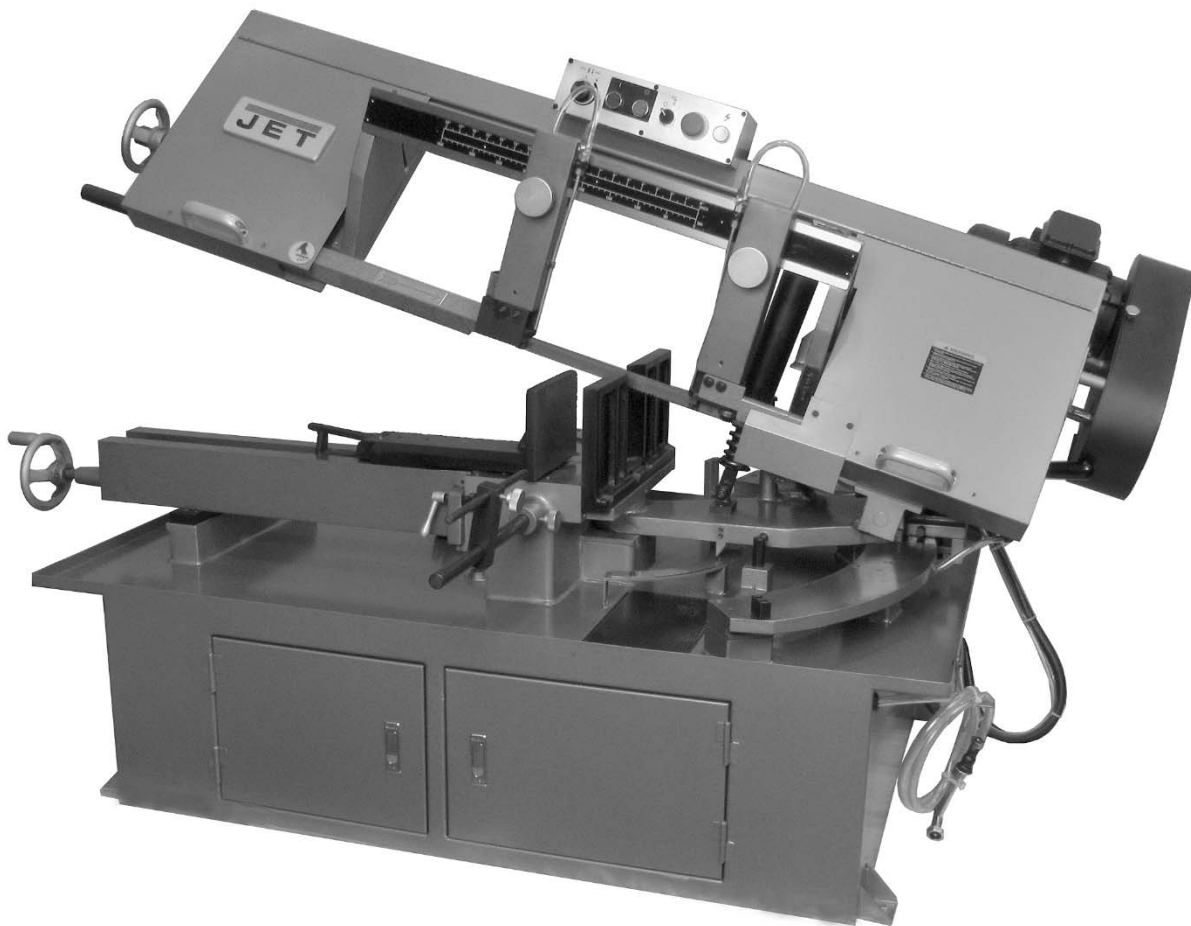




# Operating Instructions and Parts Manual Horizontal Dual Mitering Band Saw

Models: MBS-1018-1, MBS-1018-3



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## 1.0 IMPORTANT SAFETY INSTRUCTIONS

### WARNING – To reduce risk of injury:

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge have been obtained.
5. Do not use this band saw for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear ANSI Z87.1 approved safety glasses or face shield while using this band saw. (Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.)
7. Before operating this machine, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Wear ear protectors (plugs or muffs) if noise exceeds safe levels.
9. **CALIFORNIA PROPOSITION 65 WARNING:** This product contains chemicals known to the State of California to cause cancer, or birth defects or other reproductive harm.
10. This product, when used for welding, cutting, or working with metal, produces fumes, gases, or dusts which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health and Safety Code Section 25249.5 et seq.)
11. Make certain the switch is in the OFF position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. 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.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. Keep children away.
20. Make your workshop child proof with padlocks, master switches or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall into the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. 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.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep saw blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Maintain proper adjustment of blade tension, blade guides and thrust bearings.
27. Turn off the machine before cleaning. Use a brush to remove chips or debris — do not use your hands.

28. Do not stand on the machine. Serious injury could occur if the machine tips over.
29. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
30. Remove loose items and unnecessary work pieces from the area before starting the machine.
31. Never hand hold the material. Always use the vise and clamp it securely.
32. Be sure that blade is not in contact with workpiece when motor is started. Allow motor to come up to speed before bringing blade into contact with workpiece.
33. Avoid contact with coolant, especially guarding your eyes.
34. Never reach around or over saw blade during operation. Keep hands and fingers away from blade area.
35. Do not remove jammed pieces until blade has stopped.
36. Don't use in dangerous environment. Don't use power tools in damp or wet location, or expose them to rain. Keep work area well lighted.
37. 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 2 (sect. 6.3) shows 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.

**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.

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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 MBS-1018 Mitring 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.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: [www.jettools.com](http://www.jettools.com).

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

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

**Register your product online -**

<http://www.jettools.com/us/en/service-and-support/warranty/registration/>

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.



<sup>1</sup> subject to local and national electrical codes

<sup>2</sup> 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.

L = length, W = width, H = height

n/a = not applicable

#### 4.1 Base hole centers

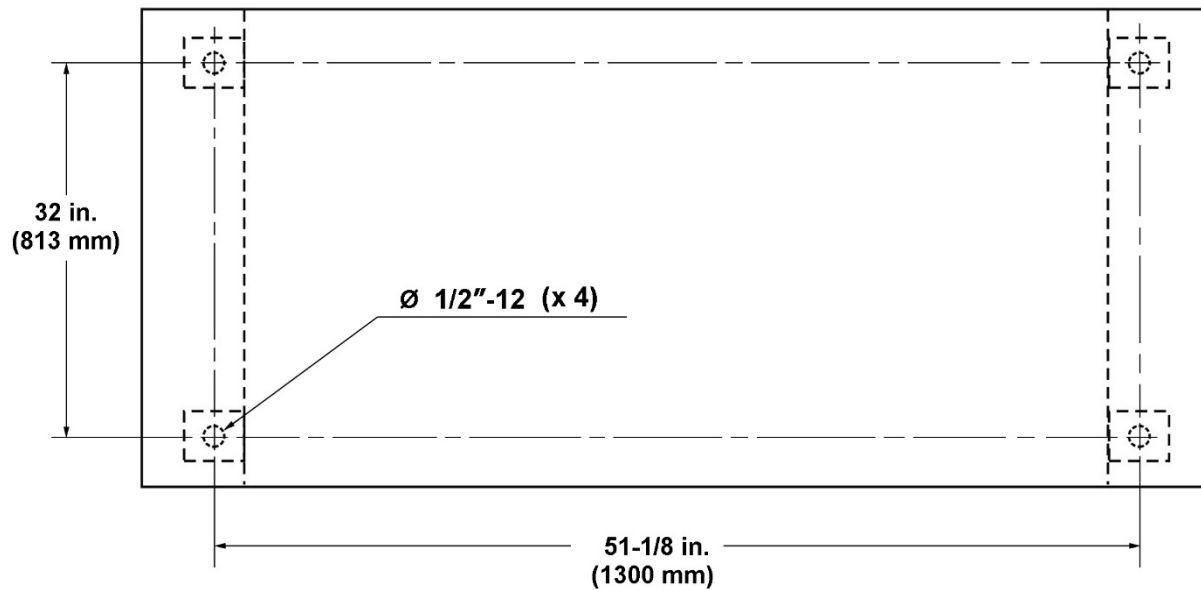


Figure 4-1

**▲WARNING** Read and understand all assembly instructions before attempting assembly. Failure to comply may cause serious injury.

## 5.0 Setup and assembly

**▲WARNING** Disconnect band saw from power during setup.

### 5.1 Shipping contents

- 1 Band saw
- 1 Tool box containing:
  - 4 Leveling pads
  - 4 Hex cap bolts, 1/2 x 2 in.
  - 4 Hex nuts, 1/2 in.
  - 1 Cross point screwdriver
  - 1 Hex wrench set (metric)
  - 1 Open end wrench set (metric)

### 5.2 Unpacking and cleanup

- 1. Finish uncrating saw and inspect for damage. Should any have occurred, contact your local distributor.
- 2. Remove all bolts attaching machine to shipping pallet.
- 3. Leave packing material between vise clamps and saw head intact until band saw has been lifted to its final position.
- 4. Clean all rust protected surfaces with a cleaner-degreaser or kerosene to remove protective coating. Do not use gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.
- 5. Lubricate all slideways with SAE 10W oil.
- 6. Compare contents of shipping carton with the contents list in this manual. Report shortages, if any, to your distributor.

### 5.3 Installation

- 1. For best performance, the band saw should be located on a solid and level foundation. Allow room for bow swiveling, servicing and for moving large stock around the machine.
- 2. Use lifting straps that are isolated from the band saw's finished surfaces and knobs, to move machine to desired location. See Figure 5-1 for strap placement. Do not strap bow or vise assembly.
- 3. Install four leveling bolts with hex nuts through the base flanges, as shown in *sect. 12.2.1*, index # 280 and 283.
- 4. Place a level on the table surface and check side-to-side and front-to-back.

- 5. Adjust leveling screws until machine is level in both directions and tighten nuts against the base flanges.
- 6. Remove braces holding control box, and mount control box directly to bow, using the existing screws and washers.
- 7. Install material stop into front hole in table, as shown in Figure 7-9.
- 8. Fill coolant reservoir with 15L (4 gal.) of appropriate coolant, by pouring it through the filter screen atop the pan.

