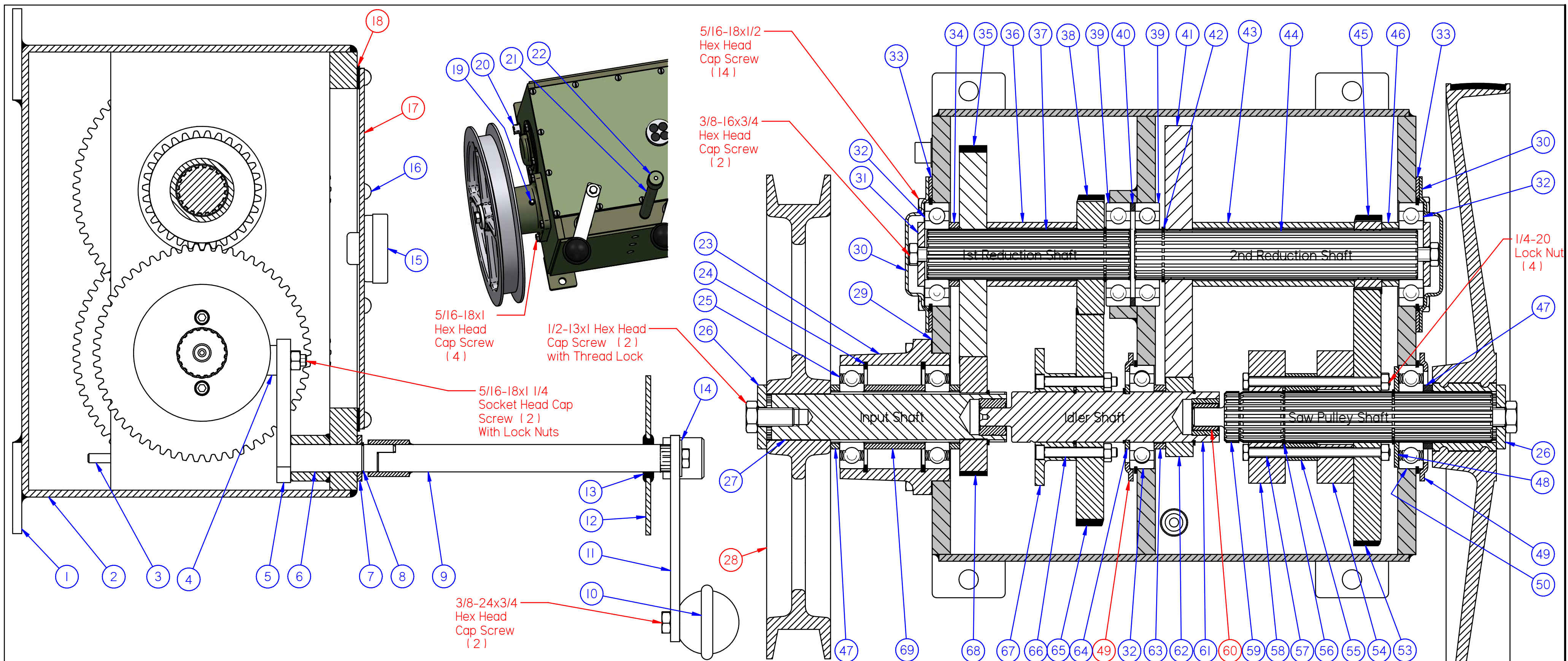




GROB 4V-36 Parts

GrobBandSaw.com
888-550-3116





Item Number	Part Number	Title	Qty.	Item Number	Part Number	Title	Qty.	Item Number	Part Number	Title	Qty.	Item Number	Part Number	Title	Qty.
1	18120-A	Pad	4	21	18329-A	Oil Filler Tube	1	41	18019-A	69T. Gear	1	61	18006-B	Idler Shaft	1
2	18033-D	4V Gear Box	1	22	18328-A	Filler Cap	1	42	5100-137	External Retaining Ring	6	62	18011-A	20T. Gear	1
3	18172-A	Trans. Dip Stick	1	23	18178-B	Housing	1	43	18021-A	4 7/16 Spacer	1	63	18012-A	.318 Spacer	1
4	18029-A	Inside Shift Knob	2	24	N5000-28I	Internal Retaining Ring	2	44	18018-B	Second Red. Shaft	1	64	18010-A	1/8 Spacer	1
5	18028-A	Inside Shift Lever	2	25	6207-2RS	Bearing	2	45	18020-A	20T. Gear	1	65	18007-A	58T. Shifting Gear	1
6	18068-A	Shifting Pivot Pin	2	26	18123-A	Clamp Washer	2	46	18076-A	Spacer	1	66	1/4-20 x 2	Socket Head Cap Screw	2
7	15243-A	Washer	2	27	18001-B	Input Shaft	1	47	18171-A	Lower Pulley Spacer	2	67	18071-A	Shift Ring / 58T. Gear	1
8	5100-75	External Retaining Ring	2	28	18055-C See NOTES	Drive Pulley	1	48	18325-A	Broached Bearing Spacer	1	68	18005-A	31T. Gear	1
9	18075-A	Shift Shaft Assy.	2	29	18088-A	Gasket	1	49	18026-A See NOTES	Bearing Clamp Plate	2	69	18003-A	Bearing Spacer	1
10	18385-A	M-80A Knob with 3/8-24 Tap	2	30	18022-A	Bearing Cover	2	50	6207-2RSNR	Bearing	1				
11	18061-A	Table Clamp & Shift Lever	2	31	15065-A	Clamp Washer	2	51	18105-I-B See NOTES	Lower Saw Pulley for 4V-18 Saws	1				
12	18175-5	Table Top	1	32	6207-NR	Bearing	3	52	GS-2079-A See NOTES	18" Rubber Tire	1				
13	G-1125	Rubber Grommet	2	33	18089-A	Gasket	2	53	18024-A	69T. Shifting Gear	1				
14	18124-A	Clamp Washer	2	34	18004-A	Spacer	2	54	18074-A	Shift Hub	1				
15	18373-A	Air Filter Assembly	1	35	18014-A	58T. Gear	1	55	18073-A	Shift Ring Spacer	1				
16	1/4-20 x 1/2	Slotted Rd Hd Screw	14	36	18015-A	Spacer	1	56	18179-A	Grob Shifting Ring	2				
17	18110-B See NOTES	Gear Box Cover, Steel Box	1	37	18013-B	First Reduction Shaft	1	57	18478-A	Hex Head Cap Screw	2				
18	18091-A See NOTES	Cover Gasket	1	38	18016-A	31T. Gear	1	58	18072-A	Shift Ring / 69T. Gear	1				
19	1/8-27 NPT	Pipe Plug	1	39	6207	Bearing	2	59	18023-B	Saw Pulley Shaft	1				
20	1/2-14 NPT	Pipe Plug	1	40	18017-A	1/8 Bearing Spacer	1	60	GR-8-N See NOTES	McGill Guidroll	2				

NOTES

Item 28 24001-C for 4V-24 and 4V-36 Band Saws
 Item 60 AA-628-6 Oilite Bushing Used on Some Older Transmissions
 New Style Cast Iron Box:
 Item 17 18437-B Cover
 Item 18 18438-A Gasket
 Item 49 (Middle Plate) 18436-A Clamp

