



Operating Instructions and Parts Manual 18-inch Woodworking Band Saw

Model JWBS-18SFX, JWBS-18SFX-3



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1.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. Read and understand entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge have been obtained.
5. Do not use this band saw for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shield while using this machine. (Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.)
7. Before operating band saw, remove ties, rings, watches and other jewelry, and roll sleeves up past the elbows. Also, remove all loose clothing and confine long hair. Wear non-slip footwear or use anti-skid floor strips. Do not wear gloves.
8. Keep work area clean. Cluttered areas and benches invite accidents.
9. Use proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Sect. 6.2, Table 2 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.
10. Disconnect tools before servicing; when changing accessories, such as the blade.
11. Maintain proper adjustment of blade tension, blade guides, and thrust bearings.
12. Adjust upper blade guides to just clear workpiece (approximately 1/8").
13. Make sure blade tension, tracking and blade guides are all properly adjusted.
14. Make relief cuts where possible, when cutting curved stock.
15. When feeding small work pieces into blade, always use push stick, fixture, or similar device to keep hands at a safe distance.
16. Hold stock firmly and flat against table.
17. Wear ear protectors (plugs or muffs) during extended periods of operation.
18. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
19. Make certain switch is in OFF position before connecting machine to power supply.
20. Make certain machine is properly grounded.
21. Do not back stock out of blade while blade is running.
22. Do not remove jammed, cut-off pieces until blade has stopped.
23. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
24. Keep safety guards in place at all times when machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
25. Check for damaged parts before using the machine. If a guard or machine part is damaged, carefully check to see if it will operate and function properly and safely. Check for alignment of moving parts, binding issues, breakage, mounting, and any conditions that could impact operation and safety. Replace any part or guard damaged beyond safe and proper operating conditions.
26. Keep floor around machine clean and free of scrap material, oil, and grease.
27. Keep visitors a safe distance from work area. Keep children away.
28. Make your workshop child proof with padlocks, master switches or by removing starter keys.
29. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
30. Maintain a balanced stance at all times so that you do not fall into blade or other moving parts.

- Do not overreach or use excessive force to perform any machine operation.
31. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
 32. Use recommended accessories; improper accessories may be hazardous.
 33. Maintain machine with care. Keep blade clean and sharp. Do not use blades that are cracked, poorly welded, or have missing or deformed teeth. Follow instructions for lubricating and changing accessories.
 34. Turn off machine before cleaning. Use a brush or compressed air to remove chips or debris — not your hands.
 35. Do not stand on machine. Serious injury could occur if machine tips over.
 36. Never leave machine running unattended. Turn power off and do not leave band saw until blade comes to a complete stop.
 37. Remove loose items and unnecessary work pieces from area before starting machine.
 38. Keep hands out of path of saw blade. Do not reach around a moving saw blade.
 39. Do not use in dangerous environment. Do not expose machine to rain or use in wet or damp locations. Keep work area well lighted.
 40. Do not start the band saw with a workpiece in contact with the blade.
 41. Allow blade to reach full speed before cutting.
 42. Use a push stick or other safety device when ripping narrow workpieces.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠ WARNING This means that if precautions are not heeded, it may result in serious, or possibly even fatal, injury.

SAVE THESE INSTRUCTIONS

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3.0 About This Manual

This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model JWBS-18SFX Band Saw.

This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

This manual is not intended to be an exhaustive guide to band saw operational methods, use of jigs or after-market accessories, choice of stock, etc. Additional knowledge can be obtained from experienced users or trade articles. Whatever accepted methods are used, always make personal safety a priority.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our website: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠ WARNING Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Register your product online by visiting the website below or scanning the QR code:

<https://jettools.com/product-registration>



4.0 Specifications

Table 1

Model number	JWBS-18SFX	JWBS-18SFX-3
Stock numbers		
Band Saw with Stand	JT1-549	JT1-548
Motor and electrical		
Motor type	Totally enclosed fan-cooled induction, capacitor run	
Horsepower	1.75 HP (1.3 kW Copper Wire)	3 HP (2.2kW Copper Wire)
Motor phase	Single	Single
Motor voltage	115V	230V
Cycle	60 Hz	60 Hz
Listed FLA (full load amps)	15A	12A
Starting Amps	51A	58A
Running Amps (no load)	4.5A	5.7A
Start capacitor	CD60 100 μ F 275V 50/60Hz	CBB60 40 μ F 250V
Run capacitor	CBB60 40 μ F 450V 50/60Hz	CBB60 40 μ F 450V 50/60Hz
Motor speed	1720 RPM	
Power transfer	Multi-Wedge Belt 4PL1150	
On/off switch	KEDU Model: KJD-17B 120V-16A	KEDU Model: KJD-17B-16 230V-16A
Power plug	115V (5-15P), w/ground – 1.75HP	230V (6-15P), w/ground – 3HP
Power cord	SJT 14AWG x 3C, 105°C x 1900mm	
Motor power cable	SJT 14 AWG x 3C 105°C (1.75HP) SJT 14 AWG x 4C 105°C (3.0HP) SJT 20 AWG x 2C 105°C (1.75HP & 3HP-QKS7 cord)	
Limit switch	KEDU QKS7	
Socket for light	KEDU / Model: S230E-5 115V – 15A	NA
Recommended circuit size ¹	20A (for 115V)	20A (for 230V)
Sound emission ²	75 dB at 3ft (900mm) from blade	
Capacities and speeds		
Band saw size	18-1/2 in. (469.9 mm)	
Wheel diameter	18-1/2 in. (469.9 mm)	
Cutting capacity (cutting height)	16 in. (406 mm)	
Throat capacity	18 in. (457 mm)	
Blade length (blade not provided)	150 in. (3810 mm)	
Minimum blade width	1/8 in. (3.175 mm)	
Maximum blade width	1-1/4 in. (31.75 mm)	
Blade speed	3740 FPM (15.7m/s) / Wheel Speed 6400 RPM	
Main Materials		
Table	Cast iron	
Table insert	Anodized aluminum	
Trunnion	Cast iron	
Saw wheel	Cast iron	
Base	Steel	
Tires	Polyurethane	
Door locking knobs	Plastic	
Blade guides	Ball bearings	
Resaw fence	Extruded aluminum	
Paint finish	Powder coating	
Dust Collection		
Dust port outside diameter	2 ports @ 4 in. (100mm) each	
Minimum extraction volume required	600 CFM	

Dimensions and Weights		
Overall dimensions (LxWxH)	31-7/8" x 38" x 79-1/4" (810 x 965 x 2015 mm)	34-1/4" x 38" x 79-1/4" (870 x 965 x 2015 mm)
Base footprint	28-3/4" x 18-3/8" (730 x 465 mm)	
Net weight (approximate)	383 lbs (174 kgs)	406 lbs (184 kgs)
Shipping weight (approximate)	470 lbs (214 kgs)	502 lbs (228 kgs)

¹ Subject to local/national electrical codes.

² The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

L = length, W = width, H = height

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

⚠WARNING

Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

5.0 Setup and Assembly

5.1 Shipping Contents

See Figures 5-1 and 5-2.

- 1 Band saw (not shown)
- 1 Fence Body – **A**
- 1 Resaw fence – **B**
- 1 Table – **C**
- 1 Table insert – **D**
- 1 Guide rail – **E**
- 1 Handle – **F**
- 1 Lower door – **G**
- 1 Dust chute – **H**
- 1 Operating Instructions and Parts Manual (not shown)
- 1 Warranty card (not shown)

- 1 Hardware package (JWBS18SFX-HPN):
 - 3 Socket hd cap screws M8x16 – **HP1**
 - 3 Flat washers 8mm – **HP2**
 - 4 Hex socket head screws M8x25 – **HP3**
 - 4 Big flat washers 8mm – **HP4**
 - 1 Hex socket head screw M4x8 – **HP5**

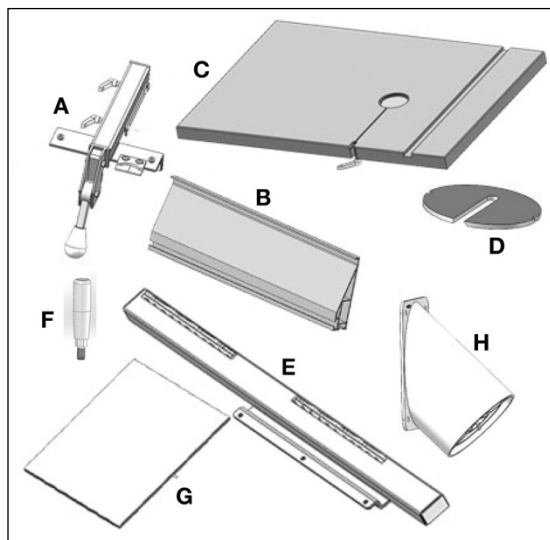


Figure 5-1: Shipping Contents & Hardware Package JWBS18SFX-HPN

5.2 Tools Required for Assembly

(Note: Additional tools may be needed for adjustments.)

- 2.5mm ball hex wrench (provided)
- 3mm, 4mm, 5mm, 6mm hex wrenches (provided)
- 10mm, 14mm wrenches
- Rubber mallet (or hammer and block of wood)
- Straight edge
- Measuring tape, gauge, or ruler
- Machinists square (or similar 90° measuring device)

5.3 Unpacking and Cleanup

Remove crate and packing material from band saw except for the transport skid on the bottom. Inspect the machine for damage. Report any damage to your distributor and shipping agent. Do not discard packing material until machine is assembled and running satisfactorily.

Move the saw to its permanent working location. The site should be dry, well lit, and have enough room to handle long stock and servicing or adjustment of the machine from any side.

Attach hoist to lifting ring atop band saw to move saw off skid. Clean all rust protected surfaces with a mild solvent or diesel fuel and a soft cloth. Do not use lacquer thinner, paint thinner, or gasoline, as these will damage painted surfaces.

⚠WARNING

Band saw must be disconnected from power source during assembly procedures. Failure to comply may cause serious injury.

5.4 Installing Handle

Thread handle (F, Figure 5-2) into front handwheel, and tighten with 10mm wrench on flats.

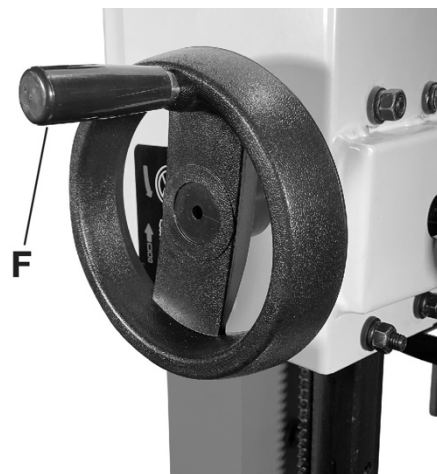


Figure 5-2: Handle Install

5.5 Installing Upper Dust Chute

Mount upper dust chute (H, Figure 5-3) with four M4 x 8 screws (HP5).

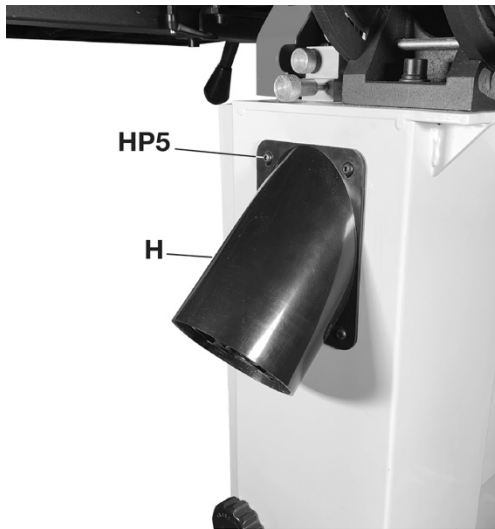


Figure 5-3

5.6 Installing Table

CAUTION Table is heavy; an assistant is recommended.

Position table onto trunnion and line up table to trunnion slots. Insert screws and washers (HP3/4, Figure 5-4). *Only hand tighten screws at this time – blade must be installed and table aligned before fully tightening.*

Follow all instructions concerning blade installation and adjustment, then proceed with table alignment in *sect. 5.15*.

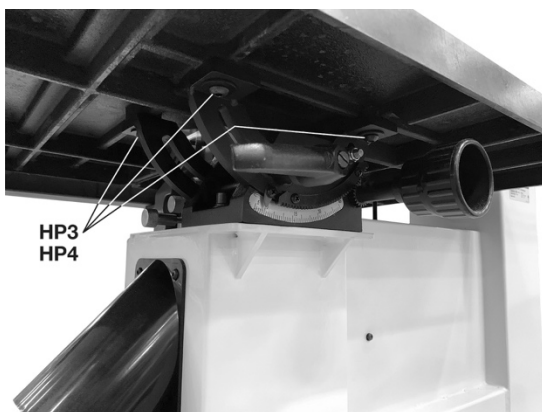


Figure 5-4: Table Installation

5.7 Installing Lower Door

1. Align door hinges with hinge posts on band saw frame (see Figure 5-5).
2. Slide door hinges over hinge posts. Make sure door shuts properly and door lock knob properly engages the door lock shaft (see Figure 5-6).

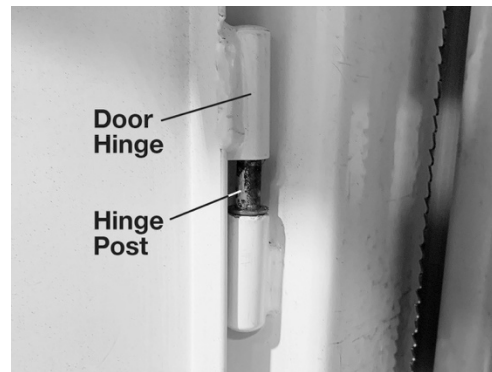


Figure 5-5

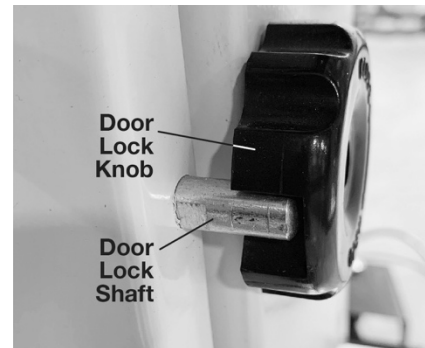


Figure 5-6

5.8 Installing Blade

Note: A blade is not provided with the saw. You may purchase one locally or from your JET dealer. See *sect. 4.0* for blade requirements of the JWBS-18SFX.

