

**MODEL M1013  
5" X 6" METAL CUTTING  
BANDSAW**



**OWNER'S MANUAL**  
*(FOR MODELS MANUFACTURED SINCE 6/09)*

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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT**

**THE WRITTEN APPROVAL OF WOODSTOCK INTERNATIONAL, INC.**

#6731CR

Printed in China



## **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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# INTRODUCTION

## Woodstock Technical Support

This machine 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](mailto: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**  
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# MACHINE SPECIFICATIONS



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

## MODEL M1013 5" X 6" METAL CUTTING BANDSAW

### Motor

Type .....	TEFC Capacitor Start Induction
Horsepower .....	1/2 HP
Voltage .....	110/220V
Prewired .....	110V
Phase .....	Single
Amps .....	7/3.5A
Speed .....	1725 RPM
Cycle .....	60 Hz
Number Of Speeds .....	1
Power Transfer .....	V-Belt Drive
Bearings .....	Sealed and Lubricated

### Main Specifications

#### Operation Info

Blade Speeds .....	80, 120, 200 FPM
Blade Length .....	64 1/2"
Head Swivel .....	45°

#### Cutting Capacities

Angle Cuts .....	45° Right, 60° Left
Vise Jaw Depth .....	4 3/8"
Vise Jaw Height .....	2 1/2"
Max. Capacity Rectangular Height @ 90° .....	5"
Max. Capacity Rectangular Width @ 90° .....	6"
Max. Capacity Rectangular Height @ 60° .....	1 3/4"
Max. Capacity Rectangular Width @ 60° .....	2 3/16"
Max. Capacity Rectangular Height @ 45° .....	2 15/16"
Max. Capacity Rectangular Width @ 45° .....	3 3/4"
Max. Capacity Round @ 90° .....	5"
Max. Capacity Round @ 60° .....	1 3/4"
Max. Capacity Round @ 45° .....	3 3/4"

#### Table info

Length .....	12"
Width .....	4 1/2"
Floor To Cutting Area Height .....	29"



### Overall Dimensions

Weight .....	150 lbs.
Length .....	39"
Width .....	23 <sup>3</sup> / <sub>8</sub> "
Height .....	54 <sup>3</sup> / <sub>4</sub> "
Foot Print (Length/Width).....	26 <sup>1</sup> / <sub>2</sub> " x 20 <sup>1</sup> / <sub>2</sub> "

### Construction Materials

Table .....	Precision-Ground Cast Iron
Wheels .....	Machined Cast Iron
Body .....	Cast Iron
Base .....	Formed & Welded Steel w/Coolant Sump
Wheel Cover .....	Formed Steel
Paint .....	Epoxy

### Shipping Dimensions

Weight .....	176 lbs.
Length .....	41"
Width .....	19"
Height .....	22"

### Electrical

Switch .....	Automatic Shut-Off
Switch Voltage .....	110V
Cord Length.....	6 ft.
Cord Gauge .....	18 gauge
Recommended Breaker Size for 110V .....	15A
Recommended Breaker Size for 220V .....	15A
Included Plug Type .....	NEMA 5-15

### Other

Wheel Size .....	13"
Blade Guides.....	Adjustable Carbide
ISO Factory .....	ISO 9001
Country of Origin .....	China
Warranty .....	2 Years
Serial Number Location.....	Machine ID Label on Body Frame
Assembly Time .....	30 Minutes

### Features

Control Panel Conveniently Located  
 Adjustable Hydraulic Downfeed  
 Quick Release Vise for Rapid Workpiece Change-Out  
 Blade Included

# Controls and Features

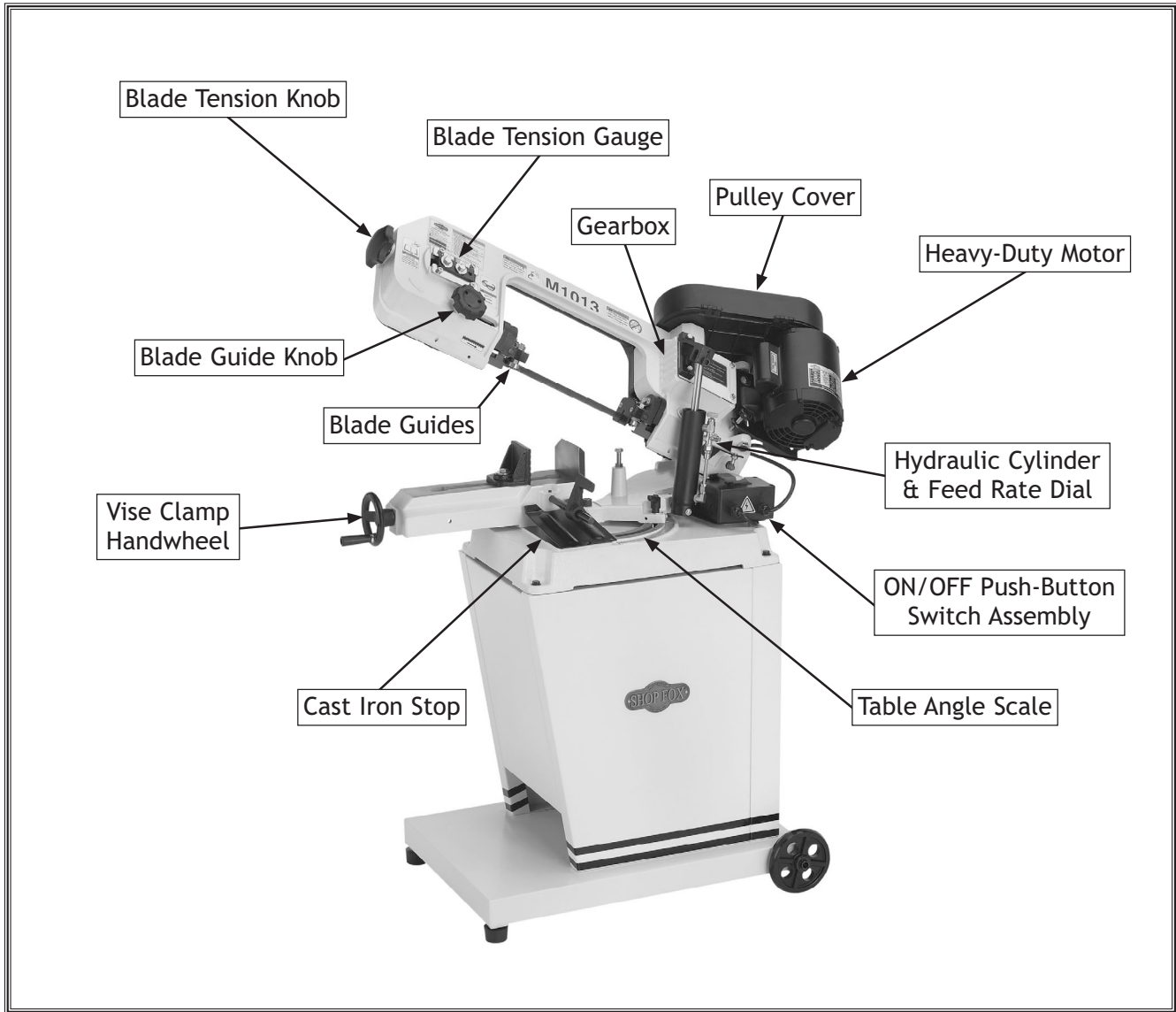


Figure 1. Model M1013.

# 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 A 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 for Metal Cutting Bandsaws



**⚠️ WARNING**  
 READ and understand this entire 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!

**⚠️ CAUTION**  
 USE this and other machinery with caution and respect. Always consider safety first, as it applies to your individual working conditions. No list of safety guidelines can be complete—every shop environment is different. Failure to follow guidelines could result in serious personal injury, damage to equipment or poor work results.

1. **Blade Condition:** Do not operate with a dull, cracked or badly worn blade—they can break during use or greatly decrease cutting performance. Inspect blades for cracks and missing teeth before each use.
2. **Blade Replacement:** Wear gloves to protect hands and safety glasses to protect eyes when replacing the blade. When replacing blades, make sure teeth face forward and down toward the table in the direction of blade travel.
3. **Workpiece Handling:** Your hands can be cut or drawn into the blade during operation if the workpiece moves unexpectedly. Always keep your hands a safe distance away from the moving blade.
4. **Magnesium Fire Hazard:** Use EXTREME CAUTION if cutting magnesium. Using the wrong cutting fluid or overheating material could lead to an extremely hot fire that is difficult to extinguish. Additionally, do not allow magnesium swarf or dust to pile up around the machine and only dispose of the waste using approved methods.
5. **Hot Surfaces:** Be aware that touching hot workpieces or chips after welding, grinding, or cutting can cause burns.
6. **Cutting Fluid Safety:** If cutting fluid is used for operations, only use the minimum amount necessary, and promptly clean it from the machine and work area after use. Cutting fluid is associated with skin disease, lung damage, and cancer. Avoid breathing, ingesting, or touching cutting fluid and always wear approved personal protective equipment when using or cleaning it. Always follow the manufacturer's recommendation to ensure safe and appropriate use.
7. **Entanglement Hazards:** Always keep the blade guard correctly positioned and wheel doors closed and secured when bandsaw is in operation. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.
8. **Unstable Workpieces:** Workpieces that cannot be supported or stabilized without a vise or jig should not be cut on a vertical metal-cutting bandsaw, because they can unexpectedly move while cutting and draw the operator's hands into the blade causing serious personal injury. Examples are chains, cables, round or oblong-shaped workpieces, workpieces with internal or built-in moving or rotations parts, etc.
9. **Clearing Chips:** Metal chips can easily cut skin—even through a piece of cloth. Avoid clearing chips by hand or with a rag. Use a brush or vacuum to clear metal chips.

# ELECTRICAL

ELECTRICAL

## **⚠ WARNING**

The machine must be properly set up before it is safe to operate. **DO NOT** connect this machine to the power source until instructed to do so in the "Test Run" portion of this manual.

## 110V/220V Operation

The Model M1013 is prewired for 110V operation. For 220V operation, the motor must be re-wired as directed by the wiring diagram on the inside of the motor junction box cover. If this diagram is not available, use the wiring diagram on **Page 31**.

The power supply circuit used for this machine **MUST** be grounded and rated for the amperage given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes.

This machine must be grounded! The cord supplied with this machine comes with a grounding wire. If your outlet does not accommodate a ground pin, have it replaced by a qualified electrician.

If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire or circuit overload hazard—consult a qualified electrician to reduce this risk.

## Extension Cords

We do not recommend using an extension cord; however, if you have no alternative, use the following guidelines:

- Use a cord rated for Standard Service (S).
- Do not use an extension cord longer than 50 feet.
- Ensure that the cord has a ground wire and pin.
- Use the gauge size listed below as a minimum.

## Electrical Specifications

Operating Voltage	Amp Draw	Min. Circuit Size	Recommended Plug	Extension Cord
110V Operation	7 Amps	15A	NEMA 5-15 (incl.)	14 Gauge
220V Operation	3.5 Amps	15A	NEMA 6-15 (not incl.)	16 Gauge

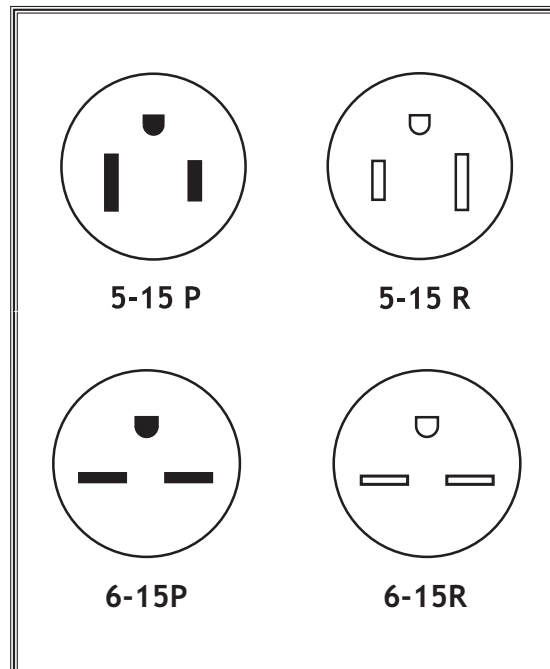


Figure 2. NEMA 5-15 and 6-15 plugs and receptacles.

## **⚠ WARNING**



**DO NOT** work on your electrical system if you are unsure about electrical codes and wiring! Seek assistance from a qualified electrician. Ignoring this warning can cause electrocution, fire, or machine damage.

# SETUP

## Unpacking

This machine has been carefully packaged for safe transportation. If you notice the machine has been damaged during shipping, please contact your authorized Shop Fox dealer immediately.