Item No. 51
 Lower Saw Pulley
 4V-18 18105-I
 4V-24 24007
 4V-36 24007

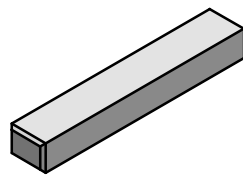
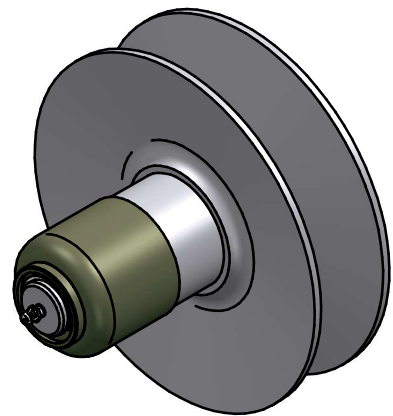
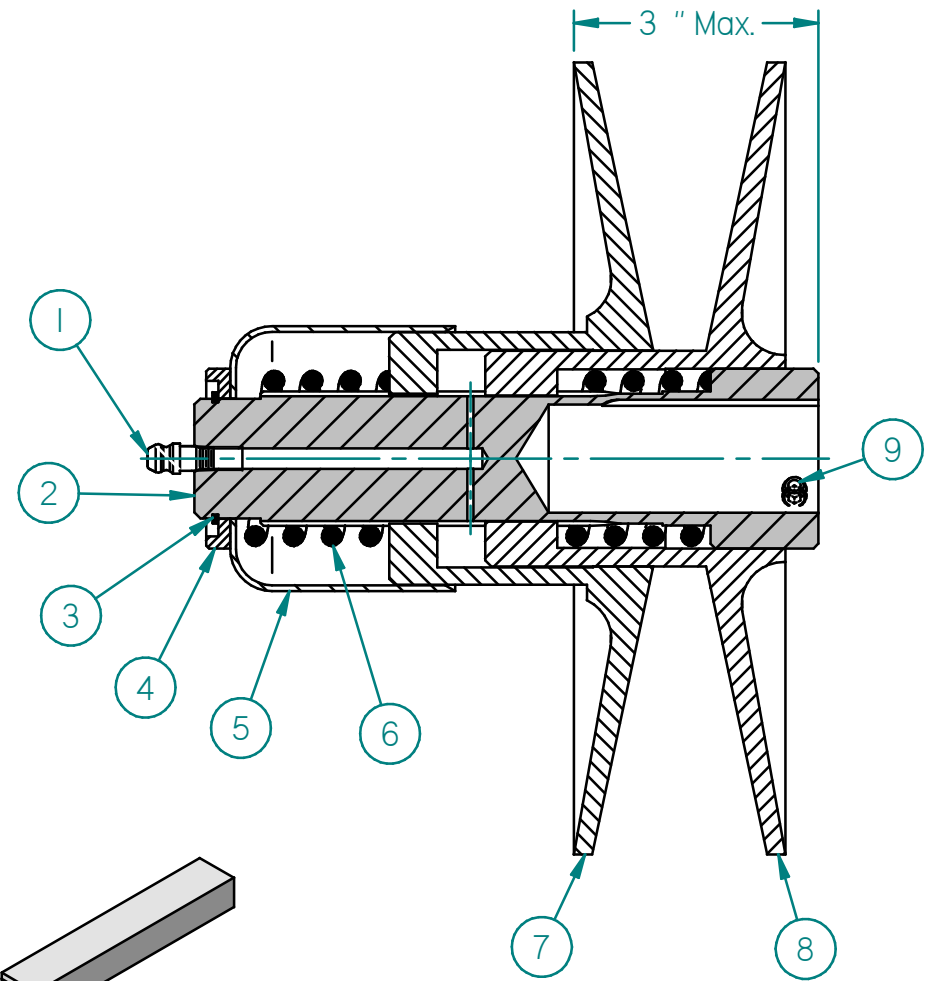
Item No. 52
 Rubber Tires
 18" GS-2079
 24" S-1361
 Glue: 3M 2141

Order By **PART NUMBERS ONLY**

GROB INC. **GRAFTON, WIS.**
 Transmission Assembly for Grob 4V Band Saws

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS	TR.	CH. 4-11-07	DWG. NO.
				DATE 7-18-03	SCALE	O.K. Rev 5	18180-C

Item Number	Document Number	Title	Quantity
1	#1652-B	Alemite Grease Fitting	1
2	18241-A	Vari-Drive Shaft	1
3	5100-125	External Retaining Ring	1
4	18242-A	Vari-Drive Retainer	1
5	18243-A	Vari-Drive Cup Shield	1
6	18252-A	Spring	2
7	18239-B	Vari-Drive Sheave, Front	1
8	18240-B	Vari-Drive Sheave, Rear	1
9	1/4-20 x 1/4	Set Screw-Cup pt. with Thread Lock	2



