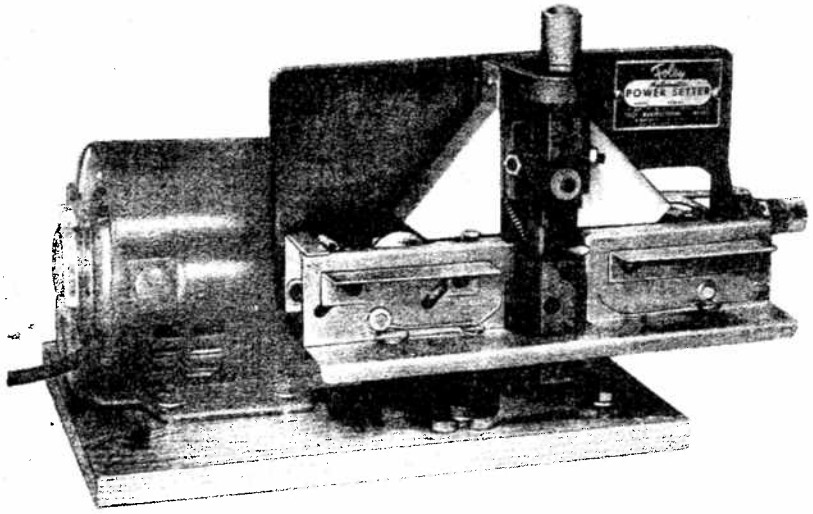
OPERATING & SERVICE INSTRUCTIONS

FOLEY AUTOMATIC POWER SETTERS

FOR HAND AND BAND SAWS



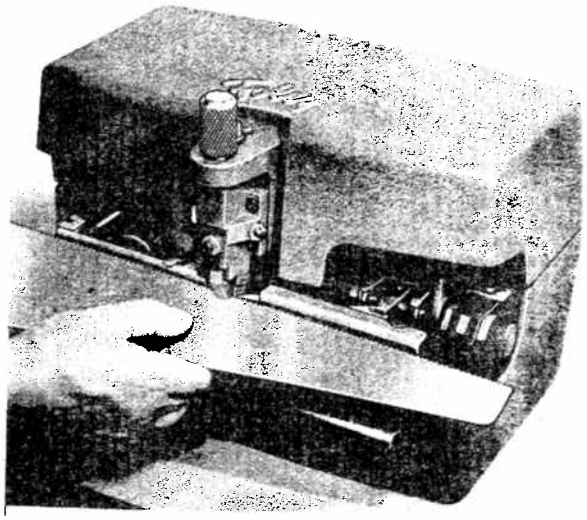
SHORT COURSE OPERATING INSTRS.

The GREEN SHEET in this Manual is a simplified version of complete operating instructions.

For more detailed information read the entire instructions.

ABOVE —
MODEL 525 WITHOUT CASE

AT RIGHT —
MODEL 52 WITH CASE



Your Foley Setter is constructed to give long trouble-free operation and dependable, accurate service in the setting of teeth on carpenters' hand saws, as well as narrow wood-cutting band saws.
Please read printed directions, and study the photographs carefully, before attempting to operate the machine.
If there is any point in these operating directions that is not entirely clear, please write the Service Department of Foley Manufacturing Company for assistance.

FOLEY MANUFACTURING COMPANY
3300 FIFTH STREET N.E. MINNEAPOLIS, MINNESOTA 55418

ONE YEAR GUARANTEE

All Foley 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 machines without notice.

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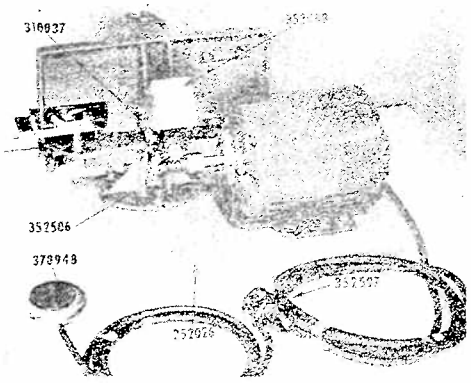
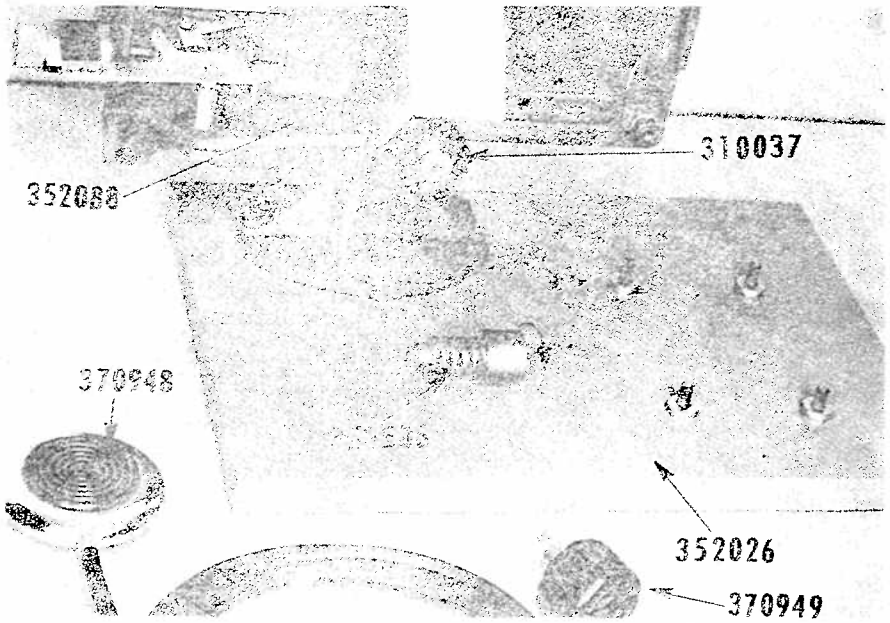
Printed in U.S.A.

ASSEMBLY INSTRUCTIONS

MODEL 525

FOLEY SAW SETTER





ASSEMBLY: To provide protection during shipment, the Model 525 Setter is secured to center of No. 352026 wood base, with three mounting bolts, washers and nuts. This is not the correct position for operation; before Setter is placed in service, it should be moved to upper left hand corner of board as pictured. Merely bolt lightly in place; do not tighten bolt nuts until after mesh of gears has been checked.

DIRECTION OF MOTOR SHAFT ROTATION: Shaft of motor used on Model 525 Foley Setter must rotate clockwise, or to the right, (as viewed from shaft end). This is the direction of rotation commonly found on most fractional horsepower motors, such as the Foley No. 361529.

In the event that motor shaft turns counterclockwise, on motor you wish to use, direction of rotation should be reversed. On practically all motors of standard make it is possible, by either unscrewing or unsoldering the leads, to switch the terminal box connections which will reverse direction of rotation.

Motor speed should not exceed 1750 RPM. The Model 525 Setter may be operated with any motor of 1/20 HP to ⅓ HP, having speed of 1425 RPM to 1750 RPM.

POSITIONING MOTOR: Place No. 352506 Worm and Adaptor on motor shaft, and lock firmly in place with Allen key. Place motor as shown, with motor shaft at right angles to Setter drive shaft, so worm engages No. 310037 gear and is directly underneath gear. (In above illustrations, No. 352088 gear guard is raised to show how gears mesh.)

If the worm gear on Setter is too low and prevents sliding motor into place, use shims of sufficient thickness under the foot of Setter to provide necessary height. If worm adaptor and motor are too far below the worm gear on Setter shaft, place shims under the motor base.

Four holes, provided in wood base for bolting motor in place, are spaced to match standard motor base units. Other holes should be drilled in board if required by any variation in your motor base dimensions.

After re-checking alignment and fit of gears, tighten all bolts to hold motor and Setter firmly in correct position.

CONNECT MOTOR AND FOOT SWITCH: Standard No. 370948 foot switch operates on 110/120 volt and comes complete with cord and series fitting to receive plug of motor cord. No wiring is required. Just insert plug of motor cord into No. 352507 series fitting, as shown, and plug fitting into electric outlet.

Standard No. 370948 foot switch **must not be** used on any circuit higher than 120 volt. For higher-voltage current, such as 220 or 440 volt, special No. 370949 foot switch assembly is required.

Test operation of Model 525 Setter by hand before firing, and actual saw setting. To test, remove the cam cover and rotate the cam by hand counterclockwise, making sure the hammers operate freely.

OPERATION AND MAINTENANCE: The Model 525 Foley Setter has identically the same operating mechanism as the Model 52 Setter. Detailed instructions on operation and maintenance, contained in this manual, apply equally to both models.

Read Paragraphs #1 through #7

The following is a "short course" of instructions for the use of your Power Setter. If you should experience any difficulty in operating the machine, read detailed instructions, Paragraphs #8 through #40.

Adjustment for Different Point Saws -

The knob at the right side of the machine is used for making the feed spacing adjustment which is required when setting saws of different points. This knob has numbers etched in it denoting points per inch. Turn this knob in the direction required until the range of numbers which appear through the rectangular window agrees with the saw which you desire to set.

Direction of First Setting Blow -

At the top of the machine there is a hole through which a pin will be easily visible when the hammers are up. If visible, the first blow will be downward; if not visible, the first blow will be up.

Adjustment for Amount of Set -

At the left of the machine there is a knurled wheel which has its outer edge above the top of the saw guide. The amount of resulting set is dependent upon the amount the saw teeth overhang the anvils. To increase the overhang, or amount of set, turn the knurled wheel clockwise; to decrease, turn counter-clockwise. It is suggested that about 2/3 of the saw tooth overhang the anvils when setting an 8-point saw. A greater portion should overhang with finer point saws and a less portion with coarser point saws.

Clamping of Saw between Anvils -

At the top of the machine is a knurled knob called the Anvil Lock Knob. If the knob is turned counter-clockwise it will raise the top anvil. Turn the knob counter-clockwise and insert the handle end of the saw between the anvils so that the tip of the feed pawl is against the first tooth to be set. Choose this first tooth to agree with the first setting blow. See Section titled "Direction of First Setting Blow". Release the knob. It is not necessary to turn this knob clockwise as a spring in the mechanism will clamp the saw between the anvils at the proper tension.

Operating Machine -

With the saw clamped between the anvils, the adjustment for different point saws, and the adjustment for the amount of set being made, your machine is now ready to be operated. Hold the saw against the saw guide, but do not push it toward the left tending to aid the work of the feed pawl. Depress the foot switch and continue to exert a light pressure on the saw against the saw guide.

OPERATING INSTRUCTIONS FOR FOLEY AUTOMATIC POWER SETTER

(Refer to Exploded-View Drawing in Parts Price List for parts identification)

1. EXAMINE SHIPMENT: Carefully inspect machine for in-transit damage. Look particularly for cracked castings, loose bolts, bent or broken parts. Any loss or damage should be reported to the freight agent immediately. Secure the freight agent's notation of loss or damage on the freight bill. Traffic regulations require the transportation company to stand cost of repair or replacement.

2. REPAIR OR REPLACEMENT OF DAMAGED SHIPMENT: You may elect to file your own claim against the transportation company. In case of damage to easily-replaced parts, order and pay for the new parts needed; enter your claim, for their value, against the delivering carrier. Return entire machine to Minneapolis, for complete rebuilding, only in case of serious damage.

3. Alternatively, you may ask the factory to repair or replace without cost to you. In this case, the following papers must be sent to Minneapolis, so parts replacement may be made and so all charges may be assessed against the transportation company:

   (a) Itemized report showing nature and extent of damage. See Exploded-View Drawing for parts identification.

   (b) Paid freight bill, bearing agent's notation of damage.

   (c) Original bill of lading, and invoice (if available).

4. Do not return machine to Minneapolis -- unless damage appears so serious and extensive that factory rebuilding is required. This is seldom necessary.

5. MOUNTING INSTRUCTIONS: Place Setter on well-constructed bench of convenient height. A bench height of 32" to 36" is recommended, depending upon height of operator. Bench space occupied by machine is $14\frac{1}{2}$" x 8". Allow sufficient room on each side of Setter for saw to extend.

