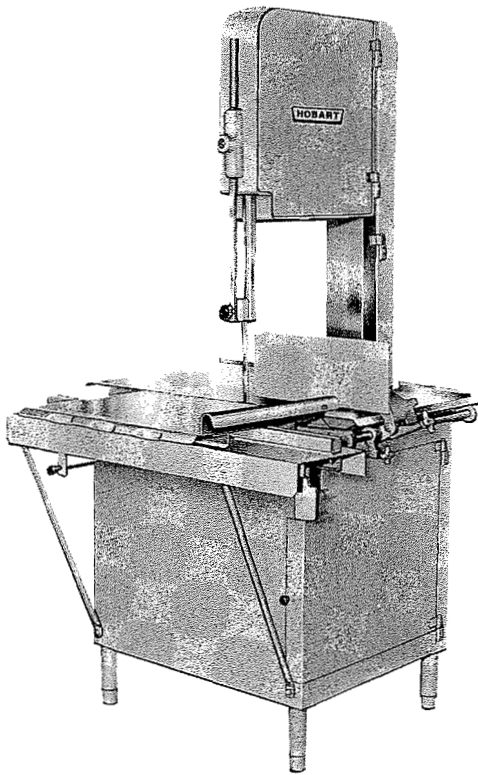




INSTRUCTION MANUAL

... with Replacement Parts



MODELS 5216, 5216-HS, 5216-D & 5216-D HS MEAT SAWS

ML-19620	5216 (Painted)
ML-19622	5216-HS (Painted)
ML-19621	5216-D (SST)
ML-19623	5216-D HS (SST)

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Installation, Operation and Care of MODELS 5216, 5216-HS, 5216-D & 5216-D HS MEAT SAWS

Save These Instructions

GENERAL

The 5216 Meat Saw is designed to process large quantities of product. It is equipped with a 2 H.P. electrical motor. Applications above 250 volts include reduced voltage pilot circuit. Thermal overload protection is offered as an option. A carriage table, easily moved by operator's body, and a carriage lock are standard.

One long life blade is furnished with each meat saw. The blade cannot be resharpened and replacements are available through authorized Hobart offices.

INSTALLATION

Place the machine as close to its operating location as possible. Remove the shipping box. Remove and unpack all disassembled components. The pusher plate and scrap pan are packed in the base compartment. Remove the four retaining bolts from the underside of the skid and slide the machine off the skid.

FEET ASSEMBLY

Coat the threads of the feet with Lubriplate (supplied) and thread the feet into machine legs. Make final adjustments in machine location.

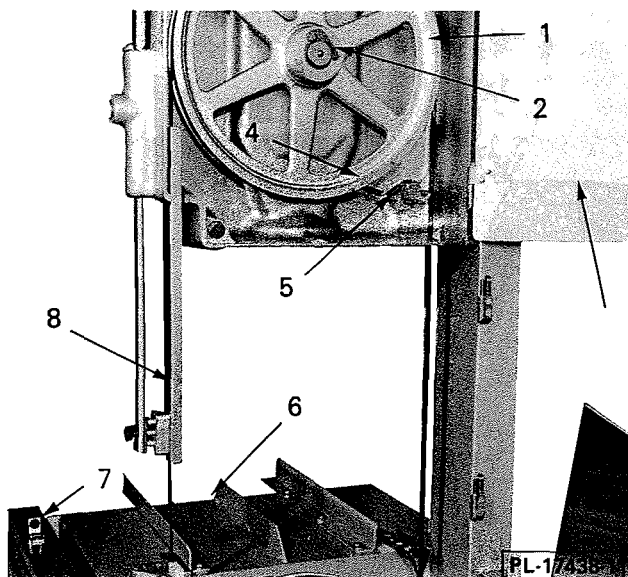


Fig. 1

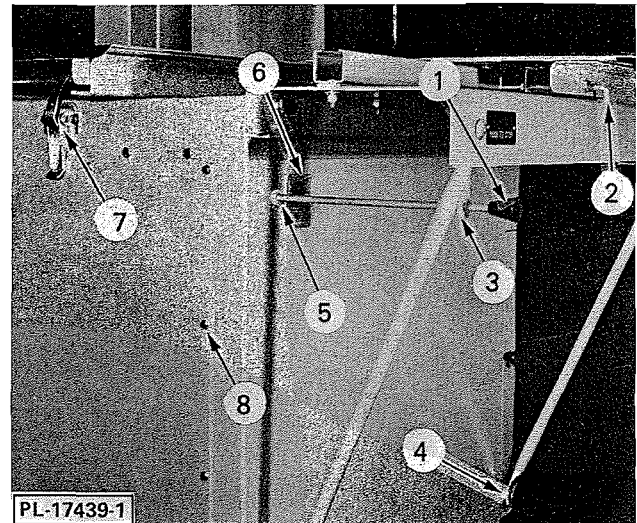


Fig. 2

Level the machine side to side and front to back by placing a spirit level on top of the base unit (6, Fig. 1) and adjusting the feet as necessary. Lock feet in place, using the set screws furnished.

CARRIAGE SUPPORT

Remove the twelve retaining screws (8, Fig. 2) and the motor access panel on the left-hand side of machine. Locate the carriage support (7, Fig. 3), using dowel pins as locators, and bolt in place. Next assemble the two support braces. One support brace has a tag attached to it. Install the brace on the right-hand side, tag end up (to carriage support). **NOTE:** Spacers (4, Fig. 2) are used on lower carriage bolts with nuts and lock washers on inside of base.

BLADE

Lower upper blade pulley by turning tension adjusting hand wheel several revolutions to the left. Open head door (3, Fig. 1). Raise gauge plate (10, Fig. 3) to its vertical position. Completely lower the upper guide assembly. Place the saw blade over the upper and lower blade pulleys. The blade teeth must point to the **RIGHT** and **DOWN**. If the teeth do not point **DOWN**, remove the blade, twist it inside out and replace on saw. Make sure the blade is properly placed in the upper guide unit (8, Fig. 1).

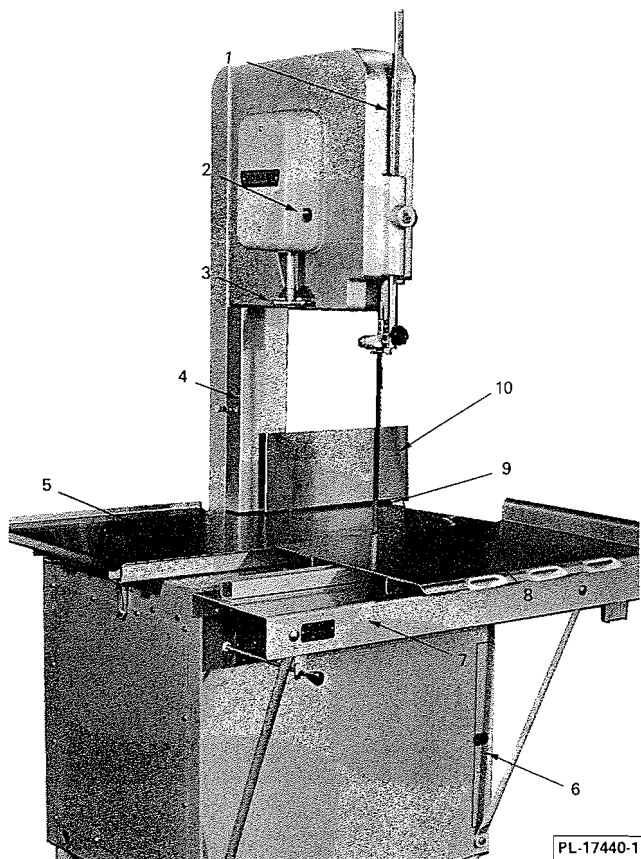


Fig. 3

Turn the tension adjusting hand wheel (3, Fig. 3) to the right until the figure "3" starts to appear in the tension indicator (2, Fig. 3). Turn the upper blade pulley, by hand, in the direction of operation, until the blade centers itself on the pulleys.

Turn the tension adjusting hand wheel (3, Fig. 3) slowly to the right until the indicator registers approximately "4" at eye level. This is the best operating tension for the blade. Swing nylon blade guard (5, Fig. 4) UP. Position front wiper assembly (6, Fig. 4), with blade in slot of steel block and wipers on both sides of blade (9, Fig. 3). Align wiper assembly into wiper bracket slideway slot and lower into position. Close nylon guard. Close head door.

TABLE

With the gauge plate in its raised position, tilt the table on its side, blade side edge up. Slide the table (5, Fig. 3) under the saw head. Move the table to its approximate location. The rear table angle should be against and inside of the rear table rest angle (3, Fig. 4). Lower the blade edge side. Raise the left end of the table and slide to the right until the table slide rod engages the table catch (1, Fig.

4). Lower the left end of the table, aligning the front notch with the blade guide. The table is properly positioned when the reinforcement of the table is inside the angular rest of the base. Lock the table in place with the table clamp (7, Fig. 2). Assemble and latch the blade cover (4, Fig. 3).

CARRIAGE

The carriage may be assembled from left or right side. Turn the "L" shaped carriage stop (7, Fig. 1) so that the rubber bumper is toward rear of machine. Align the center bearings of the carriage with the carriage guide. Roll carriage into position. Return carriage stop to stopping position.

SWITCH

Remove the upper right and lower control box mounting bracket bolts. Pivot the box to the left. Insert the rod, from the inside, through the bushing (5, Fig. 2), base and into the bracket (3, Fig. 2). Screw the knob (1, Fig. 2) on. Position the control box in place and slide the bent end of the rod into the adapter. Replace the control box and motor panel.

ELECTRICAL CONNECTIONS

WARNING: DISCONNECT ELECTRICAL POWER SUPPLY AT FUSED DISCONNECT SWITCH AND PLACE A TAG INDICATING CIRCUIT IS BEING WORKED ON.

All internal wiring of the machine is completed before shipping. Before making electrical supply connection, check the specifications on the data plate (6, Fig. 2) to assure they agree with those of your electrical service.

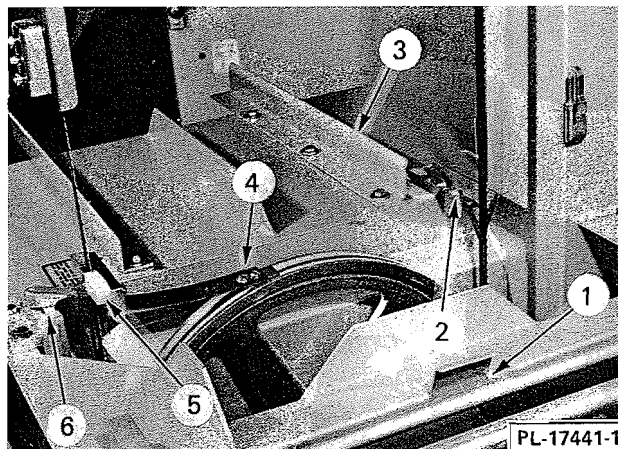


Fig. 4

Electrical connections should be made by qualified workmen who will observe all applicable safety codes and the National Electrical Code.