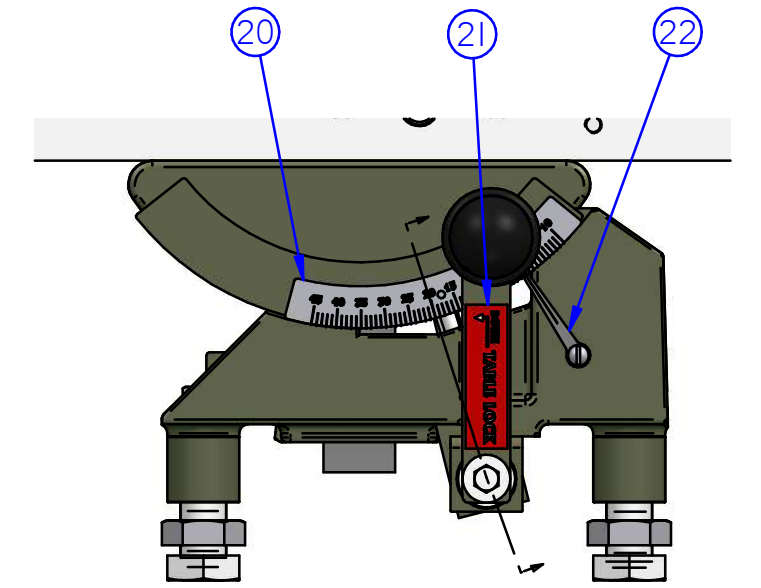
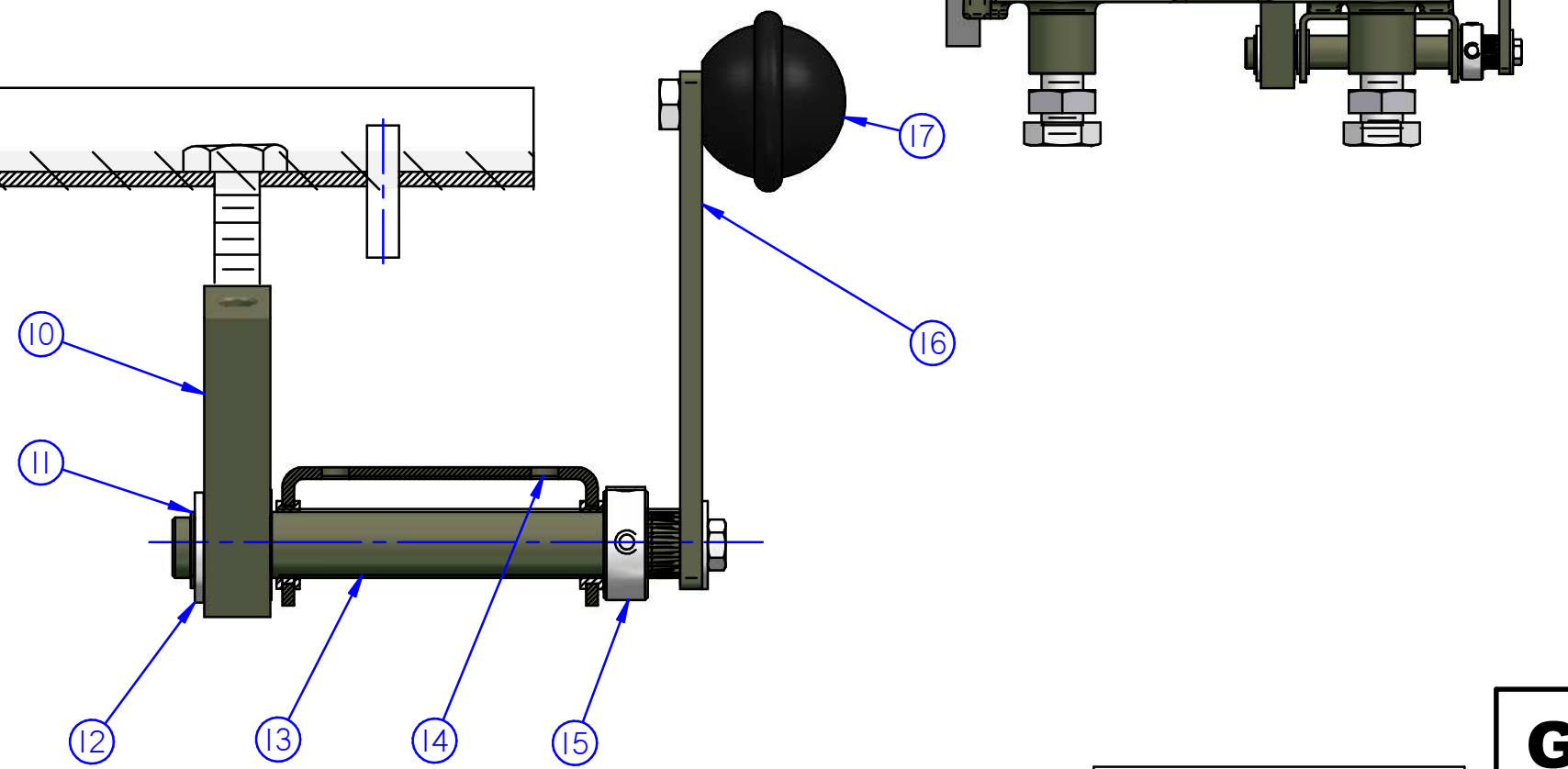
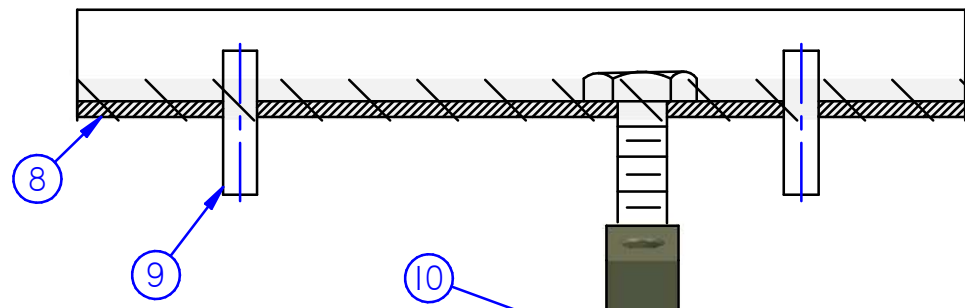
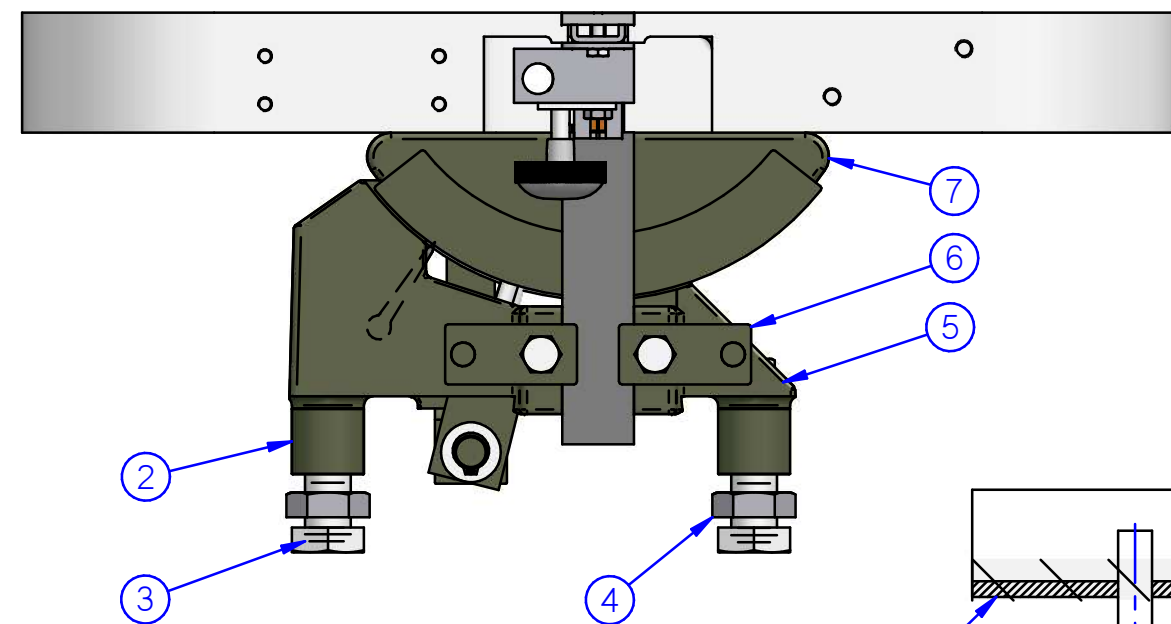
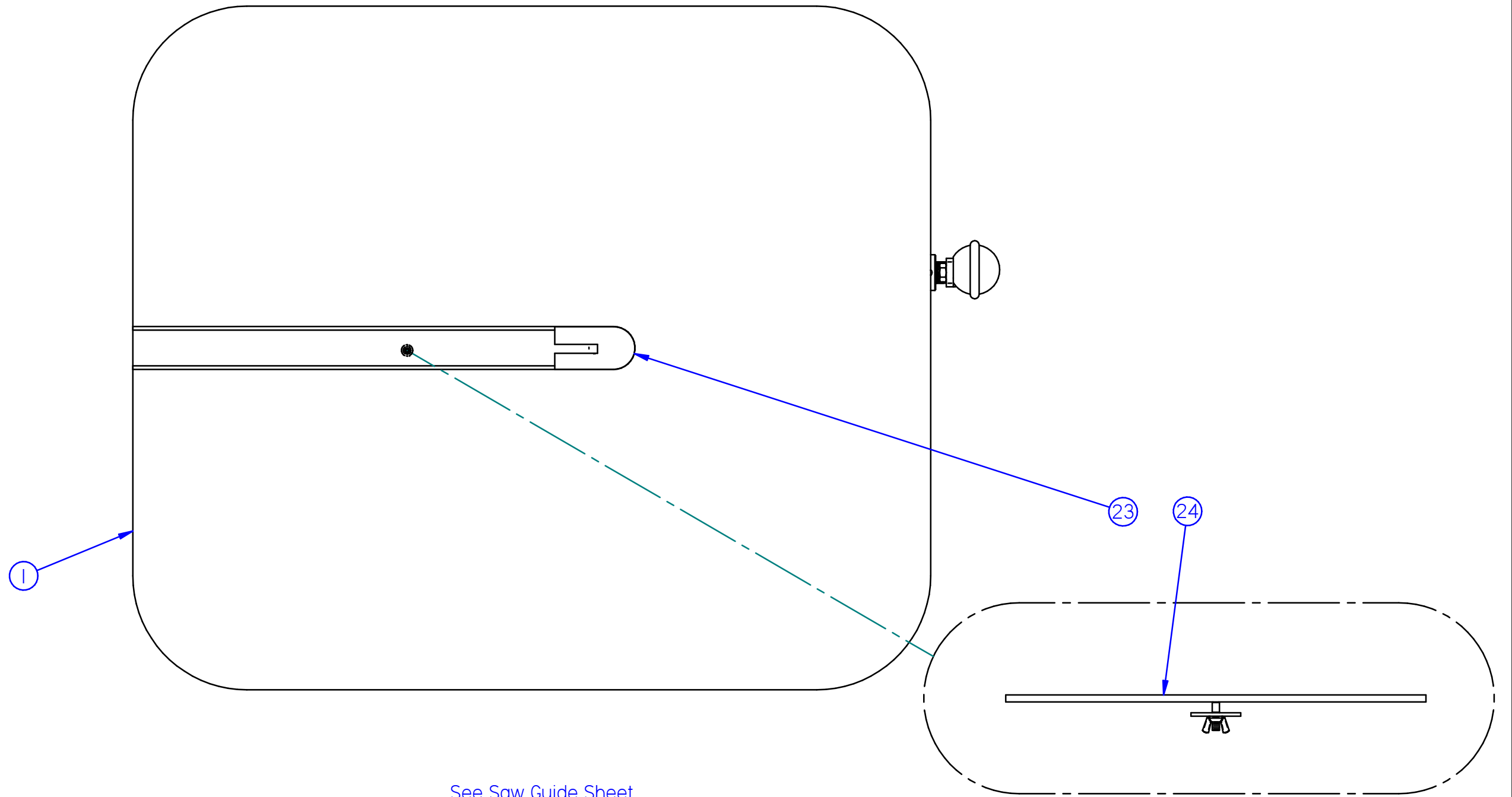
18351-A Key

