

15'' WOOD BAND SAW

OPERATING AND MAINTENANCE INSTRUCTIONS

ORDERING INFORMATION

The 381 mm / 15" wood band saw, shown here with 15" wheels, 2820 mm / 111" blade and a reclining table, has a 317,5 mm / 12-1/2" resaw capacity..

SPECIFICATIONS

WHEELS

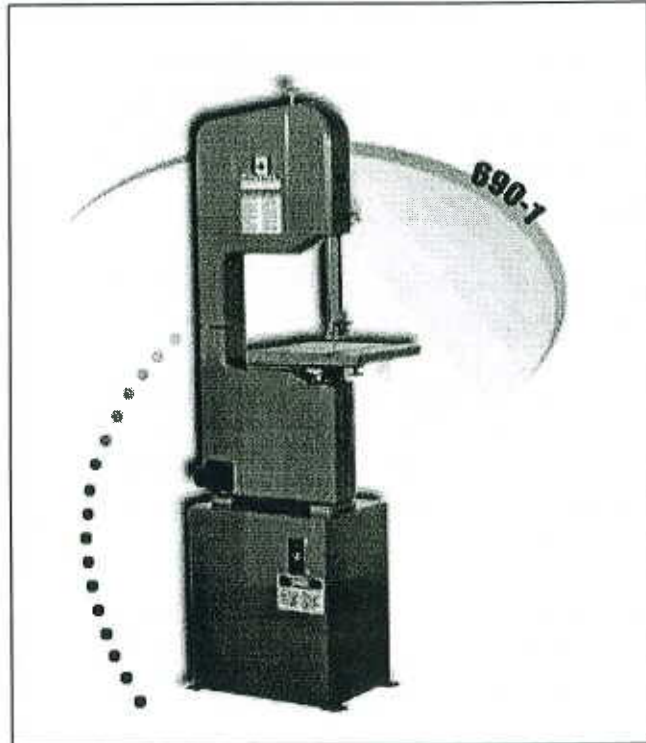
Diameter	381 mm / 15"
Speed	750 RPM

BLADES

Speed	914 m/minute 3000 ft/minute
Maximum width of cut	374,6 mm / 14-3/4"
Maximum depth of cut	317,5 mm / 12-1/2"
Maximum blade width	19 mm / 3/4"
Minimum blade width	3 mm / 1/8"
Blade length	2820 mm / 111"

TABLE

Dimensions	381 mm x 381 mm / 15" X 15"
Inclination	45 deg. right, 10 deg. left
Height	1066,6 mm / 42"



MODEL NO	SERIAL NO
690	

IMPORTANT: When ordering replacement parts, always give the model and serial number of the machine and part number. Also a brief description of each item and quantity desired.

Accessories available from GENERAL

1950	Miter gauge
1951	Lamp 15" flexible arm
4950	Ball bearing blade guides Carter
6906	Blade 6,3 mm x 2820 mm 4 tooth 1/4" x 111"
6907	Blade 9,25 mm x 2845 mm 4 tooth 3/8" x 111"
6908	Blade 12,7 mm x 2845 mm 4 tooth 1/2" x 111"
6909	Blade 19 mm x 2845 mm 3 tooth 3/4" x 111"

All replacement parts can be obtained from:

GENERAL MFG CO. LTD
 835, Cherrier Street
 Drummondville, Quebec, Canada
 J2B 5A8
 Phone: (819) 472-1161
 Fax: (819) 472-3266
 Website: www.general.ca

SAFETY RULES

Read carefully before operating the machine

- (1) Learn the machine's applications and limitations, as well as the specific potential hazards peculiar to this machine. Follow available operating instructions and safety rules carefully.
- (2) Keep working area clean and be sure adequate lighting is available.
- (3) Do not wear loose clothing, gloves, bracelets, necklaces or ornaments. Wear face, eye, ear, respiratory and body protection devices, as indicated for the operation or environment.
- (4) Do not use blade larger or heavier than the machine is designed to accommodate. Never operate a cutting tool at greater speed than recommended.
- (5) Keep hands well away from saw blade. Use a push stick or push block to hold or guide the work when working close to cutting tool.
- (6) Whenever possible, use properly locked clamps, jig, or vise to hold the work.
- (7) Be sure the power is disconnected from the machine before tools are serviced.
- (8) Never leave the machine with the power on.
- (9) Be positive that hold-downs and anti-kickback devices are positioned properly, and that the work-piece is being fed through the cutting tool in the right direction.
- (10) Do not use a dull, gummy, bent or cracked cutting tool.
- (11) Be sure that keys and adjusting wrenches have been removed before turning power on.
- (12) Use only accessories designed for the machine.
- (13) Adjust the machine for minimum exposure of cutting tool necessary to perform the operation.