   Model 525 Setter: See following Yellow page for detailed set-up and assembly instructions.

   Model 52 Setter: Three easily-accessible holes are located in bottom of base casting 352032. Insert wood screws or machine screws and nuts to secure Setter to bench. Machine should be positioned so front of base casting is flush with front edge of bench.

   A wedge-shaped wooden block was inserted under motor prior to shipment, as protection against damage in transit. Remove the wooden block from under motor before operating machine.

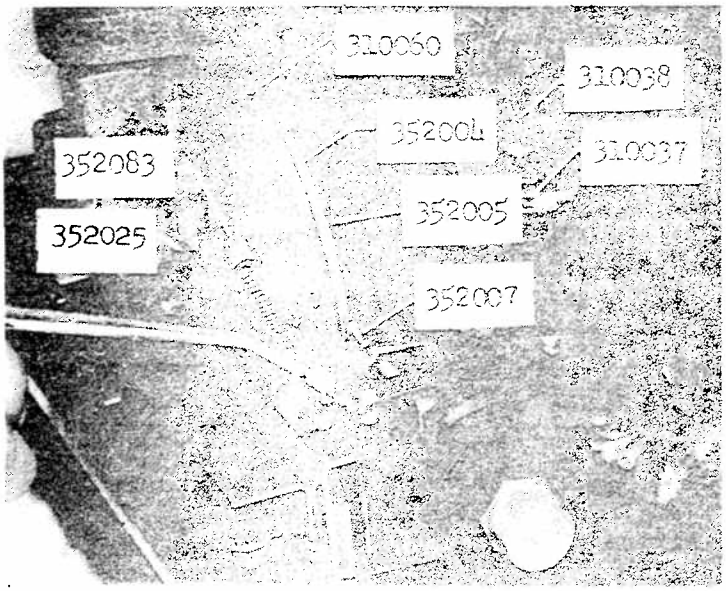


Figure 1

6. ASSEMBLY OF ELECTRICAL PARTS:

Follow directions given under the heading "Connect Motor And Foot Switch" on Green instruction sheet.

7. LUBRICATION: The Foley Setter has been properly lubricated before leaving factory. To keep machine running smoothly and without undue wear, follow lubrication schedule as outlined below.

(a). A heavy grease should be applied to the motor worm 310038 and the worm gear 310037 about once a week.

(b). Apply a few drops of S.A.E. 20 oil daily to the cam follower rollers 310060, hammer cam 352004, to the feed cam 352005, and spring pivot arm 352083, along both sides of the V-shaped hammer slide 352025, the feed plunger 352007, slots on left side of 352048 saw guide, and any other surface where a rubbing or rolling contact occurs.

8. Mechanically your Foley Power Setter is now ready to operate, except for feed and depth-of-set adjustments. Detailed instructions concerning these steps are given immediately after the following discussion of how to measure saw teeth.

9. DIFFERENCE BETWEEN POINTS-PER-INCH and TEETH-PER-INCH: The standard measurement of saw teeth is points to the inch. There is always one more point to the inch than there are full teeth. For example, an 8-point saw has 8 points to the inch (counting the eighth point at the end of inch). However, there are only 7 full teeth in a one-inch spacing. They consist of 6 full teeth, plus two half teeth -- making a total of 7 teeth to the inch on an 8-point saw.

This difference between points-per-inch and teeth-per-inch should be borne in mind, when operating Setter, for this reason: Markings on the feed indicator knob are points-per-inch, NOT teeth-per-inch.

10. FEED SPACING ADJUSTMENT (Refer to Figure 2): The Feed Indicator Knob adjusts the feeding mechanism automatically to take any desired number of points per inch from 4 to 16. Adjustment is made by turning this knob 352065 until the desired number of points per inch appears through window of Feed Indicator Lock Spring 352064. The feed indicator is located at right-hand side of Setter as you face it.

11. FEED INDICATOR: The Feed Indicator is graduated into eight stations, marked as follows:

4	-	4½
5	-	5½
6		
7		
8		
9	-	10
11	-	14
15	-	16

These stations indicate the range of saw tooth sizes in points per inch. As the feed indicator is turned for different sizes of teeth, the Knob 352065 will come to rest on different stations. Turn the knob to the right and then to the left, to familiarize yourself with its operation.

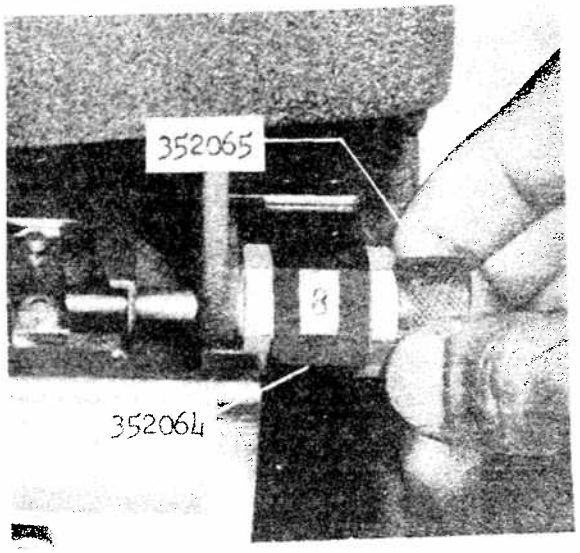


Figure 2

12. EXAMPLE (FEED SPACING ADJUSTMENT): To make proper feed adjustment for a 9-point or 10-point saw, turn Feed Indicator Knob until the station marked "9 - 10" appears through window of Lock Spring. With this adjustment, the pawl will automatically feed the saw through the Setter, one tooth at a time, any 9-point or 10-point saw.

Similarly to set a 7-point saw, turn Indicator until station "7" appears through window. To set an 11, 12, 13 or 14 point saw, turn Indicator to station "11 - 14".

13. HOW AMOUNT OF SET IS CONTROLLED: (See Figure 3)

Amount of set is regulated by positioning saw under the hammer such as to allow a greater or smaller portion of each tooth to overhang the anvils.

For a heavy, wide set, Saw Guide 352549 will be adjusted to allow a greater portion of the tooth to be struck.

For a lesser amount of set, Saw Guide is moved toward you, thus reducing the portion of the tooth which is struck.

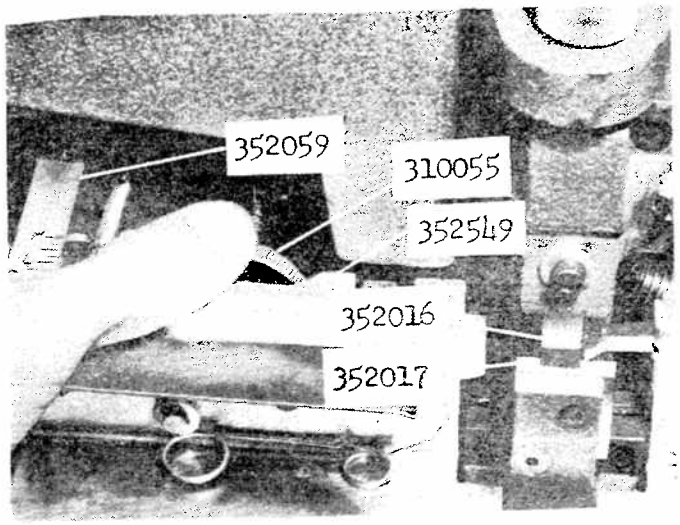


Figure 3

14. ADJUST SAW GUIDE TO REGULATE AMOUNT OF SET: To adjust Saw Guide, first turn Anvil Lock Knob 352068 counter-clockwise to raise Anvil 352016. (Blade cannot be inserted until Anvil has been raised.) Then insert saw between the 352016 and 352017 Anvils.

Release anvil lock knob, and rotate Knurled Wheel 310055 until the desired amount of tooth projects beyond anvil. Clockwise rotation of wheel moves saw guide IN, and counter-clockwise rotation moves it OUT. In positioning saw for correct amount of set, be sure toothed edge is held firmly against upright part of saw guide its entire length.

While learning to operate the machine, insert teeth of practice saw to varying depths. Note how depth of tooth extension over anvil can be decreased or increased, by turning Wheel 310055 IN or OUT. A careful visual check, of the amount that tooth extends over anvil is suggested while you are becoming familiar with Setter.

15. DEPTH-OF-SET GAUGE: A Depth-of-Set Gauge 352059 is mounted at extreme left-hand side of saw guide. The letter "H" indicates direction in which saw guide should be adjusted for a heavy set. Letter "L" indicates direction for a light set.

After operator is thoroughly familiar with machine, Gauge 352059 may be used as a reference for obtaining desired amount of set -- taking the place of visual inspection of tooth overhang.

16. AMOUNT THAT TOOTH SHOULD EXTEND OVER ANVIL: For finishing saws, let slightly more than 1/16-inch of the tooth overhang the anvils. For roughing saws or saws intended for use on green lumber, somewhat more set should be allowed.

17. HAMMER BLOW: There is no adjustment required in the spring which delivers the power to hammer stroke. The spring mounting and tension remains constant regardless of the amount of set desired.

18. SELECT THE FIRST TOOTH TO BE SET: There are two distinct and separate things to be considered when selecting the first tooth to be set.

(a) Determining the direction of the first hammer blow.

(b) Selecting a starting tooth which will be set in the same direction as the first hammer blow.

A detailed discussion of both of these points is contained in the following paragraphs.

19. INDICATOR SHOWS DIRECTION OF HAMMER BLOW (See Figure 4): The hammers that do the tooth setting travel up and down. The machine may stop on either the upward or downward cycle. Each time the Setter is to be used, the operator must note in which direction the first setting blow will be; whether UP or DO

Travel direction is shown by Directional Indicator R841125.

When Directional Indicator R841125 is easily visible, the first hammer blow will be DOWN.

When Directional Indicator is NOT visible, the first hammer blow will be UP.

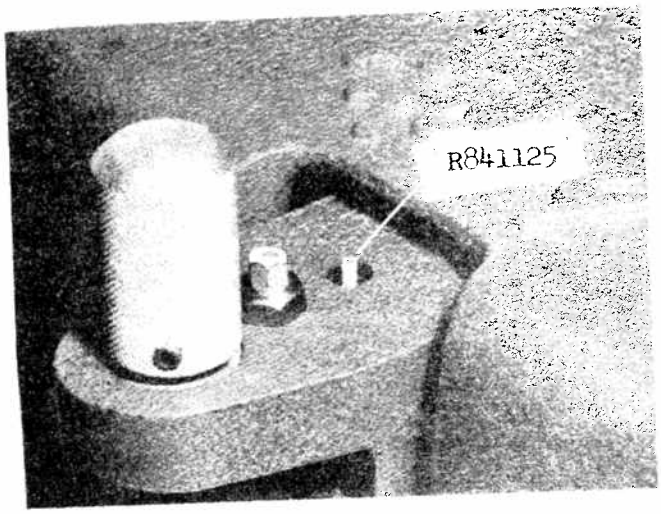


Figure 4

20. CHOOSING THE FIRST TOOTH TO BE SET: To correctly select the starting tooth, it is necessary to consider each saw individually. For this purpose, all saws may be divided into three groups, as follows:

(a). RIP SAWS WITH NO PRIOR SET: On a rip saw with no prior set, you may start with any tooth. No consideration need be given to which direction the first hammer blow will go, or to which way the starting tooth will be set.

(b). SAWS WITH PRIOR SET (either rip or crosscut): On any saw that has ever been set previously, you must set the teeth in the same direction as the previous set. Set must never be reversed or tooth breakage will result. Teeth which have once been set downward must always be set downward. It is very important to start out right, setting tooth in the proper direction.

(c). CROSSCUT SAWS WITH NO PRIOR SET: On a crosscut saw having no prior set, tooth bevel determines the correct direction of set for each tooth.

