

READ THIS FIRST

Model M1054

IMPORTANT UPDATE

Applies to Models Mfd. Since 6/20,
Manual Insert Printed 10/10,
and Owner's Manual Revised 8/07

Phone #: (360) 734-3482 • Tech Support: techsupport@woodstockint.com • Web: www.woodstockint.com



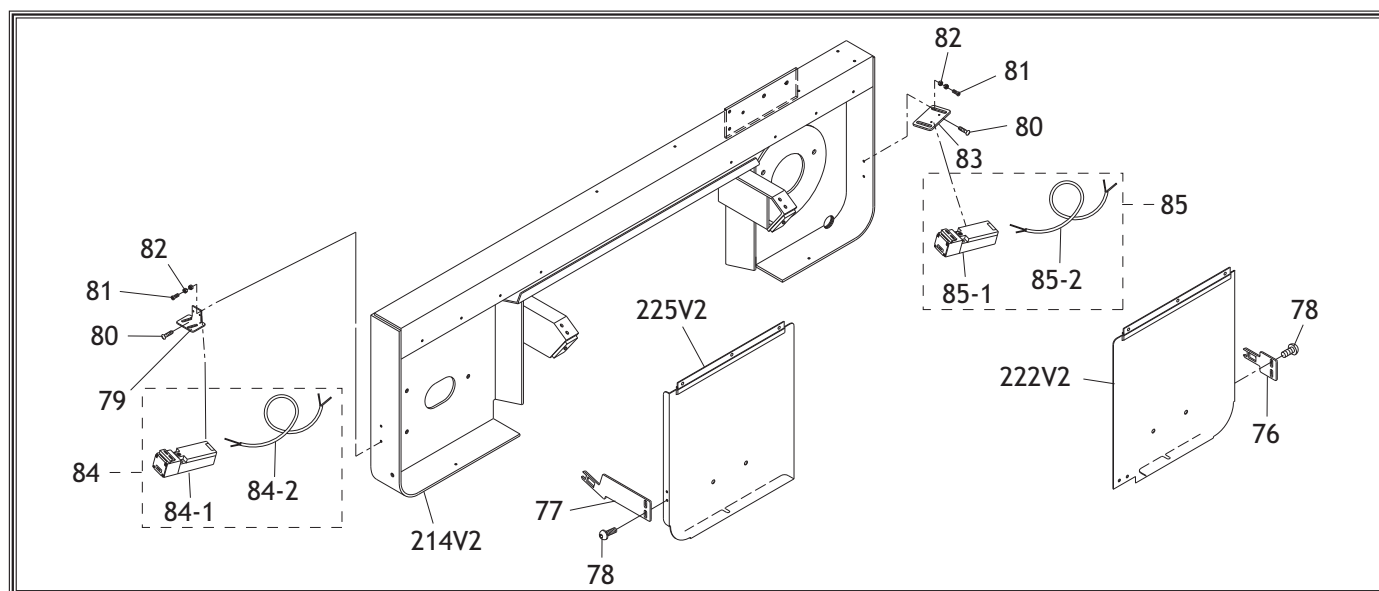
We made the following changes to this machine since the manual was printed:

- The saw bow and blade covers changed to allow for the mounting of two limit switches.

Aside from the information contained in this update, all other content in the owner's manual is applicable and **MUST** be read and understood for your own safety.

IMPORTANT: Keep this update with the owner's manual for future reference. If you have any further questions, contact our Technical Support.

Revised Parts Breakdown



REF	PART #	DESCRIPTION
76	XM1054076	FRONT LIMIT SWITCH KEY
77	XM1054077	REAR LIMIT SWITCH KEY
78	XM1054078	BUTTON HD CAP SCR M4-.5 X 12
79	XM1054079	REAR LIMIT SWITCH BRACKET
80	XM1054080	PHLP HD SCR M5-.8 X 10
81	XM1054081	CAP SCREW M4-.7 X 12
82	XM1054082	HEX NUT M4-.7
83	XM1054083	FRONT LIMIT SWITCH BRACKET
84	XM1054084	REAR LIMIT SWITCH SQ3

REF	PART #	DESCRIPTION
84-1	XM1054084-1	LIMIT SWITCH KEDU QKS8
84-2	XM1054084-2	LIMIT SWITCH CORD 18G 2W 60"
85	XM1054085	FRONT LIMIT SWITCH SQ2
85-1	XM1054085-1	LIMIT SWITCH KEDU QKS8
85-2	XM1054085-2	LIMIT SWITCH CORD 18G 2W 60"
214V2	XM1054214V2	SAW BOW V2.06.20
222V2	XM1054222V2	BLADE COVER V2.06.20
225V2	XM1054225V2	REAR BLADE COVER V2.06.20

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#21273CS

Printed in Taiwan

Electrical Safety Instructions

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (360) 734-3482 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

WARNING

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

QUALIFIED ELECTRICIAN. Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

MODIFICATIONS. Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (360) 734-3482.

Electrical Components



Figure 41. Downfeed limit switch (SQ1).

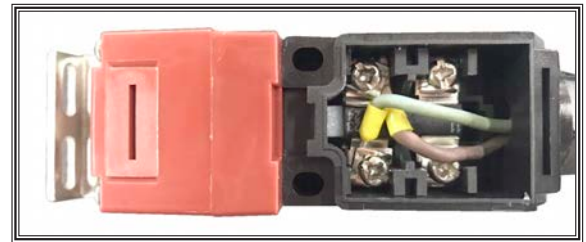


Figure 44. Front cover limit switch (SQ2).



Figure 42. Junction box (M1).

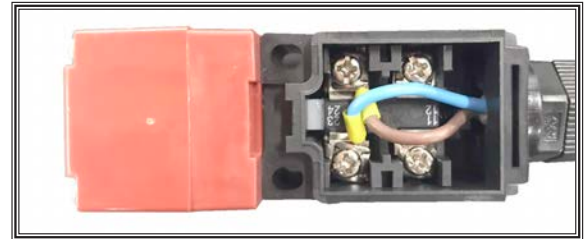


Figure 45. Rear cover limit switch (SQ3).

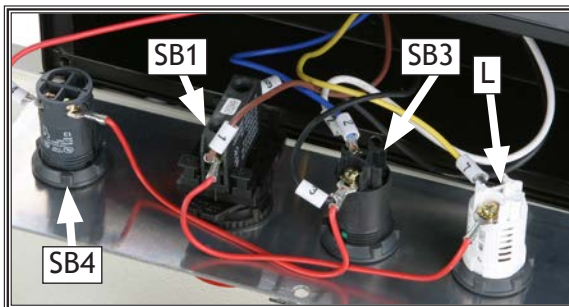


Figure 43. Control panel wiring.



Figure 46. Pump motor/capacitor (M2).

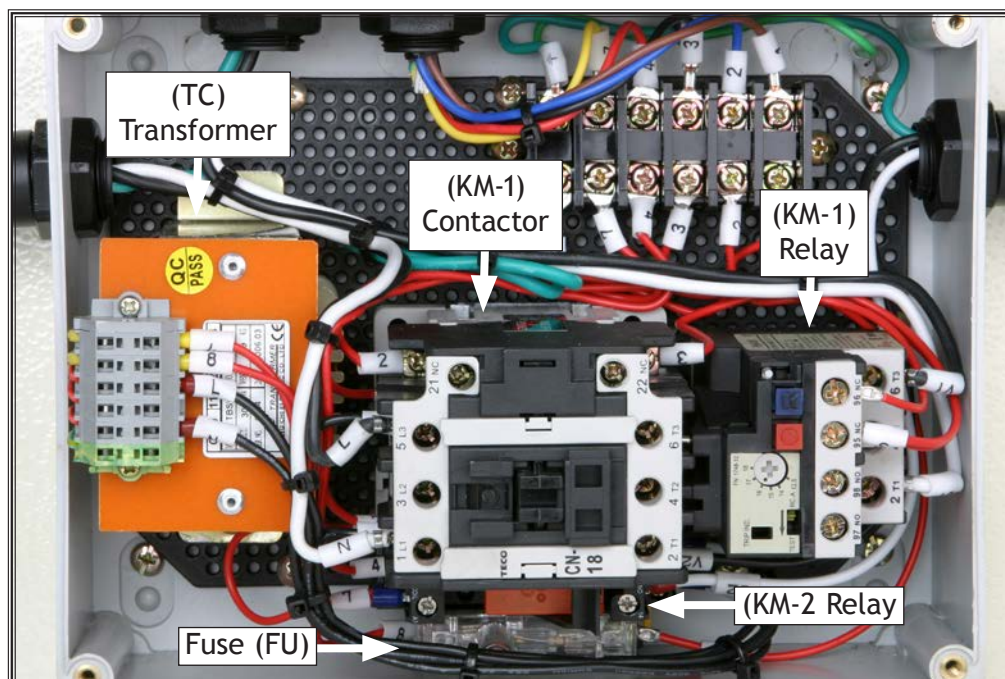
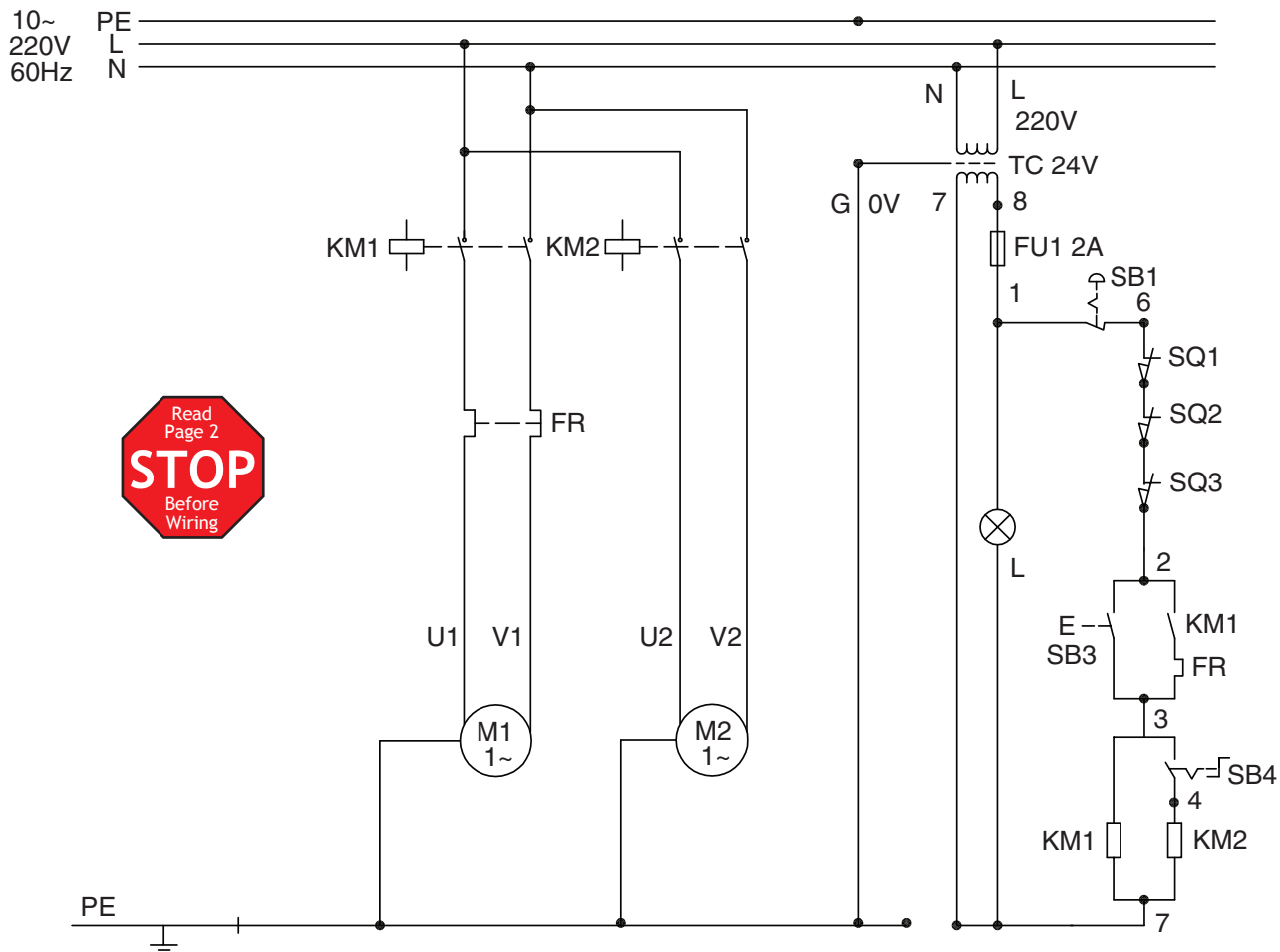


Figure 47. M1048 Contactor & relay electrical box.

Model M1054 220V Wiring Diagram



LEGEND

M1 = Main Motor
M2 = Pump Motor
KM1 = Contactor Main Motor
KM2 = Contactor Pump Motor
L = Indicator Lamp
SB1 = Emergency Stop Button
SB3 = Start Button
SB4 = Pump Motor Switch
SQ1 = Downfeed Limit Switch
SQ2 = Front Cover Limit Switch
SQ3 = Rear Cover Limit Switch
TC = Transformer for Control System
FU1 = Fuse
FR = Thermal Relay Main Motor

Model M1054
10" x 18" Metal Cutting Bandsaw
Manual Insert
(For Models Manufactured Since 4/10)



Phone #: (360) 734-3482 • Online Tech Support: tech-support@shopfox.biz • Web: www.shopfox.biz

The Model M1054 is the same machine as the Model M1048 except for improvements to the headstock, belt tension mechanism, vise, and other small changes. The Data Sheet and parts breakdowns in this insert replace the corresponding sections in the M1048 manual. All other content in the Model M1048 owner's manual applies to this machine. Before operating your new machine, you **MUST** read and understand this insert and the entire Model M1048 manual to reduce the risk of injury when using this machine.

If you have any further questions about this manual insert or the differences between the Model M1054 and the Model M1048, contact Technical Support at (360) 734-3482 or email tech-support@shopfox.biz.



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#13340JB

Printed in Taiwan

MACHINE SPECIFICATIONS



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MODEL M1054 10" X 18" METAL CUTTING BANDSAW

Product Dimensions:

Weight 705 lbs.
Length/Width/Height 67³/₄ x 24¹/₂ x 41¹/₂ in.
Foot Print (Length/Width) 47 x 21 in.

Shipping Dimensions:

Type Wood Slat Crate
Weight 770 lbs.
Length/Width/Height 69 x 27 x 46 in.

Electrical:

Required Power Source 220V-240V, Single-Phase, 60Hz
Minimum Circuit Size 20 Amp
Switch Push Button ON/OFF
Switch Voltage 220V
Cord Length 7 ft.
Cord Gauge 14 Gauge
Plug Included No
Recommended Plug Type NEMA L6-20 or 6-20

Motor:

Type TEFC Capacitor Start Induction
Horsepower 1¹/₂ HP
Voltage 220V
Phase Single-Phase
Amps 15.5A
Speed 1725 RPM
Cycle 60 Hz
Power Transfer Pulley + Gear
Bearings Shielded & Lubricated

Main Specifications:

Operation Information

Blade Speeds 114, 196, 288, 377 FPM
Blade Length 121¹/₂ in.

Table Information

Table Length 30 in.
Table Width 6¹/₂ in.
Floor-To-Vise Height 22³/₄ in.

Cutting Capacities

Angle Cuts	45-90 deg.
Vise Jaw Depth	12 in.
Vise Jaw Height.....	5 in.
Max. Capacity Rectangle Width at 90°	18 in.
Max. Capacity Rectangle Height at 90°	10 in.
Max. Capacity Rectangle Height at 90° and Maximum Width.....	5 in.
Max. Capacity Round at 90°	10 in.
Max. Capacity Rectangle Width at 45°	9 ³ / ₈ in.
Max. Capacity Rectangle Height at 45°	7 in.
Max. Capacity Round at 45°	6 in.

Construction

Table Construction	Precision-Ground Cast Iron
Stand Construction	Pre-Formed Steel
Bow Construction.....	Cast Iron
Wheel Construction	Cast Iron
Base Construction	Cast Iron
Paint.....	Epoxy

Miscellaneous

Wheel Size	11 ¹ / ₂ in.
Blade Guides Upper	Ball Bearing
Blade Guides Lower	Ball Bearing + Carbide Guide
Coolant Capacity.....	1 ¹ / ₂ Gallons

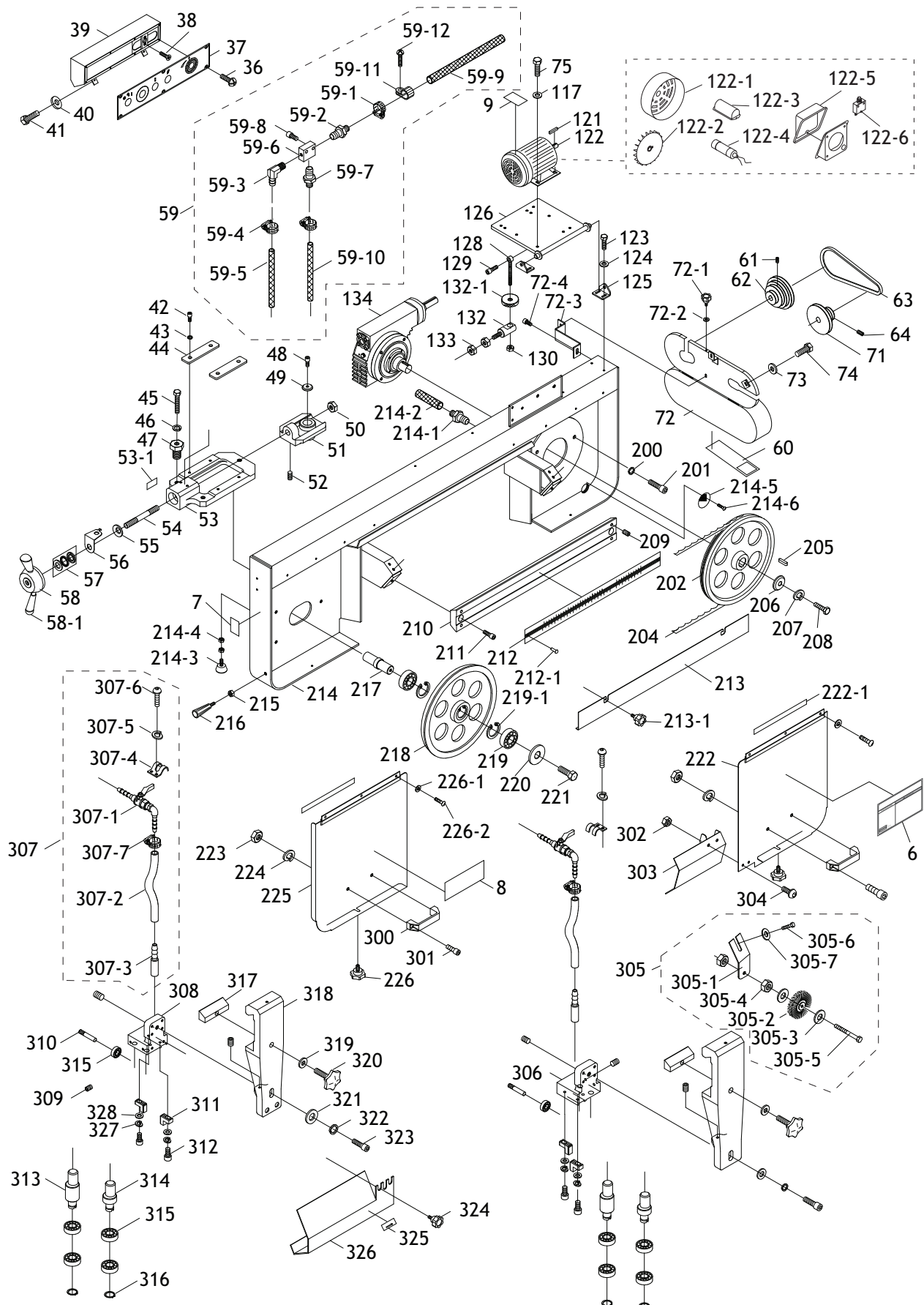
Other Specifications:

