

BIRO®

MODEL 44 POWER MEAT CUTTER OPERATING AND SERVICE MANUAL

STARTING WITH SERIAL NO. 3850



IMPORTANT NOTICE



This Manual contains important safety instructions which must be strictly followed when using this equipment.

INSTALLATION



TO AVOID SERIOUS PERSONAL INJURY, PROPERLY INSTALL EQUIPMENT IN ADEQUATE WORK AREA

ALWAYS Use Qualified Technician and Electrician for Installation.

ALWAYS Install Equipment in Work Area with Adequate Light and Space.

ONLY Operate on a Solid, Level, Non-Skid Surface.

NEVER Operate With the Saw Guide Bar with Saw Guard in the Raised Position or the Saw Guard Removed from the Saw Guide Bar.

ALWAYS Adjust Saw Guide Bar with Saw Guard to Within 1/2" of Product to be Cut.

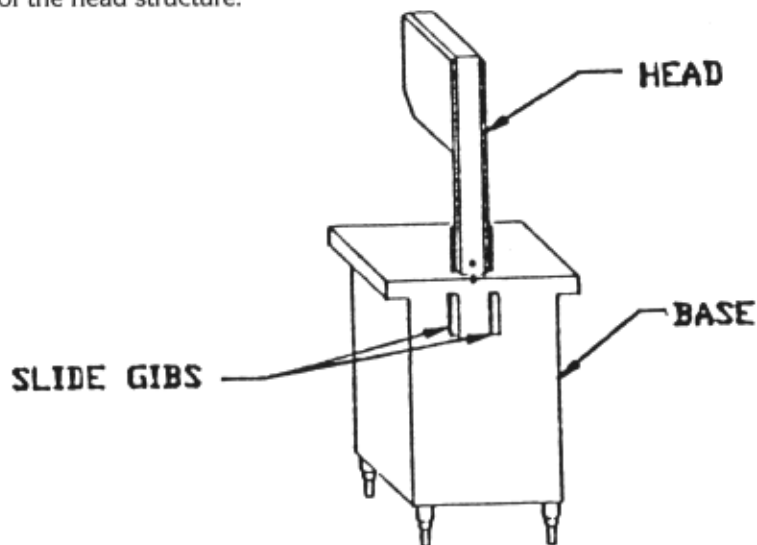
NEVER Operate Without all Warning Labels Attached and Wall Chart Posted.

1. Read this Manual thoroughly before installation and operation. **Do not** proceed with installation and operation if you have any questions or do not understand anything in this Manual. Contact your local Distributor, or BIRO first.
2. Install machine on a level, solid, non-skid surface in a well-lighted work area away from children and visitors.



ALWAYS LEVEL MACHINE BEFORE USING

3. After installing machine in operational area, it is imperative that the four adjusting legs be adjusted to level the machine and also to eliminate rocking.
4. To assemble meat gauge plate (Part No. A18275) to the machine; Loosen the lock knob (Part No. 272-7) on the right side of meat gauge bracket. Raise the meat gauge gear rack (Part No. 18272) and slip the meat gauge plate over the gear rack. Lower the gear rack back to its original position, tighten lock knob. Keep gear rack well oiled with food grade oil to ensure free movement.
5. The head structure (Part No. S18005) comes detached from the base. Slip the head into the slide gibs (Part No. 18260) located on the back of the base structure. Make sure the slide gibs are oiled or greased to ensure free vertical movement of the head structure.



6. Place removable finger lift with saw guard assembly (Part No. A18211) on the saw guide bar (Part No. 116-27) and fasten in place with finger lift fastener knob (Part No. 211A-291Q).



SHARP SAW BLADE. HANDLE WITH EXTREME CAUTION.