On a crosscut saw, one side of tooth is lower than the other. The high side must always be set to the outside, away from the center of saw. In other words, teeth on which the beveled edge is visible to the operator must be set downward.

21. NOTE REGARDING OLD SAWS: Even though most of the original set has been worn away, so the set cannot easily be seen after the saw has been jointed and filed, traces of it may remain. To insure remembering in which direction each tooth should be set, mark teeth with crayon before filing is started. Otherwise, direction of set may be reversed unknowingly, causing tooth breakage.

22. MATCH THE TOOTH SELECTION TO DIRECTION OF HAMMER BLOW: If Directional Indicator shows that the first hammer blow will be downward, select a starting tooth that should be set downward, as determined by the bevel or the prior set.

If Directional Indicator shows that first hammer blow will be upward, start with a tooth that should be set upward. (See Paragraph 19).

23. START AT HANDLE END OF SAW: Handle end of saw should be inserted between the anvils 352016 and 352017, so that Feed Pawl engages the first tooth to be set.

It is suggested that a new operator skip the first few teeth; start about 1½" from end of saw, in order that saw will span the gap at center of saw guide. Starting at 1½" from handle end of blade is not objectionable because the saw handle makes the last three or four inches unusable.

24. INSERTING AND CLAMPING SAW: To open anvil jaws, so toothed edge of saw may be inserted, turn Anvil Lock Knob 352068 counter-clockwise. This raises anvil 352016; blade cannot be inserted until anvil has been raised.

25. ANVIL LOCK KNOB 352068 is spring-loaded, to grip saw with correct tension. Its operation is entirely automatic, and no adjustment is required. After saw has been inserted between anvils by turning lock knob counter-clockwise, merely release the knob. Automatically it returns to position of correct tension.

26. BADLY RUSTED OR PITTED SAW BLADE: Before being retoothed, filed or set, a badly rusted saw should be dressed to reasonable smoothness by the use of steel wool or fine emery cloth.

27. FIT FIRST TOOTH AGAINST FEED PAWL: Section 23, above, directed that saw blade be inserted between anvils SO THAT FEED PAWL ENGAGES THE FIRST TOOTH TO BE SET.

The tooth that is fitted against the tip, or just a little to the left of the feed pawl will receive the first setting blow, when Setter is started.

28. GETTING READY TO OPERATE (REVIEW):

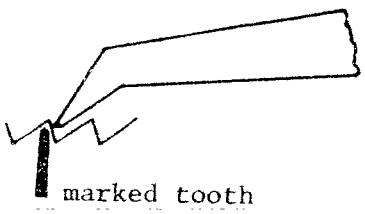
(a). Look at Directional Indicator on Setter (See Section 19). Note whether next setting blow will be UP or DOWN.

(b). If first setting blow will be UP, select a starting tooth which should be set UP. (See Section 20).

If first setting blow will be DOWN, select a starting tooth which should be set DOWN.

(c). Mark this starting tooth with crayon, so it can be identified easily.

(d). Place saw blade between anvils so the feed pawl engages this crayon-marked tooth.



29. CLEARANCE FOR SAW HANDLE: It is not necessary to remove handles from hand saws. Setting of all carpenters' hand saws may be done with the saw handles left in place.

However, on some saws, the handle will not clear the left-hand Saw Rest 352055, **when this saw rest is in its normal (UP) position. Because that is** so, provision is made for depressing the left-hand saw rest momentarily, where required for passage of saw handle. For details, see Section 30.

30. HOW TO DEPRESS LEFT-HAND SAW REST 352055: (See Figure 5).

Normal position of left-hand saw rest 352055 **is UP, level** with the stationary right-hand rest on the 352048 **saw guide.** After being lowered to allow **passage of saw handle, it snaps back to the normal UP position when tab on 352053 Saw Rest Latch is pressed.**

To DEPRESS left-hand saw rest, force it down and to the left with light finger-pressure. It locks and holds the lower position automatically.

To RELEASE, press tab on 352053 Saw Rest Latch.

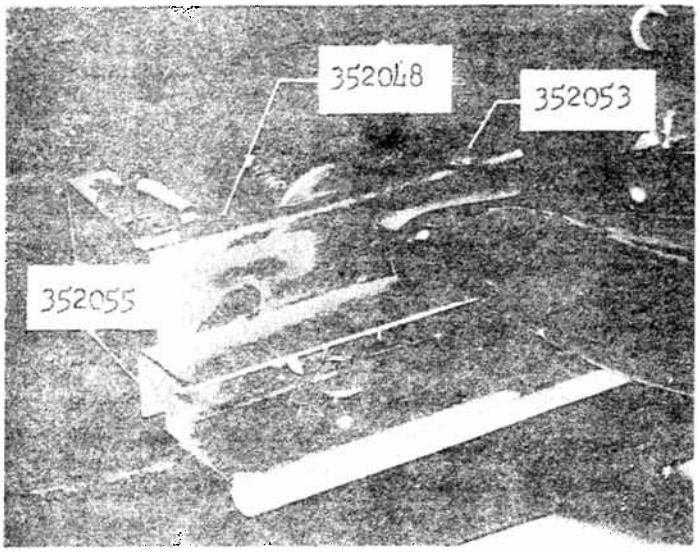


Figure 5

It is suggested that the operator become thoroughly familiar with the working of this left-hand saw rest assembly, before attempting to set his first saw.

31. OPERATING THE SETTER: Actual operation of the Foley Power Setter is extremely simple -- once the machine has been properly adjusted and the saw has been inserted correctly.

Hold the saw IN against the back of Saw Guide 352048, but do not apply any force or forward motion in the direction of feed.

Start the machine by stepping on foot switch. Continue to exert a light pressure of saw against the saw guide. Saw will feed through Setter automatically. Alternate teeth are spread uniformly in opposite directions -- ONCE THROUGH AND THE SAW IS SET!

32. CAUTION: Allow the feed pawl to do all the work of moving saw ahead. Hand pressure forward, in the direction of feed, must be avoided.

A new operator may be tempted to "help the feed pawl", subconsciously exerting a forward pressure. Such operation is incorrect and will cause skipping of teeth or tooth breakage.

To repeat, these precautions are most important and must be observed:

(a) Hold saw IN against the saw guide (or towards back of Setter) all during the setting operation.

It will be found that little inward pressure is needed to keep the blade against back of guide. Pressure of one or two fingers is sufficient.

Take care to keep toothed edge of saw held in evenly against the back guide, so saw teeth are touching the guide on both sides of the hammer at all times.

(b) Let the pawl do all the work of moving saw ahead.

Do not attempt to hand feed the saw. TOOTH BREAKAGE WILL RESULT if forward pressure is exerted by the operator. Forcing the saw forward by hand, instead of allowing pawl to feed saw uniformly, will cause skipping of teeth, reversing of set and tooth breakage.

To guard against forcing saw ahead manually: Use just a two-finger pressure, against back of saw blade, when holding saw IN against Saw Guide.

(c) Grasp and hold the saw correctly:

Grasp the saw with both hands, the left hand at the handle end and the right hand in the center of the saw. If you have the saw in the carrier, grasp the left hanger in the left hand and the center hanger with the right hand. Feed the saw through until the right hand is in line with the hammers.

Stop by releasing the foot switch, leave the saw in position, gripped between the anvil jaws so the correct feed will continue when the setter is started again. DO NOT MOVE SAW.

Release the hands from the saw or hangers, then grasp the center of the saw or the center hanger with the left hand and the right hand on the point of the saw or the end hanger. Proceed to set the rest of the saw. The shifting of these positions insures the operator holding the saw in at all times.

If the operator stands stationary and grasps the saw with both hands, one at each end of the saw, his "reach" is not long enough to keep the saw held in during the full length of its travel through the setter. RESULT: Unavoidably, the saw creeps out, causing misfeed and tooth breakage.

If the foot switch is set on the floor a little to the left of the center of the setter and you depress it with the left foot you have a better balance when setting the saw. Also stand about the center of the setter.

33. SET UP FOR BAND SAWS (Refer to Figure 6):

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 352048 has two Band Saw Clips 352046-352047 attached. To place band saw in Setter, first adjust feed travel and width of set as outlined in earlier sections.

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.

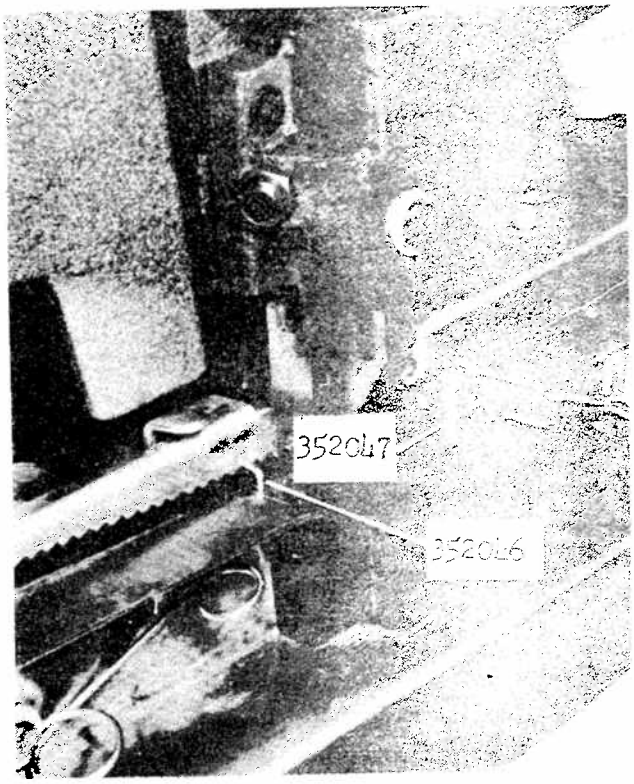


Figure 6

34. WATCH FOR BRAZED OR WELDED JOINTS IN BAND SAW BLADE: Use a crayon to mark all joints, so they are easily located. Avoid passing any brazed or welded joints through Setter anvils while anvil jaws are tightly closed on saw.

As each welded or brazed joint is about to pass through anvils, STOP THE SETTER. Turn Anvil Lock Knob 352068 counter-clockwise. This raises anvil 352016 so joint may be hand fed past the anvil surface. Setting of the one, two or three teeth that occur at the joint is not required. By-pass them.

After brazed joint has been passed through anvils, release the Lock Knob. It automatically returns to tension position. Continue with setting operation.

35. CAUTION CONCERNING BRAZED OR WELDED JOINTS:

(a). Setter must be STOPPED at each joint. It is not sufficient merely to open anvil jaws, by turning Anvil Lock Knob, while Setter mechanism is in operation. To do so may cause breakage of 352[illegible] Anvil & Stud Assembly.

(b). After stopping Setter and after hand feeding saw past the joint, re-clamp saw in such position that next tooth will be set in the proper direction. (See Section 22). Take care not to reverse the set on following teeth.

(c). You may encounter bands that have been inexpertly brazed or welded. At the joint, there may be a half tooth instead of a continuous line of uniform, full-sized teeth. Or, there may be two teeth set in the same direction on both sides of the joint. These occurrences make it essential that you STOP at each joint, then recheck both the FEED and the DIRECTION OF NEXT HAMMER BLOW, before resuming with automatic setting after passing a joint.

GENERAL OPERATING SUGGESTIONS

36. OPERATE WITH COVER OPEN OR CLOSED: The Foley Power Setter should be operated with the cover closed as a safety measure.

37. HAND SAW CARRIERS: It is not necessary for carpenters' hand saws to be mounted on a Hand Saw Carrier.

However, such saws may be set while still mounted on Carriers used when filing with Foley Automatic Saw Filers or when retoothing with Foley Power Retoothers. (See Section 38).

38. WHEN TO DO THE SETTING: It is recommended that saws be set just previous to the last filing operation.

Most tooth breakage can be traced to the fact that the saw is hard, or has hard spots; that the operator attempts too much set; or to setting immediately after retoothing -- before the first file pass has been made.

