assistant to help stabilize the workpiece.

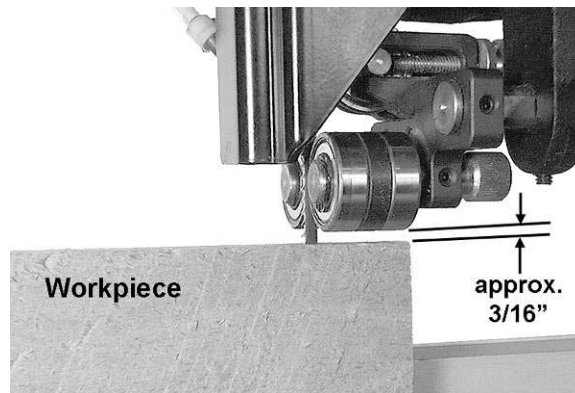


Figure 9-1

9.2 Ripping

Ripping is cutting lengthwise through the workpiece, and with the grain (of wood stock). See Figure 9-2.

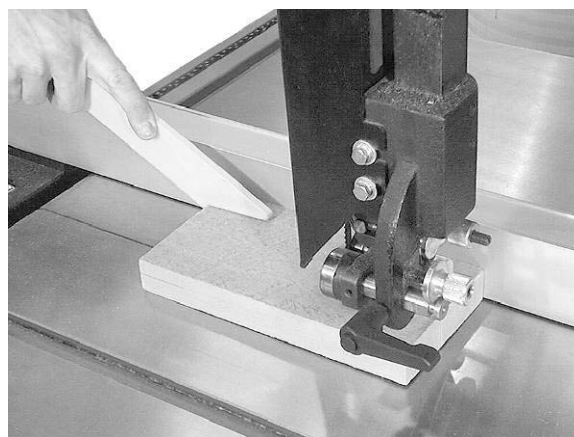


Figure 9-2

9.3 Crosscutting

Crosscutting is cutting across the grain of the workpiece, while using the miter gauge to feed the workpiece into the blade.

Slide the bar of the miter gauge into the end of the slot on the table.

The right hand should hold the workpiece steady against the miter gauge, while the left hand pushes the miter gauge past the blade, as shown in Figure 9-3.

Do not use the fence in conjunction with the miter gauge. The offcut of the workpiece must not be constrained during or after the cutting process.

▲CAUTION Using the fence in conjunction with the miter gauge can cause binding and possible damage to the blade.

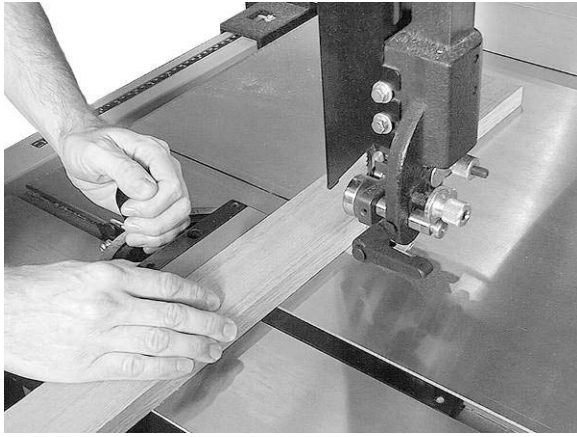


Figure 9-3

9.4 Resawing

Resawing is the process of slicing stock to reduce its thickness, or to produce boards that are thinner than the original workpiece. Figure 9-4 demonstrates resawing.

The ideal blade for resawing is the widest one the machine can handle, as the wider the blade the better it can hold a straight line.

When resawing thin stock, use a push block, push stick, or similar device to keep your hands away from the blade.

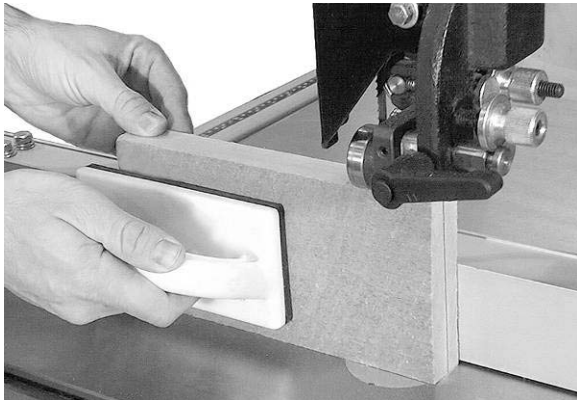


Figure 9-4

9.5 Blade lead

Blade lead, or drift, is when the blade begins to wander off the cutting line even when the band saw fence is being used. Figure 9-5 shows an example of blade lead. It is more common with small, narrow blades, and is almost always attributable to poor blade quality, or lack of proper adjustments. Inspect the band saw for the following:

- Fence not parallel to miter slot and blade.
- Blade not tensioned correctly.
- Blade is dull.
- Teeth have excessive "set" on one side of blade.
- Workpiece being fed too quickly.

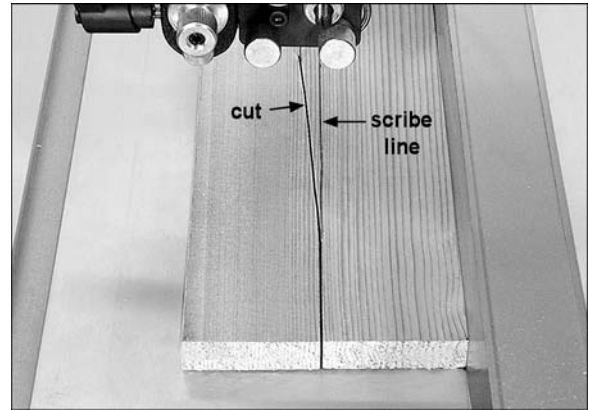


Figure 9-5

9.6 Saw blade selection

Using the proper blade for the job will increase the operating efficiency of your band saw, help reduce necessary saw maintenance, and improve your productivity. Thus, it is important to follow certain guidelines when selecting a saw blade.

Here are factors to consider when selecting a blade:

- The type of material you will be cutting.
- The thickness of the workpiece or part.
- The features of the workpiece or part, such as bends or curves with small radii.

These factors are important because they involve basic concepts of saw blade design. There are five (5) blade features that are normally changed to meet certain kinds of sawing requirements. They are:

1. width
2. pitch (number of teeth per inch)
3. tooth form (or shape)
4. the "set" of the teeth
5. the blade material itself.

9.7 Width

Band saw blades come in different standard widths, measured from the back of the blade to the tip of the tooth. Generally, wider blades are used for ripping or making straight cuts; narrower blades are often used when the part being cut has curves with small radii. When cutting straight lines with a narrow blade, the blade may have a tendency to wander, causing *blade lead*. (refer to sect. 9.5).

9.8 Pitch

Pitch is measured in "teeth per inch" (TPI). Figure 9-6 shows blades with different pitches. A fine pitch (more teeth per inch) will cut more slowly but smoother. A coarse pitch (fewer teeth per inch) will cut rougher but faster. As a rule of thumb, the thicker the workpiece, the coarser will be the blade pitch. If you have to cut a hard or very brittle material, you will probably want to use a blade with a finer pitch in order to get good clean cuts.

General rule: Use a blade that will have no fewer than 6 and no more than 12 teeth in the workpiece at any given time.

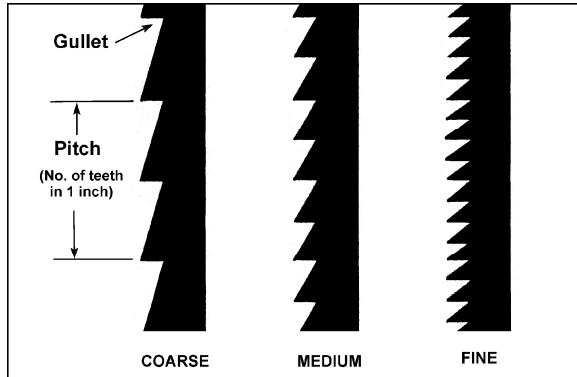


Figure 9-6

9.9 Shape

Figure 9-7 shows common types of tooth shape. Tooth shape has an effect on cutting rate, and with few exceptions, the Skip and Hook types are used to obtain higher feed rates when cutting thick workpieces. Variable-tooth blades are also available, which combine features of the other styles.

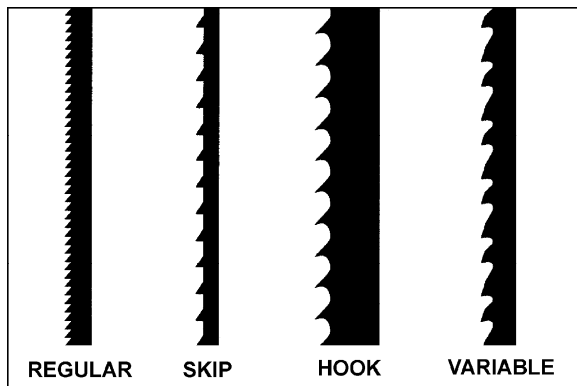


Figure 9-7

9.10 Set

The term "set" refers to the way in which the saw teeth are bent or positioned. Set patterns are usually selected depending on the type of material that needs to be cut. Three common set patterns are shown in Figure 9-8.

Generally, the *Raker* set is used for cutting metal workpieces; the *Wave* set, when the thickness of the workpiece changes, such as cutting hollow tubing or structurals. The *Straight* set is most often preferred when cutting wood or plastics.

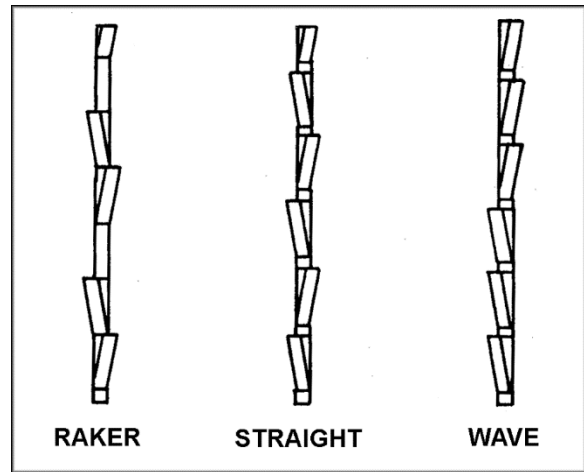


Figure 9-8

9.11 Material

Band saw blades can be made from different types of materials. Some of the most common include spring steel, carbon steel, carbon steel equipped with a high speed or welded edge (bi-metal), or carbide tips. A special type of saw blade is made from "high speed steel"; these should not be used on band saws with low rates of speed.

Because of the importance of blade selection, it is recommended that you use the *Blade Selection Guide* in sect. 11.0.

9.12 Blade breakage

Band saw blades are subject to high stresses and breakage may sometimes be unavoidable. However, many factors can be controlled to help prevent most blade breakage. Here are some common causes for breakage:

1. Misalignment of blade guides
2. Feeding work too fast
3. Using a wide blade to cut a short radius curve
4. Excessive tension
5. Teeth are dull or improperly set
6. Upper guides are set too high off workpiece
7. Faulty weld on blade

10.0 User-maintenance

⚠WARNING Before any intervention on the machine, disconnect it from the electrical supply by pulling out the plug. Failure to comply may cause serious injury.

Clean band saw regularly to remove any resinous deposits and sawdust.

Keep miter slot, and guide bearings, clean and free of resin.

Keep blade clean and sharp. Check it periodically for cracks or other signs of wear.

The drive belt should be checked periodically. If it looks worn, frayed, glazed or otherwise damaged, replace it.

Check that the cleaning brush over the band wheel is working properly, and remove any deposits from the band wheels to avoid vibration and blade breakage.

Do not let saw dust build up in the upper and lower wheel housings. Vacuum or blow out dust from inside cabinet. (Use proper dust mask equipment).

The table surface must be kept clean and free of rust for best results. If rust appears, it can often be removed with a mixture of household ammonia, good commercial detergent and #000 steel wool. Alternatively, commercial rust removers can be found at many hardware stores.

Apply a light coat of paste wax to the table surface. Aerosol protectants are also available in major hardware stores and supply catalogs. Whatever method is chosen, the coating should protect the metal and provide a smooth surface, without staining workpieces.

If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

Connect the band saw to a JET dust collection system of appropriate capacity.

Vacuum out the motor fan cover.

10.1 Lubrication points

1. Periodically apply a light, non-hardening grease to rack and pinion system of guide post.
2. Grease sliding surfaces of the table trunnions.
3. Oil any pins, shafts, and joints. (Do not get oil on pulleys or belts.)
4. Clean and oil the tensioning mechanism if it becomes difficult to adjust.

Note: Bearings on the band saw are pre-lubricated and sealed, and do not require attention.

10.2 Additional servicing

Any other servicing should be performed by an authorized service representative.

11.0 Blade Selection Guide

Table 3

Identify the material and thickness of your workpiece. The chart will show the recommended PITCH, blade TYPE, and FEED RATE.

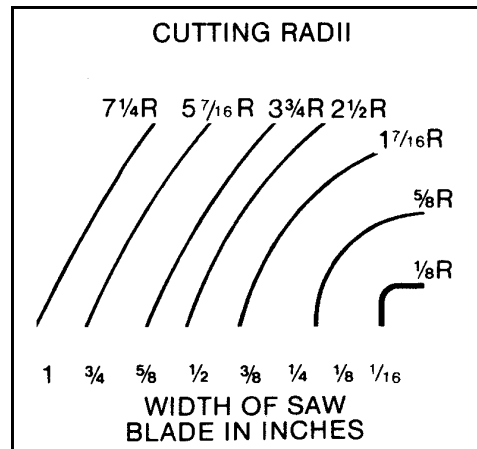
Key: H – Hook L – Low
 S – Skip M – Medium
 R – Regular H – High

Example: 10/H/M means 10 teeth per inch / Hook Type Blade / Medium Feed

| Material/s | | Workpiece Thickness | | | |
|------------|-------------|---------------------|--------|-------|-------|
| | | 1/2" | 1" | 3" | 6+" |
| Woods | Hardwood | 10/R/L | 8/R/L | 3/H/M | 3/H/M |
| | Softwood | 10/R/L | 8/R/L | 3/H/M | 3/H/M |
| Non-Metals | Carbon | 10/R/L | 6/R/L | 3/S/M | 3/S/M |
| | Mica | 32/R/L | -- | -- | -- |
| | Asbestos | 8/R/L | 6/R/L | 3/S/M | 3/S/M |
| | Hard Rubber | 10/R/L | 8/R/L | 6/R/M | 2/S/H |
| Plastics | Formica | 14/R/M | 10/R/M | 4/H/H | 4/H/H |
| | Masonite | 10/R/L | 4/S/L | 3/S/M | 3/H/M |
| | Micarta | 14/R/M | 10/R/M | 4/H/H | 3/H/H |
| | Plexiglas | 10/R/L | 6/R/L | 3/S/M | 3/S/M |
| | Paper | 14/R/L | 10/R/L | 4/S/L | 3/S/M |

Study the part drawing or prototype, or actually measure the smallest cutting radius required, and locate this radius (in inches) on the chart at the right. Follow the curve to where the approximate blade width is specified. If a radius falls between two of the curves, select the widest blade that will saw this radius.

This procedure should be used for making initial blade selections. These recommendations can, of course, be adjusted to meet specific requirements of a cutting job. Compromises may be necessary if you cannot find all needed specifications in a single blade.



12.0 Troubleshooting JWBS-series Band Saws

12.1 Operational problems

Table 4

| Symptom | Probable Cause | Correction * |
|--|--|--|
| Table tilt does not hold position under load. | Lock handle not tight. | Tighten lock handle. |
| | Trunnion locking mechanism is broken or worn. | Replace trunnion locking mechanism. |
| Table will not tilt. | Trunnion not lubricated. | Lubricate trunnion. |
| | Trunnion jammed. | Disassemble and replace jammed parts. |
| Table vibration while sawing. | Drive belt too slack. | Increase tension on drive belt. Replace belt if worn. |
| | Incorrect choice of saw blade pitch. | Check blade selection chart and use correct blade. |
| | Saw dust or debris on band wheel. Or tire is worn/damaged. | Keep band wheels clean. Replace tires if necessary. |
| Surface finish on workpiece is rough. | Blade pitch too coarse. | Change to finer pitch blade. |
| | Workpiece being fed too strongly. | Reduce feed force. |
| Blade cutting inaccurately. Cuts not straight. | Gum or pitch on blade. | Clean blade. |
| | Worn blade teeth or damaged blade. | Replace blade. |
| | Fence not parallel to blade. | Align fence properly. |
| | Incorrect adjustment of blade guides. | Adjust blade guides properly. |
| | Workpiece being fed too strongly. | Reduce feed force. |
| | Upper blade guides not located close enough to workpiece. | Position guides about 1/8" above workpiece. |
| | Incorrect choice of saw blade for that particular operation. | Install correct blade. |
| | Blade tension too light. | Increase tension. |
| Blade cannot be tensioned properly. | Tension spring is fatigued. | Replace tension spring (contact JET service representative). |
| Blade binds in workpiece. | Incorrect blade tension or damaged blade. | Correct accordingly. |
| | Blade too wide for desired radius. | Select narrower blade. |
| Blade forms cracks at base of teeth. | Teeth not suitable for operation, or incorrectly set. | Replace with proper blade. |
| | Blade thickness not suitable for band wheel diameter. | Replace with proper thickness blade. |
| | Blade sharpened incorrectly, becomes overheated. | Sharpen blade properly or replace. |
| | Band wheels have become misaligned. | Contact service representative. |
| Cracks on back edge of blade. | Workpiece being fed too quickly. | Reduce feed speed to lessen strain on blade. |
| | Welding on blade not perfectly aligned. | Eliminate welded part, and re-weld properly; or acquire a new blade. Round the back edge of a new blade. |
| | Thrust bearing is worn; caused by constant contact with back of blade. | Replace thrust bearing. Adjust new bearing according to instructions. |

| Symptom | Probable Cause | Correction * |
|---------------------------------|--|---|
| Blade breaks prematurely. | Feed force too great. | Reduce feed force. |
| | Blade pitch too coarse. | Refer to blade selection chart; use finer pitch blade. |
| | Guide bearings not properly supporting blade. | Check guide bearings for correct position and signs of wear. Adjust or replace as needed. |
| | Blade tensioned too tightly. | Reduce tension. |
| Blade breaks close to weld. | Blade overheated during welding. | Have blade annealed, or eliminate brittle part and weld correctly. |
| | Blade cooled too rapidly after welding. | Have blade annealed, or eliminate brittle part and weld correctly. |
| Premature dulling of saw teeth. | Blade pitch too fine. | Refer to blade selection chart. Use blade with coarser pitch. |
| | Feed pressure too light. | Increase feed pressure. |
| | Cutting rate too low. | Increase feed pressure and cutting rate. |
| | Incorrect choice of blade. | Re-examine material. Select proper blade from chart. |
| | Chipped tooth or foreign object lodged in cut. | Stop saw and remove lodged particle. Replace blade if damaged. |

* **WARNING:** Some corrections may require a qualified electrician.

