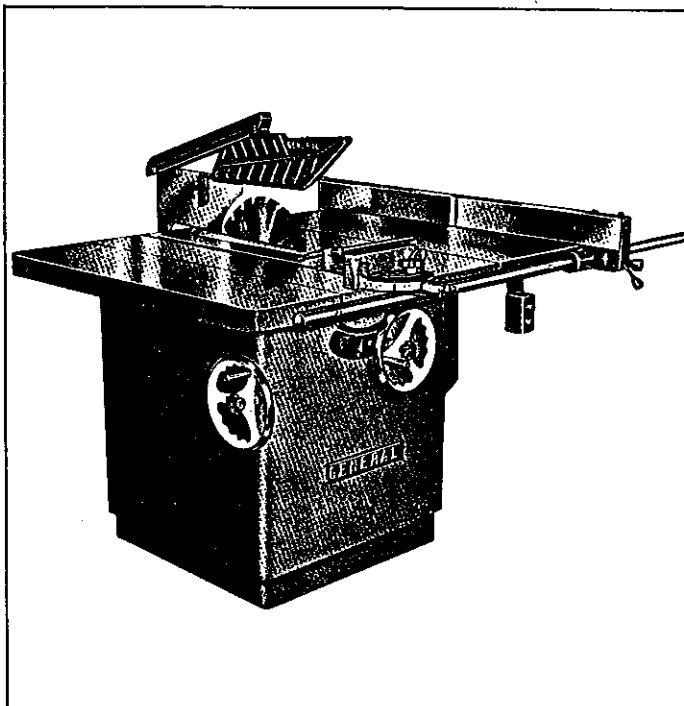


14" TILTING ARBOR SAW OPERATING AND MAINTENANCE INSTRUCTIONS

SPECIFICATIONS

| | |
|--|-------------------------|
| Diameter of saw blade | 14" |
| Diameter of arbor | 1" |
| Maximum depth of cut | 4-7/8" |
| Maximum depth of cut at 45 | 3-3/8" |
| Saw tilts to right | 45 |
| Maximum rip to right of saw: | |
| Guide bars in standard position | 30" |
| Guide bars in Set-Over position | 50" |
| Maximum width of cut-off (1" stock) | 22-1/4" |
| Maximum cut left of blade | 20" |
| Distance in front of blade, maximum cut | 18-1/4" |
| Maximum width of dado with extension arbor | 2" |
| Diameter of dado | 8" or 10" |
| Table size | 38" to 48" |
| T-Slot Miter gauge groove | 3/8" x 1-3/8" |
| Speed of saw blade | 3450 Rpm. - 12,600 Fpm. |
| Motor required | T.E.F.C., 5 H.P. |
| Shipping weight | 1,040 lbs |



MODEL NO.
550

SERIAL NO.

IMPORTANT: When ordering replacement parts, always give model number, serial number of machine and part number. Also give description and quantity of each item.

All replacements parts can be obtained from:

GENERAL MFG. CO. LTD.
835 Cherrier, Drummondville
Quebec, Canada, J2B 5A8

EQUIPMENT INCLUDED WITH THE MACHINE

- Rapid-set rip fence
- Combination blade
- Miter gauge and stop rods
- Blade guard and splitter with anti-kickback fingers
- 1" arbor for saw blade
- 5 H.P. motor to operate on 3 phase, 208/220/440 or 550 Volts, 60 cycle
- Magnetic starter and start stop push button station
- Dust outlet connection

OPTIONAL EQUIPMENT

Dado table insert

Arbor extension 1" dia., for dado with 1" hole

Arbor extension 1-1/8" dia., for dado with 1-1/8" hole

Arbor extension 1-1/4" dia., for dado with 1-1/4" hole

Arbor 1-1/8" dia., for saws with 1-1/8" hole

Arbor 1-1/4" dia., for saws with 1-1/4" hole

Circular saw blades

Dado cutters

The General 14" Tilting Arbor Saw is carefully tested and inspected before shipment and if properly used will give perfect results. It is easy to operate and requires little maintenance but a reasonable amount of care and attention is required to insure perfect performance and accurate work. It is imperative that you take a few moments to read and familiarize yourself with these instructions and they will probably save you a lot of time and trouble.

