MODEL H7874
CERAMIC GUIDE SET FOR G0531/G0566/G0568/G0569
INSTRUCTIONS

Introduction (Figure 1)

These Euro-style blade guides replace the standard blade guides on your G0531/G0566 or G0568/G0569 bandsaw. They are designed to run cooler and are more wear resistant.

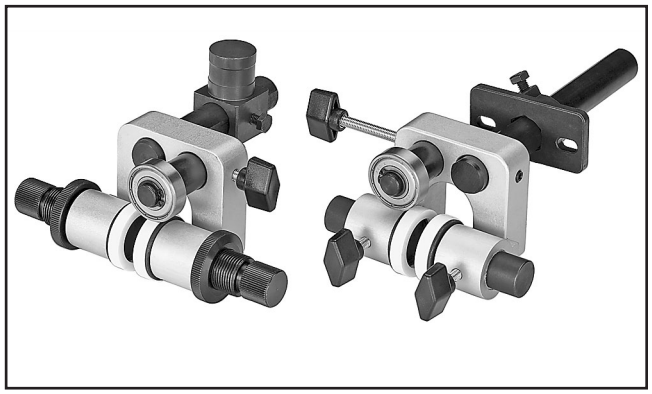


Figure 1. Model H7874.

Inventory (Figure 2)

A. Upper Guide Block Shaft w/Support Block 1
B. Upper Guide Block Assembly 1
C. Lower Guide Block Assembly 1
D. Lower Guide Block Shaft w/Plate..... 1

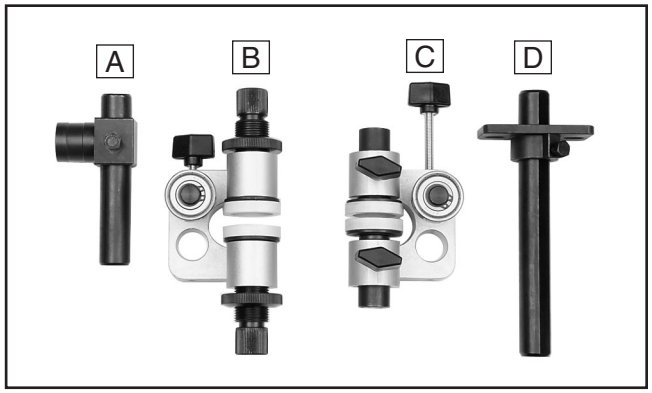


Figure 2. H7874 inventory.

Tools Needed

- Wrench 10mm 1
- Hex Wrench 3mm 1
- Hex Wrench 5mm 1
- Feeler Gauge Set or Dollar Bill 1

Installing H7874 Upper Guides

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen the two cap screws that secure the upper guide block assembly to the guide post (see **Figure 3**).

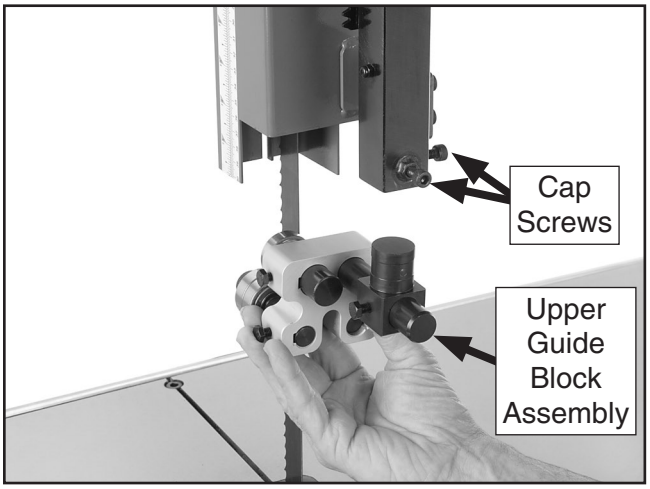


Figure 3. Removing existing upper blade guide assembly from guide post.

3. While holding the upper blade guide assembly with one hand, lower it, then remove it from the guide post.

Tip: *Hold onto the guide post or it may drop and damage the cast iron table.*

4. Use the knurled adjustment shafts to move the ceramic blade guides on the Model H7874 upper blade guide assembly away from each other (see **Figure 4**). This will allow enough room to fit the blade guides around the blade later.