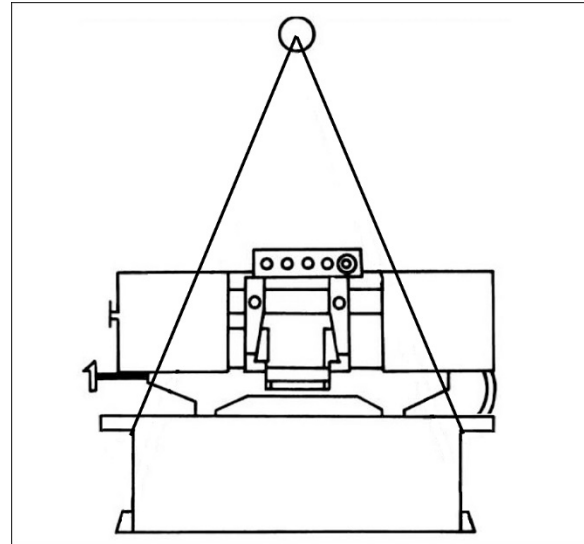


Figure 5-1

## 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.

The **MBS-1018-1** Horizontal Band Saw is rated at single phase, 230V power only. The band saw comes with a plug designed for use on a circuit with a grounded outlet that looks like the one pictured in Figure 9-1.

It is recommended that the MBS-1018-1 band saw be connected to a dedicated 15-amp circuit with circuit breaker or time-delay fuse marked "D". **Local codes take precedence over recommendations.**

The **MBS-1018-3** Horizontal Band Saw is rated at 3-phase, 230/460V and is prewired for 230V. The MBS-1018-3 is not provided with an electrical plug; you may either attach a proper UL/CSA-listed plug, or "hardwire" the machine directly to a service panel.

It is recommended that the MBS-1018-3 band saw be connected to a dedicated 7-amp circuit with circuit breaker or time-delay fuse marked "D". **Local codes take precedence over recommendations.**

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

## 6.1 GROUNDING INSTRUCTIONS

This tool 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.

**⚠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.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Figure 9-1. The MBS-1018-1 has a grounding plug that looks like the plug illustrated in Figure 9-1. 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.

### If hardwired:

Permanently connected tools: This tool should be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. Make sure a disconnect is available for the operator. During hard-wiring of the machine, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the drill press will be connected. ALWAYS FOLLOW PROPER LOCK-OUT/TAG-OUT PROCEDURES.

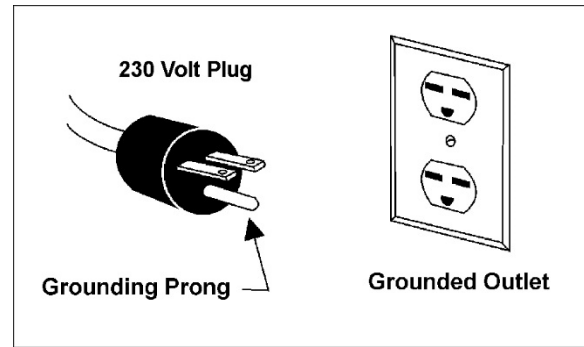


Figure 9-1: 230V plug and receptacle

## 6.2 Voltage conversion (MBS-1018-3 only)

1. Reconnect leads in motor junction box according to diagram inside junction box cover. Diagrams are also found at back of this manual. (If discrepancies should occur, diagrams on machine take precedence.)
2. Reconnect leads on transformer in electrical box.
3. Reconnect leads to coolant pump according to diagram inside pump junction box cover.
4. If using a plug, connect a proper UL-listed plug for the incoming voltage.

Make sure incoming current matches power requirements of saw. If saw blade does not move in proper direction, disconnect machine from power supply and reverse any two of the three power leads (except green ground wire).

## 6.3 Extension cords

The use of extension cords is discouraged; try to position equipment within reach of the power source. If an extension cord becomes necessary, be sure it is 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 2 shows recommended size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Ampere Rating		Volts	Total length of cord in feet			
More Than	Not More Than		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	

Extension Cord Recommendations  
Table 2

## 7.0 Adjustments

**⚠WARNING** Disconnect machine from power source before making adjustments, unless indicated otherwise.

### 7.1 Blade installation and removal

Refer to Figure 7-1.

**⚠WARNING** Always wear leather gloves when handling blades to avoid injury.

A blade (1in. W x 144in. L) is pre-installed and tensioned on saw. To replace blade:

1. Disconnect machine from power source.
2. Close feed rate knob by turning it clockwise as far as it will go, then raise bow a little.
3. Open both wheel covers (A, Figure 7-1) and clean out any swarf from wheel areas.
4. Remove blade guards (B, C).
5. Release blade tension by turning blade tension handwheel (D) counter-clockwise.
6. Remove blade from both wheels and out of each blade guide.
7. Make sure teeth of new blade are pointing in direction of travel. If necessary, turn blade inside out.
8. Position new blade around wheels and through upper blade guard (E, Figure 7-1). Slide it into the blade guide bearings with back edge of blade contacting backup bearing. (see Figure 7-2). If guide bearing adjustment is needed, see sect. 7.3
9. Lightly increase tension (D) and position blade so it rests against shoulder of both wheels.
10. When blade is properly positioned, place full tension upon it (see sect. 7.4.1).
11. Reinstall blade guards (B,C).
12. Jog the On/Off button to ensure blade is tracking properly. If tracking adjustment is needed, see sect. 7.4.2.
13. Close wheel covers and reinstall their screws.

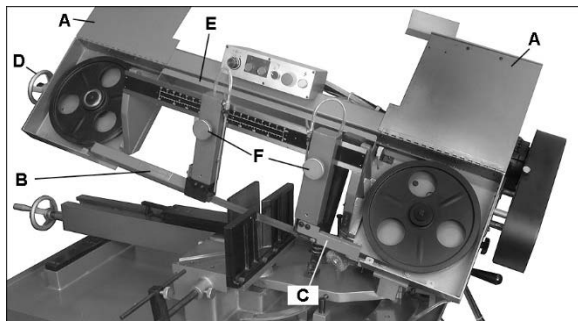


Figure 7-1

### 7.2 Bracket adjustment

The blade guide brackets (F, Figure 7-1) must be set to just clear the workpiece, but should not interfere with workpiece or other saw components during bow's descent.

Loosen knobs and slide brackets into position. Always tighten knobs before operating machine.

### 7.3 Blade guide bearing adjustment

The back of blade should ride against back-up support bearing (G, Figure 7-2) which is positioned at an angle to provide greater bearing support, eliminating bearing wear and extending blade life.

The blade should also ride between the two roller bearings. The front bearing (H) on left hand blade guide is on an eccentric shaft and can be adjusted to suit blade thickness:

1. Disconnect machine from power source.
2. Loosen nut (H<sub>1</sub>) and turn lower nut (H<sub>2</sub>) to position bearing. Retighten nut (H<sub>1</sub>). Do not overtighten the bearings against the blade; when adjusted properly, the bearings should be able to be rotated with your fingers with only minor resistance, with the blade stopped.
3. After completing above adjustments, loosen set screws (J) and adjust both tungsten carbide guides against surface of blade. Retighten set screws.
4. Adjust the right hand tungsten carbide guides in the same manner.

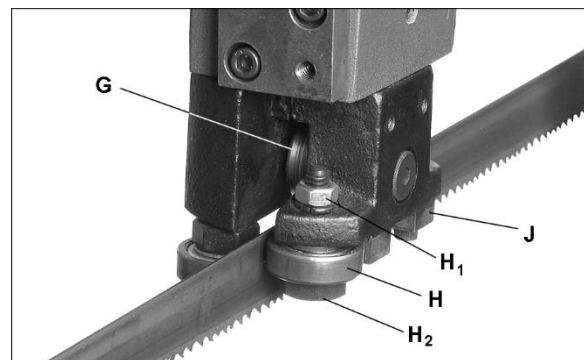


Figure 7-2: blade guide bearing adjustment

### 7.4 Blade tension and tracking

Refer to Figure 7-3.

#### 7.4.1 Tension

Blade tension has been set by manufacturer at approximately 1800 kg/cm<sup>2</sup> (25,000 psi) for the supplied blade, but should be verified by the operator. Turn handwheel (D, Figure 7-3) clockwise; if collar (K) slips out of position, then blade is properly tensioned. Continue turning handwheel until collar re-engages. NOTE: Simply turn handwheel, do not press on it.

If tension mechanism will not move blade, loosen and then re-tighten socket head cap screws on gibs (X, Figure 7-3).

#### 7.4.2 Tracking

**⚠WARNING** Tracking is performed with wheel covers open and blade moving. Use extreme caution so that you do not come into contact with blade.

Blade tracking has been set by manufacturer. Adjustment is rarely required when blade is used properly and is correctly welded.

Tracking is set properly when back of blade lightly touches shoulder of wheels. Note: Over-tracking (allowing blade back to rub hard against wheel shoulder) may damage blade wheels and blade.

If blade is not tracking properly:

1. Raise bow enough to allow saw motor to operate.
2. Open pulley cover and remove left blade guard.
3. Remove left and right bearing guide assemblies.

**NOTE:** Maintain proper tension at all times using the blade tensioning mechanism.

4. Loosen center locking screws (L, Figure 7-3) in all three hex adjustment screws (M) on tensioning mechanism.

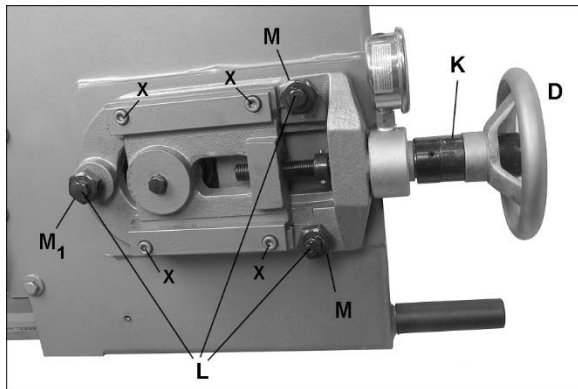


Figure 7-3: blade tension and tracking

**⚠CAUTION** While performing the following, keep blade from excessively rubbing on wheel shoulder, which may damage wheel and/or blade.

5. Start saw. Slowly turn single hex adjustment screw ( $M_1$ ) to tilt idler wheel. Do not turn either of the other two adjustment screws. Turn adjustment screw until blade is touching shoulder of idler wheel.

**NOTE:** Turning screw inward causes blade to move toward wheel shoulder. Turning screw outward causes blade to move away from shoulder.

6. Turn single hex adjustment screw ( $M_1$ ) so blade starts to move away from wheel shoulder — then immediately turn single hex adjustment screw in opposite direction so that blade stops, then moves slowly toward shoulder.

