



GROB 6V-36 Parts

GrobBandSaw.com
888-550-3116



INSTRUCTIONS FOR INSTALLING HS-235 TENSION SHAFT

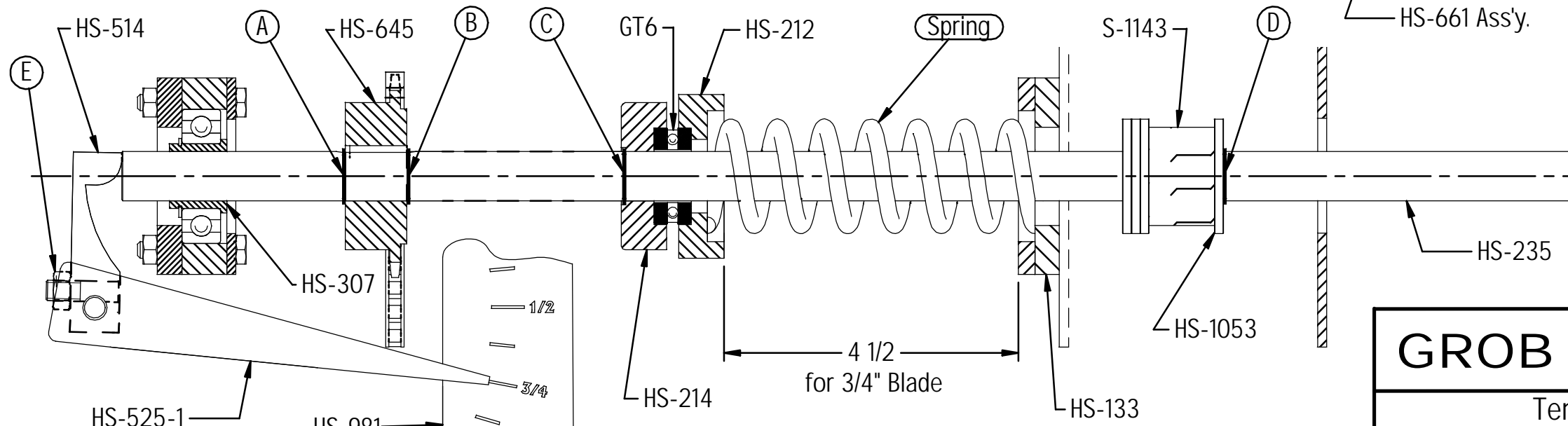
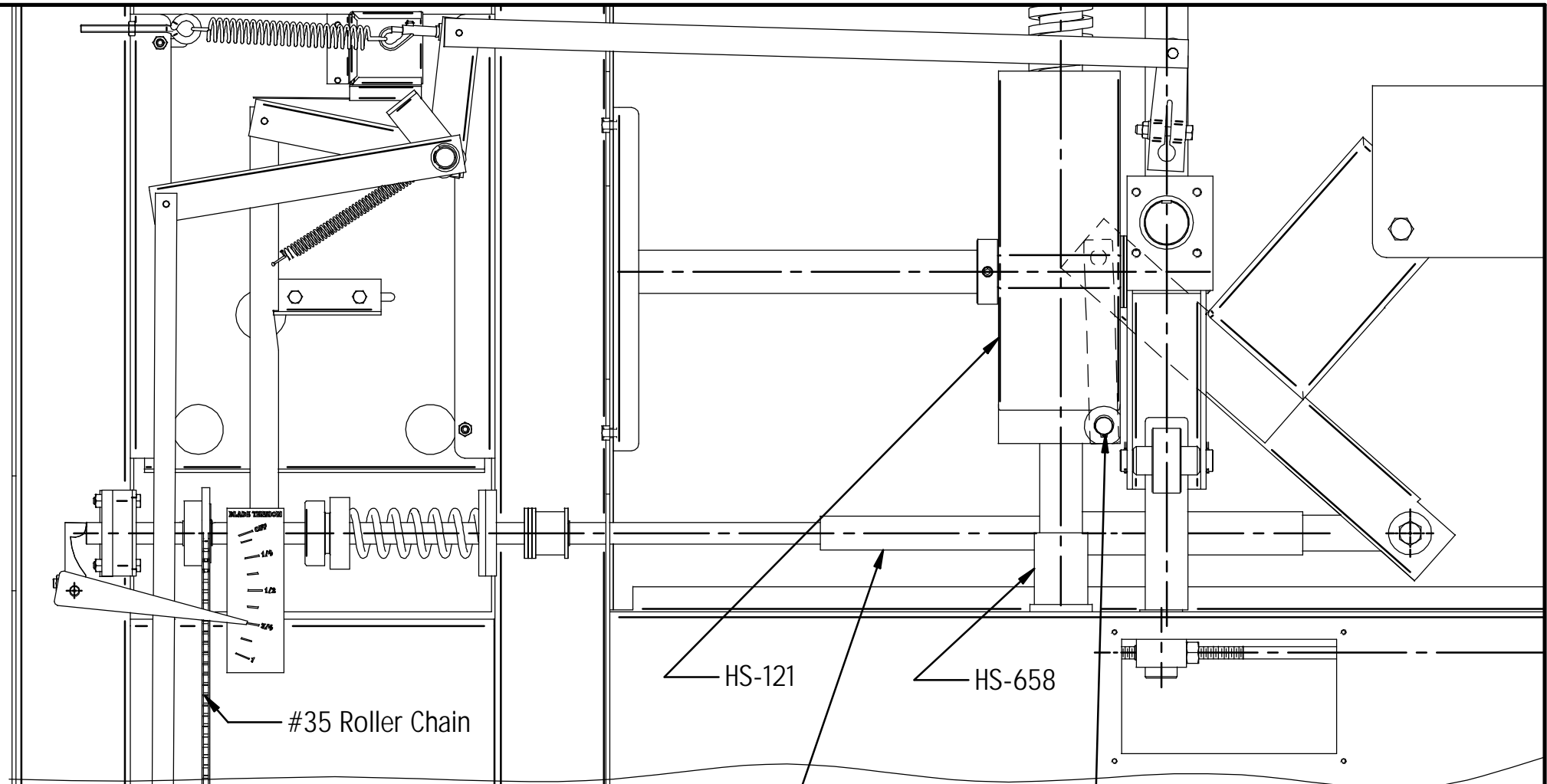
- 1 Slide threaded end of Tension Shaft thru HS-307 Bearing.
- 2 Assemble Parts in order as follows: HS-645, HS-214, GT6 Brg., HS-212, and Spring.
- 3 Slide Shaft thru HS-133 Frame Plate and assemble 3 HS-1053 Washers, S-1143 Rubber Bumper and 1 HS-1053 Washer onto Shaft.
- 4 Slide Shaft forward and install 5103-75 Retaining Rings marked A, B, D, and lastly C.
- 5 Turn Shaft until it is caught with nut in HS-661 Assembly

SETTING TENSION INDICATOR

- 1 Turn Tension Shaft to establish 4 1/2" dimension as shown below.
- 2 Loosen Nut E, set HS-525 Indicator at 3/4 on HS-981 Tension Plate, push HS-514 Lever up against Shaft and tighten Nut E.

REMOVING TENSION SHAFT

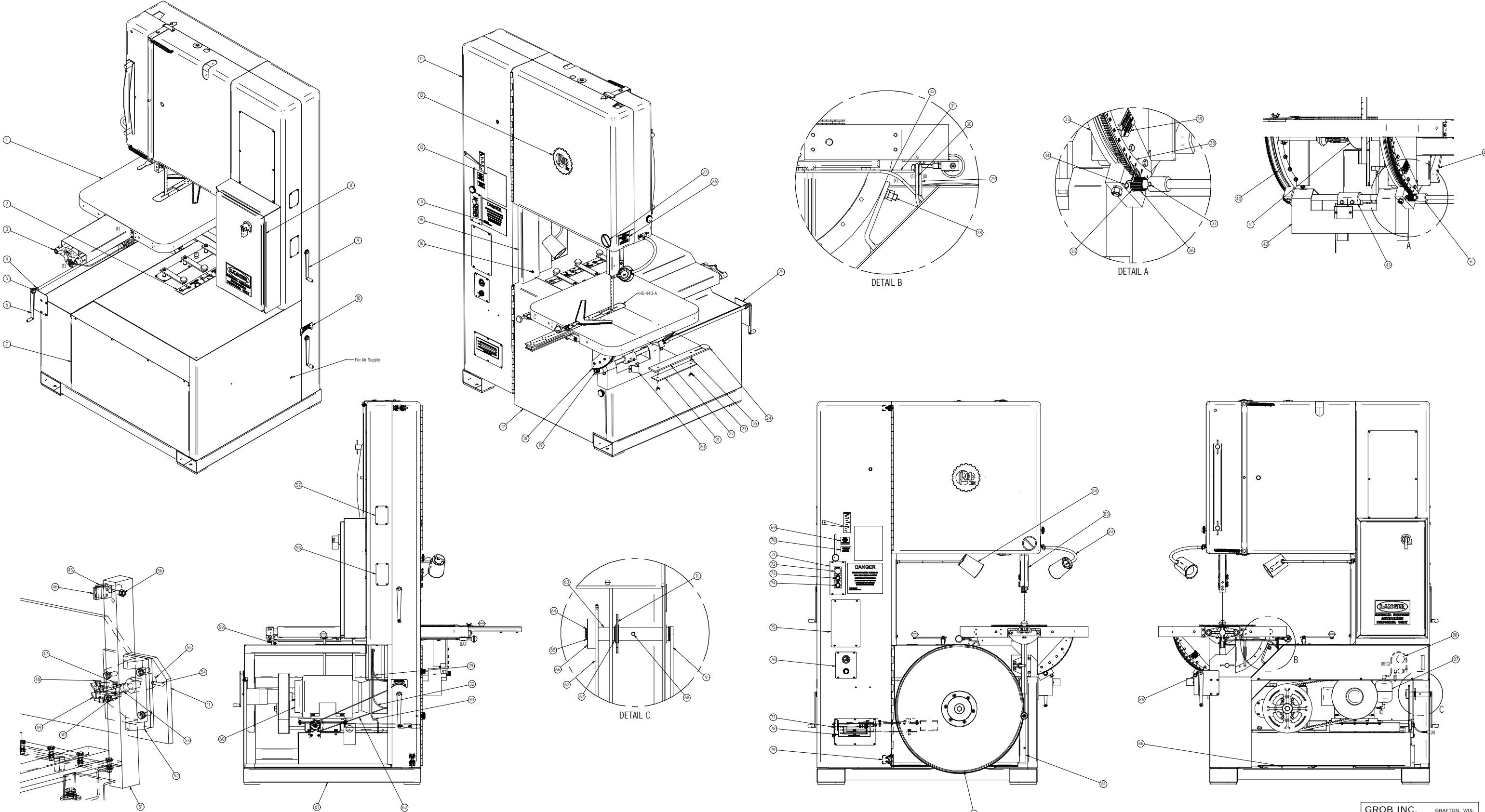
- 1 Lower HS-121 Carriage to HS-658 Stop. Remove 5100-62 Retaining Ring and HS-253 Pin.
- 2 Unscrew Tension Shaft from HS-661 Assembly.
- 3 Remove 3 5103-75 Retaining Rings A, B, and C.
- 4 Slide Shaft in and remove 5103-75 Retaining Ring D.
- 5 Remove 4 Washers and Rubber Bumper and slide Shaft out.

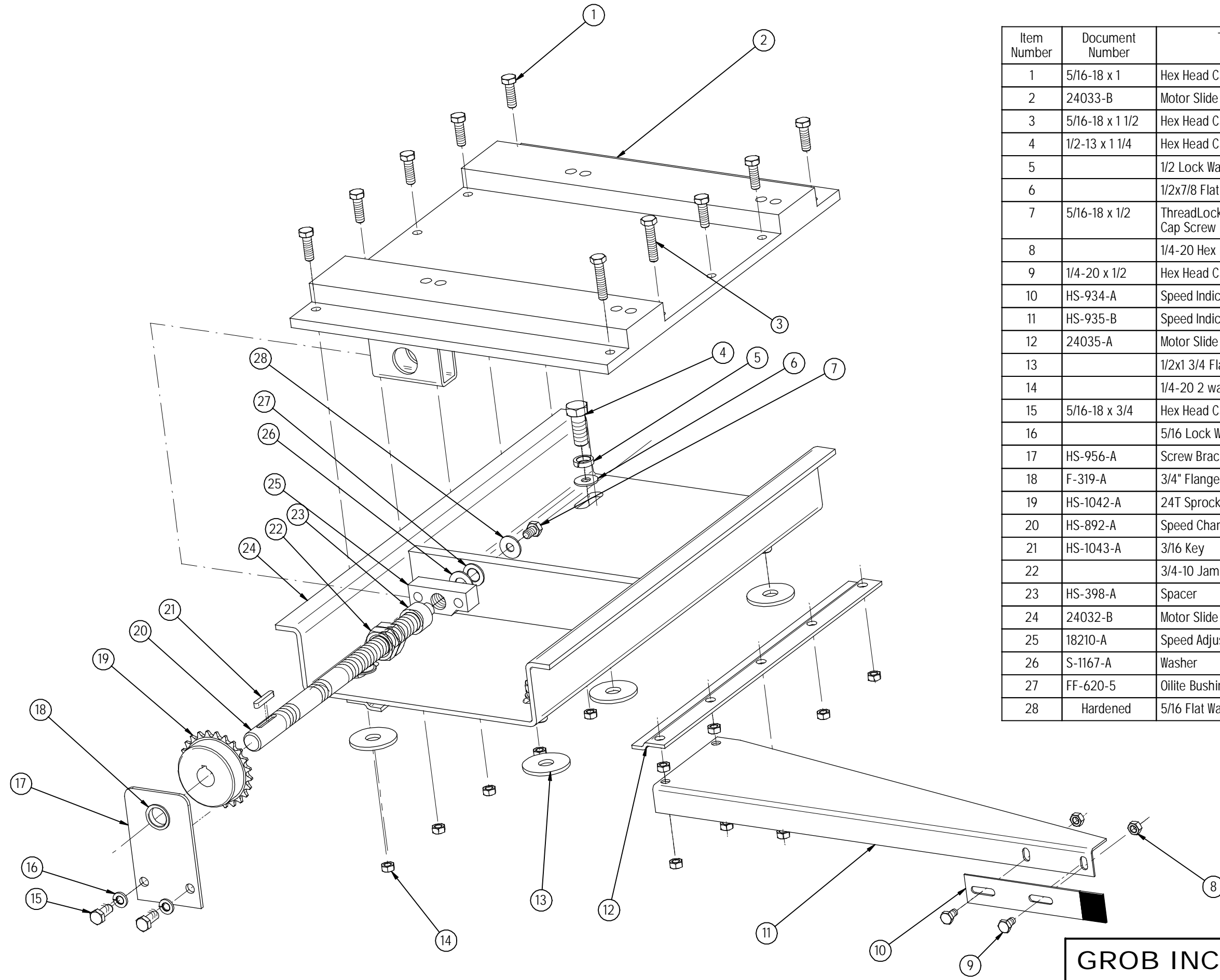


GROB INC. GRAFTON, WIS.
 Tension Shaft Instructions
 for 6V-36 Band Saw

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS DATE 12-17-01	TR. SCALE	CH. O.K.	DWG. NO. HS-1051-B
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Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity				
1	HS-950-D	Table	1	10	HS-125-A	H / Lo Speed Decal	1	19	HS-243-A	Table Tilt Pinion	1	28	HS-434-A	T-Bolt - Short	1	37	HS-644-A	Coupling Pin	1	46	GS-2236-A	T Single Price Saw Guide	2	55	HS-547-A	Clamp Pin Nut	1	64	5100-75	External Retaining Ring	1	73	Stop Button	CH 10250130R	1	82	Work Light - Short	1	
2	HS-932-A	Decal - Shift Positions	1	11	HS-505-D	Frame	1	20	HS-965-A	Table Tilt Stop	1	29	HS-281-C	Table Tilt Scale	1	47	HS-1068-A	Wt Wagon Box Head Pin	1	56	S-547-A	Guide Holder Clamp Stud	2	65	HS-580-A	Chain Adjustment Cover	1	66	HS-850-A	40 Tooth Sprocket	1	75	GS-2286-B	Built Wider Blank Plate	1	84	HS-941-B	Upper Saw Band Guard	1
3	HS-745-C	Air / Hydraulic Feed Assy	1	12		8" Grob Decal	1	21	HS-441-A	Table Filter Plate (Front)	1	30	HS-610-A	Table Tilt Warning	1	48	HS-587-A	Guide Bar Clamp Pin	2	57	HS-562-A	Tension Pickup Cover	1	67	5100-112	External Retaining Ring	2	76	HS-923-B	Air Gauge & Valve Assy	1	85	HS-435-A	T Bolt - Long	1				
4	HS-348-A	3/4" Set Collar	1	13		Sawing Chart	1	22	HS-439-A	Table Filter Plate (Rear)	1	31	HS-106-B	Outer Table Support Bracket	1	49	HS-588-A	Clamp Pin	2	58	HS-560-A	Chain Adjustment Cover	1	68	5100-112	External Retaining Ring	2	76	HS-923-B	Air Gauge & Valve Assy	1	85	HS-435-A	T Bolt - Long	1				
5	F-319-A	3/4" Flanged Bushing	4	14		DMG2R Plate	1	23	HS-439-A	Table Filter Plate (Rear)	1	31	HS-106-B	Outer Table Support Bracket	1	49	HS-588-A	Clamp Pin	2	58	HS-560-A	Chain Adjustment Cover	1	68	5100-112	External Retaining Ring	2	76	HS-923-B	Air Gauge & Valve Assy	1	85	HS-435-A	T Bolt - Long	1				
6	HS-303-B	Table Tilt Crank Assembly	1	15	HS-309-C	Rear Saw Band Guard	1	24	HS-963-A	5/16" B Wing Nut	1	32	HS-107-B	Lower Table Support Bracket	2	42	HS-221-C	Table Support	1	50	HS-324-A	Guide Bar Clamp	1	69	HS-442-A	Tension Crank Pin	1	77	HS-933-A	Speed Chart Plate	1	86	HS-1000-A	RS Lower Base Pin	2				
7	HS-954-B	Rear Base Cover	1	16	HS-1074-A	Rear Saw Band Guard	1	24	HS-963-A	5/16" B Wing Nut	1	32	HS-107-B	Lower Table Support Bracket	2	42	HS-221-C	Table Support	1	50	HS-324-A	Guide Bar Clamp	1	69	HS-442-A	Tension Crank Pin	1	77	HS-933-A	Speed Chart Plate	1	86	HS-1000-A	RS Lower Base Pin	2				
8	HS-1076-C	Electrical Box Assembly	1	17	HS-125-C	Base Door Assembly	1	26	HS-436-B	Table Tilt Crank Support	1	34	HS-437-A	Table Index Painter	1	43	HS-241-B	Table Tilt Shaft Clamp	1	52	HS-633-C	Lower Clamp Frame	1	61	HS-1027-D	Sub Base	1	70	HS-231-A	Caution Close Door Decal	1	79	HS-285-A	Door Limit Switch Assy	2	88	HS-978-B	Front Base Cover	1
9	HS-593-A	Crank Assembly	2	18	HS-244-C	Gear Sector	2	27	HS-436-B	Table Tilt Crank Support	1	34	HS-437-A	Table Index Painter	1	43	HS-241-B	Table Tilt Shaft Clamp	1	52	HS-633-C	Lower Clamp Frame	1	61	HS-1027-D	Sub Base	1	70	HS-231-A	Caution Close Door Decal	1	79	HS-285-A	Door Limit Switch Assy	2	88	HS-978-B	Front Base Cover	1