12.2 Mechanical and electrical problems

Table 5

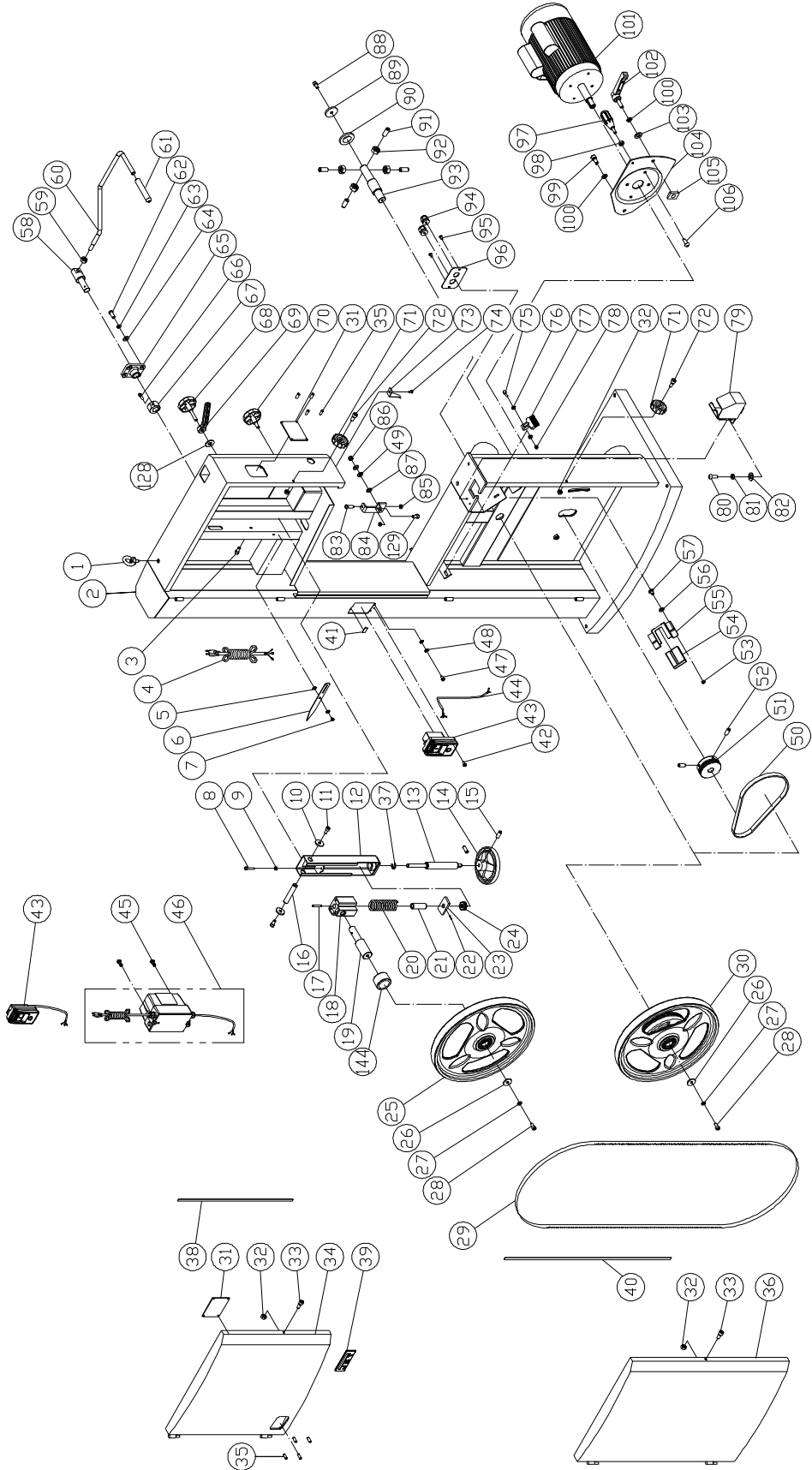
| Symptom | Probable Cause | Correction * |
|--|---|--|
| Machine will not start/restart or repeatedly trips circuit breaker or blows fuses. | No incoming power. | Verify machine connections. |
| | Cord damaged. | Replace cord. |
| | Band Saw frequently trips. | One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to reduce feed pressure into the blade. If this does not resolve the issue, check for loose electrical lead. |
| | Building circuit breaker trips or fuse blows. | Verify that band saw is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead. Check amp setting on motor starter. |
| | Overload automatic reset has not reset. | When the 3HP and 5HP Band Saw overloads on the circuit break built into the motor starter, it takes time for the machine to cool down before restart. Allow machine to adequately cool before attempting restart. If problem persists, check amp setting on the motor starter inside the electrical box. |
| | Switch or motor failure (how to distinguish). | If you have access to a voltmeter, you can separate a starter failure from a motor failure by first, verifying incoming voltage at 115 +/-10% (or 230+/-10%) and second, checking the voltage between starter and motor at 115 +/-10% (or 230+/-10%). If incoming voltage is incorrect, you have a power supply problem. If voltage between starter and motor is incorrect, you have a starter problem. If voltage between starter and motor is correct, you have a motor problem. |
| | Motor overheated. | Clean motor of dust or debris to allow proper air circulation. Allow motor to cool down before restarting. |
| | Motor failure. | If electric motor is suspect, you have two options: Have a qualified electrician test the motor for function or remove the motor and take it to a qualified electric motor repair shop for testing. |
| | Miswiring of unit. | Double check to confirm all electrical connections are correct. Refer to wiring diagram to make needed corrections. |
| Band Saw does not attain full speed. | Switch failure. | If the start/stop switch is suspect, you have two options: Have a qualified electrician test the switch for function, or purchase a new start/stop switch and establish if that was the problem on change-out. |
| | Extension cord too light or too long. | Replace with adequate size and length cord. |
| | Low current. | Contact a qualified electrician. |

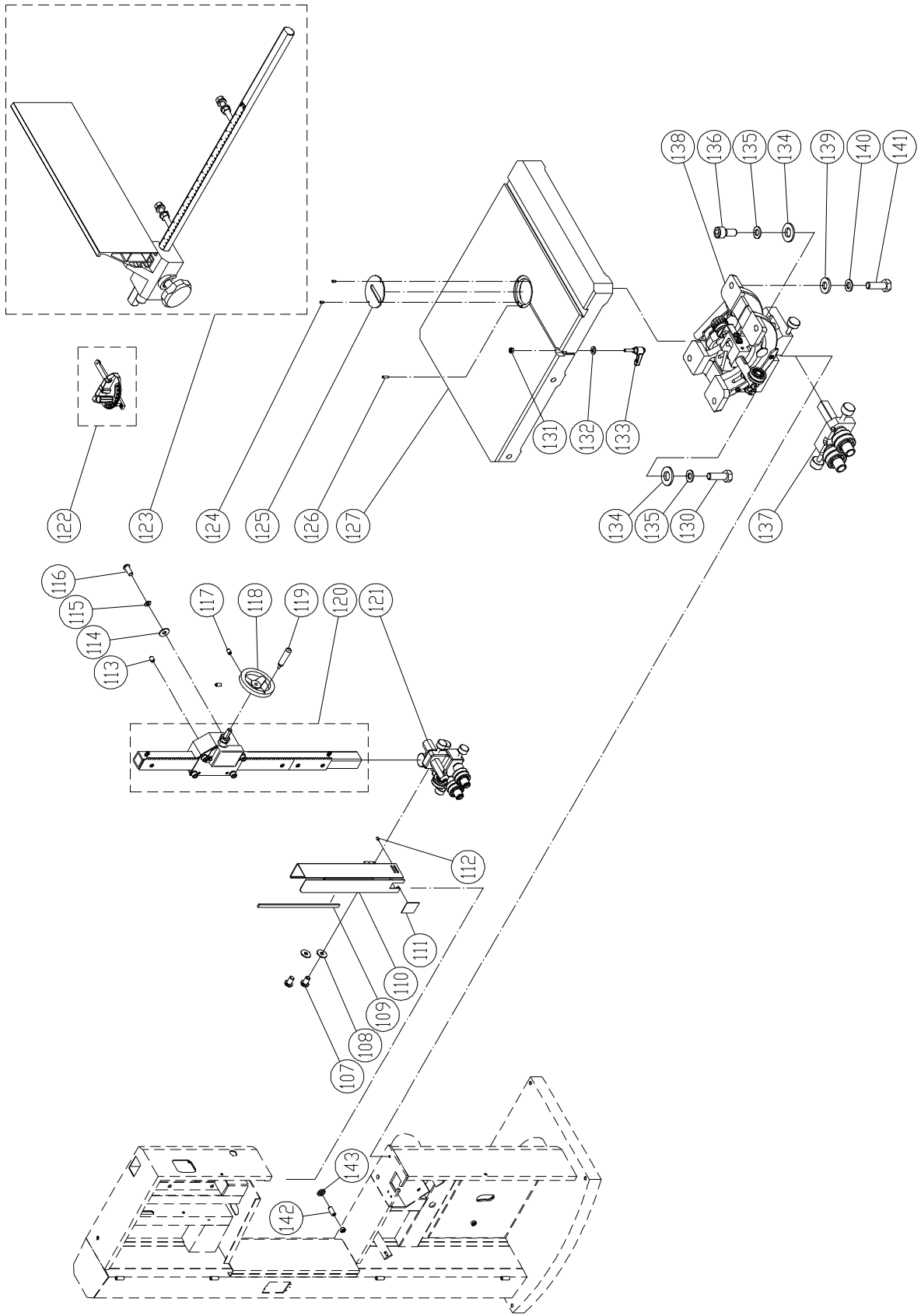
* **WARNING:** Some corrections may require a qualified electrician.

13.0 Replacement Parts

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

13.1.1 JWBS-15 Assembly – Exploded View





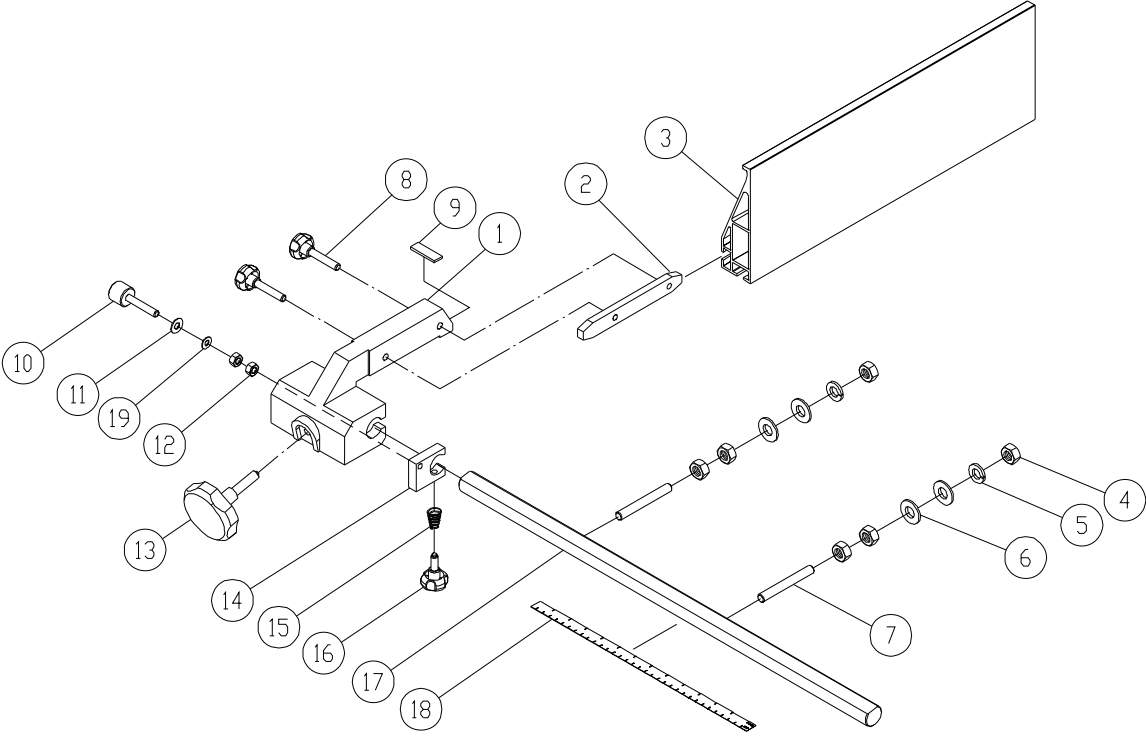
13.1.2 JWBS-15 Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|--|----------------------------------|-----|
| 1 | PM1500-004 | Lifting Ring | M10 | 1 |
| 2 | JWBS15-102 | Machine Main Body Frame | | 1 |
| 3 | TS-1482021 | Hex Cap Bolt | M6x12 | 1 |
| 4 | JWBS15-104 | Power Cord | 1-3/4HP | 1 |
| | JWBS15-104B | Power Cord | 3HP | 1 |
| 5 | TS-1550041 | Flat Washer | M6 | 2 |
| 6 | PM1500-011 | Tension Pointer | | 1 |
| 7 | PM1500-012 | Step Screw | | 1 |
| 8 | TS-1503111 | Socket Head Cap Screw | M6x50 | 1 |
| 9 | TS-2311061 | Hex Nut | M6 | 1 |
| 10 | TS-1550061 | Flat Washer | M8 | 2 |
| 11 | TS-1504031 | Socket Head Cap Screw | M8x16 | 2 |
| 12 | JWBS15-112 | Upper Wheel Sliding Bracket | | 1 |
| 13 | JWBS15-113 | Adjusting Bolt | | 1 |
| 14 | JWBS15-114 | Handwheel | 6" | 1 |
| 15 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 16 | JWBS15-116 | Upper Shaft | | 1 |
| 17 | JWBS15-117 | Spring Pin | Ø5x36 | 1 |
| 18 | JWBS15-118 | Upper Wheel Sliding Bracket | | 1 |
| 19 | JWBS15-119 | Upper Wheel Shaft | | 1 |
| 20 | JWBS15-120 | Spring | | 1 |
| 21 | PM1500-010-02 | Bushing | | 1 |
| 22 | JWBS15-122 | Pin | Ø3x20 | 1 |
| 23 | JWBS15-123 | Locate Block | | 1 |
| 24 | BB-51201 | Bearing | 51201 | 1 |
| 25 | PM1500-019 | Upper Wheel Assembly | Ø15" | 1 |
| 26 | TS-1550061 | Flat Washer | M8 | 2 |
| 27 | TS-2361081 | Spring Washer | M8 | 2 |
| 28 | TS-1504041 | Socket Head Cap Bolt | M8x20 | 2 |
| 29 | JWBS15-129 | Saw Blade | 133"L x 1/2" W x 0.026"T x 6 TPI | 1 |
| 30 | PM1500-020 | Lower Wheel Assembly | Ø15" | 1 |
| 31 | PM1500-050 | Viewing Window | | 2 |
| 32 | TS-1541021 | Nylon Nut | M6 | 4 |
| 33 | TS-1503021 | Socket Head Cap Screw | M6x10 | 2 |
| 34 | JWBS15-134 | Upper Door | | 1 |
| 35 | JWBS15-135 | Socket Head Cap Screw | M4x8 | 8 |
| 36 | JWBS15-136 | Lower Door | | 1 |
| 37 | PM1800B-027-026 | Retaining Ring | E15 | 1 |
| 38 | JWBS15-138 | Sponge | | 1 |
| 39 | JET-138-R2000 | Jet Logo | 138x57mm | 1 |
| 40 | JWBS15-140 | Sponge | 760x10mm T=1 | 1 |
| 41 | JWBS15-141 | Sponge | 16x5mm T=2 | 1 |
| 42 | TS-1532032 | Pan Head Screw | M4x10 | 1 |
| 43 | JOSS-S-213 | On/Off Switch Assembly | 1-3/4HP | 1 |
| | JOSS-S-213SK | Safety Key for JOSS-S-213 (not shown) | | 1 |
| | JWBS15-143B | Control Switch Assembly | 3HP | 1 |
| | JWBS15-143BSK | Safety Key for JWBS15-143B (not shown) | | 1 |
| 44 | JWBS15-144 | Motor Cord | 14AWGx3C | 1 |
| 45 | TS-1533052 | Pan Head Screw | M5x16 | 2 |
| 46 | JWBS15-146 | Magnetic Switch Assembly | 3HP only | 1 |
| | JWBS15-146CS | Contact Switch | | 1 |
| | JWBS15-146OP | Overload Protector | | 1 |
| 47 | TS-1533032 | Pan Head Screw | M5x10 | 2 |
| 48 | TS-0733041 | Ext. Tooth Lock Washer | M5 | 4 |
| 49 | PM1800B-159 | Special Washer | Ø16x8.2x0.4T | 2 |
| 50 | JWBS15-150 | Poly V Belt | 350J9 | 1 |
| 51 | PM1500-025 | Motor Pulley | | 1 |
| 52 | TS-1523041 | Set Screw | M6x12 | 2 |
| 53 | TS-2311061 | Hex Nut | M6 | 2 |
| 54 | JWBS18DX-249 | Dust Collect Insert | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------------|-----------------------------------|----------------|-----|
| 55 | JWBS15-155 | Fixed Plate | | 1 |
| 56 | TS-2361061 | Spring Washer | M6 | 2 |
| 57 | TS-2246122 | Socket Head Button Screw | M6x12 | 2 |
| 58 | PM1500-074 | Tension Quick Release Lever Shaft | | 1 |
| 59 | TS-1540083 | Hex Nut | M12 | 1 |
| 60 | JWBS15-160 | Tension Quick Release Lever | | 1 |
| 61 | JWBS15-161 | Grip | | 1 |
| 62 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 63 | TS-2361081 | Spring Washer | M8 | 4 |
| 64 | TS-1550061 | Flat Washer | M8 | 4 |
| 65 | PM1500-070 | Shaft Fixed Block | | 1 |
| 66 | TS-1503061 | Socket Head Cap Screw | M6x25 | 1 |
| 67 | PM1500-069 | Cam | | 1 |
| 68 | JWBS15-168 | Lock Knob | M10x53 | 1 |
| 69 | PM1500-068 | Lock Handle | M10 | 1 |
| 70 | JWBS15-170 | Lock Knob | M10x25 | 1 |
| 71 | 135041 | Knob | | 2 |
| 72 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 73 | JWBS15-173 | Pointer | | 1 |
| 74 | 6286494 | Pan Head Screw | M5x6 | 1 |
| 75 | TS-1482051 | Hex Cap Screw | M6x25 | 1 |
| 76 | TS-1550041 | Flat Washer | M6 | 2 |
| 77 | PM1500-058 | Brush | | 1 |
| 78 | TS-1541021 | Hex Nylon Lock Nut | M6 | 1 |
| 79 | JWBS15-179 | Lower Blade Guard | | 1 |
| 80 | TS-2246082 | Socket Head Button Screw | M6x8 | 2 |
| 81 | TS-2361061 | Lock Washer | M6 | 2 |
| 82 | TS-1550041 | Flat Washer | M6 | 2 |
| 83 | TS-1490041 | Hex Cap Screw | M8x25 | 1 |
| 84 | JWBS15-184 | Support Plate | | 2 |
| 85 | TS-1541031 | Hex Nut | M8 | 1 |
| 86 | TS-1541031 | Nylon Nut | M8 | 1 |
| 87 | TS-1550061 | Flat Washer | M8 | 2 |
| 88 | TS-1504041 | Socket Head Cap Screw | M8x20 | 1 |
| 89 | PM1500-077 | Washer | | 1 |
| 90 | PM1500-137 | Plate | | 1 |
| 91 | TS-1524051 | Set Screw | M8x20 | 4 |
| 92 | TS-1540061 | Hex Nut | M8 | 4 |
| 93 | JWBS15-193 | Lower Wheel Shaft | | 1 |
| 94 | PM1500-062 | Strain Relief | PG13.5 | 2 |
| 95 | PM1500-039 | Tapping Screw | M4x8 | 2 |
| 96 | PM1500-083 | Strain Relief Fixed Plate | for 1-3/4 HP | 1 |
| | JWBS15-196A | Strain Relief Fixed Plate | for 3HP | 1 |
| 97 | JWBS15-197 | Handle | | 1 |
| 98 | TS-1540061 | Hex Nut | M8 | 1 |
| 99 | TS-149105 | Hex Cap Screw | M10x35 | 1 |
| 100 | TS-2361101 | Spring Washer | M10 | 2 |
| 101 | JWBS15-1101 | Motor | 1-3/4HP | 1 |
| | JWBS18B-1101FM | Motor Fan (not shown) | | 1 |
| | JWBS18B-1101FMC | Motor Fan Cover (not shown) | | 1 |
| | JWBS18B-1101SC | Start Capacitor (not shown) | 300MFD, 250VAC | 1 |
| | JWBS18B-1101RC | Running Capacitor (not shown) | 40µF, 250VAC | 1 |
| | JWBS18B-1101JB | Junction Box (not shown) | | 1 |
| | JWBS18B-1101JBC | Junction Box Cover (not shown) | | 1 |
| | JWBS18B-1101CS | Centrifugal Switch (not shown) | | 1 |
| | JWBS15-1101A | Motor | 3HP/230V | 1 |
| | JWBS18B-1101AMF | Motor Fan (not shown) | | 1 |
| | JWBS18B-1101AMFC | Motor Fan Cover (not shown) | | 1 |
| | JWBS18B-1101ASC | Start Capacitor (not shown) | 300MFD, 250VAC | 1 |
| | JWBS18B-1101ARC | Running Capacitor (not shown) | 60µF, 300VAC | 1 |
| | JWBS18B-1101AJB | Junction Box (not shown) | | 1 |
| | JWBS18B-1101AJBC | Junction Box Cover (not shown) | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|-----------------------------------|-------------|-----|
| | JWBS18B-1101ACS | Centrifugal Switch (not shown) | | 1 |
| 102 | PM1500-015 | Motor Bracket Lock Handle | M10x33 | 1 |
| 103 | TS-1550071 | Flat Washer | M10 | 1 |
| 104 | JWBS15-1104 | Motor Bracket | | 1 |
| 105 | PM1500-038 | Locating Block | | 1 |
| 106 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 107 | TS-1502031 | Socket Head Cap Screw | M5x12 | 2 |
| 108 | TS-1550031 | Flat Washer | M5 | 2 |
| 109 | JWBS15-1109 | Magnet | 7x340mm | 1 |
| 110 | JWBS15-1110 | Blade Guard Cover | | 1 |
| 111 | PM1800B-093 | Viewing Window | | 1 |
| 112 | TS-1521011 | Set Screw | M4x4 | 2 |
| 113 | 5302731 | Set Screw | M8x6 | 4 |
| 114 | TS-1550061 | Flat Washer | M8 | 4 |
| 115 | TS-2361081 | Spring Washer | M8 | 4 |
| 116 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 117 | TS-1523041 | Set Screw | M6x12 | 2 |
| 118 | JWBS15-1118 | Handwheel | 5" | 1 |
| 119 | JWBS15-1119 | Handle | M8 | 1 |
| 120 | JWBS15-1120 | Guide Bar Bracket Assembly | | 1 |
| 121 | JWBS15-1121 | Upper Blade Guide Assembly | | 1 |
| 122 | JWBS15-1122 | Miter Gauge Assembly | | 1 |
| 123 | JWBS15-1123 | Rip Fence Assembly | | 1 |
| 124 | JWBS15-1124 | Roll Pin | Ø4x8 | 2 |
| 125 | JWBS15-1125 | Table Insert | | 1 |
| 126 | TS-1522011 | Set Screw | M5x5 | 3 |
| 127 | JWBS15-1127 | Table | 21-1/2"x16" | 1 |
| 128 | TS-1550071 | Flat Washer | M10 | 1 |
| 129 | TS-1490021 | Hex Cap Screw | M8x16 | 1 |
| 130 | TS-149105 | Hex Cap Screw | M10x35 | 1 |
| 131 | TS-1540061 | Hex Nut | M8 | 1 |
| 132 | TS-1550061 | Flat Washer | M8 | 1 |
| 133 | JWBS15-1133 | Handle | M8x45 | 1 |
| 134 | TS-1550071 | Flat Washer | M10 | 2 |
| 135 | TS-2361101 | Spring Washer | M10 | 2 |
| 136 | TS-1505051 | Socket Head Cap Screw | M10x35 | 1 |
| 137 | JWBS15-1137 | Lower Blade Guide Assembly | | 1 |
| 138 | JWBS15-1138 | Trunnion Support Bracket Assembly | | 1 |
| 139 | TS-1550061 | Flat Washer | M8 | 4 |
| 140 | TS-2361081 | Spring Washer | M8 | 4 |
| 141 | TS-1490041 | Hex Cap Screw | M8x25 | 4 |
| 142 | 7015-48 | Set Screw | M8x30 | 1 |
| 143 | TS-1541031 | Hex Nylon Lock Nut | M8 | 1 |
| 144 | JWBS15-1144 | Bushing | | 1 |

