

Parts Manual



SAWING PRODUCTS

400S

Serial No: 597-09101 to

Band Sawing Machine

DAMAGE CLAIM PROCEDURES

VISIBLE DAMAGE AT THE TIME OF DELIVERY:

1. Note damage on carrier's delivery receipt. Accept the shipment. It can be returned later if repairs are not possible in the field.
2. Request a "damage inspection" from the delivery carrier:
 - a. The carrier will send his own people or contract an independent agency to make the inspection.
 - b. The inspector will request a signature on the report and leave a copy.
 - c. The carrier "damage inspection" report is not final. If additional damage is found when repairs are started, contact the carrier for another inspection; or at least give them the details of the damage.
3. Do not move the equipment from the receiving area and keep all shipping materials until carrier "damage inspection" report is complete.
4. If possible, take photographs of the damage and keep them for your files. Photos could possibly prove a claim at a later time.
5. Keep a record of all expenses and be sure they are documented.
6. Repair damage in the field whenever possible. Carriers encourage this to keep expenses down.
7. You have nine (9) months to file a claim.

CONCEALED DAMAGE:

1. You have fourteen (14) days to report damage not noted at time of delivery.
 - a. Report damage as soon as possible. This makes it easier to prove that it did not happen at cosignee's plant.
 - b. Inspect machine(s) carefully before moving from the receiving area. Again, if machine is not moved, it is easier to prove your case.
2. Request a "damage inspection" from the delivery carrier:
 - a. The carrier will send his own people or contract an independent agency to make the inspection.
 - b. The inspector will request a signature on the report and leave a copy.
 - c. The carrier "damage inspection" report is not final. If additional damage is found when repairs are started, contact the carrier for another inspection; or at least give them the details of the damage.
3. Do not move the equipment from the receiving area and keep all shipping materials until carrier "damage inspection" report is complete.
4. If possible, take photographs of the damage and keep them for your files. Photos could possibly prove a claim at a later time.
5. Keep a record of all expenses and be sure they are documented.
6. Repair damage in the field whenever possible. Carriers encourage this to keep expenses down.
7. You have nine (9) months to file a claim.

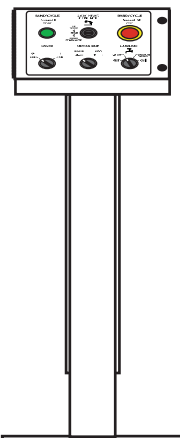
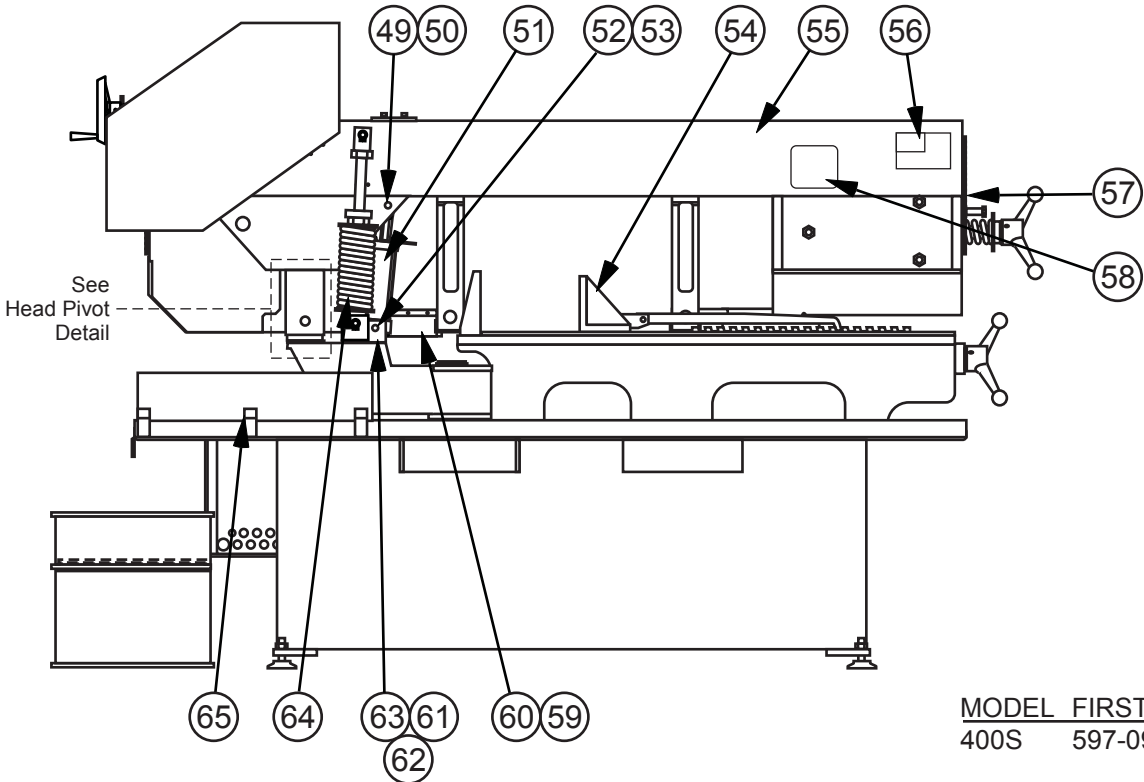
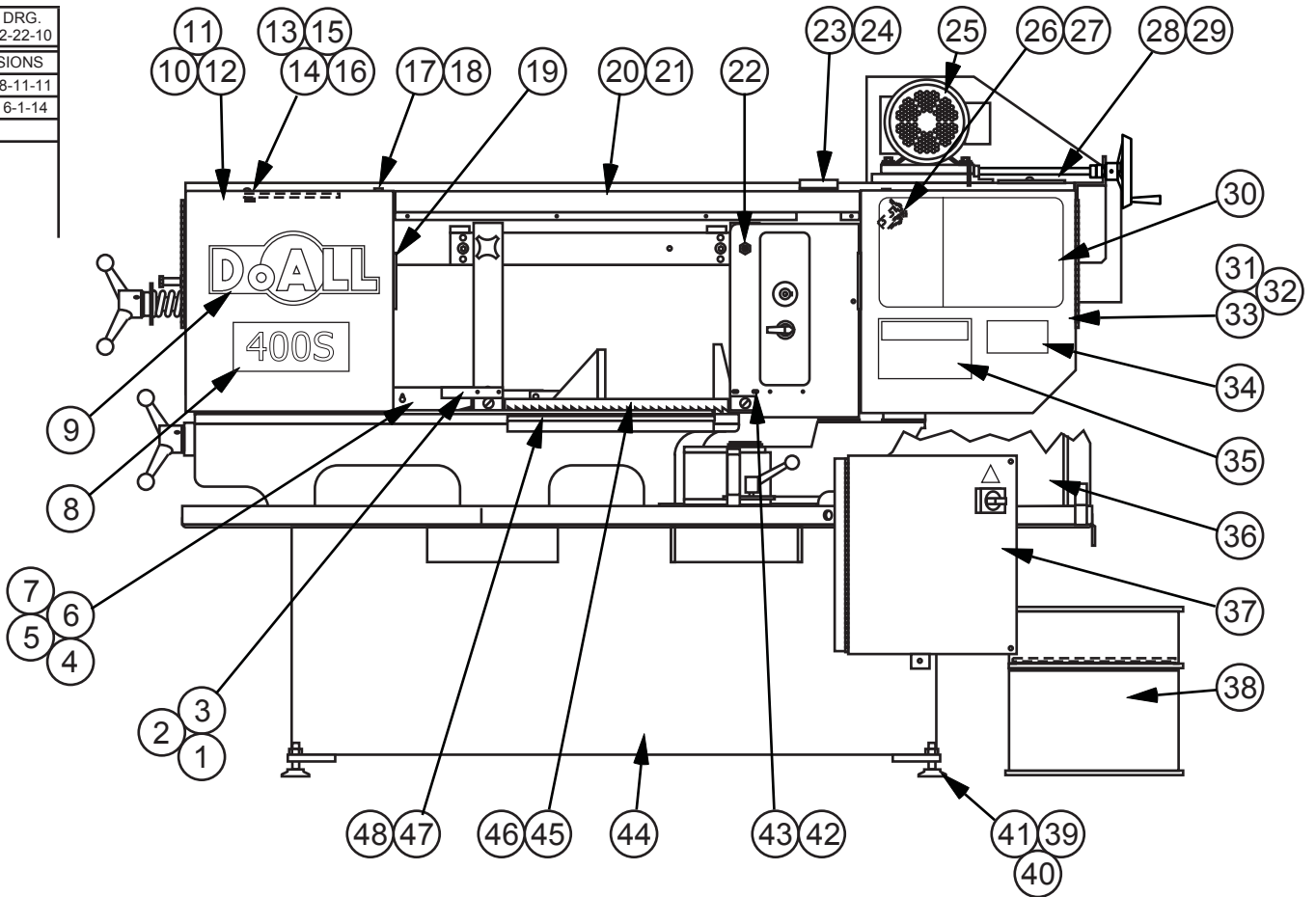
PARTS MANUAL INDEX

6/14

Fiche No. E-140 Model 400S Serial No. 597-10101 to _____

PAGE NO.	DESCRIPTION	FIRST SERIAL	LAST SERIAL	PAGES
PS-1-159	Final Assembly	All		2 - 3
PS-5-88	Adjusting Screw Assembly (Saw Guides)	All		40 - 41
PS-2-171	Band Brush Assembly	All		4 - 5
PS-4-127	Band Speed Adjustment Handwheel Assembly	All		10 - 11
PS-2-170	Band Tension Handwheel Assembly	All		22 - 23
PS-2-170	Bandwheel Assemblies	All		22 - 23
PS-1-162	Band Wiper Assembly	All		28 - 29
PS-7-390	*Control Panel (Pneumatic)	All		32 - 33
PS-10-136	*Conveyor Assemblies (5' and 10')	All		6 - 7
PS-2-172	Counterbalance Spring Assembly	All		8 - 9
PS-1-159	Discharge Tray (Small - Standard)	All		2 - 3
PS-1-162	*Discharge Tray Assembly (Large)	All		28 - 29
PS-1-159	Door Latches	All		2 - 3
PS-4-127	Drive Assembly	All		10 - 11
PS-4-131	*Drive Assembly (Low Band Speed Option)	All		12 - 13
PS-8-364	Electrical Assembly	597-10101	to 597-13259	14 - 15
PS-8-380	Electrical Assembly	597-13260	to	16 - 17
PS-8-365	Electrical Control Box Assembly	All		18 - 19
PS-6-78	Flood Coolant Assembly	All		20 - 21
PS-6-80	*Flood Coolant Assembly (Europa Only)	All		22 - 23
PS-6-78	*Flushing Hose Assembly	All		20 - 21
PS-6-80	*Flushing Hose Assembly (Europa Only)	All		22 - 23
PS-2-170	Head Assembly	All		24 - 25
PS-7-387	Head Feed Control Assembly	All		26 - 27
PS-7-389	Head Feed Cylinder Assembly	All		28 - 29
PS-1-162	Head Pivot Detail	All		30 - 31
PS-7-387	Hydraulic Controls	All		26 - 27
PS-1-162	*Laser Line Generator Assembly	All		30 - 31
PS-1-162	Miscellaneous Details	All		30 - 31
PS-6-79	*Mist Lubricator Assembly	All		32 - 33
PS-7-390	*Pneumatic Details	All		34 - 35
PS-7-391	*Pneumatic Head Lift Assembly	All		36 - 37
PS-7-392	*Pneumatic Vise Assembly	All		38 - 39
PS-8-365	Pushbutton Panel Detail	All		18 - 19
PS-5-88	Saw Guide Arm Assembly	All		40 - 41
PS-10-136	*Vertical Guide Roller Assembly (Conveyor)	All		6 - 7
PS-3-282	Vise Detail	All		42 - 43
PS-3-282	Vise Clamp Handwheel Assembly	All		42 - 43
PS-8-364	*Worklight	597-10101	to 597-13259	14 - 15
PS-8-380	*Worklight	597-13260	to	16 - 17
PS-10-142	*Workstop Assembly (With Large Discharge Tray Only)	All		44 - 45
	*Denotes Attachment or Optional Equipment.			

NEW DRG.
S.C.L. 2-22-10
REVISIONS
S.C.L. 8-11-11
S.C.L. 6-1-14



MODEL FIRST MACH. LAST MACH.
400S 597-09101

FINAL ASSEMBLY

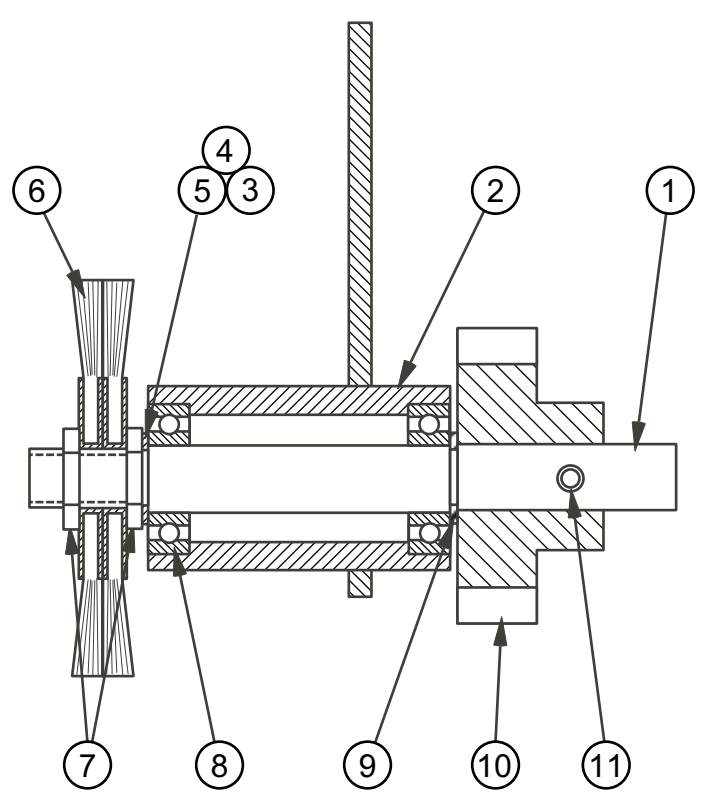
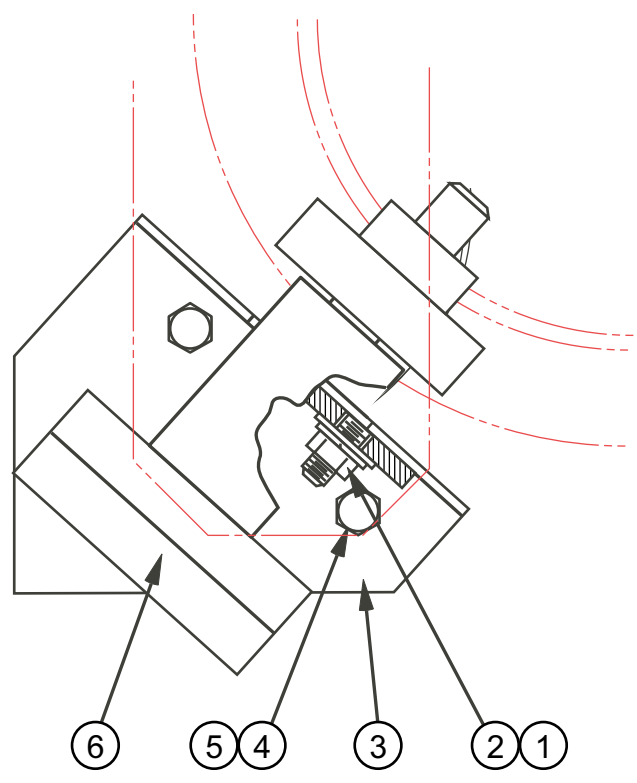
FINAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1008780	Final Assembly		47	1009405	. Discharge Tray (Small) (Standard)	1
1	320595	. L.H. Blade Guard Weldment	1		1009399	. Discharge Tray Assembly (Large) (Optional) (See Detail)	1
2	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2	48	199987	. Screw, Flat. Hd. Soc. M6-1.0 x 10	3
3	199258	. Washer, Flat #10 S.A.E. Std.	2	49	175144	. Pin	1
4	1008854	. Shield	1	50	35-006426	. Retaining Ring	2
5	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2	51	1009700	. Head Feed Control Assembly (Standard) (See Detail)	1
6	199258	. Washer, Flat #10 S.A.E. Std.	2		1009699	. Head Feed Control Assembly (Full Cycle Option) (See Detail)	1
7	199530	. Nut, Hex. Self-Locking M5-0.8	2			. Pin	1
8	1008682	. Decal (400S)	1	52	1008305	. Retaining Ring	2
9	416163	. Label (DoALL)	1	53	35-006426	. Vise and Pivot Detail (See Detail)	1
10	1009128	. L.H. Door Weldment	1	54		. Head Assembly (See Detail)	1
11	199299	. Self Drilling Fastener M4.8 x 13	4	55	1009198	. Decal (American Flag)	1
12	197022	. Nylon Edging	A.R.	56	201469	. Escutcheon (Band Tension)	1
13	175478	. Door Stop	1	57	176072	. Label (Machine Specifications)	1
14	199899	. Screw, Button Hd. Soc. M6-1.0 x 16	1	58	1012541	. R.H. Band Guard	1
15	199245	. Locknut M6-1.0	1	59	1009423	. Screw, Button Hd. Soc. M5-0.8 x 10	2
16	199965	. Washer, Flat M6	1	60	199974	. Pull Pocket	2
17	316583	. Spring Latch (Each Door)	2	61	320619	. Band Cover Weldment (Standard)	1
18	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4	62	198161	. Band Cover Weldment (Mist Lubricator Option)	1
19	201569	. Pull Pocket	2	63	199346	. Screw, Button Hd. Soc. M5-0.8 x 10	4
20	1008801	. Band Cover Weldment (Standard)	1	64	517499	. Nut, Hex. Jam M12-1.75	1
	1008802	. Band Cover Weldment (Mist Lubricator Option)	1	65	1008608	. Band Cover	1
21	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4			. Screw, Soc. Hd. Cap M8-1.25 x 12	2
22	199222	. Nut, Hex. Jam M12-1.75	1			. Drive Assembly (See Detail)	1
23	1008813	. Band Cover	1			. Band Wiper Assembly (See Detail)	1
24	224156	. Screw, Soc. Hd. Cap M8-1.25 x 12	2			. Screw, Button Hd. Soc. M5-0.8 x 10	2
25		. Drive Assembly (See Detail)	1			. Bearing Cover	1
26	207716	. Band Wiper Assembly (See Detail)	1			. Screw, Button Hd. Soc. M5-0.8 x 10	2
27	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2			. Saw Band Selector	1
28	175268	. Bearing Cover	1			. R.H. Door Weldment	1
29	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2			. Self Drilling Fastener M4.8 x 13	4
30	1008687	. Saw Band Selector	1			. Nylon Edging	A.R.
31	1009124	. R.H. Door Weldment	1			. Label (Diameters/X-Section Area)	1
32	199299	. Self Drilling Fastener M4.8 x 13	4			. Escutcheon (Warning)	1
33	197022	. Nylon Edging	A.R.			. Front Splash Shield	1
34	209652	. Label (Diameters/X-Section Area)	1			. Electrical Assembly (See Detail)	1
35	404478	. Escutcheon (Warning)	1			. Flood Coolant Assembly (See Detail) ..	1
36	1013577	. Front Splash Shield	1			. Mist Lubricator Assembly (Optional) (See Detail)	1
37		. Electrical Assembly (See Detail)	1			. Foot casting	4
38	1008849	. Flood Coolant Assembly (See Detail) ..	1			. Screw, Hex. Hd. Cap M16-2.0 x 70	4
	214935	. Mist Lubricator Assembly (Optional) (See Detail)	1			. Nut, Hex. Jam M16-2.0	4
39	012420	. Foot casting	4			. Screw, Button Hd. Soc. M5 x 0.8 x 10 .	2
40	199253	. Screw, Hex. Hd. Cap M16-2.0 x 70	4			. Washer, Flat #10 Std. S.A.E.	2
41	199955	. Nut, Hex. Jam M16-2.0	4			. Base Weldment	1
42	199974	. Screw, Button Hd. Soc. M5 x 0.8 x 10 .	2			. Saw Band (Imperial Bi-Metal Super Silencer)	1
43	199258	. Washer, Flat #10 Std. S.A.E.	2			. Saw Band Tag	1
44	6000056	. Base Weldment	1				
45	209790	. Saw Band (Imperial Bi-Metal Super Silencer)	1				
46	304525	. Saw Band Tag	1				