In each of these cases, setting the saw immediately before the last filing pass will reduce tooth breakage to a minimum. The Foley Automatic Power Setter is made such that a hand saw may be set while it is mounted on standard Foley Hand Saw Carriers. Thus, no additional "set-up" is required and no time loss results from operating in this recommended sequence.

If material in a saw blade is soft enough so tooth breakage is not likely to result, machine may be used to set such a saw immediately after retoothing, without any previous filing.

RIP Saws must always be filed or finish-filed after teeth have been set.

Due to the hammer-anvil design of Foley Setter, hammer blows cannot dull the sharpened surfaces or mash saw tooth points.

39. REMOVE FILING BURR BEFORE SETTING: A filing burr on saw teeth may cause an unequal set, with teeth spread more on one side than on the other. Uneven set resulting from this cause can be averted by following either of these precautions:

(a). Avoid throwing a burr on side of saw, during filing operation, by taking light filing strokes (with light file pressure).

(b). Remove any filing burr there may be, by side-dressing the saw, before proceding with setting. Pass a flat file or oil stone lengthwise down each side of toothed edge, proceding from handle end to toe of saw.

40. REPAIR AND ADJUSTMENT: Your Foley Automatic Power Setter was accurately adjusted at the factory, and was thoroughly tested in the actual setting of saws before being shipped.

Being a precision machine, it should not be tampered with, unless repair or readjustment is absolutely necessary.

Before attempting any change in adjustment, please read carefully the REPAIR AND MAINTENANCE instructions contained in the following sheets.

Bear in mind that your Foley Power Setter was test-operated prior to shipment, and was passed as being in perfect adjustment. Barring accidental loss of correct adjustment in transit, no readjustment of new factory-inspected machine should be required. For this reason, incorrect operation rather than mechanical failure should be suspected in the event that perfect results are not obtained on the first practice saw.

41. Special memo regarding UNEVEN SET: Factory inspection prior to shipment includes a careful check of hammer travel, to make sure that teeth will be spread an equal amount on each side of saw. Consequently, no re-adjustment should be required before the Setter is placed into service. The most likely causes of uneven set, produced by a new factory-adjusted machine, are:

A filing burr on one side of saw (See Section 39).

Teeth of unequal height (low on one side of saw and high on the other) -- a condition which should be remedied by jointing and filing to uniform size. Unless corrected, the high teeth on one side of saw will overhang the anvil further and consequently will be set more, even though the Setter hammer travel is in balance.

Any unequal set that is actually traceable to the Setter itself can easily be eliminated. See instructions under the heading "EQUALIZING SET", on page 16.

SERVICE INSTRUCTIONS

FOLEY AUTOMATIC POWER SETTER

I. ADJUSTING OF FEED MECHANISM

There are two adjustments on the feed mechanism of the Power Setter which must be properly made to assure a good set on a saw.

The first of these adjustments is for properly positioning each tooth for the hammer blow. Two indications of this adjustment being incorrect are uneven set and the hammer striking the tooth at some position other than at the point. The latter is more evident when setting a fine point saw.

The second adjustment of the feed mechanism controls the amount of back travel of the Feed Pawl. An indication of this being out of adjustment is the skipping of teeth while setting a saw. To properly make these adjustments, the following steps must be taken:

(1) Disconnect the power cord so the machine will not be accidentally turned on.

(2) Rotate the cam assembly by hand to the position shown in Figure 7 so that the 352007 plunger is against the highest point on the lobe of the 352005 feed cam.

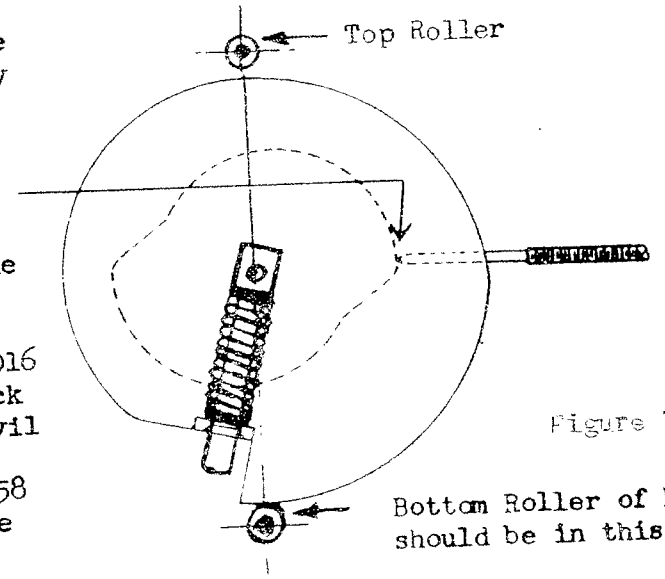


Figure 7

(3) Raise the adjustable anvil 352016 by turning the 352068 anvil lock knob counterclockwise. The anvil must be raised far enough to place the bent tab "B" of 352058 feed mechanism adjustment gauge between the two anvils.

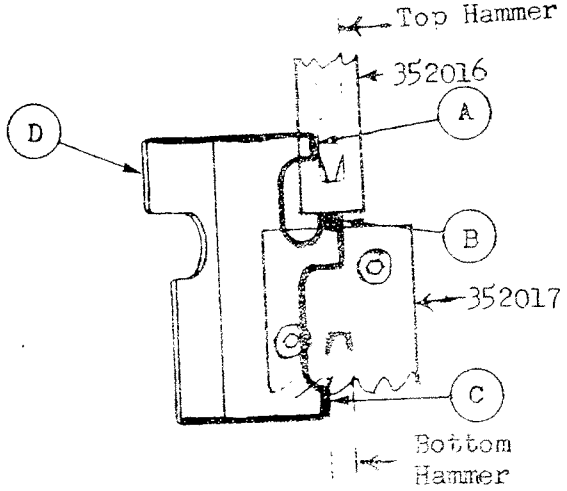


Figure 8

(4) Place gauge on end behind the two anvils 352016 and 352017 so front of gauge is flush against the back side of anvils, with edges "A" and "C" of gauge (see sketch) are against two hammers of hammerslide 352025. Then turn the anvil lock knob clockwise until upper anvil rests very firmly on Tab "B" of gauge. See Figure 9.

(5) When adjusting feed mechanism for Model 525 Setter, loosen motor mounting bolts and slide the motor to one side so gears do not mesh.

(6) Remove the feed indicator knob 352065 complete with the 352066 feed spacing nut by turning it counter-clockwise until it is removed from the machine.

Also Refer to Fig. #9 & #10

(7) Now check position of the feed pawl, see Figure 10. It may be too close to Tab "B" and the adjusting guage may rock, or there may be a space between Tab "B" and the feed pawl. If either of these conditions exist, then adjustment of feed pawl is necessary. Loosen the two C130224 set screws and remove the feed spacing nut 352066 from the 352065 feed indicator knob. Remove any burrs caused by set screws on spacing nut.

(8) With two wrenches, hold the 352067 feed spacing screw from turning while loosening the J312100 hex nut. Back off the J312100 hex nut five or six turns. (See Figure 9A).

(9) By hand, turn the 352067 screw, causing the 352007 plunger to turn until the tip of the 352011 feed pawl has been brought up against the tab of the 352058 feed mechanism adjustment gauge. (See Figures 9 and 10).

(10) Hold the 352067 screw from turning and tighten the J312100 nut. Remove the gauge from meachine.

Figure 9

(11) Place the long tab of the 352058 gauge (indicated as "D" in Figure 8) so that the wide flat part of the gauge lies on the 352007 plunger between the mounting plate 352010 and 352067 feed spacing screw. With the 352058 gauge against the 352010 mounting plate, there should be up to 1/32" space between the gauge and the feed spacing screws. See Figure 11. If the space is less than 1/32", loosen the C310460 socket set screw enough to permit the feed spacing screw to be backed off until the C310460 socket set screw is again tightened in place.

(12) Remove the gauge and replace spacing nut "B" on the 352067 feed spacing screw.

(13) Place the long tab of the 352058 gauge (indicated as "D" in Figure 8) so the thinnest part of the gauge is between the mounting plate 352010 and the 352066 feed spacing nut. See Figure 12. Rotate the feed spacing nut until it just touches the thinnest part of Tab "D". Slip the feed indicator knob over the feed spacing nut with feed range 15 and 16 appearing in window of the 352064 feed indicator lock spring.

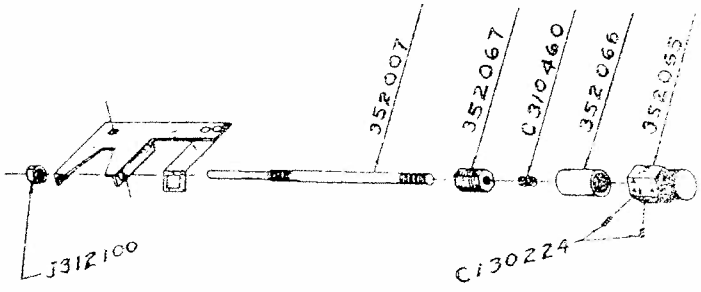


Figure 9A

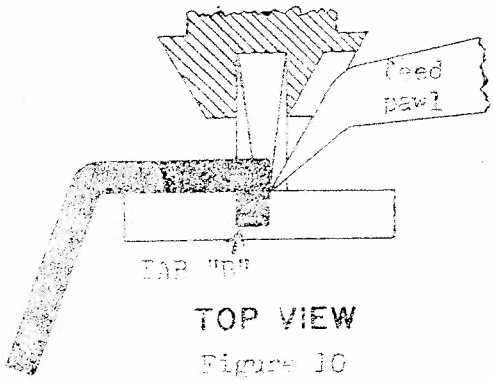


Figure 10

NOTE: If it is found that the machine skips teeth but the hammer strikes the teeth of the saw properly, it will only be necessary to follow steps 1, 2 and 9, 10 and 11.