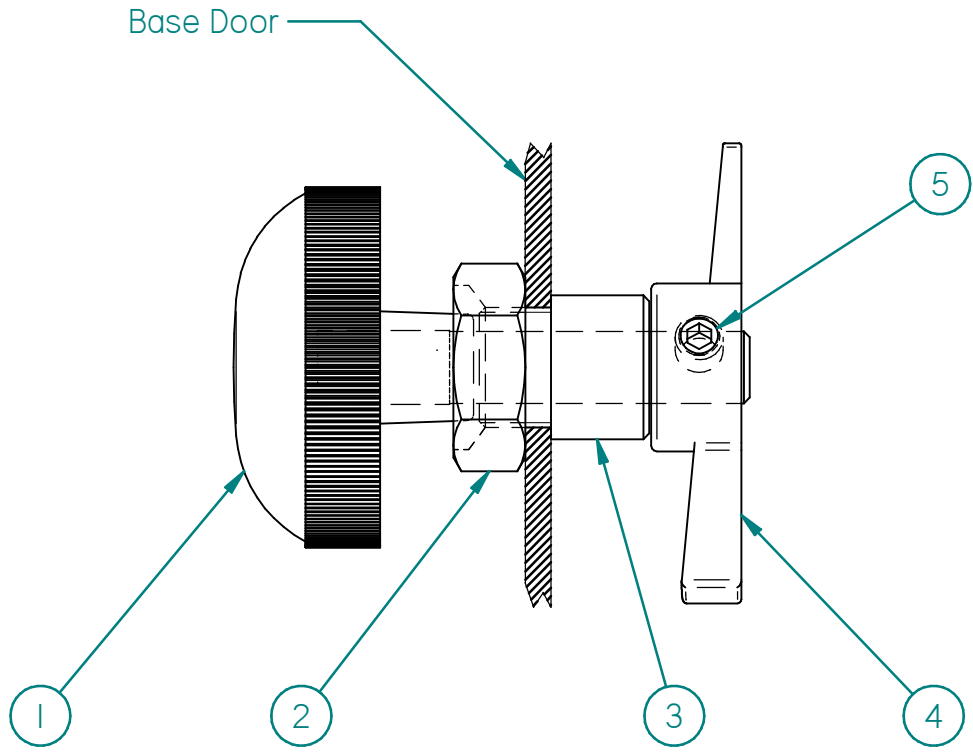


Item Number	Document Number	Title	Quantity
1	5/16-18 x 1	Hex Head Cap Screw	8
2	24033-B	Motor Slide Plate	1
3	5/16-18 x 1 1/2	Hex Head Cap Screw	2
4	1/2-13 x 1 1/4	Hex Head Cap Screw	4
5		1/2 Lock Washer	4
6		1/2x7/8 Flat Washer	4
7	5/16-18 x 1/2	ThreadLocked Hex Head Cap Screw	1
8		1/4-20 Hex Nut	2
9	1/4-20 x 1/2	Hex Head Cap Screw	2
10	HS-934-A	Speed Indicator	1
11	HS-935-B	Speed Indicator Bracket	1
12	24035-A	Motor Slide Clamp	2
13		1/2x1 3/4 Flat Washer	4
14		1/4-20 2 way Lock Nut	12
15	5/16-18 x 3/4	Hex Head Cap Screw	2
16		5/16 Lock Washer	2
17	HS-956-A	Screw Bracket	1
18	F-319-A	3/4" Flanged Bushing	1
19	HS-1042-A	24T Sprocket	1
20	HS-892-A	Speed Change Screw	1
21	HS-1043-A	3/16 Key	1
22		3/4-10 Jam Nut	2
23	HS-398-A	Spacer	1
24	24032-B	Motor Slide Channel	1
25	18210-A	Speed Adjustment Nut	1
26	S-1167-A	Washer	1
27	FF-620-5	Oilite Bushing	1
28	Hardened	5/16 Flat Washer	1

GROB INC. GRAFTON, WIS.

Motor Slide Assembly
for 6V-36 Band Saw

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS DATE 9-18-02	TR. SCALE	CH. O.K.	DWG. NO. HS-1078-C
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Item Number	Document Number	Title	Quantity
1	HS-1085-A	Knob Assembly	1
2	HS-1084-A	Countersunk Jam Nut	1
3	HS-1081-A	Base Door Latch Ferrule	1
4	S-587-A	Base Door Clamp	1
5	1/4-20 x 1/4	Set Screw-Cup pt	1

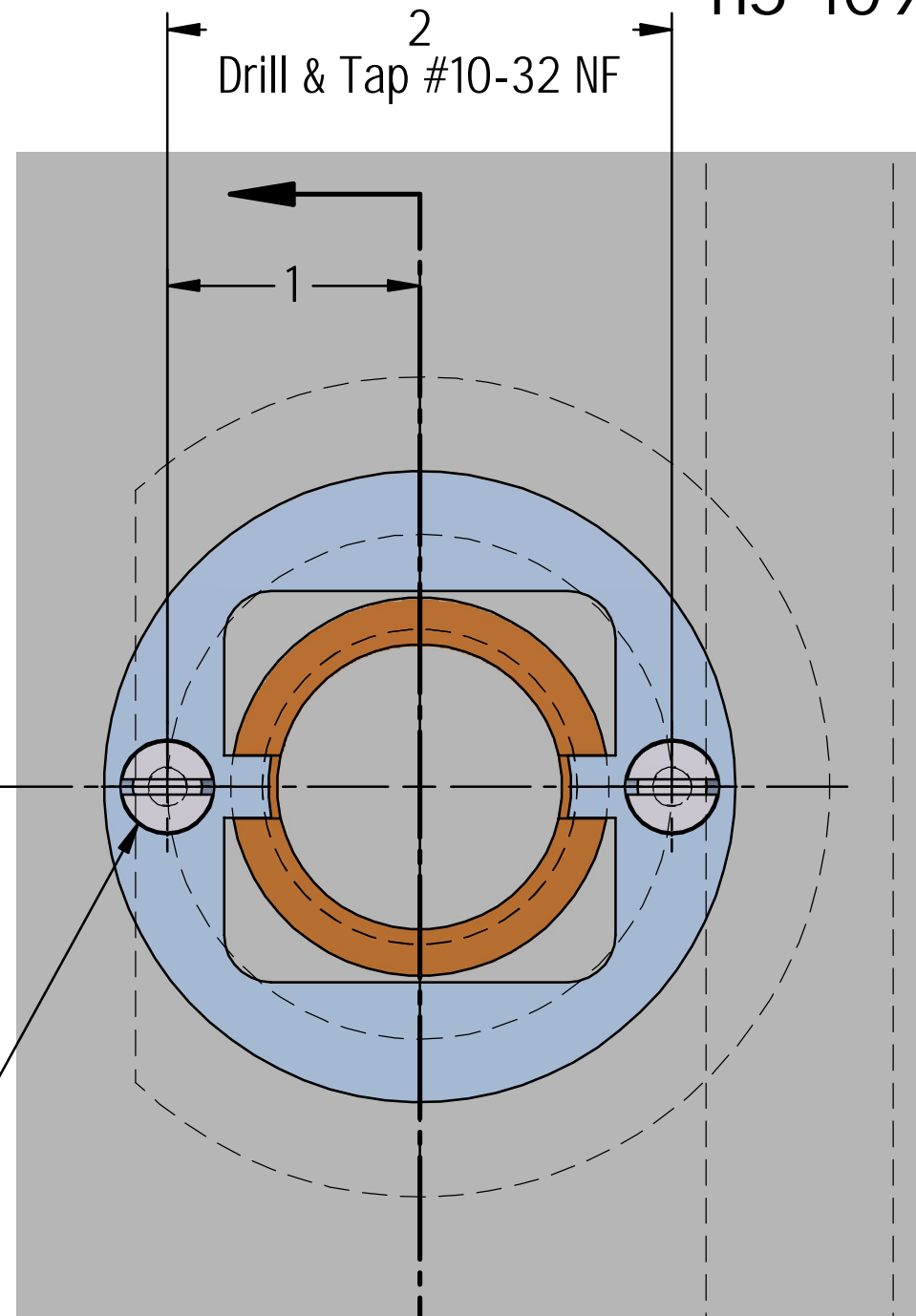
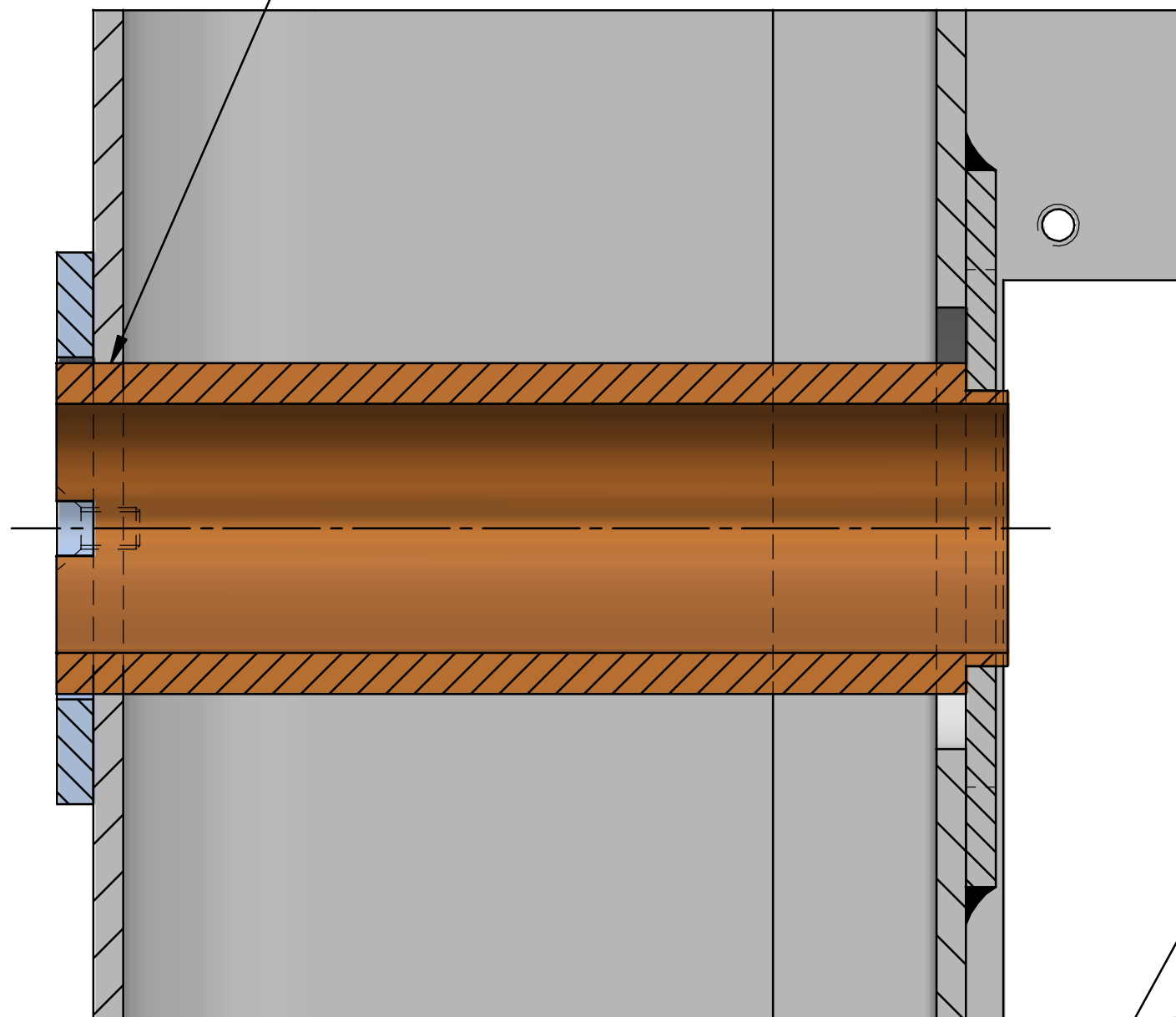
GROB INC. **GRAFTON, WIS.**

Base Door Latch Assembly
for 6V-36 Band Saw

One				DRN. KS	TR.	CH.	DWG. NO.
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 10-16-02	SCALE 1:1	O.K.	HS-1080-A

HS-1094-A

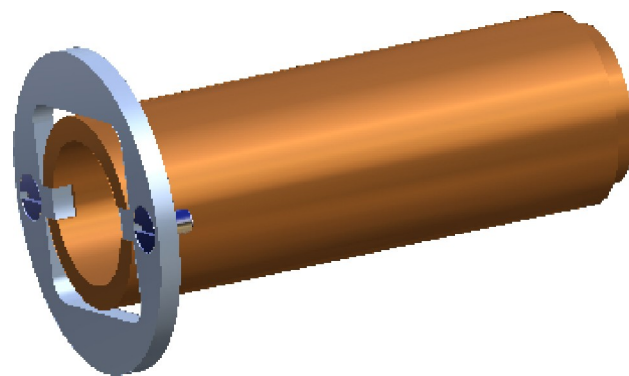
Hole in Frame MUST Be Opened Up
For 1 1/2" Dia. Sleeve.



2
Drill & Tap #10-32 NF

1

#10-32 x 3/8 NF
Flat Head Screw
(2)

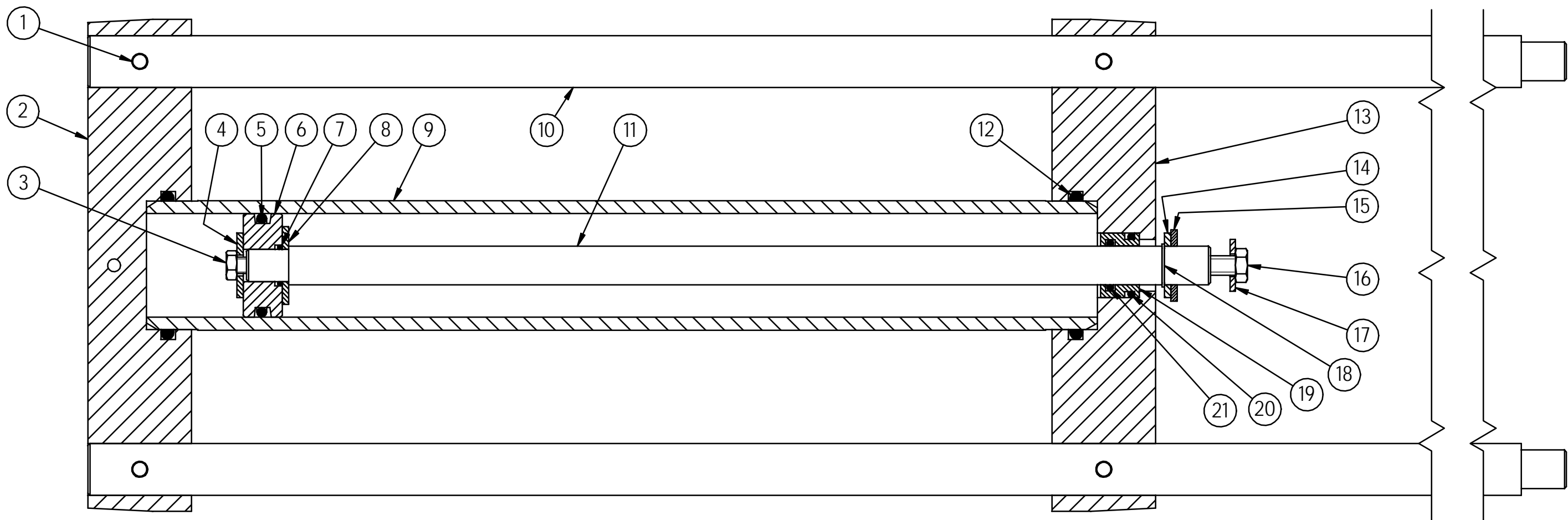


GROB INC.

GRAFTON, WIS.