WARNING Disconnect machine from power source before installing blade.

WARNING Wear gloves and safety glasses when handling, installing, and adjusting blades. New blades are usually packaged in a coiled position. To prevent injury uncoil them slowly and carefully. However, do not wear gloves while operating the machine.

1. Disconnect band saw from power source.
2. Pull table pin (K, Figure 5-7) out of its slot, and remove table insert (D).

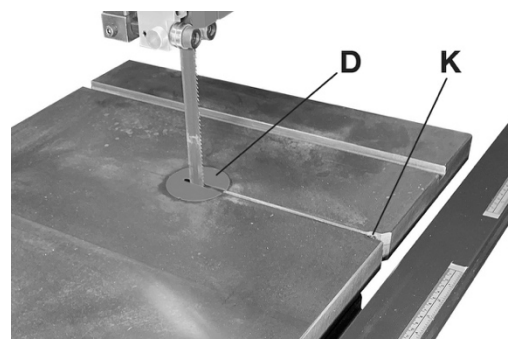


Figure 5-7

3. Open upper and lower doors by rotating doorknobs.
4. Swing the lower blade guard (M – Figure 5-14) to the left.
5. Back off upper and lower blade guides to allow gap for blade insertion (see sect. 5.12 through 5.14).
6. Raise quick tension lever (see D, Figure 5-9) to release position. If needed, rotate tension handwheel (E, Figure 5-9) counterclockwise for further de-tensioning.
7. Remove wood insert (Figure 5-8), if installed.

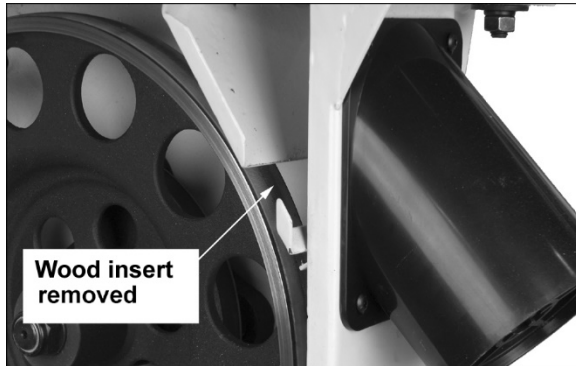


Figure 5-8

8. Guide blade through table slot. Place blade loosely in upper and lower blade guides. Make sure blade teeth point down toward table, and toward front of saw.
(If the teeth will not point down, no matter how the blade is oriented, then blade is inside-out. Twist it into correct orientation and re-install it.)
9. Position blade at center of upper and lower wheels.
10. Reinstall wood insert, table insert and table pin. (The table pin prevents deflection of table along blade slot.)
11. Before operating band saw, the new blade must be tensioned and tracked, in that order. Refer to sect. 5.9 and 5.10.
12. The blade guides must also be set properly according to instructions in sect. 5.11 through 5.14.

5.8.1 Replacing Wood Insert

⚠WARNING Attempting to cut the wood insert while the saw is running poses a safety risk. Perform the below instructions with the saw unplugged from the power source.

The saw comes with a wood insert which is pre-cut and slotted to fit the saw. Should the insert need to be replaced, the dimensions are as follows:

Size of Wood Insert:

70 L x 113 W x 7.5 Th mm
(2-3/4 L x 4-3/16 W x 1/4 Th in.)

When replacing the wood insert, use the following procedure to cut the blade slot.

1. Disconnect saw from power source.
2. Open bottom door and slide the wood insert until it contacts the blade edge (see Figure 5-8a).

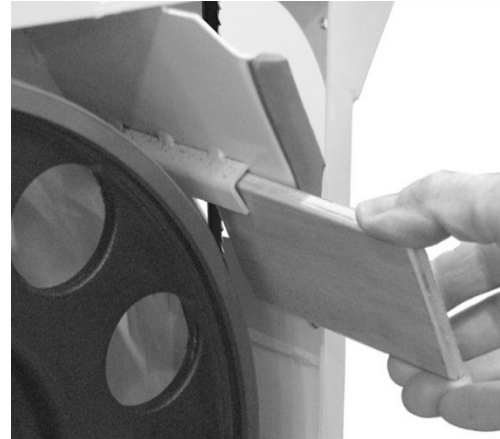


Figure 5-8a

3. Rotate bottom wheel by hand to cut a groove into the edge of the wood insert. This will be your cut angle reference.
4. Estimate the needed length of the cut when the insert will be installed all the way in. Mark this point on the wood insert (see Figure 5-8b).

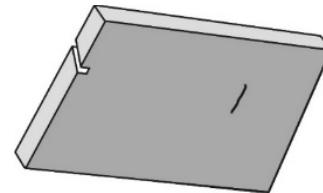


Figure 5-8b

5. Cut the blade channel into the wood insert. If using the bandsaw, connect to power source. The cut angle on the wood insert will be greater than the 45-degree maximum tilt on the band saw. Thus, a jig of some kind must be used with the band saw. Another method of cutting may be used. Possibilities include clamping the insert in a vise and cutting it with a hand saw, or using another machine that accepts the cut angle.

Whatever method or machine is used, make sure all necessary safety measures are taken.

5.9 Blade Tension

Refer to Figures 5-9 and 5-10.

Blade tension should be checked following blade replacement, and periodically as the blade stretches from use.

1. Lower tension lever (D, Figure 5-9) to tension position.
2. Set proper blade tension by rotating handwheel (E, Figure 5-9), clockwise to tighten, counterclockwise to loosen.
3. The gauge (F, Figure 5-10) indicates approximate tension according to blade width in inches. Initially, set blade tension to correspond to width of blade. As you become familiar with the saw, you may find it necessary to alter blade tension from the initial setting.

Keep in mind that too little or too much blade tension can cause blade breakage and/or poor cutting performance.

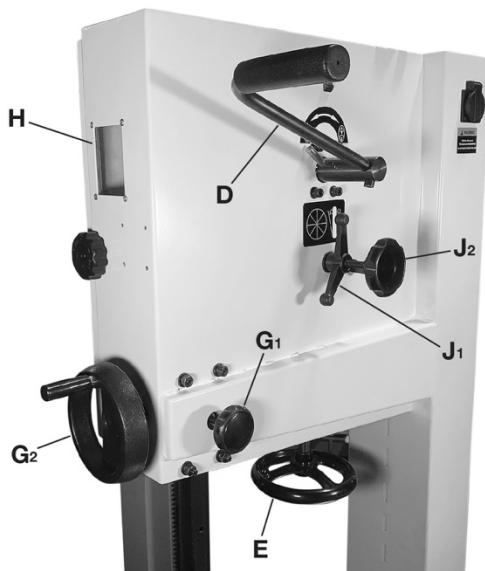


Figure 5-9

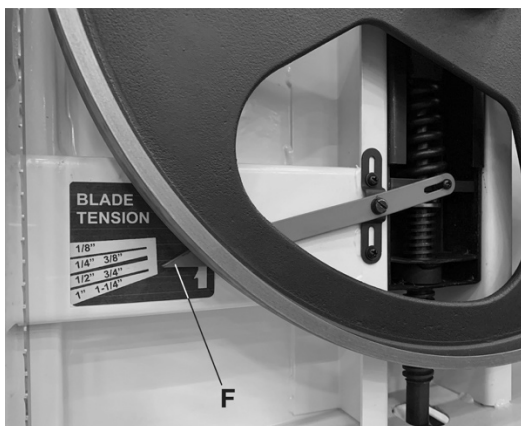


Figure 5-10

Tip: When the band saw is not being used, raise tension lever (D) to *release* position – this will prolong the life of blade and tires.

5.10 Blade Tracking

Refer to Figures 5-9, 5-10, and 5-11.

After proper tensioning, the blade must be tracked. “Tracking” refers to position of blade on the wheels while machine is in operation. Tracking should be checked periodically and is mandatory after every blade change. Blade tracking is done initially by hand with machine disconnected from power.

1. **Disconnect band saw from power source.**
2. Blade must be correctly tensioned (*sect. 5.9*). Lower blade tension lever to *tension* position.
3. Back off blade guides so they will not interfere with blade movement.
4. Loosen guide post locking knob (G₁, Figure 5-9) and use handwheel (G₂) to lower guide post until you can see blade through tracking window (H).
5. Open upper door to expose wheel.
6. Rotate wheel by hand, observing position of blade through tracking window. The blade should ride approximately at center of tire (Figure 5-11).

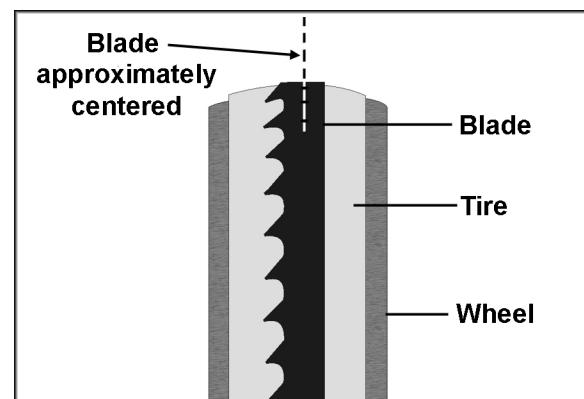


Figure 5-11

7. If blade tends to migrate toward left or right edge of wheel, loosen locking handle (J₁, Figure 5-9) counterclockwise, and rotate tracking knob (J₂) with your right hand while continuing to rotate wheel with your left.
IMPORTANT: This adjustment is sensitive; perform in small increments and give blade time to react to changes.
8. When blade is tracking near approximate center of tire, tighten locking handle (J₁), and close upper door.
9. Connect saw to power and turn it on to observe blade in action through tracking window (H). Make further adjustments as needed.

5.11 Blade Guides Overview

Thrust (back support) *bearings* are located behind saw blade and provide support to back of blade when saw is in operation.

Guide bearings are located on either side of saw blade and provide stability for blade when saw is in operation. These bearings rotate on an eccentric shaft so distance from blade can be adjusted for optimal performance.

5.12 Upper Blade Guides

CAUTION Blade teeth are sharp; use care when working near saw blade.

The guide bearings should be set so that contact between blade and guides will occur only when blade is under pressure from a workpiece. To adjust upper bearing guides for proper blade control, proceed as follows.

Refer to Figures 5-12 and 5-13.

1. Disconnect band saw from power source.
2. Blade must already be tensioned and tracking correctly. See sect. 5.9 and 5.10.

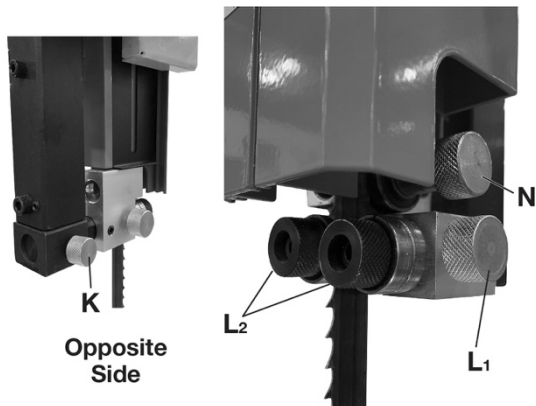


Figure 5-12: Blade Guide Adjustment

3. Lower tension lever (D, Figure 5-9) to tension position.
4. Loosen the lock knob (K, Figure 5-12).
5. Slide entire guide bracket until front of guide bearings are about 0.015" (1/64") behind blade gullet (curved area at base of tooth). See Figure 5-13.
6. Tighten lock knob (K, Figure 5-12).

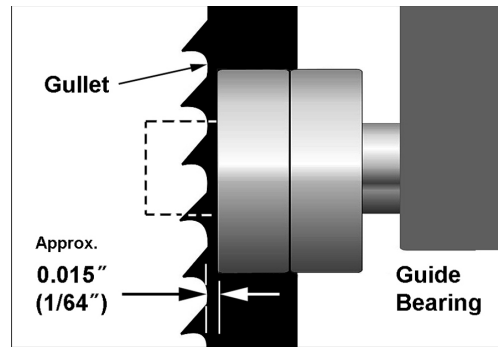


Figure 5-13: Guide Bearing Position

7. Loosen lock knob (L₁) for either of the front guide bearings.
8. The guide bearing rotates on an eccentric shaft. Adjust guide bearing by rotating knurled knob (L₂) until guide bearing is almost touching blade.

Tip: This blade-to-bearing gap can be quickly set by inserting a business card, or dollar bill folded twice (4 thicknesses), between them then allowing the guide bearing to *lightly* contact the card/bill.

CAUTION Do not force guide bearing against side of blade. Overtightening will reduce bearing life. Guide bearings should not rotate when saw is running without a workpiece; they will generally only make contact with blade when there is pressure from the cutting operation.

9. Tighten lock knob (L₁).
10. Repeat process for opposite guide bearing.

5.13 Upper Thrust Bearing

CAUTION Blade teeth are sharp; use care when working near saw blade.

Refer to Figure 5-12.

The thrust bearing prevents backward deflection of blade during cutting.

1. Disconnect band saw from power source.
2. Loosen the lock knob (N, Figure 5-12), and slide thrust bearing until it almost touches back of blade. (This blade-to-bearing gap can be set in similar fashion as the side guides, with business card or dollar bill.)

NOTE: On narrow blades (1/8" blades), it may be preferable to set thrust bearing in actual contact with blade.

3. Tighten lock knob (N).
4. Make sure all lock knobs on upper guide bearing assembly are tightened when adjustments are complete.

5.14 Lower Blade Guides

CAUTION Blade teeth are sharp; use care when working near saw blade.

Refer to Figure 5-14.

1. Disconnect band saw from power source.
2. Open lower door and swing lower guard (M) out of the way.
3. Adjust lower guide bearings and lower thrust bearing below table in similar manner to that of upper guide and thrust bearings.

Movement summary: Loosen lock knob (P) to move entire guide bearing assembly. Loosen lock knob (S) and rotate knob (S) to adjust guide bearing in relation to blade. Thrust bearing is controlled by locking knob (O).