7. Placing blade on cutter: Hang upper wheel assembly (Part No. A18003U335) on the hinge bracket (Part No. 71-2). Lift the nylon filler (Part No. 177). Hang blade on the upper wheel and hold with right hand. With left hand force the back of the blade between the front blade cleaners (Part No. 131), located below the nylon filler. Lower the nylon filler and insert the back of the blade in the upper saw guide (Part No. 602B). The blade has already dropped over the lower wheel. With right hand force the back of the blade between the rear blade cleaners (Part No. 131). The blade is now ready to be tightened. Press down on the ratchet arm (Part No. 18010) located at the rear of the base structure. Turn the upper wheel slowly by hand to ensure proper tracking of the saw blade on the wheels. Tighten to proper tension. When the tension gauge (Part No. 18197), located at the bottom rear of the head becomes tight laterally the blade is at proper tension.
8. The stationary platter (Part No. A18163) is placed on top of the base structure and held in place by two push-pull hold down rods (Part No. 18212W), located on the back of the base structure.
9. The sliding meat carriage assembly (Part No. A18155EZ) is installed by turning the movable stop assembly (Part No. A16200) clockwise. After the carriage assembly is in the channel for operation, turn the movable stop counterclockwise to lock.
10. Post **SAFETY TIPS** wall chart within easy view of operator. Keep Manual available to operator.
11. Machine **MUST** be properly grounded. Use qualified electrician to install according to building codes.

WIRING MOTOR

- (1) Interchange of current is made in motor outlet box. Leads are properly marked. Changing instructions are on motor plate or motor outlet box.
- (2) All cutters are wired 220 volts unless otherwise specified. Be sure motor specifications (voltage, cycle, phase) match power supply line. Be sure line voltage is up to specification.
- (3) Connect leads to machine in a manner that will be approved by local electrical inspectors.
- (4) We recommend not less than No. 12 wire. If leads are too light, machine may not have sufficient cutting power and/or speed.
- (5) The V-belt is packed loose in machine to prevent deformation, and must be installed on pulleys at time of wiring motor.
- (6) The BIRO Manufacturing Company is not responsible for permanent wiring, connection or installation.




NOTE TO OWNER AND ELECTRICIAN: IF THIS MACHINE IS NOT CORD AND PLUG CONNECTED TO THE ELECTRICAL SUPPLY SOURCE, THEN IT SHOULD BE EQUIPPED WITH, OR CONNECTED TO, A LOCKABLE, MANUALLY-OPERATED DISCONNECT SWITCH (OSHA 1010.147).




KEEP HANDS CLEAR OF SHARP MOVING BAND TYPE SAW BLADE

13. Make sure saw guide bar with saw guard is in its lowest position. Close head and base doors.
14. Push start button and check for proper phasing of motor. Blade should be travelling down through saw guide.
15. Watch for proper tracking of blade. Back of blade should be centered in hole in saw guide in stationary bar (Part No. 119A). Push stop button to stop machine.
16. Check Placement of all warning labels, wall chart and Manual. Machine is ready for trained operators to process product.
17. Contact your local Distributor or BIRO directly if you have any questions or problems with the installation or operation of this machine.

WARNING LABELS AND WALL CHART



WARNING



DO NOT Use Unless Trained and Authorized By Supervisor And Over 18 Years Old.

Read Operation Manual Thoroughly Before Operating.

ALWAYS Keep Hands Clear of Saw Blade and Other Moving Parts. Turn Off Saw when Finished Cutting.

ALWAYS Keep Blade Guard Adjusted to 1/2" Above the Product being Cut.

ALWAYS Use End Cut Pusher Plate When Cutting Smaller Piece of Product.

DO NOT Use Saw if it is Altered, Damaged, Improperly Maintained, or If Warnings Are Illegible or Missing.

ALWAYS Disconnect and Unplug from Main Power Source and Perform LOCKOUT/TAGOUT Before Cleaning or Servicing.

#653PC-E

Item No. 653PC-E



MUCHO CUIDADO



NO Opere Esta Sierra Sin Haber Sido Entrenado Para Ello Ni Tampoco Sin Autorizacion de un Supervisor. Uno Tiene que Haber Cumplido 18 Anos Para Operarla.