## Inventory

The following is a description of the main components shipped with the Model M1013. Lay the components out to inventory them.

**Note:** If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for safer shipping.

J. Belt Cover .....	1
K. Work Stop.....	1
L. Work Stop Shaft.....	1
M. Wheels .....	2

### Assembly Hardware (Not Shown):

–Hex Wrench 4mm .....	1
–Hex Bolt M8-1.25 x 30.....	4
–Flat Washer 17mm (Wheels) .....	4
–Flat Washer 8mm .....	4
–Cotter Pin 1/8" x 1" (Wheels) .....	2
–Hex Nut M8-1.25 (Feet).....	2
–Phillips Head Screw M6-1 x 12.....	16
–Flat Washer 6mm .....	16
–Hex Bolt 1/4"-20 x 1/2" .....	2
–Flat Washer 1/4" .....	2

SETUP

Inventory (Figure 3)	Qty
A. Base.....	1
B. Front Panel .....	1
C. Rear Panel .....	1
D. Right Panel .....	1
E. Left Panel.....	1
F. Chip Tray.....	1
G. Feet.....	4
H. Axle.....	1
I. V-Belt.....	1

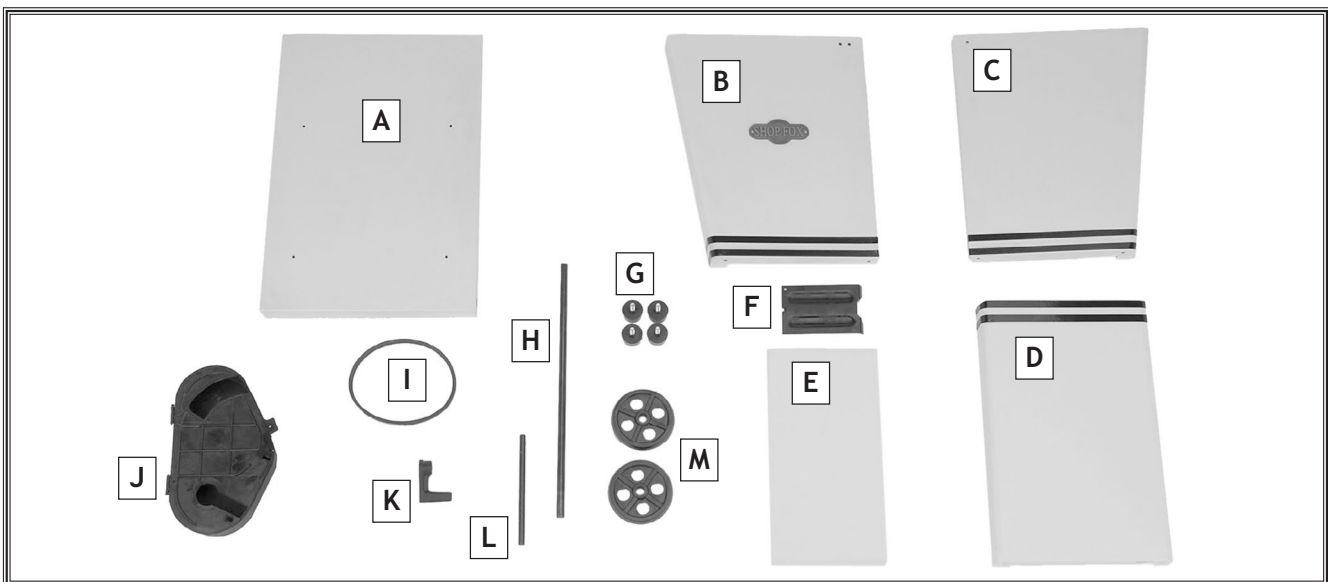
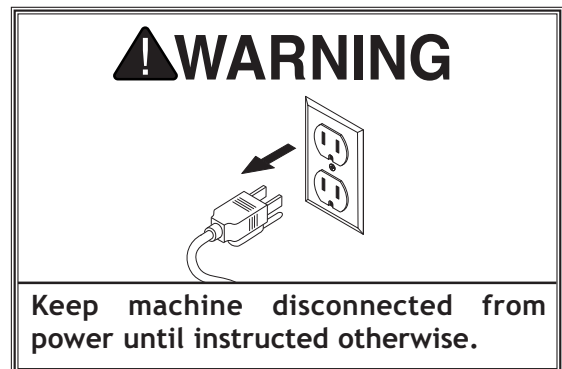


Figure 3. Model M1013 inventory.

## 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 Machine Type.
- **Lighting:** Lighting should be bright enough to eliminate shadow and prevent eye strain.
- **Electrical:** Electrical circuits must be dedicated or large enough to handle amperage requirements. Outlets must be located near each machine, so power or extension cords are clear of high-traffic areas. Follow local electrical codes for proper installation of new lighting, outlets, or circuits.

## Cleaning Machine

The table and other unpainted parts of your metal cutting 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.

	<p><b>⚠ WARNING</b>                  NEVER clean with gasoline or other petroleum-based solvents. 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!</p>
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SETUP

	<p><b>⚠ WARNING</b>                  USE helpers or power lifting equipment to lift this Machine Name. Otherwise, serious personal injury may occur.</p>
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	<p><b>⚠ CAUTION</b>                  MAKE your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. NEVER allow untrained visitors in your shop when assembling, adjusting or operating equipment.</p>
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	<p><b>⚠ CAUTION</b>                  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.</p>

# Wheels, Feet, and Cabinet

This bandsaw is shipped with four rubber feet with posts and two wheels with an axle. It is your option to install four rubber feet if you do not need to move the bandsaw, or install the axle and wheels if you need to move the bandsaw regularly.

To install the wheels, feet, and the cabinet, do these steps:

1. At the end of the base with the axle holes, insert the axle into the base (see **Figure 4**).
2. Slide a 17mm flat washer and wheel onto each end of the axle, followed by another 17mm flat washer and cotter pin.
3. Thread a 3/8-16 hex nut on both rubber feet.
4. Thread rubber feet into the base (see **Figure 4**).
5. Position the base on the floor, and adjust the feet until the base is level and stable.
6. Tighten the hex nuts against the base to lock the feet in position.
7. Position the front and rear panels on the base and install the panels to the base with four M6-1 x 12 Phillips head screws and 6mm flat washers, as shown in **Figure 5**.
8. Position the left panel between the front and rear panels, and secure it in place with six M6-1 x 12 Phillips head screws and 6mm flat washers, as shown in **Figure 6**.



**Figure 4.** Installing wheels and feet.



**Figure 5.** Front and rear panels installed.



**Figure 6.** Left panel installed.

9. Position the right panel between the front and rear panel, and secure it in place with six M6-1 x 12 Phillips head screws and 6mm flat washers, as shown in Figure 7.


	<p><b>⚠ WARNING</b> The Model M1013 is heavy! To avoid personal injury, get help to lift this machine.</p>
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Figure 7. Installing right panel.

10. With the help of an assistant or a hoisting device, place the bandsaw onto the cabinet.
11. Secure the bandsaw to the cabinet with four M8-1.25 x 30 hex bolts and 8mm flat washers, as shown in Figure 8.

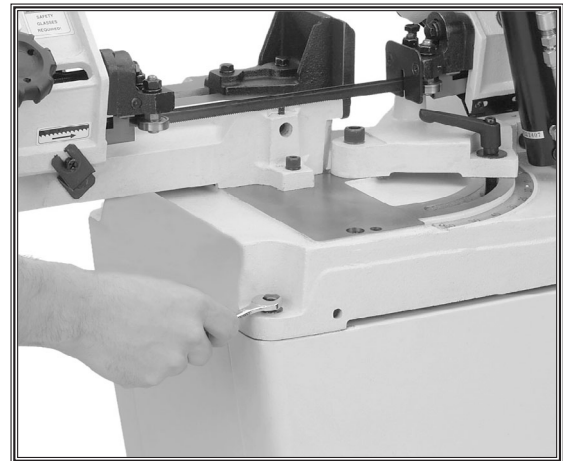


Figure 8. Installing bandsaw to cabinet.

SETUP

# Shipping Strap Removal & Stop Adjustment

To ensure that your bandsaw arrives without damage to the hinge system, a shipping strap was installed. After removing the shipping strap, you will have to make a series of adjustments, beginning with the feed stop bolt.

To remove the shipping strap and adjust the feed stop bolt, do these steps:

1. Remove the shipping strap hex bolt and strap with a 12mm wrench, as shown in **Figure 9**.

**Note:** *Keep this shipping strap in the event that you must transport or ship the bandsaw.*

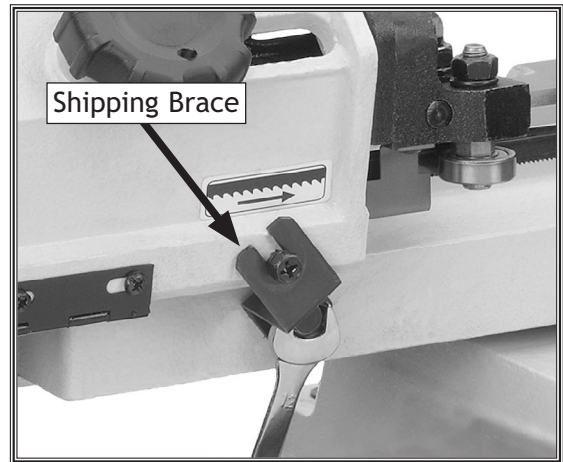
2. Adjust the feed stop bolt and jam nut with a 14mm wrench (**Figure 10**), so the bandsaw blade teeth are just below the table surface when the cut is complete.

## Squaring Vise to Blade

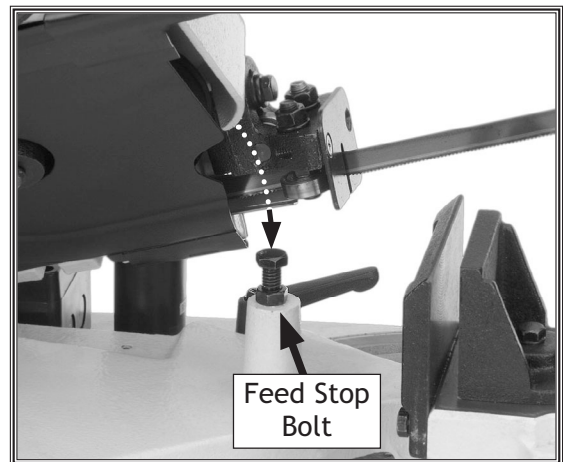
To ensure that your bandsaw will make cuts that match the degree scale, you must make sure to square the vise to the blade.

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

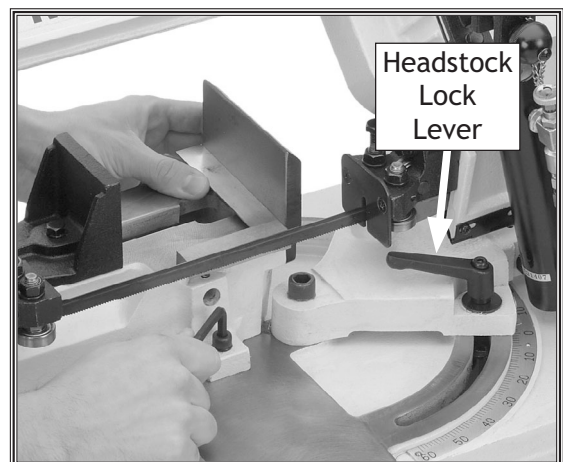
1. Rotate the headstock until the pointer reads "0" on the tabletop scale, and tighten the headstock lock lever so the headstock stays indexed at zero.
2. Using a 6mm wrench, loosen the two cap screws that hold the vise to the table, as shown in **Figure 11**.
3. Using a small machinists square, adjust the vise so it is square to the blade.
4. Tighten the two cap screws, so the vise and blade are square with one another.