4. Make sure all knobs and screws are tightened after adjustments are complete.

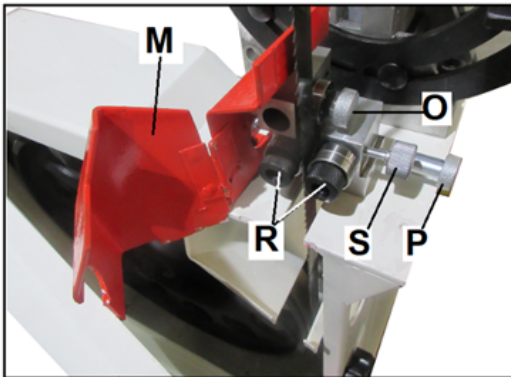


Figure 5-14: Lower Blade Guides

5.15 Aligning Table

The table must be adjusted so that:

- Blade runs through center of table insert.
- Table is aligned with blade.
- Table is square to blade at 90° scale reading.

1. Disconnect band saw from power source.
2. The table screws should still be only hand tight.
3. Lower tension lever (D, Figure 5-9) to tension position.
4. Install table insert (B, Figure 5-7). Blade should be positioned at center of insert opening. If it is not, nudge table left or right as needed to center it.

Table must now be aligned with blade, and surface set square to blade at 90° scale reading, as follows.

5.15.1 Table-to-Blade Alignment

1. With blade tension lever in *tension* position, place a long straightedge flush against blade, making sure it evenly contacts both front and

back of blade. See Figure 5-15. Do not deflect blade by pushing into it.

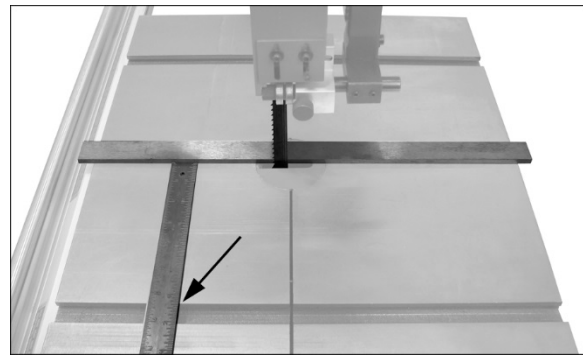


Figure 5-15

2. Use a gauge or ruler (Figure 5-15) to carefully measure distance from miter slot edge to straight edge. Take measurements at both front and back of table – these should be identical.
3. If miter slot is not parallel to blade, nudge table with rubber mallet in the needed direction.
4. When parallelism is achieved (and blade is still centered through table insert), securely tighten the four trunnion screws (HP3, Figure 5-16).

5.15.2 Table-to-Blade Squaring and 90° Stop

1. Insert stop screw with stop screw hex nut (see Figure 5-16) into threaded hole in table.
2. Set a square on table top and against blade, as shown in Figure 5-17.
3. Loosen lock handle (see Figure 5-16) and manually tilt table until table and blade are square.
4. Tighten lock handle.
5. Turn stop screw until it contacts saw frame and tighten stop screw hex nut against table.
6. If needed, loosen screw and move pointer (see Figure 5-16) to align with zero on scale. Retighten screw.

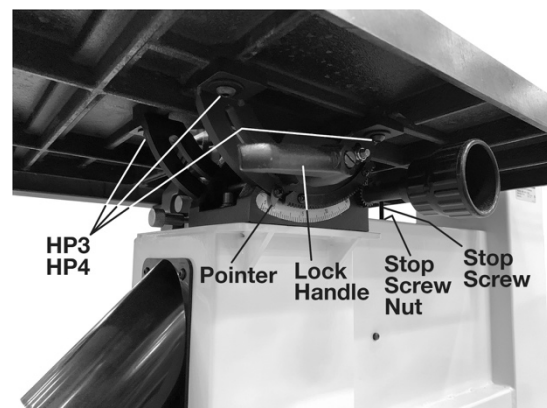


Figure 5-16: Table Alignments

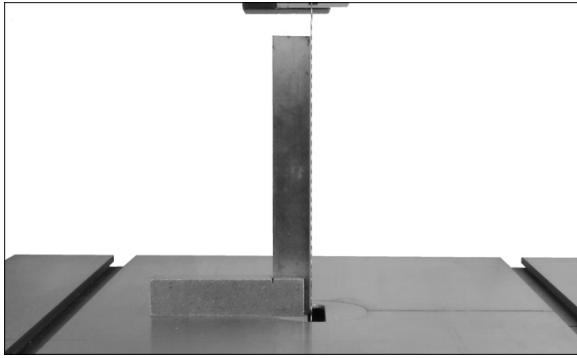


Figure 5-17: Squaring Table to Blade

5.16 Installing Guide Rail and Fence

1. Install guide rail assembly to underside of table as shown in Figure 5-18. Align mounting holes in guide rail base with threaded mounting holes on underside to table.



Figure 5-18

2. Attach guide rail assembly to table using three socket head cap screws and 8mm washers (HP1 & HP2, see Figure 5-19). Tighten screws firmly.

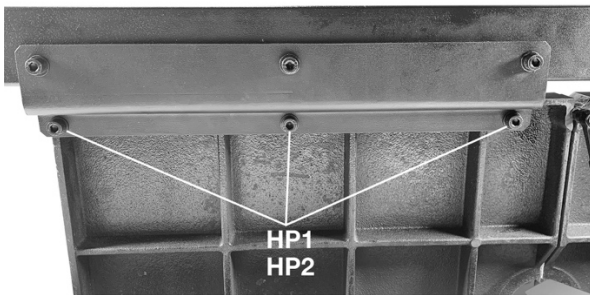


Figure 5-19

3. Place fence body onto guide rail (see Figure 5-20). Push down fence lock handle to lock fence body to rail. There should be an even gap between table surface and the length of fence body (see Figure 5-21).
4. Loosen the fence lock bar by turning the lock bar handles (see Figure 5-22)

5. Slide the resaw fence onto the fence lock bar as shown in Figure 5-23. Tighten the lock bar handles. If fence is difficult to slide onto fence lock bar, try lifting the fence lock handle or loosening the lock bar handles more.

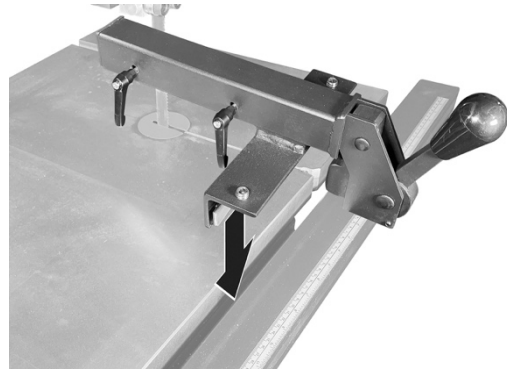


Figure 5-20

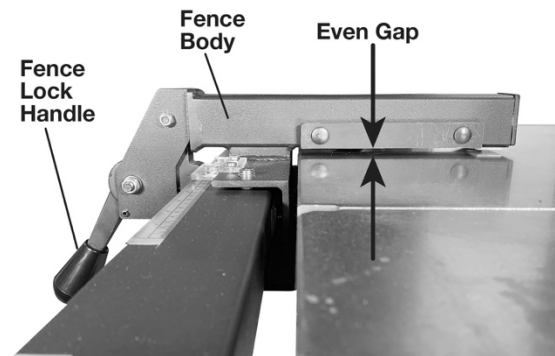


Figure 5-21

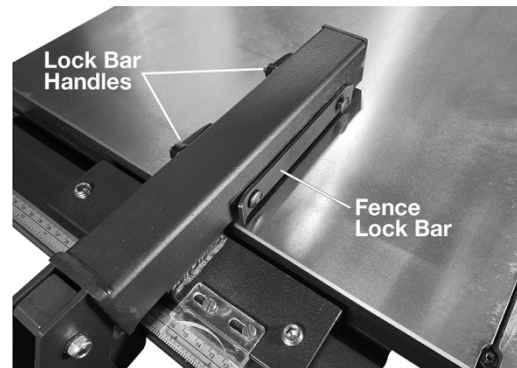


Figure 5-22

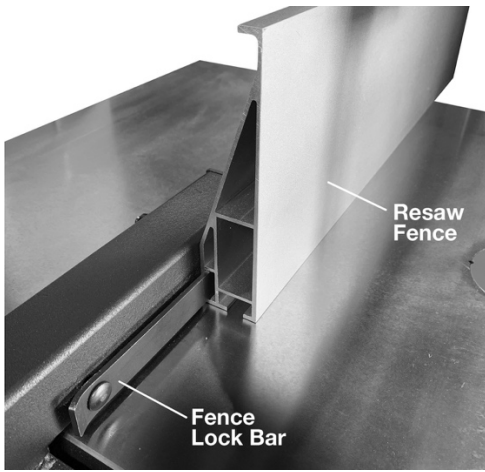


Figure 5-23

5.16.1 Fence to Miter Slot Alignment

1. Slide fence against edge of miter slot (Figure 5-24) and push down lock handle to lock position. The fence should align parallel to miter slot along entire length of fence.
2. If adjustment is needed, turn one of the back adjustment screws (B, Figure 5-25) to turn fence in line with miter slot.

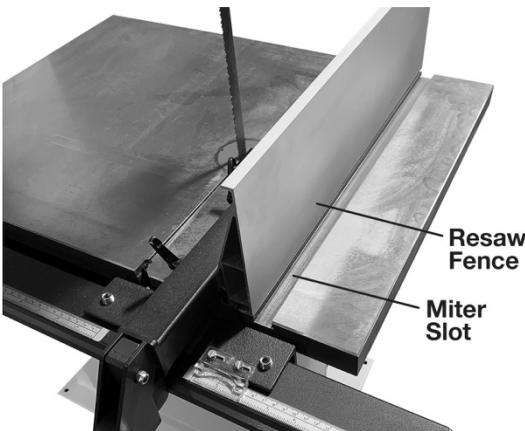


Figure 5-24

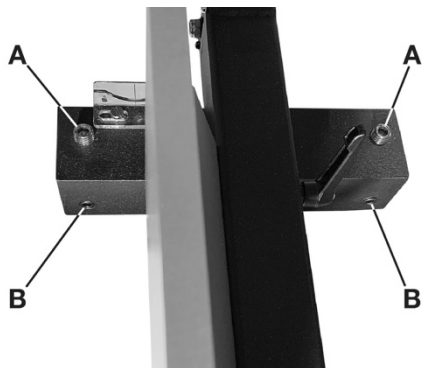


Figure 5-25

5.16.2 Fence to Blade Alignment

1. Set table at 90° to blade and lock in position.
2. Move fence against blade (do not deflect blade by pushing into it). See Figure 5-26.
3. Verify that fence, top-to-bottom, lies flat against side of blade. If it does not, adjust the set screws (A, Figure 5-25) until fence is parallel to blade along the vertical length of fence.



Figure 5-26

5.16.3 Cursor Alignment

1. With fence against blade, verify that cursor (see Figure 5-27) aligns with zero on scale.
2. If adjustment is needed, loosen the two cursor adjustment screws (see Figure 5-28) on the fence body and nudge fence plastic cursor plate right or left until cursor aligns with zero when fence is against blade.
3. Tighten the two screws.

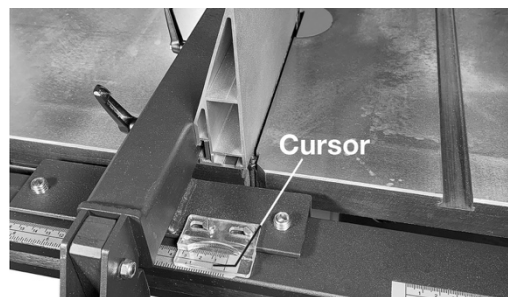


Figure 5-27

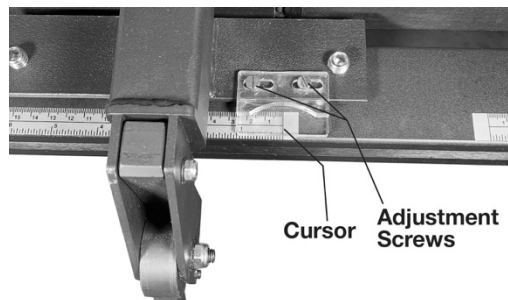


Figure 5-28

5.17 Setting Up Brake Pedal

The brake pedal is shipping in the up position. The pedal must be adjusted 90-degrees to the horizontal position.

Refer to Figure 5-29.

1. Loosen socket set screw (T) on brake pedal disc (U).
2. Rotate brake pedal (V) 90-degrees to the horizontal position.
3. Tighten socket set screw (T) to fix brake pedal in proper position.

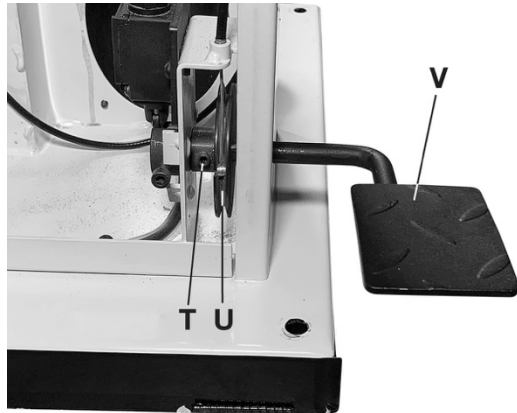


Figure 5-29

5.18 Dust Collection

It is strongly recommended that a dust collection system (not provided) be connected to the two 4-inch diameter ports on the saw (see Figure 5-30). It will help keep the shop clean, as well as prevent potential health hazards due to air-borne wood dust. See our website at Jettools.com for a full line of dust collectors.

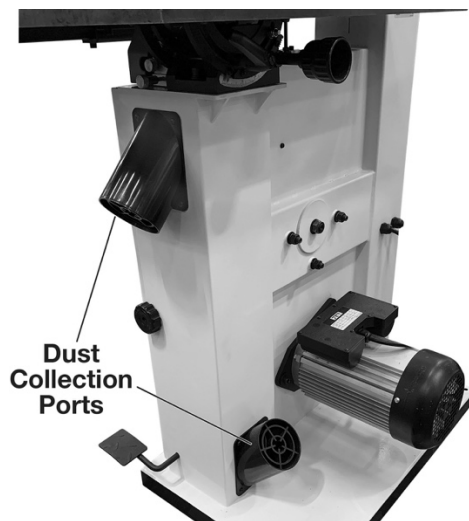


Figure 5-30

6.0 Electrical Connections

⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

6.1 GROUNDING INSTRUCTIONS

All Grounded, Cord-Connected Tools

This machine must be grounded. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation that is green, with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Before connecting to power source, be sure the switch is in *off* position.