Following Not Shown:

406872	. Instruction Tag	1
206698	. CE Label (Europa Only)	1
1012466	. Shipping Pallet	1
416770	. Shipping Bracket	1
1008897	. Documentation CD	1
100666	. Escutcheon (DoALL-CSA)	1

NEW DRG. S.C.L. 2-22-10
REVISIONS

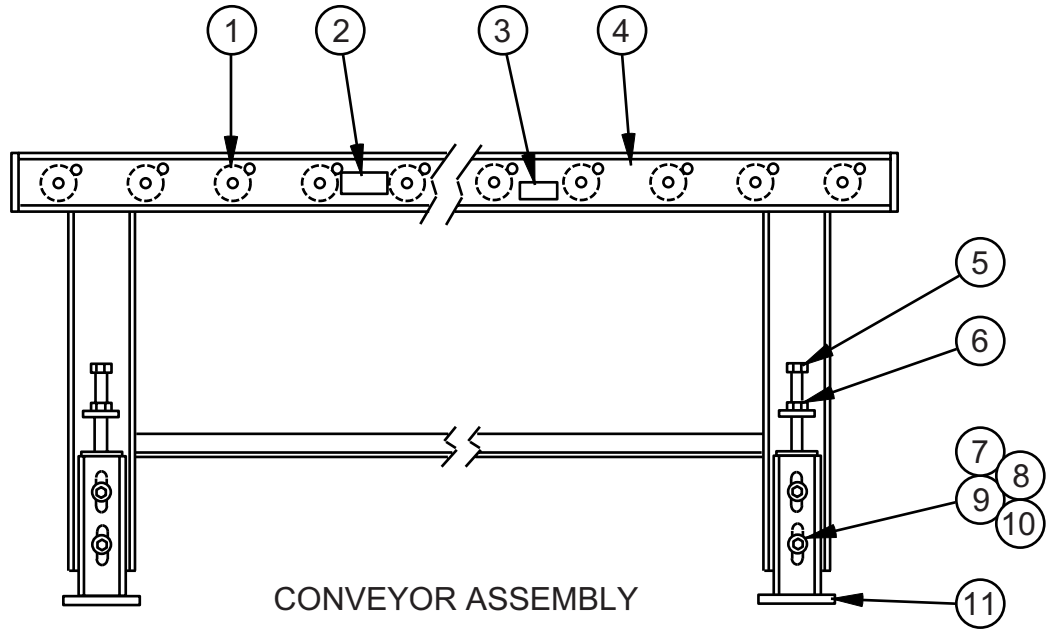


MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

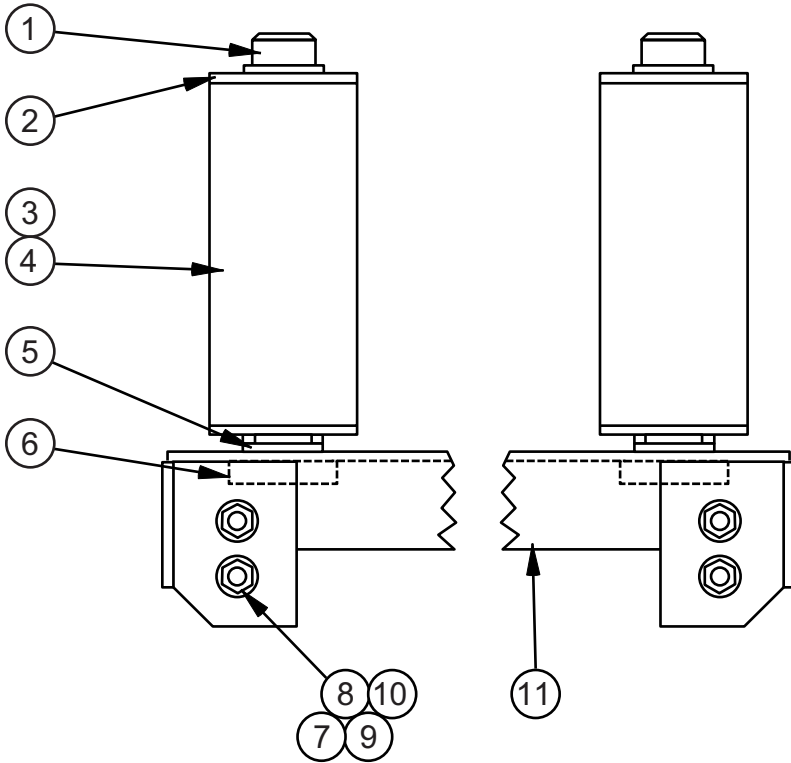
BAND BRUSH ASSEMBLY

BAND BRUSH ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	417836	Band Brush Assembly (Powered)	
1	199188	. Nut, Hex. M6-1.0	2
2	199579	. Washer, Flat M6 Wrought	4
3	320802	. Bracket Weldment	1
4	199899	. Screw, Button Hd. Soc. M6-1.0 x 16	2
5	199347	. Washer, Lock M6	4
6	320800	. Band Brush Assembly (See Detail)	1
Ref.	320800	. Band Brush Assembly	
1	209672	.. Shaft	1
2	320799	.. Bracket Weldment	1
3	208826	.. Retaining Ring	1
4	133470	.. Spacer (.0149)	A.R.
5	133471	.. Spacer (.0299)	A.R.
6	010983	.. Wire Brush	2
7	199222	.. Nut, Hex. Jam M12-1.75	2
8	207462	.. Bearing	2
9	35-009613	.. Retaining Ring If Supplied)	1
10	320801	.. Pinion	1
11	004260	.. Spring Pin	1



CONVEYOR ASSEMBLY



VERTICAL GUIDE ROLLER ASSEMBLY

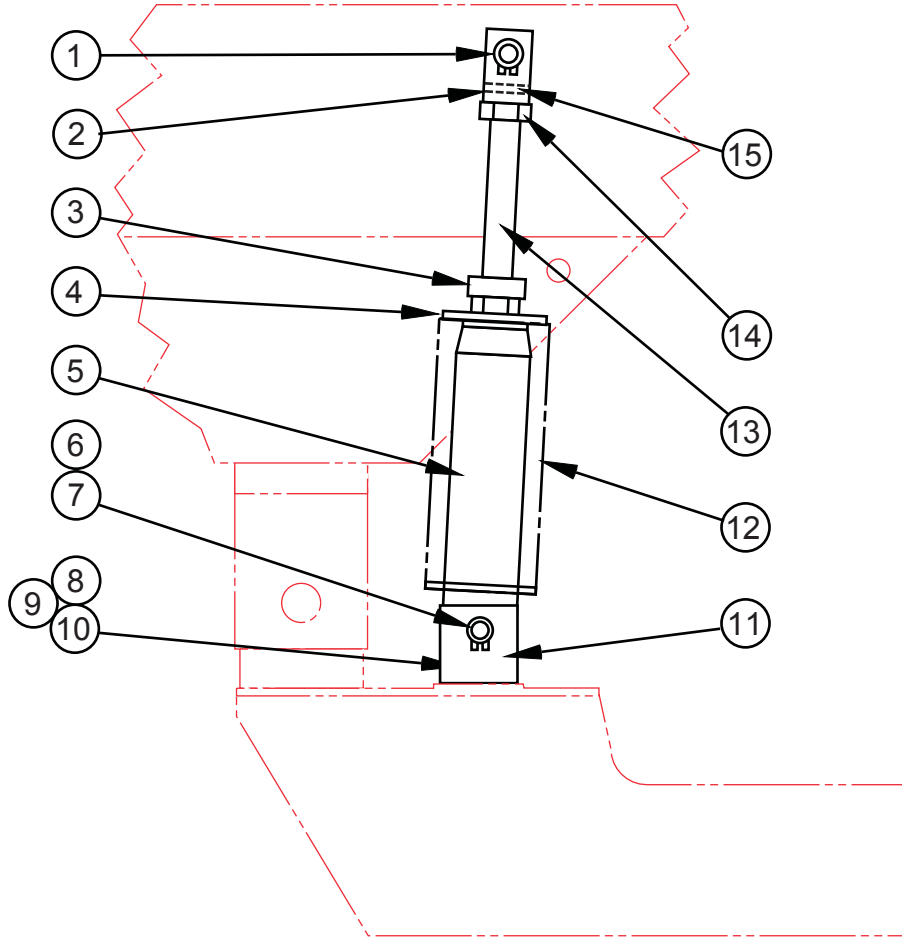
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

CONVEYOR ASSEMBLY (AND RELATED ITEMS)

CONVEYOR ASSEMBLY
(And Related Items)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	207709	5' Conveyor Assembly	
1	202786	. Roller	5
2	203025	. Label (DoALL Logo)	2
3	203035	. Label (Conveyor Capacity)	2
4	517488	. Frame Weldment	1
5	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150	4
6	199933	. Nut, Hex. M12-1.75	4
7	199581	. Screw, Hex. Hd. Cap M12-1.75 x 35	8
8	199289	. Washer, Flat M12 Wrought	16
9	199345	. Washer, Lock M12	8
10	199933	. Nut, Hex. M12-1.75	8
11	417100	. Foot Weldment	4
Ref.	207710	10' Conveyor Assembly	
1	202786	. Roller	10
2	203025	. Label (DoALL Logo)	2
3	203035	. Label (Conveyor Capacity)	2
4	517489	. Frame Weldment	1
5	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150	6
6	199933	. Nut, Hex. M12-1.75	6
7	199581	. Screw, Hex. Hd. Cap M12-1.75 x 35	12
8	199289	. Washer, Flat M12 Wrought	24
9	199345	. Washer, Lock M12	12
10	199933	. Nut, Hex. M12-1.75	12
11	417100	. Foot Weldment	6
		Optional Filler Plates (Not Shown):	
	217236	. Filler Plate (6.97 Long) (Optional)	1
	217233	. Filler Plate (9.25 Long) (Optional).....	A.R.
Ref.	517268	Vertical Guide Roller Assembly	
1	199295	. Screw, Hex. Hd. Cap M16-2.0 x 220	2
2	850900	. Roller End Bearing	4
3	206750	. Roller	2
4	206861	. Roller Shaft	2
5	199296	. Clevis Pin Washer	2
6	206893	. Square Nut M16-2.0	2
7	199975	. Screw, Hex. Hd. Cap M10-1.5 x 35	8
8	199346	. Washer, Lock M10	8
9	198976	. Washer, Flat M10	16
10	199939	. Nut, Hex. M10-1.5	8
11	516029	. Base Weldment	8

NEW DRG. S.C.L. 2-22-10
REVISIONS



MODEL 400S SHOWN.

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

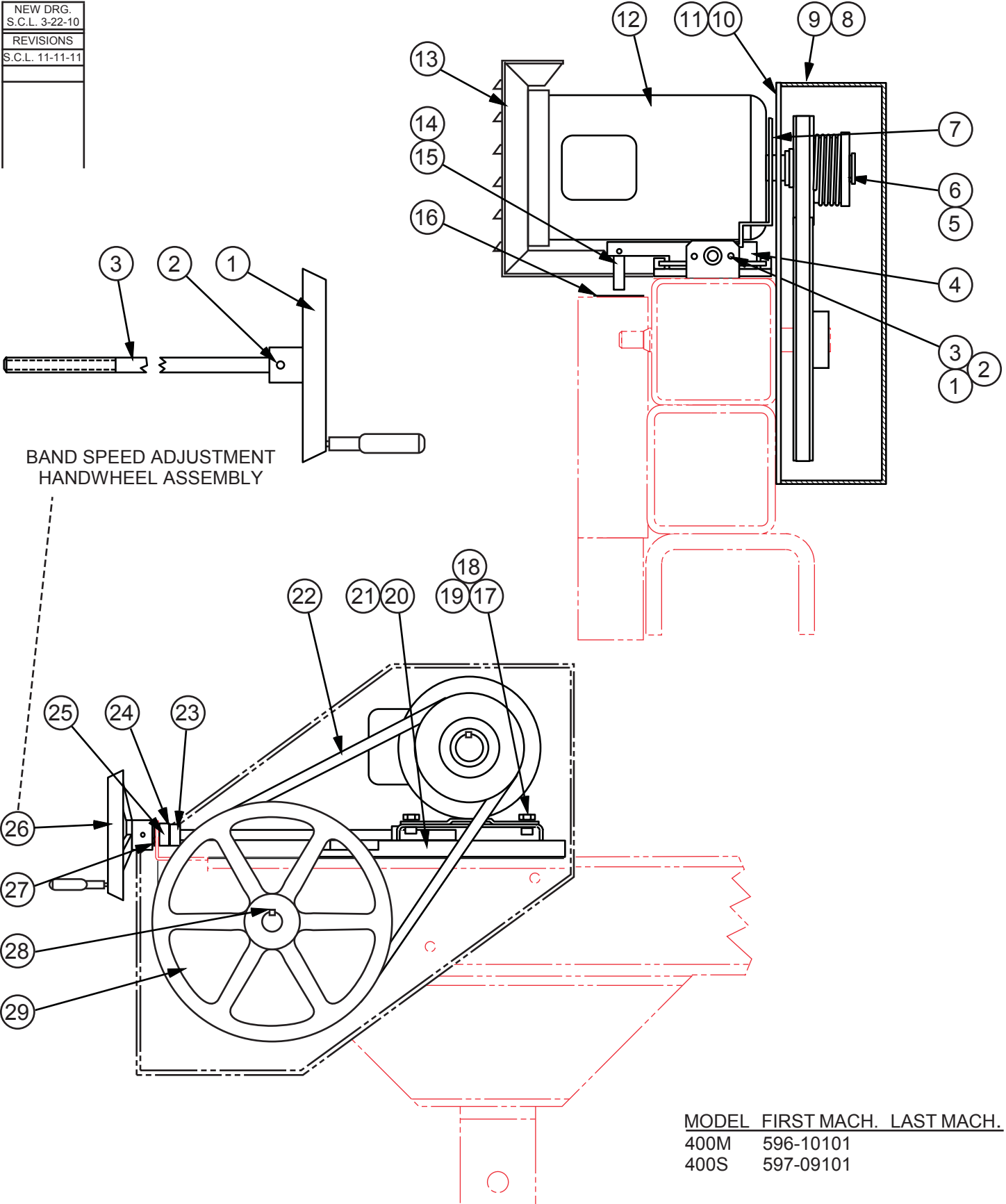
COUNTERBALANCE SPRING ASSEMBLY

COUNTERBALANCE SPRING ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517499	Counterbalance Spring Assembly	
1	35-008688	. Retaining Ring	1
2*	178683	. Clevis	1
3*	201366	. Shaft Collar	1
4	179576	. Top Washer	1
5	318126	. Rod Guide Weldment	1
6	179579	. Pin	1
7	35-009613	. Retaining Ring	2
8	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20	2
9	199346	. Washer, Lock M10	2
10	198976	. Washer, Flat M10	2
11	318127	. Bracket	1
12	178236	. Compression Spring	1
13*	179577	. Threaded Rod 3/4-10NC x 13-1/2	1
14*	199140	. Nut, Hex. Jam 3/4-10NC	2
15*	004261	. Spring Pin	1

*NOTE: Marked Items are Part of Assembly #326829 - Screw and Lug Assembly.

