

FIELD LEVEL AIR OVER OIL FEED CONVERSION FOR MODEL #612 & #1012 UPCUT SAWS

1. Shut off air and electrical supplies to saw.
2. In front panel above door hole, drill a 1" hole centered between the side channels and the top of the door hole and the bottom of the table.
3. The components of the regulator assembly on the side of the saw need to be rearranged. For a straight air saw the arrangement is starting at the rear of the saw.

Air Only = Main regulator - oiler - square manifold block, top cylinder regulator, elbow.

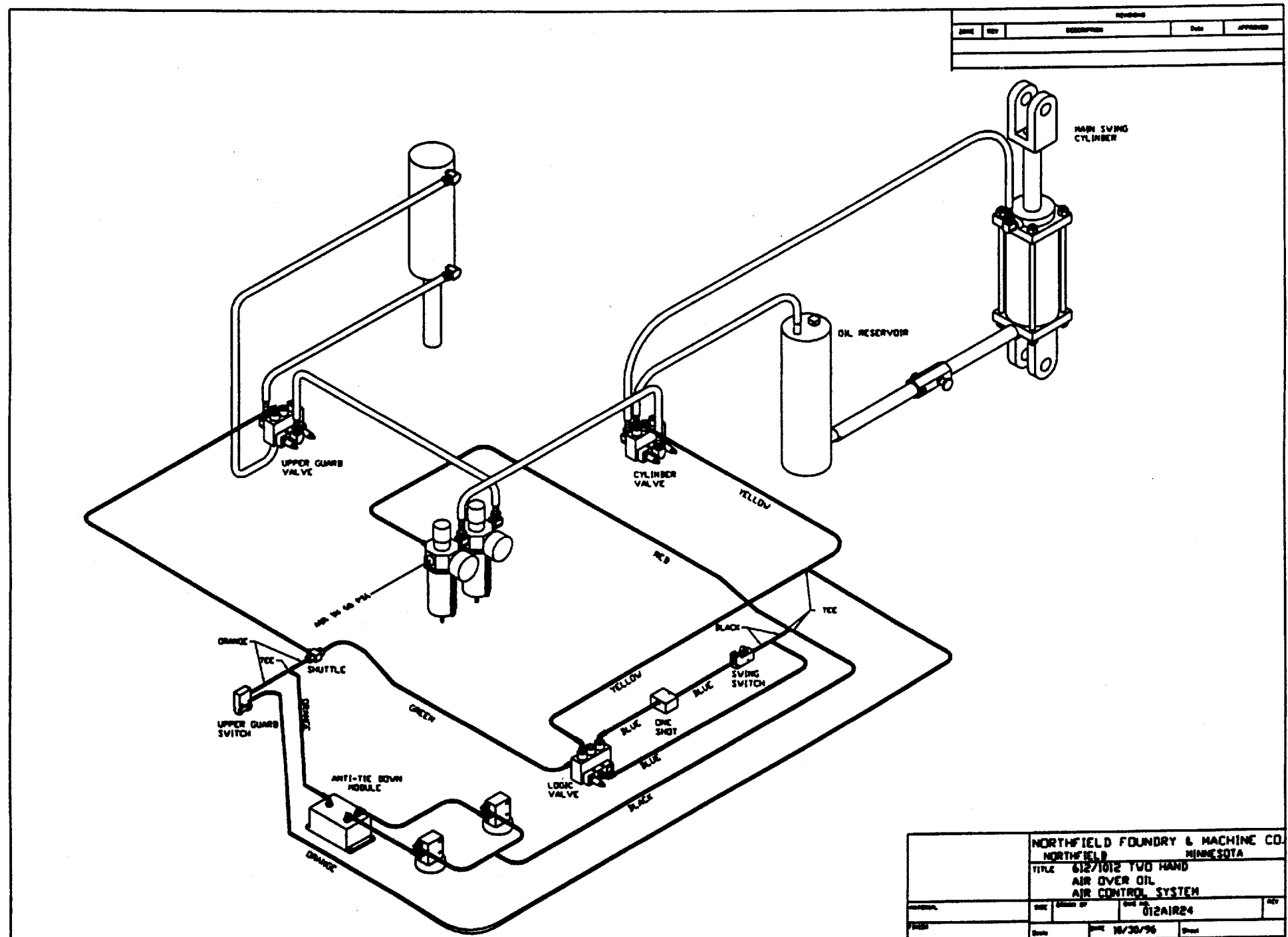
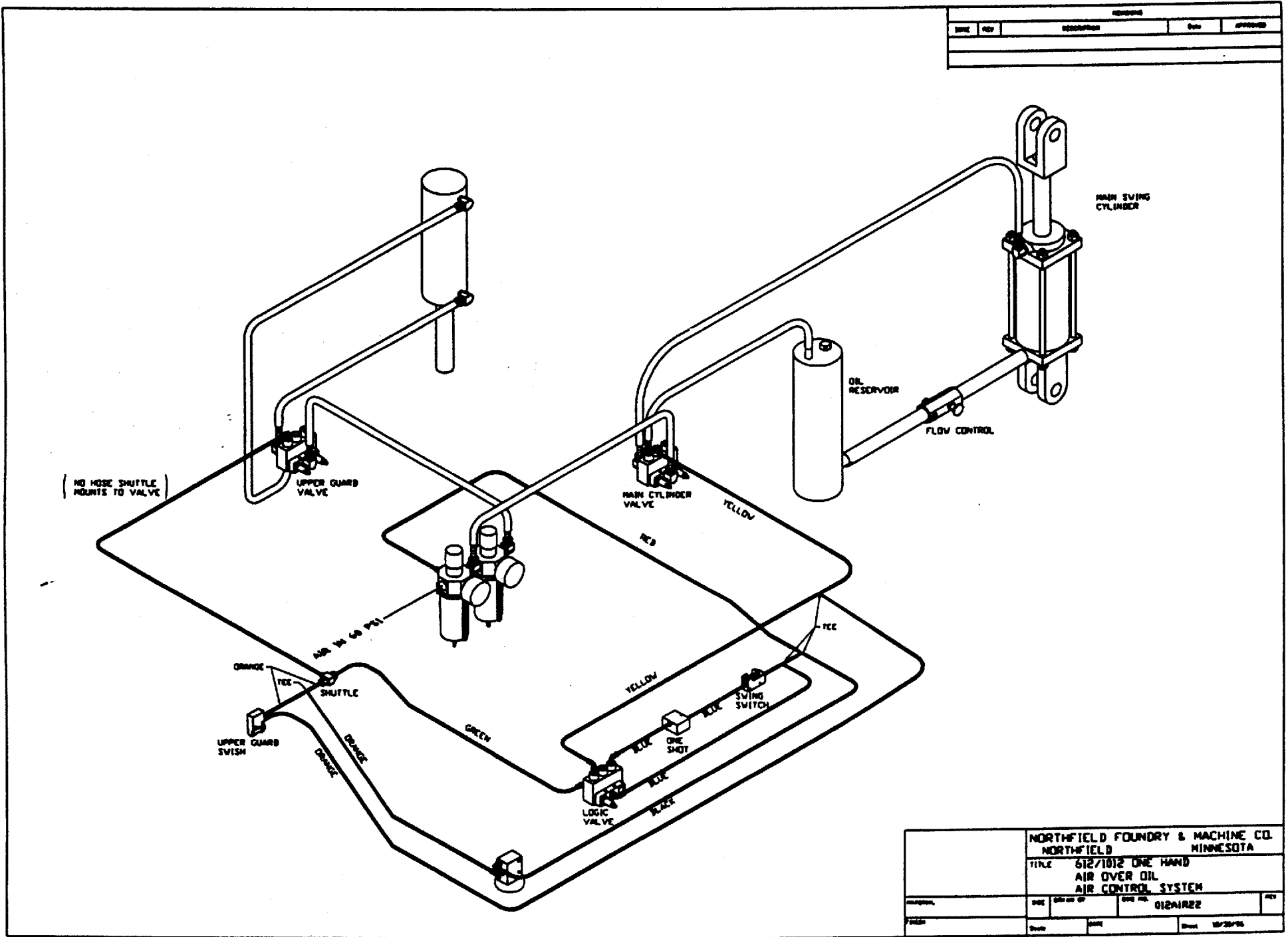
Reassemble the components to the following configurations.