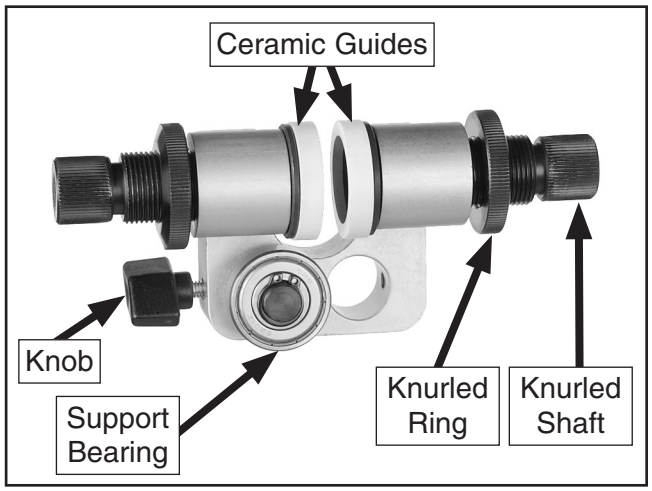


Figure 4. Ceramic guides adjusted outward.

5. Loosen the set screw on the upper guide block, insert the upper shaft into the guide block so the shaft end is flush with the front of the block, then tighten the set screw (see **Figure 5**).

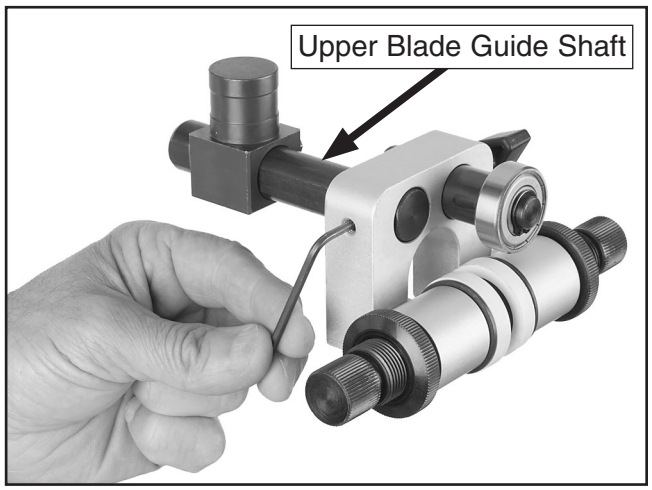


Figure 5. Securing upper shaft.

6. Insert the upper guide block into the guide post, with the blade between the blade guides, then secure with the cap screws loosened in **Step 2** (see **Figure 6**).

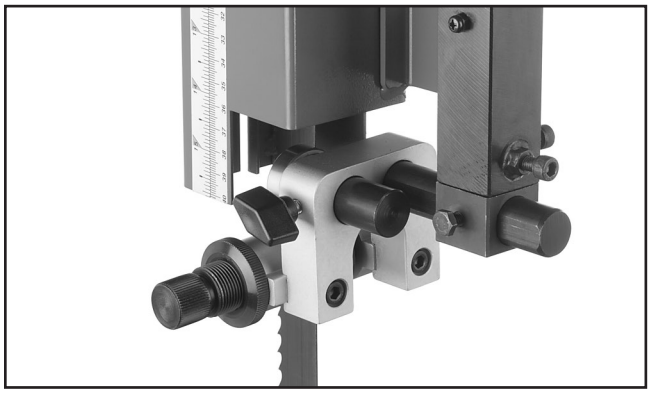


Figure 6. Upper guide assembly installed onto guide post.

7. Loosen the lateral adjustment rod bolt on the guide block, then loosen the knob that secures the support bearing (see **Figure 7**).

