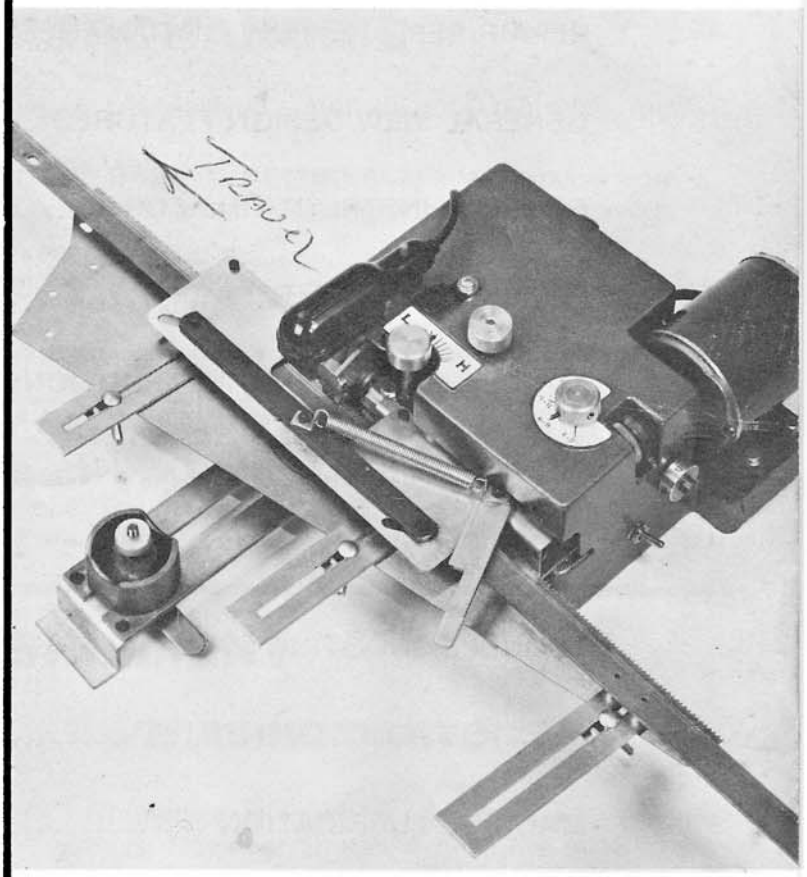
FOLEY BELSAW

OWNERS MANUAL

392 AUTOMATIC POWER SETTER

— NOTICE —

READ INSTRUCTIONS AND SAFETY RULES BEFORE USING.



ONE YEAR GUARANTEE

All Foley-Belsaw equipment is guaranteed to be sturdily constructed and free of defects in workmanship or material.

If within one year from date of shipment, any parts should prove defective, replacement parts will be furnished free of charge when defective part is returned postpaid for inspection.

Guarantee does not cover damage sustained in transit or caused by misuse.

We reserve the right to make changes in design, construction, or materials on all Foley-Belsaw machines without notice.

THE FOLEY–BELSAW CO. **6301 EQUITABLE ROAD • BOX 593** **KANSAS CITY, MO. 64141**

(3927000 4-82)

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RETURNING MERCHANDISE

Written authority from our Service Department must be received, prior to your returning the merchandise.

OUR KANSAS CITY OFFICE IS NOT EQUIPPED TO HANDLE RETURNS—we will advise you immediately the factory address to which the item is to be shipped, freight prepaid. This will avoid delay in making exchange, or any other adjustment.

Merchandise without the proper authorization will not be accepted by our receiving department and will be returned to the customer.

PRICE QUOTATIONS

Due to inflation and rising costs, parts prices are subject to change without notice. Therefore, should any part require replacement for other reasons or after the warranty period, please write or call toll-free 1-800-328-7140 or 1-800-821-3452. We will then furnish you with current prices.

RECEIVING SHIPMENT

RECEIVING SHIPMENT

Count the cartons and make sure to matches with the quantity received shown on the Bill of Lading.

DAMAGED CARTONS

EXAMINE YOUR SHIPMENT CAREFULLY—Upon receipt note the condition of the cartons. The truck is not allowed to wait while you inspect the contents of each carton, however, if upon unpacking your shipment you notice damage of any kind to the contents **STOP** and notify the transportation company immediately and request an inspection. (This must be done within 15-days of delivery.) Keep all shipping cartons and have them available for the inspector. The inspector will write up a complete inspection report and leave one copy with you.

MISSING CARTONS

If you are short some boxes, have the driver make a notation on the delivery receipt. Example: 1 carton short, etc.

MISSING CARTONS

Normally the shortage will show up in several days. However, if after 5-days the missing carton(s) have not been found, call Foley-Belsaw by using the toll free numbers 1-800-328-7140 or 1-800-821-3452 to notify us of the lost merchandise. We will ship you replacements and bill you for them. When you receive the invoice for the replacements submit it with your claim to the transportation company.

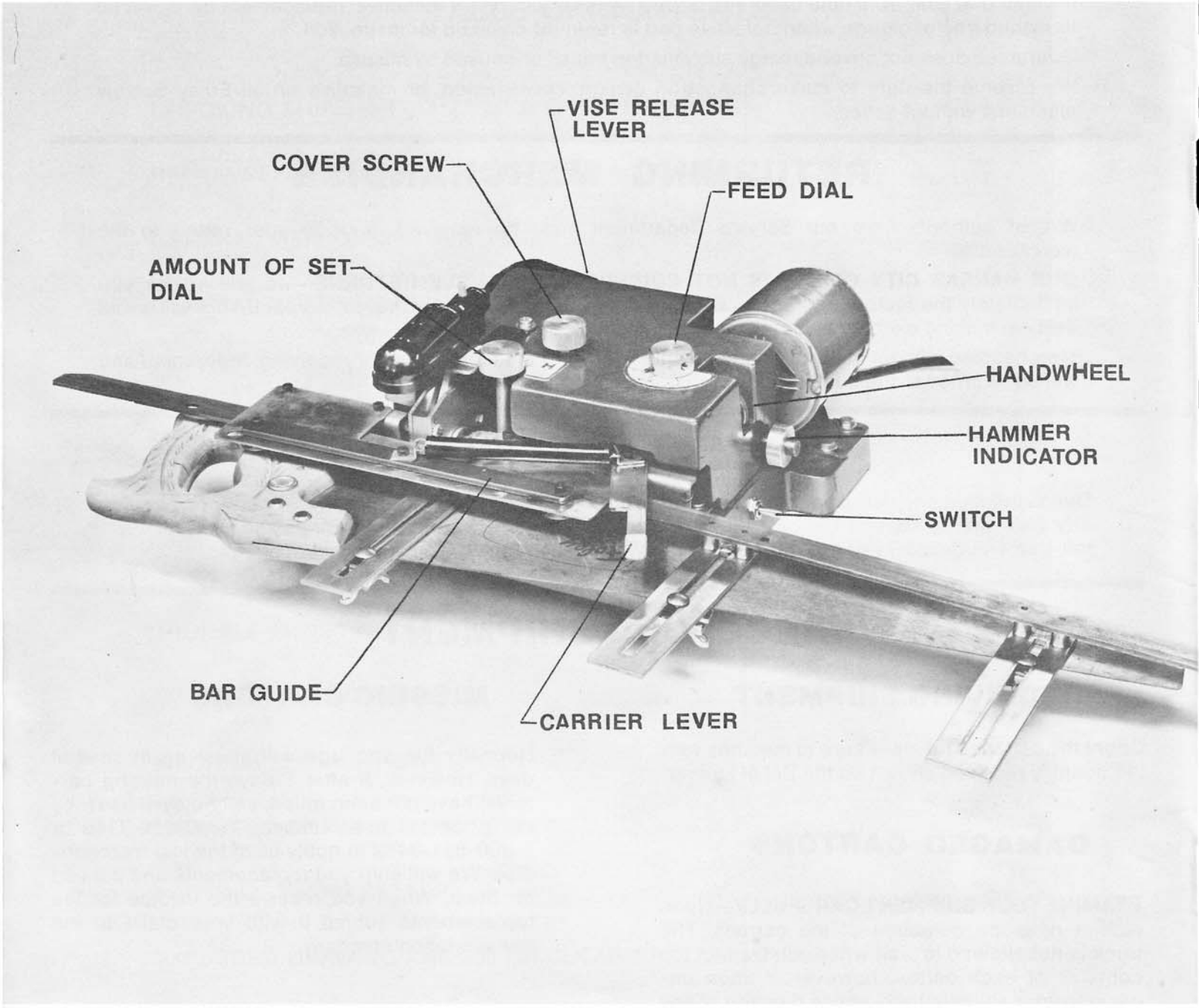
REPLACING MISSING/ DAMAGED CARTONS

In the case of easily replaced parts, first order new parts needed, pay for them and then enter a claim with the transportation company for their value.

In the case of damaged machinery beyond your capability, call Foley-Belsaw by using the toll free numbers 1-800-328-7140 or 1-800-821-3452 immediately. You must still request an inspection within 15-days or we will not be liable for any loss incurred in replacing the machine.

MODEL 392 FOLEY AUTOMATIC POWER SETTER

General View Showing Design Features and Points of Adjustment



GENERAL INSTRUCTIONS FOR USE AND OPERATION OF MODEL 392 AUTOMATIC POWER SETTER

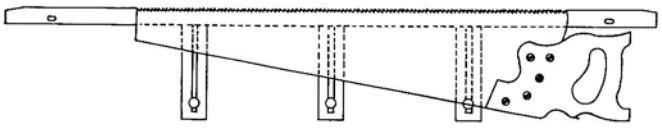
Setting Up Your Saw Setter

Your setter should be fastened to a bench with the lag screws provided. Be sure to locate the machine so there is a minimum of 36 inches on each side of the machine to allow room for the saw carrier.