⚠WARNING Check with a qualified electrician or service person if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded. Failure to comply may cause serious or fatal injury.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

For Model JWBS-18SFX – 115V

This model is intended for use on a 115V circuit and has a grounded outlet that matches the band saw electrical cord plug, as shown in Figure 6-1.

If the outlet is not a properly grounded three-pole receptacle, do not use a temporary adaptor. Have a properly grounded three-pole receptacle installed by a qualified electrician.

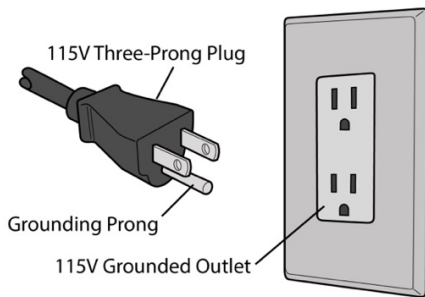


Figure 6-1: 115V Connection

For Model JWBS-18SFX-3 – 230V

This model is intended for use on a 230V circuit and has a grounded outlet that matches the band saw electrical cord plug, as shown in Figure 6-2. Make sure the machine is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this machine. If the machine must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified electrician. After reconnection, the machine should comply with all local codes and ordinances.

Make sure the voltage of your power supply matches the specifications on the motor plate of the Band Saw.

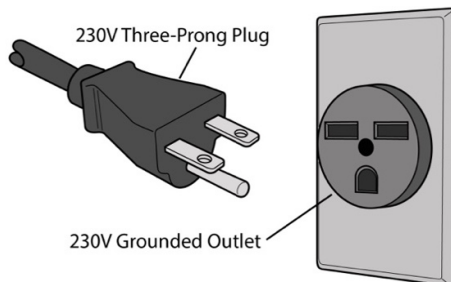


Figure 6-2: 230V Connection

6.2 Extension Cords

The use of extension cords is discouraged; try to position your machine within reach of the power supply. If an extension cord becomes necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Use Table 2 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Recommended Gauges (AWG) of Extension Cords

Amp Rating		Volts	Total length of cord in feet			
More Than	Not More Than	120	25	50	100	150
		240	50	100	200	300
		AWG				
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not Recommended	

Table 2

7.0 Adjustments

7.1 Resaw Fence

The fence can be installed in one of two positions: vertical (resaw position) or horizontal. Horizontal position is useful for small or thin workpieces and allows blade guide to be lowered without interference from fence. Zero setting of cursor cannot be used with horizontal fence position.

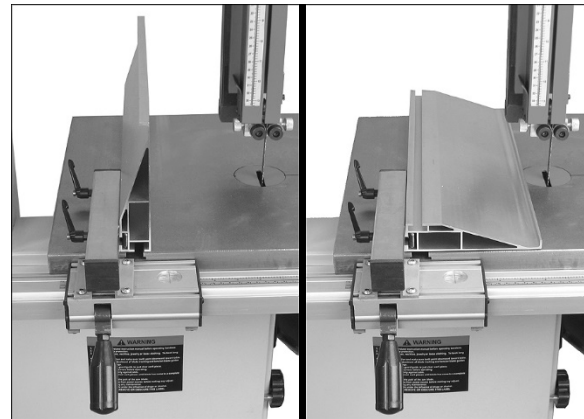


Figure 7-1: Fence Positions

7.2 Miter Gauge (optional accessory)

Refer to Figure 7-2.

1. Slide miter gauge (not included, optional accessory) into table slot from front edge of table.
2. Loosen knobs (A₁) and install miter fence (A₂) onto gauge body. Position fence as needed and tighten knobs.
3. Loosen handle (A₃), pull out pin (A₄), and rotate body to desired angle. Tighten handle.



Figure 7-2: Miter Gauge Adjustments

7.2.1 Setting Positive Stops

Refer to Figure 7-2.

The miter gauge has positive stops at 0 (90°), and 45° left and right, located beneath the gauge body.

1. Use a square to verify that miter fence is square to blade when set at 90° on scale.

2. If miter gauge is not square to blade, loosen handle (A₃) and adjust until square. Tighten handle.
3. Verify that pointer (A₅) shows 90°. If it does not, loosen screw and shift pointer to 90°. Tighten screw.
4. Adjust a stop if needed by loosening hex nut and rotating screw (A₆). Retighten nut.

The top channel on miter fence will accommodate accessory items, such as hold-downs. Remove end cap and install t-bolts into the channel.

7.3 Table Tilt

Refer to Figure 7-3.

1. Loosen lock lever (B).
2. For **right tilt** (as viewed from front or operator's side of saw), rotate tilt handle (C) clockwise and lift table with your hand to tilt table up to 45°.
3. For **left tilt** (as viewed from front or operator's side of saw), loosen lock lever (B) and rotate tilt handle (C) clockwise slightly to release pressure on the 90° stop bolt (D). Rotate circular plate (E) out of the way. Then rotate tilt handle counterclockwise and lift table with your hand to tilt table up to 15°.

The now-exposed hole in the band saw body allows the stop bolt (D) to descend through it, to keep intact the setting of the 90° stop.

4. Tighten lock lever (B) to secure setting.

NOTE: The circular plate (E) can be tightened or loosened as desired by using a 4mm hex wrench on the screw.

Also, the lock lever (B) can be pivoted to a more convenient position. Simply lift straight out on the lever and rotate it on the pin, then release the lever making sure it seats itself on the pin.

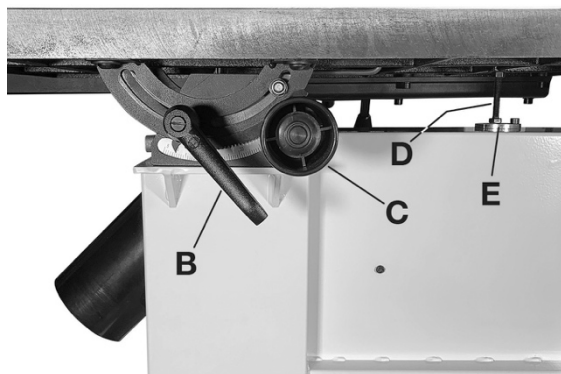


Figure 7-3: Table Tilt

7.4 Guide Post

Refer to Figures 7-4 and 7-5.

1. Loosen lock knob (see G₁, Figure 7-4) and raise or lower guide post using handwheel (G₂, Figure 7-4).
2. Position blade guide assembly so that bottom of guide bearing assembly is about 3/16-inch above material to be cut. The scale pointer (Figure 7-5) indicates height of guide assembly from table. This provides minimal clearance between workpiece and bottom of guide bearings, which minimizes blade deflection and enhances operator safety.
3. Tighten lock knob (G₁, Figure 7-4).

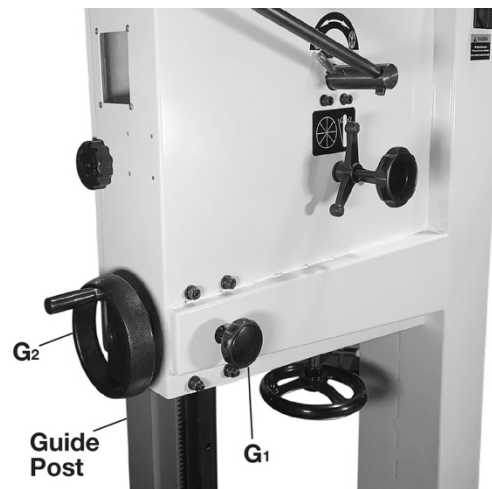


Figure 7-4

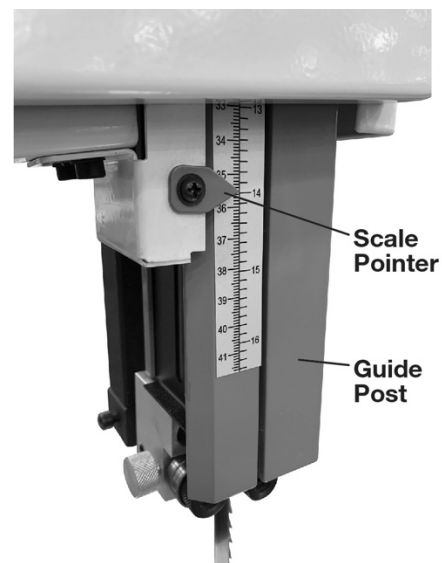


Figure 7-5

7.5 Drive Belt Adjustments

The drive belt and pulleys are properly adjusted by the manufacturer. However, belt tension should be occasionally checked when the band saw is new, as a new belt may stretch slightly during the breaking-in process.

7.5.1 Drive Belt Tension

Check tension by pushing with moderate pressure on belt halfway between pulleys. An adequately tensioned belt will deflect a maximum of 1/8-inch.

7.5.2 Drive Belt Replacement

⚠WARNING Disconnect machine from power source before replacing drive belt.

If belt becomes worn, cracked, frayed, or glazed, it should be replaced as follows:

1. Disconnect band saw from power source.
2. Open upper and lower doors and remove blade.
3. Loosen motor plate screws (A, Figure 7-6). If needed, slightly loosen pivot screw (B). Lift motor upward to remove tension on belt and tighten screws (A) to hold motor in raised position.

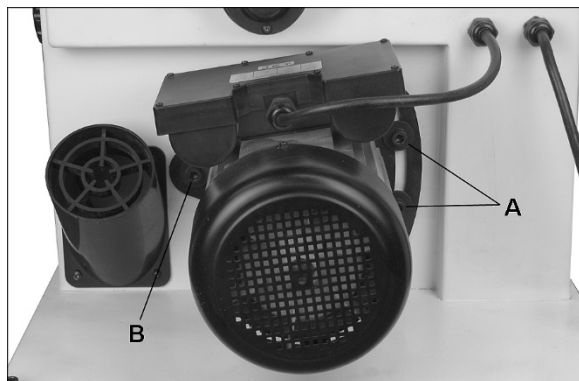


Figure 7-6

4. Open lower wheel door. Remove nut and washer and remove blade wheel. If lower wheel cannot be easily removed, you may need to use a wheel puller to remove it.
5. Remove old belt from pulleys and install new belt, making sure it seats properly in pulley grooves.
6. Reinstall lower blade wheel, washer, and nut, and tighten securely.
7. Loosen motor plate screws (A) and allow motor to lower, tensioning the belt. Tighten screws (A).
8. Install blade and verify blade tension and tracking before operating (sect 5.9 and 5.10).

7.6 Wheel Brush

An adjustable brush is located in lower wheel housing (see Figure 7-7). It should remain in constant contact with wheel to prevent buildup of gum and debris. Loosen adjustment screw on brush housing to slide the brush back and forth. After repositioning brush, tighten the screw.



Figure 7-7

8.0 Operating Controls

8.1 Start/Stop Switch

Refer to Figure 8-1.

To Start – Press green start button (A).

To Stop – Press red OFF paddle (B) to stop.

To Reset – If band saw stops without pressing the stop button (as result of tripped fuse or circuit breaker, etc.) proceed as follows:

1. Press red STOP paddle to reset.
2. Press green start button to restart machine.

⚠WARNING After machine is shut off, allow wheels and blade to come to a complete stop before opening guards/doors, adjusting, or leaving the area.



Figure 8-1: Start/Stop Switch

8.2 Switch Lockout

To safeguard your machine from unauthorized operation and accidental starting, especially by young children, install a padlock through the green power ON button (see Figure 8-2). Use a padlock with a shackle maximum diameter of 1/8" and at least 2.5" in length. Place the key in a location that is inaccessible to children and others not qualified to use the tool.



Figure 8-2: Switch Lockout

8.3 Brake Pedal

When the red STOP paddle is used to shut off the band saw, the blade will coast slowly to a stop. An alternate method of stopping the machine is to press

and hold the brake pedal, shown in Figure 8-3. The blade will stop moving in a few seconds after pedal is pressed. Restart saw by pressing start switch on column.

In case of emergency, always use the brake pedal to stop the saw.

NOTE: Unnecessary and excessive use of brake pedal may shorten life of brake pad.

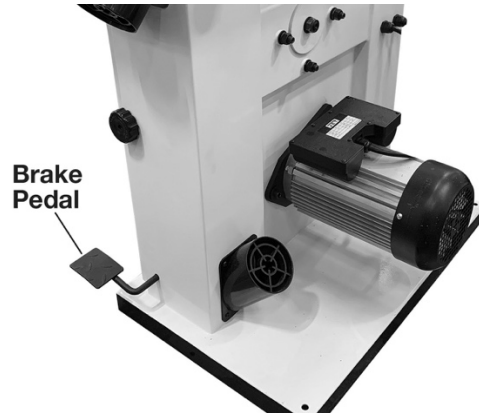


Figure 8-3: Brake Pedal

9.0 Operation

The following section contains basic information and is not intended to cover all possible applications or techniques using the band saw. Consult published sources of information, acquire formal training, and/or talk to experienced band saw users to gain proficiency and knowledge of band saw operations.

The following figures are general in nature and may not show your specific model.

9.1 General Procedure

1. Make sure the blade and upper and lower blade guide bearings are properly adjusted for tension and tracking.
2. Adjust blade guide assembly so that the guide bearings are just above workpiece (about 3/16") allowing minimum exposure to blade. See Figure 9-1.
3. If using the fence, move it into position and lock it to the guide rail. If you are using the miter gauge for a crosscut, the fence should be moved safely out of the way.
4. Turn on band saw and allow a few seconds for the machine to reach full speed.

⚠WARNING Whenever possible, use a push stick, hold-down, power feeder, jig, or similar device while feeding stock, to prevent your hands getting too close to the blade.

5. Place the straightest edge of the workpiece against the fence and push the workpiece slowly into the blade. Do not force the workpiece into the blade.

