

TECHNICAL MANUAL

**OPERATOR'S, ORGANIZATIONAL, DIRECT
SUPPORT, AND GENERAL SUPPORT MAINTENANCE
MANUAL INCLUDING REPAIR PARTS LIST
FOR**

**SAW, BAND, METAL CUTTING
MODEL 3613-20**

**NSN 3405-00-351-9704
(DOALL COMPANY)**

HEADQUARTERS, DEPARTMENT OF THE ARMY

JULY 1981

WARNINGS

1. **To Avoid Potential Hazards, Observe These Precautions When Operating Or Servicing This Machine-Operator Must:**
 - Wear safety glasses.
 - Wear gloves-when handling saw band.
 - Not wear gloves when operating machine.
 - Set saw guides as close to work as possible.
 - Close band wheel covers before tensioning band or starting machine.
 - Close doors, replace all covers and safety guards before operating machine.
 - Use a fixture to feed work piece and keep hands away from moving saw band.
 - Avoid contact with coolant. Especially guard your eyes.
 - Step to one side and away from welding unit before welding a saw band.
 - Install friction band and spark shield before friction sawing.
 - Use a dust collector when sawing generates dust.
 - Disconnect electrical supply before removing panels or drive covers.
2. **Disconnect Electric Power To The Welder Before Making Adjustments.**
3. **All Adjustments Must Be Made With The Power Off, Except Where Specifically Instructed Otherwise.**

INSTRUCTIONS FOR REQUISITIONING PARTS

NOT IDENTIFIED BY NSN

When requisitioning parts not identified by National Stock Number, it is mandatory that the following information be furnished to the supply officer.

- 1 - Manufacturer's Federal Supply Code Number - 18056
- 2 - Manufacturer's Part Number exactly as listed herein.
- 3 - Nomenclature exactly as listed herein, including dimensions, if necessary.
- 4 - Manufacturer's Model Number - 3613-20
- 5 - Manufacturer's Serial Number (End Item)
- 6 - Any other information such as Type, Frame Number, and Electrical Characteristics, if applicable.
- 7 - If DD Form 1348 is used, fill in all blocks except 4, 5, 6, and Remarks field in accordance with AR 723-50.

Complete Form as Follows:

- (a) In blocks 4, 5, 6, list manufacturer's Federal Supply Code Number - 18056 followed by a colon and manufacturer's Part Number for the repair part.
- (b) Complete Remarks field as follows:
Noun: (nomenclature of repair part)
For: NSN: 3405-00-351-9704
Manufacturer: Continental Machines, Inc.
for

Model: 3613-20 DoALL Company

Serial: (of end item)

Any other pertinent information such as Frame
Number, Type, Dimensions, etc.

DAMAGE CLAIM PROCEDURE

VISIBLE DAMAGE AT TIME OF DELIVERY

1. Note damage on carrier's delivery receipt. Accept the shipment. It can be returned later if repairs aren't possible in the field.
2. Request a "damage inspection" from the delivering carrier:
 - a. The carrier will send his own people or contract an independent agency to make the inspection.
 - b. The inspector will request a signature on the report and leave a copy.
 - c. The carrier "damage inspection" report isn't final. If additional damage is found when repairs are started, contact the carrier for another inspection; or, at least give them the details of the damage.
3. Don't move the equipment from the receiving area and keep all shipping materials until the carrier "damage inspection" report is complete.
4. If possible, take photographs of the damage and keep them with your file. Photos could possibly prove a claim at a later time.
5. Keep a record of all expenses and be sure they are documented.
6. Repair damage in the field whenever possible. Carriers encourage this to keep expenses down.
7. You have 9 months to file a claim.

CONCEALED DAMAGE

1. You have 14 days after delivery to report damage not noted at time of delivery.
 - a. Report damage as soon as possible. This makes it easier to prove that it didn't happen in consignee's plant.
 - b. Inspect machines carefully before moving from the receiving area. Again if machine isn't moved it's easier to prove your case.
2. Request a "damage inspection" from the delivering carrier:
 - a. The carrier will send his own people or contract an independent agency to make the inspection.
 - b. The inspector will request a signature on the report and leave a copy.
 - c. The carrier "damage inspection" report isn't final. If additional damage is found when repairs are started, contact the carrier for another inspection; or, at least give them the details of the damage.
3. Don't move the equipment from the receiving area and keep all shipping materials until the carrier "damage inspection" report is complete.
4. If possible, take photographs of the damage and keep them with your file. Photos could possibly prove a claim at a later time.
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Technical Manual

No. 9-3405-215-14&P

HEADQUARTERS
DEPARTMENT OF THE ARMY
Washington, DC, 10 July 1981

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MODEL 3613-20
(NSN 3405-00-351-9704)**

REPORTING OF ERRORS

You can help improve this manual. If you find any mistakes or if you know of a way to improve the procedures, please let us know. Mail your letter, DA Form 2028 (Recommended Changes to Publications and Blank Forms), or DA Form 2028-2, located in the back of this manual direct to: Commander, US Army Armament Materiel Readiness Command, ATTN: DRSAR-MAS, Rock Island, IL 61299. A reply will be furnished direct to you.