**Figure 9.** Removing shipping strap.



**Figure 10.** Feed stop bolt.



**Figure 11.** Squaring vise to blade, headstock, and table scale.

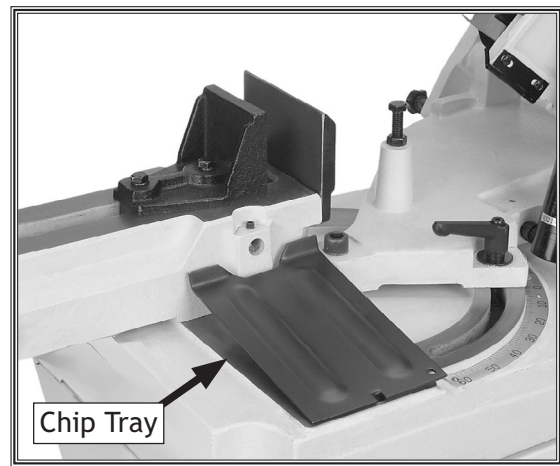


## Chip Tray & Cast Iron Stop

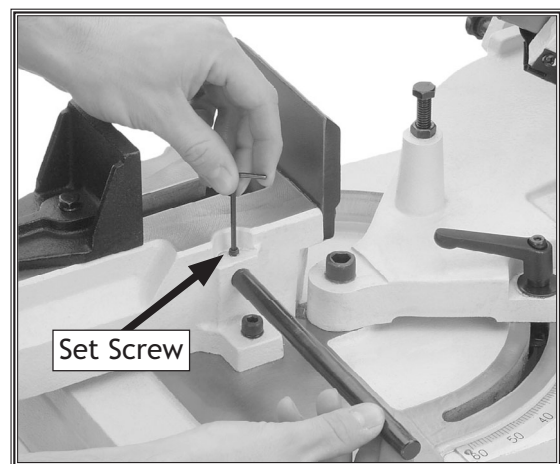
The chip tray directs small workpieces into a bucket when the cut is complete. The cast iron stop allows you to repeat cuts at the same length.

To install the chip tray and cast iron stop, do these steps:

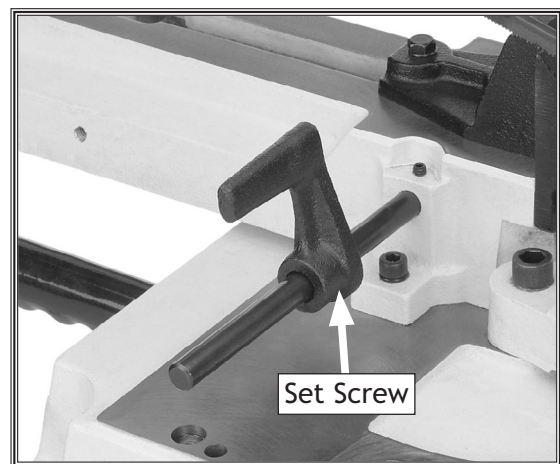
1. Position the chip tray, as shown in **Figure 12**.
2. Insert the stop rod approximately  $\frac{3}{4}$ " into the saw until the end of the rod is just flush with the inside casting surface, as shown in **Figure 13**.
3. Use a 4mm hex wrench to tighten the set screw shown in **Figure 13**.
4. Slide the cast iron stop onto the stop rod and tighten the set screw in the side of the stop, as shown in **Figure 14**.



**Figure 12.** Chip tray installed.



**Figure 13.** Installing stop rod.



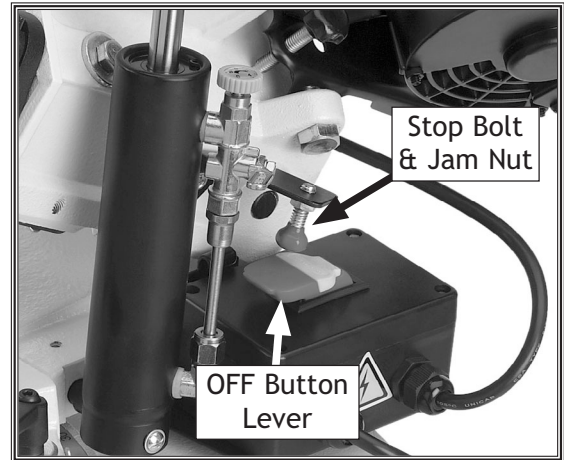
**Figure 14.** Cast iron stop installed.

## Automatic OFF Adjustment

After you have removed the shipping strap and have adjusted the headstock stop bolt, you must adjust the OFF button lever stop bolt, so the bandsaw shuts OFF automatically when a cut is complete.

To set the adjust the OFF button, do these steps:

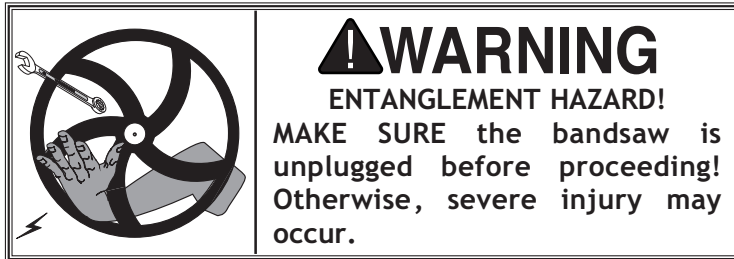
1. With the headstock in the complete down position, loosen the 12mm stop bolt and jam nut shown in **Figure 15**.
2. Push down on the OFF button lever so the button is completely depressed.
3. While keeping the lever depressed, use your fingertips to turn the stop bolt until the head just touches the lever.
4. Back off the stop bolt  $\frac{1}{3}$  turn and tighten the jam nut.



**Figure 15.** Automatic OFF components.

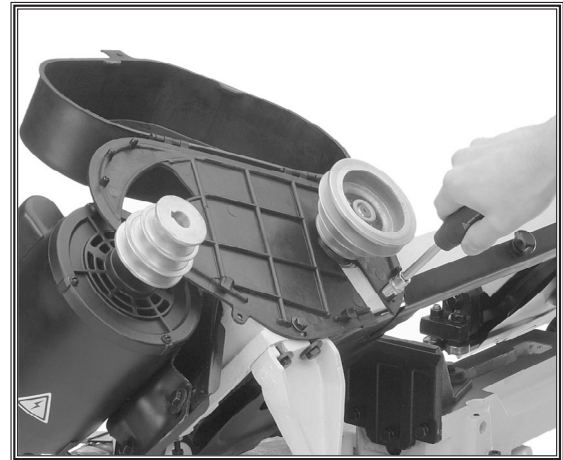
## Pulley Cover

When opened, the pulley cover gives you access to change the pulley ratio so the bandsaw can cut at one of three speeds.

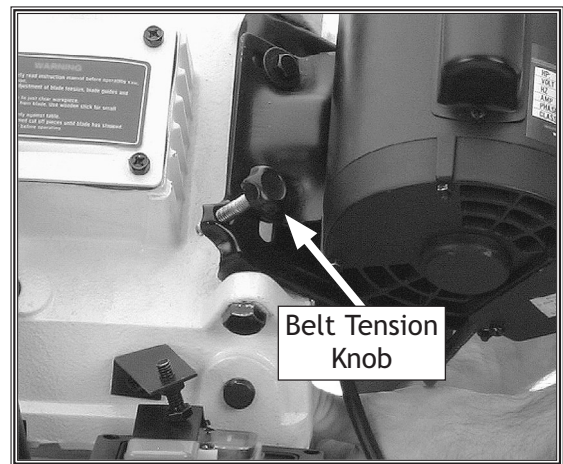


To install the pulley cover, do these steps:

1. Position and rotate the pulley cover into place, as shown in **Figure 16**.
2. Install the two  $\frac{1}{4}$ -20 x  $\frac{1}{2}$ " hex bolts and washers to secure the pulley cover.
3. Loosen the belt tension knob enough to install the belt on the appropriate pulley that will give the required blade speed. Refer to **Blade Speed** on **Page 23** for blade speed selections.
4. Adjust the belt tension knob (**Figure 17**), so the belt has approximately  $\frac{1}{4}$ " deflection when pressed in between the pulleys, then close and secure the cover.



**Figure 16.** Positioning the pulley cover.



**Figure 17.** Belt tension knob.

# Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting.

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.

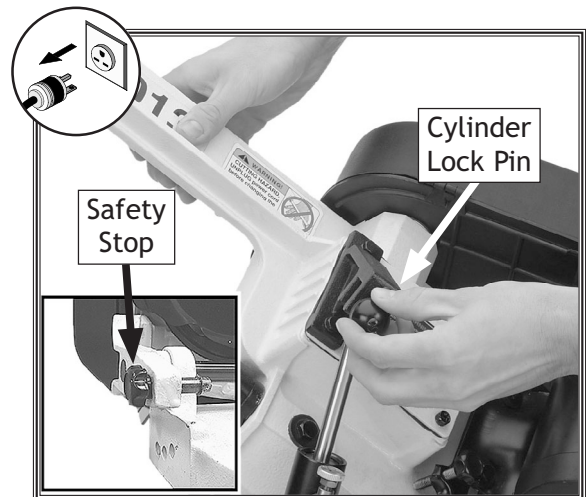


Figure 18. Raising and locking headstock.

To set the blade tension, do these steps:

1. Make sure the blade is tracking properly (refer to **Blade Tracking** on **Page 29** for detailed instructions).
2. Remove the cylinder lock pin, raise the headstock to the full vertical position, and push the safety stop inward to lock the headstock in the vertical position (see **Figure 18**).
3. Open the blade cover, as shown in **Figure 19**, slide the blade guides as far apart as possible, then secure them in place
4. Turn the blade tension knob until the blade is snug, and the blade tension scale indicates "medium" (see **Figure 20**).
5. Adjust the blade guides as instructed in the next subsection
6. Close and secure the blade guard.

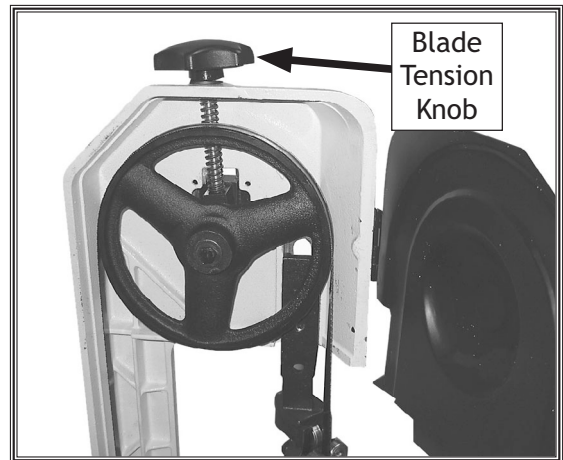


Figure 19. Blade tension adjustment knob.

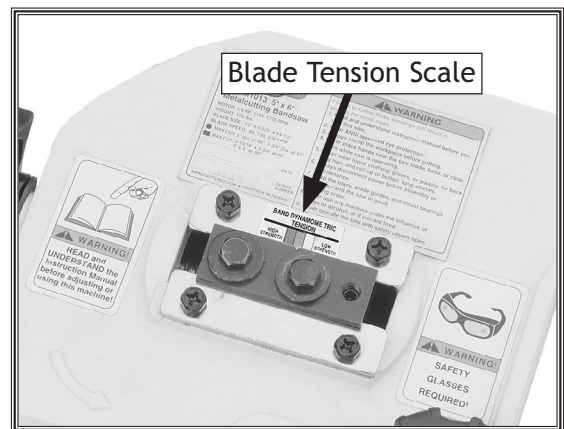


Figure 20. Typical blade tension scale.

## Blade Guides

The blade guide side bearings support and twist the blade straight so the blade will enter the workpiece perpendicular to the table surface (see Figure 21). The blade guide support bearings prevent blade twist by stopping the blade from being pushed back during a cut. Both adjustments are critical for correct saw operation.

Note: Make sure the blade is tensioned and tracks correctly before you adjust the blade guide bearings. Refer to Blade Tension on the previous page and Blade Tracking on Page 29 for detailed instructions.

To adjust the guide bearings, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Let the bandsaw headstock park in the full down position.
3. Use a 12mm wrench to loosen the lower guide bearing adjustment hex bolt shown in Figure 22.
4. Adjust the blade guide housing so the support bearing rests against the rear of the blade, as illustrated in Figure 21.
5. Tighten the adjustment hex bolt.
6. Use a 14mm wrench to loosen the outer side bearing eccentric jam nuts of the upper guide bearing.

Note: The inner side bearing are not on eccentric shafts and cannot be adjusted.

7. Use a 12mm wrench to rotate the side bearing eccentrics until the bearings hold the blade perpendicular to the table surface, and have a bearing-to-blade clearance of 0.000"–0.001". The bearings must not pinch the blade.

Note: To make sure the blade is perpendicular to the table, use a standard machinist's square.

8. Tighten the jam nuts, loosen the lock knob, and slide the blade guide close to the workpiece so the blade is supported and will not twist during the cut (see Figure 23).

