



URETHANE BAND SAW TIRES BASIC INSTALLATION INSTRUCTIONS

Following these instructions 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 adhesives 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 or nylon zip ties 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 of times.
7. Re-assemble your saw and set it up according to your saw's owner's manual.

NOTES:

1. **Adhesives** - Adhesive is usually not required for these tires. However, it is recommended for larger saws, older Powermatic saws and wheels without raised edges. If you need adhesive, we recommend using '3M™ Yellow Super Weatherstrip and Gasket Adhesive 3M ID B40069421' (Yellow) which is a contact cement or '3M™ Scotch-Weld 2216 2-part Epoxy Adhesive' which allows about 90 minutes of working time.
 - 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/PVC) between the wheel and tire.
 - c. Apply a small amount of adhesive to the wheel and tire on one side of the dowel. Be careful not to get it on the dowel.
 - d. Rotate 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. Wipe off the excess with a mild solvent cleaner and dry.
2. **Crowning wheels** – Before using this method: We manufacture crowned tires 1" up to 1-1/2". If you need a crown on wheels wider than 1-1/2" and are machined with a flat surface, 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 1-1/2" or wider when using narrow blades.
 - a. Using duct tape or preferred Gorilla Tape™, tear a thin strip approximately 1/4" wide long enough to wrap around the wheel.
 - b. Carefully apply it aligned 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 .030" thick crown is sufficient. No more than 30-40% of any wheel size should be covered.
 - e. Install the tire being careful not to move or pry against the tape.
 - f. Adhesives should be used when building up a crown.
3. **Warm water installations** – Caution: it is easier but can also cause unwanted problems. If you choose to warm your tires this way, use hot tap water which is usually 125 degrees. Installations with water that is too hot will cause the tires to slip. It could take many months for the problem to show.

PRODUCT SUPPORT: For more detailed information go to <http://sgtool.com> or e-mail contact@sgtool.com
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