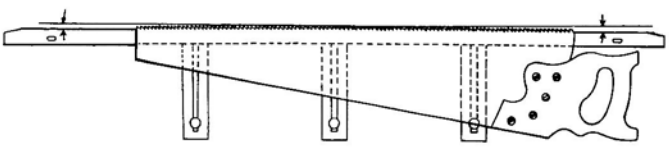
General Set-Up Instructions for the Hand Saw Carrier Bars

Your 392 Power Setter comes equipped with a straight carrier bar, almost all the saws will use this saw carrier, but in the event that a crowned saw is to be set a crowned carrier No. 358980 should be used. A back or mitre saw will also require a special saw carrier No. 358981.

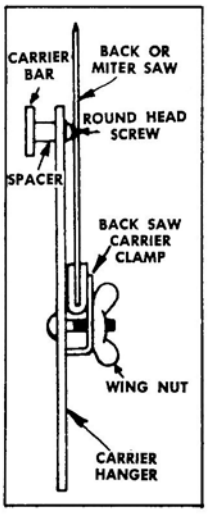
1. Straight Carrier Bar—For use with saws that have a straight toothed edge. (Cross-cut and Rip Style) #358982



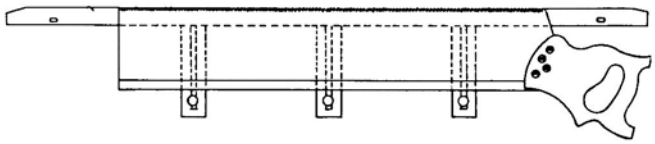
2. Crowned Carrier Bar—For use with saws that have a crowned tooth edge. This carrier bar has a 3/16" crown. (Crown of saw must match the carrier. Other carriers are available by special order.) #358980



3. Back or Miter Saw Carrier—Same basic construction as #1 but it includes a round head screw to allow for thicker top (stiff back) of miter box and back saws. #358981

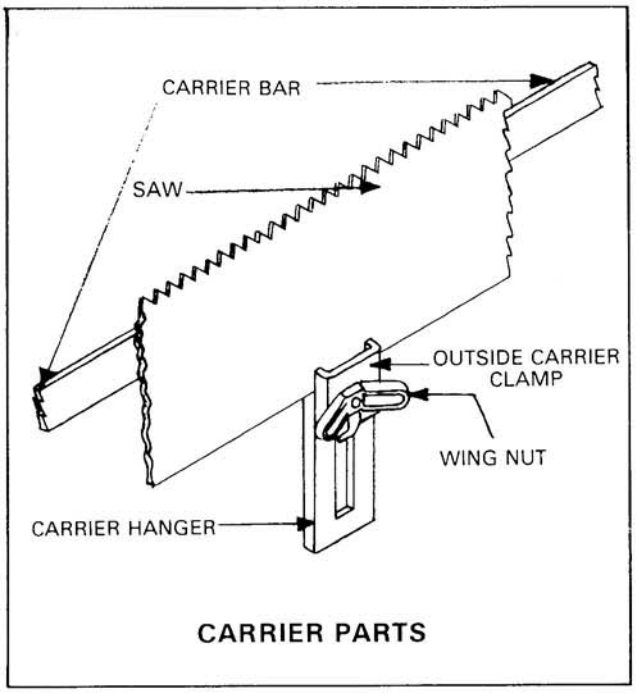


AT RIGHT
Cross section view showing assembly of back or miter box saw on No. 358981 carrier.



Handsaw Mounting Instructions

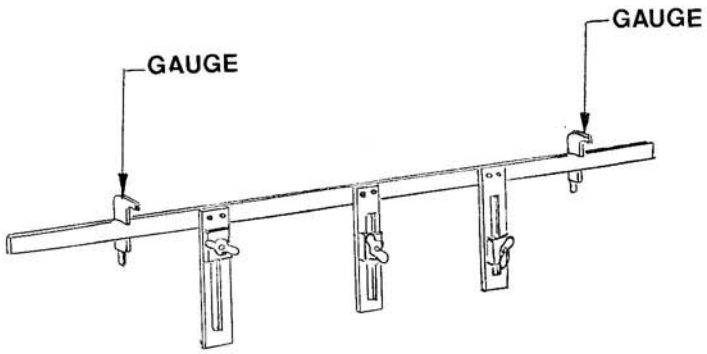
1. Loosen the clamps on the hangers so they move up and down.



CARRIER PARTS

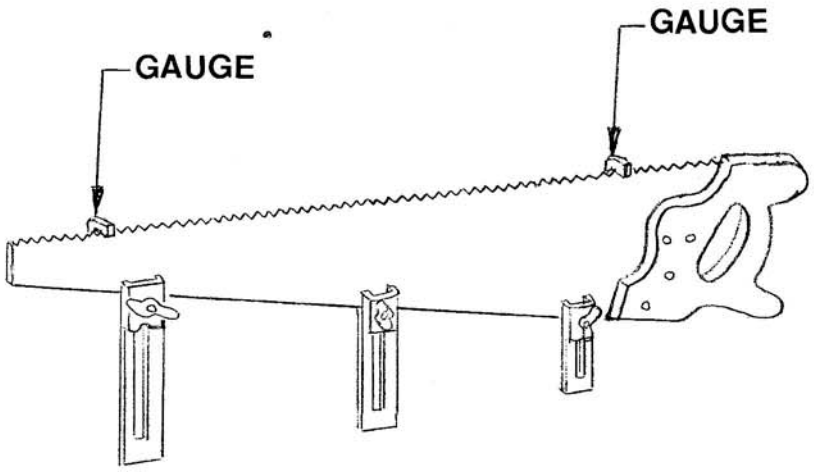
CARRIER PARTS

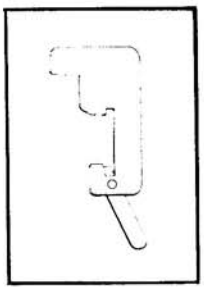
2. Place the gauges on the carrier bars, one on each end, just short of the carrier hangers and lock in place.



3. Place your saw onto the saw carrier, **with the handle to the right,** making sure the carrier gauges are in the bottom of the gullets at each end of the saw. (Saw must be centered on carrier.)

4. Hold the saw firmly against the carrier gauges and bring up the carrier clamps so that the carrier bolts are touching the back of the saw. Tighten the wing nuts firmly. Remove the saw carrier gauges.





SAW GAUGE

5. Move the Vise Lever to the down position for Handsaws. (Refer to Diagram 1)

6. Push the Shift Knob to the in position for Handsaws. This adjustment is easier to accomplish when the motor is running. (Refer to Diagram 1)

7. Turn feed dial pointer to the number of points per inch on the saw to be set. Every handsaw has a number of dimensions that vary according to the kind of work it is designed for. An ordinary crosscut saw, for example, may be anywhere from 20 to 26 inches long and have a point size ranging from 8 to 16.

   Now let's explain point sizes. The number of teeth on any saw is expressed in points per inch, but this doesn't mean teeth per inch. The reason is this—to arrive at the point size of a saw, you put a ruler on the teeth and count the number of tooth points there are in an inch. But notice that while an 8-point saw has 8 tooth points to the inch, it actually has only 7 teeth to the inch. (Refer to Diagram 2)

8. Adjust the Amount of Set Dial to the desired amount of set. This adjustment will vary depending upon the thickness & condition of the saw to be set. It has been found that an adjustment approximately halfway between the H&L will give you the required set for an 8-pt. saw. (Refer to Diagram 3)

   An 8 point handsaw should have the entire tooth overhanging the anvil for an average set. On smaller teeth, it will require overhanging a little more.

9. Turn the handwheel till hammer indicator points to up or down. The vise jaws will be open in this position.

10. Forcibly move Carrier Lever to the left until Bar Guide catches in open position.

11. Insert saw mounted on carrier as shown in Diagram 4, sliding saw to the left and between the vise jaws until the feed pawl engages the teeth. If the hammer indicator points to down, position the saw so a tooth to be set down is resting against the feed pawl.