CAUTION When cutting, do not overfeed the blade; overfeeding will reduce blade life and may cause the blade to break.

6. When cutting long stock, the operator should use roller stands, support tables, or an assistant to help stabilize the workpiece.

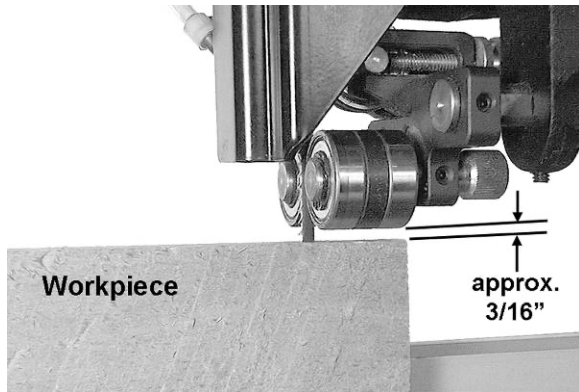


Figure 9-1

9.2 Ripping

Ripping is cutting lengthwise through the workpiece, along the grain (of wood stock). See Figure 9-2.

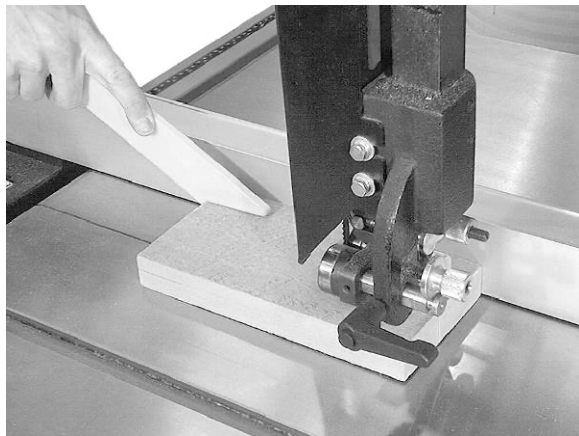


Figure 9-2: Ripping

9.3 Crosscutting

Crosscutting is cutting across the grain of the workpiece, while using the miter gauge to feed the workpiece into the blade.

Slide the bar of the miter gauge into the end of the slot on the table.

The right hand should hold the workpiece steady against the miter gauge, while the left hand pushes the miter gauge past the blade, as shown in Figure 9-3.

Do not use the fence in conjunction with the miter gauge. The offcut of the workpiece must not be constrained during or after the cutting process.

CAUTION Using the fence in conjunction with the miter gauge can cause binding and possible damage to the blade.

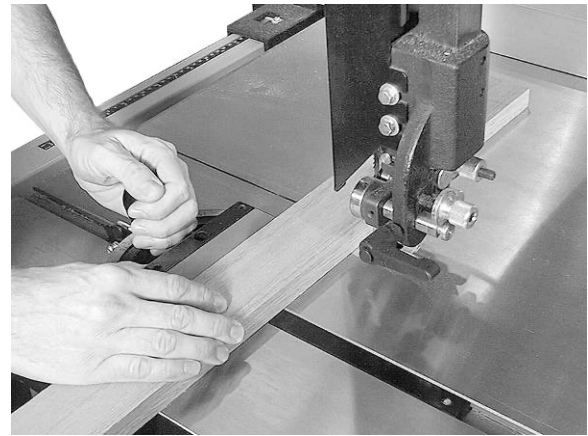


Figure 9-3: Crosscutting

9.4 Resawing

Resawing is the process of slicing stock to reduce its thickness, or to produce boards that are thinner than the original workpiece. See Figure 9-4.

The ideal blade for resawing is the widest one the machine can handle, as the wider the blade the better it can hold a straight line.

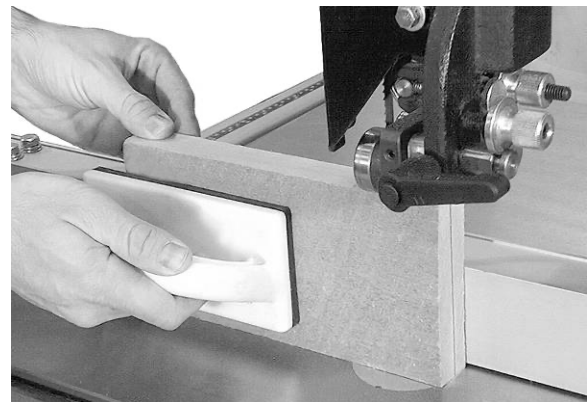


Figure 9-4: Resawing

When resawing thin stock, use a push block, push stick, or similar device to keep your hands away from the blade.

9.5 Blade Lead

Blade lead, or drift, is when the blade begins to wander off the cutting line even when the band saw fence is being used.

Figure 9-5 shows an example of blade lead. It is more common with small, narrow blades, and is almost always attributable to poor blade quality, or lack of proper adjustments. Inspect the band saw for the following:

- Fence not parallel to miter slot and blade.
- Blade not tensioned correctly.
- Blade is dull.

- Teeth have excessive “set” on one side of blade.
- Workpiece being fed too quickly.

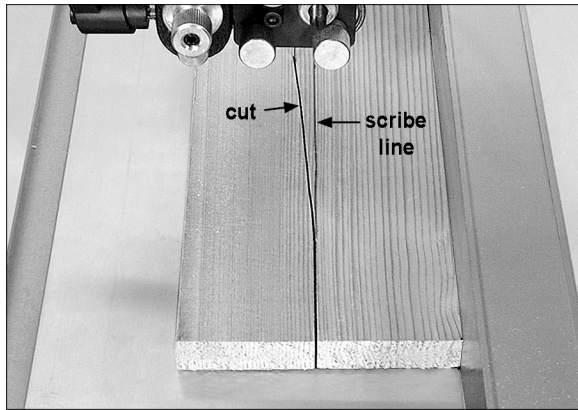


Figure 9-5: Blade Lead

9.6 Saw Blade Selection

Using the proper blade for the job will increase the operating efficiency of your band saw, help reduce necessary saw maintenance, and improve your productivity. Thus, it is important to follow certain guidelines when selecting a saw blade.

Here are factors to consider when selecting a blade:

- The type of material you will be cutting.
- The thickness of the material.
- The features of the material, such as bends or curves with small radii.

These factors are important because they involve basic concepts of saw blade design. There are five (5) blade features that are normally changed to meet certain sawing requirements. They are:

1. width
2. pitch (number of teeth per inch)
3. tooth form (or shape)
4. the “set” of the teeth
5. the blade material itself.

9.7 Width

Band saw blades come in different standard widths, measured from the back of the blade to the tip of the tooth. Generally, wider blades are used for ripping or making straight cuts; narrower blades are often used when the part being cut has curves with small radii. When cutting straight lines with a narrow blade, the blade may tend to wander, causing *blade lead*. (refer to sect. 9.5).

9.8 Pitch

Pitch is measured in “teeth per inch” (TPI). Figure 9-6 shows blades with different pitches. A fine pitch (more teeth per inch) will cut more slowly but smoother. A coarse pitch (fewer teeth per inch) will cut rougher but faster. As a rule of thumb, the thicker the workpiece, the coarser will be the blade pitch. If you cut a hard or very brittle material, you may want to use a blade with a finer pitch to get clean cuts.

General rule: Use a blade that will have no fewer than 6 and no more than 12 teeth in the workpiece at any given time.

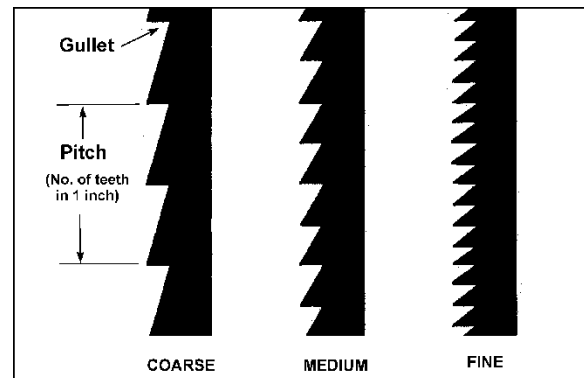


Figure 9-6: Blade Pitch

9.9 Shape

Figure 9-7 shows common types of tooth shape. Tooth shape influences cutting rate, and with few exceptions, the Skip and Hook types are used to obtain higher feed rates when cutting thick workpieces. Variable-tooth blades are also available, which combine features of the other styles.

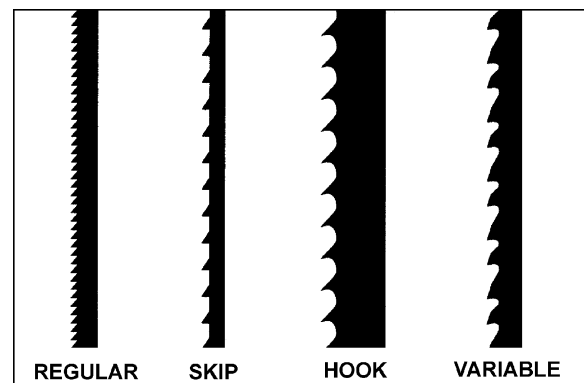


Figure 9-7: Blade Shape

9.10 Set

The term "set" refers to the way in which the saw teeth are bent or positioned. Set patterns are usually selected depending on the type of material that needs to be cut. Three common set patterns are shown in Figure 9-8.

Generally, the *Raker* set is used for cutting metal workpieces; the *Wave* set, when the thickness of the workpiece changes, such as cutting hollow tubing or structurals. The *Straight* set is most often preferred when cutting wood or plastics.

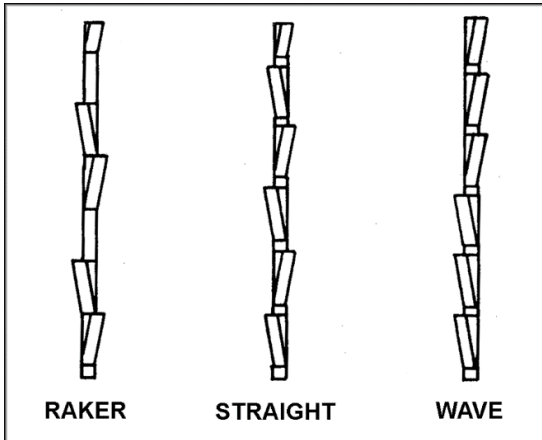


Figure 9-8: Blade Set

9.11 Material

Band saw blades can be made from different types of materials. Some of the most common include spring steel, carbon steel, carbon steel equipped with a high speed or welded edge (bi-metal), or carbide tips. A special type of saw blade is made from "high speed steel"; these should not be used on band saws with low rates of speed.

Because of the importance of blade selection, it is recommended that you use the *Blade Selection Guide* in *sect. 11.0*.

9.12 Blade Breakage

Band saw blades are subject to high stresses and breakage may sometimes be unavoidable. However, many factors can be controlled to help prevent most blade breakage. Follow blade manufacturer for blade recommendations for 18.5" wheels. Here are some common causes for breakage:

1. Misalignment of blade guides
2. Feeding work too fast
3. Using a wide blade to cut a short radius curve
4. Excessive tension
5. Teeth are dull or improperly set
6. Upper guides are set too high off workpiece
7. Faulty weld on blade
8. Blade too thick for wheel diameter

10.0 User Maintenance

⚠WARNING Before any intervention on the machine, disconnect it from electrical supply by pulling out the plug. Failure to comply may cause serious injury.

Clean band saw regularly to remove any resinous deposits and sawdust.

Keep miter slot and guide bearings clean and free of resin.

Keep blade clean and sharp. Check it periodically for cracks or other signs of wear.

The drive belt should be checked periodically. If it looks worn, frayed, glazed, or otherwise damaged, replace it.

Check that the cleaning brush over the band wheel is working properly and remove any deposits from the band wheels to avoid vibration and blade breakage.

Do not allow saw dust to build up in the upper- and lower-wheel housings. Vacuum or blow out dust from inside cabinet. (Use proper dust mask equipment).

The table surface must be kept clean and free of rust for best results. If rust appears, it can often be removed with a mixture of household ammonia, good commercial detergent and #000 steel wool. Alternatively, commercial rust removers can be found at many hardware stores.

Periodically apply a light coat of paste wax or other non-silicone protectant to the table surface. Select a product that will protect the metal and provide a smooth surface, without staining workpieces.

If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

Connect the band saw to a dust collection system of appropriate capacity of at least 600 CFM. (See our website Jettools.com for a full line of JET dust collectors.)

Periodically vacuum out the motor fan cover.

Periodically check the brake pedal socket set screw and tighten. See *Section 5.17 Setting Up Brake Pedal*.

10.1 Lubrication Points

1. Periodically apply a light, multi-purpose grease to the following:
 - Rack and pinion system of guide post.
 - Sliding surfaces of table trunnions.
2. Oil any pins, shafts, and joints. (Do not get oil on pulleys or belts.)
3. Clean and oil the blade tension mechanism if it becomes difficult to adjust.

Note: Bearings on the band saw are pre-lubricated and sealed, and do not require attention.

10.2 Additional Servicing

Any other servicing should be performed by an authorized service representative

11.0 Blade Selection Guide

Table 3

Identify the material and thickness of your workpiece. The chart will show the recommended PITCH, blade TYPE, and FEED RATE.

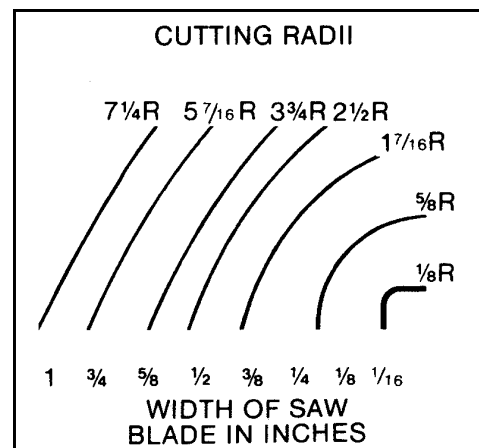
Key: H – Hook L – Low
 S – Skip M – Medium
 R – Regular H – High

Example: 10/H/M means 10 teeth per inch / Hook Type Blade / Medium Feed

Material/s		Workpiece Thickness			
		1/2"	1"	3"	6+"
Woods	Hardwood	10/R/L	8/R/L	3/H/M	3/H/M
	Softwood	10/R/L	8/R/L	3/H/M	3/H/M
Non-Metals	Carbon	10/R/L	6/R/L	3/S/M	3/S/M
	Mica	32/R/L	--	--	--
	Asbestos	8/R/L	6/R/L	3/S/M	3/S/M
	Hard Rubber	10/R/L	8/R/L	6/R/M	2/S/H
Plastics	Formica	14/R/M	10/R/M	4/H/H	4/H/H
	Masonite	10/R/L	4/S/L	3/S/M	3/H/M
	Micarta	14/R/M	10/R/M	4/H/H	3/H/H
	Plexiglas	10/R/L	6/R/L	3/S/M	3/S/M
	Paper	14/R/L	10/R/L	4/S/L	3/S/M

Study the part drawing or prototype, or measure the smallest cutting radius required, and locate this radius (in inches) on the chart at the right. Follow the curve to where the approximate blade width is specified. If a radius falls between two of the curves, select the widest blade that will saw this radius.