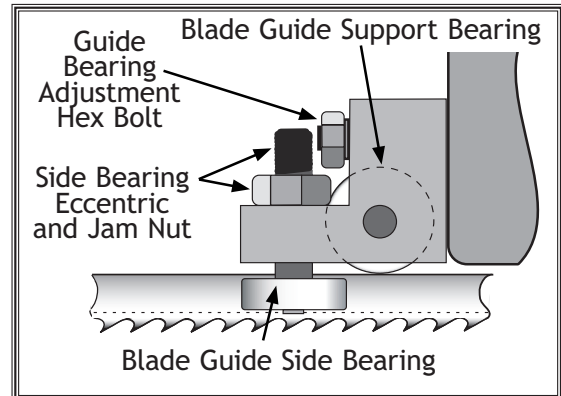


Figure 21. Blade guide adjustment locations.

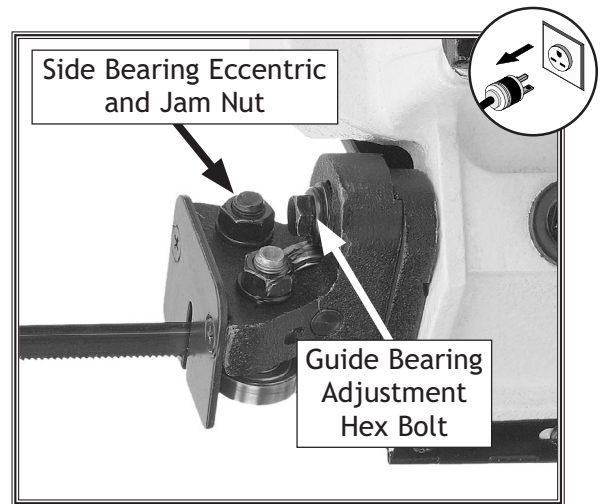


Figure 22. Blade guide adjustments.

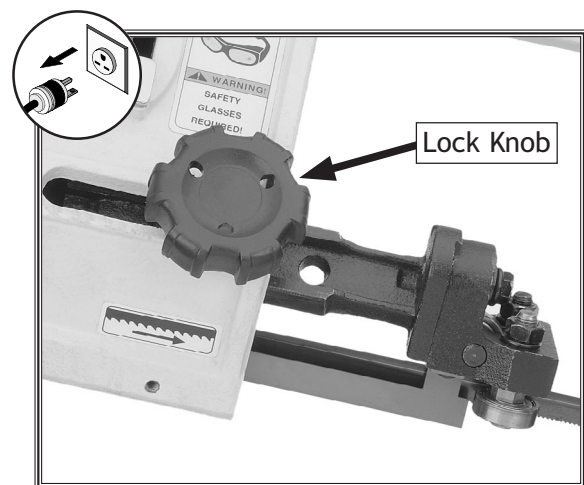


Figure 23. Blade guide position lock knob.

## Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 32**.

If you still cannot remedy a problem, contact our Tech Support at (360) 734-3482 for assistance.

To test run the machine, do these steps:

1. Make sure you understand the safety instructions at the beginning of the manual, and verify that the machine is setup properly.
2. Ensure all tools and objects used during set up are cleared away from the machine.
3. Connect the machine to the power source.
4. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run. The bandsaw should run smoothly with little or no vibration.
  - Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.
5. Turn the machine **OFF**.

### WARNING



Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses to reduce the risk of injury.

### 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.

# OPERATIONS

## General

This machine 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 or trade articles, or seek training from an experienced *Machine Type* operator before performing any unfamiliar operations. **Above all, your safety should come first!**

## Operation

Before making cuts to the workpiece, it is important that all safety precautions and bandsaw adjustments are addressed.

For basic cutting operations, do these steps:

1. Select and install the required blade (refer to **Blade Selection on Page 24**).
2. Select the required cutting speed (refer to **Blade Speed on Page 23**).
3. Raise and lock the headstock, so the blade is approximately 3" from the workpiece, and open the vise to accept the workpiece.

Note: NEVER let the saw blade rest on the workpiece without the saw running. Otherwise, you will permanently damage the saw blade!

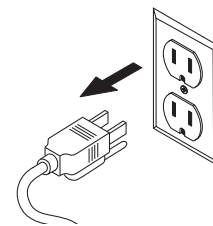
4. Insert the workpiece into the vise, so the blade will contact the flattest part of the workpiece first, and clamp the workpiece in the vise.

### ⚠ 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!**

### ⚠ WARNING



**DO NOT investigate problems or adjust the machine while it is running. Wait until the machine is turned OFF, unplugged and all working parts have come to a complete stop before proceeding!**

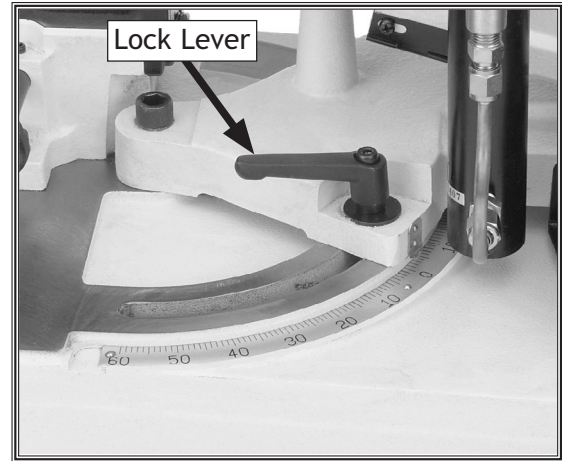
### ⚠ WARNING



**Always wear safety glasses when operating this machine. Failure to comply may result in serious personal injury.**

5. Adjust the cast iron stop for duplicate cuts and install the ejector chute if required.
6. Loosen the headstock lock lever (**Figure 24**), and swivel the headstock to the needed angle of cut, and lock the lever in place.
7. Set the blade guide so the guides hold the blade close to the workpiece, and the blade will not twist with a cutting load (refer to **Blade Guides** on **Page 19** for detailed instructions).
8. Open the feed ON/OFF valve and turn the feed rate knob so the feed rate is correct, based on your observations of the blade chip characteristics. Refer to **Feed Rate** on **Page 25** for detailed instructions.

Note: When the cut is complete, the ON/OFF switch push lever will shut **OFF** the bandsaw.



**Figure 24.** Headstock swivel system.



# Blade Speed

The Model M1013 has these three blade speeds: 80, 120, and 200 FPM.

To change blade speeds, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Determine the best speed for your cut. The table in **Figure 25** is provided as a basic guideline. Material thickness and the type of blade used will factor into FPM selection.
3. Slacken the V-belt (refer to the **Pulley Cover** subsection on **Page 17** for detailed instructions).
4. Position the V-belt on the pulleys for the desired FPM (feet per minute), as illustrated in **Figure 25**.
5. Correctly tension the V-belt, then close and secure the pulley cover before beginning operation.

**Note:** These suggested blade speeds are an average for both High Carbon Blades and Bimetal Blades. Refer to your saw blade manufacturer for exact speeds.

Workpiece Material	Speed in FPM
Tool Steel	90
Stainless Steel	90
Alloy Steel	90
Bearing Bronze	90
High Carbon Steel	135
Medium Carbon Steel	135, 195
Hard Brass	195
Hard Bronze	195
Low Carbon Steel	195
Soft Brass	195
Copper	255
Aluminum	255
Plastics	255

**Note:** FPM = Feet Per Minute.

Speed at 60Hz	Wheel Pulley	Motor Pulley
80 FPM		
120 FPM		
200 FPM		

**Figure 25.** Blade cutting speed chart.

# Blade Selection

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 bimetal blades/HSS blades. However, for exact specifications of bandsaw blades, contact the blade manufacturer.

Here are some general rules of thumb with respect to bandsaw blade use.

- At least three teeth must contact the metal at any phase of the cut. Otherwise, the teeth can load up with metal, fracture, and break off. If the TPI is too high, the teeth can load up with material and overheat, damaging the blade.
- For a faster but rougher cut, use a blade with a lower TPI and a higher feed rate.
- For a slower but smoother cut, use a blade with more TPI and a lower feed rate.

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 Thickness" row of the blade selection chart in **Figure 26**, and read across to find the workpiece thickness you need to cut.
3. Refer to the "Shape" of metal and "Material Type" columns, 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, and the TPI for bimetal raker blades in parentheses.

OPERATIONS

TOOTH SELECTION																				
mm	50	75	100	150	200	250	300	350	400	450										
	5/8		4/6		3/4				2/3											
	4/6	3/4			2/3		1.4/2.5						1.5/.8							
	3/4			2/3		1.4/2.5						1.5/.8								
inch	2	2½	3	3½	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19

CUTTING SPEED RATE RECOMMENDATION							
Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)
Carbon Steel	196-354 (60) (108)	Tool Steel	203 (62)	Alloy Steel	111-321 (34) (98)	Free Machining Stainless Steel	150-203 (46) (62)
Angle Steel	180-220 (54) (67)	High-Speed Tool Steel	75-118 (25) (36)	Mold Steel	246 (75)	Gray Cast Iron	108-225 (33) (75)
Thin Tube	180-220 (54) (67)	Cold-Work Tool Steel	95-213 (29) (65)	Water Hardened Tool Steel	242 (75)	Ductile Austenitic Cast Iron	65-85 (20) (26)
Aluminum Alloy	220-534 (67) (163)	Hot-Work Tool Steel	203 (62)	Stainless Steel	85 (26)	Malleable Cast Iron	321 (98)
Copper Alloy	229-482 (70) (147)	Oil-Hardened Tool Steel	203-213 (62) (65)	CR Stainless Steel	85-203 (26) (62)	Plastics	220 (67)

Figure 26. Blade selection chart.

## Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by blade type and feed rate.

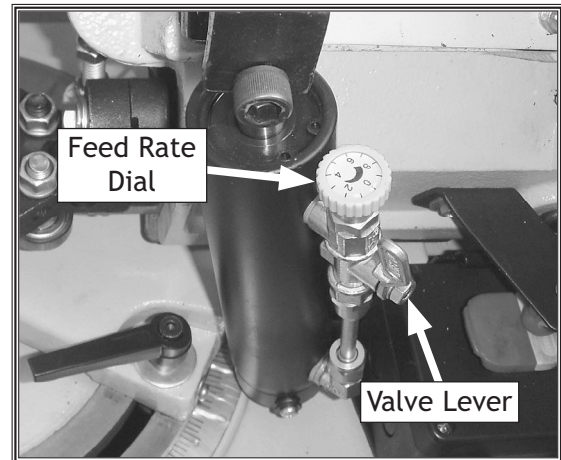
The feed rate is controlled by the valve lever and feed rate dial on the hydraulic cylinder shown in **Figure 27**.

Turning the valve lever in-line with the piping, as shown in the **Figure 28**, opens it up, which allows the fluid to circulate and allows the head to move. Turning the valve lever sideways or perpendicular to the piping closes it, which locks the headstock in place.

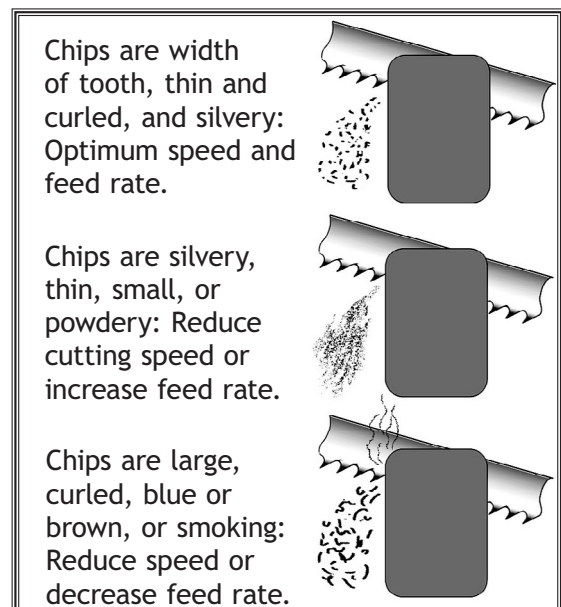
The feed rate dial controls the amount of fluid that circulates around the hydraulic cylinder, which in turn, controls the speed that it moves.

### To set the feed rate, do these steps:

1. Raise the headstock and turn the valve lever sideways (horizontally).
2. Clamp the workpiece in the table vise.
3. Move the headstock and blade a few inches above the workpiece.
4. With the correct saw blade installed and blade speed selected, turn the saw ON.
5. Slowly rotate the feed rate dial to a conservative feed rate until the saw begins to cut the workpiece.
6. Observe the chips that exit the cut, and increase or decrease the feed rate according to the chip characteristics (see **Figure 28**).



**Figure 27.** Feed rate dial and lever.



**Figure 28.** Reading chip characteristics.

# MAINTENANCE

## General

Regular periodic maintenance on your machine 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.
- Missing or leaking rubber toggle switch boots.
- Worn or damaged cords, switches, or plugs.
- Damaged V-belt.
- Any other condition that could hamper the safe operation of this machine.