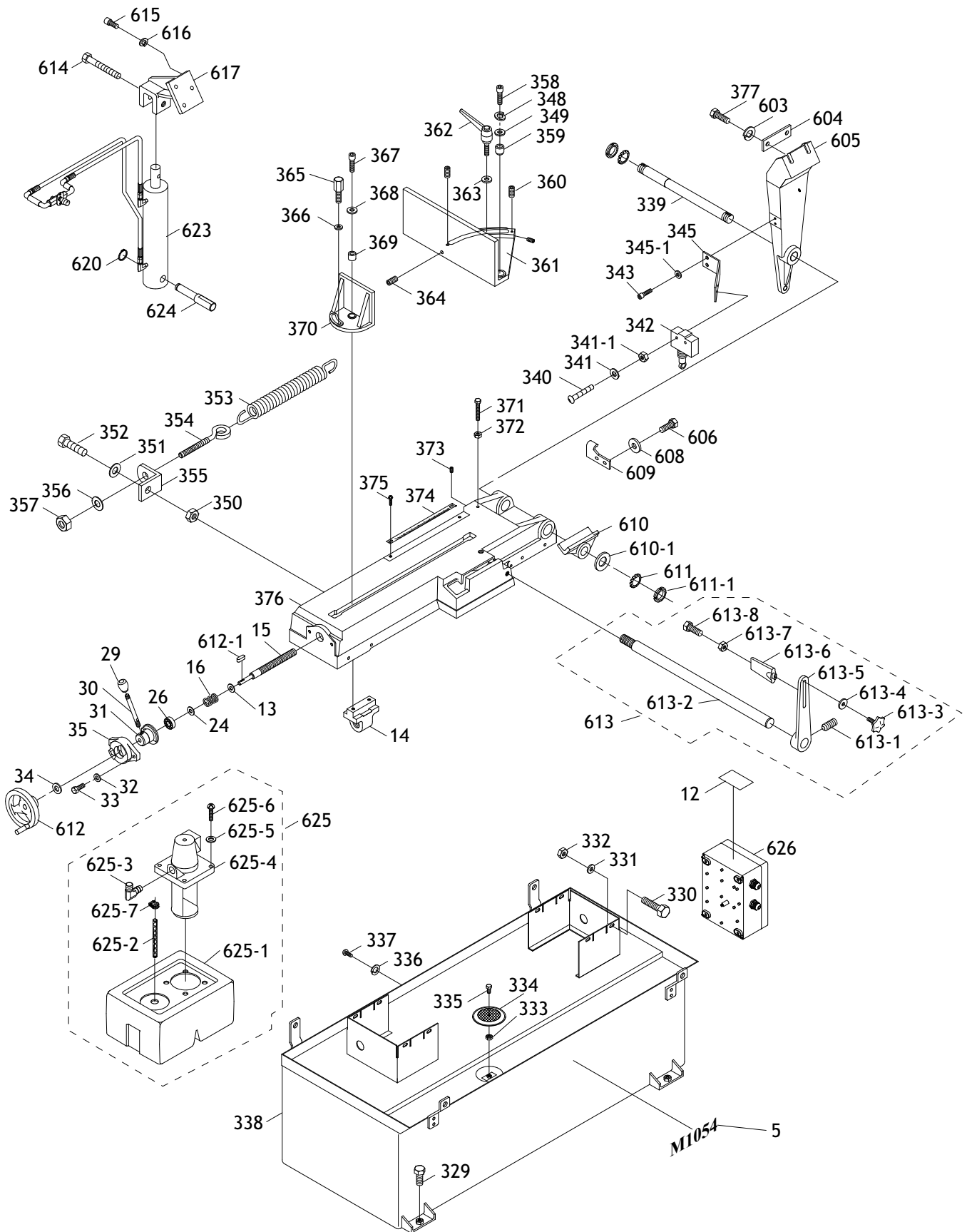
ISO Factory.....	ISO 9001
Country Of Origin	Taiwan
Warranty.....	2 Years
Serial Number Location	ID Label on Front of Machine
Assembly Time.....	90 Minutes

Features:

Centralized control panel on top of saw bow
 Heavy-duty all-steel 1-piece base
 Adjustable hydraulic downfeed
 Worm gear box has hardened and ground gears
 Quick-release vise for fast job changes
 Miter cutting ability
 Blade wheels have heavy-duty ball bearings
 Magnetic safety switch

Parts Breakdown





Parts List

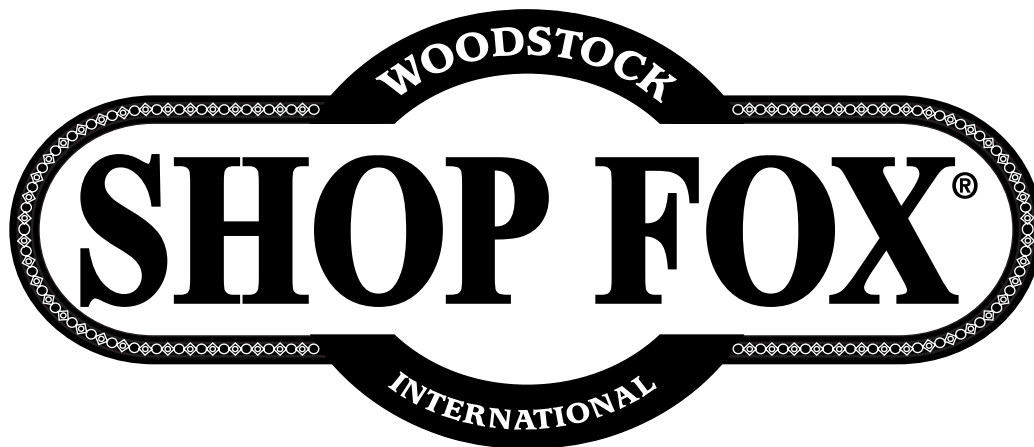
REF	PART #	DESCRIPTION	REF	PART #	DESCRIPTION
5	XM1054005	MODEL NUMBER LABEL	59-9	XM1054059-9	CUTTING FLUID HOSE 1/4"ID X 52"
6	XM1054006	MACHINE ID LABEL	59-10	XM1054059-10	CUTTING FLUID HOSE 1/4"ID X 12-1/2"
7	XM1054007	BLADE TENSION LABEL	59-11	XM1054059-11	HOSE CLIP
8	XM1054008	CUTTING SELECTION	59-12	XPS68M	PHLP HD SCR M6-1 X 10
9	XM1054009	MOTOR LABEL	60	XM1054060	SPEED INDICATOR LABEL
12	XM1054012	ELECTRICITY WARNING LABEL	61	XPSS16M	SET SCREW M8-1.25 X 10
13	XM1054013	WISE LEADSCREW WASHER 1/2"	62	XM1054062	MOTOR PULLEY
14	XM1054014	WISE LEADSCREW NUT	63	XPVA32	V-BELT A32
15	XM1054015	WISE LEADSCREW	64	XPSS16M	SET SCREW M8-1.25 X 10
16	XM1054016	COMPRESSION SPRING	71	XM1054071	SPINDLE PULLEY
24	XM1054024	WISE LEADSCREW WASHER 12MM	72	XM1054072	MOTOR PULLEY COVER ASSEMBLY
26	XM1054026	WISE LEADSCREW BEARING	72-1	XM1054072-1	KNOB BOLT M6-1 X 10
29	XM1054029	LEVER CAP	72-2	XPW03M	FLAT WASHER 6MM
30	XM1054030	WISE QUICK RELEASE LEVER	72-3	XM1054072-3	BLADE COVER BRACKET
31	XM1054031	WISE QUICK RELEASE HUB	72-4	XPCAP04M	CAP SCREW M6-1 X 10
32	XPW02	FLAT WASHER 3/8	73	XPW03M	FLAT WASHER 6MM
33	XPB24	HEX BOLT 3/8-16 X 1-1/4	74	XPB04M	HEX BOLT M6-1 X 10
34	XPW06M	FLAT WASHER 12MM	75	XPB87M	HEX BOLT M8-1.25 X 15
35	XM1054035	WISE LEADSCREW PILLOW BLOCK	117	XPW01M	FLAT WASHER 8MM
36	XPS05M	PHLP HD SCR M5-.8 X 8	121	XM1054121	KEY 8 X 7 X 30
37	XM1054037	CONTROL PANEL	122	XM1054122	MOTOR 1HP 110/220V 60HZ
38	XPFH02M	FLAT HD SCR M6-1 X 12	122-1	XM1054122-1	MOTOR FAN COVER
39	XM1054039	CONTROL BOX	122-2	XM1054122-2	MOTOR FAN
40	XPW03M	FLAT WASHER 6MM	122-3	XM1054122-3	CAPACITOR COVER
41	XPB02M	HEX BOLT M6-1 X 12	122-4	XPC800	S CAPACITOR 800M 125V 1-3/4 X 3-3/8
42	XPCAP52M	CAP SCREW M8-1.25 X 10	122-5	XM1054122-5	MOTOR JUNCTION BOX
43	XPLW04M	LOCK WASHER 8MM	122-6	XM1054122-6	THERMAL OVERLOAD
44	XM1054044	PRESS BOARD	123	XPB08M	HEX BOLT M6-1 X 20
45	XPB34M	HEX BOLT M10-1.5 X 60	124	XPW03M	FLAT WASHER 6MM
46	XPLW06M	LOCK WASHER 10MM	125	XM1054125	MOTOR BRACKET
47	XM1054047	THREADED INSERT	126	XM1054126	MOTOR PLATE
48	XPCAP14M	CAP SCREW M8-1.25 X 20	128	XM1054128	SHAFT
49	XPW01M	FLAT WASHER 8MM	129	XM1054129	CAP SCREW M10-1.5
50	XPN13M	HEX NUT M16-2	130	XPN09M	HEX NUT M12-1.75
51	XM1054051	BLADE WHEEL BASE	132	XM1054132	THREADED ROD END M10
52	XPSS11M	SET SCREW M6-1 X 16	132-1	XM1054132-1	KNOB
53	XM1054053	BLADE WHEEL BASE WAY	133	XPN02M	HEX NUT M10-1.5
53-1	XM1054053-1	TENSION SCALE	134	XM1054134	GEARBOX ASSEMBLY 30:1 DRIVE
54	XM1054054	BLADE LEADSCREW	200	XPLW06M	LOCK WASHER 10MM
55	XM1054055	CONCAVE WASHER 16MM	201	XPCAP61M	CAP SCREW M10-1.5 X 20
56	XM1054056	TENSION INDICATION RING	202	XM1054202	DRIVE WHEEL
57	XP51203	THRUST BEARING 51203	204	XM1054204	BLADE 1 X 1/32 X 121-1/2
58	XM1054058	BLADE TENSION HANDWHEEL	205	XPK136M	KEY 8 X 8 X 30
58-1	XM1054058-1	BLADE TENSION HANDLE	206	XM1054206	DRIVE WHEEL WASHER
59	XM1054059	3 WAY VALVE ASSEMBLY	207	XPLW05M	LOCK WASHER 12MM
59-1	XM1054059-1	HOSE CLAMP 12MM	208	XPB27M	HEX BOLT M12-1.75 X 30
59-2	XM1054059-2	STRAIGHT CONNECTOR 1/4 NPT	209	XPSS09M	SET SCREW M8-1.25 X 20
59-3	XM1054059-3	L CONNECTOR	210	XM1054210	COLUMN
59-4	XM1054059-4	HOSE CLAMP 19MM	211	XPCAP129M	CAP SCREW M12-1.75 X 20
59-5	XM1054059-5	CUTTING FLUID HOSE 1/4"ID X 31-1/2"	212	XM1054212	SCALE
59-6	XM1054059-6	3 WAY VALVE	212-1	XPRIV001M	RIVET 2 X 5MM
59-7	XM1054059-7	STRAIGHT CONNECTOR 1/4 NPT	213	XM1054213	COVER
59-8	XM1054059-8	CAP SCREW M6-1 X 30	213-1	XM1054072-1	KNOB BOLT M6-1 X 10

REF	PART #	DESCRIPTION
214	XM1054214	SAW BOW
214-1	XM1054214-1	PIPE CONNECTOR 1/2 NPT
214-2	XM1054214-2	CUTTING FLUID HOSE
214-3	XM1054214-3	RUBBER FOOT M8-1.25 X 40
214-4	XPN03M	HEX NUT M8-1.25
214-5	XM1054214-5	FILTER
214-6	XPBHS35M	BUTTON HD CAP SCR M5-.8 X 10
215	XPN08	HEX NUT 3/8-16
216	XM1054216	HANDLE
217	XM1054217	SHAFT
218	XM1054218	IDLER WHEEL
219	XM1054219	TAPERED ROLLER BEARING 6025
219-1	XPR26M	INT RETAINING RING 52MM
220	XM1054220	STEEL WASHER 16 X 30 X 3MM
221	XPB09M	HEX BOLT M8-1.25 X 20
222	XM1054222	BLADE COVER
222-1	XM1054222-1	FOAM PAD
223	XPN03M	HEX NUT M8-1.25
224	XPLW04M	LOCK WASHER 8MM
225	XM1054225	REAR BLADE COVER
226	XM1054072-1	KNOB BOLT M6-1 X 10
226-1	XPW02M	FLAT WASHER 5MM
226-2	XPBHS35M	BUTTON HD CAP SCR M5-.8 X 10
300	XM1054300	HANDLE
301	XPCAP100M	CAP SCREW M8-1.25 X 15
302	XPN01M	HEX NUT M6-1
303	XM1054303	REAR BLADE GUARD
304	XPBHS09M	BUTTON HD CAP SCR M6-1 X 12
305	XM1054305	BRUSH ASSEMBLY
305-1	XM1054305-1	BRUSH SUPPORT BRACKET
305-2	XM1054305-2	BLADE BRUSH
305-3	XPW03M	FLAT WASHER 6MM
305-4	XPN01M	HEX NUT M6-1
305-5	XPB52M	HEX BOLT M6-1 X 35
305-6	XPB04M	HEX BOLT M6-1 X 10
305-7	XPW03M	FLAT WASHER 6MM
306	XM1054306	LOWER BLADE GUIDE BLOCK
307	XM1054307	VALVE ASSEMBLY
307-1	XM1054307-1	CUTTING FLUID VALVE
307-2	XM1054307-2	HOSE 6MM
307-3	XM1054307-3	HOSE FITTING
307-4	XM1054307-4	HOSE CLIP
307-5	XPLW03M	LOCK WASHER 6MM
307-6	XPBHS09M	BUTTON HD CAP SCR M6-1 X 12
307-7	XM1054307-7	HOSE CLAMP 12MM
308	XM1054308	UPPER BLADE GUIDE BLOCK
309	XM1054309	SET SCREW M6-1 X 5
310	XM1054310	BEARING SHAFT
311	XM1054311	CARBIDE GUIDE
312	XPCAP02M	CAP SCREW M6-1 X 20
313	XM1054313	LONG ECCENTRIC SHAFT
314	XM1054314	SHORT ECCENTRIC SHAFT
315	XP608-2RS	BALL BEARING 608-2RS
316	XPR39M	EXT RETAINING RING 8MM

REF	PART #	DESCRIPTION
317	XM1054317	GIB
318	XM1054318	BLADE GUIDE ARM
319	XPW04M	FLAT WASHER 10MM
320	XM1054320	BLADE GUIDE KNOB BOLT
321	XPW01M	FLAT WASHER 8MM
322	XPLW04M	LOCK WASHER 8MM
323	XPB07M	HEX BOLT M8-1.25 X 25
324	XM1054072-1	KNOB BOLT M6-1 X 10
325	XM1054325	SAW DIRECTION LABEL
326	XM1054326	FRONT BLADE GUARD
327	XPLW03M	LOCK WASHER 6MM
328	XPW03M	FLAT WASHER 6MM
329	XPB39M	HEX BOLT M6-1 X 50
330	XPB15M	HEX BOLT M8-1.25 X 40
331	XPW07	FLAT WASHER 5/16
332	XPN03M	HEX NUT M8-1.25
333	XPN01M	HEX NUT M6-1
334	XM1054334	FILTER
335	XPB18M	HEX BOLT M6-1 X 15
336	XPLW02	LOCK WASHER 1/4
337	XPS68M	PHLP HD SCR M6-1 X 10
338	XM1054338	BASE
339	XM1054339	PIVOT SHAFT
340	XPS51M	PHLP HD SCR M4-.7 X 30
341	XPW05M	FLAT WASHER 4MM
341-1	XPN04M	HEX NUT M4-.7
342	XM1054342	SAFETY SWITCH
343	XPCAP25M	CAP SCREW M6-1 X 12
345	XM1054345	LIMIT SWITCH SUPPORT
345-1	XPW03M	FLAT WASHER 6MM
348	XPLW06M	LOCK WASHER 10MM
349	XPW04M	FLAT WASHER 10MM
350	XPN02	HEX NUT 5/16-18
351	XPW07	FLAT WASHER 5/16
352	XPB07	HEX BOLT 5/16-18 X 3/4
353	XM1054353	EXTENSION SPRING
354	XM1054354	SPRING ADJUSTING ROD
355	XM1054355	SPRING HANDLE BRACKET
356	XPW02	FLAT WASHER 3/8
357	XPN08	HEX NUT 3/8-16
358	XPCAP84M	CAP SCREW M10-1.5 X 35
359	XM1054359	BUSHING
360	XPSS01M	SET SCREW M6-1 X 10
361	XM1054361	REAR VISE JAW
362	XM1054362	VISE FENCE LOCK KNOB
363	XPW04M	FLAT WASHER 10MM
364	XPSS19M	SET SCREW M8-1.25 X 30
365	XM1054365	VISE LOCK KNOB BOLT
366	XPW04M	FLAT WASHER 10MM
367	XPCAP84M	CAP SCREW M10-1.5 X 35
368	XPW04M	FLAT WASHER 10MM
369	XM1054369	BUSHING
370	XM1054370	FRONT VISE JAW
371	XPB118M	HEX BOLT M8-1.25 X 45

REF	PART #	DESCRIPTION
372	XPNO3M	HEX NUT M8-1.25
373	XPSS16M	SET SCREW M8-1.25 X 10
374	XM1054374	ANGLE SCALE
375	XPS05M	PHLP HD SCR M5-.8 X 8
376	XM1054376	BASE
377	XPB14M	HEX BOLT M10-1.5 X 35
603	XPLW06M	LOCK WASHER 10MM
604	XM1054604	PIVOT BRACKET SPACER
605	XM1054605	REAR PIVOT BRACKET
606	XPB09M	HEX BOLT M8-1.25 X 20
608	XPW07	FLAT WASHER 5/16
609	XM1054609	POSITION BRACKET
610	XM1054610	PIVOT BRACKET
610-1	XM1054610-1	PIVOT SPACER
611	XPTLW08M	EXT TOOTH WASHER 10MM
611-1	XM1054611-1	SPANNER NUT M10-1.25
612	XM1054612	HANDWHEEL
612-1	XPB20M	KEY 5 X 5 X 15
613	XM1054613	WORK STOP SET
613-1	XPSS01M	SET SCREW M6-1 X 10
613-2	XM1054613-2	DISTANCE SET ROD
613-3	XM1054613-3	THUMB SCREW

REF	PART #	DESCRIPTION
613-4	XPLW02	LOCK WASHER 1/4
613-5	XM1054613-5	SUPPORT ROD
613-6	XM1054613-6	DISTANCE SET BRACKET
613-7	XPNO2M	HEX NUT M10-1.5
613-8	XPB32M	HEX BOLT M10-1.5 X 25
614	XPB73M	HEX BOLT M10-1.5 X 50
615	XPCAP13M	CAP SCREW M8-1.25 X 30
616	XPLW01	LOCK WASHER 5/16
617	XM1054617	CYLINDER UPPER BRACKET
620	XPR07M	EXT RETAINING RING 18MM
623	XM1054623	CYLINDER ASSEMBLY
624	XM1054624	PIVOT SHAFT
625	XM1054625	PUMP SET 1/8HP 110/220V
625-1	XM1054625-1	CUTTING FLUID TANK
625-2	XM1054625-2	HOSE 13X19-350MM
625-3	XM1054625-3	COUPLER PT1/2X1/4
625-4	XM1054625-4	PUMP 1/8HP 110/220V
625-5	XPW06	FLAT WASHER 1/4
625-6	XPS12	PHLP HD SCR 1/4-20 X 5/8
625-7	XM1054625-7	HOSE CLAMP 19MM
626	XM1054626	CONTROL BOX ASSEMBLY



MODEL M1048 10" X 18" METAL CUTTING BANDSAW



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WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

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

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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USE THE QUICK GUIDE PAGE LABELS TO SEARCH OUT INFORMATION FAST!