Tension Crank Repair Kit
for 6V-36 Tension Crank

One				DRN. KS	TR.	CH.	DWG. NO.
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 1-5-05	SCALE	O.K.	HS-1094-A



Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity
1	15238-A	Feed Shaft Pin	4	10	HS-725-A	Air/Hyd. Feed Shaft	2	19	15453-A	Bushing	1
2	HS-728-C	End Cap - Feed Cylinder	1	11	HS-726-A	Piston Shaft	1	20	ARP568A-214	O-Ring	1
3	5/16-18 x 1/2	Hex Head Cap Screw	1	12	ARP568A-333	O-Ring	2	21	ARP568A-210	O-Ring	1
4	15239-A	Feed Shaft Clamp	1	13	HS-727-C	End Cap - Feed Cylinder	1				
5	ARP568A-326	O-Ring	1	14	15243-A	Washer	1				
6	15109-A	Piston	1	15	15258-A	1/8" Rubber Washer	1				
7	ARP-568A-114	O-Ring	1	16	3/8-16 x 1	Hex Head Cap Screw	1				
8	15454-A	Piston Shaft Washer	1	17		3/8 Flat Washer	1				
9	HS-723-A	Cylinder	1	18	5100-75	External Retaining Ring	1				

GROB INC.		GRAFTON, WIS.	
Air/Hydraulic Feed Cylinder Assembly for 6V-36 Band Saw			
DRN.	KS	TR.	CH.
DATE	3-4-05	SCALE	1:2
		O.K.	
			DWG. NO. HS-1095-B

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

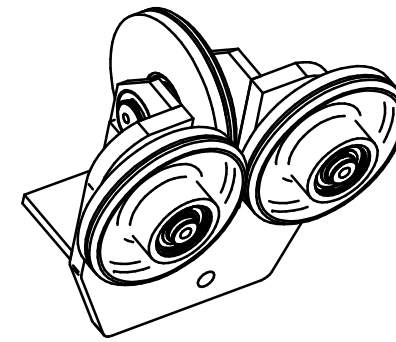
Roller Guide Parts List

HS-471 Complete Roller Guide Assembly
Includes Upper & Lower Assy.

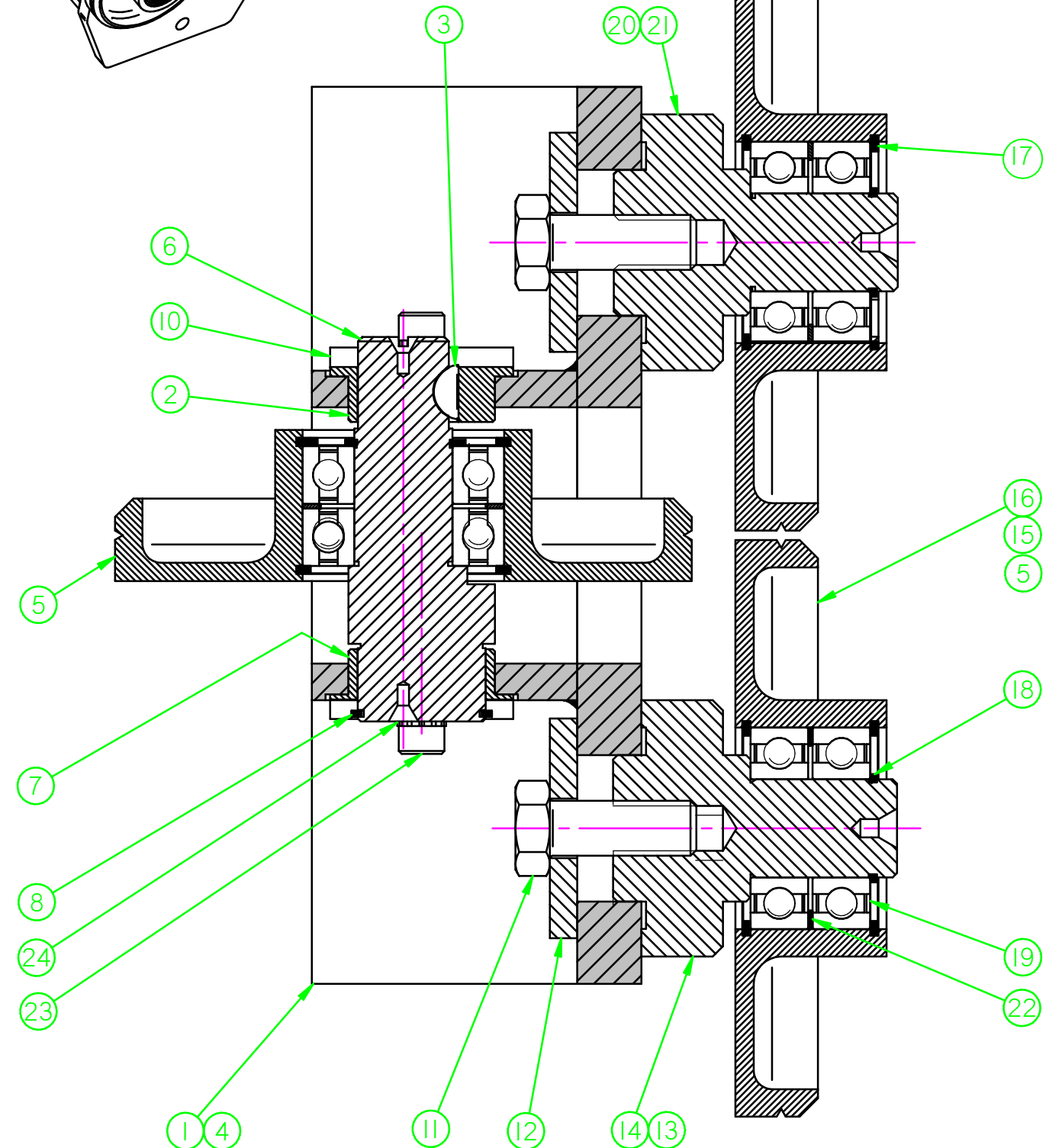
HS-332 Set for 5/8" - 1" Saw Blades
HS-611 Set for 3/8" & 1/2" Saw Blades
HS-696 Set for 1/4" Saw Blade

Sets Include 4 Side Rollers, Shafts, & Bearings

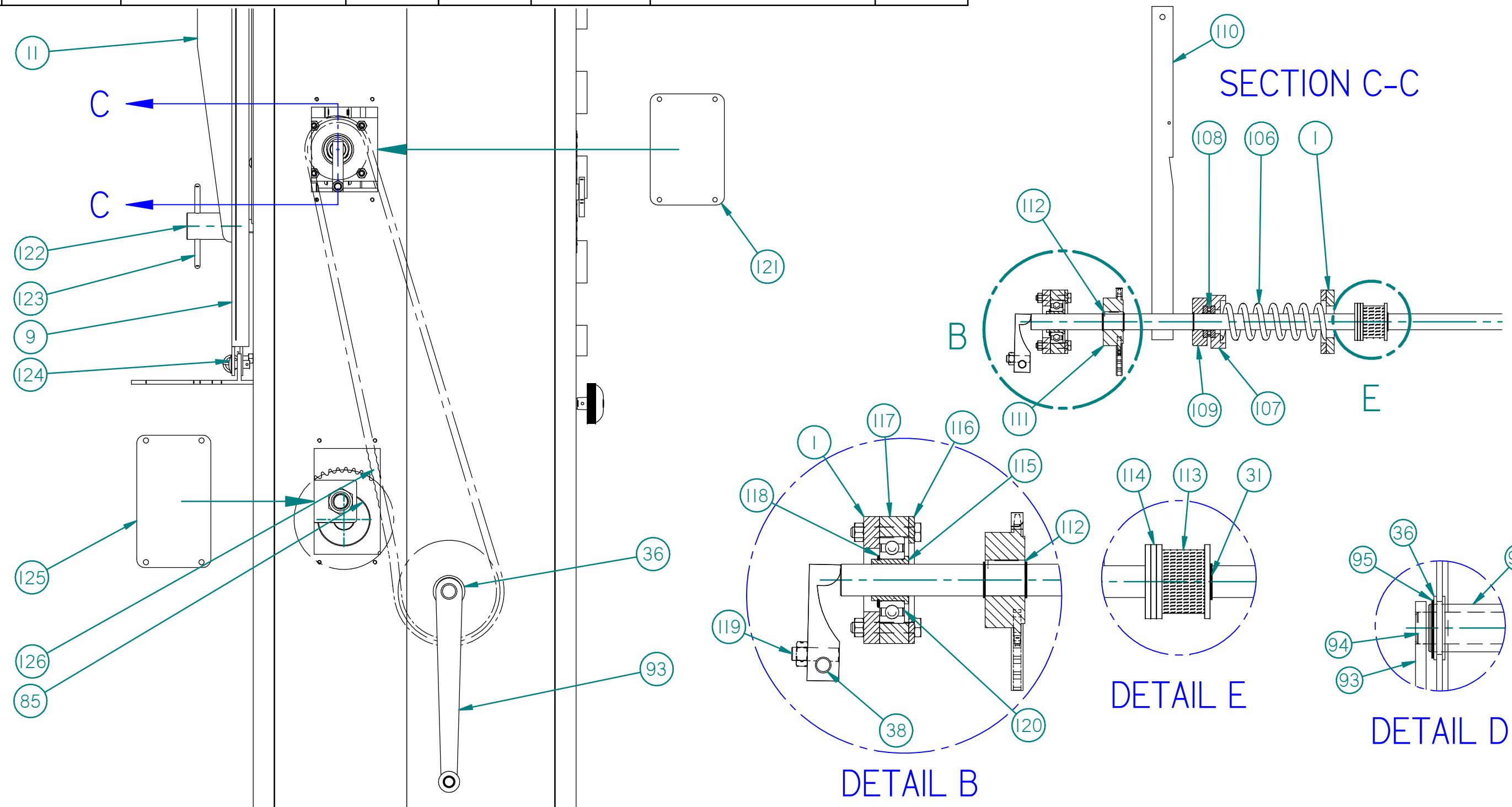
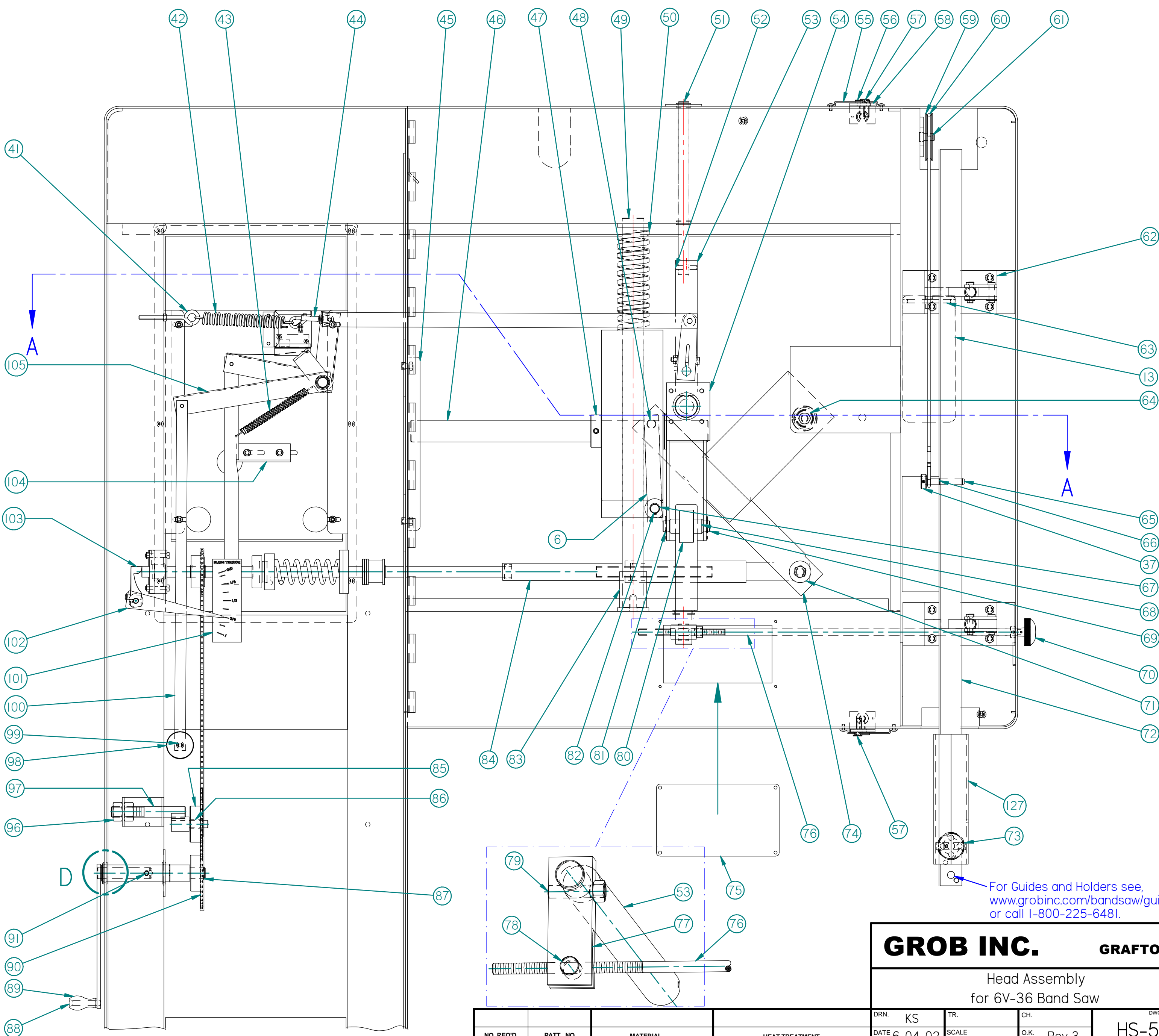
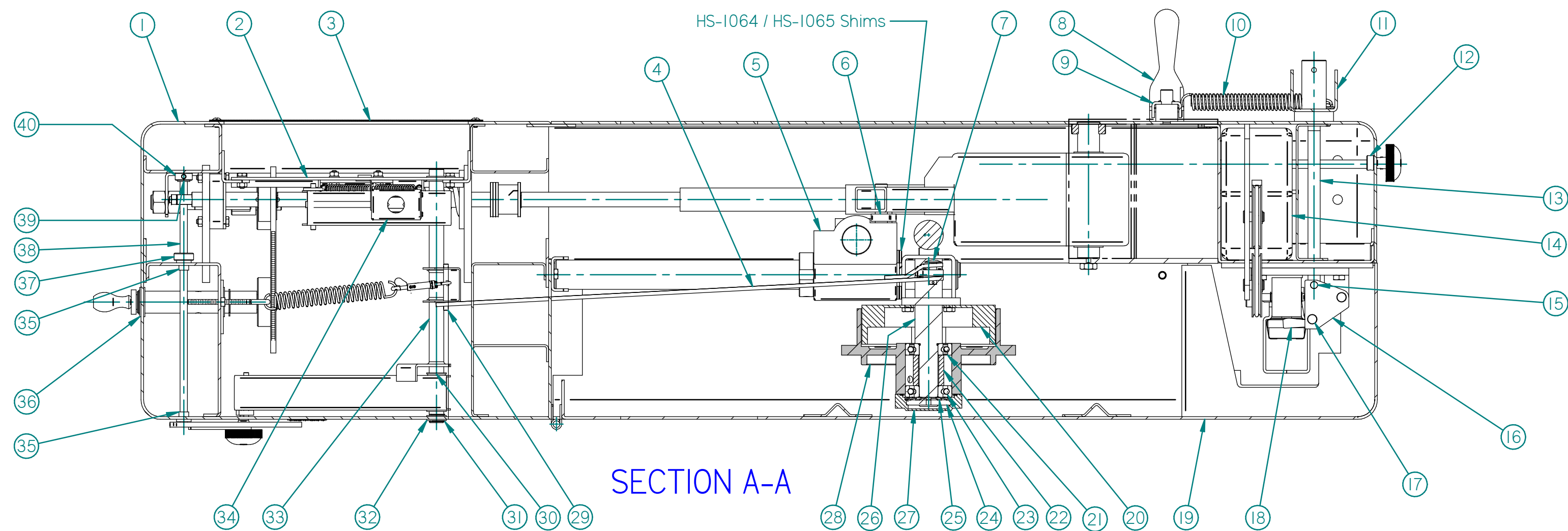
Item Number	Quantity	Document Number	Title
1	2	HS-397-C	Roller Guide Frame
2	2	HS-448-A	Eccentric Roller Shaft Bushing
3	2	#213	Woodruff Key
4	2	15186	Roller Guide Frame/S-24-U
5	6	HS-332-A	Rear Roller/All Blades-Side Roll 5/8-1
		HS-332-Assy.	Roller with Bearing
6	2	HS-528-A	Rear Roller Shaft
7	2	HS-527-A	Roller Shaft Bushing
8	2	5103-87	External Retaining Ring
9	obs.	#1728	Alemite Grease Fitting
10	4	HS-538-A	Roller Guide Clamp
11	4	3/8-16 x 1"	Hex Bolt
12	4	HS-469-A	1 1/2 od Washer
13	2	HS-470-A	Concentric Side Roller Shaft 5/8"-1"
14	4	HS-664-A	Concentric Side Roll Shft-1/4",3/8",1/2"
15	4	HS-696-A	Side Roller for 1/4" Saw Blade
		HS-696-Assy	Inc. HS-696,Rings,Bearings,Spacer
16	4	HS-611-A	Side Roller 3/8"-1/2" Saw Blade
		HS-611-Assy	Inc. HS-611,Rings,Bearings,Spacer
17	12	N5000-137	Internal Retaining Ring
18	6	5101-66	External Retaining Ring
19	12	6003-2RS	Bearing
20	2	HS-663-A	Eccentric Side Roll Shft 1/4,3/8-1/2
21	2	HS-467-A	Eccentric Side Roller Shaft 5/8" - 1"
22	6	HS-468-A	Roller Guide Bearing Spacer
23	2	#10-24	Socket Head Cap Screw
24	2	#10	Star-Lock Washer



HS-471
(Lower Shown)