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

7. Turn single hex adjustment screw ( $M_1$ ) to stop motion of blade on wheel as it gets closer to wheel shoulder. Put a 6-inch length of paper between blade and wheel. The paper should not be cut as it passes between wheel shoulder and blade.
8. Turn single hex adjustment screw ( $M_1$ ) a small amount. Repeat insertion of paper between wheel shoulder and blade until paper is cut in two pieces. **NOTE:** You may have to repeat the check with the paper several times before blade and shoulder cuts paper into two pieces. Do not hurry this adjustment; patience and accuracy here will pay off with better, more accurate, quieter cutting and much longer machine and blade life.
9. When the paper is cut, turn hex adjustment screw ( $M_1$ ) slightly counterclockwise. This assures that blade is not rubbing excessively against wheel shoulder.
10. Shut off saw.
11. Hold hex adjustment screws ( $M$ ,  $M_1$ ) with a wrench and tighten center locking screws ( $L$ ). Make sure hex adjustment screws do not move while tightening center screws.
12. Install left and right bearing guide assemblies. See sect. 7-3 for adjustments.
13. Install left blade guard and close pulley cover.

#### 7.5 Blade speed change

Refer to Figure 7-4.

1. Open pulley cover.
2. Grasp handle (P, Figure 7-4) and loosen knob (N). Allow motor assembly to drop, which will de-tension belt.
3. Slip belt into proper pulley grooves, according to chart inside pulley cover (also shown in Figure 7-5).
4. Lift handle (P) to apply tension on belt, and tighten knob (N).
5. Retighten handle and close pulley cover.

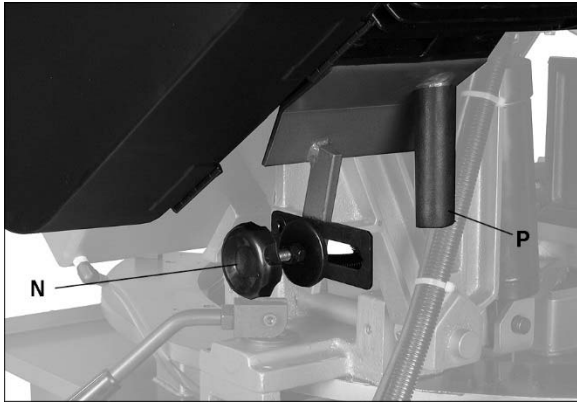


Figure 7-4: belt de-tensioning

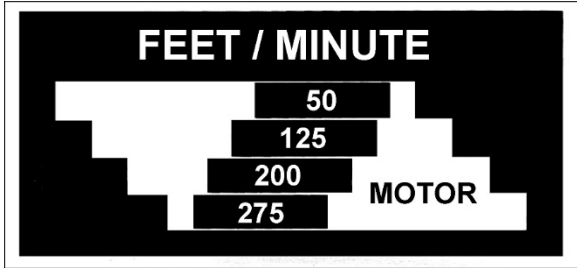


Figure 7-5: belt positioning

## 7.6 Vise adjustment

Refer to Figure 7-6.

The workpiece is placed between the vise jaws with required amount to be cut-off extending past the blade.

To position floating jaw, lift rack block (R) and slide jaw into general position. Lower rack block and turn handwheel (S) to tighten jaw against workpiece.

The floating jaw can be positioned before or behind blade to clear angle of bow when mitering. Loosen both handles (T) and push assembly along T-slot. Make sure floating jaw will clear blade and bow components, then tighten *both* handles (T).

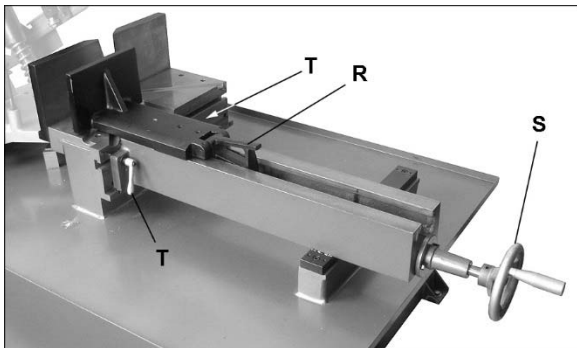


Figure 7-6: vise adjustment

## 7.7 Bow swivel adjustment

Refer to Figures 7-7 and 7-8.

1. Remove 90° stop pin (V).
2. Lift up on lever (W) and push bow to desired angle according to scale (X).

3. Push down lever (W) all the way until it locks into position. If lever will not push all the way down or does not have sufficient tightness to secure bow, adjust screw beneath lever (W<sub>1</sub>).

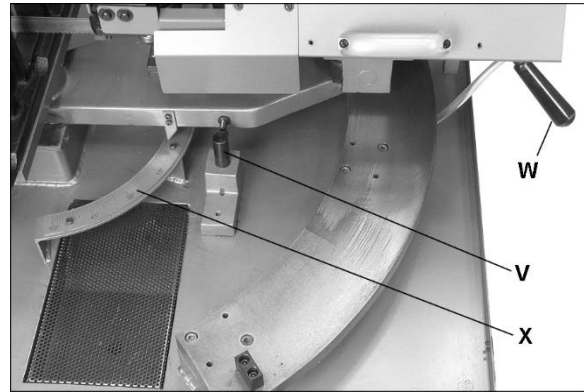


Figure 7-7: bow swivel adjustment

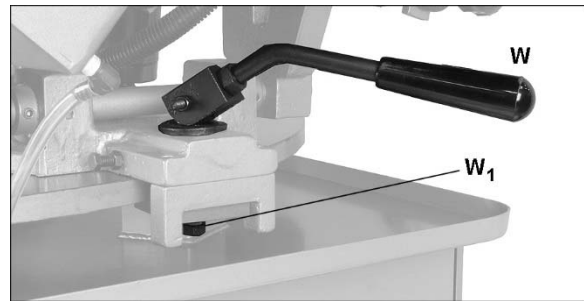


Figure 7-8: bow locking lever

## 7.8 Material stop

Refer to Figure 7-9.

The material stop is generally used when cutting multiple pieces to the same length. Position stop block (Y) desired distance away from blade and tighten knob.

If closer reach is needed toward blade, insert small rod and upper knob (Z).

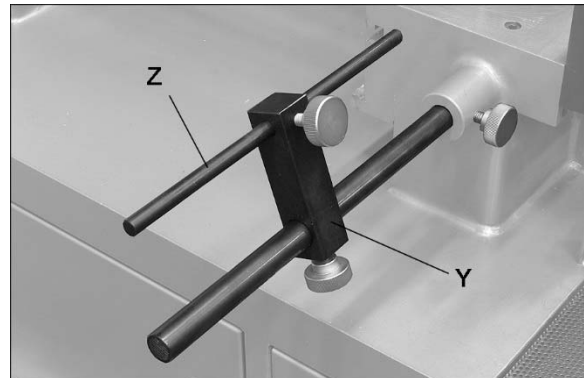


Figure 7-9: material stop

## 7.9 Coolant flow

**CAUTION** Coolant pump must be submerged before operating to prevent damage to pump.

The blade guides are fitted with coolant valves. Coolant is provided to the fittings through interconnecting tubing, and is dispensed directly onto saw blade.

Adjust coolant flow valves atop blade guide brackets to provide desired flow. The flow should be no more than blade can draw into the workpiece by its movement through the material.

The coolant flow can be stopped in two ways: Turn off coolant pump switch on control panel, or close coolant flow valves.

## 8.0 Control panel

Refer to Figure 8-1.

**Power Indicator Light (A)** – illuminates whenever machine is running.

**WARNING** If bulb is out, light will not be on but machine may still have power.

**Emergency Stop Button (B)** – Press to immediately stop all machine functions. To restart machine, rotate button clockwise until it disengages.

**Coolant Switch (C)** – Turn arrow to “I” to turn on coolant flow. Turn arrow to “O” to stop coolant flow.

**Stop Button (D)** – Press to stop motor/blade. Coolant will still flow.

**Start Button (E)** – Press to start motor/blade.

**Feed Rate Control (F)** – Sets amount of downward force that is applied to saw blade. The feed rate is proportional to opening of valve. Increasing valve opening (counterclockwise) increases feed rate; decreasing valve opening (clockwise) reduces feed rate. When set to zero, bow is locked in raised position.

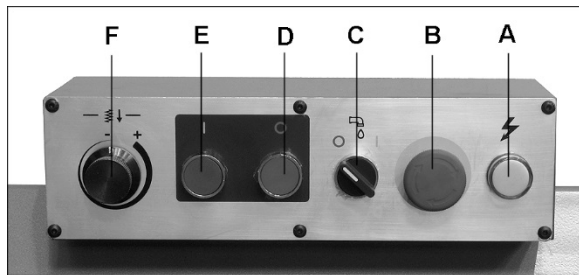


Figure 8-1: control panel

## 9.0 Operation

### 9.1 Automatic shut-off

#### 9.1.1 Cut completion

The machine and any accessories which are wired into the electrical system are controlled by the start-stop buttons. Saw will automatically shut off when cut is completed. The limit switch (A, Figure 9-1), contacts top of hydraulic cylinder (B) and deactivates motor.

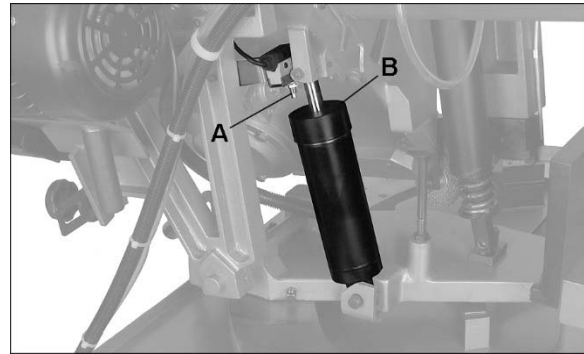


Figure 9-1: auto shut-off switch

#### 9.1.2 Blade breakage

If blade breaks during operation, a sensor near drive wheel will shut off the saw (Figure 9-2).

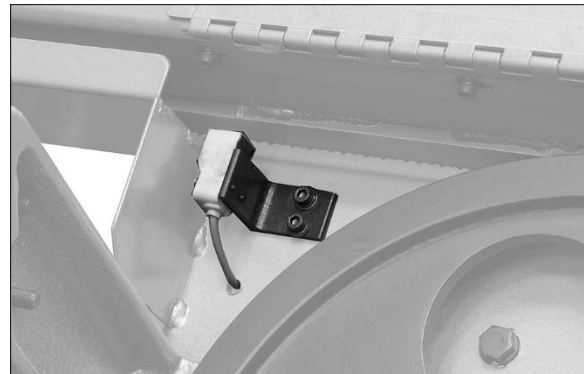


Figure 9-2: blade break sensor

### 9.2 Auxiliary coolant hose

The saw is equipped with auxiliary coolant hose and spray nozzle. This can be used to direct greater volume of coolant at workpiece, or for washing off table area.