SUGGESTED WIRE AND FUSE SIZES FOR INDIVIDUAL BRANCH CIRCUITS

Volts	Ph.	Max. Time Delay Fuse Size	Min. Conductor Ampacity	60°C CU Wire Size
115	1	30	30	10
200-230	1	15	15	14
200-230	3	15	15	14
460	3	15	15	14

Connect the individual branch electrical power supply to the contactor leads. A 1-3/32" diameter hole (for 3/4" conduit) is provided in the base for connecting rigid or flexible conduit. Circuit conductors and fuse protection should conform to local, as well as national, code requirements.

Motor Rotation

In three phase applications a check must be made to verify correct direction of rotation. Apply electrical power and energize the machine momentarily by pulling then pushing the switch knob. The blade must travel in the DOWNWARD direction.

If rotation is incorrect, **DISCONNECT ELECTRICAL POWER SUPPLY** and interchange any two power supply leads. Re-energize machine momentarily and verify correct direction of rotation.

Replace motor access panel and twelve retaining screws.

CLEANING & SANITIZING

It will be necessary to thoroughly clean and sanitize the machine after installation and prior to being placed into service. Refer to MAINTENANCE for instructions.

OPERATION

SAFETY

Safety devices incorporated in the saw **MUST** be in correct operating position anytime the saw is in service.

BEFORE turning machine ON, adjust the UPPER GUIDE ASSEMBLY by sliding the guide (1, Fig. 3) up or down as necessary to keep the guide as close to the work as possible.

The BUTT-END PUSHER PLATE is to be used when slicing short ends, thus keeping operator's hands away from saw blade.

The GAUGE PLATE (10, Fig. 3) is shaped to give maximum support of the product being cut while providing operator protection and facilitating slice removal.

All doors and inspection covers **MUST** be in operating (closed) position while machine is running.

CONTROLS

The SWITCH KNOB (1, Fig. 2) must be pulled to start the machine. To turn machine OFF push knob in.

SAWING

Place item to be cut on the carriage (8, Fig. 3) and turn saw ON by pulling switch knob (1, Fig. 2). Stand in front of machine, leaning lightly against the scalloped front of the carriage. Move the carriage to the left, past the saw blade (9, Fig. 3) at a steady and uniform rate. Use your left hand to remove and stack product as it is cut. **NEVER REACH IN FRONT OF BLADE.** Always reach around the left side or in back of saw blade. On the return stroke, pull the item back and away from saw blade.

To cut slices of uniform thickness, set the gauge plate at the desired position by turning the adjusting knob (1, Fig. 5). A scale is stamped into the table.

If the gauge plate is not needed and interferes with the work, it may be moved out of the way. Lift the

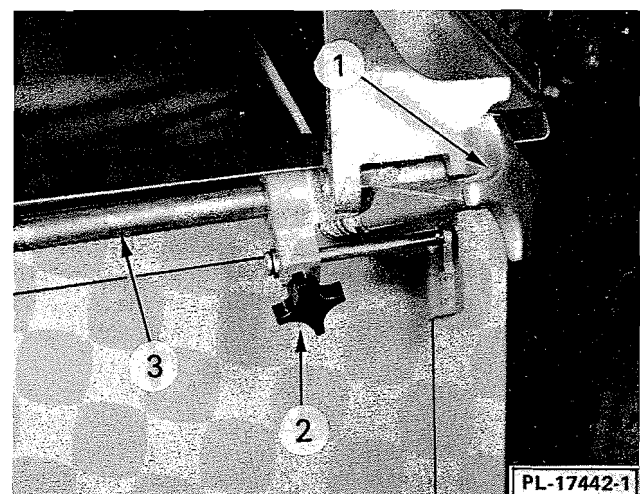


Fig. 5

adjusting knob, to disengage the teeth, and slide the gauge plate to the rear of the machine or raise the gauge plate to a vertical position and slide to a convenient location.

An adjustable gauging pin permits the operator to slide the gauge plate out of the way and then back to the original position at a later time. To set the pin, adjust the gauge plate to the desired position by turning hand knob (1, Fig. 5). Loosen the gauging pin hand knob (2, Fig. 5) and slide the pin against the gauge plate support stop. Tighten the gauging pin hand knob.

The pusher plate is used to hold meat against the gauge plate when slicing short ends. Dowels in the pusher plate maintain the necessary alignment with the raised edge of the carriage. A stop on the carriage prevents over-travel. Holding the pusher plate handle with the right hand, a safe distance from the blade will always be maintained. Store the pusher plate on the underside of the carriage support (7, Fig. 3) when not in use.

If locked carriage operation is desired align the right edge of the carriage with the right edge of the table. Screw the carriage lock (2, Fig. 2) in until it engages with the carriage rail.

MAINTENANCE

WARNING: DISCONNECT ELECTRICAL POWER SUPPLY AT THE FUSED DISCONNECT SWITCH AND PLACE A TAG INDICATING THE CIRCUIT IS BEING WORKED ON BEFORE BEGINNING ANY MAINTENANCE PROCEDURE.

CLEANING AND SANITIZING

It is recommended that the saw be thoroughly cleaned and sanitized after each day's operation or any time it is not to be used for an extended period of time (overnight).

Supplies

Recommended cleaning and sanitizing supplies include: a 12" handle nylon bristle brush; a two compartment pail for cleaning solutions; a pail and spray bottle for sanitizer; a scrap pail; and clean cloths.

Solutions

For cleaning, a powdered detergent such as Soilax or Spic 'n' Span is recommended. Do not use liquid soaps as they will corrode metal surfaces.

Prepare a hot detergent solution in one side of the two compartment pail. Fill the other compartment with warm potable rinse water.

Mix a sanitizing solution by adding one tablespoon of household bleach (5.25%) and an iodophor sanitizer such as Iodet, to one gallon of cool water in a pail. This makes a 200 ppm solution. Use this solution to fill the spray bottle, as well as the pail, for sanitizing.

Disassembly

Remove the pusher plate turn (at either end of carriage support) the "L" shaped carriage stop (7, Fig. 1) and remove carriage.

Rotate gauge plate (10, Fig. 3) to raised (vertical) position.

Release the table clamp (7, Fig. 2). Remove the blade cover. Raise the left end of the table, slide to the left until free from the table catch, tilt blade edge up and remove table from under head.

Open and lift off head door (3, Fig. 1). Open and lift off base door (6, Fig. 3). Remove scrap pan.

Swing nylon blade guard (5, Fig. 4) up and lift front wiper assembly (6, Fig. 4) from machine.

Remove the rear blade scrapper.

Turn tension adjusting hand wheel (3, Fig. 3) to the left, releasing blade tension. Remove blade.

Depress upper pulley wiper (5, Fig. 1) and slide out of saw head.

Open latches (2, Fig. 1) and slide the upper and lower blade pulleys (1, Fig. 1) from shafts. **NOTE:** Pulleys are interchangeable.

All removed parts can be cleaned and sanitized in a sink. Clean and sanitize machine, starting at the top and working down.

Washing

Remove any large scraps of product and place in scrap pail. Dip a clean cloth in the detergent solution, wring out and thoroughly wash each component. Use the brush for hard to reach or stubborn soil. Use care to thoroughly clean interior corners of pulley housings. Using a second clean cloth in the rinse water, thoroughly rinse each component immediately after washing.

Sanitizing

Soak a clean cloth in the sanitizing solution. Wring cloth out so that when wiping parts they are left moist, but not dripping wet. Thoroughly wipe all surfaces. Resoak and wring out cloth frequently. Use the spray bottle to sanitize hard to reach spots by spraying a light mist on all surfaces. Do not wipe surfaces dry after sanitizing. Allow adequate time to dry.

Reassembly

Prior to reassembly a light coating of tasteless mineral oil should be applied to all surfaces. Reassembly is a reversal of disassembly. Machine should be covered when stored.

Clean Up

Rinse buckets, brush, the spray bottle and any other tools in the remaining detergent and sanitizing solutions. Store cleaning tools in a proper storage location. The cleaning cloths used should be sent to a laundry for cleaning or discarded.

NOTE: Hydraulic cleaning equipment is available through private suppliers. If such equipment is used, follow suppliers instructions.

LUBRICATION

Little lubrication is required as all high speed shafts have prepacked bearings.

A small amount of grease is required in the six ball bearing rollers of the carriage. Regularity of lubrication will depend on amount of use.

Frequently apply a few drops of tasteless oil to: the gauge plate rack (3, Fig. 5); upper blade slide rod (1, Fig. 3); and pulley shafts. Check to assure each component moves freely.

SAW BLADE REPLACEMENT

Move the carriage (8, Fig. 3) to the left-hand carriage stop. Raise the gauge plate (10, Fig. 3) to the vertical position. Release the table clamp (7, Fig. 2). Remove table. Swing nylon blade guard up. Open head door (3, Fig. 1).

Turn tension adjusting hand wheel (3, Fig. 3) to the left, releasing blade tension. Remove blade.

Install new blade over upper and lower blade pulleys. The blade teeth must point to the **RIGHT** and **DOWN**. If the teeth do not point **DOWN**, remove the blade, twist it inside out and replace on

saw. Make sure the blade is properly placed in the upper guide and wiper unit.

Turn the tension adjusting hand wheel (3, Fig. 3) to the right until the figure "3" starts to appear in the tension indicator (2, Fig. 3). Turn the upper blade pulley (1, Fig. 1), by hand, in the direction of operation, until the blade centers itself on the pulleys.

Turn the tension adjusting hand wheel (3, Fig. 3) slowly to the right until the indicator registers approximately "4" at eye level. This is the best operating tension for the blade.

The remainder of assembly is a reversal of disassembly.

BLADE BACK-UP BLOCK ADJUSTMENT

Clearance between back-up blocks and blade should be approximately 1/32". The clearance should always be checked after blade installation.

Energize machine momentarily to allow blade to seat. Turn machine **OFF**. **DISCONNECT ELECTRICAL POWER SUPPLY** and measure the distance from the left edge of the blade and the upper and lower wiper unit back up blocks. If the clearance is not approximately 1/32" an adjustment will be necessary.

To adjust upper back-up block, loosen lock nut (1, Fig. 6) and turn screw as necessary. Tighten lock nut. To adjust lower back-up block, loosen lock nut (2, Fig. 6) and turn screw as necessary. Tighten lock nut.

Re-energize machine momentarily. **DISCONNECT ELECTRICAL POWER SUPPLY** and recheck clearance. Repeat procedure as required.

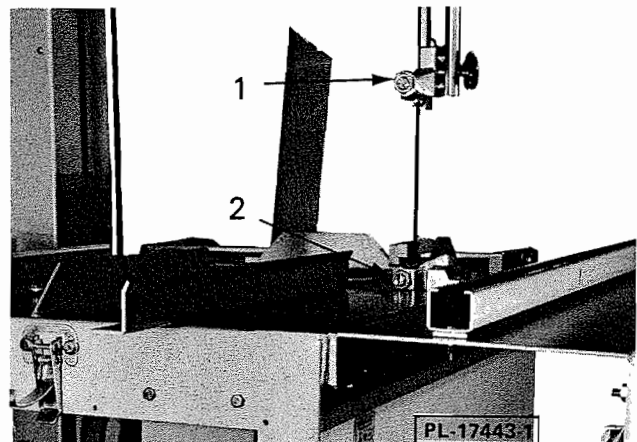


Fig. 6

PULLEY WIPER ADJUSTMENT

The upper pulley wiper (4, Fig. 1) and lower pulley wiper (4, Fig. 4) should be aligned so that they track squarely in the center of the pulley.