INSTALLATION

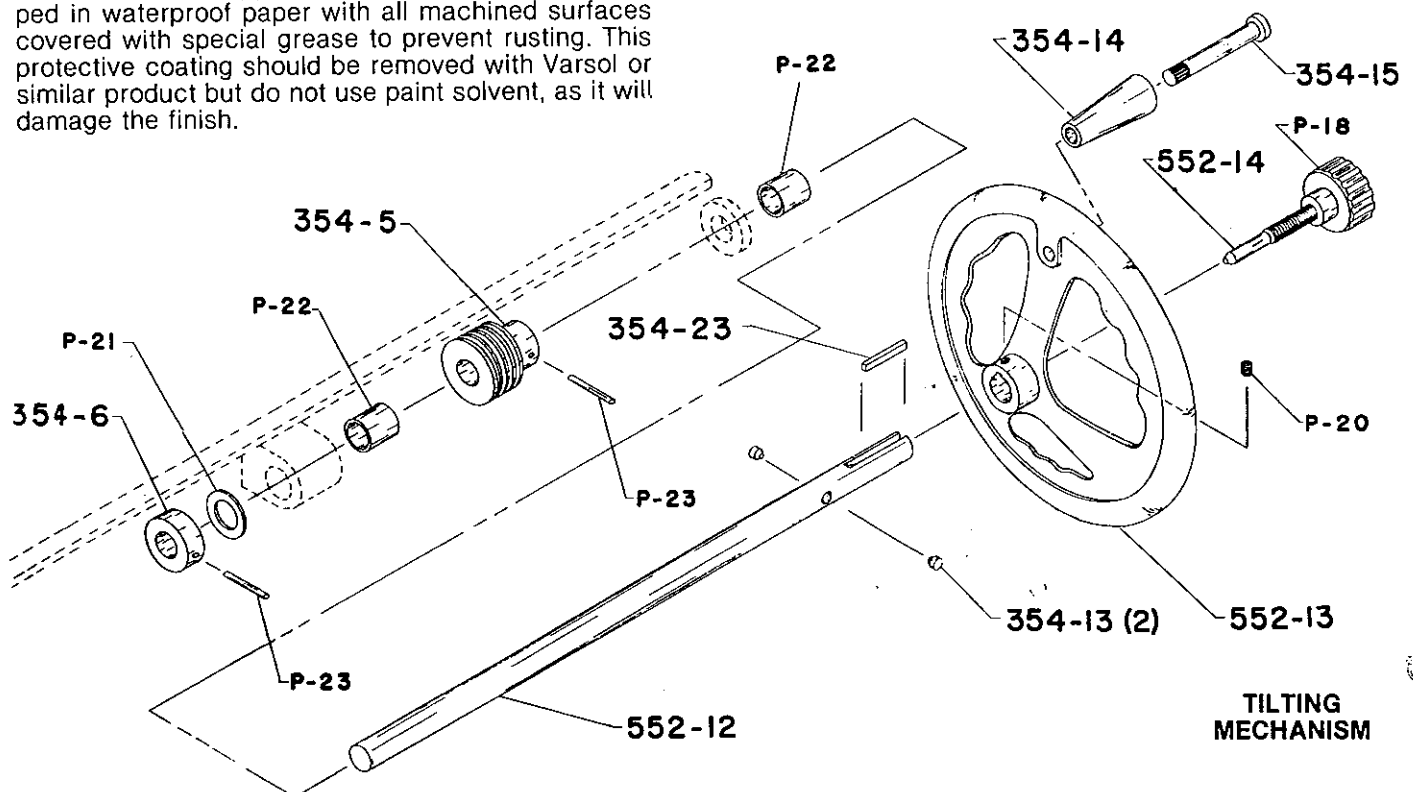
The machine is shipped in a wooden crate and wrapped in waterproof paper with all machined surfaces covered with special grease to prevent rusting. This protective coating should be removed with Varsol or similar product but do not use paint solvent, as it will damage the finish.

The Saw is now ready to be put in its place. If the saw is to be bolted to the floor, care should be taken in doing so, in order that your machine will not be twisted out-of-true, when tightened to the floor. On concrete floors, no special foundation is necessary to install the machine. A good wooden floor is also satisfactory, in such case lag screws may be used.

It is most important that your machine be perfectly levelled both lengthwise and crosswise before final bolting down, shims should be placed underneath the machine, and the saw levelled by placing a spirit level across the table in both direction. When the machine is levelled and the four corners are resting firmly, tighten the bolts.

WIRING

Your machine is shipped from the factory, complete with motor and controls with all necessary wiring. It is only necessary to bring the power lines to the machine to put it in operation. Motor and starter are supplied as per customer requirements and can be 208/220/440/550 volts, 60 cycles. Be sure that the line voltage is the same as stamped on the motor and starter. The 5 H.P. motor with a 14" saw blade will have a cutting speed of 12,600 Fpm. and turns at 3,450 Rpm. Totally enclosed motors are built to operate at higher temperature and higher temperature rise is normal. It is recommended that the machine be connected to an exhaust system and a dust connection is provided.



ADJUSTMENTS

Your tilting arbor saw leaves the factory completely adjusted. However, a complete checkup is recommended, both to familiarize yourself with it and to be sure that every thing is in order. The front handwheel is used to raise and lower the saw table. Adjustable stops are provided to limit the travel. The saw blade can be raised to a maximum of 4-7/8" above the table. The left handwheel is used to tilt the saw blade from 90° to 45°. The saw blade can be locked at any height or any angle of tilt by the knobs extending in front of the handwheels.

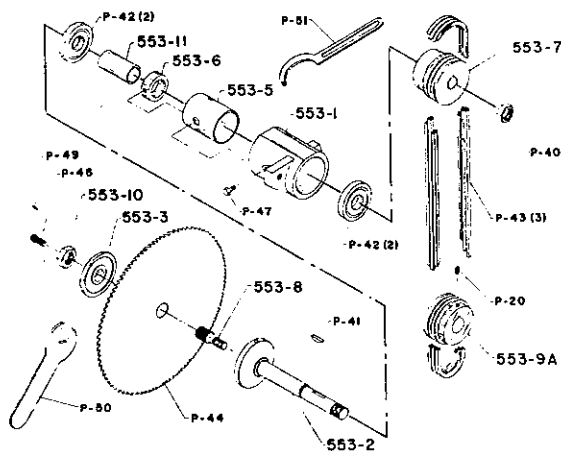
Only a small amount of force is required to lock securely. Any added force puts on unnecessary strain on the lock device.

SAW BLADE

The saw blade should be placed at 90° and the stop screws adjusted. This is done through the motor opening, by turning the screw up or down and locking it in place with the lock nut. The pointer should be adjusted at 0. It will now give the right reading. Tilt the saw blade to 45° and adjust the stops, proceeding in the same manner as above.

The machine is furnished with a combination saw blade suitable for either ripping or cross-cutting, which will save considerable time in a shop, where the amount of cross-cutting and ripping is about equal. The tilting arbor Saw uses ripping saw, combination saw, cross-cutting saw or planer saw, 14" diameter with hole 1" diameter. It is important that saw blades be kept sharp at all times as a dull blade requires several times more power than a sharp one.

Always keep saws sharp and well set to obtain satisfactory work. The saw blade is slipped on the arbor with teeth pointing towards front and placed firmly against the flange. Use the pin wrench, on the arbor flange to prevent the saw arbor from turning while the nut is being drawn up tight. To change saw, reverse the procedure. Be sure that the flange, saw and nut are clean of dust then put back in place. Never strike on the nut to loosen or tighten it as this will damage the saw arbor and bearings.