First Used On	
Model	Serial No.
4V-18	1160
4V-24	638
4V-36	1061

GROB INC.		GRAFTON, WIS.	
Vari-Drive Pulley Assembly for 4V Band Saws			
DRN.	KS	TR.	CH.
DATE	1-29-01	SCALE	1:2
		O.K.	Rev 1
			DWG. NO. 18246-A

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT

Item No.	Part No.	Description	Quantity
1	18219-C	Table	1
2	18165-A	Support Boss Sleeve	4
3	18164-A	Table Support Stud	4
4	18286-A	Table Support Stud Nut	8
5	18277-C	Table Trunnion Support	1
6	18108-A	Lower Guide Bar Clamp	2
7	18279-A	Table Trunnion	2
8	18278-A	Table Trunnion Clamp Channel	1
9	3/8 x 2 Pin	Slotted Spring Pin	2
10	18282-A	Table Tilt Clamp Block	1
11	5100-68	External Retaining Ring	1
12	5/8 x 1 1/4	Flat Washer	2
13	18283-A	Table Tilt Clamp	1
14	18281-A	Table Tilt Clamp Bracket	1
15	18348-A	3/4" Set Collar	1
16	18061-A	Table Clamp Lever	1
17	18385-A	M-80A Knob with 3/8-24 Tap	1



See Saw Guide Sheet for Optional Guides

Table Tilt: 45° Down Right
5° Down Left

First Used on Serial Number			
4V-18	4V-24	4V-36	4V-60
2511, 2537-2542, 2550, 2556, to ...	1117-1118, 1174 to...	1267 to...	226 to...

Item No.	Part No.	Description	Quantity
18	18100-A	Lower Guide Bar	1
19	18095-A	1/8-1/2 Lower Single Pc. Guide Holder	1
20	18053-A	Table Tilt Indicator	1
21	18212-A	Table Lock Decal	1
22	S-1163-A	Table Tilt Pointer	1
23	18146-A	Rear Table Filler Plate	1
24	18145-1-A	Standard Table Filler Plate Assembly	1