GENERAL Guarantee

All component parts of GENERAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality, GENERAL agrees to repair or replace any genuine part or parts which, upon examination, proves to be defective in workmanship or material within a period of 24 months. In order to obtain warrantee, all defective parts must be returned prepaid to General Mfg Co. Ltd. Repairs made without our written authorization voids all guarantees.

15" WOOD BAND SAW

A band saw requires a reasonable amount of care and attention to insure perfect performance and accurate work, and no matter how good the manufacturer makes the machine, the operator must take good care of it if it is to continue to give the best result. It will take just a few moments to read and familiarize yourself with these instructions and they will probably save you a lot of trouble and time.

INSTALLATION

Your band saw is shipped in a crate and wrapped in waterproof paper. Remove the bolts that hold it to the crate and take away the paper. The surface of the table and the mechanism have been covered with a special grease to prevent rusting. Remove it with a grease solvent, but no paint solvent should be used as it will damage the paint. A stand, model 6900, is available from GENERAL.

POWER REQUIRED

For average work and steady production, a 1/2 HP , 230V capacity motor should be used.

SPEED

For a standard motor of 1725 RPM, a 2 "V" 2-3/4" diameter pulley should be used to give a correct speed of 750 RPM to the wheels. Nothing will be gained by increasing the speed, except that the life of your blades will shortened considerably. Be sure that the motor runs in the right direction, that is the teeth of the blade should be moving downward towards the table. If not, reverse the rotation of the motor according to the instructions of the manufacturers.

TABLE

The table of your band saw tilts to 45 deg. to the right and 10 deg. to the left. To tilt it to the right, the lock knobs under the table are turned then loosened. They are then tightened after the table has been tilted to the desired angle. To tilt the table to the left, the table is first tilted to the right, then the stop sleeve #1935 on the screw at the left under the table is removed, then the table is tilted to the left until it rests on the screw.

The setting of the table at 90 deg. has been set at the factory but it should be checked to insure that it has not been set at the factory, but it should be checked to be sure that it has not been disturbed in shipping. Screwing the screws up or down will place the table square. When set, lock in place. After the table setting is correct, adjust the pointer at "0" so your scale will give you the correct angle when the table is tilted.

BLADE ADJUSTMENTS

The band saw is shipped with a 1/4" blade. To change blades, you must open the guard. Then, the upper wheel is lowered by turning the knob place vertically on the adjustment on that wheel until the blade is loose. Remove the pin on the front of the table, then take the blade off the wheel and through the slot. To replace a blade, this operation is reversed and the upper wheel is raised until the blade is reasonably tight as indicated on the tension scale. Then replace the pin on the table.

The blade should not be loose to work properly and care must be taken that it is not too tight as this is a common cause of blade breakage and other unsatisfactory blade performance. With a little experience, the proper tension will be determined.

After the tension has been adjusted, loosen the upper and lower guide and guide pins by loosening the thumb-screws and the socket screws with the wrench supplied. Pull them back, so the blade runs clear of them. Then turn the wheels forward by hand and watch if the glade travels on the centre of the wheel. If not, adjust by turning the knob placed horizontal at the back of the upper wheel, until the blade "track". Never adjust the blade while the machine is running. Now check the blade setting by running the saw under power.

SETTING THE GUIDES

The brackets carrying the guide pins should now be adjusted forward until the front edge of the guide blocks are just behind the gullets of the teeth. The guide blocks should not touch the teeth, as they will be worn out and if they are too far back, they will not give pooper support to the blade. Lock the brackets in place. The guide blocks should be set as close as possible to the blade yet without binding, then tighten the screws that hold the blocks in place. The ball-bearing blade supports should be brought forward as near as possible to the back of the blade without touching it and locked in place. The blade, when running free, should not bear against the support bearings, but have a clearance of about 1/64".

If the blade is allowed to run hard against the support bearings at all times, the back will become work hardened, and this will cause eventual breakage. The proper adjustments are very important for the correct operations of the band saw.

Be sure to readjust the guides every time a blade is changed, especially if blades of varying widths are used. After considerable use, the guide blocks will be worn at their front edges, causing a tendency to bind on the rear of the blade, then reverse the ends. When both are worn, grind them square.

BLADES

The band saw blades are subject to tremendous strain and if long use is desired, good care must be taken of them. Various type of work need various thickness, width and temper blades. Always use the widest blade possible, using narrow blade for cutting sharp curves and delicate work only. This will save blades. Change and use wider blades every time that is possible. This will lengthen the life of your blades and give more satisfactory work.

