Introduction (Figure 1)
These Euro-style blade guides replace the blade guides on the G0531, G0531B, G0566, G0568, and G0569 bandsaw.

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

Tools Needed
• Wrench 10mm ............................................ 1  
• Hex Wrench 3mm ...................................... 1  
• Hex Wrench 5mm ...................................... 1  
• Feeler Gauge Set or Dollar Bill ................. 1

Installing T21973 Upper Guides
1. DISCONNECT BANDSAW FROM POWER!
2. While holding the upper blade guide block assembly with one hand, loosen the two cap screws that secure the upper guide block assembly to the guide post (see Figure 3).
3. Lower the upper blade guide block assembly, then remove it from the guide post.
4. Use the knurled adjustment shafts to move the blade guides on the Model T21973 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.

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).

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).

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

8. Slide the guide block shaft forward so the support bearing shown in Figure 7 slightly overlaps the back of the blade and the blade guides are \( \frac{1}{16} \)" behind the blade gullets, as illustrated in Figure 8.

Figure 4. Blade guides adjusted outward.

Figure 5. Securing upper shaft.

Figure 6. Upper guide assembly installed onto guide post.

Figure 7. Loosening lateral adjustment bolt.

Figure 8. Correct blade guides alignment against the blade.
Installing T21973 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.

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.

9. Adjust the blade guides parallel to the blade.

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

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

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

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

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

Figure 9. Correct gap between blade guides and blade (illustration not to scale).

Figure 10. Lower blade guide (rear view).

Figure 11. Lower blade guide assembly (front view; photo may not exactly match your machine).
—If you have difficulty sliding the assembly out, loosen the bearing rotation bolts (see 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.

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

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

9. Place the guide block assembly behind the blade, then move it forward so the blade guides are just behind the blade gullets as explained in Step 8 on Page 2.

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.

12. Adjust the guide block as needed until the blade guides are $\frac{1}{16}$" behind the blade gullets, as illustrated in Figure 8 on Page 2.

13. Adjust the blade guides parallel to the blade.

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

15. Loosen the knobs securing the 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.

4. Tighten the guide block assembly cap screws.

5. Loosen the knob on the support bearing adjustment shaft (see Figure 4 on Page 2).

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.

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

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

1. DISCONNECT BANDSAW FROM POWER!

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

3. Open the upper and lower wheel covers.

4. 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.

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

6. 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.

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

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

If you need help with this item, call our Tech Support at: (570) 546-9663.
T21973 Upper Blade Guide Assembly

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## T21973 Lower Blade Guide Assembly

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