NEW DRG.
S.C.L. 3-22-10
REVISIONS
S.C.L. 11-11-11



BAND SPEED ADJUSTMENT
HANDWHEEL ASSEMBLY

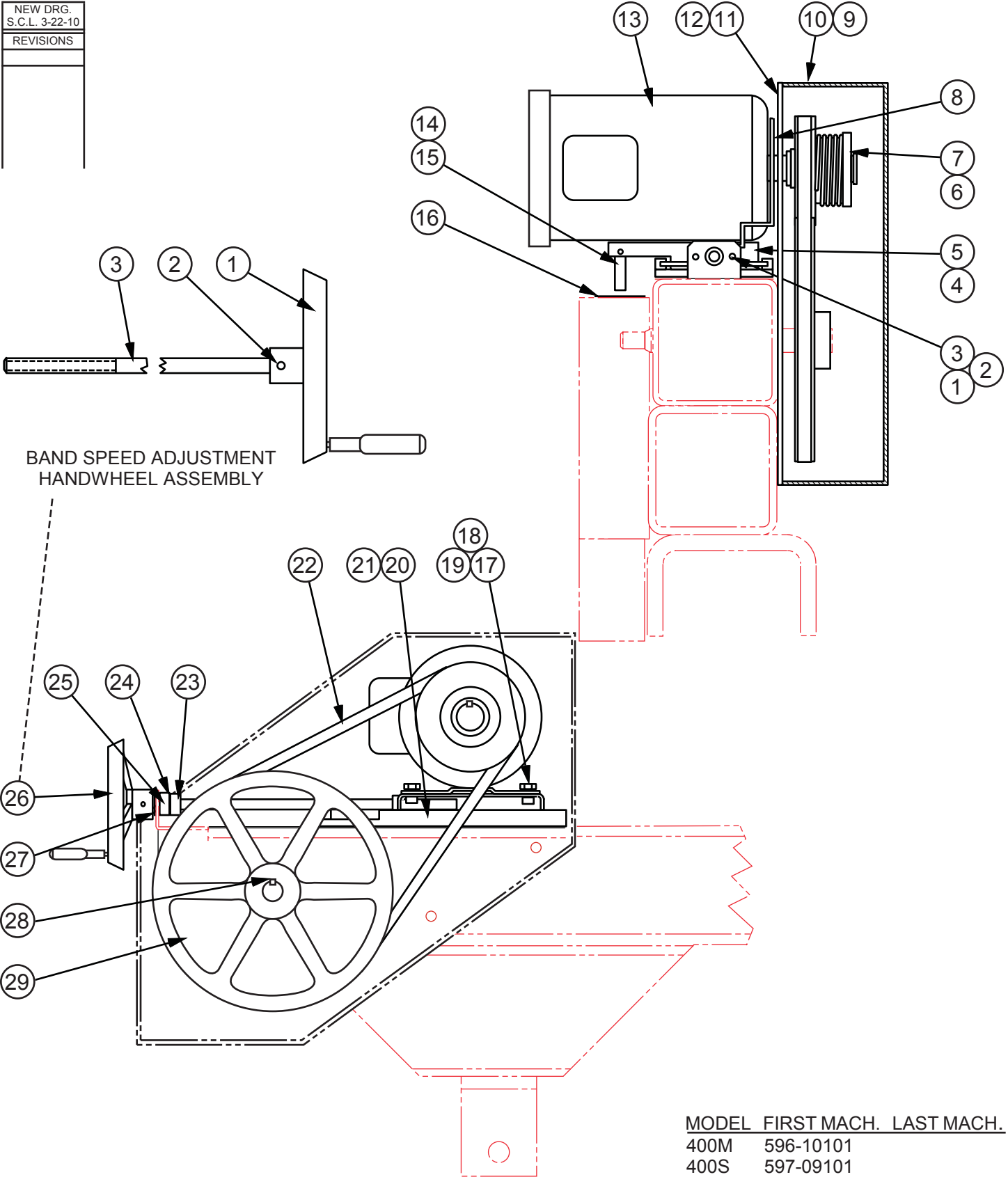
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-09101	

DRIVE ASSEMBLY

DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.		Drive Assembly	
1	199899	. Screw, Button Hd., Soc. M6-1.0 x 16	2
2	199347	. Washer, Lock M6	2
3	199188	. Nut, Hex. M6-1.0	2
4*	1013242	. Motor Slide Weldment (208V, 230V, 460V, 575V)	1
	415163	. Motor Slide Weldment (200V, 400V & 1 Phase Motors Only)	1
5*	175280	. Variable Pulley (208V, 230V, 460V, 575V)	1
	207433	. Variable Pulley (200V, 400V & 1 Phase Motors Only)	1
6*	7-001345	. Key (208V, 230V, 460V, 575V)	1
	198986	. Key (200V, 400V & 1 Phase Motors Only)	1
7	320833	. Cover	2
8	1009175	. Cover Weldment	1
9	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	6
10	1009176	. Cover Mounting Plate	1
11	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
12*	1013068	. Electric Motor (208V, 230V, 460V)	1
	1013073	. Electric Motor (575V)	1
	1013251	. Electric Motor (200V, 400V)	1
	133879	. Electric Motor (1 Phase Only)	1
13	326647	. Louvered Motor Cover (1 Phase Motors Only)	1
14	1008876	. Pointer	1
15	198979	. Screw, Button Hd. Soc. M5-0.8 x 6	1
16	179480	. Escutcheon (Band Speed) (60 Hz)	1
	179482	. Escutcheon (Band Speed) (50 Hz)	1
17	199239	. Screw, Hex. Hd. Cap M8-1.25 x 20	4
	198026	. Screw, Hex. Hd. Cap 5/16-18NC x 5/8 (200V, 400V & 1 Phase Motors)	4
18	199968	. Washer, Lock M8	4
	199323	. Washer, Lock 5/16 Std. (1 Phase Motor Only)	4
19	198574	. Washer, Flat M8 Wrought	4
	199262	. Washer, Flat 5/16 S.A.E. Std. (1 Phase Motor Only)	4
20	417748	. Base Motor Slide	1
21	199056	. Screw, Soc. Hd. Cap M8-1.25 x 16 (Low Head)	4
22	158815	. V-Belt	1
23	34-005410	. Set Screw Collar	1
24	199289	. Washer, Flat M12 Wrought	1
25	142408	. Flanged Bearing	1
26	318133	. Band Speed Adjustment Handwheel Assembly (See Detail)	1
27	199289	. Washer, Flat M12 Wrought	1
28	004443	. Key	1
29	1008792	. Pulley	1
Following Not Shown:			
	167329	. Nylon Clamp	2
Ref.	318133	. Band Speed Adjustment Handwheel Assembly	
1	216098	. . Handwheel (W/Fold-In Handle)	1
2	004263	. . Spring Pin	1
3	317323	. . Screw	1
*NOTE: For Machines With Baldor Motors:			
4	417913	. Motor Slide Weldment	1
	415163	. Motor Slide Weldment (1 Phase Motors Only)	1
5	207433	. Variable Pulley	1
	175280	. Variable Pulley (1 Phase Motors Only)	1
6	198986	. Key (3 Phase Motors Only)	1
12	209621	. Electric Motor	1
	209622	. Electric Motor (575V Only)	1
	133879	. Electric Motor (1 Phase Only)	1

NEW DRG.
S.C.L. 3-22-10
REVISIONS



BAND SPEED ADJUSTMENT
HANDWHEEL ASSEMBLY

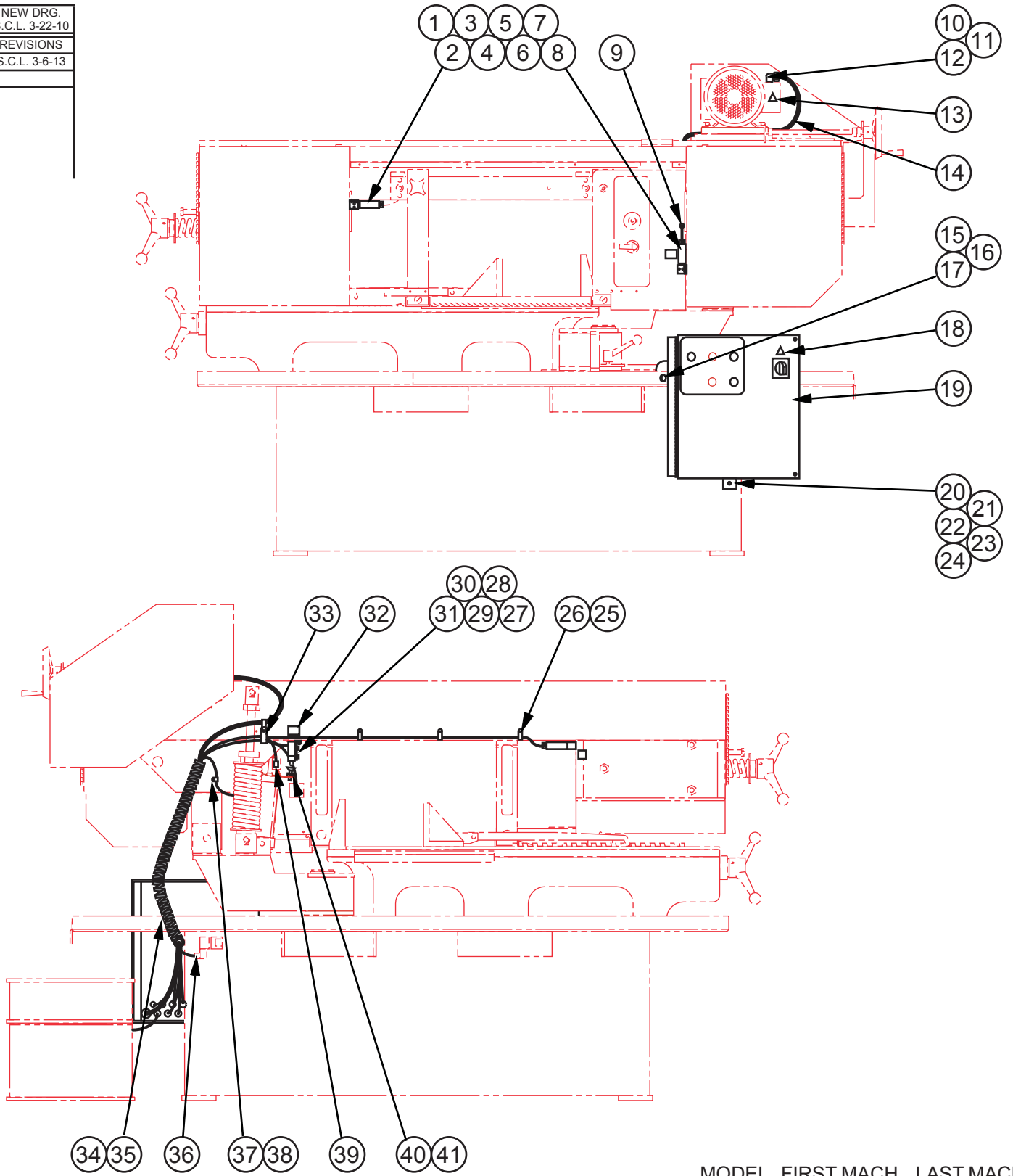
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-09101	

DRIVE ASSEMBLY
(LOW BAND SPEED OPTION)

DRIVE ASSEMBLY
(Low Band Speed Option)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1010276	Drive Assembly (Low Band Speed Option)	
1	199899	. Screw, Button Hd., Soc. M6-1.0 x 16	2
2	199347	. Washer, Lock M6	2
3	199188	. Nut, Hex. M6-1.0	2
4	417913	. Motor Slide Weldment	1
5	417914	. Adaptor Plate	1
6	207433	. Variable Pulley	1
7	198986	. Key	1
8	320833	. Cover	2
9	1009175	. Cover Weldment	1
10	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	6
11	1009176	. Cover Mounting Plate	1
12	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
13	209639	. Electric Motor	1
	209640	. Electric Motor (575V Only)	1
14	1008876	. Pointer	1
15	198979	. Screw, Button Hd. Soc. M5-0.8 x 6	1
16	179476	. Escutcheon (Band Speed) (60 Hz)	1
	209449	. Escutcheon (Band Speed) (50 Hz)	1
17	199239	. Screw, Hex. Hd. Cap M8-1.25 x 20	4
18	199968	. Washer, Lock M8	4
19	198574	. Washer, Flat M8 Wrought	4
20	417748	. Base Motor Slide	1
21	199056	. Screw, Soc. Hd. Cap M8-1.25 x 16 (Low Head)	4
22	211937	. V-Belt	1
23	34-005410	. Set Screw Collar	1
24	199289	. Washer, Flat M12 Wrought	1
25	142408	. Flanged Bearing	1
26	318133	. Band Speed Adjustment Handwheel Assembly (See Detail)	1
27	199289	. Washer, Flat M12 Wrought	1
28	004443	. Key	1
29	1008792	. Pulley	1
Following Not Shown:			
	167329	. Nylon Clamp	2
Ref.	318133	. Band Speed Adjustment Handwheel Assembly	
1	216098	. . Handwheel (W/Fold-In Handle)	1
2	004263	. . Spring Pin	1
3	317323	. . Screw	1

NEW DRG.
S.C.L. 3-22-10
REVISIONS
S.C.L. 3-6-13



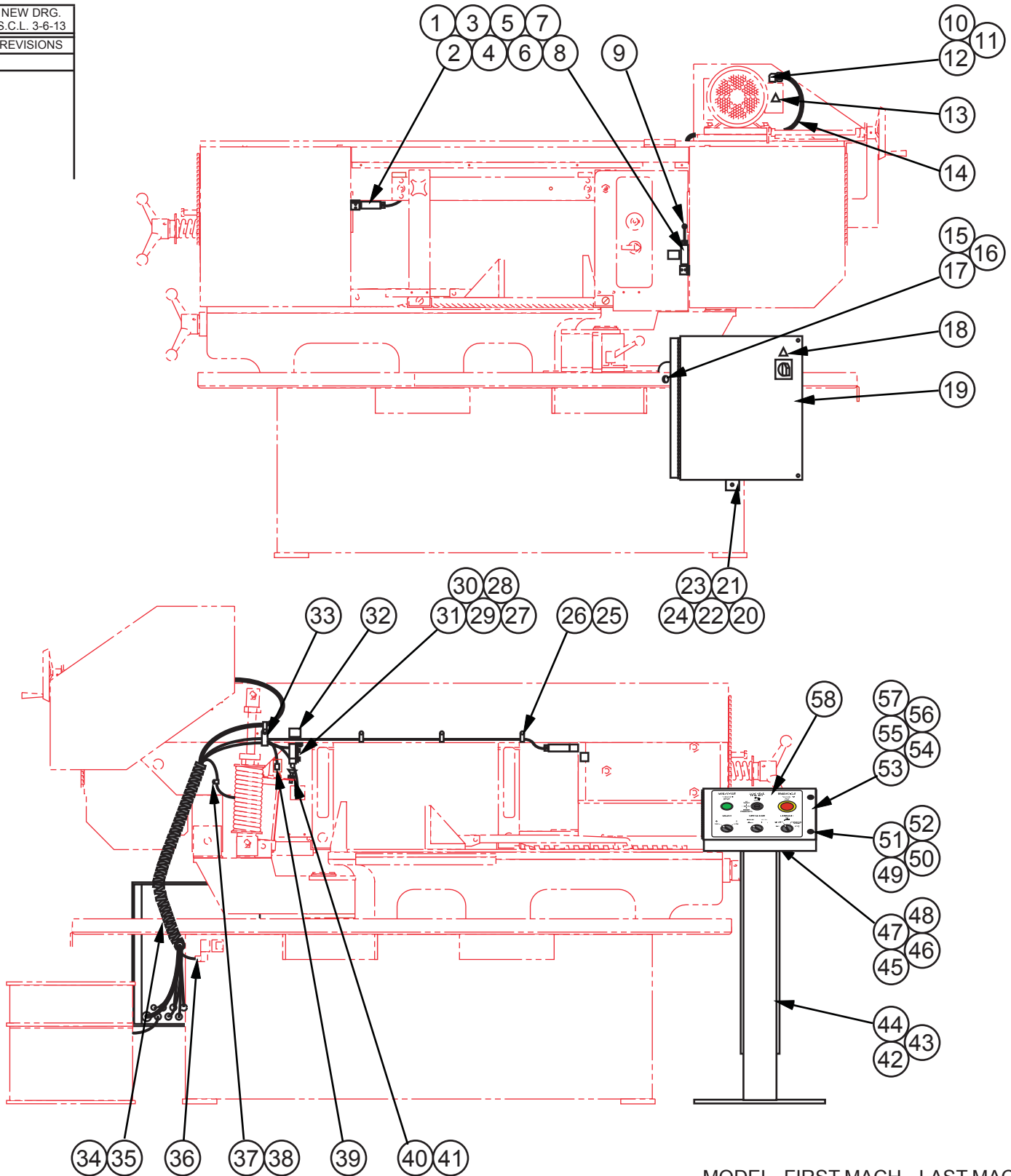
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	596-13294
400S	597-10101	597-13259

ELECTRICAL ASSEMBLY

ELECTRICAL ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Electrical Assembly	
1	215624	. Limit Switch (Door Interlock)	2
2	199389	. Screw, Button Hd. Soc. M4-0.7 x 30	4
3	215619	. Cord Grip Connector (.236-.472)	2
4	197332	. Electrical Cord (#18-2 Conductor)	A.R.
5	221855	. Interlock Key Bracket	2
6	199728	. Screw, Button Hd. Soc. M4-0.7 x 10	8
7	199214	. Nut, Hex. M4-0.7	4
8	199248	. Washer, Flat M4	A.R.
9	015780	. Rubber Grommet	1
10	016160	. 90° Cord Grip Connector	1
11	014411	. Flange Washer	1
12	019543	. Bond Nut	1
13	176528	. Label (Electrical Hazard)	1
14	197218	. Electrical Cord (#14-4 Conductor)	A.R.
	197219	. Electrical Cord (#14-3 Conductor) (Single Phase Motors Only)	A.R.
15	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
16	199347	. Washer, Lock M6	2
17	199188	. Nut, Hex. M6-1.0	2
18	176528	. Label (Electrical Hazard)	1
19		. Electrical Control Enclosure Assembly (See Detail)	1
20	1008451	. Support Bracket	1
21	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	1
22	199965	. Washer, Flat M6	2
23	199347	. Washer, Lock M6	1
24	199188	. Nut, Hex. M6-1.0	1
25	167329	. Nylon Clamp	4
26	199728	. Screw, Button Hd. Soc. M4-0.7 x 10	4
27	176768	. Limit Switch (Head Down)	1
28	199439	. Screw, Button Hd. Soc. M4-0.7 x 25	2
29	320597	. Bracket	1
30	199974	. Screw, Button Hd. Soc. M5-1.0 x 10	2
31	197332	. Electrical Cord (#18-2 Conductor)	A.R.
32	1008674	. Label (Limit Switch- Specify Number)	3
33	016561	. Nylon Clamp	1
34	197388	. Wire Wrap (1" Black Poly)	A.R.
35	107637	. Cable Tie	A.R.
36	177054	. Solenoid Plug Connector Kit (Pneumatic Options Only)	1
37	016560	. Cable Hanger Clamp	1
38	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	1
39	177054	. Solenoid Plug Connector Kit (Pneumatic Options Only)	2
40	207502	. Elevator Bolt M6-1.0 x 25	1
41	199232	. Nut, Hex. Jam M6-1.0	1
Following Not Shown:			
	221545	. Worklamp (Includes Mounting Bracket) (Optional)	1
	199898	. Screw, Soc. Hd. Cap M5-0.8 x 16	2
	199348	. Washer, Lock M5	2

