OTMT®

Blade Welder

Model Number OT10189BW

Read carefully before attempting to assemble, install, operate or maintain the product described. Failure to comply with instructions could result in personal injury and/or property damage! Retain instructions for future reference.

OTMT

DESCRIPTION

The OTMT Blade Welder is designed for the convenient production of welded band saw blades. Blade widths of 1/8 to 1/2" and thickness of .020 to .035" can be welded. The welder features a blade shear, grinder, and an anneal button. This portable work station will produce high quality band saw blades from band stock.

UNPACKING

Refer to Figure 10.

Check for shipping damage. If damage has occurred, a claim must be filed with the carrier. Check for completeness. Immediately report missing parts to your dealer.

The welder comes assembled as one unit. Additional parts which need to be fastened to welder should be located and accounted for before assembling blade shear assembly (Ref. Nos. 6-27).

SPECIFICATIONS

Blade Width	1/8 - 1/2"
Blade Thickness	0.020 - 0.035"
Volts	120
Frequency	60 Hz
Amps	8
Power	1.2 KVA
Duty cycle	25%
Size	12 x 12 x 15"
Weight	40 lbs
Shipping weight	55 lbs

GENERAL SAFETY INFORMATION

⚠ WARNING **For your own safety, read all of the instructions and precautions before operating tool.**

⚠ CAUTION **Always follow proper operating procedures as defined in this manual — even if you are familiar with the use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.**

PROPOSITION 65 WARNING: Some dust created by using power tools contain chemicals known by the state of California to cause cancer, birth defects or other reproductive harm.

Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks and cement and other masonry products.
- Arsenic and chromium from chemically treated lumber.

⚠ WARNING **Your risk from these exposures vary, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well ventilated area and work with approved safety equipment. Always wear an OSHA/NIOSH approved, properly fitting face mask or respirator when using such tools.**

Be Prepared For Job

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of the machine.
- Wear protective hair covering to contain long hair.
- Wear safety shoes with non-slip soles.
- Wear safety glasses complying with United States ANSI Z87.1. Everyday glasses have only impact resistant lenses. They are **NOT** safety glasses.
- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

Prepare Work Area For Job

- Keep work area clean. Cluttered work areas invite accidents.
- Do not use power tools in dangerous environments. Do not use power tools in damp or wet locations. Do not expose power tools to rain.
- Work area should be properly lighted.
- Proper electrical receptacle should be available for the tool. Three-prong plug should be plugged directly into properly grounded, three-prong receptacle.
- Extension cords should have a grounding prong and the three wires of the extension cord should be of the correct gauge.
- Keep visitors at a safe distance from work area.
- Keep children out of workplace. Make workshop childproof. Use padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.

Tool Should Be Maintained

- Always unplug tool prior to inspection.
- Consult manual for specific maintenance and adjustment procedures.
- Keep tool lubricated and clean for safest operation.
- Remove adjusting tools. Form habit of checking to see that adjusting tools are removed before switching machine on.
- Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.
- Check for damaged parts. Check for alignment of moving parts, binding, breakage, and mounting or any other condition that may affect a tool's operation.
- A guard or other damaged part should be properly repaired or replaced. Do not perform makeshift repairs. (Use parts list provided to order replacement parts.)

Know How To Use Tool

- Use right tool for job. Do not force tool or attachment to do a job for which it was not designed.
- Disconnect tool when mounting blade or using shear.
- Avoid accidental start-up. Make sure that the tool is in the off position before plugging in.
- Do not force a tool. It will work most efficiently at the rate for which it was designed.
- Keep hands away from moving parts and grinding surfaces.
- Turn power off completely whenever tool is to be left unattended.

GENERAL SAFETY INFORMATION (CONTINUED)

- Do not overreach. Keep proper footing and balance.
- Never stand on tool. Serious injury could occur if tool is tipped or if grinding wheel is unintentionally contacted.
- Know your tool. Learn the tool's operation, application and specific limitations.
- Handle workpiece correctly. Protect hands from possible injury.

⚠ CAUTION **Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.**

ASSEMBLY

Refer to Figures 1 and 10.

⚠ CAUTION **Do not attempt assembly if parts are missing. Use this manual to order replacement parts.**

Blade shear must be assembled and mounted to cabinet. Thread shear handle and knob (Ref. Nos. 22 and 21) into blade cam (Ref. No. 23).

Mount blade alignment brackets (Ref. Nos. 8 and 25) to shear using two screws, washers and nuts (Ref. Nos. 6, 7 and 11).

Tilt blade alignment brackets down so that alignment surfaces line up with each other and are vertical and perpendicular (See Figure 1). Tighten screws.