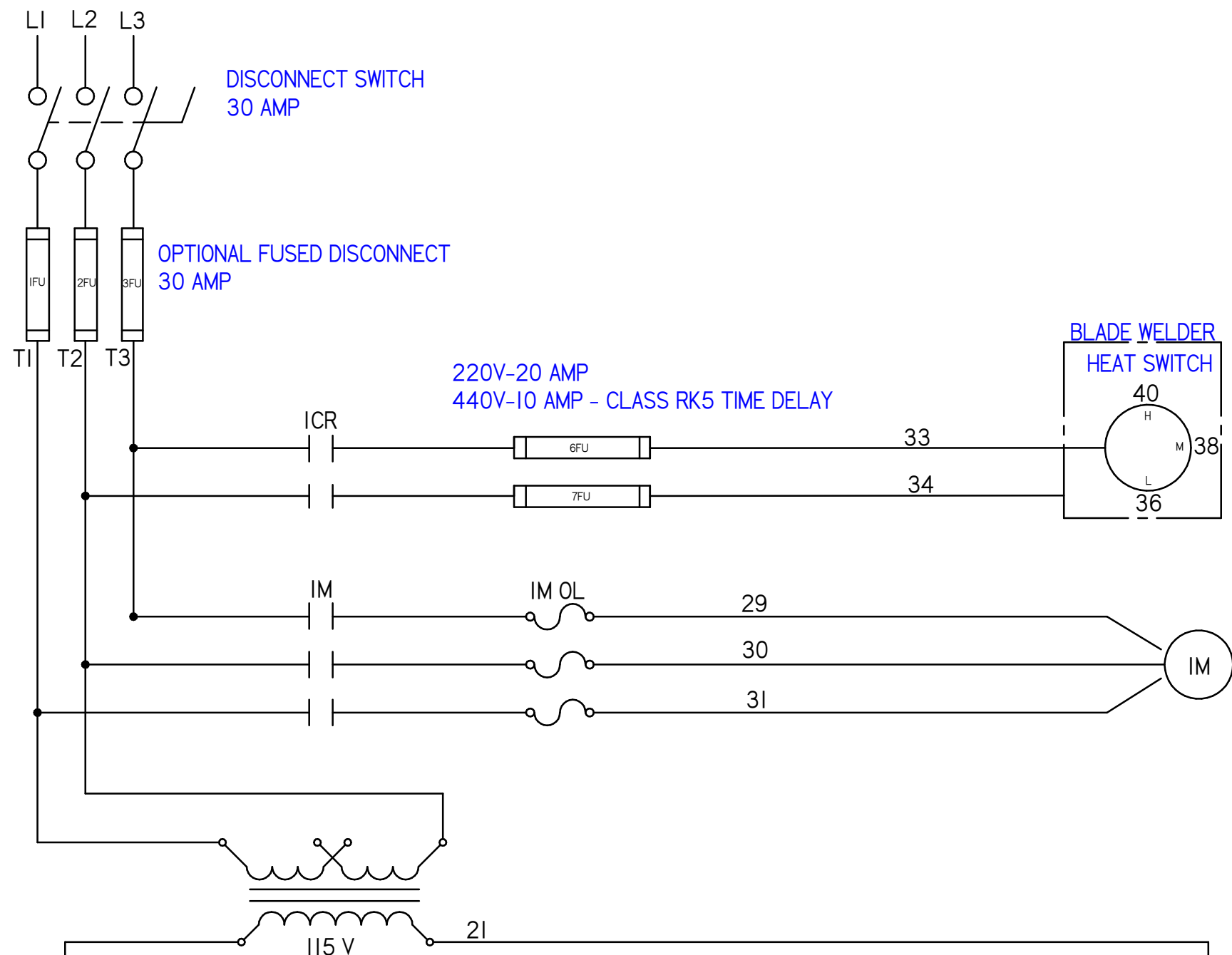
GROB INC. **GRAFTON, WIS.**

Table Assembly
for 4V Band Saws

DRN. KS	TR.	CH.	DWG. NO.
DATE 9-12-01	SCALE	O.K. Rev I	18284-C

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT

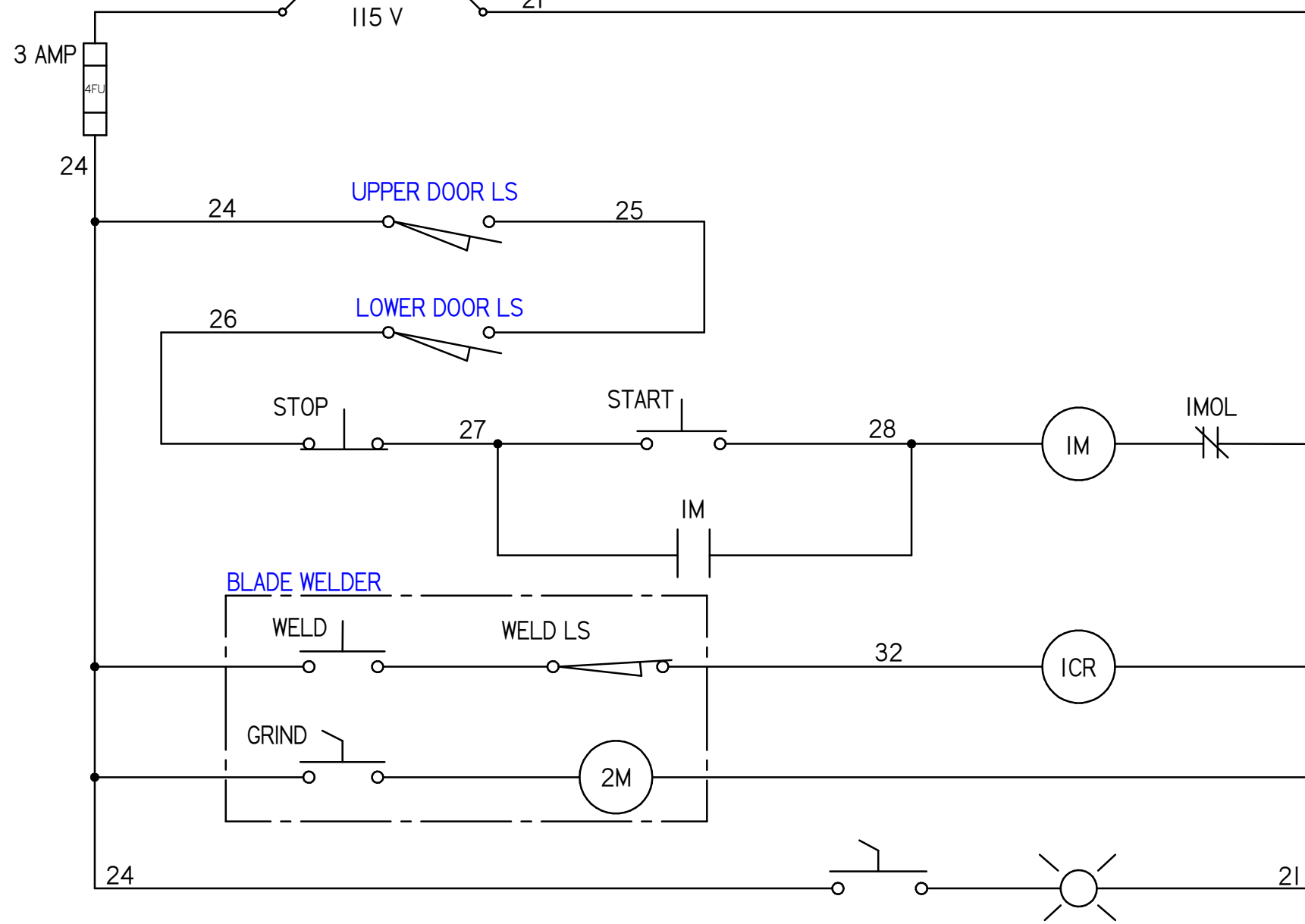
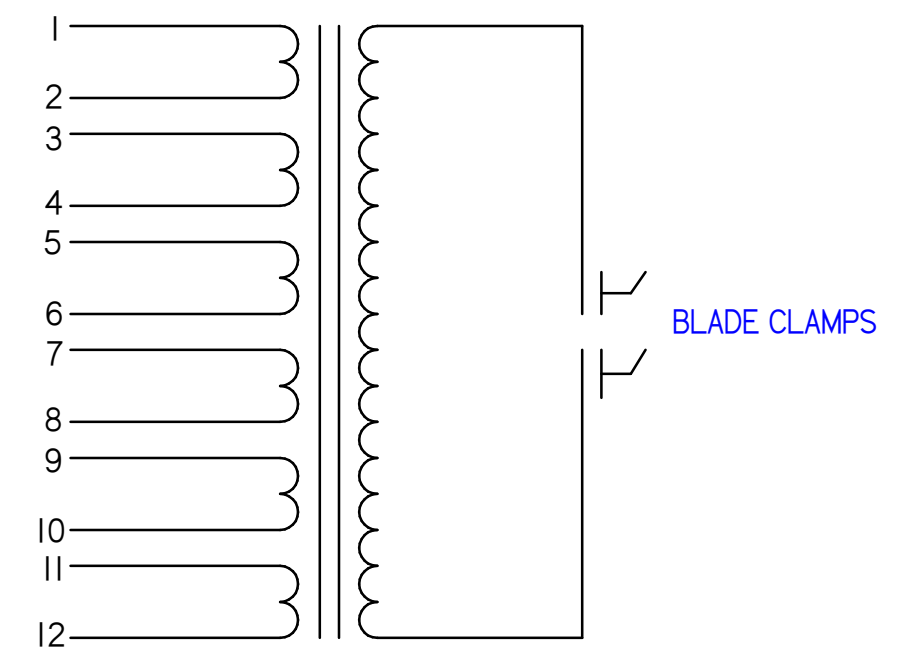
208/220/440/3Ph/60Cy



GROB RWA BLADE WELDER
(OPTIONAL) RELAY & FUSES
INCLUDED WITH WELDER

3 HP, 1750 RPM, 182T FRAME
DOUBLE SHAFT

WELDER TRANSFORMER



SAW MOTOR STARTER

BLADE WELDER RELAY
(INCLUDED WITH WELDER ONLY)

GRINDER MOTOR
(OPTIONAL ON BLADE WELDER)

WORKLIGHT
(OPTIONAL)

WELDER TRANSFORMER TERMINAL CONNECTIONS

440 VOLT

32	32
33	33
34	1
35	2,3
36	4,5,36
37	6,7
38	8,9,38
39	10,11
40	12,40

220 VOLT

32	32
33	33
34	1,3
35	2,4
36	5,7,36
37	6,8
38	9,11,38
39	
40	10,12,40

JUMPERS

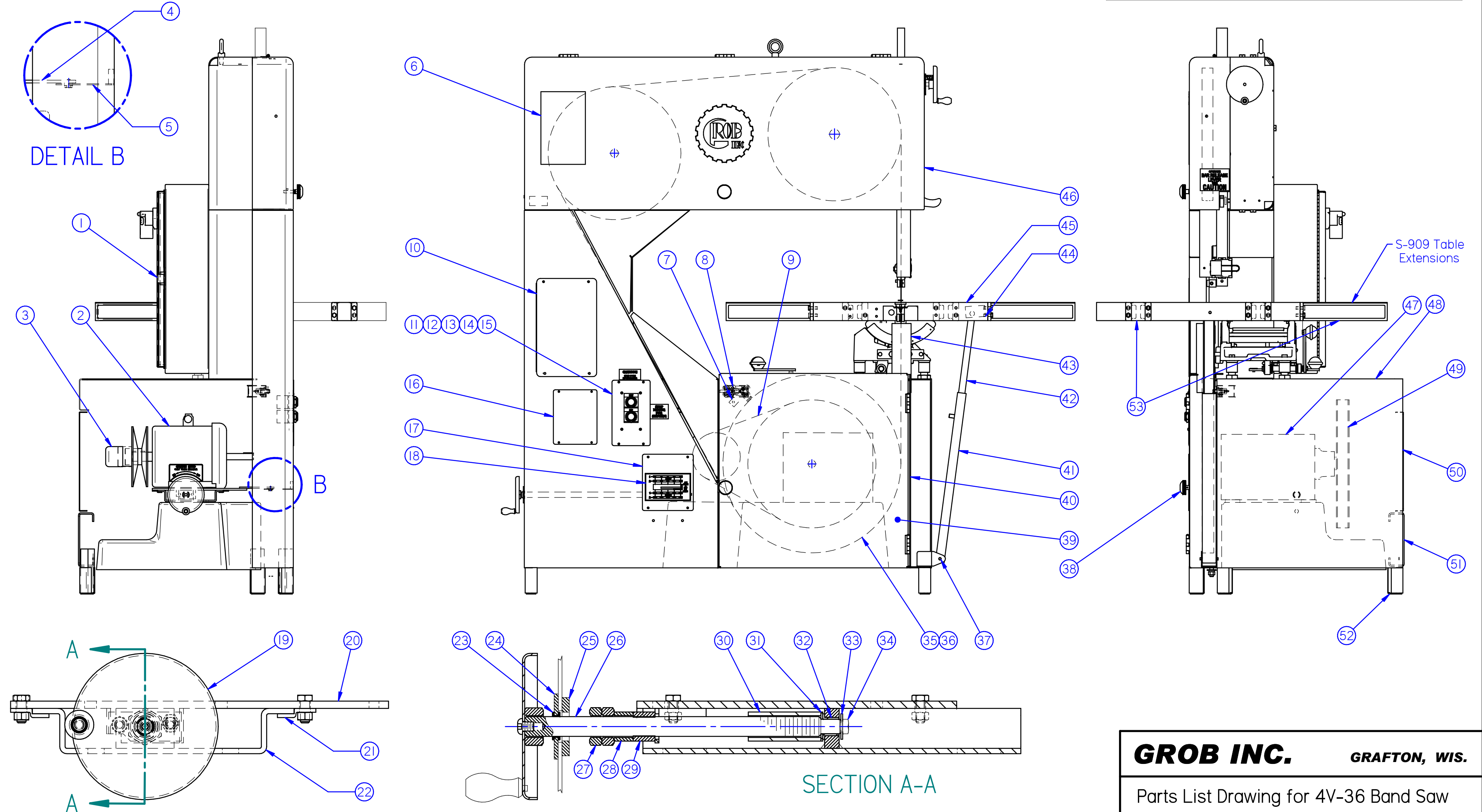
GROB INC. GRAFTON, WIS.