NEW DRG. S.C.L. 3-6-13
REVISIONS



MODEL	FIRST MACH.	LAST MACH.
400M	596-13295	
400S	597-13260	

ELECTRICAL ASSEMBLY

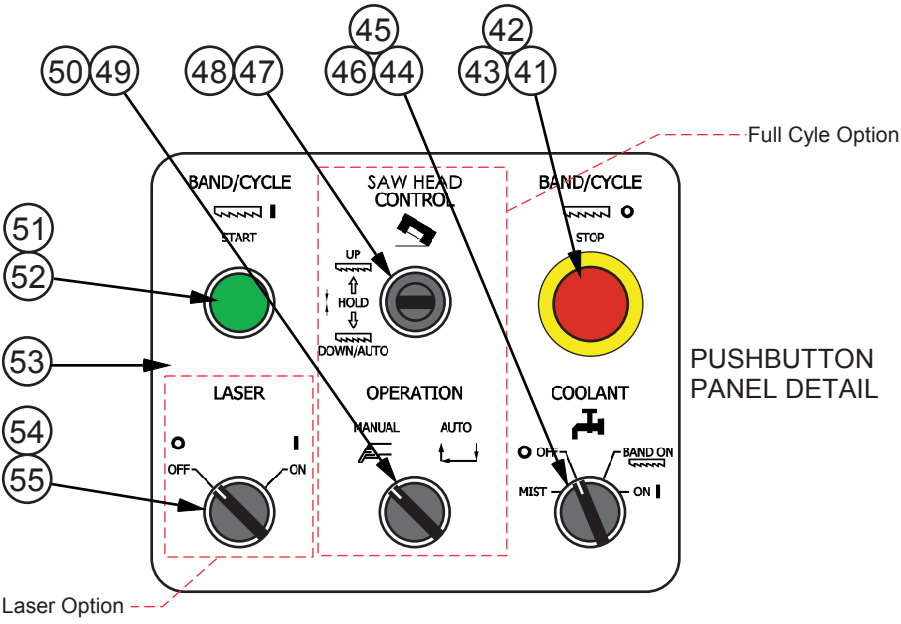
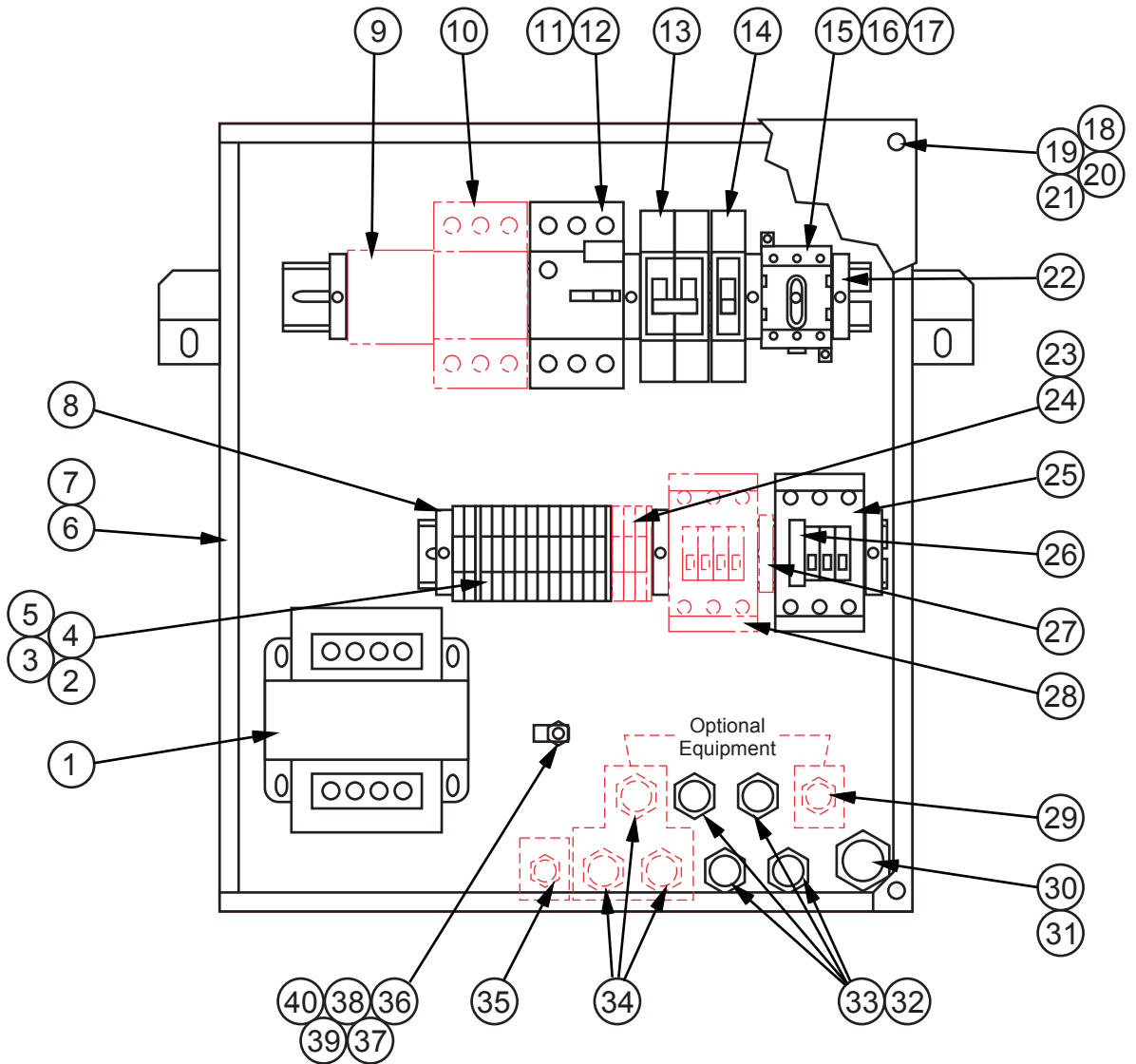
ELECTRICAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Assembly	
1	215624	. Limit Switch (Door Interlock)	2
2	199389	. Screw, Button Hd. Soc. M4-0.7 x 30	4
3	215619	. Cord Grip Connector (.236-.472)	2
4	197332	. Electrical Cord (#18-2 Conductor)	A.R.
5	221855	. Interlock Key Bracket	2
6	199728	. Screw, Button Hd. Soc. M4-0.7 x 10	8
7	199214	. Nut, Hex. M4-0.7	4
8	199248	. Washer, Flat M4	A.R.
9	015780	. Rubber Grommet	1
10	016160	. 90° Cord Grip Connector	1
11	014411	. Flange Washer	1
12	019543	. Bond Nut	1
13	176528	. Label (Electrical Hazard)	1
14	197218	. Electrical Cord (#14-4 Conductor)	A.R.
	197219	. Electrical Cord (#14-3 Conductor) (Single Phase Motors Only)	A.R.
15	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
16	199347	. Washer, Lock M6	2
17	199188	. Nut, Hex. M6-1.0	2
18	176528	. Label (Electrical Hazard)	1
19		. Electrical Control Enclosure Assembly (See Detail)	1
20	1008451	. Support Bracket	1
21	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	1
22	199965	. Washer, Flat M6	2
23	199347	. Washer, Lock M6	1
24	199188	. Nut, Hex. M6-1.0	1
25	167329	. Nylon Clamp	4
26	199728	. Screw, Button Hd. Soc. M4-0.7 x 10	4
27	176768	. Limit Switch (Head Down)	1
28	199439	. Screw, Button Hd. Soc. M4-0.7 x 25	2
29	320597	. Bracket	1
30	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
31	197332	. Electrical Cord (#18-2 Conductor)	A.R.
32	1008674	. Label (Limit Switch- Specify Number)	3
33	016561	. Nylon Clamp	1
34	197388	. Wire Wrap (1" Black Poly)	A.R.
35	107637	. Cable Tie	A.R.
36	177054	. Solenoid Plug Connector Kit (Pneumatic Options Only)	1
37	016560	. Cable Hanger Clamp	1
38	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	1
39	177054	. Solenoid Plug Connector Kit (Pneumatic Options Only)	2
40	207502	. Elevator Bolt M6-1.0 x 25	1
41	199232	. Nut, Hex. Jam M6-1.0	1
42	1007745	. Consolelet Weldment	1
43	1008739	. Back Cover	1
44	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
45	197158	. Sealtite Conduit 3/4 I.D.	A.R.
46	014485	. 45° Sealtite Connector	1
47	014480	. Flange Washer	1
48	014772	. Plastic Insulated Bushing	1
49	207170	. Screw, Hex. Hd. Slotted M5-0.8 x 20	2
50	204152	. Nylon Washer	2
51	207171	. Rivet Nut M5-0.8	2
52	204150	. Retainer Ring	2
53	1014454	. Enclosure Weldment	1
54	203925	. Gasket strip	A.R.
55	199202	. Nut, Hex. M5-0.8	4
56	199244	. Washer, Flat M5	4
57	199348	. Washer, Lock M5	4
58		. Pushbutton Panel Detail (See Detail)	1

Following Not Shown:

221545	. Worklamp (Includes Mounting Bracket) (Optional)	1
199898	. Screw, Soc. Hd. Cap M5-0.8 x 16	2
199348	. Washer, Lock M5	2

NEW DRG.
S.C.L. 3-22-10
REVISIONS
S.C.L. 3-8-11
S.C.L. 5-3-11
S.C.L. 3-6-13



LAYOUT MAY VARY!
CHECK YOUR ELECTRICAL
SCHEMATIC.

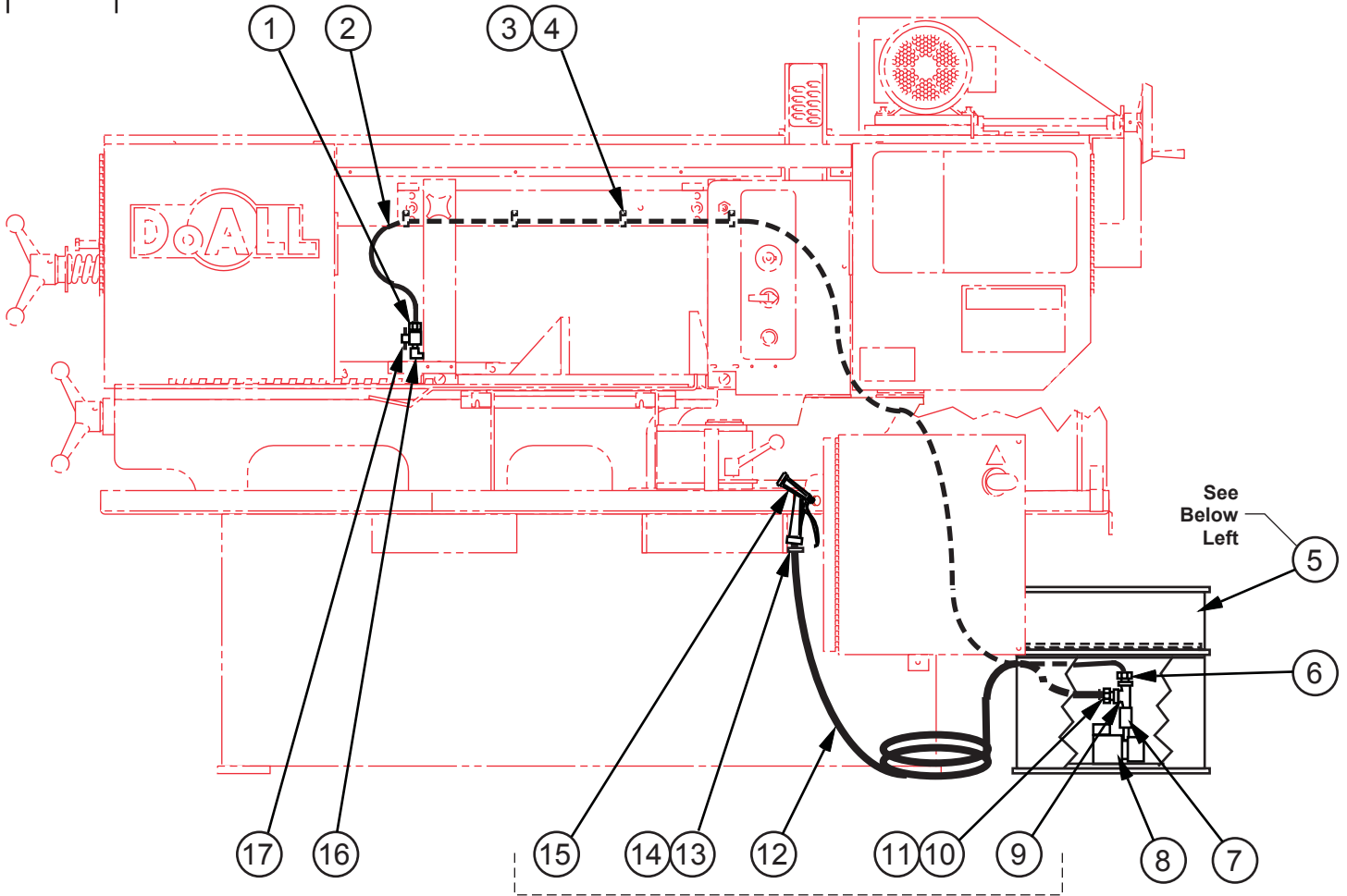
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-10101	

ELECTRICAL CONTROL BOX ASSEMBLY

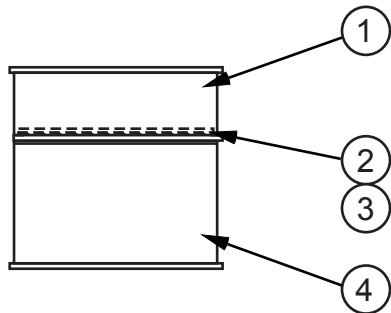
ELECTRICAL CONTROL BOX ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control Box Assembly		41	207184	. Selector Switch (4 Position)	1
1	320079	. Transformer (200V, 208V, 400V)	1	42	207186	. Contact Block (1-NC)	2
	320078	. Transformer (220V-1 Phase, 230V, 460V, 575V)	1	43	207187	. Contact Block (1-NO, 1-NC)	1
	323468	. Transformer (400V-Europa Only)	1	44	207191	. Pushbutton Operator (Red Mushroom)	1
2	200615	. Terminal Block	12	45	207186	. Contact Block (1-NC)	1
3	200617	. End Section	2	46	200093	. E-Stop Marker	1
4	202922	. Jumper Bar	1	47*	207182	. Selector Switch (3 Position) (Full Cycle Option)	1
5	224775	. Terminal Marker Set	1	48*	211500	. Contact Block (2-NO)	2
6	522930**	. Enclosure Weldment	1	49	207181	. Selector Switch (2 Position)	1
	1010345	. Enclosure Weldment (Europa Only)	1	50	207185	. Contact Block (1-NO)	1
7	203925	. Gasket Strip	A.R.	51	207190	. Pushbutton Operator (Green)	1
8	200618	. End Stop	4	52	207185	. Contact Block (1-NO)	1
9	207200	. Control Relay (Full Cycle Option)	1	53	1008674	. Escutcheon	1
10	220642	. Motor Starter Protector (400V-Europa)	1	54	207181	. Selector Switch (2 Position)	1
11	220648	. Motor Starter Protector (200V)	1	55	207185	. Contact Block (1-NO)	1
	220647	. Motor Starter Protector (208V, 230V) ..	1			Following Not Shown:	
	220648	. Motor Starter Protector (208V, 230V) (Low Speed Option)	1	1008846		. CB and MSP Schedule	1
	220649	. Motor Starter Protector (220V- 1 Phase)	1	224717		. CB and MSP Schedule (Europa Only) .	1
	220646	. Motor Starter Protector (400V, 460V, 575V)	1	197158		. Sealtite Conduit 3/4 I.D.	A.R.
12	220654	. Auxiliary Contact (1-NO)	1	014686		. Sealtite Connector	1
13	1007400	. Circuit Breaker (200V, 208V)	1	014480		. Flange Washer	1
	1007399	. Circuit Breaker (220V-1 Phase, 230V)	1	135106		. Hole Seal	A.R.
	1007397	. Circuit Breaker (400V, 460V)	1	203542		. Wire Terminal #4	6
	215212	. Fuse Holder (575V Only)	2	207111		. Wire Terminal Locking Fork #8	12
	203158	. Fuse (1 Amp) (575V Only)	2	007635		. Wire Terminal Ring #10	A.R.
14	420357	. Circuit Breaker	1	201679		. Wire Terminal Receptacle	4
15	1007434	. Disconnect Switch	1	197339		. Wire, #14 Black (19 Strand)	A.R.
16	1007441	. Disconnect Switch Shaft	1	197195		. Wire, #14 Green/Yellow (19 Strand)	A.R.
17	1007437	. Disconnect Switch Handle	1	197197		. Wire, #16 Red (19 Strand)	A.R.
18	207170	. Screw, Hex. Hd. Slotted M5-0.8 x 20 ...	2	197325		. Wire, #16 White (19 Strand)	A.R.
19	207171	. Rivet Nut M5-0.8	2	197205		. Wire, #18 Blue (16 Strand)	A.R.
20	204150	. Retainer Ring	2			*NOTE: Before Serial #596-11149 on 400M, #597-11136 on 400S; Order Full Cycle Switch Assembly - #224684 to Replace.	
21	204152	. Nylon Washer	2			**NOTE: Before Serial #596-13295 on 400M, #597-13260 on 400S;	
22	200618	. End Stop	4	6	1011168	. Enclosure Weldment	1
23	209033	. Terminal Block (Laser Option)	3				
24	209034	. End Section (Laser Option)	1				
25	207206	. Contactor (200V, 208V, 230V, 400V, 460V, 575V)	1				
	207207	. Contactor (220-1 Phase)	1				
26	207219	. Auxiliary Contact	1				
27	207221	. Auxiliary Contact (Full Cycle Option) ...	1				
28	207206	. Contactor (400V-Europa Only)	1				
29	201686	. Cord Grip Connector (.157-.314) (Mist Lube Option)	1				
30	201687	. Cord Grip Connector (.545-.709)	1				
31	197218	. Electrical Cord (#14-4 Conductor)	A.R.				
	197219	. Electrical Cord (#14-3 Conductor) (1 Phase Only)	A.R.				
32	201688	. Cord Grip Connector (.200-.394)	4				
33	197332	. Electrical Cord (#18-2 Conductor)	A.R.				
34	201688	. Cord Grip Connector (.200-.394) (Full Cycle and/or Worklamp Options)	A.R.				
35	201686	. Cord Grip Connector (.157-.314) (Laser Option)	1				
36	139194	. Wire Terminal	1				
37	199312	. Screw, Pan Hd. Slotted M5-0.8 x 30	1				
38	199244	. Washer, Flat M5	1				
39	199089	. Washer, Lock M5 Shakeproof	A.R.				
40	199202	. Nut Hex. M5-0.8	A.R.				