12. Move Carrier Lever to the right and then turn the motor switch on.

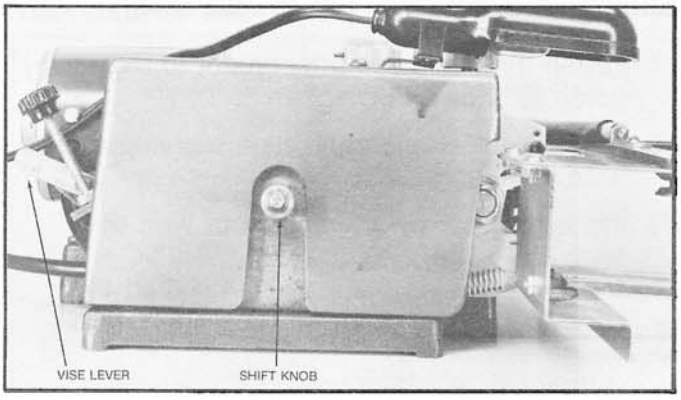


DIAGRAM 1

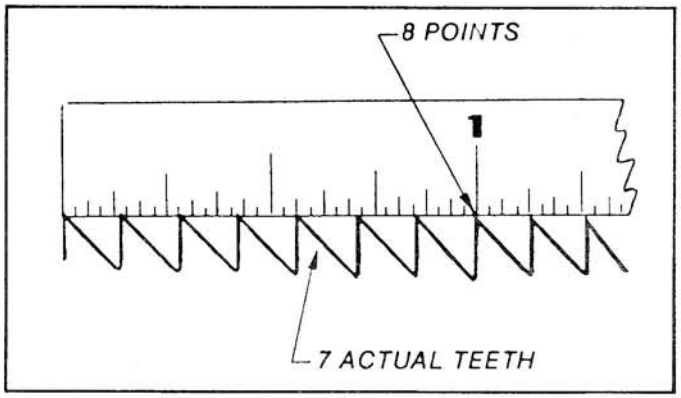


DIAGRAM 2

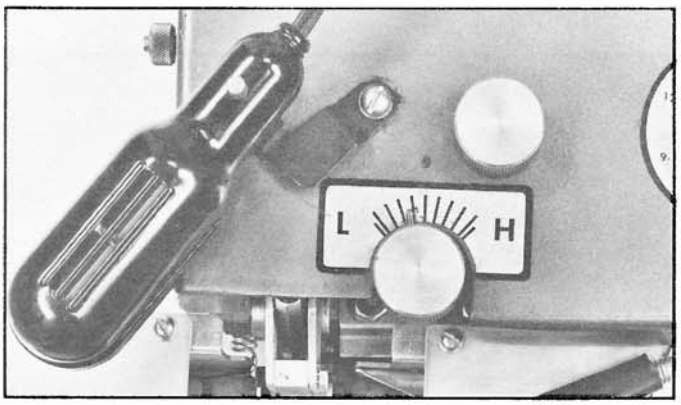


DIAGRAM 3

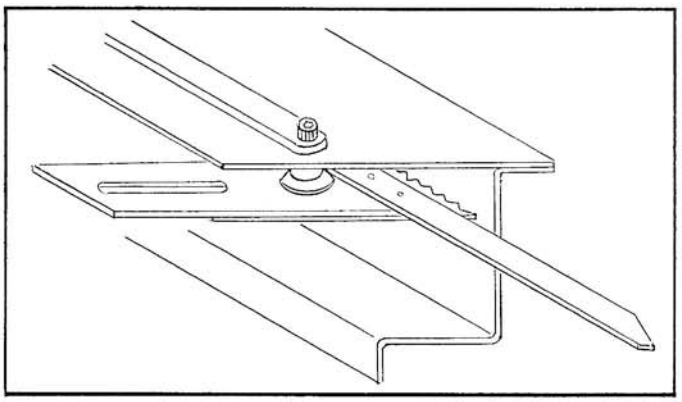


DIAGRAM 4

Setting Circular Saws (up to .062 thick)

1. Fasten the circle saw attachment to the saw guide as shown in Diagram 5.
2. Loosen lock wrench and slide saw cup away from the machine.
3. Place the saw on the saw cup, with the teeth facing to the right,
   slip the cone on the stud and thread the cone lock knob down till the saw is held to the saw cup, but the saw can be turned with some resistance.

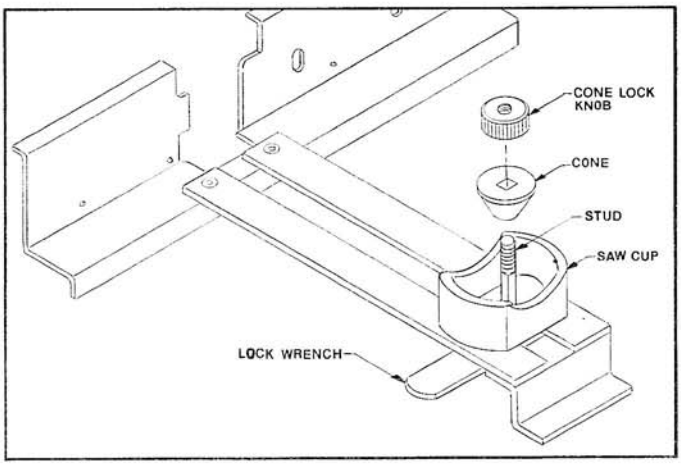


DIAGRAM 5

4. Move the Vise Lever to the up position for circle saws. (Refer to Diagram 6)
5. Pull the Shift Knob to the out position for circle saws. (Refer to Diagram 6)

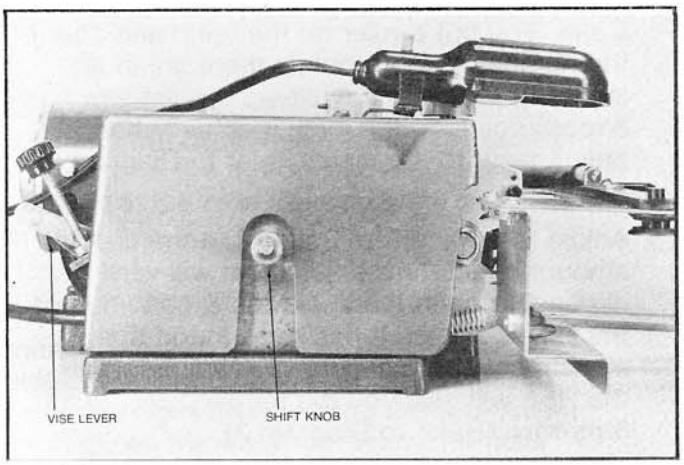


DIAGRAM 6

6. Turn the handwheel so the hammer indicator has the word "UP", or "DOWN", in the top position. (Refer to Diagram 7)
7. Turn the "Amount of Set Dial" halfway between light and heavy. (Refer to Diagram 3)

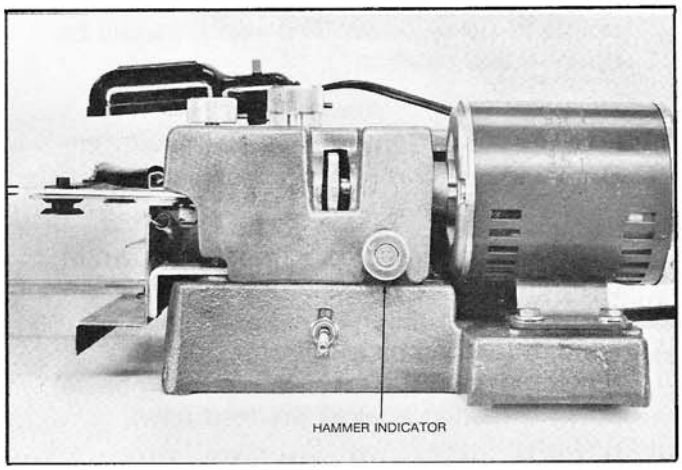


DIAGRAM 7

8. Turn the "Feed Dial" to the number of points per inch that are on the saw to be set. (Refer to Diagram 8)
9. Depress the vise release lever and slide the saw between the vise jaws until the entire saw tooth protrudes over the vise jaw, and then tighten the lock under the cup securely. (Refer to Diagram 8)
10. Position the feed pawl on a tooth to be set down if the hammer indicator reads DOWN, or on a tooth to be set up if the indicator reads UP.
11. Turn handwheel and observe the hammer bending the tooth and the feed pawl backing up and over the next tooth. Turn on switch and run the setter until the entire saw has been set.

TOP VIEW OF UNIT

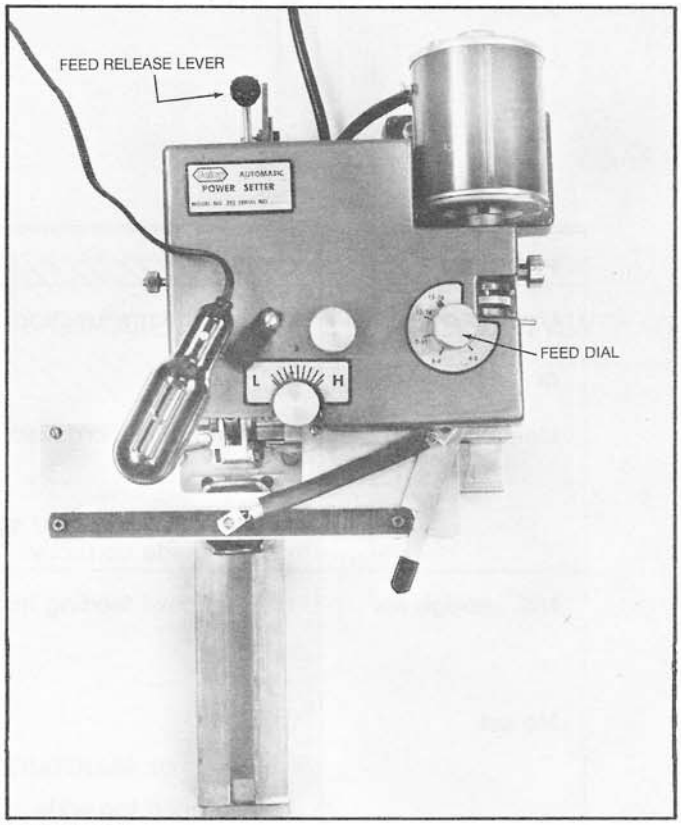


DIAGRAM 8

Band Saws

The teeth on Band Saws are set in exactly the same manner as those on hand saws which have been discussed previously.

Note that Saw Guide has two Band Saw Clips attached. To place band saw in Setter, first adjust feed travel as in item 7—page 7 and amount of set as in item 8—page 7.

Next, pull the two Spring Clips upward and outward, snapping them over the back edge of band saw. Setter may now be operated in the usual manner without having to hold the band saw in position by hand.