The blades should always be sharp and well set. If a blade is broken, it can be brazed or welded. However, if it has become badly work, hardened it will soon break in another place. Blades from 3 mm / 1/8" to 19 mm / 3/4" by 111" long can be used on the GENERAL 15" band saw.

OPERATION

Before running, be sure that the adjustments are right and that the guards are closed. Turn the wheels by hand before turning on the power to be sure that everything is right.

Keep the upper guide close to your work at all time. Do not force the work against the blade. A light touch

will enable you to follow your line more easily and prevent friction with the bearing supports from heating the blade which causes work-hardening of the blade and shortens its life.

When the blade is sharp, very little pressure is required for cutting. Do not twist the blade trying to cut a sharp curve or a corner; use a narrow blade. When cutting curves, turn the part slowly so the blade can follow the line easily without being twisted. Blade breakage is caused by any one of a number of conditions such as being the natural result of the peculiar stresses to which such saws are subjected, but it is usually caused by the lack of care or of judgement on the part of the operator.

The most common causes of blade breakage are misalignments and miss-adjustments of the guides, forcing or twisting a wide blade around a narrow corner, dullness of the teeth or insufficient set, feeding too fast, blade too tight, top guide tool high above work and using a blade incorrectly welded.

LUBRICATION

The ball-bearings which carry the wheels and the ball-bearing blade supports are greased-sealed and require no lubrication for their entire life. No special care is necessary for the rest of the machine.

GAUGE

The table of the GENERAL band saw has a groove of . 3/8" x 3/4" to accommodate a miter gauge which enables you to cross cut at right angle or at any angle desired. A rip fence can also be used to rip stock to 228,6 mm/ 9" wide between blade and fence. It can be used on both side of the blade and the full width of the table

REPLACEMENT PARTS

IMPORTANT : Always give part number and description of item when ordering.
Also give serial No.

PART NO	DESCRIPTION	QTY
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FRAME AND LOWER WHEEL PARTS

195	Lower spindle	1
1944-A	Pulley for 690	1
3423	Square key	1
491-3SA	Lower door with hinge	1
491-4	Door lock	2
494-1	Lower wheel with rubber tire	1
691-1	Saw frame	1
P-4	Woodruff key # 9 3/16 x 3/4	1
P-7	Socket set screw 5/16-18 x 5/16	1
P-78	Handle 1" 5/16 -18	2
P-116	Round head socket machine screw 8-32 x 3/8	4
P-173	Round head socket machine screw 1/4-20 x 3/8	6
P-187	Round head socket machine screw 5/16-18 x 1/2	2
P-194	Bearing 6204-2RS	2
P-196	Jam nut 3/4-16	2
P-197	Loading spring S-20	1
P-420	Name plate 352-8	1
P-428	Rubber tire 1918-1	1
P-1161	Universal dust port	1
P-1167	Hexagonal nut 8-32	4
P-1177	Rivet 1/8 x .265 x .125	2

UPPER WHEEL PARTS

1934-1	Lock nut	1
356-21	Pointer	1
493-1	Upper wheel with rubber tire	1
493-2	Pivoting arm	1
493-3	Sliding bracket	1
493-4	Gib	2
493-5SA	Tension screw assembly	1
493-6	Tension scale bracket	1
493-7	Pointer bracket	1
493-9	Pivoting pin	1
493-10	Spacer	1
493-11	Upper spindle	1
493-13	Spacer	1

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MANUFACTURER OF CIRCULAR SAWS, BAND SAWS, WOOD LATHES, PLANERS,
JOINTERS, MORTISERS, DRILL PRESSES, SHAPERS AND SANDERS

REPLACEMENT PARTS

IMPORTANT : Always give part number and description of item when ordering.
Also give serial No.

PART NO	DESCRIPTION	QTY
493-14SA	Adjusting screw assembly	1
691-2SA	Upper door	1
P-7	Socket set screw 5/16-18 x 5/16	1
P-100	Hexagonal head cap screw 5/16-18 x 3/4	4
P-120	Tapping screw 8-32 x 1/4	1
P-188	Snap ring N-1300-137	2
P-189	Bearing 6202-2RS	1
P-190	Jam num 1/2-20	1
P-193	Bearing 602 Nice	1
P-319	Tapping screw 10-32 x 3/8	2
P-329	Drive screw 4 x 1/4	2
P-428	Rubber tire 1918-1	1
P-431	Fiber washer 5/8 x 7/8 x 1/6	1
P-444	Handle 5/16	1