RIPPING FENCE

The rapid-set rip fence is assembled on the saw and slides on the front and rear guide bars. The fence travels the full length of the table when unlocked. The most common position is on the right side of the saw blade. The fence should be parallel with the saw blade and is aligned by loosening the 2 front screws on top. Tighten the front bracket while the rear is loose and adjust the fence parallel to the saw blade by moving the rear end to one side or the other then tighten again. The pointer for indicating the width of cut should be placed at 0 on the guide bar when the fence just touch the side of the saw blade.

Care should be taken when tilting that the fence is moved away from the saw blade because if it is too near, the saw blade will strike, damaging both your blade and fence. As received from the factory, there is a capacity of 30" between saw blade and rip fence. However, the guide bars having a set-over feature, the width of ripping is increased to 50". This is done by removing the socket screws holding it to the table, moving the guide bars over one hole spacing and screwing back in place.

ARBOR BRACKET

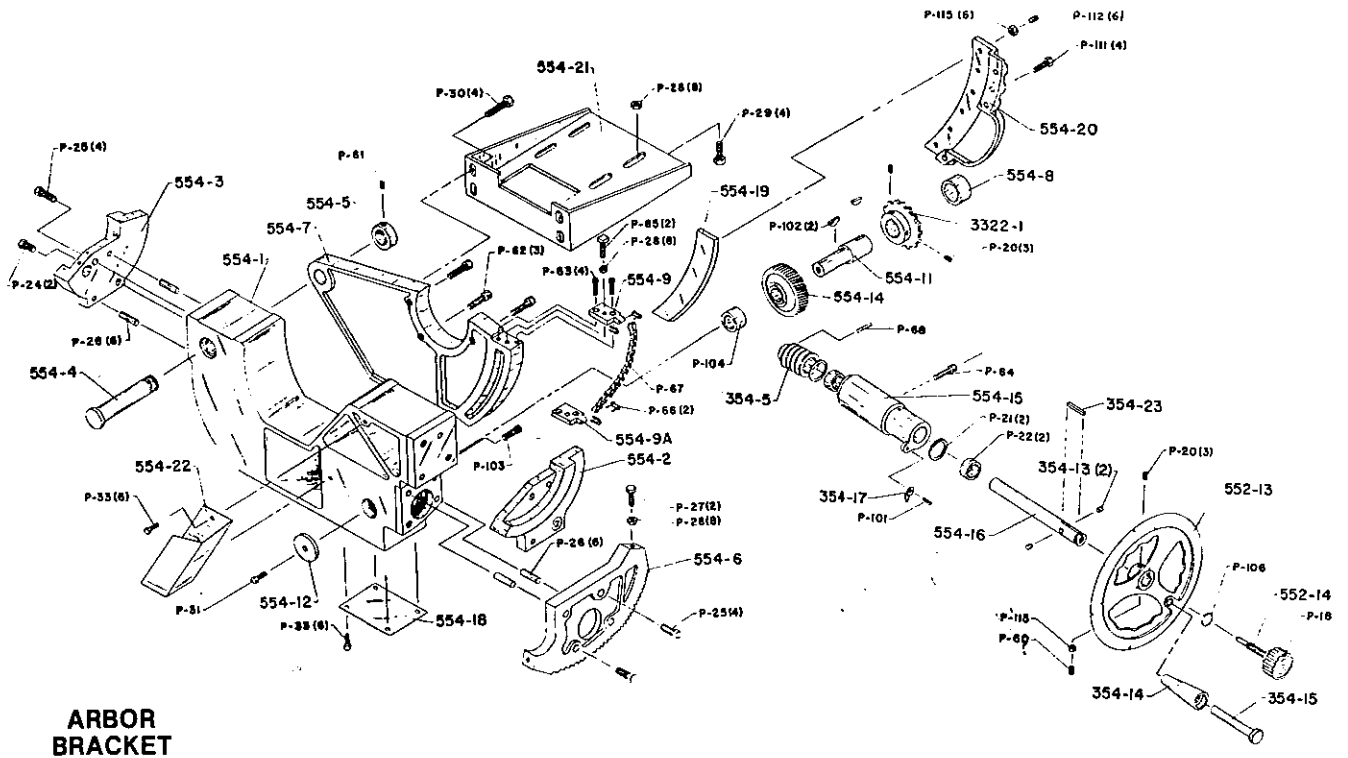
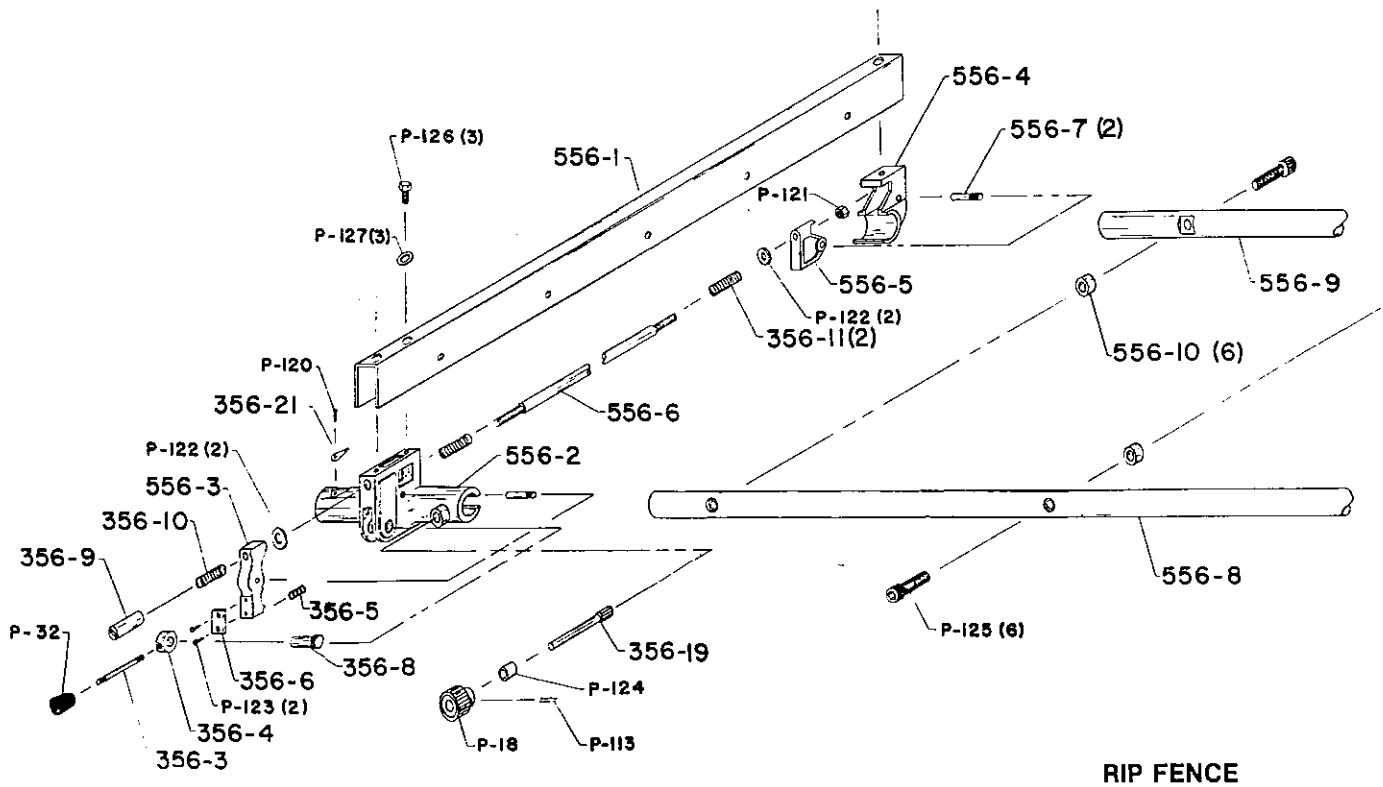
The spindle is adjusted at the factory so that the saw blade is in the center of the opening of the table insert at both 90° and 45°. If a derangement should occur, the spindle can be adjusted as follows: the spindle being held in place by a screw at the side of the arbor housing, loosen the screw and move the spindle sideways and bringing it into the alignment required. This screw is reached through the table opening. After proper alignment is made, tighten the screw securely.