SCHMATIC WIRING DIAGRAM 208/220/440 VOLT
FOR 4V SERIES BAND SAW

DRN. SV	TR.	CH.	DWG. NO.
DATE 1-14-08	SCALE	O.K.	18410-C-1

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT
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Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	18371-C	Electrical Assembly	1	14	Stop Button	CH 10250T30R	1	27		3/4-10 Jam Nut	2	40	36013-B	Door Hinge Bracket	1
2	182T	3hp 230/460v. Motor	1	15		Push Button Box	1	28	HS-398-A	Spacer	1	41	18292-A	Lower Stabilizer Channel	1
3	18246-A	Grob Vari-Drive Pulley	1	16	18393-A	Blank Plate	1	29	18210-A	Speed Adjustment Nut	1	42	18293-A	Upper Stabilizer Channel	1
4	18122-A	Air Blower Support Plate	1	17	18128-A	Cover	1	30	18183-A	Spacer	1	43	36024-B	Lower Saw Band Guard	1
5	36044-A	Speed Indicator Pointer	1	18	24021-A	Speed Chart	1	31	S-1167-A	Washer	1	44	18291-A	Upper Table Support Brkt.	1
6	18111-B	Sawing Chart	1	19	18390	Speed Adj. Handwheel	1	32	FF-620-5	Oilite Bushing	1	45	18284-C	Table Assembly	1
7	GS-2077-A	Lower Wheel Brush Ass'y.	1	20	18121-B	Motor Support Plate	1	33		5/16" Flat Washer	1	46	36017-C	Head Assembly	1
8	18285-A	Switch Assembly	1	21	18218-A	Motor Clamp Plate	2	34		5/16-18 x 1/2 Hex Bolt	1	47	18180-C	Transmission Assembly	1
9	2322V681	4V-36 Vari-Speed Drive Belt	1	22	18117-B	Motor Slide Channel	1	35	24007-C	Lower Saw Pulley	1	48	36011-D	Frame	1
10	GS-2286-B	Blank Plate	1	23	F-319-A	Bushing	1	36	S-1361	Rubber Tire	1	49	24001-C	Drive Pulley	1
11	18321-A	Push Button Plate	1	24	36009-A	Screw Support	1	37	18295-A	Table Support Pin	2	50	24014-A	Rear Base Cover	1
12	18323-A	Gasket	1	25	36008-A	Screw Support Clamp	1	38	GS-2212-A	Door Knob Assembly	1	51	24013-B	Rear Base Support Channel	1
13	Start Button	CH 10250T30B	1	26	36007-A	Speed Adjustment Screw	1	39	36012-B	Base Door	1	52	18189-A	Leg Cover for 18174 Leg	4
												53	S-909-B	Table Extension	6



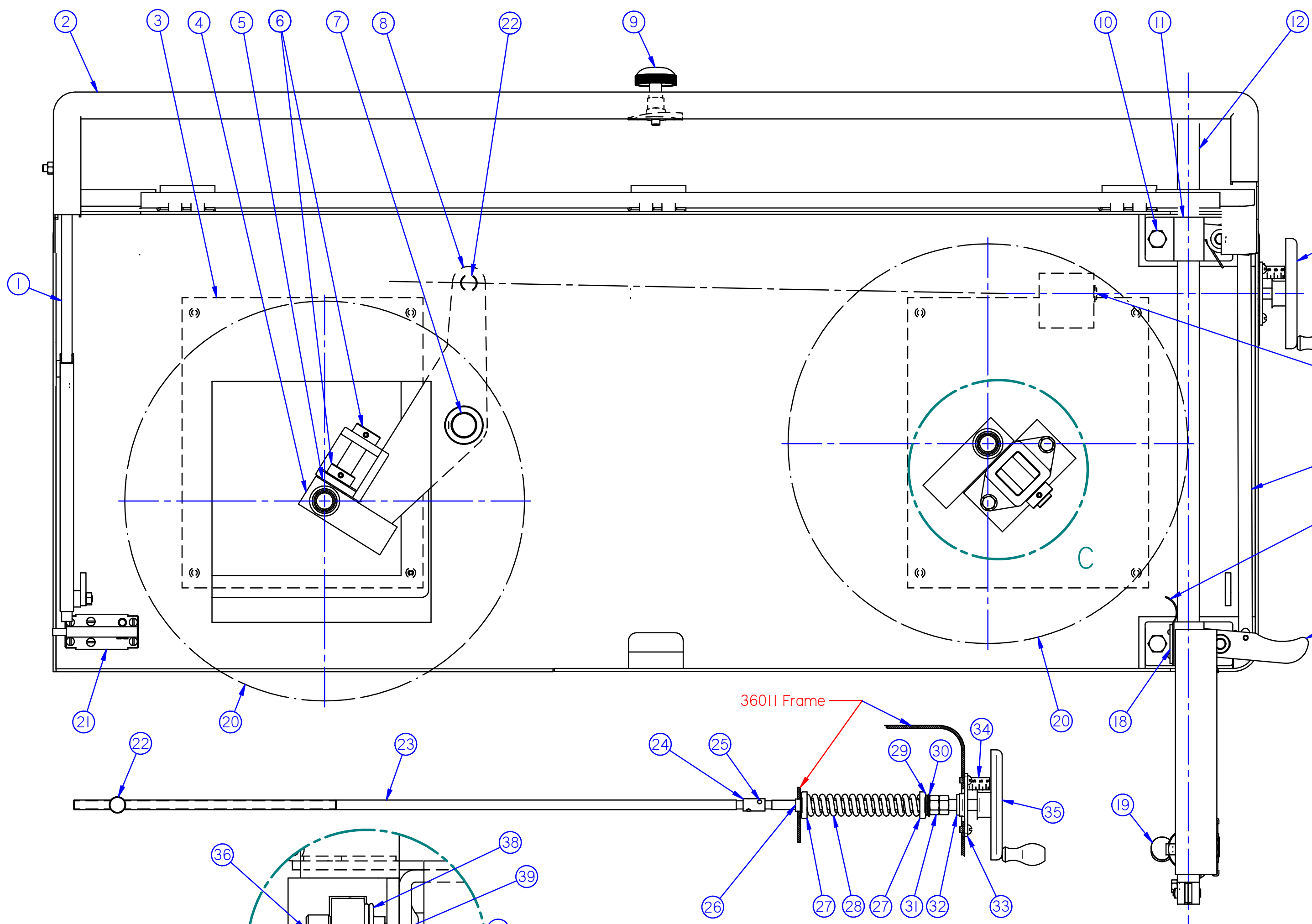
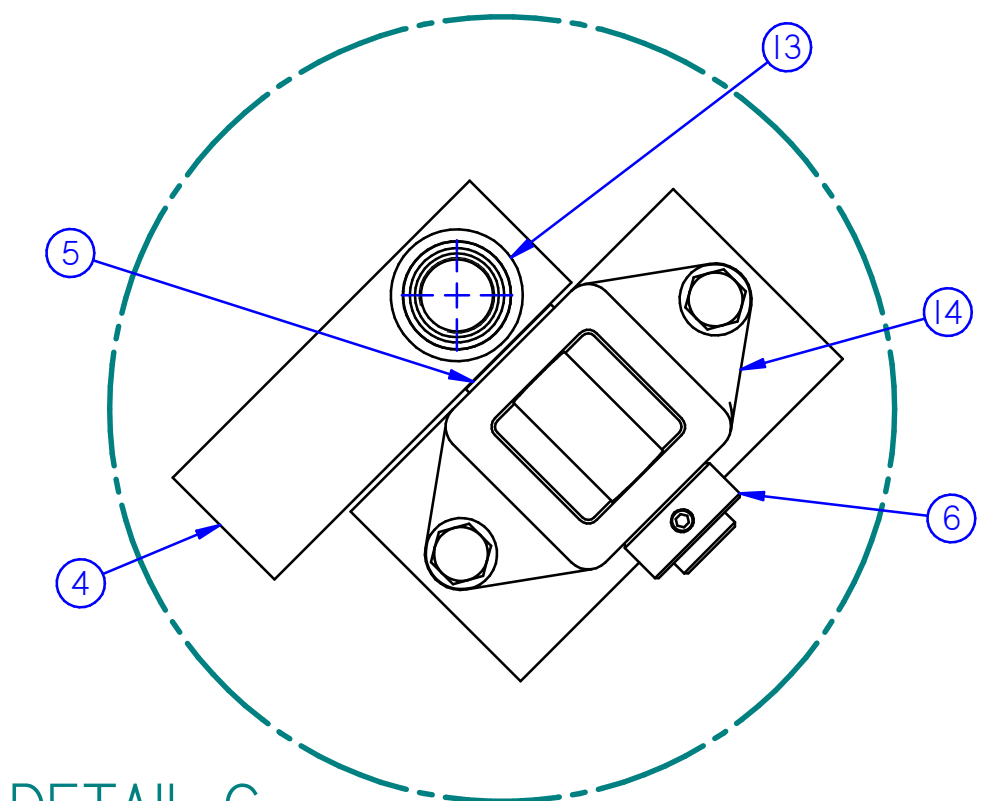
GROB INC. GRAFTON, WIS.