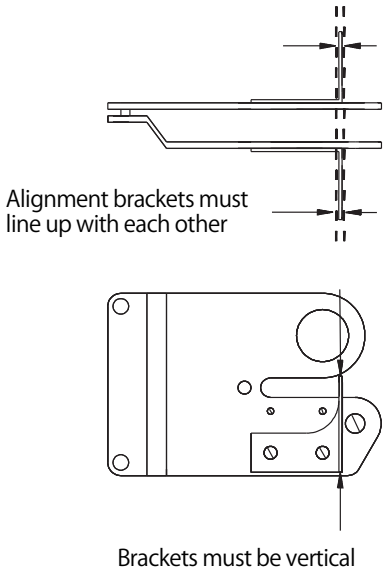


Figure 1 – Blade Alignment Brackets

Mount shear assembly to side of cabinet using two bolts and lock washers (Ref. Nos. 10 and 11).

Remove the protective paper from spark deflector (Ref. No. 29).

INSTALLATION

Refer to Figures 2-5.

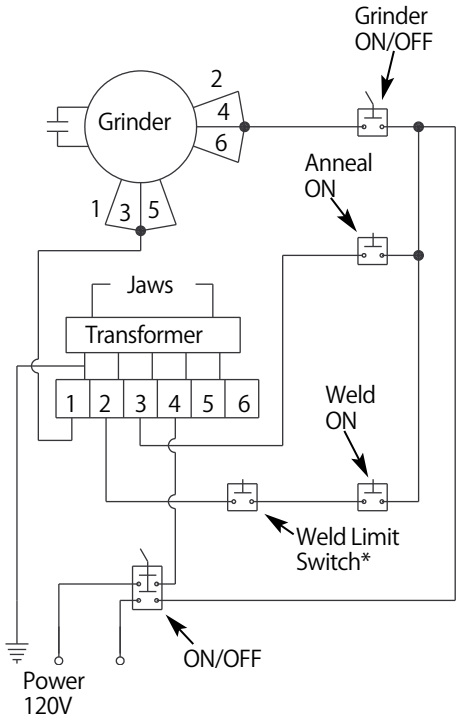
⚠ WARNING **All electrical connections must be performed by a qualified electrician.**

⚠ CAUTION **Make sure unit is off and disconnected from power source before mounting, connecting, reconnecting, removing cover, or anytime wiring is inspected.**

Power Source

The welder is designed for operation on the voltage and frequency specified. Normal loads will be handled safely on voltages not more than 10% above or below the specified voltage.

Running the unit on voltages which are not within the range may cause overheating and transformer burn-out. Heavy loads require that the voltage at welder terminals be no less than the voltage specified.



*Weld limit switch is N.O. contact; it is closed prior to weld and opened after weld is complete.

Figure 2 – Electrical Schematic

Grounding Instructions

⚠ WARNING **Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.**

Check with a qualified electrician if grounding instructions are not understood or if in doubt as to whether the tool is properly grounded.

This tool is equipped with an approved 3-conductor cord rated at 300V and a 3-prong grounding type plug (See Figure 3) for your protection against shock hazards.

Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown in Figure 3.

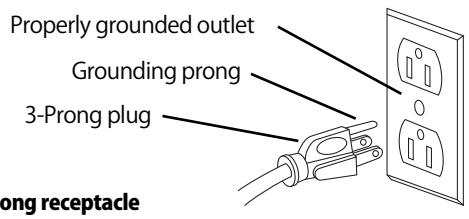


Figure 3 – 3-Prong receptacle

INSTALLATION (CONTINUED)

Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

⚠ WARNING **Do not permit fingers to touch the terminals of plug when installing or removing from outlet.**

Plug must be plugged into matching outlet that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify plug provided. If it will not fit in outlet, have proper outlet installed by a qualified electrician.

Inspect tool cords periodically, and if damaged, have repaired by an authorized service facility.

Green (or green and yellow) conductor in cord is the grounding wire. If repair or replacement of the electric cord or plug is necessary, do not connect the green (or green and yellow) wire to a live terminal.

Where a 2-prong wall receptacle is encountered, it must be replaced with a properly grounded 3-prong receptacle installed in accordance with National Electric Code and local codes and ordinances.

⚠ WARNING **This work should be performed by a qualified electrician.**

A temporary 3-prong to 2-prong grounding adapter (See Figure 4) is available for connecting plugs to a two pole outlet if it is properly grounded.

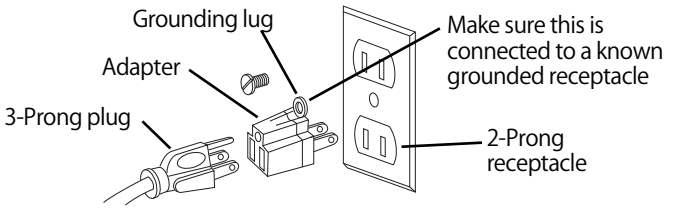


Figure 4 – 2-Prong receptacle with adapter

Do not use a 3-prong to 2-prong grounding adapter unless permitted by local and national codes and ordinances.

(A 3-prong to 2-prong grounding adapter is not permitted in Canada.) Where permitted, the rigid green tab or terminal on the side of the adapter must be securely connected to a permanent electrical ground such as a properly grounded water pipe, a properly grounded outlet box or a properly grounded wire system.