LEA Cuidadosamente el Manual de Operacion Antes de Usar Este Equipo.

SIEMPRE Guarde las Manos a Salvo de la Hoja de Serrar y de Otras Partes Moviles. Cirre el Interruptor Despues de Terminar de Cortar.

SIEMPRE Tenga Ajustado el Guardasierra Para que Quede a 1/2" Por Encima del Producto que se Corta.

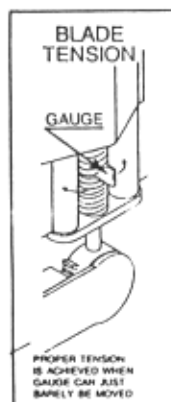
SIEMPRE Haga Uso de la Placa de Empuje Para Cortes de Extremos al Cortar Trocitos Pequenos.

NO Utilice la Sierra si se Halla Alterada, Danadao si No ha Sido Debidamente Mantenido o si la Advertencia es Alegible o si Falta Esta.

SIEMPRE Desconecte el Equipo Decenchifandolo de la Fuente de Fuerza. DejeLo Bajo Llave o con Etiqueta que Prohiba su Uso Antes de Limpiarlo o Hacer Trabajos de Mantenimiento.

#653PC-SP

Item No. 653PC-SP



Item No. 710

ALWAYS LOWER GUARD TO HEIGHT OF PRODUCT



D A N G E R

E X P O S E D B L A D E



Item No. 708

MAINTENANCE



SHARP MOVING BAND TYPE SAW BLADE

TO AVOID SERIOUS PERSONAL INJURY

ALWAYS Turn Off, Unplug From Power Source and Perform Lockout/Tagout Procedure to This Machine **BEFORE** Cleaning or Servicing.

NEVER Touch This Machine Without Training and Authorization By Your Supervisor.

ALWAYS Keep Hands Clear of Band Type Saw Blade and Other Moving Parts.

NEVER Bypass, Alter, or Modify This Equipment in Any Way From Its Original Condition.

PROMPTLY REPLACE Any Worn or Illegible Labels.

USE ONLY GENUINE BIRO Parts and accessories Properly Installed.

A. GENERAL

1. Machine should be generally inspected every time it is cleaned (at least daily) to ensure that it is in good condition and has not been damaged or tampered with.
 - a. **SAW WHEELS:** Clean outer diameter grooves daily. Check for cracks, gouges, or wear on flange and grooves.



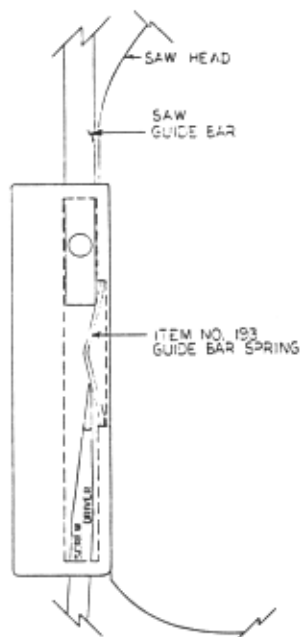
DO NOT IMMERSE UPPER WHEEL ASSEMBLY IN WATER

- b. **WHEEL CLEANER ASSEMBLIES:** Check condition of fiber cleaner, change every four (4) weeks.
- c. **REMOVABLE FINGER LIFT ASSEMBLY:** Check condition of saw guard, make sure mounting bolts are tight and **DANGER EXPOSED BLADE** decal is attached and legible. Check condition of upper saw guide (Part No. 602B), replace every six (6) months. Check adjustment of upper saw guide. Should be $\frac{1}{32}$ " between back of blade and saw guide carbide.



NEVER USE THIS MACHINE WITHOUT PROPERLY INSTALLED AND FUNCTIONING SAW GUIDE BAR AND SAW GUARD

- d. **SAW GUIDE BAR:** Check condition of bar for coating peeling and wear, replace as necessary. Check saw guide bar spring for proper tension. The spring should hold the bar in any desired position in its travel. Replace saw guide bar spring (Part No. 193) as necessary using instructions on following page.