INTRODUCTION

Woodstock Technical Support

Your new **SHOP FOX®** 10" x 18" Metal Cutting Bandsaw has been specially designed to provide many years of trouble-free service. Close attention to detail, ruggedly built parts and a rigid quality control program assure safe and reliable operation.

Woodstock International, Inc. is committed to customer satisfaction. Our intent with this manual is to include the basic information for safety, setup, operation, maintenance, and service of this product.

We stand behind our machines! In the event that questions arise about your machine, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: tech-support@shopfox.biz. Our knowledgeable staff will help you troubleshoot problems and process warranty claims.

If you need the latest edition of this manual, you can download it from <http://www.shopfox.biz>.
If you have comments about this manual, please contact us at:

Woodstock International, Inc.
Attn: Technical Documentation Manager
P.O. Box 2309
Bellingham, WA 98227

Specifications

Bandsaw Motor Size	2HP, 15A, 220V, Single-Phase
Motor Speed	1,725 RPM
Power Transfer	V-Belt Drive and Worm-Gear Reduction
Angle Cuts	45-90°
Rear Vise Jaw Size	12 ¹ / ₂ "W x 5"H
Maximum Rectangular Height Capacity	5" at 90°
Maximum Rectangular Width Capacity	18 ³ / ₈ " at 90°
Maximum Rectangular Height Capacity	7" at 45°
Maximum Rectangular Width Capacity	9 ³ / ₈ " at 45°
Maximum Round Capacity	10" at 90°
Maximum Round Capacity	6" at 45°
Table Size	22" x 8"
Floor To Cutting Height	23"
Coolant Capacity	2-1/2 gal.
Footprint	47" x 19"
Overall Dimensions	68" L x 24" W x 41 ¹ / ₂ " H
Blade Speeds	114, 196, 288, 377 FPM
Blade Size	129 ³ / ₈ " x 1 ¹ / ₁₆ "
Bearings	Permanently-Lubricated Ball Bearings
Power Control	Push Button ON/OFF Switch
Net Weight	770 lbs.

Controls and Features

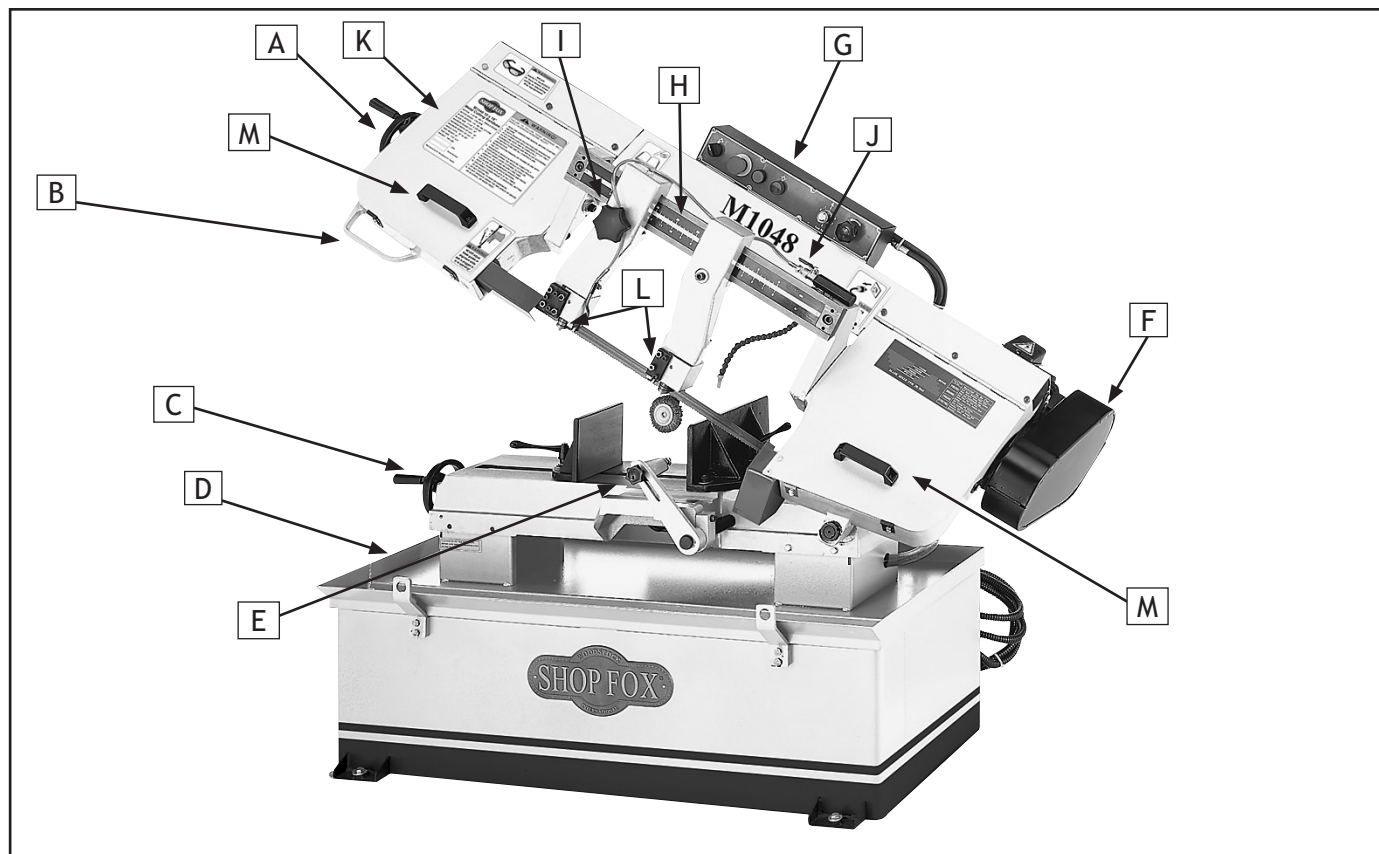


Figure 1. M1048 Machine Identification.

- A. Blade Tension Handwheel
- B. Lift Handle
- C. Vise Handwheel
- D. Coolant Drip Pan
- E. Work Stop
- F. Pulley Cover
- G. Control Panel
- H. Blade Guide Scale
- I. Blade Guide Knob
- J. Coolant Valve Control
- K. Bow
- L. Blade Guides
- M. Wheel Covers

Control Panel

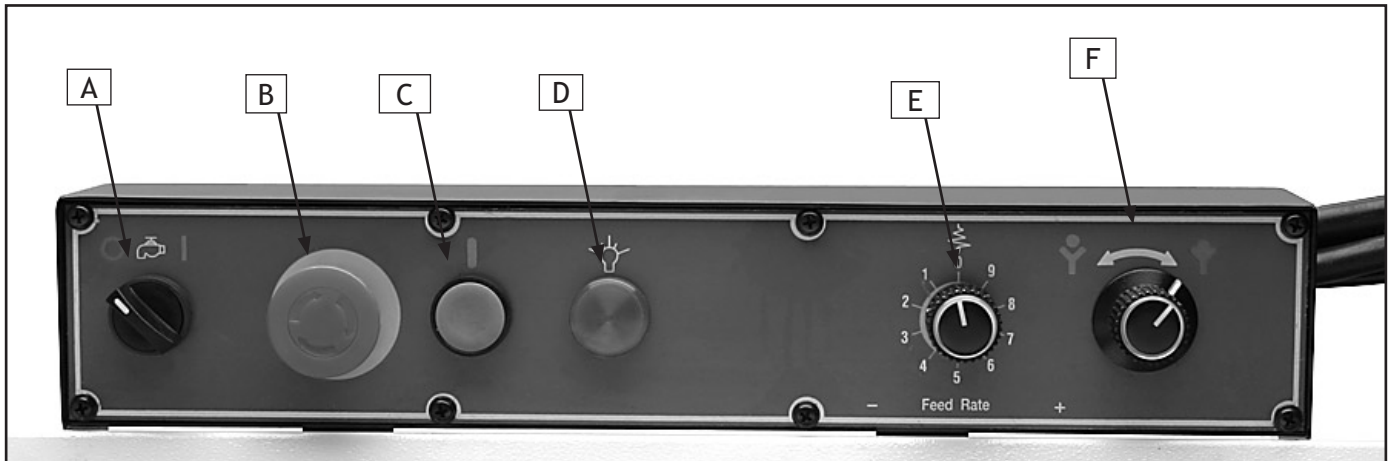


Figure 2. M1048 control panel.

- A. **Coolant Pump Switch:** Turns the coolant pump ON.
- B. **EMERGENCY STOP/OFF Button:** Interrupts power to the system and turns the motor **OFF**. Twist the button until it pops out to re-energize the system. Also works as a standard OFF button.

Note: The bandsaw has an automatic shut-off (limit switch) that turns the motor and coolant pump **OFF** at the bottom of the cut.

- C. **START Button:** Turns the motor **ON** and begins the sawing action.
- D. **Power Light:** When lit, indicates that system is energized and machine is ready to operate.
- E. **Feed Rate Dial:** Fine tunes the feed rate by controlling the hydraulic valve. Range is from 0 being slowest to 9 being fastest.
- F. **Feed Control Knob:** Turning the knob to the left lowers the bow at the feed rate you have set. Turning the knob to the right locks the bow in position.

SAFETY

**READ MANUAL BEFORE OPERATING MACHINE.
FAILURE TO FOLLOW INSTRUCTIONS BELOW WILL
RESULT IN PERSONAL INJURY.**

DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

CAUTION

Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment, and/or a situation that may cause damage to the machinery.

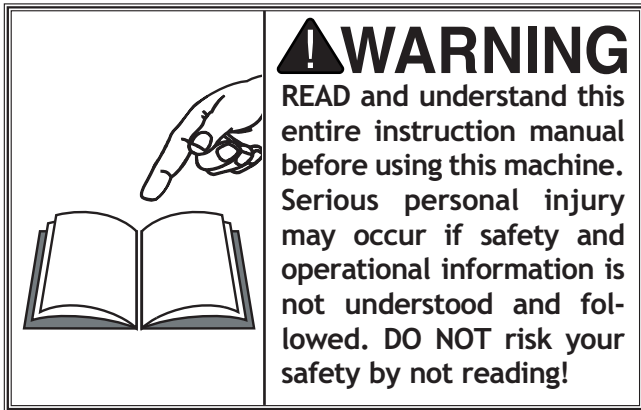
Standard Safety Instructions

1. **READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
2. **ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eye-glasses only have impact resistant lenses—they are NOT safety glasses.
3. **ALWAYS WEAR AN NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
4. **ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
5. **WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
6. **NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.
7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.

10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power off and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords over-heat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery ON.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.

Additional Safety Instructions for Bandsaws

SAFETY



1. **BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.
2. **HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Hands could be crushed by falling machine components or cut by the blade.
3. **ENTANGLEMENT HAZARDS.** Do not operate this bandsaw without blade guard in place. Otherwise, loose clothing, jewelry, long hair and work gloves can be drawn into working parts.
4. **BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Wear gloves to protect hands and safety glasses to protect eyes, and always disconnect from power.
5. **WORKPIECE HANDLING.** Always support the workpiece with table, vise, or other support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.
6. **LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall, which could cause serious injury.
7. **POWER INTERRUPTION.** Unplug machine after power interruption. Machines without magnetic switches can start up after power is restored.
8. **FIRE HAZARD.** Use **EXTREME CAUTION** if cutting magnesium. Using the wrong cutting fluid will lead to chip fire and possible explosion.
9. **CUTTING FLUID SAFETY.** Always follow manufacturer's cutting fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid is a slipping hazard and a toxicity hazard.
10. **ATTENTION TO WORK AREA.** Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.
11. **HEARING PROTECTION & HAZARDS.** Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals. Always wear hearing protection.
12. **HOT SURFACES.** Due to friction, the workpiece, chips, and some machine components can be hot enough to burn you.

ELECTRICAL

220V Operation

The Model M1048 is wired for 220V operation. Always connect this machine to a dedicated circuit (wire, breaker, plug, receptacle) with a verified ground, using the recommended circuit size and plug/receptacle listed at the bottom of this page.

Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. If you are unsure about the wiring codes in your area or plan to connect your machine to a shared circuit, you may create a fire hazard—consult a qualified electrician to reduce this risk.

Extension Cords

We do not recommend using an extension cord for 220V operation. When it is necessary to use an extension cord, use the following guidelines:

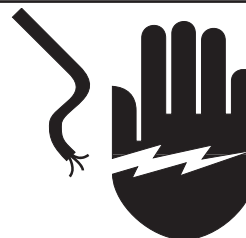
- Use cords rated for Standard Service
- Never exceed a length of 50 feet
- Ensure cord has a ground wire and pin
- Do not use cords in need of repair

Grounding

This machine must be grounded! Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. If it is not, it will be necessary to run a separate copper grounding wire, of the appropriate size, from the outlet to a known ground. Under no circumstances should you connect your machine to an ungrounded power source or electrocution or severe shock could occur.

WARNING

Electrocution or severe shock could occur if machine is not grounded.

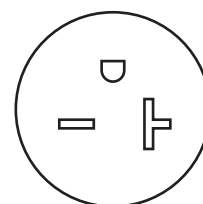


CAUTION

Replacing an existing circuit breaker with one rated for higher amperage may result in a fire. Get help from an electrician if your circuit is too small for the machine.



6-20P



6-20R

Figure 3. Plug & receptacle examples.

Operating Voltage	Amp Draw	Min. Circuit Size	Plug/Receptacle	Extension Cord
220V Operation	15 Amps	20A	NEMA 6-20	12 Gauge

SETUP

Unpacking

The **SHOP FOX®** Model M1048 has been carefully packaged for safe transporting. If you notice the machine has been damaged, please contact your authorized **SHOP FOX®** dealer immediately.

Inventory

The following is a description of the main components shipped with the **SHOP FOX®** Model M1048. Lay the components out to inventory them.

Note: Some parts and hardware may already be installed on the machine. Make sure to check the machine when you use this inventory list.

Box Inventory (Figure 4)

	Qty
A. Model M1048 Metal Cutting Bandsaw.....	1

Hardware and Tools (Not Shown)

—Chip Tray	1
—Triagle Screw ⁵ / ₁₆ -18 x ³ / ₄ "	1
—Flat Washer ⁵ / ₁₆	1
—Hex Nut ⁵ / ₁₆ -18.....	1
—Hex Bolts M12-1.75 x 50 (Leveling).....	4
—Hex Nuts M12-1.75 (Leveling)	4
—Handwheel.....	1
—Knob	1

If any parts are missing, examine the packaging for the missing parts. For any missing parts, find the part number in the back of this manual and contact Woodstock International, Inc. at (360) 734-3482 or at tech-support@shopfox.biz

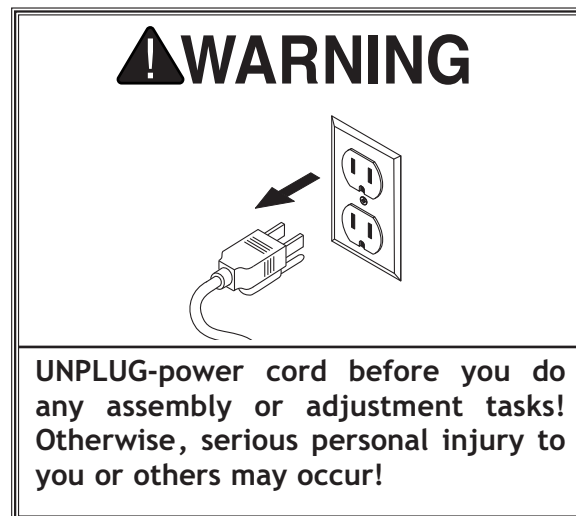
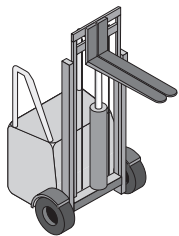


Figure 4. Model M1048 inventory.

Machine Placement

- **Floor Load:** This machine distributes a heavy load in a small footprint. Some residential floors may require additional bracing to support both machine and operator.
- **Working Clearances:** Consider existing and anticipated needs, size of material to be processed through the machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your bandsaw.
- **Lighting:** Lighting should be bright enough to eliminate shadow and prevent eye strain.



WARNING

USE helpers and power lifting equipment to lift this 10" x 18" Metal Cutting Bandsaw. Otherwise, serious personal injury may occur.



CAUTION

MAKE your shop "child safe." Ensure that your workplace is inaccessible to youngsters by closing and locking all entrances when you are away. NEVER allow untrained visitors in your shop when assembling, adjusting or operating equipment.

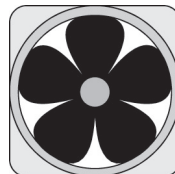
Cleaning Machine

The table and other unpainted parts of your Bandsaw are coated with a waxy grease that protects them from corrosion during shipment. Clean this grease off with a solvent cleaner or citrus-based degreaser. DO NOT use chlorine-based solvents such as brake parts cleaner or acetone—if you happen to splash some onto a painted surface, you will ruin the finish.



WARNING

NEVER use gasoline or other petroleum-based solvents to clean with. Most have low flash points, which make them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur if this warning is ignored!



CAUTION

ALWAYS work in well-ventilated areas far from possible ignition sources when using solvents to clean machinery. Many solvents are toxic when inhaled or ingested. Use care when disposing of waste rags and towels to be sure they DO NOT create fire or environmental hazards.

Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Both options are described below. Whichever option you choose, it will be necessary to use a precision level to level your machine.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 5**) and anchor studs (**Figure 6**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine at a later point.

Using Machine Mounts

Using machine mounts, shown in **Figure 7**, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine to reduce strain on the floor.

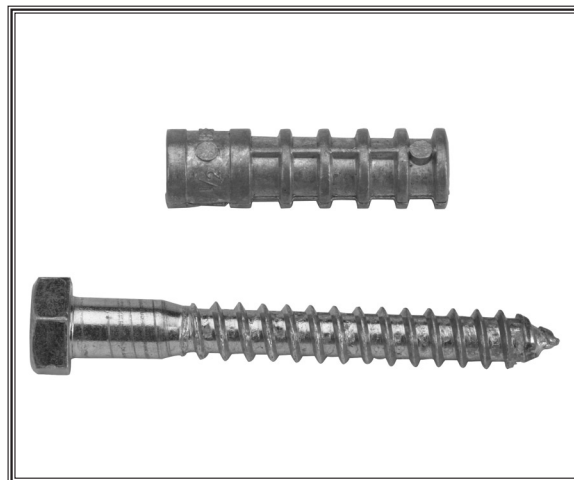


Figure 5. Typical lag shield anchor and lag bolt.