NOTE

Manufactured by: Continental Machines, Inc.
Savage, Minnesota 55378
for
DoAll Company
254 N. Laurel Avenue
Des Plaines, IL 60016

Procured under Contract No. DAAA09-79-C-4136

This technical manual is an authentication of the manufacturers' commercial literature and does not conform with the format and content specified in AR 310-3, Military Publications. This technical manual does, however, contain available information that is essential to the operation and maintenance of the equipment.

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INSTALLATION

LOCATION

The machine should be located so that adequate space is provided for your cutting needs. You will also want to provide sufficient clearance around the machine for maintenance and lubrication procedures, plus operation of any accessories accompanying the machine.

Floor area required for the machine itself is 40 inches (1025 mm) by 73 inches (1850 mm). Maximum machine height is 74 inches (1885 mm).

NOTICE!!!

OSHA Regulation No. 1910.212 (B). Machines designed for a fixed location shall be securely anchored to prevent walking or moving.

LIFTING

You will find a tapped hole in the machine head's upper surface. Screw a forged 3/4-10 UNC eyebolt into this hole to lift machine into position, or for later moving it to another location. Lifting by overhead hoist is recommended. Machine weight is 1565 pounds (705 kg).

UNCRATING

Carefully remove all protective coverings, strappings, hold-down brackets, and skid. Check inside rear drive housing for other removable brackets, extra machine parts, or supplies placed there for shipment. Unfasten power feed weight hold-down bracket (if accessory is supplied).

Use solvent to remove rust-preventive coating applied to all exposed bare metal surfaces prior to shipment. Inspect machine for broken or damaged parts.

ELECTRICAL INSTALLATION

Bring line circuit leads into electrical enclosure on machine column. Refer to wiring diagram furnished.

Check air discharge nozzle for proper rotation of chip blower pump.

Overload protection is provided. If machine is started and stopped repeatedly and in rapid succession, the overload relay may be tripped. Let relay cool a few minutes before starting machine.

ALIGNMENT

Machine must be properly aligned before being bolted into position. Follow these procedures:

- (1) Release band tension. Remove band. Remove post saw guard and table center plate, plus upper and lower saw guides.

CAUTION
ALWAYS WEAR GLOVES WHEN
HANDLING SAW BANDS.

- (2) Re-install band over each wheel. Tension to maximum reading on tension indicator.
- (3) Shim between base mounting pads and floor until machine is level and weight rests evenly on all pads. Check by tapping with bar or hammer.
- (4) Post front should be parallel with lower keeper block's machined saw guide mounting recess. Check by placing spacer block - ground to exactly 0.250-inch (6.35 mm) thickness -- in keeper block. Place an accurate straight edge against spacer block and post. Use a feeler gage to check post clearance and parallelism to straight edge. Clearance should not exceed 0.004-inch (0.1 mm) in 4 inches (100 mm). See Fig. 1.

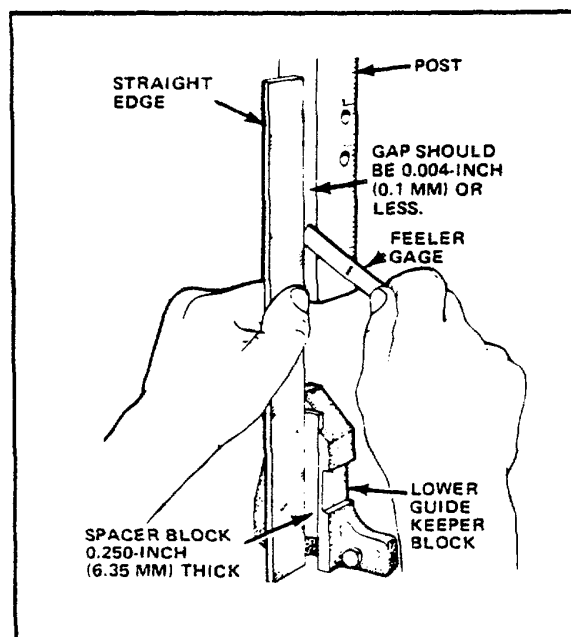


FIG. 1. ALIGN POST TO LOWER SAW GUIDE KEEPER BLOCK.