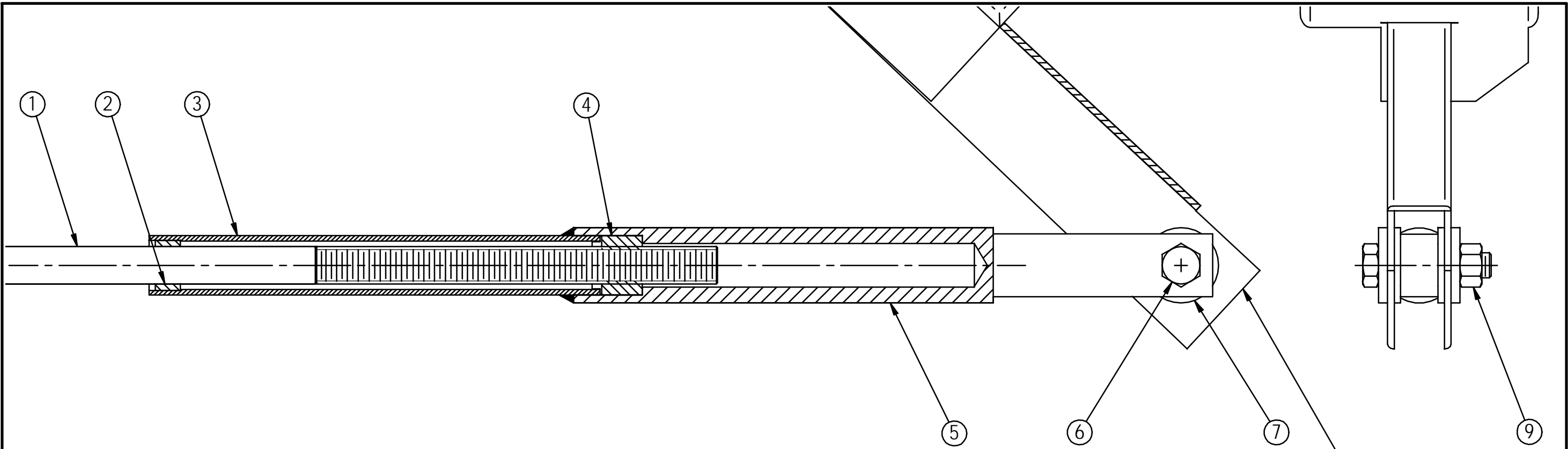
Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	HS-505-D	Frame	1	44		1/2 x 3 Clasp	1	87	5100-75	External Retaining Ring	2
2	HS-501-B	Mounting Plate	1	45	HS-141-B	Alignment Channel	1	88	S-1198-A	Handwheel Crank Pin	1
3	HS-539-B	Cover	1	46	HS-549-A	Pivot Shaft	1	89	S-1199-A	Handwheel Crank	1
4	HS-513-A	Brake Link	1	47	HS-1063-A	1 1/2 Set Collar	1	90	HS-850-A	40 Tooth Sprocket	1
5	HS-121-C	Carriage	1	48	HS-135-A	Upper Pin-Tension Link	1	91	HS-642-A	Tension Crank Pin	1
6	HS-254-A	Tension Link	1	49	HS-140-A	Column Bar	1	92	HS-578-A	Tension Crank Shaft	1
7	HS-239-A	Brake Link Pin	1	50		Column Bar Spring	1	93	HS-593-A	Hand Crank	1
8	HS-493-B	Column Door Lower Latch	1	51	HS-515-A	Eccentric Shaft Extension	1	94	HS-579-A	Tension Crank	1
9	HS-165-B	Door Latch U-Channel	1	52	HS-643-A	Eccentric Shaft Pin	1	95	5100-112	External Retaining Ring	4
10	V19C	Gardner Spring	2	53	HS-516-A	Eccentric Shaft	1	96	3/4-10	Hex Nut	2
11	HS-545-B	Clamping Channel	1	54	HS-953-C	Pivot Housing	1	97	HS-568-A	Chain Tightener Shaft	1
12	HS-1066-A	7/16 Set Collar	1	55	HS-1057-A	Upper Door Latch Guide	2	98	HS-999-A	Brake Reset Knob	1
13	HS-544-A	Clamp Pin	2	56	HS-162-A	Door Lock Hinge Pin	2	99	HS-1054-A	Brake Reset Knob Spacer	1
14	HS-543-C	Counter Weight	1	57	HS-164-A	Lock Pin	2	100	HS-541-A	Cocking Lever	1
15	HS-1068-A	1/4 Wagon Box Head Pin	2	58	HS-166-B	Column Door Upper Latch	1	101	HS-981-A	Saw Band Tension Plate	1
16	HS-323-A	Clamp Plate	4	59	HS-601-A	Counterweight Pulleys	2	102	HS-525-1-A	Tension Indicator	1
17	HS-587-A	Guide Bar Clamp Pin	4	60	1/8" 302 S/S	Guide Bar Tension Cable	1	103	HS-514-A	Tension Pick-up Lever	1
18	HS-324-A	Guide Bar Clamp	2	61	5100-50	External Retaining Ring	2	104	HS-500-A	Reset Bracket	1
19	HS-542-C	Column Door	1	62	HS-499-B	Guide Bar Clamp Bracket	2	105	HS-509-A	Brake Reset Lever	1
20	324379	Bendix Brake Assembly	1	63	HS-651-A	Weight Pin	1	106	HS-854-A	Tension Shaft Spring	1
21	6008-2RS	Bearing	1	64	HS-550-A	Tension Lever Arm Shaft	1	107	HS-212-A	Tension Spring Retainer	1
22	HS-359-A	Upper Pulley Spacer	1	65	HS-1056-A	Guide Bar Tension Pin	1	108	G16	Bearing	1
23	6008-NR	Bearing	1	66	5100-37	External Retaining Ring	2	109	HS-214-A	Thrust Bearing Cap	1
24	N-08	Bearing Locknut	1	67	5100-62	External Retaining Ring	1	110	HS-503-A	Brake Reset Lever	1
25	W-08	Bearing Lockwasher	1	68	HS-398-A	Tilt Roller Spacer	2	111	HS-645-A	KSA-24 Sprocket	1
26	HS-112-A	Upper Pulley Shaft	1	69	HS-567-A	Upper Tilt Roller Pin	1	112		3/16 Square Key	1
27	HS-358-A	Bearing Cap	1	70		10-NK Knob	1	113	S-1143-A	Rubber Bumper	1
28	HS-292-C	Upper Brake Drum	1	71	HS-654-A	Adaptor Bushing	2	114	HS-1053-A	Tension Shaft Stop Disc	4
29	HS-841-A	Brake Reset Lever Pin	3	72	HS-432-B	Upper Guide Bar	1	115	HS-307-A	Adaptor Sleeve	1
30	F-319-A	3/4" Flanged Bushing	2	73	S-1276-A	Saw Band Oiler Assembly	1	116	HS-419-A	Cover	1
31	5103-75	External Retaining Ring	6	74	HS-251-C	Tension Lever Arm	1	117	HS-421-A	Tension Bearing Block	1
32	F-319-A	3/4" Flanged Bushing	2	75	HS-497-A	Channel Cover	1	118	5100-98	External Retaining Ring	1
33	HS-506-B	Brake Reset Shaft Assembly	1	76	HS-158-A	Tilt Rod Threaded	1	119	HS-1052-A	Clamp Pin	1
34	HS-1055-B	Brake Switch	1	77	HS-159-A	Clamp Lever	1	120	6205-2Z	Bearing	1
35	FF-519-2	Oilite Bushing	2	78	S-1090-A	Tension Screw Nut	1	121	HS-562-A	Tension Pickup Cover	1
36	S-1052-A	1.125 Flanged Bushing	5	79	HS-641-A	Stud	1	122	HS-546-A	Clamp Pin Nut	1
37	HS-782-A	3/8" Set Collar	2	80	HS-393-A	Wheel Tilt Roller	1	123	HS-546-A	Handle for Clamp Pin Nut	1
38	HS-553-A	Tension Pick-up Shaft	1	81		1/8 Cotter Pin	2	124	HS-1067-A	Door Latch Link Pin	2
39	FF-520-10	Oilite Bushing	1	82	HS-253-A	Lower Tension Link Pin	1	125	HS-561-A	Chain Adjustment Cover	1
40	I8232-A	1/2" Set Collar	1	83	HS-658-A	Carriage Stop	1	126		#35 Roller Chain	1
41	1/4-20 x 4	Eye Bolt	1	84	HS-661-B	Tension Shaft Assembly	1	127	HS-941-B	Upper Saw Band Guard	1
42	V2C	Gardner Spring	1	85	HS-851-A	40 Tooth Sprocket	1				
43	V23C	Gardner Spring	1	86	AA-628-20	Oilite Bearing	1				



GROB INC. GRAFTON, WIS.

Head Assembly
for 6V-36 Band Saw

NO. REVD	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN KS	TR.	CH.	ENGL. NO.
DATE 6-04-02	SCALE	O.K.	Rev 3				HS-592-D



Item No.	Part No.	Description	Quantity
1	HS-235-A	Tension Shaft	1
2	HS-655-A	Tension Shaft Sleeve	1
3	HS-656-A	Tube	1
4	HS-653-A	Tension Nut	1
5	HS-657-B	Tension Nut Housing	1
6	1/2-13 x 2 1/4	Hex Head Cap Screw	1
7	HS-654-A	Adaptor Bushing	2
8	HS-251-C	Tension Lever Arm	1
9	1/2-13	Hex Nut	1

8
Not Part
Of Assembly

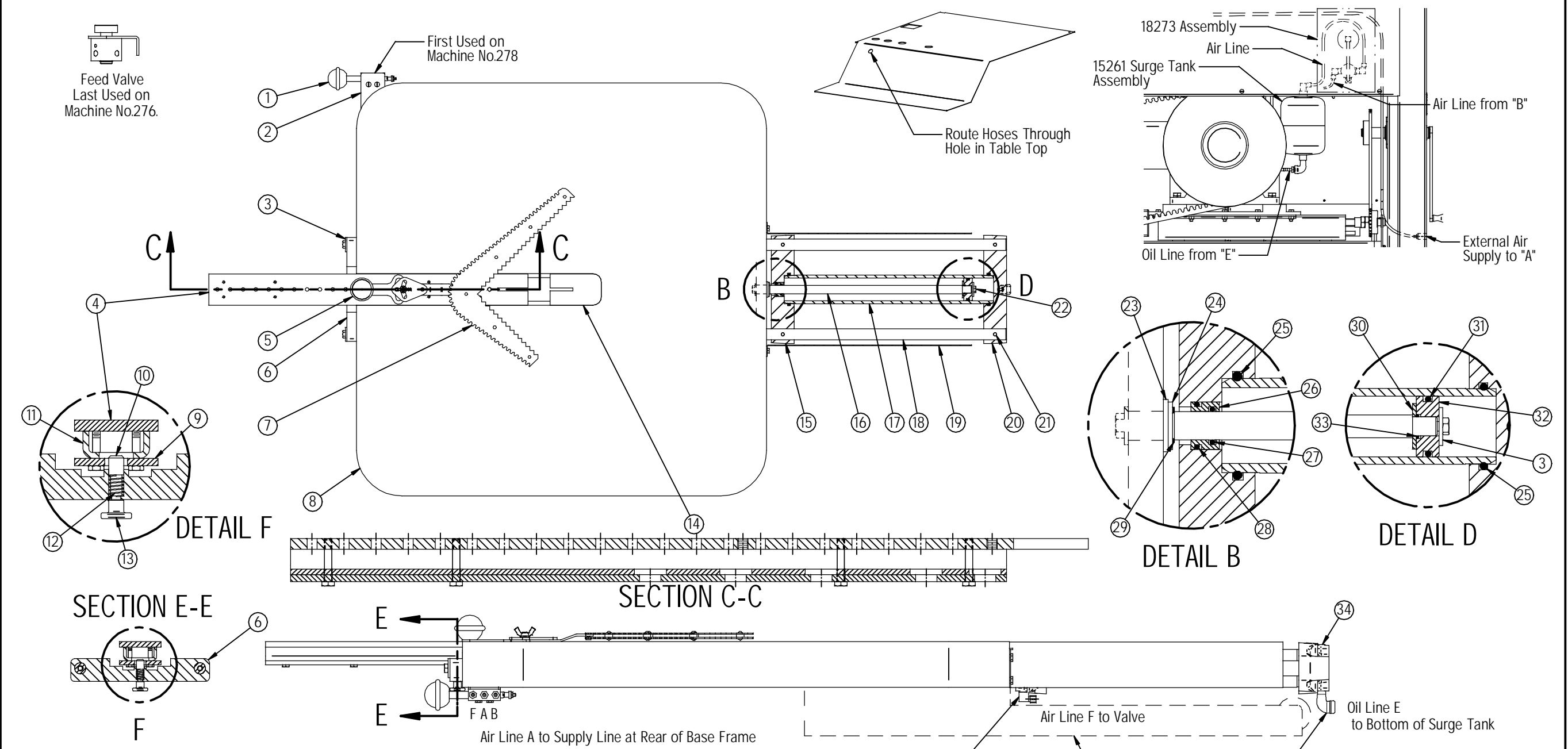
GROB INC. GRAFTON, WIS.

Tension Shaft Assembly
for 6V-36 Band Saw

First Used on Machine No. 150

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS	TR.	CH.	DWG. NO.
				DATE 10-18-01	SCALE 1:2	O.K.	HS-661-B

Item Number	Document Number	Title	Qty.	Item Number	Document Number	Title	Qty.	Item Number	Document Number	Title	Qty.	Item Number	Document Number	Title	Qty.
1	18150-B	Feed Valve Assy.	1	7	18215-B	Square Workholder	1	13	HS-377-A	Stroke Adjusting Pin Nut	1	19	HS-735-B	Feed Cylinder Guard	1
2	HS-977-A	Feed Valve Bracket	1	8	HS-950-D	Table	1	14	HS-440-A	Table Filler Plate	1	20	HS-728-C	End Cap - Feed Cylinder	1
3	15239-A	Feed Shaft Clamp	3	9	HS-259-B	Table Slide Clamp Plate	1	15	HS-727-C	End Cap - Feed Cyl.	1	21	15238-A	Feed Shaft Pin	4
4	15251-B	Slide Plate	1	10	HS-262-A	Stroke Adjustment Pin	1	16	HS-726-A	Piston Shaft	1	22	5/16-18 x 1/2	Hex Head Cap Screw	1
5	GS-2369-B	Workholder Assy.	1	11	HS-382-B	Feed Slide Spacer	1	17	HS-723-A	Cylinder	1	23	15258-A	1/8" Rubber Washer	1
6	HS-237-A	Feed Straddle Bar	1	12	HS-746-A	Stroke Adj Pin Spring	1	18	HS-725-A	Air/Hyd. Feed Shaft	2	24	15243-A	Washer	1



Item Number	Document Number	Title	Qty.	Item Number	Document Number	Title	Qty.
25	ARP568A-333	O-Ring	2	31	ARP568A-326	O-Ring	1
26	15453-A	Bushing	1	32	15109-A	Piston	1
27	ARP568A-210	O-Ring	1	33	ARP-568A-114	O-Ring	1
28	ARP568A-214	O-Ring	1	34	1/4-18 NPT	Pipe Plug	1
29	5100-75	External Retaining Ring	1	35	P-39	1/4 x 1/4 Hose Fitting	1
30	15454-A	Piston Shaft Washer	1	36	1/4 NPT	Street L	1

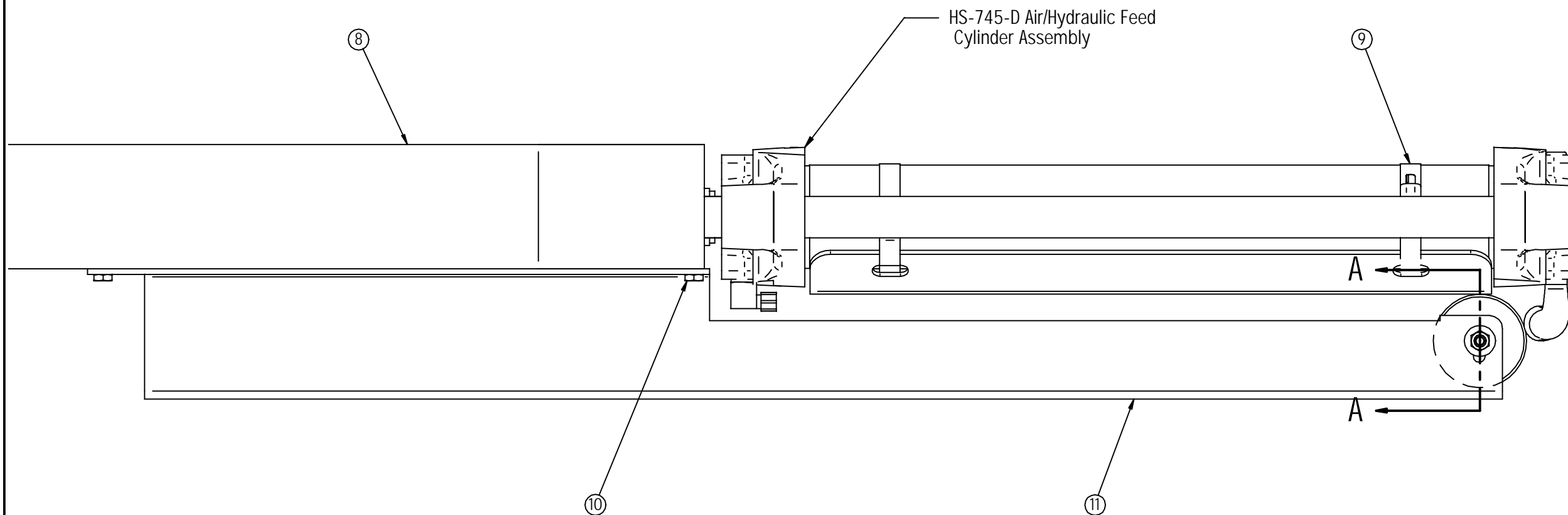
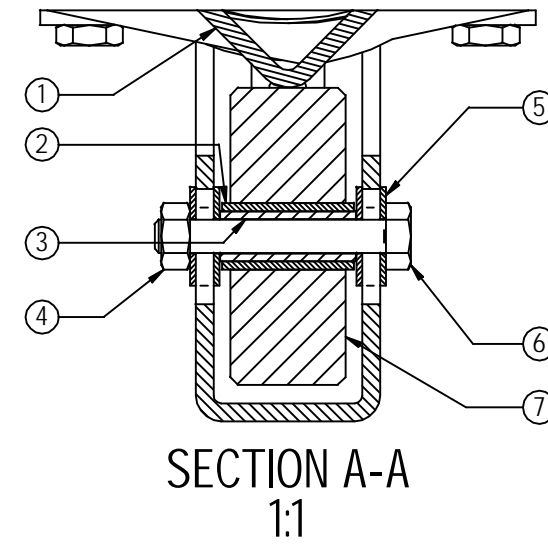
First Used on Machine No. 186.

NO. REQ'D		PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS	TR.	CH.	DATE 12-13-04	SCALE	O.K. Rev 3	HS-745-C
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GROB INC. GRAFTON, WIS.