This procedure should be used for making initial blade selections. These recommendations can, of course, be adjusted to meet specific requirements of a cutting job. Compromises may be necessary if you cannot find all needed specifications in a single blade.



12.0 Troubleshooting JWBS-18SFX Band Saw

12.1 Operational Problems

Table 4

Symptom	Probable Cause	Correction
Table tilt does not hold position under load.	Lock handle not tight.	Tighten lock handle.
	Trunnion locking mechanism is broken or worn.	Replace trunnion locking mechanism.
Table will not tilt.	Trunnion not lubricated.	Lubricate trunnion.
	Trunnion jammed.	Disassemble and replace jammed parts.
Table vibration while sawing.	Band saw on uneven floor.	Place machine on level surface; use shims if needed.
	Loose fasteners.	Inspect and tighten screws, nuts, etc.
	Drive belt too slack.	Increase tension on drive belt. Replace belt if worn.
	Incorrect choice of saw blade pitch.	Check blade selection chart and use correct blade.
	Saw dust or debris on band wheel. Or tire is worn/damaged.	Keep band wheels clean. Replace tires if necessary.
Surface finish on workpiece is rough.	Blade pitch too coarse.	Change to finer pitch blade.
	Workpiece being fed too strongly.	Reduce feed force.
Blade cutting inaccurately. Cuts not straight.	Gum or pitch on blade.	Clean blade.
	Worn blade teeth or damaged blade.	Replace blade.
	Fence not parallel to blade.	Align fence properly.
	Incorrect adjustment of blade guides.	Adjust blade guides properly.
	Workpiece being fed too strongly.	Reduce feed force.
	Upper blade guides not located close enough to workpiece.	Position guides about 3/16" above workpiece.
	Incorrect choice of saw blade for that particular operation.	Install correct blade.
	Blade tension too light.	Increase tension.
Blade cannot be tensioned properly.	Tension spring is fatigued.	Replace tension spring (contact JET service representative).
Blade binds in workpiece.	Incorrect blade tension or damaged blade.	Correct accordingly.
	Blade too wide for desired radius.	Select narrower blade.
Blade forms cracks at base of teeth.	Teeth not suitable for operation, or incorrectly set.	Replace with proper blade.
	Blade thickness not suitable for band wheel diameter.	Replace with proper thickness blade.
	Blade sharpened incorrectly, becomes overheated.	Sharpen blade properly or replace.
	Band wheels have become misaligned.	Contact JET service representative.
Cracks on back edge of blade.	Workpiece being fed too quickly.	Reduce feed speed to lessen strain on blade.
	Welding on blade not perfectly aligned.	Eliminate welded part, and re-weld properly; or acquire a new blade. Round (i.e. "stone") the back edge of a new blade.
	Thrust bearing is worn; caused by constant contact with back of blade.	Replace thrust bearing. Adjust new bearing according to instructions.

Symptom	Probable Cause	Correction
Blade breaks prematurely.	Feed force too great.	Reduce feed force.
	Blade pitch too coarse.	Refer to blade selection chart; use finer pitch blade.
	Guide bearings not properly supporting blade.	Check guide bearings for correct position and signs of wear. Adjust or replace as needed.
	Blade tensioned too tightly.	Reduce tension.
Blade breaks close to weld.	Blade overheated during welding.	Have blade annealed or eliminate brittle part and weld correctly.
	Blade cooled too rapidly after welding.	Have blade annealed or eliminate brittle part and weld correctly.
Premature dulling of saw teeth.	Blade pitch too fine.	Refer to blade selection chart. Use blade with coarser pitch.
	Feed pressure too light.	Increase feed pressure.
	Cutting rate too low.	Increase feed pressure and cutting rate.
	Incorrect choice of blade.	Re-examine material. Select proper blade from chart.
	Chipped tooth or foreign object lodged in cut.	Stop saw and remove lodged particle. Replace blade if damaged.

12.2 Mechanical and Electrical Problems

Table 5

Symptom	Probable Cause	Correction *
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	No incoming power.	Verify machine connections.
	Cord damaged.	Replace cord.
	Band Saw frequently trips.	One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to reduce feed pressure into the blade. If this does not resolve the issue, check for a loose electrical lead.
	Building circuit breaker trips or fuse blows.	Verify that band saw is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead.
	Switch or motor failure (how to distinguish).	If you have access to a voltmeter, you can separate a switch failure from a motor failure by first, verifying incoming voltage at 115 +/-10% (or 230+/-10%) and second, checking the voltage between switch and motor at 115 +/-10% (or 230+/-10%). If incoming voltage is incorrect, you have a power supply problem. If voltage between switch and motor is incorrect, you have a switch problem. If voltage between switch and motor is correct, you have a motor problem.
	Motor overheated.	Clean motor of dust or debris to allow proper air circulation. Allow motor to cool down before restarting.
	Motor failure.	Have a qualified electrician or motor repair shop test the motor for function.
	Miswiring of unit.	Double check to confirm all electrical connections are correct. Refer to wiring diagram to make needed corrections.

Symptom	Probable Cause	Correction *
	Switch failure.	If the start/stop switch is suspect, you have two options: Have a qualified electrician test the switch for function or purchase a new start/stop switch and establish if that was the problem on change-out.
Band Saw does not attain full speed.	Extension cord too light or too long.	Replace with adequate size and length cord.
	Low current.	Contact a qualified electrician.
	Motor failure.	Have a qualified electrician or motor repair shop test the motor for function.

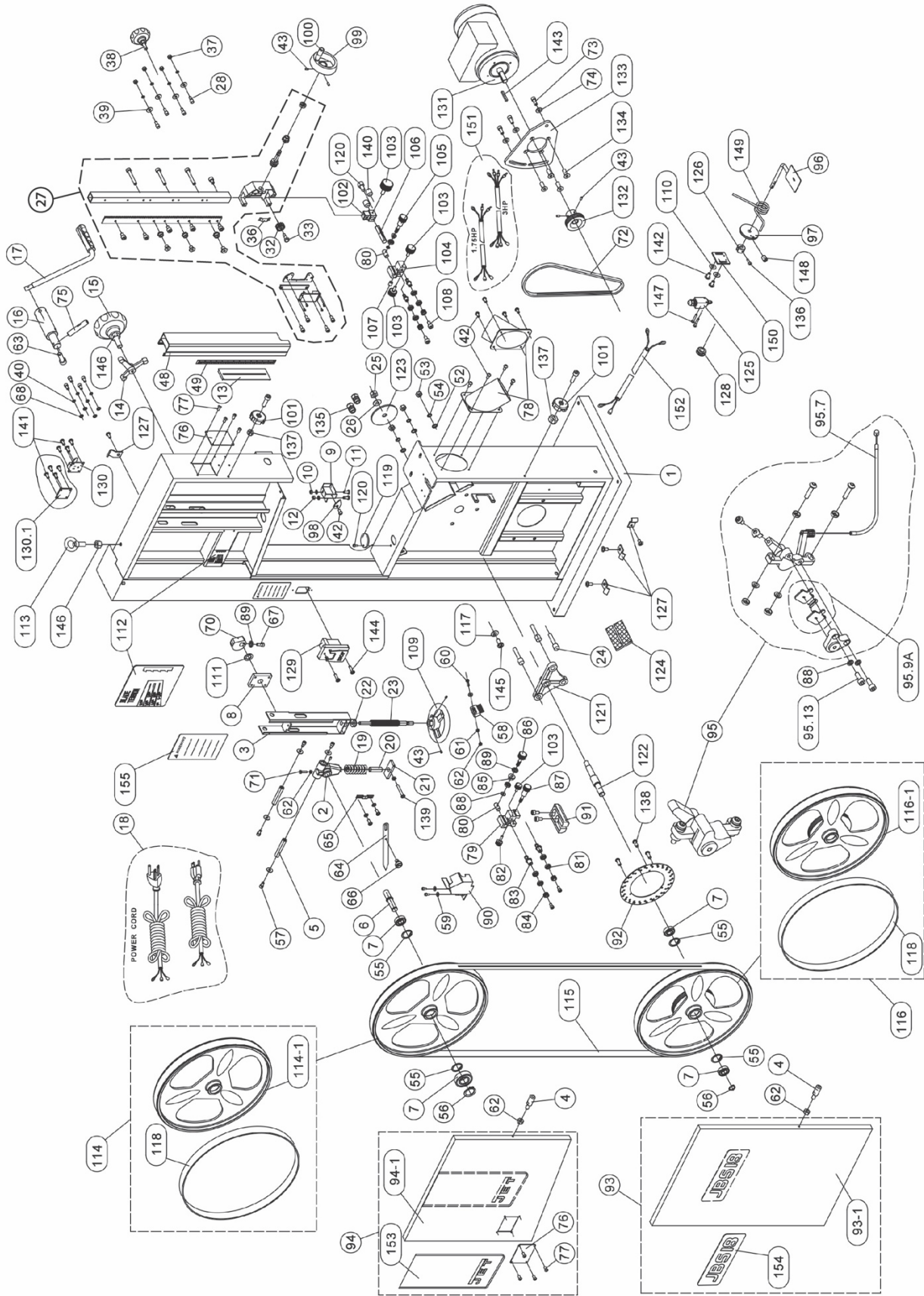
* **WARNING:** Some corrections may require a qualified electrician.

13.0 Replacement Parts

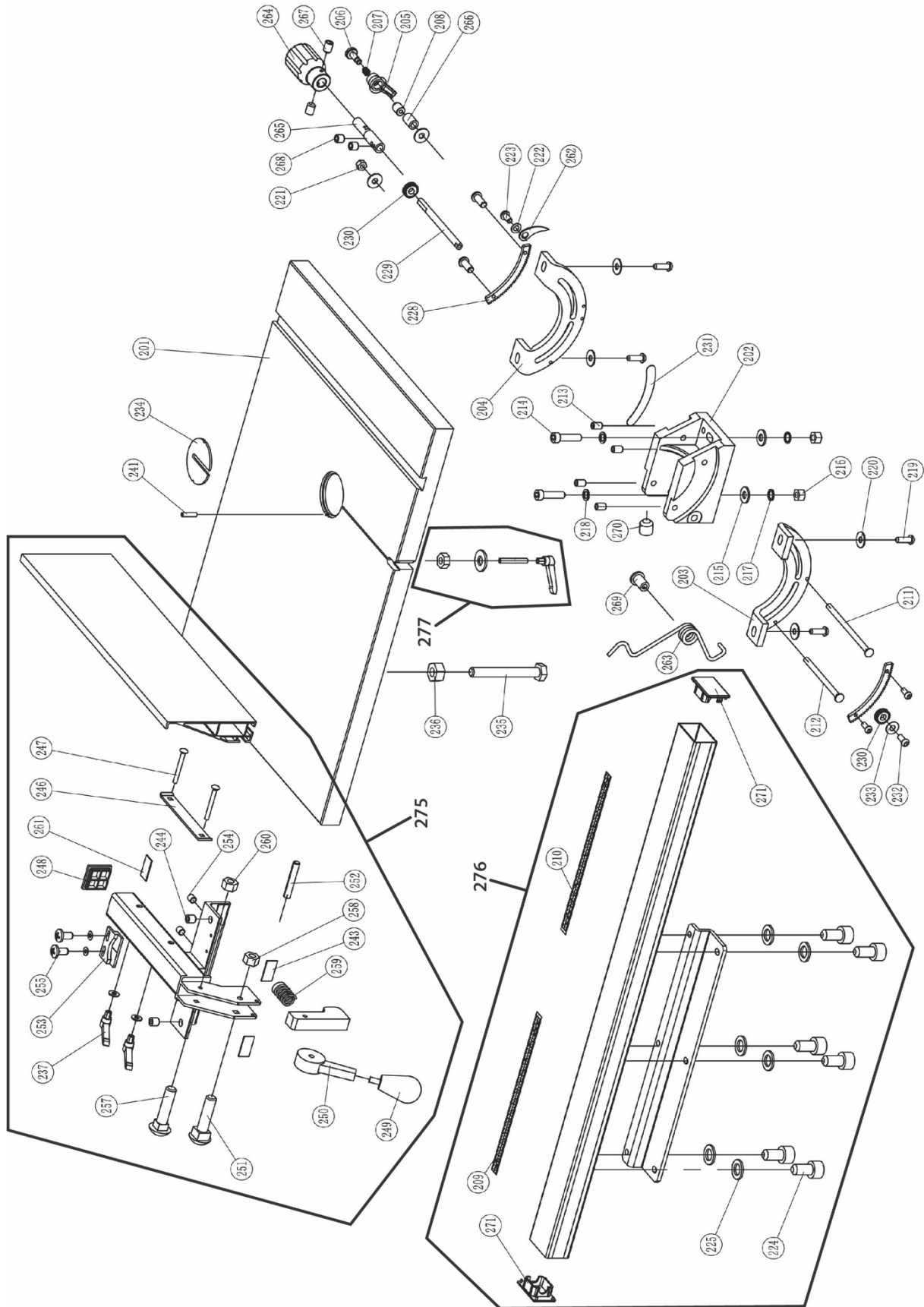
Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only and may not be available individually.