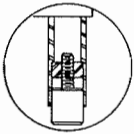
To adjust, **DISCONNECT ELECTRICAL POWER SUPPLY**. Remove the table and open the head door to access the pulleys. Make a visual inspection to determine direction and amount of adjustment required. Loosen the two retaining screws, position wiper(s) and retighten. Momentarily energize machine to verify adjustment.

BLADE SCRAPER ADJUSTMENT

Correct adjustment of the front scrapers is achieved when scrapers are slightly behind the set of

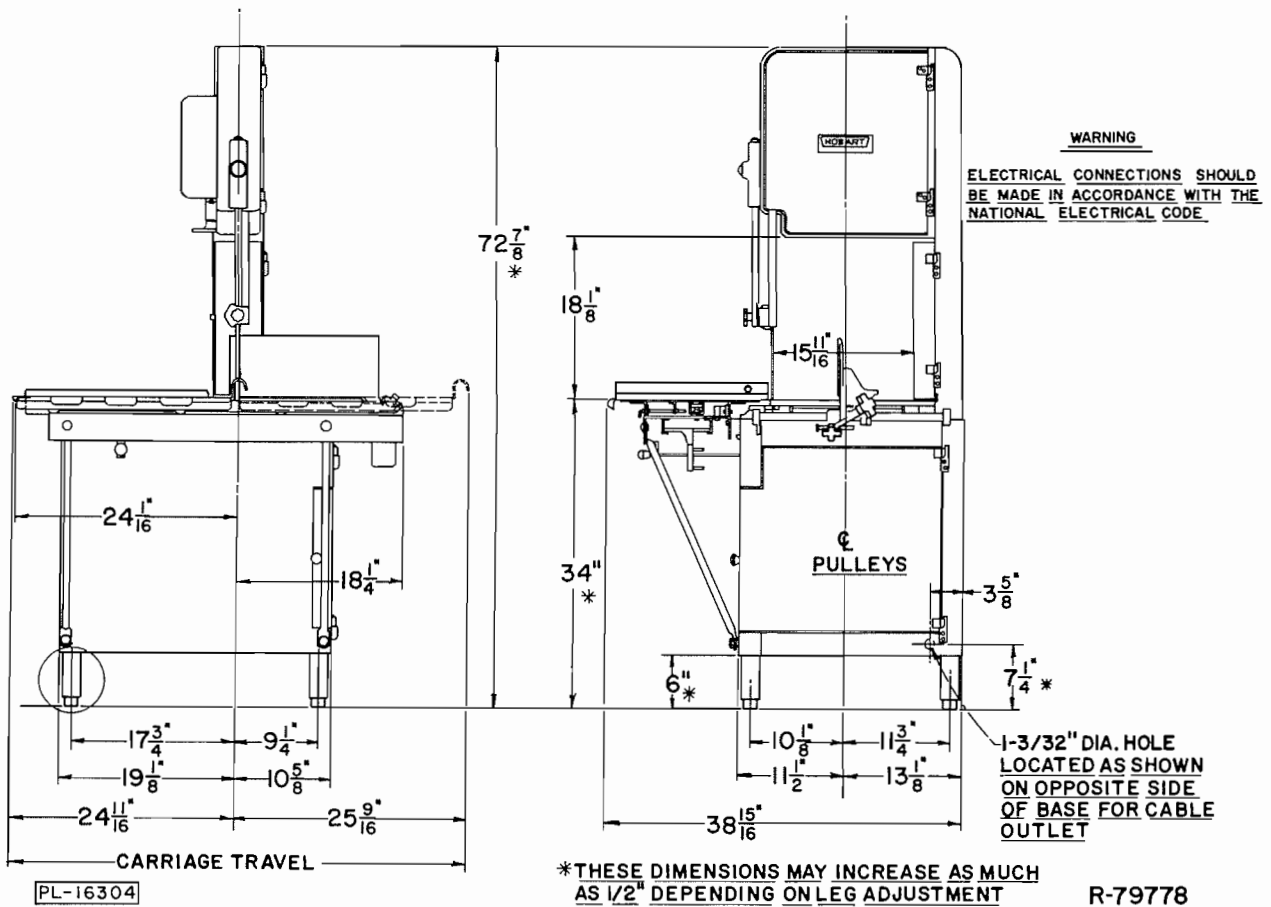
the blade teeth while the blade is resting against the back-up blocks. Correct adjustment of the back scrapers is achieved when the scrapers are slightly behind the set of the blade.

To adjust, **DISCONNECT ELECTRICAL POWER SUPPLY**. Remove the table and open the head door. Remove the upper pulley scraper unit (5, Fig. 1) and lower guide and scraper units. Loosen the scraper retaining screws so that the scrapers (2, Fig. 4) can be moved by pushing against it. Replace the units. With a piece of wood, push the blade against the back-up blocks. Position the scrapers. Remove the guide units and tighten the retaining screws. Replace guide units, table and close head door.



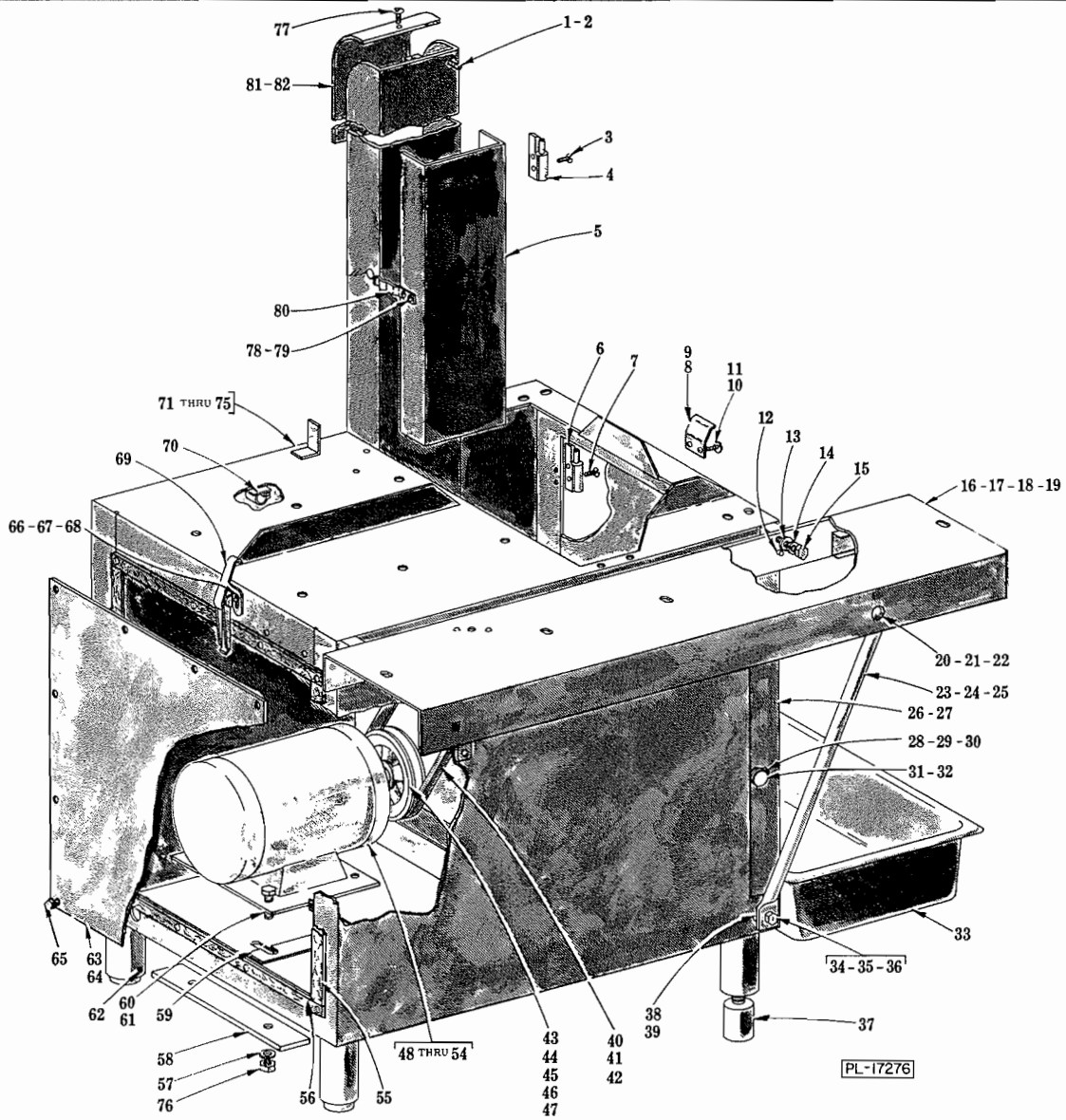
ENLARGED VIEW OF LEG
SHOWING ADJUSTING FOOT

MACHINE IS PARTIALLY DISASSEMBLED
FOR SHIPMENT. CRATED MACHINE WILL
PASS THRU A 33" OPENING.