ALIGNMENT

All saws are aligned at the factory but it may be necessary sometimes to realign the saw blade. To do so, the following procedure is used: loosen the four screws at each corner which hold the table to the chassis and move the table until the blade is in the center of the insert and parallel with the miter gauge groove and then tighten the screws to secure the table to the chassis.

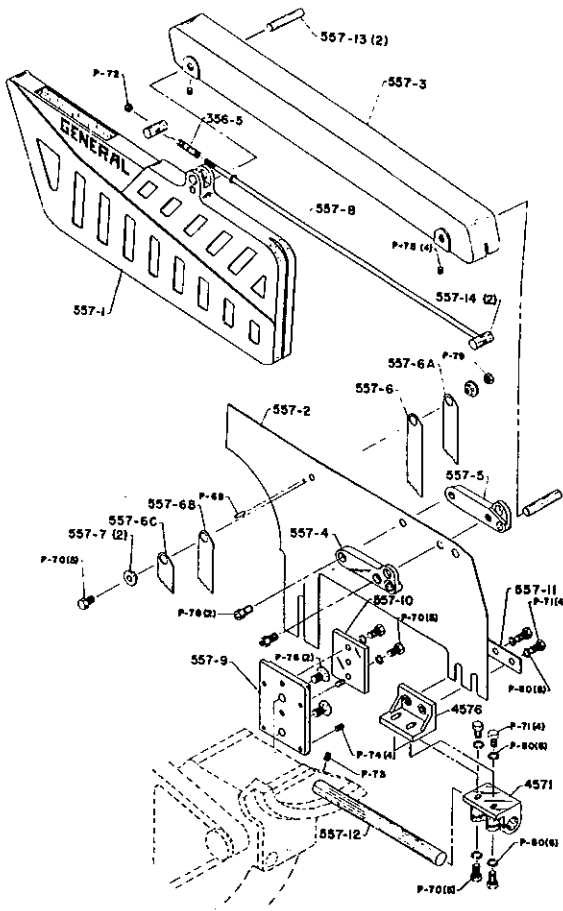
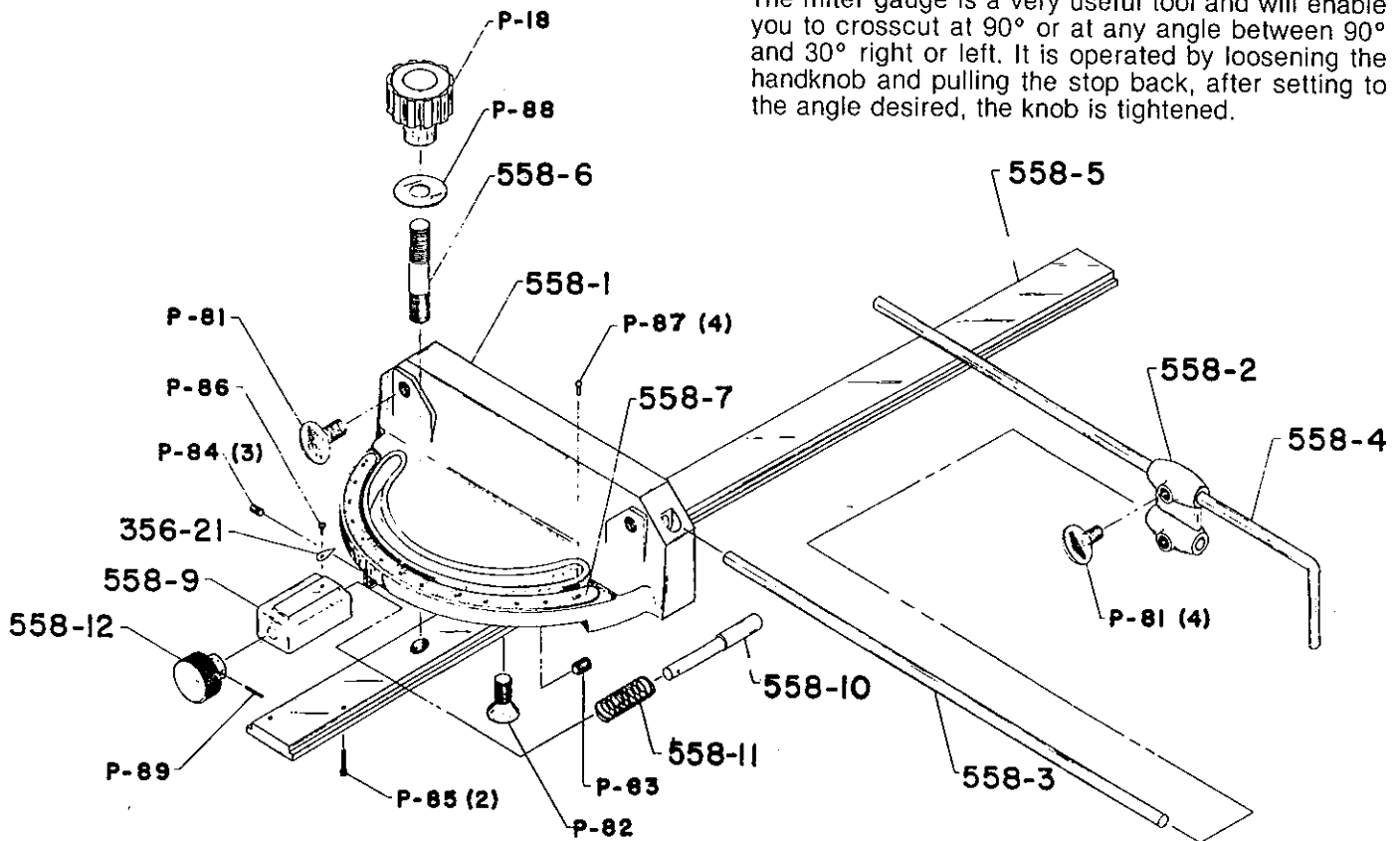
DADOING AND MOLDING