Air/Hydraulic Feed Assembly
for 6V-36 Band Saw

Item Number	Part Number	Description	Qty
1	HS-809-B	Feed Roller V-Channel	1
2	AA-521-11	Oilite Bushing	1
3	HS-807-A	Roller Spacer	1
4		1/4-20 Hex Nut	1
5		1/4 x 3/4 x .045 Flat Washer	4
6	1/4-20 x 1 3/4	Hex Head Cap Screw	1
7	HS-805-A	Feed Roller	1
8	HS-950-D	Table	1
9		2 1/2" Hose Clamp	2
10	1/4-20 x 1/2	Hex Head Cap Screw	4
11	HS-806-B	Feed Roller Channel	1

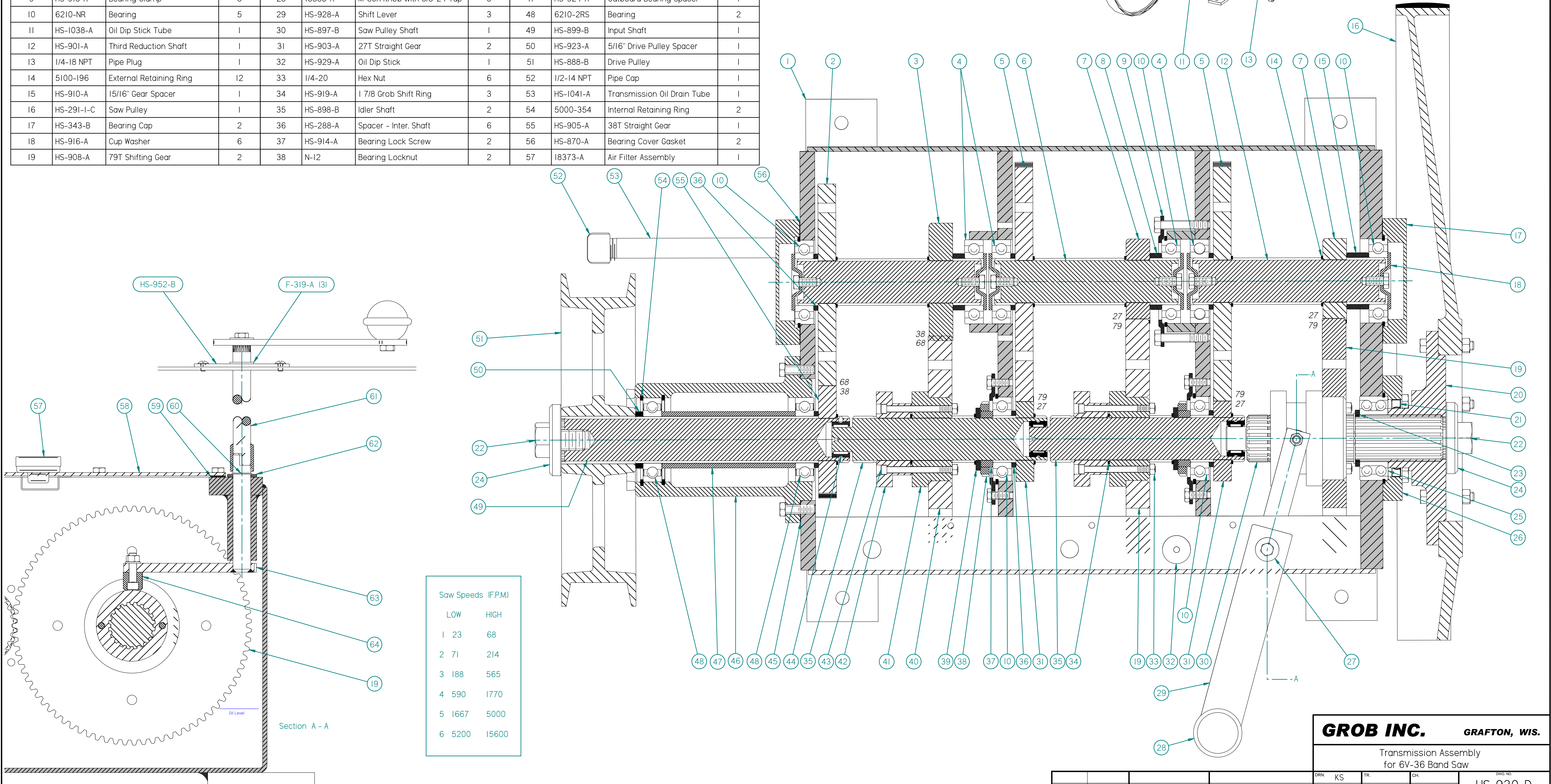
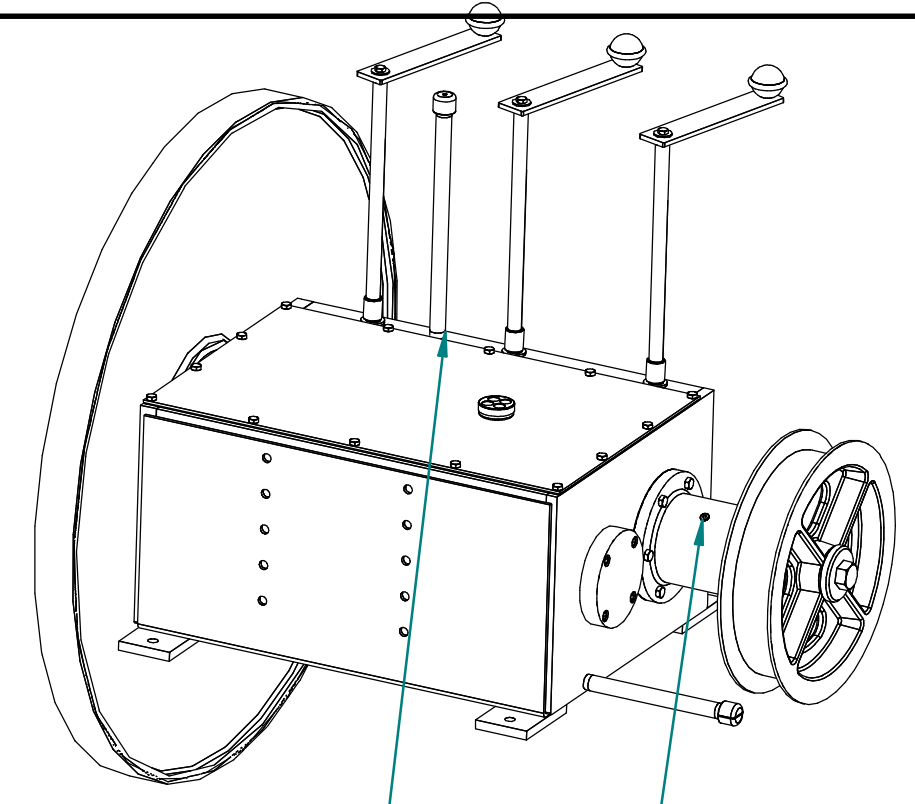


First Used on Machine #210

GROB INC.		GRAFTON, WIS.	
Air/Hydraulic Feed Roller Assembly for 6V-36 Band Saw			
DRN. KS	TR.	CH.	DWG. NO.
DATE 11-8-04	SCALE 1:2	O.K. Rev 3	HS-810-C

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

Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity	Item Number	Document Number	Title	Quantity
1	HS-895-D	Transmission Case	1	20	HS-825-A	Saw Pulley Hub	1	39	HS-915-A	Bearing Lock Retainer	2	58	HS-920-A	Transmission Cover	1
2	HS-907-A	68T Gear	1	21	471271	National Oil Seal	1	40	HS-906-A	68T Shifting Gear	1	59	HS-986-A	Gasket	1
3	HS-904-A	38T Shifting Gear	1	22	7/8-9 x 1 1/2	Hex Bolt	2	41	HS-912-A	Shifting Gear Hub	3	60	5100-75	External Retaining Ring	3
4	6210	Bearing	3	23	I5323-A	Bearing Spacer	1	42	HS-911-A	Outer Shift Ring	3	61	HS-927-A	Shifting Shaft	3
5	HS-909-A	79T Gear	2	24	HS-958-A	Pulley Clamp Washer	2	43	I/4-20 x 3	Socket Head Cap Screw	6	62	I5243-A	Washer	3
6	HS-900-A	1st & 2nd Reduction Shaft	2	25	5210-NR	Bearing	1	44	SJ7193	Torrington Roller Bearing	3	63	HS-922-A	Shifting Pivot Assembly	3
7	HS-902-A	27T Shifting Gear	2	26	HS-917-A	Saw Pulley Bearing Clamp	1	45	HS-947-A	Bearing Housing Gasket	1	64	I8029-A	Inside Shift Knob	3
8	HS-925-A	1/2" Gear Spacer	2	27	I8124-A	Clamp Washer	3	46	HS-946-C	Outboard Bearing Housing	1				
9	HS-918-A	Bearing Clamp	3	28	I8385-A	M-80A Knob with 3/8-24 Tap	3	47	HS-924-A	Outboard Bearing Spacer	1				
10	6210-NR	Bearing	5	29	HS-928-A	Shift Lever	3	48	6210-2RS	Bearing	2				
11	HS-1038-A	Oil Dip Stick Tube	1	30	HS-897-B	Saw Pulley Shaft	1	49	HS-899-B	Input Shaft	1				
12	HS-901-A	Third Reduction Shaft	1	31	HS-903-A	27T Straight Gear	2	50	HS-923-A	5/16" Drive Pulley Spacer	1				
13	I/4-18 NPT	Pipe Plug	1	32	HS-929-A	Oil Dip Stick	1	51	HS-888-B	Drive Pulley	1				
14	5100-196	External Retaining Ring	12	33	I/4-20	Hex Nut	6	52	I/2-14 NPT	Pipe Cap	1				
15	HS-910-A	15/16" Gear Spacer	1	34	HS-919-A	1 7/8 Grob Shift Ring	3	53	HS-1041-A	Transmission Oil Drain Tube	1				
16	HS-291-I-C	Saw Pulley	1	35	HS-898-B	Idler Shaft	2	54	5000-354	Internal Retaining Ring	2				
17	HS-343-B	Bearing Cap	2	36	HS-288-A	Spacer - Inter. Shaft	6	55	HS-905-A	38T Straight Gear	1				
18	HS-916-A	Cup Washer	6	37	HS-914-A	Bearing Lock Screw	2	56	HS-870-A	Bearing Cover Gasket	2				
19	HS-908-A	79T Shifting Gear	2	38	N-12	Bearing Locknut	2	57	I8373-A	Air Filter Assembly	1				



Saw Speeds (F.P.M.)		
	LOW	HIGH
1	23	68
2	71	214
3	188	565
4	590	1770
5	1667	5000
6	5200	15600

GROB INC. GRAFTON, WIS.

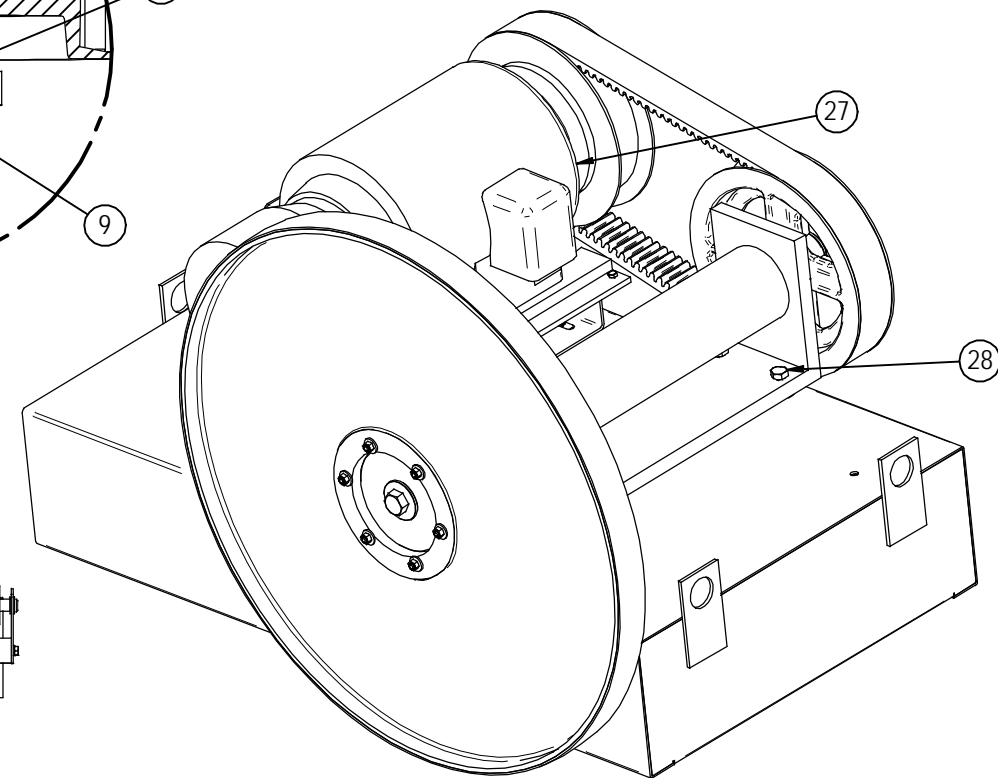
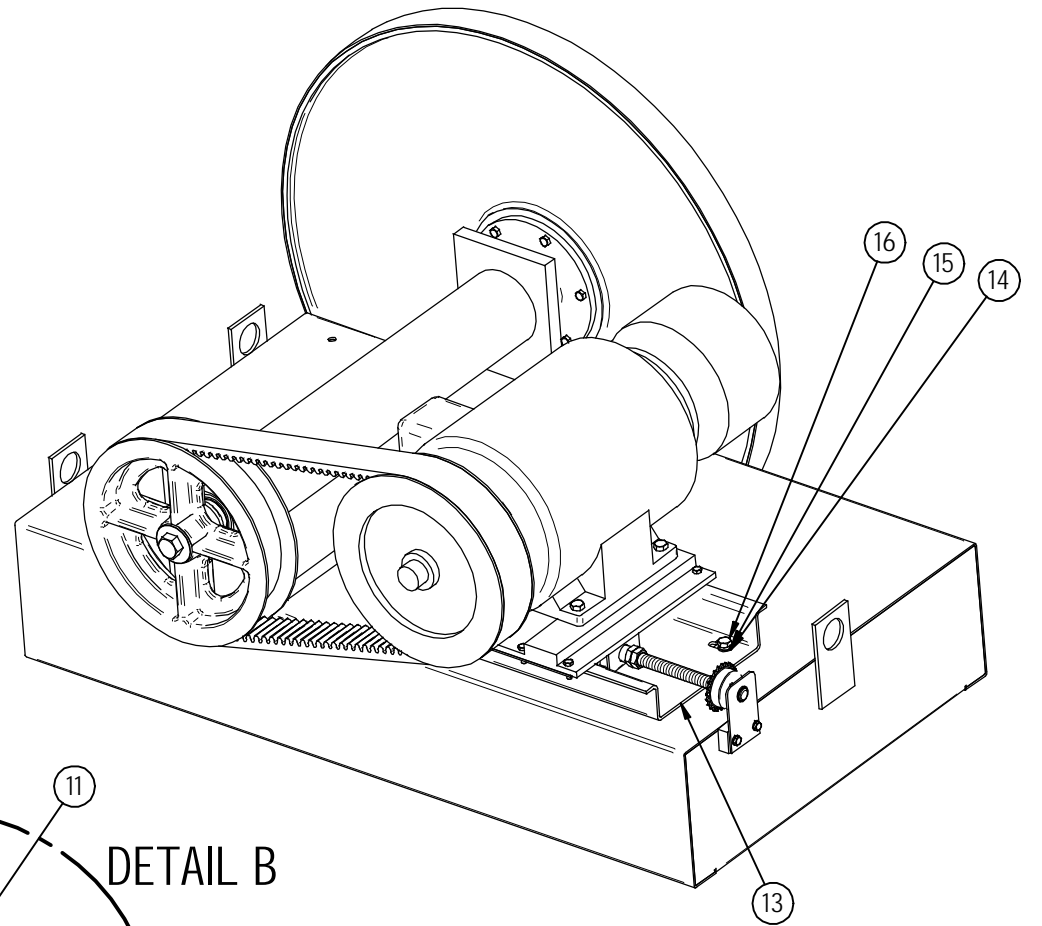
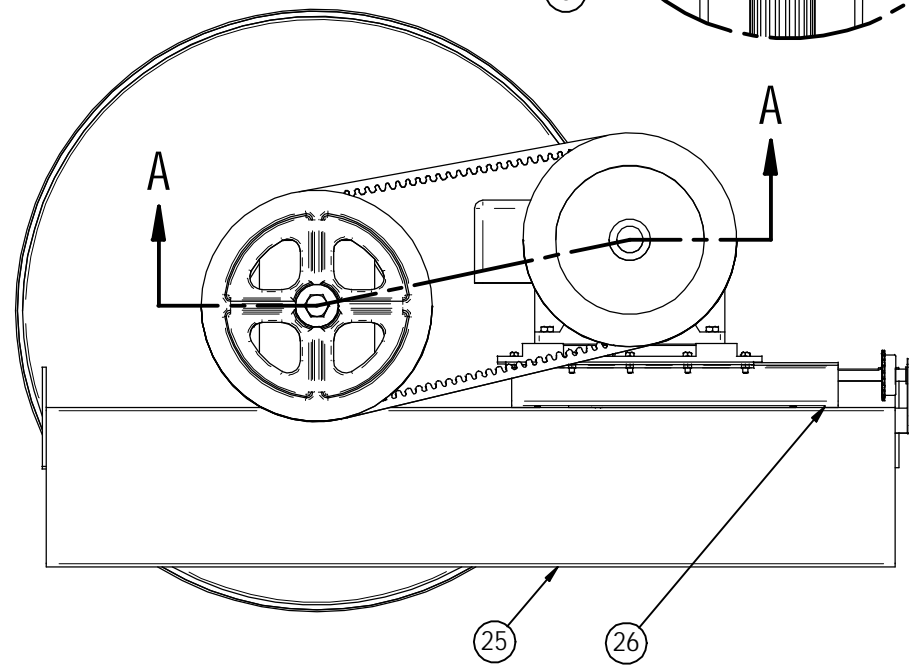
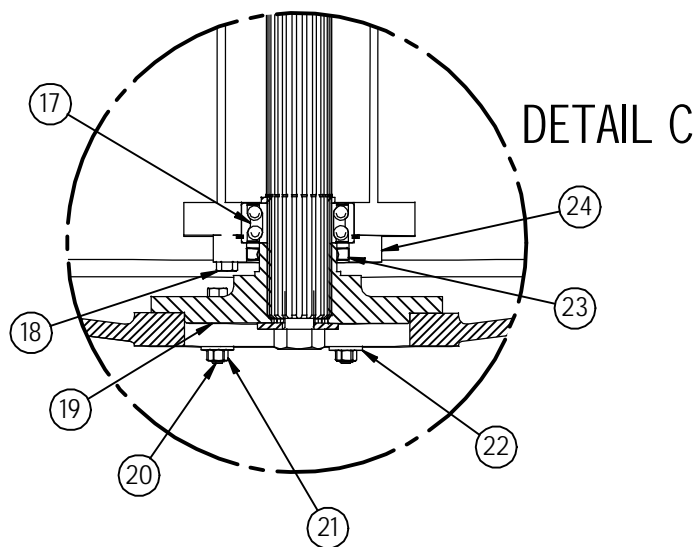
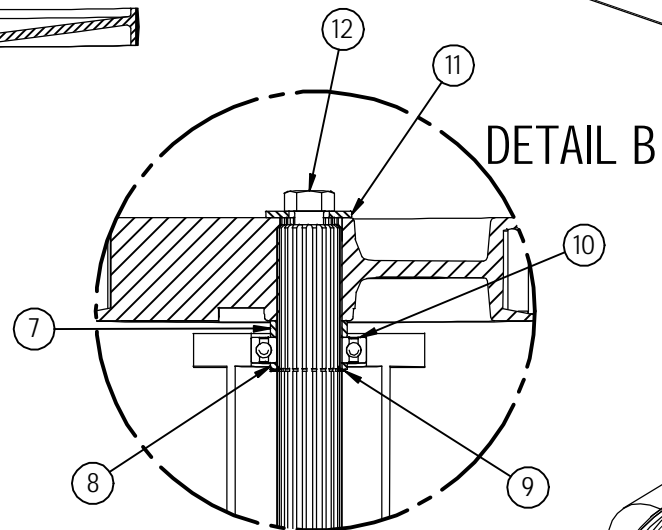
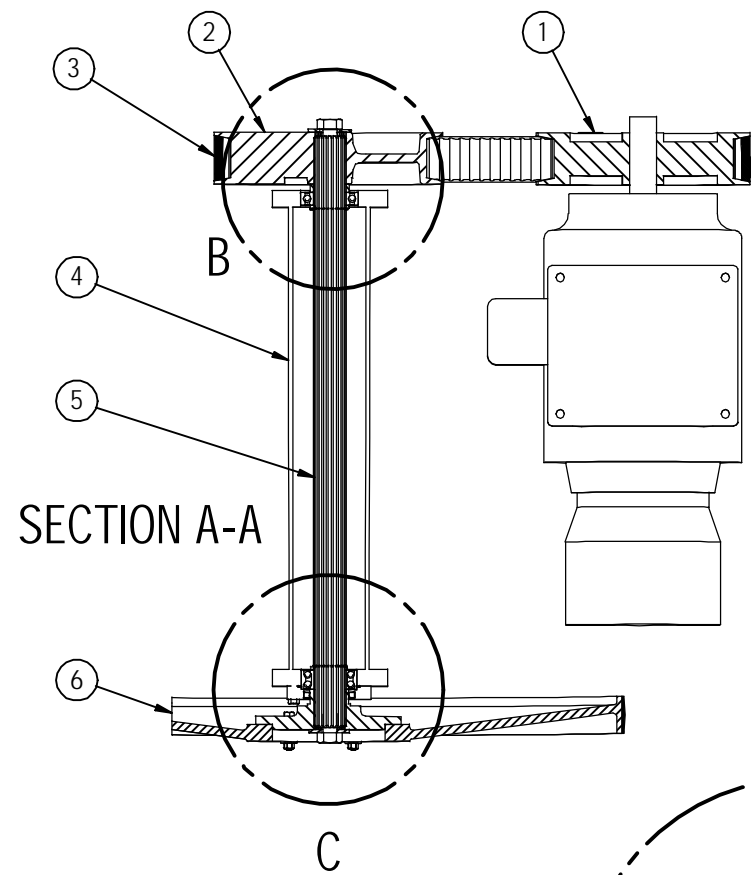
Transmission Assembly
for 6V-36 Band Saw

