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# **Pneumatic Band Saw Stainless Steel Type 5 6031 0010 Tech. Doc. No. 502**



Illustration can differ from the original

## **Repair Manual and Spare Parts List**

## REPAIR INSTRUCTION

Disassembly and re-assembly should be done according to the sectional drawing only.

The pneumatic motor with the handle can be removed from the band saw head after loosening the fillister-head screws item 77.

### Disassembly of motor/ replacement of vanes

Unlock locking ring item 18 and take out front motor component consisting of thrust collar item 16, Belleville spring item 17 and shaft seal ring item 20 with ring item 19.

Touch the motor housing softly to a wooden surface to pull out inner motor parts.

Pull off end plate item 12 with bearing item 13, snap ring item 14 and spacer item 15 from rotor item 10 and take out locking pin item 8. Disassemble snap ring item 14 and take out bearing item 13.

Remove cylinder bushing item 6 and vanes item 11. Pull off end plate item 2 with bearing item 3 and spacer item 5 from rear rotor seat item 10. Unlock snap ring item 4 and disassemble bearing item 3. Screw off silencer item 22.

### Reassembly of motor

Reassembly is performed essentially the same as disassembly, but in reverse order. Inspect all parts for wear and damage. Replace any worn or damaged parts.

Vanes item 11 should be exchanged.

Vanes are considered worn if their width is less than 9.7 mm (3/8").

### Disassembly of handle

Untighten screw plug item 37. Remove spring item 35, ball item 34, seal item 32 and cylindrical pin item 33.

Hit out double notched pin item 31 and remove Pusher item 30.

Take out screw plug item 40, spring item 39 and locking bolt item 38.

### Reassembly of handle

Reassembly is performed in reverse order.

### Disassembly of band saw head

Undo screws item 12 and 42 and detach pulleys item 7 and 40 with tire pulleys.

After undoing screw item 47, detach washer item 48, needle bearing item 43 and washers item 44 and 45. Unscrew hexagonal nut item 72, and remove washer item 73. Undo hexagonal nut item 71 and screw out threaded pin item 70. Loosen screw item 32 and pull out tension sleeve item 31. Pull out tension shaft item 27 and knob item 28. Remove pin item 29 and separate knob item 28 from tension shaft item 27. After loosening hexagonal nuts item 75 pull out washers item 73 remove yoke item 30 as well as spring item 37 and washer item 33. Undo screws item 59 and 69 and remove stop item 74 and guides item 50 and 60.

#### Reassembly of band saw head

Reassembly is performed essentially the same as disassembly, but in reverse order.  
Control function by moving pulleys item 7 and 40 before connecting the motor.

For disassembling the gearbox, remove the pulley item 7 by loosening the screws item 12.

#### Disassembly of the Gearbox

Pull off planet carrier item 9. Take out all gearbox stages and remove planetary wheels item 5, 8, 11 and needle bearings item 4, 7, 0. Take out bearing item 14. Remove snap rings item 15 and pull out bearing ring item 12 with second bearing item 14. Separate pinion item 20, 21 from planet carrier item 3, 6.

#### Reassembly of Gearbox

Reassembly is performed essentially the same as disassembly but in reverse order.  
Add sufficient grease to gearbox.

#### **Spare Parts**

Only original spare parts may be used. There is no warranty for damages and liability is disclaimed, if non-original spare parts and accessories are used.

<b>Spare Parts List</b>					
Description:  <b>Pneumatic Band Saw</b>					Part and drawing number: <b>5 6031 0010</b>
Item	Qty.	Description	Part and drawing no.		Remarks
	1	Pneumatic band saw 5 6031 0010			
		consisting of:			
1	1	Band saw standard equipment	5 6031 0000		see extra list
2	1	Handle	5 6032 6010		
3	2	Fillister-head screw	9 1112 3110		
4	1	Nipple	9 2201 0010		

<b>Spare Parts List</b>					
Description:  <b>Band Saw Body</b>				Part and drawing number: <b>5 6031 0000</b>	
Item	Qty.	Description	Part and drawing no.		Remarks
1	1	Band saw head	5 6031 8000		see extra list
2	1	Pneumatic motor	5 6037 0020		see extra list
3	1	Saw band 10-14 tpi variable	9 2506 0230		