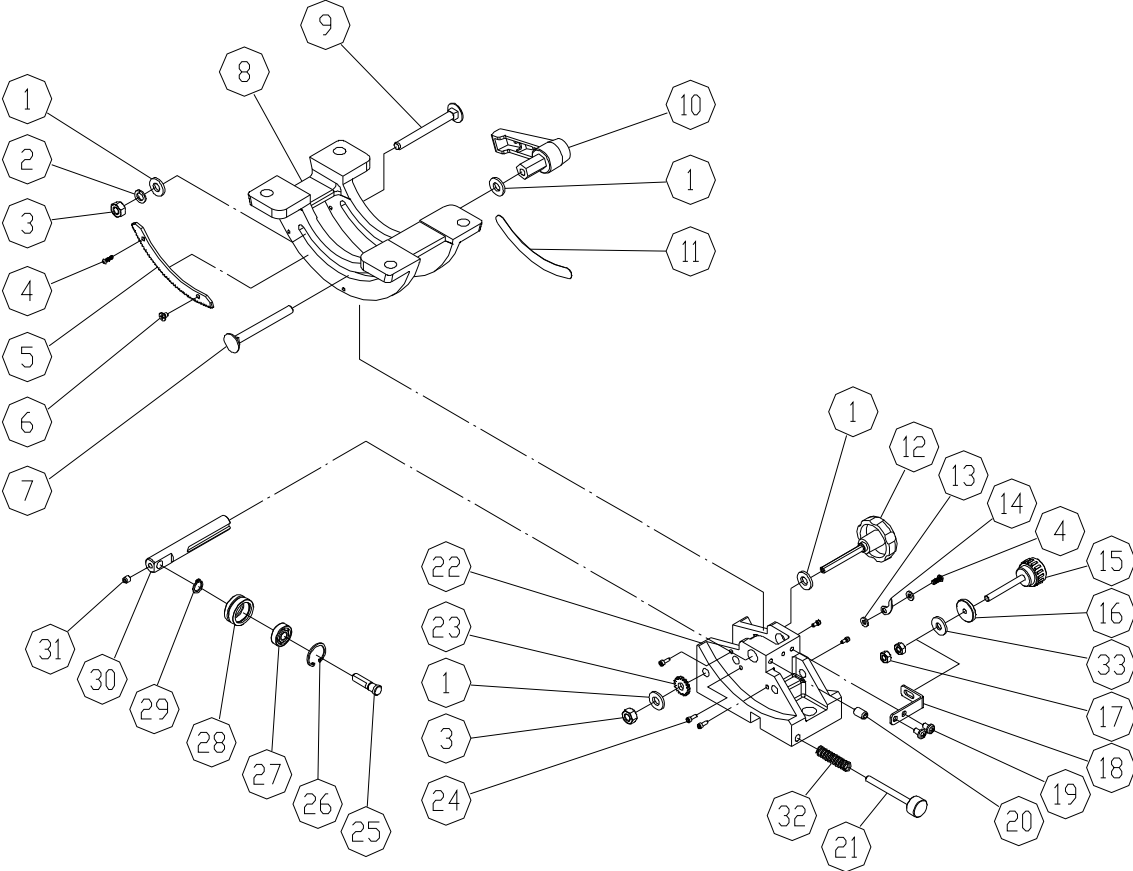
13.2.1 JWBS-15 Rip Fence Assembly – Exploded View



13.2.2 JWBS-15 Rip Fence Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|---------------------------------|----------|-------|
| | JWBS15-1123 | Rip Fence Assembly (#1 thru 18) | | |
| 1 | JWBS15-1123-201 | Fence Body | | 1 |
| 2 | JWBS15-1123-202 | Lock Bar | | 1 |
| 3 | JWBS15-1123-203 | Fence, Aluminum | 462mm | 1 |
| 4 | TS-2311101 | Nut | M10 | 6 |
| 5 | TS-2361101 | Spring Washer | M10 | 2 |
| 6 | TS-1550071 | Flat Washer | M10 | 4 |
| 7 | JWBS15-1123-207 | Set Screw | M10x80 | 2 |
| 8 | JWBS15-1123-208 | Knob | M8x40 | 2 |
| 9 | PM1500-107-10 | Resistance Pad | | 1 |
| 10 | JWBS15-1123-210 | Adjustment Knob | M8x50 | 1 |
| 11 | JWBS15-1123-211 | Fiber Washer | | 1 |
| 12 | TS-1540061 | Nut | M8 | 2 |
| 13 | JWBS15-1123-213 | Knob | M8x40 | 1 |
| 14 | JWBS15-1123-214 | Locate Block | | 1 |
| 15 | PM1800B-059-017 | Cone Spring | | 1 |
| 16 | JWBS15-1123-216 | Knob | M6x14 | 1 |
| 17 | JWBS15-1123-217 | Fence Guide Rail | 640mm | 1 |
| 18 | JWBS15-1123-218 | Scale | 350mm | 1 |
| 19 | JWBS15-1123-219 | Wave Washer | Ø8x13 mm | 1 |

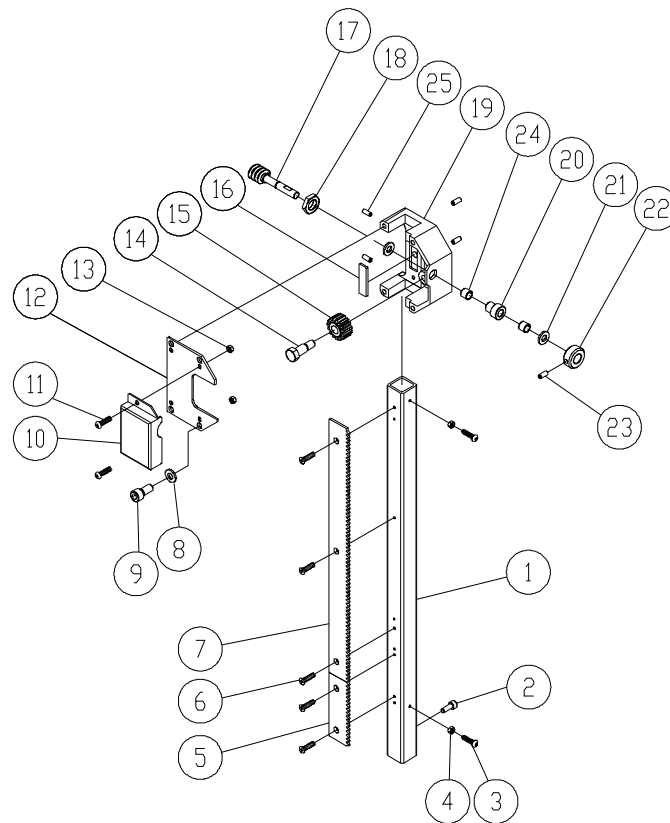
13.3.1 JWBS-15/18/20 Trunnion Support Bracket Assembly – Exploded View



13.3.2 JWBS-15/18/20 Trunnion Support Bracket Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|--|----------|-----|
| | JWBS15-1138 | Trunnion Support Bracket Assembly (#1 thru 32) | | |
| 1 | TS-1550061 | Flat Washer | M8 x Ø18 | 4 |
| 2 | TS-2361081 | Lock Washer | M8 | 1 |
| 3 | TS-1541031 | Nylon Lock Hex Nut | M8 | 2 |
| 4 | TS-2171012 | Phillips Pan Head Machine Screw | M4x6 | 2 |
| 5 | PM1500-085-05 | Gear Rack | | 1 |
| 6 | TS-2284061 | Phillips Flat Head Machine Screw | M4x6 | 1 |
| 7 | PM1500-085-07 | Carriage Bolt | M8x85 | 1 |
| 8 | PM1500-085-08 | Trunnion Block | | 1 |
| 9 | PM1500-085-09 | Carriage Bolt | M8x80 | 1 |
| 10 | JWBS15-1138-310 | Lock Handle | | 1 |
| 11 | PM1500-085-11 | Tilt Scale | | 1 |
| 12 | PM1500-085-12 | Adjustment Knob Bolt | | 1 |
| 13 | TS-1550021 | Flat Washer | M4 x Ø8 | 2 |
| 14 | PM1500-085-14 | Angle Pointer | | 1 |
| 15 | JWBS15-1138-315 | Adjustment Knob Bolt | M6 | 1 |
| 16 | PM1500-085-16 | Locking Ring | | 1 |
| 17 | TS-2311061 | Hex Nut | M6 | 2 |
| 18 | PM1500-085-18 | Adjustment Plate | | 1 |
| 19 | 5712561 | Phillips Pan Head Machine Screw | M5x8 | 2 |
| 20 | PM1500-085-20 | Set Screw | | 1 |
| 21 | PM1500-085-21 | Lock Knob | | 1 |
| 22 | JWBS15-1138-322 | Trunnion Support Bracket | | 1 |
| 23 | PM1500-085-23 | Gear | | 1 |
| 24 | TS-2235061 | Socket Head Cap Screw | M5x6 | 6 |
| 25 | PM1500-085-25 | Adjustment Shaft | | 1 |
| 26 | PM1500-085-26 | Retaining Ring | R22 | 1 |
| 27 | BB-608ZZ | Ball Bearing | 608ZZ | 1 |
| 28 | PM1500-085-28 | Thrust Bearing Holder | | 1 |
| 29 | PM1500-085-29 | Retaining Ring | S8 | 1 |
| 30 | JWBS15-1138-330 | Adjustment Bar | | 1 |
| 31 | TS-1523011 | Socket Set Screw | M6x6 | 1 |
| 32 | JWBS15-1138-332 | Spring | | 1 |
| 33 | TS-1550041 | Flat Washer | M6 x Ø19 | 1 |

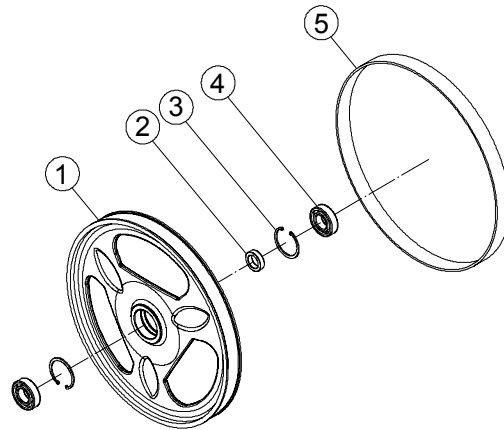
13.4.1 JWBS-15 Guide Bar Bracket Assembly – Exploded View



13.4.2 JWBS-15 Guide Bar Bracket Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---|----------|-----|
| | JWBS15-1120 | Guide Bar Bracket Assembly (#1 thru 25) | | 1 |
| 1 | JWBS15-1120-401 | Guide Bar | | 1 |
| 2 | TS-1503021 | Socket Head Cap Screw | M6x10 | 2 |
| 3 | TS-1532032 | Pan Head Screw | M4x10 | 2 |
| 4 | TS-1540021 | Nut | M4 | 2 |
| 5 | PM1500-091-08 | Guide Bar Rack (Short) | | 1 |
| 6 | TS-2284081 | Phillips Flat Head Machine Screw | M4x8 | 5 |
| 7 | PM1500-091-20 | Guide Bar Rack (Long) | | 1 |
| 8 | TS-2361081 | Spring Washer | M8 | 4 |
| 9 | TS-1504031 | Socket Head Cap Screw | M8x16 | 4 |
| 10 | PM1500-091-04 | Cover | | 1 |
| 11 | TS-1534041 | Pan Head Screw | M5x10 | 2 |
| 12 | PM1500-091-09 | Cover | | 1 |
| 13 | TS-1540031 | Hex Nut | M5 | 2 |
| 14 | PM1500-091-10 | Fixed Pin | | 1 |
| 15 | PM1500-091-11 | Gear | | 1 |
| 16 | PM1500-091-12 | Fixed Plate | | 1 |
| 17 | PM1500-091-13 | Worm Shaft | | 1 |
| 18 | JWBS15-1120-418 | Nut | | 1 |
| 19 | PM1500-091-15 | Guide Bracket | | 1 |
| 20 | PM1500-091-18 | Bushing | | 1 |
| 21 | PM1500-091-25 | Fiber Washer | | 2 |
| 22 | PM1500-091-19 | Collar | | 1 |
| 23 | TS-1522011 | Set Screw | M5x5 | 2 |
| 24 | JWBS15-1120-424 | Bushing Bearing | DU 10x12 | 2 |
| 25 | JWBS15-1120-425 | Plastic Nylon Set Screw | M7x10 | 4 |