DRN	KS	TR.	CH.	ENGR. NO.
DATE	12-20-01	SCALE	1:2	OK Rev 1

HS-930-D

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

Item Number	Document Number	Title	Quantity
1		TB Woods Companion Sheave	1
2	HS-888-B	Drive Pulley	1
3	4430V790	Vari-Speed Belt	1
4	HS-943-C	Single Speed Bracket	1
5	HS-942-A	Single Speed Shaft	1
6	HS-291-1-C	Saw Pulley	1
7	HS-925-A	1/2" Gear Spacer	1
8	15323-A	Bearing Spacer	2
9	5100-196	External Retaining Ring	2
10	6210-2RS	Bearing	1
11	15311-A	Clamp Washer	2
12	7/8-9 x 1 1/4	Hex Bolt	2
13	HS-1078-C	Motor Slide Assembly	1
14		1/2x7/8 Flat Washer	4
15		1/2 Lock Washer	4
16	1/2-13 x 1 1/4	Hex Head Cap Screw	8
17	5210-NR-2RS	Bearing	1
18	3/8-16 x 1 3/4	Hex Head Cap Screw	4
19	HS-825-A	Saw Pulley Hub	1
20	3/8-16 x 2	Hex Bolt	6
21		3/8-16 Hex Nut	6
22		3/8 Flat Washer	6
23	471271	National Oil Seal	1
24	HS-917-A	Saw Pulley Bearing Clamp	1
25	HS-963-D	Concrete Base	1
26		1/2x1 3/4 Flat Washer	8
27		15HP Baldor Electric Motor	1
28	5/8-11 x 2	Hex Head Cap Screw	4

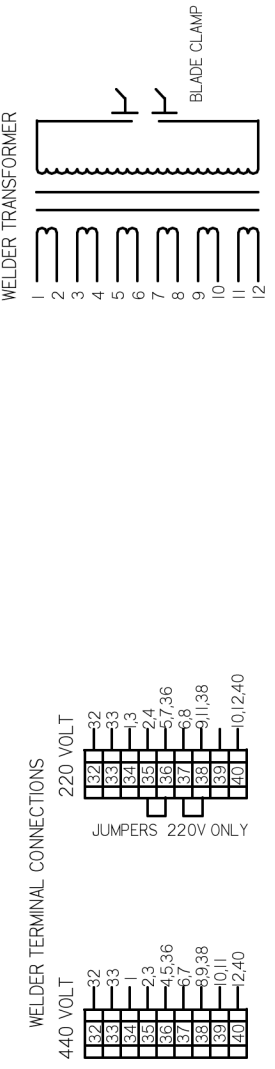
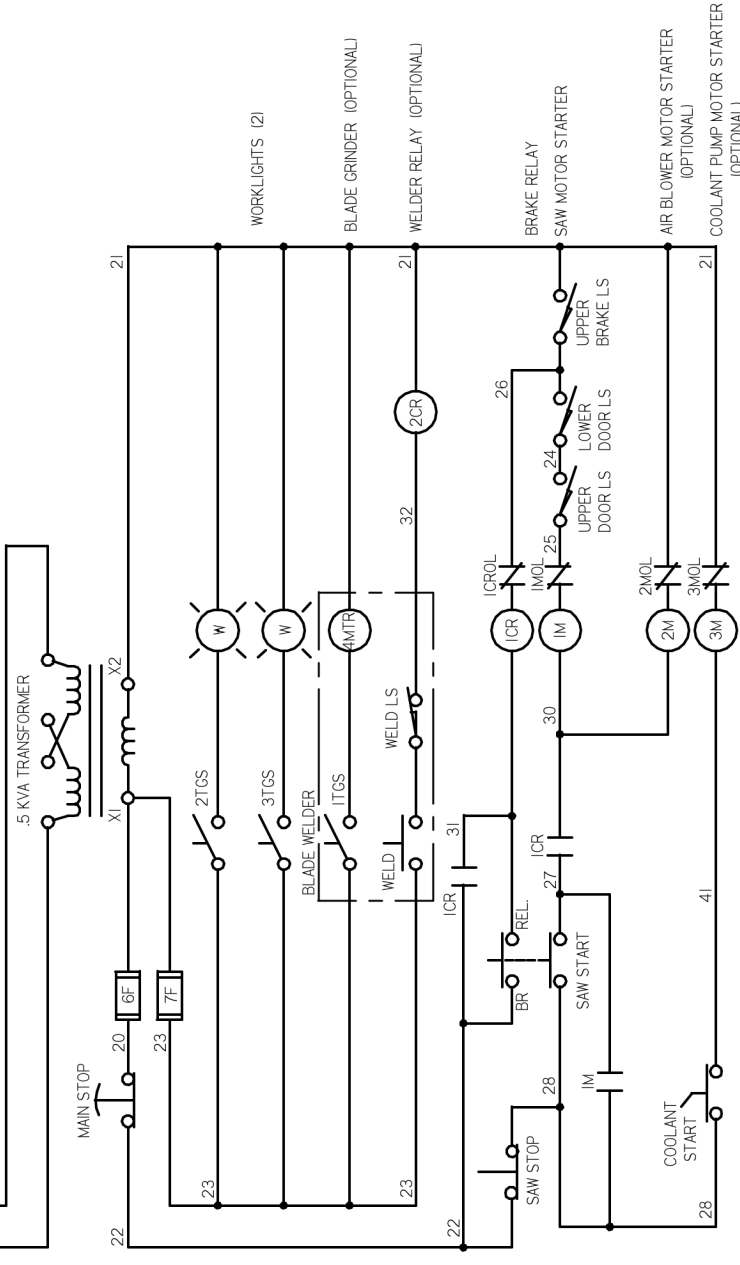
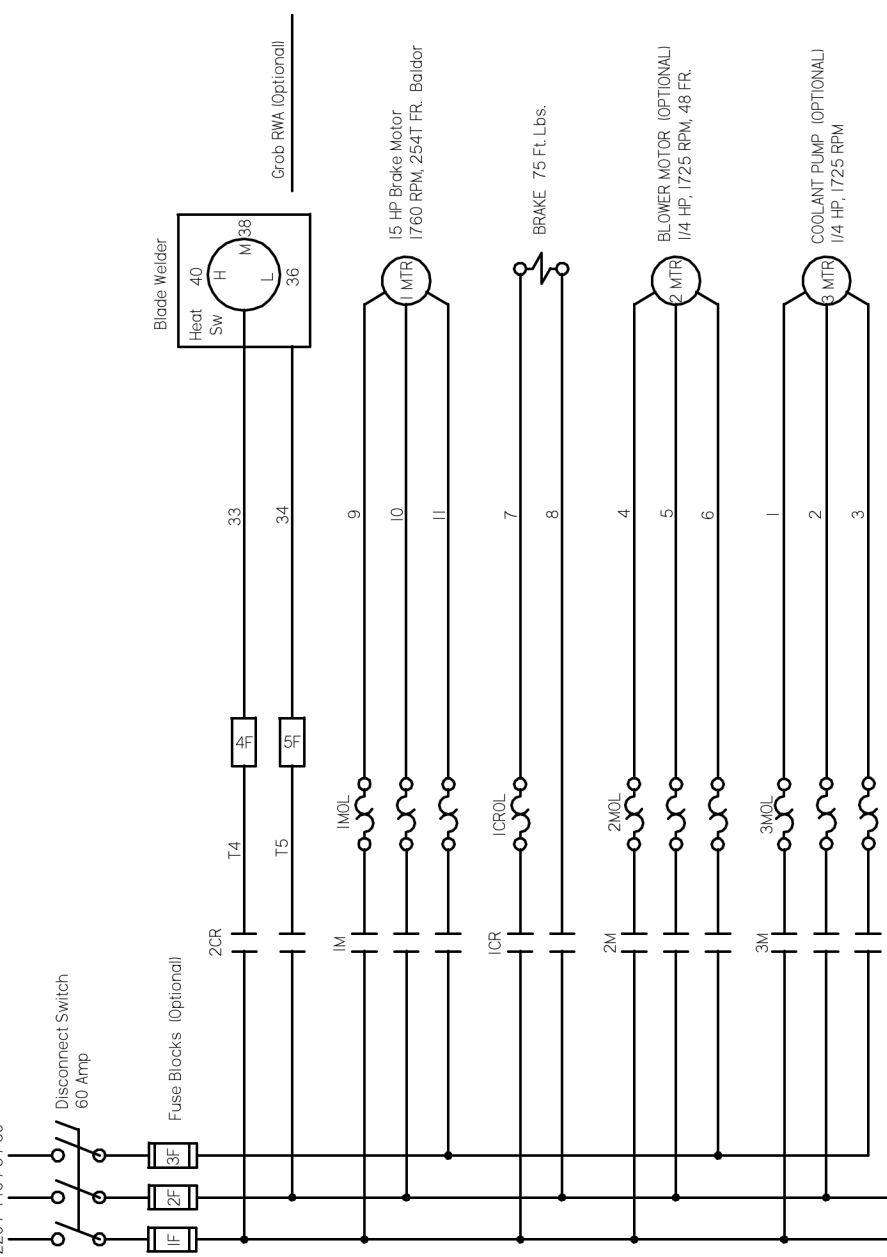


GROB INC. GRAFTON, WIS.

Single Speed Unit Assembly
for 6V-36 Band Saw

One				DRN. KS	TR.	CH.	DATE 10-9-03	SCALE 1:8	O.K. Rev 1	DWG. NO. HS-945-1-C
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT							

220 / 440 / 3 / 60



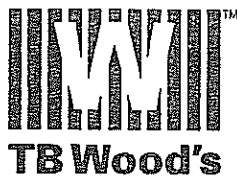
STARTING SERIAL NUMBER 480

GROB INC. GRAFTON, WIS.

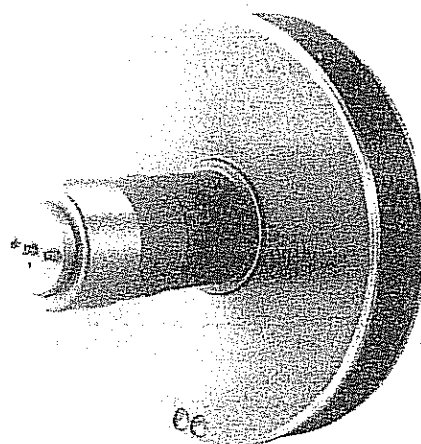
Schematic Wiring Diagram
for 6V-36 Band Saw

DRN SV	TR	CR	DRW. NO.
DATE 8-9-01	SCALE	OK	HS-964-C

NO. REC'D	PATT. NO.	MATERIAL	HEAT TREATMENT
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Roto-Cone® Variable Speed Sheave



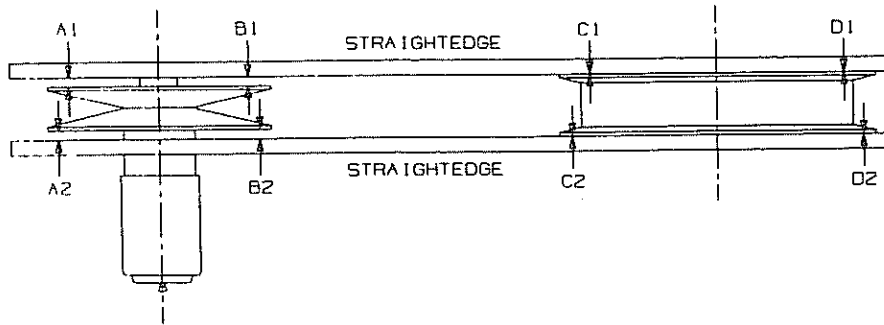
Installation Instructions

TB Wood's Incorporated • Chambersburg, PA
T. B. Wood's Canada Ltd. • Stratford, Ontario

Installation Instructions

NOTE: This manual is to be used in conjunction with the installation instructions packaged with the other component parts of this drive. The following instructions are based on the assumption that the companion has already been properly installed and the motor and motor base are in location. All related component instructions should be closely followed and available for reference during installation.

1. Inspect the motor shaft and key for nicks and burrs and remove if present. Install key in shaft.
2. Place Roto-Cone sheave on the shaft. This may be a slight interference fit, requiring some force to install.
3. Adjust the motor base so the motor is as close to the companion as possible. Align sheaves by using the four-point alignment method shown below. Place string or straightedge across companion and Roto-Cone sheave. The Roto-Cone sheave should be mounted as close to the motor housing as possible. If the parallel offset is more than 1/2", reposition motor base instead of moving sheave on shaft. To achieve correct angular alignment, swivel motor on base. Sheaves are properly aligned when gap $A1=A2=B1=B2$ and gap $C1=C2=D1=D2$.



4. Using a torque wrench, tighten the setscrews holding the Roto-Cone to the shaft to the following torque value.

Sheave Model	Torque (ft. lbs.)
RC55, RC60	3
RC75, RC80, RC105	7
RC100	14
RC1315, RC1330	24

CAUTION: Failure to use the proper torque values during installation can result in damaging the sheave or motor shaft.

5. Adjust motor base to move variable sheave as far away from the companion as possible and check alignment once more. Alignment must be good at both ends of motor base travel. Make alignment corrections as required, then tighten motor and motor base to mounting surface as outlined in motor base installation instructions.
6. With an approved grease, lubricate the Roto-Cone pulley by filling the grease fittings on the outboard endcap until grease appears near the center of the flange next to the motor. On model RC1330, a grease fitting is also present where the outboard flange meets the spring can.

Approved Grease	Manufacturer
Lubriplate No. 1200-2	Fiske Brothers Refining Co.
Atlantic Lubricant 52	Atlantic Refining Co.
Supreme Grease No. 2	Gulf Refining Co.
Alvinia EP Grease No. 2	Shell Oil Co.
Amolith Grease No. 2	Standard Oil Co.