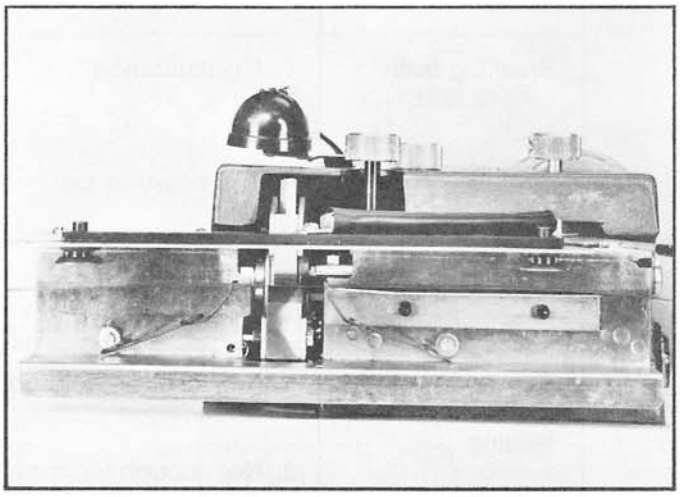


DIAGRAM 9

Trouble-Shooting

PROBLEM	CAUSE	REMEDY
Unequal set or Uneven set	1. Machine malfunction	1. Follow equalizing set instructions on page 12
	2. Holding saw crooked	2. Tighten up saw guide (refer to adjustment on page 12)
	3. Saw not being held against saw guide correctly	3. Follow adjustment on page 14 for adjusting saw guide
Not enough set or No set	1. Feed pawl feeding incorrectly	1. Follow feed pawl adjustment on page 11 Check and see if feed pawl is chipped or broken on end, replace if broken
	2. Vise open too wide	2. Follow vise adjustment on page 15
	3. Hammerscrews broken	3. Replace hammers by following steps on page 13
Breaking teeth	1. Crystallization	1. No remedy—except try retoothing several times to see if you can remove crystallized area of saw
	2. Too heavy of set	2. Back off amount of set dial to lighter setting (see page 7, Diagram 3)
	3. Unequal set	3. Follow equalizing set instructions on page 12
Saw not feeding properly	1. Saw bent or teeth not uniform or damaged	1. Retooth or straighten saw
	2. Not enough tooth overhanging anvil	2. See adjustments in operating section on pages 6-9
	3. Point selection wrong	3. Turn feed dial to correct setting (see page 7, item 7)
	4. Feed pawl spring loose or broken	4. Repair or replace, (see exploded view, page 19, item 52)

Feed Pawl Adjustment

1. *Unplug power cord so machine cannot be turned on accidentally and remove cover.*
2. Turn handwheel till feed pawl is advanced as far as it will go to the left.
3. Unhook saw table spring and swing saw table out, but do not disconnect feed pawl spring.
4. Hold gauge provided with machine as shown in illustrations.
5. The point of the feed pawl should just touch the gauge with the gauge resting against the hammer screws. If the feed pawl is holding the gauge away from the hammer screws or the feed pawl doesn't touch the gauge make the following adjustments.
   a. Loosen lock nut.
   b. Insert small allen wrench in the crosshole in the adjusting screw and turn adjusting screw till feed pawl just touches the gauge.
   c. Hold adjusting screw from turning while tightening lock nut.
6. Turn feed stop to position shown in illustration (the stop used for setting 15 or 16 teeth to the inch).
7. Loosen back stop screw lock nut and adjust screw so there is 7/32 inch or the thickness of the feed pawl gauge between the screw and the feed stop and tighten lock nut.