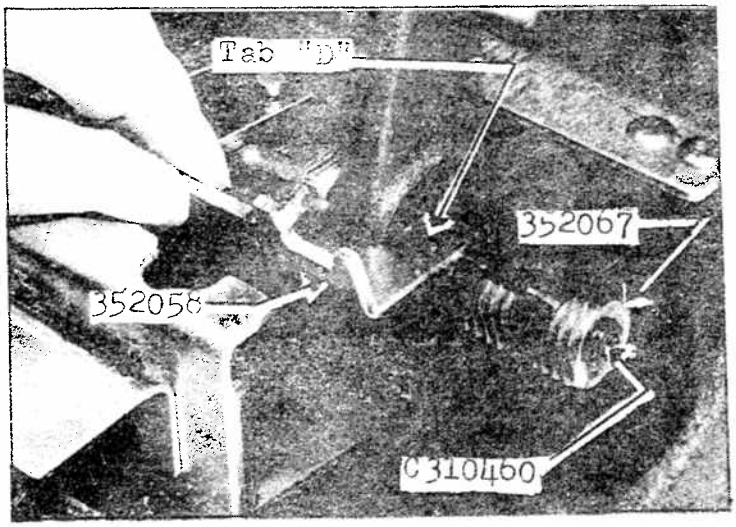


Figure 11

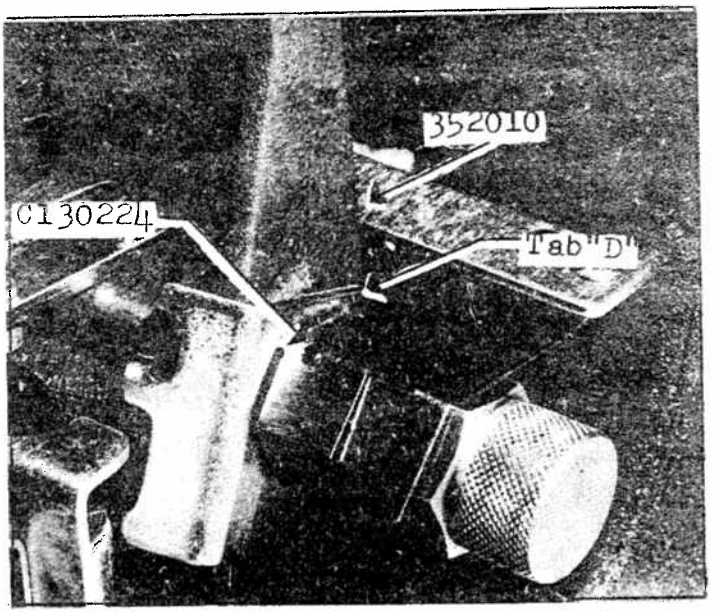


Figure 12

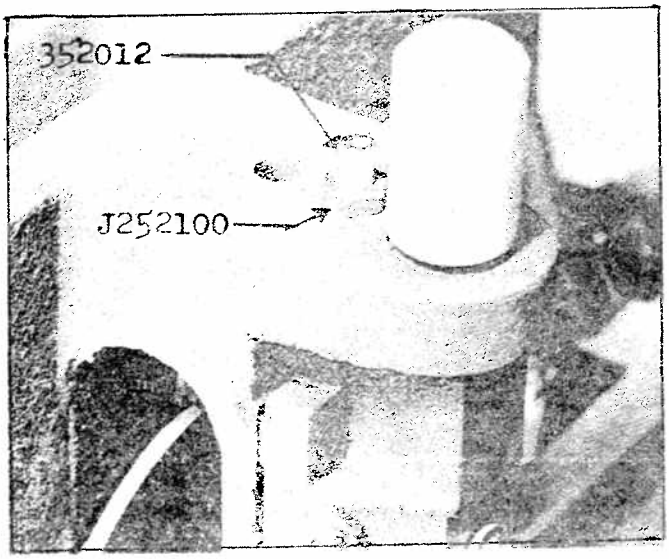


Figure 13

EQUALIZING SET

Should you find after continued use of your machine that there is consistently more set on one side of the saw than on the other, it can be evened up by adjustment of the 352012 screw located at the top of the machine.

Downward blow needs no adjustment, it is automatically controlled by the step on the upper adjustable anvil and step on upper hammer.

If there is more set on the upward side of the saw, the following steps should be taken. Using two wrenches, loosen the J252100 lock nut and turn in the 352012 set equalizer screw. See Figure 13.

Just 1/12 of one turn in either direction of this screw will adjust the hammer stroke .003 of an inch. This should be the maximum amount of turn at one time and before rechecking to see if the set has been equalized, be sure to tighten the J252100 lock nut before running the machine.

If there is less set on the upward side of the saw, loosen the J252100 lock nut and back off the 352012 set equalizer screw in the same manner as above. Tighten lock nut.

ADJUSTMENT OF GIBS

In the machine, there are four small round gib buttons made of a hardened steel. They are not visible when looking at the assembled machine, but are there for the purpose of guiding the hammerslide. Two of these are in the upper gib support casting 352015 and two are in the lower gib support casting 352014.

These are positioned by the 352013 screws which extend out of the side of the castings at an angle and which have a hex jam nut J252100 on them to hold them securely in place. Adjustment of the gibs should not be necessary until after very long continued use. When the gibs have become worn, it will be found that the hammerslide will move slightly from left to right. To check for wear, place one finger of each hand on the hammerslide and push from right to left. There should be a slight amount of movement, but if it appears that the hammerslide is too loose, the following instructions will be helpful:

1. Disconnect the power cord so the machine will not be accidentally turned on.

2. Disconnect the 352050 spring at the left side of the 352048 saw guide and swing the saw guide out.

3. Rotate the cam assembly by hand until the upper roller of the 352543 hammerslide is just about ready to roll off the step on the 352004 hammer cam, near the bent over lugs, which receive the spring pivot arm. See Figure 7, but in reverse order.

4. Loosen the lock nut J252100 on the 352013 gib adjustment screw at the left side of the upper gib support 352015, by the use of a wrench and one of the Allen Keys furnished with the machine.

5. Holding the cam at this point to prevent further motion of the hammerslide, turn in the gib adjustment screw until there is a definite resistance to further movement of the screw. This locks the hammerslide.

6. Rotate the cam assembly by turning the worm on the motor to the point where the hammerslide just begins to drop.

7. Becuase the gibs are tight, the hammerslide cannot move. Very slowly loosen the gib adjustment screw until the hammerslide moves its ENTIRE stroke. Then lock it in place by tightening the lock nut, using the Allen key to prevent rotation of the screw during this process.

8. Rotate the cam assembly by hand a few times to be certain that the hammerslide moves freely and is not being held by too tight an adjustment.

9. Rotate the cam assembly by hand until the lower roller on the 352543 hammerslide is just about ready to roll off the step on the 352004 hammer cam, near the bent over lugs which receive the spring pivot arm. As shown in Figure 7.

10. Loosen the hex jam nut J252100 on the 352013 gib adjustment screw at the left side of the lower gib support 352014, by the use of a wrench and one of the Allen keys furnished with the machine.

11. Holding the cam at this point to prevent further motion of the hammerslide, turn in the gib adjustment screw until there is a definite resistance to further movement of the screw. This locks the hammerslide.

12. Rotate the cam assembly by hand, turning the worm on the motor to the point where the hammerslide just begins to raise.

13. Because the gibs are tight, the hammerslide cannot move. Very slowly loosen the gib adjustment screw until the hammerslide moves its ENTIRE stroke. Then lock it in place by tightening the lock nut, using the Allen key to prevent rotation of the screw during this process.

14. Rotate the cam assembly by hand a few times to be certain that the hammerslide slides freely and is not being held by too tight an adjustment.

15. Replace the 352050 spring at the left side of the saw guide. Also replace feed pawl spring if it has been disconnected.

ANVIL LOCK MECHANISM

Should it become necessary for any reason to disassemble this mechanism, the following steps must be followed: (See exploded drawing on the back of this booklet for parts identification)

1. Disconnect the power cord so machine will not be accidentally turned on,

2. Remove the locking set screw C190455 in the anvil lock knob 352068 and pull up on the knob to remove it.

3. Using two wrenches, hold the bottom nut J211100 and loosen the top nut. Remove the two nuts and lock washer and the slot spacer 352057.

4. Remove the spring guide 352073, the washer 352075 and turn out the screw 352072.

If it should be necessary to remove the Gib Support and Anvil and Stud Assembly, follow the steps as listed below:

1. Rotate the 352004 cam so the hammerslide will be in the up position.

2. Remove the four B191025 flat head screws holding the 352015 gib support casting to the mounting plate casting.

3. Let the 352070 anvil lock stud slide out the hole through which it passes. The gib casting, anvil and stud will then be removed as a sub-assembly.

4. Remove the two small 352019 gib buttons from the back side of the casting so they will not be lost. It is possible that the gib buttons may be stuck on the hammerslide.

5. Take the 352075 washer and the 352069 tube off the 352070 stud.

To replace the Gib Support and Anvil and Stud Assembly, follow the steps as listed below:

1. Place the 352069 tube and the 352075 washer on the 352070 stud.

2. Place the 352019 gib buttons in the small holes at the ends of the 352013 gib adjustment screws.

3. Place the assembly back on the machine, being careful not to drop the gib buttons. Insert and tighten the four B191025 flat head screws which attach the casting to the mounting plate casting.

To reassemble the anvil lock mechanism, follow the steps as listed below:

1. Screw in the 352072 anvil lock screw, place the 352075 washer on the stud. Turn the anvil lock screw tight -- then back anvil lock screw off 1/8 turn for a little up and down play of adjustable anvil. This play must be maintained about 1/64". Put spring tube with slot up over the adjusting anvil stud and line up slot in tube with slot in stud. Place anvil lock spring over the stud with outside tail at the bottom. The inside tail should rest in slots of both pieces. Insert slot spacer into slot of stud making sure it doesn't rest on inside tail of anvil lock spring. Thread hex nut on stud to full length of thread. Place lock washer over stud and thread on last hex nut. Hold bottom nut with wrench while locking top nut in place.

2. Use a small Allen wrench in hole of anvil lock screw and hold the lock screw in position to prevent turning. Place the anvil lock knob over the stud assembly so tail of the spring enters slot of lock knob.

3. Turn knob counter-clockwise until spring is wound up tightly. Still holding the anvil lock screw in place with Allen wrench, let spring unwind about 1/2 turn until hole in lock knob is in line with a hole in anvil screw. Remove Allen wrench and push the lock knob down. Be sure holes are still lined and thread dog point set screw into lock knob and anvil lock screw. Set screw slot horizontally so snap ring will hold screw in place.

4. Make sure the anvil and stud assembly will move up and down without binding or too much play. If it binds or is too loose, see adjustable anvil and stud assembly, Paragraph #2.

5. Reassemble gib support, anvil and stud assembly following the procedure as outlined on Page 18, Paragraphs 1 through 3.

Adjustable Anvil and Stud Assembly

1. Should this part need to be replaced or repaired, follow the instructions for removal as outlined in Paragraphs 1 through 5 on Page 18.

2. To remove the anvil and stud assembly from the gib support casting 352015, remove the B19063 socket head cap screw, 352020 washer and 352021 tube. Reassemble in reverse order, making sure the anvil and stud are not locked solidly to the casting. If it is too tight or too loose, adjust the small socket set screw C190360 in the back of the adjusting anvil 352016. This should be a smooth fit so it works up and down. The B190631 screw locks against the C190360 set screw when tightened.

3. Should anvil pin 310040 be sheared it can be replaced by using a piece of 1/16" round piano wire or the shank end of a 1/16" drill cut to width of adjusting anvil. Pin should not exceed the width of the anvil as it may bind in slot of gib casting.

GRINDING OF THE TIP OF THE FEED PAWL

After using the Power Setter for quite a long period of time, it will be found that the tip of the 352011 feed pawl which makes contact with the saw may wear so that it no longer has a sharp tip. An indication of serious wear on the tip of the feed pawl is the skipping of teeth. If very carefully observed, it will be found that the tip of the feed pawl is too wide to drop into the gullets of very fine point saws without moving the saw ahead during the feed stroke. To properly resharpen the feed pawl, the following steps MUST be taken:

1. Unhook the 352050 spring at the left side of the saw guide and swing the saw guide out.

2. Unhook the 352050 spring from the end of the feed pawl.

3. Remove the J131100 hex nut from the 352022 shoulder bolt which attaches the feed pawl to the 352006 pivot arm.

4. Unscrew the shoulder bolt from the pivot arm.

5. To sharpen the feed pawl, first grind the tip such that the grinding surface of the wheel is parallel with the length of the feed pawl. (See Figure 14) Do not grind off any more material than is necessary to bring out a sharp corner. Secondly, grind the back side of the tip on the pawl until the width of the tip is slightly less than 1/32 inch. (See Figure 15)

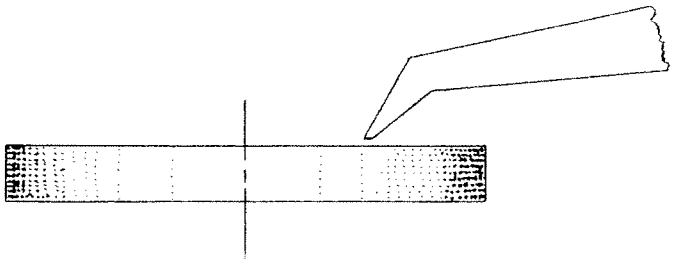


Figure 14

6. Replace feed pawl, shoulder bolt and nut. After tightening the nut, check to be sure the feed pawl does not bind on the pivot arm. If it does, loosen the lock nut and back out the bolt a small amount and then retighten the lock nut.

7. Replace the feed pawl spring.

8. Swing the saw guide into position and replace the spring at the left of the saw guide.

9. IMPORTANT: Because of grinding off the tip of the feed pawl, the feed mechanism must now be adjusted. To properly adjust the feed mechanism, follow the instructions in section entitled, "Instructions for Adjustment of Feed Mechanism". Use the gauge that was furnished with the machine.