7. Adjust motor base to move Roto-Cone as close to companion sheave as possible. Place the belt into the groove of both sheaves. Seat the belt in the Roto-Cone sheave by adjusting the motor away from the companion while rotating the drive by hand.

CAUTION: Belt must NOT be pried over the flanges of either sheave as this will damage the belt. Drive MUST be rotated while center distance is adjusted to prevent damaging drive components.

WARNING
 All rotating equipment must be properly guarded to prevent personnel from coming in contact with the drive. Failure to do so could result in serious injury.

8. Drive is now ready to operate.

Maintenance Instructions

Roto-Cone sheave should be exercised thru the speed range every 8 hours to distribute grease to all working areas. Sheave should be regreased every 40 hours.

If the Roto-Cone is acting sluggish or appears that it is not opening and closing fast enough, the pulley should be flushed and regreased.

1. With the sheave mounted on the motor or on an arbor, flush the Roto-Cone sheave by adding kerosene thru the grease fittings until it flows from the various openings in the sheave.
2. Remove the Roto-Cone from the shaft and drain the kerosene.
3. Relubricate with an approved grease as listed above.

Repair Instruction

WARNING
 Improper disassembly could cause injury. The internal spring is under high compressive load. Read the following instructions completely before disassembling sheave.

The kits indicated below contain the gear, gear rack, spiral pin and gear rack capscrews. These are the only field replaceable parts and can be ordered as indicated.

Sheave Model	Rack and Gear Kit
RC55	RC55K
RC60	RC60K
RC75	RC75K
RC80	RC80K
RC105	RC105K
RC100	RC100K
RC1315	RC1300K
RC1330	RC1320K

Disassembly

Match mark all parts before disassembly to aid in maintaining the sheave's balance during reassembly. Great care must be exercised during disassembly because the spring force may be as high as 400 lbs.

1. To remove the spring and associated parts, follow the instructions corresponding to the sheave model number.

RC55 Place the sheave in a press and lightly depress the end cap with the arbor. This is to contain the spring after the spiral pin is removed. After the sheave is secured in the press, use a punch to remove the pin.

RC60 thru RC1315 Place the sheave in a press and depress the outer spring cover until the spiral pin is visible in the end cap. Use punch to remove pin.

RC1330 Remove the allen head capscrews holding the outer spring cover and remove this cover. The spring retainer is now accessible. Place the sheave in a press and use a "U" shaped spacer to compress the spring retainer and spring approximately 1/8" and remove the retaining ring.

2. Slowly release the press and remove the end cap/retainer and spring.
3. The allen head capscrews holding the gear rack to the outboard flange will be visible and can now be removed. Removal of these capscrews will allow the outboard flange to be slid off the center sleeve.
4. Remove the outboard flange to expose the capscrews attaching the inboard flange to the opposite gear rack. Remove these capscrews and slide the inboard flange from the center sleeve.
5. The gear racks can be lifted from their key slots and inspected. Use a punch to remove the gear pin and gear from the sleeve.

Reassembly

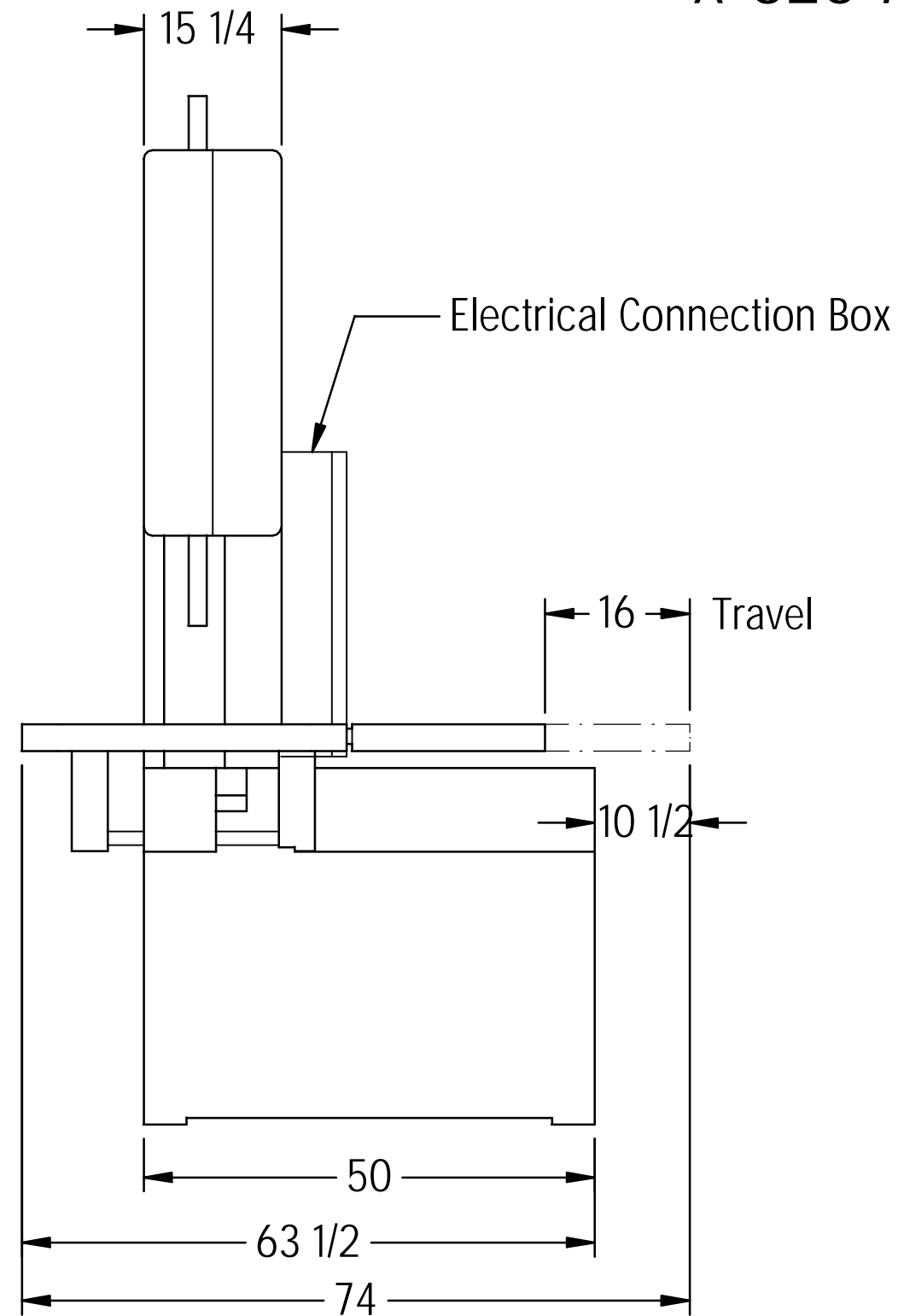
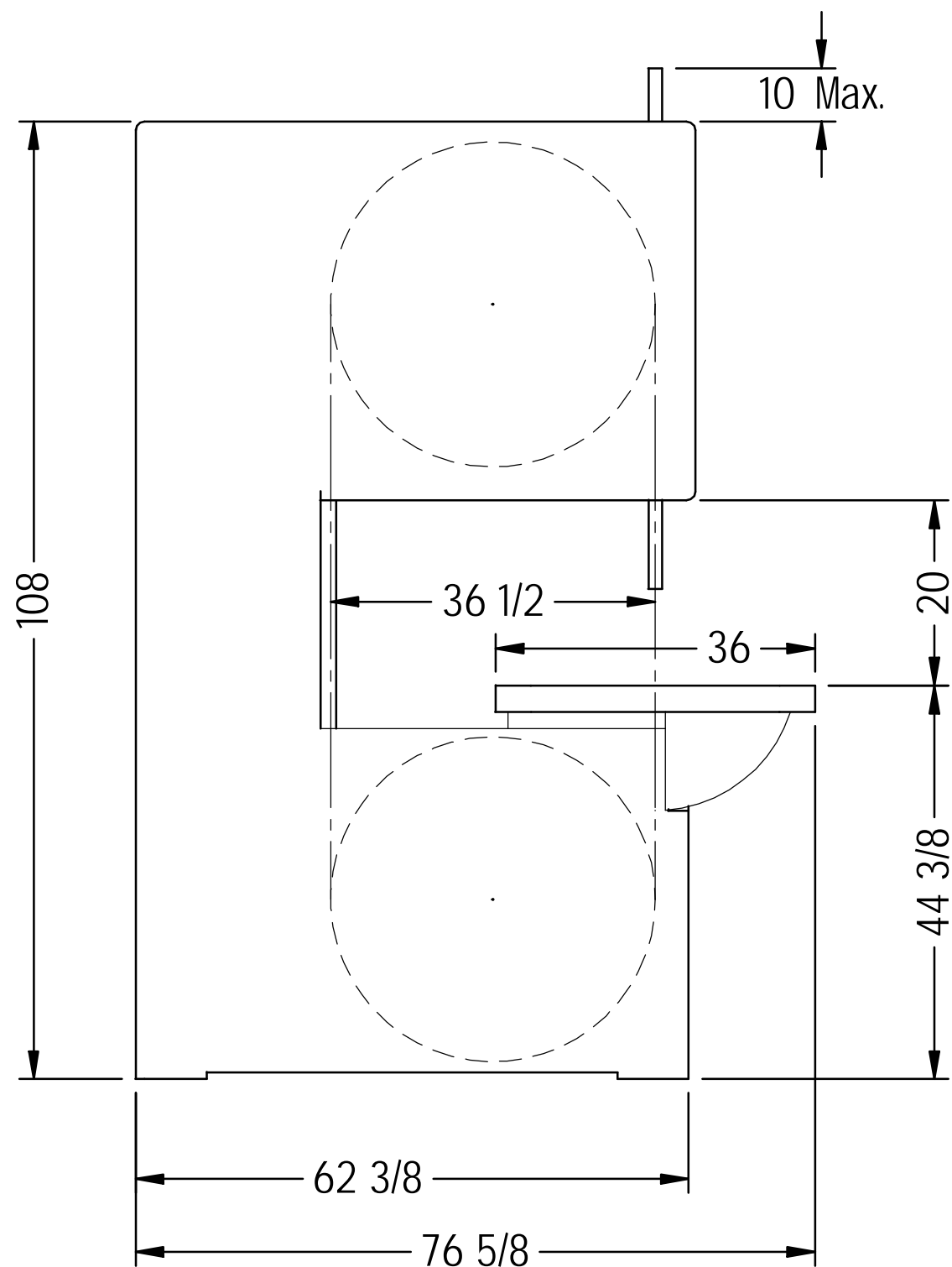
All parts should be cleaned to remove all the grease. Align match marks during assembly.

1. Position gear in slot of center sleeve and replace gear pin thru sleeve, keeping it flush with the sleeve.
2. Place the inboard gear rack in the keyway of the center sleeve, locating it approximately flush with the inboard end of the sleeve.
3. Place the outboard gear rack in the opposite keyway on the center sleeve locating it approximately flush with the outboard end of the sleeve.
4. Insert center sleeve and gear racks into the bore of the inboard flange. The thru holes on the flange must align with the correct tapped holes in the respective gear rack. Using a medium strength Loctite, install the capscrews between the inboard flange and respective gear rack.
5. Repeat line 4 to install the outboard flange.
6. Replace the spring and end cap/retainer under the press. Compress the spring enough to replace the spiral pin/retaining ring.
7. Re-install sheave on the shaft per the directions previously outlined.
8. Regrease the assembly with an approved grease.

TB WOOD'S INCORPORATED • 440 N. Fifth Avenue • Chambersburg, PA 17201-1778

Phone: 800-789-6637 • FAX: 717-264-6420

X-326-A



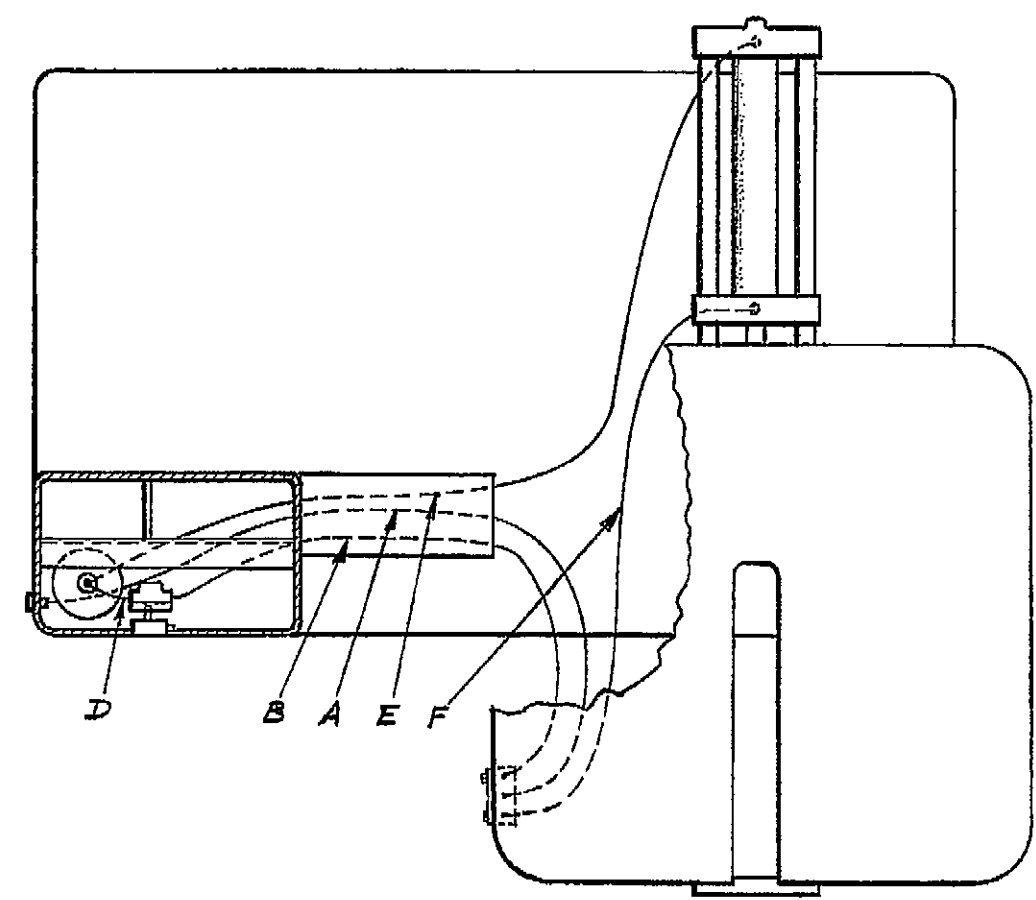
GROB INC.

GRAFTON, WIS.

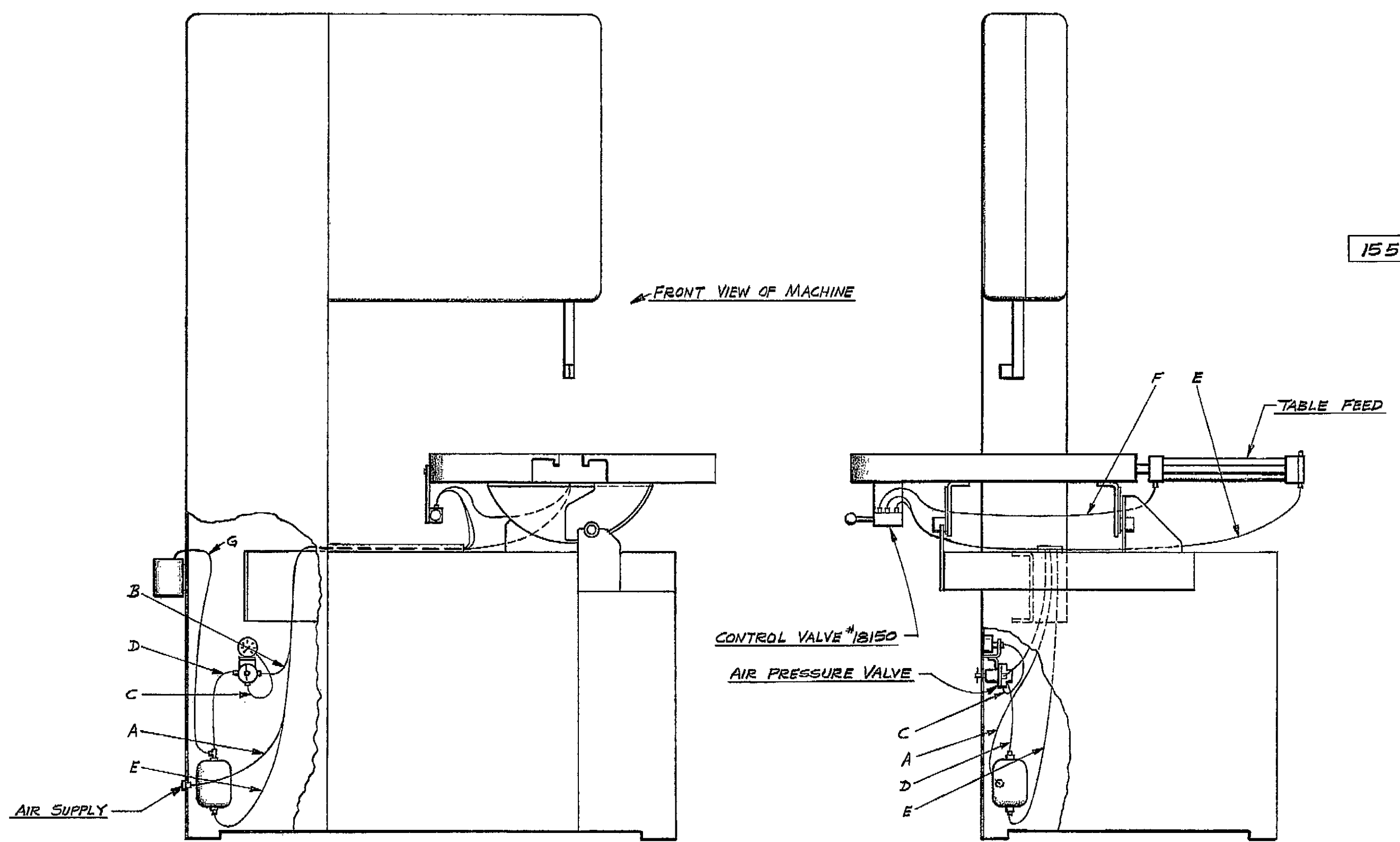
6V-36 Band Saw

				DRN. RRZ	TR.	CH.	DWG. NO.
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 5-7-58	SCALE	O.K.	X-326-A