INSTALLATION DIAGRAM

5216 REPLACEMENT PARTS

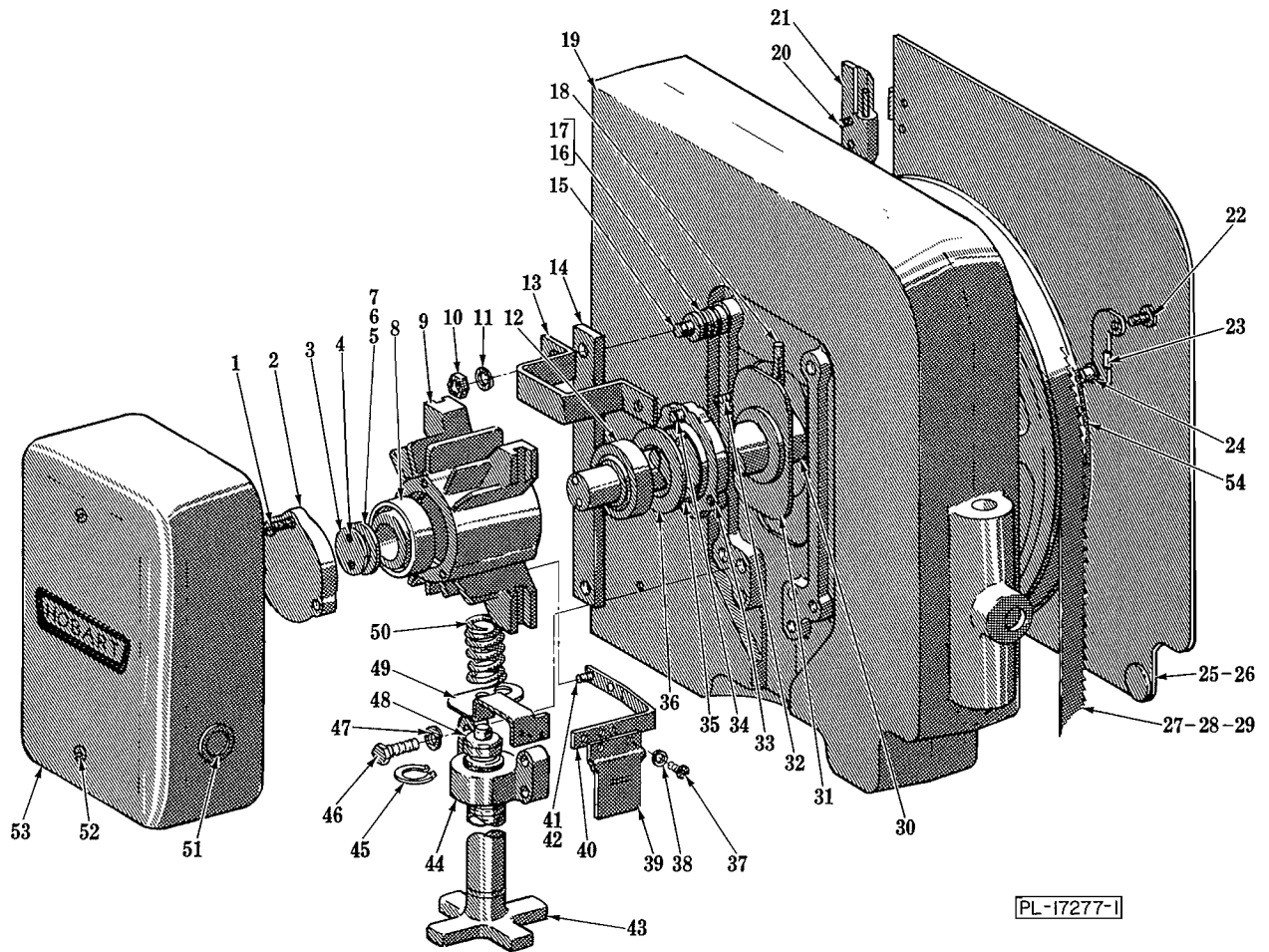


BASE UNIT

ILLUS. PL-17276	PART NO.	NAME OF PART	AMT.
	1	SC-41-27 Cap Screw - 3"-16 x 5/8" Hex Hd	8
	2	WL-4-2 Lock Washer - 3/8" Light	8
	3	SD-24-29 Self-Tapping Screw - #10-32 x 3/4" Phil. Flat Hd. "Taptite"	4
	4	P-78917 Bracket - Hinge	2
	5	R-79124 Blade Cover Assy	1
	6	P-78917 Bracket - Hinge	2
	7	SD-24-29 Self-Tapping Screw - #10-32 x 3/4" Phil. Flat Hd. "Taptite"	4
	8	P-77192-1 Clamp - Stationary Table (Painted Mach.)	1
	9	P-77192-2 Clamp - Stationary Table (SST Mach.)	1
	10	SC-53-5 Mach. Screw - #10-24 x 3/8" Truss Hd	2
	11	NS-31-15 Stop Nut - #10-24 "Elastic"	2
	12	PG-11-3 Groov-Pin - Type 4, 5/16" x 3/4"	2
	13	WS-6-44 Washer	2
	14	WL-6-27 Lock Washer - 3/8" Light	2
	15	SC-41-28 Cap Screw - 3/8"-16 x 3/4" Hex Hd	2
	16	D-124496-1 Carriage Support Assy. (Standard) (Painted Mach.)	1
	17	D-124496-2 Carriage Support Assy. (Standard) (SST Mach.)	1
	18	D-124507-3 Carriage Support Assy. (Heavy Duty) (Painted Mach.)	1
	19	D-124507-2 Carriage Support Assy. (Heavy Duty) (SST Mach.)	1

BASE UNIT (Cont.)

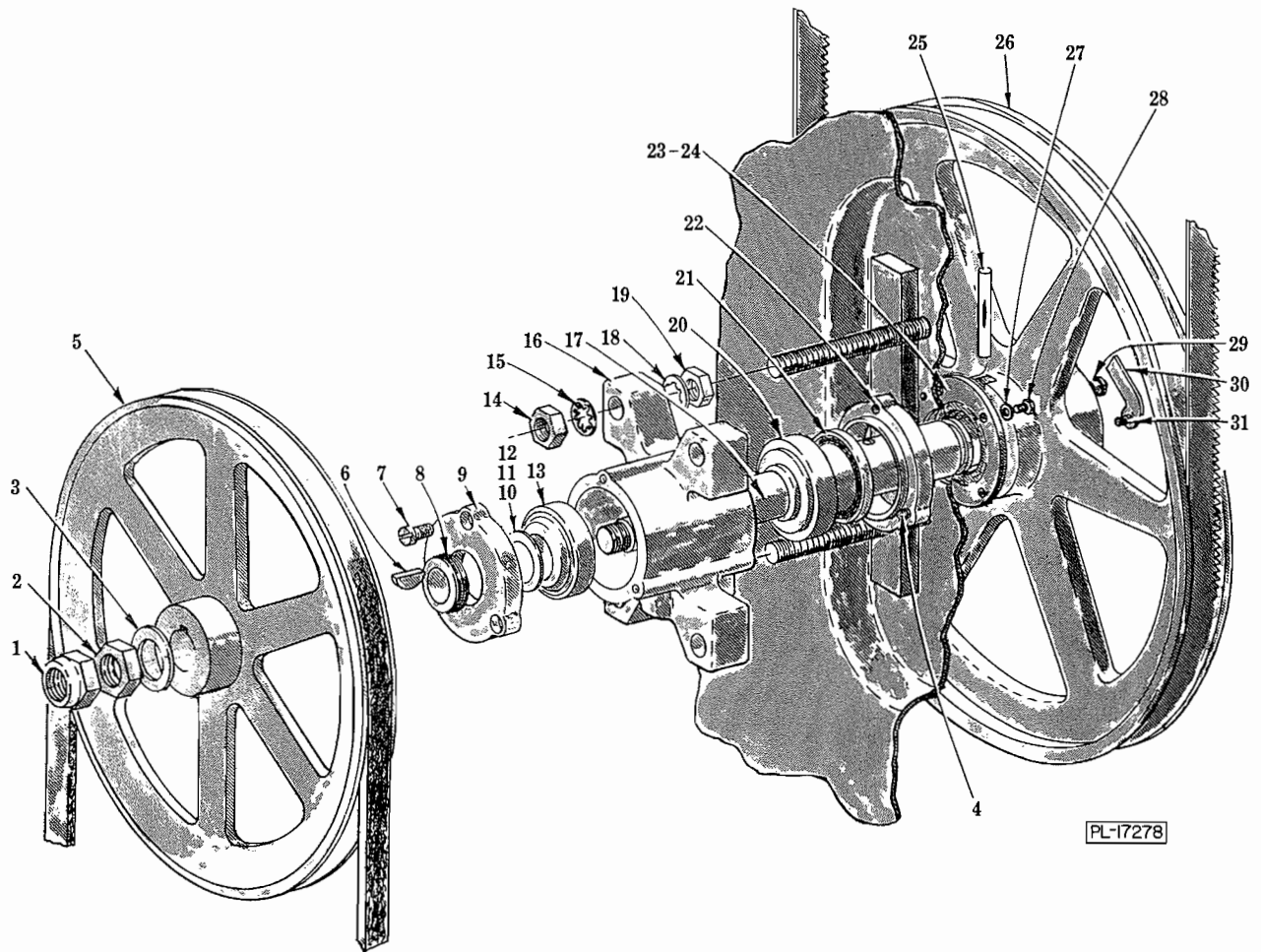
ILLUS. PL-17276	PART NO.	NAME OF PART	AMT.
20	SC-82-38	Carriage Bolt - 3/8"-16 x 1"	2
21	WL-6-27	Lock Washer - 3/8" Light	2
22	NS-15-13	Full Nut - 3/8"-16 Hex Fin	2
23	S-78993-1	Brace - Carriage Support (Standard) (Painted Mach.)	2
24	S-78993-2	Brace - Carriage Support (Standard) (SST Mach.)	2
25	E-120010-2	Brace - Carriage Support (Heavy Duty)	2
26	R-78040-1	Base Door Assy. (Painted Mach.)	1
27	R-78040-2	Base Door Assy. (SST Mach.)	1
28	SC-21-22	Mach. Screw - #10-24 x 3/8" Rd. Hd	1
29	NS-11-18	Mach. Nut - #10-24 Hex	1
30	M-68176	Clip - Spring	1
31	B-120039	Knob - Door	1
32	SC-21-22	Mach. Screw - #10-24 x 3/8" Rd. Hd	1
33	S-101054	Pan - Scrap	1
34	SC-41-30	Cap Screw - 3/8"-16 x 1" Hex Hd	2
35	WL-6-27	Lock Washer - 3/8" Light	2
36	NS-15-13	Full Nut - 3/8"-16 Hex Fin	2
37	B-290349	Foot & Insert Assy	4
38	M-74888-1	Washer - Shim (Painted Mach.)	2
39	M-74888-2	Washer - Shim (SST Mach.)	2
40	B-122720-1	"V" Belt (50 Hz.) (3300 & 6100 F.P.M. Cutting Speed)	1
41	B-120025-4	"V" Belt (60 Hz.) (3300 & 6100 F.P.M. Cutting Speed)	1
42	B-120025-6	"V" Belt (60 Hz.) (4700 F.P.M. Cutting Speed)	1
43	R-71418-1	"V" Pulley - Motor (5.6" O.D.) (60 Hz.) (3300 & 6100 F.P.M. Cutting Speed) (Incls. item #46)	1
44	R-71418-2	"V" Pulley - Motor (6.6" O.D.) (50 Hz.) (3300 & 6100 F.P.M. Cutting Speed) (Incls. item #46)	1
45	C-119949-3	"V" Pulley - Motor (4.25" O.D.) (60 Hz.) (4700 F.P.M. Cutting Speed) (Incls. item #46)	1
46	SC-47-32	Set Screw - 5/16"-18 x 5/16" Soc. Hdls., Cup Pt	1
47	R-12430-62	Key	1
48	D-118306-1	Motor (3 Ph., 200/230/460 V., 60 Hz.) (1725 R.P.M.) (2 H.P. Standard) (Incls. item #47)	1
49	D-118386-1	Motor (3 Ph., 200/230/460 V., 60 Hz.) (1725 R.P.M.) (3 H.P. Optional) (Incls. item #47)	1
50	D-118298-1	Motor (1 Ph., 115/200/230 V., 60 Hz.) (1725 R.P.M.) (Incls. item #47)	1
51	D-118298-2	Motor (1 Ph., 115/220/240 V., 50 Hz.) (1425 R.P.M.) (Incls. item #47)	1
52	D-118306-2	Motor (3 Ph., 220/240/380/415 V., 50 Hz.) (1425 R.P.M.) (Incls. item #47)	1
53	D-118430-1	Motor (3 Ph. 200/230/460 V., 60 Hz.) (3450 R.P.M.) (Incls. item #47)	1
54	D-118430-2	Motor (3 Ph. 220/240/380/415 V., 50 Hz.) (2850 R.P.M.) (Incls. item #47)	1
55	B-107182	Gasket (Short)	2
56	B-107181	Gasket (Long)	2
57	WL-6-27	Lock Washer - 3/8" Light	4
58	P-78992	Reinforcement - Base	2
59	B-122706	Booster - Motor	AR
60	SC-36-71	Cap Screw - 3/8"-16 x 1-1/4" Hex Hd	4
61	SC-37-74	Cap Screw - 3/8"-16 x 1-1/2" Hex Hd. (3 Ph., 50 Hz.; High Speed ONLY)	4
62	SC-111-5	Set Screw - 1/4"-20 x 1/4" Hdls., Cup Pt. "Nylok"	4
63	A-110387-1	Motor Access Panel & Gasket Assy. (Painted Mach.) (Incls. items #55 & 56)	1
64	A-110387-2	Motor Access Panel & Gasket Assy. (SST Mach.) (Incls. items #55 & 56)	1
65	SD-32-15	Self-Tapping Screw - #10-32 x 3/8" Hex Washer Hd. "Taptite"	12
66	SC-41-1	Cap Screw - 1/4"-20 x 3/4" Hex Hd	2
67	NS-31-19	Stop Nut - 1/4"-20 "Elastic"	2
68	WS-3-49	Washer	4
69	C-119598	Clamp - Table	1
70	B-106825-1	Clip - Wiring	2
71	E-124508-1	Base Unit Assy. (Incls. items #6 & 7) (Painted Mach.)	1
72	E-124509-1	Base Unit Assy. (Incls. items #6 & 7) (SST Mach.)	1
73	NS-11-18	Mach. Nut - #10-24 Hex	2
74	WL-13-11	Lock Washer - #10 Int. Shakeproof	3
75	C-118544-1	Lug - Solderless	1
76	NS-15-13	Full Nut - 3/8"-16 Hex Fin	4
77	SC-53-5	Mach. Screw - #10-24 x 3/8" Truss Hd	5
78	SC-53-1	Mach. Screw - #10-24 x 1/4" Truss Hd	2
79	WL-13-11	Lock Washer - #10 Int. Shakeproof	2
80	M-68176	Clip - Spring	1
81	S-71223-1	Cover - Column Top (Painted Mach.)	1
82	S-71223-2	Cover - Column Top (SST Mach.)	1