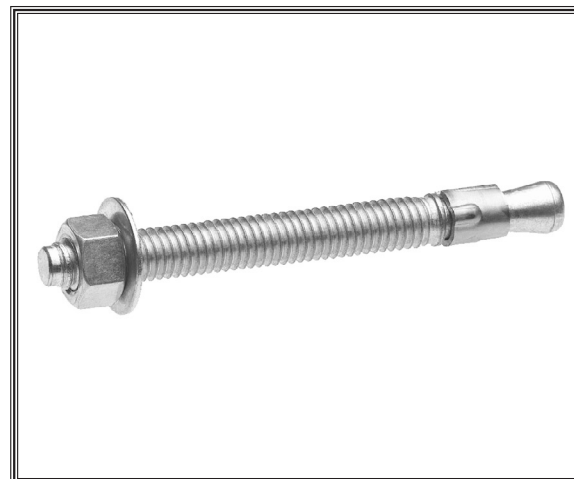


Figure 6. Typical anchor stud.



Figure 7. Machine mount example.

Moving & Placing Unit

The Model M1048 comes with lifting brackets installed on the base. Use a forklift and straps rated for the machine weight to lift the machine off the pallet and onto a suitable location (see **Figure 8**). The lifting brackets can be removed and saved for future use.

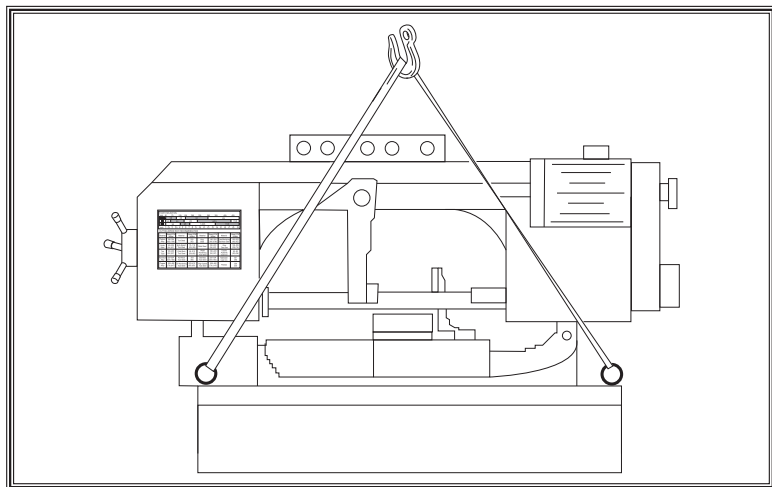


Figure 8. M1048 lifting points.

Shipping Bracket

The bracket in **Figure 9** has been installed to keep the saw in alignment during shipping. Remove it before using your saw. Store it for safe keeping, in the event you move your saw to a different location.

To remove the shipping bracket, do these steps:

1. Remove the upper and lower hex bolts with a 12mm wrench.

Workstop

The workstop is used when many cuts of the same length are needed (see **Figure 10**).

To setup the workstop do these steps:

1. Position the workstop rod the desired distance from the blade and tighten the cap screw to hold it in place.
2. Fine tune the measurement by adjusting the hex bolt and stop nut.
3. Swing the workstop arm down and out of the way when not in use.

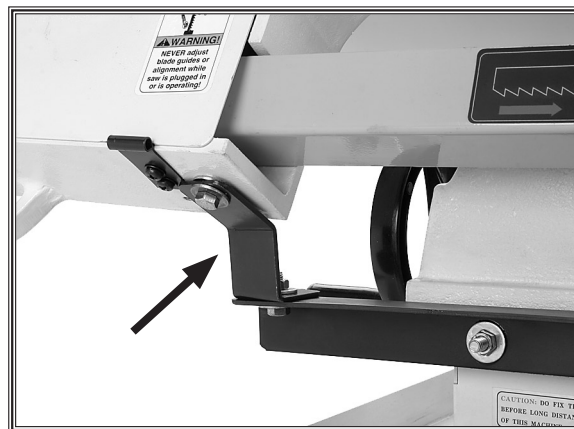
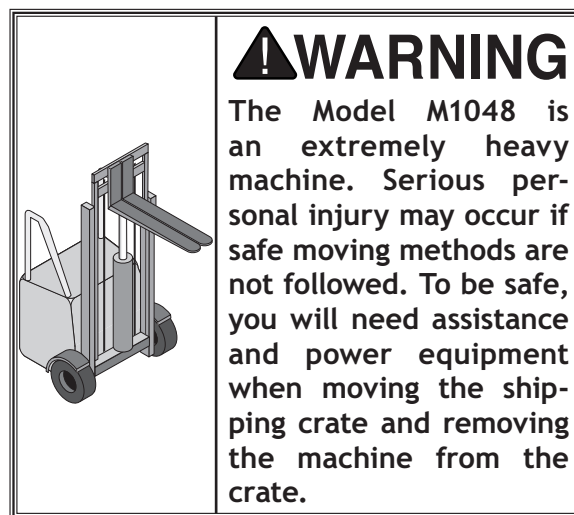


Figure 9. Shipping bracket.

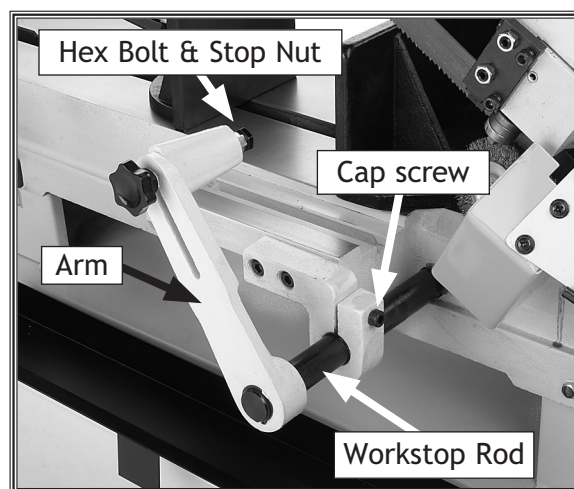


Figure 10. Workstop assembly.

Chip Tray

The chip tray fits over the lip of the base as illustrated in Figure 11.

Feed Stop

Depending on how the Model M1048 was shipped, it may be necessary to adjust the feed stop before the test run. The blade should not make contact with any part of the vise assembly.

To adjust the feed stop bolt, do these steps:

1. Adjust the feed stop bolt and jam nut (Figure 12), so the bandsaw blade teeth are $\frac{1}{16}$ " below the vise table surface.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure accurate cutting results.

Step-by-step instructions on verifying these adjustments can be found in the **SERVICE** section.

Factory adjustments that should be verified:

1. Blade Tracking (Page 29).
2. Blade Guide Bearings (Page 30).

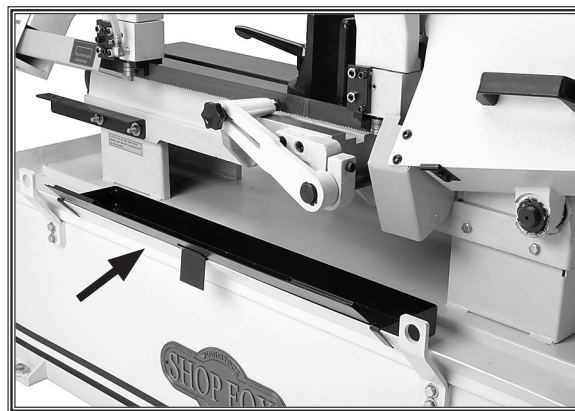


Figure 11. Chip tray installation.

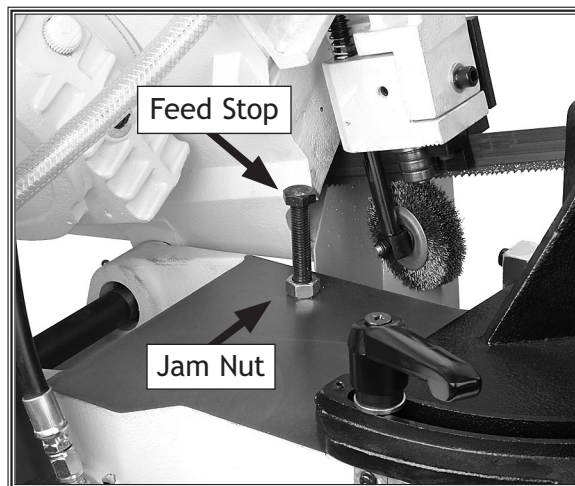


Figure 12. Feed stop.

Test Run

Complete this process once you have familiarized yourself with all instructions in this manual.

To test run the bandsaw, do these steps:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Put on safety glasses and secure loose clothing or long hair.
4. Connect the bandsaw to power.
5. Raise the bandsaw and close the feed control knob to keep the saw in place.
6. Start the bandsaw while keeping your finger near the EMERGENCY STOP/OFF button (**Figure 13**) at all times during the test run. The bandsaw should run smoothly with little or no vibration.

Note: If the EMERGENCY STOP/OFF button is pressed, it needs to be twisted until it pops out or the bandsaw will not start.

- Immediately turn the bandsaw **OFF** if you suspect any problems, and refer to **Page 26** to troubleshoot/fix any problems before starting the bandsaw again.
- If the source of an unusual noise or vibration is not readily apparent, contact our technical support for help at (360) 734-3482 or contact us online at tech-support@shopfox.biz.

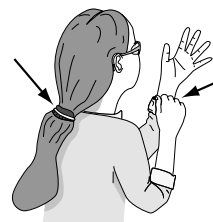
7. Push the emergency stop button to test safety shut-off.

! WARNING



Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

! WARNING



Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.

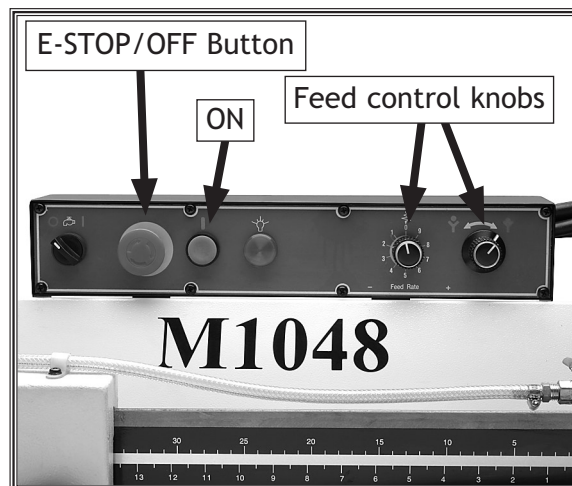


Figure 13. Control panel.

OPERATIONS

General

The Model M1048 will perform many types of operations that are beyond the scope of this manual. Many of these operations can be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. **If at any time you are experiencing difficulties performing any operation, stop using the machine!**

If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced bandsaw operator before performing any unfamiliar operations. **Above all, your safety should come first!**

! CAUTION

Always turn the saw **OFF** and allow the blade to come to a complete stop before using the vice! Failure to follow this caution may lead to injury.

! WARNING



READ and understand this entire instruction manual before using this machine. Serious personal injury may occur if safety and operational information is not understood and followed. **DO NOT** risk your safety by not reading!

Vise

The vise has a quick release feature that allows jaw width to be quickly adjusted when changing from one sized material to another.

To rapidly change the vise jaw gap, do these steps:

1. Turn the handwheel counterclockwise to relieve any pressure on the vise jaw.
2. Pull or push the jaw in the desired direction.
3. Finish tightening the jaw against the workpiece with the handwheel.

Note: *Figure 14 shows correct methods of holding different workpiece shapes.*

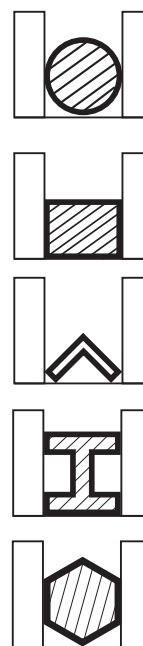


Figure 14. Workholding options by material shape.

The vise can be adjusted to cut any angle from a straight 90 degree cut-off, to a 45 degree angle by loosening the two vise lock handles. Positive stops at 90° and 45° allow you to quickly return the rear jaw to either angle. Angles between 90° and 45° can be read using the scale on the side of the vise table. Use a combination square or bevel protractor if higher precision is required when finding these angles.

To adjust the positive stops, do these steps:

1. Check the current vise jaw-to-blade angle with a machinist square (see **Figure 15**).
2. If the angle is not 90°, loosen the vise lock handle then adjust the set screw as needed to set the positive stop to 90° (see **Figure 16**).
3. With the rear vise jaw making contact with the positive stop, tighten the rear vise jaw and re-check the angle.
4. Loosen the rear vise lock handle and swing the rear jaw until it reaches the 45° positive stop.
5. Tighten the rear jaw and check the angle.
6. If the angle is not at 45°, loosen the vise jaw and adjust the set screw as needed to set the positive stop to 45°.
7. With the rear vise jaw making contact with the positive stop, tighten the rear vise jaw and re-check the angle.
8. After the final angle has been chosen, loosen the lock handle in **Figure 17** on the opposite jaw so the jaw can float, and match the angle of the workpiece and rear jaw.
9. Tighten the vise against the workpiece then tighten the jaw lock handle.



Figure 15. Squaring vise to blade.

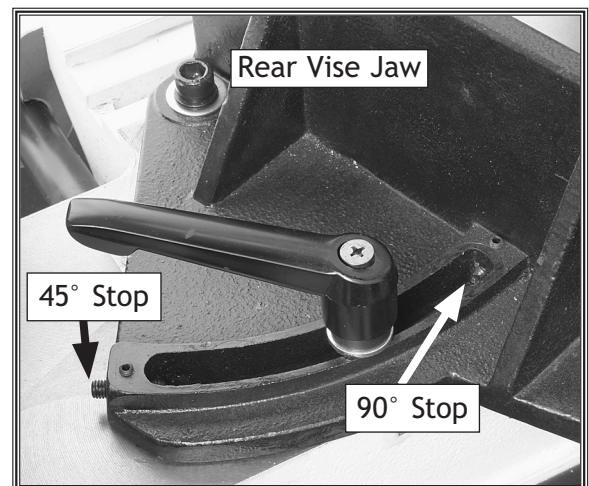


Figure 16. Positive stop adjustments.



Figure 17. Front vise jaw lock handle.

Blade Guide Arms

The blade guide bearings are mounted on the front and rear arms. The rear arm is adjustable and should be set as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off of the cut line.

To adjust the rear blade guide arm:

Loosen the knob shown in **Figure 18** and slide the rear blade guide as close to the workpiece as possible, then tighten the knob.

The front blade guide arm has a self-adjusting wire brush that makes contact with the blade to help clear away chips and extend blade life (see **Figure 19**).

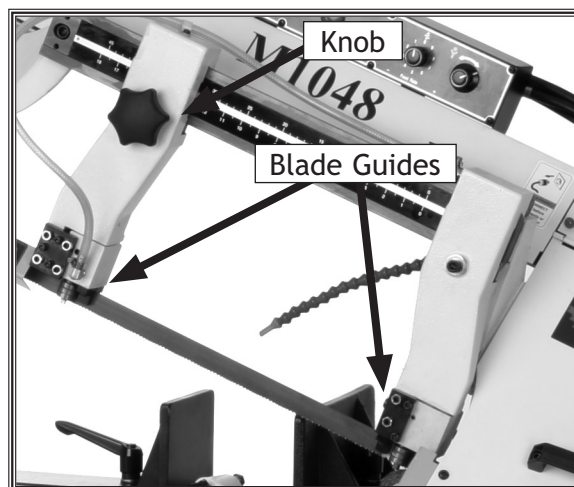


Figure 18. Blade guides.

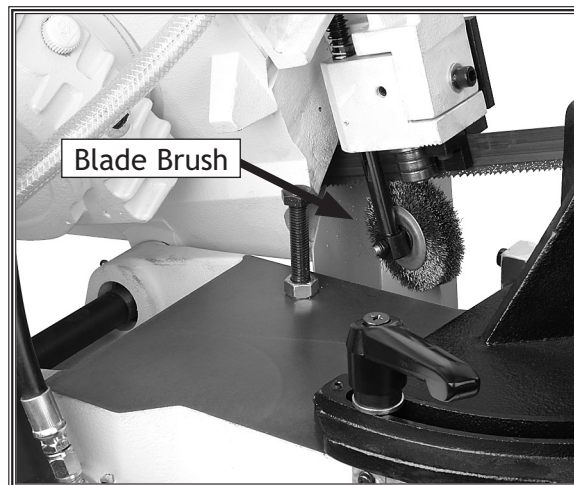


Figure 19. Blade brush.

Blade Selection

The Model M1048 uses 129³/₈" x 1¹/₁₆" bandsaw blades.

Selecting the right blade for the job depends on a variety of factors, such as the type of material being cut, hardness of the material, material shape machine capability, and operator technique.

The chart below is a basic starting point for choosing blade type based on teeth per inch (TPI) for variable tooth pitch blades and for standard raker type bi-metal blades/HSS blades. However, for exact specifications of bandsaw blades, contact the blade manufacturer.

To select the correct blade TPI do these steps:

1. Measure the material thickness. This measurement is the length of cut taken from where the tooth enters the workpiece, sweeps through, and exits the workpiece.
2. Refer to the "Material Width/Diameter" row of the blade selection chart in **Figure 20** and read across to find your workpiece thickness you need to cut.
3. Refer to the "Material Shapes" row and find the shape and material to be cut.
4. In the applicable row, read across to the right and find the box where the row and column intersect. Listed in the box is the minimum TPI recommended for the variable tooth pitch blades.
5. The "Cutting Speed Rate Recommendation" section of the charts offers guidelines for various metals, given in feet per minute (speed FPM) and meters per minute in parenthesis. Choose the speed closest to the number shown in the chart.

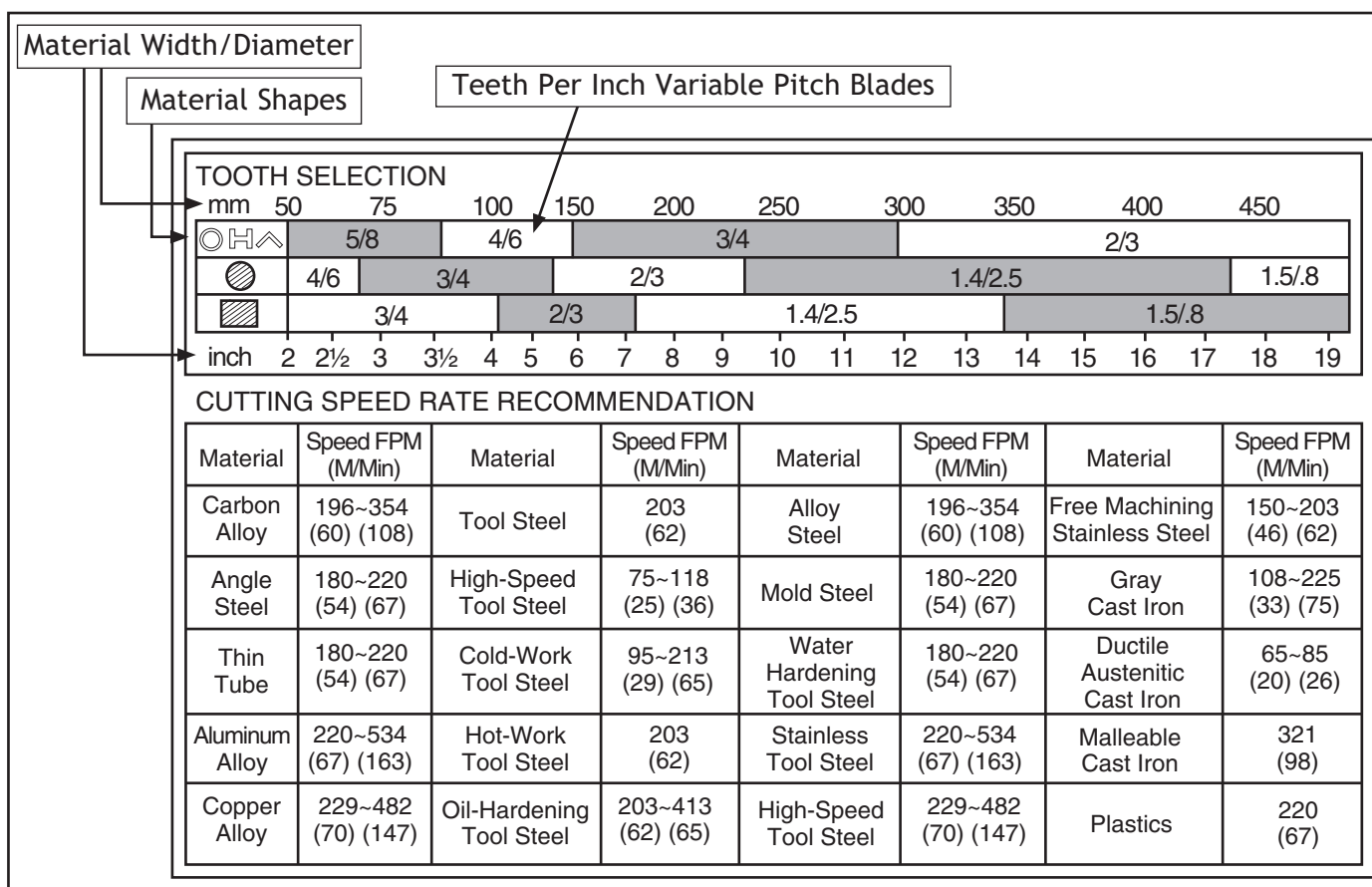


Figure 20. Model M1048 Blade selection and speed chart.