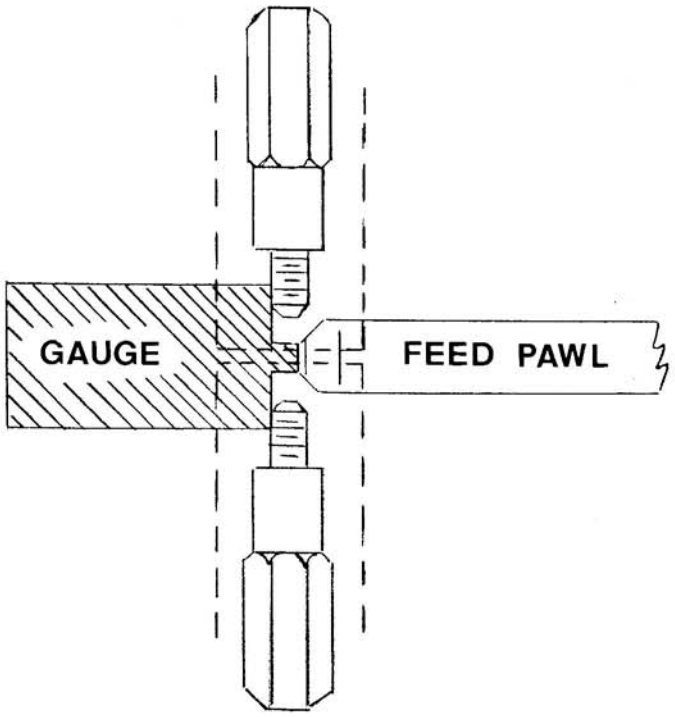


DIAGRAM 10

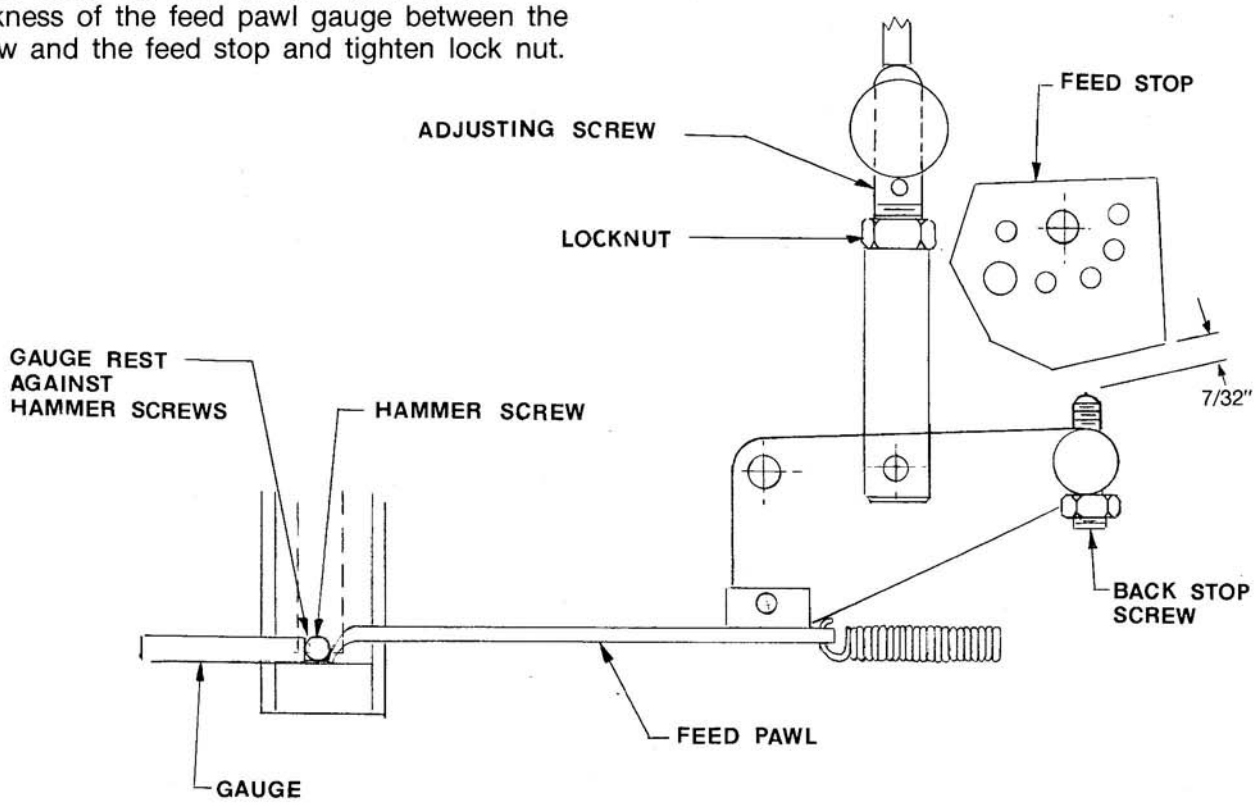


DIAGRAM 11

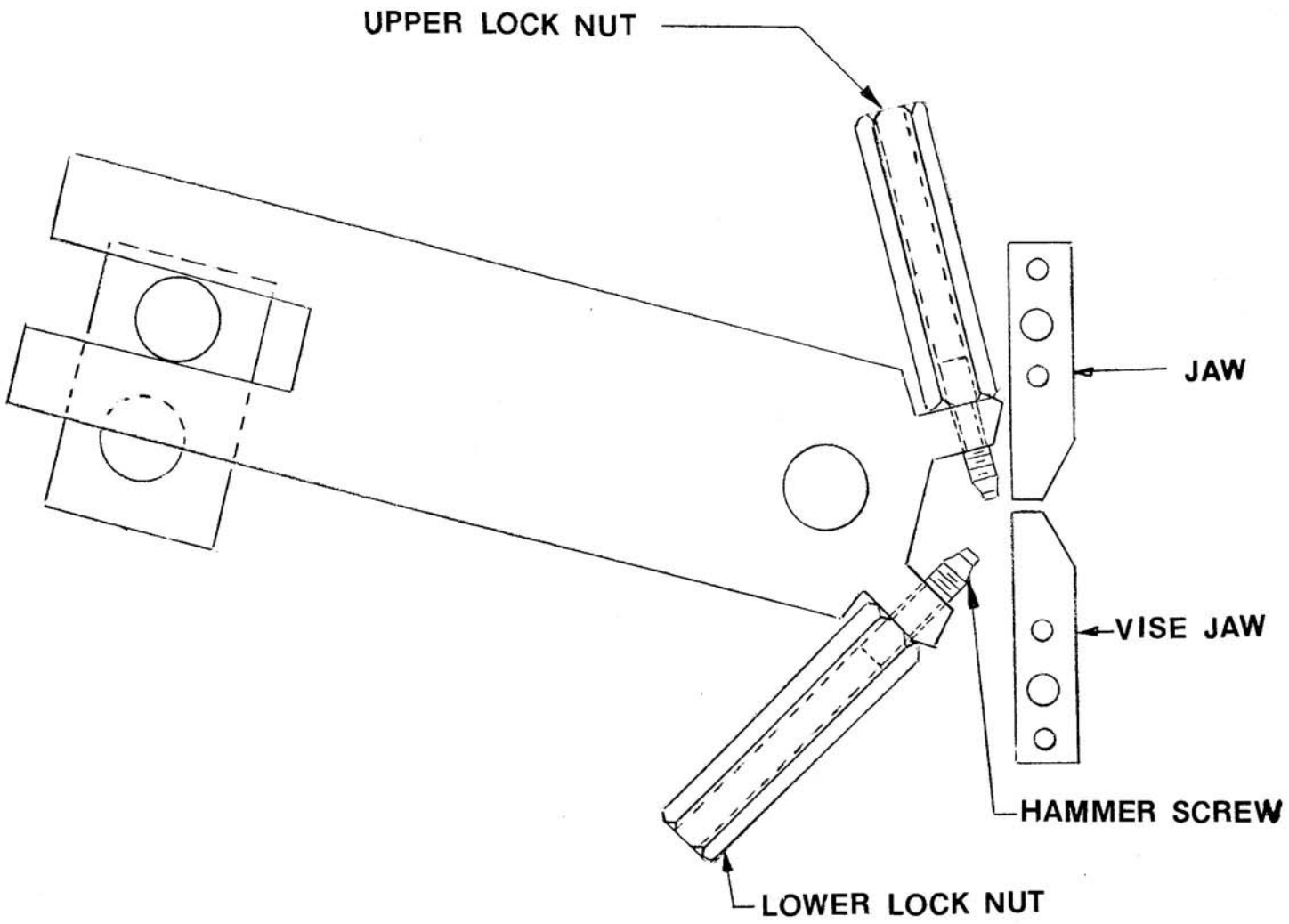


DIAGRAM 12

Machine Adjustments

Equalizing the Set

With the Amount of Set Dial positioned half way between high and low the set should be about .012 to .018 on a 7 or 8 point saw.

Not enough down set.

1. *Unplug cord so machine cannot be turned on accidentally.*
2. Remove cover screw and remove cover.
3. Turn the handwheel till the back of hammer is in highest position as illustrated.
4. Insert 3/32" dia. allen wrench in upper locknut hole and loosen locknut while holding the hammer screw from turning.
5. Turn allen wrench clockwise to increase the amount of set, counterclockwise to decrease the amount of set. One fourth of a turn will change the amount of set about .008, ⅛ of a turn .004 etc. After turning screw the desired amount, hold the screw from turning with allen wrench and snug up locknut.

Not enough up set

1. *Unplug cord so machine cannot be turned on accidentally.*
2. Remove cover screw and remove cover.
3. Turn the handwheel till back of hammer is in lowest position.
4. Insert allen wrench in lower locknut hole and loosen the locknut ¼ turn while holding the hammer screw from turning.
5. Turn allen wrench clockwise to increase the amount of set, counter-clockwise to decrease the amount of set. One-fourth of a turn will change the amount of set about .008, ⅛ of a turn .004 etc. After turning screw the desired amount hold the screw from turning with allen wrench and snug up locknut.

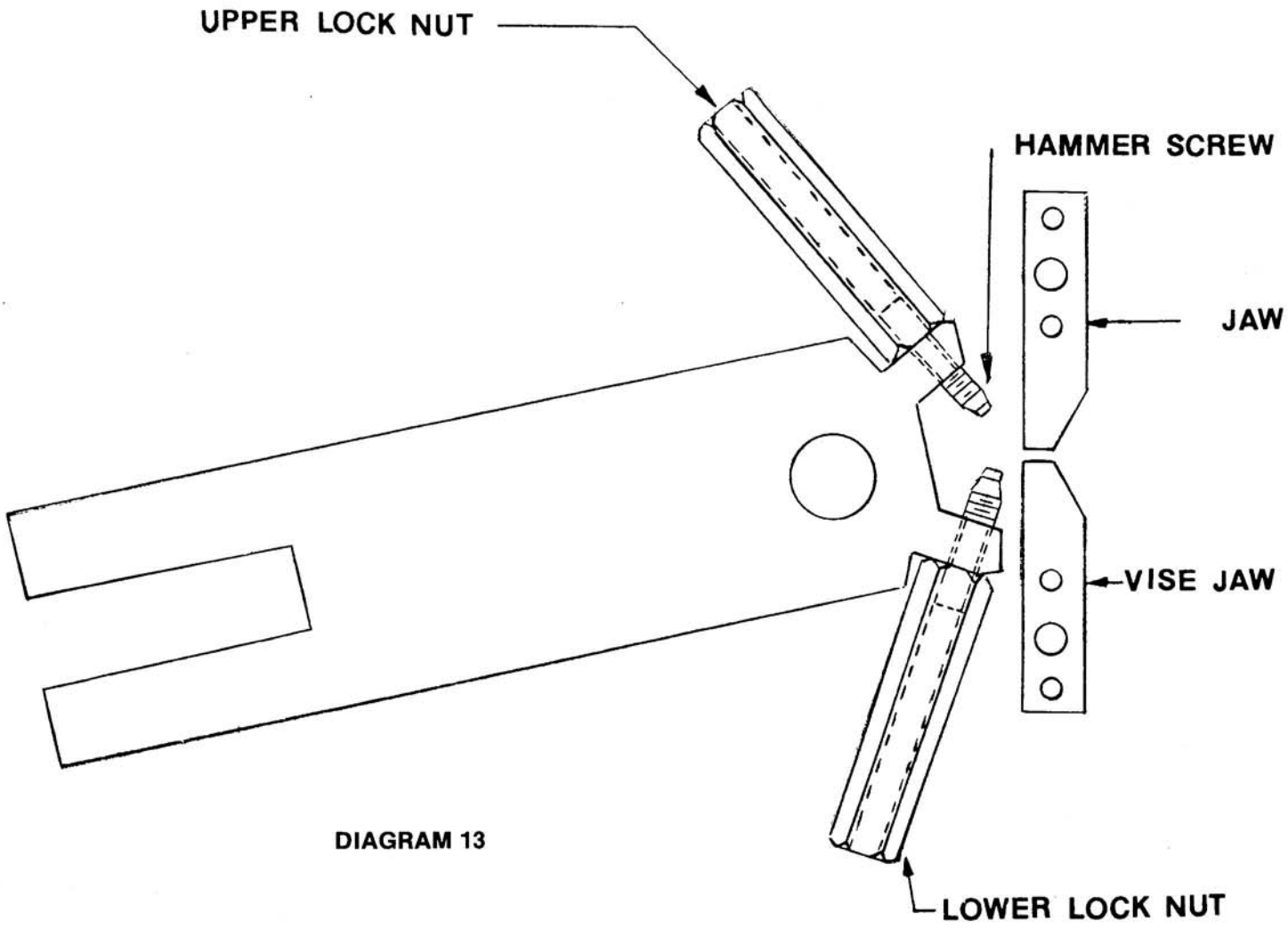


DIAGRAM 13

Replacement
Upper Hammer Screw

1. *Unplug machine and remove cover.*
2. Position Hammer Screw as shown in Diagram 12.
3. Remover Upper Locknut.
4. Remove damaged Upper Hammer Screw.
5. Place the backside of handsaw or thin piece of sheet metal into vise opening. (Do not use the tooth side of the handsaw)
6. Screw in a new Upper Hammer Screw. Screw down until it touches saw and then screw one complete turn more.
7. Screw on Upper Locknut and tighten.

Replacement
Lower Hammer Screw

1. *Unplug machine and remove cover.*
2. Position Hammer Screws as shown in Diagram 13.
3. Remover Lower Locknut.
4. Remove damaged Lower Hammer Screw.
5. Place the backside of a handsaw or a thin piece of sheet metal into vise opening. (Do not use the tooth side of the handsaw)
6. Screw in a new Lower Hammer Screw. Screw down until it touches saw and then screw one complete turn more.
7. Screw on Lower Locknut and tighten.

Mounting Cover Back onto Machine

The following parts must be positioned as follows:

1. Position Feed Stop as shown in diagram.
2. Turn Feed Dial to the 15-16 pts. per inch setting.

Then secure cover to the base. Double check that the Feedshaft Weldment on cover mounts into holes A & B on the Feed Stop.
(Refer to Diagram 14)

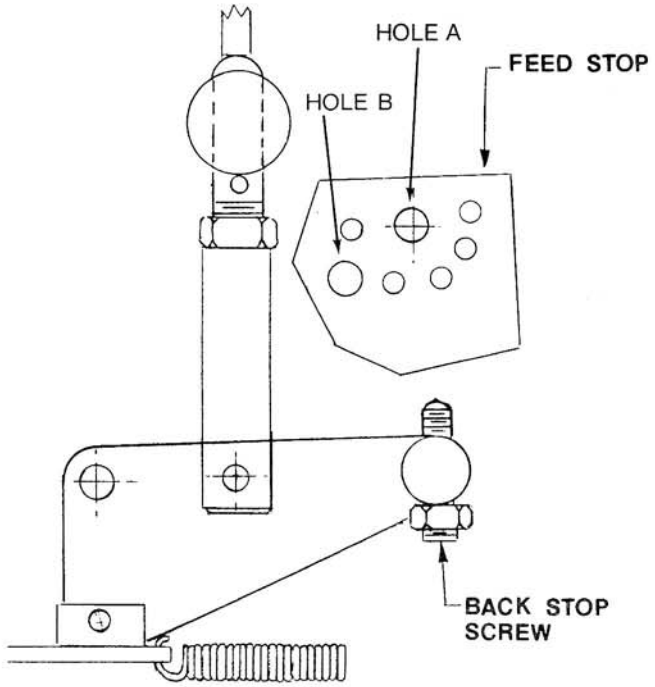


DIAGRAM 14

Saw Guide Adjustment

1. *Unplug machine* and remove cover.
2. Mount saw into carrier.
3. Mount carrier into machine.
4. Release carrier lever.
5. Loosen the 4 top plate fasteners. (See Diagram 15)
6. Adjust top plate so the saw teeth are touching the full length of the table.
7. Tighten the 4 top plate fasteners.