Many cover plate screws, water pipes and outlet boxes are not properly grounded. To ensure proper ground, grounding means must be tested by a qualified electrician.

Extension Cords

- The use of any extension cord will cause some drop in voltage and loss of power.
- Wires of the extension cord must be of sufficient size to carry the current and maintain adequate voltage.
- Use the table to determine the minimum wire size (A.W.G.) extension cord.
- Use only 3-wire extension cords having 3-prong grounding type plugs and 3-pole receptacles which accept the tool plug.
- If the extension cord is worn, cut, or damaged in any way, replace it immediately.

Extension Cord Length

Wire Size	A.W.G.
Up to 25 ft.	14

NOTE: Using extension cords over 25 ft. long is not recommended.

Electrical Connections

Refer to Figure 5.

Refer to electrical schematic and operation control diagrams for the following controls:

- The ON/OFF Switch controls power to the unit.
- The Weld Button connects transformer power to welder jaws.
- The Weld Limit Switch disconnects power to the jaws when the weld is complete.
- The Anneal Switch is used to heat the blade as needed when annealing.
- The Weld Pressure Adjustment Knob applies force to the blade through the welder jaws.
- The Grinder ON/OFF switch provides power to the grinder motor.

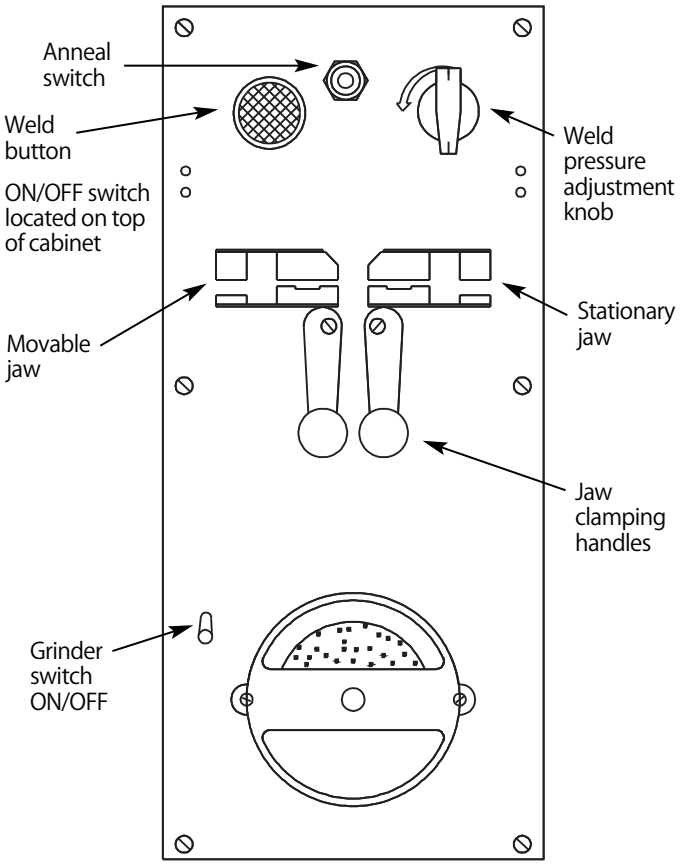


Figure 5 – Operations Controls

OPERATION

Refer to Figures 6, 7, 8 and 9.

⚠ WARNING **Operation of any power tool can result in foreign objects being thrown into eyes which can result in severe eye damage. Always wear safety goggles complying with United States ANSI Z87.1 (shown on package) before commencing power tool operation.**

Preparing Blade for Welding

A properly prepared blade is essential in producing a high-quality, long lasting band saw blade. The blade must be cut to proper length. Blade ends should be cut and ground square. Any rust, oil or dirt must be removed. Some teeth must be ground off blade ends depending upon the pitch of the blade.

Blade Cutting

Refer to Figure 6.

Refer to your Band Saw Instruction Manual for the recommended maximum blade length. Cut blade to maximum length so that blade can be rewelded if broken.

Cut the blade ends flat, square and smooth using the blade shear. Lean the back of blade against the shear blade guide when cutting blade ends (See Figure 6). Use grinder, as needed, to make blade ends flat, square and smooth.

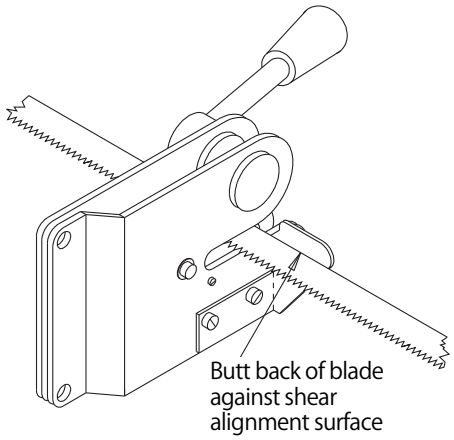


Figure 6 – Blade Cutting

Blade Mounting

Refer to Figure 7.