TABLE PARTS

1935	Stop	1
1936	Stop screw	1
492-1	Table	1
492-2	Trunnion	2
492-4	Table bracket	1
492-7	Pin	1
492-8	Insert	1
J-80-19	Chip-breaker screw	1
P-37	Hexagonal head cap screw 3/8-16 x 1-3/4	2
P-120	Tapping screw 8-32 x 1/4	1
P-135	Lock washer 5/16	3
P-150	Flat washer 3/8 SAE	2
P-177	Hexagonal head cap screw 5/16-18 x 2	3
P-182	Nut 5/16-18	1
P-184	Drive screw 6 x 5/16	2
P-185	Chain 1044-N	1
P-315	Drive screw 2 x 1/4	2
P-424	Scale 492-6	1
P-427	Shoe 492-3	2
P-433	Handle 6 lobes 3/8-16	2
P-692	Socket head cap screw 5/16-18 x 5/8	6

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REPLACEMENT PARTS

IMPORTANT : Always give part number and description of item when ordering.
Also give serial No.

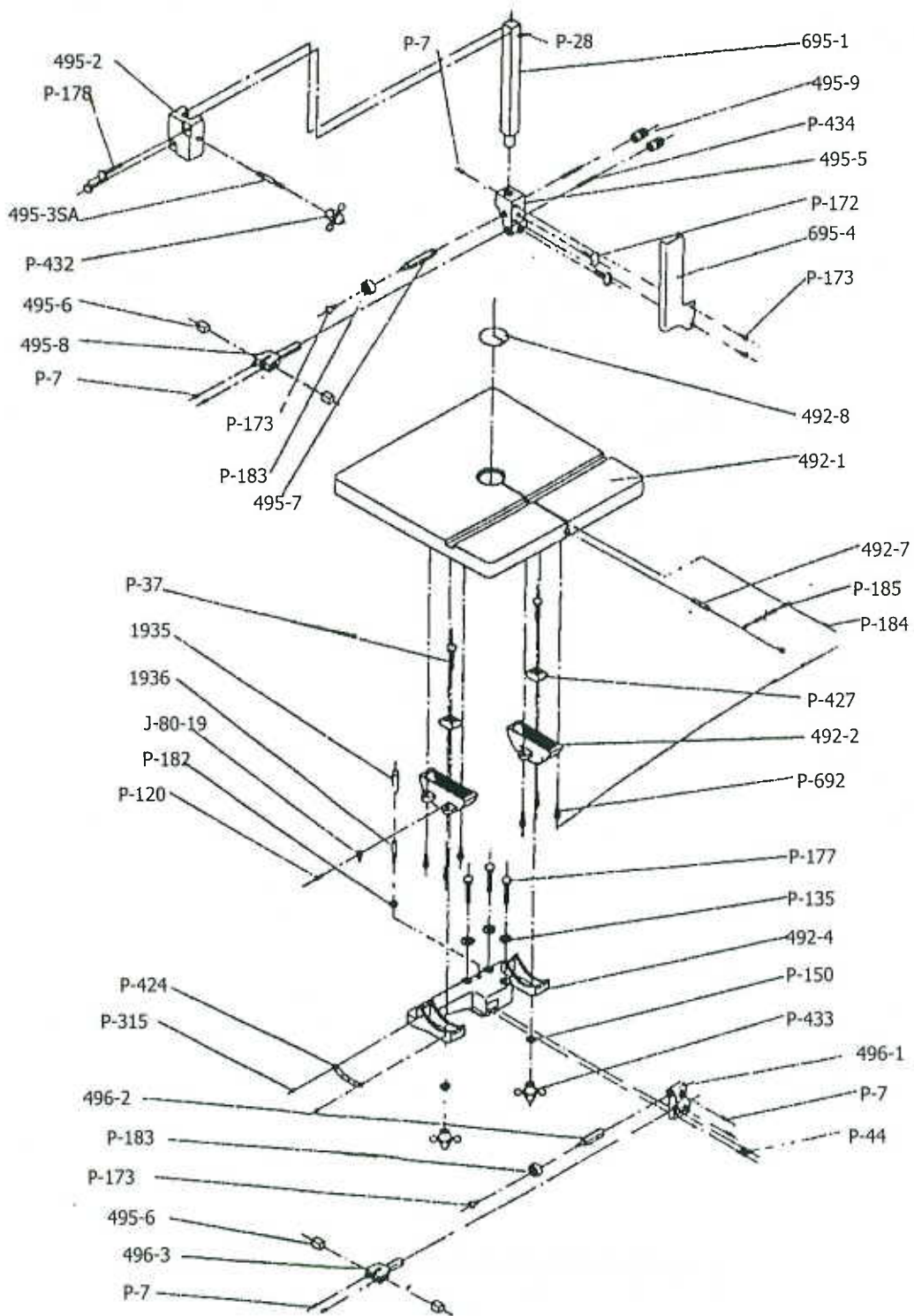
PART NO	DESCRIPTION	QTY
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GUIDE PARTS