1. Remove the finger lift fastener knob and the fingerlift assembly.
2. Remove the finger lift fastener stud.
3. Push the saw guide bar up and out of the top of the head structure.
4. Remove the saw guide bar spring.
5. Clean and lubricate the babbitt pocket area (the square indented area that seats the saw guide bar spring).
6. Lower the new saw guide bar spring through the top of the babbitt pocket area and guide the spring into position with a standard screwdriver. (NOTE: Drawing)
7. While holding the saw guide bar spring in position, re-enter the saw guide bar from the top compressing the saw guide bar spring slightly until the saw guide bar slides past the spring.
8. Replace the finger lift fastener stud, the fingerlift assembly and the finger lift fastener knob.
9. Test by making several adjustments.

- e. **STATIONARY BAR ASSEMBLY:** Check condition of nylon filler (Part No. 177), change every four (4) weeks. Check condition of saw guide (Part No. 119A), check tracking of blade through guide, back of blade should be centered in hole, replace every six (6) months. Check condition of lower blade back-up guide (Part No. 605). Check adjustment of back-up guide, should have $\frac{1}{32}$ " gap between back of blade and saw guide carbide. Replace every six (6) months.
- f. **SAW CLEANERS:** Check condition of blade cleaners, replace every four (4) weeks.
- g. **RATCHET ASSEMBLY:** Check for smooth operation through full range of travel. Check condition of trigger spring, replace as necessary.
- h. **SLIDE GIBS:** Check that head structure moves freely up and down. Check for side to side and fore to aft slop, adjust as required. Grease every four (4) weeks.
- i. **MEAT GAUGE ASSEMBLY:** Check free movement of meat gauge plate on gear rack. Gear rack to be kept lubricated at all times with light food grade oil. Check operation of release handle. Check that worm gear engages properly with gear rack.
- j. **MEAT CARRIAGE ASSEMBLY:** Check for free movement through full range of travel. Check for side to side slop, adjust as necessary. Check condition of bearings, replace as necessary. Check condition of thumb guard, replace as necessary.
- k. **SAFETY ITEMS:** Safety end cut pusher plate with machine and accessible. All warning labels present, properly affixed and legible. Model and Serial Number plate properly affixed and legible. Wall poster within operators view from machine. Manual accessible to operator.

B. LUBRICATION

1. **UPPER WHEEL BEARINGS:** Grease every four (4) months. Change grease every twelve (12) months.
2. **LOWER BEARING HOUSING:** Grease every four (4) months. Change grease every twelve (12) months.
3. **SLIDE GIBS:** Grease every four (4) weeks.
4. **MEAT CARRIAGE BEARINGS:** Grease every four (4) weeks.
5. **SAW GUIDE BAR:** Oil daily with food machine oil.
6. **MEAT GAUGE GEAR RACKS:** Oil daily with food machine oil.