HEAD UNIT

HEAD UNIT

ILLUS. PL-17277-1	PART NO.	NAME OF PART	AMT.
1	SC-12-69	Mach. Screw - 1/4"-20 x 1/2" Fil. Hd	3
2	P-67210	Cap - Bearing	1
3	M-67241	Retainer - Bearing	1
4	SC-99-4	Cap Screw - #10-24 x 1/2" Flat Hd. "Esllok"	2
5	A-103036-1	Washer - Shim (.002" Thk.)	AR
6	A-103036-2	Washer - Shim (.005" Thk.)	AR
7	A-103036-3	Washer - Shim (.008" Thk.)	AR
8	BR-2-27	Roller Bearing	1
9	D-103022	Carrier - Upper Bearing	1
10	NS-13-22	Full Nut - 3/8"-16 Hex Fin	4
11	WL-4-2	Lock Washer - 3/8" Light	4
12	BR-2-27	Roller Bearing	1
13	P-67147	Cover Brkt. & Weld Nut Assy	2
14	P-67187	Gib - Upper Bearing Carrier	2
15	M-75894	Stud - Upper Bearing Carrier Support	4
16	B-123176-1	Spacer - Bearing Carrier (Upper Studs)	2
17	B-123176-4	Spacer - Bearing Carrier (Lower Studs)	2
18	B-122922	Groov-Pin - Special	1
19	D-102526-2	Head & Magnetic Catch Assy	1
20	SC-22-23	Mach. Screw - #10-24 x 7/8" Flat Hd	4
21	P-78917	Bracket - Hinge	2
22	M-20851	Screw - Latch	1
23	M-20852	Latch	1
24	M-79686	Catch - Friction	1
25	S-75806-1	Door Assy. (Head) (60 Hz.)	1
26	S-75806-2	Door Assy. (Head) (50 Hz.)	1
27	B-124446-1	Blade - Meat Saw (.022" - 4T) (Standard)	1
28	B-124446-2	Blade - Meat Saw (.022" - 3T) (Frozen Beef/Fish)	1
29	B-124446-3	Blade - Meat Saw (.014" - 3T) (Frozen Fish)	1
30	D-117018	Shaft - Upper Bearing Carrier	1
31	B-103288	Shield - Bearing Carrier	1
32	M-75837	Spring - Detent	2
33	B-103029	Cap - Bearing Carrier	1
34	SC-12-69	Mach. Screw - 1/4"-20 x 1/2" Fil. Hd	3
35	A-103178	Seal - Grease	1
36	B-103290	Plate - Bearing Carrier	1
37	SC-7-71	Mach. Screw - #10-24 x 1/4" Rd. Hd	2
38	WL-3-22	Lock Washer - #10 Light	2
39	P-67249	Plate - Blade Tension Sight	1
40	P-75817	Bracket - Tension Indicator	1
41	SC-90-45	Cap Screw - #10-24 x 3/8" Hex Hd	2
42	WL-3-22	Lock Washer - #10 Light	2
43	C-120469-3	Hand Wheel & Adjusting Screw Assy	1
44	P-75897	Nut - Blade Tension Adjusting	1
45	RR-4-8	Retaining Ring	1
46	SC-41-14	Cap Screw - 5/16"-18 x 1-1/8" Hex Hd	4
47	WL-3-44	Lock Washer - 5/16" Medium	4
48	BB-13-1	Thrust Bearing - Nice #603	1
49	P-75816	Indicator - Tension	1
50	M-20867	Spring - Adj. Blade Tension	1
51	M-75656	Window Unit	1
52	SD-31-2	Self-Tapping Screw - #10-24 x 1-3/8" Truss Hd "Powerlok"	2
53	C-120830	Cover & Window Assy. (Incls. item #51)	1
54	R-72364-2	Flanged Pulley (Blade) Assy. (Incls. items #22, 23 & 24)	1
	A-114628	Upper Bearing Carrier Assy. (Incls. items #1 thru 9, 12, 18 & 30 thru 36)	1