### 9.3 Prior to Operation

1. Check that blade tooth direction matches diagram on blade guard, and blade guides are properly set.
2. Check gauge to verify proper blade tension. Make adjustments if needed.
3. Check to see that blade is properly seated on wheels after applying correct tension.

4. Select proper speed and feed rate for material being cut.
5. Material to be cut must be securely held in vise.
6. Check to see that coolant level is adequate and turn on coolant pump if material to be cut requires it. Machine should be filled with approximately 15 L (4 gal.) of proper coolant mixture. Follow directions on product maker's label and fill coolant tank through chip tray area.
7. Do not start cut on a sharp edge.
8. Keep machine lubricated. See *sect. 10.2*.

#### 9.4 General operating procedure

**⚠WARNING** All blade covers and guards must be in place and secured before turning on band saw.

1. Select proper speed for type of material to be cut.
2. Close feed rate knob and lift bow high enough to clear workpiece.

**⚠CAUTION** Make sure blade is not in contact with workpiece when motor is started. Do not drop bow onto workpiece or force blade through workpiece.

3. Place stock between vise jaws, set stock for desired width of cut and tighten vise. (See Figure 9-3 for recommended placement in vise of varied workpiece shapes.)
4. Make sure left blade guide bracket is adjusted as close as possible to left vise jaw.
5. Start motor and allow machine to reach operating speed.
6. Adjust coolant valves as desired.
7. Turn feed rate control knob for desired rate. Allow blade to slowly enter workpiece.
8. Saw will shut off at completion of cut.

#### 9.5 Evaluating cutting efficiency

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

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

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

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

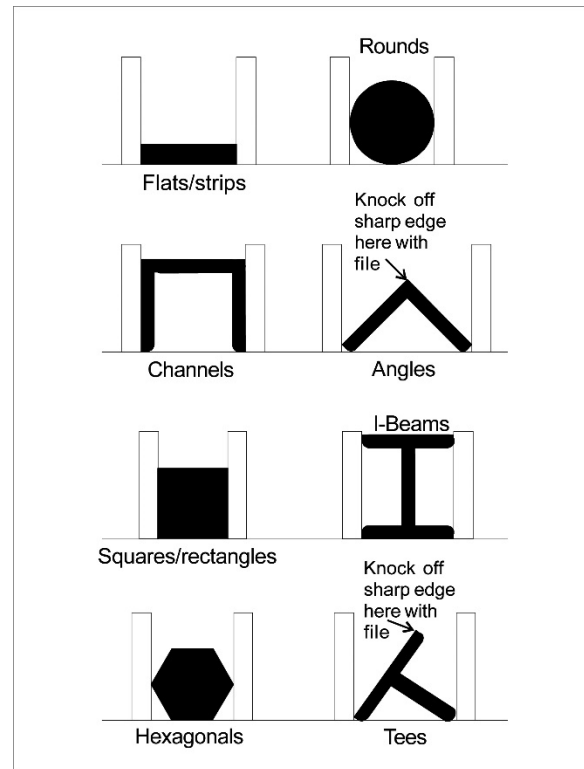


Figure 9-3

#### 9.6 Blade selection

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

See Table 3 for recommended speeds for various materials. These selections, while appropriate for many shop cutting needs, do not encompass the wide variety of blades of special configuration (tooth pitch and set) and special alloys for cutting unusual or exotic materials.

Speed/FPM	Material
100	Tool Steel, Stainless Steel, Phosphor Bronze, Hard Bronze, Hard Cast Iron, Malleable Iron
165	Mild Steel, Soft Cast Iron, Med. Hard Brass, Med. Hard Bronze
230	Soft Brasses and Bronzes, Hard Aluminum, Plastics

Table 3

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

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

For very high production on cutting of special materials, or to work hard-to-cut materials such as stainless steel, tool steel, or titanium, ask your industrial distributor for more specific blade recommendations. Also, the supplier who provides the workpiece material should be prepared to provide very specific instructions regarding the best blade (and coolant or cutting fluid, if needed) for the material and shape supplied.

## 9.7 Blade break-in procedures

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

1. Clamp a round section workpiece in the vise. The workpiece should be 2 inches or larger in diameter.
2. Set saw on low speed. Start cut with a very light feed rate.
3. When saw has completed 1/3 of cut, increase feed rate slightly and allow saw to complete the cut.
4. Keep the same settings and begin a second cut on the same or similar workpiece.
5. When blade has completed about 1/3 of cut, increase feed rate. Watch chip formation until cutting is at its most efficient rate (*sect. 9.5*) and allow saw to complete the cut. The blade is now considered ready for regular service.

## 10.0 User-maintenance

**⚠WARNING** Always disconnect power to machine before performing maintenance. Failure to do this may result in serious personal injury.

### 10.1 General cleaning

Keep wheels clear of chips and debris.

Keep slide areas (such as vise ways and T-slot, slide for bow swiveling, and behind scale where blade brackets slide) clean and oiled. Make sure vise lead screw remains free of cuttings or other obstructions.

Keep a light coat of SAE 10W oil on machined parts to inhibit rust.

### 10.2 Lubrication

All ball bearings are permanently lubricated and sealed; they require no further attention.

Coolant – Maintain proper coolant level. Clean chip sludge from coolant tank and hose as needed. Replace coolant on a frequency appropriate to type of coolant being used. Oil-based coolants can sour. Refer to coolant supplier's instructions for frequency.

Vise lead screw – apply a light oil monthly.

Hydraulic cylinder pivot – apply a light oil every 6 months.

Blade tension screw – grease every 6 months.

Wire brush bearing – apply a light oil monthly.

### 10.2.1 Hydraulic system

If it is necessary to fill the hydraulic cylinder with oil, proceed as follows:

1. Lift bow slightly (about 15°) and place a block beneath bow to hold it.
2. Turn cylinder cover (B, Figure 9-1) counter-clockwise, then fill with hydraulic oil or equivalent.
3. Retighten cylinder cover.

### 10.2.2 Gearbox

The gearbox has been pre-filled by the manufacturer. After first 50 hours of use the gearbox should be drained and refilled. After that check oil once a year.

1. Remove drain plug (A, Figure 10-1) and allow lubricant to drain completely. Reinstall drain plug.
2. Remove oil fill plug (B) and fill gearbox with 850mL (0.9 qt.) of Mobil™ SHC 634 gearbox oil, or equivalent. Replace fill plug.

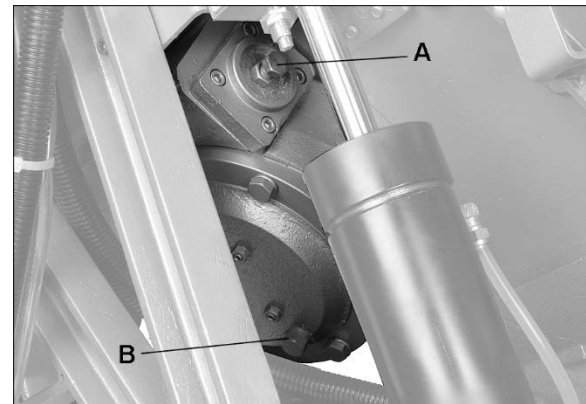


Figure 10-1

### 10.3 Belt replacement

De-tension belt (see *sect. 7.5*). Slip old belt off pulleys and install new belt. Re-tension belt and tighten knob.

New belts may stretch slightly as they get broken in, so belt tension should be re-checked after a period of use.

## 10.4 Additional servicing

Any additional servicing should be performed by authorized service personnel.

## 11.0 Troubleshooting MBS-1018 Band Saw

Symptom	Possible Cause	Correction*
Excessive blade breakage	Material loose in vise.	Clamp work securely.
	Incorrect speed or feed.	Check machinery handbook for speed/feed appropriate for material being cut.
	Teeth too coarse for material.	Check machinery handbook for recommended blade type.
	Incorrect blade tension.	Adjust blade tension to the point where the blade just does not slip on the wheel.
	Saw blade is in contact with workpiece before the saw is started.	Start the motor before placing the saw on the workpiece.
	Blade rubs on wheel flange.	Adjust blade tracking.
	Misaligned guides.	Adjust guides.
	Cracking at weld.	Longer annealing cycle.
Premature blade dulling	Blade teeth too coarse.	Use a finer tooth blade.
	Blade speed too high.	Try a lower blade speed.
	Inadequate feed pressure.	Decrease spring tension.
	Hard spots in workpiece or scale on/in workpiece.	Increase feed pressure (hard spots). Reduce speed, increase feed pressure (scale).
	Work hardening of material (especially stainless steel).	Increase feed pressure by reducing spring tension.
	Insufficient blade tension.	Increase tension to proper level.
	Operating saw without pressure on workpiece.	Do not run blade at idle in/on material.
Bad cuts (out-of-square)	Workpiece not square with blade.	Adjust vise so it is square with the blade. (Always clamp work tightly in vise.)
	Feed pressure too fast.	Decrease pressure.
	Guide bearings not adjusted properly.	Adjust guide bearing clearance to 0.001 inch (0.002 inch maximum).
	Inadequate blade tension.	Gradually increase blade tension.
	Span between the two blade guides too wide.	Move blade guide bar closer to work.
	Dull blade.	Replace blade.
	Incorrect blade speed.	Check blade speed/pulley position.
	Blade guide assembly is loose.	Tighten blade guide assembly.
	Blade guide bearing assembly loose.	Tighten blade guide bearing assembly.
	Blade track too far away from wheel flanges.	Adjust blade tracking.
	Guide bearing worn.	Replace worn bearing.

