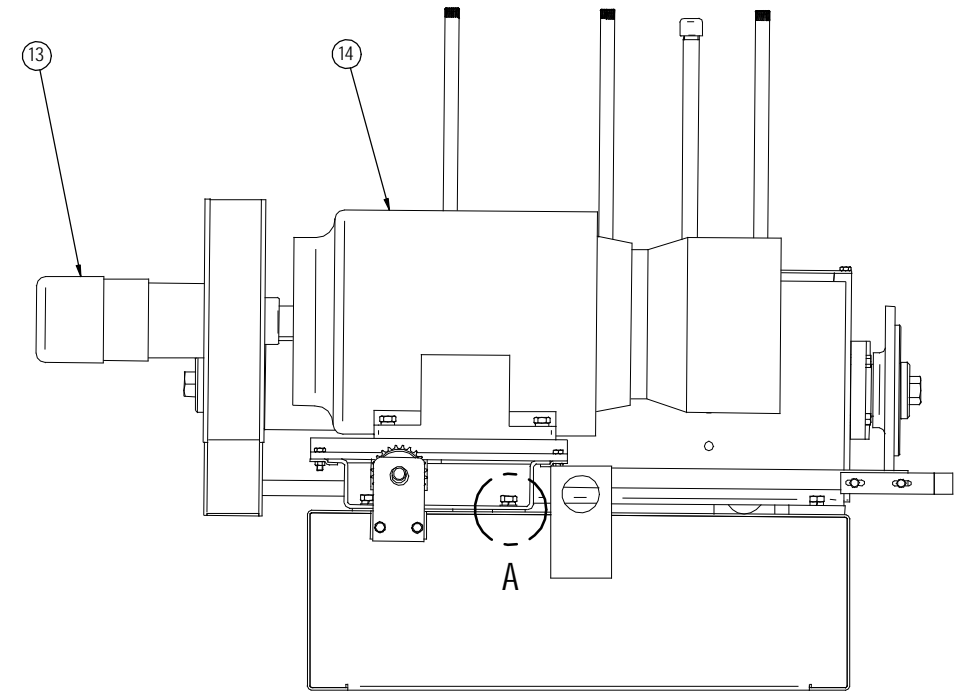
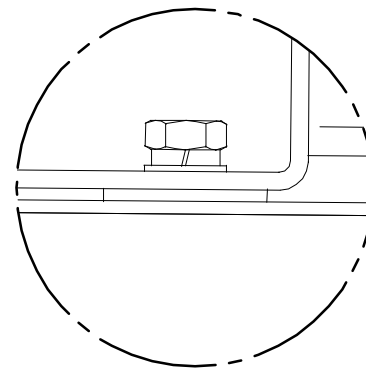
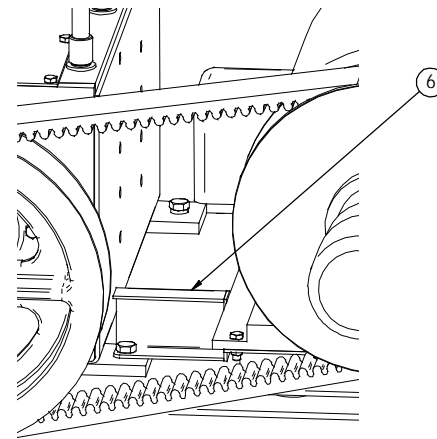
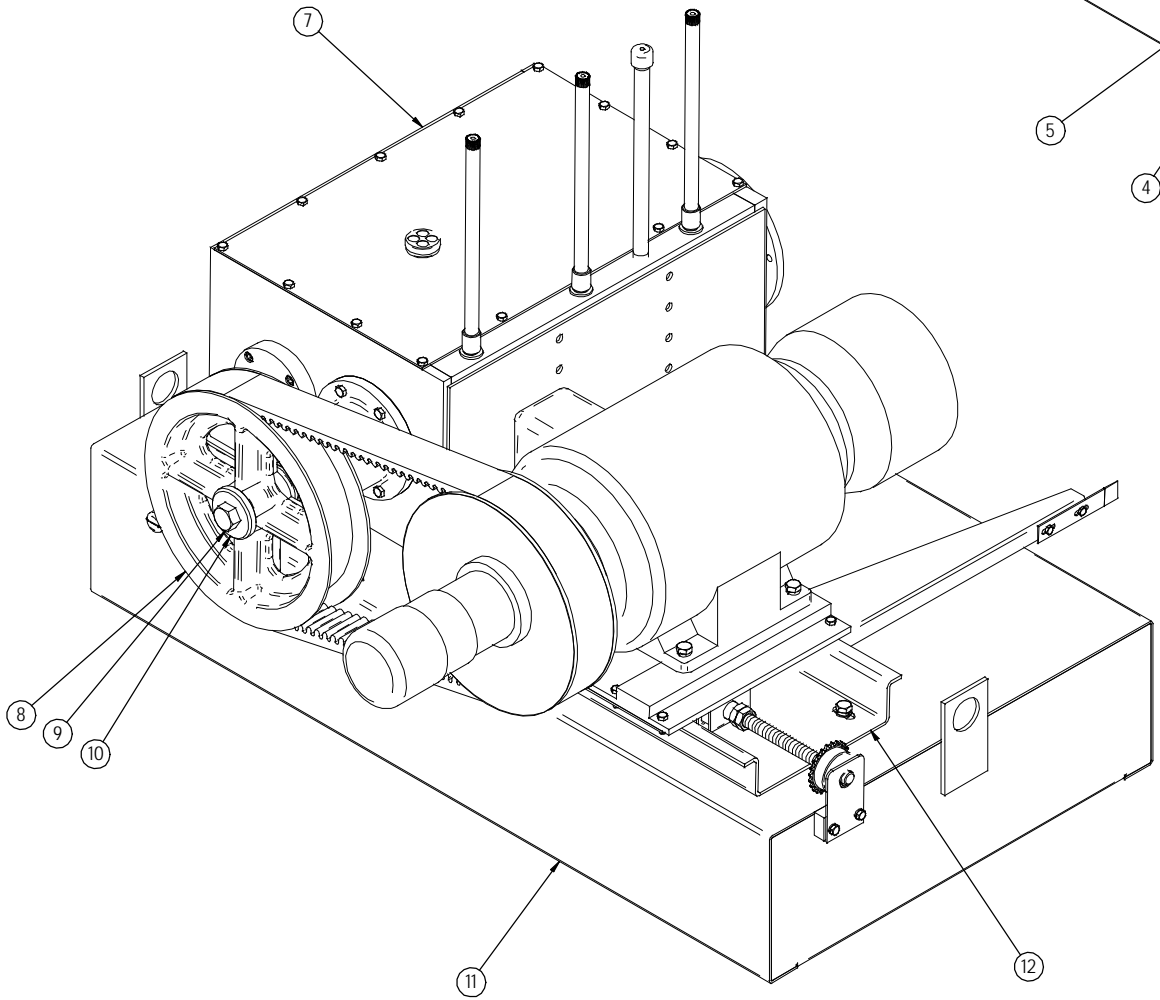
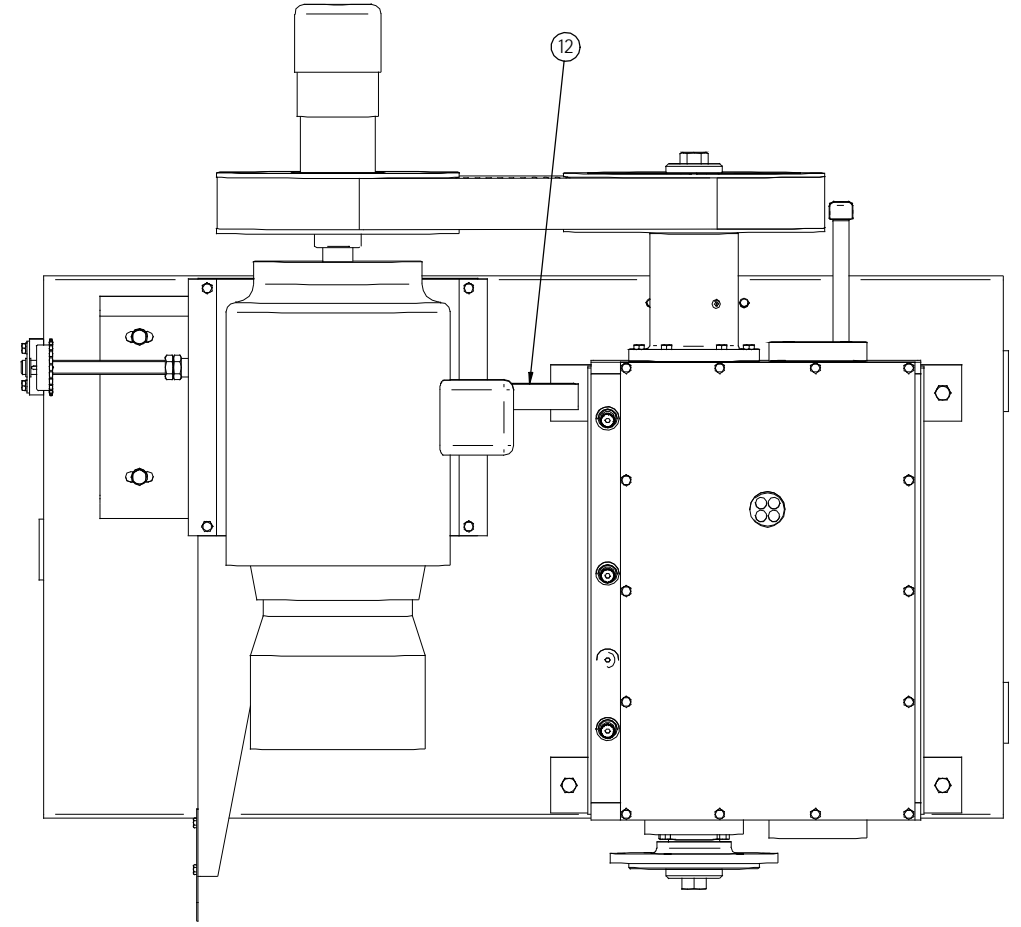
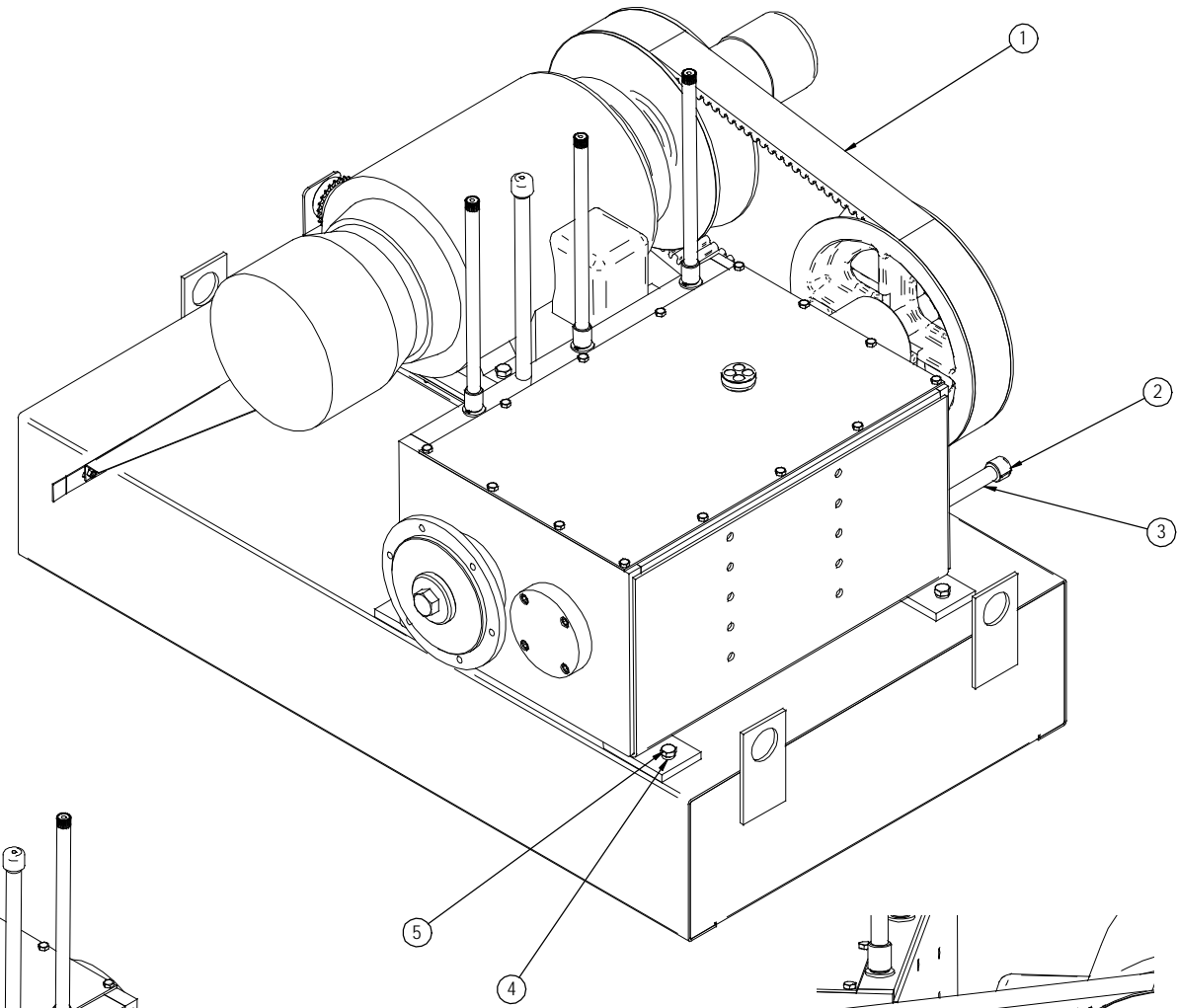




GROB 6V-36 Parts
Single Speed
GrobBandSaw.com
888-550-3116



Item Number	Document Number	Title	Quantity
1	4430V790	Vari-Speed Belt	1
2	1/2-14 NPT	Pipe Cap	1
3	HS-1041-A	Transmission Oil Drain Tube	1
4		1/2 Lock Washer	8
5	1/2-13 x 1 1/2	Hex Head Cap Screw	8
6	HS-939-A	Motor Slide Stop	1
7	HS-930-D	Transmission Assembly	1
8	HS-888-B	Drive Pulley	1
9	7/8-9 x 1 1/2	Hex Bolt	1
10	HS-958-A	Pulley Clamp Washer	1
11	HS-963-D	Concrete Base	1
12	HS-1078-C	Motor Slide Assembly	1
13	RC1315	Woods Variable Speed Sheave	1
14		15HP Baldor Electric Motor	1



GROB INC. GRAFTON, WIS.

6V-36 Power Unit Assembly

One	NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS	TR.	CHK.	DATE 9-17-02	SCALE 1:5	D.K.	HS-1037-D
-----	-----------	-----------	----------	----------------	---------	-----	------	--------------	-----------	------	-----------

INSTRUCTIONS FOR INSTALLING HS-235 TENSION SHAFT

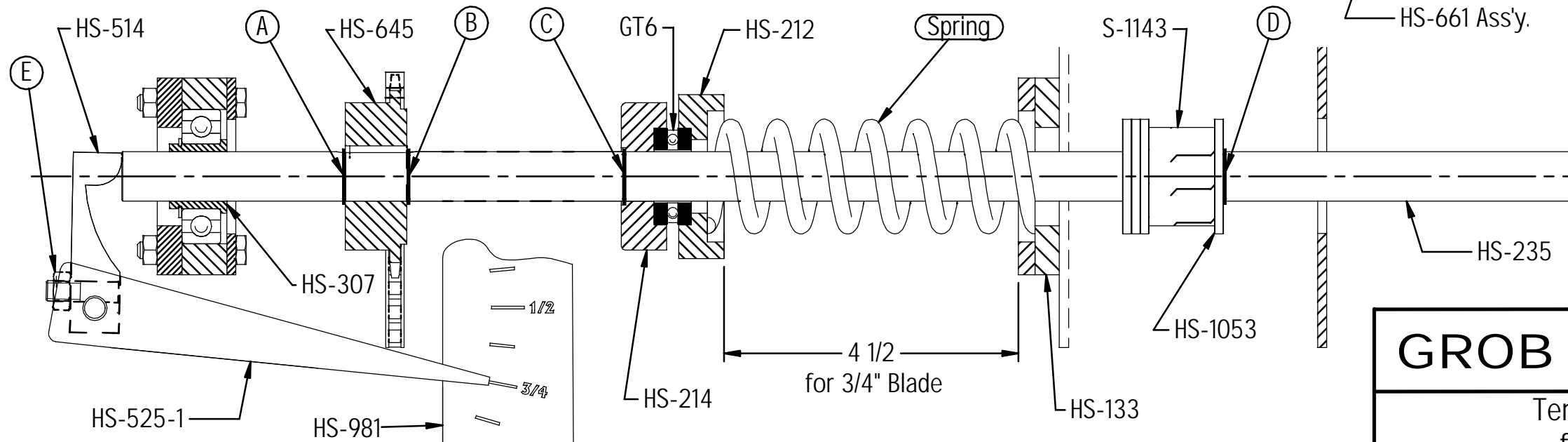
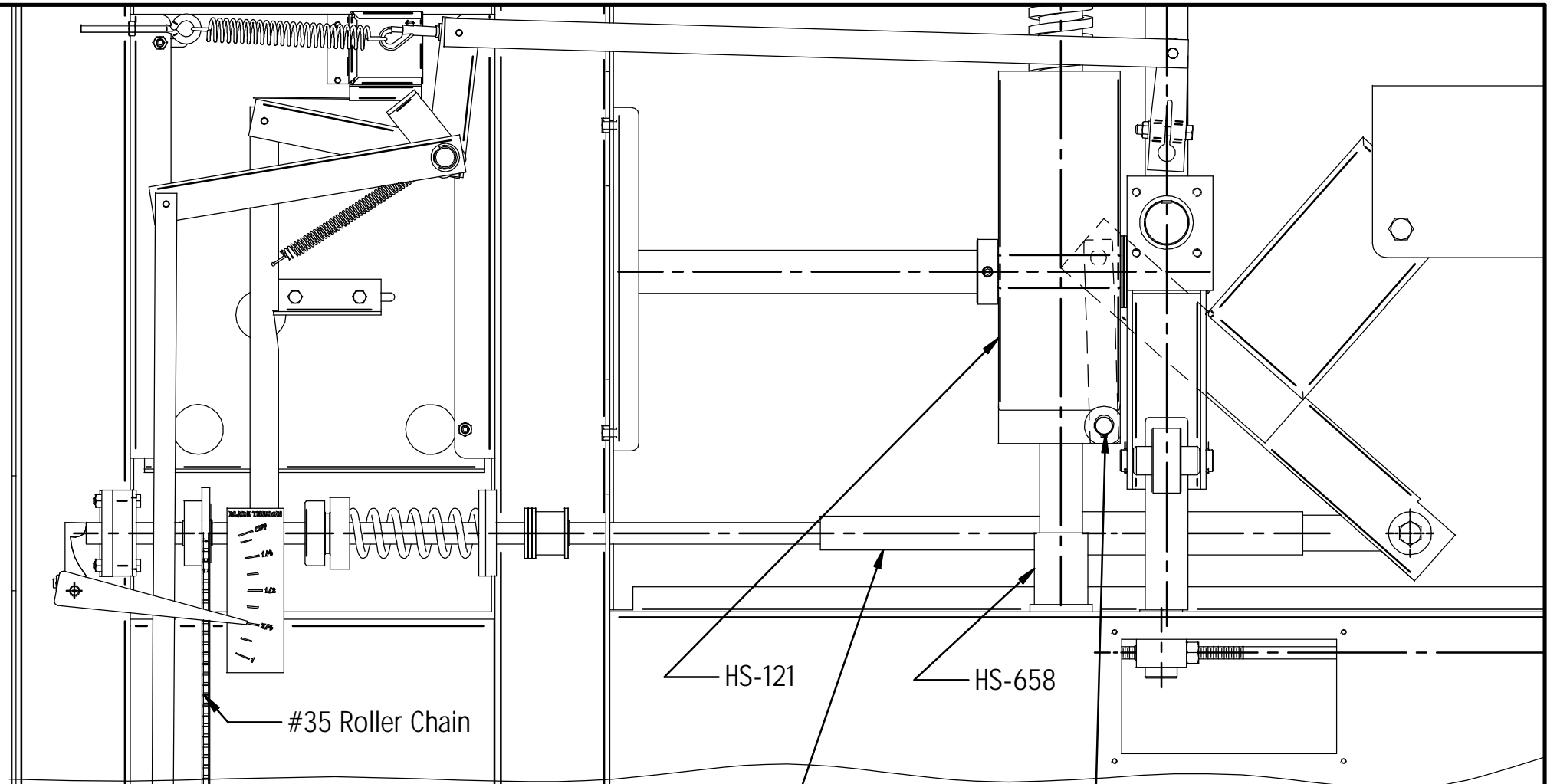
- 1 Slide threaded end of Tension Shaft thru HS-307 Bearing.
- 2 Assemble Parts in order as follows: HS-645, HS-214, GT6 Brg., HS-212, and Spring.
- 3 Slide Shaft thru HS-133 Frame Plate and assemble 3 HS-1053 Washers, S-1143 Rubber Bumper and 1 HS-1053 Washer onto Shaft.
- 4 Slide Shaft forward and 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