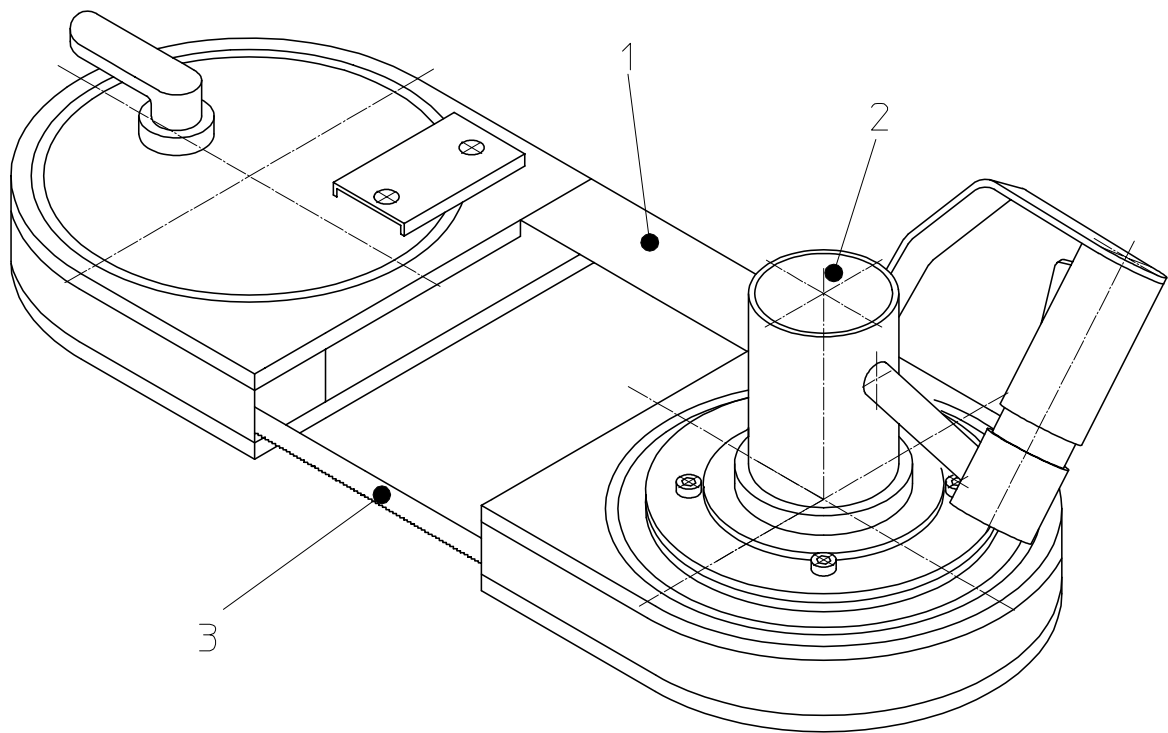
### Spare Parts List

Description:

**Band Saw Body**

Part- and drawing number:

**5 6031 0000**



## Spare Parts List

Description:

**Band Saw Head**

Part and drawing number:

**5 6031 8000**

Item	Qty.	Description	Part and drawing no.	Remarks
1	1	Frame Assy.	5 6031 7000	see extra list
2	1	Gearbox	5 6030 4000	see extra list
7	1	Drive pulley, Assy.	5 6031 8180	
		consisting of:		
	1	Drive pulley	5 6031 8080	
	1	Tire pulley	5 6031 8050	
12	3	Counter-sunk screw	9 1113 4090	
13	6	Stop washer	9 1714 0040	
27	1	Tension shaft	5 6030 8360	
28	1	Tension lever	5 6030 6210	
29	1	Brace	9 1630 0020	
30	1	Yoke	5 6003 7040	
31	1	Tension sleeve	5 6003 7060	
32	1	Fillister-head screw	9 1112 3110	
33	1	Pulley, Assy.	5 6030 7930	
	1	Pulley shaft	5 6030 7280	
36	2	Fillister-head Screw	9 1112 5160	
37	2	Tension Spring	9 1808 0240	
40	1	Drive pulley, Assy.	5 6031 8180	
		consisting of:		
	1	Drive pulley	5 6031 8080	
	1	Tire pulley	5 6031 8050	
41	1	Bearing ring	5 6030 8580	
42	3	Counter-sunk screw	9 1113 4070	
43	1	Needle bearing	9 1014 0330	
44	2	Washer	9 3333 0010	
45	1	Washer	9 3325 0870	

<b>Spare Parts List</b>					
Description:				Part and drawing number	
<b>Band Saw Head</b>				<b>5 6031 8000</b>	
Item	Qty.	Description	Part and drawing no.		Remarks
47	1	Flat-head screw	9 1116 5020		
48	1	Washer	9 3325 0850		
50	1	Guide unit I	5 6031 7980		see extra list
58	2	Snap ring	9 3329 0010		
59	2	Fillister-head screw	9 1110 2020		
60	1	Guide unit II	5 6031 7990		see extra list
68	2	Snap ring	9 3329 0010		
69	2	Fillister-head screw	9 1112 3150		
70	1	Threaded pin	5 6030 8410		
71	1	Hexagonal nut	9 1203 0310		
72	1	Hexagonal nut	9 1210 0120		
73	3	Washer	9 3302 0020		
74	1	Work stop	5 6031 8100		
75	2	Hexagonal nut	9 1210 0030		
77	4	Fillister-head screw	9 1112 4100		