Blade Speed

The Model M1048 has four speed settings—114, 196, 288, and 377 feet per minute (FPM). Refer to the chart on **Page 19** for cutting speed recommendations by material type.

To change blade speeds, do these steps:

1. UNPLUG THE BANDSAW!
2. Open the belt cover.
3. With one hand, support the weight of the motor. With the other hand, loosen the belt tension knob (see **Figure 21**). The motor will drop and the V-belt will slacken.
4. Move the V-belt to the desired pulley combination (see **Figure 22**).
5. Lift the motor to tension the belt and tighten the belt tension knob.
6. Close the belt cover.



Figure 21. Belt tension knob.

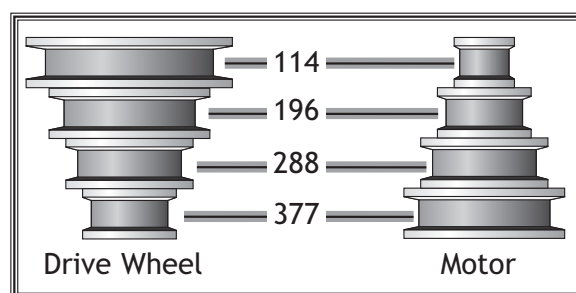


Figure 22. V-belt positions in FPM.

Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by blade type, feed rate, and feed pressure. The feed rate is controlled by two knobs on the control panel.

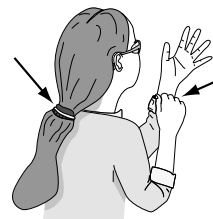
Note: If a lubricant is used on the cut, the feed rate can be increased by approximately 15%.

To set the feed rate, do these steps:

1. Raise the bow to the highest position.
2. Set the "Feed Rate Dial" in **Figure 23** to the desired feed rate—0 is the slowest, 9 is the fastest.
3. Turn the feed control knob to the left to lower the bow at the feed rate you have set. Turning the knob to the right locks the bow in position.

Continued on next page 

! WARNING



ENTANGLEMENT HAZARD! DO NOT operate bandsaw with pulley cover open. Personal injury could occur.

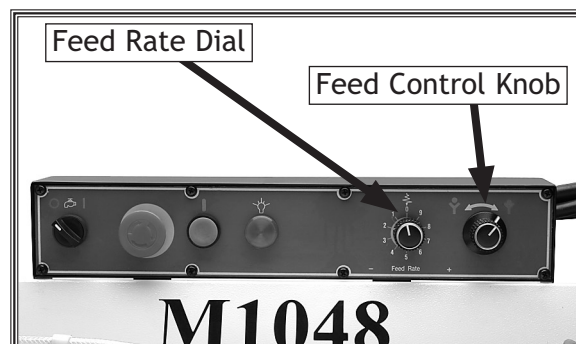


Figure 23. Feed rate controls.

4. Look for the following signs to determine the best feed rate setting for your workpiece.
 - If you get worn tightly-curved shavings, that are brown to black in color, you are using too much downward pressure.
 - Blue looking chips are from extreme heat caused by high blade speed.
 - Thin powder-like chips are from insufficient feed pressure. This will dull your blade faster.
 - The best cut and feed rate will give you evenly shaped spiraled-curved chips with very little color change, if any at all.

Coolant System

This bandsaw has a built-in coolant system that extends the life of your bandsaw blades by lowering the temperature of the blade and workpiece when cutting.

See **Cutting Fluid** on **Page 22** for additional information.

To use the coolant system do these steps:

1. Access the reservoir by removing the rear panel on the base (see **Figure 24**).
2. Thoroughly clean and remove any foreign material that may have fallen inside the reservoir during shipping.
3. Fill the reservoir with your chosen cutting fluid solution and replace the rear panel.
4. Make sure the coolant control valve is turned **OFF**.
5. Turn the coolant pump switch **ON** before making your cut.
6. Adjust the valve on the coolant hose to control the flow of coolant (see **Figure 25**). Make sure that the pressure is not so high that coolant spills on the floor and creates a slipping hazard.
7. When the bandsaw reaches the bottom of the cut, the motor and coolant system will shut **OFF**.



Figure 24. Coolant system reservoir and cover.

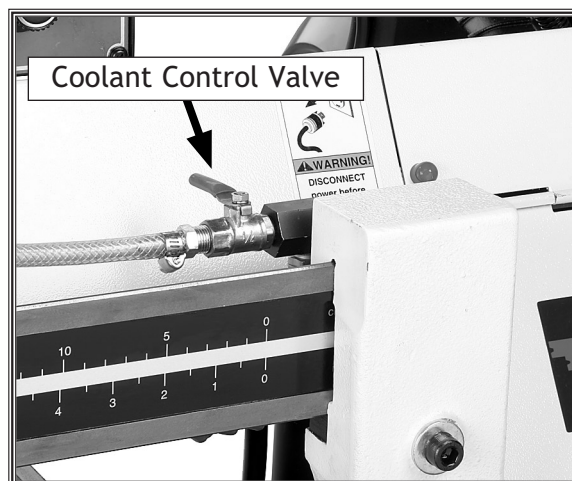


Figure 25. Coolant control valve.

NOTICE

Keep the tray chip screen clear so coolant can recycle to the pump reservoir. **NEVER** operate the pump with the reservoir below the low mark or you will over-heat the pump and void your warranty!

Cutting Fluid



! WARNING

NEVER attempt to cut magnesium when using soluble oils or emulsions (oil-water solutions) as a cutting fluid! The water in the solution will increase the risk of an accidental magnesium-chip fire. For cutting magnesium alloys, use a specific cutting fluid intended for magnesium.

While simple in concept and function, many issues must be taken into account and addressed to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

Use the selections below to choose the appropriate cutting fluids:

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use a water soluble cutting fluid.
- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use "Neat Cutting Oil" (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).
- For cutting cast iron, cutting fluid is not recommended.

Remember: Too much flow at the cutting fluid nozzle will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.

Adjust the flow rate lever so the coolant will cool and lubricate the blade, and flush the chips away so they do not stick to the blade. If the chips build up on the blade, eventually they will bind and skid in the next cut, breaking blade teeth, and damaging the bandsaw wheels.



! WARNING

BIOLOGICAL and POISON HAZARD!

The reservoir on this machine is designed to store cutting fluid. During storage some fluids grow dangerous microbes, or due to the collection of toxic metal chips in the fluid, the fluid can become a potent and extremely poisonous solution to humans and animals.

USE the correct personal protection equipment when handling cutting fluids to prevent infections and poisoning.

USE a good bactericide and fungicide for additional protection.

FOLLOW federal, state, and the fluid manufacturer requirements to properly dispose of cutting fluid when it becomes unsafe.

NOTICE

Thoroughly clean and flush coolant system when switching between coolant types to prevent possible contamination.

Operation Tips

The following tips will help you safely and effectively operate your bandsaw, and help you get the maximum life out of your saw blades.

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material and use the quick release vise feature to speed production.
- Let the blade reach full speed before engaging the workpiece.
- Never start a cut with the blade in contact with the workpiece.
- Examine chip color and form for signs of proper feed and speed rates.
- Keep drains free of chips for rapid return of coolant to the coolant pump.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut, and flag the ends to alert passers-by of potential danger.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.

Bandsaw Accessories

The following bandsaw accessories may be available through your local Woodstock International Inc. Dealer. If you do not have a dealer in your area, these products are also available through online dealers. Please call or e-mail Woodstock International Inc. Customer Service to get a current listing of dealers at: 1-800-545-8420 or at sales@woodstockint.com.

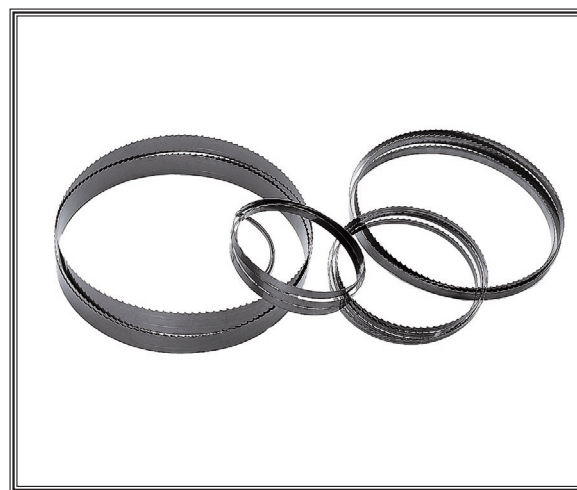


Figure 26. Bandsaw blades.

D3660—129³/₈" x 1¹/₁₆" x .035 10 TPI Raker
 D3661—129³/₈" x 1¹/₁₆" x .035 14 TPI Raker
 D3662—129³/₈" x 1¹/₁₆" x .035 3-4 VP
 D3663—129³/₈" x 1¹/₁₆" x .035 4-6 VP
 D3664—129³/₈" x 1¹/₁₆" x .035 5-8 VP
 D3665—129³/₈" x 1¹/₁₆" x .035 6-10 VP
 D3666—129³/₈" x 1¹/₁₆" x .035 8-12 VP

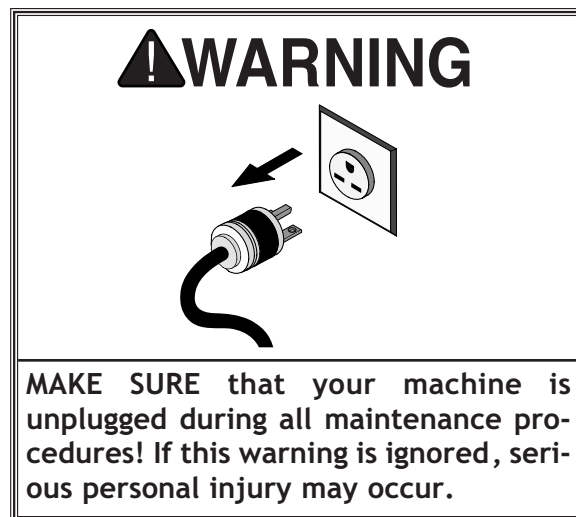
MAINTENANCE

General

Regular periodic maintenance on your **SHOP FOX®** Model M1048 will ensure its optimum performance. Make a habit of inspecting your machine each time you use it.

Check for the following conditions and repair or replace when necessary:

- Loose mounting bolts.
- Damaged or dull saw blade.
- Worn or damaged wires, or other unsafe condition.
- Clean after each use.
- Proper blade tension and coolant level.
- Check gear box fluid level.
- Change gear box oil (every four months if being used daily).



Cleaning

Frequently brush-off metal chips with a brush, or use a shop vacuum to remove the chips. Keeping metal chips away from bandsaw mechanisms is important to making sure that your bandsaw lasts a long time.

This machine is equipped with a cutting fluid system, which pumps water and oil based cutting lubricants. It is especially important to make sure the internal working parts of the motor and electrical switches are kept dry and splash free.

Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. Do not lubricate them. However, you must periodically lubricate threaded adjustment locations and check the gear box oil level.

Lubricate the following areas as follows:

- **Blade Tension Mechanism:** Open the main blade guard and drop a few drops of oil on the tension knob lead screw (see **Figure 27**).

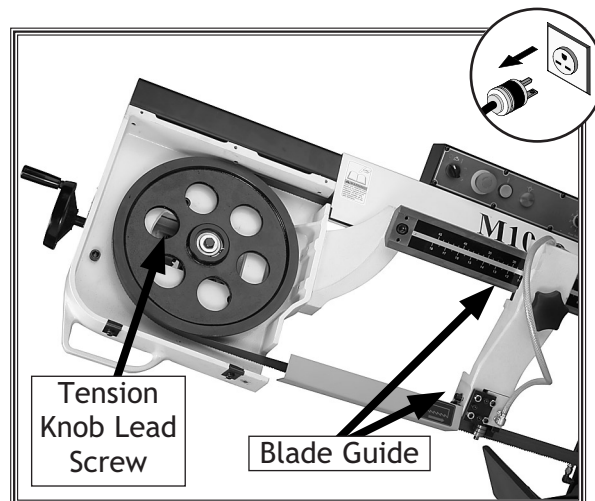


Figure 27. Main lubrication points.

- **Blade and Guides:** Drop a few drops of light machine oil on the blade and the blade guides daily, especially when cutting cast iron, as no cutting fluid is recommended (see **Figure 27**).
- **Table and Machined Surfaces:** Tables can be kept rust-free with regular applications of products like SLIPIT®. For long term storage you may want to consider products like Boeshield T-9™.
- **Vise lead screw:** Place a few drops of light machine oil on the vise lead screw weekly (see **Figure 28**).
- **Grease Fittings on Pivot Point:** Grease these with general purpose grease as needed to keep the pivot moving freely (see **Figure 29**).

The gearbox should be drained and refilled after the first 50 hours of use and then once every year. Use a high quality, ISO 68 or SAE 90 gear oil.

To change the gear oil, do these steps:

1. Run the bandsaw for a couple of minutes to warm up the oil in the gearbox.
2. DISCONNECT THE BANDSAW FROM THE POWER SOURCE!
3. Raise the bow to the highest angle and close the feed control knob to lock the bow in position.
4. Drain the gearbox by removing the drain plug shown in **Figure 29**.
5. Replace the drain plug, then lower the bow to its lowest position.
6. Open the fill cap and fill the gearbox with oil until you see the oil level reach the halfway point in the sight glass (see **Figure 30**).
7. Tighten the fill plug, connect the machine to power and run the saw for a minute or two, then check the oil level. Add more oil if needed to maintain level at the halfway mark in the sight glass.



Figure 28. Vise leadscrew lubrication area.

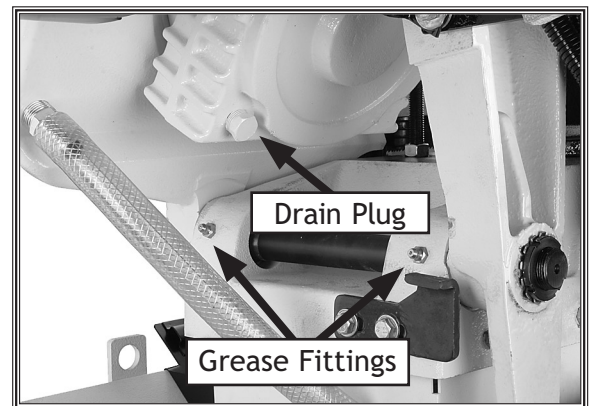


Figure 29. Lubrication points.

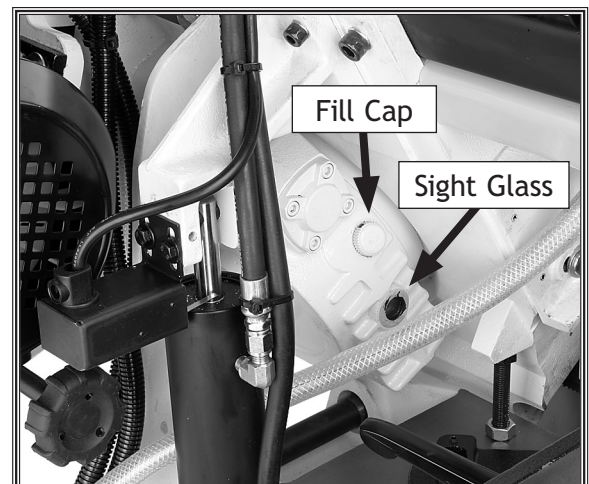
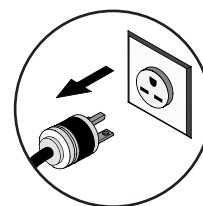


Figure 30. Gear box.

SERVICE

Troubleshooting



This section covers the most common symptoms and corrections with this type of machine. **WARNING!** **DO NOT** make any adjustments until moving parts have come to a complete stop and power is disconnected! If you require additional machine service not included in this section, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: tech-support@shopfox.biz.

Motor & Electrical

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine does not start or a breaker trips.	1. E-Stop button pressed. 2. Plug/receptacle is at fault or wired incorrectly. 3. Start capacitor is at fault. 4. Wall fuse/circuit breaker is blown/tripped. 5. Motor connection wired incorrectly. 6. Power supply is at fault/switched OFF. 7. Motor ON/OFF switch is at fault. 8. Wiring is open/has high resistance. 9. Motor is at fault.	1. Twist E-Stop button until it pops out. 2. Test for good contacts; correct the wiring. 3. Test/replace capacitor if faulty. 4. Ensure correct size for machine load; replace weak breaker. 5. Correct motor wiring connections. 6. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 7. Replace faulty ON/OFF switch. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Test/repair/replace.
Machine stalls or is under-powered.	1. Wrong blade for the workpiece material. 2. Wrong workpiece material. 3. Feed rate/cutting speed too fast for task. 4. Blade is slipping on wheels. 5. Low power supply voltage. 6. Motor bearings are at fault. 7. Plug/receptacle is at fault. 8. Motor connection is wired incorrectly. 9. Motor has overheated. 10. Motor is at fault.	1. Use blade with correct properties for your type of cutting. 2. Use metal with correct properties for your type of cutting. 3. Decrease feed rate/cutting speed. 4. Adjust blade tracking and tension. 5. Ensure hot lines have correct voltage on all legs. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test for good contacts; correct the wiring. 8. Correct motor wiring connections. 9. Clean off motor, let cool, and reduce workload. 10. Test/repair/replace.
Machine has vibration or noisy operation.	1. Motor fan is rubbing on fan cover. 2. Blade is at fault. 3. Gearbox is at fault. 4. Wrong blade for material. 5. Speed is set too slow.	1. Replace dented fan cover; replace loose/damaged fan. 2. Replace/resharpen blade. 3. Rebuild gearbox for bad gear(s)/bearing(s). 4. Change blade. 5. Adjust speed as required.