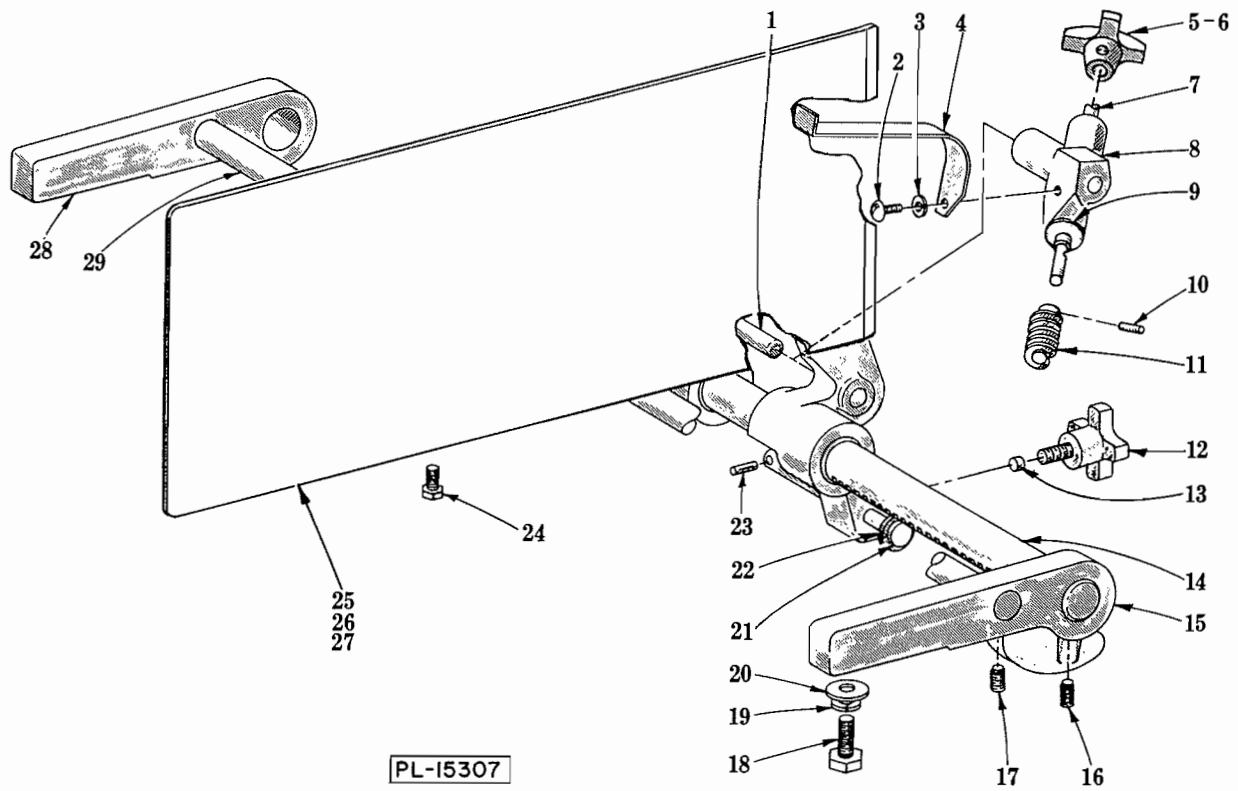


PL-17278

LOWER BEARING CARRIER UNIT

LOWER BEARING CARRIER UNIT

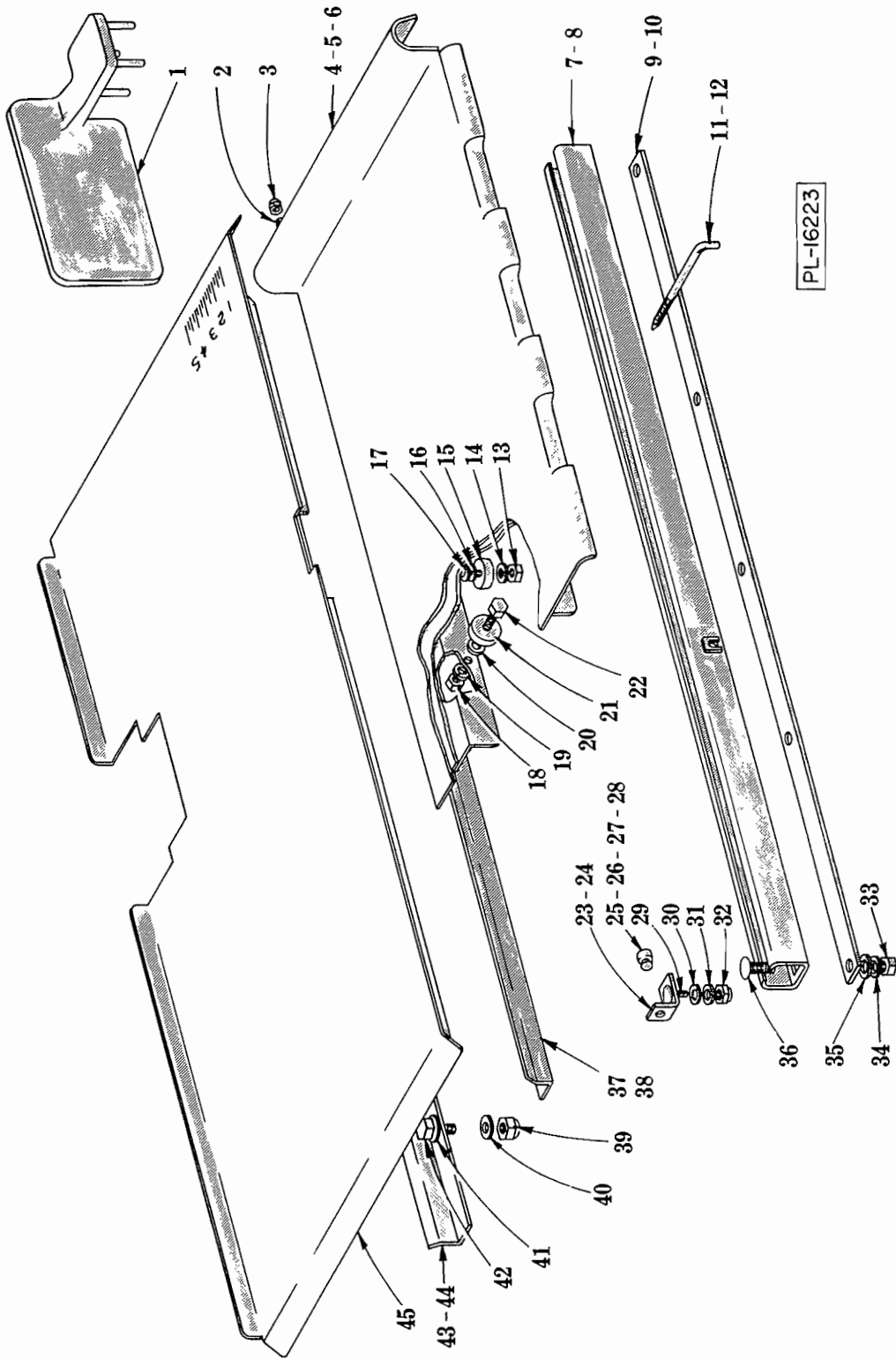
ILLUS. PL-17278	PART NO.	NAME OF PART	AMT.
1	NS-31-43	Stop Nut - 3/4"-16 "Elastic"	1
2	NS-17-49	Jam Nut - 3/4"-16 Hex Fin	1
3	WS-29-12	Washer	1
4	SC-12-69	Mach. Screw - 1/4"-20 x 1/2" Fil. Hd	3
5	R-83776	"V" Pulley - Brg. Carrier (12-3/4" O.D.)	1
6	KW-3-15	Key - #807 Woodruff	1
7	SC-12-69	Mach. Screw - 1/4"-20 x 1/2" Fil. Hd	3
8	B-114560	Conveyor - Lower Bearing Carrier Grease	1
9	C-114561	Cap - Lower Brg. Carrier ("V" Belt Side)	1
10	B-123192-1	Washer - Shim (.002" Thk.)	AR
11	B-123192-2	Washer - Shim (.005" Thk.)	AR
12	B-123192-3	Washer - Shim (.008" Thk.)	AR
13	BR-2-27	Roller Bearing	1
14	NS-13-30	Full Nut - 1/2"-13 Hex Fin	4
15	WL-8-31	Lock Washer - 1/2" Int. Shakeproof	4
16	D-114562	Carrier - Lower Bearing	1
17	D-117016	Shaft - Lower Brg. Carrier	1
18	WL-8-31	Lock Washer - 1/2" Int. Shakeproof	4
19	NS-13-30	Full Nut - 1/2"-13 Hex Fin	4
20	BR-2-20	Roller Bearing	1
21	M-71403	Seal - Grease	1
22	M-77319	Bearing Cap & Seal Assy. (Incls. item #21)	1
23	M-77510-2	Washer & Seal Assy. (Incls. item #24)	1
24	M-77511	Seal - Diaphragm	1
25	B-122922	Groov-Pin - Special	1
26	R-72364-2	Flanged Pulley (Blade) Assy. Unit (Incls. items #29, 30 & 31)	1
27	WS-23-34	Washer	4
28	SC-67-12	Mach. Screw - #10-32 x 5/16" Trimmed Hex Hd	4
29	M-79686	Catch - Friction	1
30	M-20852	Latch	1
31	M-20851	Screw - Latch	1
	C-117022-2	Lower Bearing Carrier Assy. (Incls. items #4, 7 thru 13, 16, 17, 20 & 22)	1



GAUGE PLATE UNIT

GUAGE PLATE UNIT

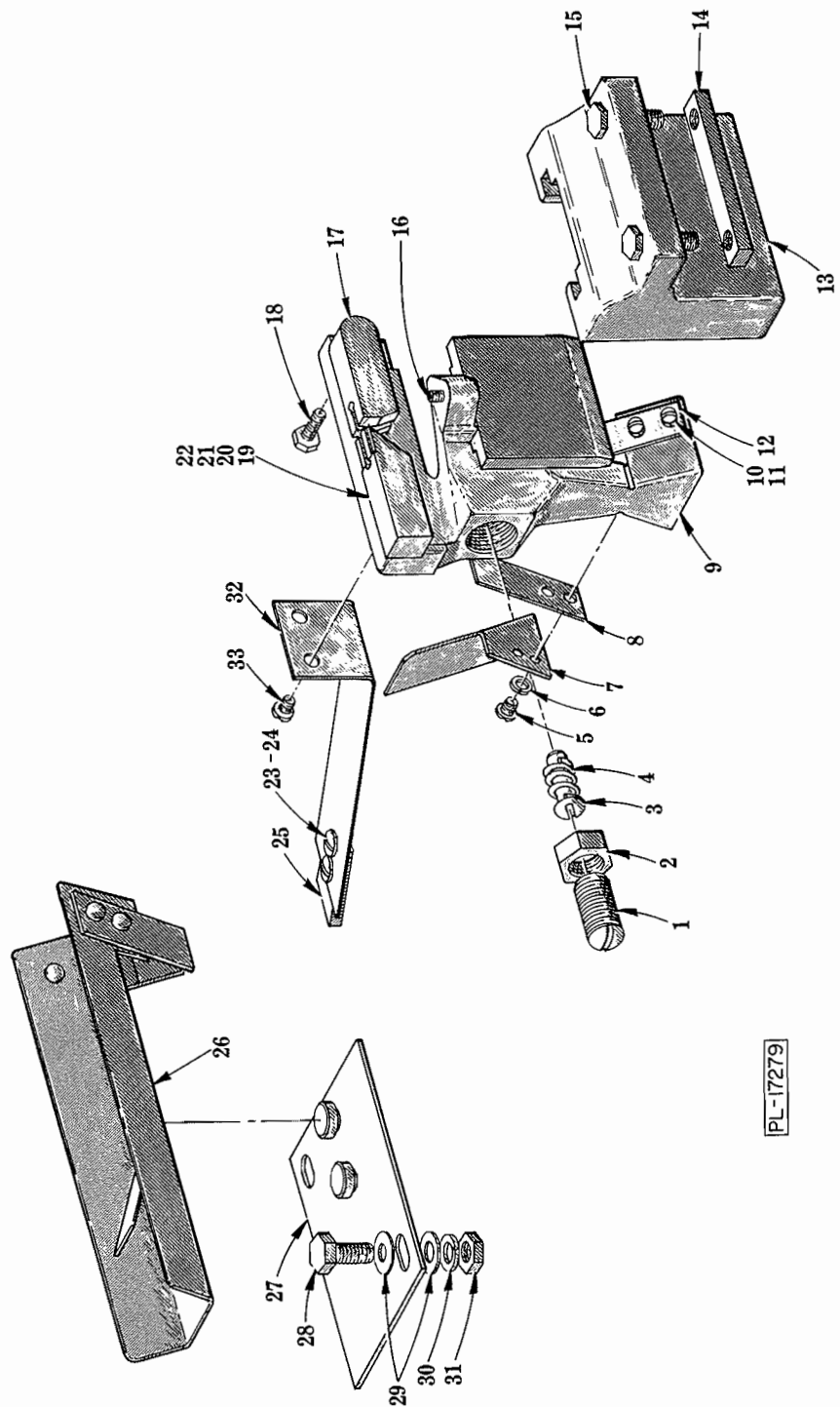
ILLUS. PL-15307	PART NO.	NAME OF PART	AMT.
1	M-77235	Pin	1
2	SC-21-14	Mach. Screw - #8-32 x 3/8" Rd. Hd	1
3	WL-6-1	Lock Washer - #8 Light	1
4	P-77848	Spring - Gauge Plate	1
5	B-118551	Knob	1
6	SC-111-5	Set Screw - 1/4"-20 x 1/4" Soc. Hdls., Cup Pt. "Nylok"	1
7	M-77843	Shaft - Worm	1
8	M-83481	Worm Bracket & Bearing Assy	1
9	WS-18-36	Washer	1
10	PG-7-7	Groov-Pin - Type E, 1/8" x 7/16"	1
11	M-20887	Worm	1
12	C-118958-1	Knob - Positioning	1
13	M-78920	Slug	1
14	P-77841-2	Rack - Gauge Plate	1
15	R-117404	Bracket - Gauge Plate Support (Front)	1
16	SC-103-10	Set Screw - 5/16"-18 x 3/8" Soc. Hdls., Cup Pt. "Unbrako/Loc-Well"	2
17	SC-103-10	Set Screw - 5/16"-18 x 3/8" Soc. Hdls., Cup Pt. "Unbrako/Loc-Well"	2
18	SC-41-28	Cap Screw - 3/8"-16 x 3/4" Hex Hd	4
19	WL-6-27	Lock Washer - 3/8" Light	4
20	WS-18-37	Washer	4
21	M-85397	Gauging Pin	1
22	WS-18-36	Washer	1
23	PG-11-2	Groov-Pin - Type E, 7/64" x 1/2"	1
24	M-79155	Bolt (Special)	1
25	D-120136-1	Gauge Plate Assy. (SST) (USDA)	1
26	NS-25-4	Acorn Nut - 1/4"-20	6
27	C-120138	Arm & Bushing Assy. (SST) (USDA)	1
28	R-117405	Bracket - Gauge Plate Support (Rear)	1
29	M-77842	Rod - Gauge Plate Stop	1
	E-120139-1	Gauge Plate Assy. (Incls. items #1 thru 13 & 21 thru 27)	1
	D-124056-2	Gauge Plate Assy. (SST) (USDA) (Incls. items #25, 26 & 27)	1
	P-77846	Worm Bracket Assy. (Incls. items #2 thru 11)	1