When dado cutters or molding cutters are used, a special insert must be used. This will permit the use of dado cutters up to 2" wide. A piece of wood is placed in the opening of the dado insert and an opening is made in it with the dado cutter to insure a perfect fit. Parallel piece of wood should be screwed to the fence in the holes provided when doing dado or moldings. This will protect your fence and cutters when doing certain types of work. For dadoing an arbor extension has to be used instead of the saw arbor. It is changed by using a hexagon wrench, locking the spindle with the pin wrench and turning the wrench towards the front of the machine thereby loosening the arbor. It is replaced by reversing the procedure.



MITER GAUGE

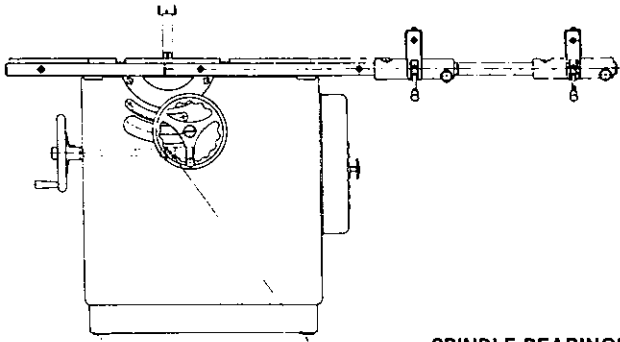
The miter gauge is a very useful tool and will enable you to crosscut at 90° or at any angle between 90° and 30° right or left. It is operated by loosening the handknob and pulling the stop back, after setting to the angle desired, the knob is tightened.



BLADE GUARD

The guard is a plitter-mounted type of saw guard. The splitter is fitted with anti-kickback fingers of different length. Due to the fact that this guard raises or lowers by pivoting at a point well back, it is possible to make the guard ride the work with little effort even when the saw is tilted to 45°. The splitter is attached to the rear trunnion of the saw and for additional rigidity it is also fastened behind the saw blade.

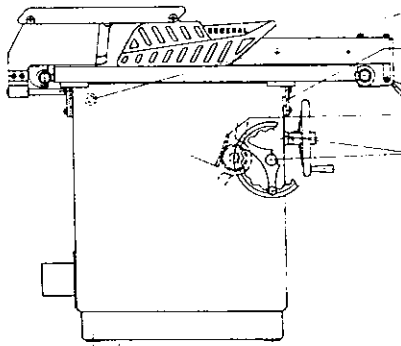
The guard may be lifted from the saw to permit dading and molding and gives an unobstructed clear table. It can be just as conveniently put back in place again to serve as blade guard and splitter. It is necessary that the splitter be aligned perfectly with the saw blade to avoid clamping. It is important that the rip fence be perfectly parallel to the saw blade and splitter. If any misalignment of the splitter will cause difficulty. It is **important** that it be adjusted properly.