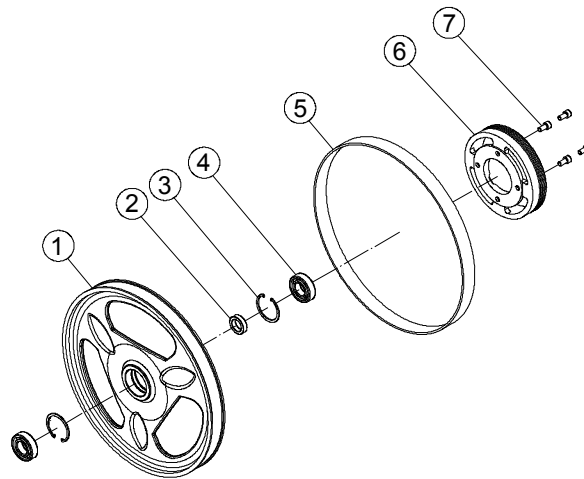
13.5.1 JWBS-15 Upper Wheel Assembly – Exploded View



13.5.2 JWBS-15 Upper Wheel Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|--------------------|---------------------------------------|---------------------|-----|
| | PM1500-019..... | Upper Wheel Assembly (#1 thru 5)..... | | |
| 1..... | PM1500-019-01..... | Upper Wheel..... | Dia. 15 inches..... | 1 |
| 2..... | PM1500-019-02..... | Spacer..... | | 1 |
| 3..... | JWBS20QT-504..... | Retaining Ring..... | R52..... | 2 |
| 4..... | BB-6205LLU..... | Ball Bearing..... | 6205LLU..... | 2 |
| 5..... | PM1500-019-05..... | Tire..... | | 1 |

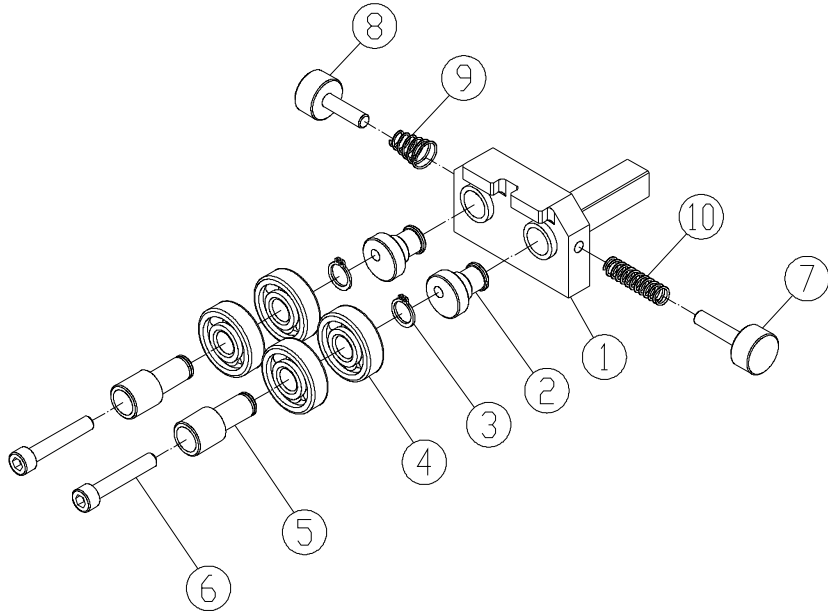
13.6.1 JWBS-15 Lower Wheel Assembly – Exploded View



13.6.2 JWBS-15 Lower Wheel Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|--------------------|---------------------------------------|---------------------|-----|
| | PM1500-020..... | Lower Wheel Assembly (#1 thru 7)..... | | |
| 1..... | PM1500-020-01..... | Lower Wheel..... | Dia. 15 inches..... | 1 |
| 2..... | PM1500-019-02..... | Spacer..... | | 1 |
| 3..... | JWBS20QT-504..... | Retaining Ring..... | R52..... | 2 |
| 4..... | BB-6205LLU..... | Ball Bearing..... | 6205LLU..... | 2 |
| 5..... | PM1500-019-05..... | Tire..... | | 1 |
| 6..... | PM1500-020-06..... | Drive Pulley..... | | 1 |
| 7..... | TS-1504031..... | Socket Head Cap Screw..... | M8x16..... | 4 |

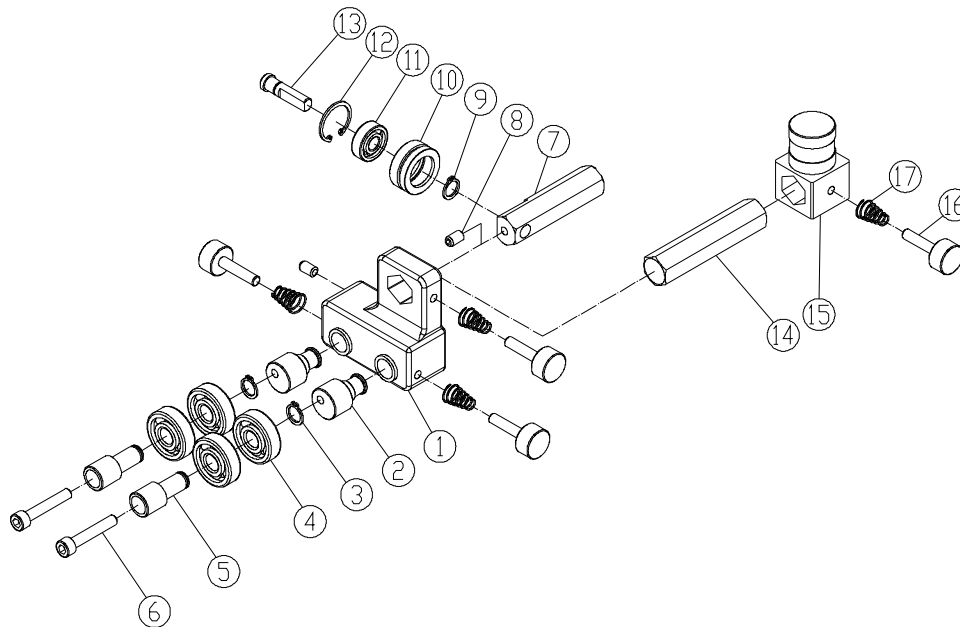
13.7.1 JWBS-15 Lower Blade Guide Assembly – Exploded View



13.7.2 JWBS-15 Lower Blade Guide Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---|--------|-----|
| | JWBS15-1137 | Lower Blade Guide Assembly (#1 thru 10) | | |
| 1 | PM1500-096-01 | Lower Blade Guide Support | | 1 |
| 2 | PM1500-096-02 | Eccentric Shaft | | 2 |
| 3 | 6286478 | E Ring | S12 | 2 |
| 4 | BB-6201ZZ | Ball Bearing | 6201ZZ | 4 |
| 5 | PM1500-095-05 | Knurled Knob | | 2 |
| 6 | TS-1503081 | Socket Head Cap Screw | M6x35 | 2 |
| 7 | PM1500-095-16 | Lock Knob | | 1 |
| 8 | JWBS15-1137-508 | Lock Knob | | 1 |
| 9 | PM1800B-059-017 | Cone Spring | | 1 |
| 10 | JWBS15-1138-332 | Spring | | 1 |

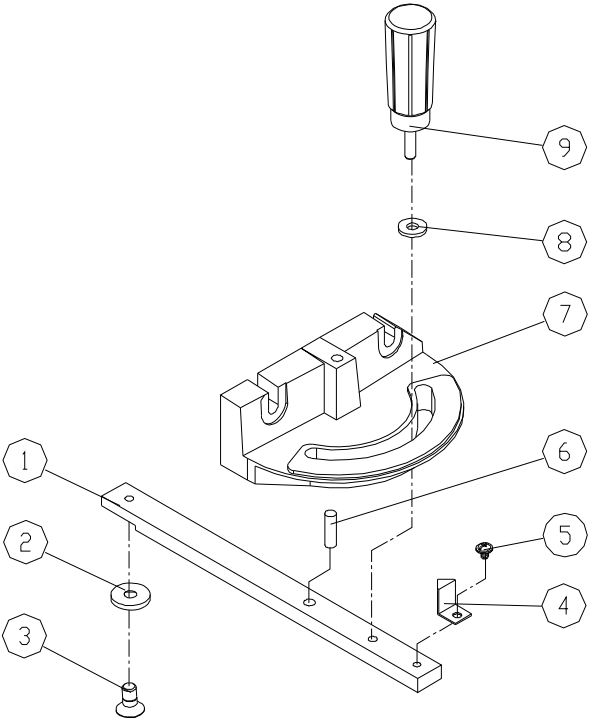
13.8.1 JWBS-15 Upper Blade Guide Assembly – Exploded View



13.8.2 JWBS-15 Upper Blade Guide Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---|--------|-------|
| | JWBS15-1121 | Upper Blade Guide Assembly (#1 thru 17) | | |
| 1 | PM1500-095-01 | Upper Blade Guide Support | | 1 |
| 2 | PM1500-095-02 | Eccentric Shaft | | 2 |
| 3 | 6286478 | Retaining Ring | S12 | 2 |
| 4 | BB-6201ZZ | Ball Bearing | 6201ZZ | 4 |
| 5 | PM1500-095-05 | Knurled Knob | | 2 |
| 6 | TS-1503081 | Socket Head Cap Screw | M6x35 | 2 |
| 7 | PM1500-095-07 | Sleeve | | 1 |
| 8 | TS-1523011 | Set Screw | M6x6 | 2 |
| 9 | PM1500-085-29 | S Ring | S8 | 1 |
| 10 | PM1500-085-28 | Thrust Bearing Holder | | 1 |
| 11 | BB-608ZZ | Ball Bearing | 608ZZ | 1 |
| 12 | PM1500-085-26 | Retaining Ring | R22 | 1 |
| 13 | PM1500-085-25 | Adjust Shaft | | 1 |
| 14 | PM1500-095-14 | Hex Post | | 1 |
| 15 | PM1500-095-15 | Upper Guide Support Block | | 1 |
| 16 | PM1500-095-16 | Lock Knob | | 1 |
| 17 | PM1800B-059-017 | Cone Spring | | 4 |

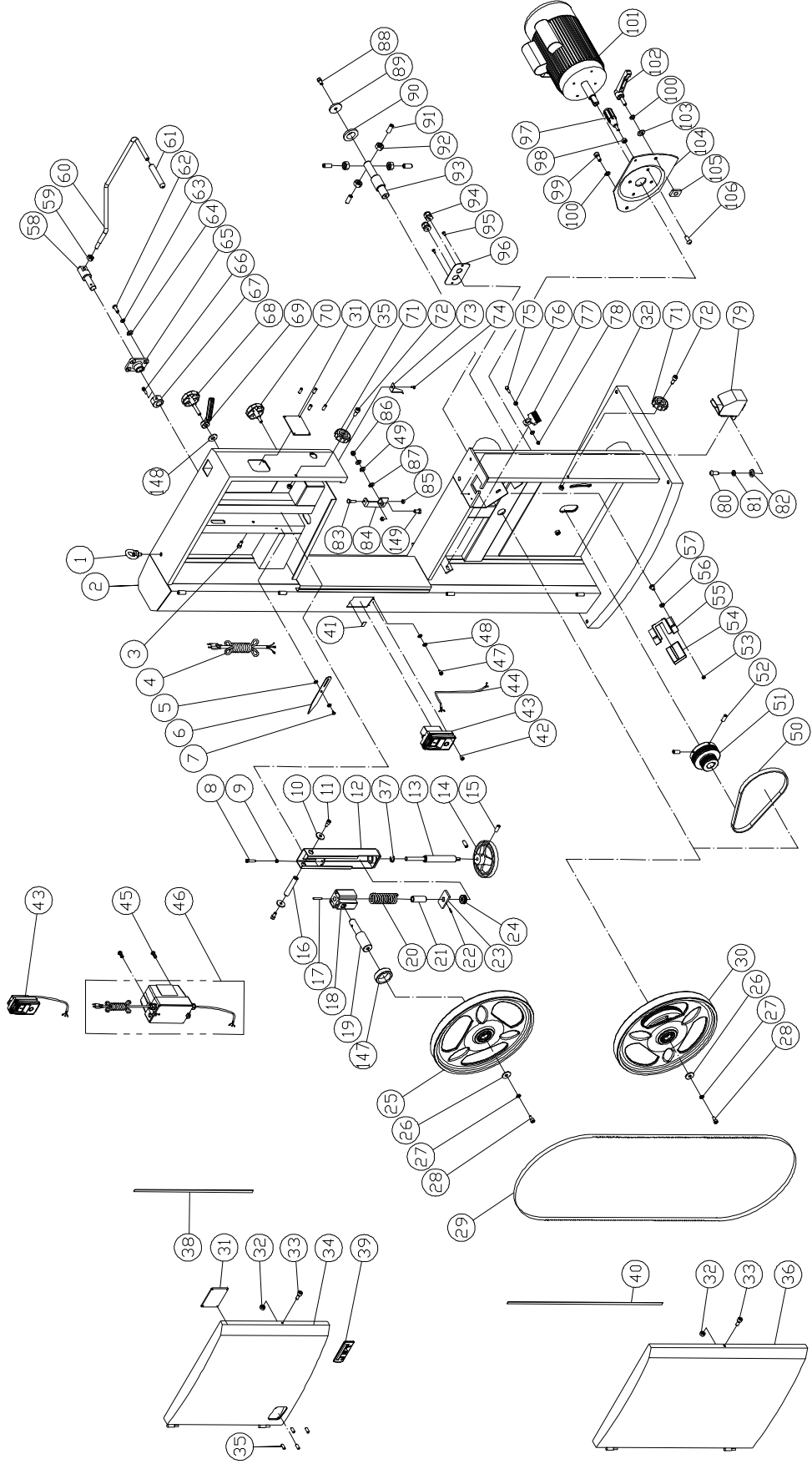
13.9.1 JWBS-15/18/20 Miter Gauge Assembly – Exploded View

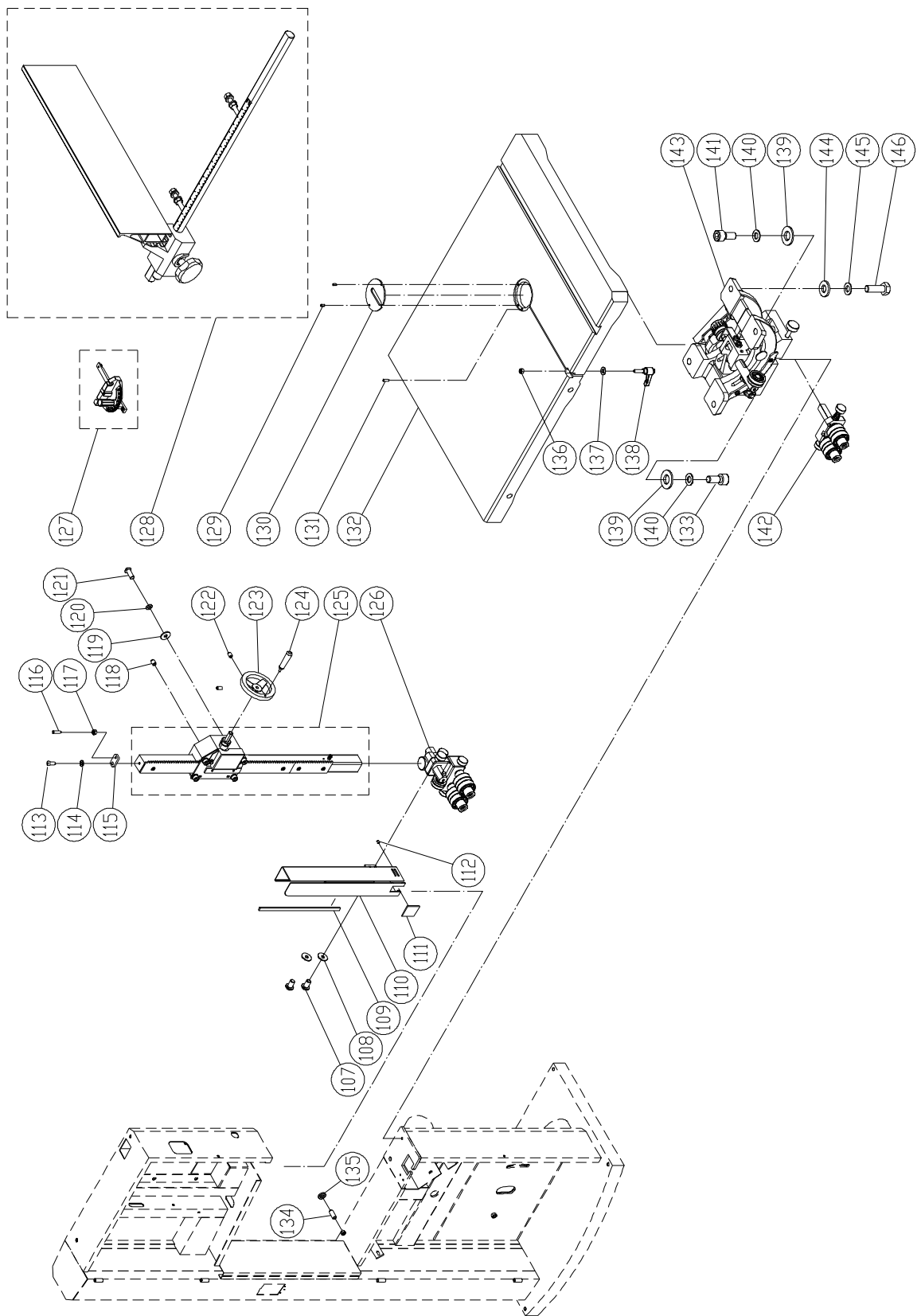


13.9.2 JWBS-15/18/20 Miter Gauge Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|----------------------------------|---------|-------|
| | JWBS15-1122 | Miter Gauge Assembly (#1 thru 9) | | |
| 1 | JWBS15-1122-701 | Guide Bar | | 1 |
| 2 | JWBS15-1122-702 | Guide Piece | | 1 |
| 3 | JWBS15-1122-703 | Countersunk Bolt | M6x6 | 1 |
| 4 | JWBS15-1122-704 | Pointer | | 1 |
| 5 | PWBS14-251-5 | Pan Head Flanged Screw | M5x8 | 1 |
| 6 | JWBS15-1122-706 | Steel Pin | Ø6x10mm | 1 |
| 7 | JWBS15-1122-707 | Miter Gauge Body | | 1 |
| 8 | JWBS15-1122-708 | Nylon Washer | | 1 |
| 9 | JWBS15-1122-709 | Handle | | 1 |