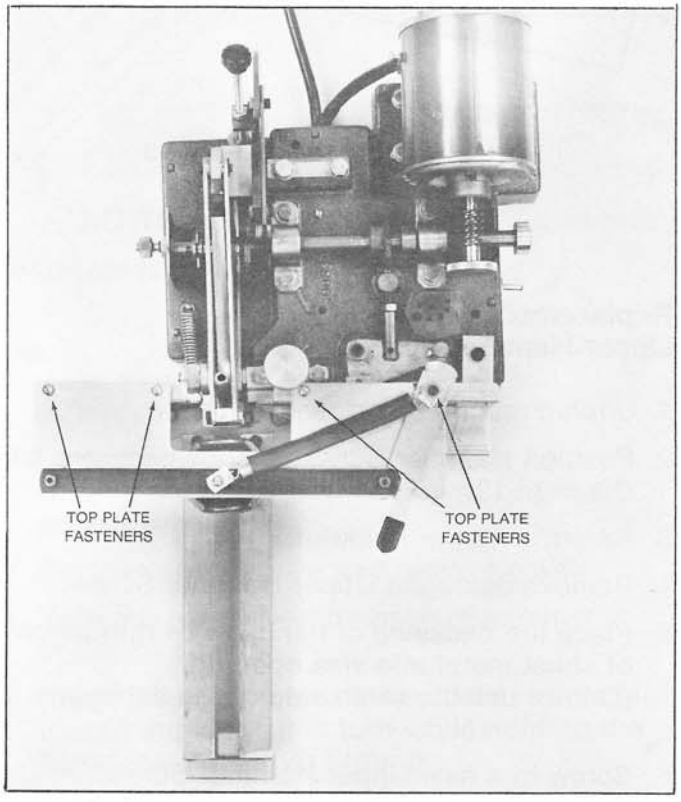


DIAGRAM 15

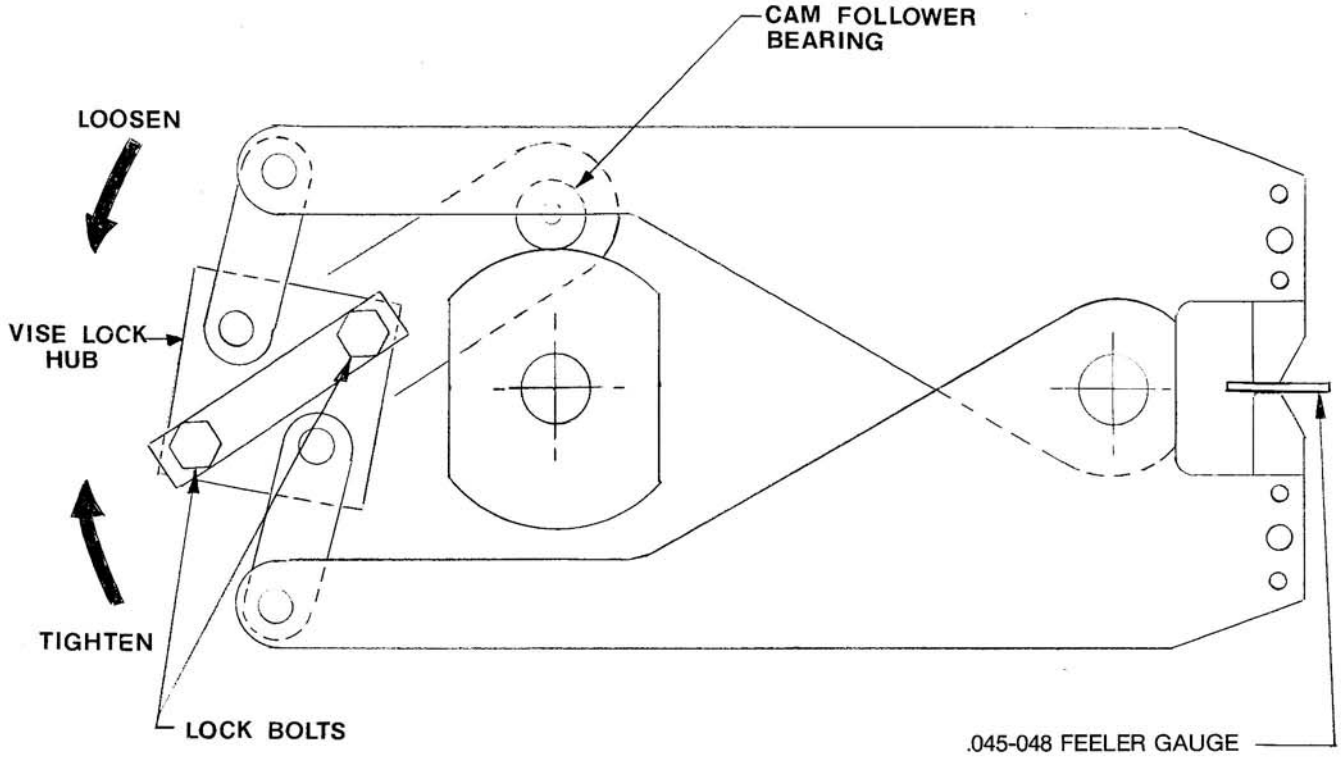


DIAGRAM 16

Vise Adjustment

1. *Unplug power cord so machine cannot be turned on accidentally.*

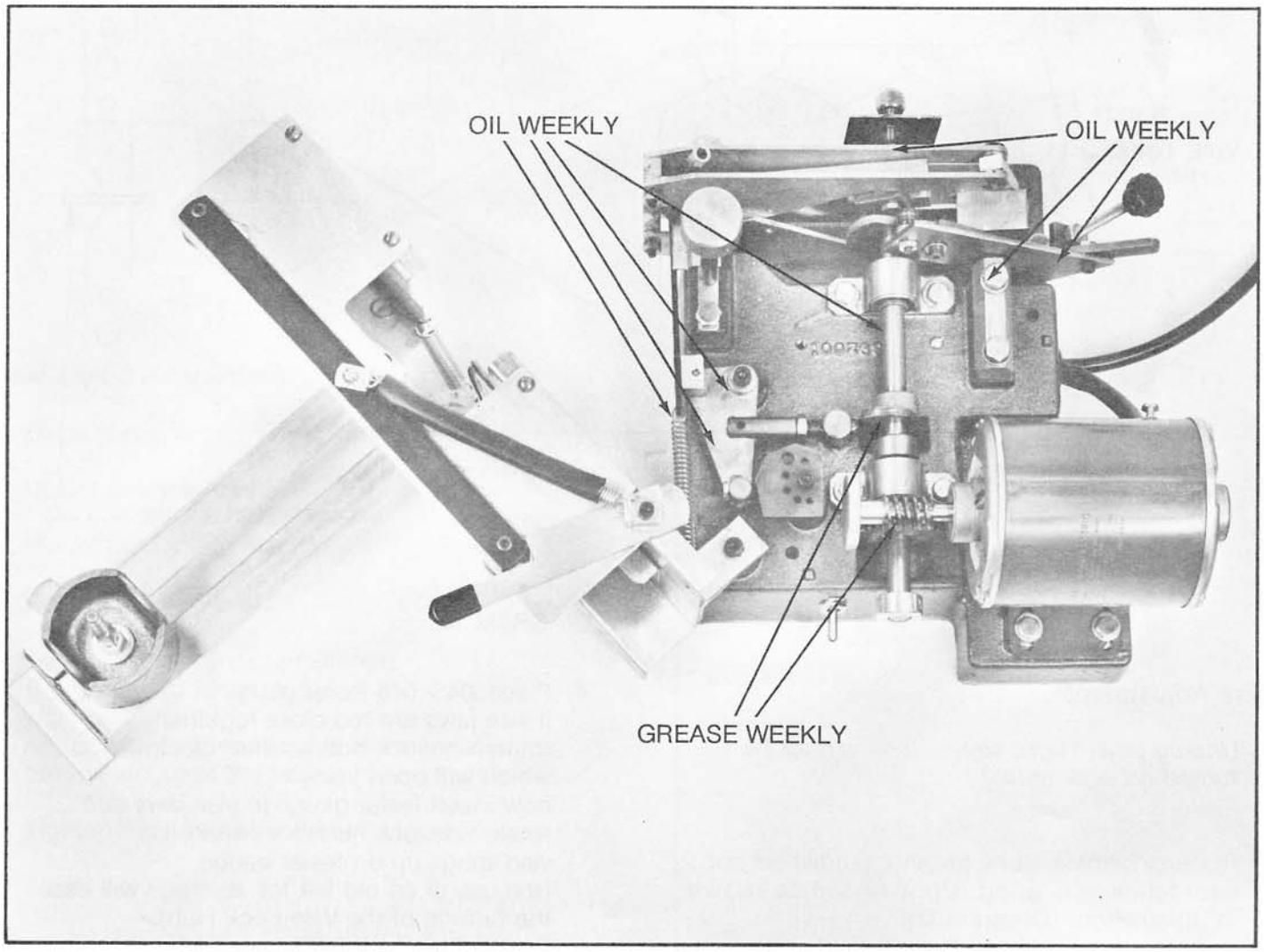
2. Position crankshaft by turning handwheel so cam follower bearing is positioned as shown in illustration. (Diagram 16)