**LUBRIFICATION
14" TILTING ARBOR SAW MODEL 550**

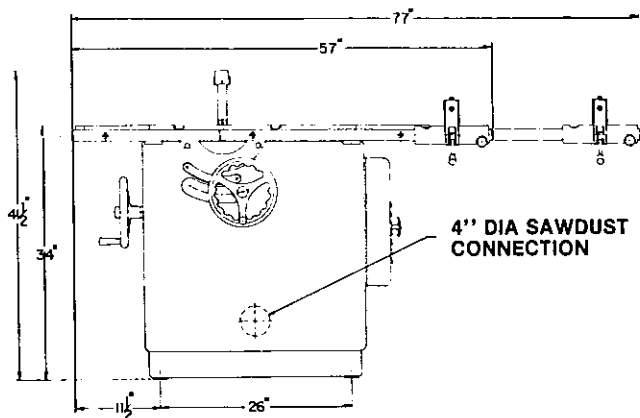
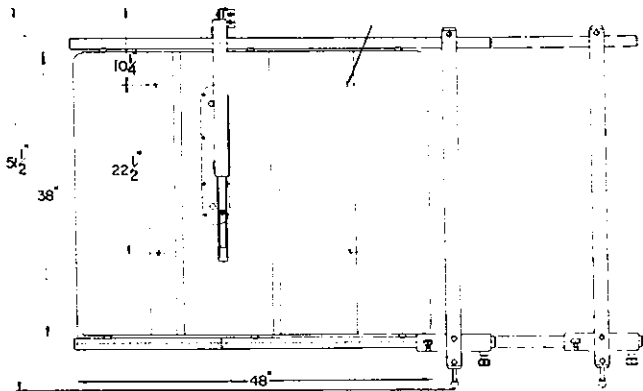
SPINDLE BEARINGS ARE GREASE-SEALED, REQUIRE NO LUBRIFICATION.
CLEAN TABLE SURFACE AND APPLY LIGHT FILM OF OIL TO PREVENT RUSTING.

WEEKLY

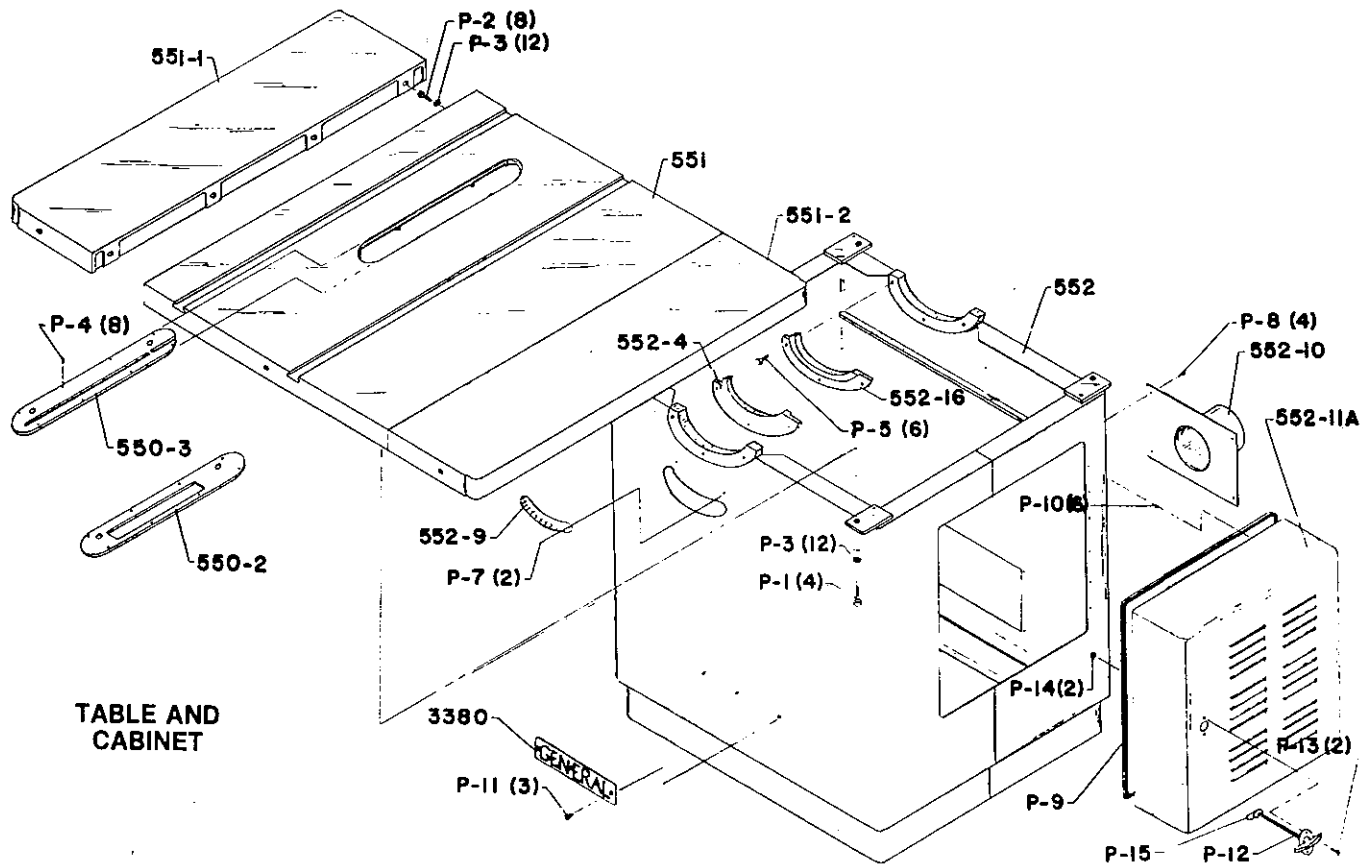


- APPLY GRAPHITE PASTE TO TILTING WORM.
- OIL SPINDLE SUPPORT PIVOT.
- CLEAN AND OIL TILTING TRUNNIONS.
- OIL FENCE CAM FACE.
- OIL ELEVATING SLIDES AND ROLLER CHAIN.
- OIL ELEVATING AND TILTING HANDWHEEL BEARINGS.
- CHECK GREASE IN GEAR BOX EVERY SIX (6) MONTHS.