13.10.1 JWBS-18 Bandsaw Assembly – Exploded View





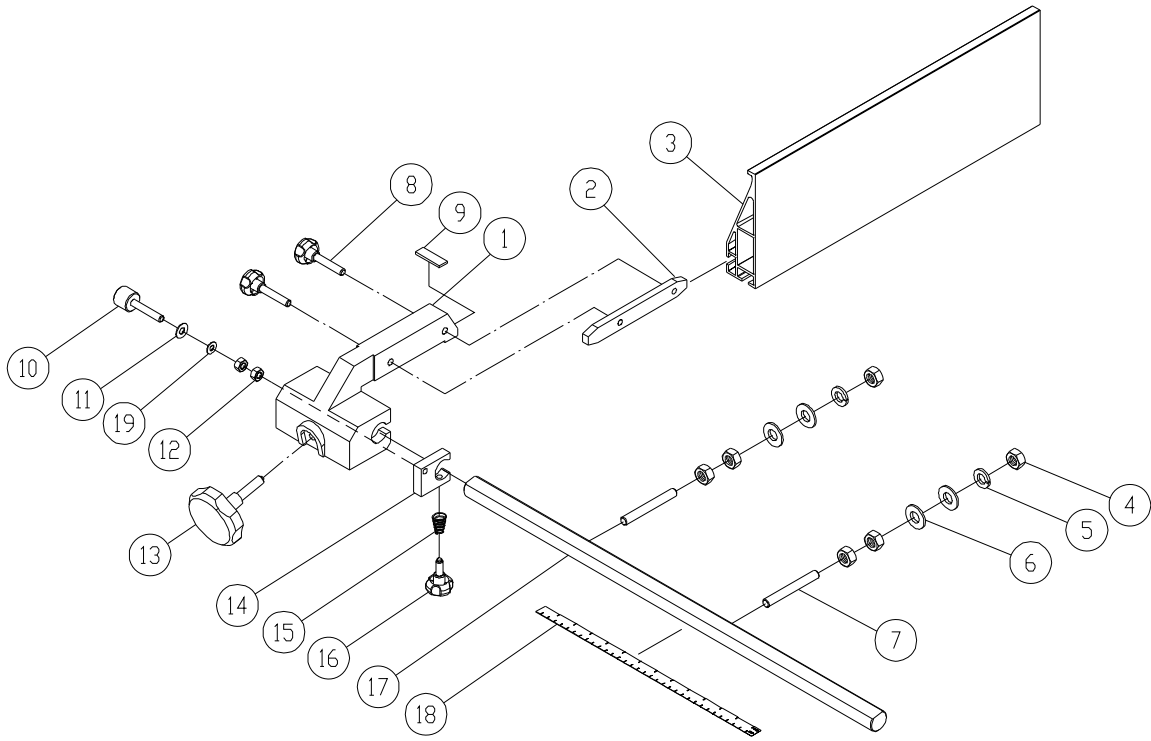
13.10.2 JWBS-18 Bandsaw Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|--|---------------------------------|-----|
| 1 | PM1500-004 | Lifting Ring | M10 | 1 |
| 2 | JWBS18B-102 | Machine Main Body Frame | | 1 |
| 3 | TS-1482021 | Hex Cap Bolt | M6x12 | 1 |
| 4 | JWBS15-104 | Power Cord | 1-3/4HP | 1 |
| | JWBS15-104B | Power Cord | 3HP | 1 |
| 5 | TS-1550041 | Flat Washer | M6 | 2 |
| 6 | JWBS18B-106 | Tension Pointer | | 1 |
| 7 | PM1500-012 | Step Screw | | 1 |
| 8 | TS-1503111 | Socket Head Cap Screw | M6x50 | 1 |
| 9 | TS-2311061 | Hex Nut | M6 | 1 |
| 10 | TS-1550061 | Flat Washer | M8 | 2 |
| 11 | TS-1504031 | Socket Head Cap Screw | M8x16 | 2 |
| 12 | JWBS15-112 | Upper Wheel Sliding Bracket | | 1 |
| 13 | JWBS18B-113 | Adjusting Bolt | | 1 |
| 14 | JWBS15-114 | Handwheel | 6" | 1 |
| 15 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 16 | JWBS15-116 | Upper Shaft | | 1 |
| 17 | JWBS15-117 | Spring Pin | Ø5x36mm | 1 |
| 18 | JWBS15-118 | Upper Wheel Sliding Bracket | | 1 |
| 19 | JWBS18B-119 | Upper Wheel Shaft | | 1 |
| 20 | JWBS15-120 | Spring | | 1 |
| 21 | PM1500-010-02 | Bushing | | 1 |
| 22 | JWBS15-122 | Pin | Ø 3x20mm | 1 |
| 23 | JWBS15-123 | Locate Block | | 1 |
| 24 | BB-51201 | Bearing | 51201 | 1 |
| 25 | PM1800B-018 | Upper Wheel Assembly | Ø18" | 1 |
| 26 | PM1800B-017 | Washer | | 2 |
| 27 | TS-2361081 | Spring Washer | M8 | 2 |
| 28 | TS-1504041 | Socket Head Cap Bolt | M8x20 | 2 |
| 29 | JWBS18B-129 | Saw Blade | 150"L x 3/4" x 0.026" T x 6 TPI | 1 |
| 30 | JWBS18B-130 | Lower Wheel Assembly | Ø18" | 1 |
| 31 | PM1500-050 | Viewing Window | | 2 |
| 32 | TS-1541021 | Nylon Nut | M6 | 4 |
| 33 | TS-1503021 | Socket Head Cap Screw | M6x10 | 2 |
| 34 | JWBS18B-134 | Upper Door | | 1 |
| 35 | JWBS15-135 | Socket Head Cap Screw | M4x8 | 8 |
| 36 | JWBS18B-136 | Lower Door | | 1 |
| 37 | PM1800B-027-026 | Retaining Ring (E) | E15 | 1 |
| 38 | JWBS15-138 | Sponge | | 1 |
| 39 | JET-138-R2000 | Jet Logo | 138x57mm | 1 |
| 40 | JWBS15-140 | Sponge | 760x10x1T mm | 1 |
| 41 | JWBS15-141 | Sponge | 16x5x2T mm | 1 |
| 42 | TS-1532032 | Pan Head Screw | M4x10 | 1 |
| 43 | JOSS-S-213 | On/Off Switch Assembly | 1-3/4HP | 1 |
| | JOSS-S-213SK | Safety Key for JOSS-S-213 (not shown) | | 1 |
| | JWBS15-143B | Control Switch Assembly | 3HP | 1 |
| | JWBS15-143BSK | Safety Key for JWBS15-143B (not shown) | | 1 |
| 44 | JWBS15-144 | Motor Cord | 14AWGx3C | 1 |
| 45 | TS-1533052 | Pan Head Screw | M5x16 | 2 |
| 46 | JWBS15-146 | Magnetic Switch Assembly | 3HP only | 1 |
| | JWBS15-146CS | Contact Switch | | 1 |
| | JWBS15-146OP | Overload Protector | | 1 |
| 47 | TS-1533032 | Pan Head Screw | M5x10 | 2 |
| 48 | TS-0733041 | Ext. Tooth Lock Washer | M5 | 4 |
| 49 | PM1800B-159 | Special Washer | 16x8.2x0.4T | 2 |
| 50 | JWBS18B-150 | Poly-V Belt | 430J10 | 1 |
| 51 | JWBS18B-151 | Motor Pulley | | 1 |
| 52 | TS-1523041 | Set Screw | M6x12 | 2 |
| 53 | TS-2311061 | Hex Nut | M6 | 2 |
| 54 | JWBS18DX-249 | Dust Collect Insert | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------------|-----------------------------------|----------------|-----|
| 55 | JWBS15-155 | Fixed Plate | | 1 |
| 56 | TS-2361061 | Spring Washer | M6 | 2 |
| 57 | TS-2246122 | Socket Head Button Screw | M6x12 | 2 |
| 58 | PM1500-074 | Tension Quick Release Lever Shaft | | 1 |
| 59 | TS-1540083 | Hex Nut | M12 | 1 |
| 60 | JWBS18B-160 | Tension Quick Release Lever | | 1 |
| 61 | JWBS15-161 | Grip | | 1 |
| 62 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 63 | TS-2361081 | Spring Washer | M8 | 4 |
| 64 | TS-1550061 | Flat Washer | M8xØ18 | 4 |
| 65 | PM1500-070 | Shaft Fixed Block | | 1 |
| 66 | TS-1503061 | Socket Head Cap Screw | M6x25 | 1 |
| 67 | PM1500-069 | Cam | | 1 |
| 68 | JWBS15-168 | Lock Knob | M10x53 | 1 |
| 69 | PM1500-068 | Lock Handle | M10 | 1 |
| 70 | JWBS15-170 | Lock Knob | M10x25 | 1 |
| 71 | 135041 | Knob | | 2 |
| 72 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 73 | JWBS15-173 | Pointer | | 1 |
| 74 | 6286494 | Pan Head Screw | M5x6 | 1 |
| 75 | TS-1482051 | Hex Cap Screw | M6x25 | 1 |
| 76 | TS-1550041 | Flat Washer | M6 | 2 |
| 77 | PM1500-058 | Brush | | 1 |
| 78 | TS-1541021 | Hex Nylon Lock Nut | M6 | 1 |
| 79 | JWBS18B-179 | Lower Blade Guard | | 1 |
| 80 | TS-2246082 | Socket Head Button Screw | M6x8 | 2 |
| 81 | TS-2361061 | Lock Washer | M6 | 2 |
| 82 | TS-1550041 | Flat Washer | M6 | 2 |
| 83 | TS-1490071 | Hex Cap Screw | M8x40 | 1 |
| 84 | JWBS15-184 | Support Plate | | 1 |
| 85 | TS-1541031 | Hex Nut | M8 | 2 |
| 86 | TS-1541031 | Nylon Nut | M8 | 1 |
| 87 | TS-1550061 | Flat Washer | M8 | 2 |
| 88 | TS-1504041 | Socket Head Cap Screw | M8x20 | 1 |
| 89 | PM1800B-088 | Washer | | 1 |
| 90 | PM1800B-087 | Plate | | 1 |
| 91 | TS-2279301 | Set Screw | M10x30 | 4 |
| 92 | TS-1541041 | Hex Nut | M10 | 4 |
| 93 | PM1800B-084 | Lower Wheel Shaft | | 1 |
| 94 | PM1500-062 | Strain Relief | PG13.5 | 2 |
| 95 | PM1500-039 | Tapping Screw | M4x8 | 2 |
| 96 | PM1500-083 | Strain Relief Fixed Plate | 1-3/4 HP | 1 |
| | JWBS15-196A | Strain Relief Fixed Plate | 3HP | 1 |
| 97 | JWBS15-197 | Handle | | 1 |
| 98 | TS-1540061 | Hex Nut | M8 | 1 |
| 99 | TS-149105 | Hex Cap Screw | M10x35 | 1 |
| 100 | TS-2361101 | Spring Washer | M10 | 2 |
| 101 | JWBS18B-1101 | Motor | 1-3/4HP | 1 |
| | JWBS18B-1101FM | Motor Fan (not shown) | | 1 |
| | JWBS18B-1101FMC | Motor Fan Cover (not shown) | | 1 |
| | JWBS18B-1101SC | Start Capacitor (not shown) | 300MFD, 250VAC | 1 |
| | JWBS18B-1101RC | Running Capacitor (not shown) | 40µF, 250VAC | 1 |
| | JWBS18B-1101JB | Junction Box (not shown) | | 1 |
| | JWBS18B-1101JBC | Junction Box Cover (not shown) | | 1 |
| | JWBS18B-1101CS | Centrifugal Switch (not shown) | | 1 |
| | JWBS18B-1101A | Motor | 3HP/230V | 1 |
| | JWBS18B-1101AMF | Motor Fan (not shown) | | 1 |
| | JWBS18B-1101AMFC | Motor Fan Cover (not shown) | | 1 |
| | JWBS18B-1101ASC | Start Capacitor (not shown) | 300MFD, 250VAC | 1 |
| | JWBS18B-1101ARC | Running Capacitor (not shown) | 60µF, 300VAC | 1 |
| | JWBS18B-1101AJB | Junction Box (not shown) | | 1 |
| | JWBS18B-1101AJBC | Junction Box Cover (not shown) | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|-----------------------------------|---------|-----|
| | JWBS18B-1101ACS | Centrifugal Switch (not shown) | | 1 |
| 102 | PM1500-015 | Motor Bracket Lock Handle | M10x33 | 1 |
| 103 | TS-1550071 | Flat Washer | M10 | 1 |
| 104 | JWBS15-1104 | Motor Bracket | | 1 |
| 105 | PM1500-038 | Locating Block | | 1 |
| 106 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 107 | TS-1482031 | Hex Cap Screw | M6x16 | 2 |
| 108 | TS-1550071 | Flat Washer | M6 | 2 |
| 109 | JWBS15-1109 | Magnet | 7x340mm | 1 |
| 110 | JWBS18B-1110 | Blade Guard Cover | | 1 |
| 111 | PM1800B-093 | Viewing Window | | 1 |
| 112 | TS-1521011 | Set Screw | M4x4 | 2 |
| 113 | TS-2246122 | Socket Head Button Screw | M6x12 | 1 |
| 114 | TS-2361061 | Spring Washer | M6 | 1 |
| 115 | PM1800B-163 | Locate Plate | | 1 |
| 116 | F010432 | Set Screw | M6x35 | 1 |
| 117 | TS-1540041 | Hex Nut | M6 | 1 |
| 118 | 5302731 | Set Screw | M8x6 | 4 |
| 119 | TS-1550061 | Flat Washer | M8 | 4 |
| 120 | TS-2361081 | Spring Washer | M8 | 4 |
| 121 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 122 | TS-1523041 | Set Screw | M6x12 | 2 |
| 123 | JWBS15-1118 | Handwheel | 5" | 1 |
| 124 | JWBS15-1119 | Handle | M8 | 1 |
| 125 | JWBS18B-1125 | Guide Bar Bracket Assembly | | 1 |
| 126 | JWBS18B-1126 | Upper Blade Guide Assembly | | 1 |
| 127 | JWBS15-1122 | Miter Gauge Assembly | | 1 |
| 128 | JWBS18B-1128 | Rip Fence Assembly | | 1 |
| 129 | F012085 | Roll Pin | Ø4x8 mm | 2 |
| 130 | JWBS15-1125 | Table Insert | | 1 |
| 131 | TS-1522011 | Set Screw | M5x5 | 3 |
| 132 | JWBS18B-1132 | Table | | 1 |
| 133 | TS-149105 | Hex Cap Screw | M10x35 | 1 |
| 134 | 7015-48 | Set Screw | M8x30 | 1 |
| 135 | TS-1541031 | Hex Nylon Lock Nut | M8 | 1 |
| 136 | TS-1540061 | Hex Nut | M8 | 1 |
| 137 | TS-1550061 | Flat Washer | M8 | 1 |
| 138 | JWBS18B-1138 | Handle | M8x35 | 1 |
| 139 | TS-1550071 | Flat Washer | M10 | 2 |
| 140 | TS-2361101 | Spring Washer | M10 | 2 |
| 141 | TS-1505051 | Socket Head Cap Screw | M10x35 | 1 |
| 142 | JWBS18B-1142 | Lower Blade Guide Assembly | | 1 |
| 143 | JWBS15-1138 | Trunnion Support Bracket Assembly | | 1 |
| 144 | TS-1550061 | Flat Washer | M8 | 4 |
| 145 | TS-2361081 | Spring Washer | M8 | 4 |
| 146 | TS-1490041 | Hex Cap Screw | M8x25 | 4 |
| 147 | JWBS18B-1147 | Bushing | | 1 |
| 148 | TS-1550071 | Flat Washer | M10 | 1 |
| 149 | TS-1490021 | Hex Cap Screw | M8x16 | 1 |

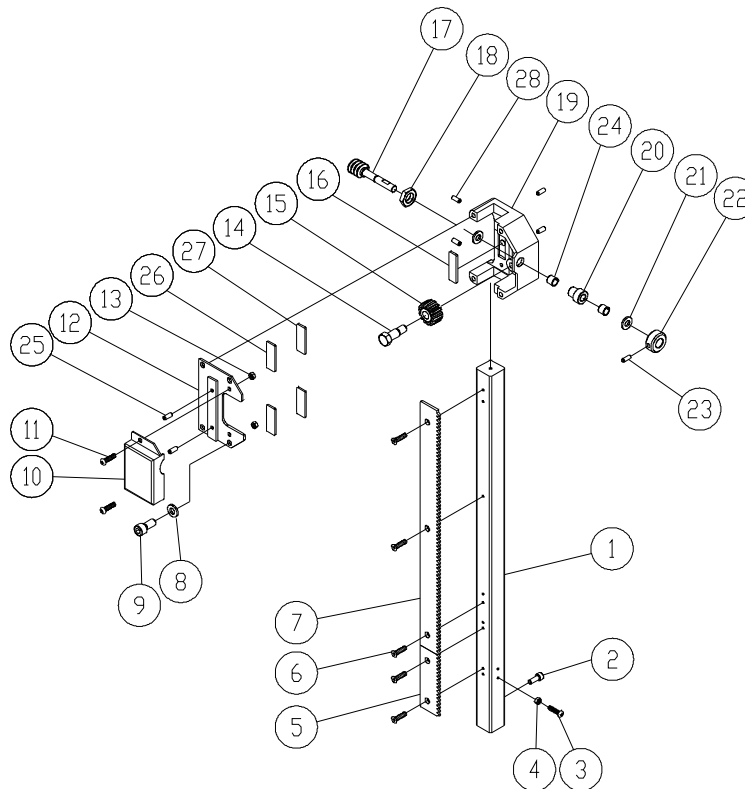
13.11.1 JWBS-18/20 Rip Fence Assembly – Exploded View