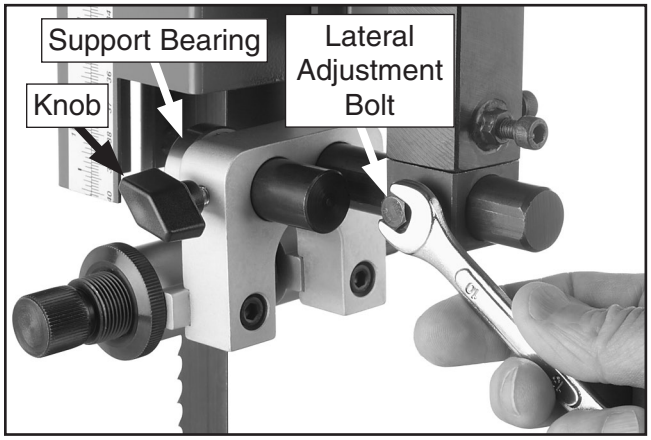


Figure 7. Loosening lateral adjustment bolt.

8. Slide the guide block shaft forward so the support bearing (**Figure 7**) slightly overlaps the back of the blade and the ceramic bearings are 1/16" behind the blade gullets, as illustrated in **Figure 8**.

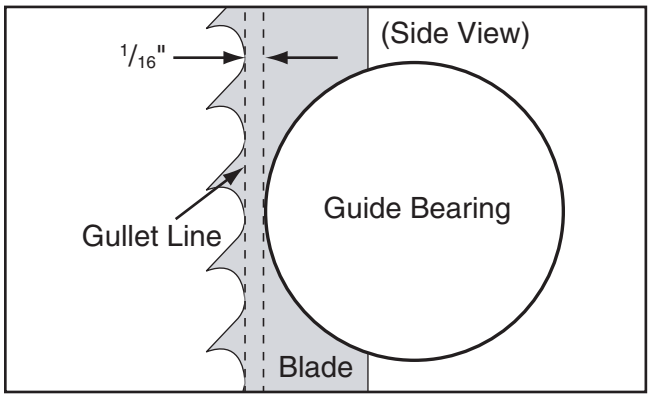


Figure 8. Correct guide bearing alignment against the blade.

Note: *The 1/16" spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the ceramic bearings as close to the blade gullets as possible, while still maintaining the proper support bearing spacing adjustment.*

9. Adjust the ceramic bearings parallel to the blade.

10. Tighten the lateral adjustment rod bolt (see **Figure 7**).

11. Loosen the knurled rings on the ceramic blade guides (**Figure 4**), then rotate each blade guide shaft so the bearings are 0.004" away from the blade (see **Figure 9**).

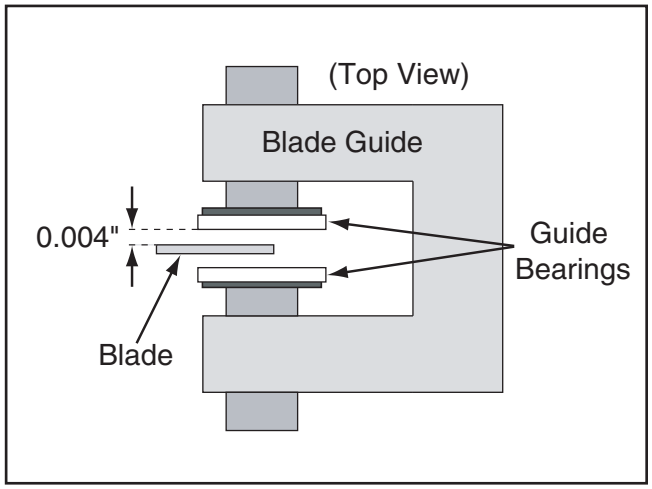


Figure 9. Correct gap between guide bearings and blade.

Note: *0.004" is approximately the thickness of a dollar bill.*

12. Tighten the knurled rings (**Figure 4**) to lock the ceramic blade guides in position.

Installing H7874 Lower Guides

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower door to access the lower blade guide assembly.

3. Remove the cap screws on the lower guide block rear plate (see **Figure 10**), loosen the bolt retaining the lateral adjustment rod, then remove the rear plate.