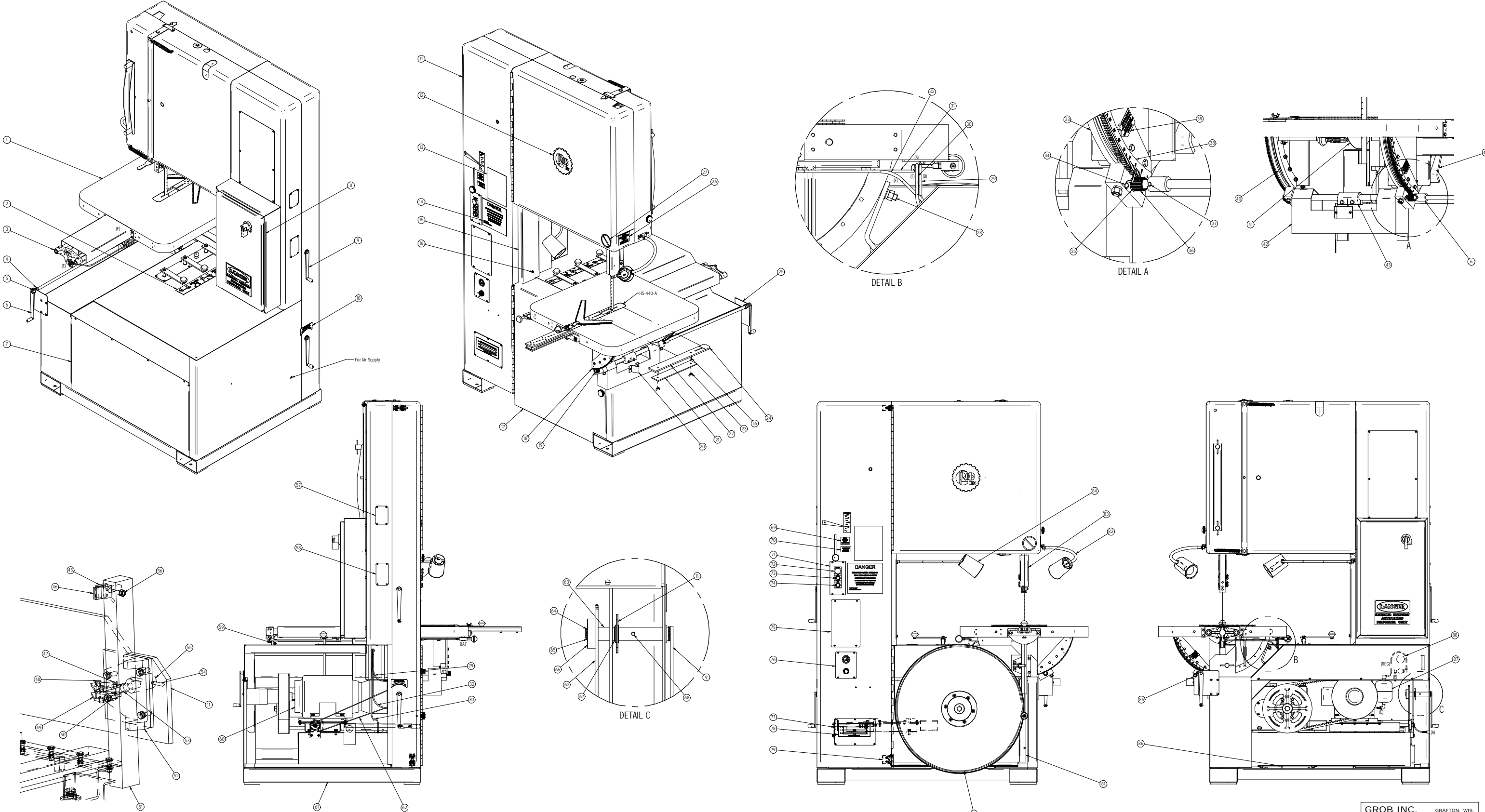
- 1 Lower HS-121 Carriage to HS-658 Stop. Remove 5100-62 Retaining Ring and HS-253 Pin.
- 2 Unscrew Tension Shaft from HS-661 Assembly.
- 3 Remove 3 5103-75 Retaining Rings A, B, and C.
- 4 Slide Shaft in and remove 5103-75 Retaining Ring D.
- 5 Remove 4 Washers and Rubber Bumper and slide Shaft out.

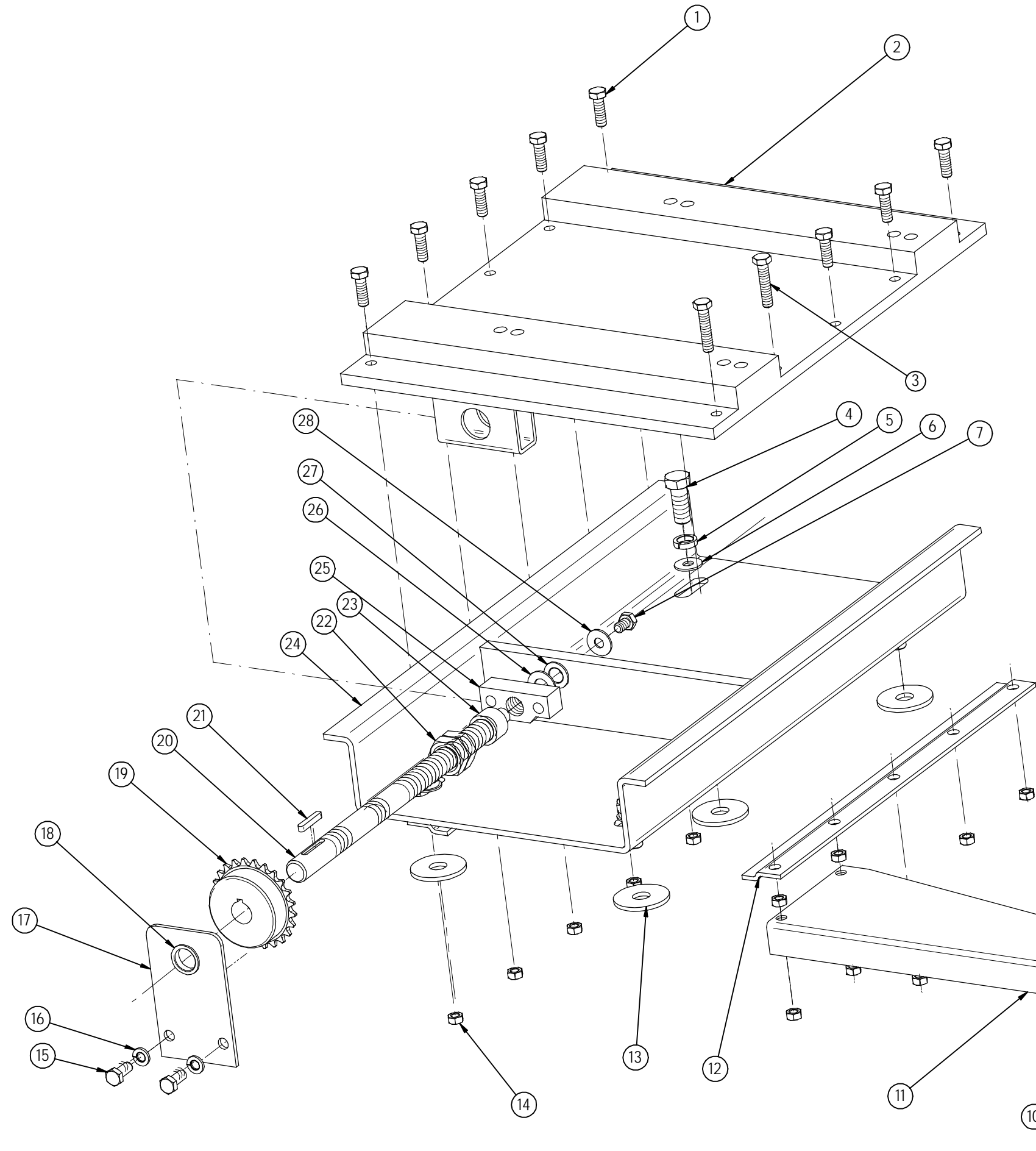


GROB INC. GRAFTON, WIS.
 Tension Shaft Instructions
 for 6V-36 Band Saw

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS DATE 12-17-01	TR. SCALE	CH. O.K.	DWG. NO. HS-1051-B
-----------	-----------	----------	----------------	--------------------------	--------------	-------------	-----------------------

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	Wagon Box Head Pin	1	56	S-547-A	Guide Holder Clamp Stud	2	65	5100-76	External Retaining Ring	1	74	Start Button	CH 10250130B	1	83	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-410-A	Table Tilt Warning	1	48	HS-587-A	Guide Bar Clamp Pin	2	57	HS-562-A	Tension Pickup Cover	1	66	HS-850-A	40 Tooth Sprocket	1	75	GS-2286-B	Built Wider Blank Plate	1	84	Work Light - 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	Chain Adjustment Cover	1	67	5100-77	External Retaining Ring	2	76	HS-273-B	Air Gauge & Valve Assy	1	85	HS-435-A	T-Bolt - Long	2							
5	F-379-A	3/4" Flanged Bushing	4	14		DMG2R Plate	1	23	HS-106-B	Outer Table Support Bracket	1	32	HS-946-B	Lower Saw Band Guard	1	50	HS-524-A	Guide Bar Clamp	1	59	HS-810-C	Feed Roller Assembly	1	68	HS-442-A	Tension Crank Pin	1	77	HS-933-A	Speed Chart Plate	1	86	HS-1000-A	HS Lower Base Pin	2			
6	HS-303-B	Table Tilt Crank Assembly	1	15	HS-309-C	Rear Saw Band Guard	1	24	HS-983-A	Table Filter Plate (Rear)	1	33	HS-107-B	Inner Table Support Bracket	2	42	HS-221-C	Table Support	1	51	HS-521-A	Lower Guide Bar	1	69	HS-370-A	Stop Miter for Shifting Decal	1	78	HS-931-B	Speed Chart	1	87	HS-1524-B	Surge Tank	1			
7	HS-954-B	Rear Base Cover	1	16	HS-1074-A	Rear Saw Band Stud	4	25	HS-426-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-533-C	Sub Base	1	70	HS-231-A	Caution Close Door Decal	1	79	HS-285-A	Door Limit Switch Assy	2	88	HS-1075-D	Air Line - Reg	1			
8	HS-1076-C	Electrical Box Assembly	1	17	HS-125-C	Base Door Assembly	1	26	HS-288-A	Bar Release Decal	1	35	HS-1232	Idle Bearing	2	44	HS-589-A	R Table Support Bkt	1	53	HS-552-A	Clamp Stud	1	62	HS-548-A	Switch Box Cover	1	80	HS-2911-C	Saw Pulley	2							
9	HS-593-A	Crank Assembly	2	18	HS-244-C	Gear Sector	2	27	HS-297-A	Table Tilt Pinion	1	36	HS-297-A	Table Tilt Pinion	1	45	S-1124-A	S&I Upper 1 Pc Guide Holder	2	54	HS-546-A	Handle for Clamp Pin Nut	1	63	HS-578-A	Tension Crank Shaft	1	72	AR 800T-D402	Emergency Stop Button	1	81	HS-978-B	Front Base Cover	1			

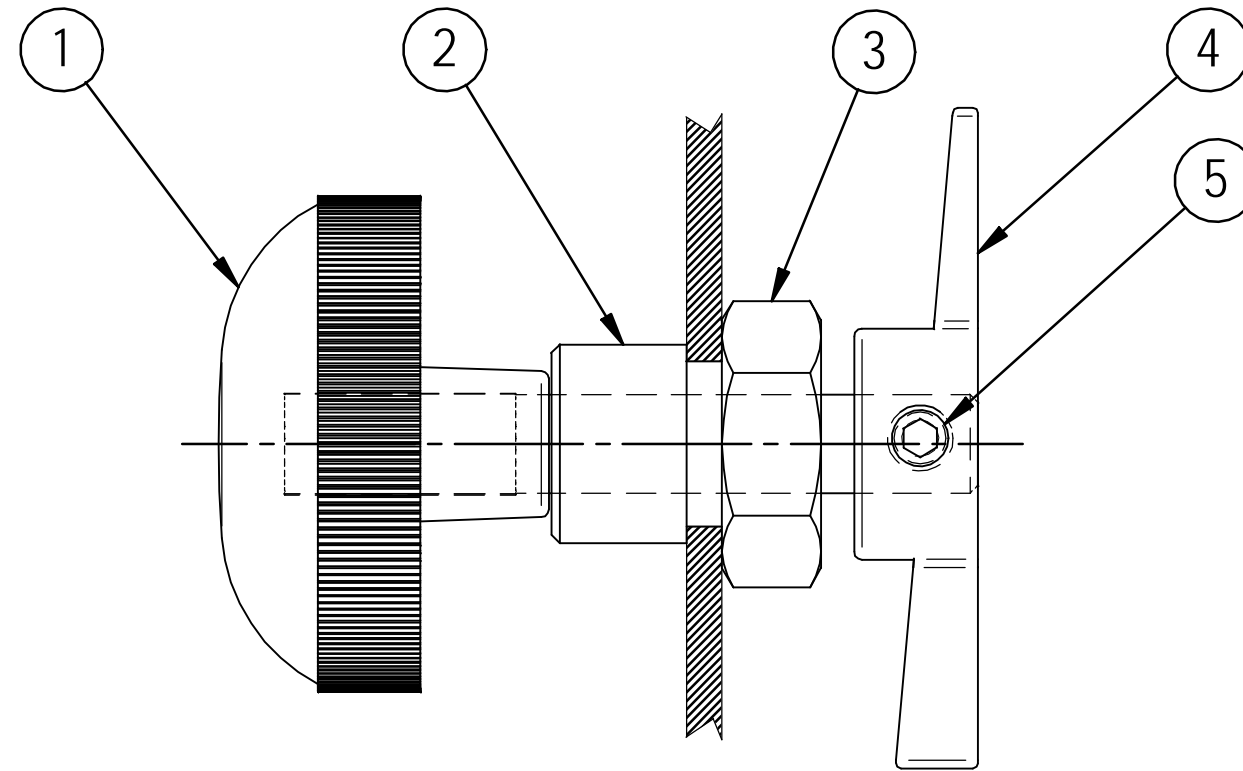




Item Number	Document Number	Title	Quantity
1	5/16-18 x 1	Hex Head Cap Screw	8
2	24033-B	Motor Slide Plate	1
3	5/16-18 x 1 1/2	Hex Head Cap Screw	2
4	1/2-13 x 1 1/4	Hex Head Cap Screw	4
5		1/2 Lock Washer	4
6		1/2x7/8 Flat Washer	4
7	5/16-18 x 1/2	ThreadLocked Hex Head Cap Screw	1
8		1/4-20 Hex Nut	2
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			
DRN. KS	TR.	CH.	DWG. NO.
DATE 9-18-02	SCALE	O.K.	HS-1078-C

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



Item Number	Document Number	Title	Quantity
1	HS-1086-A	Knob Assembly	1
2	HS-1081-A	Base Door Latch Ferrule	1
3		5/8-24 Jam Nut	1
4	S-587-A	Base Door Clamp	1
5	1/4-20 x 1/4	Set Screw-Cup pt	1

Supersedes Assembly No. HS-1080-A

GROB INC.