Bandsaw Operations

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	- Excessive feed rate. - The blade TPI is too great, or the material is too coarse.	- Refer to Feed Rate on Page 20, or Changing Blade Speed on Page 20, and adjust as required. - Refer to Blade Selection on Page 19 and adjust as required.
Blades break often.	- Blade is not tensioned correctly. - The workpiece is loose in the vise. - The feed or cut speed is wrong. - The blade TPI is too great, or the material is too coarse. - The blade is rubbing on the wheel flange. - The bandsaw is being started with the blade resting on the workpiece. - The guide bearings are misaligned, or the blade is rubbing on the wheel flange. - The blade is too thick, or the blades are of low quality.	- Check to see that blade is not excessively tight or too loose. - Clamp the workpiece tighter, or use a jig to hold the workpiece. - Refer to Feed Rate on Page 20, or Changing Blade Speed on Page 20, and adjust as required. - Refer to Blade Selection on Page 19, and adjust as required. - Refer to Blade Tracking on Page 29, and adjust as required. - Start bandsaw and then slowly lower the headstock by setting the feed rate. - Refer to Blade Tracking on Page 29, or Blade Guides on Page 30 and adjust as required. - Use a higher quality blade.
Blade dulls prematurely.	- The cutting speed is too fast. - The blade TPI is too coarse. - The blade feed pressure is too light. - The workpiece has hard spots, welds, or scale is on the material. - The blade is twisted. - The blade is slipping on the wheels.	- Refer to Changing Blade Speed on Page 20, and adjust as required. - Refer to Blade Selection on Page 19, and adjust as required. - Refer to Feed Rate on Page 20, and adjust as required. - Increase the feed pressure, and reduce the cutting speed. - Replace the blade. - Refer to Blade Tension on Page 29, and adjust as required.
Blade wears on one side.	- The blade guides are worn or mis-adjusted. - The blade guide slide bracket is loose. - The wheels are out of alignment.	- Refer to Blade Guides on Page 30 and replace or adjust. - Tighten the blade guide bracket. - Refer to Blade Tracking on Page 29, and adjust as required.
Teeth are ripping from the blade.	- The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. - The workpiece is vibrating in the vise. - The blade gullets are loading up with chips.	- Refer to Blade Selection on Page 19 and decrease the feed pressure. Refer to Feed Rate on Page 20, and adjust as required. - Re-clamp the workpiece in the vise, and use a jig if required. - Use a coarser-tooth blade.
The cuts are crooked.	- The feed pressure is too high. - The guide bearings are out of adjustment, or too far away from the workpiece. - The blade tension is low. - The blade is dull. - The blade speed is wrong. - Blade not square to table.	- Refer to Feed Rate on Page 20, and adjust as required. - Refer to Blade Guides on Page 30 and replace or adjust. - Refer to Blade Tension on Page 29, and adjust as required. - Refer to Blade Change on Page 28 and replace the blade. - Refer to Blade Speed on Page 20, and adjust as required. - Refer to Squaring Blade to Table on Page 31.

Blade Change

⚠ CAUTION

CUTTING HAZARD! Blades are sharp! Wear heavy leather gloves when handling blades to prevent cuts.

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

To change the blade on the bandsaw, do these steps:

1. DISCONNECT THE BANDSAW FROM POWER!
2. Raise the bow of the bandsaw about six inches then close the feed control valve by turning the knob to the right.
3. Loosen and slide the both blade guides toward the center of the bow as shown in **Figure 31**.
4. Remove the two screws to open the upper blade guard (see **Figure 32**).
5. Open both wheel covers and clean out all the chips and shavings.
6. Loosen the blade tension handle in **Figure 31** and slip the old blade off of the wheels then out of the blade guide roller bearings.
7. Install the new blade into front and rear blade guide roller bearings, as shown in **Figure 33**, then around the bottom and top wheels.

Note: It is sometimes possible to flip the blade inside out, and the blade teeth will be pointing in the wrong direction. Make sure the blade teeth are facing toward the workpiece, as shown in **Figure 34**, before mounting on the bandsaw.

8. Apply a light amount of tension to hold the blade in place. Work your way around the blade to adjust the position so the back of the blade is against the flange of the wheels.
9. Complete the blade change by following the steps in the next section—**Blade Tension & Tracking**.

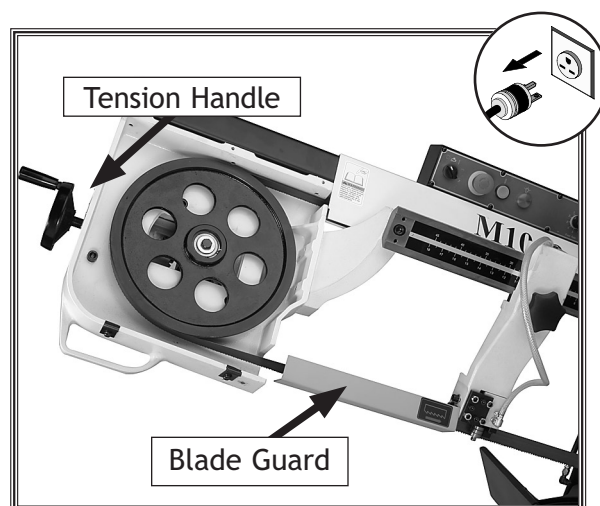


Figure 31. Tension handle and blade.

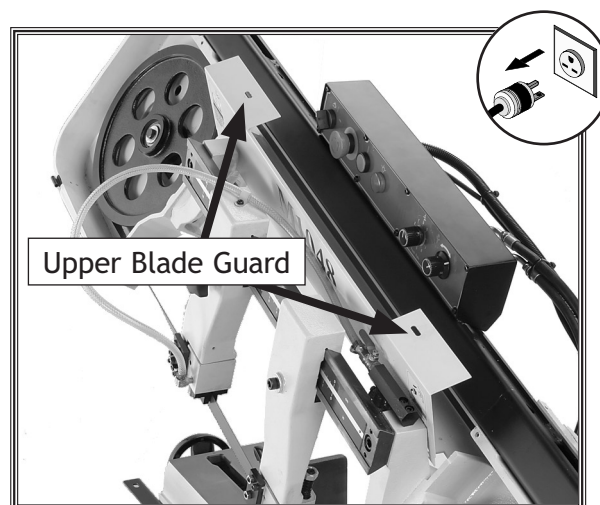


Figure 32. Opened upper blade guard.

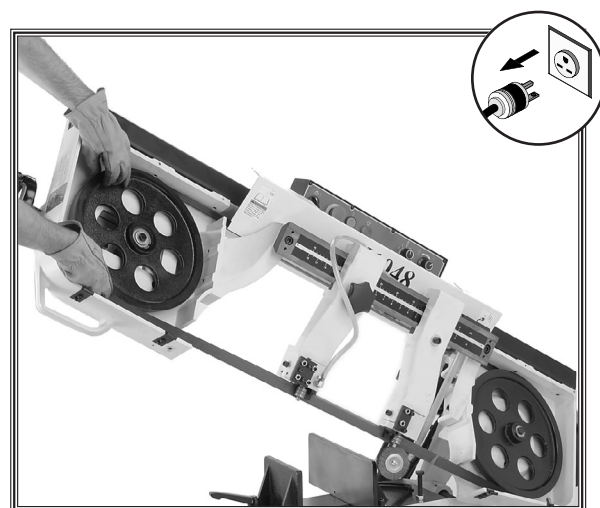


Figure 33. Installing the blade.

Blade Tension & Tracking

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting. The Model M1048 features a blade tension indicator to assist you with blade tensioning.

Two major signs that you do not have proper blade tension are: 1) the blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too tight.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.

To tension the blade on the bandsaw, do these steps:

1. Turn the blade tension handle clockwise to tension the blade.
2. Use the graduated scale on the blade tension indicator (**Figure 35**) to determine blade tension in PSI.
 - For carbon blades, the blade tension should be 20,000 PSI.
 - For bi-metal blades, like the one supplied with your machine, the blade should be tensioned from 30,000 to 35,000 PSI.

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly. Do not attempt to adjust tracking until the blade is properly tensioned.

To adjust the blade tracking on the bandsaw, do these steps:

1. Loosen or tighten the tracking set screw in **Figure 36** until the blade is tracking properly. The blade is tracking properly when the back of the blade is lightly touching the flange of both wheels.
2. Remove the V-belt from the motor pulley and spin either wheel by hand to observe how the blade is tracking. Make sure the blade teeth are not cutting into any part of the saw. Adjust as needed.

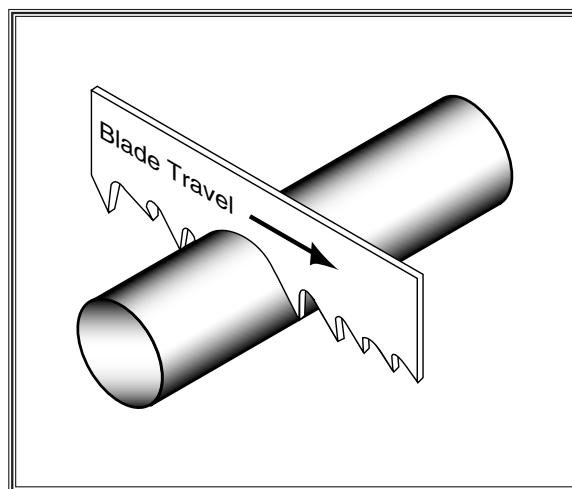


Figure 34. Blade cutting direction.

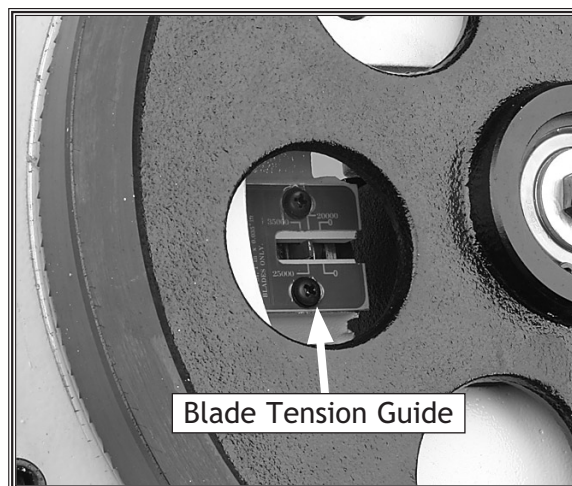


Figure 35. Blade tension guide.



Figure 36. Tracking set screw.

Blade Guide Bearings

The blade guide bearings are adjusted at the factory but due to shipping and storage may need adjustment. Use **Figures 37 & 38** to guide you through the following steps.

To adjust the blade guide bearings, do these steps:

1. Before making adjustments, make sure the blade is tensioned and tracking correctly.
2. DISCONNECT THE BANDSAW FROM POWER!
3. Raise the bow high enough to give you room to work, then lock in place.
4. Remove both blade guards.
5. The back of the blade (A) in **Figure 37** should make light contact with the backing bearing (C).
 - If it does not, loosen the set screw (B) shown in **Figure 37**, and move the bearing (C) up or down until it lightly touches the back of the blade.

The blade guide roller bearings also need to be adjusted. The front bearing is mounted on an eccentric and can be easily adjusted to suit the blade thickness.

To adjust the blade guide roller bearings, do these steps:

1. Loosen the set screw in **Figure 38** to allow the eccentric bushing to turn.
2. Turn the square nut on the eccentric shaft to adjust the distance of the guide bearing. The guide bearings and blade should make light contact or have a maximum clearance of 0.002".
3. Adjust the carbide blade guides so they make the same contact with the blade as the bearings.
4. Adjust the eccentric blade guide rollers bearing on the front arm the same way.

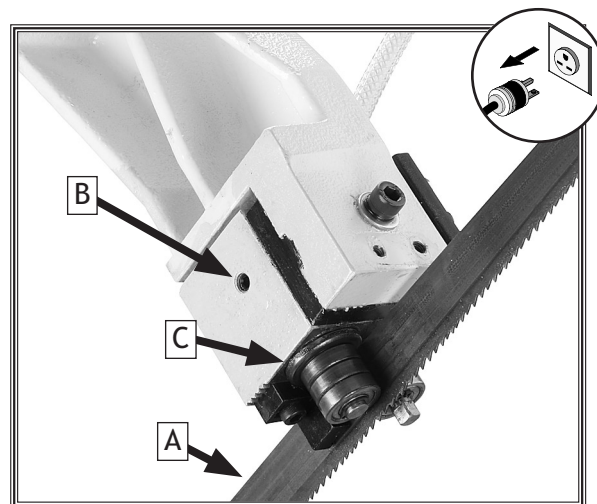


Figure 37. Blade guide adjustments.

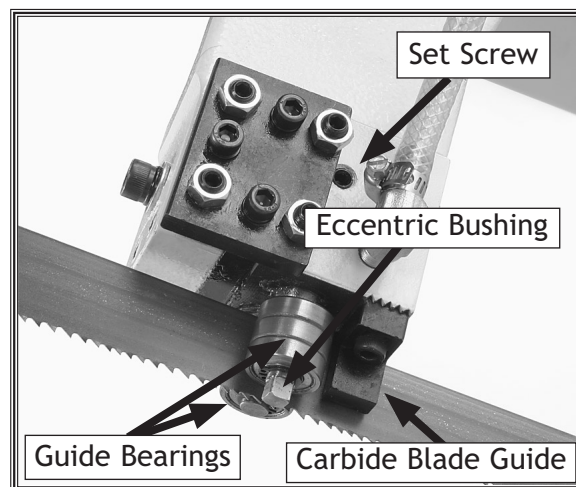


Figure 38. More blade guide adjustments.

Squaring Blade to Table

This adjustment has been made at the factory and should not need to be adjusted under normal circumstances. However, if you find the saw is not cutting square, you may need to adjust the blade. Only make this adjustment after factors such as excessive feed rate or the blade guide being set too far away from the workpiece have been ruled out.

To square the blade the to the table, do these steps:

1. DISCONNECT THE BANDSAW FROM POWER!
2. Examine your workpiece for clues as to which way the blade is twisted, or set up a machinist square on the table and blade as shown in **Figure 39**.
3. Check for gaps along several points of the blade length between the two blade guides. Set the machinist square between the blade teeth for a more accurate reading.
4. Adjust the blade by loosening the lock nuts and turning the set screws. This will cause the bearing bracket to pivot (see **Figure 40**).
5. Adjust the set screws in pairs. Tightening the upper pair will pivot the bearing block toward the table. Tightening the lower pair will pivot the bearing bracket away from the table.
6. Cut a small section from a scrap piece of material with a known square end and measure for uniform thickness. If the thickness is not uniform, repeat **Steps 1-5** until your personal requirements are met.

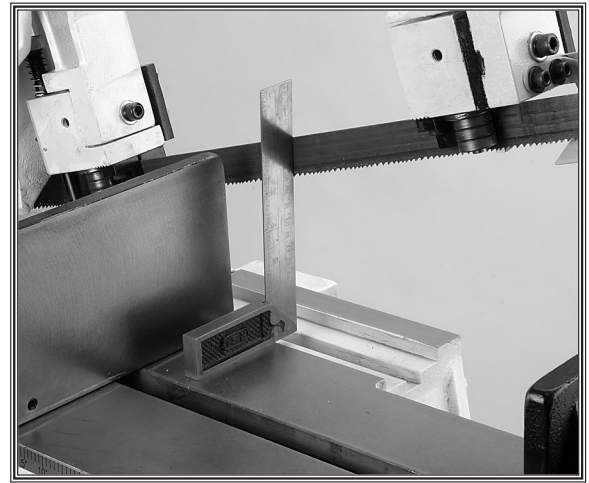


Figure 39. Square blade to table.

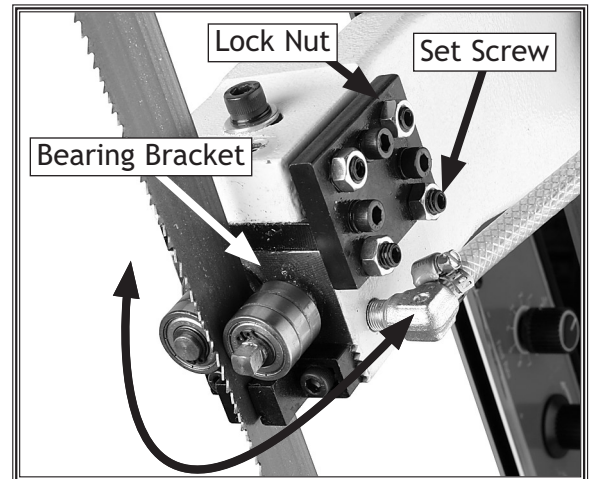


Figure 40. Bearing block pivot.

Electrical Components

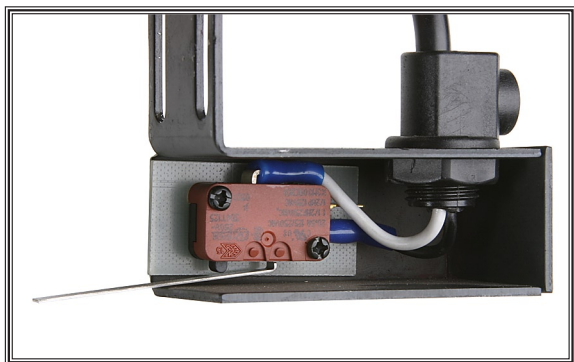


Figure 41. Limit switch (SQ1).

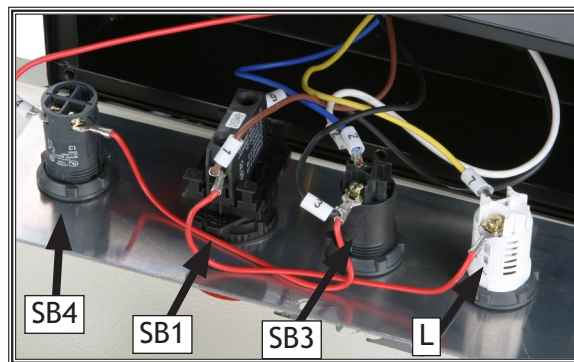


Figure 43. Control panel wiring.



Figure 42. Junction box (M1).

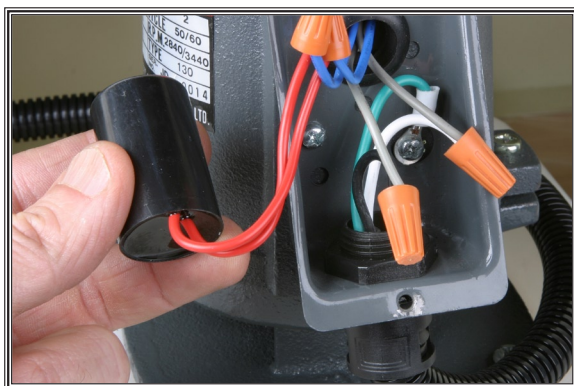


Figure 44. Pump motor wiring and capacitor (M2).