13.1.1 JWBS-18SFX Bandsaw Assembly – Exploded View



13.1.2 JWBS-18SFX Table, Fence, & Lower Blade Guide Assembly – Exploded View



13.1.3 JWBS-18SFX Bandsaw Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	Part Not Offered	Machine Main Body Frame		1
2	JWBS18SFX-002	Upper Wheel Axis Seat		1
3	JWBS18SFX-003	U-Bracket		1
4	JWBS14SFX-075	Shaft		2
5	JWBS18SFX-005	Upper Shaft		2
6	JWBS18SFX-006	Upper Wheel Shaft		1
7	BB-6004ZZ	Bearing	6004/2RZ	4
8	JWBS14SFX-014	Eccentric Base		1
9	JWBS18SFX-009	Guard Board		1
10	TS-1540021	Hex Nut	M4	3
11	TS-1532032	Pan Head Machine Screw	M4x10	2
12	TS-1550021	Flat Washer	4mm	4
13	JWBS18SFX-013	Activity Protective Board		1
14	JWBS14SFX-034	Handle		1
15	JWBS18SFX-015	Lock Handle (include #146)		1
16	JWBS14SFX-020	Shaft		1
17	JWBS14SFX-028	Tension Handle and Grip		1
18	JWBS14SFX-024	Power Cord 14AWGx3C, 5-15P/115V	1-3/4HP	1
	JWBS18SFX-018	Power Cord 14AWGx3C, 6-15P/230V	3HP	1
19	JWBS18SFX-019	Spring		1
20	JWBS18SFX-020	Sleeve		1
21	JWBS18SFX-021	Pointer Seat		1
22	JWBS18SFX-022	Bearing	8201	1
23	JWBS18SFX-023	Blade Tension Shaft		1
24	JWBS14SFX-080	Bolt		3
25	TS-2342161	Hex Nut, Nylon Lock	M16	1
26	TS-155010	Flat Washer	16mm	2
27	JWBS18SFX-27	Gear Box Assembly		1
28	JWBS18SFX-028	Double Headed Bolt		4
32	JWBS14SFX-018	Gear		1
33	JWBS14SFX-017	Gear Shaft		1
36	JWBS14SFX-093	Upper Guide Insert		1
37	TS-1541031	Hex Nut	M8	5
38	JWBS14SFX-023	Knob		1
39	TS-1550061	Flat Washer	8 mm	8
40	TS-2361081	Spring Washer	M8	8
42	F009875	Socket Head Button Screw	M4x8	13
43	TS-1523041	Socket Set Screw	M6x12	5
48	JWBS18SFX-048	Blade Guard		1
49	JWBS18SFX-049	Cutting Height Scale		1
52	TS-2360121	Flat Washer	12mm	3
53	TS-1540083	Hex Nut	M12	3
54	TS-2361121	Lock Washer	12mm	3
55	JWBS18SFX-055	C-Ring	42	4
56	JWBS18SFX-056	C-Ring	20	2
57	TS-1504031	Socket Head Cap Screw	M8x16	8
58	JWBS18SFX-058	Brush		1
59	TS-1550041	Flat Washer	6 mm	3
60	TS-2286302	Pan Head Machine Screw	M6x30	1
61	TS-1550041	Flat Washer	6 mm	2
62	TS-1540041	Hex Nut	M6	4
63	TS-1515031	Socket Flat Head Screw	M8x25	1
64	JWBS18SFX-064	Tension Pointer		1
65	JWBS18SFX-065	Tension Indicator Plate		1
66	JWBS18SFX-066	Slotted Head Screw		1
67	TS-1503071	Socket Head Cap Screw	M6x30	1
68	TS-1550061	Flat Washer	8mm	4
70	JWBS18SFX-070	Eccentric Shaft		1
71	TS-1503061	Socket Head Cap Screw	M6x25	1
72	JWBS18SFX-072	Multi Wedge Belt	4PL1150	1

Index No.	Part No.	Description	Size	Qty
73	TS-1505041	Socket Head Cap Screw	M10x30	3
74	TS-1550071	Flat Washer	M10	3
75	JWBS18SFX-075	Socket Set Screw, CPP		1
76	JWBS18SFX-076	Sight Glass		1
77	JWBS14SFX-131-2	Rivet	4x8 mm	8
78	JWBS14SFX-067	Dust Chute	100 mm	2
79	JWBS14SFX-270	Guide Base, Lower Guide		1
80	JWBS18SFX-080	Bearing Nut		2
81	BB-61900ZZ	Ball Bearing	61900/2RZ	10
82	JWBS14SFX-268	Knurled Lock Knob B		1
83	JWBS14SFX-139	Eccentric Shaft		1
84	JWBS14SFX-140	Bearing Bushing		1
85	JWBS14SFX-119	Sleeve		2
86	JWBS14SFX-269	Knurled Lock Knob C		1
87	JWBS18SFX-267	Knurled Lock Knob A		1
88	TS-1550071	Flat Washer	6 mm	3
89	TS-2361061	Lock Washer	M6	2
90	JWBS14SFX-272	Lower Blade Guard		1
91	JWBS14SFX-271	Wedge Way Guide		1
92	JWBS18SFX-092	Brake Disc		1
93	JWBS18SFX-093	Lower Door Assembly		1
93-1	JWBS18SFX-0931	Lower Door		1
94	JWBS18SFX-094	Upper Door Assembly		1
94-1	JWBS18SFX-0941	Upper Door		1
95	JWBS18SFX-095	Brake Assembly Kit		1
95.7	JWBS18SFX-957	Brake Line		1
95.9A	JWBS18SFX-959A	Brake Pads Kit		1
95.13	TS-1503041	Socket Head Cap Screw	M6x16	2
96	JWBS18SFX-096	Brake Pedal		1
97	JWBS18SFX-097	Brake Disc A		1
98	JWBS18SFX-098	Pointer		1
99	JWBS18SFX-099	Handle Wheel	5"	1
100	TS-2361101	Handle		1
101	JWBS14SFX-022	Door Lock Knob		2
102	JWBS18SFX-102	Upper Guide Mount		1
103	JWBS14SFX-138	Lock Knob		4
104	JWBS18SFX-104	Upper Guide Base		1
105	JWBS14SFX-267	Knurled Lock Knob A		1
106	JWBS18SFX-106	Bearing Guide Rod		1
107	TS-2276081	Set Screw	M6x8	3
108	TS-1502021	Socket Head Cap Screw	M5x10	4
109	JWBS18SFX-109	Handle Wheel		1
110	TS-1550031	Flat Washer	5 mm	2
111	TS-1550111	Flat Washer	20 mm	1
112	JWBS18SFX-112	Tension Gauge		1
113	PM1500-004	Lifting Ring	M10	1
114	JWBS18SFX-114K	Upper Wheel Assembly		1
114-1	JWBS18SFX-1141	Upper Wheel		1
115	JWBS18SFX-115	Saw Blade*	Optional	1*
116	JWBS18SFX-116K	Lower Wheel Assembly		1
116-1	JWBS18SFX-1161	Lower Wheel		1
117	TS-1550021	Flat Washer	4mm	1
118	JWBS18SFX-118	Tire		2
119	JWBS18SFX-119	Positioning Plate		1
120	TS-1503031	Socket Head Cap Screw	M6x12	6
121	JWBS18SFX-121	Lower Wheel Bracket		1
122	JWBS18SFX-122	Lower Wheel Shaft		1
123	JWBS18SFX-123	Plate		1
124	JWBS18SFX-124	Wood Insert		1
125	JWBS18SFX-125	Travel Switch	QKS7	1
126	JWBS18SFX-126	Travel Switch Base		1
127	JWBS14SFX-076	Cord Clip		4

Index No.	Part No.	Description	Size	Qty
128	JWBS18SFX-128	Wire Sleeve		1
129	JWBS18SFX-129	ON/OFF Switch / 1.75HP	KJD17B (115V)	1
	JWBS18SFX-1293	ON/OFF Switch / 3HP	KJD17B-16 (230V)	1
130	JWBS14SFX-065	Electrical Socket 115V 1.75HP	1-3/4HP	1
130.1	JWBS18SFX-130.1	Cover; 230V 3HP	3HP	1
131	JWBS18SFX-131	Motor Assembly	1-3/4HP/115V	1
	JWBS18SFX-131W	Wiring Diagram (not shown)		1
	JWBS18SFX-ML	Motor Label, JWBS-18SFX-1.75HP (not shown)	1-3/4HP/115V	1
	JWBS18SFX-131F	Motor Fan (not shown)		1
	JWBS18SFX-131C	Motor Fan Cover (not shown)		1
	JWBS18SFX-131R	Running Capacitor (not shown)	40µF, 450V AC	1
	JWBS18SFX-131S	Start Capacitor (not shown)	100µF, 265V AC	1
	JWBS18SFX-131J	Junction Box (not shown)		1
	JWBS18SFX-131B	Junction Box Cover (not shown)		1
	JWBS18SFX-313	Motor Assembly	3HP/230V	1
	JWBS18SFX-313F	Motor Fan (not shown)		1
	JWBS18SFX-313C	Motor Fan Cover (not shown)		1
	JWBS18SFX-313S	Start Capacitor (not shown)	150 µF, 265VAC	1
	JWBS18SFX-313R	Running Capacitor (not shown)	40µF, 450VAC	1
	JWBS18SFX-313J	Junction Box (not shown)		1
	JWBS18SFX-313B	Junction Box Cover (not shown)		1
	JWBS18SFX-ML3	Motor Label, JWBS-18SFX-3HP (not shown)		1
132	JWBS18SFX-132	Motor Pulley 1.75HP	1-3/4HP	1
	JWBS18SFX-1323	Motor Pulley 3HP/230V	3HP	1
133	JWBS18SFX-133	Motor Plate	1-3/4HP	1
	JWBS18SFX-1333	Motor Plate	3HP	1
134	TS-1514021	Socket Head Flat Screw	M6x16-1-3/4HP	4
	TS-1515011	Socket Head Flat Screw	M8x16-3HP	4
135	JWBS18SFX-135	Strain Relief	M16	2
136	TS-1503051	Socket Head Cap Screw	M6x20	3
137	TS-1541021	Nylon Lock Hex Nut	M6	2
138	TS-2245122	Socket Head Button Screw	M5x12	3
139	TS-2284302	Pan Head Machine Screw	M4x30	1
140	TS-1522011	Socket Set Screw	M5x6	3
141	TS-2284081	Flat Head Cap Screw	M4x8	4
142	TS-1533032	Pan Head Machine Screw	M5x10	6
143	6294761	Key 1.75HP	6x45	1
	JWBS18SFX-1433	Key 3HP	8x45	1
144	TS-1532052	Pan Head Machine Screw	M4x16	2
145	TS-2284082	Pan Head Machine Screw	M4x8	3
146	TS-2342101	Hex Nut	M10	2
147	TS-2284302	Pan Head Machine Screw	M4x25	2
148	TS-1524021	Socket Set Screw	M8x10	1
149	JWBS18SFX-149	Spring		1
150	JWBS18SFX-150	Plate for QKS7 Switch		1
151	JWBS18SFX-151	Motor Cord for 1.75HP	14AWGx3C	1
	JWBS18SFX-1513	Motor Cord for 3HP	14AWGx4C	1
152	JWBS18SFX-152	Cord for QKS7 Switch	20AWGx2C	1
153	JWBS18SFX-153	JET Logo with Adhesive		1
154	JWBS18SFX-154	JBS18 Model Logo with Adhesive		1
155	JWBS18SFX-155	Warning Label, JWBS-18SFX		1
201	JWBS18SFX-201	Table (includes #241)		1
202	JWBS18SFX-202	Lower Table Trunnion		1
203	JWBS18SFX-203	Upper Table Trunnion A		1
204	JWBS18SFX-204	Upper Table Trunnion B		1
205	JWBS18SFX-205	Lock Handle		1
206	JWBS18SFX-206	Screw		1
207	JWBS18SFX-207	Spring		1
208	JWBS18SFX-208	Gear		1
209	JWBS18SFX-209	Scale A		1
210	JWBS18SFX-210	Scale B		1
211	JWBS18SFX-211	Carriage Bolt	M8x140	1

Index No.	Part No.	Description	Size	Qty
212	JWBS18SFX-212	Carriage Bolt	M8x115	1
213	TS-1525031	Socket Set Screw	M10x16	4
214	TS-1505061	Socket Head Cap Screw	M10x40	2
215	TS-1550071	Flat Washer	10 mm	2
216	TS-2342101	Hex Nut	M10	2
217	TS-2361101	Lock Washer	10mm	2
218	TS-1550071	Flat Washer	10 mm	2
219	TS-2248252	Socket Head Button Screw	M8x25	4
220	JWBS18SFXHP4	Big Flat Washer	8 mm	6
221	TS-1541031	Nylon Lock Hex Nut	M8	1
222	TS-1550021	Flat Washer	4 mm	1
223	TS-2244102	Socket Head Button Screw	M4x10	1
224	TS-1504031	Socket Head Cap Screw	M8x16	6
225	TS-1503031	Flat Washer	8 mm	6
226	JWBS18SFX-226	Fence Rail Extrusion		1
227	JWBS18SFX-227	Fence Rail Base		1
228	JWBS18SFX-228	Rack		2
229	JWBS18SFX-229	Gear Shaft		1
230	JWBS18SFX-230	Gear		2
231	JWBS18SFX-231	Scale		2
232	TS-2245122	Socket Head Button Screw	M5x12	5
233	TS-1550031	Flat Washer	5 mm	3
234	JWBS18SFX-234	Table Insert		1
235	JWBS18SFX-235	Hex Cap Screw	M8x65	1
236	TS-1541031	Hex Nut	M8	1
237	JWBS18SFX-237	Adjustable Handle	M6	2
238	TS-1550041	Flat Washer	6 mm	2
241	JWBS18SFX-241	Pin	3x10	1
243	JWBS18SFX-243	Friction Plate		2
244	TS-1526011	Socket Set Screw	M12x12	2
246	JWBS18SFX-246	Lock Bar		1
247	JWBS18SFX-247	Carriage Bolt	M6x55	1
248	JWBS18SFX-248	Cap for Fence Base		1
249	JWBS18SFX-249	Knob		1
250	JWBS18SFX-250	Eccentric Wheel		1
251	JWBS18SFX-251	Carriage Bolt	M8x35	1
252	JWBS18SFX-252	Pin	5x30	1
253	JWBS18SFX-253	Pointer		1
254	TS-1525011	Socket Set Screw	M10x10	2
255	TS-1533032	Pan Head Machine Screw	M5x10	2
257	JWBS18SFX-257	Carriage Bolt	M6x35	1
258	TS-1541031	Nylon Lock Hex Nut	M8	1
259	JWBS18SFX-259	Spring		1
260	TS-1541021	Nylon Lock Hex Nut	M6	1
261	JWBS18SFX-261	Washer		1
262	JWBS18SFX-262	Pointer		1
263	JWBS18SFX-263	Spring		1
264	JWBS18SFX-264	Handle		1
265	JWBS18SFX-265	Shaft		1
266	JWBS18SFX-266	Sleeve		1
267	TS-2276081	Socket Set Screw	M6x8	2
268	TS-1523011	Socket Set Screw	M6x6	2
269	JWBS18SFX-269	Shaft for Spring		1
270	TS-1522011	Socket Set Screw	M5x6	1
271	JWBS18SFX-271	Cap for Fence Rail		2
275	JWBS18SFX-242A	Fence Base Assembly		1
276	JWBS18SFX-226A	Fence Rail Assembly		1
277	JWBS18SFX-277A	Lock Handle Assembly		1