5/8" DIA 4 HOLES



**14" TILTING ARBOR SAW
MODEL 550**



IMPORTANT

1. Keep the fence parallel to the saw.
2. Always use the splitter-mounted guard whenever possible and keep it properly aligned.
3. Always have a push stick handy.
4. Remember that the saw must always slide on its spindle easily. If it's tight fit, it may give trouble.
5. Never use a dull saw.
6. Keep the faces of the flanges and nut clean.
7. Always use a wood facing on your ripping fence when dadoing.

Replacement parts

Important: Always give part number and description of each item when ordering.
Also give serial number of band saw.

| PART NO | DESCRIPTION | QTY | PART NO | DESCRIPTION | QTY |
|--------------------|------------------------------------|-----|------------------------|------------------------------------|-----|
| TABLE PARTS | | | | | |
| 551 | Table | 1 | P-50 | Wrench | 1 |
| 551-1 | Extension left | 1 | P-51 | Pin wrench | 1 |
| 551-2 | Extension right | 1 | MECHANISM PARTS | | |
| P-1 | Hex H. Screw 1/2" x 1-1/4" | 4 | 552-13 | Handwheel ass'y | 1 |
| P-2 | Hex H. Screw 1/2" x 1-1/2" | 8 | 552-14 | Locking knob | 1 |
| P-3 | 1/2" Lockwasher | 12 | 554-1 | Chute | 1 |
| P-4 | Socket H.S. 1/4 N.F. x 3/8 Nylock | 8 | 554-2 | Front trunnion | 1 |
| FRAME PARTS | | | 554-3 | Rear trunnion | 1 |
| 552 | Chassis ass'y | 1 | 554-4 | Pivot pin | 1 |
| 552-4 | Front trunnion bracket | 1 | 554-5 | Pivot nut | 1 |
| 552-9 | Tilt scale | 1 | 554-6 | Tilting sector | 1 |
| 552-10 | Dust connection | 1 | 554-7 | Elevating bracket | 1 |
| 552-11A | Motor cover | 1 | 554-8 | Sleeve | 1 |
| 552-12 | Tilting shaft | 1 | 554-9 | Chain connector | 1 |
| 552-13 | Handwheel ass'y | 1 | 554-9A | Chain connector | 1 |
| 552-14 | Knob & Locking screw | 1 | 554-11 | Pinion shaft | 1 |
| 552-16 | Rear trunnion bracket | 1 | 554-12 | Washer | 1 |
| 354-5 | R.H. Worm | 1 | 554-14 | Gear | 1 |
| 354-6 | Collar | 1 | 554-15 | Elevating housing | 1 |
| 354-13 | Lock pin | 2 | 554-16 | Elevating shaft | 1 |
| 354-14 | Handle plastic | 1 | 554-18 | Cover | 1 |
| 354-15 | Handle pin | 1 | 554-19 | Gib 2-1/2 | 1 |
| 354-23 | Key | 1 | 554-20 | Adjusting flange | 1 |
| 3380 | Name plate | 1 | 554-21 | Motor base | 1 |
| P-5 | Hex H. Screw 7/16" x 1" | 6 | 554-22 | Saw dust deflector | 1 |
| P-7 | Pan H. Screw Type F No. 7 x 3/8" | 4 | 554-23 | Worm, use (354-5) | 1 |
| P-8 | Hex H. Screw 5/16" x 1/2" | 4 | 354-5 | Worm | 1 |
| P-9 | Rubber strip RW-60 (68") | 1 | 354-13 | Lock pin | 2 |
| P-10 | Pan H. Screw No. 10-32 - 3/8" | 6 | 354-14 | Handle | 1 |
| P-11 | F.H. Screw 1/4" x 3/4" | 3 | 354-15 | Handle pin | 1 |
| P-12 | Door handle No. 787 | 1 | 354-17 | Indicator | 1 |
| P-13 | Oval H. Screw 10/32" x 1/2" | 2 | 354-23 | Key | 1 |
| P-14 | Hex nut 10/32" | 2 | P-18 | Locking knob | 1 |
| P-15 | Latch No. 5559 | 1 | P-20 | Socket Set Screw 5/16" x 5/16" | 3 |
| P-18 | Lock knob (1533) | 1 | P-21 | Fiber washer 3/4" x 1-3/8" x 1/16" | 2 |
| P-20 | Socket Set Screw 5/16" x 5/16" | 1 | P-22 | Oilite bearing (AA-885) | 2 |
| P-21 | Fibre washer 3/4" x 1-3/8" x 1/16" | 2 | P-24 | Hex H. Screw 7/16" x 1-1/4" | 2 |
| P-22 | Oilite bearing No. AA-885 | 2 | P-25 | Hex H. Screw 7/16" x 1-1/2" | 4 |
| P-23 | Roll Pin 3/16" x 1-1/4" | 2 | P-26 | Pin 5/16" x 1" | 6 |
| SAW SPINDLE | | | P-27 | Hex H. Screw 3/8" x 1-1/2" | 2 |
| 553-1 | Spindle housing | 1 | P-28 | Hex nut 3/8" | 8 |
| 553-2 | Spindle | 1 | P-29 | Hex H. Screw 3/8" x 1-1/4" | 4 |
| 553-3 | Saw flange | 1 | P-30 | Hex H. Screw 3/8" x 3/4" | 4 |
| 553-5 | Spindle spacer | 1 | P-31 | Hex H. Screw 3/8" x 1" | 1 |
| 553-6 | Locking collar | 1 | P-33 | Hex H. Screw 1/4" x 1/2" | 4-2 |
| 553-7 | Spindle pulley 3-3/4" | 1 | P-60 | Socket S. Screw 5/16" x 3/4" | 1 |
| 553-8 | Saw arbor | 1 | P-61 | Socket S. Screw 3/8" x 3/8" | 1 |
| 553-9A | Motor pulley 3-3/4" | 1 | P-62 | Socket H. Screw 3/8" x 1-1/2" | 3 |
| 553-10 | Arbor nut | 1 | P-63 | Socket H. Screw 1/4" x 3/4" | 4 |
| 553-11 | Bearing spacer | 1 | P-64 | Socket H. Screw 3/8" x 1-1/4 | 1 |
| P-20 | Socket Set Screw | 1 | P-65 | Square H. Screw 3/8" x 2" | 2 |
| P-40 | Jam nut 1" N.F. | 1 | P-66 | Connecting Link No. 50 - 5/8 P | 2 |
| P-41 | Woodruff key 1/4" x 1" | 1 | P-67 | Roller Chain No. 50 - 16 P | 1 |
| P-42 | Bearing (88506) | 2 | P-68 | Roll pin 3/16" x 1-1/4" | 1 |
| P-43 | Vee-belt 4L-250 | 3 | P-101 | R.H. Screw 1/4" x 1/2" | 1 |
| P-44 | Saw blade | 1 | P-102 | Woodruff key No. 15 1/4" x 1/2" | 2 |
| P-46 | Socket H. Screw 3/8" x 1/2" | 1 | P-103 | Socket H. Screw 7/16" x 1/2" | 1 |
| P-47 | Hex H. Screw 3/8" x 1-1/4" | 1 | P-104 | Oilite Bearing AA-1523-2 | 1 |
| P-49 | Roll pin 3/32" x 3/8" | 1 | P-106 | Tru-ARc Ring No. 5100-75 | 1 |
| | | | P-111 | Hex H. Screw 3/8" x 1-1/4" | 4 |
| | | | P-112 | Headless Slotted Screw 5/16" x 1" | 6 |
| | | | P-115 | Jam nut 5/16" | 6 |