Clean welder jaw of any scale, oil, rust or dirt. Clean blade ends which contact welder jaws to provide proper electrical contact.

Set weld pressure adjustment knob to "0" (released). Insert one end of blade into stationary jaw with teeth facing out and blade end centered between jaws.

Firmly seat back of blade against back alignment surface of welder jaw and clamp blade tight with the jaw clamping handle (See Figure 7).

Insert other end of blade into movable jaw; butt the blade ends together and clamp tight.

IMPORTANT: The blade ends should butt against each other over the full width of the blade and should not overlap (See Figure 7).

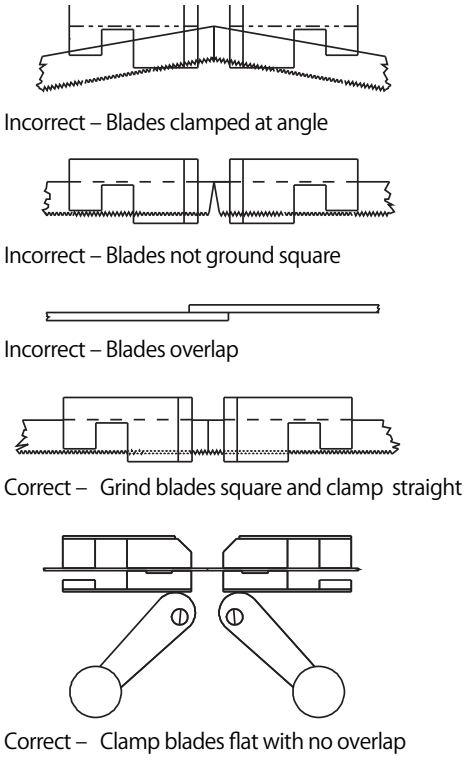


Figure 7 – Blade Mounting and Clamping

Tooth Spacing

Refer to Figure 8.

Approximately 1/8" of blade will be consumed during the welding process. This blade loss must be taken into account.

All blades must have some of the teeth ground off so that the tooth spacing will be uniform after welding.

Tooth grinding procedure must be done carefully in order to grind the proper number of teeth and not to grind below gullet which would weaken the blade.

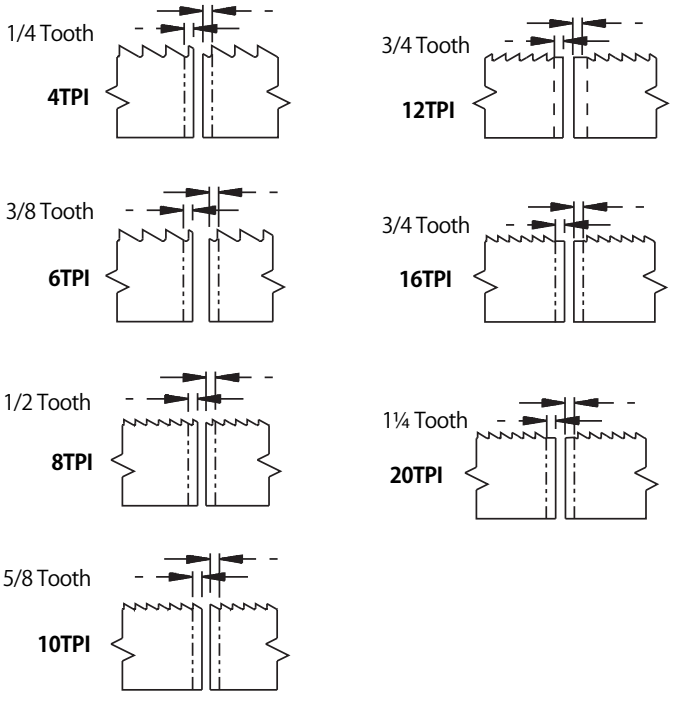


Figure 8 – Tooth Spacing (TPI = Teeth per inch)

OPERATION (CONTINUED)

Blade Welding

Refer to Figures 5 and 9.

To set weld pressure adjustment knob, turn the knob counterclockwise to increase the pressure. The pressure adjustment knob controls force applied to the movable jaw.

NOTE: Weld pressure adjustment knob must be reset to "0" after each welding.

Wider blades and thicker blades need more weld pressure to force the blade ends together during welding. If too little pressure is applied, the blade ends will melt. Too much pressure may cause the blades to overlap.

For example, for 1/2" wide blades, turn the pressure adjustment knob counterclockwise until the pointer is at 6 (See Figure 9).

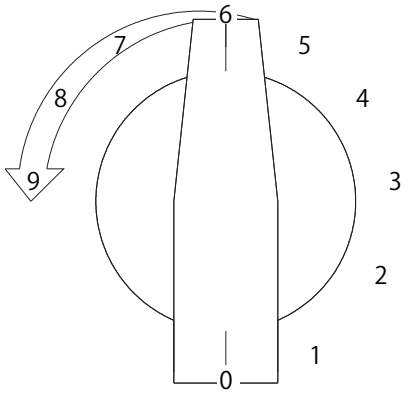


Figure 9 – Weld Pressure Adjustment

If blade melts, increase pressure. If there are "blow holes" in the weld, increase pressure. If blade overlaps, decrease pressure. Wider blades need more pressure and thinner blades need less pressure. Weld pressure is also affected by blade material.