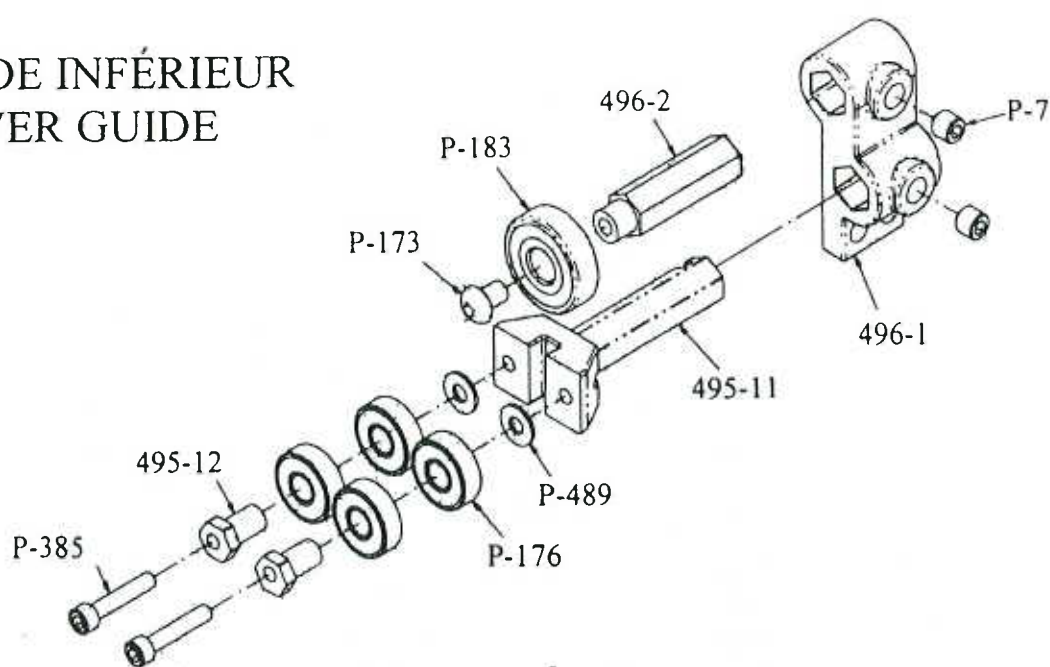
495-2	Guide arm bracket	1
495-3SA	Lock screw assembly	1
495-5	Upper guide bracket	1
495-6	Guide block	4
495-7	Upper guide spindle	1
495-8	Upper block bracket	1
495-9	Lock nut	2
496-1	Lower guide bracket	1
496-2	Lower roll spindle	1
496-3	Lower block bracket	1
695-1	Guide bar	1
695-4	Protector	1
P-7	Socket set screw 5/16-18 x 5/16	6
P-28	Spring pin 3/16 x 1	1
P-44	Socket head cap screw 1/4-20 x 3/4	2
P-172	Thumb screw 5/16-18 x 2	2
P-173	Round head socket machine screw 1/4-20 x 3/8	2
P-178	Hexagonal head cap screw 5/16-18 x 1-3/4	2
P-183	Bearing 6200-ZZ	2
P-434	Socket set screw 5/16-18 x 1-1/2	2

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GUIDE INFÉRIEUR LOWER GUIDE



No pièce	Description	Quantité
496-2	Régleur axial	1
495-11	Régleur radial	1
495-12	Douille d'ajustement	2
496-1	Support du guide inférieur	1
P-7	Vis de réglage à six pans creux 5/16"-18 X 5/16"	1
P-173	Vis mécanique à tête ronde creuse 1/4" -20 X 3/8"	1
P-176	Roulement 608-2RS	4
P-183	Roulement 6200 ZZ	1
P-385	Vis à tête cylindrique à six pans creux 10-32 X 1"	2
P-489	Rondelle plate 3/16"	2

INSTRUCTIONS

Assurez-vous que la scie est débranchée de la source, avant de procéder à l'ajustement des guides.

Toujours laisser l'espacement d'une feuille de papier soit 0.003" ou 0.076mm lors de l'ajustement.

Vous devez débiter l'ajustement par les roulements arrière P-183 des guides supérieur et inférieur. Pour ce faire suivez les instructions ci-dessous;

Pour l'ajustement des roulements P-183 desserrez les vis P-172 (supérieur) et P-7 (inférieur) régler les régleurs axiaux 495-7 de façon à avoir toujours l'épaisseur d'une feuille de papier entre les roulements et la lames, resserrer les vis.