NEW DRG. S.C.L. 3-22-10
REVISIONS



FLUSHING HOSE ASSEMBLY
(OPTIONAL - 400M, 400S; STANDARD - 400A)



COOLANT RESERVOIR ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

FLOOD COOLANT ASSEMBLY

FLOOD COOLANT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1008849	Flood Coolant Assembly	
1	016001	. Barbed Insert	1
2	197144	. Plastic Tubing 1/4 I.D. (Clear)	A.R.
3	009955	. Tubing Clamp.....	A.R.
4	199974	. Screw, Button Hd. Soc.M5-0.8 x 10	A.R.
5	1007881	. Coolant Reservoir Assembly (See Detail)	1
6	103316	. Barbed Insert	1
7	204233	. Pipe Coupling (Brass)	1
8	110263	. Coolant Pump (110/120V, 50/60 Hz)	1
	136530	. Coolant Pump (220/240V, 50/60 Hz)	1
	172623	. Coolant Pump (CSA Approved)	1
9*	120857	. Service Tee (Brass)	1
10*	002004	. Barbed Insert	1
11*	017902	. Hose Clamp	1
12*	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
13*	176816	. Barbed Insert (Plastic)	1
14*	176827	. Hose Clamp	1
15*	176420	. Hoze Nozzle	1
16	5-027506	. 90° Street Elbow (Brass)	1
17	120241	. Valve	1

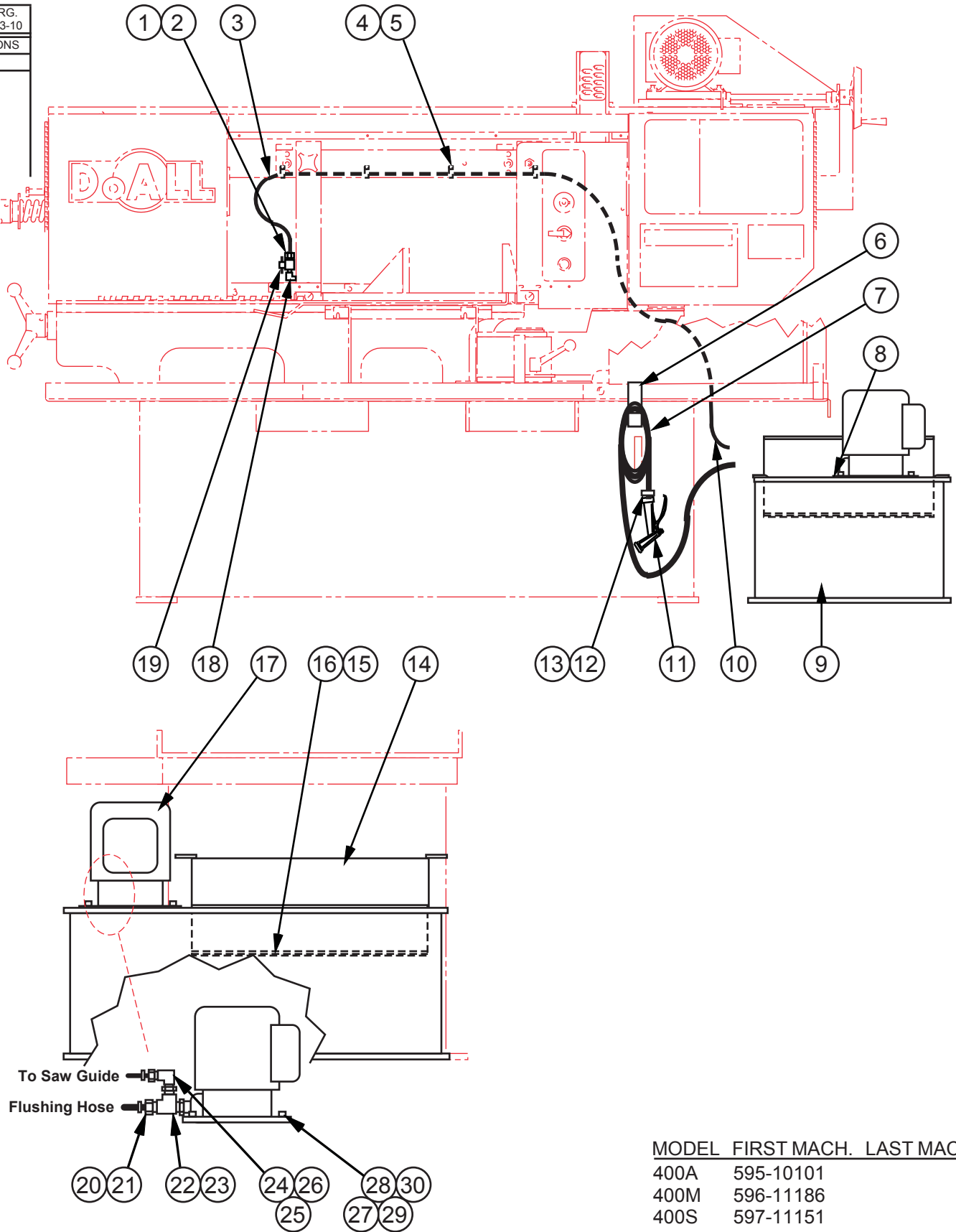
*NOTE: Part of Flushing Hose Assembly - #178639. (Optional 400M, 400S; Standard 400A)

Ref.	1007881	. Coolant Reservoir Assembly	
1	1007898	. . Chip Container	1
2	1007883	. . Screen/Filter Cover	1
3	1007882	. . Screen/Filter	1
4	1008539	. . Coolant Reservoir	1

Following Not Shown:

214769	. Cutting Fluid (Power-Cut Concetrate; 1 Quart)	1
--------	---	---

NEW DRG.
S.C.L. 6-3-10
REVISIONS



To Saw Guide
Flushing Hose

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-11186	
400S	597-11151	

FLOOD COOLANT ASSEMBLY (EUROPA ONLY)

**FLOOD COOLANT ASSEMBLY
(Europa Only)**

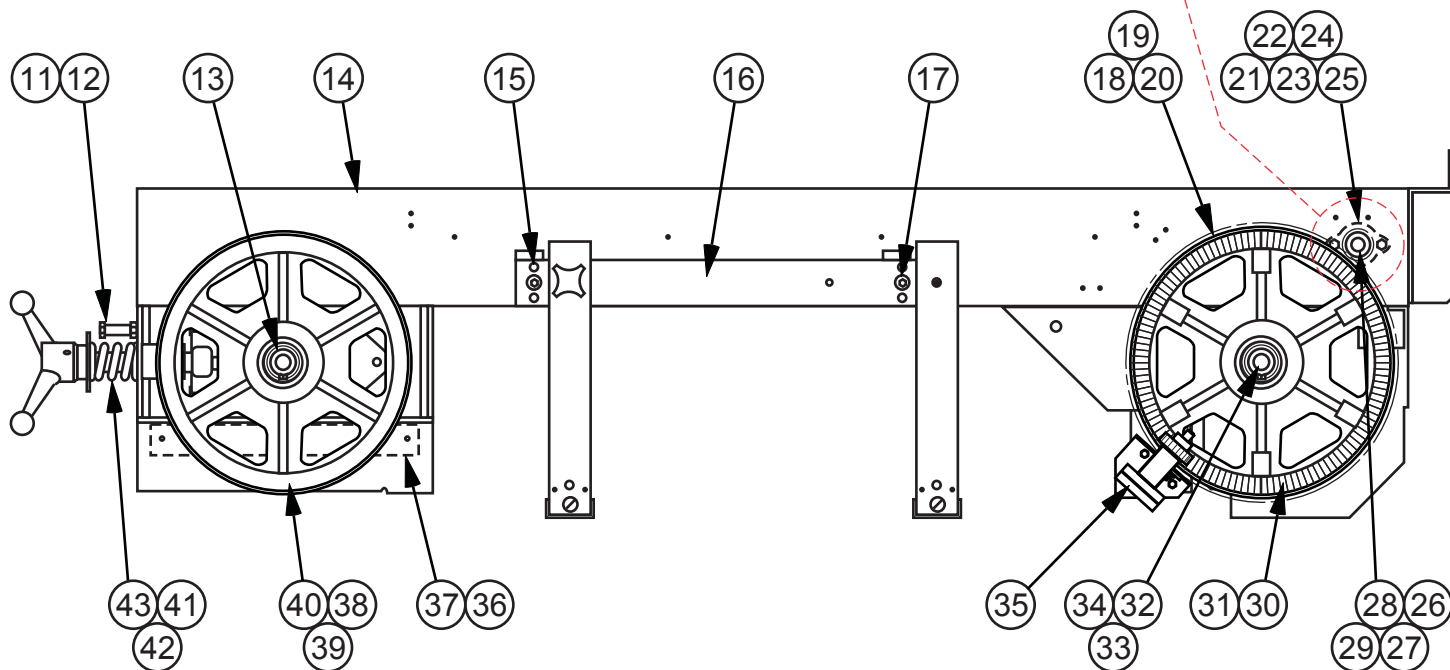
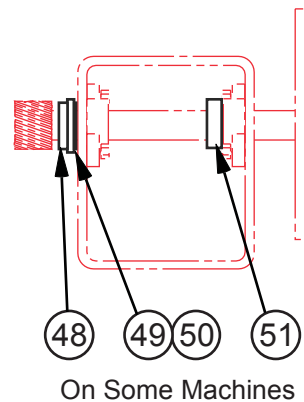
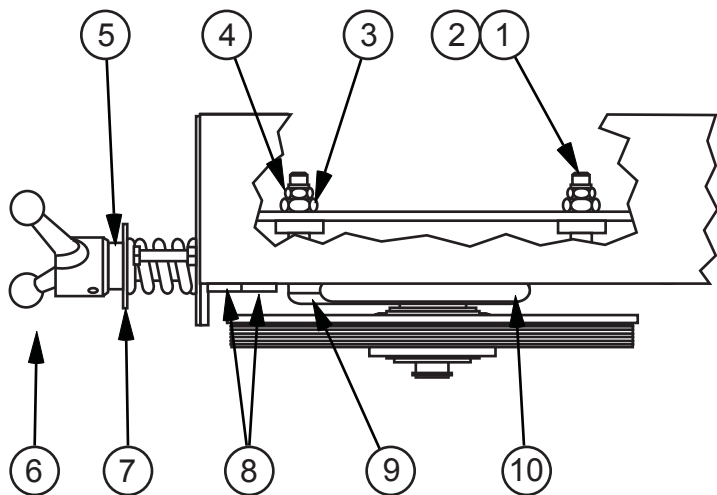
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1012934	Flood Coolant Assembly (Europa Only)	
1	016001	. Barbed Insert	1
2	1008570	. Hose Clamp	1
3	197095	. Plastic Tubing 1/4 I.D. (Clear-Reinforced)	A.R.
4	009955	. Tubing Clamp.....	A.R.
5	199974	. Screw, Button Hd. Soc.M5-0.8 x 10	A.R.
6*	316116	. Hook	1
7*	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
8	1012942	. Pump Mounting Plate (for .25 HP Coolant Pump)	1
	1011856	. Pump Mounting Plate (for .3 HP Coolant Pump)	1
9	1007897	. Coolant Reservoir	1
10	197095	. Plastic Tubing 1/4 I.D. (Clear-Reinforced)	A.R.
11*	176420	. Hoze Nozzle	1
12*	176816	. Barbed Insert (Plastic)	1
13*	176827	. Hose Clamp	1
14	1011897	. Chip Container Weldment	1
15	1011859	. Screen/Filter Cover	1
16	1011858	. Screen/Filter	1
17	224711	. Coolant Pump (.25 HP; 50 Hz)	1
	224710	. Coolant Pump (.3 HP; 50 Hz)	1
18	5-027506	. 90° Street Elbow (Brass)	1
19	120241	. Shut-Off Valve	1
20	009667	. Barbed Insert	1
21	176827	. Hose Clamp	1
22	133540	. Service Tee	1
23	017535	. Reducer Bushing	1
24	017537	. Reducer Bushing	1
25	133439	. 90° Barbed Insert	1
26	1008570	. Hose Clamp	1
27	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	4
28	199347	. Washer, Lock M6	4
29	199965	. Washer, Flat M6	4
30	199188	. Nut, Hex. M6-1.0	4

*NOTE: Part of Optional Flushing Hose Assembly - #178639.

Following Not Shown:

214769	. Cutting Fluid (Power-Cut Concentrate; 1 Quart)	2
--------	--	---

NEW DRG.
S.C.L. 2-22-10
REVISIONS
S.C.L. 3-10-14

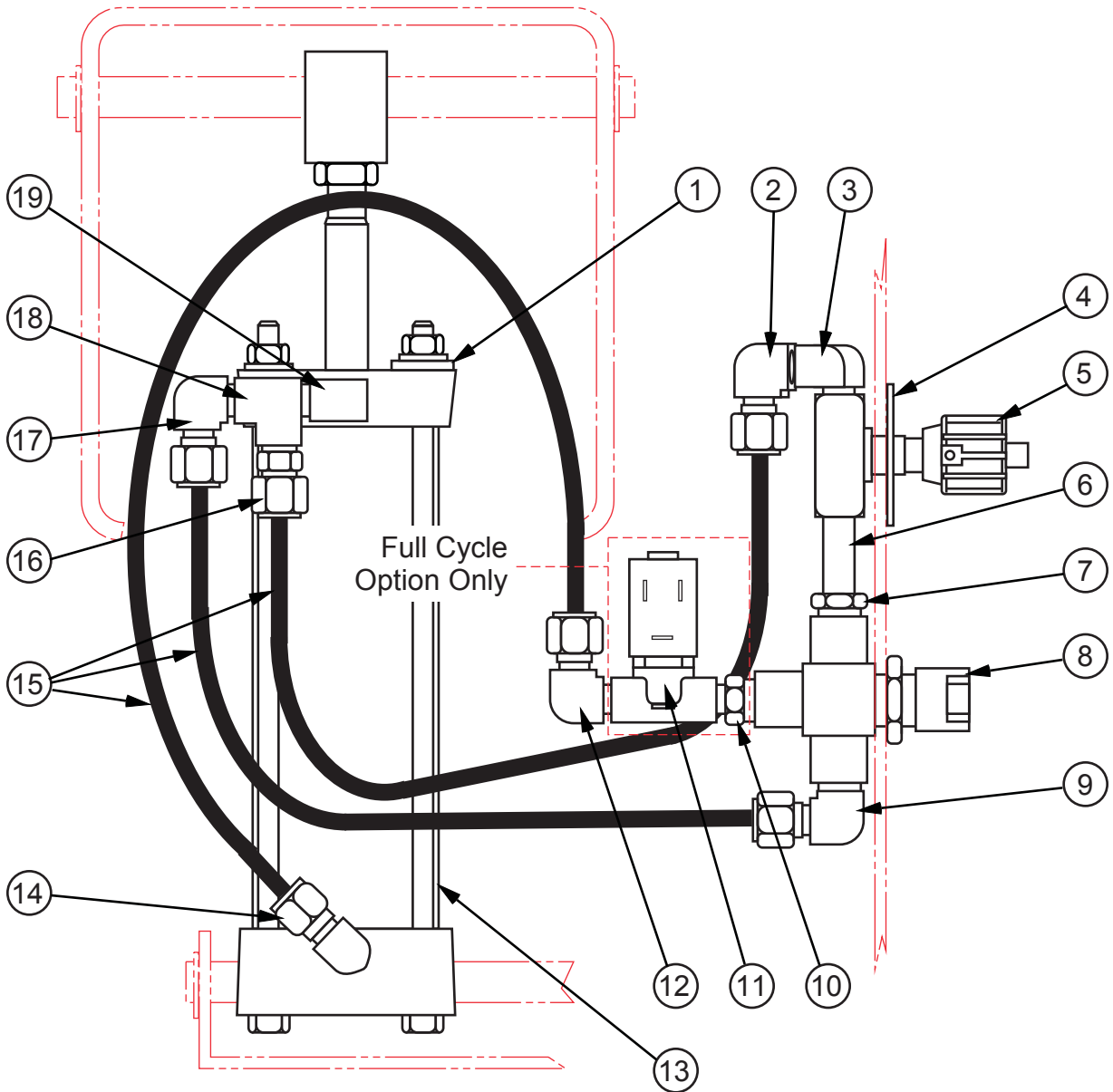


MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

HEAD ASSEMBLY

HEAD ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Head Assembly	
1	199980	. Screw, Soc. Hd. Cap M10-1.5 x 80	3
2	199346	. Washer, Lock M10	3
3	199142	. Nut, Hex. Jam 3/4-16NF	3
4	005956	. Adjusting Screw 3/4-16NF x 2-5/16 (.42 Dia.)	3
5	108749	. Thrust Ball Bearing	1
6	1008019	. Band Tension Handle Assembly	1
	1008020	. . Handle	1
	1009977	. . Bandwheel Screw	1
	004277	. . Spring Pin	1
7	149978	. Washer	1
8	157703	. Rubber Bushing	2
9	513889	. Head Slide and Shaft Sub-Assembly	1
	316591	. . Idler Shaft	1
	199227	. . Screw, Soc. Set M10-1.5 x 16 (Cone Point)	1
	202383	. . Loctite Adhesive (#242)	A.R.
10	517542	. Head Casting	1
11	199238	. Screw, Hex. Hd. Cap M10-1.5 x 60	1
12	199939	. Nut, Hex. M10-1.5	1
13	204455	. Retaining Ring	1
14	1009195	. Head Weldment	1
15	199559	. Screw, Soc. Set M12-1.75 x 25 (Flat Point)	4
16	225521	. Saw Guide Arm Assembly (See Detail)	1
17	199918	. Screw, Soc. Hd. Cap M12-1.75 x 45	2
18	317088	. Bandwheel Assembly (Driver)	1
	505879	. . Bandwheel (Driver)	1
	137905	. . Ball Bearing	2
19	122652	. Shim (.010)	A.R.
20	122653	. Shim (.020)	A.R.
21	1008462	. Flange Bearing	2
22	198167	. Screw, Hex. Hd. Cap M8-1.25 x 40	2
23	199968	. Washer, Lock M8	2
24	199941	. Nut, Hex. M8 x 1.25	2
25	199967	. Washer, Flat M8	2
26	132475	. Pinion Gear	1
27	35-008688	. Retaining Ring	1
28	1008794	. Pinion Shaft	1
29	014214	. Key	1
30	1009188	. Door Support	1
31	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	5
32	320598	. Drive Shaft	1
33	199251	. Screw, Soc. Set M10-1.5 x 12 (Cone Point)	1
34	204455	. Retaining Ring	1
35	417836	. Band Brush Assembly (Powered) (See Detail)	1
36	206885	. Bar	1
37	199041	. Screw, Soc. Hd. Cap M5-0.8 x 20	2
38	176858	. Bandwheel Assembly (Idler)	1
	503489	. . Bandwheel (Idler)	1
	137905	. . Ball Bearing	2
39	122652	. Shim (.010)	A.R.
40	122653	. Shim (.020)	A.R.
41	108750	. Compression Spring	1
42	108748	. Tube	1
43	199306	. Washer, Flat 3/4 Wrought	1