Replacement parts

Important: Always give part number and description of each item when ordering.
Also give serial number of band saw.

| PART NO | DESCRIPTION | QTY | PART NO | DESCRIPTION | QTY |
|--------------------|--------------------------------|-----|------------------------|----------------------|-----|
| RIP FENCE | | | SAW BLADE GUARD | | |
| 556 | Fence ass'y | 1 | 557 | Splitter guard ass'y | 1 |
| 556-1 | Fence | 1 | 557-1 | Guard | 1 |
| 556-2 | Front bracket | 1 | 557-2 | Splitter ass'y | 1 |
| 556-3 | Locking clamp | 1 | 557-3 | Guard arm | 1 |
| 556-4 | Rear bracket | 1 | 557-4 | Right back support | 1 |
| 556-5 | Rear clamp | 1 | 557-5 | Left back finger | 1 |
| 556-6 | Clamp bar | 1 | 557-6 | Kick back finger | 1 |
| 556-7 | Pin | 2 | 557-6A | Kick back finger | 1 |
| 556-8 | Front guide bar | 1 | 557-6B | Kick back finger | 1 |
| 556-9 | Rear guide bar | 1 | 557-6C | Kick back finger | 1 |
| 556-10 | Spacer | 6 | 557-7 | Finger pivot | 2 |
| 356-3 | Handle | 1 | 557-8 | Rod | 1 |
| 356-4 | Cam | 1 | 557-9 | Front bracket | 1 |
| 356-5 | Spring front clamp | 1 | 557-10 | Front clamp plate | 1 |
| 356-6 | Wear plate | 1 | 557-11 | Rear clamp plate | 1 |
| 356-8 | Pin | 1 | 557-12 | Holding pin | 1 |
| 356-9 | Adjusting sleeve | 1 | 557-13 | Guard pin | 2 |
| 356-10 | Compression spring | 1 | 557-14 | Pin | 2 |
| 356-11 | Compression spring | 2 | 356-5 | Spring | 1 |
| 356-19 | Pinion | 1 | 4571 | Rear bracket | 1 |
| 356-21 | Indicator | 1 | 4576 | Adjusting bracket | 1 |
| P-18 | Button | 1 | | | |
| P-32 | Plastic handle | 1 | | | |
| P-113 | Roll pin 3/32" x 3/4" | 1 | | | |
| P-120 | R.H. Screw F. 8/32" x 1/4" | 1 | | | |
| P-121 | Hex nut ESNA No. 52 | 1 | | | |
| P-122 | Flat washer 1/4" | 2 | | | |
| P-123 | Fill H. Screw 8-32 - 1/4" | 2 | | | |
| P-124 | Oilite Bearing AA-520-4 | 1 | | | |
| P-125 | Socket H. Screw 1/2" x 2" | 6 | | | |
| P-126 | Hex H. Screw 7/16" x 3/4" | 3 | | | |
| P-127 | Flat washer 7/16" | 3 | | | |
| MITER GAUGE | | | | | |
| 558-1 | Body | 1 | | | |
| 558-2 | Stop rod clamp | 1 | | | |
| 558-3 | Stop rod bent | 1 | | | |
| 558-4 | Stop rod | 1 | | | |
| 558-5 | T-Bar | 1 | | | |
| 558-6 | Pivoting pin | 1 | | | |
| 558-7 | Scale | 1 | | | |
| 558-8 | Locking knob | 1 | | | |
| 558-9 | Bracket | 1 | | | |
| 558-10 | Index pin | 1 | | | |
| 558-11 | Spring | 1 | | | |
| 558-12 | Knob index pin | 1 | | | |
| 356-21 | Indicator | 1 | | | |
| P-18 | Button (1533) | 1 | | | |
| P-81 | Wing Screw 3/8" x 3/4" | 4 | | | |
| P-82 | F.H. Socket Screw 5/16" x 1" | 1 | | | |
| P-83 | Socket Set Screw 1/4" x 1/4" | 1 | | | |
| P-84 | Socket Set Screw 10/32" x 3/8" | 3 | | | |
| P-85 | Socket H. Screw 6-32 x 1/2" | 3 | | | |
| P-86 | R.H. Screw 8-32 x 1/4" | 1 | | | |
| P-87 | Drive Screw No. 2 x 1/4" | 4 | | | |
| P-88 | Flat Washer 3/8" | 1 | | | |
| P-89 | Groove pin 3/32" x 1/2" | 1 | | | |