⚠ WARNING **Welding operation produces sparks at blade intersection. Step away to left side of welder during welding operation.**

To complete welding operation, flip spark deflector down. Step to left side of welder. Press weld button and hold down. The blade ends will become red hot and soft. The movable jaw will force the blade ends together creating a bead of metal and the limit switch will automatically cut power to jaws. Release weld button and wait 10 seconds to allow blade to cool. Reset weld pressure adjustment to "0".

Heat build-up in the tool can cause serious damage to the tool. Allow transformer to cool down to room temperature between each welding or each annealing operation.

IMPORTANT: Let the transformer be idle for at least 3 minutes between successive welding/annealing operations.

Insufficient cooling time can also result in inaccurate movable jaw retraction, causing defective weldments.

Blade Annealing

After the blade has been welded, the weld area will be very hard and brittle. Before the blade can be used, it must be annealed and the flash removed.

The blade weld is annealed by heating the blade just under the melting temperature and then slowly cooling the weld.

NOTE: Reset weld pressure adjustment knob to "0" prior to annealing. Failure to do so can cause damage to transformer.

Press the anneal button until the weld area glows a cherry red and then release the anneal button.

⚠ CAUTION **The blade weld will melt, destroying the weld, if the anneal button is not released as soon as the weld glows cherry red.**

Let the blade cool for several seconds . Press the anneal button again, but release the button before the weld glows as brightly as the first time. Wait several seconds until the blade cools further. Repeat the anneal process 6 or 7 times, decreasing the anneal temperature each time. The weld flash must be ground from the blade. See "Grinding Blade".

Grinding Blade

After annealing the blade, the metal buildup or flash must be ground from the blade.Toggle grinder switch to the ON position. Flip the grinder guard open, exposing the top of the grinding wheel.

Weld should be ground to same thickness as blade. Grind flash off under-side of blade taking care not to grind into blade.

Turn blade inside out and grind the other side of the blade the same as the first side (or, flip the grinder guard to the closed position and use the bottom of the wheel). Take care not to grind into blade. Turn blade inside out again (to original shape).

Turn grinder off when grinding is completed. The blade must be annealed again.

Anneal Blade After Grinding

After flash has been removed, anneal the blade a second time. The weld may have been hardened by heat created during grinding. Repeat "Blade Annealing" step.

After second blade annealing operation, the blade is ready for installation onto band saw. Follow Band Saw Instruction Manual when installing and adjusting blade.

Clean Welder Jaws

After each welding operation, wipe welder jaws clean of any oil, dirt or rust and scrape any flash deposited on welder jaws.

MAINTENANCE

⚠ WARNING **Make certain unit is disconnected from power source before attempting to service or remove any component. If power cord is worn, cut, or damaged in any way, have it replaced immediately by a qualified electrician.**

Welder jaws must be kept clean at all times. The jaws must be wiped clean of any dirt or oil and scraped clean of flash after each weld.

The shear blades should be wiped with an oily cloth to remove any dirt or rust.

To replace grinding wheel, remove two screws holding grinder guard and remove guard (Figure 11, Ref. Nos. 7 and 58). Hold grinding wheel stationary and remove nut and washer (Ref. Nos. 4 and 5). Install new wheel on grinder motor shaft and fasten with washer and nut. Make sure nut is tight. Attach grinder guard with two screws.

TROUBLESHOOTING GUIDE

Symptom	Possible Cause(s)	Corrective Action
Blade does not heat up when weld button is pressed	1. No power to welder	1. Check power at receptacle and check that power switch is ON.
	2. Weld pressure adjustment not reset	2. Reset weld pressure adjustment knob; see "Blade Welding"
	3. Weld pressure adjustment set to 0	3. Adjust weld pressure properly; see "Blade Welding"
	4. Blade or jaws dirty, rusty or oily	4. Clean blade and jaws
	5. Loose connection to weld switch, limit switch, transformer, or welder jaws	5. Check; tighten if necessary
	6. Burnt transformer	6. Replace
Misaligned weld	1. Dirt or scale on jaws or blades	1. Clean jaws and blades
	2. Blade ends not cut square	2. Cut ends square
	3. Blade ends not correctly aligned when clamped in jaws	3. Clamp blades against jaw alignment surface
	4. Worn jaws	4. Replace
Blade ends overlap	1. Improper weld pressure	1. Reduce weld pressure; see "Blade Welding"
	2. Blade ends aligned incorrectly	2. Align blades properly
Incomplete weld	1. Weld pressure adjusted incorrectly	1. Increase weld pressure: see "Blade Welding"
	2. Improper clamping	2. See "Mounting Blade"
	3. Defective limit switch	3. Replace
	4. Movable jaw sticking	4. Clean and oil jaw dovetails on inside of cabinet
Weld breaks when used	1. Weld not annealed correctly	1. See "Blade Annealing"
	2. Weld ground too thin	2. Grind weld to thickness of blade
	3. Incomplete weld	3. See Incomplete Weld section (above)
Blade melts when welding	1. Weld pressure adjusted incorrectly	1. Increase weld pressure
	2. Inaccurate moveable jaw retraction	2. Allow sufficient time for tool to cool down; see "Blade Welding"
	3. Movable jaw sticking	3. Clean and oil jaw dovetails on inside of cabinet
Brittle welds	1. Weld not annealed correctly	1. See "Blade Annealing"
	2. Dirt, oil or flash on blade or jaws	2. Clean blade and jaws