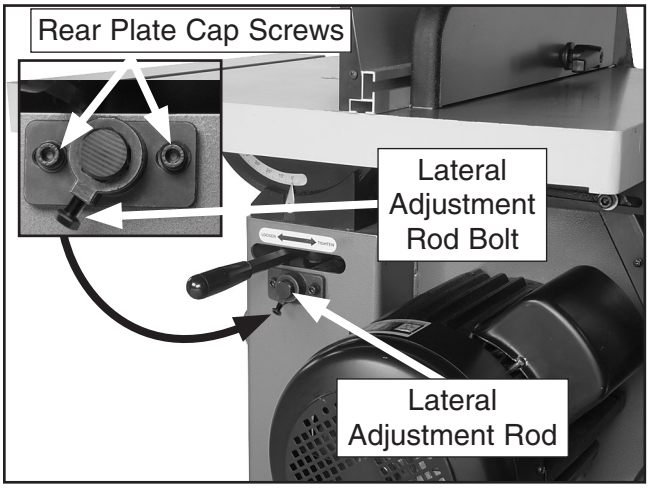


Figure 10. Lower blade guide (rear view).

4. Loosen the hex bolt that secures the lower guide block assembly to the lateral adjustment rod (**Figure 11**), then remove the rod and lower guide block assembly.

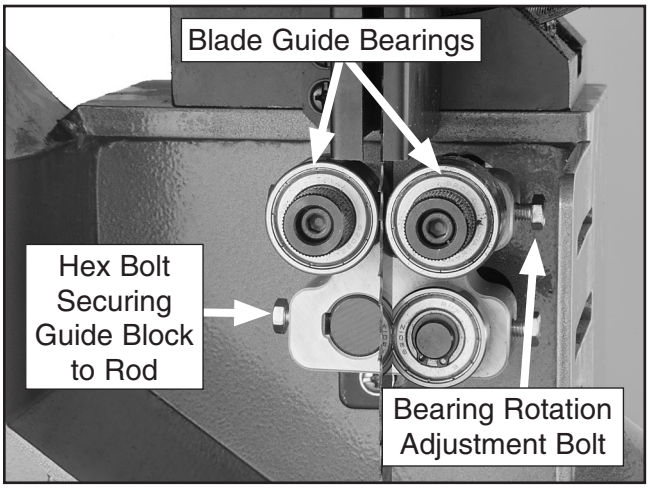


Figure 11. Lower blade guide assembly (front view).

—If you have difficulty sliding the assembly out, loosen the bearing rotation bolts (**Figure 11**) and rotate the bearings outward to make it easier to slide the guide block out.

5. Install the new rear plate with the cap screws you removed in **Step 2**. Do not final tighten the screws yet.

6. Insert the lateral adjustment rod through the plate, so the flat of the rod faces the hex bolt (see **Figure 12**) and the bolt faces down.

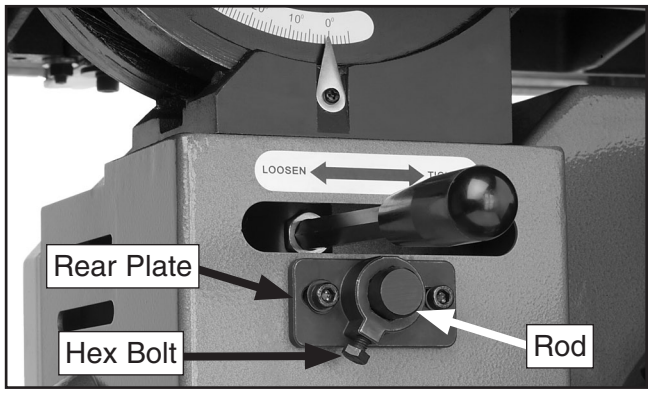


Figure 12. Rear plate and lower rod installed.

7. Remove the long threaded knob from the side of the lower guide block assembly.

8. Loosen the knobs on each of the ceramic guides, then adjust the guides as far away from each other to create more room between these and the blade in the next step.

9. Place the guide block assembly behind the blade, then move it forward so the ceramic guides are just behind the blade gullet.

10. While holding the guide block, insert the lateral adjustment rod through the guide block.

11. Position the front of the adjustment rod flush with the face of the guide block, then tighten the set screw on the left side of the block, as shown in **Figure 13**.