Pour l'ajustement des roulement P-176, desserrez les boulons P-385 et ajusté l'espacement à l'aide de la douille d'ajustement 495-12 avec une clé 7/16", lorsque l'ajustement est terminé resserrer les boulons.

Les roulements ne doivent pas toucher les dents de la lame car celles-ci s'useront plus rapidement, s'il sont trop loin, ils ne supporteront pas suffisamment la lame durant la coupe.

Toujours porter des équipements de sécurité lorsque vous travaillez.

Part No.	Description	Quantity
496-2	Upper guide spindle	1
495-11	Upper block bracket	1
495-12	Adjustment sleeve	2
496-1	Lower guide bracket	1
P-7	Socket set screw 5/16"-18 X 5/16"	1
P-173	Machine screw 1/4" -20 X 3/8"	1
P-176	Bearing 608-2RS	4
P-183	Bearing 6200 ZZ	1
P-385	Socket head cap screw 10-32 X 1"	2
P-489	Flat washer 3/16"	2

INSTRUCTIONS

Be sure to disconnect the saw from the power supply before making any adjustments to the band saw guides.

Always keep the bearing at minimum of 0.003" or 0.076mm from the blade (thickness of a sheet of paper).

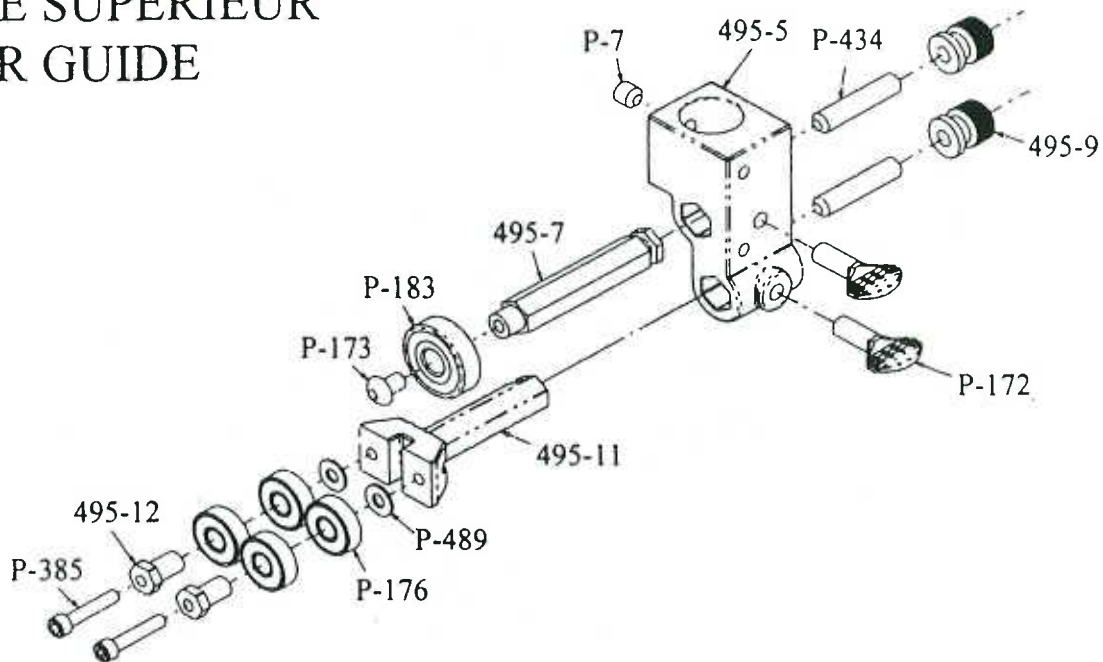
Adjust P-183 bearing by loosening P-172 screws on upper guide and P-7 on lower guide and by moving 495-7 spindle in or out.

To Adjust P-176 bearings, loosen P-385 bolts with a 7/16" wrench, screwing in or out the 495-12 adjustment sleeve. Tighten P-385 bolts back.

Bearing must not touch blade teeth as it will damage it.

Always wear security device when working.

GUIDE SUPÉRIEUR UPPER GUIDE



No pièce	Description	Quantité
495-5	Support du guide du haut	1
495-7	Régleur axial	1
495-9	Bouton de réglage	2
495-11	Régleur radial	1
495-12	Douille d'ajustement	2
P-7	Vis de réglage à six pans creux 5/16"-18 X 5/16"	1
P-172	Vis à clé 5/16"-18 X 3/4"	2
P-173	Vis mécanique à tête ronde creuse 1/4" -20 X 3/8"	1
P-176	Roulement 608-2RS	4
P-183	Roulement 6200 ZZ	1
P-385	Vis à tête cylindrique à six pans creux 10-32 X 1"	2
P-434	Vis de réglage à six pans creux 5/16"-18 X 1 1/2"	2
P-489	Rondelle plate 3/16"	2