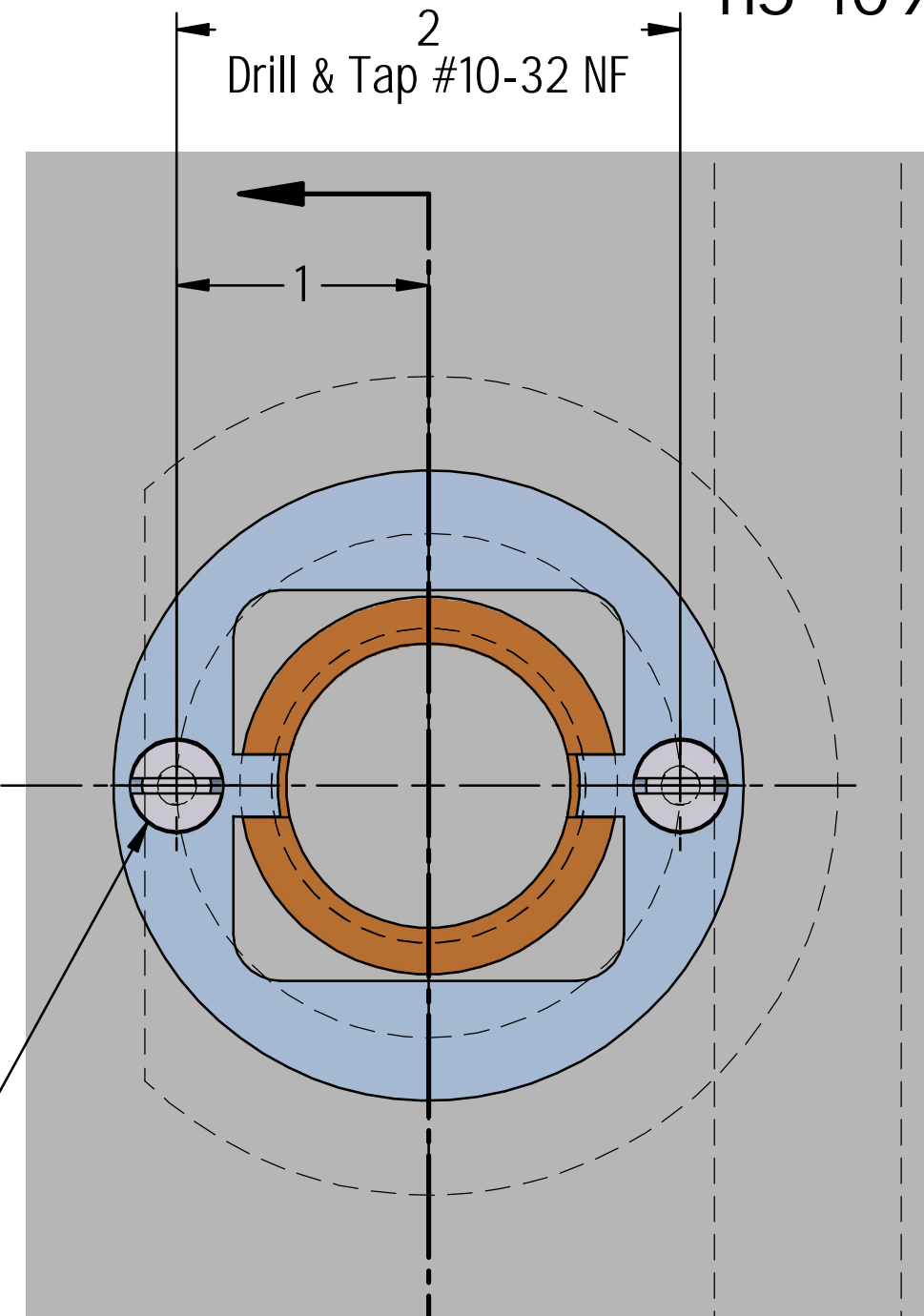
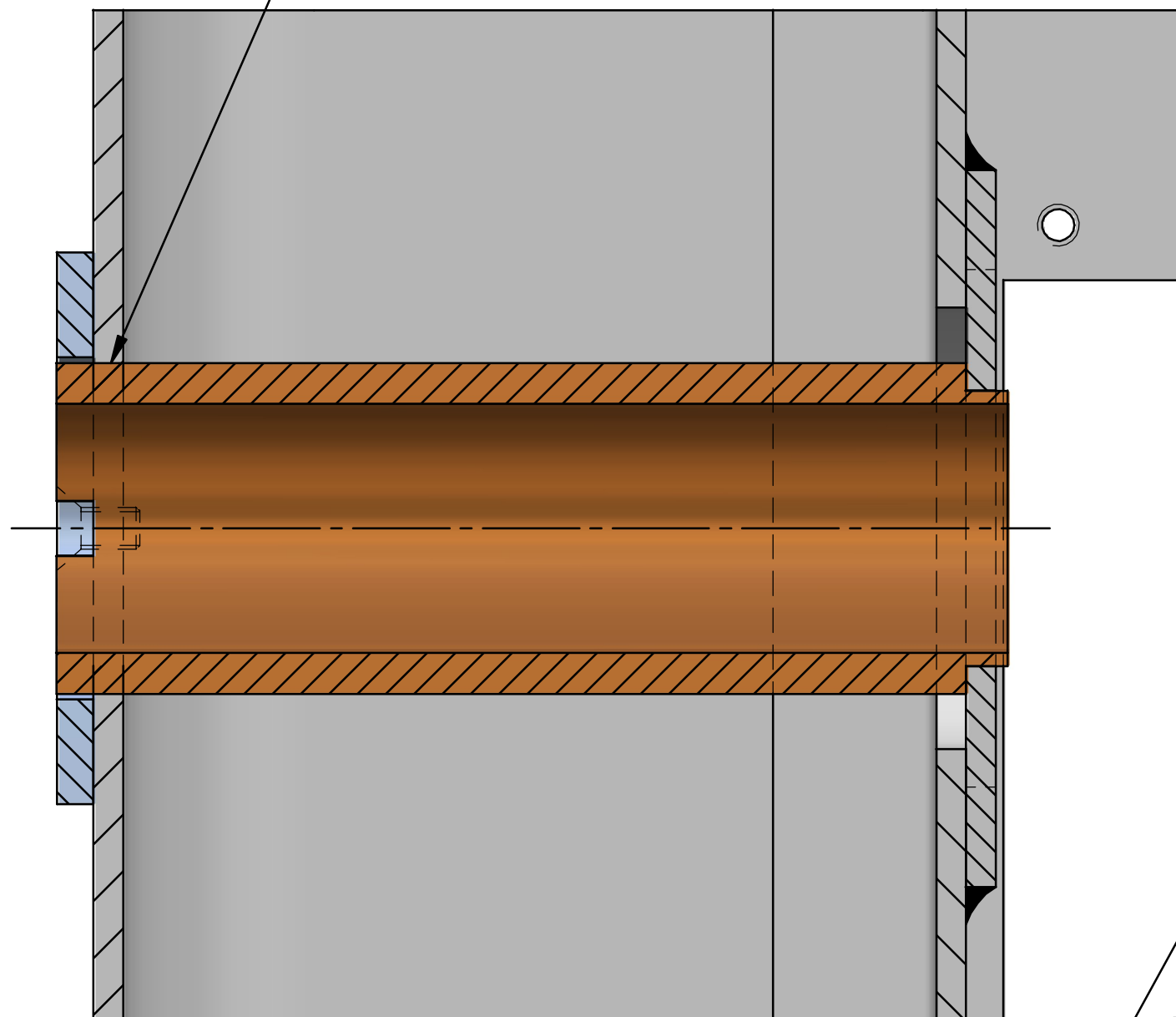
GRAFTON, WIS.

Base Door Latch Assembly
for 6V-36 Band Saw

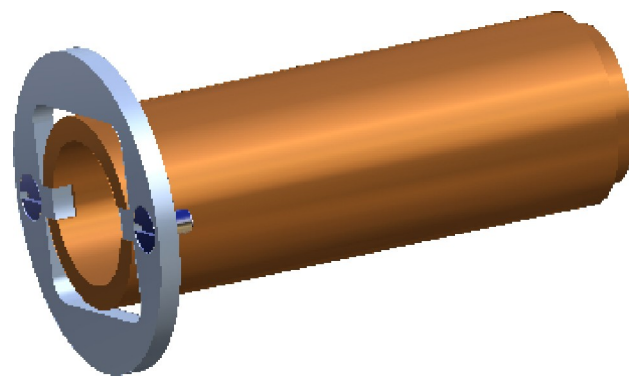
One				DRN. KS	TR.	CH.	DWG. NO.
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 10-17-02	SCALE 1:1	O.K. Rev 1	HS-1083-A

HS-1094-A

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



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

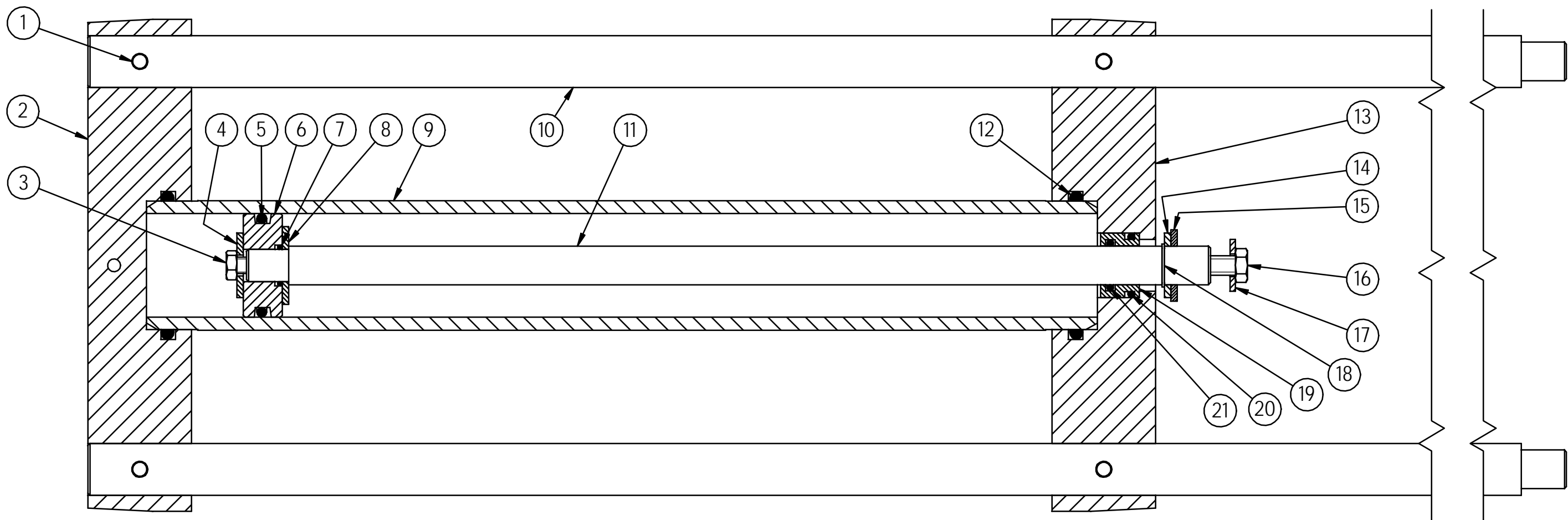


GROB INC.

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

One				DRN. KS	TR.	CH.	DWG. NO.
NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DATE 3-4-05	SCALE 1:2	O.K.	HS-1095-B

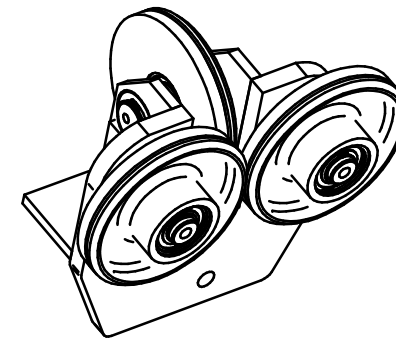
Roller Guide Parts List

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

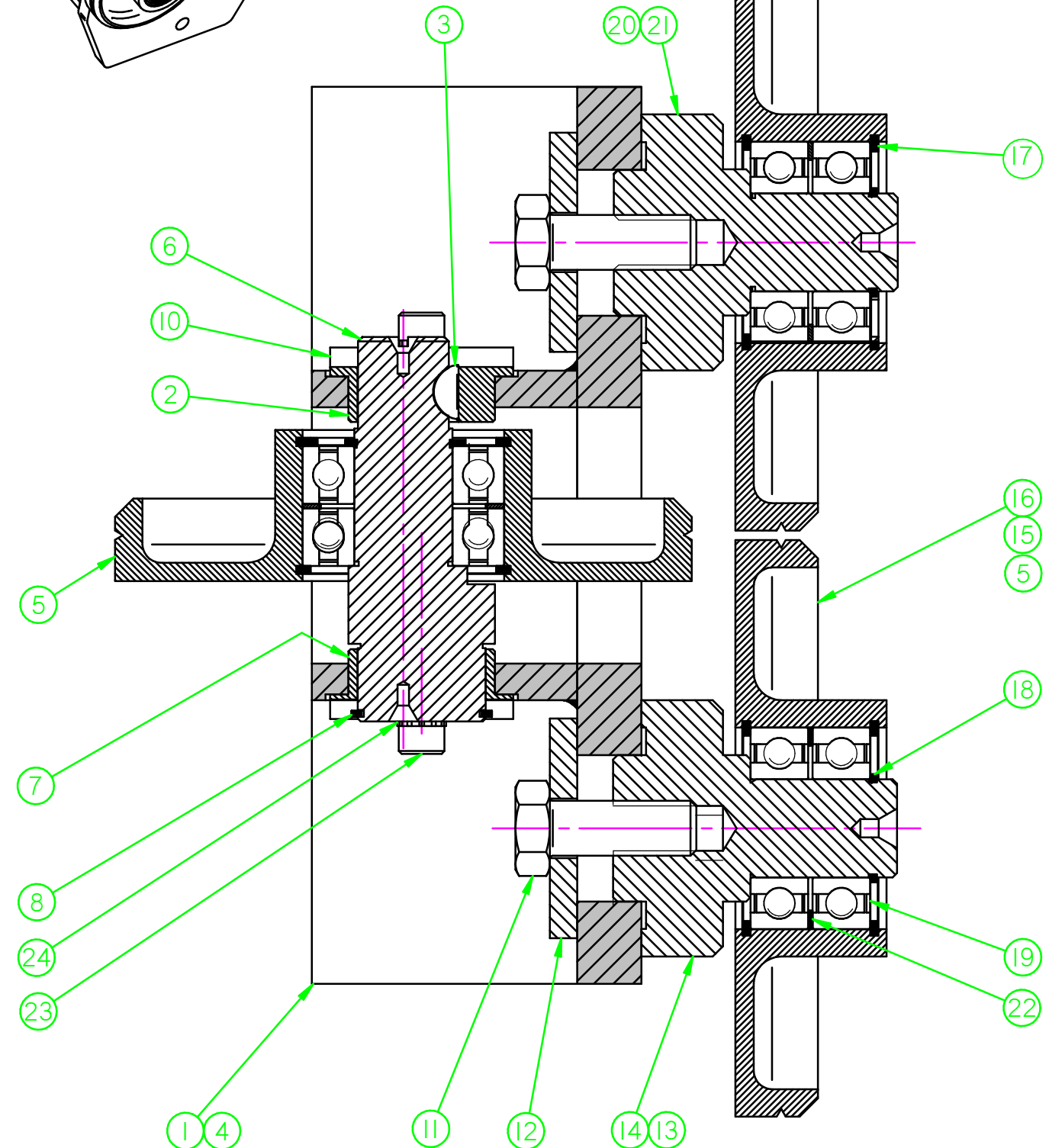
HS-332 Set for 5/8" - 1" Saw Blades
HS-611 Set for 3/8" & 1/2" Saw Blades
HS-696 Set for 1/4" Saw Blade