## Cleaning

Keeping metal chips away from bandsaw mechanisms is important to ensure that your bandsaw lasts a long time. Use a shop vacuum or brush-off metal chips frequently.

## Lubrication

The gearbox and all bearings are sealed and permanently lubricated and no scheduled lubrication is needed. However, you must periodically lubricate adjustment locations and bare metal surfaces. Refer to **Figures 29–30** for lubrication points.

Lubricate the following areas listed below:

- Blade Tension Mechanism:** Open the main blade guard, and drop a few drops of oil on the tension knob lead screw.
- Blade and Guides:** Drop a few drops of light machine oil on the blade and the blade guides daily.
- Gear Box:** Is packed with grease and should only be changed if you suspect contamination.
- Table and Machined Surfaces:** Keep bare metal surfaces 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:** Drop a few drops of light machine oil on the vise lead screw weekly.

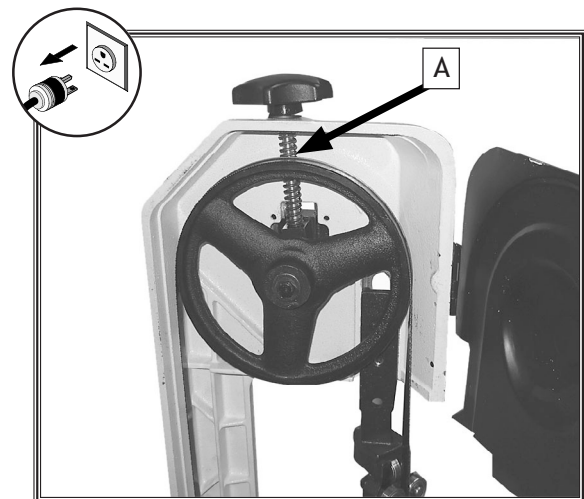
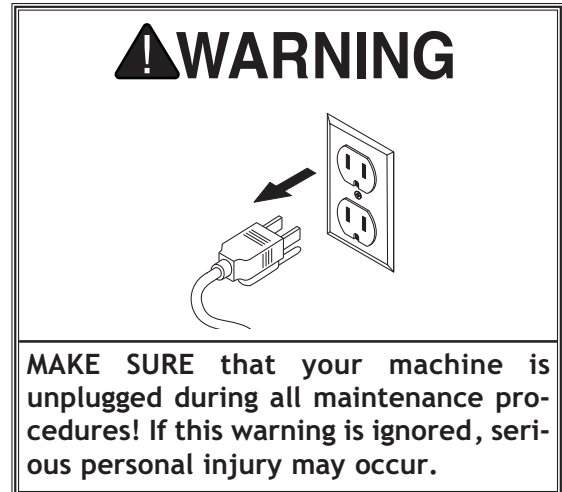


Figure 29. Lubrication points.

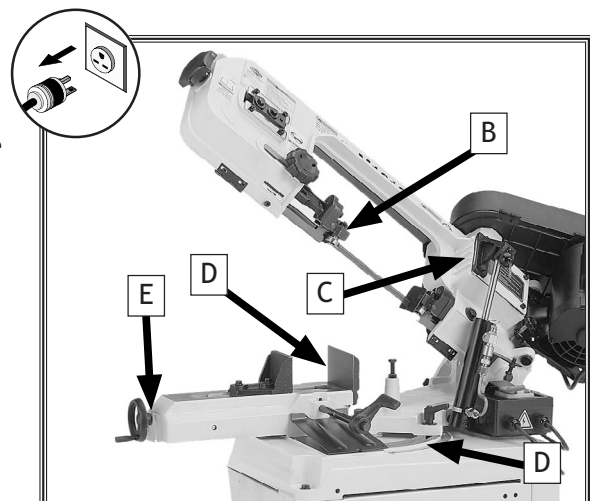


Figure 30. Lubrication points.

# SERVICE

## General

This section covers the most common service adjustments or procedures that may need to be made during the life of your machine.

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](mailto:tech-support@shopfox.biz).

## Blade Change

Change the blade when it becomes dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

To change the bandsaw blade, do these steps:

1. DISCONNECT BANDSAW FROM POWER!
2. Hold the headstock, un-attach the feed cylinder by removing the cap screw, then raise the headstock to the full vertical position (see **Figure 31**).
3. Push the safety stop in, use a screwdriver to remove the upper and lower blade guide guards, and loosen the blade guides (see **Figure 32**).

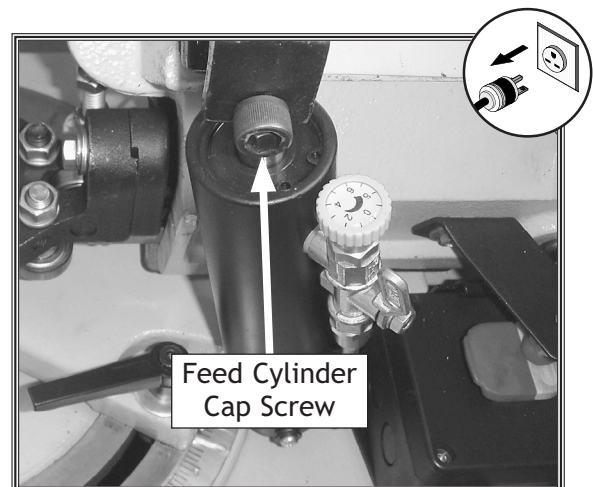
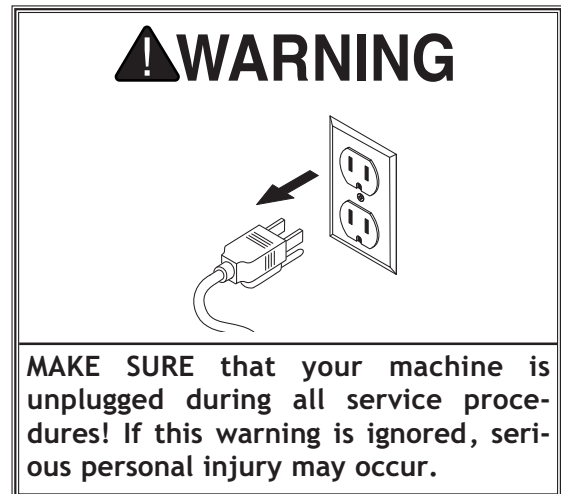


Figure 31. Feed cylinder cap screw.

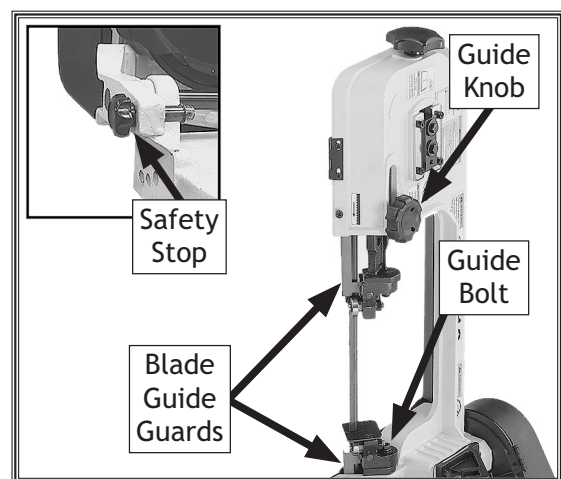


Figure 32. Blade guide guards and fasteners.

4. Loosen the tension knob and slip the blade off of the wheels.
5. Install the new blade through both blade guide bearings and around the bottom wheel (see the example in **Figure 33**).
6. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

7. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels.
8. Tighten the tension knob as tight as necessary so the blade will not slip on the wheels during start up.
9. Spin the wheel by hand until the blade resumes the previous tracking.
  - If the tracking needs to be adjusted, complete the instructions in the **Blade Tracking** procedure in the next section.
10. Properly adjust the blade tension (**Page 18**) and the guide bearings (**Page 19**).



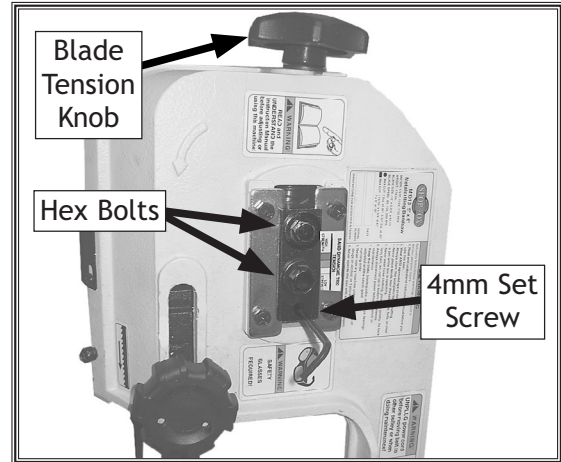
**Figure 33.** Typical blade installation.

## Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

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

1. DISCONNECT BANDSAW FROM POWER!
2. Raise the headstock and lock it in place by pushing in the safety stop knob.
3. Remove both blade guide assemblies.
4. Open the wheel access cover.
5. Loosen, but do not remove the lower cap screw in the blade wheel tilting mechanism (**Figure 34**).
6. Adjust the tracking set screw with a 4mm hex wrench, as shown in **Figure 34**, then tighten the cap screw loosened in **Step 5**.
  - Tightening the set screw will move the blade closer to the shoulder of the wheel.
  - Loosening the set screw will move the blade away from the shoulder.
7. Tension the blade.
8. Spin the wheel by hand and observe how the blade tracks on the wheel.
  - If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.
  - If the blade drifts away from the shoulder of the wheel or hits the shoulder, repeat **Steps 5-8**.
9. Replace the blade guard and blade guide assemblies.
10. Adjust the blade guides as needed. Refer to **Blade Guides** on **Page 19**.



**Figure 34.** Tracking adjustment controls.

# 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. Study this diagram carefully. If you notice differences between your machine and these wiring diagrams, call Woodstock International Technical Support at (360) 734-3482.

## ⚠️ 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.
- 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.
- 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.
- CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on these components.
- ELECTRICAL REQUIREMENTS.** You **MUST** follow the electrical 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.

### NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.shopfox.biz](http://www.shopfox.biz).

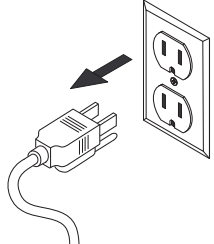
### WIRING DIAGRAM COLOR KEY

BLACK	BLUE	YELLOW	LIGHT BLUE
WHITE	BROWN	YELLOW GREEN	BLUE WHITE
GREEN	GRAY	PURPLE	TURQUOISE
RED	ORANGE	PINK	



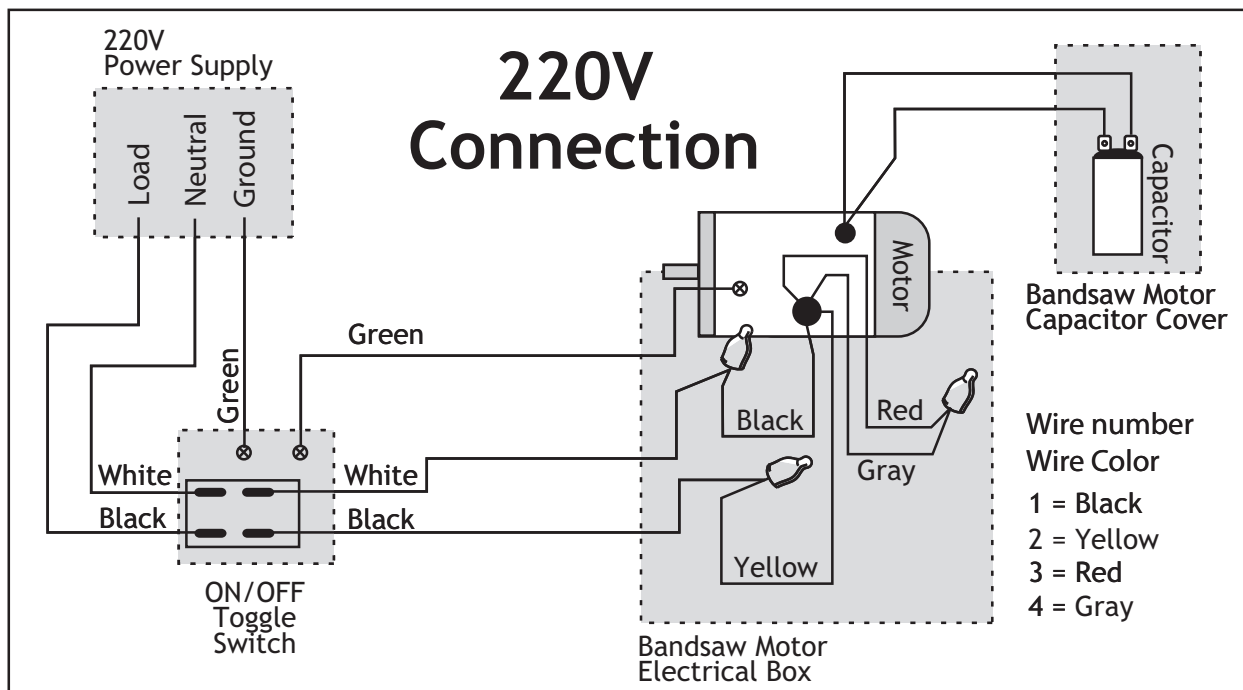
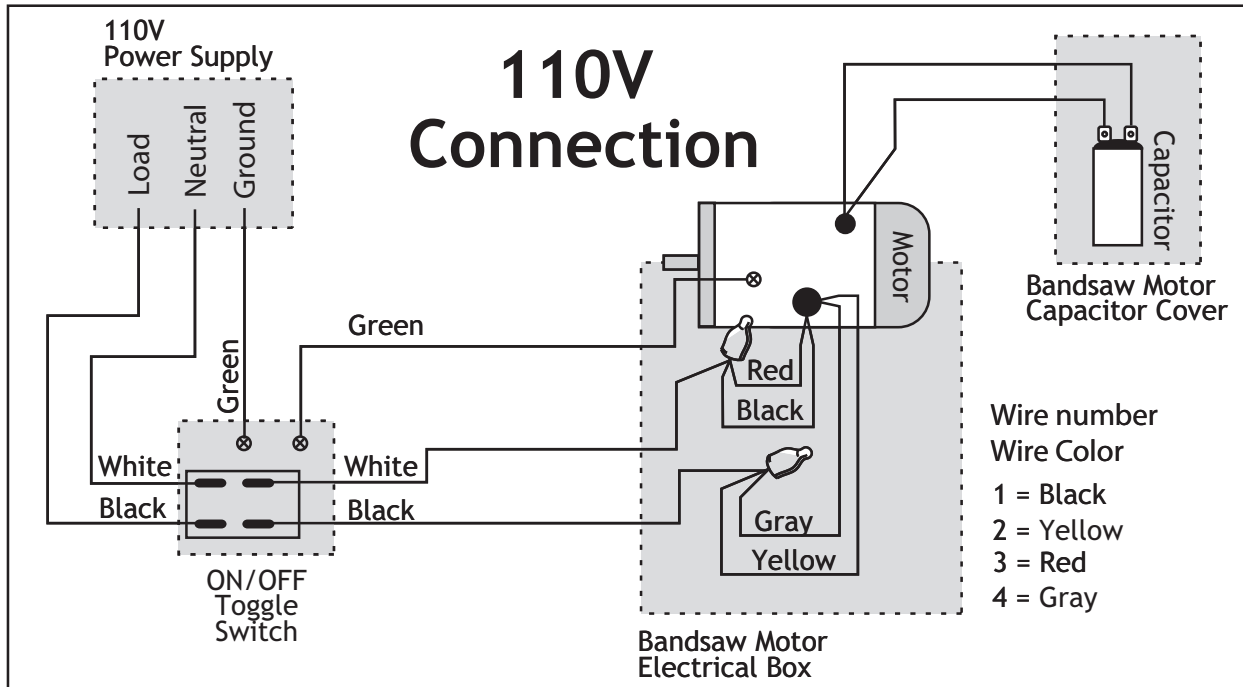
# Wiring Diagram





⚠ DANGER

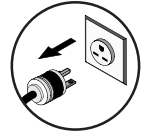
Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard leading to injury or death.



SERVICE

# Troubleshooting

This section covers the most common problems and corrections with this type of machine. **WARNING! DO NOT** make any adjustments until power is disconnected and moving parts have come to a complete stop!



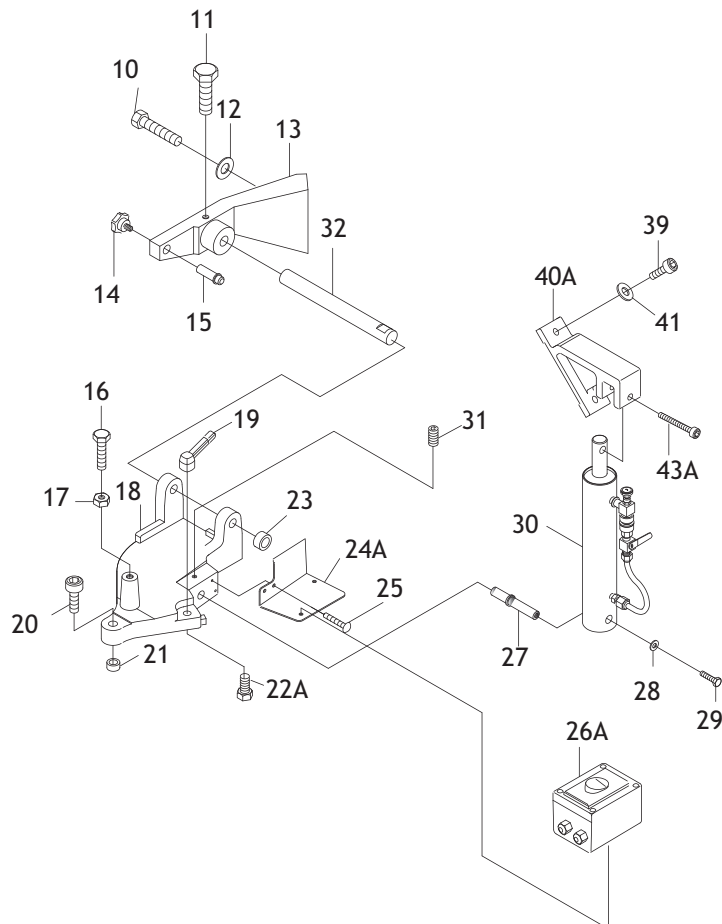
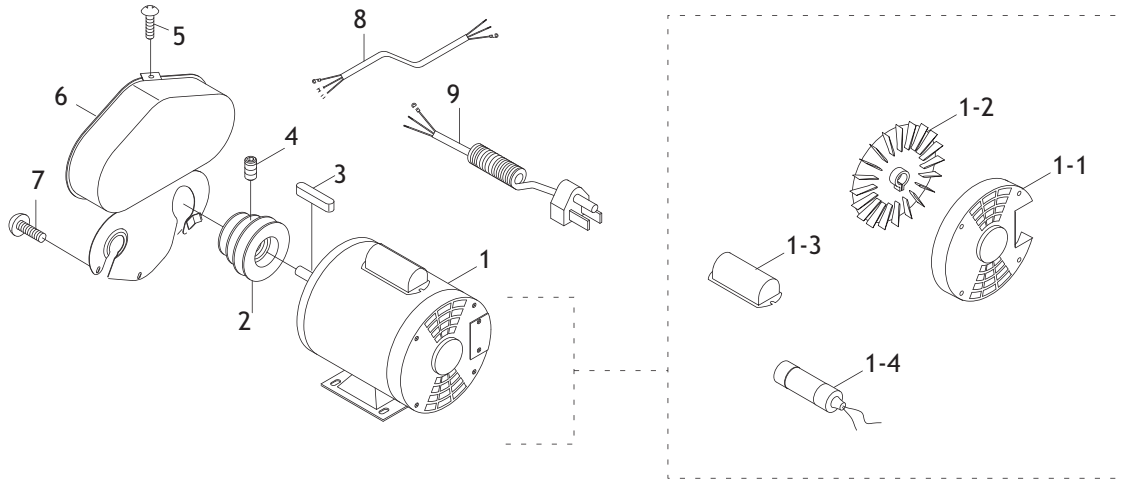
PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>1. Plug/receptacle is at fault or wired incorrectly.</li> <li>2. Start capacitor is at fault.</li> <li>3. Wall fuse/circuit breaker is blown/tripped.</li> <li>4. Motor connection wired incorrectly.</li> <li>5. Power supply is at fault/switched OFF.</li> <li>6. Motor ON/OFF switch is at fault.</li> <li>7. Wiring is open/has high resistance.</li> <li>8. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Test for good contacts; correct the wiring.</li> <li>2. Test/replace if faulty.</li> <li>3. Ensure correct size for machine load; replace weak breaker.</li> <li>4. Correct motor wiring connections.</li> <li>5. Ensure hot lines have correct voltage on all legs and main power supply is switched ON.</li> <li>6. Replace faulty ON/OFF switch.</li> <li>7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.</li> <li>8. Test/repair/replace.</li> </ol>
Machine stalls or is under-powered.	<ol style="list-style-type: none"> <li>1. Wrong blade for the workpiece material.</li> <li>2. Wrong workpiece material.</li> <li>3. Feed rate/cutting speed too fast for task.</li> <li>4. Blade is slipping on wheels.</li> <li>5. Low power supply voltage.</li> <li>6. Motor bearings are at fault.</li> <li>7. Plug/receptacle is at fault.</li> <li>8. Motor connection is wired incorrectly.</li> <li>9. Motor has overheated.</li> <li>10. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use blade with correct properties for your type of cutting.</li> <li>2. Use metal with correct properties for your type of cutting.</li> <li>3. Decrease feed rate/cutting speed.</li> <li>4. Adjust blade tracking and tension.</li> <li>5. Ensure hot lines have correct voltage on all legs.</li> <li>6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>7. Test for good contacts; correct the wiring.</li> <li>8. Correct motor wiring connections.</li> <li>9. Clean off motor, let cool, and reduce workload.</li> <li>10. Test/repair/replace.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor fan is rubbing on fan cover.</li> <li>2. Blade is at fault.</li> <li>3. Gearbox is at fault.</li> <li>4. Wrong blade &amp; too slow of speed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace dented fan cover; replace loose/damaged fan.</li> <li>2. Replace/resharpen blade.</li> <li>3. Rebuild gearbox for bad gear(s)/bearing(s).</li> <li>4. Change blade and or speed.</li> </ol>
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> <li>1. Excessive feed rate.</li> <li>2. The blade TPI is too great, or the material is too coarse.</li> </ol>	<ol style="list-style-type: none"> <li>1. Refer to <b>Feed Rate</b> on <b>Page 25</b>, or <b>Blade Speed</b> on <b>Page 23</b>, and adjust as required.</li> <li>2. Refer to <b>Blade Selection</b> on <b>Page 24</b> and adjust as required.</li> </ol>



PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Blades break often.	<ol style="list-style-type: none"> <li>1. Blade is not tensioned correctly.</li> <li>2. The workpiece is loose in the vise.</li> <li>3. The feed or cut speed is wrong.</li> <li>4. The blade TPI is too great, or the material is too coarse.</li> <li>5. The blade is rubbing on the wheel flange.</li> <li>6. The bandsaw is being started with the blade resting on the workpiece.</li> <li>7. The guide bearings are misaligned, or the blade is rubbing on the wheel flange.</li> <li>8. The blade is too thick, or the blades are of low quality.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check to see that blade is not excessively tight or too loose.</li> <li>2. Clamp the workpiece tighter, or use a jig to hold the workpiece.</li> <li>3. Refer to <b>Feed Rate</b> on <b>Page 25</b>, or <b>Blade Speed</b> on <b>Page 23</b>, and adjust as required.</li> <li>4. Refer to <b>Blade Selection</b> on <b>Page 24</b> and adjust as required.</li> <li>5. Refer to <b>Blade Tracking</b> on <b>Page 29</b>, and adjust as required.</li> <li>6. Start bandsaw and then slowly lower the headstock by setting the feed rate.</li> <li>7. Refer to <b>Blade Tracking</b> on <b>Page 29</b>, or <b>Blade Guides</b> on <b>Page 19</b> and adjust as required.</li> <li>8. Use a higher quality blade.</li> </ol>
Blade dulls prematurely.	<ol style="list-style-type: none"> <li>1. The cutting speed is too fast.</li> <li>2. The blade TPI is too coarse.</li> <li>3. The blade feed pressure is too light.</li> <li>4. The workpiece has hard spots, welds, or scale is on the material.</li> <li>5. The blade is twisted.</li> <li>6. The blade is slipping on the wheels.</li> </ol>	<ol style="list-style-type: none"> <li>1. Refer to <b>Blade Speed</b> on <b>Page 23</b>, and adjust as required.</li> <li>2. Refer to <b>Blade Selection</b> on <b>Page 24</b>, and adjust as required.</li> <li>3. Refer to <b>Feed Rate</b> on <b>Page 25</b>, and adjust as required.</li> <li>4. Increase the feed pressure, and reduce the cutting speed.</li> <li>5. Replace the blade.</li> <li>6. Refer to <b>Blade Tension</b> on <b>Page 18</b>, and adjust as required.</li> </ol>
Blade wears on one side.	<ol style="list-style-type: none"> <li>1. The blade guides are worn or mis-adjusted.</li> <li>2. The blade guide slide bracket is loose.</li> <li>3. The wheels are out of alignment.</li> </ol>	<ol style="list-style-type: none"> <li>1. Refer to <b>Blade Guides</b> on <b>Page 19</b> and replace or adjust.</li> <li>2. Tighten the blade guide bracket.</li> <li>3. Refer to <b>Blade Tracking</b> on <b>Page 29</b>, and adjust as required.</li> </ol>
Teeth are ripping from the blade.	<ol style="list-style-type: none"> <li>1. The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece.</li> <li>2. The workpiece is vibrating in the vise.</li> <li>3. The blade gullets are loading up with chips.</li> </ol>	<ol style="list-style-type: none"> <li>1. Refer to <b>Blade Selection</b> on <b>Page 24</b> and decrease the feed pressure. Refer to <b>Feed Rate</b> on <b>Page 25</b>, and adjust as required.</li> <li>2. Re-clamp the workpiece in the vise, and use a jig if required.</li> <li>3. Use a coarser-tooth blade.</li> </ol>