13.11.2 JWBS-18/20 Rip Fence Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------------|---------------------------------|----------|-----|
| | JWBS18B-1128 | Rip Fence Assembly (#1 thru 18) | | 1 |
| 1 | JWBS15-1123-201 | Fence Body | | 1 |
| 2 | JWBS15-1123-202 | Lock Block | | 1 |
| 3 | JWBS18B-1128-203 | Aluminum Fence | 572mm | 1 |
| 4 | TS-2311101 | Nut | M10 | 6 |
| 5 | TS-2361101 | Spring Washer | M10 | 2 |
| 6 | TS-1550071 | Flat Washer | M10 | 4 |
| 7 | JWBS15-1123-207 | Set Screw | M10x80 | 2 |
| 8 | JWBS15-1123-208 | Knob | M8x40 | 2 |
| 9 | PM1500-107-10 | Nylon Pad | | 1 |
| 10 | JWBS15-1123-210 | Adjustment Knob | M8x50 | 1 |
| 11 | JWBS15-1123-211 | Fiber Washer | | 1 |
| 12 | TS-1540061 | Nut | M8 | 2 |
| 13 | JWBS15-1123-213 | Knob | M8x40 | 1 |
| 14 | JWBS15-1123-214 | Locate Block | | 1 |
| 15 | PM1800B-059-017 | Cone Spring | | 1 |
| 16 | JWBS15-1123-216 | Knob | M6x14 | 1 |
| 17 | JWBS18B-1128-217 | Fence Guide Rail | | 1 |
| 18 | JWBS18B-1128-218 | Scale | | 1 |
| 19 | JWBS15-1123-219 | Wave Washer | Ø8x13 mm | 1 |

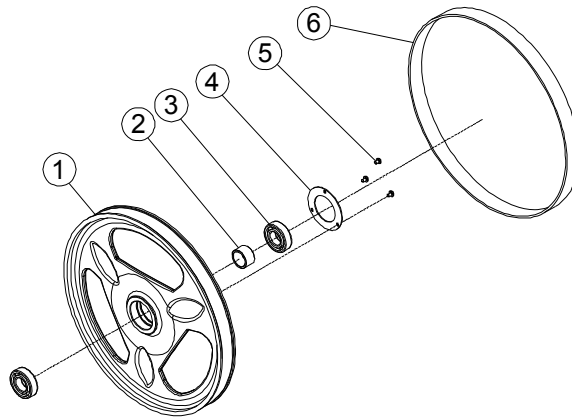
13.12.1 JWBS-18/20 Guide Bar Bracket Assembly – Exploded View



13.12.2 JWBS-18/20 Guide Bar Bracket Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|------------------|---|----------|-----|
| | JWBS18B-1125 | Guide Bar Bracket Assembly (#1 thru 28) | | |
| 1 | JWBS18B-1125-401 | Guide Bar | | 1 |
| 2 | TS-1503021 | Socket Head Cap Screw | M6x10 | 2 |
| 3 | TS-1532032 | Pan Head Screw | M4x10 | 1 |
| 4 | TS-1540021 | Nut | M4 | 1 |
| 5 | PM1500-091-08 | Guide Bar Rack (Short) | | 1 |
| 6 | TS-2284081 | Phillips Flat Head Machine Screw | M4x8 | 5 |
| 7 | PM1500-091-20 | Guide Bar Rack (Long) | | 1 |
| 8 | TS-2361081 | Spring Washer | M8 | 4 |
| 9 | TS-1504031 | Socket Head Cap Screw | M8x16 | 4 |
| 10 | PM1500-091-04 | Cover | | 1 |
| 11 | TS-1534041 | Pan Head Screw | M5x10 | 2 |
| 12 | JWBS18B-1125-412 | Cover | | 1 |
| 13 | TS-1540031 | Hex Nut | M5 | 2 |
| 14 | PM1500-091-10 | Fixed Screw | | 1 |
| 15 | PM1500-091-11 | Gear | | 1 |
| 16 | PM1500-091-12 | Fixed Plate | | 1 |
| 17 | PM1500-091-13 | Worm Shaft | | 1 |
| 18 | JWBS15-1120-418 | Nut | | 1 |
| 19 | PM1500-091-15 | Guide Bracket | | 1 |
| 20 | PM1500-091-18 | Bushing | | 1 |
| 21 | PM1500-091-25 | Fiber Washer | | 2 |
| 22 | PM1500-091-19 | Collar | | 1 |
| 23 | TS-1522011 | Set Screw | M5x5 | 2 |
| 24 | JWBS15-1120-424 | Bushing Bearing | DU 10x12 | 2 |
| 25 | TS-1523011 | Set Screw | M6x6 | 2 |
| 26 | JWBS18B-1125-426 | Plate | | 2 |
| 27 | JWBS18B-1125-427 | Nylon Piece | | 2 |
| 28 | JWBS15-1120-425 | Plastic Nylon Set Screw | M7x10 | 4 |

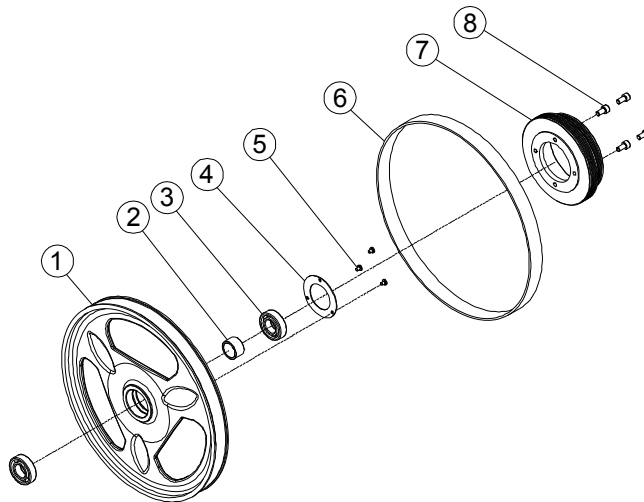
13.13.1 JWBS-18 Upper Wheel Assembly – Exploded View



13.13.2 JWBS-18 Upper Wheel Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|----------------|----------------------------------|---------|-------|
| | PM1800B-018 | Upper Wheel Assembly (#1 thru 6) | | |
| 1 | PM1800B-018-01 | Upper Wheel | | 1 |
| 2 | PM1800B-018-02 | Spacer | | 1 |
| 3 | BB-6306LLU | Ball Bearing | 6306LLU | 2 |
| 4 | PM1800B-018-04 | Bearing Press Plate | | 1 |
| 5 | PM1800B-018-05 | Phillips Pan Head Machine Screw | M6 x 8 | 3 |
| 6 | PM1800B-018-06 | Tire | | 1 |

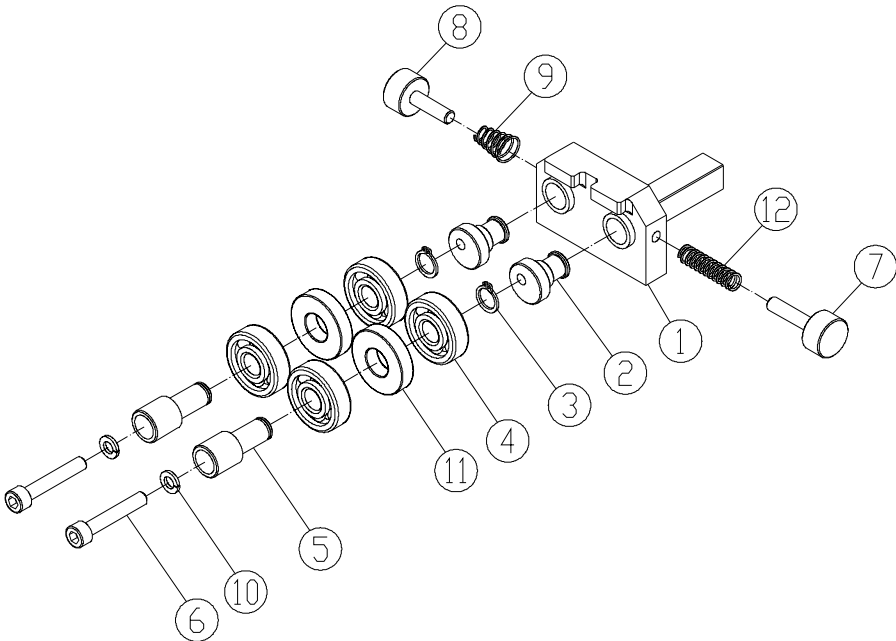
13.14.1 JWBS-18 Lower Wheel Assembly – Exploded View



13.14.2 JWBS-18 Lower Wheel Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|----------------------------------|---------|-------|
| | JWBS18B-130 | Lower Wheel Assembly (#1 thru 8) | | |
| 1 | PM1800B-022-01 | Lower Wheel | 18" | 1 |
| 2 | PM1800B-018-02 | Bushing | | 1 |
| 3 | BB-6306LLU | Ball Bearing | 6306LLU | 2 |
| 4 | PM1800B-018-04 | Bearing Press Plate | | 1 |
| 5 | PM1800B-018-05 | Pan Head Bolt | M6x8 | 3 |
| 6 | PM1800B-018-06 | Tire | PU | 1 |
| 7 | JWBS18B-130-807 | Pulley | | 1 |
| 8 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 4 |

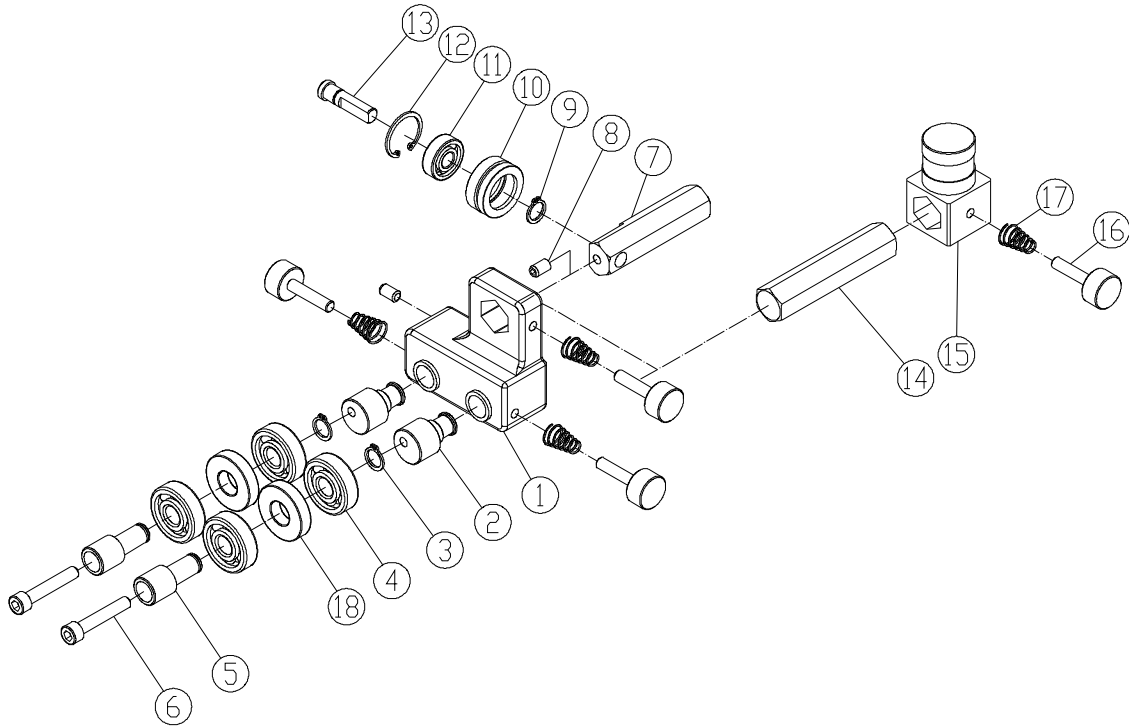
13.15.1 JWBS-18/20 Lower Blade Guide Assembly – Exploded View



13.15.2 JWBS-18/20 Lower Blade Guide Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---|--------|-----|
| | JWBS18B-1142 | Lower Blade Guide Assembly (#1 thru 12) | | |
| 1 | PM1500-096-01 | Lower Blade Guide Support | | 1 |
| 2 | PM1500-096-02 | Eccentric Shaft | | 2 |
| 3 | PM1800B-059-05 | Retaining Ring | S15 | 2 |
| 4 | BB-6202ZZ | Ball Bearing | 6202ZZ | 4 |
| 5 | PM1800B-059-02 | Knurled Adjusting Knob | | 2 |
| 6 | TS-1503101 | Socket Head Cap Screw | M6x45 | 2 |
| 7 | PM1500-095-16 | Lock Knob | | 1 |
| 8 | JWBS15-1137-508 | Lock Knob | | 1 |
| 9 | PM1800B-059-017 | Cone Spring | | 1 |
| 10 | TS-2361061 | Spring Washer | M6 | 2 |
| 11 | PM1800B-059-04 | Spacer | | 2 |
| 12 | JWBS15-1138-332 | Spring | | 1 |

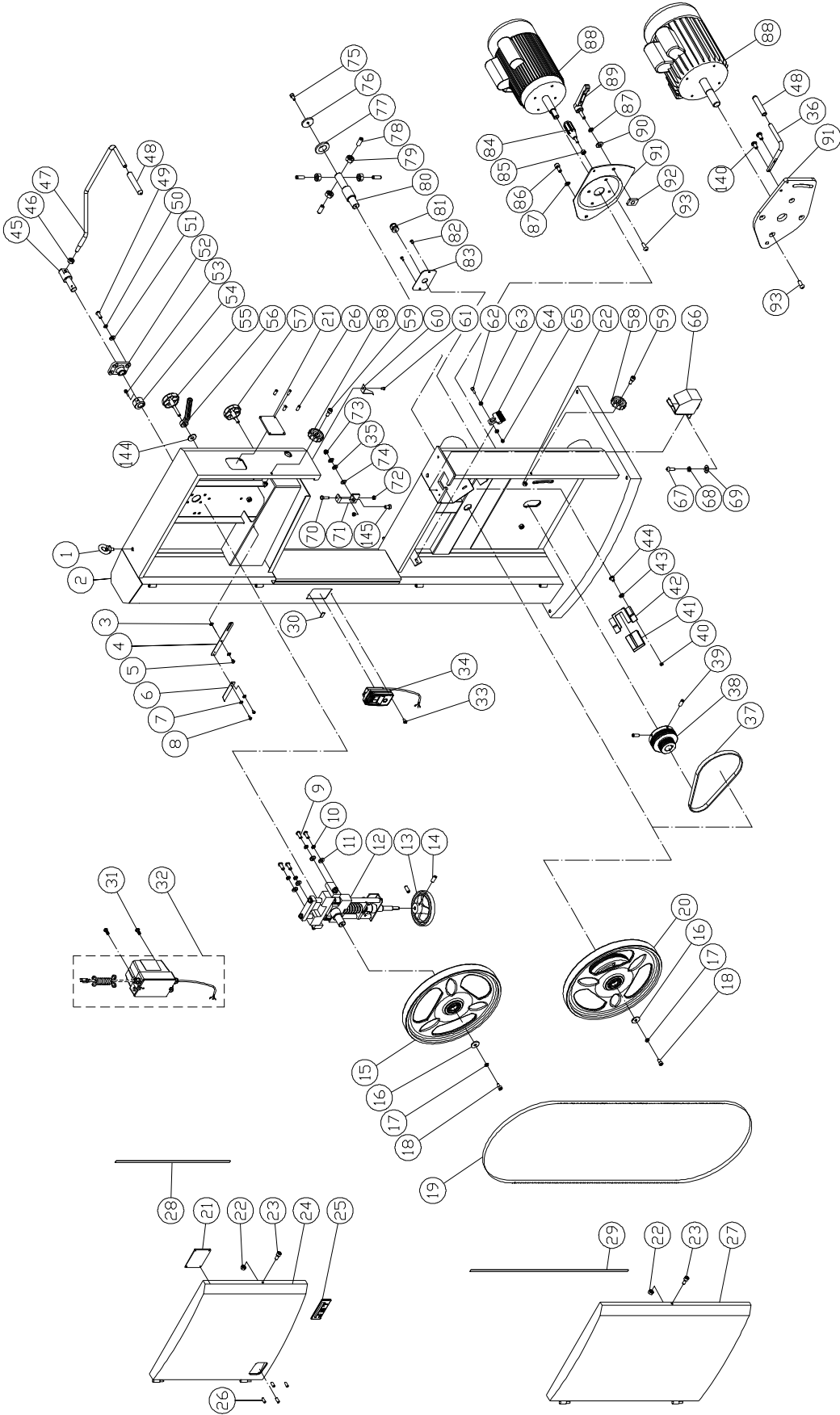
13.16.1 JWBS-18/20 Upper Blade Guide Assembly – Exploded View