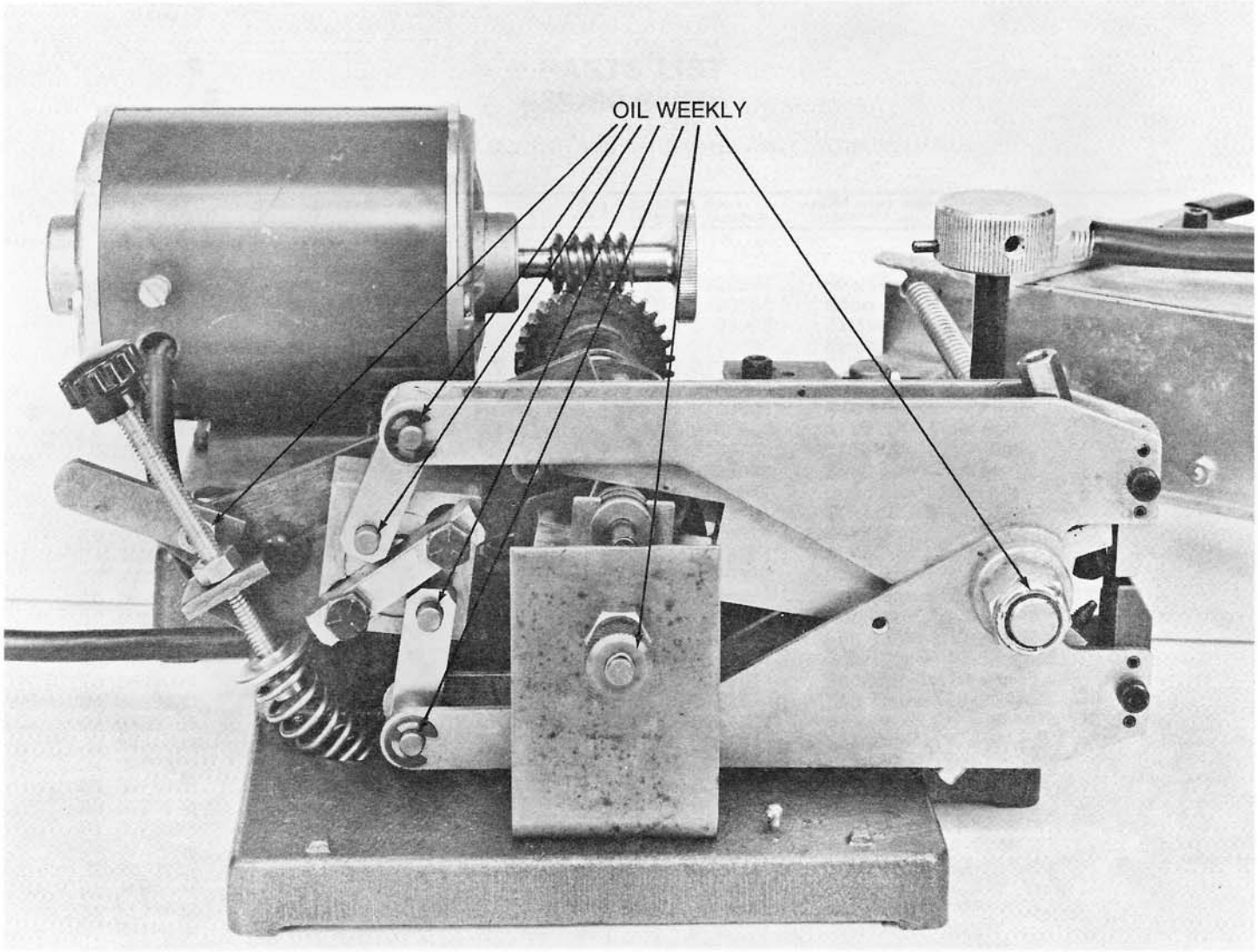
3. Loosen lock bolts one full turn.

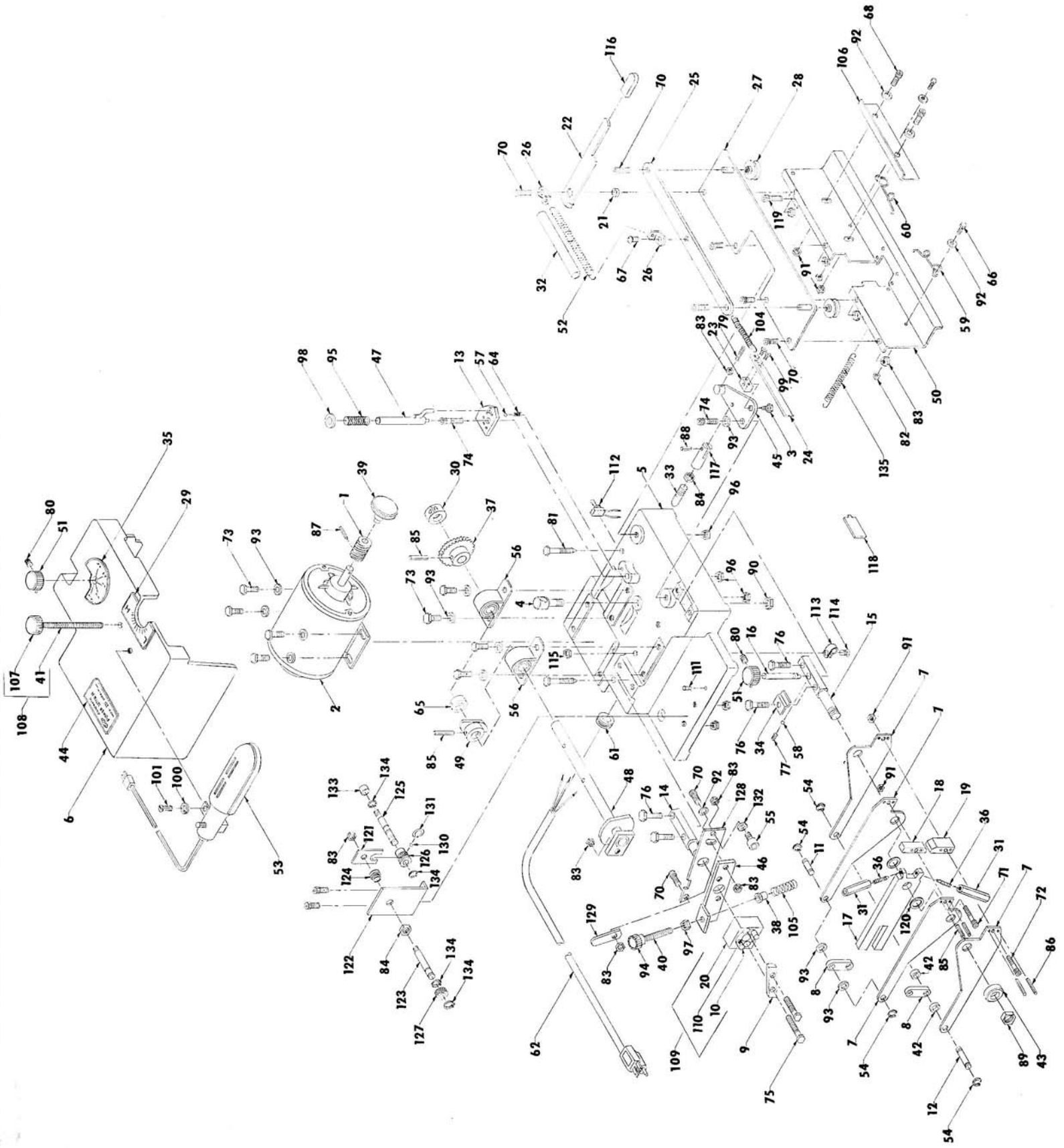
4. Place .045-.048 feeler gauge in vise jaws, if vise jaws are too close together rotate vise lock hub counter-clockwise which will open jaws, now insert feeler gauge in vise jaws and rotate vise lock hub clockwise till vise snugs up on feeler gauge, (the use of an old file for leverage will ease the turning of the Vise Lock Hub), then tighten lock bolts securely. Now recheck vise opening to make sure the opening is .045-.048.

Machine Lubrication

To help insure trouble-free performance and long life, your machine should be lubricated as illustrated using S.A.E. 30 or 40 weight oil where oil is called for and wheel bearing or universal joint grease where grease is called for.