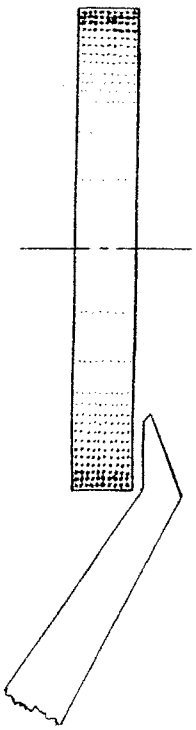


Figure 15

REPLACEMENT OF GEAR TRAIN

To install a new 310037 worm gear DO NOT remove or loosen the bolts and nuts attaching the motor to the mounting plate casting. Instead follow the procedure outlined below:

1. Remove the two C190260 set screws attaching the 310037 gear to the 352029 cam shaft bearing and slide the gear off the shaft. It will be found that there are two set screws in the same hole, one on top of the other. This is merely a means of locking them so they will not loosen in operation.

2. Slide worm gear off shaft.

3. Slide the new gear on over the shaft so that the hole for the set screws in the gear is above the small round depression in the cam shaft.

4. Insert the first set screw and tighten very securely; then insert the second set screw and tighten it also very securely by using one of the Allen keys furnished with the machine.

No adjustment for backlash between the worm and the worm gear will be required provided the motor is not removed nor the bolts attaching the motor to the mounting plate casting are disturbed.

Installation of a new 310038 worm on the motor shaft should be done while the worm gear, as described above, is removed. Do this by driving out the small pin R840050 located between the teeth of the worm with a small diameter punch or nail set. The worm will then slide off the motor shaft and a new one may replace it by reversing the procedure. When this has been completed, install new worm gear by following the procedure outlined above.

INSTRUCTIONS FOR FACTORY REPAIR SERVICE

The Foley Setter is so designed that all parts are readily replaceable in the field. In no instance should factory assembly and adjustment be required.

As parts are required, due to wear or breakage, refer to the exploded view drawing; order by correct part number and name.

Repair or readjustment of machine can be made at the factory on a time and material cost basis.

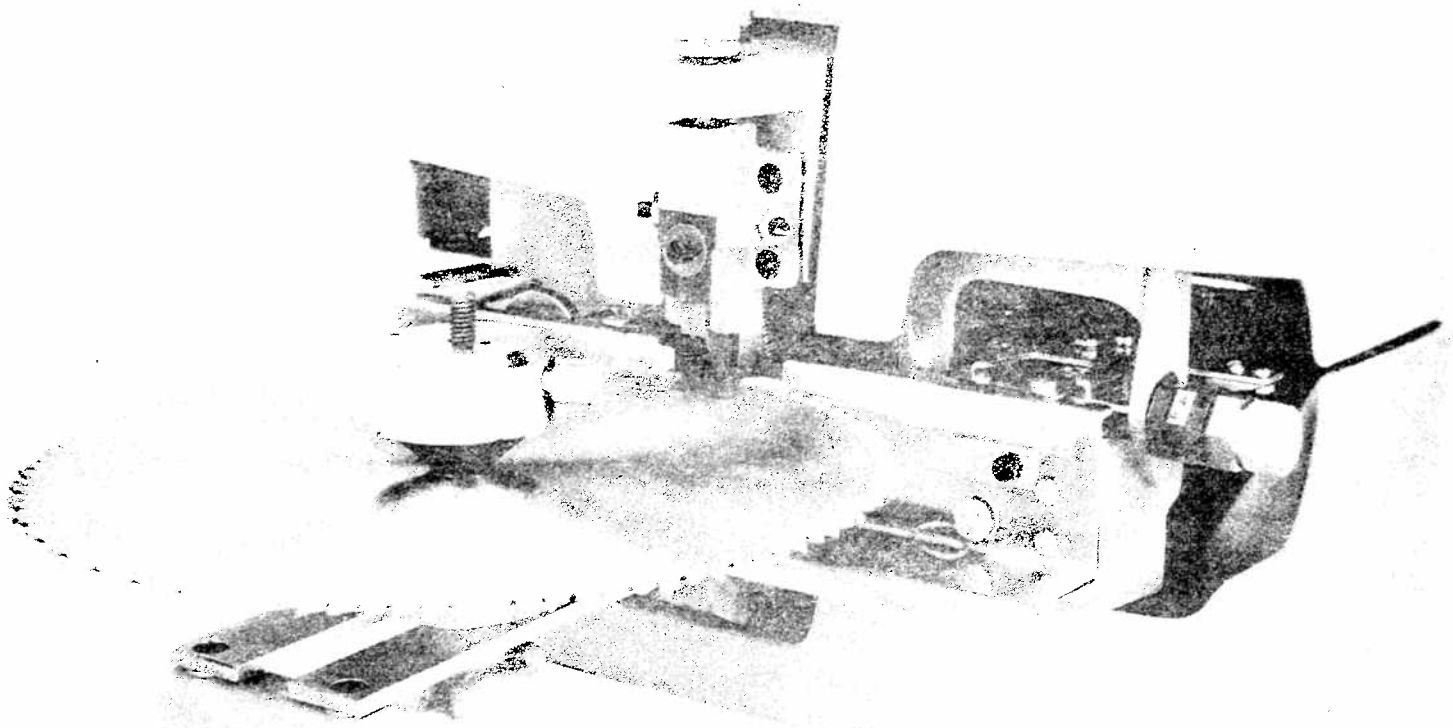
In this event, please follow the procedure outlined below:

1. Ship entire machine to Minneapolis via parcel post freight (do not disassemble or ship a sub-assembly only).

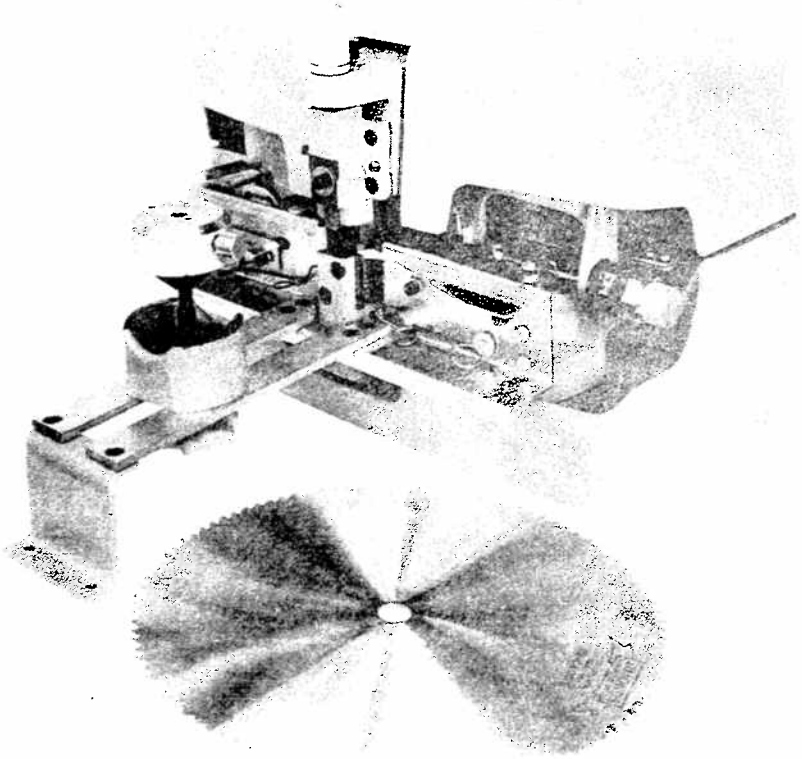
2. Mail to Foley Factory at Minneapolis, the original bill of lading with a notification and letter of instructions.

3. Enclose a $10.00 deposit to apply on repair or rebuilding cost (any over-payment will be refunded; any balance due Foley Manufacturing Company will be collected C.O.D. on return of setter to you.) The requirement of a $10.00 deposit is waived in the case of Governmental Departments, Schools and Industrial Firms that are suitably rated in Dun & Bradstreet. (An official purchase order, covering repair work, is requested).

4. Repairs will be made and the Setter returned by freight collect as quickly as possible.



SPECIAL MODIFICATION
OF FOLEY AUTOMATIC SAW SETTER
TO SET LIGHT-GAUGE CIRCULAR SAWS 3¼" TO 12" IN DIAMETER *AUTOMATICALLY*



Now at low cost, the Foley Automatic Power Setter can be equipped to handle light-gauge circular saw blades — in addition to hand saws and band saws.

The No. 352575 Circular Saw Attachment, which mounts on machine front as pictured above, does not interfere with hand and band saw setting. Circular saw capacity is 3½" to 12" diameter, up to .062" or 16 gauge thickness, on blades having evenly-spaced teeth, 4 to 16 points per inch. Takes ½" to 1⅛" arbor holes.

This adaptation makes Model 52 and Model 525 Setters ideal for fast and accurate setting of formica, thin plywood, and meat scribe saws. Both sides are set automatically at 360 teeth per minute.

NOTE: Foley Automatic Power Setters cannot be used on extremely heavy gauge saws — those thicker than .062" or 16 gauge — nor on combination blades which do not have evenly spaced teeth. The machine recommended for such saws is the Foley Model 359 Setter, hand lever type with trip hammer design.

NEW REDUCED RATES

No. 35202-G — Model 52 Power Setter including built-in motor, and with Circular Saw Attachment.

No. 35206-G — Model 525 Setter, less motor; with Circular Saw Attachment.

CIRCULAR SAW ATTACHMENT ONLY

No. 352575 — Circular Saw Attachment, including a new Saw Table that is drilled and fitted to accept the saw holding assembly.

No. 352950 — Circular Saw Attachment, alone, for later Setters built with Saw Table having 4 drilled holes, ready to receive the saw holding assembly.

FOLEY MANUFACTURING COMPANY, 3300 FIFTH ST. N.E., MINNEAPOLIS, MINNESOTA 55418 — **PHONE 789-8831, AREA CODE 612**

Printed in U.S.A.

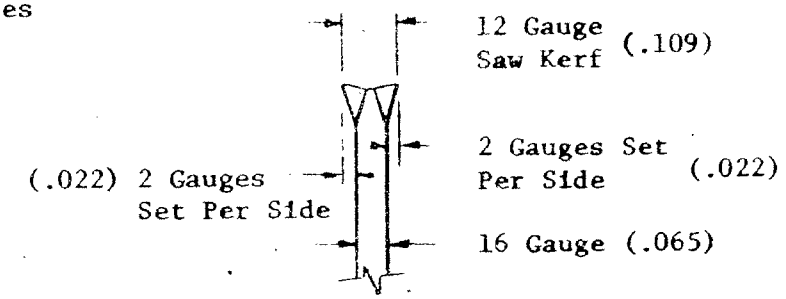
AMOUNT OF SET can be varied to extent desired by changing amount of saw tooth that hangs over beveled portion of anvil. The more overhang, the more set. Saw manufacturers recommend generally a set per side of 10/1000" to 15/1000" for dry hard wood and slightly more for soft wood and heavier saws.

Recommended Set On Each Side Of A Circular Saw. Courtesy of SIMONDS SAW & STEEL CO.

FOR DRY SOFT WOOD - 2 gauge set on each side of saw.
FOR GREEN SOFT WOOD - 2-1/2 gauges set on each side of saw.

Hard wood requires slightly less set than soft wood. On saws for Electric Hand Saw Machines, on account of the rough work they do, we recommend 2-1/2 gauges set on side of saw.