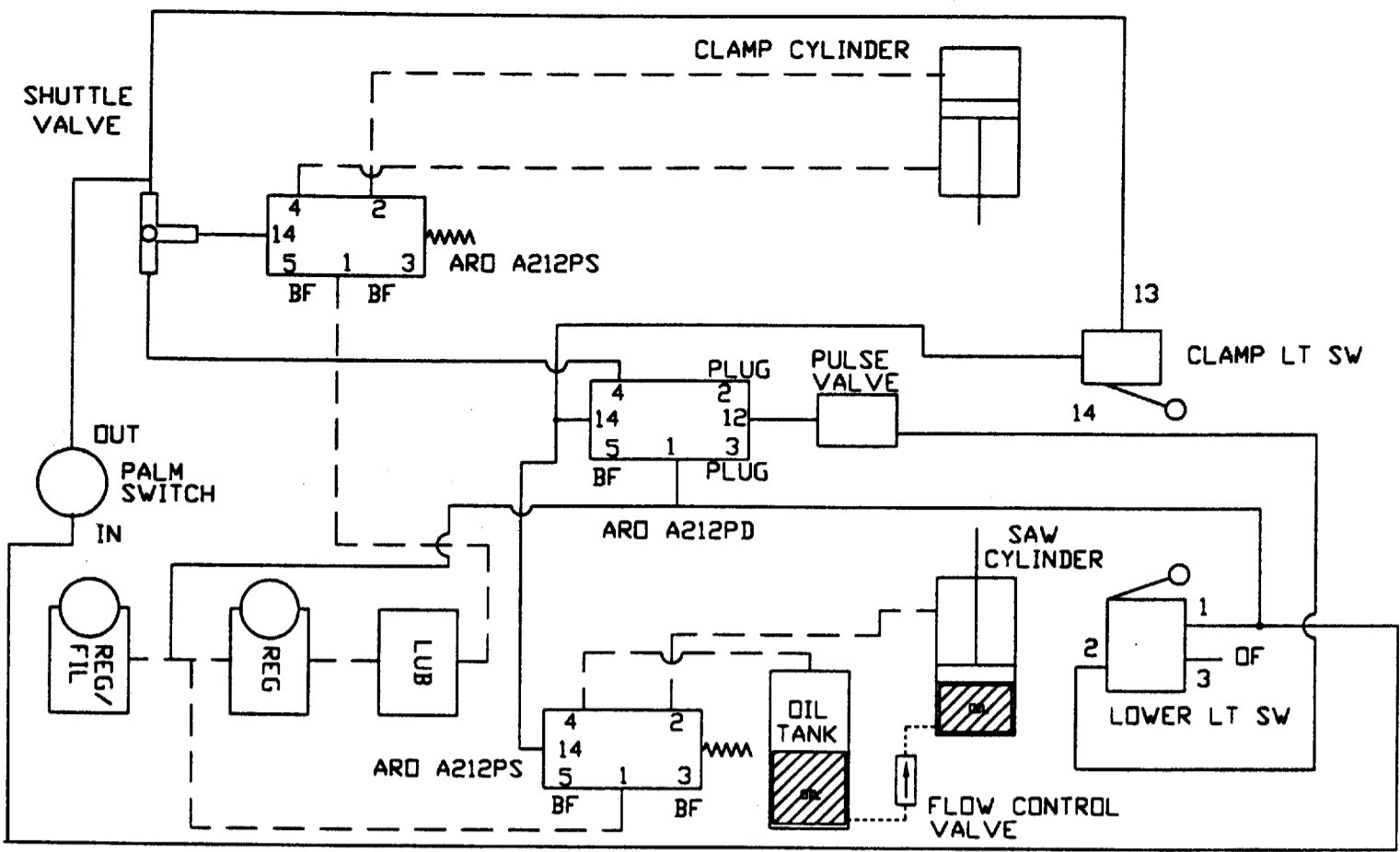
Air Over Oil = Main regulator, square manifold block, oiler, top cylinder regulator, elbow.