- A --- AIR SUPPLY TO CENTER TAP IN CONTROL VALVE
1/8" PLASTIC HOSE
- B --- AIR PRESSURE VALVE TO REAR TAP IN CONTROL VALVE
1/8" PLASTIC HOSE
- C --- AIR PRESSURE VALVE TO AIR PRESSURE GAUGE
1/8" PLASTIC HOSE
- D --- TOP OF SURGE TANK TO AIR PRESSURE VALVE
1/8" PLASTIC HOSE
- E --- BOTTOM OF SURGE TANK TO REAR OF TABLE FEED
1/4" RUBBER HOSE
- F --- FRONT TAP IN CONTROL VALVE TO FRONT OF TABLE FEED
1/8" PLASTIC HOSE



LINE "G", AND TEE ON TOP OF SURGE TANK, ARE USED ONLY ON MACHINES EQUIPPED WITH MIST COOLANT ATTACHMENT.
1/8" PLASTIC HOSE

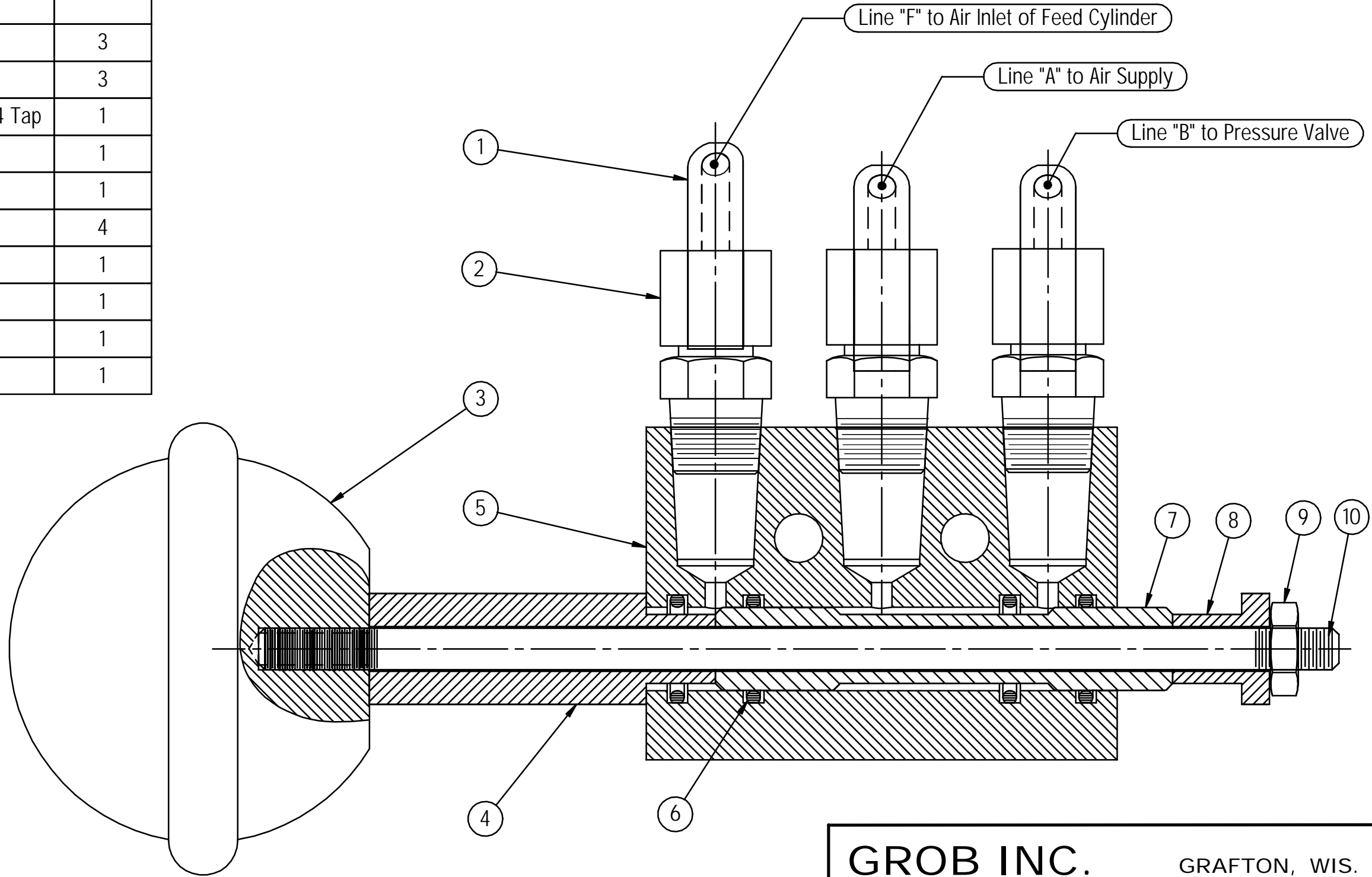


GROB INC. GRAFTON, WIS.

TABLE FEED OIL AND AIR LINE DRAWING
FOR GV-36 BAND SAW

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. W.S.S.	TR.	CH.	DWG. NO.
				DATE 9-16-68	SCALE	O. K.	15541-C

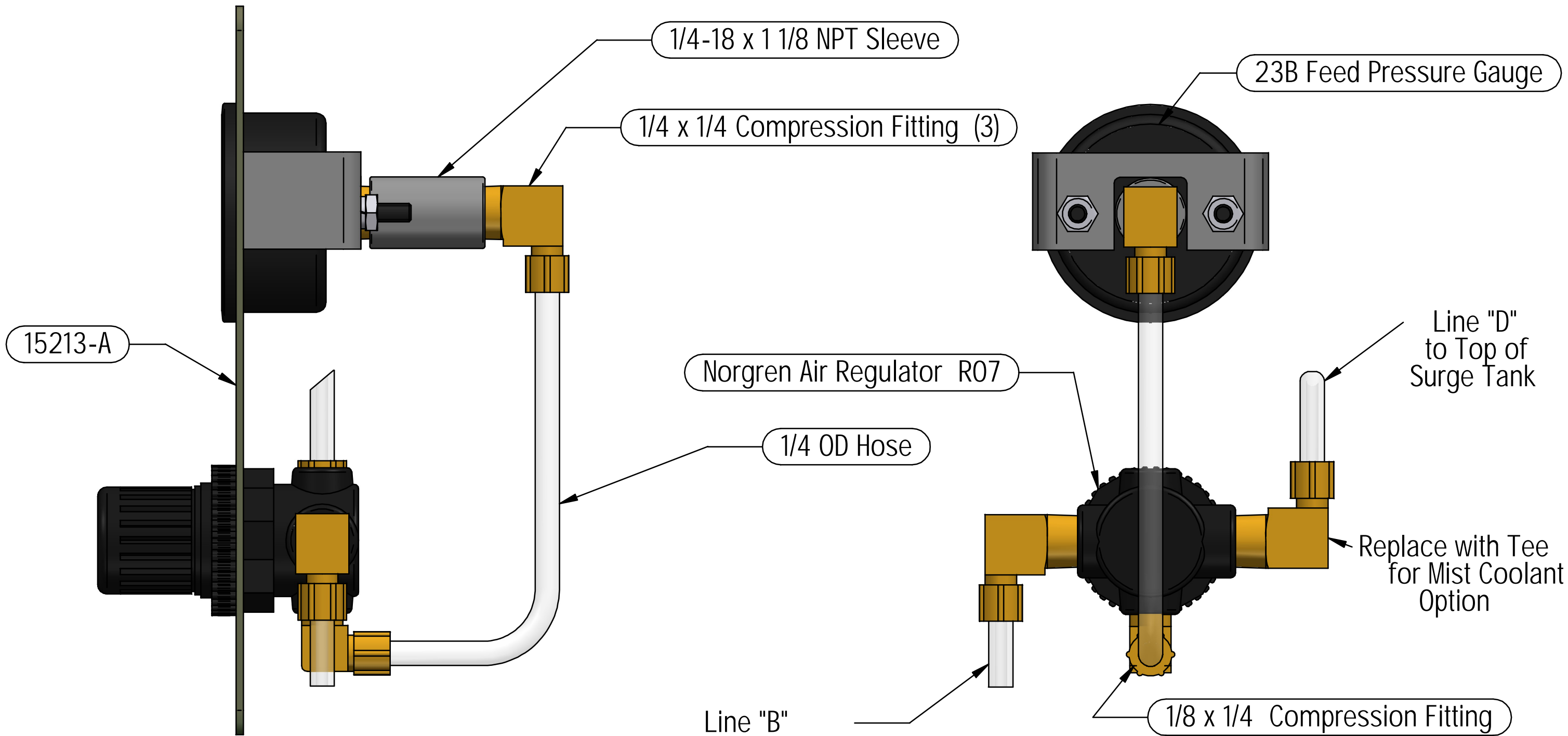
Item Number	Document Number	Title	Quantity
1	1/4 Air Line	Air Line	3
2	P-38	1/4 x 1/8 Fitting	3
3	18383-A	M-80A Knob / #10-24 Tap	1
4	18195-A	Handle Spacer	1
5	18193-A	Valve Body	1
6	ARP568A-012	O-Ring Seal	4
7	18194-A	Valve Stem	1
8	18196-A	Retaining Sleeve	1
9	#10-24	Hex Nut	1
10	18197-A	Clamp Stud	1



GROB INC. GRAFTON, WIS.

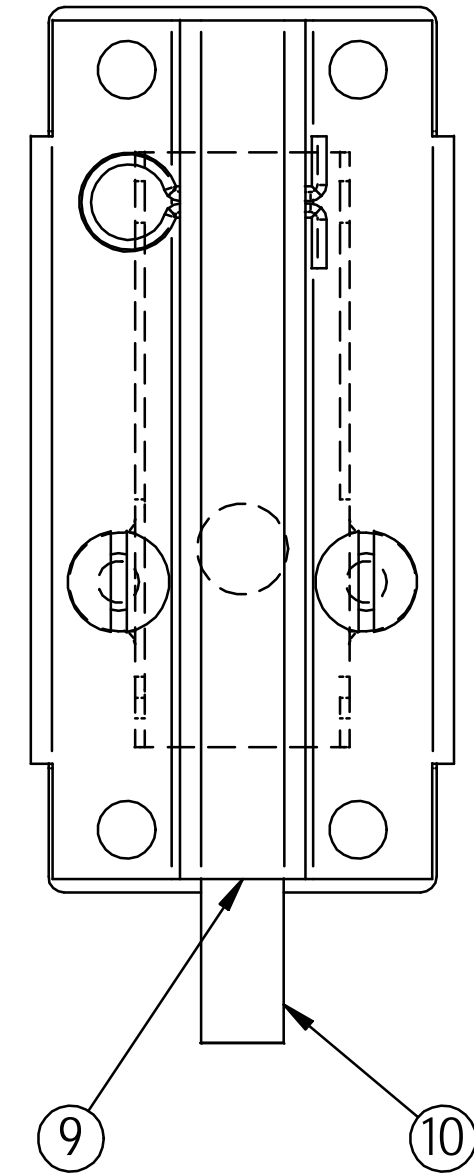
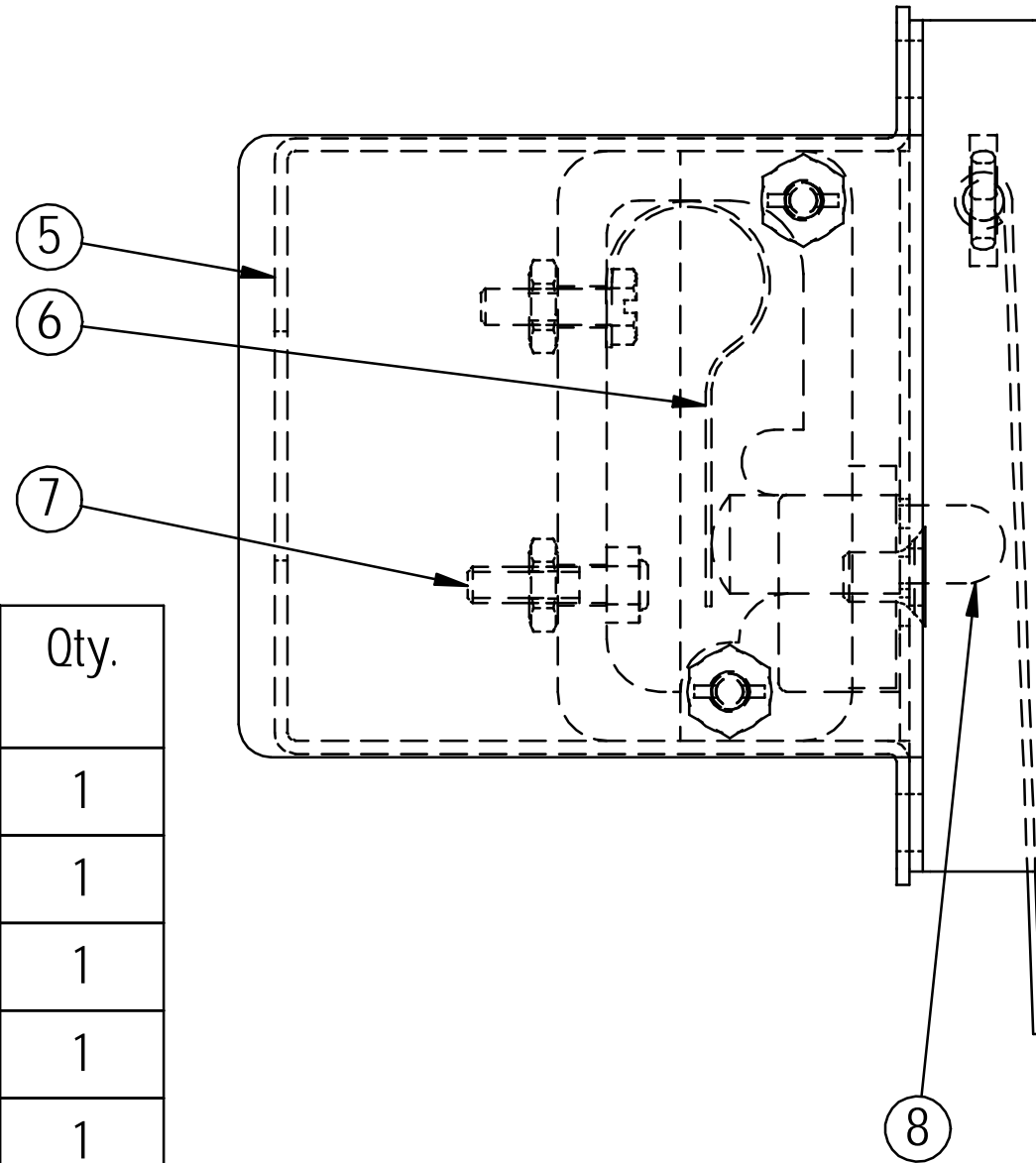
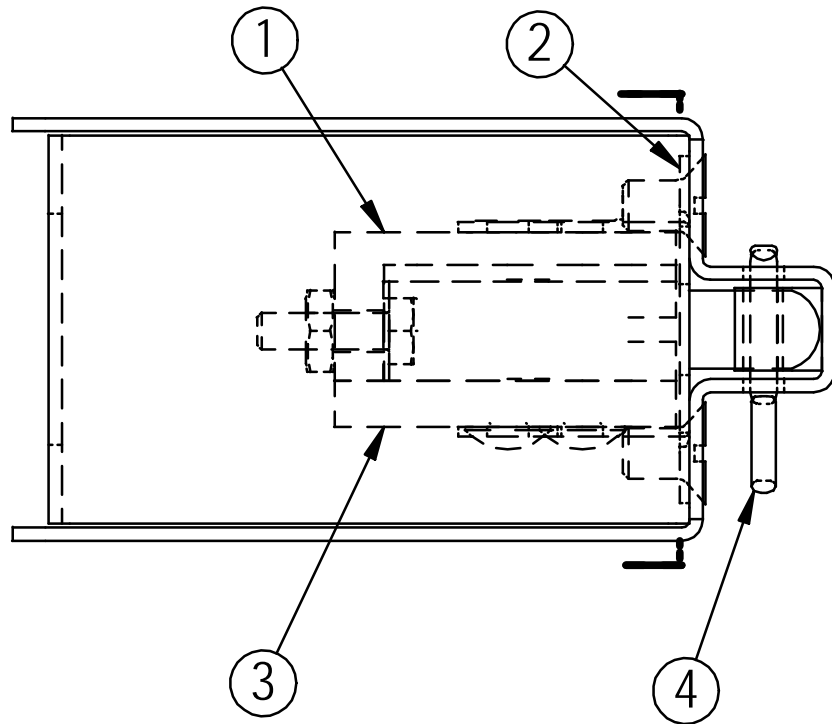
Feed Control Valve Assembly
for Grob Band Saws

One				DRN. KS	TR.	CH.	DWG. NO.
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 1-02-03	SCALE 2:1	O.K.	18150-B



GROB INC. GRAFTON, WIS.
 Air Pressure Gauge & Valve Assembly
 for Grob Band Saws

One				DRN. KS	TR.	CH.	18273-B
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 1-31-01	SCALE	O.K.	



Item No.	Part No.	Description	Qty.
1	BW-294-A	Switch Body	1
2	BW-196-A	Switch Bracket	1
3	BW-293-A	Switch Cap	1
4	.125	Cotter Pin	1
5	18262-A	Switch Cover	1
6	BW-202-A	Contact Leaf	1
7	BW-205-A	Cap Screw	1
8	BW-191-A	Push Button	1
9	18261-A	Switch Jacket	1
10	18269-A	Door Limit Switch Spring	1

GROB INC. GRAFTON, WIS.
 Door Limit Switch Assembly
 for Grob Band Saws

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

DRN. KS	TR.	CH.
DATE 5-01-03	SCALE 1:1	O.K.

DWG. NO.
18285-A



GROB 6V-36 Parts

GrobBandSaw.com
888-550-3116