C. SAW GUIDE BAR AND SAW GUARD

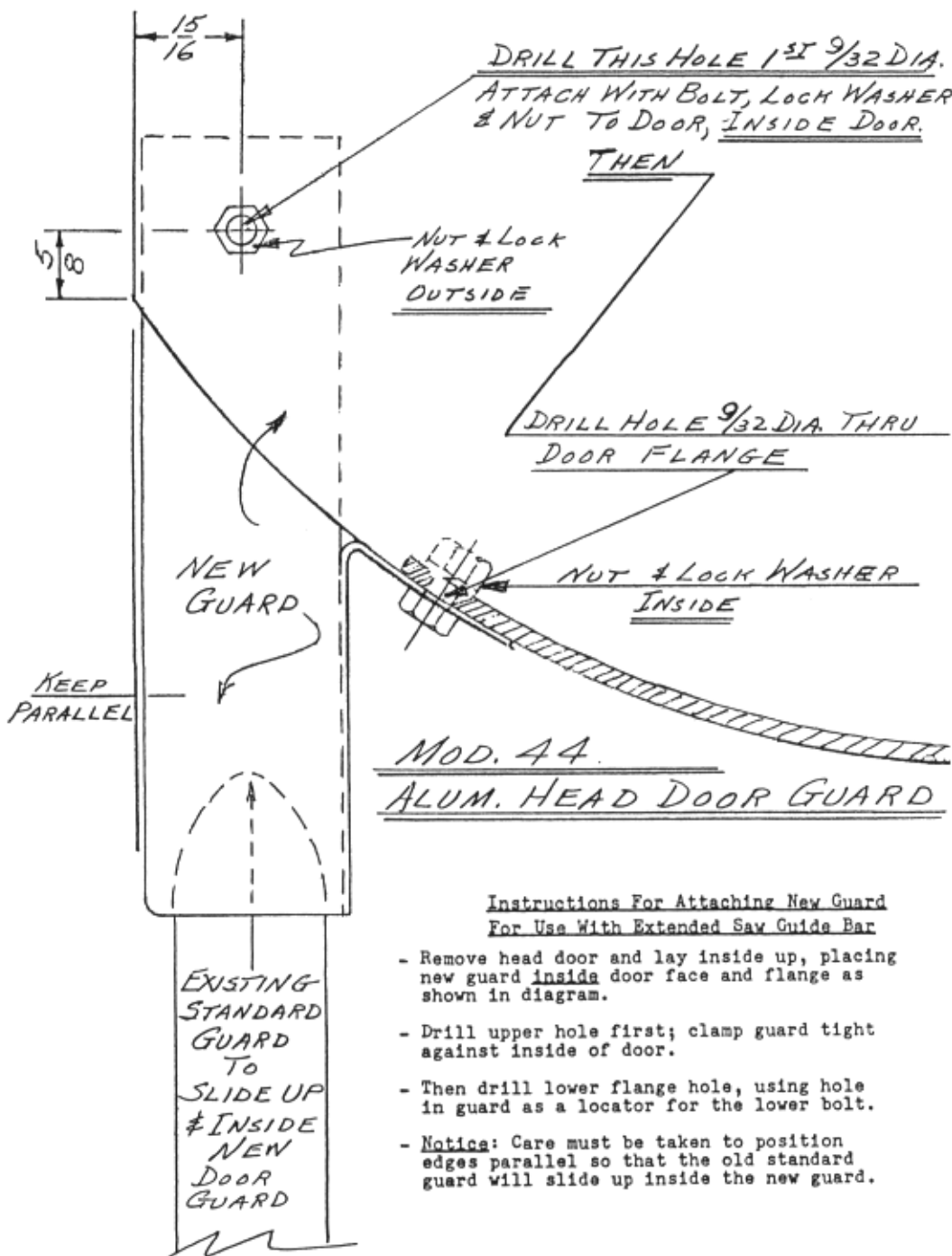
The factory recommends that when service is performed on any BIRO SAW the servicing agency be sure that the BIRO SAW is equipped with the most current safety features available.

MODEL 44 SAW GUIDE BARS AND SAW GUARDS

Production of the BIRO Model 44 began March 1956. All units prior to serial #4511 were equipped with a (round) cast aluminum head. The saw guide bar measured 21½" and the (Item #255) SAW GUARD was the same as used on Models 33 and 34.

The factory recommends that on all units equipped with (round) cast aluminum heads, the complete head assembly be replaced with the current stainless steel (fabricated square) HEAD ASSEMBLY (Item #AS18005).

All units serial #4511 on were built with a fabricated (square) steel head. The saw guide bar on these units measured 27" and is current. All units serial #4511 on are equipped with the most current safety features.



CLEANING



SHARP MOVING BAND TYPE SAW BLADE TO AVOID SERIOUS PERSONAL INJURY

ALWAYS Turn Off, Unplug From Power Source and Perform Lockout/Tagout Procedure to This Machine **BEFORE** Cleaning or Servicing.