You will have to drill a 1" hole for the air line that goes to the repositioned square manifold block.

4. The oil reservoir bracket must be mounted on the inside of the front panel, on the side opposite of the blade enclosure. The bracket sits flush with the bottom of the front panel and flush with the side where the front panel is welded to the side channel. The bracket is mounted with the leg with the single hole up. Two 3/8-16 tapped holes must be drilled into the front panel to mount the oil reservoir bracket with 3/8-16 hex head bolts.
5. Mount the oil reservoir with short hydraulic hose attached and tightened to bracket by means of the 3/8-16 stud on the bottom of the reservoir. The reservoir should be positioned so that the elbow with the hydraulic line on the bottom faces out, toward the side panel of the saw base.
6. Cut 3/8" air line from and remove brass fittings from the bottom port of the swing cylinder. Replace with 1/2" street ell. Use Teflon tape on the threads and tighten so that the fitting faces the front panel.

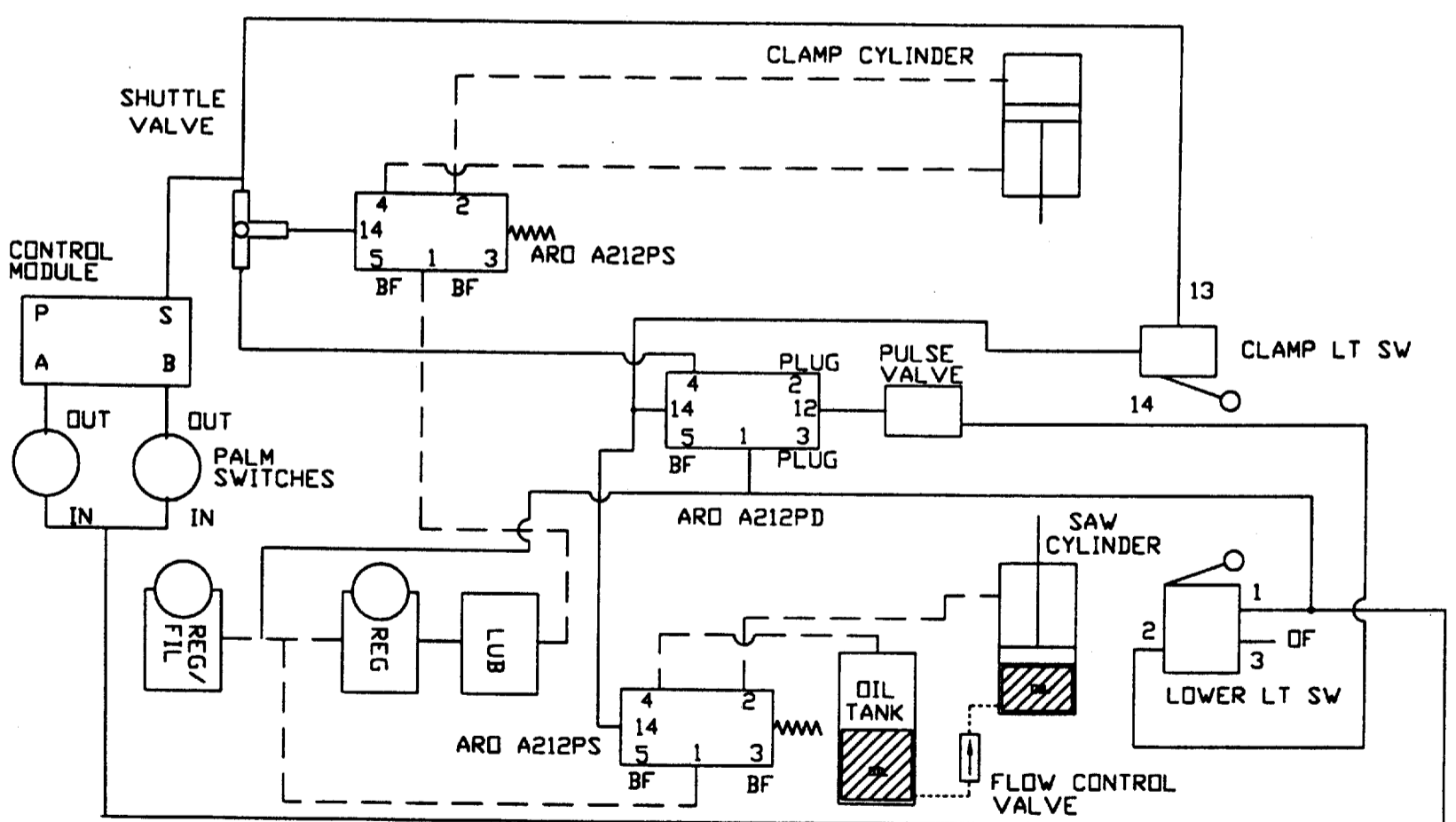
7. Connect short hydraulic line that comes from the bottom of the oil reservoir to the “Rego” flow control valve. Note that the flow control valve has a controlled flow arrow stamped into the body of the valve. This arrow should point towards the swing cylinder.
8. Connect the long hydraulic line to the other end of the “Rego” flow control valve and then to the ½" street ell that you installed on the bottom of the swing cylinder. Leave this connection slightly loose for air bleeding purposes later.
9. Position the adjusting knob of the “Rego” flow control valve through the 1" hole you drilled in the top front panel. Tighten the hydraulic hoses so valve maintains position in the 1" hole. Position the two cable clamps provided on either side of the hose ends attached to the “Rego” flow control valve. Drill and tap 1/4-20 holes in the front panel to attach the hose clamps.