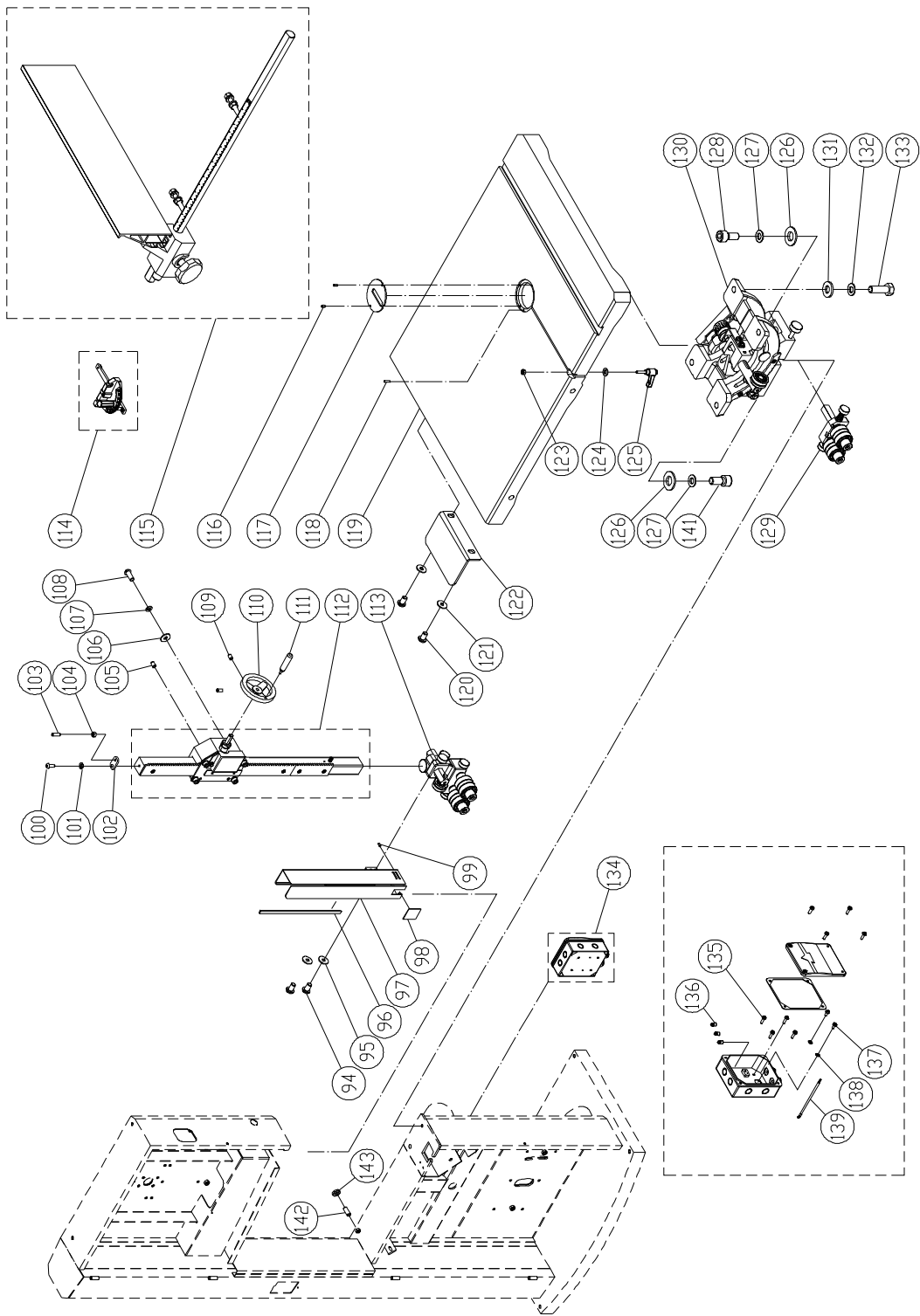


13.16.2 JWBS-18/20 Upper Blade Guide Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---|--------|-----|
| | JWBS18B-1126 | Upper Blade Guide Assembly (#1 thru 18) | | |
| 1 | PM1500-095-01 | Upper Blade Guide Support | | 1 |
| 2 | PM1500-095-02 | Eccentric Shaft | | 2 |
| 3 | PM1800B-059-05 | Retaining Ring | S15 | 2 |
| 4 | BB-6202ZZ | Ball Bearing | 6202ZZ | 4 |
| 5 | PM1800B-059-02 | Knurled Knob | | 2 |
| 6 | TS-1503101 | Socket Head Cap Screw | M6x45 | 2 |
| 7 | PM1500-095-07 | Spacing Sleeve | | 1 |
| 8 | TS-1523011 | Set Screw | M6x6 | 2 |
| 9 | PM1500-085-29 | Retaining Ring | S8 | 1 |
| 10 | PM1500-085-28 | Thrust Bearing Holder | | 1 |
| 11 | JWBS15-1121-611 | Ball Bearing | 608ZZ | 1 |
| 12 | PM1500-085-26 | Retaining Ring | R22 | 1 |
| 13 | PM1500-085-25 | Adjust Shaft | | 1 |
| 14 | PM1500-095-14 | Hex Post | | 1 |
| 15 | PM1500-095-15 | Upper Guide Support Block | | 1 |
| 16 | PM1500-095-16 | Lock Knob | | 1 |
| 17 | PM1800B-059-017 | Cone Spring | | 4 |
| 18 | PM1800B-059-04 | Spacer | | 2 |

13.17.1 JWBS-20 Bandsaw Assembly – Exploded View





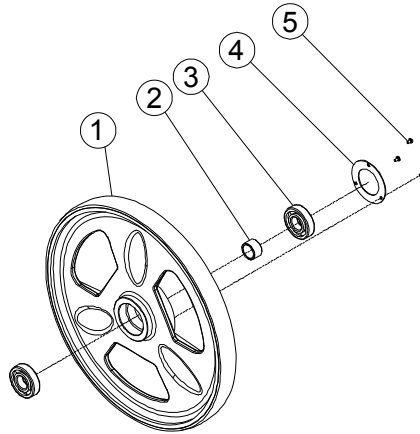
13.17.2 JWBS-20 Bandsaw Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|----------------|--|--------------------------------|-----|
| 1 | PM1500-004 | Lifting Ring | M10 | 1 |
| 2 | JWBS20B-102 | Machine Main Body Frame | | 1 |
| 3 | TS-1550041 | Flat Washer | M6xØ13 | 2 |
| 4 | JWBS18B-106 | Tension Pointer | | 1 |
| 5 | PM1500-012 | Step Screw | | 1 |
| 6 | PM2013B-169 | Tension Scale Indicator | | 1 |
| 7 | TS-1550021 | Flat Washer | M4 | 2 |
| 8 | F001171 | Pan Head Screw | M4x5 | 2 |
| 9 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 10 | TS-2361081 | Spring Washer | M8 | 4 |
| 11 | TS-1550061 | Flat Washer | M8 | 4 |
| 12 | JWBS20B-112 | Upper Wheel Sliding Bracket Assembly | | 1 |
| 13 | JWBS15-114 | Handle Wheel | 6" | 1 |
| 14 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 15 | PM2013B-018 | Upper Wheel Assembly | 20" | 1 |
| 16 | PM1800B-017 | Special Washer | | 2 |
| 17 | TS-2361081 | Spring Washer | M8 | 2 |
| 18 | TS-1504041 | Socket Head Cap Screw | M8x20 | 2 |
| 19 | JWBS20B-119 | Saw Blade | 158"Lx 1" W x 0.036" T x 3 TPI | 1 |
| 20 | JWBS20B-120 | Lower Wheel Assembly | Ø20" | 1 |
| 21 | PM1500-050 | Viewing Window | | 2 |
| 22 | TS-1541021 | Nylon Nut | M6 | 4 |
| 23 | TS-1503021 | Socket Head Cap Screw | M6x10 | 2 |
| 24 | JWBS20B-124 | Upper Door | | 1 |
| 25 | JET-138-R2000 | Jet Logo | 138x57mm | 1 |
| 26 | TS-1501021 | Socket Head Cap Screw | M4x8 | 8 |
| 27 | JWBS20B-127 | Lower Door | | 1 |
| 28 | JWBS20B-138 | Sponge | 585x10mm T=1 | 1 |
| 29 | JWBS15-140 | Sponge | 760x10mm T=1 | 1 |
| 30 | JWBS15-141 | Sponge | 16x5mm T=2 | 1 |
| 31 | TS-1533052 | Pan Head Screw | M5x16 | 2 |
| 32 | JWBS15-146 | Magnetic Switch Assembly | 3HP only | 1 |
| | JWBS15-146CS | Contact Switch (not shown) | | 1 |
| | JWBS15-146OP | Overload Protector (not shown) | | 1 |
| | JWBS20B-132A | Magnetic Switch Assembly | 5HP 230V | 1 |
| | JWBS20B-132ACS | Contact Switch (not shown) | | 1 |
| | JWBS20B-132AOP | Overload Protector (not shown) | | 1 |
| | JWBS15-104B | Power Cord | 3HP | 1 |
| 33 | TS-1532032 | Pan Head Screw | M4x10 | 1 |
| 34 | JWBS15-143B | Control Switch Assembly | 3HP/ 5HP | 1 |
| | JWBS15-143BSK | Safety Key for JWBS15-143B (not shown) | | 1 |
| 35 | PM1800B-159 | Special Washer | 16x8.2x0.4T | 2 |
| 36 | JWBS20B-136 | Motor Adjust Handle | | 1 |
| 37 | JWBS18B-150 | Poly-V Belt | 430J10 | 1 |
| 38 | JWBS20B-138MP | Motor Pulley | | 1 |
| 39 | TS-1523041 | Set Screw | M6x12 | 2 |
| 40 | TS-2311061 | Hex Nut | M6 | 2 |
| 41 | JWBS18DX-249 | Dust Collect Insert | | 1 |
| 42 | JWBS15-155 | Fixed Plate | | 1 |
| 43 | TS-2361061 | Spring Washer | M6 | 2 |
| 44 | TS-2246122 | Socket Head Button Screw | M6x12 | 2 |
| 45 | PM1500-074 | Tension Quick Release Lever Shaft | | 1 |
| 46 | TS-1540083 | Hex Nut | M12 | 1 |
| 47 | JWBS18B-160 | Tension Quick Release Lever | | 1 |
| 48 | JWBS15-161 | Grip | | 2 |
| 49 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 50 | TS-2361081 | Spring Washer | M8 | 4 |
| 51 | TS-1550061 | Flat Washer | M8xØ18 | 4 |
| 52 | PM1500-070 | Shaft Fixed Block | | 1 |
| 53 | TS-1503061 | Socket Head Cap Screw | M6x25 | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|--------------------------------|----------------|-----|
| 54 | PM1500-069 | Cam | | 1 |
| 55 | JWBS15-168 | Lock Knob | M10x53 | 1 |
| 56 | PM1500-068 | Lock Handle | M10 | 1 |
| 57 | JWBS15-170 | Lock Knob | M10x25 | 1 |
| 58 | 135041 | Knob | | 2 |
| 59 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 60 | JWBS15-173 | Pointer | | 1 |
| 61 | JWBS15-174 | Pan Head Screw | M5x6 | 1 |
| 62 | TS-1482051 | Hex Cap Screw | M6x25 | 1 |
| 63 | TS-1550041 | Flat Washer | M6 | 2 |
| 64 | PM1500-058 | Brush | | 1 |
| 65 | TS-1541021 | Nylon Nut | M6 | 1 |
| 66 | JWBS18B-179 | Lower Blade Guard | | 1 |
| 67 | TS-2246082 | Socket Head Button Screw | M6x8 | 2 |
| 68 | TS-2361061 | Lock Washer | M6 | 2 |
| 69 | TS-1550041 | Flat Washer | M6 | 2 |
| 70 | TS-1490071 | Hex Cap Screw | M8x40 | 1 |
| 71 | JWBS15-184 | Support Plate | | 1 |
| 72 | TS-2311081 | Hex Nut | M8 | 1 |
| 73 | TS-1541031 | Hex Nylon Lock Nut | M8 | 1 |
| 74 | TS-1550061 | Flat Washer | M8 | 2 |
| 75 | TS-1504041 | Socket Head Cap Screw | M8x20 | 1 |
| 76 | PM1800B-088 | Washer | | 1 |
| 77 | PM1800B-087 | Plate | | 1 |
| 78 | TS-2279301 | Set Screw | M10x30 | 4 |
| 79 | TS-1541041 | Hex Nut | M10 | 4 |
| 80 | PM1800B-084 | Lower Wheel Shaft | | 1 |
| 81 | PM1500-062 | Strain Relief | PG13.5 | 1 |
| 82 | PM1500-039 | Tapping Screw | M4x8 | 2 |
| 83 | JWBS15-196A | Strain Relief Fixed Plate | | 1 |
| 84 | JWBS15-197 | Handle | | 1 |
| 85 | TS-1540061 | Hex Nut | M8 | 1 |
| 86 | TS-149105 | Hex Cap Screw | M10x35 | 1 |
| 87 | TS-2361101 | Spring Washer | M10 | 2 |
| 88 | JWBS20B-188 | Motor | 3HP/230V | 1 |
| | JWBS18B-1101FM | Motor Fan (not shown) | | 1 |
| | JWBS18B-1101FMC | Motor Fan Cover (not shown) | | 1 |
| | JWBS18B-1101SC | Start Capacitor (not shown) | 300MFD, 250VAC | 1 |
| | JWBS18B-1101RC | Running Capacitor (not shown) | 60µF, 300VAC | 1 |
| | JWBS18B-1101JB | Junction Box (not shown) | | 1 |
| | JWBS18B-1101JBC | Junction Box Cover (not shown) | | 1 |
| | JWBS18B-1101CS | Centrifugal Switch (not shown) | | 1 |
| | JWBS20B-188A | Motor | 5HP/230V | 1 |
| | PM1800B-120MF | Motor Fan (not shown) | | 1 |
| | PM1800B-120MFC | Motor Fan Cover (not shown) | | 1 |
| | PM1800B-120SC | Starting Capacitor (not shown) | 300MFD, 250VAC | 1 |
| | PM1800B-120RC | Running Capacitor (not shown) | 45µf, 450VAC | 1 |
| | PM1800B-120CC | Capacitor Cover (not shown) | | 1 |
| | PM1800B-120JB | Junction Box (not shown) | | 1 |
| | PM1800B-120JBC | Junction Box Cover (not shown) | | 1 |
| | PM1800B-120CS | Centrifugal Switch (not shown) | | 1 |
| 89 | PM1500-015 | Motor Bracket Lock Handle | M10x33 | 1 |
| 90 | TS-1550071 | Flat Washer | M10 | 1 |
| 91 | JWBS15-1104 | Motor Bracket | | 1 |
| | JWBS20B-191A | Motor Bracket | 5HP | 1 |
| 92 | PM1500-038 | Locating Block | | 1 |
| 93 | TS-2248202 | Socket Head Button Screw (3HP) | M8x20 | 4 |
| | TS-1515031 | Socket Flat Head Screw (5HP) | M8x25 | 4 |
| 94 | TS-1482031 | Hex Cap Screw | M6x16 | 2 |
| 95 | TS-1550041 | Flat Washer | M6 | 2 |
| 96 | JWBS15-1109 | Magnet | 7x340mm | 1 |
| 97 | JWBS18B-1110 | Blade Guard Cover | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------|---------------------------------------|---------|-----|
| 98 | PM1800B-093 | Viewing Window | | 1 |
| 99 | TS-1521011 | Set Screw | M4x4 | 2 |
| 100 | TS-2246122 | Socket Head Button Screw | M6x12 | 1 |
| 101 | TS-2361061 | Spring Washer | M6 | 1 |
| 102 | PM1800B-163 | Locate Plate | | 1 |
| 103 | F010432 | Set Screw | M6x35 | 1 |
| 104 | TS-1540041 | Hex Nut | M6 | 1 |
| 105 | JWBS15-1113 | Set Screw | M8x6 | 4 |
| 106 | TS-1550061 | Flat Washer | M8 | 4 |
| 107 | TS-2361081 | Spring Washer | M8 | 4 |
| 108 | TS-2248202 | Socket Head Button Screw | M8x20 | 4 |
| 109 | TS-1523041 | Set Screw | M6x12 | 2 |
| 110 | JWBS15-1118 | Handwheel | 5" | 1 |
| 111 | JWBS15-1119 | Handle | M8 | 1 |
| 112 | JWBS18B-1125 | Guide Bracket Assembly | | 1 |
| 113 | JWBS18B-1126 | Upper Blade Guide Assembly | | 1 |
| 114 | JWBS15-1122 | Miter Gauge Assembly | | 1 |
| 115 | JWBS18B-1128 | Rip Fence Assembly | | 1 |
| 116 | F012085 | Roll Pin | Ø4x8 mm | 2 |
| 117 | JWBS15-1125 | Table Insert | | 1 |
| 118 | TS-1522011 | Set Screw | M5x5 | 3 |
| 119 | JWBS18B-1132 | Table | | 1 |
| 120 | TS-2246122 | Socket Head Button Screw | M6x12 | 2 |
| 121 | TS-1550041 | Flat Washer | M6 | 2 |
| 122 | JWBS20B-1122 | Extension Plate | | 1 |
| 123 | TS-1540061 | Hex Nut | M8 | 1 |
| 124 | TS-1550061 | Flat Washer | M8 | 1 |
| 125 | JWBS18B-1138 | Handle | M8x35 | 1 |
| 126 | TS-1550071 | Flat Washer | M10 | 2 |
| 127 | TS-2361101 | Spring Washer | M10 | 2 |
| 128 | TS-1505051 | Socket Head Cap Screw | M10x35 | 1 |
| 129 | JWBS18B-1142 | Lower Blade Guide Assembly | | 1 |
| 130 | JWBS15-1138 | Trunnion Support Bracket Assembly | | 1 |
| 131 | TS-1550061 | Flat Washer | M8 | 4 |
| 132 | TS-2361081 | Spring Washer | M8 | 4 |
| 133 | TS-1490041 | Hex Cap Screw | M8x25 | 4 |
| 134 | PM1800B-077 | Wire Connection Box | | 1 |
| 135 | PM1800B-155 | Phillips Pan Head Machine Screw (Big) | M5x10 | 4 |
| 136 | PM1800B-154 | Wire Cap | P4 | 3 |
| 137 | TS-1533032 | Phillips Pan Head Machine Screw | M5x10 | 2 |
| 138 | JWS25X-405 | Star Washer | M5 | 2 |
| 139 | PM1800B-151 | Ground Wire | | 1 |
| 140 | TS-2248202 | Socket Head Button Screw | M8x20 | 2 |
| 141 | TS-149105 | Hex Cap Screw | M10x35 | 1 |
| 142 | 7015-48 | Set Screw | M8x30 | 1 |
| 143 | TS-1541031 | Hex Nylon Lock Nut | M8 | 1 |
| 144 | TS-1550071 | Flat Washer | M10 | 1 |
| 145 | TS-1490021 | Hex Cap Screw | M8x16 | 1 |

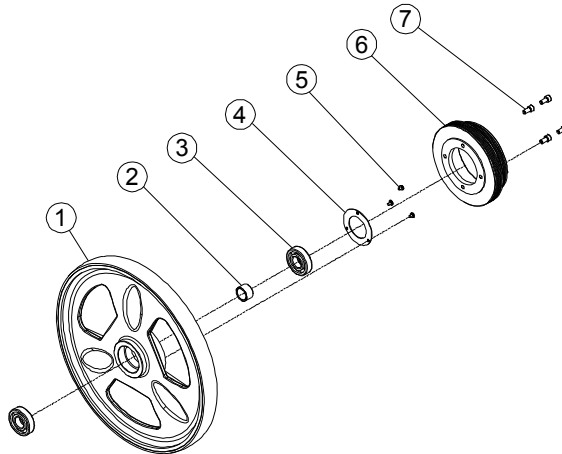
13.18.1 JWBS-20 Upper Wheel Assembly – Exploded View