Symptom	Possible Cause	Correction*
Bad cuts (rough)	Blade speed too high for feed pressure.	Reduce blade speed and feed pressure.
	Blade too coarse.	Replace with finer blade.
Blade is twisting	Blade is binding in the cut.	Decrease feed pressure.
	Blade tension too high.	Decrease tension on blade
Unusual wear on side or back of blade	Blade guides worn	Replace blade guides.
	Blade guide bearings not adjusted.	Adjust blade guide bearings.
	Blade guide bearing bracket is loose.	Tighten blade guide bearing bracket.
Teeth missing/ripped from blade	Blade tooth pitch too coarse for workpiece.	Use blade with finer tooth pitch.
	Feed too slow; feed too fast.	Increase feed pressure and/or blade speed.
	Workpiece vibrating.	Clamp workpiece securely.
	Gullets loading up with chips.	Use blade with coarse tooth pitch; reduce feed pressure. Brush blade to remove chips.
Motor running too hot	Blade tension too high.	Reduce tension on blade.
	Drive belt tension too high.	Reduce tension on drive belt.
	Blade too coarse for workpiece (especially with tubular stock).	Use blade with fine tooth pitch.
	Blade too fine for workpiece (especially with heavier, soft material).	Use blade with coarse tooth pitch.
	Insufficient gearbox lubrication	Check gearbox oil.
No coolant flow	Pump motor is burned out.	Replace pump.
	Screen/filter on pump is clogged.	Clean screen/filter.
	Impeller is loose.	Tighten impeller.
	Coolant level too low.	Add coolant to reservoir.
Excessive noise or vibration	Belt is too tight.	Reset belt tension.
Tension mechanism won't move blade	Gibs won't slide.	Loosen and retighten socket head cap screws on gibs.

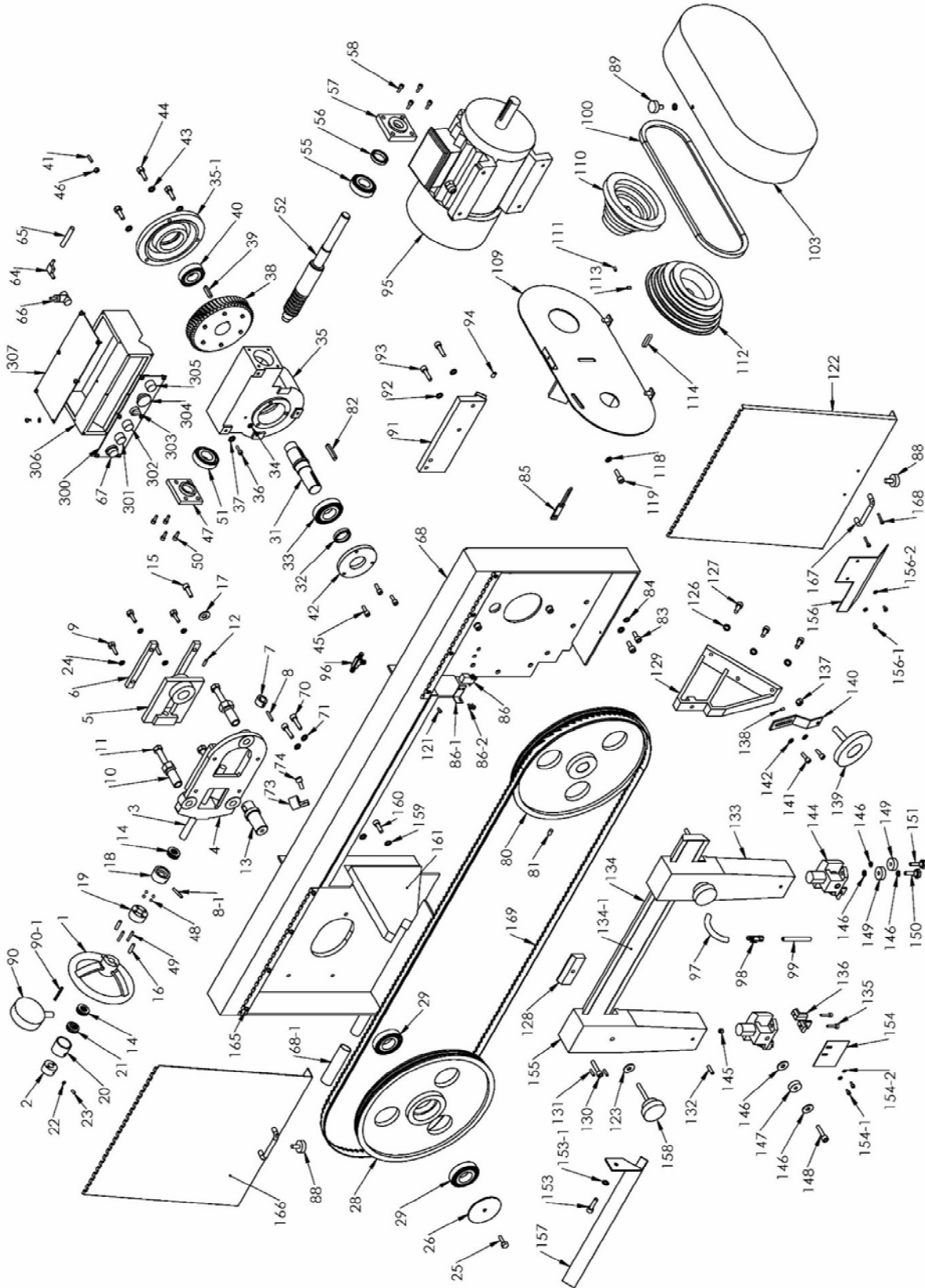
**\*Warning:** Some corrections may require a qualified electrician.

## 12.0 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.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

12.1.1 MBS-1018-1/MBS-1018-3 Bow Assembly – Exploded View



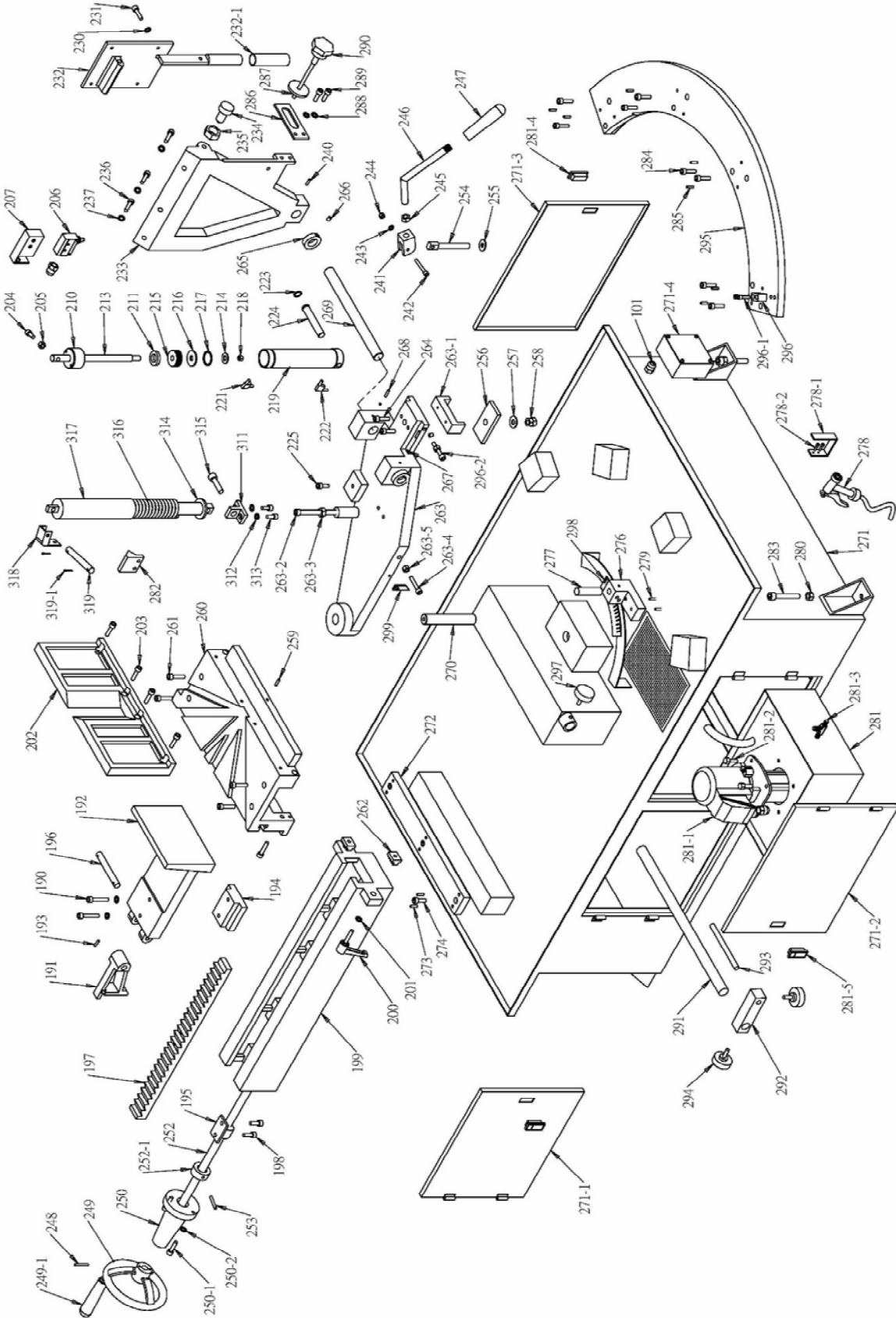
## 12.1.2 MBS-1018-1/MBS-1018-3 Bow Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	EHB916V-249	Handwheel		1
2	EHB916V-02	Collar		1
3	EHB916V-03	Shaft		1
4	EHB916V-04	Bracket		1
5	EHB916V-05	Slide		1
6	EHB916V-06	Gib		2
7	EHB916V-07	Collar		1
8	F012076	Roll pin	M5x30	2
8-1	F012077	Roll pin	M5x40	1
9	TS-0081031	Hex Cap Screw	5/16x3/4	4
10	EHB916V-10	Adjusting Screw	3/4x1-1/2	1
11	TS-0060111	Hex Cap Screw	3/8x2-1/2	1
12	TS-0271031	Set Screw	3/8"x3/8	1
13	EHB916V-13	Spindle		1
14	BB-51103	Thrust bearing	511003	2
15	TS-0060061	Hex Cap Screw	3/8x1-1/4	1
16	F012076	Roll pin	M5x30	1
17	TS-0732061	Lock Washer	3/8"	1
18	EHB916V-18	Driven		1
19	EHB916V-19	Thrust Bearing Housing		1
20	EHB916V-20	Lock Nut		1
21	EHB916V-21	Disc Spring		6
22	EHB916V-22	Copper		1
23	TS-0267041	Set Screw	1/4"x3/8"	1
24	TS-0720081	Lock Washer	5/16"	1
25	TS-0060051	Hex Cap Screw	3/8"x1"	1
26	EHB916V-26	Special Washer		1
28	EHB916V-28	Wheel LH		1
29	BB-6306ZZ	Bearing	6306ZZ	2
	MBS-1018-GBA	Gear Box Assembly (includes #31-47,50-58,82)		1
31	EHB916V-31	Output Shaft		1
32	EHB916V-32	Oil Seal	32.42.7	1
33	BB-30207	Bearing	30207	1
34	EHB916V-34	Oil Plug	1/4"	1
35	EHB916V-35	Gear Box Housing		1
35-1	EHB916V-35-1	Cover		1
36	TS-0060031	Hex Cap Screw	3/8-16x3/4"	3
37	TS-0732061	Lock Washer	3/8"	3
38	EHB916V-38	Worm Gear		1
39	EHB916V-39	Key	7x7x35 mm	1
40	BB-30206	Bearing	30206	1
41	TS-0267121	Set Screw	1/4"x3/4"	3
42	EHB916V-42	Cap		1
43	TS-0732061	Lock Washer	3/8"	3
44	TS-0060071	Hex Cap Screw	3/8"-16x1-1/2"	3
45	TS-0207021	Socket Head Cap Screw	1/4"-20x5/8"	3
46	TS-0561011	Hex Nut	1/4"	3
47	EHB916V-47	Cap		1
48	SB-3/16	Steel Ball	3/16"	2
49	TS-0270061	Set Screw	5/16"-18x5/8"	1
50	TS-0207021	Socket Head Cap Screw	1/4"-20x5/8"	4
51	BB-6004	Bearing		1
52	EHB916V-52	Input Shaft		1
55	BB-3205	Bearing	3205	1
56	EHB916V-56	Oil Seal	25.35.7	1
57	EHB916V-57	Cap		1
58	TS-0207021	Socket Head Cap Screw	1/4"-20x5/8"	4
64	EHB916V-64	Fitting		1
65	EHB916V-65	Tubing	5/16"x65"	2
66	EHB916V-66	Valve		1