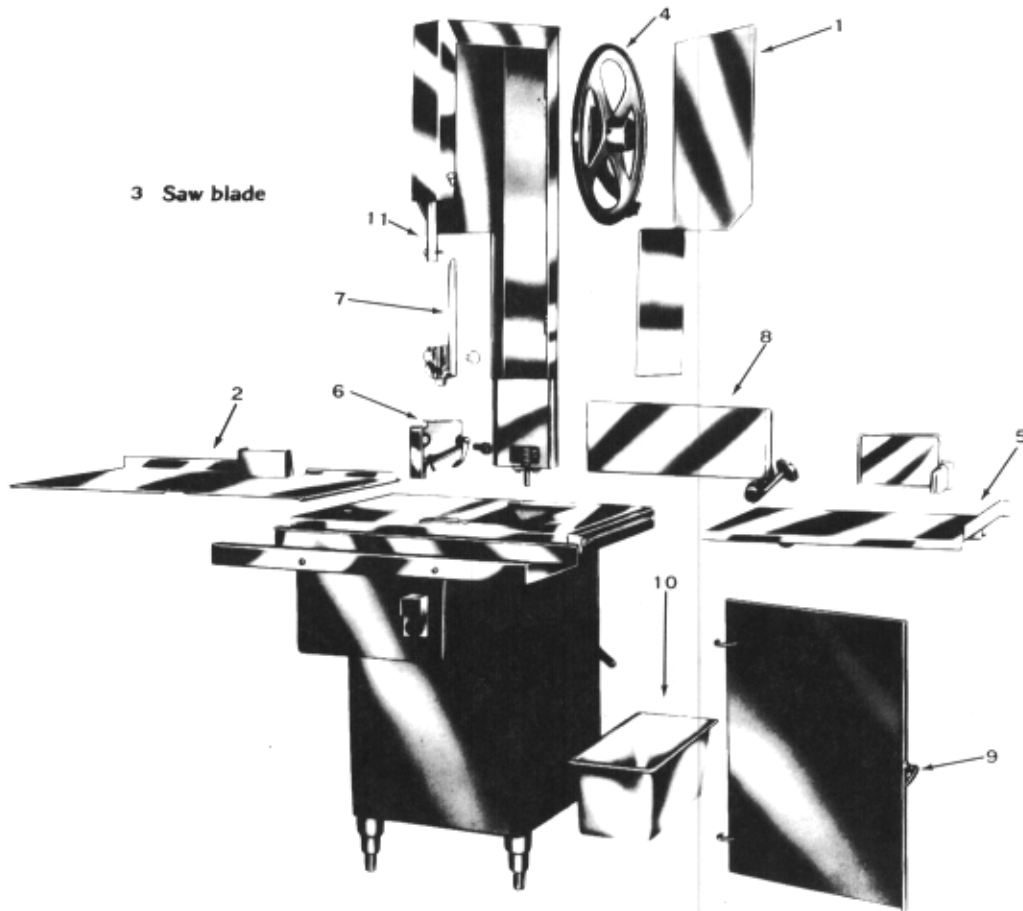
ONLY Use Recommended Cleaning Equipment, Materials and Procedures.

NEVER Spray Water or Other Liquid Substances Directly at Motor, Power Switch or any Other Electrical Components.