Parts List Drawing for 4V-36 Band Saw

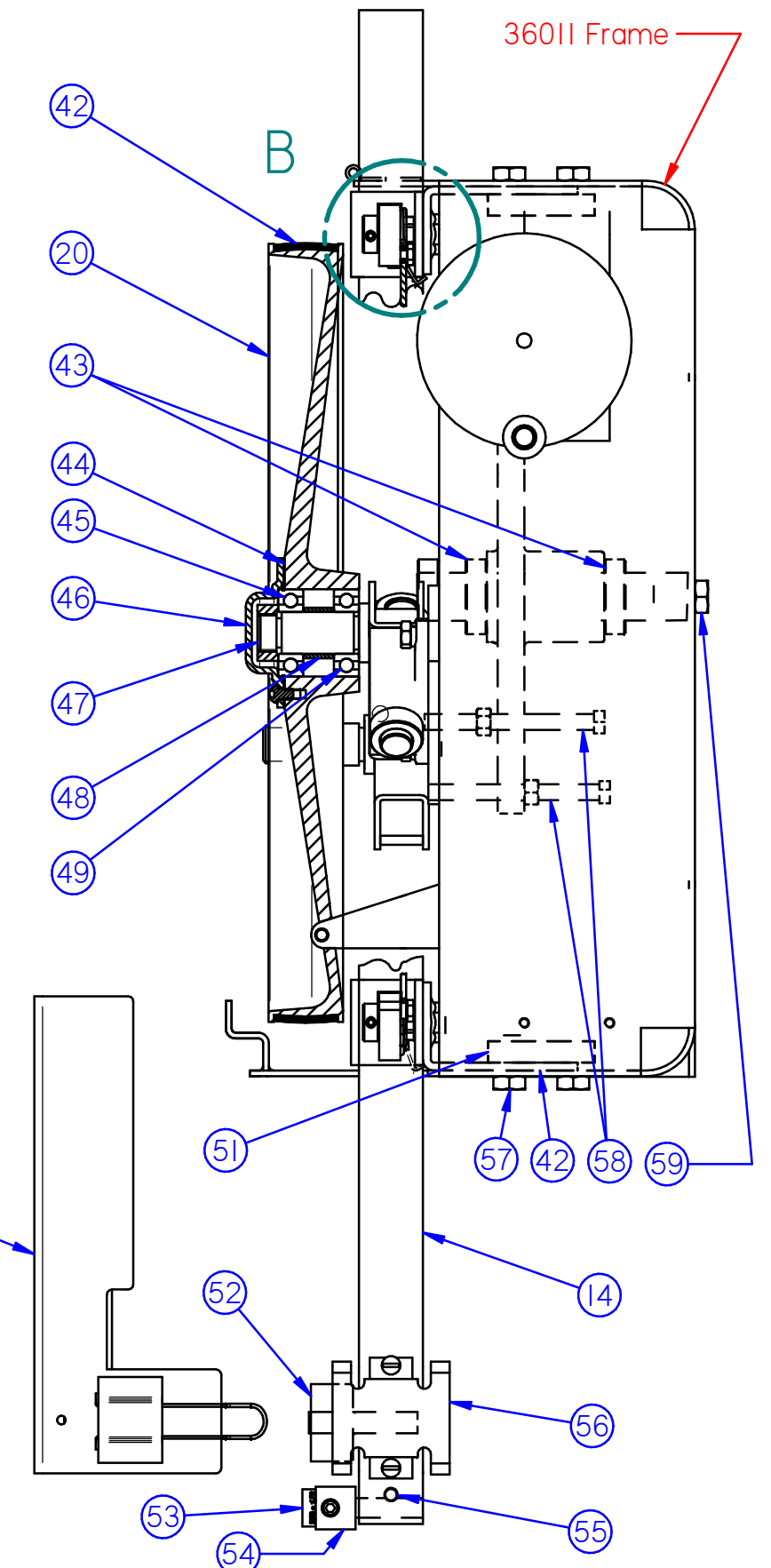
DRN. Grob8	TR. KS	CH.	DWG. NO.
DATE 9-17-02	SCALE 1:10	O.K. Rev 2	36015-C

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT

Item	Part No.	Description	Qty.	Item	Part No.	Description	Qty.	Item	Part No.	Description	Qty.	Item	Part No.	Description	Qty.
1		Atwood #12595 Door Prop	2	16	18170	Tension Spring	1	31	1/2-20 Jam Nut	2	46	S-1152	Bearing Cover	2	
2	36021	Upper Door Assembly	1	17	S-1022	Lower Guide Bar Clamp	1	32	FF-707-5	Oilite Bushing	1	47		7/8-14 Hex Nut	2
3	36025	Cover for Access Hole	2	18	18289	Tension Spring Clamp Plate	1	33	18177	Tension Screw Support Brkt.	1	48	GS-2147	Upper Pulley Bearing Spacer	2
4	S-1296	Pulley Pivot Channel Ass'y.	2	19		1/4-20 x 1/2 Thumb Screw	1	34	18176	Tension Indicator	1	49	6205-Z	Peer Bearing	2
5		Shim Washer	2	20	GS-2068-1	Upper Saw Pulley	2	35	18391	Tension Handwheel Assy.	1	50	18141	Upper Saw Band Guard	1
6	18348	3/4" Set Collar	3	21	18285	Switch Assembly	1	36	18232	1/2" Set Collar	2	51	18185	Clamp Block	2
7	GS-1513	Idler Pulley Lever Shaft	1	22	S-1090	Tension Screw Nut	1	37	S-1023	Upper Guide Bar Clamp	1	52	S-1276	Saw Band Oiler Assembly	1
8	GS-1512	Idler Pulley Lever	1	23	S-943	Saw Band Tension Screw	1	38	S-1077	Guide Bar Clamp Spring	2	53	Guide	1 Pc.Hard Aluminum Bronze	1
9	GS-2212	Door Knob Assembly	1	24	S-1053	Universal Coupling	1	39	18214	Guide Bar Clamp Pin	2	54	S-1071	1/8"-1/2" S-1124 5/8"-1"	1
10		1/2-20 x 3/4 Hex Bolt	2	25	18358	Pin	2	40	GS-2222	Clamp Link Spacer	2	55	S-547	Guide Holder Clamp Stud	1
11	S-1017	Guide Bar Block	2	26	S-1102	Handwheel Shaft Bearing	1	41	18169	Guide Bar Bracket	2	56	GS-2249	Saw Band Guard Nest	1
12	18139	Upper Guide Bar	1	27	S-1084	Compression Spring Cup	2	42	GS-2079	18" Pulley Tire	2	57		1/2-13 x 3/4 Hex Bolt	4
13	18324	Upper Pulley Bearing Spacer	2	28	S-1135	Compression Spring	1	43	18349	1 1/8" Set Collar	2	58		3/8-16 x 4 Square Hd Screw	2
14	S-966	Pivot Bracket	1	29	R5498	NICE Bearing	1	44	GS-2367	Gasket	2	59		1/2-13 x 1 Hex Bolt	1
15	36020	Clamp Link	1	30	S-1167	Retaining Washer	1	45	6205-NR	Peer Bearing	2	60			



DETAIL C



DETAIL B

Item #54 Single Piece Guide Holder Shown, See Holder Sheet for Other Listings.