Part No.	Description	Quantity
495-5	Upper guide bracket	1
495-7	Upper guide spindle	1
495-9	Adjustment nut	2
495-11	Upper block bracket	1
495-12	Adjustment sleeve	2
P-7	Socket set screw 5/16"-18 X 5/16"	1
P-172	Thumb screw 5/16"-18 X 3/4"	2
P-173	Machine screw 1/4" -20 X 3/8"	1
P-176	Bearing 608-2RS	4
P-183	Bearing 6200 ZZ	1
P-385	Socket head cap screw 10-32 X 1"	2
P-434	Socket set screw 5/16"-18 X 1 1/2"	2
P-489	Flat washer 3/16"	2

CIE GENERAL MFRE LTÉE

835, Cherrier

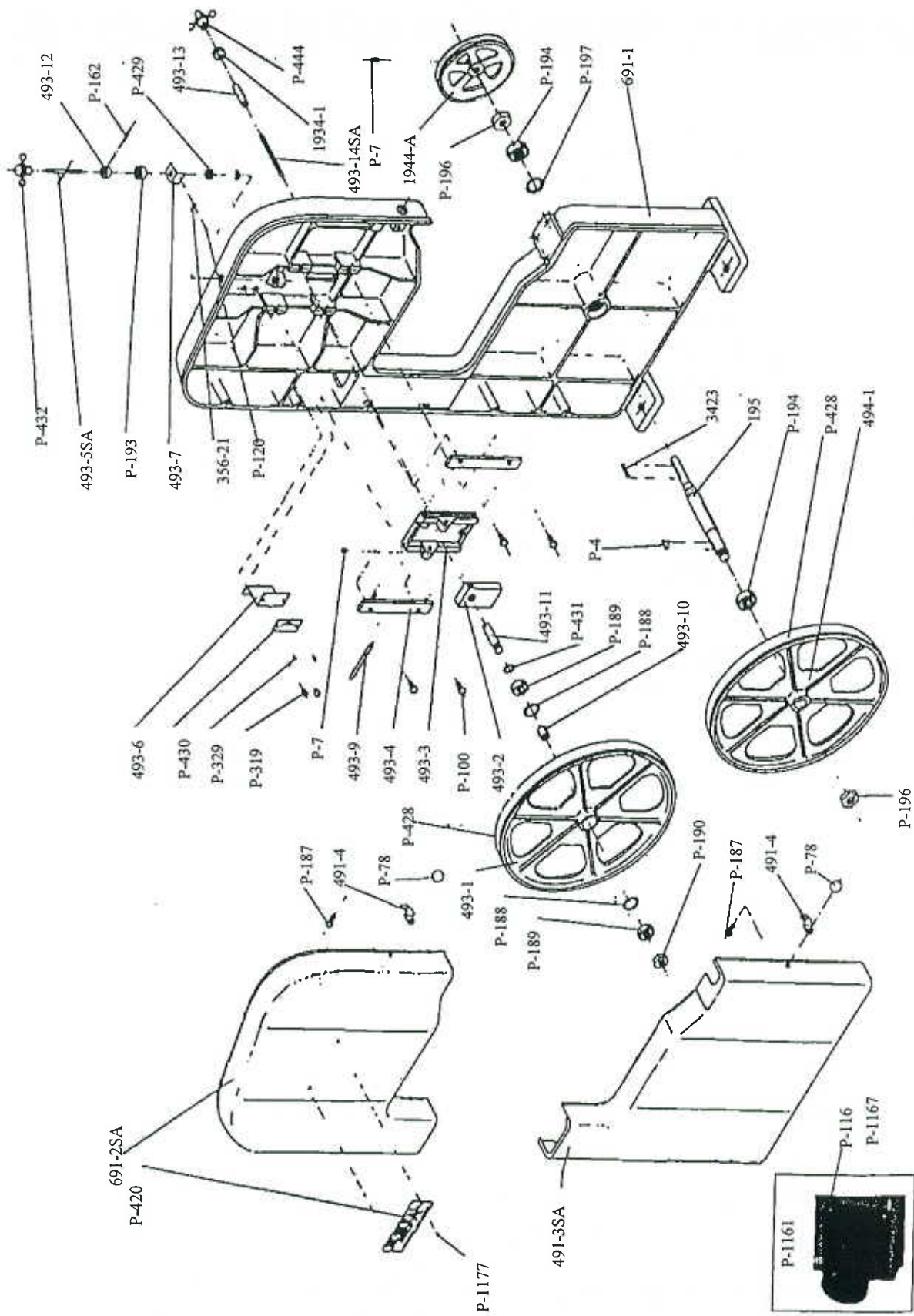