Sets Include 4 Side Rollers, Shafts, & Bearings

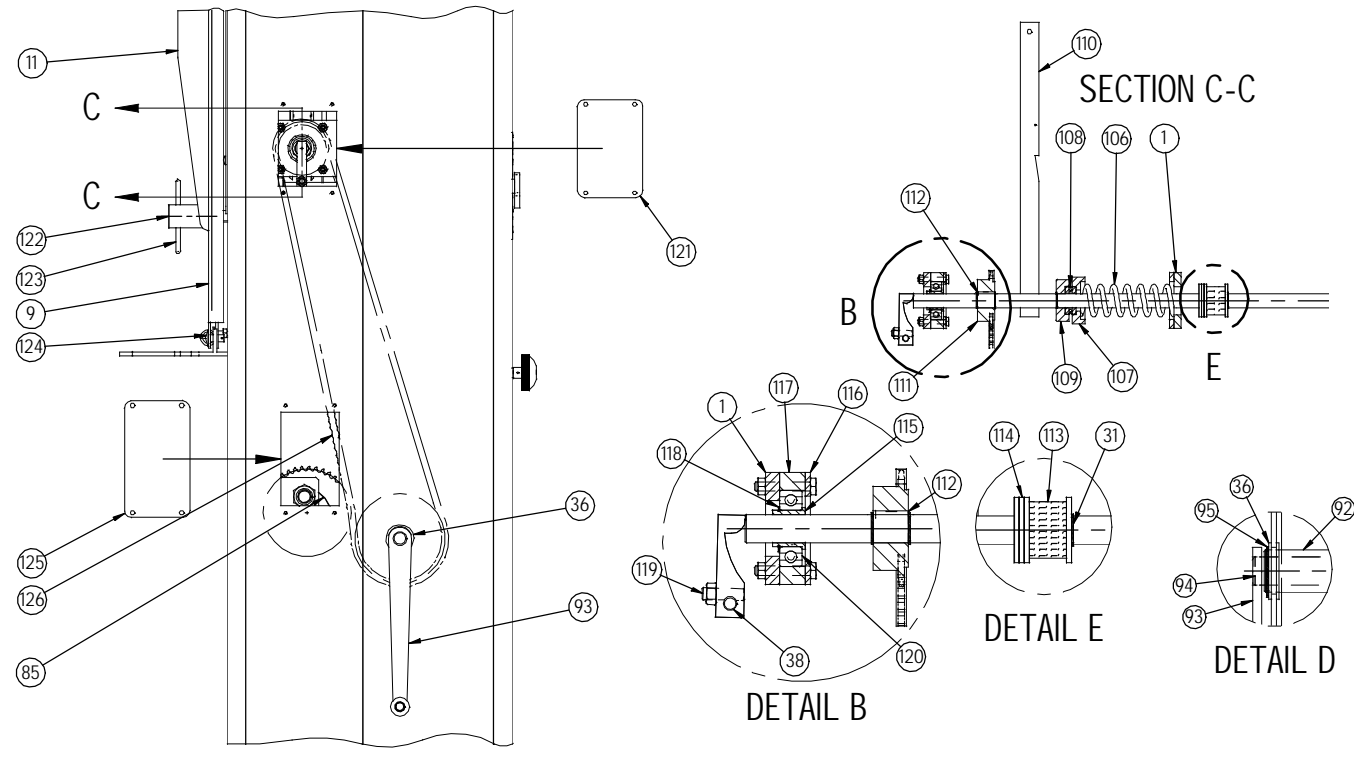
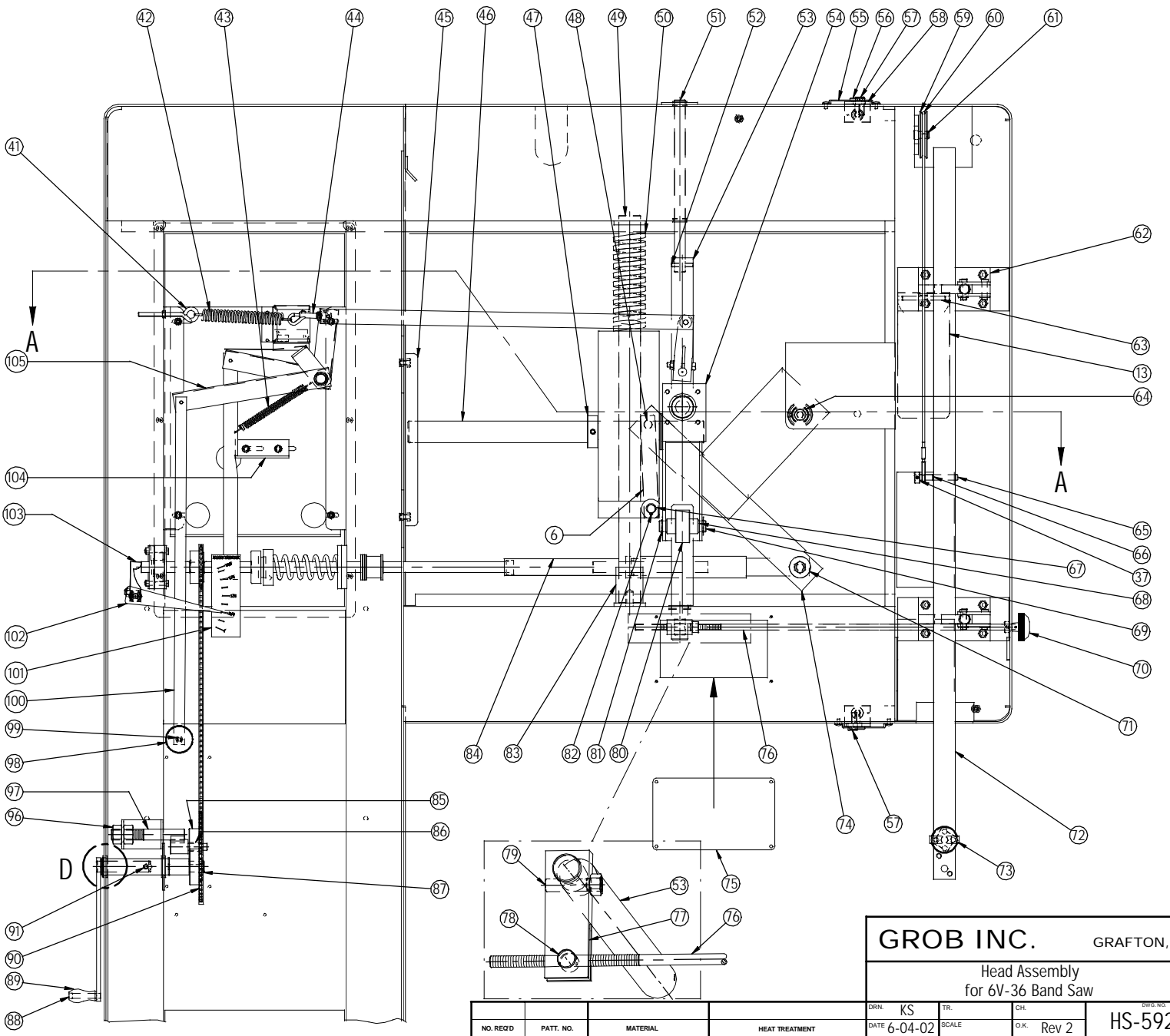
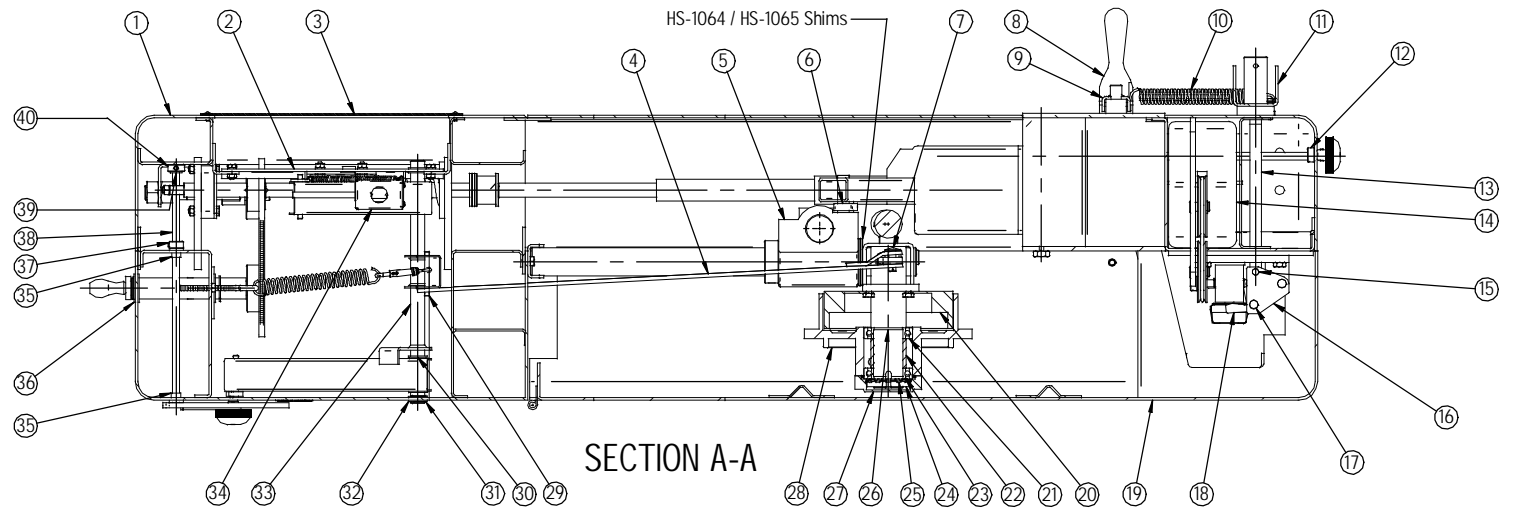
Item Number	Quantity	Document Number	Title
1	2	HS-397-C	Roller Guide Frame
2	2	HS-448-A	Eccentric Roller Shaft Bushing
3	2	#213	Woodruff Key
4	2	15186	Roller Guide Frame/S-24-U
5	6	HS-332-A	Rear Roller/All Blades-Side Roll 5/8-1
		HS-332-Assy.	Roller with Bearing
6	2	HS-528-A	Rear Roller Shaft
7	2	HS-527-A	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)

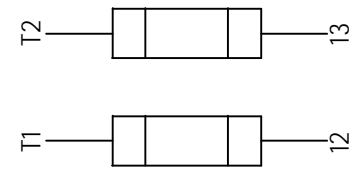
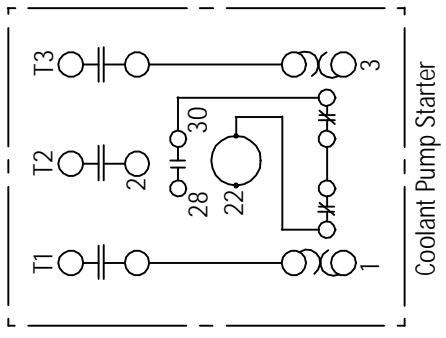
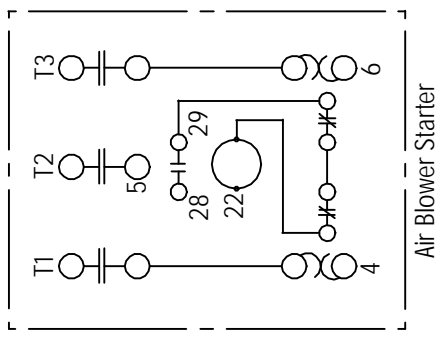
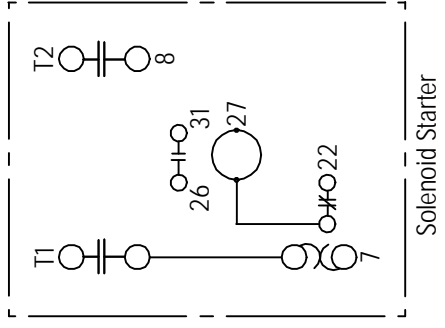
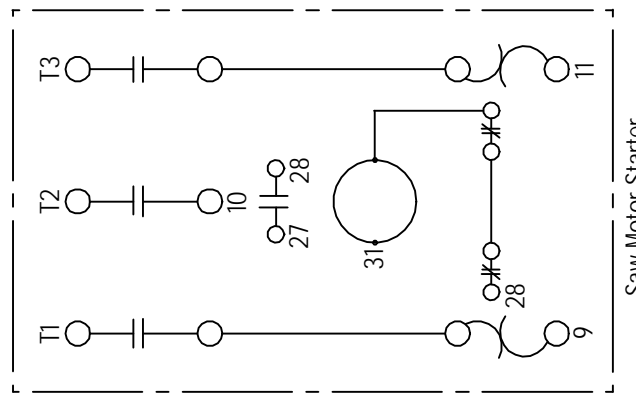
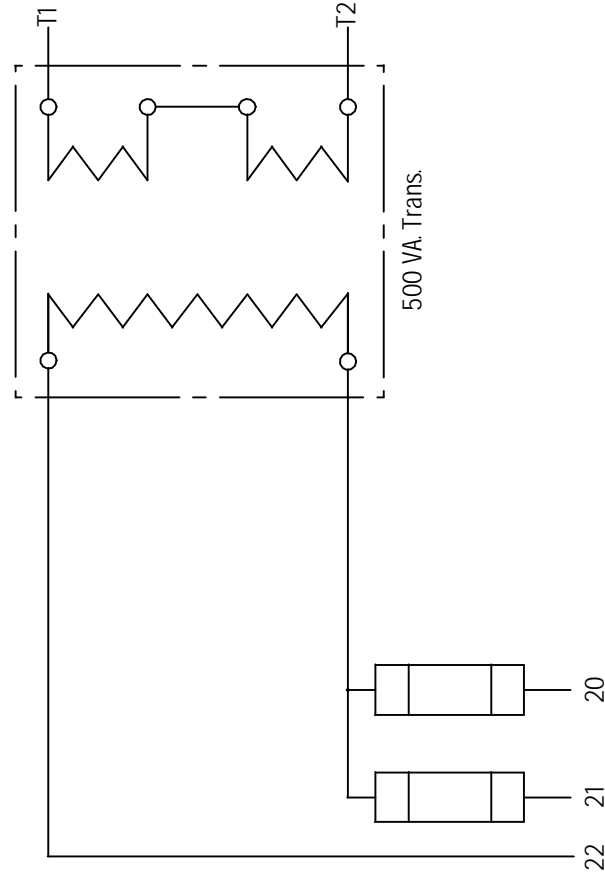
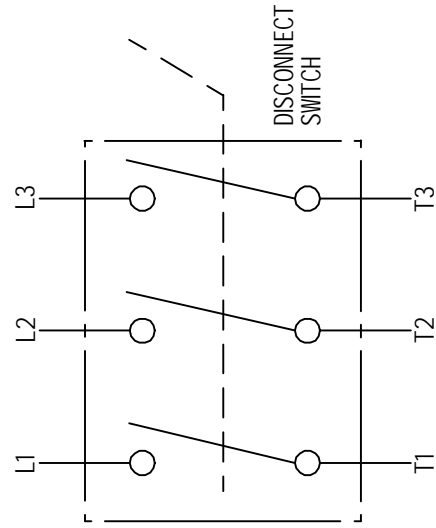


Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.	Item No.	Part No.	Description	Qty.
1	HS-505-D	Frame	1	43	V23C	Gardner Spring	1	85	HS-851-A	40 Tooth Sprocket	1
2	HS-501-B	Mounting Plate	1	44		1/2 x 3 Clasp	1	86	AA-628-20	Oilite Bearing	1
3	HS-539-B	Cover	1	45	HS-141-B	Alignment Channel	1	87	5100-75	External Retaining Ring	2
4	HS-513-A	Brake Link	1	46	HS-549-A	Pivot Shaft	1	88	S-1198-A	Handwheel Crank Pin	1
5	HS-121-C	Carriage	1	47	HS-1063-A	1 1/2 Set Collar	1	89	S-1199-A	Handwheel Crank	1
6	HS-254-A	Tension Link	1	48	HS-135-A	Upper Pin-Tension Link	1	90	HS-850-A	40 Tooth Sprocket	1
7	HS-239-A	Brake Link Pin	1	49	HS-140-A	Column Bar	1	91	HS-642-A	Tension Crank Pin	1
8	HS-493-B	Column Door Lower Latch	1	50	9-4028-11	Column Bar Spring	1	92	HS-578-A	Tension Crank Shaft	1
9	HS-165-B	Door Latch U-Channel	1	51	HS-515-A	Eccentric Shaft Extension	1	93	HS-593-A	Hand Crank	1
10	V19C	Gardner Spring	2	52	HS-643-A	Eccentric Shaft Pin	1	94	HS-579-A	Tension Crank	1
11	HS-545-B	Clamping Channel	1	53	HS-516-A	Eccentric Shaft	1	95	5100-112	External Retaining Ring	4
12	HS-1066-A	7/16 Set Collar	1	54	HS-953-C	Pivot Housing	1	96		3/4-10 Hex Nut	2
13	HS-544-A	Clamp Pin	2	55	HS-1057-A	Upper Door Latch Guide	2	97	HS-568-A	Chain Tightener Shaft	1
14	HS-543-C	Counter Weight	1	56	HS-162-A	Door Lock Hinge Pin	2	98	HS-999-A	Brake Reset Knob	1
15	HS-1068-A	1/4 Wagon Box Head Pin	2	57	HS-164-A	Lock Pin	2	99	HS-1054-A	Brake Reset Knob Spacer	1
16	HS-323-A	Clamp Plate	4	58	HS-166-B	Column Door Upper Latch	1	100	HS-541-A	Cocking Lever	1
17	HS-587-A	Guide Bar Clamp Pin	4	59	HS-601-A	Counterweight Pulleys	2	101	HS-981-A	Saw Band Tension Plate	1
18	HS-324-A	Guide Bar Clamp	2	60	1/8" 302 S/S	Guide Bar Tension Cable	1	102	HS-525-1-A	Tension Indicator	1
19	HS-542-C	Column Door	1	61	5100-50	External Retaining Ring	2	103	HS-514-A	Tension Pick-up Lever	1
20	324379	Bendix Brake Assembly	1	62	HS-499-B	Guide Bar Clamp Bracket	2	104	HS-500-A	Reset Bracket	1
21	6008-RS1	Bearing	1	63	HS-651-A	Weight Pin	1	105	HS-509-A	Brake Reset Lever	1
22	HS-359-A	Upper Pulley Spacer	1	64	HS-550-A	Tension Lever Arm Shaft	1	106	HS-854-A	Tension Shaft Spring	1
23	6008-NR	Bearing	1	65	HS-1056-A	Guide Bar Tension Pin	1	107	HS-212-A	Tension Spring Retainer	1
24	N-08	Bearing Locknut	1	66	5100-37	External Retaining Ring	2	108	GT6	Bearing	1
25	W-08	Bearing Lockwasher	1	67	5100-62	External Retaining Ring	1	109	HS-214-A	Thrust Bearing Cap	1
26	HS-112-A	Upper Pulley Shaft	1	68	HS-398-A	Tilt Roller Spacer	2	110	HS-503-A	Brake Reset Lever	1
27	HS-358-A	Bearing Cap	1	69	HS-567-A	Upper Tilt Roller Pin	1	111	HS-645-A	KSA-24 Sprocket	1
28	HS-292-C	Upper Brake Drum	1	70		10-NK Knob	1	112		3/16 Square Key	1
29	HS-841-A	Brake Reset Lever Pin	3	71	HS-654-A	Adaptor Bushing	2	113	S-1143-A	Rubber Bumper	1
30	F-319-A	3/4" Flanged Bushing	2	72	HS-432-B	Upper Guide Bar	1	114	HS-1053-A	Tension Shaft Stop Disc	4
31	5103-75	External Retaining Ring	6	73	S-1276-A	Saw Band Oiler Assembly	1	115	HS-307-A	Adaptor Sleeve	1
32	F-319-A	3/4" Flanged Bushing	2	74	HS-251-C	Tension Lever Arm	1	116	HS-419-A	Cover	1
33	HS-506-B	Brake Reset Shaft Assembly	1	75	HS-497-A	Channel Cover	1	117	HS-421-A	Tension Bearing Block	1
34	HS-1055-B	Brake Switch	1	76	HS-158-A	Tilt Rod Threaded	1	118	5100-98	External Retaining Ring	1
35	FF-519-2	Oilite Bushing	2	77	HS-159-A	Clamp Lever	1	119	HS-1052-A	Clamp Pin	1
36	S-1052-A	1 1/2 Flanged Bushing	5	78	S-1090-A	Pivot Nut	1	120	6205-2Z	Bearing SKF 6205	1
37	HS-782-A	3/8" Set Collar	2	79	HS-641-A	Stud	1	121	HS-562-A	Tension Pickup Cover	1
38	HS-553-A	Tension Pick-up Shaft	1	80	HS-393-A	Wheel Tilt Roller	1	122	HS-547-A	Clamp Pin Nut	2
39	FF-520-10	Oilite Bushing	1	81		1/8 Cotter Pin	2	123	HS-546-A	Handle for Clamp Pin Nut	2
40	18232-A	1/2" Set Collar	1	82	HS-253-A	Lower Tension Link Pin	1	124	HS-1067-A	Door Latch Link Pin	2
41	1/4-20 x 4	Eye Bolt	1	83	HS-658-A	Carriage Stop	1	125	HS-561-A	Chain Adjustment Cover	1
42	V2C	Gardner Spring	1	84	HS-661-B	Tension Shaft Assembly	1	126		#35 Roller Chain	1