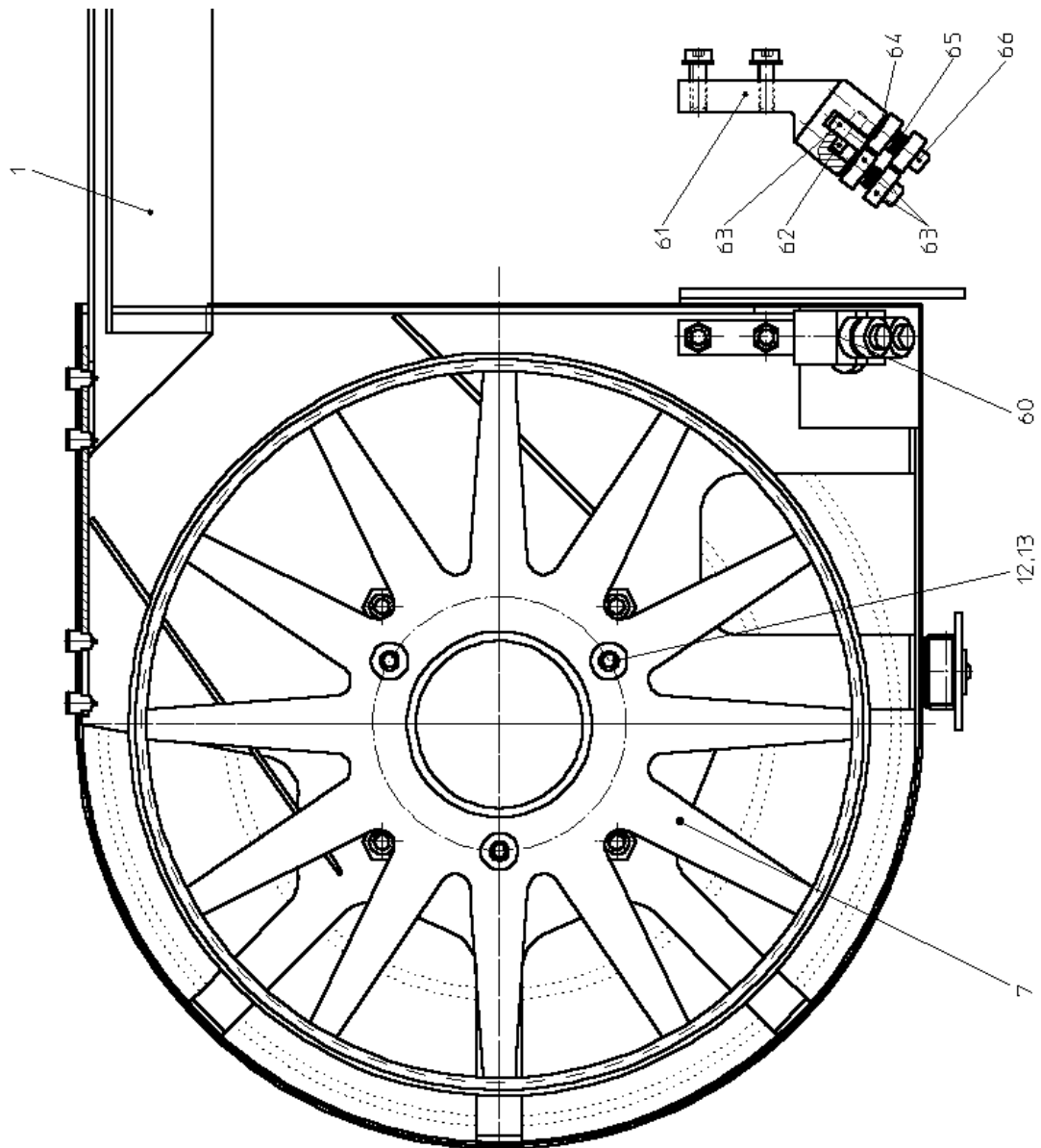
### Spare Parts List

Description:

**Band Saw Head**

Part and drawing number:

**5 6031 8000**



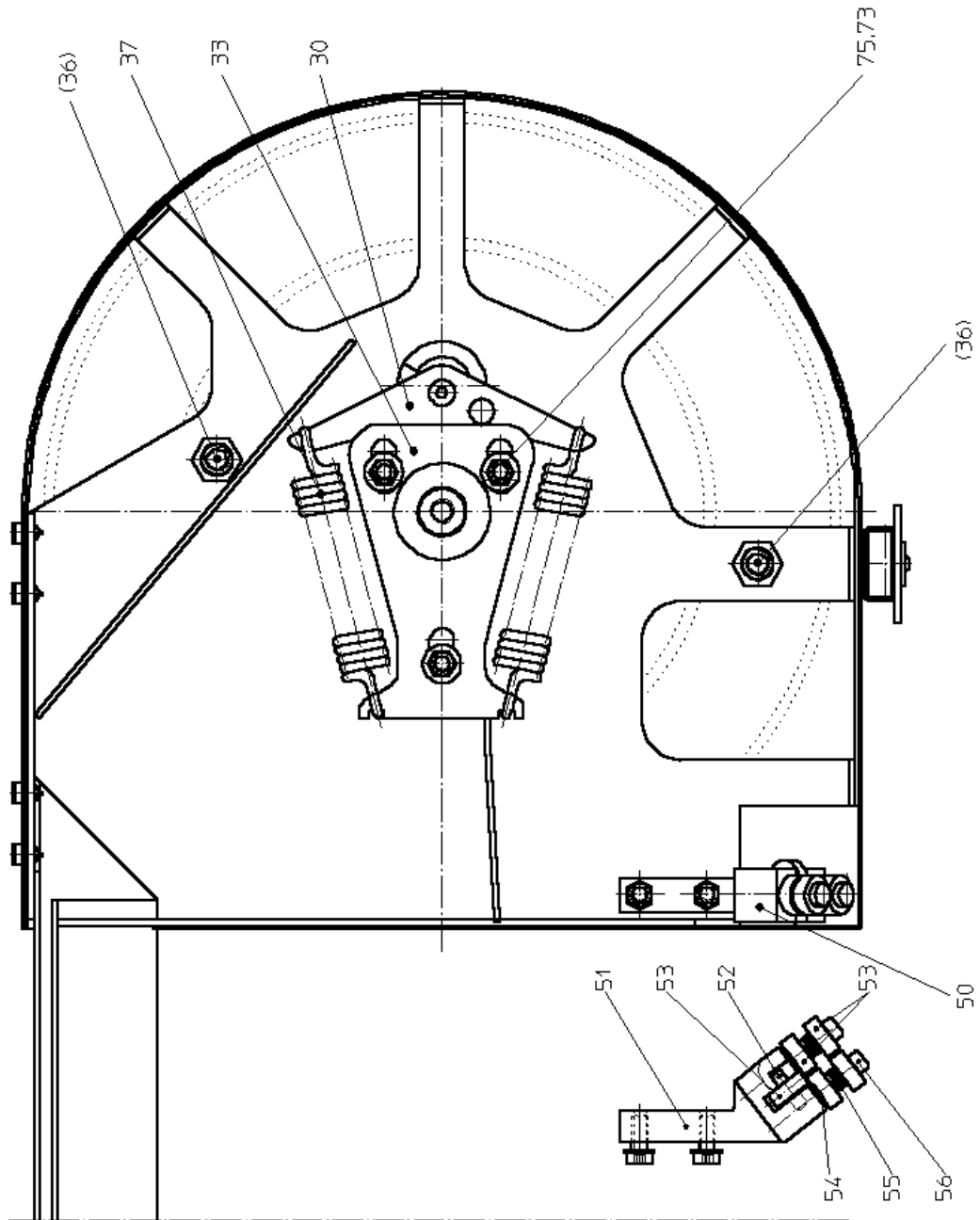
## Spare Parts List

Description:

**Band Saw Head**

Part and drawing number:

**5 6031 8000**



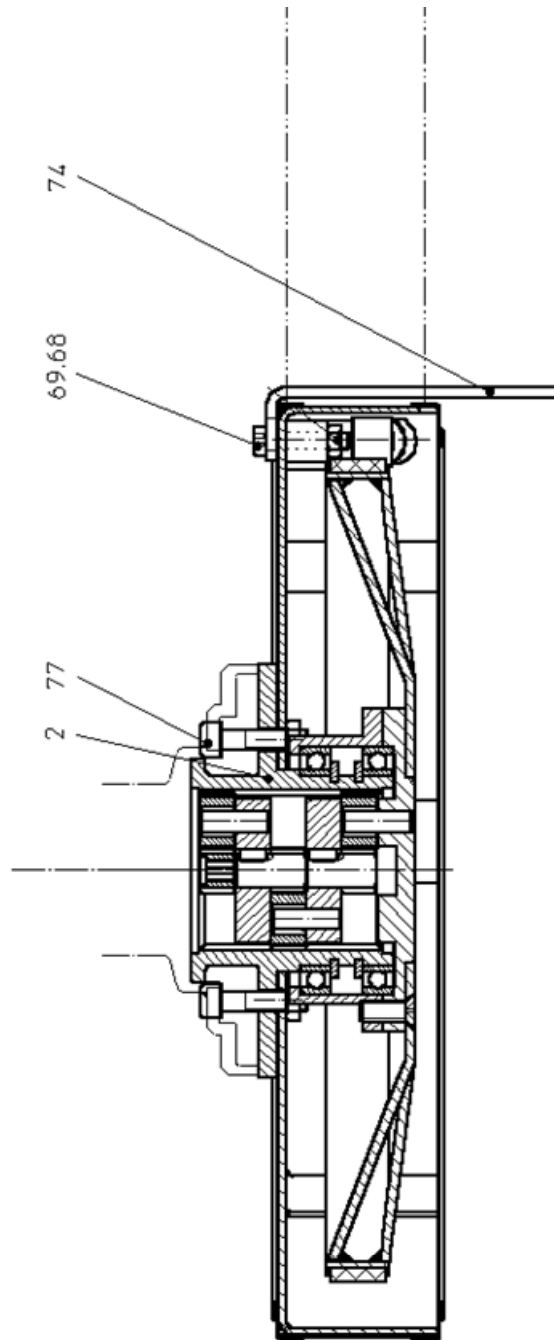
## Spare Parts List

Description:

**Band Saw Head**

Part and drawing number:

**5 6031 8000**



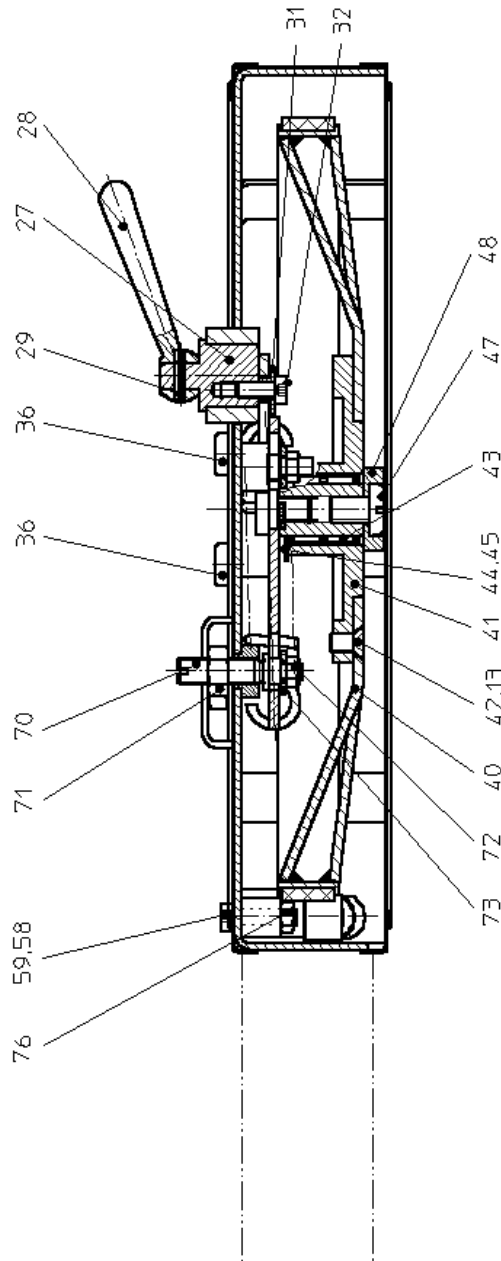
## Spare Parts List

Description:

**Band Saw Head**

Part and drawing number:

**5 6031 8000**





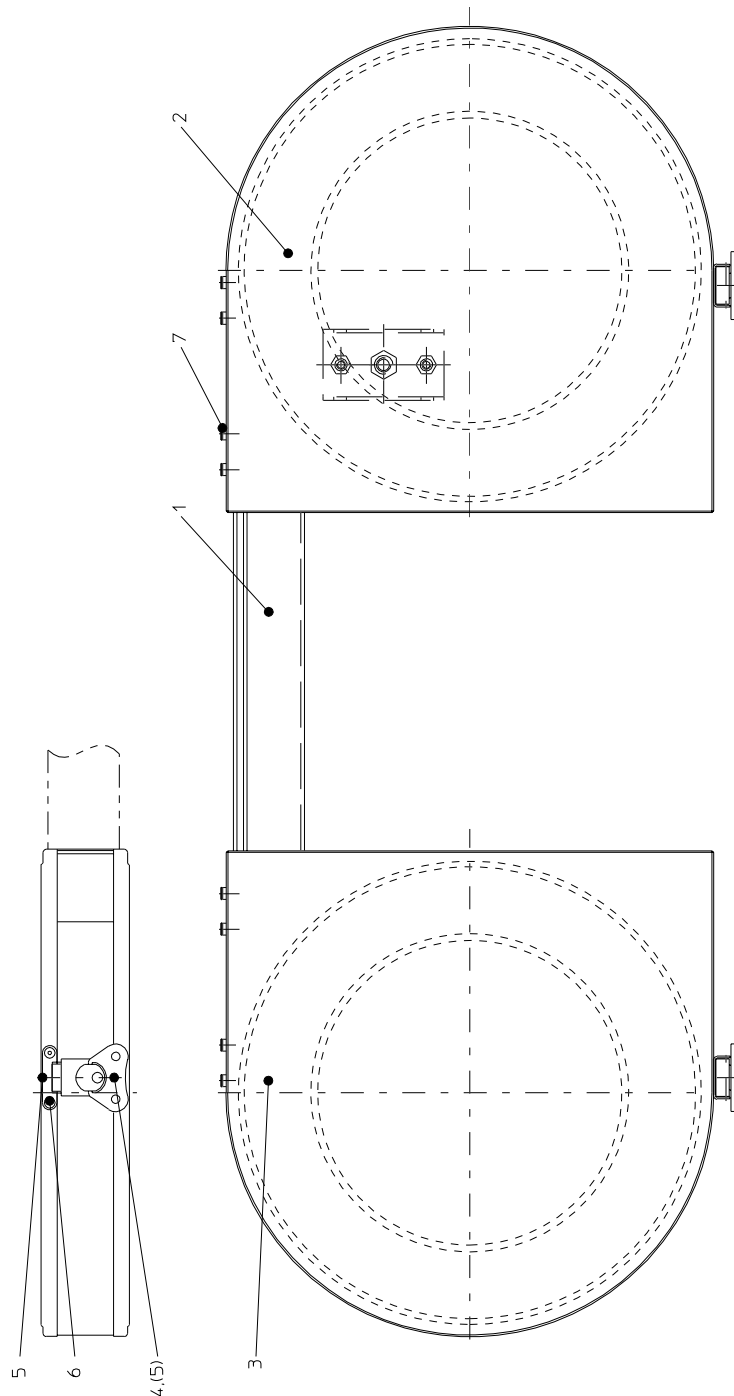
## Spare Parts List

Description:

**Band Saw Frame**

Part and drawing number:

**5 6031 7000**





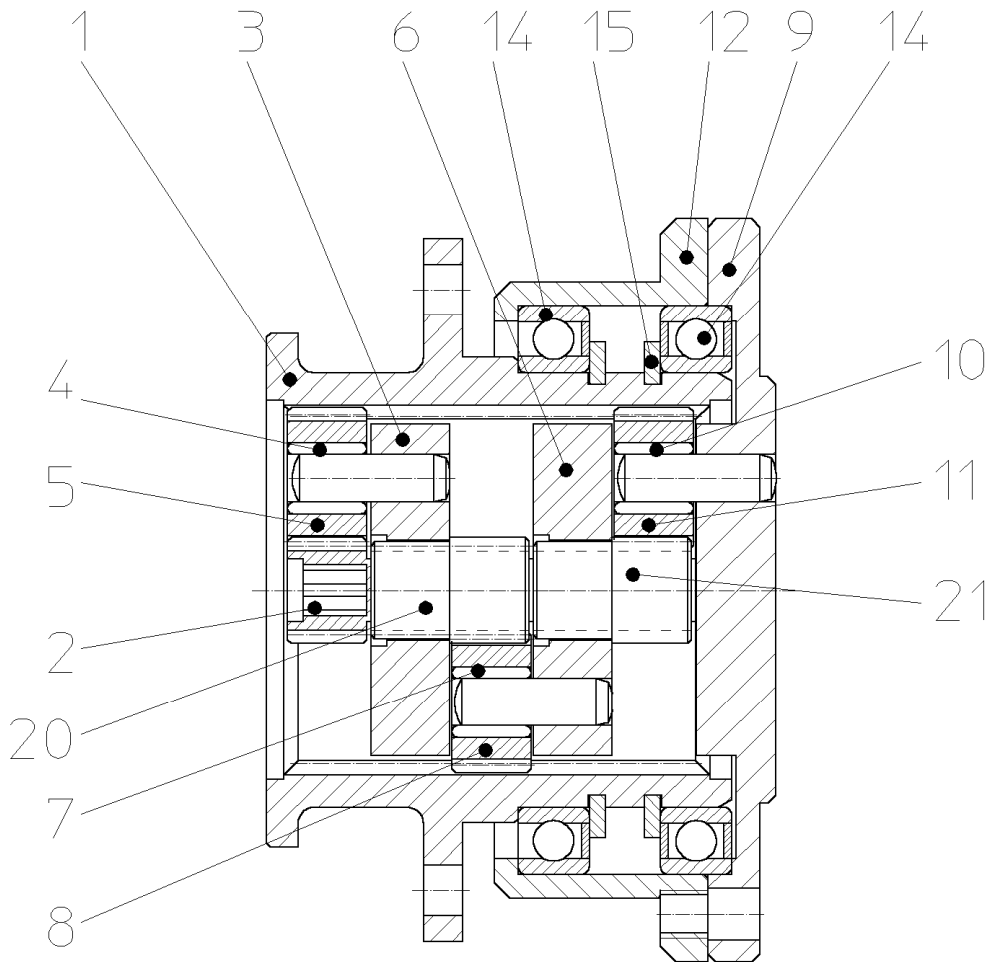
### Spare Parts List

Description:

**Gearbox**

Part and drawing number:

**5 6030 4000**





## Spare Parts List

Description:

**Band Saw Motor**

Part and drawing number:

**5 6037 0020**

Item	Qty.	Description	Part and drawing no.		Remarks
1	1	Motor housing with handle	5 6037 1010		
2	1	End plate	2 2405 1100	*	
3	1	Grooved ball bearing	9 1001 0040	*	
4	1	Snap ring	9 1703 0030		
5	1	Spacer ring	5 6101 1080		
6	1	Cylinder bushing	5 6030 1020	*	
7	1	Spiral pin	9 1642 0080		
8	1	Spiral pin	9 1642 0080		
10	1	Rotor	5 6030 1030		
11	5	Vane	5 6101 1050	*	
12	1	End plate	5 6030 1100	*	
13	1	Grooved ball bearing	9 1003 0370	*	
14	1	Snap ring	9 1703 0070		
15	1	Spacer ring	5 1202 1080		
18	1	Tension ring	5 6031 1140		
20	1	Shaft sealing ring	9 1905 1220	*	
22	1	Silencer - sintered metal	9 3801 1030	*	
23	1	Valve pusher	5 6011 3040		
24	1	Double notched taper pin	9 1641 0020		
25	1	Slide	5 6011 3150		
26	1	Locking screw	9 1171 9240		
27	1	Pressure spring	9 1803 3360		
31	1	Gasket	9 1903 0160		
32	1	Cylinder pin	9 1619 1360		
33	1	Steel ball	9 1017 0080		
34	1	Pressure spring	9 1803 0250		
35	1	O-Ring	9 1901 3160	*	
36	1	Sealing washer	5 6031 1580		
37	1	Valve seat	5 6031 1570		
38	1	Pin guide	5 6031 1590		
39	2	Threaded pin	9 1146 2010		
40	2	O-Ring	9 1901 5880	*	
41	1	Snap ring	9 1703 0110		
		*Wear parts to be stored in case of continuous			
		use			