Index No	Part No	Description	Size	Qty
67	EHB916V-67	Feed Knob		1
68	MBS1018-1-68	Bow Frame		1
68-1	MBS1018-1-68-1	Handle Grip		1
70	TS-0081031	Hex Cap Screw	5/16"x3/4"	2
71	TS-0680031	Flat Washer	5/16"	2
73	EHB916V-73	Tube Retainer		2
74	EHB916V-74	Round Head Screw	3/16"x3/8"	2
80	EHB916V-80	Drive Wheel		1
81	TS-0271032	Socket Set Screw	3/8-24x3/8"	1
82	EHB916V-82	Key	7x7x40 mm	1
83	TS-0081031	Hex Cap Screw	5/16-18x3/4"	2
84	TS-0720081	Lock Washer	5/16"	2
85	EHB916V-85	Bracket		1
86	EHB916V-86	Sensor		1
86-1	EHB916V-86-1	Sensor Seat		1
86-2	EHB916V-86-2	Screw	3/16x3/8"	1
88	EHB916V-88	Knob		2
89	EHB916V-88	Knob		1
90	EHB916V-90	Blade Tension Gauge		1
90-1	EHB916V-90-1	Pin		1
91	EHB916V-91	Front Pivot Bracket		1
92	TS-0732061	Lock Washer	3/8"	3
93	TS-0060081	Hex Cap Screw	3/8-16x3/4"	3
94	TS-0271051	Socket Set Screw	3/8-16x1/2"	1
95	EHB1018V-95	Motor	2HP,230V,1PH	1
	EHB1018V-95RC	Run Capacitor (for MBS-1018-1)	40µF 350VAC	1
	EHB1018V-95SC	Start Capacitor (for MBS-1018-1)	600µF 125VAC	1
	EHB1018V-95MFC	Motor Fan Cover		1
	EHB1018V-95MF	Motor Fan		1
	EHB1018V-95MJB	Motor Junction Box		1
	EHB1018VM-95	Motor	2HP,230/460V,3PH	1
	EHB1018VM-95MFC	Motor Fan Cover		1
	EHB1018VM-95MF	Motor Fan		1
	EHB1018VM-95MJB	Motor Junction Box		1
96	EHB916V-96	3 Way Coolant Block		1
97	EHB916V-97	Hose		2
98	EHB916V-98	Valve		2
99	EHB916V-99	Hose Clamp		2
100	VB-A36	Belt	A-36	1
103	MBS1018-1-103	Upper Guard		1
109	MBS1018-1-109	Lower Guard		1
110	MBS1018-1-110	Motor Pulley		1
111	TS-0270021	Socket Set Screw	5/16-18x5/16"	1
112	MBS1018-1-112	Gear Box Pulley		1
113	TS-0270021	Socket Set Screw	5/16-18x5/16"	1
114	EHB916V-114	Key	5x5x40 mm	1
118	TS-0720081	Lock Washer	5/16"	2
119	EHB916V-119	Hex Head Screw	5/16"-20x3/4"	2
121	EHB916V-121	Round Head Screw	#10-3/16x3/8"	4
122	MBS1018-1-122	Cover R.H		1
123	TS-0680041	Lock Washer	3/8"	4
126	TS-0680041	Lock Washer	3/8"	3
127	TS-0060031	Hex Cap Screw	3/8x16x3/4"	3
128	EHB1018V-128	Stationary Plate		2
129	MBS1018-1-129	Bracket		1
130	TS-0209061	Socket HD Cap Screw	3/8"-16x1-1/4"	2
131	TS-0267071	Set Screw	1/4"-20x3/4"	4
132	TS-0270061	Set Screw	5/16"-18x5/8"	1
133	EHB1018V-133	Bracket RH		4
134	EHB1018VM-134	Slide		1
134-1	MBS1018-1-134-1	Scale		1
135	EHB916V-135	Screw	3/16"-24x7/8"	4

Index No	Part No	Description	Size	Qty
136	EHB916V-136	Carbide Guide		4
137	EHB1018V-137	Collar		2
138	TS-0267021	Set Screw	1/4"x1/4"	2
139	EHB916V-139	Wire Brush		1
140	EHB1018V-140	Brush Holder		1
141	TS-0207021	Socket Head Cap Screw	1/4"x20x5/8"	2
142	TS-0680021	Flat Washer	1/4"x19x2.0	2
144	EHB916V-144	Guide		2
145	TS-0561021	Hex Nut	5/16"-18T	2
146	TS-0680041	Flat Washer	3/8"	4
147	BB-6200ZZ	Bearing	6200ZZ	1
148	EHB916V-148	Special Screw	10x30 mm	1
149	BB-6200ZZ	Bearing	6200ZZ	2
150	EHB916V-150	Special Screw		1
151	EHB916V-151	Special Screw		1
153	TS-0207031	Socket Head Cap Screw	1/4"-20 x 5/8"	1
153-1	TS-0680021	Flat Washer	1/4"	1
154	EHB916V-154	Guide Cover		1
154-1	EHB916V-154-1	Hex Cap Screw	3/16 x 3/8"	2
154-2	F002633	Flat Washer	3/16"	2
155	EHB1018V-155	Bracket LH		4
156	EHB916V-156	Blade Cover		1
156-1	EHB916V-156-1	Screw	3/16 x 3/8"	2
156-2	F002633	Flat Washer	3/16"	2
157	MBS1018-1-157	Blade Cover		1
158	EHB916V-158	Special Knob		2
159	TS-0680041	Flat Washer	3/8"	1
160	TS-0060031	Hex Head Screw	3/8x16x3/4"	3
161	MBS1018-1-161	Bracket		1
165	EHB916V-165	Round Head Screw	3/16x3/8"	4
166	MBS1018-1-166	Cover LH		1
167	EHB916V-167	Handle		2
168	TS-081F051	Phillips Screw	1/4"-20x3/4"	4
169	891097	Blade	1"x0.035"x144"(4/6T)	1
300	MBS1018-1-300	Control panel		1
301	EHB916V-301	Start Switch, Green		1
302	EHB1018VM-302	Stop Switch, Red		1
303	EHB916V-303	Selection Switch		1
304	EHB1018VM-304	Emergency Stop		1
305	EHB916V-305	Power Indicator Light		1
306	MBS1018-1-306	Control Box		1
307	MBS1018-1-307	Control Box Cover		1
	LM000250	Warning Label (not shown)	4" x 3"	1
	JET-203	JET Logo (not shown)	203 x 84mm	1

12.2.1 MBS-1018-1/MBS-1018-3 Base Assembly – Exploded View



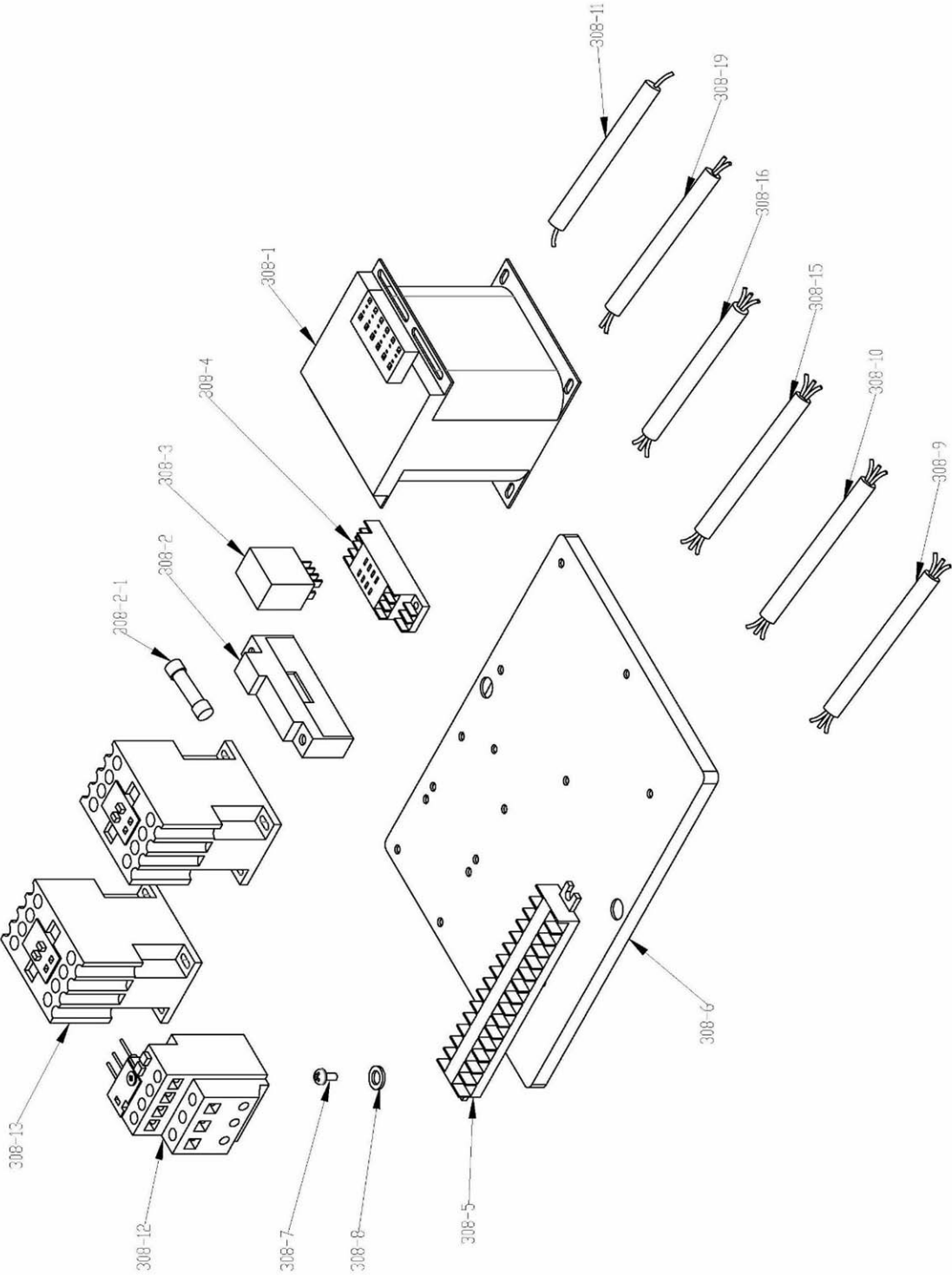
## 12.2.2 MBS-1018-1/MBS-1018-3 Base Assembly – Parts List