GROB INC. GRAFTON, WIS.
 Head Assembly
 for 6V-36 Band Saw
 DWN KS TR. CHL. SWS. DD.
 DATE 6-04-02 SCALE O.K. Rev 2
 HS-592-D

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



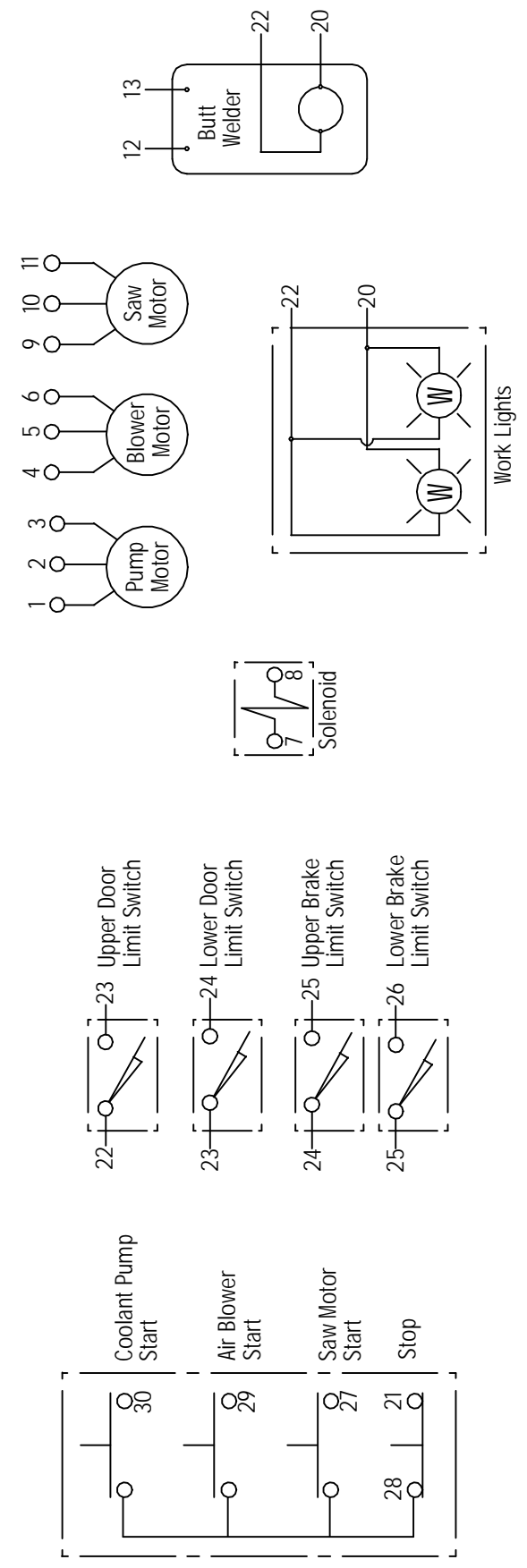
1	2	3	4	5	6	7	8	9	10	11	12	13
---	---	---	---	---	---	---	---	---	----	----	----	----

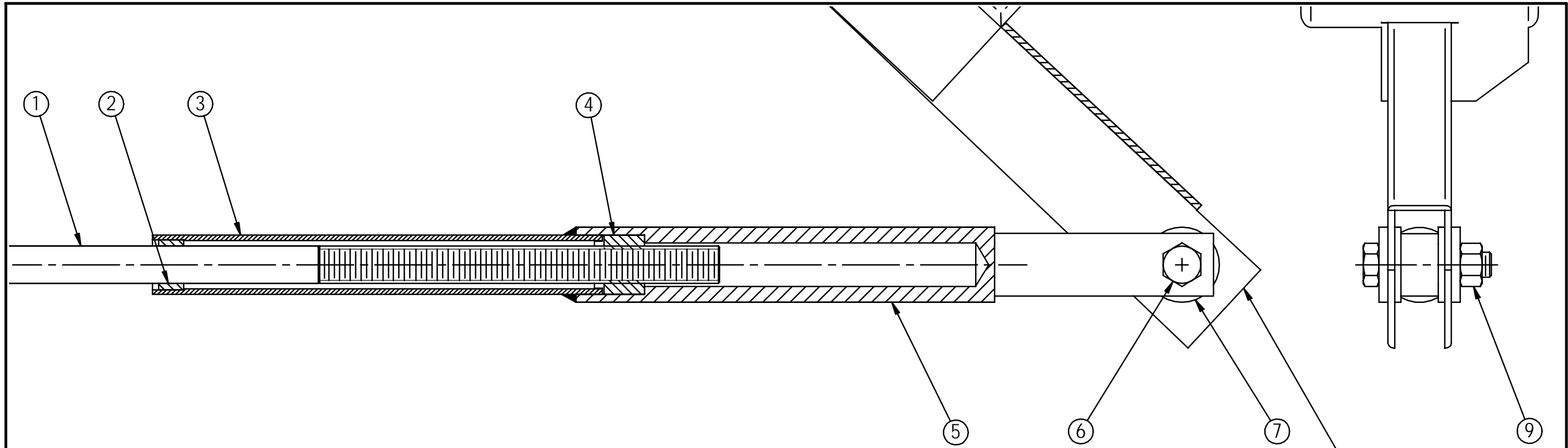
20	21	22	23	24	25	26	27	28	29	30	31	32
----	----	----	----	----	----	----	----	----	----	----	----	----

GROB INC. GRAFTON, WIS.

220 v / 440 v
Wiring Diagram
for 2S-36 Band Saw

DRN. KS	TR.	CH.	DWG. NO.
DATE 6-06-02	SCALE	O.K.	HS-596-C





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

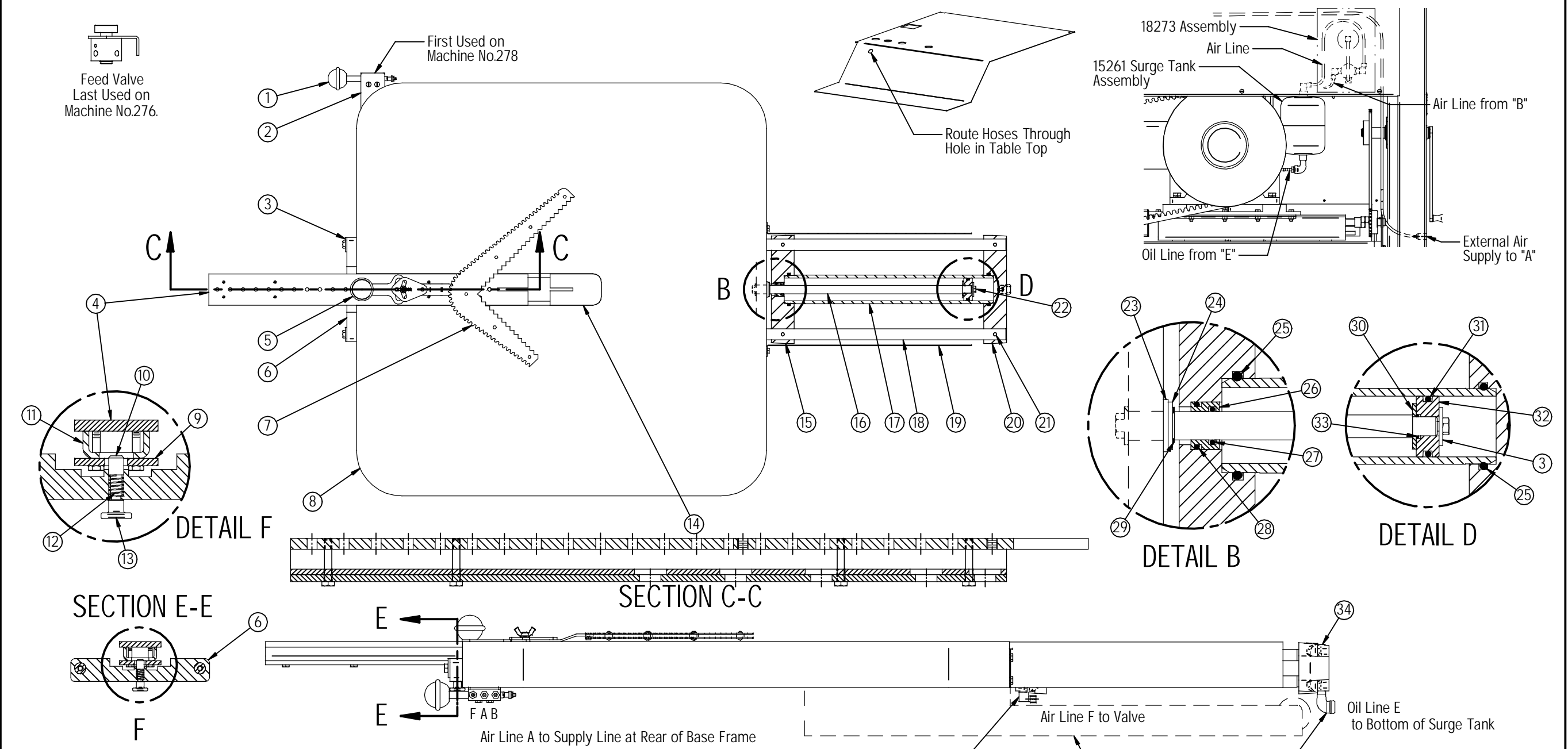
GROB INC. GRAFTON, WIS.

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



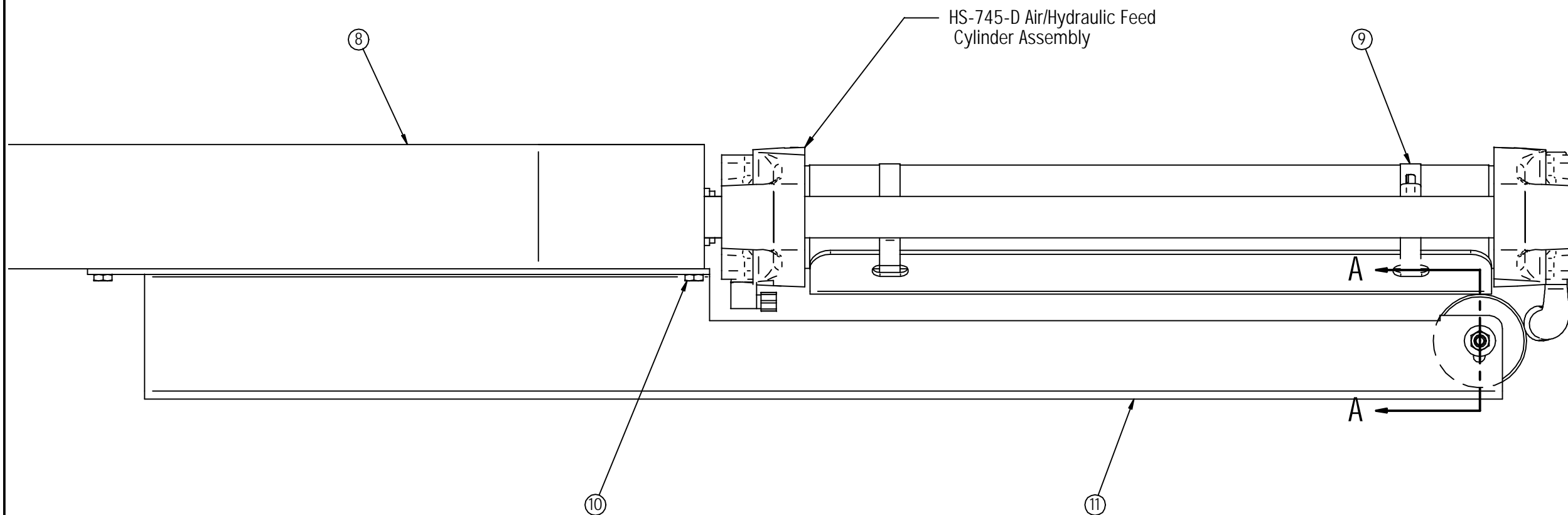
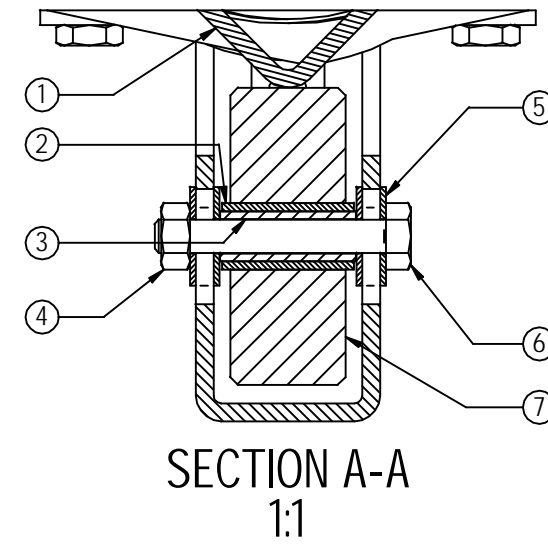
Item Number	Document Number	Title	Qty.	Item Number	Document Number	Title	Qty.
25	ARP568A-333	O-Ring	2	31	ARP568A-326	O-Ring	1
26	15453-A	Bushing	1	32	15109-A	Piston	1
27	ARP568A-210	O-Ring	1	33	ARP-568A-114	O-Ring	1
28	ARP568A-214	O-Ring	1	34	1/4-18 NPT	Pipe Plug	1
29	5100-75	External Retaining Ring	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.

GROB INC.		GRAFTON, WIS.	
Air/Hydraulic Feed Assembly for 6V-36 Band Saw			
DRN. KS	TR.	CH.	DATE 12-13-04
SCALE	O.K.	Rev 3	HS-745-C

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

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

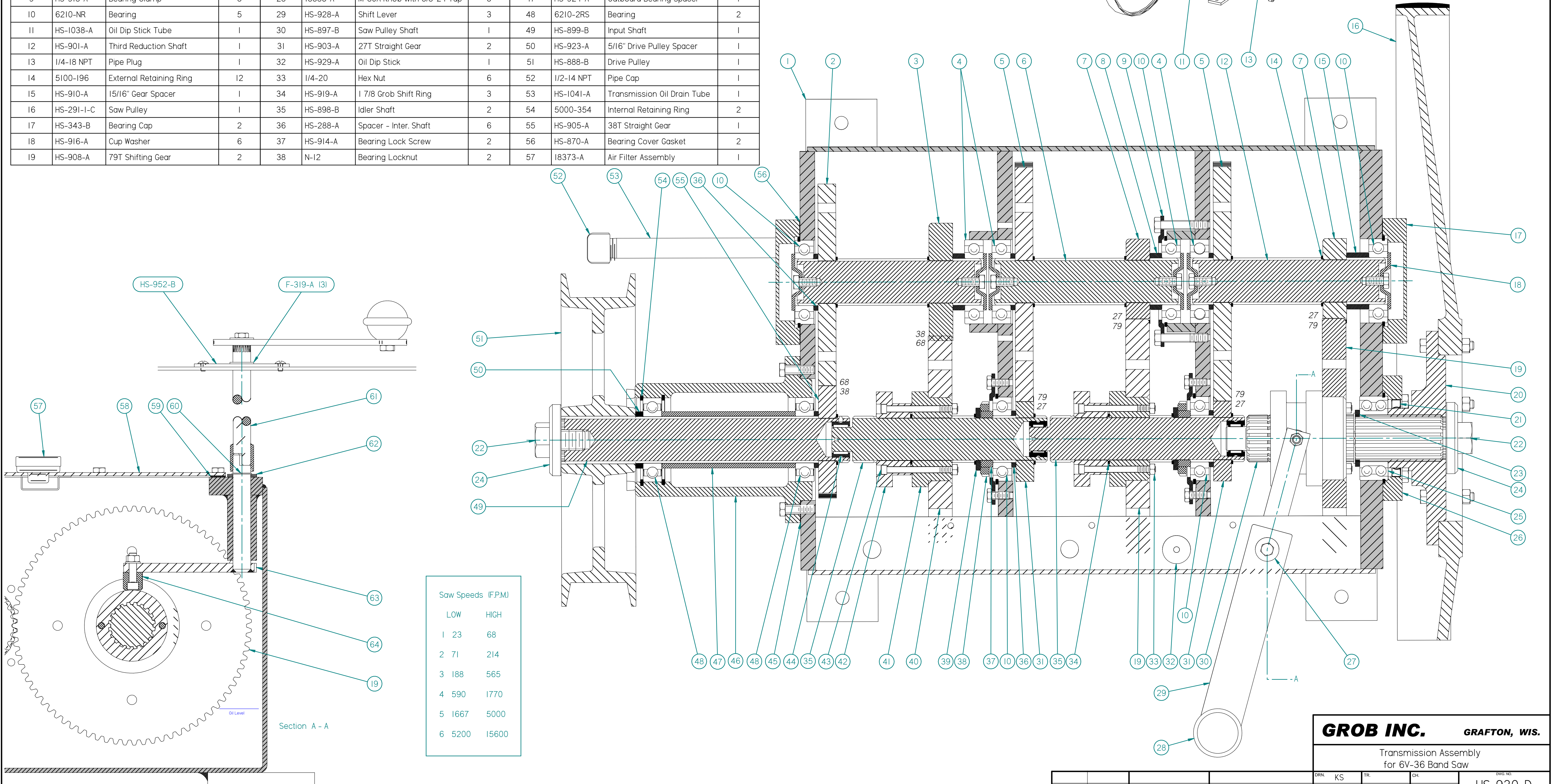
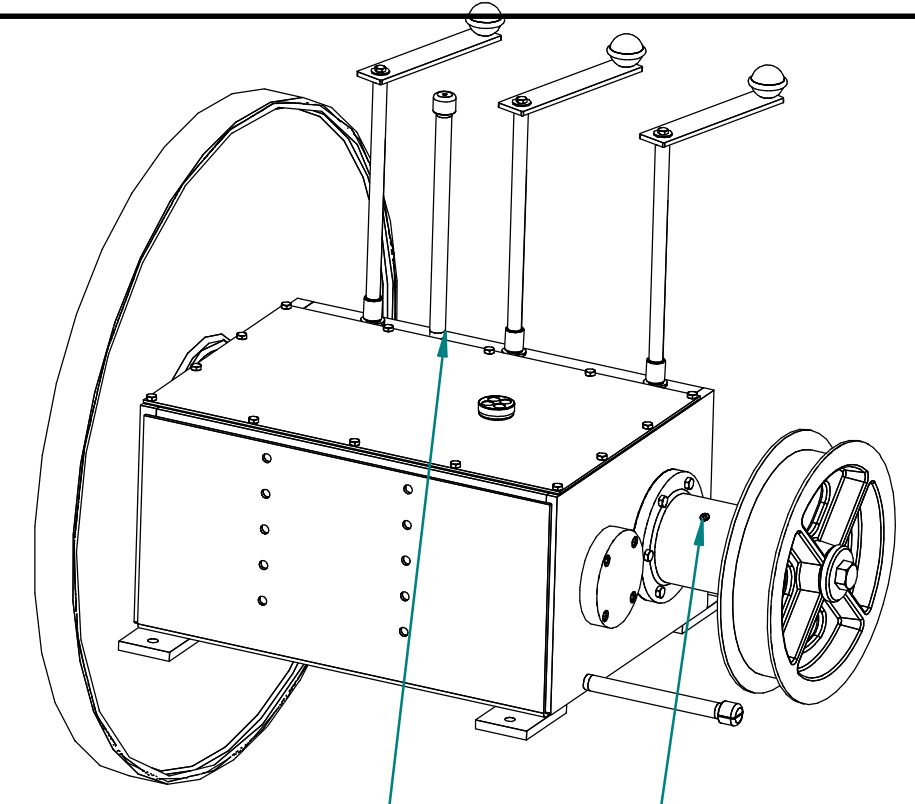