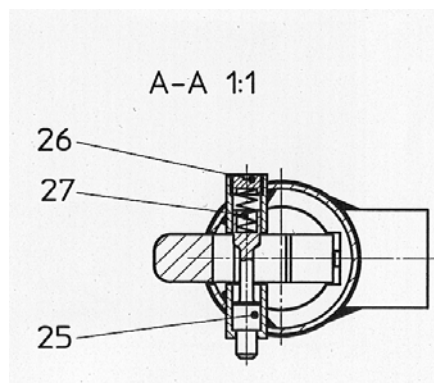
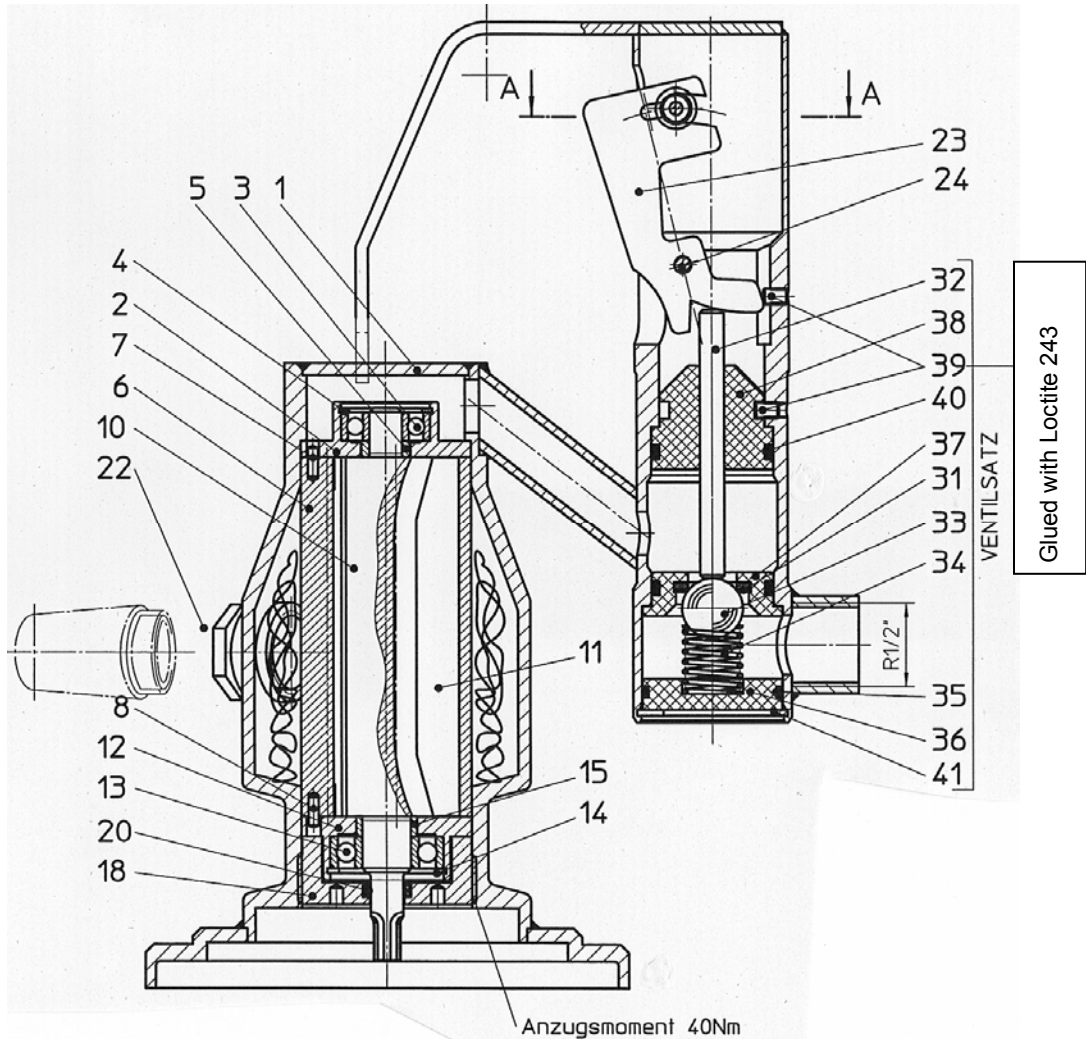
## Spare Parts List

Description:

**Band Saw Motor**

Part and drawing number:

**5 6037 0020**



**Spare Parts List**

Description:

Part and drawing number:

**Guide Unit I**

**5 6031 7980**

Item	Qty.	Description	Part and drawing no.		Remarks
51	1	Guide holder	5 6031 8130		
52	1	Pin	9 1619 0170		
53	5	Grooved ball bearing	9 1001 0290	*	
54	6	Spring washer	9 3322 0060		
55	4	Washer	9 3302 0150		
56	2	Flange-head screw	9 1110 2020		
58	2	Locking plate	9 3329 0010		
59	2	Flange-head screw	9 1112 3110		

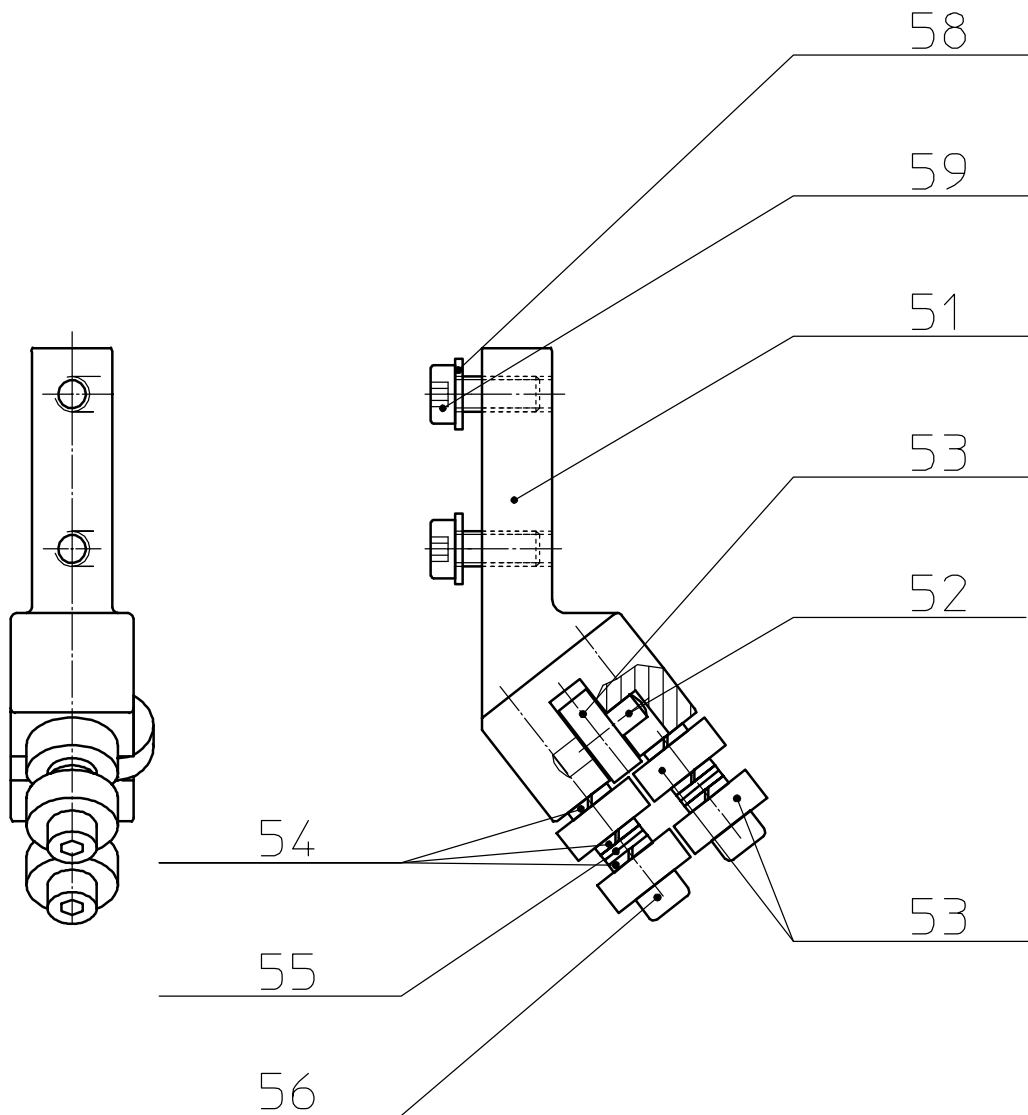
### Spare Parts List

Description:

**Guide Unit I**

Part and drawing number:

**5 6031 7980**



<b>Spare Parts List</b>					
Description:				Part and drawing number:	
<b>Guide Unit II</b>				<b>5 6031 7990</b>	
Item	Qty.	Description	Part and drawing no.		Remarks
61	1	Guide holder	5 6031 8130		
62	1	Pin	9 1619 0170		
63	5	Grooved ball bearing	9 1001 0290	*	
64	6	Spring washer	9 3322 0060		
65	4	Washer	9 3302 0150		
66	2	Fillister head screw	9 1110 2020		
68	2	Locking plate	9 3329 0010		
69	2	Fillister-head screw	9 1112 3150		

### Spare Parts List

Description:

**Guide Unit II**

Part and drawing number:

**5 6031 7990**