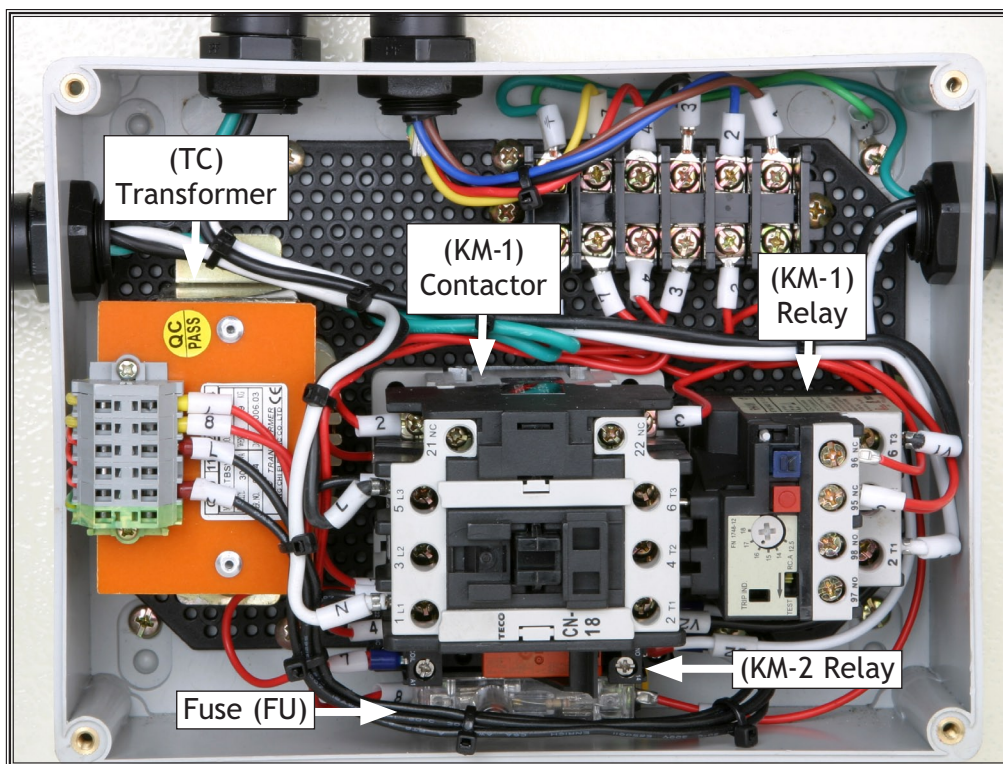
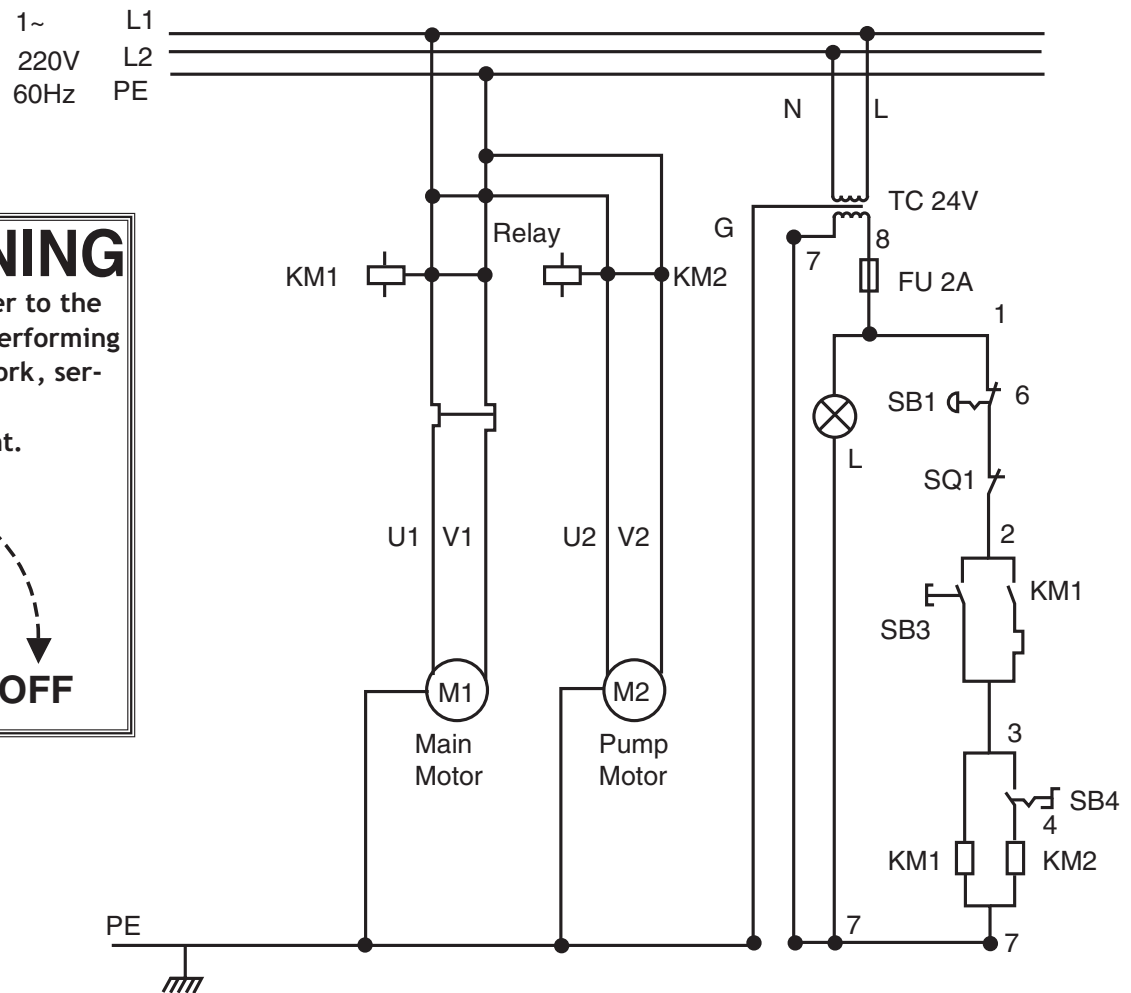
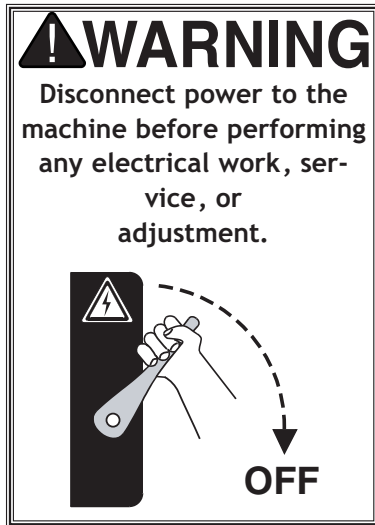


Figure 45. M1048 Contactor & relay electrical box.

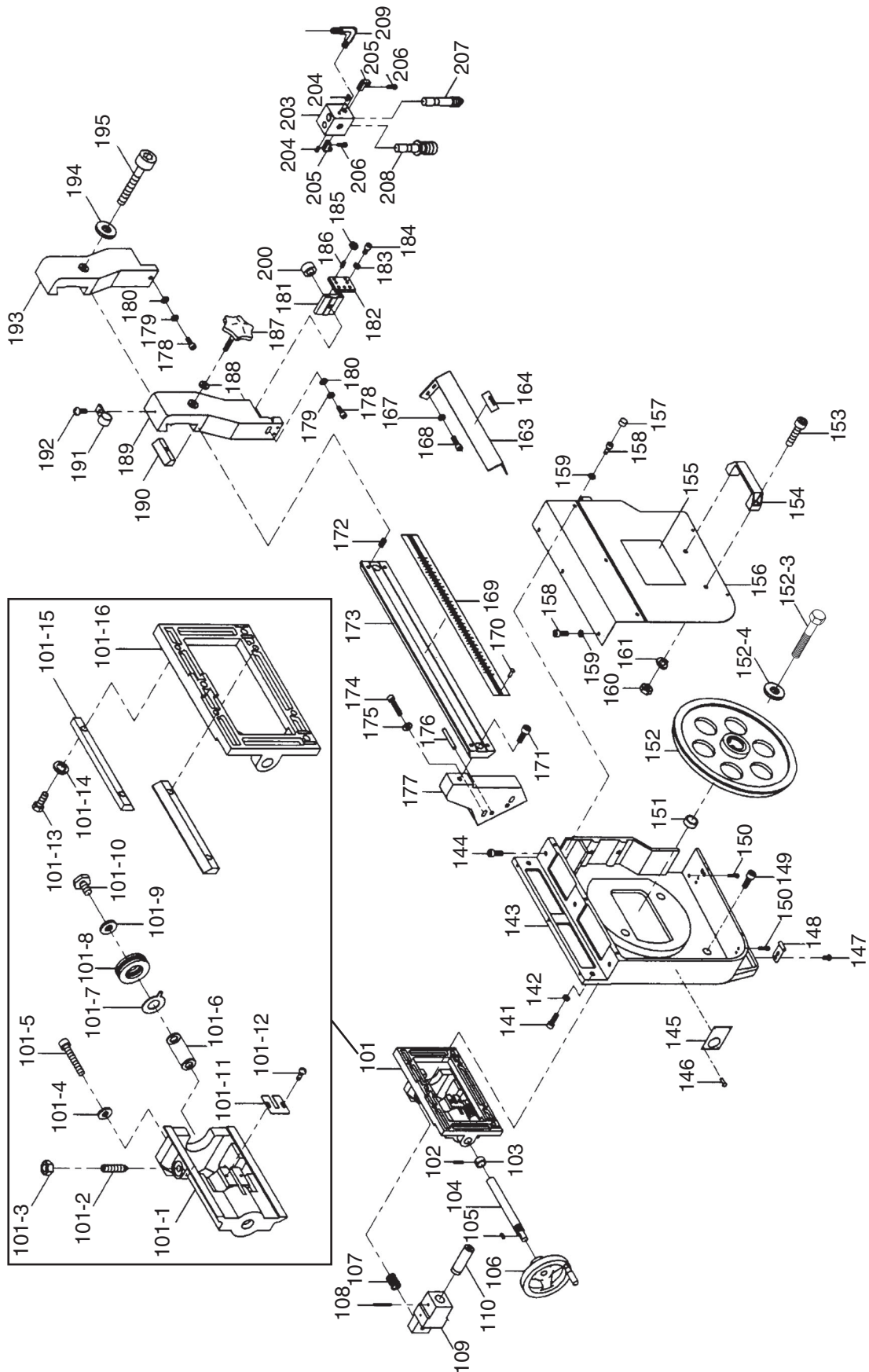
Model M1048 220V Wiring Diagram



LEGEND

M = Motor
 KM1 = Contactor Main Motor
 KM2 = Pump Motor Relay
 KM1 = Thermal Relay Main Motor
 L = Indicator Lamp
 SB1 = Emergency Stop Button
 SB3 = Start Button
 SB4 = Pump Motor Switch
 SQ1 = Limit Switch
 TC = Transformer for Control System (24V)
 FU2A = Fuse

Blade Guides Parts Breakdown

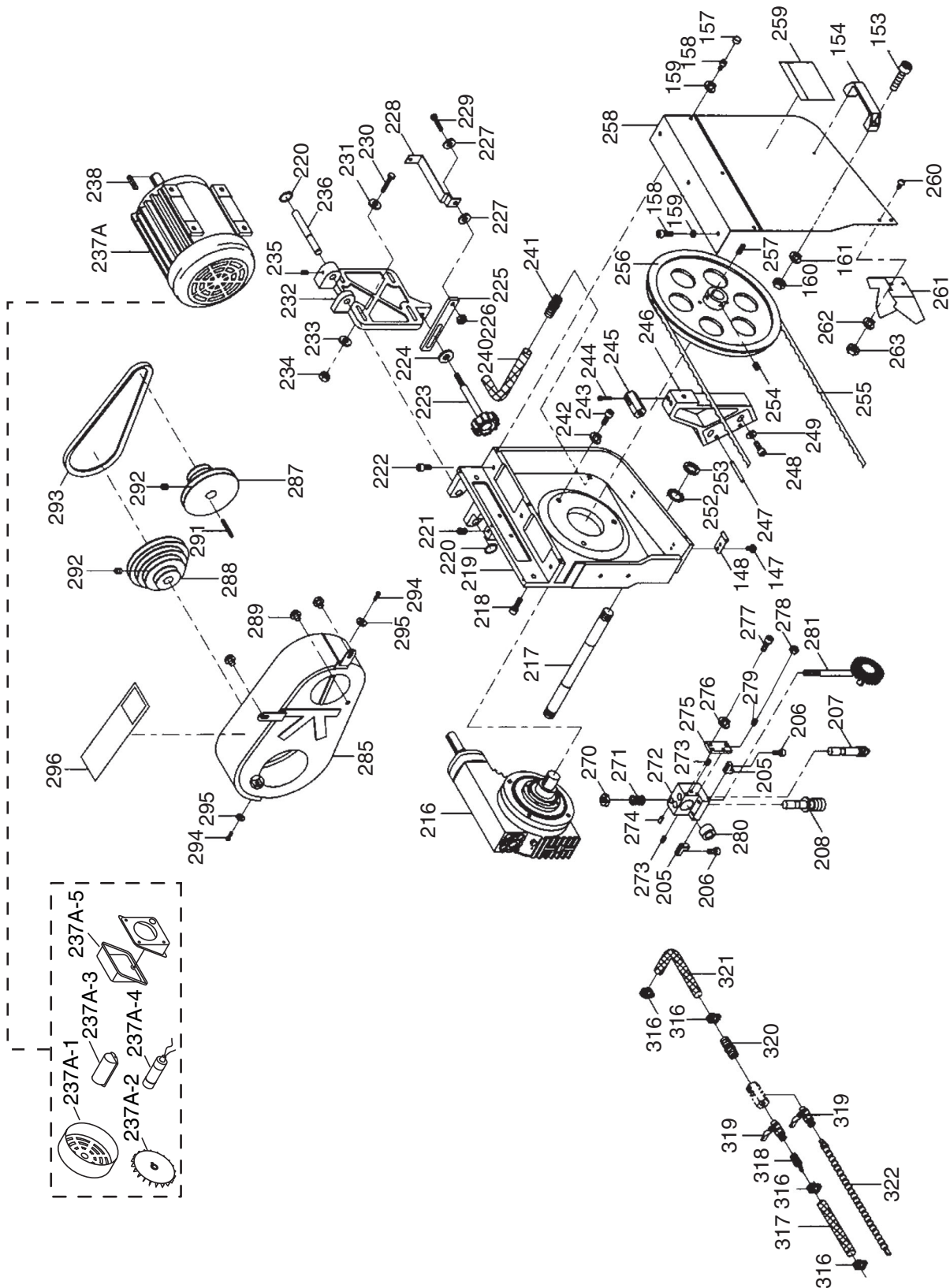


Blade Guides Parts List

REF	PART #	DESCRIPTION
101	XM1048101	SLIDE SET
101-1	XM1048101-1	SLIDE
101-2	XM1048101-2	SPECIAL SET SCREW
101-3	XPN10	HEX NUT 7/16-20
101-4	XPW04M	FLAT WASHER 10MM
101-5	XPSB134M	CAP SCREW M10-1.5 X 65
101-6	XM1048101-6	DISC SPRING
101-7	XM1048101-7	INDICATOR DIAL
101-8	XM1048101-8	BEARING 51204
101-9	XPW01	FLAT WASHER 1/2
101-10	XM1048101-10	SPECIAL SCREW
101-11	XM1048101-11	SCALE
101-12	XPS05M	PHLP HD SCR M5-.8 x 8
101-13	XPB32M	HEX BOLT M10-1.5 x 25
101-14	XPLW06M	LOCK WASHER 10MM
101-15	XM1048101-15	GIB
101-16	XM1048101-16	BRACKET
102	XPRP49M	ROLL PIN 5 X 25
103	XM1048103	COLLAR
104	XM1048104	LEADSCREW
105	XPK20M	KEY 5 X 5 X 15
106	XM1048106	HANDWHEEL & HANDLE
107	XM1048107	COMPRESSION SPRING
108	XPRP30M	ROLL PIN 5 X 50
109	XM1048109	BRACKET
110	XM1048110	SHAFT
141	XPSB72M	CAP SCREW M10-1.5 X 30
142	XPLW06M	LOCK WASHER 10MM
143	XM1048143	IDLER WHEEL BOX
144	XPSB130M	CAP SCREW M10-1.5 X 16
145	XM1048145	TENSION LABEL
146	XM1048146	RIVET
147	XPS68M	PHLP HD SCR M6-1 X 10
148	XM1048148	BRACKET
149	XPSB77M	CAP SCREW M12-1.75 X 30
150	XPSB06M	CAP SCREW M6-1 X 25
151	XM1048151	BUSHING
152	XM1048152	IDLER WHEEL ASSY
152-3	XPB70M	HEX BOLT M10-1.5 X 16
152-4	XPW04M	FLAT WASHER 10MM
153	XPSB11M	CAP SCREW M8-1.25 X 16
154	XM1048154	HANDLE
155	XM1048155	SPEED INDICATOR LABEL
156	XM1048156	IDLER WHEEL COVER

REF	PART #	DESCRIPTION
157	XM1048157	PLASTIC BUSHING
158	XPSB04M	CAP SCREW M6-1 X 10
159	XPLW02	LOCK WASHER 1/4
160	XM1048160	HEX NUT M8
161	XPLW01	LOCK WASHER 5/16
163	XM1048163	BLADE GUARD
164	XM1048164	BLADE LABEL
167	XPLW02	LOCK WASHER 1/4
168	XPSB04M	CAP SCREW M6-1 X 10
169	XM1048169	SCALE
170	XM1048170	RIVET
171	XPSB77M	CAP SCREW M12-1.75 X 30
172	XPSS09M	SET SCREW M8-1.25 X 20
173	XM1048173	COLUMN
174	XPSB84M	CAP SCREW M10-1.5 X 35
175	XPW04M	FLAT WASHER 10MM
176	XPRP49M	ROLL PIN 5 X 25
177	XM1048177	LEFT COLUMN SUPPORT
178	XPSB05M	CAP SCREW M8-1.25 X 50
179	XPLW04M	LOCK WASHER 8MM
180	XPLW01	LOCK WASHER 5/16
181	XM1048181	SUPPORT SEAT
182	XM1048182	ADJ FIXING PLATE (IDLER)
183	XPLW02	LOCK WASHER 1/4
184	XPSB02M	CAP SCREW M6-1 X 20
185	XPN03M	HEX NUT M8-1.25
186	XPSS09M	SET SCREW M8-1.25 X 20
187	XM1048187	BLADE ADJUSTABLE KNOB
188	XPW04M	FLAT WASHER 10MM
189	XM1048189	ARM (LEFT)
190	XM1048190	GIB
191	XM1048191	HOSE CLAMP
192	XPS05M	PHLP HD SCR M5-.8 X 8
193	XM1048193	ARM (RIGHT)
194	XPW04M	FLAT WASHER 10MM
195	XPSB71M	CAP SCREW M10-1.5 X 60
200	XM1048200	BEARING SPACER
203	XM1048203	BEARING BRACKET (IDLER)
204	XPSS20M	SET SCREW M8-1.25 X 8
205	XM1048205	CARBIDE GUIDE
206	XPSB02M	CAP SCREW M6-1 X 20
207	XM1048207	ECCENTRIC SHAFT SET
208	XM1048208	BEARING SHAFT ASSY
209	XM1048209	MICRO CONTROL BLOCK