Example of Setting a Saw for Dry Soft Wood:
If the saw is 16 gauge (.065), 2 gauges set per side would make saw kerf 12 gauge (.109)
.109 - .065 .044 Set Both Sides
$\frac{.044}{2}$ - .022 set per side

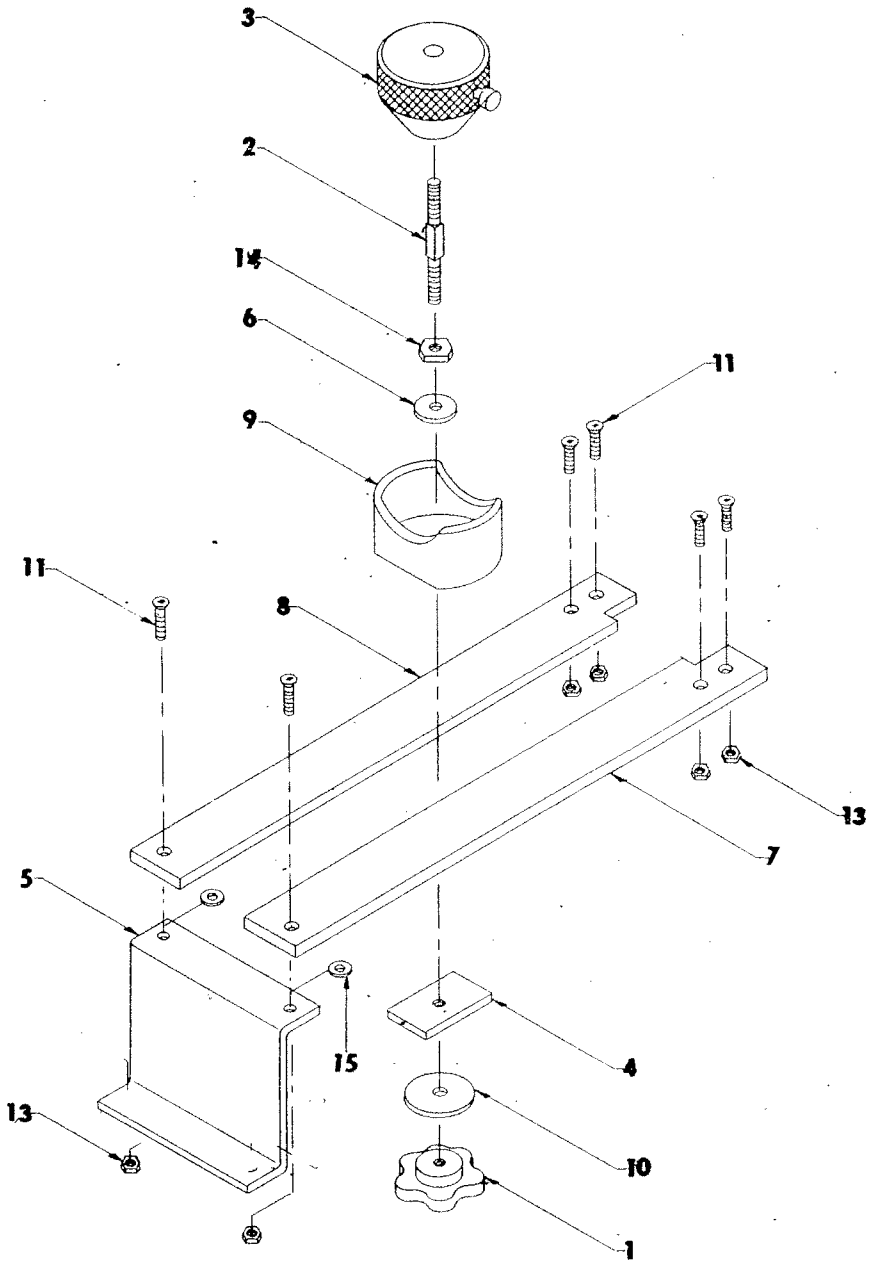


Thickness of Saw	Dry Wood Set Per Side	With 2 Gauges Set Per Side Saw Kerf Will Be	With 2-1/2 Gauges Set Per Side Saw Kerf Will Be	Wet Wood Set Per Side
10 Ga. (.134)	.035	6 Ga. (.203)	5 Ga. (.220)	.044
11 Ga. (.120)	.030	7 Ga. (.180)	6 Ga. (.203)	.041
12 Ga. (.109)	.028	8 Ga. (.165)	7 Ga. (.180)	.036
13 Ga. (.095)	.026	9 Ga. (.148)	8 Ga. (.165)	.035
14 Ga. (.083)	.025	10 Ga. (.134)	9 Ga. (.148)	.033
15 Ga. (.072)	.024	11 Ga. (.120)	10 Ga. (.134)	.031
16 Ga. (.065)	.022	12 Ga. (.109)	11 Ga. (.120)	.027
17 Ga. (.058)	.018	13 Ga. (.095)	12 Ga. (.109)	.025
18 Ga. (.049)	.017	14 Ga. (.083)	13 Ga. (.095)	.023
19 Ga. (.042)	.015	15 Ga. (.072)		
20 Ga. (.035)	.015	16 Ga. (.065)		

SAW GAUGES (Decimal Equivalents)

Birmingham or Stubs gauge used which is also used for tubing, strip steel, spring steel, and flat wire.

GAUGE	DECIMAL EQUIVALENT	GAUGE	DECIMAL EQUIVALENT
1	.300	11	.120
2	.284	12	.109
3	.259	13	.095
4	.238	14	.083
5	.220	15	.072
6	.203	16	.065
7	.180	17	.058
8	.165	18	.049
9	.148	19	.042
10	.134	20	.035



PARTS LIST
352950 CIRCULAR SAW ATTACHMENT

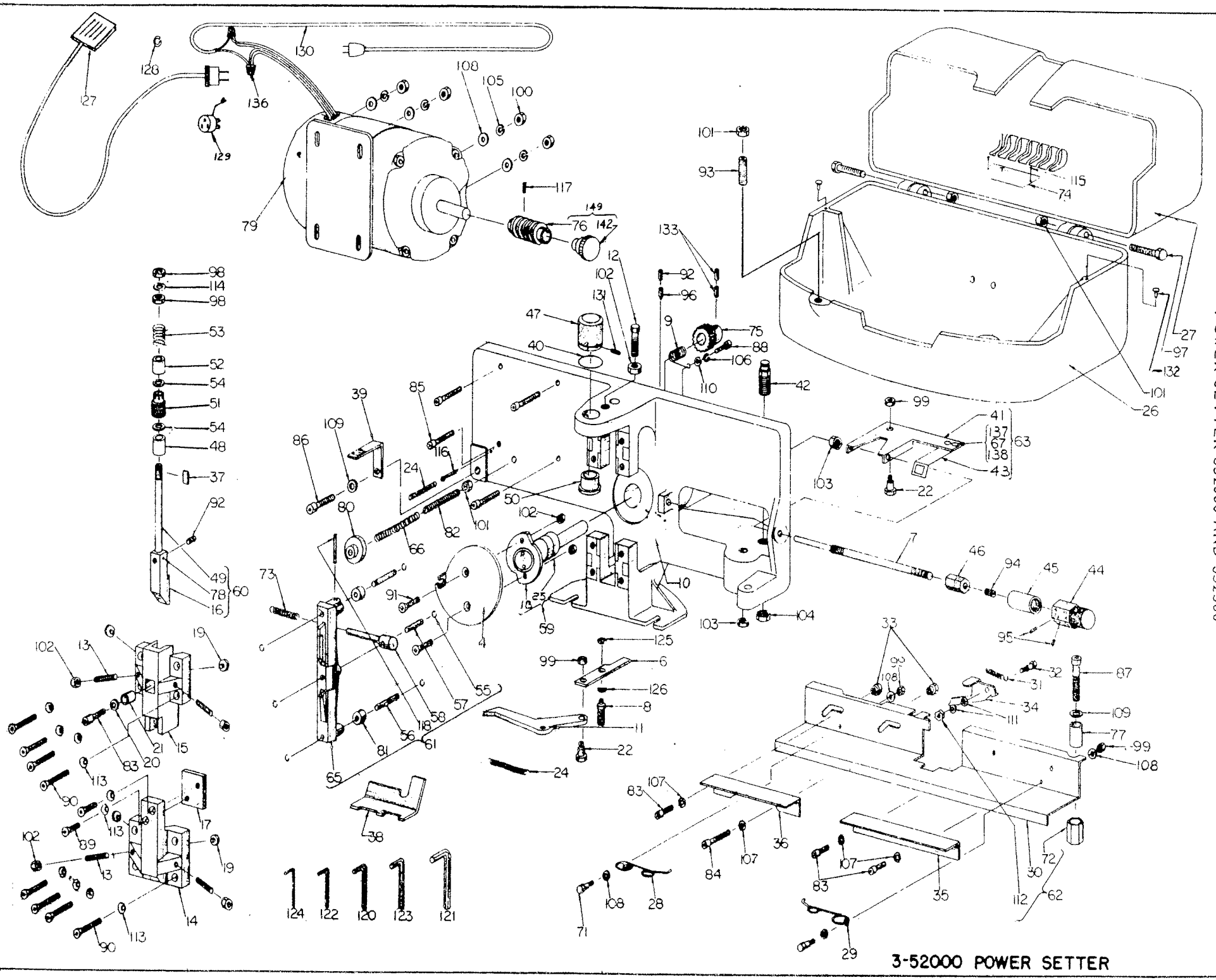
Dia. No.	Part No.	Part Name
1	314038	Handwheel
2	346010	Stud
3	346506	Cone & Body Assembly
4	352039	Guide Nut
5	352040	Support Angle
6	352041	Washer
7	352100	Arm R.H.
8	352101	Arm L.H.
9	353538	Cup
10	358091	Washer
11	B190805	Flat Sock. Hd. Screw 10-24 NC x 1/2
13	J191000	Hex Nut 10-24 NC
14	J311000	Hex Nut 5/16 - 18NC
15	R000522	Plain Washer #10 x 3/4