TABLE, CARRIAGE AND TRACK UNIT

TABLE, CARRIAGE AND TRACK UNIT

ILLUS. PL-16223	PART NO.	NAME OF PART	AMT.
1	P-77576-2	Pusher Plate Assy	1
2	SC-53-1	Mach. Screw - #10-24 x 1/4" Truss Hs. (Standard)	1
3	NS-27-3	Acorn Nut - #10-24 (Standard)	1
4	S-79089-1	Carriage Assy. (Standard) (Painted Mach.)	1
5	S-79089-2	Carriage Assy. (Standard) (SST Mach.)	1
6	E-119960	Carriage Assy. (Heavy Duty)	1
7	R-78098-1	Carriage Guide Assy. (Painted Mach.)	1
8	R-78098-2	Carriage Guide Assy. (SST Mach.)	1
9	P-79094-1	Spacer - Carriage Guide (Painted Mach.)	1
10	P-79094-2	Spacer - Carriage Guide (SST Mach.)	1
11	M-78935-1	Screw - Carriage Lock (Standard)	1
12	B-119972	Screw - Carriage Lock (Heavy Duty)	1
13	NS-15-13	Full Nut - 3/8"-16 Hex Fin	2
14	WL-6-27	Lock Washer - 3/8" Light	2
15	BB-8-11	Ball Bearing - Nice #SK-T2198	2
16	WS-18-34	Washer (.010" Thk.)	AR
17	WS-18-37	Washer (1/16" Thk.)	2
18	NS-15-13	Full Nut - 3/8"-16 Hex Fin	4
19	WL-6-27	Lock Washer - 3/8" Light	4
20	WS-18-31	Washer	4
21	BB-8-11	Ball Bearing - Nice #SK-T2198	4
22	SC-41-30	Cap Screw - 3/8"-16 x 1" Hex Hd	4
23	P-86049	Stop - Carriage (Standard)	2
24	B-119827	Stop - Carriage (Heavy Duty)	2
25	M-77318	Bumper - Carriage Stop (Standard)	2
26	B-18682-2	Bumper - Carriage Stop (Heavy Duty) (Not Shown)	2
27	NS-15-11	Full Nut - 5/16"-18 Hex Fin. (Heavy Duty)	2
28	WS-17-21	Washer (Heavy Duty)	2
29	SC-94-20	Carriage Bolt - 5/16"-18 x 1"	2
30	WS-18-34	Washer	2
31	M-70087	Washer - Spring	2
32	NS-31-29	Stop Nut - 5/16"-18 "Elastic"	2
33	NS-15-11	Full Nut - 5/16"-18 Hex Fin	5
34	WL-6-23	Lock Washer - 5/16" Medium	5
35	WS-17-21	Washer	5
36	SC-94-20	Carriage Bolt - 5/16"-18 x 1"	5
37	S-78055-1	Rest - Front Table (Painted Mach.)	1
38	S-78055-2	Rest - Front Table (SST Mach.)	1
39	NS-31-29	Stop Nut - 5/16"-18 "Elastic"	6
40	WS-17-1	Washer	6
41	WS-17-1	Washer	6
42	SC-41-12	Cap Screw - 5/16"-18 x 7/8" Hex Hd	6
43	S-78055-3	Rest - Rear Table (Painted Mach.)	1
44	S-78055-4	Rest - Rear Table (SST Mach.)	1
45	S-78049-2	Table Assy	1
	B-78093-1	Carriage Unit Assy. (Standard) (Incls. items #2, 3, 4, 11 & 13 thru 22) (Painted Mach.)	1
	B-28093-2	Carriage Unit Assy. (Standard) (Incls. items #2, 3, 5, 11 & 13 thru 22) (SST Mach.)	1
	B-120228	Carriage Unit Assy. (Heavy Duty) (Incls. items #2, 3, 6 & 12 thru 22)	1



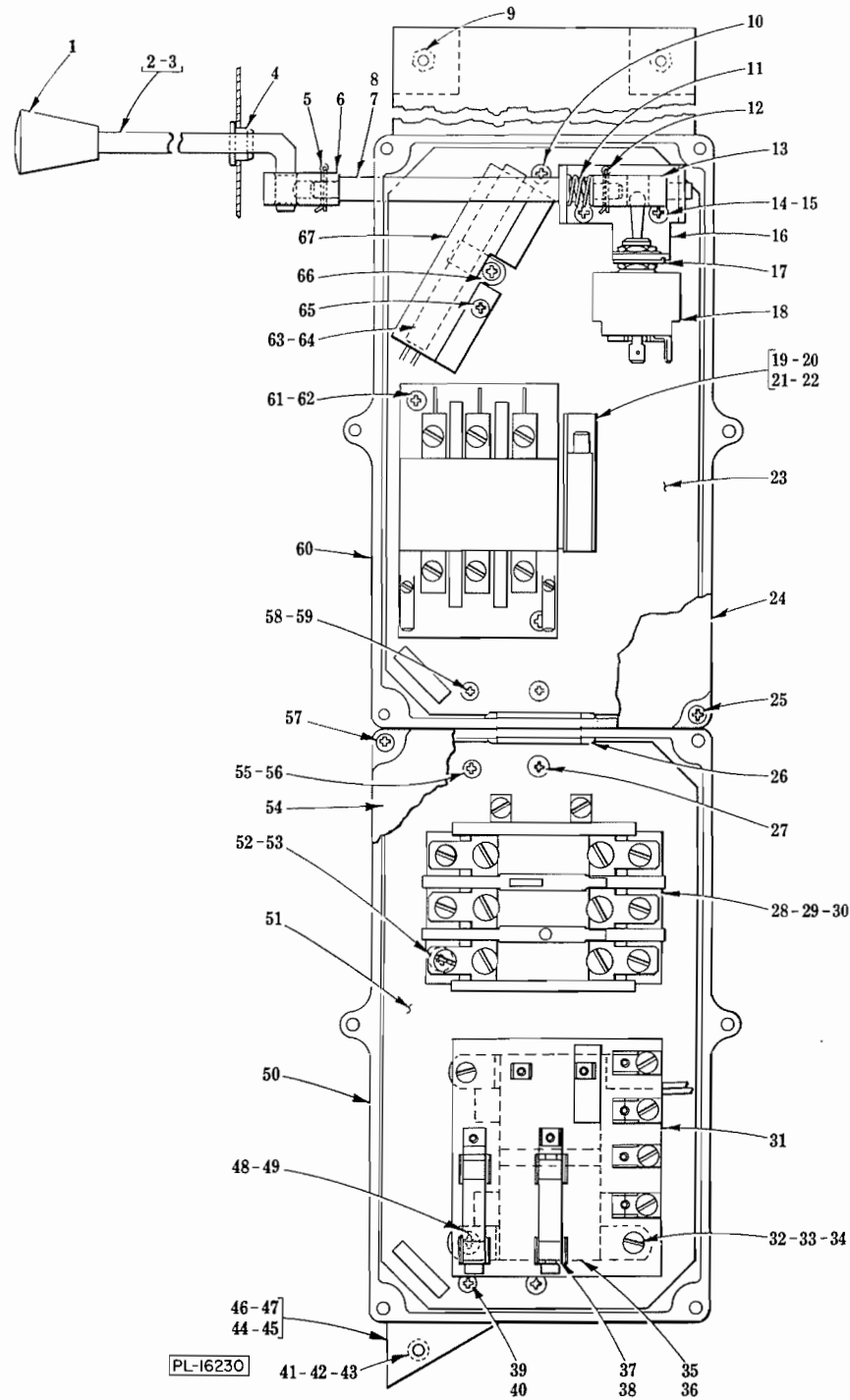
PL-17279

LOWER GUIDE AND WIPER UNIT

LOWER GUIDE AND WIPER UNIT

ILLUS. PL-17279	PART NO.	NAME OF PART	AMT.
1	SC-49-22	Set Screw - 9/16"-18 x 7/8" Hdls., Flat Pt	1
2	NS-18-33	Jam Nut - 9/16"-18 Hex Fin	1
3	M-101924	Blade Back-Up Block Assy	1
4	M-101925	Spring - Back-Up Block	1
5	SC-21-85	Mach. Screw - #8-32 x 3/16" Rd. Hd	2
6	WL-6-2	Lock Washer - #8 Medium	2
7	B-121168	Deflector - Scrap	1
8	B-121170	Scraper - Blade	1
9	B-121660	Lower Wiper Support & Bushing Assy	1
10	WL-6-2	Lock Washer - #8 Medium	2
11	SC-21-85	Mach. Screw - #8-32 x 3/16" Rd. Hd	2
12	B-121170	Scraper - Blade	1
13	C-121161	Slideway - Wiper Bracket	1
14	M-67702	Plate - Wiper Bracket Retainer	1
15	SC-41-13	Cap Screw - 5/16"-18 x 1" Hex Hd	2
16	SC-109-84	Set Screw - #10-24 x 5/8" Soc. Hdls., Flat Pt	1
17	B-102653	Guard - Saw Blade	1
18	SC-41-61	Cap Screw - 1/4"-28 x 3/4" Hex Hd	2
19	B-109142-4	Guide - Saw Blade (.020" Blade)	1
20	B-109142-2	Guide - Saw Blade (.014" Blade)	1
21	B-109142-1	Guide - Saw Blade (.026" Blade)	1
22	B-109142-3	Guide - Saw Blade (.038" Blade)	1
23	WS-23-34	Washer	2
24	SC-53-1	Mach. Screw - #10-24 x 1/4" Truss Hd	2
25	B-123886	Wiper - Pulley	1
26	C-124266	Rear Wiper Assy	1
27	B-121158	Rear Wiper Base Assy	1
28	SC-62-54	Cap Screw - 1/4"-20 x 3/4" Hex Hd	2
29	WS-3-45	Washer	4
30	WL-3-38	Lock Washer - 1/4" Medium	2
31	NS-13-2	Full Nut - 1/4"-20 Hex Fin	2
32	C-123701-1	Spring - Pulley Wiper	1
33	SD-15-3	Self-Tapping Screw - #10-24 x 1/4" Pan Hd. "Taptite"	2
	D-123846-5	Lower Guide & Wiper Assy. (.020" Blade) (Incls. items #1 thru 12 & 16, 17, 18, 19, 23, 24, 25, 32 & 33)	1
	D-123846-6	Lower Guide & Wiper Assy. (.014" Blade) (Incls. items #1 thru 12 & 16, 17, 18, 20, 23, 24, 25, 32 & 33)	1

