

SULPHUR GROVE TOOL

URETHANE BAND SAW TIRES

BASIC INSTALLATION INSTRUCTIONS

Following these instruction will give you improved band saw performance with better tracking control and eliminating blade slippage.

CAUTION: **ALWAYS unplug your saw while installing these tires or performing any other maintenance. Use common sense precautions including wearing eye protection and gloves especially when removing and handling blades. Always follow the safety instructions in your owner's manual. If something doesn't seem safe it is probably not.**

1. If possible it is easier to replace the tires if the wheels are removed from the saw.
2. Remove the old tires and clean any debris and adhesive from the wheel. If you are balancing the wheel it should be done at this time.
3. The tires are undersized and need to be stretched on. Pre-stretch a tire by pulling on it while it is hooked on a stationary object such as a bench vise. Be sure to avoid sharp edges.
4. Secure the wheel to your work bench for easier installation being careful not to damage the wheel.
5. Place the weld of the tire on the far side of the wheel and begin stretching the tire around the wheel in both directions. Use clamps to secure your progress. You may need to use a pry tool to help the tire onto the wheel. Be sure to avoid sharp edges.
6. Even out the stretch. Do this by inserting a round object such as a dowel rod between the tire and the wheel and rotating it around the wheel a couple times.
7. Re-assemble your saw and set it up according to your saw's owner's manual.

NOTES:

1. **Trimming** – These tires can be trimmed. If the tires you have are too wide they can be trimmed with a quality pair of scissors or sharp utility knife.
2. **Adhesives** - Adhesive is not required for these tires. However in some rare cases it may be needed. If you need adhesive we recommend using '3M™ Super Weatherstrip Adhesive'.
 - a. This can be messy. You may want to protect your work area and hands.
 - b. With the tire already installed reinsert the round object (dowel) between the wheel and tire.
 - c. Apply a small amount of adhesive to the wheel on one side of the dowel. Don't wait for the adhesive to get tacky.
 - d. Move the dowel around the wheel away from the adhesive to expose more of the wheel and repeat the previous step. Do this until you have covered most of the wheel.
 - e. Rub the tire as you go to press out any excess adhesive and prevent lumps.
 - f. Wipe off the excess with a mild solvent cleaner and dry.
3. **Crowning wheels** - Some wheels are machined with a flat surface and have no crown. A crown is not required but helps track narrow blades. Follow these steps to create a crowned surface. You only need to crown the top wheel or whichever wheel is used to adjust the blade tracking. This process is done before installing the tire and is only recommended for tires 1" or wider.
 - a. Using duct tape or preferred Gorilla Tape™, tear a thin strip approximately $\frac{1}{4}$ " wide long enough to wrap around the wheel.
 - b. Carefully apply it to the center of the wheel surface.
 - c. Using another strip wider than the first repeat step (b).
 - d. Repeat this process as many times as necessary to achieve the crown. Typically a 1" wide wheel will only need 2 layers. No more than 50% of any size wheel surface should be covered.
 - e. Install the tire being careful not to move or pry against the tape.
 - f. Adhesive may be needed when building up a crown.
4. **Warm water installations** – A common practice installing a band saw tire is to warm it up before stretching it on. It does make it easier but can also cause unwanted problems. If the urethane gets too hot it can alter the characteristics of the tire which keeps it tight to the wheel. You then may need adhesive. If you choose to warm your tires this way use hot tap water which is usually 125 degrees. The absolute limit is 140 degrees.

PRODUCT SUPPORT: For more detailed information go to http://www.sgtool.com/Tech_Help_and_FAQs.html or e-mail help@sgtool.com
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