# PARTS

## Motor & Feed Rate Control

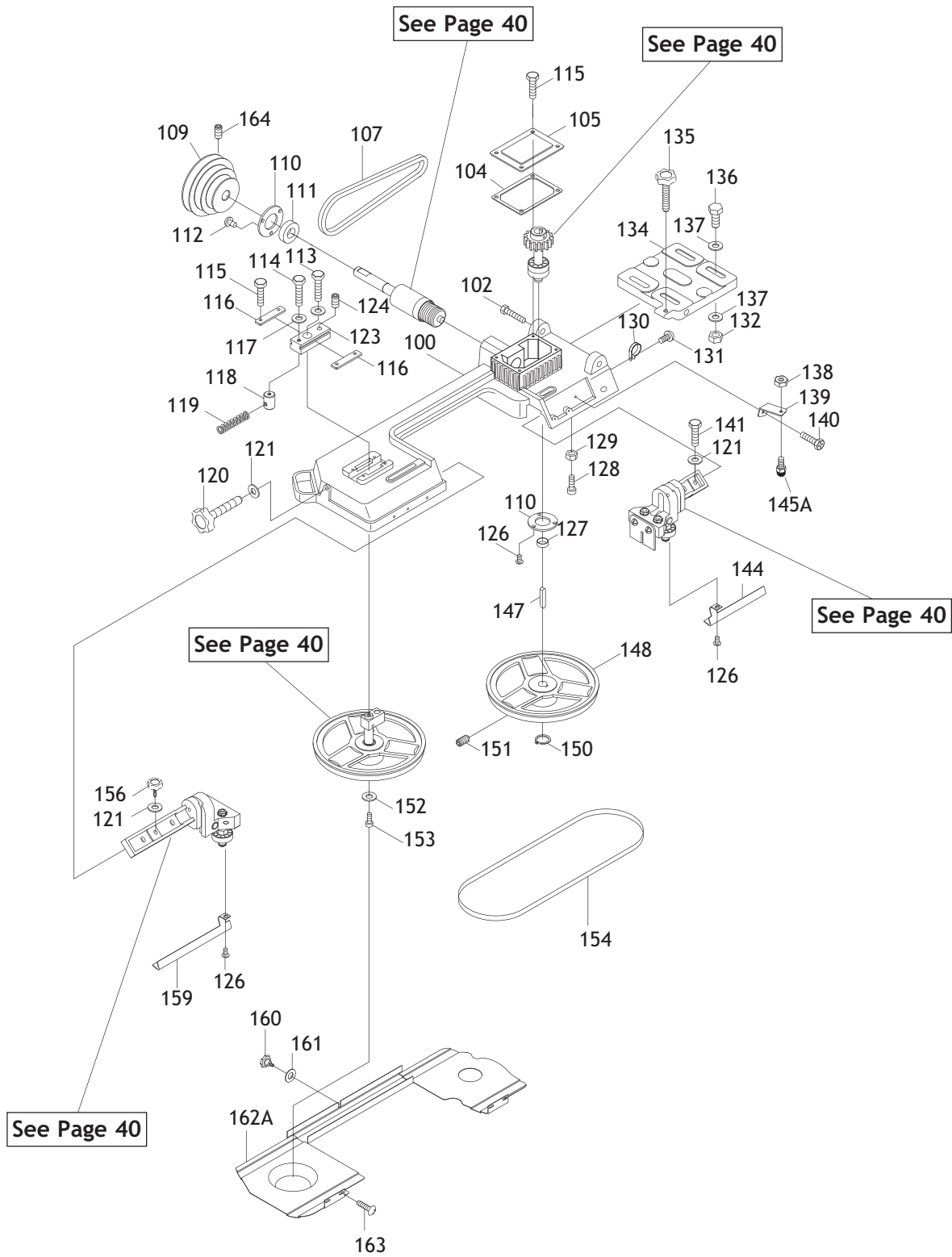


## Motor & Feed Rate Control Parts List

REF	PART #	DESCRIPTION
1	XM1013001	MOTOR 1/2HP 110/220V 1PH
1-1	XM1013001-1	MOTOR FAN COVER
1-2	XM1013001-2	MOTOR FAN
1-3	XM1013001-3	CAPACITOR COVER
1-4	XM1013001-4	S CAPACITOR 200M 125V
2	XM1013002	MOTOR PULLEY
3	XPK12M	KEY 5 X 5 X 30
4	XPSS17	SET SCREW 5/16-18 X 5/16
5	XPHTEK11	TAP SCREW 1/4 X 5/16(3/4)
6	XM1013006	BELT COVER
7	XPS04	PHLP HD SCR 1/4-20 X 1/2
8	XM1013008	MOTOR CABLE
9	XM1013009	POWER CABLE
10	XPB03	HEX BOLT 5/16-18 X 1
11	XPB07	HEX BOLT 5/16-18 x 3/4
12	XPW07	FLAT WASHER 5/16
13	XM1013013	PIVOT
14	XM1013014	KNOB BOLT 1/4-20 X 5/8
15	XM1013015	SPECIAL PIN 10 X 38.5 MM
16	XPB58	HEX BOLT 3/8-16 X 2

REF	PART #	DESCRIPTION
17	XPN08	HEX NUT 3/8-16
18	XM1013018	BRACKET
19	XM1013019	HANDLE
20	XPCAP97	CAP SCREW 1/2-12 X 2-1/2
21	XPN13	HEX NUT 1/2-13
22A	XM1013022A	SPECIAL BOLT 3/8"-16 X 1 3/4"
23	XM1013023	BUSHING 19 X 17 X 7
24A	XM1013024A	SWITCH BASE V2.10.06
25	XPS06	PHLP HD SCR 10-24 X 3/8
26A	XM1013026A	SWITCH BOX V2.08.06
27	XM1013027	SUPPORT ROD
28	XPW03	FLAT WASHER #10
29	XPS06	PHLP HD SCR 10-24 X 3/8
30	XM1013030	CYLINDER ASSEMBLY
31	XPSS04	SET SCREW 1/4-20 X 5/16
32	XM1013032	PIVOTING ROD
39	XPCAP05	CAP SCREW 1/4-20 X 3/4
40A	XM1013040A	CYLINDER UPPER SUPPORT V2.10.06
41	XPLW01	LOCK WASHER 5/16
43A	XM1013043A	SPECIAL CAP SCREW V2.10.06

# Saw Assembly

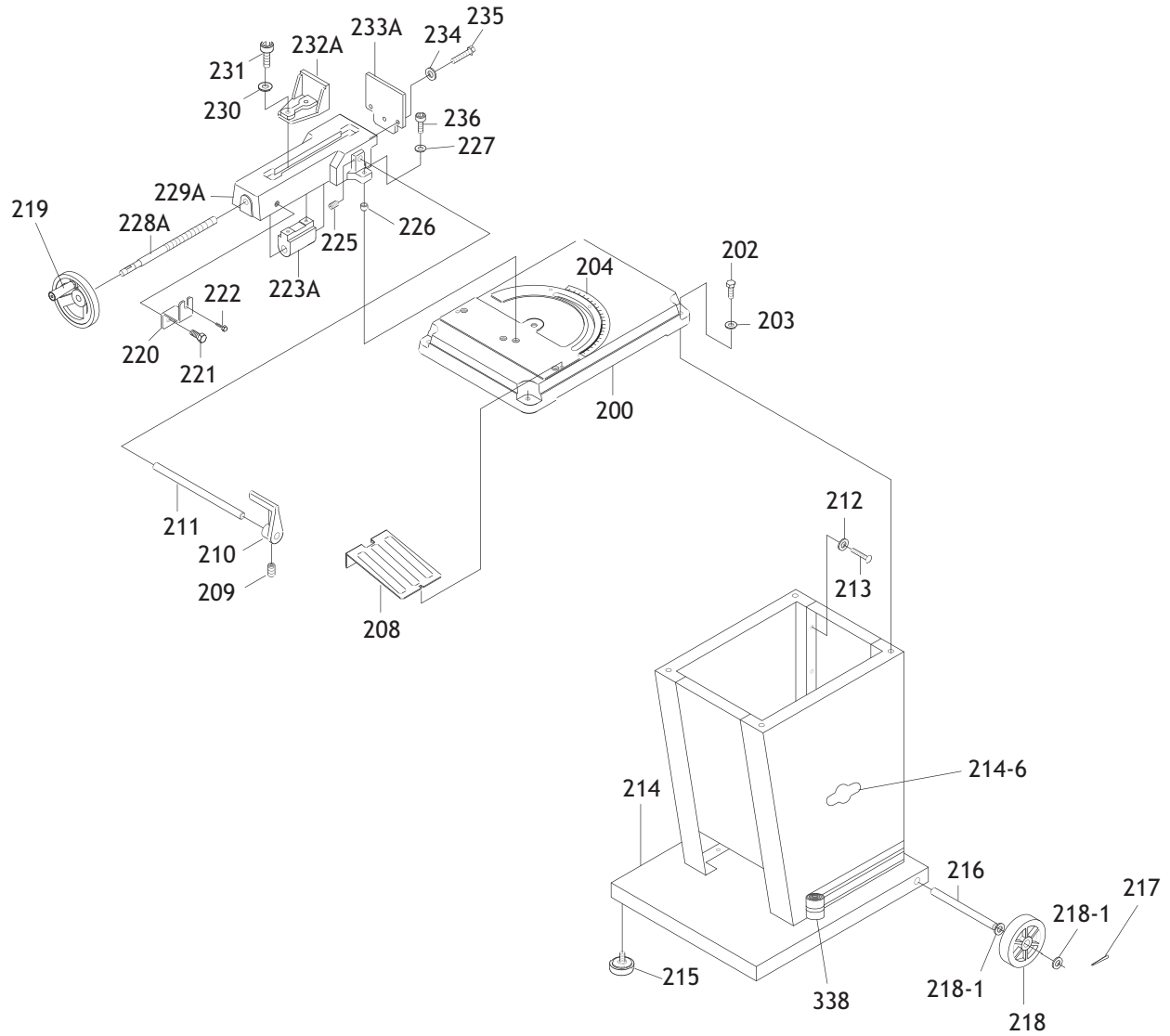


## Saw Assembly Parts List

REF	PART #	DESCRIPTION
100	XM1013100	BODY FRAME
102	XPB41	HEX BOLT 1/2-12 X 1-1/2
104	XM1013104	GEAR BOX GASKET
105	XM1013105	PLATE
107	XPVA23	V-BELT A-23
109	XM1013109	PULLEY
110	XM1013110	BEARING COVER
111	XM1013111	OIL SEAL
112	XPS24	PHLP HD SCR 8-32 X 3/8
113	XPB03	HEX BOLT 5/16-18 X 1
114	XPB07	HEX BOLT 5/16-18 x 3/4
115	XPB02	HEX BOLT 1/4-20 X 5/8
116	XM1013116	BLADE TENSION SLIDING GUIDE
117	XPW07	FLAT WASHER 5/16
118	XM1013118	SHAFT BLOCK
119	XM1013119	COMPRESSION SPRING
120	XM1013120	BLADE TENSION KNOB
121	XPW02	FLAT WASHER 3/8
123	XM1013123	BLADE TENSION SLIDING PLATE
124	XPSS38	SET SCREW 5/16-18 X 5/8
126	XPS08M	PHLP HD SCR M5-.8 X 12
127	XM1013127	BUSHING
128	XPCAP05	CAP SCREW 1/4-20 X 3/4
129	XPNO5	HEX NUT 1/4-20
130	XM1013130	WIRE CLAMP
131	XPS06	PHLP HD SCR 10-24 X 3/8