Index No.	Part No.	Description	Size	Qty
.....	JWBS18SFX-ID	ID Label, JWBS-18SFX (not shown)		1
.....	JWBS18SFX-ML	Motor Label, JWBS-18SFX-1.75HP (not shown)	1-3/4HP/115V	1
.....	JWBS18SFX-ML3	Motor Label, JWBS-18SFX-3HP (not shown)	3HP/230V	1
.....	JET750-55	Hex wrench (not shown)	2.5mm	1
.....	TS-152704	Ball End Hex wrench (not shown)	3mm	1
.....	TS-152705	Hex wrench (not shown)	4mm	1
.....	TS-152706	Hex wrench (not shown)	5mm	1
.....	TS-152707	Hex wrench (not shown)	6mm	1
.....	JWBS18SFX-HPN	Hardware Package (see sect. 5-1 for contents)		
HP1	TS-1504031	Socket Head Cap Screw	M8x16	3
HP2	TS-1550061	Flat Washer	8mm	3
HP3	TS-2248252	Hex Socket Head Button Screw	M8x25	4
HP4	JWBS18SFXHP4	Big Flat Washer	8mm	4
HP5	F009884	Socket Head Button Screw	M5x8	4

* Optional Accessory – see your dealer to order.

13.1.4 JWBS-18SFX (#714403) – Band Saw Light Kit * – Exploded View

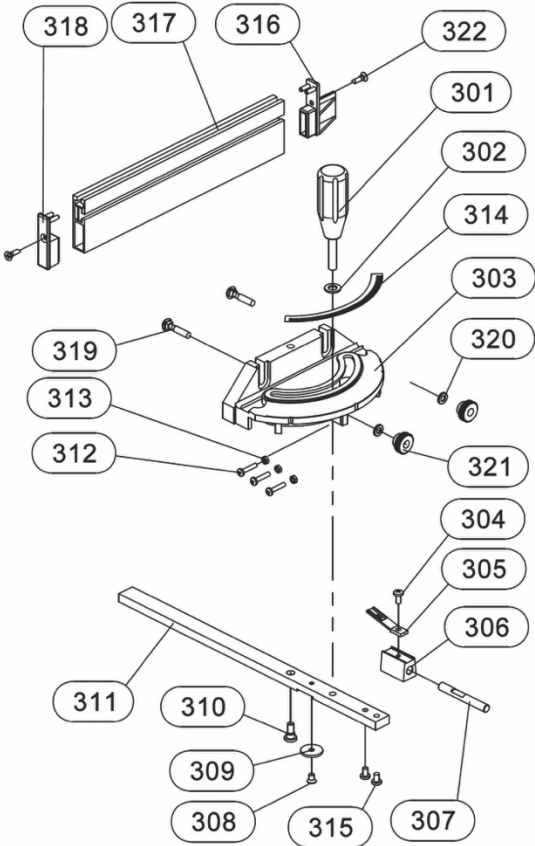


* Optional Accessory – see your dealer to order.

13.1.5 JWBS-18SFX Light Kit* (#714403) – Parts List (Optional Accessory)

Index No	Part No	Description	Size	Qty
.....	714403	Band Saw Light Kit (#501 thru 503).....		1
501	JWBS14SFX-503	Light (110V—230V)		1
502	TS-1502041	Socket Head Cap Screw	M5x16	4
503	TS-152705	Hex Wrench	4mm	1
.....	LM000338	ID Label, JWBS-14LIT (not shown)		1

13.1.6 JWBS-18SFX (#714401) – Miter Gauge* – Exploded View

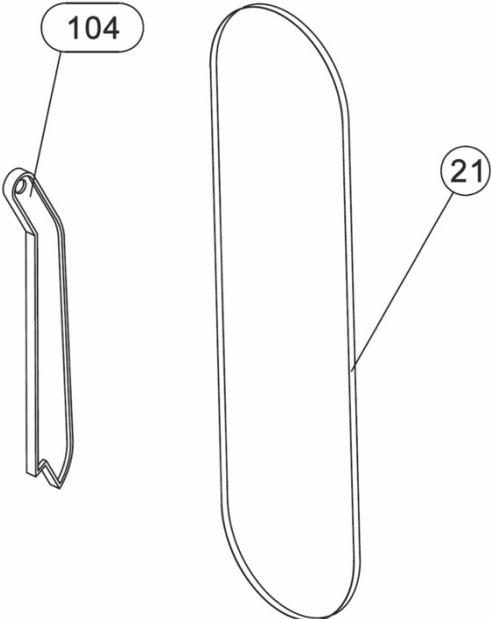


* Optional Accessory – see your dealer to order.

13.1.7 Miter Gauge Assembly for JWBS-18SFX Band Saw* (Optional Accessory)

Index No	Part No	Description	Size	Qty
.....	JWBS14SFX-300	Miter Gauge Assembly (#301 thru 322)		1
301	JWBS14SFX-301	Miter Gauge Handle		1
302	TS-1550061	Flat Washer	8mm	1
303	JWBS14SFX-303	Miter Gauge		1
304	TS-1534041	Flat Head Machine Screw	M5x10	1
305	JWBS14SFX-305	Pointer		1
306	JWBS14SFX-306	Pointer Base		1
307	JWBS14SFX-307	Shaft		1
308	JWP208-053A	Flat Head Machine Screw	M5x8	1
309	JWBS14SFX-309	Washer		1
310	JWBS14SFX-310	Screw		1
311	JWBS14SFX-311	Sliding Guide		1
312	TS-2284202	Pan Head Machine Screw	M4x20	3
313	TS-1540021	Hex Nut	M4	3
314	JWBS14SFX-314	Scale		1
315	TS-1533032	Pan Head Machine Screw	M5x10	2
316	JWBS14SFX-316	Cap A		1
317	JWBS14SFX-317	Miter Gauge Fence		1
318	JWBS14SFX-318	Cap B		1
319	JWBS14SFX-319	Carriage Bolt	M6x30	2
320	TS-1550041	Flat Washer	6mm	2
321	JWBS14SFX-321	Thumbnut	M6	2
322	F011652	Self-Tapping Screw	#8x3/8"	2

13.1.8 JWBS-18SFX (#714401) – Blade & Push Stick* – Exploded View



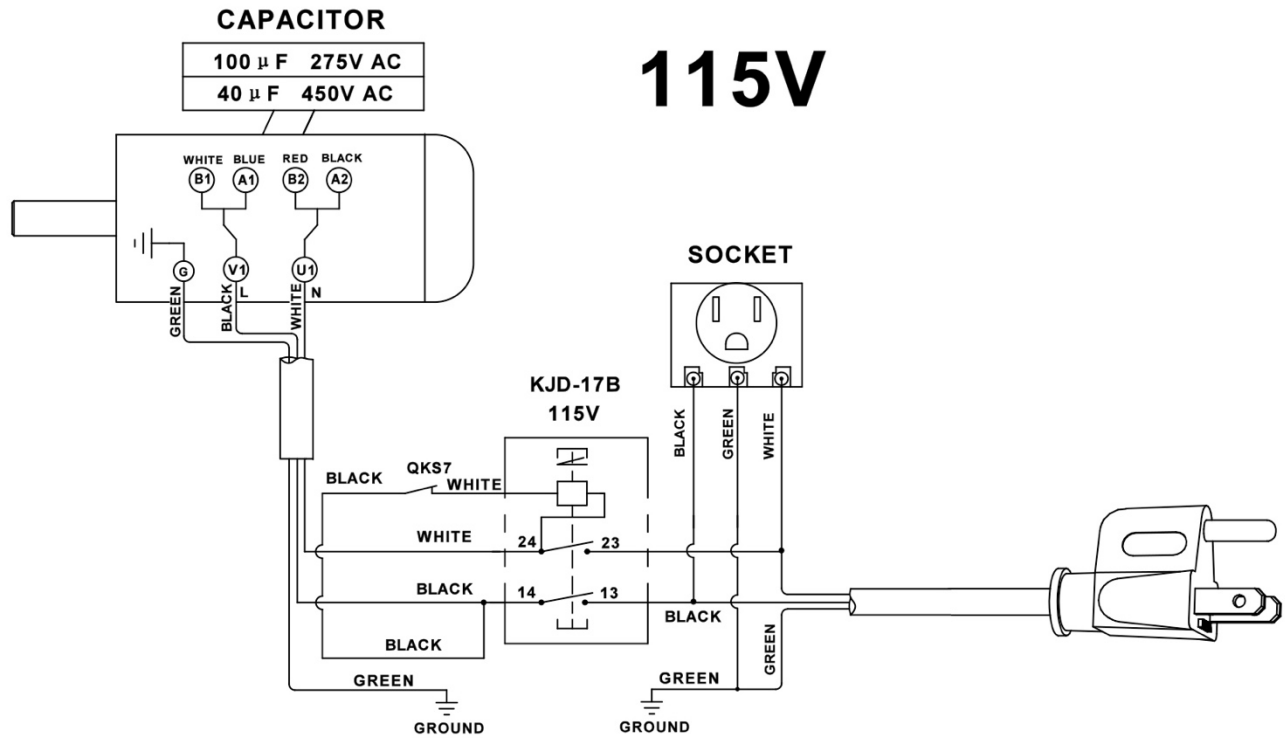
* Optional Accessory – see your dealer to order.

13.1.9 Blade & Push Stick for JWBS-18SFX Band Saw* (Optional Accessory)

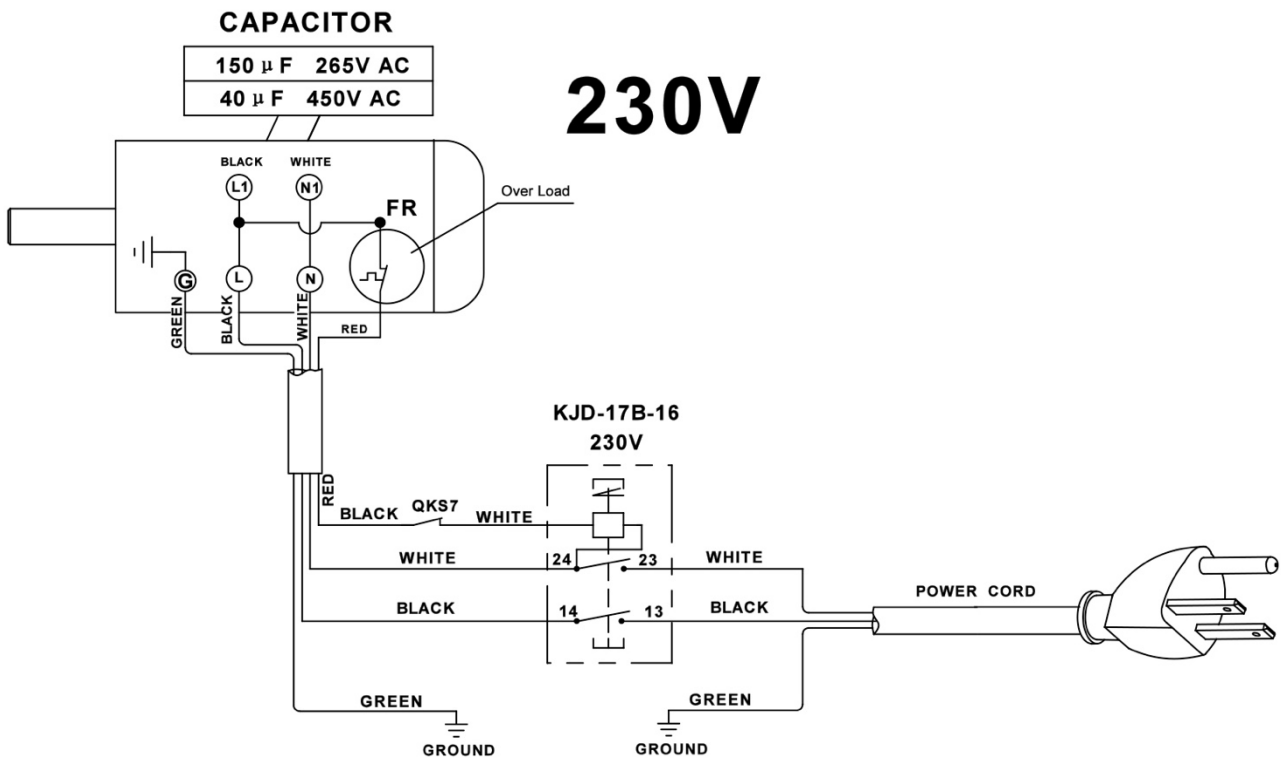
Index No	Part No	Description	Size	Qty
104	JWBS14SFX-104	Push Stick, Red		1
021	JWBS18SFX-115	Saw Blade		1

14.0 Electrical Connections

14.1 Connections for 1.75HP (Model number: JWBS-18SFX, Stock number : JT1-549)



14.2 Connections for 3HP (Model number: JWBS-18SFX-3, Stock number : JT1-548)



15.0 Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90-day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations, or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five-Year Warranty that are used for commercial or industrial purposes default to a Two-Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

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Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

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