Index No	Part No	Description	Size	Qty
101	EHB916V-101	Cable Gland	PG-11	1
190	TS-0060071	Hex Cap Screw	3/8x1-1/2"	2
191	EHB1018VM-191	Rack Block		1
192	EHB1018VM-192	Floating Vise Jaw		1
193	TS-0267041	Set Screw	1/4-20x3/8"	1
194	EHB1018VM-194	Rack Block		1
195	EHB1018VM-195	Acme Nut Assembly		1
196	EHB1018VM-196	Fixed Pin		1
197	EHB1018VM-197	Rack		1
198	TS-0081031	Hex Cap Screw	5/16-18x3/4"	2
199	EHB1018VM-199	Moveable Bed		1
200	EHB1018VM-200	Adjustable Handle		2
201	TS-0680041	Flat Washer	3/8"	1
202	EHB1018VM-202	Fixed Vise Jaw		1
203	TS-0051061	Hex Cap Screw	5/16"-18x1-1/4"	4
204	TS-0060081	Hex Cap Screw	3/8-16x1-3/4"	1
205	TS-0561031	Hex Nut	3/8"	1
206	EHB916V-206	Limit Switch		1
207	MBS1018-1-207	Limit Switch Seat		1
	EHB916V-OHCA	Oil Hydraulic Cylinder Assembly (includes #210-222)		1
210	EHB916V-210	Cap		1
211	EHB916V-211	Oil Seal	20.35.7	1
213	EHB1018VM-213	Rod		1
214	TS-0680031	Flat Washer	5/16"	1
215	EHB916V-215	Piston		1
216	EHB916V-216	Seal		1
217	EHB916V-217	"O" Ring		1
218	TS-0561021	Hex Nut	5/16"x18T	2
219	EHB916V-219	Tube Assembly		1
221	EHB916V-221	Tube Fitting		1
222	EHB916V-222	Tube Fitting		1
223	EHB916V-223	Ext. Retaining Ring	S-17	1
224	EHB916V-224	Pivot Shaft		1
225	EHB916V-225	Socket Set Screw	3/8"-16Tx3/8"	1
230	TS-0680031	Flat Washer	5/16"	4
231	TS-0051051	Hex Cap Screw	5/16x1"	4
232	MBS1018-1-232	Motor Plate		1
232-1	MBS1018-1-232-1	Handle Grip		1
233	EHB1018V-233	Rear Pivot Bracket		1
234	TS-0271031	Adjusting Screw	1/2"x2"	2
235	EHB916V-235	Hex Nut	1/2"-12	2
236	EHB916V-236	Hex Head Screw	3/8"-16Tx1-3/4"	3
237	TS-0680041	Flat Washer	3/8"	3
240	TS-0271051	Set Screw	3/8"-16x1/2"	1
241	EHB1018VM-241	Eccentric		1
242	TS-0051011	Hex Cap Screw	5/16x1-3/4"	1
243	TS-0680031	Flat Washer	5/16"	1
244	TS-0561021	Hex Nut	5/16x18T	1
245	TS-0561071	Hex Nut	5/8"	1
246	MBS1018-1-246	Shaft		1
247	MBS1018-1-247	Handle		1
248	EHB916V-248	Roll Pin	1/4x1/2"	1
249	EHB916V-249	Hand Wheel		1
249-1	EHB916V-249-1	Handle		1
250	EHB1018VM-250	Seat		1
250-1	TS-0051051	Hex Cap Screw	5/16"-18x1"	2
250-2	TS-0720081	Lock Washer	5/16"	2
252	EHB1018VM-252	Acme Screw		1
252-1	EHB916V-252-1	Collar		1
253	EHB916V-253	Roll Pin	6x30 mm	1

Index No	Part No	Description	Size	Qty
254	EHB1018VM-254	Locking Screw		1
255	EHB1018VM-255	Special Washer		1
256	EHB1018VM-256	Locking Piece		1
257	TS-0680061	Flat Washer	1/2"	1
258	TS-0561051	Hex Nut	1/2"-12	2
259	TS-0267121	Socket Set Screw	1/4x3/4"	1
260	EHB1018VM-260	Table		1
261	TS-0051051	Hex Cap Screw	5/16"x1"	4
262	EHB1018VM-262	Block		1
263	EHB1018VM-263	Swiveling Seat		1
263-1	EHB1018VM-263-1	Support Seat		1
263-2	TS-0070161	Hex Cap Screw	1/2x5-1/2"	1
263-3	TS-0640111	Hex Nut	1/2"	1
263-4	TS-0060071	Hex Cap Screw	3/8x1-1/2"	1
263-5	TS-0570031	Hex Nut	3/8"-16	1
264	TS-0050031	Hex Cap Screw	1/4"x3/4"	2
265	EHB916V-265	Collar		2
266	TS-0271031	Socket Set Screw	3/8-16Tx3/8"	4
267	EHB916V-267	Copper		2
268	TS-0271031	Socket Set Screw	3/8-16Tx3/8"	2
269	EHB916V-269	Pivot Shaft		1
270	EHB1018VM-270	Spindle		1
271	MBS1018-1-271	Base Assembly		1
271-1	MBS1018-1-271-1	Left Door		1
271-2	MBS1018-1-271-2	Right Door		1
271-3	MBS1018-1-271-3	Rear Door		1
271-4	MBS1018-1-271-4	Wiring Box		1
272	EHB1018VM-272	Sliding Surface		1
273	TS-0267071	Socket Set Screw	1/4-20x3/4"	6
274	TS-0051051	Hex Cap Screw	5/16"-18x1"	3
276	EHB1018VM-276	Seat		1
277	EHB1018VM-277	Movable Block		1
278	EHB916V-278	Spray Gun Set		1
278-1	EHB916V-278-1	Hook		1
278-2	EHB916V-278-2	Hex Cap Screw		2
279	TS-0051051	Hex Cap Screw	5/16"-18x1"	2
280	TS-0561051	Hex Nut	1/2"-12T	4
281	EHB1018VM-281	Coolant Tank		1
281-1	EHB1018V-281-1	Coolant Pump	1/8Hp,230V,1 Ph	1
281-1	EHB1018VM-281-1	Coolant Pump	1/8Hp,230V,3 Ph	1
281-2	EHB916V-281-2	Pan Head Machine Screw		1
281-3	EHB916V-96	3 Way Coolant Block		1
281-4	MBS1018-1-281-4	Lock with Key		1
281-5	MBS1018-1-281-5	Lock without Key		2
282	EHB1018VM-282	Bracket		1
283	TS-0070051	Hex Cap Screw	1/2"-12x2"	4
284	TS-0051061	Hex Cap Screw	5/16"x1-1/4"	8
285	TS-0267071	Set Screw	1/4"-20x3/4"	8
286	EHB1018VM-286	Strap		1
287	EHB916V-26	Special Washer		1
288	TS-0680021	Flat Washer	1/4"	2
289	TS-0050031	Hex Cap Screw	1/4"-20x3/4"	2
290	MBS1018-1-290	Knob		1
291	EHB1018V-258	Shaft	7/8"	1
292	EHB1018V-259	Stop Bracket		1
293	EHB1018V-260	Bar		1
294	EHB916V-261	Knob		2
295	EHB1018VM-295	Arch Seat		1
296	EHB1018VM-296	Support Block		1
296-1	EHB1018VM-296-1	Socket Head Cap Screw		2
296-2	EHB1018VM-296-2	Screw w/Nut		1
297	EHB916V-261	Knob		1

Index No	Part No	Description	Size	Qty
298	EHB1018VM-298	Scale		1
299	EHB1018VM-299	Indicator		1
311	EHB1018VM-311	Acme Lead Screw Seat		1
312	TS-0680031	Flat Washer	5/16"	2
313	TS-0208061	Socket Head Cap Screw	5/16-18x1"	2
314	EHB1018VM-314	Fixing Rod For Spring		1
315	TS-0211071	Socket Head Cap Screw	1/2"x1-1/2"	1
316	EHB1018VM-316	Spring		1
317	EHB1018VM-317	Spring Cover		1
318	EHB1018VM-318	Bracket		1
319	EHB1018VM-319	Spindle		1
319-1	EHB1018VM-319-1	Open Pin	1/8x1"	2
	LM000248	ID/Warning Label, MBS-1018-1 (not shown)		1
	LM000249	ID/Warning Label, MBS-1018-3 (not shown)		1