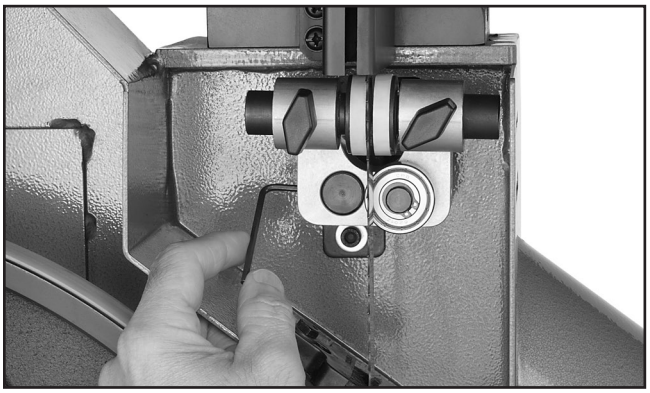


Figure 13. Securing lower block to rod.

12. Adjust the guide block as needed until the ceramic bearings are 1/16" behind the blade gullets, as illustrated in **Figure 8** on **Page 2**.

13. Adjust the ceramic bearings parallel to the blade.

14. Tighten the hex bolt and the two cap screws on the rear plate.

15. Loosen the knobs securing the ceramic blade guides, then adjust each bearing 0.004" away from the blade, as illustrated in **Figure 9** on **Page 3**, then tighten the knobs.

16. Close and lock the upper and lower wheel covers.

Adjusting Upper Support Bearings

1. Make sure the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the upper guide block assembly cap screws (see **Figure 3** on **Page 1**) and rotate the blade guide assembly side-to-side, until the support bearing is perpendicular with the face of the blade, as illustrated in **Figure 14**.

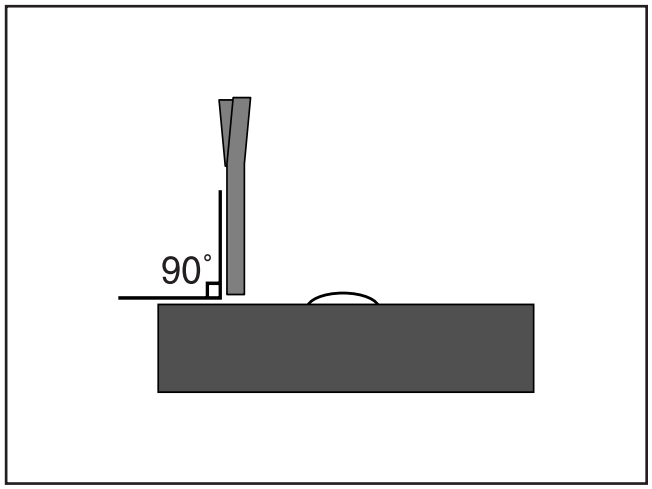


Figure 14. Illustration of blade set perpendicular (90˚) to the support bearing face.

4. Tighten the guide block assembly cap screws.

5. Loosen the knob on the support bearing adjustment shaft (see **Figure 4** on **Page 2**)—if it is not already loose.

6. Using a feeler gauge between the support bearing and the blade, position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 15**.

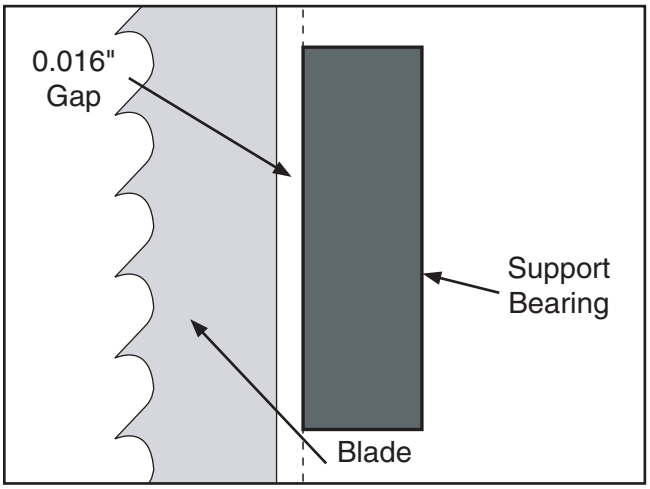


Figure 15. Blade aligned 0.016" away from the bearing edge.

Note: *For a quick gauge, fold a crisp dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016") and place it between the support bearing and the blade as shown in* ***Figure 16***.