REF	PART #	DESCRIPTION
132	XPNO2	HEX NUT 5/16-18
134	XM1013134	MOTOR MOUNT PLATE
135	XM1013135	KNOB BOLT 5/16-18 X 1-3/4
136	XPB07	HEX BOLT 5/16-18 x 3/4
137	XPW07	FLAT WASHER 5/16
138	XPNO8	HEX NUT 3/8-16
139	XM1013139	SWITCH CUT OFF TIP
140	XPCAP04	CAP SCREW 1/4-20 X 1/2
141	XPB24	HEX BOLT 3/8-16 X 1-1/4
144	XM1013144	RIGHT SAFETY GUARD (OPTION)
145A	XM1013145A	STOP BOLT 3/8-16 X 1 V2.10.06
147	XPK23M	KEY 5 X 5 X 25
148	XM1013148	FRONT BLADE WHEEL
150	XPR05M	EXT RETAINING RING 15MM
151	XPSS17	SET SCREW 5/16-18 X 5/16
152	XPW07	FLAT WASHER 5/16
153	XPB07	HEX BOLT 5/16-18 x 3/4
154	XM1013154	BLADE 1/2" X 0.025" X 64-1/2"
156	XM1013156	KNOB BOLT 3/8-16 X 1-1/4
159	XM1013159	LEFT SAFETY GUARD
160	XM1013160	KNOB BOLT 1/4"-20 X 5/8"
161	XPW06	FLAT WASHER 1/4
162A	XM1013162A	PLASTIC SAFETY COVER V2.08.06
163	XPS06	PHLP HD SCR 10-24 X 3/8
164	XPSS17M	SET SCREW M8-1.25 X 6

# Stand Assembly



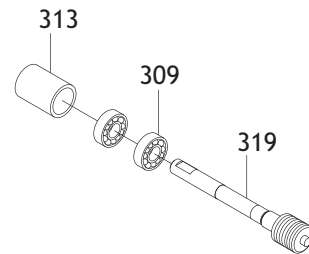
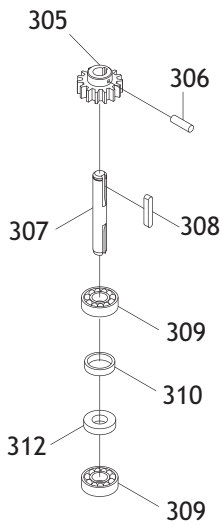
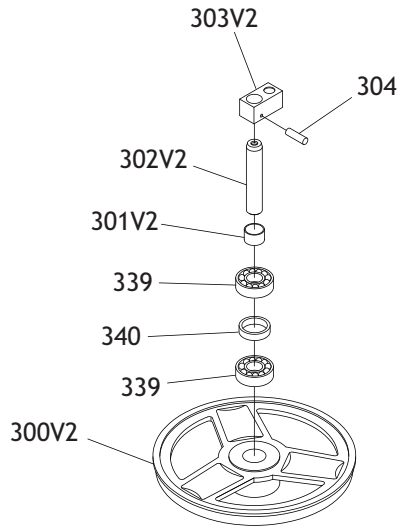
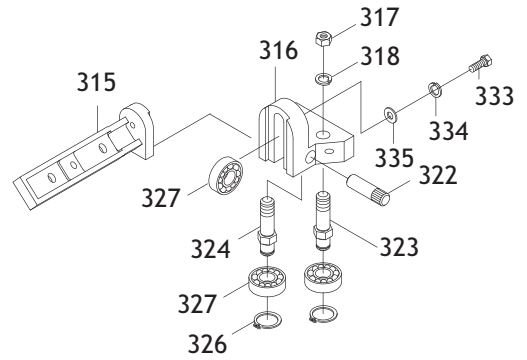
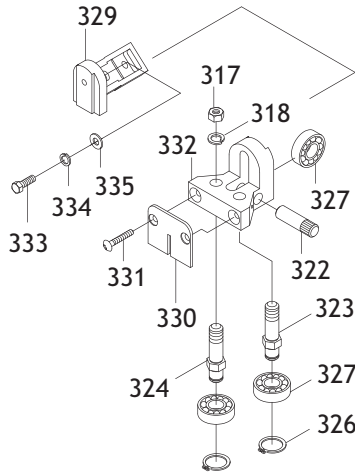


## Stand Assembly Parts List

REF	PART #	DESCRIPTION
200	XM1013200	BASE
202	XPB26M	HEX BOLT M8-1.25 X 30
203	XPLW04M	LOCK WASHER 8MM
204	XM1013204	SCALE
208	XM1013208	EJECTOR PLATE
209	XPSS17	SET SCREW 5/16-18 X 5/16
210	XM1013210	DISTANCE SET BRACKET
211	XM1013211	STOCK STOP ROD 1/2"
212	XPW03M	FLAT WASHER 6MM
213	XPS14M	PHLP HD SCR M6-1 X 12
214	XM1013214	DELUXE STAND ASSEMBLY
214-6	XM1013214-6	SHOP FOX LOGO 2-5/16" X 5"
215	XM1013215	RUBBER FOOT
216	XM1013216	WHEEL ROD
217	XM1013217	COTTER PIN 1/8 X 1
218	XM1013218	WHEEL
218-1	XPW27MM	FLAT WASHER 17MM
219	XM1013219	HANDWHEEL ASSEMBLY

REF	PART #	DESCRIPTION
220	XM1013220	PLATE
221	XPCAP30	CAP SCREW 5/16-18 X 1/2
222	XPS04	PHLP HD SCR 1/4-20 X 1/2
223A	XM1013223A	BRACKET W/NUT V2.01.08
225	XPSS03	SET SCREW 1/4-20 X 3/8
226	XM1013226	BUSHING
227	XPLW01	LOCK WASHER 5/16
228A	XM1013228A	ACME SCREW V2.01.08
229A	XM1013229A	VICE BASE V2.01.08
230	XPW07	FLAT WASHER 5/16
231	XPCAP69	CAP SCREW 5/16-18 X 1/4
232A	XM1013232A	VICE HALF V2.01.08
233A	XM1013233A	WALL PLATE V2.01.08
234	XPW07	FLAT WASHER 5/16
235	XPB07	HEX BOLT 5/16-18 x 3/4
236	XPCAP08	CAP SCREW 5/16-18 X 1-1/2
338	XM1013338	STRIPE FOR STAND 6" X 4'

# Guides & Shafts



## Guides & Shafts Parts List

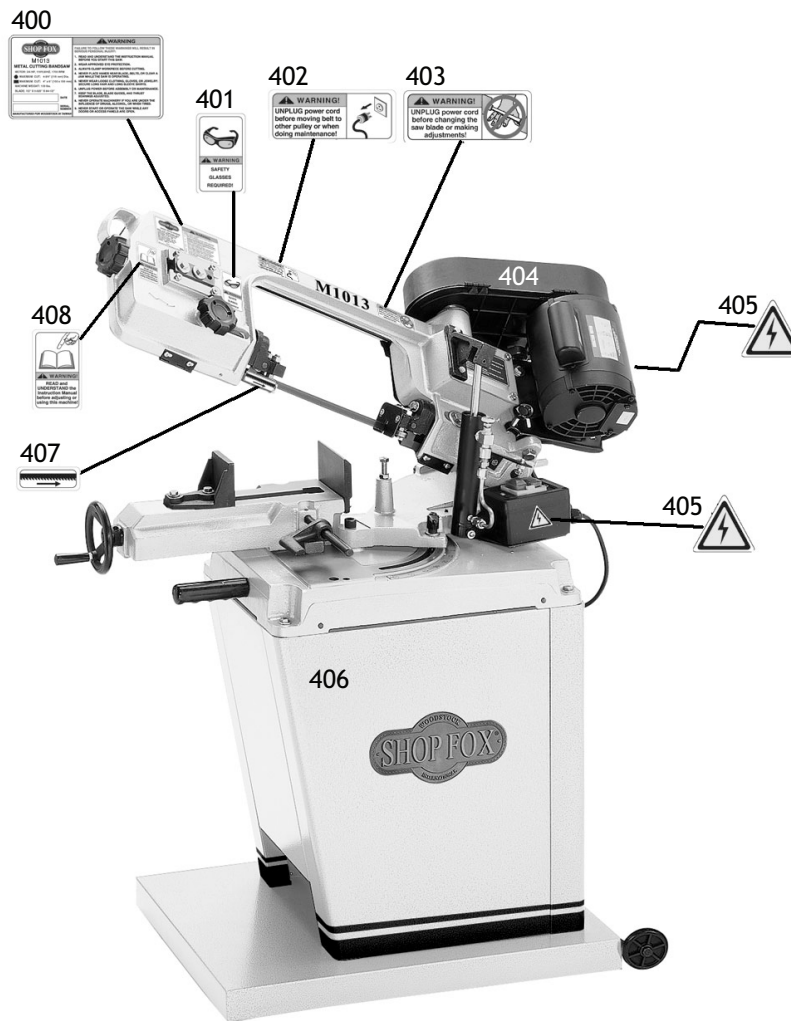
REF	PART #	DESCRIPTION
300V2	XM1013300V2	REAR BLADE WHEEL V2.06.09
301V2	XM1013301V2	BUSHING V2.06.09
302V2	XM1013302V2	BLADE WHEEL SHAFT V2.06.09
303V2	XM1013303V2	AXLE BLOCK V2.06.09
304	XPRP39M	ROLL PIN 4 X 20
305	XM1013305	WORM GEAR
306	XPRP20M	ROLL PIN 4 X 22
307	XM1013307	TRANSMISSION WHEEL SHAFT
308	XPK23M	KEY 5 X 5 X 25
309	XP6202-OPEN	BALL BEARING 6202 OPEN
310	XM1013310	BUSHING
312	XM1013312	SEAL
313	XM1013313	BUSHING
315	XM1013315	LEFT ADJUSTABLE BRACKET
316	XM1013316	FRONT GUIDE CASTING
317	XPN08	HEX NUT 3/8-16

REF	PART #	DESCRIPTION
318	XPLW04	LOCK WASHER 3/8
319	XM1013319	WORM GEAR SHAFT
322	XM1013322	SPECIAL PIN 10 X 40MM
323	XM1013323	GUIDE ECCENTRIC
324	XM1013324	GUIDE SHAFT
326	XPR01M	EXT RETAINING RING 10MM
327	XP6000-OPEN	BALL BEARING 6000 OPEN
329	XM1013329	RIGHT ADJUSTABLE BRACKET
330	XM1013330	STOP PLATE
331	XPFH03	FLAT HD SCR 1/4-20 X 1/2
332	XM1013332	REAR GUIDE CASTING
333	XPB03	HEX BOLT 5/16-18 X 1
334	XPLW01	LOCK WASHER 5/16
335	XPW07	FLAT WASHER 5/16
339	XP6202ZZ	BALL BEARING 6202 ZZ
340	XM1013340	BUSHING

# Machine Labels

## ⚠ 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](http://www.shopfoxtools.com) to order new labels.



REF	PART #	DESCRIPTION
400	XM1013400	MACHINE ID LABEL
401	XM1013401	SAFETY GLASSES LABEL
402	XM1013402	DISCONNECT POWER LABEL
403	XM1013403	AMPUTATION HAZARD LABEL
404	XPPAINT-7	SHOPFOX BLACK TOUCH-UP PAINT

REF	PART #	DESCRIPTION
405	XPLABLE-14B	ELECTRICITY LABEL
406	XPPAINT-1	SHOPFOX WHITE TOUCH-UP PAINT
407	XM1013123-1	BLADE TENSION LABEL
408	XPLABEL-12A	READ MANUAL LABEL



# Warranty Registration

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 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?
 

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Local Store
<input type="checkbox"/> Mail Order Catalog	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
  
2. How long have you been a woodworker/metalworker?
 

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------
  
3. How many of your machines or tools are Shop Fox?
 

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
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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?
 

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
  
7. What is your annual household income?
 

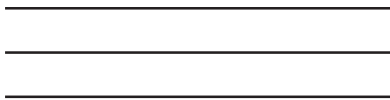
<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
  
8. Which of the following magazines do you subscribe to?
 

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

9. Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

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FOLD ALONG DOTTED LINE



Place  
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BELLINGHAM, WA 98227-2309



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# WARRANTY

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 a Shop Fox factory service center 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.

Every effort has been made to ensure that all Shop Fox machinery meets high quality and durability standards. We reserve the right to change specifications at any time because of our commitment to continuously improve the quality of our products.



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