12.3.1 MBS-1018-1/MBS-1018-3 Electrical Box Assembly – Exploded View



### 12.3.2 MBS-1018-1 Electrical Box Assembly – Parts List

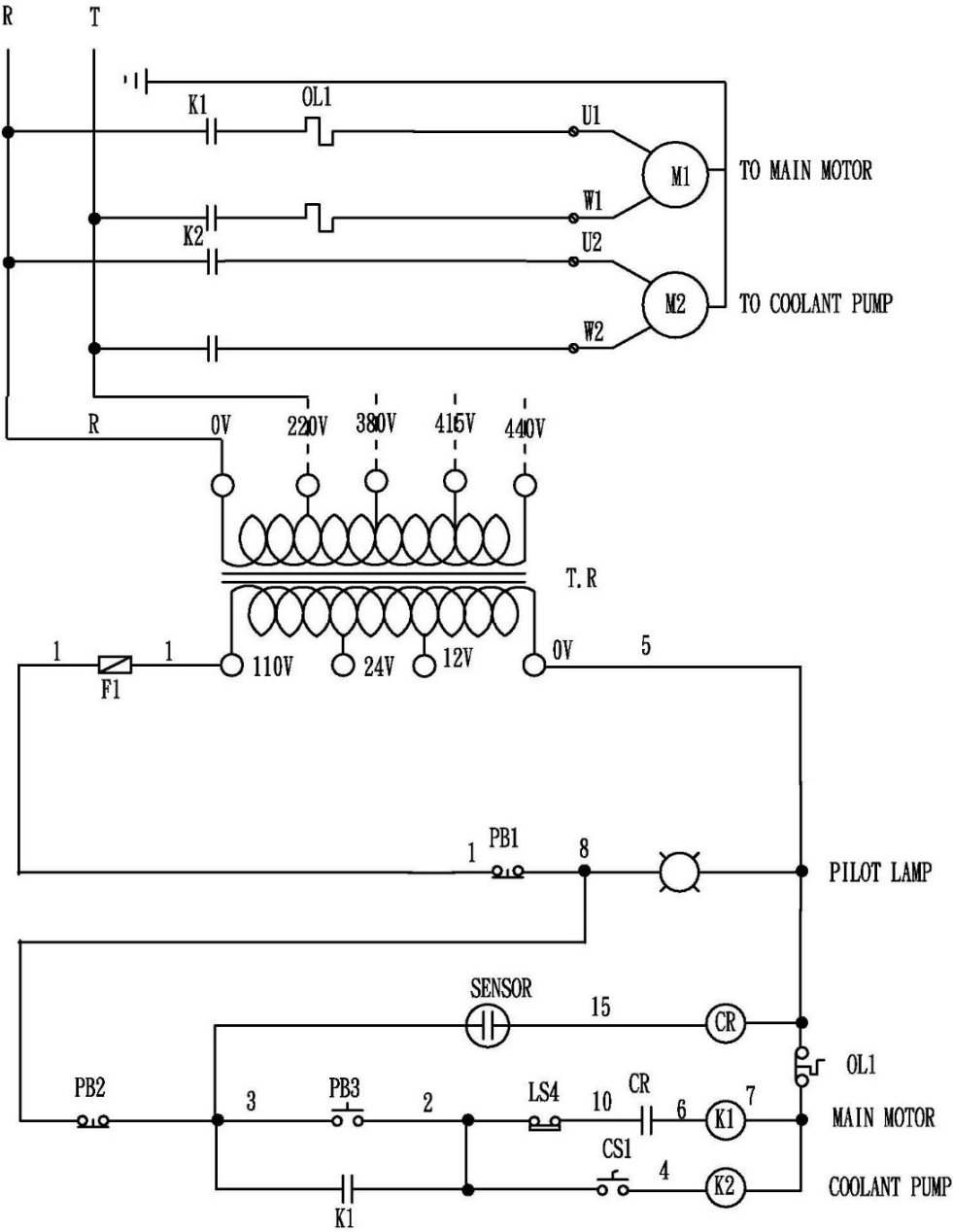
Index No	Part No	Description	Size	Qty
308-1	EHB916V-308-1	Transformer	115/230/110V	1
308-2	EHB916V-308-2	Fuse Block	32A	1
308-2-1	MBS1018-1-308-2-1	Fuse	3A	1
308-3	EHB916V-308-3	Overload Relay	100/110VAC	1
308-4	EHB916V-308-4	Relay Socket	CT-BMY2	1
308-5	MBS1018-1-308-5	Terminal Block		6
308-6	MBS1018-1-308-6	Electrical Plate		1
308-7	TS-081D022	Phillips Pan Hd Machine Screw	#10-32x3/8"	30
308-8	TS-0680011	Washer	3/16"	30
308-9	MBS1018-1-308-9	Power Cable		1
308-10	MBS1018-1-308-10	Control Cable		1
308-11	MBS1018-1-308-11	Ground Cable	Yellow/Green	1
308-12	EHB1018V-308-12	Overload Relay	11.3-16A	1
308-13	EHB916V-308-13	Magnetic Contactor	CU-11/110V	2
308-15	MBS1018-1-308-15	Motor Cable		1
308-16	MBS1018-1-308-16	Pump Cable		1
308-19	MBS1018-1-308-19	Limit Switch Cable		1

### 12.3.3 MBS-1018-3 Electrical Box Assembly – Parts List

Index No	Part No	Description	Size	Qty
308-1	EHB1018VM-308-1	Transformer	230/460/12/24/110V	1
308-2	EHB916V-308-2	Fuse Block	32A	1
308-2-1	MBS1018-1-308-2-1	Fuse	3A	1
308-3	MBS1018-1-308-3	Overload Relay	100/110VAC	1
308-4	EHB916V-308-4	Relay Socket	CT-BMY2	1
308-5	MBS1018-1-308-5	Terminal Block		6
308-6	MBS1018-3-308-6	Electrical Plate		1
308-7	TS-081D022	Phillips Pan Hd Machine Screw	#10-32x3/8"	30
308-8	TS-0680011	Washer	3/16"	30
308-9	MBS1018-3-308-9	Power Cable		1
308-10	MBS1018-3-308-10	Control Cable		1
308-11	MBS1018-3-308-11	Ground Cable	Yellow/Green	1
308-12	EHB1018VM-308-12	Overload Relay	5.5-7.5A	1
308-13	EHB1018VM-308-13	Magnetic Contactor	CU-11/110V	2
308-15	MBS1018-3-308-15	Motor Cable		1
308-16	MBS1018-3-308-16	Pump Cable		1
308-19	MBS1018-3-308-19	Limit Switch Cable		1

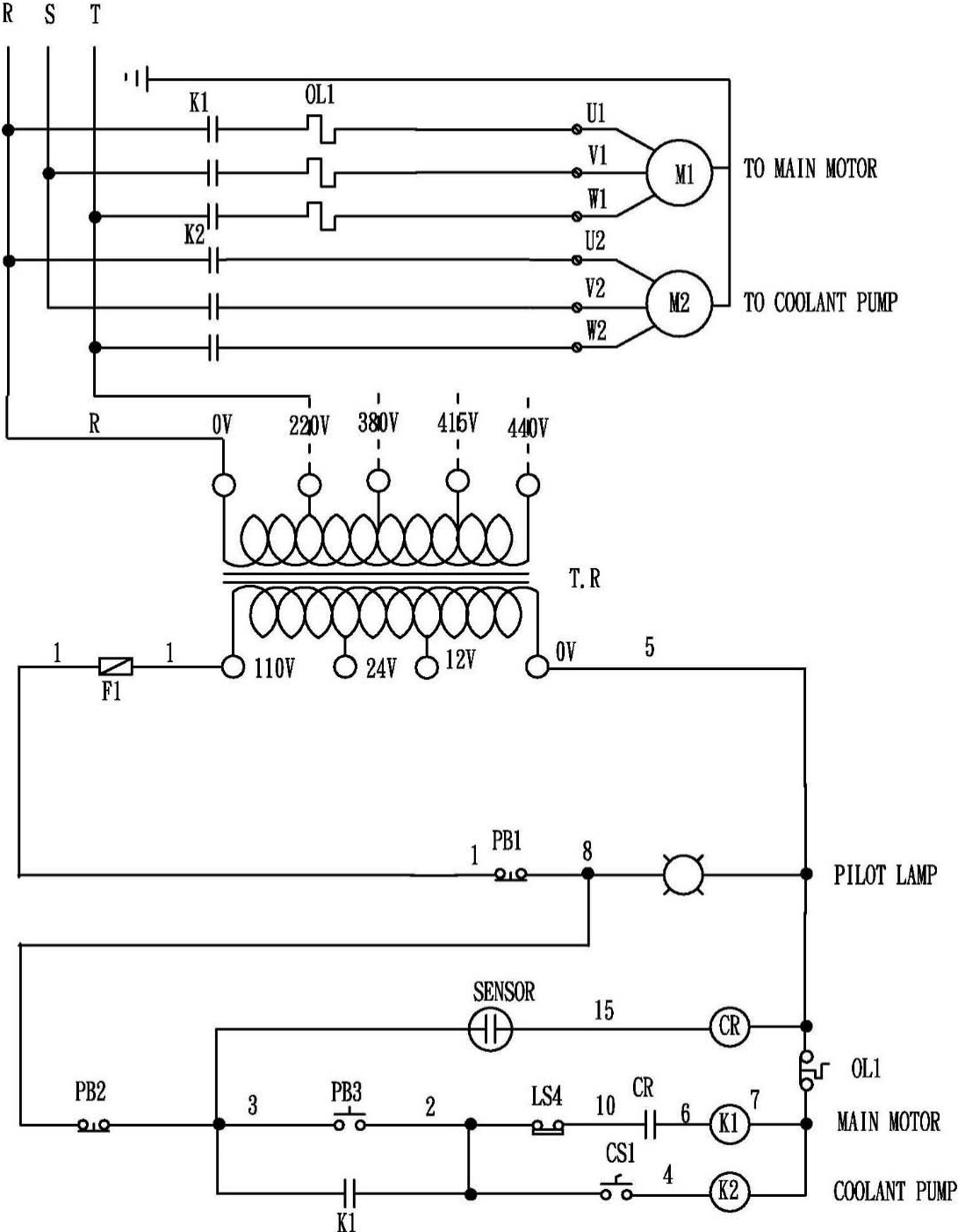
# 13.0 Electrical Connections

## 13.1 Wiring Diagram for MBS-1018-1



- K1,K2 – contactor
- LS4 – limit switch
- M1 – main motor
- M2 – coolant pump
- OL1 – overload
- PB1 – emergency stop button
- PB2,PB3 – pushbutton
- TR – transformer

### 13.2 Wiring Diagram for MBS-1018-3



## 14.0 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.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

### 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

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

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