Drive Wheel Parts Breakdown

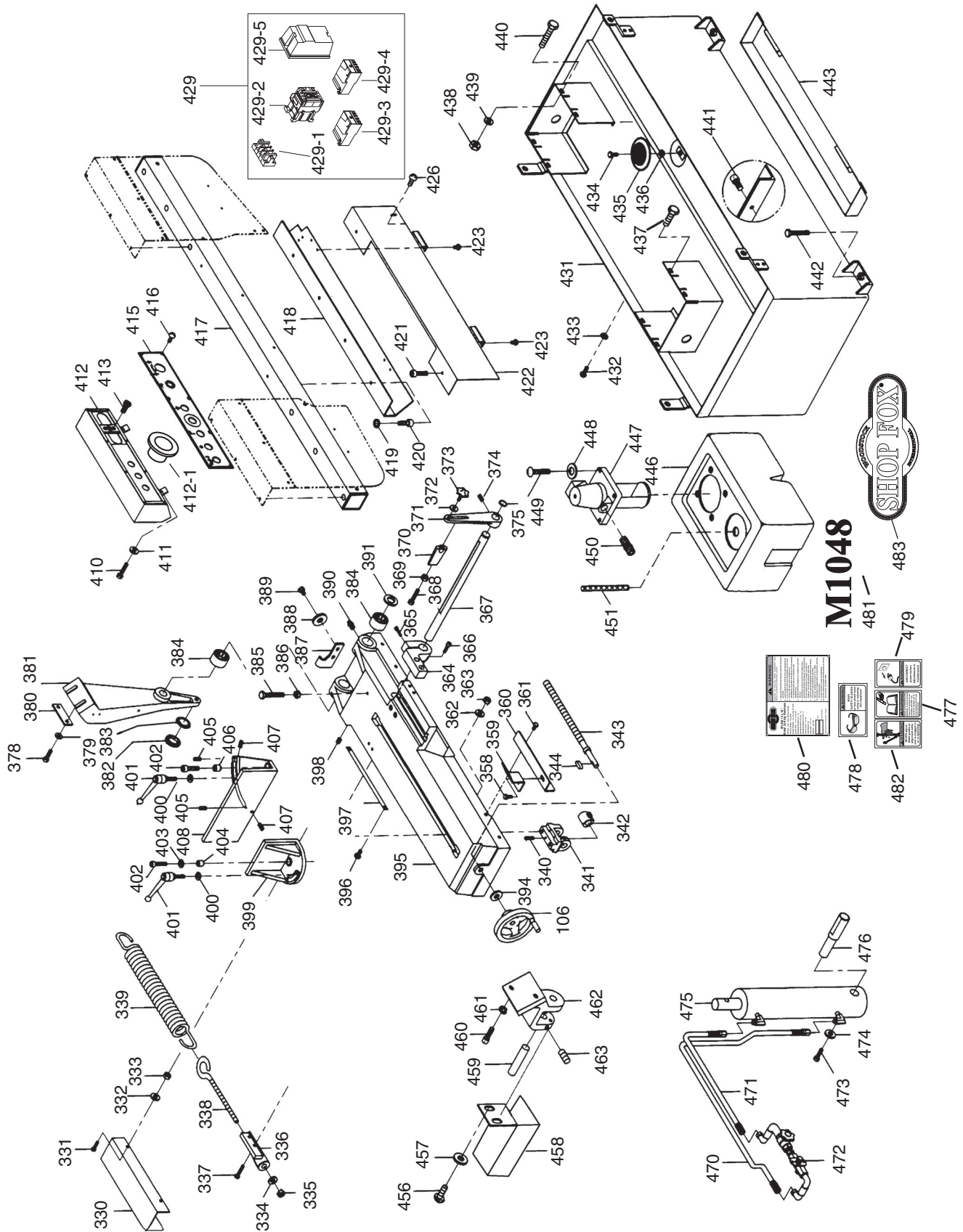


Drive Wheel Parts List

REF	PART #	DESCRIPTION
216	XM1048216	GEAR BOX ASSY
217	XM1048217	PIVOT SHAFT
218	XPSB72M	CAP SCREW M10-1.5 X 30
219	XM1048219	DRIVE WHEEL BOX
220	XPR05M	EXT RETAINING RING 15MM
221	XPSS09M	SET SCREW M8-1.25 X 20
222	XPSB130M	CAP SCREW M10-1.5 X 16
223	XM1048223	BELT TENSION KNOB
224	XPW04M	FLAT WASHER 10MM
225	XM1048225	MOTOR ADJUSTABLE ROD
226	XPN03M	HEX NUT M8-1.25
227	XPW07	FLAT WASHER 5/16
228	XM1048228	BRACKET
229	XPB15M	HEX BOLT M8-1.25 X 40
230	XPB15M	HEX BOLT M8-1.25 X 40
231	XPW07	FLAT WASHER 5/16
232	XM1048232	MOTOR PLATE
233	XPW07	FLAT WASHER 5/16
234	XPN03M	HEX NUT M8-1.25
235	XPSS01M	SET SCREW M6-1 X 10
236	XM1048236	PIVOT SHAFT
237A	XM1048237A	2 HP MOTOR 220V
237A-1	XM1048237A-1	MOTOR COVER
237A-2	XM1048237A-2	MOTOR FAN
237A-3	XM1048237A-3	CAPACITOR COVER
237A-4	XM1048237A-4	CAPACITOR 800MFD 125VAC
237A-5	XM1048237A-5	JUNCTION BOX
238	XPB20M	KEY 5 X 5 X 15
240	XM1048240	HOSE 5/8"
241	XM1048241	HOSE FITTING PT 1/2"
242	XPLW06M	LOCK WASHER 10MM
243	XPSB61M	CAP SCREW M10-1.5 X 20
244	XPSB06M	CAP SCREW M6-1 X 25
245	XM1048245	BRACKET
246	XM1048246	COLUMN RIGHT SUPPORT
247	XPRP49M	ROLL PIN 5 X 25
248	XPSB84M	CAP SCREW M10-1.5 X 35
249	XPW04M	FLAT WASHER 10MM
252	XM1048252	EXT TOOTH WASHER 25MM
253	XM1048253	COLLAR

REF	PART #	DESCRIPTION
254	XPSS20M	SET SCREW M8-1.25 X 8
255	D3664	BLADE 129-3/8" X 1 X .035 5-8 VP
256	XM1048256	DRIVE WHEEL
257	XPB61M	KEY 7 X 7 X 30
258	XM1048258	WHEELCOVER
259	XM1048259	SPEED LABEL
260	XPS68M	PHLP HD SCR M6-1 X 10
261	XM1048261	BRUSH COVER
262	XPLW02	LOCK WASHER 1/4
263	XPN03M	HEX NUT M8-1.25
270	XPN09M	HEX NUT M12-1.75
271	XM1048271	COMPRESSION SPRING
272	XM1048272	BLADE ADJUSTABLE DRIVE
273	XPSS20M	SET SCREW M8-1.25 X 8
274	XPRP44M	ROLL PIN 3 X 10
275	XM1048275	ADJ FIXING PLATE (DRIVE)
276	XPLW02	LOCK WASHER 1/4
277	XPSB02M	CAP SCREW M6-1 X 20
278	XPN03M	HEX NUT M8-1.25
279	XPSS01M	SET SCREW M6-1 X 10
280	XM1048280	BEARING SPACER
281	XM1048281	BRUSH ASSY
285	XM1048285	MOTOR PULLEY COVER
287	XM1048287	SPINDLE PULLEY
288	XM1048288	MOUNT PULLEY
289	XPS39M	PHLP HD SCR M8-1.25 X 10
291	XPB20M	KEY 5 X 5 X 15
292	XPSS16M	SET SCREW M8-1.25 X 10
293	XPVA32	V-BELT A-32 4L320
294	XPS39M	PHLP HD SCR M8-1.25 X 10
295	XPW07	FLAT WASHER 5/16
296	XM1048296	SPEED INDICATOR LABEL
316	XM1048316	HOSE CLAMP 1/2"
317	XM1048317	HOSE 5/16 X 600MM
318	XM1048318	HOSE FITTING PT1/4 X 1/4
319	XM1048319	VALVE PT 1/4
320	XM1048320	HOSE FITTING PT 1/4 X 1/2
321	XM1048321	HOSE 1/4 X 1400MM
322	XM1048322	NOZZLE PT 1/4

Main Parts Breakdown



Main Parts List

REF	PART #	DESCRIPTION
330	XM1048330	SPRING COVER
331	XPB26M	HEX BOLT M8-1.25 X 30
332	XPW07	FLAT WASHER 5/16
333	XPNO3M	HEX NUT M8-1.25
334	XPW01	FLAT WASHER 1/2
335	XPNO13	HEX NUT 1/2-13
336	XM1048336	SPRING BRACKET
337	XPB15M	HEX BOLT M8-1.25 X 40
338	XM1048338	EYE BOLT
339	XM1048339	EXTENSION SPRING
340	XPRP10M	ROLL PIN 5 X 36
341	XM1048341	BRACKET
342	XM1048342	ACME NUT ASSY
343	XM1048343	ACME SCREW
344	XPB20M	KEY 5 X 5 X 15
358	XPB87M	HEX BOLT M8-1.25 X 15
359	XM1048359	FIXED PLATE
360	XM1048360	FIXED PLATE
361	XPB17M	HEX BOLT M8-1.25 X 10
362	XPW07	FLAT WASHER 5/16
363	XPNO3M	HEX NUT M8-1.25
364	XM1048364	BRACKET
365	XPSB48M	CAP SCREW M6-1 X 35
366	XPSB13M	CAP SCREW M8-1.25 X 30
367	XM1048367	DISTANCE SET ROD
368	XPB32M	HEX BOLT M10-1.5 x 25
369	XPNO3M	HEX NUT M8-1.25
370	XM1048370	DISTANCE SET BRACKET
371	XM1048371	SUPPORT ROD
372	XPLW02	LOCK WASHER 1/4
373	XM1048373	PLUM SCREW
374	XPSS01M	SET SCREW M6-1 X 10
375	XPR11M	EXT RETAINING RING 25MM
378	XPB14M	HEX BOLT M10-1.5 X 35
379	XPLW06M	LOCK WASHER 10MM
380	XM1048380	BUSHING
381	XM1048381	REAR PIVOT BRACKET
382	XM1048382	COLLAR
383	XM1048383	STAR WASHER AW05
384	XM1048384	BEARING 6904RNA
385	XPB141M	HEX BOLT M12-1.75 X 80
386	XPNO9M	HEX NUT M12-1.75
400	XPW04M	FLAT WASHER 10MM
401	XM1048401	THUMB SCREW
402	XPSB72M	CAP SCREW M10-1.5 X 30
403	XPW04M	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
387	XM1048387	POSITION SET BRACKET
388	XPW07	FLAT WASHER 5/16
389	XPSB14M	CAP SCREW M8-1.25 X 20
390	XM1048390	GREASE NIPPLE
391	XM1048391	BUSHING
394	XPW04	FLAT WASHER 7/16
395	XM1048395	BASE
396	XPS05M	PHLP HD SCR M5-.8 X 8
397	XM1048397	DEGREE SCALE
398	XPSS16M	SET SCREW M8-1.25 X 10
399	XM1048399	WISE JAW BRACKET
404	XM1048404	BUSHING
405	XPSS01M	SET SCREW M6-1 X 10
406	XM1048406	BUSHING
407	XPSS19M	SET SCREW M8-1.25 X 30
408	XM1048408	WISE JAW BRACKET (REAR)
410	XPB02M	HEX BOLT M6-1 X 12
411	XPLW02	LOCK WASHER 1/4
412	XM1048412	CONTROL BOX
412-1	XM1048412-1	EMERGENCY STOP SWITCH
413	XPS14M	PHLP HD SCR M6-1 X 12
415	XM1048415	NAME PLATE
416	XPS70M	PHLP HD SCR M5-1 X 8
417	XM1048417	COLUMN
418	XM1048418	LOWER BLADE GUARD
419	XPLW01	LOCK WASHER 5/16
420	XPB03M	HEX BOLT M8-1.25 X 16
421	XPSB04M	CAP SCREW M6-1 X 10
422	XM1048422	UPPER BLADE COVER
423	XPS70M	PHLP HD SCR M5-1 X 8
426	XPS70M	PHLP HD SCR M5-1 X 8
429	XM1048429	COMPLETE ELECTRICAL BOX
429-1	XM1048429-1	COMPLETE FUSE HOLDER
429-2	XM1048429-2	CONTACTOR LCK09
429-3	XM1048429-3	THERMAL OVERLOAD LR7K0332
429-4	XM1048429-4	RELAY 240/24V
431	XM1048431	STAND
432	XPS68M	PHLP HD SCR M6-1 X 10
433	XPLW01M	LOCK WASHER 5MM
434	XPB18M	HEX BOLT M6-1 X 15
435	XM1048435	FILTER
436	XPNO1M	HEX NUT M6-1
437	XPB26M	HEX BOLT M8-1.25 X 30
438	XPNO3M	HEX NUT M8-1.25
439	XPW07	FLAT WASHER 5/16
440	XPB15M	HEX BOLT M8-1.25 X 40

Main Parts List

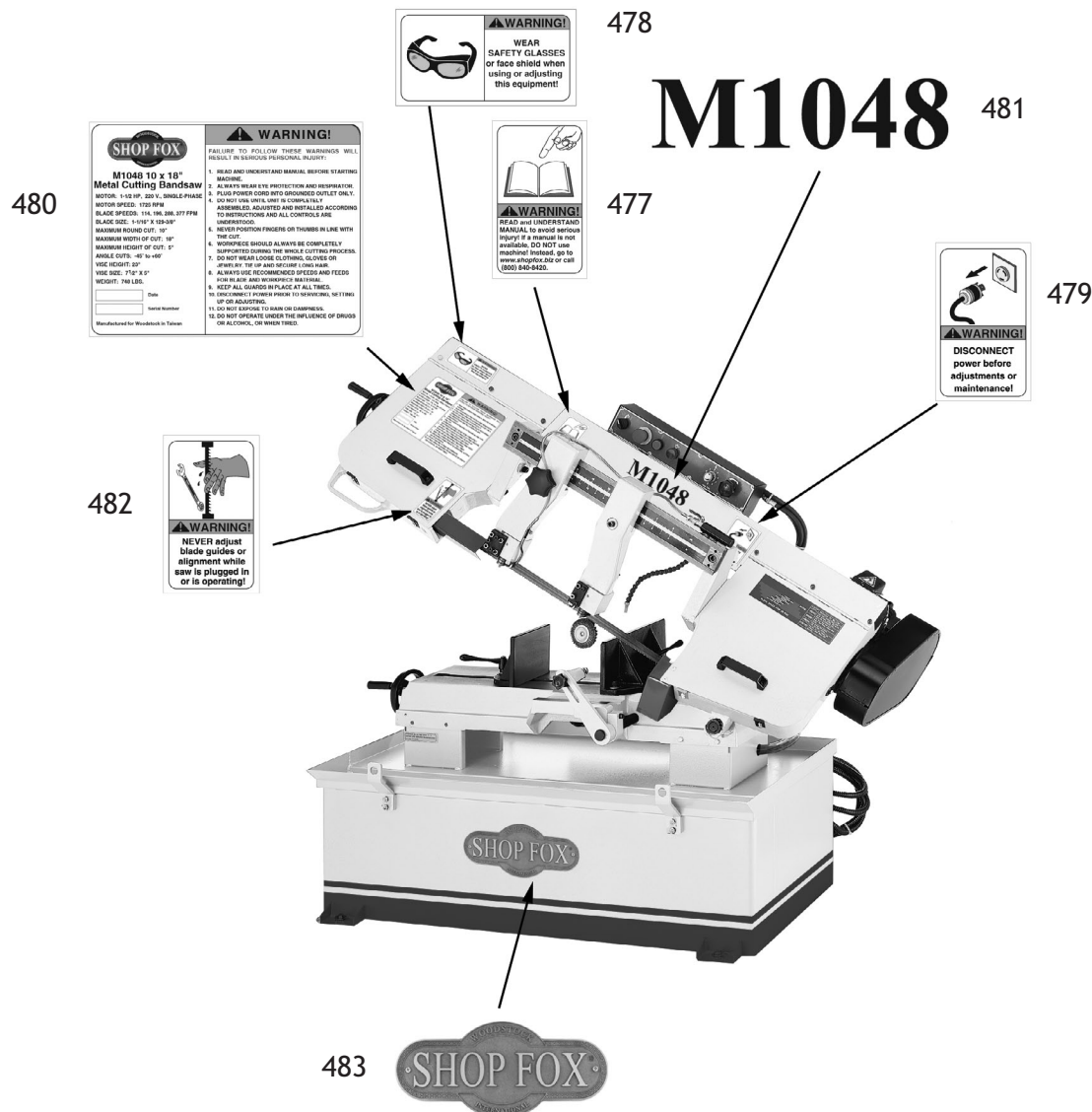
REF	PART #	DESCRIPTION
441	XPSB30M	CAP SCREW M6-1 X 45
442	XPB22M	HEX BOLT M8-1.25 X 50
443	XM1048443	CHIP TRAY
446	XM1048446	COOLANT TANK
447	XM1048447	COOLANT PUMP
448	XPW06	FLAT WASHER 1/4
449	XPS07	PHLP HD SCR 1/4-20 X 3/8
450	XM1048450	COUPLER PT 1/2 X 1/4
451	XM1048451	HOSE 3/4 X 1.5
456	XPS68M	PHLP HD SCR M6-1 X 10
457	XPLW02	LOCK WASHER 1/4
458	XM1048458	SWITCH BRACKET
459	XM1048459	PIVOT PIN
460	XPSB13M	CAP SCREW M8-1.25 X 30
461	XPLW01	LOCK WASHER 5/16
462	XM1048462	CYLINDER UPPER BRACKET

REF	PART #	DESCRIPTION
463	XPSS01M	SET SCREW M6-1 X 10
470	XM1048470	HOSE W/TUBE FITTING
471	XM1048471	HOSE W/TUBE FITTING
472	XM1048472	VALVE
473	XPB03M	HEX BOLT M8-1.25 X 16
474	XPW07	FLAT WASHER 5/16
475	XM1048475	CYLINDER ASSY
476	XM1048476	PIVOT SHAFT
477	XLABEL-12	READ MANUAL LABEL
478	XLABEL-01	SAFETY GLASSES LABEL
479	XLABEL-02	UNPLUG POWER LABEL
480	XM1048480	MACHINE ID LABEL
481	XM1048481	M1048 LABEL
482	XM1048482	BLADE SAFETY LABEL
483	XM1048483	LOGO PLATE

Label Placement

! WARNING

Safety labels warn about machine hazards and how to prevent machine damage or injury. The owner of this machine **MUST** maintain the original location and readability of all labels on this machine. If any label is removed or becomes unreadable, **REPLACE** that label before allowing the machine to enter service again. Contact Woodstock International, Inc. at (360) 734-3482 or www.shopfoxtools.com to order new labels.



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Woodstock International, Inc. warrants all **SHOP FOX®** machinery to be free of defects from workmanship and materials for a period of two years from the date of original purchase by the original owner. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, lack of maintenance, or reimbursement of third party expenses incurred.

Woodstock International, Inc. will repair or replace, at its expense and at its option, the **SHOP FOX®** machine or machine part which in normal use has proven to be defective, provided that the original owner returns the product prepaid to the **SHOP FOX®** factory service center or authorized repair facility designated by our Bellingham, WA office, with proof of their purchase of the product within two years, and provides Woodstock International, Inc. reasonable opportunity to verify the alleged defect through inspection. If it is determined there is no defect, or that the defect resulted from causes not within the scope of Woodstock International Inc.'s warranty, then the original owner must bear the cost of storing and returning the product.

This is Woodstock International, Inc.'s sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant that **SHOP FOX®** machinery complies with the provisions of any law or acts. In no event shall Woodstock International, Inc.'s liability under this warranty exceed the purchase price paid for the product, and any legal actions brought against Woodstock International, Inc. shall be tried in the State of Washington, County of Whatcom. We 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.

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Phone # _____ Email _____ Invoice # _____

Model # _____ Serial # _____ Dealer Name _____ Purchase Date _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

_____ Advertisement

_____ Friend

_____ Local Store

_____ Mail Order Catalog

_____ Website

_____ Other:

2. How long have you been a woodworker/metalworker?

_____ 0-2 Years

_____ 2-8 Years

_____ 8-20 Years

_____ 20+ Years

3. How many of your machines or tools are Shop Fox®?

_____ 0-2

_____ 3-5

_____ 6-9

_____ 10+

4. Do you think your machine represents a good value?

_____ Yes

_____ No

5. Would you recommend Shop Fox® products to a friend?

_____ Yes

_____ No

6. What is your age group?

_____ 20-29

_____ 30-39

_____ 40-49

_____ 50-59

_____ 60-69

_____ 70+

7. What is your annual household income?

_____ \$20,000-\$29,000

_____ \$30,000-\$39,000

_____ \$40,000-\$49,000

_____ \$50,000-\$59,000

_____ \$60,000-\$69,000

_____ \$70,000+

8. Which of the following magazines do you subscribe to?

_____ Cabinet Maker

_____ Popular Mechanics

_____ Today's Homeowner

_____ Family Handyman

_____ Popular Science

_____ Wood

_____ Hand Loader

_____ Popular Woodworking

_____ Wooden Boat

_____ Handy

_____ Practical Homeowner

_____ Woodshop News

_____ Home Shop Machinist

_____ Precision Shooter

_____ Woodsmith

_____ Journal of Light Cont.

_____ Projects in Metal

_____ Woodwork

_____ Live Steam

_____ RC Modeler

_____ Woodworker West

_____ Model Airplane News

_____ Rifle

_____ Woodworker's Journal

_____ Modeltec

_____ Shop Notes

_____ Other:

_____ Old House Journal

_____ Shotgun News

9. Comments: _____

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