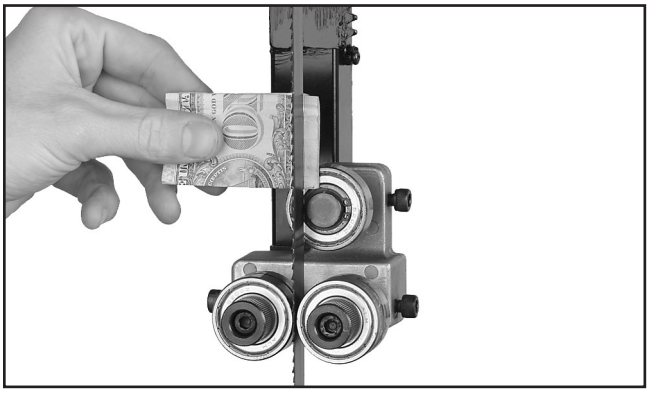


Figure 16. Example of dollar bill folded twice to make an approximate 0.016" gauge.

7. Tighten the knob to keep the support bearing locked in place.

Adjusting Lower Support Bearings

1. Repeat **Steps 1-2** in *Adjusting Upper Support Bearings* on **Page 5**.

2. Open the upper and lower wheel covers.

3. Check to make sure that the blade is perpendicular to the face of the support bearing, as illustrated in **Figure 14**.

   —If the blade is perpendicular to the face of the support bearing, continue on to the next step.

   —If the blade is not perpendicular to the support bearing, loosen the lateral adjustment rod screw and rear plate cap screws (**Figure 10** on **Page 3**) and rotate the lower guide block assembly side-to-side until the face of the support bearing is perpendicular to the blade, then re-tighten the screws.

4. Thread the long knob into the right side of the lower guide block several turns (see **Figure 17**).

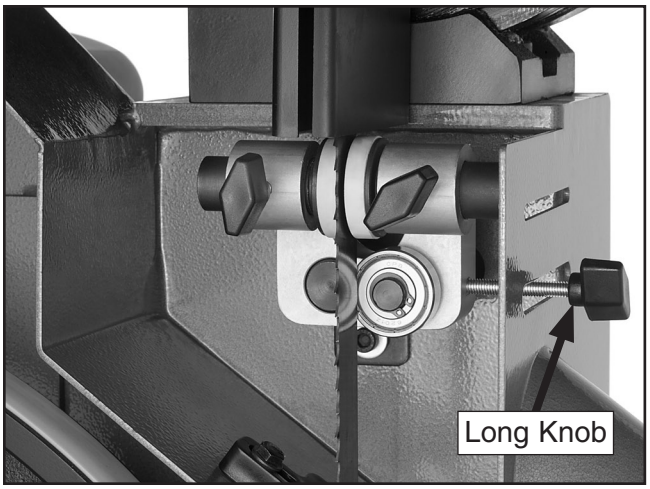


Figure 17. Long knob threaded into lower guide block.