First Used on Machine #210

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	15323-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	1/4-20 x 3	Socket Head Cap Screw	6	62	15243-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	18029-A	Inside Shift Knob	3
8	HS-925-A	1/2" Gear Spacer	2	27	18124-A	Clamp Washer	3	46	HS-946-C	Outboard Bearing Housing	1				
9	HS-918-A	Bearing Clamp	3	28	18385-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	1/4-18 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	1/4-20	Hex Nut	6	52	1/2-14 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	18373-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

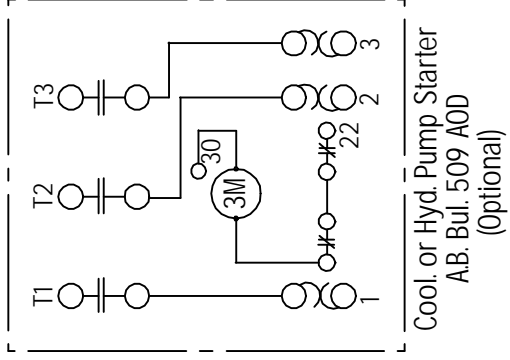
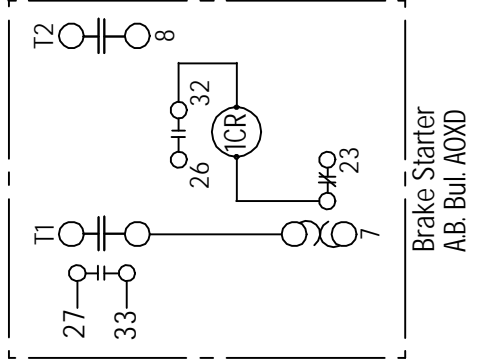
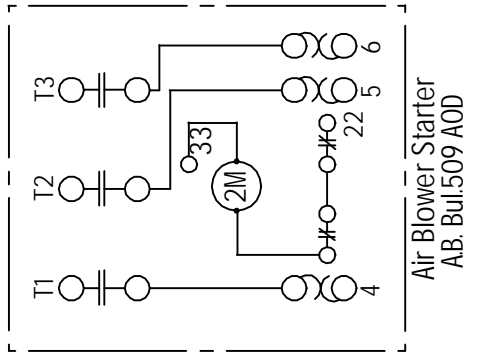
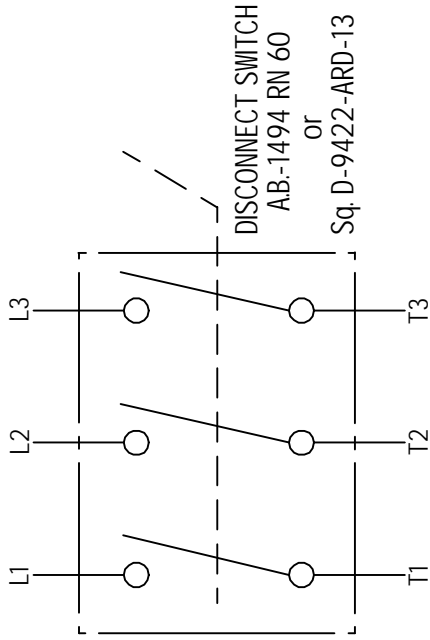
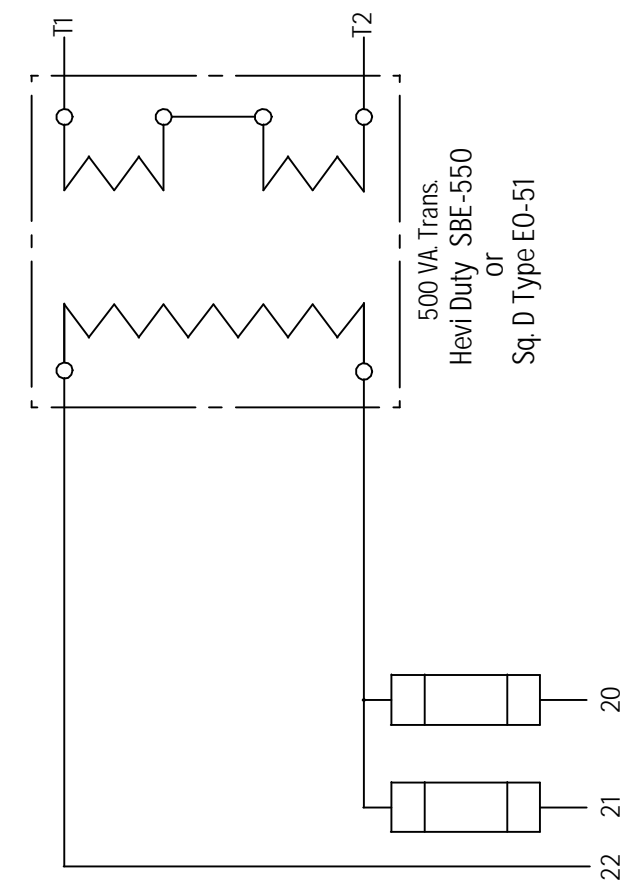
GROB INC. GRAFTON, WIS.

Transmission Assembly
for 6V-36 Band Saw

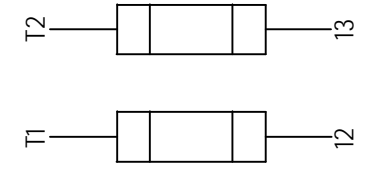
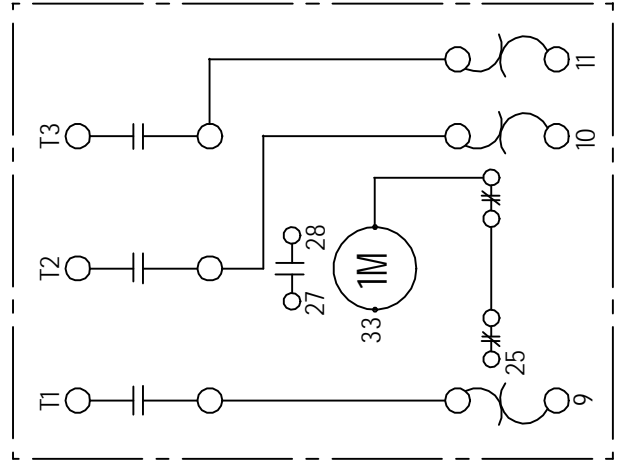
DRN	KS	TR.	CH.	ENGR. NO.
DATE	12-20-01	SCALE	1:2	OK Rev 1

HS-930-D

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

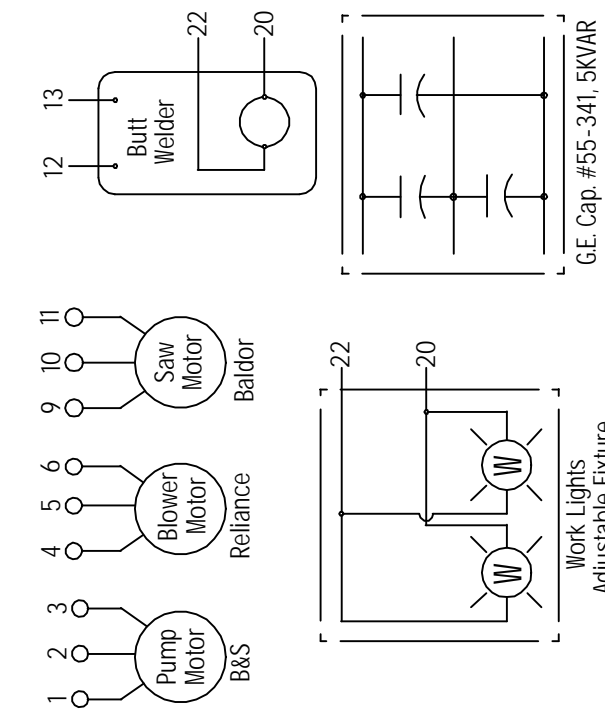
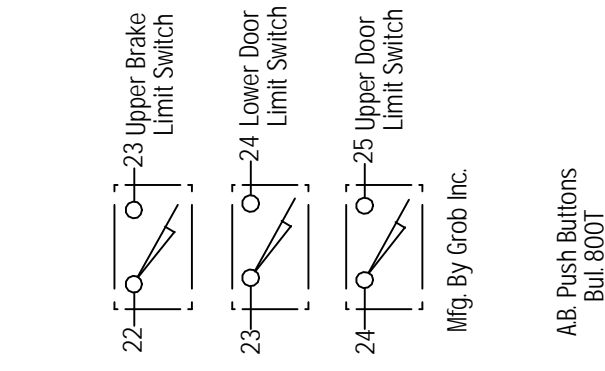
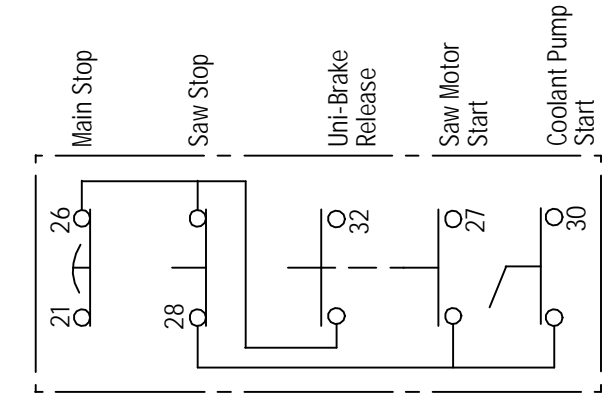


Saw Motor Starter
AB. Bul 509 COD



20	21	22	23	24	25	26	27	28	29	30	31	32

1	2	3	4	5	6	7	8	9	10	11	12	13



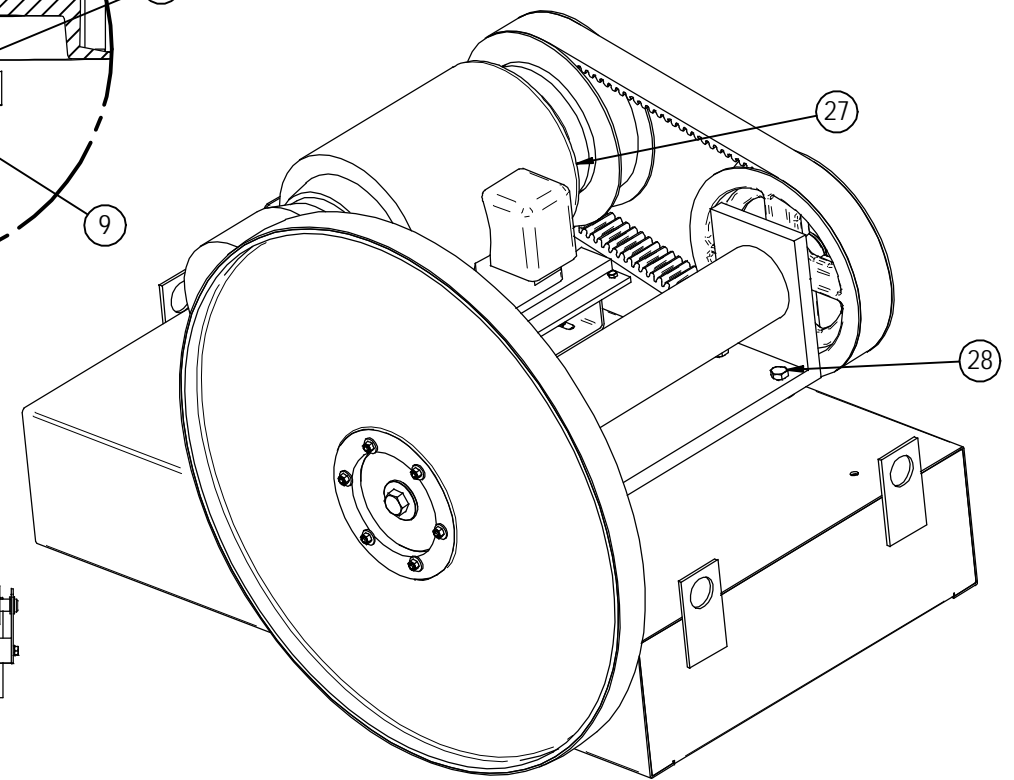
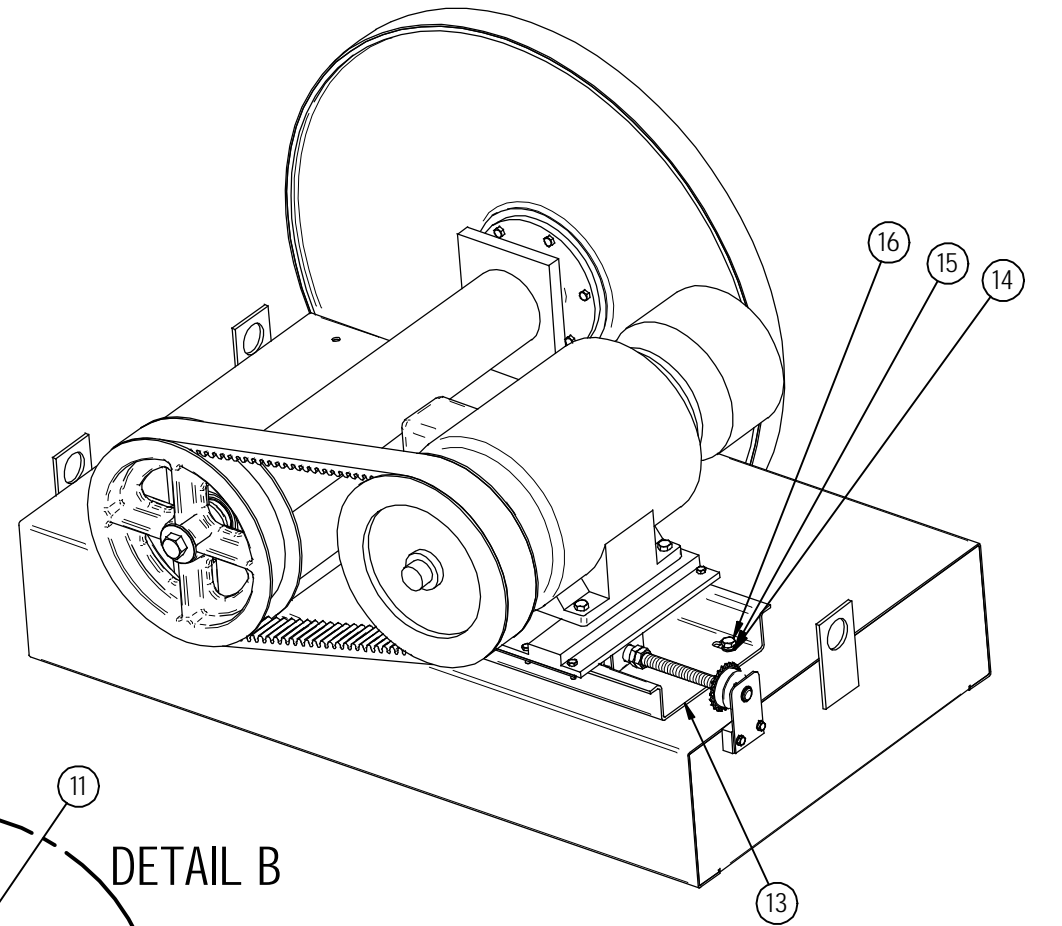
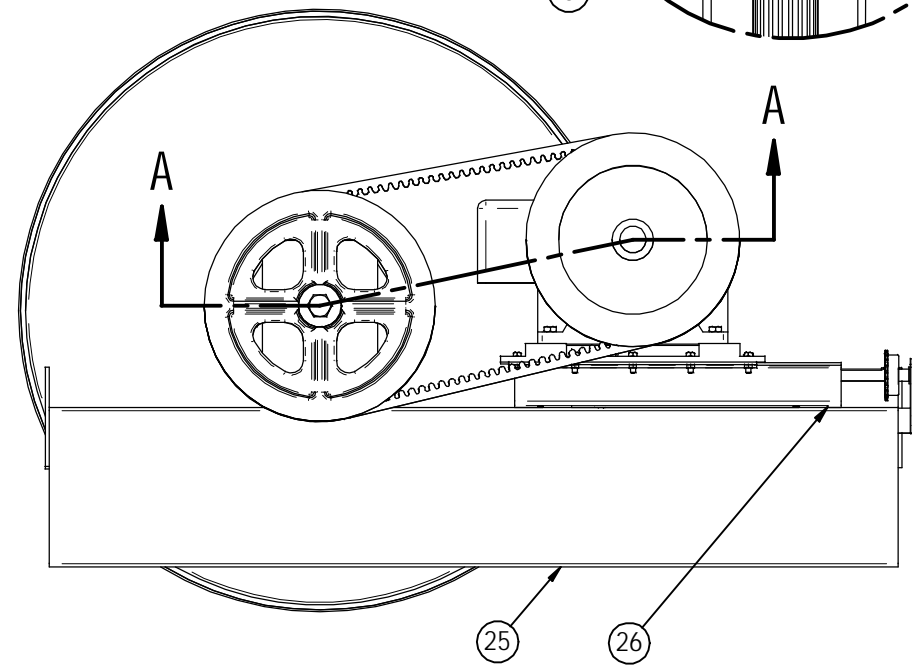
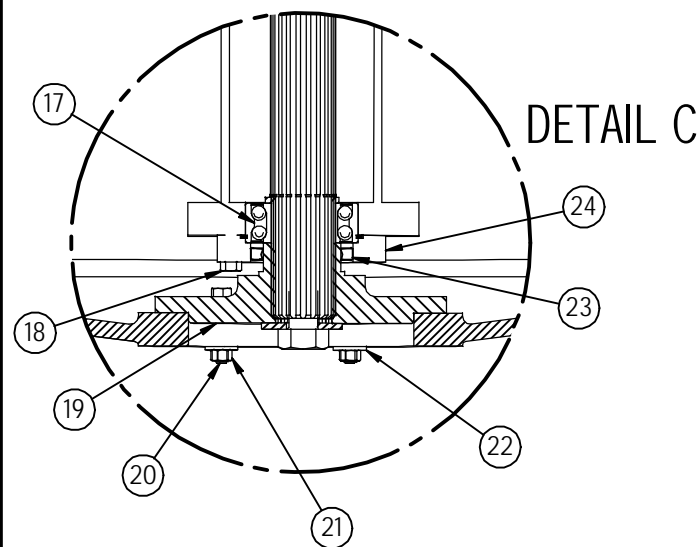
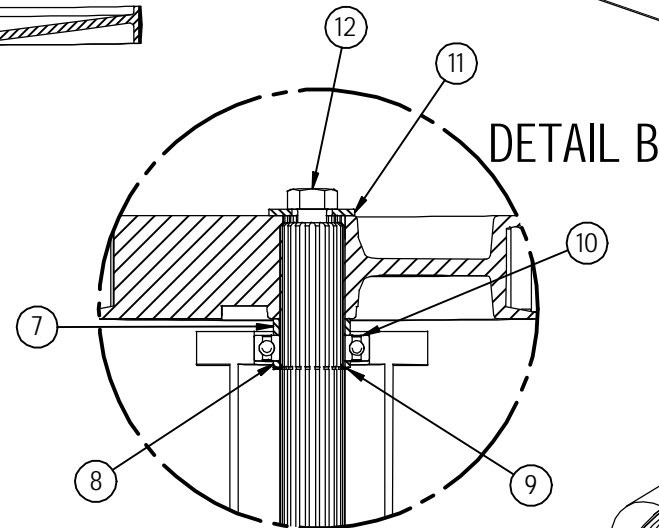
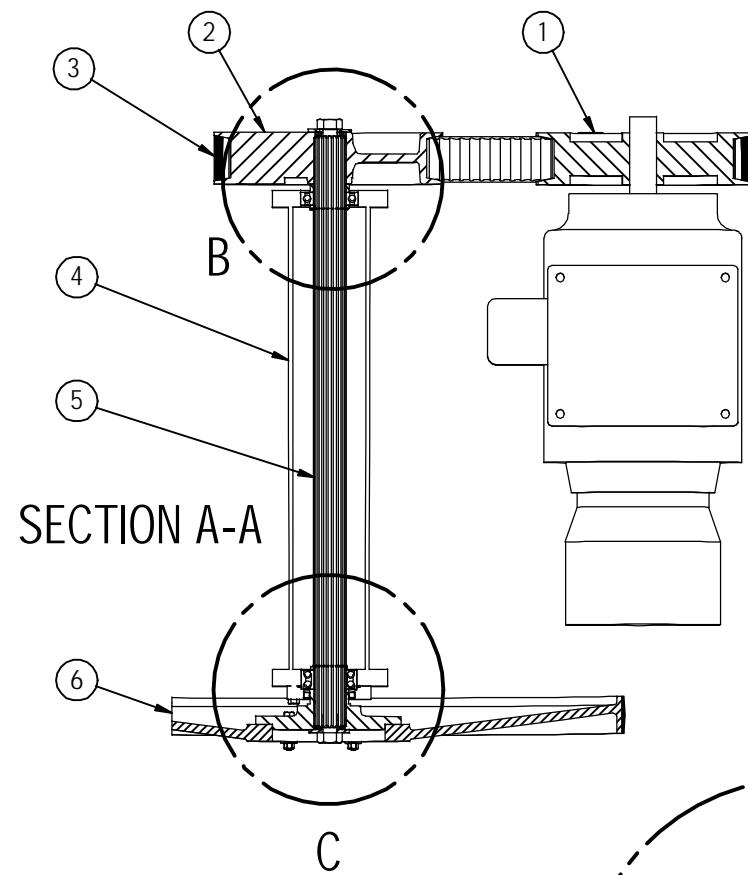
Starting Serial No. 472 Changed 8-13-97