10. Remove the 3/8" air line, cut from the swing cylinder, from the barb fitting on the 4-way valve in the rear of the machine base. Run a new 3/8" air line from the 4-way valve across the back of the saw, tie wrapping it to the 3/8" supply line that comes from the regulator assembly. Then continue towards the front of the saw along the side panel opposite the blade enclosure to the barb fitting on the top of oil reservoir. Tie wrap this portion of the 3/8" line to the small control air lines running down that side of the saw to keep it out of the way of the swing. Remove the two adjustable mufflers on the 4-way valve and replace with the non adjustable mufflers supplied.
11. Remove square head fill plug/dip stick from top of oil reservoir. Fill oil reservoir with “Mobil DTE LIGHT” hydraulic oil. Replace plug. Turn on air supply to machine, cycle saw action a few times to get system filled with oil. Continue cycling until you get a steady drip of oil from the lower cylinder hose and the action looks smooth. Tighten the lower cylinder hydraulic line. Shut off the air supply and recheck the reservoir oil level and add oil as necessary to bring to line on dip stick.





——— 5/32" ID POLY TUBING
 - - - 3/8" ID AIR HOSE
 1/2" ID HYD. LINE W/ ENDS

NORTHFIELD FOUNDRY MACHINE, CO.	REV	DATE	BY	CHKD	612/1012 AIR CONTROLS		REV	DATE	BY	CHKD	APP
					AIR OVER OIL ONE PALM SWITCH						



——— 5/32" ID POLY TUBING
 - - - 3/8" ID AIR HOSE
 1/2" ID HYD. LINE W/ ENDS

NORTHFIELD FOUNDRY MACHINE, CO.	REV	DATE	BY	CHKD	612/1012 AIR CONTROLS		REV	DATE	BY	CHKD	APP
					AIR OVER OIL TWO PALM SWITCHES						