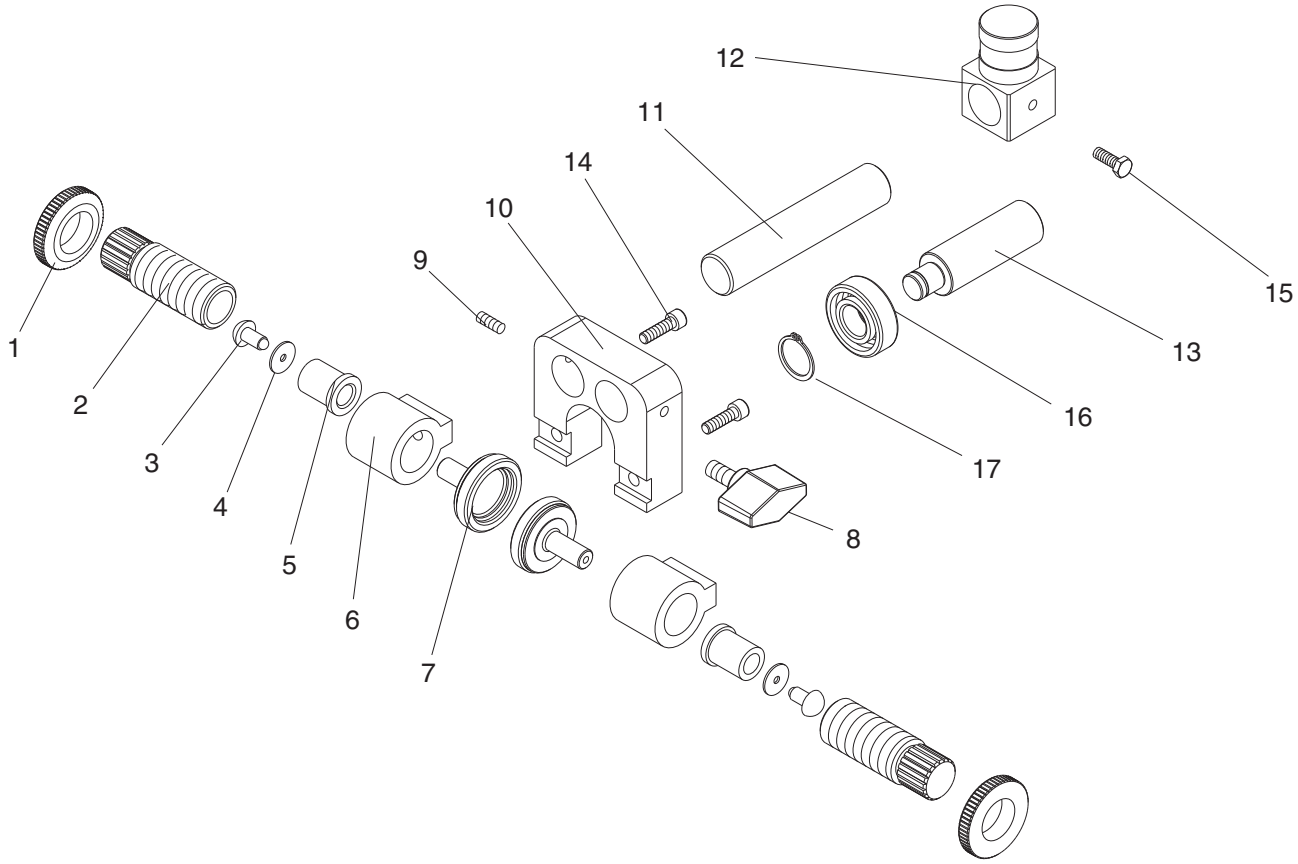
5. Using a feeler gauge, position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 15**, or use a dollar bill, as shown in **Figure 16**.

6. Thread the long knob the rest of the way to secure the support bearing.

7. Close and lock the upper and lower wheel covers.

If you need help with your new item, call our Tech Support at: (570) 546-9663.