PARTS ILLUSTRATION FOR SHEAR AND DEFLECTOR (FRONT OF WELDER)

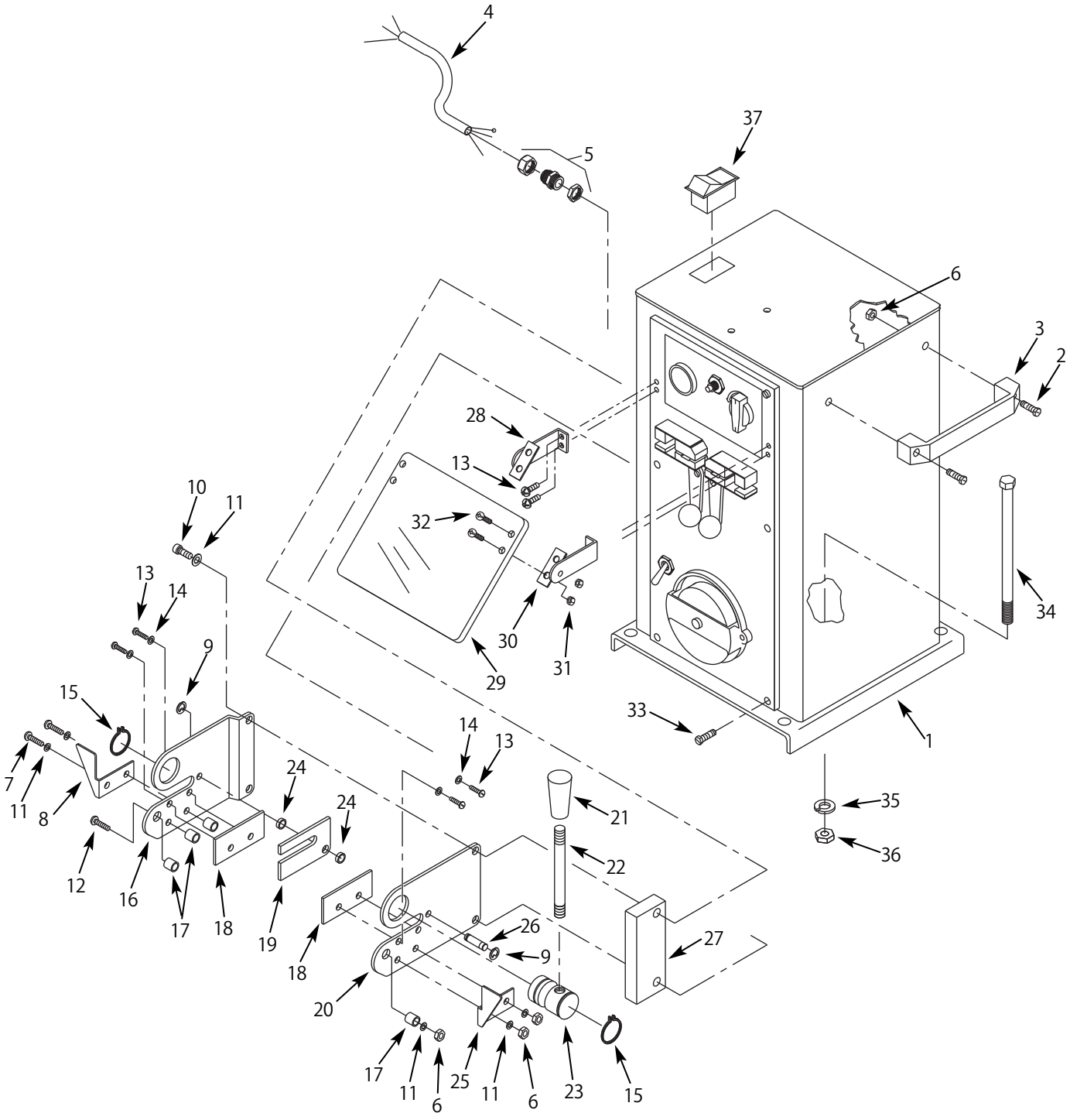


Figure 10 – Parts Illustration for Shear and Deflector (Front of Welder)

PARTS LIST FOR SHEAR AND DEFLECTOR (FRONT OF WELDER)