OIL WEEKLY



PARTS LIST
39200 Setter

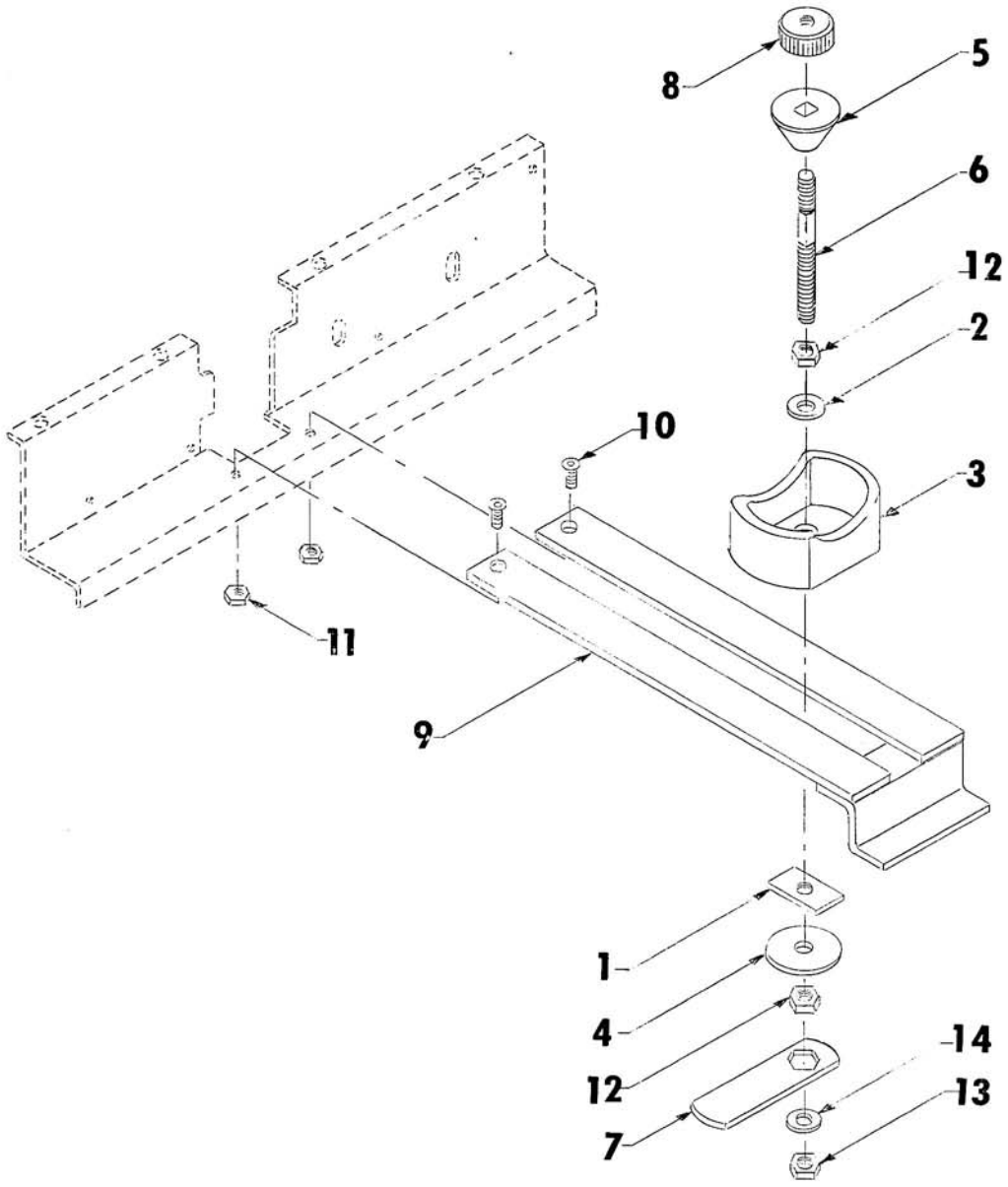
ALWAYS ORDER BY PART NUMBER AND PART NAME—NOT BY DIAGRAM NUMBER.

DIAGRAM NUMBER	PART NUMBER	PART NAME AND DESCRIPTION
1	3109038	Worm
2	3109041	Motor 1/20 HP 115V 60HZ 10
3	3309027	Shoulder Screw
4	3309035	Push Rode Guide
5	3929001	Base
6	3929002	Cover
7	3929010	Vise Arm
8	3929011	Arm Connecting Link
9	3929012	Clamp Bar
10	3929013	Lock Hub Pin
11	3929014	Upper Cross Pin
12	3929015	Lower Cross Pin
13	3929016	Feed Stop
14	3929017	Vise Lock Shaft
15	3929018	Vise Pivot
16	3929019	Set Adjustment Shaft
17	3929024	Hammer
18	3929027	Upper Anvil
19	3929028	Lower Anvil
20	3929029	Vise Lock Hub
21	3929030	Carrier Lever Spacer
22	3929031	Carrier Lever
23	3929033	Feed Pawl Pivot
24	3929034	Feed Pawl
25	3929039	Lock Bar
26	3929040	Spring Clip
27	3929041	Guide Top Plate
28	3929042	Bar Guide
29	3929043	Tooth Height Decal
30	3929044	Hammer Indicator Collar
31	3929048	Lock Nut
32	3929049	Spring Cover
33	3929050	Push Rod
34	3929051	Feed Pawl Guide
35	3929052	Feed Stop Decal
36	3929053	Hammer Set Screw
37	3929054	Worm Gear
38	3929055	Spring Guide
39	3929056	Motor Handwheel
40	3929057	Threaded Stud
41	3929058	Threaded Stud
42	3929059	Spacer
43	3929060	Spacer
44	3929062	Nameplate
45	3929521	Feed Stop Lever Weldment
46	3929590	Cam Lever Weldment
47	3929525	Feed Control Weldment
48	3929535	Cam Shaft Weldment
49	3929538	Feed Cam Weldment
50	3929547	Saw Guide Weldment
51	3929561	Knob Assy.
52	3709280	Extension Spring
53	3709296	Electric Light
54	3709602	E-Ring
55	3709608	Cam Follower
56	3709609	Pillow Block
57	3709636	3/16" Dia. Steel Ball
58	3709705	5/32" Dia. Nylon Ball
59	3529046	Band Saw Clip Left
60	3529047	Band Saw Clip Right
61	3709765	Rubber Grommet
62	3619584	Cord Set
64	3579105	Spring
65	3709877	Shaft Collar
66	3109023	Band Saw Clip Screw
67	A190422	Round Hd. Mach Sc. 10-32 NF x 1/4" Long
68	B190611	Soc. Cap Sc 10-24 NC x 3/8" Long
70	B190831	Soc. Cap Sc 10-32 NF x 1/2" Long
71	B191611	Soc. Cap Sc 10-24 NC x 1" Long
72	B192011	Soc. Cap Sc 10-24 NC x 1-1/4" Long
73	B251001	Hex Cap Sc 1/4-20 NC x 5/8" Long
74	B252411	Soc. Cap Sc 1/4-20 NC x 1-1/2" Long
75	B252421	Hex Cap Sc 1/4-28 NF x 1-1/2" Long
76	B311801	Hex Cap Sc 5/16-18 NC x 1-1/8" Long
77	C190260	Soc. Set Sc 10-32 NF x 1/8" Long
78	C190860	Soc. Set Sc 10-32 NF x 1/2" Long
79	C191660	Soc. Set Sc 10-32 NF x 1" Long
80	C250420	Soc. Set Sc 1/4-20 NC x 1/4" Long
81	E254003	Lag Sc 1/4 x 2-1/2" Long
82	J131100	Hex Nut 6-40 NF
83	J192100	Jam Nut 10-32 NF
84	J372100	Jam Nut 3/8"-24NF
85	R841075	Rollpin 1/8" Dia. x 3/4" Long
86	R841100	Rollpin 1/8" Dia. x 1" Long
87	R840050	Rollpin 3/32" Dia. x 1/2" Long
88	R847050	Rollpin 3/16" Dia. x 1/2" Long
89	R000382	Hex Nut Nylok 1/2-20 NF
90	R000396	Hex Nut Nylok 3/8-16 NC
92	R000522	Washer #10 SAE
93	R000524	Washer 1/4 SAE
94	3709017	Knob
95	3589034	Spring
96	R000380	Hex Nut Nylok 1/4-20 NC
97	J251000	Hex Nut 1/4-20 NC
98	R000527	Washer 3/8 SAE
99	B130625	F1 Hd Soc Cap Sc 6-32 x 3/8" Long
100	R000469	Lockwasher 1/4

PARTS LIST (continued)
39200 Setter

ALWAYS ORDER BY PART NUMBER AND PART NAME—NOT BY DIAGRAM NUMBER.

DIAGRAM NUMBER	PART NUMBER	PART NAME AND DESCRIPTION
101	B250802 ..	S1 Round Hd Cap Sc 1/4-20 x 1/2" Long
104	3709821 ..	Spring
105	3929089 ..	Spring
106	3929063 ..	Saw Rest
107	3929064 ..	Knob
108	3929564 ..	Knob Assy.
109	3029529 ..	Vise Lock Hub Assy.
110	3709100 ..	Oilite Bearing
111	R602031 ..	#4 x 5/16" Long
112	3707337 ..	Toggle Switch
113	3707933 ..	Cord Clip
114	B161402 ..	S1 Round Hd Cap Sc 8-32 NC x 7/8" Long
115	J161000 ..	Hex Nut 8-32 NC
116	3929065 ..	Vinyl Handle
117	3309033 ..	Push Rod Holder
118	3929066 ..	Feed Pawl Gauge
119	B251411 ..	Soc. Cap sc 1/4-20 NC x 7/8" Long
120	3709027 ..	Thrust Washer
121	3929070 ..	Pivot Gauge
122	3929071 ..	Pin Bracket
123	3929072 ..	Shift Rod
124	3929073 ..	Shift Pin Bearing
125	3929074 ..	Roller Shaft
126	3929075 ..	Sleeve
127	3929076 ..	Shift Knob
128	3929078 ..	Bearing Pivot Plate
129	3929079 ..	Lever
130	3929086 ..	Steel Ball
131	3929087 ..	Ball Snap Ring
132	3929088 ..	Spacer
133	3929577 ..	Roller Assy.
134	3709143 ..	Retaining Ring
135	3709833 ..	Extension Spring-Table



Always order by PART NUMBER and Part Name-not by diagram number.

DIAGRAM NUMBER	PART NUMBER	PART NAME AND DESCRIPTION
1	3529039	Guide Nut
2	3529041	Washer
3	3539538	Cup
4	3589091	Washer
5	3929082	Saw Cone
6	3929083	Cup Stud
7	3929084	Lock Wrench
8	3929085	Cone Locking Knob
9	3929580	Arm Weldment
10	B190805	Fl. Soc Hd Cap Sc 10-24 NC
11	J191000	Hex Nut 10-24 NC
12	J311000	Hex Nut 5/16-18 NC
13	R000381	Hex Nut Nylok 5/16-18 NC
14	R000526	Washer 5/16 SAE

FOLEY BELSAW

Any Questions? Call Toll Free

1-800-328-7140
1-800-821-3452

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