GROB INC. GRAFTON, WIS.

Wiring Diagram
for 6V-36 Band Saw

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS DATE 6-06-02	TR. SCALE	CH. O.K.	DWG. NO. HS-937-C
-----------	-----------	----------	----------------	-------------------------	--------------	-------------	----------------------

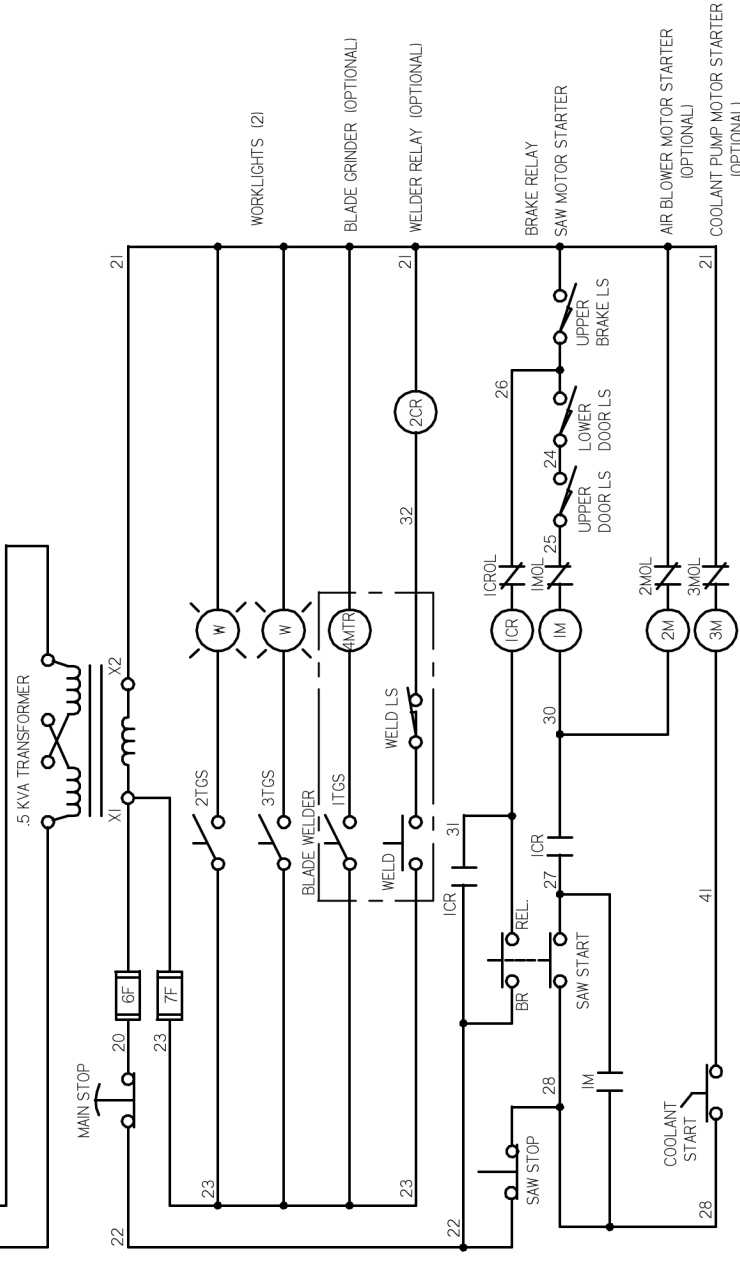
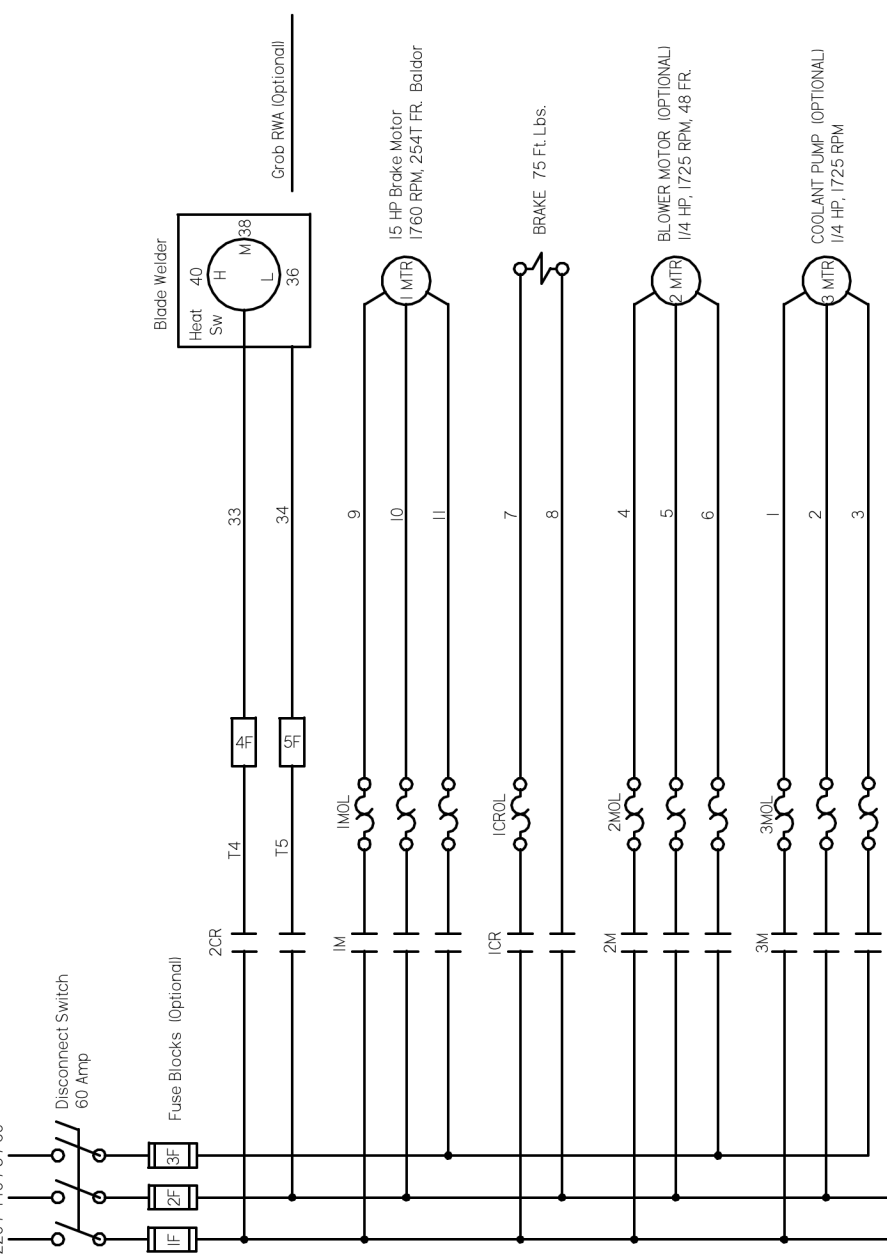
Item Number	Document Number	Title	Quantity
1		TB Woods Companion Sheave	1
2	HS-888-B	Drive Pulley	1
3	4430V790	Vari-Speed Belt	1
4	HS-943-C	Single Speed Bracket	1
5	HS-942-A	Single Speed Shaft	1
6	HS-291-1-C	Saw Pulley	1
7	HS-925-A	1/2" Gear Spacer	1
8	15323-A	Bearing Spacer	2
9	5100-196	External Retaining 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			
DRN. KS	TR.	CH.	DWG. NO.
DATE 10-9-03	SCALE 1:8	O.K. Rev 1	HS-945-1-C

One			
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
-----------	-----------	----------	----------------

IMPORTANT NOTICE !!

IDENTIFICATION OF GROB SELF SEATING SAW GUIDES

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

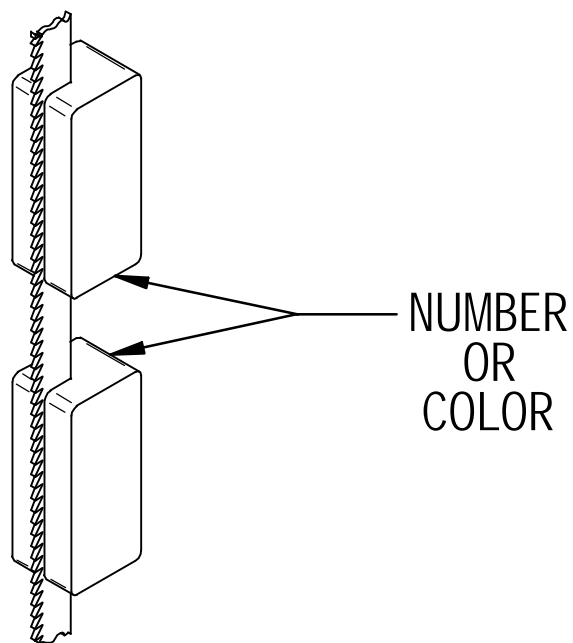
RED----- 3/16"x .025" BLACK-----5/8"x .032"

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

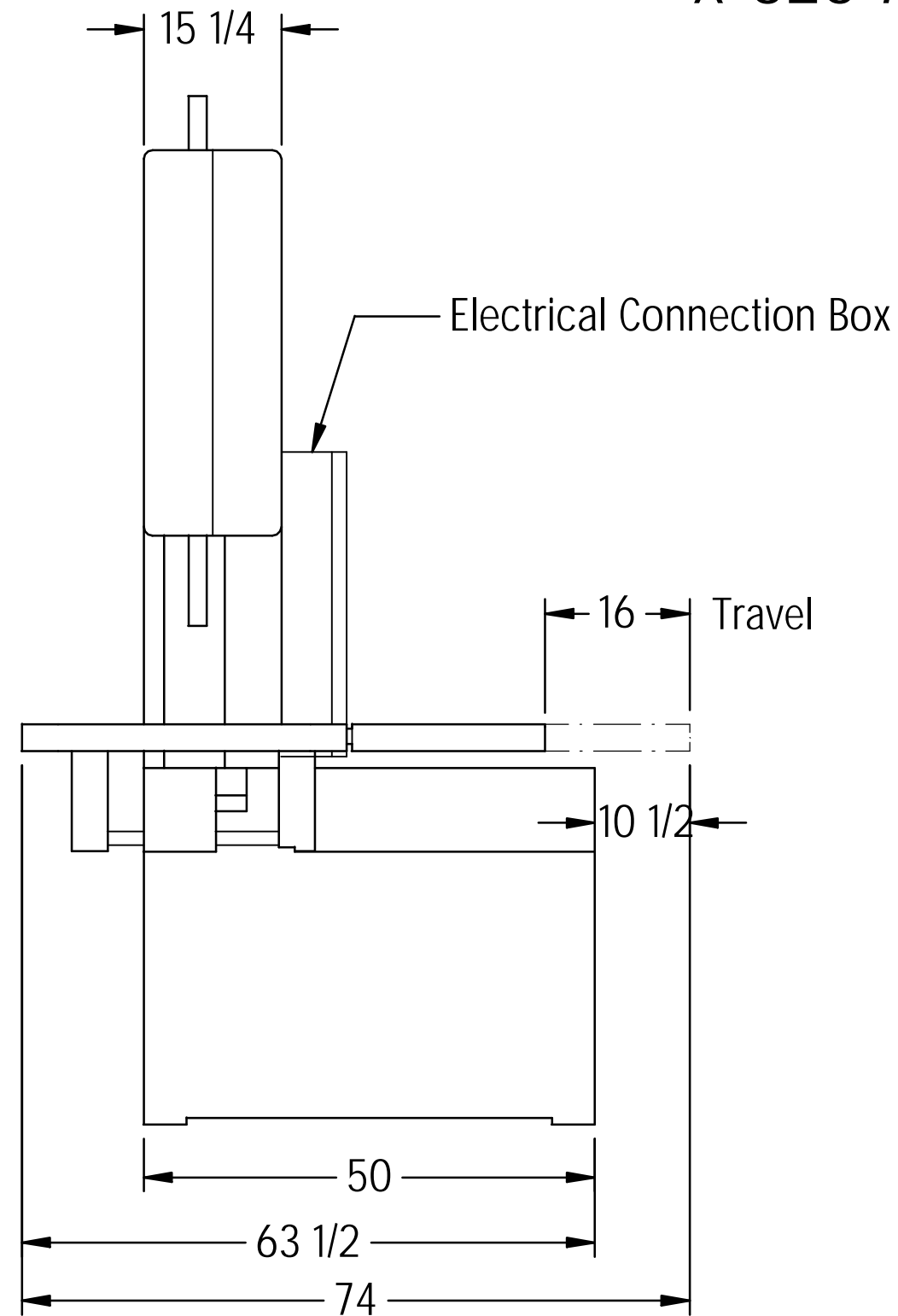
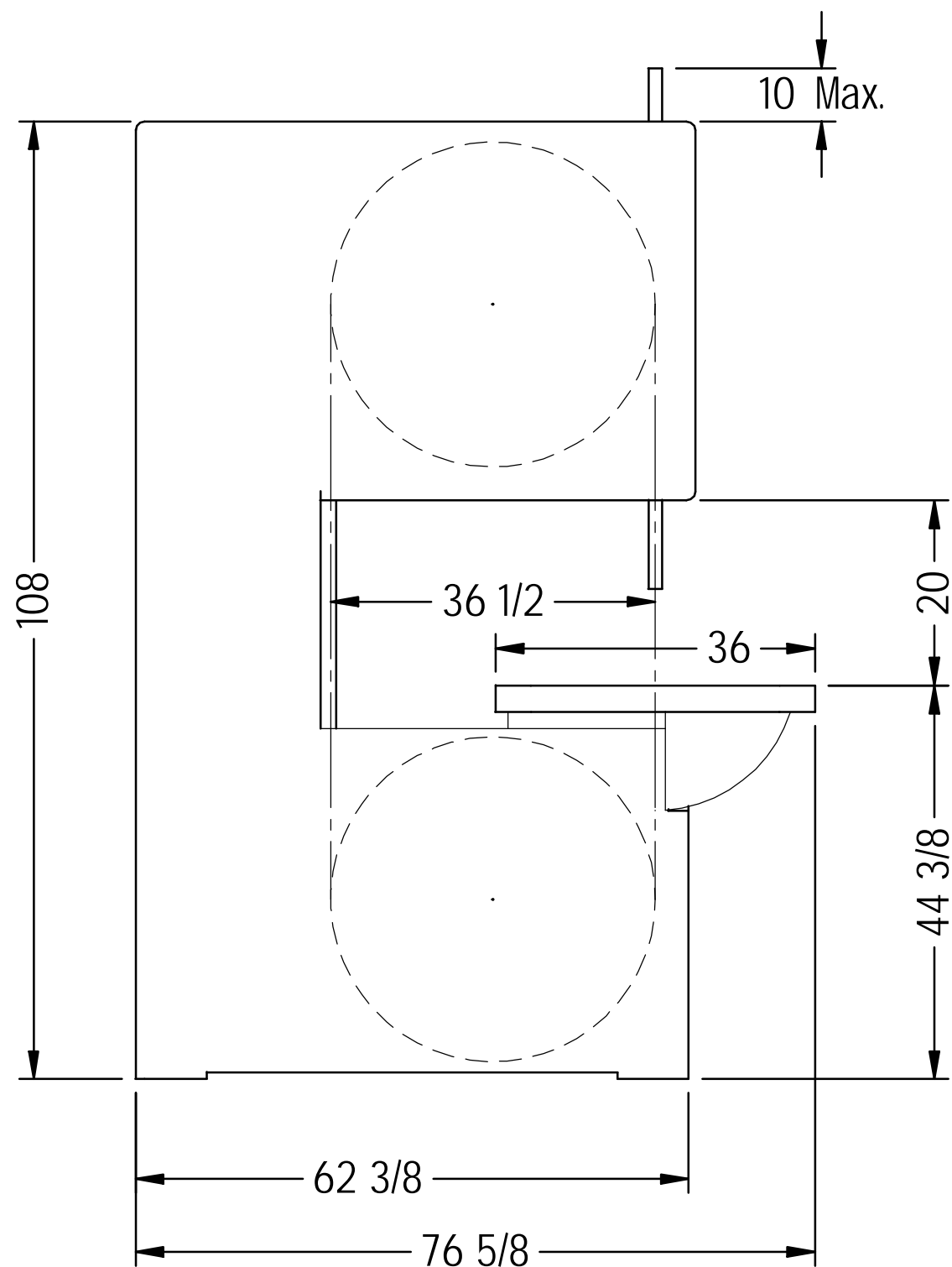
BLUE-----3/8" - 1/2"x .035" ORANGE-----7/8" - 1"x .035"

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.