13.18.2 JWBS-20 Upper Wheel Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|----------------|---------------------------------------|---------|-----|
| | PM2013B-018 | Upper Wheel Assembly (#1 thru 5)..... | | 1 |
| 1 | PM2013B-018-01 | Upper Wheel (Rubber Coating)..... | | 1 |
| 2 | PM1800B-018-02 | Spacer..... | | 1 |
| 3 | BB-6306LLU | Ball Bearing..... | 6306LLU | 2 |
| 4 | PM1800B-018-04 | Plate..... | | 1 |
| 5 | PM1800B-018-05 | Phillips Pan Head Machine Screw..... | M6x8 | 3 |

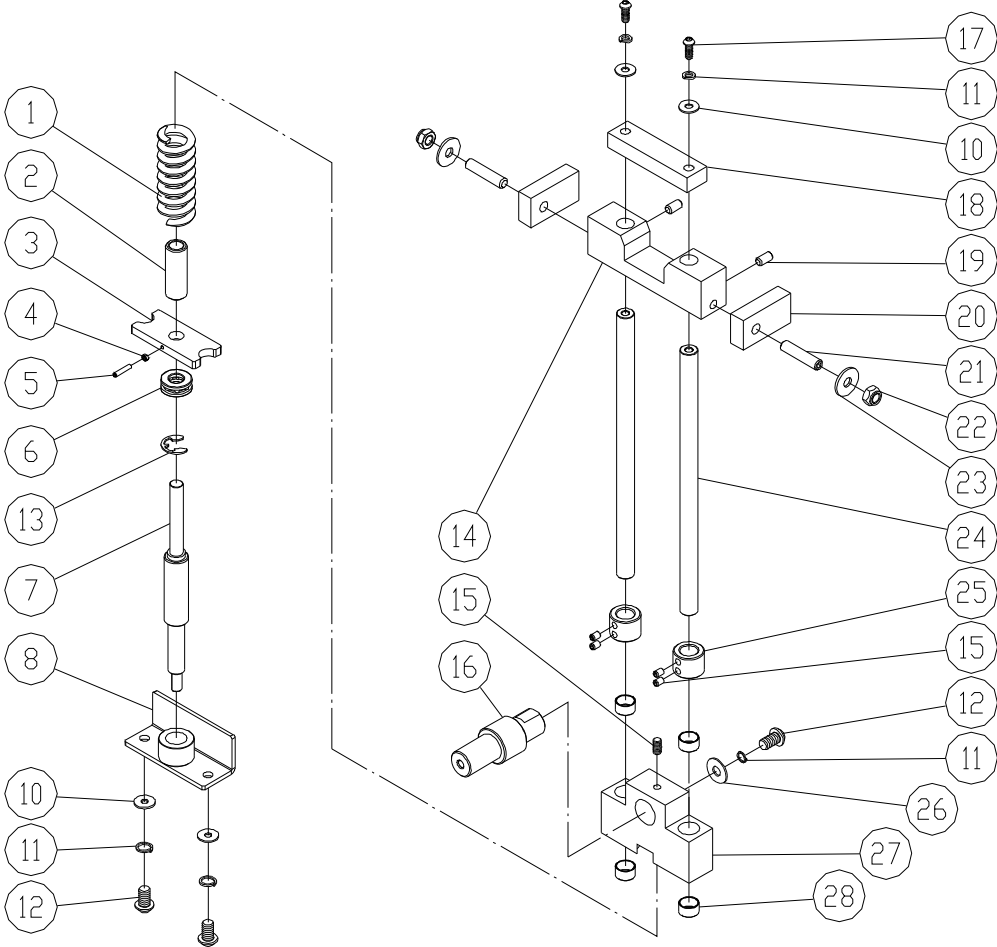
13.19.1 JWBS-20 Lower Wheel Assembly – Exploded View



13.19.2 JWBS-20 Lower Wheel Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---------------------------------------|---------|-----|
| | JWBS20B-120 | Lower Wheel Assembly (#1 thru 7)..... | | 1 |
| 1 | PM2013B-022-01 | Lower Wheel (Rubber Coating)..... | | 1 |
| 2 | PM1800B-018-02 | Spacer..... | | 1 |
| 3 | BB-6306LLU | Ball Bearing..... | 6306LLU | 2 |
| 4 | PM1800B-018-04 | Plate..... | | 1 |
| 5 | PM1800B-018-05 | Phillips Pan Head Machine Screw..... | M6x8 | 3 |
| 6 | JWBS18B-138-807 | Pulley..... | | 1 |
| 7 | TS-1504041 | Socket Head Cap Screw..... | M8x20 | 4 |

13.20.1 JWBS-20 Upper Wheel Sliding Bracket Assembly – Exploded View

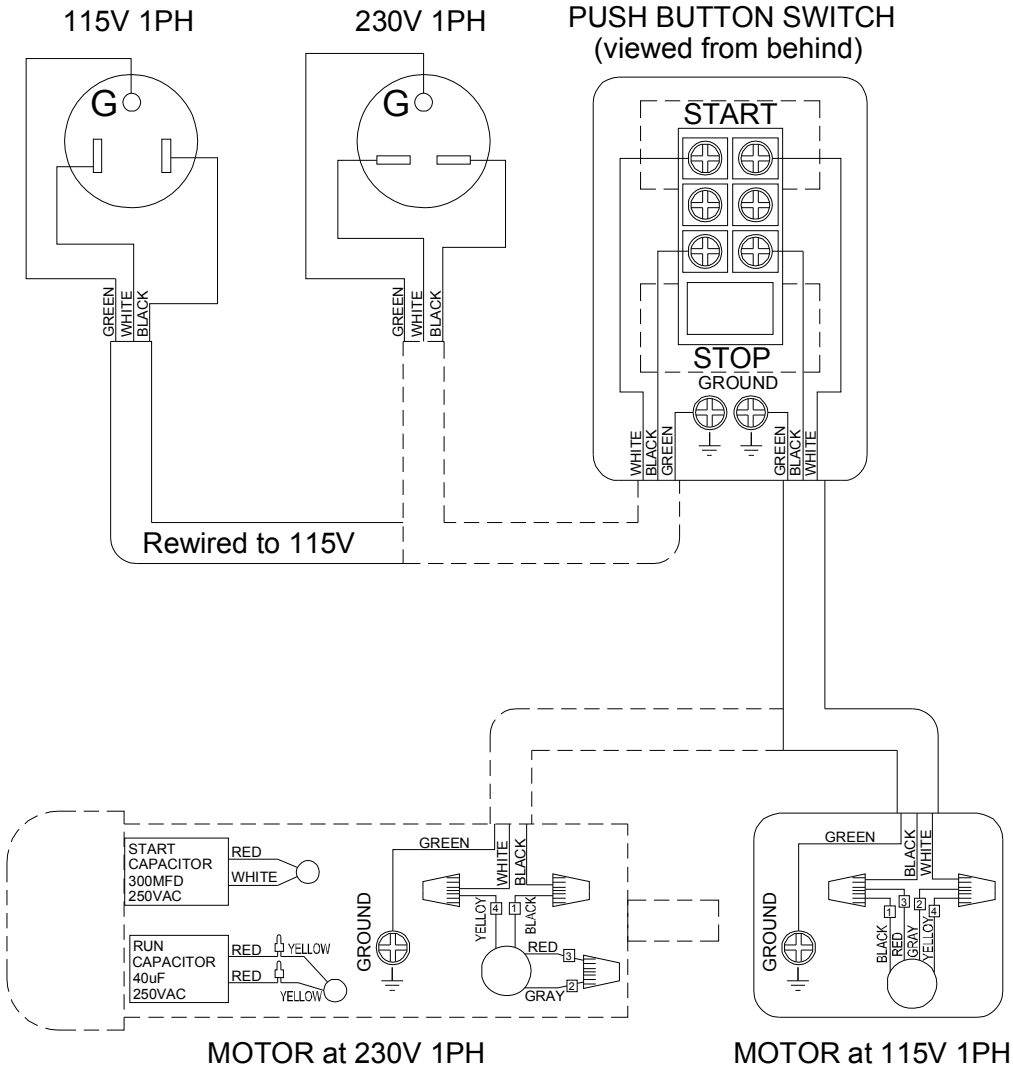


13.20.2 JWBS-20 Upper Wheel Sliding Bracket Assembly – Parts List

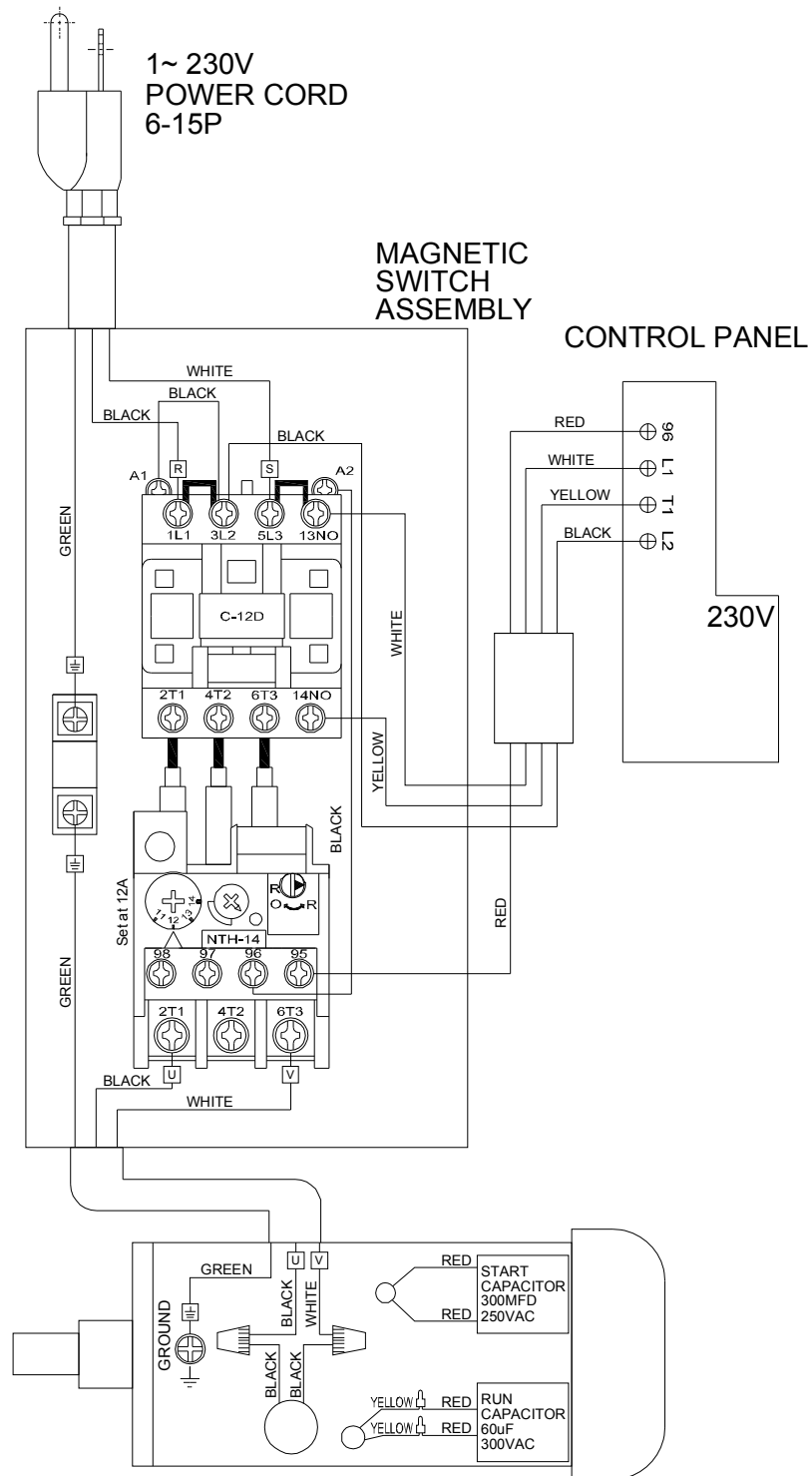
| Index No | Part No | Description | Size | Qty |
|----------|-----------------|---|--------|-----|
| 1 | JWBS20B-112-801 | Spring | | 1 |
| 2 | JWBS20B-112-802 | Bushing | | 1 |
| 3 | JWBS20B-112-803 | Plate | | 1 |
| 4 | TS-1540021 | Hex Nut | M4 | 1 |
| 5 | JWBS20B-112-805 | Set Screw | M4x35 | 1 |
| 6 | BB-51201 | Bearing | 51201 | 1 |
| 7 | JWBS20B-112-807 | Adjusting Bolt | | 1 |
| 8 | JWBS20B-112-808 | Adjust Plate Weldment (includes #9 Nut) | | 1 |
| 10 | TS-1550061 | Flat Washer | M8 | 4 |
| 11 | TS-2361081 | Spring Washer | M8 | 5 |
| 12 | TS-2248202 | Socket Head Button Screw | M8x20 | 3 |
| 13 | PM1800B-027-026 | E Ring | E15 | 1 |
| 14 | JWBS20B-112-814 | Block | | 1 |
| 15 | 5302731 | Set Screw | M8x6 | 5 |
| 16 | JWBS20B-112-816 | Wheel Shaft | | 1 |
| 17 | TS-2248302 | Socket Head Button Screw | M8x30 | 2 |
| 18 | JWBS20B-112-818 | Block | | 1 |
| 19 | TS-1523031 | Set Screw | M6x10 | 2 |
| 20 | JWBS20B-112-820 | Locate Block | | 2 |
| 21 | JWBS20B-112-821 | Set Screw | M10x50 | 2 |
| 22 | TS-2342102 | Nylon Nut | M10 | 2 |
| 23 | TS-1550071 | Flat Washer | M10 | 2 |
| 24 | JWBS20B-112-824 | Shaft | | 2 |
| 25 | JWBS20B-112-825 | Collar | | 2 |
| 26 | TS-1550061 | Flat Washer | M8 | 1 |
| 27 | JWBS20B-112-827 | Upper Wheel Sliding Bracket | | 1 |
| 28 | PM1500-010-28 | Bushing Bearing | DU1610 | 4 |

14.0 Electrical Connections

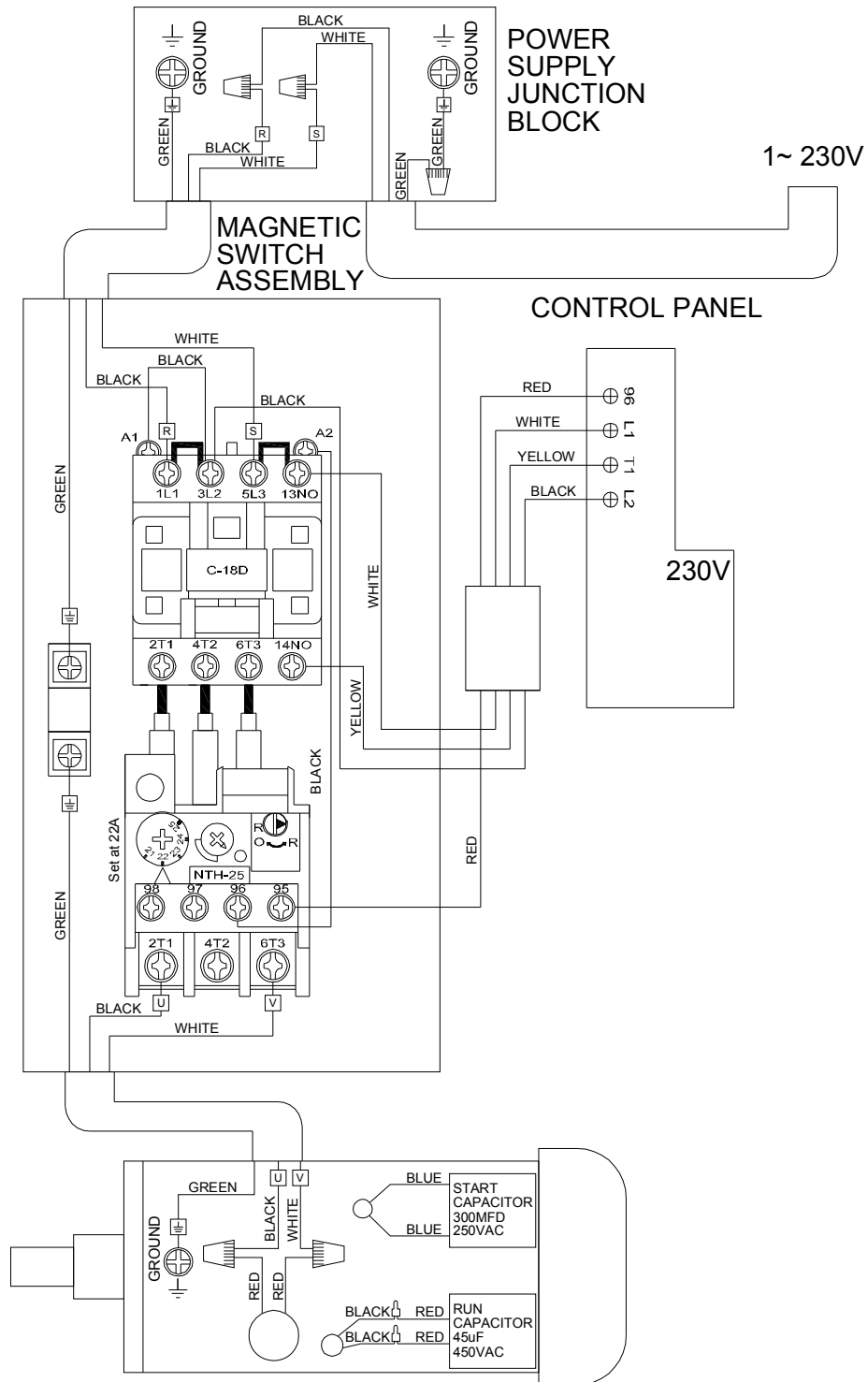
14.1 Connections for 1.75HP (models 714600, 714700)



14.2 Connections for 3HP (models 714650, 714750, 714800)



14.3 Connections for 5HP (model 714850)



15.0 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 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

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

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

Who is Covered

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

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

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

How to Get Technical Support

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

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

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

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

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Product Listing with Warranty Period

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

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