Drummondville, Québec, Canada

Téléphone / Telephone.: (819) 472-1161

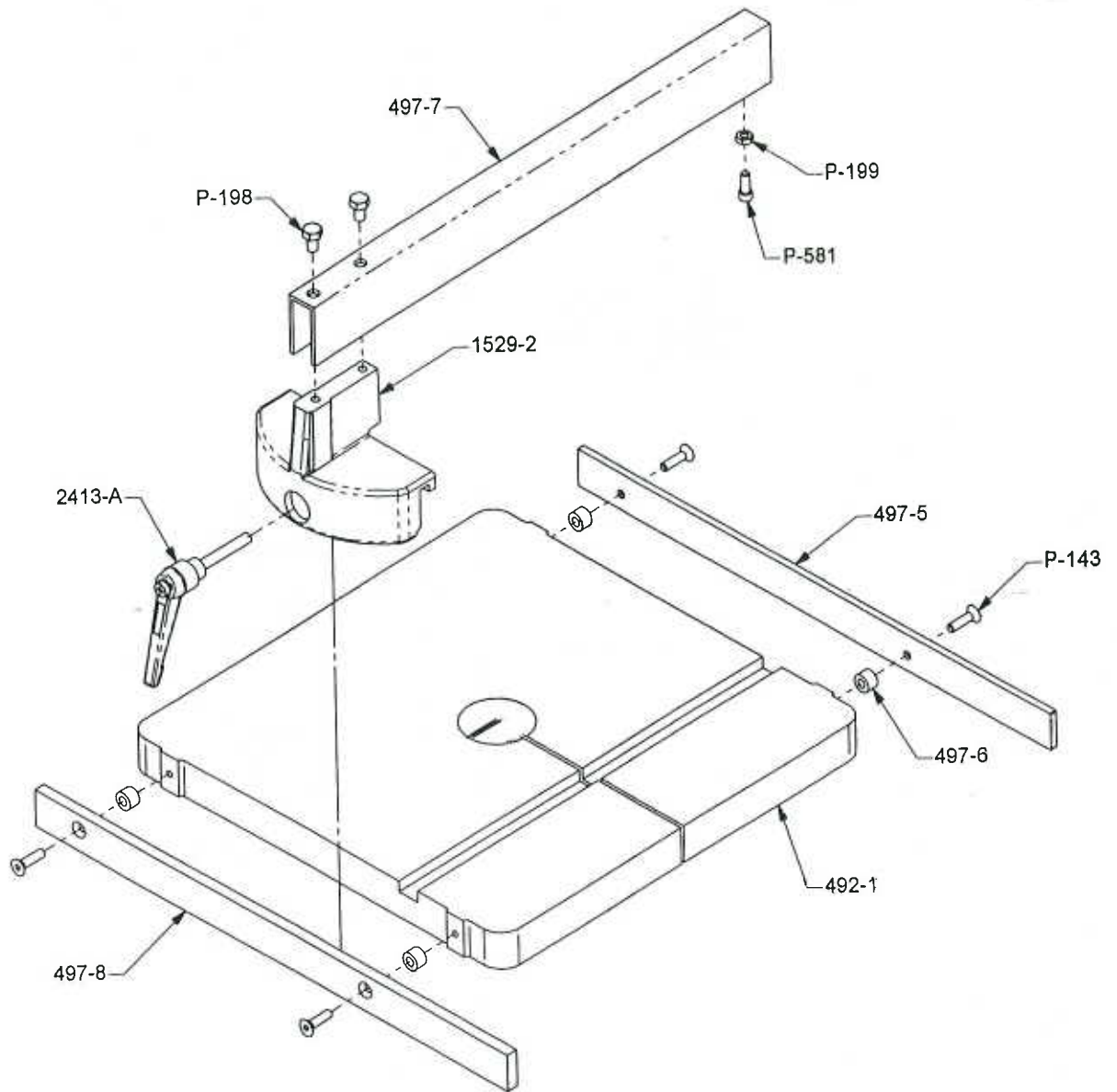
Télécopieur / Fax : (819) 472-3266

Site web: www.general.ca

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GUIDE 497



GUIDE 497

1529-2	Fence support	1
2413-A	Locking handle	1
497-5	Rear guide bar	1
497-6	Spacer	4
497-7	Guide for 497	1
497-8	Front bar	1
P-143	Flat head socket machine screw 1/4-20 x 1	4
P-198	Hexagonal head cap screw 5/16-18 x 1/2	2
P-199	Jam nut 1/4-20	1
P-581	Socket head cap screw 1/4-20 x 5/8	1