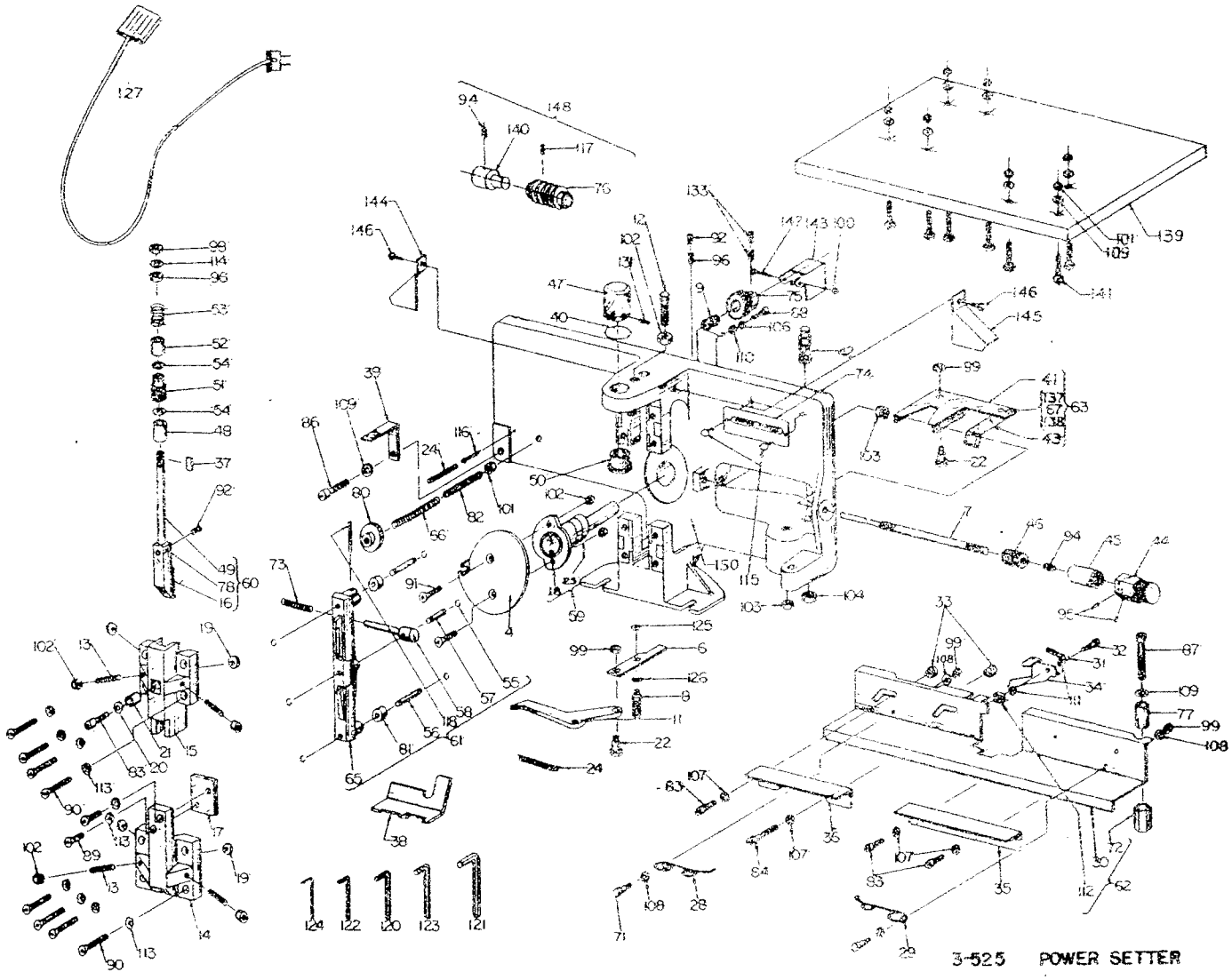
PARTS LIST

POWER SETTER 352000 AND 352500

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

DIAGRAM NO.	PART NO.	PART NAME AND DESCRIPTION	PRICE
4	352004	Hammer Cam	
	352005	Feed Cam **Furnished with #352525**	
6	352006	Feed Pivot Arm	
7	352007	Feed Plunger	
8	352008	Feed Pivot Arm Stud	
9	352009	Shaft Lock Spring	
10	352010	Mounting Plate	
11	352011	Feed Pawl	
12	352012	Set Equalizer Screw	
13	352013	Gib Adjustment Screw	
14	352014	Gib Support - Bottom	
15	352015	Gib Support - Top	
16	352016	Adjustable Anvil **Furnished with # 352530**	
17	352017	Solid Anvil	
18	352585	Feed Cam Sub Assembly **Furn with #352525**	
19	352019	Gib Button	
20	352020	Washer	
21	352021	Tube	
22	352022	Shoulder Bolt	
24	352024	Feed Pawl Spring	
25	352029	Cam Shaft Bearing **Furn with #352525**	
26	352032	Bottom Case	
27	352033	Top Case	
28	352046	Band Saw Clip - Left	
29	352047	Band Saw Clip - Right	
30	352048	Saw Guide **Furnished with #352549**	
31	352050	Saw Rest Spring	
32	352051	Saw Rest Latch Bolt	
33	352052	Saw Rest Nut	
34	352053	Saw Rest Latch	
35	352054	Saw Rest - Right	
36	352055	Saw Rest - Left	
37	352057	Slot Spacer	
38	352058	Feed Mechanism Adjustment Gauge	
39	352059	Depth of Set Gauge	
40	352061	Anvil Knob Snap Ring	
41	352062	Feed Plate **Furnished with #352560**	
42	352063	Feed Plate Retainer	
43	352064	Feed Indicator Lk Sprg **Furn with #352560**	
44	352065	Feed Indicator Knob	
45	352066	Feed Spacing Nut	
46	352067	Feed Spacing Screw	
47	352068	Anvil Lock Knob	
48	352069	Anvil Lock Tube	
49	352070	Anvil Lock Stud **Furnished with #352530**	
50	352071	Anvil Lock Sleeve	
51	352072	Anvil Lock Screw	
52	352073	Anvil Lock Spring Guide	
53	352074	Anvil Lock Spring	
54	352075	Anvil Lock Washer	
55	352080	Snap Ring	
56	352081	Roller Pin	
57	352082	Center Pin - For #352083	
58	352083	Spring Pivot Arm - Round End	
59	352525	Bearing & Feed Cam Assembly	
60	352530	Anvil & Stud Assembly	
61	352543	Hammerslide Assembly	
62	352549	Saw Guide Sub-Assembly	
63	352560	**Feed Plate & Lock Spring Assembly**	
65	352025	Hammerslide	
66	361224	File Holder Spring	
67	A130402	Rd Hd Machine Screw 6–32NC x 1/4	
71	310023	Band Saw Clip Screw	
72	310031	Guide Block **Furnished with #352549**	
73	310035	Power Spring	
74	310036	Name Plate	
75	310037	Worm Gear	
76	310038	Worm, only	
77	310039	Tube	
78	310040	Anvil Pin **Furnished with#352530**	
79	310041	Motor only	
80	310055	Saw Guide Adjustment Wheel	
81	310060	Cam Roller	
82	C253210	Slot Hd St Scr 1/4–20NCx2 - Cup Point	
83	B190631	Socket Hd Cap Scr 10–32NFx3/8 Knurled Hd	
84	B191031	Skt Hd Cp Scr 10–32NFx5/8-Knurled Hd	
85	B191231	Skt Hd Cp Scr 10–24NCx3/4-Knurled Hd	
86	B251206	Skt Hd Cp Scr 1/4–20NCx3/4	
87	B253611	Skt Hd Cp Scr 1/4–20NCx2-1/4	
88	B130611	Skt Hd Cp Scr 6–32NCx3/8-Knurled Hd	
89	B190625	Skt Hd Cp Scr 10–32NFx1/2-Flat Hd	
90	B191025	Skt Hd Cp Scr 10–32NFx5/8-Flat Hd	
91	B250825	Skt Hd Cp Scr 1/4–28NFx1/2-Flat Hd	
92	C190360	Skt Hd Set Scr 10–32NFx3/16 - Cup Point	
93	C251020	Skt Hd Set Scr 1/4–20NCx5/8 - Cup Point	
94	C310460	Skt Hd Set Scr 5/16–24NFx1/4 - Cup Pt	
95	C160824	Skt Hd Set Scr 8–32NCx1/8-Knurled Cp Pt	
96	C190363	Skt Hd Set Scr 10–32NFx3/16-Cone Point	
97	B252001	Hex Hd Cp Scr 1/4–20NCx1-1/4	
98	J121100	Hex Nut 12–28NF	
99	J131100	Hex Nut 6–40NF	
100	J191000	Hex Nut 10–24NC	
101	J251000	Hex Nut 1/4–20NC	
102	J252100	Hex Jam Nut 1/4–28NF	
103	J312100	Hex Jam Nut 5/16–24NF	
104	J432000	Hex Jam Nut 7/16–14NC	
105	R000468	Lockwasher #10 Split Lock - Medium	
106	R000479	Lockwasher #6 Split Lock - Light	
107	R000483	Lockwasher #10 Shakeproof - Int Teeth	
108	R000522	Plain Washer #10 SAE Standard	
109	R000524	Plain Washer 1/4 SAE Standard	
110	R000525	Plain Washer #6 SAE Standard	
111	R000531	Plain Washer #8 SAE Standard	
112	R000379	Weld Nt 8–32 Gripco **Furn with #352549**	
113	R000464	Lockwasher #10 Shakeproof - Extrnl Teeth	
114	R000581	Lockwasher #12 Shakeproof - Extrnl Teeth	
115	R601078	Drive Screw #2 x 3/16	
116	R772050	Cotter Key 1/16 x 1/2	
117	R840050	Rollpin 3/32 x 1/2	
118	R841125	Rollpin 1/8 x 1-1/4	
120	R000856	Allen Key - 1/8	
121	R000857	Allen Key - 3/16	
122	R000858	Allen Key - 3/32	
123	R000859	Allen Key - 5/32	
124	R000862	Allen Key - 1/16	
125	370868	"E" Retaining Ring - 3/16	
126	370894	Spring Washer	
	R000867	Allen Key	


POWER SETTER 352000 AND 352500
3-52000 POWER SETTER



PARTS LIST

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

DIAGRAM NO.	PART NO.	PART NAME AND DESCRIPTION
128	370954	Wire Clip
130	361584	Cord and Plug Set
131	C190455	Slot Hd St Scr 10–32NFx1/4 - FIDg Pt
132	352030	Grommet Type Bumper
133	C190260	Skt Hd Set Scr 10–32NFx1/8 - Cup Pt
136	370953	Solderless Connector
137	J131000	Hex Nut 6-32NC Furn with #352560
138	R000466	Lockwasher #6 Shakeproof - External Teeth, Furn with 352560 Furn with #370366
127	370368	Std Ft Switch, Cd & Series Plug Assm'y
	370345	Ft Switch with Cd, special high voltage
139	352026	Wood Base
140	352027	Adaptor, Standard for 1/2 inch motor shaft Furnished with #352506
	352028	Adaptor, Standard for 5/8 inch motor shaft Furnished with #352508
141	E252400	Carriage Bolt 1/4–20NCx1-1/2
143	352088	Gear Guard
144	352089	Cam Guard, left hand
145	352091	Cam Guard, right hand
146	A190402	Rd Hd Mach Screw 10–24NC x 1/4
147	A193202	Rd Hd Mach Screw 10–24NC x 2
148	352506	Adaptor & Worm Assembly, Std. 1/2 inch
	352508	Adaptor & Worm Assembly, Spec 5/8 inch
150	352090	Mounting Plate
	352092	Cover, not shown

DATE: January 1975

PARTS LIST
POWER SETTER 325000 AND 352500

Prices Subject to Change Without Notice

PART NO.	PRICE
310023	$ .65
310035	.60
310037	5.10
310038	10.00
310039	.90
310041	58.00
310055	2.30
310060	1.95
352004	3.95
352006	2.20
352007	5.10
352008	2.70
352009	.55
352010	47.00
352011	4.65
352012	2.30
352013	.65
352014	7.30
352015	11.00
352017	6.00
352019	1.00
352020	.30
352021	1.55
352022	.90
352024	.40
352025	25.75
352026	3.55
352030	.30
352032	28.00
352033	22.50
352046	1.00
352047	1.00
352050	.40
352051	2.70
352052	2.45
352053	.55
352054	.90
352055	.90
352057	.30
352058	1.00
352059	.80
352061	.30
352063	2.85
352065	18.00
352066	2.50
352067	2.85
352068	$ 3.95
352069	1.70
352071	3.40
352072	3.40
352073	1.50
352074	.65
352075	.30
352080	.25
352081	1.20
352082	1.30
352083	2.45
352088	1.40
352089	1.00
352090	47.00
352091	1.00
352092	6.20
352506	11.00
352508	11.00
352525	12.50
352530	17.00
352543	34.50
352549	11.00
352560	2.30
352950	55.00
361224	.40
361584	3.40
370345	42.00
370368	17.65
370868	.25
370894	.30
370953	.30
370954	.30
A130402	.30
A190402	.30
A193202	.30
B130611	.40
B190631	.40
B190825	.40
B191025	.40
B191031	.40
B191211	.40
B250825	.40
B251206	.40
B252001	.40
B253611	.55
C130224	.30
C190260	$ .30
C190360	.30
C190363	.30
C190455	.30
C251020	.30
C253210	.35
C310460	.30
E252400	.40
J131100	.25
J191000	.25
J251000	.25
J252100	.25
J312100	.25
J432000	.25
R000464	.25
R000466	.25
R000468	.25
R000479	.25
R000483	.25
R000522	.25
R000524	.25
R000525	.25
R000531	.25
R000581	.25
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R000858	.50
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R000862	.50
R601018	.25
R772050	.25
R840050	.30
R841125	.30

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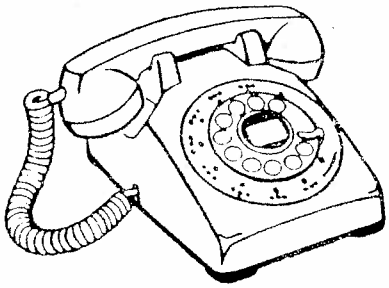
Any Questions?



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