Item #53 Single Piece Hard Aluminum Bronze Saw Guide Shown, Carbide Also Available. See Guide Sheet for Other Listings.

GROB INC.		GRAFTON, WIS.	
Head Assembly for 4V-36 Band Saw			
DRN. KS	TR.	CH.	DWG. NO.
DATE 5-7-03	SCALE 1:4	O.K. Rev I	36017-C

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT

GROB INC.

Installation and Maintenance

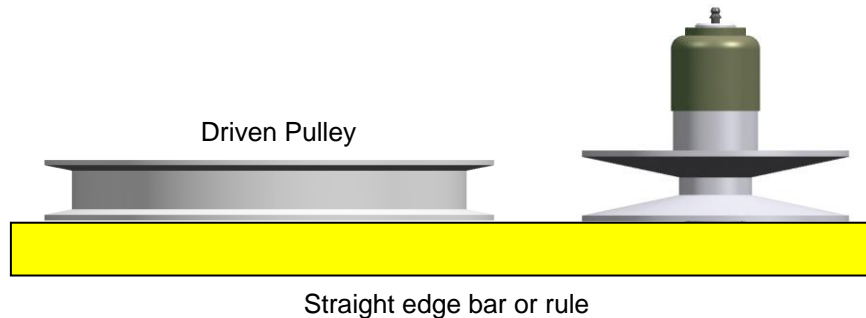
for

Vari-Drive Motor Pulley #18246

Installation

Caution: Make sure Line Switch is on OFF.

- 1 Check motor shaft and key.
- 2 Before placing key on shaft, make sure pulley slides freely. Use a fine grade of emery cloth to remove any burrs or rust. Oil motor shaft for easy future removal of pulley. *DO NOT FORCE PULLEY ON SHAFT.*
- 3 Mount Pulley on motor shaft. Position its proper alignment to the driven pulley by using a straight edge bar or rule as shown below.



Note: *Alignment must be accurate to avoid undue belt vibration or wear*

- 4 When the alignment is correct, tighten the two self locking set screws.
- 5 REPLACING BELT: Turn speed crank to move motor towards gear box until it stops.
- 6 Use a wooden wedge to spread the sheaves apart far enough to permit belt to go on both pulleys. Remove wedge and rotate pulley until belt is tight. *DO NOT PRY THE BELT ON.*
- 7 The belt should run level between the faces of the sheaves. If one side rides high with belt on an angle, investigate immediately. Belt alignment may be the cause, or a defective belt.

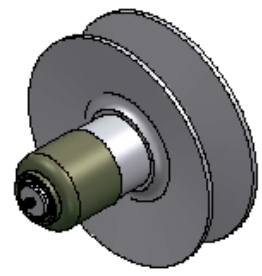
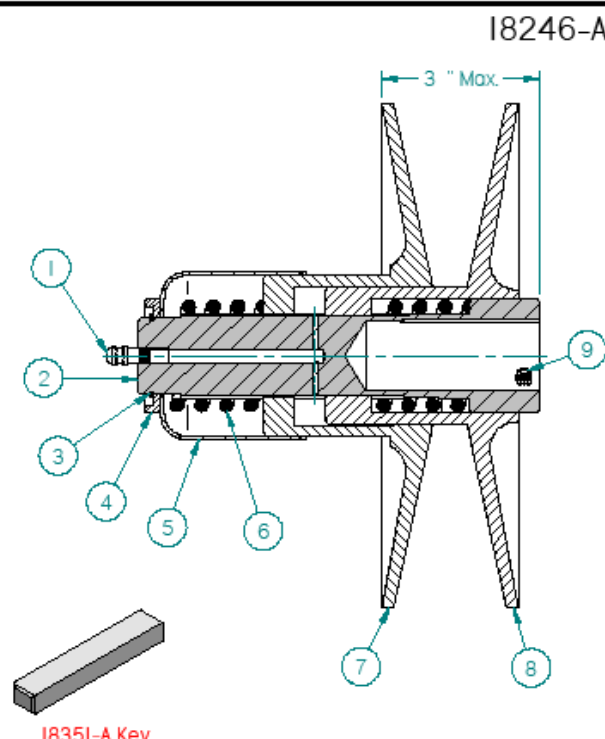
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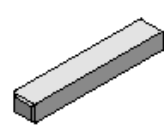
MAINTENANCE

- 1 The face of the disc and belt should be kept clean and free from grease or other liquids.
- 2 **IMPORTANT:** The pulley should be run through its speed range after each several hours of operation in order to lubricate all working surfaces.
- 3 **LUBRICATION:** The lubricant to be used should be a premium lithium based grease. Grease pulley after approximately 40 hours of operation.

CAUTION: DO NOT OVER GREASE. One or two cubic inches of grease is sufficient. Too much grease could spread to belt.

Item Number	Document Number	Title	Quantity
1	#1652-B	Alemite Grease Fitting	1
2	I8241-A	Vari-Drive Shaft	1
3	5100-I25	External Retaining Ring	1
4	I8242-A	Vari-Drive Retainer	1
5	I8243-A	Vari-Drive Cup Shield	1
6	I8252-A	Spring	2
7	I8239-B	Vari-Drive Sheave, Front	1
8	I8240-B	Vari-Drive Sheave, Rear	1
9	I/4-20 x I/4	Set Screw-Cup pt. with Thread Lock	2



I835I-A Key

First Used On				18246-A	
Model	Serial No.			GROB INC. GRAFTON, WIS.	
4V-18	I160			Vari-Drive Pulley Assembly for 4V Band Saws	
4V-24	638			DRW. NO. 18246-A	
4V-36	I06I			NO. REQ'D PATT. NO. MATERIAL HEAT TREATMENT	
				DRN KS	TR
				DATE I-29-01	SCALE I:2
				CHK	O.K. Rev I

IMPORTANT NOTICE !!

IDENTIFICATION OF GROB SELF SEATING SAW GUIDES

YELLOW-----1/8"x .025" WHITE-----3/8" - 1/2"x .025"

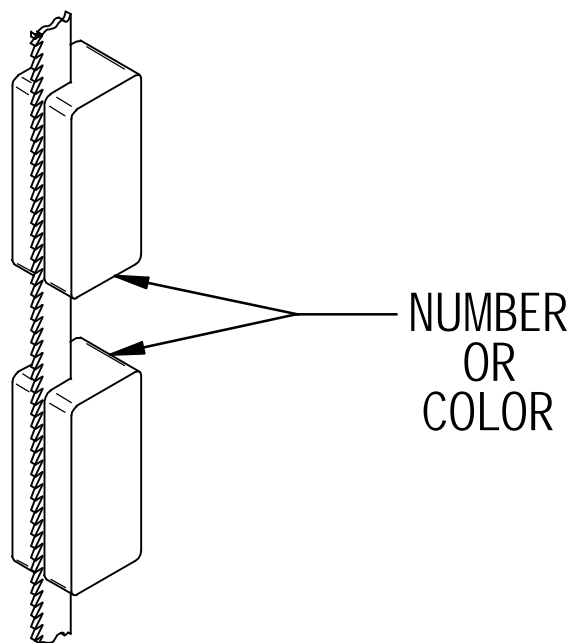
RED----- 3/16"x .025" BLACK-----5/8"x .032"

GREEN-----1/4" - 5/16"x .025" BROWN-----3/4"x .032"

BLUE-----3/8" - 1/2"x .035" ORANGE-----7/8" - 1"x .035"

AFTER SAW GUIDES HAVE BEEN SEATED, THEY WILL WEAR VERY LITTLE. IT IS IMPORTANT THAT A "SEATED GUIDE" IS CLAMPED IN ITS PREVIOUSLY "SEATED" POSITION.

FOR BETTER SERVICE AND LONGER LIFE OF SAW BLADE,
ALWAYS CLAMP GUIDE IN SAME RELATIVE POSITION TO WORK.





GROB 4V-36 Parts

GrobBandSaw.com
888-550-3116