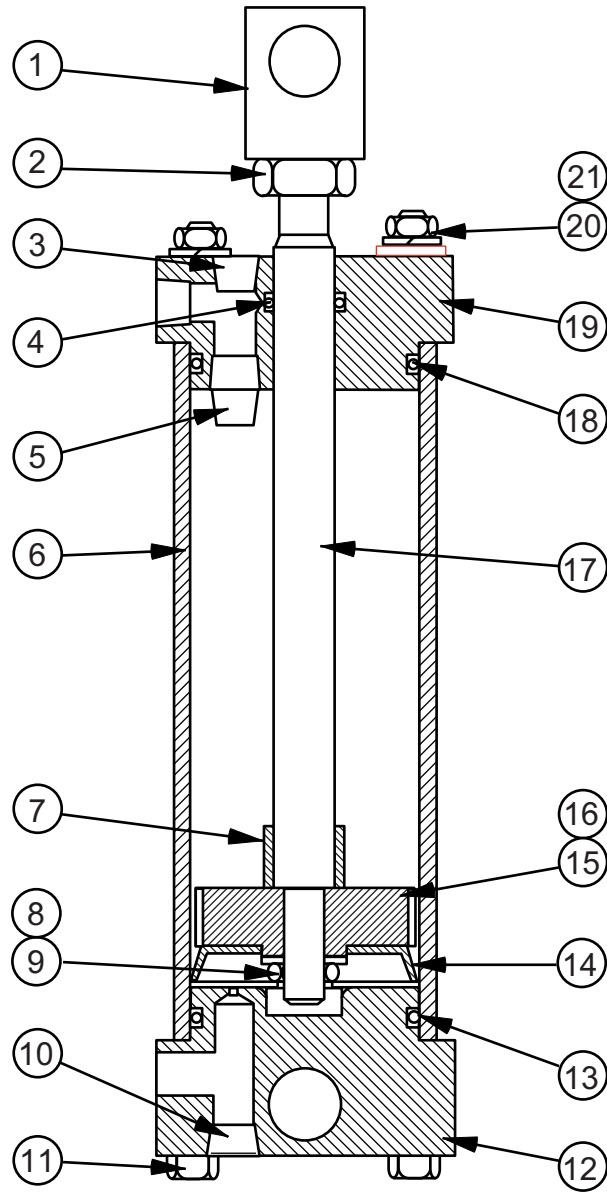
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-09101	

HEAD FEED CONTROL ASSEMBLY

HEAD FEED CONTROL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1009700	Head Feed Control Assembly (Standard)	
Ref.	1009699	Head Feed Control Assembly (Full Cycle Option)	
1	207503	. Actuator Bracket	1
2	6-023510	. 90° Male Elbow (Brass)	1
3	5-027506	. 90° Street Elbow	1
4	1002272	. Spacer	1
5	201987	. Needle Valve	1
6	203144	. Close Nipple (Brass)	1
7	260426	. Reducer Bushing	1
8	219430	. Solenoid Valve (3-Way)	1
9	175279	. 90° Male Elbow (Brass)	1
10	010923	. Hex. Nipple (Full Cycle Option)	1
11	224061	. Solenoid Valve (2-Way) (Full Cycle Option)	1
12	175279	. 90° Male Elbow (Brass) (Standard)	1
	6-023510	. 90° Male Elbow (Brass) (Full Cycle Option)	1
13	416087	. Head Feed Cylinder Assembly (See Detail)	1
14	6-023510	. 90° Male Elbow (Brass)	1
15	197264	. Nylon Tubing 1/4 O.D.	A.R.
16	6-023509	. Male Connector	1
17	6-023510	. 90° Male Elbow (Brass)	1
18	112043	. Street Tee	1
19	5-027506	. 90° Street Elbow	1
Following Not Shown:			
	201030	. Transmission Fluid (ATF)	A.R.

NEW DRG. S.C.L. 3-22-10
REVISIONS



MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

HEAD FEED CYLINDER ASSEMBLY

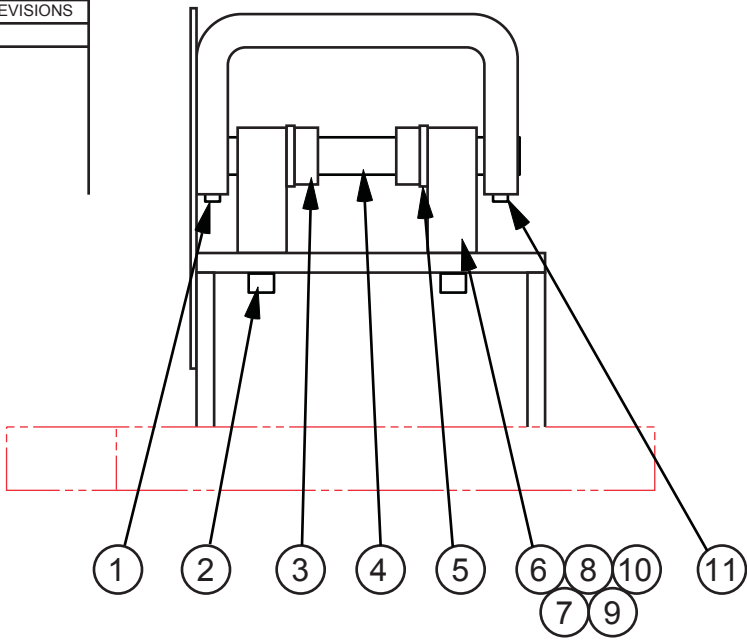
PS - 7 - 389

PRINTED IN U.S.A.

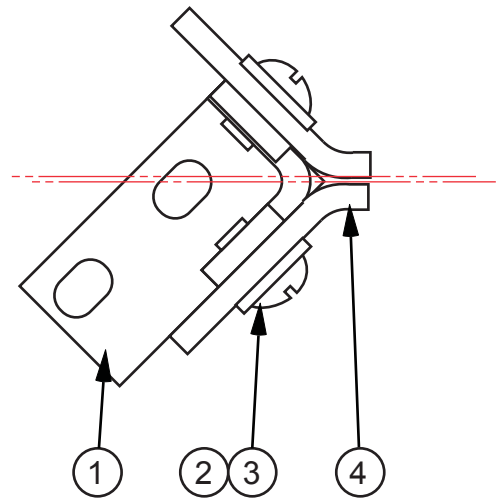
HEAD FEED CYLINDER ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	416087	Head Feed Cylinder Assembly	
1	175273	. Lug	1
2	199130	. Nut, Hex. Jam 7/16-14NC	1
3	123333	. Pipe Plug	1
4	203799	. Quad Ring	1
5	14-014528	. Close Nipple	1
6	316346	. Cylinder	1
7	175586	. Spacer	1
8	013245	. Locknut 3/8-16NC	1
9	199302	. Washer, Flat 3/8 Wrought	1
10	261233	. Pipe Plug	1
11	175476	. Tie Rod	4
12	316349	. End Cap	1
13	001508	. O-Ring	1
14	204981	. Piston Seal Cup	1
15	319876	. Piston	1
16	202383	. Adhesive Sealant (Loctite #242-31 Threadlok)	A.R.
17	319533	. Rod	1
18	001508	. O-Ring	1
19	316348	. End Cap	1
20	199176	. Nut, Hex. 1/4-20NC	4
21	199321	. Washer, Lock 1/4 Std.	4

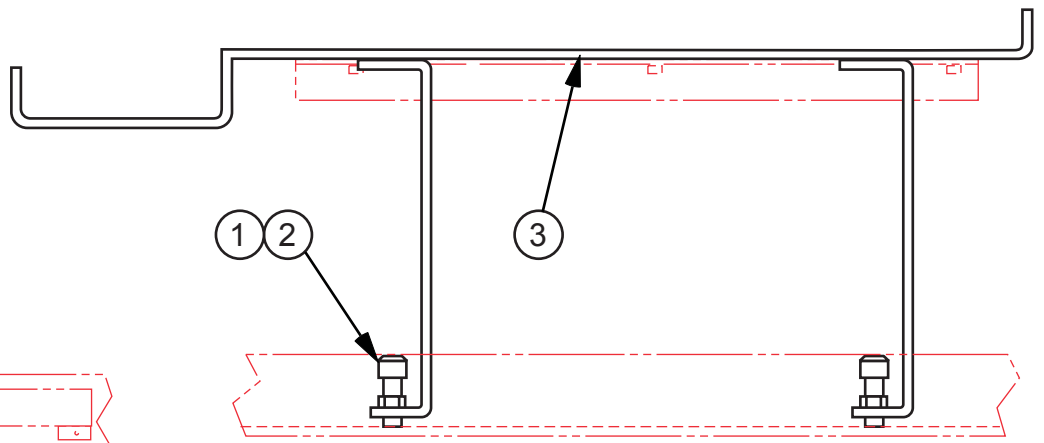
NEW DRG.
S.C.L. 2-22-10
REVISIONS



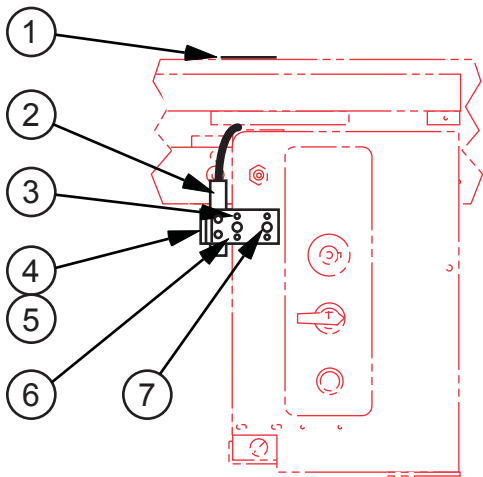
HEAD PIVOT DETAIL



BAND WIPER ASSEMBLY



DISCHARGE TRAY ASSEMBLY
(LARGE)
(OPTIONAL) (400S, 400M Only)



LASER LINE GENERATOR ASSEMBLY
(OPTIONAL)

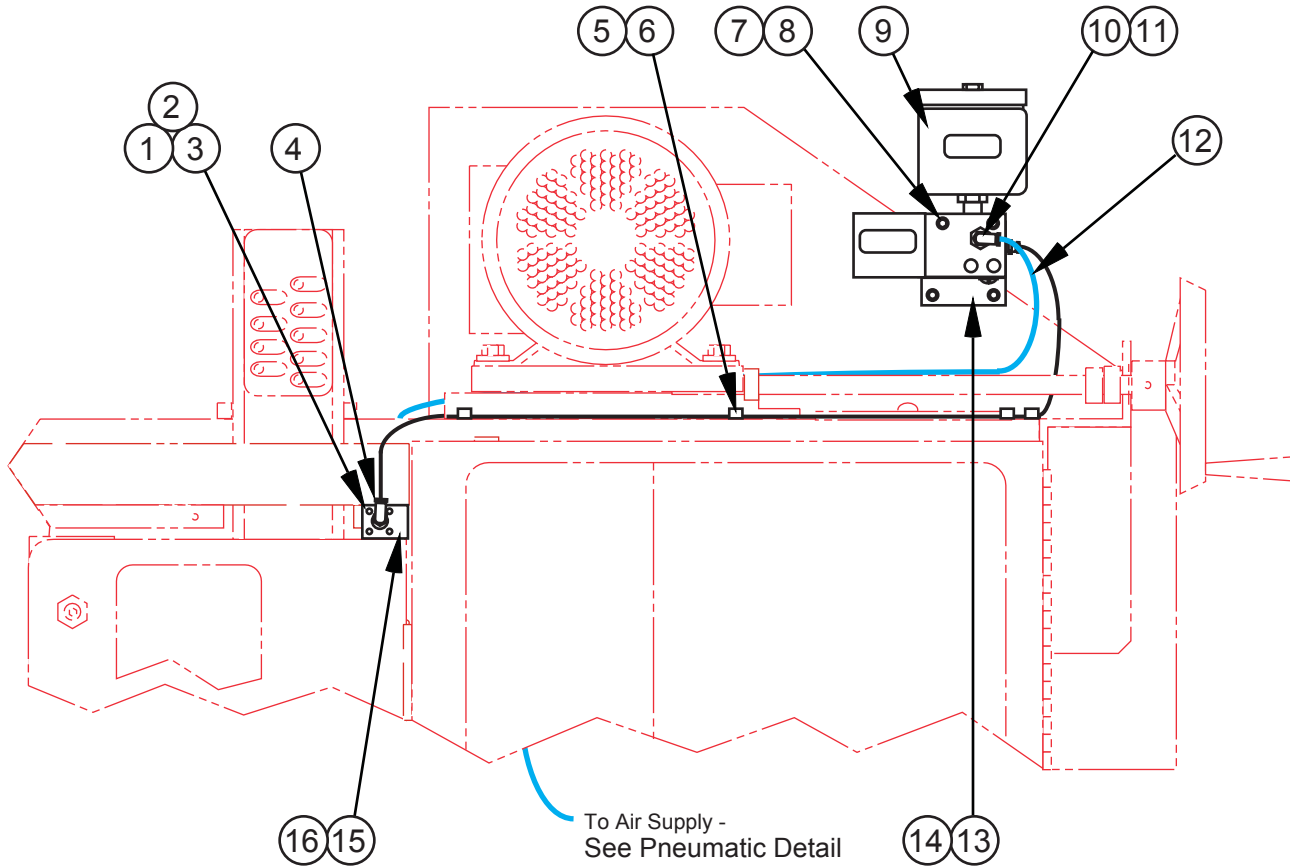
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

MISCELLANEOUS DETAILS

MISCELLANEOUS DETAILS

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Final Assembly (Head Pivot Detail)	
1	199251	. Screw, Soc. Set M10-1.5 x 12 (Cone Point)	1
2	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30	4
3	201915	. Shaft Collar	2
4	176717	. Pivot Shaft	1
5	126535	. Thrust Bearing (Bronze)	2
6	326124	. Bearing Block	2
	201914	. Sleeve Bearing (Press Fit)	2
7	176476	. Shim (.003)	A.R.
8	176477	. Shim (.005)	A.R.
9	176478	. Shim (.007)	A.R.
10	221783	. Shim (.0478)	A.R.
11	199045	. Screw, Soc. Set M10-1.5 x 16	1
Ref.	207716	Band Wiper Assembly	
1	320621	. Bracket	1
2	199408	. Screw, Pan Hd. Slotted M4-0.7 x 10	4
3	109942	. Support	2
4	109941	. Wiper	2
Ref.	1009399	Discharge Tray Assembly (Large) (Optional) (400S, 400M Only)	
1	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30	2
2	199976	. Nut, Hex. Jam M10-1.5	2
3	1008600	. Discharge Tray Weldment	1
Ref.	1010980M	Laser Line Generator Assembly (Optional)	
1	212884	. Label (Laser - Warning)	1
2	1010956	. Laser Line Generator	1
3	199914	. Screw, Soc. Set M5-0.8 x 10	4
4	1010818	. Laser Clamp Block	1
5	199041	. Screw, Soc. Hd. Cap M5-0.8 x 20	2
6	1010817	. Laser Mounting Bracket	1
7	199450	. Screw, Soc. Hd. Cap M5-0.8 x 12	2