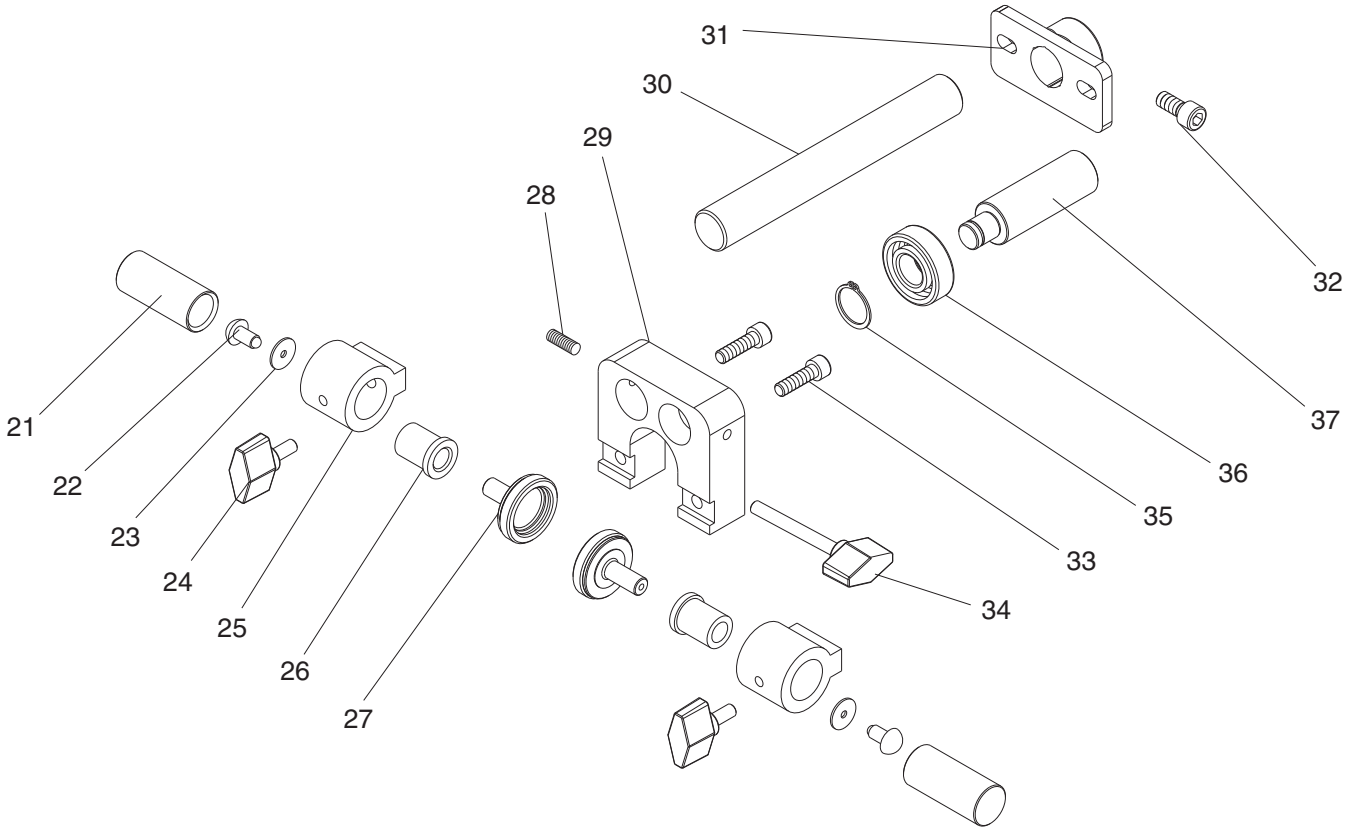
H7874 Upper Blade Guide Assembly



	PART #	DESCRIPTION
1	PH7874001	KNURLED RING M22 X 2.5
2	PH7874002	ADJUST SHAFT
3	PH7874003	RIVET 3.2 X 7.7
4	PW07M	FLAT WASHER 3MM
5	PH7874005	BUSHING
6	PH7874006	LOCATOR
7	PH7874007	CERAMIC GUIDE RING
8	PH7874008	KNOB BOLT M6-1 X 15
9	PSS01M	SET SCREW M6-1 X 10

REF	PART #	DESCRIPTION
10	PH7874010	UPPER GUIDE BLOCK
11	PH7874011	UPPER GUIDE BLOCK SHAFT
12	PH7874012	UPPER GUIDE SUPPORT BLOCK
13	PH7874013	UPPER SPACING SLEEVE
14	PCAP02M	CAP SCREW M6-1 X 20
15	PB02M	HEX BOLT M6-1 X 12
16	P6201ZZ	BALL BEARING 6201ZZ
17	PR03M	EXT RETAINING RING 12MM

H7874 Lower Blade Guide Assembly



REF	PART #	DESCRIPTION
21	PH7874005	BUSHING
22	PH7874003	RIVET 3.2 X 7.7
23	PW07M	FLAT WASHER 3MM
24	PH7874008	KNOB BOLT M6-1 X 15
25	PH7874025	LOCATOR
26	PH7874005	BUSHING
27	PH7874007	CERAMIC GUIDE RING
28	PSS01M	SET SCREW M6-1 X 10
29	PH7874010	LOWER GUIDE BLOCK

REF	PART #	DESCRIPTION
30	PH7874030	LOWER GUIDE BLOCK SHAFT
31	PH7874031	LOWER GUIDE BLOCK PLATE
32	PCAP01M	CAP SCREW M6-1 X 16
33	PCAP02M	CAP SCREW M6-1 X 20
34	PH7874034	KNOB BOLT M6-1 X 60
35	PR03M	EXT RETAINING RING 12MM
36	P6201ZZ	BALL BEARING 6201ZZ
37	PH7874013	UPPER SPACING SLEEVE