Ref. No.	Description	Part No.	Qty.
1	Welder cabinet	N/A	1
2	6-1.0 x 15mm Hex head bolt	*	4
3	Handle	17692.00	2
4	Line cord	23926.00	1
5	Strain relief	23925.00	1
6	6-1.0mm Hex nut	*	7
7	6-1.0 x 35mm Pan head screw	*	2
8	Left alignment bracket	23928.00	1
9	3CMI-6 E-ring	09845.00	2
10	6-1.0 x 25mm Socket head bolt	*	2
11	6mm Flat washer	*	6
12	6-1.0 x 40mm Pan head screw	*	1
13	5-0.8 x 8mm Pan head screw	*	8
14	5mm Lock washer	*	4
15	3AMI-25 Retaining ring	01900.00	2
16	Left bracket	05251.00	1
17	Spacer	20260.00	4
18	Lower blade	20263.00	2
19	Upper blade	05254.00	1
20	Right bracket	05252.00	1
21	Knob	17711.00	1
22	Shear handle	20262.00	1
23	Blade cam	05255.00	1
24	Spacer	20266.00	2
25	Right alignment bracket	23930.00	1
26	Pin	20261.00	1
27	Spacer	20257.00	1
28	Left deflector bracket	20267.00	1
29	Spark deflector	20264.00	1
30	Right deflector bracket	20268.00	1
31	4-0.7mm Hex nut	*	4
32	4-0.7 x 12mm Pan head screw	*	4
33	6-1.0 x 15mm Pan head screw	*	6
34	3/8-16 x 6" Hex head bolt	05955.00	1
35	3/8″ Lock washer	*	1
36	3/8″-16 Hex nut	*	1
37	Switch	23929.00	1

(*) Standard hardware item, available locally.
(N/A) Not available as replacement part.