NEW DRG. S.C.L. 2-22-10
REVISIONS

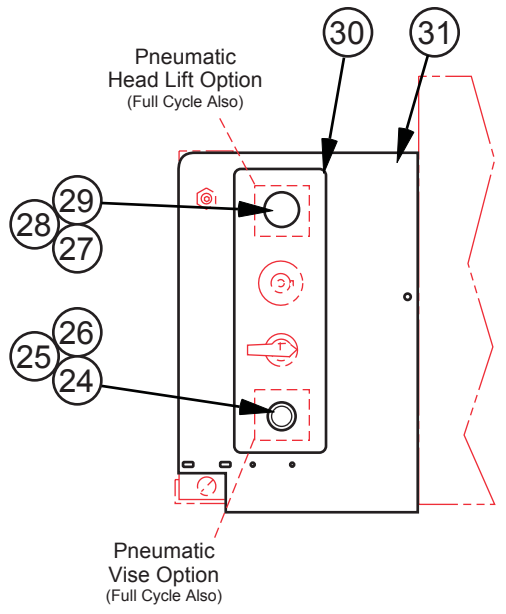
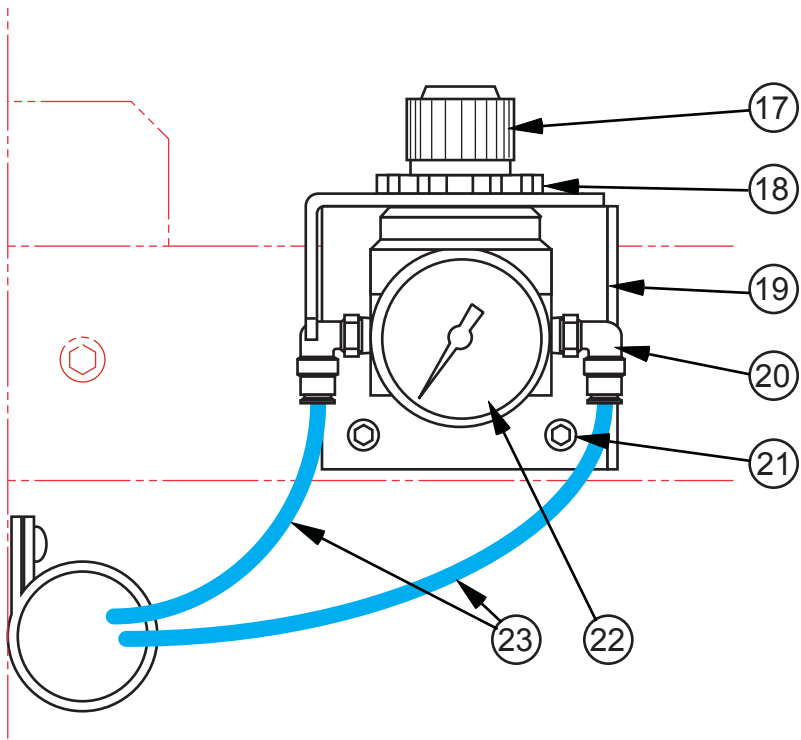
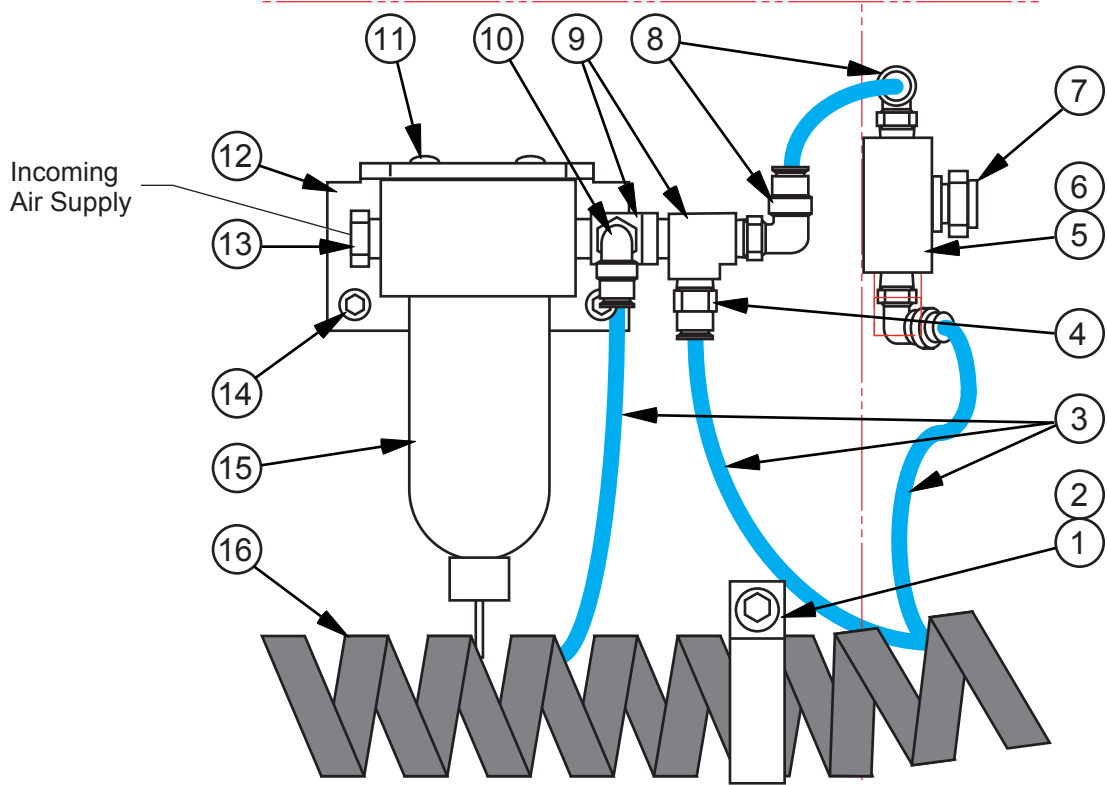


MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

MIST LUBRICATOR ASSEMBLY

MIST LUBRICATOR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	214935	Mist Lubricator Assembly	
1	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4
2	199348	. Washer, Lock M5	4
3	199202	. Nut, Hex. M5-0.8	4
4	200135	. 90° Swivel Male Elbow	1
5	209458	. Clip Half	4
6	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4
7	199824	. Screw, Soc. Hd. Cap M6-1.0 x 55	2
8	199188	. Nut, Hex. M6-1.0	2
9	208833	. Mist Lubricator (Includes Nozzle, Solenoid Valve, Tubing)	1
10	260426	. Reducer Bushing	1
11	200135	. 90° Swivel Male Elbow	1
12	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
13	214906	. Bracket	1
14	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
15	1008707	. Nozzle Bracket	1
16	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
Following Not Shown:			
	214124	. Heavy Duty Cutting Fluid (AL-2000)	A.R.



Some of these parts may not apply to your machine.

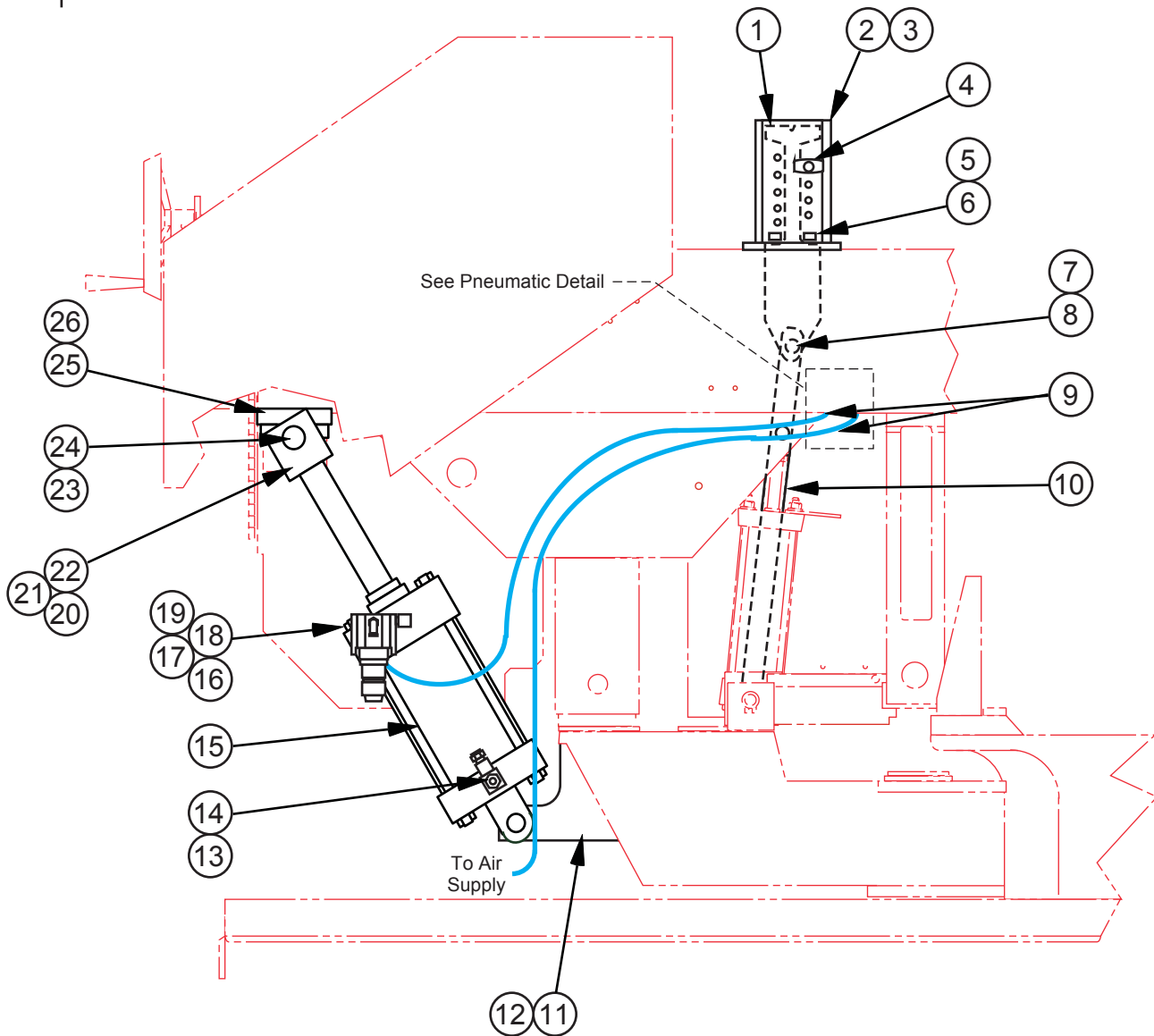
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-09101	

PNEUMATIC DETAIL

PNEUMATIC DETAIL

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Pneumatic Details	
1	009955	. Nylon Clamp	1
2	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	1
3	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
4	200133	. Male Connector	1
5	176829	. Solenoid Valve (3-Way)	1
6	214846	. Screw, Button Hd. Soc. M3-0.5 x 25	2
7	176811	. Vent Filter Breather	1
8	200135	. 90° Swivel Male Elbow	3
9	112043	. Street Tee	2
10	200135	. 90° Swivel Male Elbow	1
11	199464	. Screw, Rd. Hd. Self-Tap #8-32NC x 3/8	2
12	324821	. Filter Mounting Bracket	1
13	260426	. Reducer Bushing	1
14	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
15	217843	. Air Filter	1
	217844	. Filter Element	1
16	197388	. Wire Wrap (1" Black Poly)	A.R.
17	206114	. Air Regulator	1
18	206113	. Panel Mounting Nut	1
19	418046	. Regulator Mounting Bracket	1
20	200135	. 90° Swivel Male Elbow	2
21	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
22	200137	. Gauge	1
23	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
24	206110	. Pneumatic Valve (4-Way with Pushbutton)	1
25	176811	. Vent Filter Breather	2
26	200135	. 90° Swivel Male Elbow	3
27	206109	. Pneumatic Valve (3-Way with Pushbutton)	1
28	176811	. Vent Filter Breather	1
29	200135	. 90° Swivel Male Elbow	2
30	1008674	. Escutcheon (Hydraulic Panel)	1
31	1009187	. Control Panel	1
Following Not Shown:			
	176879	. Label (Air Supply Limits)	1

NEW DRG. S.C.L. 3-22-10
REVISIONS



Counterbalance Spring
Removed To Show Detail.

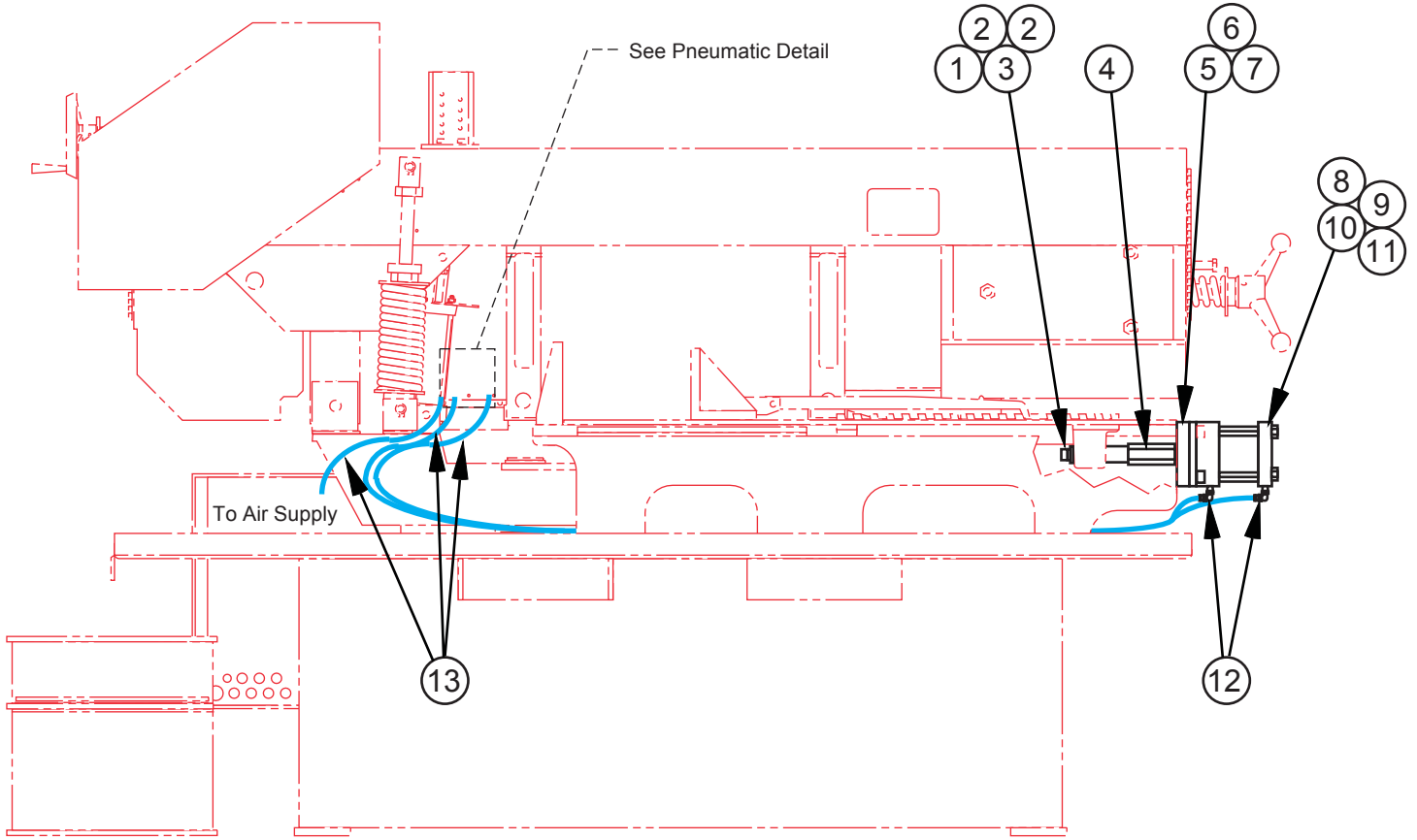
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-10101	

PNEUMATIC HEAD LIFT ASSEMBLY

PNEUMATIC HEAD LIFT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1008817	Pneumatic Head Lift Assembly	
1	319536	. Stop Plate	1
2	1008323	. Lift Stop Slide Weldment	1
3	1008676	. Escutcheon (Head Stops)	1
4	1011410	. Quick Release Pin (3/8 Dia.; T-Handle).....	1
	203146	. Detent Pin (5/16 Dia.; with Ring)	1
5	224156	. Screw, Soc. Hd. Cap M8-1.25 x 12	2
6	199968	. Washer, Lock M8	2
7	1008308	. Lift Stop Pivot Pin	1
8	35-006426	. Retaining Ring	1
9	197438	. Polyethylene Tubing 1/4 O.D. (Blue)	A.R.
10	1008311	. Head Lift Stop Bar	1
11	1013882	. Cylinder Mount Bracket	1
12	199918	. Screw, Soc. Hd. Cap M12-1.75 x 45	2
13	203809	. Right Angle Flow Control Valve	1
14	176811	. Vent Filter Breather	1
15	176228	. Pneumatic Head Lift Cylinder	1
16	206114	. Air Regulator	1
17	203144	. Pipe Nipple (Brass)	1
18	120369	. Pipe Plug	1
19	200135	. 90° Swivel Male Elbow	1
20	316604	. Pivot Bracket	1
21	198186	. Screw, Hex. Hd. Cap 3/4-16NF x 1-1/4	1
22	202383	. Adhesive (Loctite #242-31 Threadlock)	A.R.
23	179586	. Pin	1
24	35-007558	. Retaining Ring	2
25	179584	. Mounting Block Weldment	1
26	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
Following Not Shown:			
	176880	. Tag (Attention - Air Pressure)	1