X-326-A



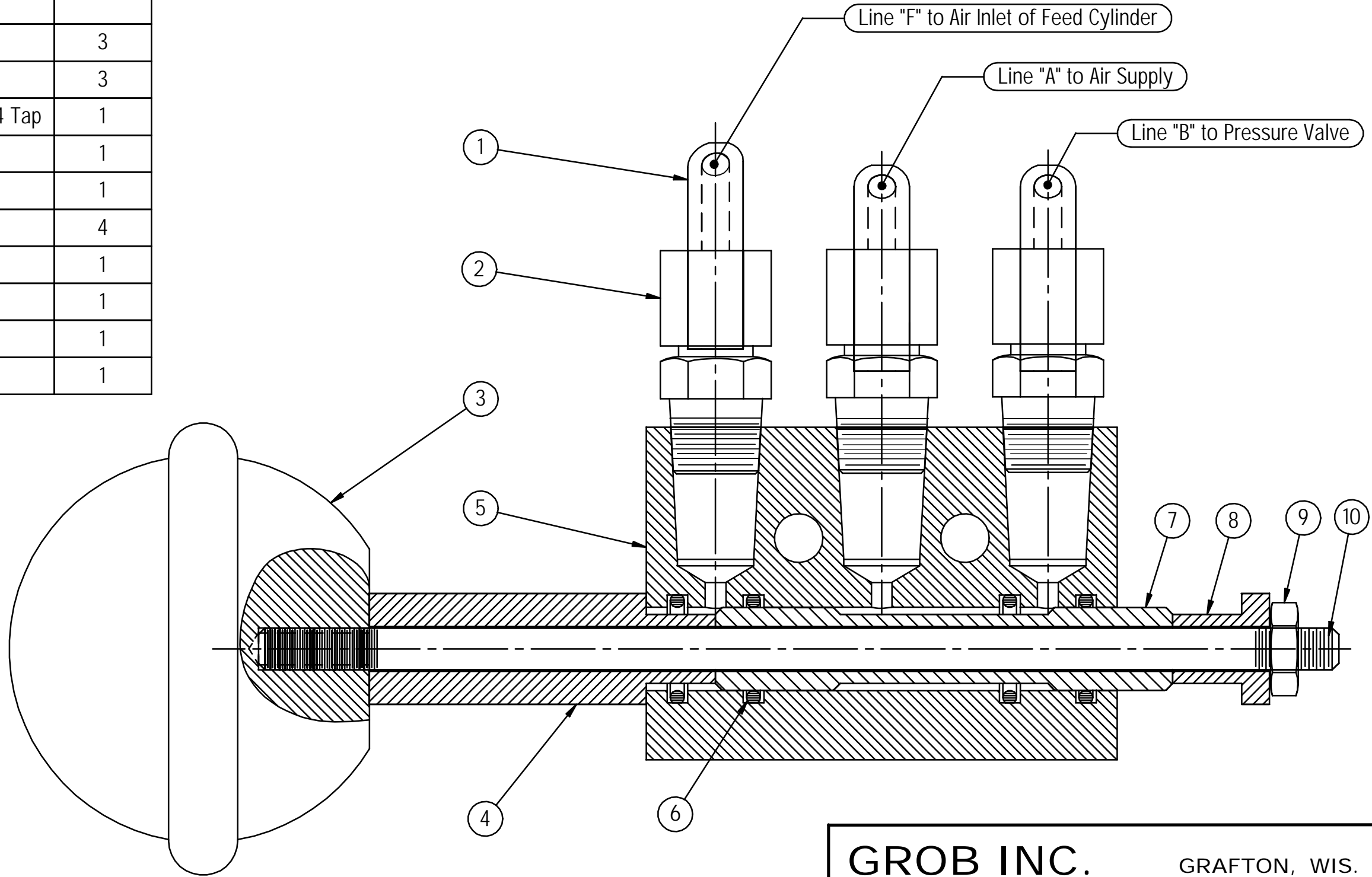
GROB INC.

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

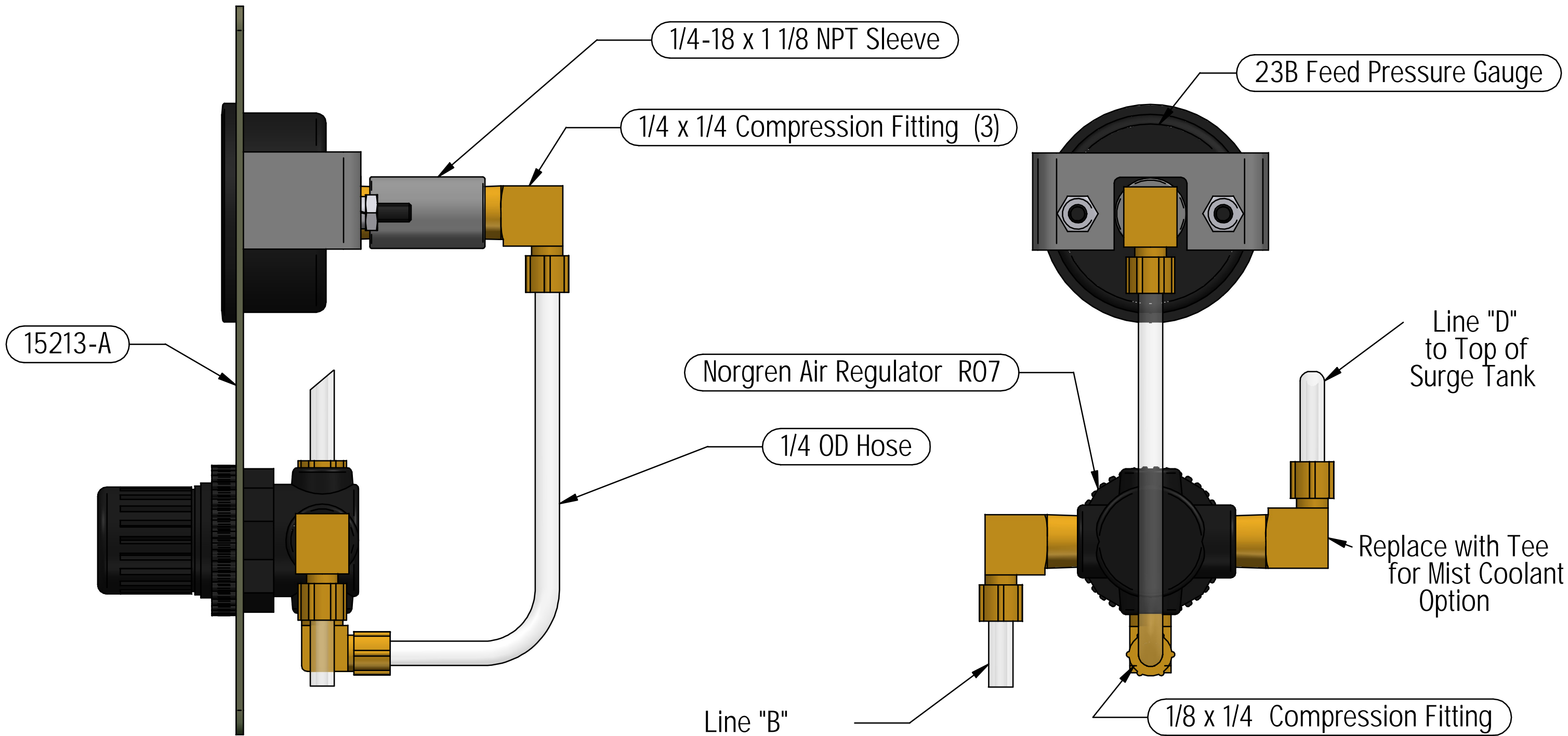
Item Number	Document Number	Title	Quantity
1	1/4 Air Line	Air Line	3
2	P-38	1/4 x 1/8 Fitting	3
3	18383-A	M-80A Knob / #10-24 Tap	1
4	18195-A	Handle Spacer	1
5	18193-A	Valve Body	1
6	ARP568A-012	O-Ring Seal	4
7	18194-A	Valve Stem	1
8	18196-A	Retaining Sleeve	1
9	#10-24	Hex Nut	1
10	18197-A	Clamp Stud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



GROB INC. GRAFTON, WIS.

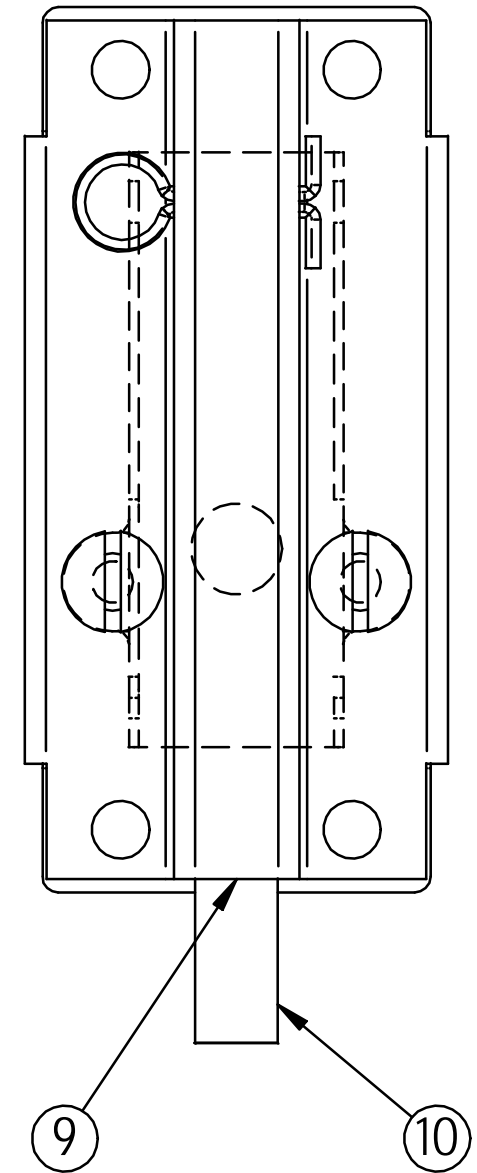
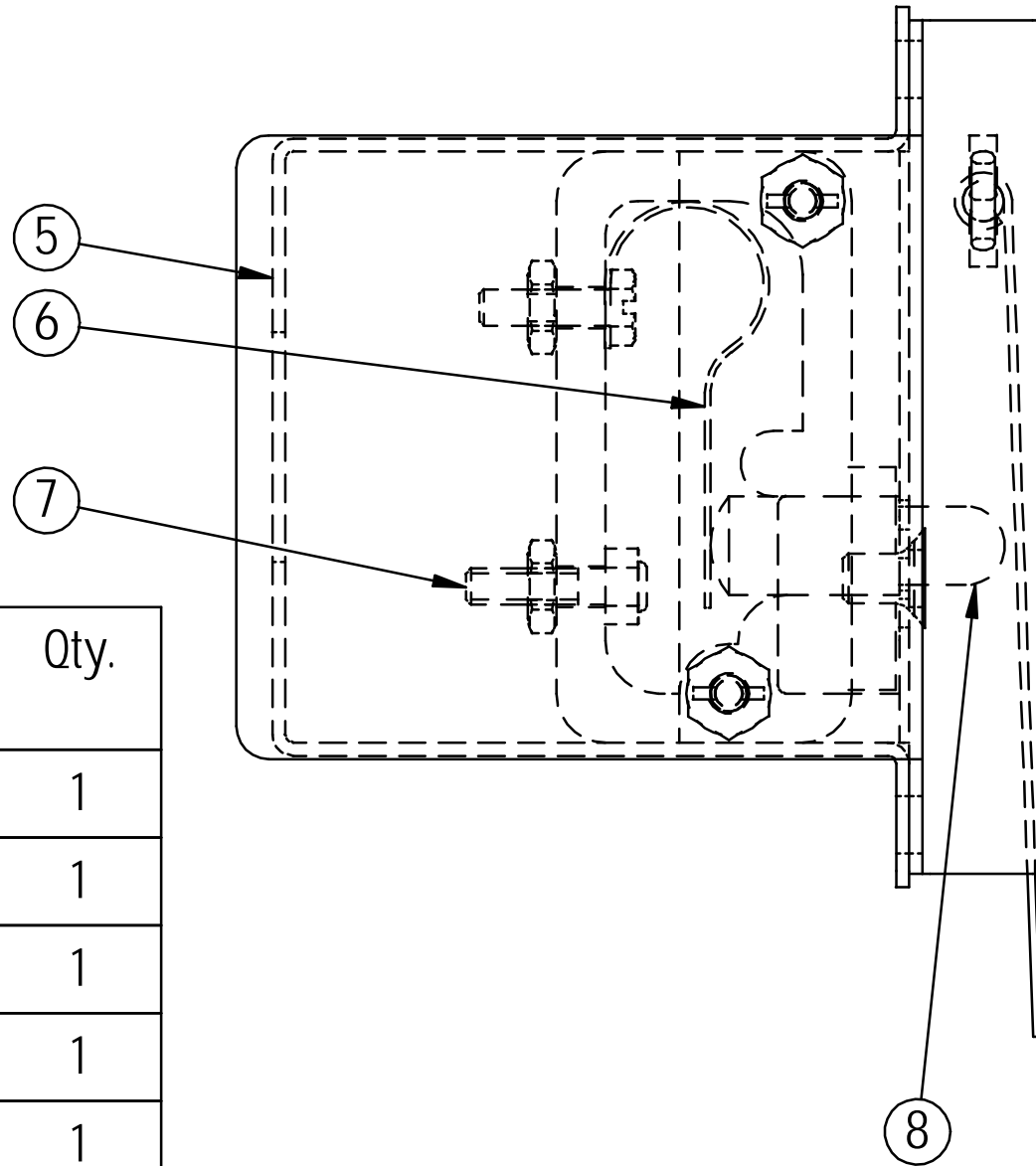
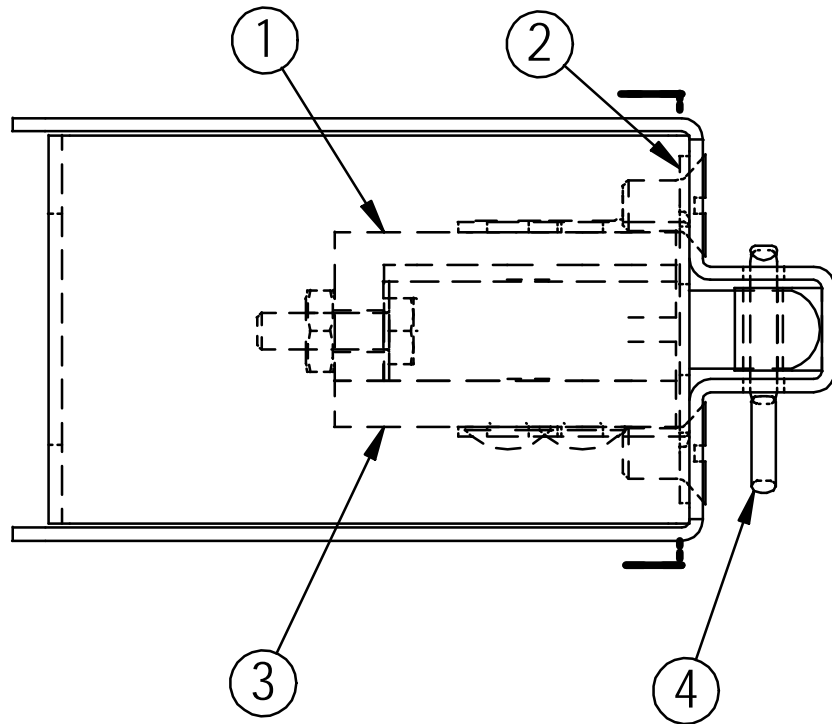
Feed Control Valve Assembly
for Grob Band Saws

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
Single Speed
GrobBandSaw.com
888-550-3116