PARTS ILLUSTRATION FOR WELDER

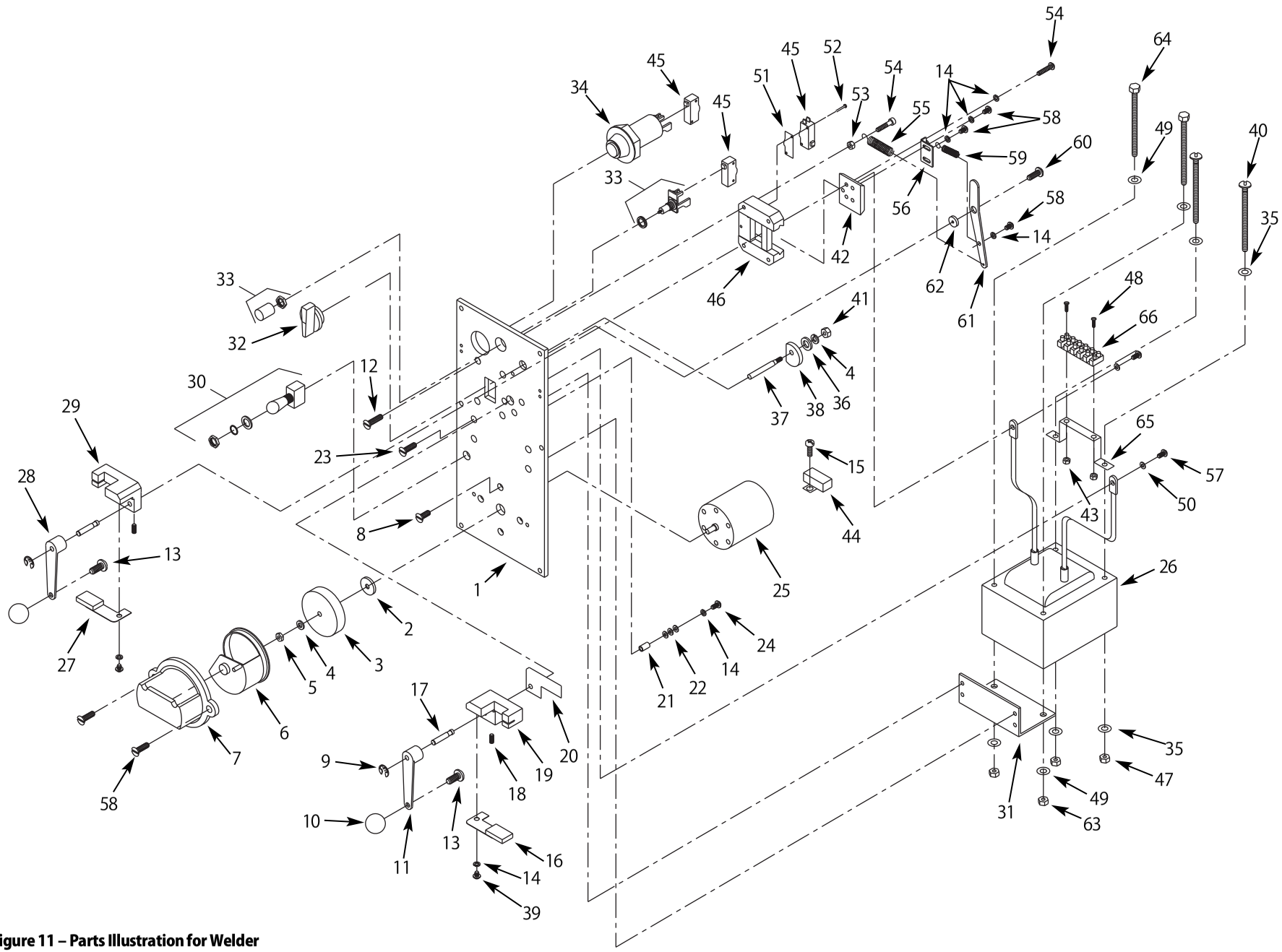


Figure 11 – Parts Illustration for Welder

PARTS LIST FOR WELDER

Ref. No.	Description	Part No.	Qty.
1	Front cover	18640.00	1
2	Spacer	20229.00	1
3	Grinding wheel	20230.00	1
4	6mm Flat washer	*	2
5	6-1.0mm Hex nut	*	1
6	Grinder cover	20231.00	1
7	Grinder guard	18641.00	1
8	#10-24 x 1/2" Flat head screw	*	4
9	3CMI-6 E-ring	09845.00	2
10	Knob	09442.00	2
11	Right clamping lever	20232.00	1
12	5-0.8 x 8mm Flat head screw	*	4
13	6-1.0 x 15mm Pan head screw	*	2
14	5mm Lock washer	*	11
15	#10-24 x 1/4" Pan head screw	*	1
16	Right clamp	05297.01	1
17	Eccentric shaft	20234.00	2
18	6-1.0 x 6mm Set screw	*	2
19	Stationary jaw	20235.00	1
20	Jaw insulator	05324.00	1
21	Insulating tube	18642.00	3
22	Insulating washer	04696.00	9
23	5-0.8 x 12mm Flat head screw	*	4
24	5-0.8 x 15mm Socket head bolt	*	3
25	Motor	18643.00	1
26	Transformer	23931.00	1
27	Left clamp	05330.01	1
28	Left clamping lever	20233.00	1
29	Moveable jaw	18644.00	1
30	Grinder switch assembly	18645.00	1
31	Bracket	23933.00	1
32	Pressure adjustment knob	20236.00	1
33	Anneal button assembly	20237.00	1
34	Weld button assembly	18646.00	1
35	4mm Flat washer	*	4
36	6mm Lock washer	*	2
37	Shaft	20238.00	1
38	Cam	20239.00	1
39	5-0.8 x 6mm Pan head screw	*	2
40	4-0.7 x 64mm Pan head screw	23935.00	2
41	6-1.0mm Hex nut	*	1
42	Guide block	18647.00	1
43	3-0.5mm Hex nut	*	2
44	Capacitor	18648.00	1
45	Limit switch	05278.00	3
46	Guide casting	18649.00	1
47	#10-24 Hex nut	*	2
48	3-0.5 x 16mm Pan head screw	*	2
49	1/4" Flat washer	*	4
50	5mm Brass flat washer	05332.00	2
51	Switch insulator	05279.00	1
52	3-0.5 x 20mm Pan head screw	*	2
53	5-0.8mm Hex nut	*	1
54	5-0.8 x 15mm Socket head bolt	*	3
55	Long spring	20240.00	1
56	Spring bracket	05283.00	1
57	5-0.8 x 10mm Brass pan head screw	03463.00	2
58	5-0.8 x 8mm Pan head screw	*	6
59	Short spring	18650.00	1
60	1/4-20 x 5/8" Pan head screw	*	1
61	Tension arm	20241.00	1
62	Bushing	20242.00	1
63	1/4"-20 Hex nut	*	2
64	1/4-20 x 2½" Hex head bolt	*	2
65	Bracket	23934.00	1
66	Terminal block	20243.00	1

(*) Standard hardware item, available locally.

LIMITED WARRANTY

ONE-YEAR LIMITED WARRANTY. *MODELS COVERED IN THIS MANUAL, ARE WARRANTED TO THE ORIGINAL USER AGAINST DEFECTS IN WORKMANSHIP OR MATERIALS UNDER NORMAL USE FOR ONE YEAR AFTER DATE OF PURCHASE. ANY PART WHICH IS DETERMINED TO BE DEFECTIVE IN MATERIAL OR WORKMANSHIP AND RETURNED SHIPPING COSTS PREPAID, WILL BE, AS THE EXCLUSIVE REMEDY, REPAIRED OR REPLACED AT OUR OPTION. FOR LIMITED WARRANTY CLAIM PROCEDURES, SEE "PROMPT DISPOSITION" BELOW. THIS LIMITED WARRANTY GIVES PURCHASERS SPECIFIC LEGAL RIGHTS WHICH VARY FROM JURISDICTION TO JURISDICTION.*

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