NEW DRG. S.C.L. 3-22-10
REVISIONS



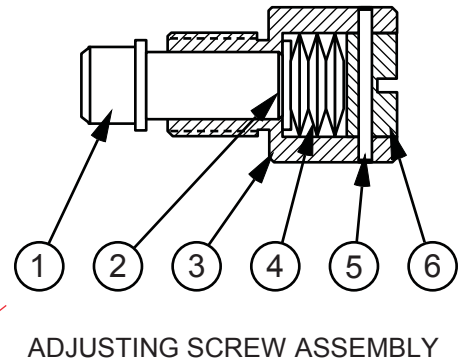
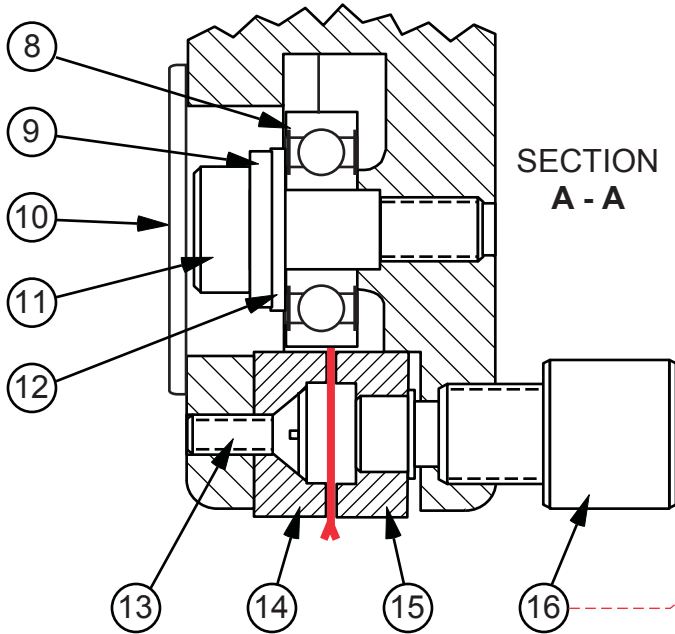
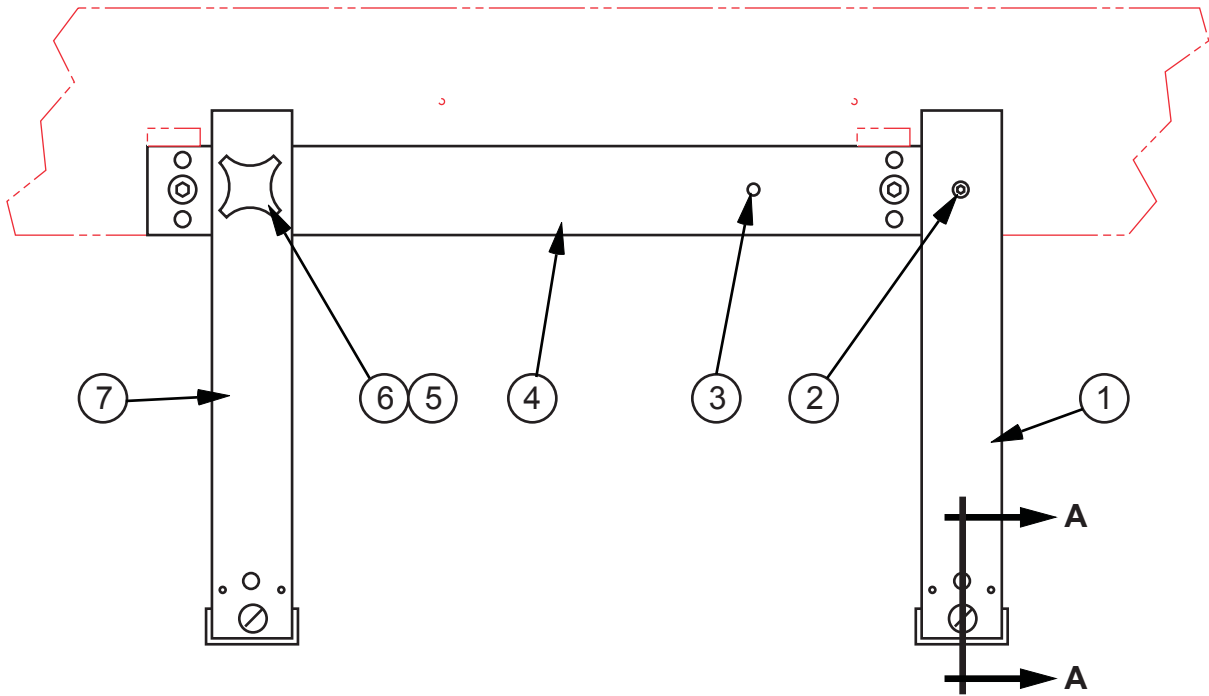
MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-10101	

PNEUMATIC VISE ASSEMBLY

PNEUMATIC VISE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1008208	Pneumatic Vise Assembly	
1	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12	1
2	199254	. Washer, Lock M6 Hi-Collar	1
3	109993	. Washer	1
4	199268	. Washer, Flat 3/4 S.A.E. Std.	1
5	1008204	. Cylinder Adaptor	1
6	1008209	. Spacer	2
7	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	4
8	199346	. Washer, Lock M10	4
9	318130	. Pneumatic Vise Clamp Cylinder	1
10	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	4
11	199346	. Washer, Lock M10	4
12	198976	. Washer, Flat M10	4
13	200135	. 90° Swivel Male Elbow	2
14	197438	. Polyethylene Tubing 1/4 O.D. (Blue)	A.R.

NEW DRG. S.C.L. 3-22-10
REVISIONS
S.C.L. 11-11-11



SAW GUIDE DETAIL - BOTH GUIDES

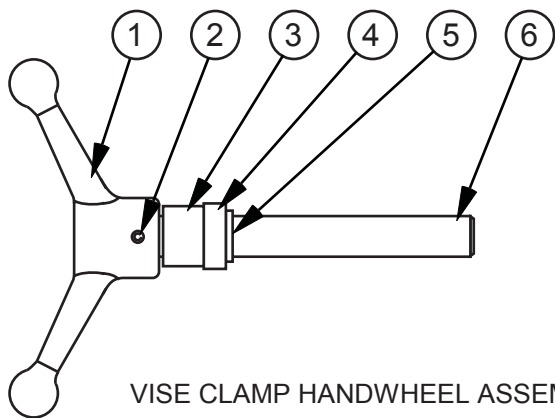
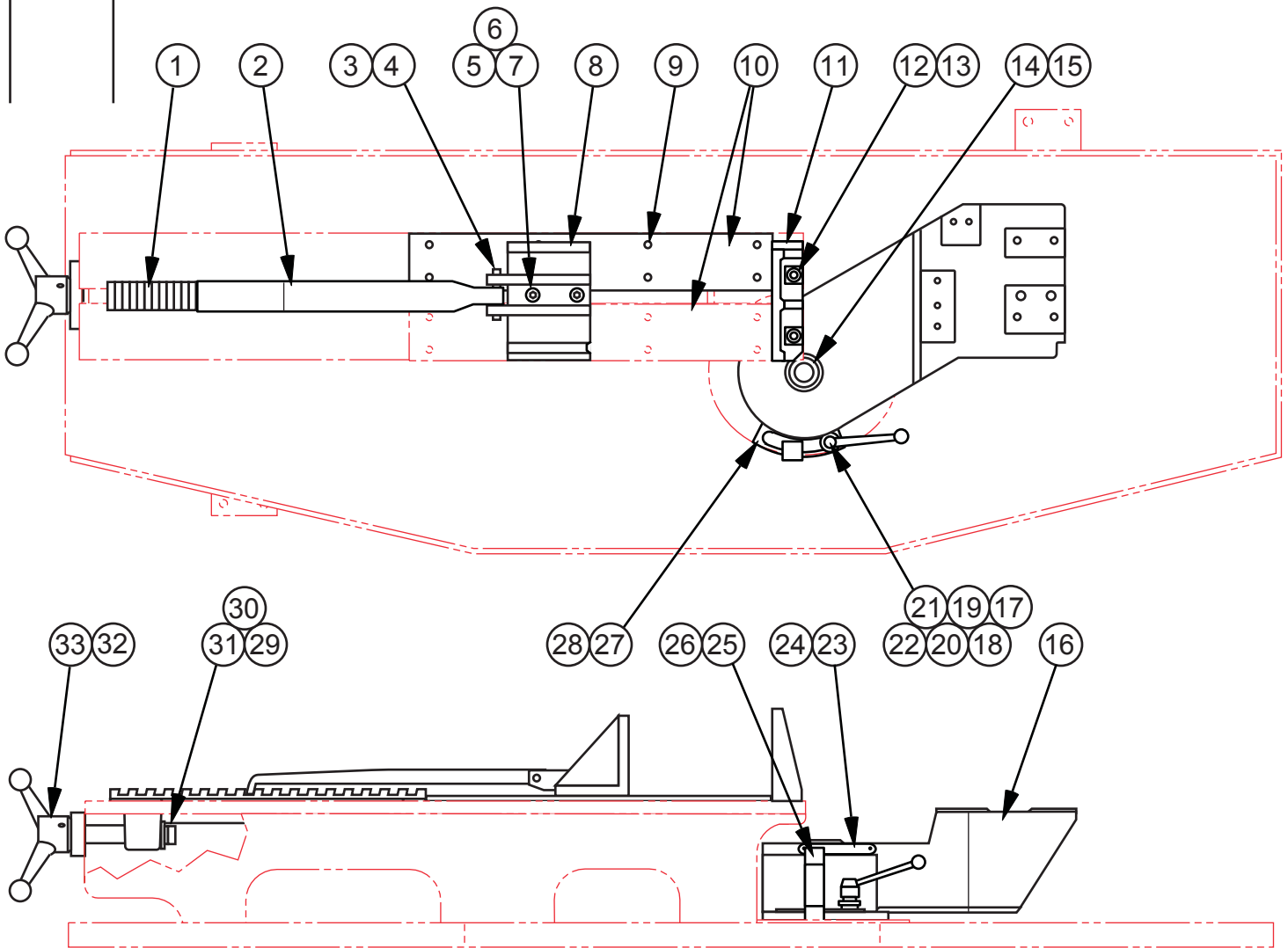
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	

SAW GUIDE ARM ASSEMBLY

SAW GUIDE ARM ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225521	Saw Guide Arm Assembly	
1	517255	. Saw Guide Arm	1
2	199237	. Screw, Soc. Set M12-1.75 x 25	1
3	004269	. Spring Pin	1
4	320590	. Mounting Bar	1
5	1008755	. Saw Guide Arm Lock Handwheel	1
6	175449	. Brass Plug	1
7	517255	. Saw Guide Arm	1
8	011529	. Ball Bearing	2
9	199346	. Washer, Lock M10	2
10	35-004528	. Plug Button	2
11	198167	. Screw, Soc. Hd. Shoulder M8-1.25 x 16 (10 mm Dia.)	2
12	198976	. Washer, Flat M10	2
13	198749	. Screw, Flat Hd. Mach. #10-24NC x 1/2	2
14	137158	. Insert Assembly (Fixed)	2
15	137155	. Insert Assembly (Adjustable)	2
16	124419	. Adjusting Screw Assembly (See Detail)	2
Ref.	124419	. Adjusting Screw Assembly	
1	124417	. . Plunger	1
2	199257	. . Washer, Flat #8 S.A.E. Std.	1
3	124418	. . Housing	1
4	104632	. . Belleville Washer	6
5	004217	. . Spring Pin	1
6	124033	. . Plug	1

NEW DRG.
S.C.L. 3-22-10
REVISIONS
S.C.L. 3-10-14



WISE CLAMP HANDWHEEL ASSEMBLY

MODEL FIRST MACH. LAST MACH.
400S 597-10101

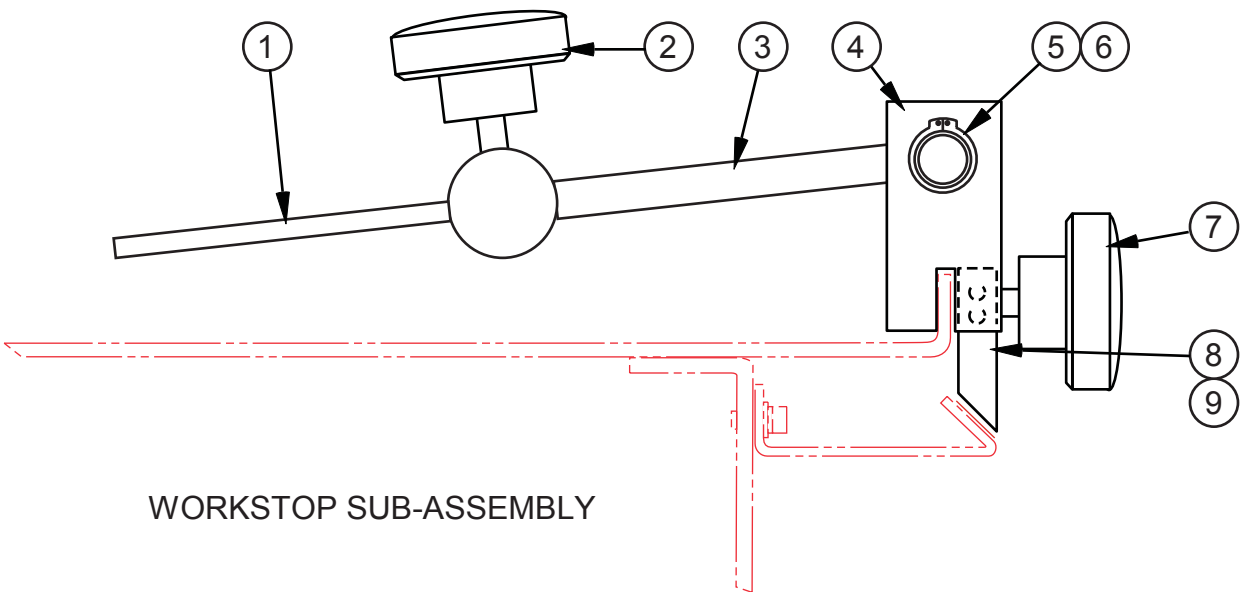
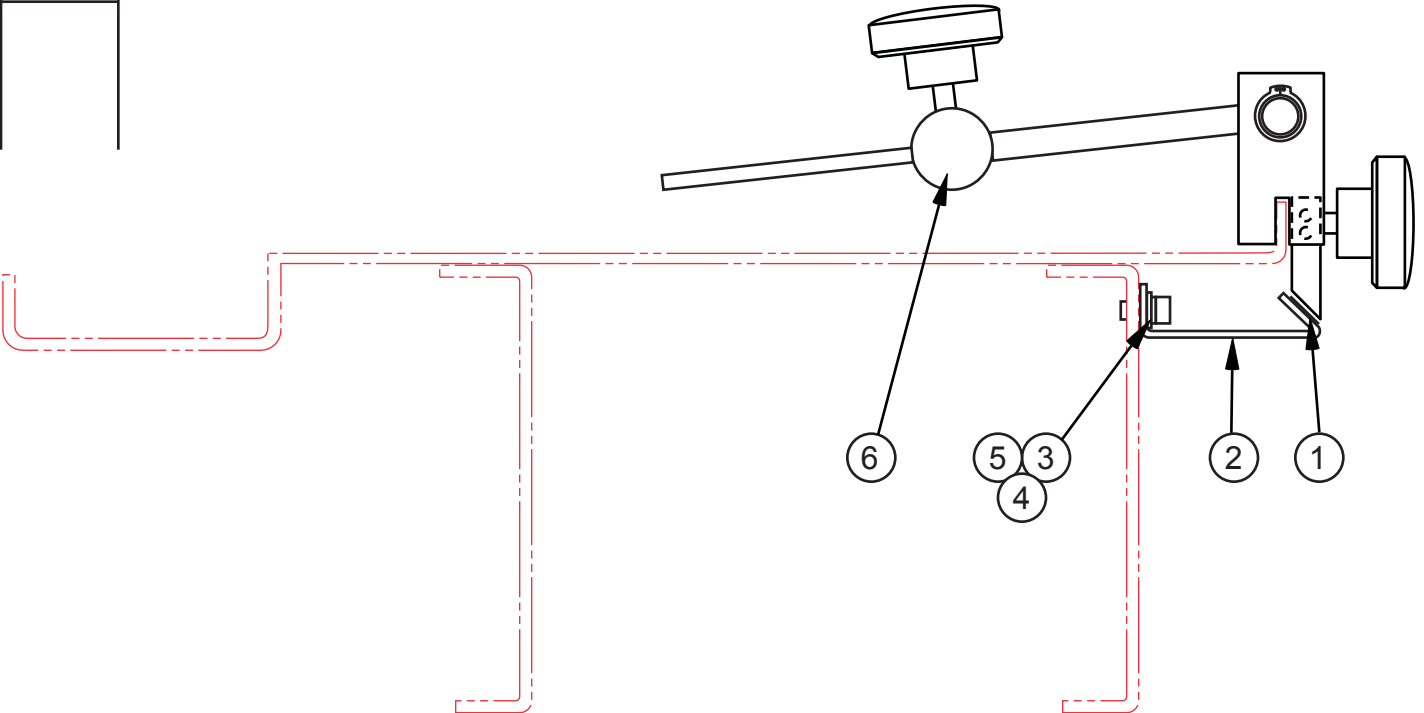
WISE and PIVOT DETAIL

WISE and PIVOT DETAIL

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Vise and Pivot Detail	
1	1008176	. Rack	1
2	314884	. Pawl	1
3	179579	. Pin	1
4	35-009613	. Retaining Ring	2
5	170740	. Nut Tee (.50 Tall; 3/8-16NC)	2
	1008869	. Nut Tee (.88 Tall; M10-1.5)	2
6	198281	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/2	2
	199919	. Screw, Soc. Hd. Cap M10-1.5 x 35	2
7	199325	. Washer, Lock 3/8 Std.	2
	199346	. Washer, Lock M10	2
8	514117	. Movable Vise Jaw	1
9	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	16
10	1008175	. Wear Plate	2
11	514121	. Fixed Vise Jaw	1
12	199908	. Screw, Soc. Hd. Cap M16-2.0 x 50	2
13	199500	. Washer, Lock M16 Hi-Collar	2
14	1009372	. Pivot Shaft	1
15	123156	. O-Ring	1
16	1008178	. Pivot	1
17	207712	. Clamp Handle	1
18	207713	. Stud M12-1.75	1
19	178548	. Hardened Washer	1
20	1008252	. Clamp Support Spacer	1
21	133470	. Spacer (.0149)	A.R.
22	133471	. Spacer (.0299)	A.R.
23	316914	. Pivot Angle Indicator	1
24	198722	. Screw, Rd. Hd. Drive M4-0.7 x 6	2
25	1009378	. Pointer	1
26	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
27	317664	. Pivot Clamp Plate	1
28	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	3
29	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12	1
30	199254	. Washer, Lock M6 Hi-Collar	1
31	109993	. Washer	1
32	1008021	. Vise Clamp Handwheel Assembly (See Detail)	1
33	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30	2
Ref.	1008021	. Vise Clamp Handwheel Assembly	
1	1008020	. . Handwheel	1
2	004277	. . Spring Pin	1
3	1008192	. . Bearing Block Assembly	1
	104284	. . . Flanged Bearing	1
4	108749	. . Thrust Ball Bearing	1
5	176759	. . Hardened Washer	1
6	1008193	. . Vise Lock Screw	1

NEW DRG.
S.C.L.12-22-10

REVISIONS



WORKSTOP SUB-ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
400M	596-10101	
400S	597-09101	

WORKSTOP ASSEMBLY
(USE WITH OPTIONAL 24" DISCHARGE TRAY ONLY)

PS - 10 - 142

PRINTED IN U.S.A.

WORKSTOP ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	224531	Workstop Assembly	
1	176463	. Rule (18"/455 mm)	1
2	327169	. Rule Support	1
3	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12	2
4	199347	. Washer, Lock M6	2
5	199579	. Washer, Flat M6 Wrought	2
6	320602	. Workstop Sub-Assembly (See Detail)	1
Ref.	320602	. Workstop Sub-Assembly	
1	200506	. . Adjusting Rod Weldment	1
2	206892	. . Knob	1
3	320603	. . Pivot Weldment	1
4	320604	. . Pivot Block Weldment	1
5	200510	. . Pivot Shaft	1
6	35-008688	. . Retaining Ring	2
7	206892	. . Knob	1
8	208030	. . Pointer	1
9	198722	. . Screw, Button Hd. Soc. M4-0.7 x 6	2