5216 REPLACEMENT PARTS

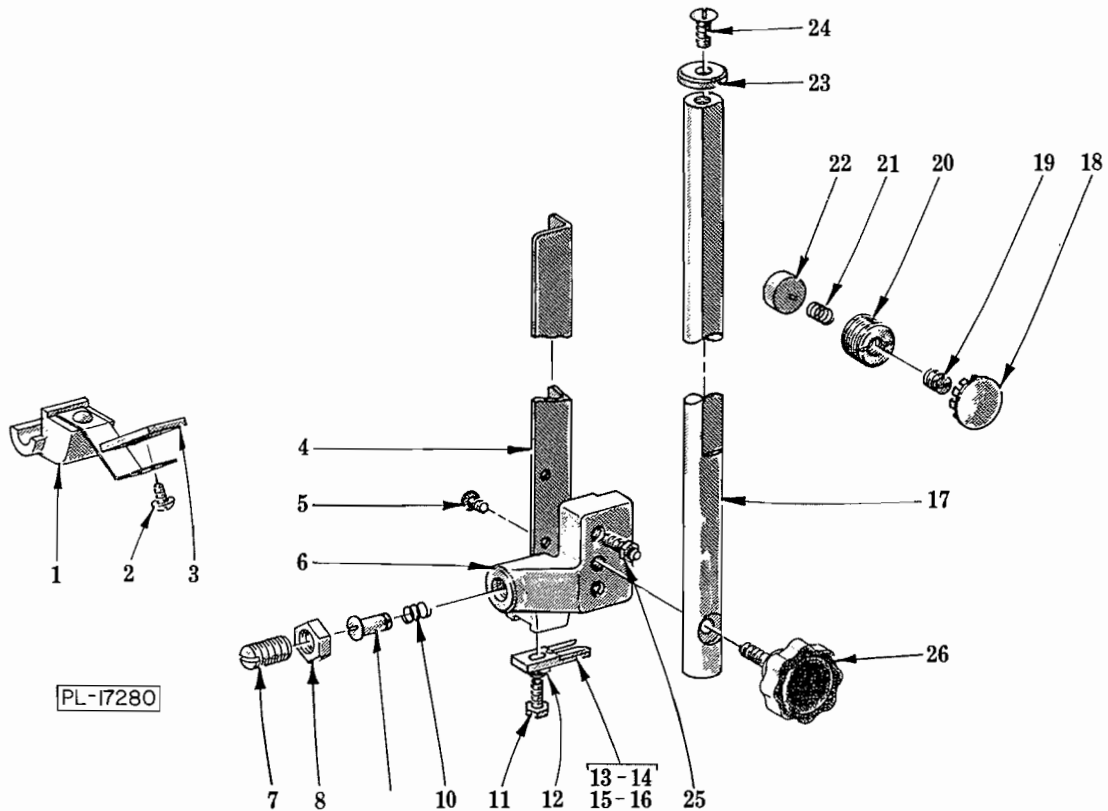


ELECTRICAL UNIT

ILLUS. NO.	PART NO.	NAME OF PART	AMT.
1	B-120054-2	Knob - Switch	1
2	C-121537-1	Rod - Switch Operating (Standard)	1
3	C-121537-2	Rod - Switch Operating (Heavy Duty)	1
4	B-121539	Bushing - Switch Rod	1

ELECTRICAL UNIT (Cont.)

ILLUS. PL-16230	PART NO.	NAME OF PART	AMT.
5	PC-5-8	Cotter Pin - 3/32" x 5/8"	1
6	C-121535	Adapter - Switch Operating	1
7	B-121553	Switch Shaft Assy. (Incls. items #6, 8, & 13)	1
8	B-121550	Shaft - Switch	1
9	SC-41-86	Cap Screw - 1/4"-20 x 3/8" Hex Hd	2
10	SD-15-40	Self-Tapping Screw - #8-32 x 3/8" Phil. Pan Hd. "Taptite"	2
11	B-121547	Spring - Compression	1
12	PC-5-8	Cotter Pin - 3/32" x 5/8"	1
13	C-121540-1	Actuator - Switch	1
14	SD-15-40	Self-Tapping Screw - #8-32 x 3/8" Phil. Pan Hd. "Taptite"	2
15	WL-7-7	Lock Washer - #8 Ext. Shakeproof	2
16	C-123241-1	Bracket - Switch	1
17	B-121827	Ring - Locking	1
18	B-120388	Switch & Label Assy	1
19	B-121925-1	Contactory Assy. (200/230 V., 60 Hz.; 220/240 V., 50 Hz.) (1 Ph.)	1
20	B-121925-2	Contactory Assy. (115 V., 50/60 Hz.) (200/230 V., 60 Hz. W/Pilot Circuit; 220/240 V., 50 Hz. W/Pilot Circuit) (1 Ph.)	1
21	B-121926-1	Contactory Assy. (200/230 V., 60 Hz.; 220/240 V., 50 Hz.) (3 Ph.)	1
22	B-121926-2	Contactory Assy. (460 V., 60 Hz; 380/415 V., 50 Hz.) (200/230 V., 60 Hz; 220/240 V., 50 Hz. W/Pilot Circuit) (3 Ph.)	1
23	C-121544	Panel - Control Box (Upper)	1
24	C-121545	Cover - Switch Box	1
25	SD-32-13	Self-Tapping Screw - #8-16 x 1" Phil. Pan Hd. "Plastite"	6
26	B-121557	Grommet	1
27	SD-15-40	Self-Tapping Screw - #8-32 x 3/8" Phil. Pan Hd. "Taptite"	2
28	B-88196-6-1	Relay - Thermal Overload (1 Ph.)	1
29	B-88196-9-1	Relay - Thermal Overload (3 Ph.)	1
30	---	Heater Element - Overload Relay (Give Elec. Spec., Mach. Model & Motor Type)	AR
31	C-114707	Terminal & Mounting Board Assy	1
32	SC-19-33	Mach. Screw - #8-32 x 1/2" Bind. Hd	2
33	WL-7-7	Lock Washer - #8 Ext. Shakeproof	2
34	NS-9-12	Mach. Nut - #8-32 Hex	2
35	B-120907	Transformer (60 Hz.)	1
36	B-120908	Transformer (50 Hz.)	1
37	FE-19-48	Fuse (.8 Amp., 600 V.) (60 Hz.)	2
38	FE-16-29	Fuse (1 Amp., 600 V.) (50 Hz.)	2
39	SD-15-20	Self-Tapping Screw - #10-32 x 3/8" Phil. Pan Hd. "Taptite"	1
40	WL-7-12	Lock Washer - #10 Ext. Shakeproof	1
41	SC-14-57	Mach. Screw - #10-24 x 1/2" Flat Hd	1
42	WL-3-20	Lock Washer - #10 Light	1
43	NS-9-22	Mach. Nut - #10-24 Hex	1
44	C-121532-1	Control Box Plate Assy. (Single)	1
45	C-121532-2	Control Box Plate Assy. (Dual)	1
46	SC-18-20	Mach. Screw - #10-24 x 1/2" Pan Hd	AR
47	WL-3-20	Lock Washer - #10 Light	AR
48	SD-15-20	Self-Tapping Screw - #10-32 x 3/8" Phil. Pan Hd. "Taptite"	2
49	WL-7-12	Lock Washer - #10 Ext. Shakeproof	1
50	D-121546-2	Box - Motor Control	1
51	C-121555	Panel - Control Box	1
52	SD-15-20	Self-Tapping Screw - #10-32 x 3/8" Phil. Pan Hd. "Taptite"	2
53	WL-7-12	Lock Washer - #10 Ext. Shakeproof	1
54	C-121545	Cover - Switch Box	1
55	SD-15-20	Self-Tapping Screw - #10-32 x 3/8" Phil. Pan Hd. "Taptite"	1
56	WL-7-12	Lock Washer - #10 Ext. Shakeproof	1
57	SD-32-13	Self-Tapping Screw - #8-16 x 1" Phil. Pan Hd. "Taptite"	6
58	SD-15-20	Self-Tapping Screw - #10-32 x 3/8" Phil. Pan Hd. "Taptite"	1
59	WL-7-12	Lock Washer - #10 Ext. Shakeproof	1
60	D-121546-1	Box - Motor Control	1
61	SD-15-20	Self-Tapping Screw - #10-32 x 3/8" Phil. Pan Hd. "Taptite"	2
62	WL-7-12	Lock Washer - #10 Ext. Shakeproof	1
63	B-122345-1	Heater Assy. (115 V., 50/60 Hz., 1 Ph.) (460 V., 60 Hz.; 380/415 V., 50 Hz., 3 Ph.) (200/230 V., 60 Hz., 1 & 3 Ph.; 220/240 V., 50 Hz., 1 & 3 Ph. W/Pilot Circuit)	1
64	B-122345-2	Heater Assy. (200/230 V., 60 Hz., 1 & 3 Ph.; 220/240 V., 50 Hz., 1 & 3 Ph.)	1
65	SD-15-40	Self-Tapping Screw - #8-32 x 3/8" Phil. Pan Hd. "Taptite"	2
66	C-108199-1	Clamp - Air Heater	1
67	C-121543	Shield - Heater	1
	C-112005	Gasket - Lid (Use with items #24 & 54) (Not Shown)	AR



UPPER GUIDE, GUARD AND PULLEY WIPER UNIT

ILLUS. PL-17280	PART NO.	NAME OF PART	AMT.
1	B-102399	Upper Pulley Wiper Assy. (Incls. items #2 & 3)	1
2	SC-53-1	Mach. Screw - #10-24 x 1/4" Truss Hd	2
3	B-123886	Wiper - Upper Pulley	1
4	C-120443-2	Guard - Upper Blade	1
5	SC-53-5	Mach. Screw - #10-24 x 3/8" Truss Hd	2
6	B-113863	Upper Guide Support & Bushing Assy	1
7	SC-49-22	Set Screw - 9/16"-18 x 7/8" Hdls., Flat Pt	1
8	NS-18-33	Jam Nut - 9/16"-18 Hex Fin	1
9	M-101924	Blade Back-Up Block Assy	1
10	M-101925	Spring - Back-Up Block	1
11	SC-67-6	Mach. Screw - #10-24 x 1/2" Trimmed Hex Hd	1
12	A-104573	Washer - Belleville	1
13	P-101929-4	Guide - Blade (.020" Blade)	1
14	P-101929-2	Guide - Blade (.014" Thk.)	1
15	P-101929-1	Guide - Blade (.026" Blade)	1
16	P-101292-3	Guide - Blade (.038" Blade)	1
17	B-102321-4	Rod - Slide	1
18	PB-2-26	Plug - Button	1
19	SC-63-33	Set Screw - 3/8"-16 x 3/8" Hdls., Flat Pt	1
20	B-120140	Screw - Slide Rod Adjusting	1
21	M-75866	Spring - Slide Rod Adjusting	1
22	B-120141	Shoe - Slide Rod	1
23	M-69849	Stop - Slide Rod	1
24	SC-53-16	Mach. Screw - 5/16"-18 x 5/8" Truss Hd	1
25	A-102322	Screw - Adjusting	2
26	C-120444-1	Knob - Positioning	1
	C-113850-5	Upper Guide & Guard Assy. (.020" Blade) (Incls. items #4 thru 13 & 25)	1
	C-113850-6	Upper Guide & Guard Assy. (.014" Blade) (Incls. items #4 thru 12, 14 & 25)	1