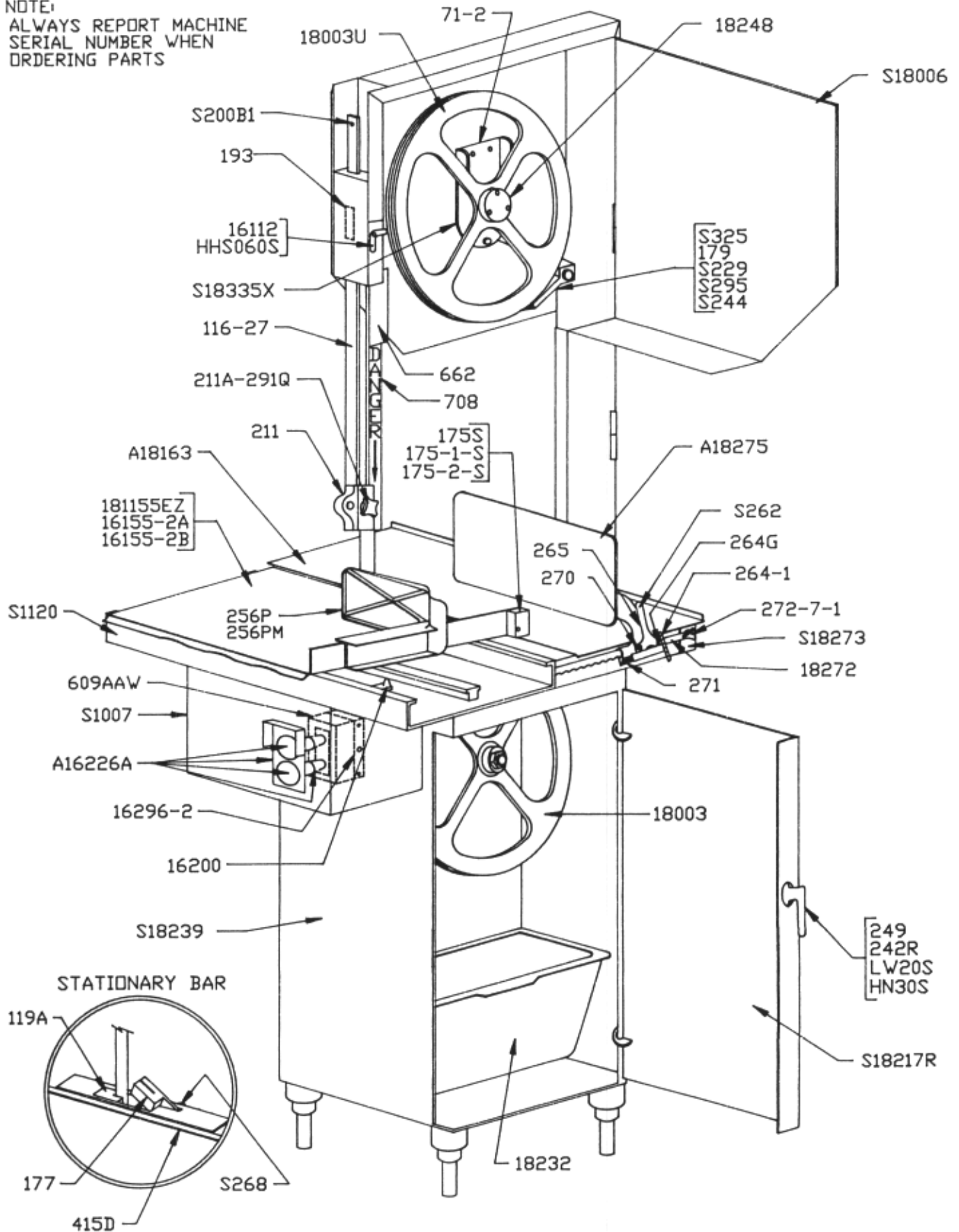
ALWAYS Thoroughly Clean Equipment at Least Daily.

CLEANING THE BIRO POWER CUTTER:

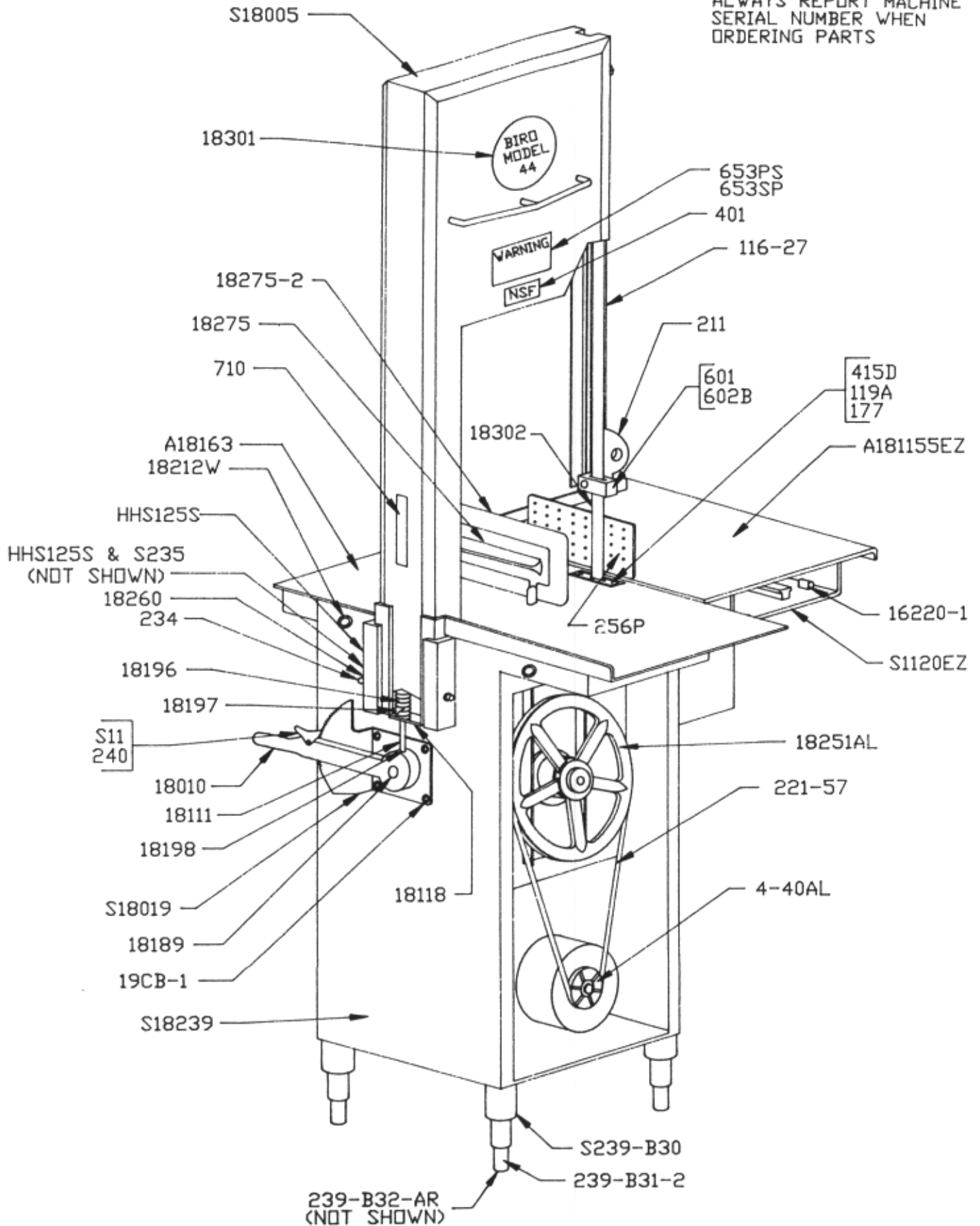
Disconnect electrical power to the machine before cleaning. Parts to be removed have been made accessible and can be removed without tools. Notice in the drawing below that all parts are numbered. Each part should be removed for cleaning in the numbered sequence shown. To ensure cleaner cuts, keep the cleaning system in good condition. Parts on the cleaning system which should be checked weekly, and changed as required are as follows: Wheel Cleaners (Part No. 179), Saw Cleaners (Part No. 131), Saw Guide in Stationary Bar (Part No. 119A), Upper Saw Guide (Part No. 602B), Lower Blade Back-Up Guide (Part No. S608) and Nylon Filler (Part No. 177).



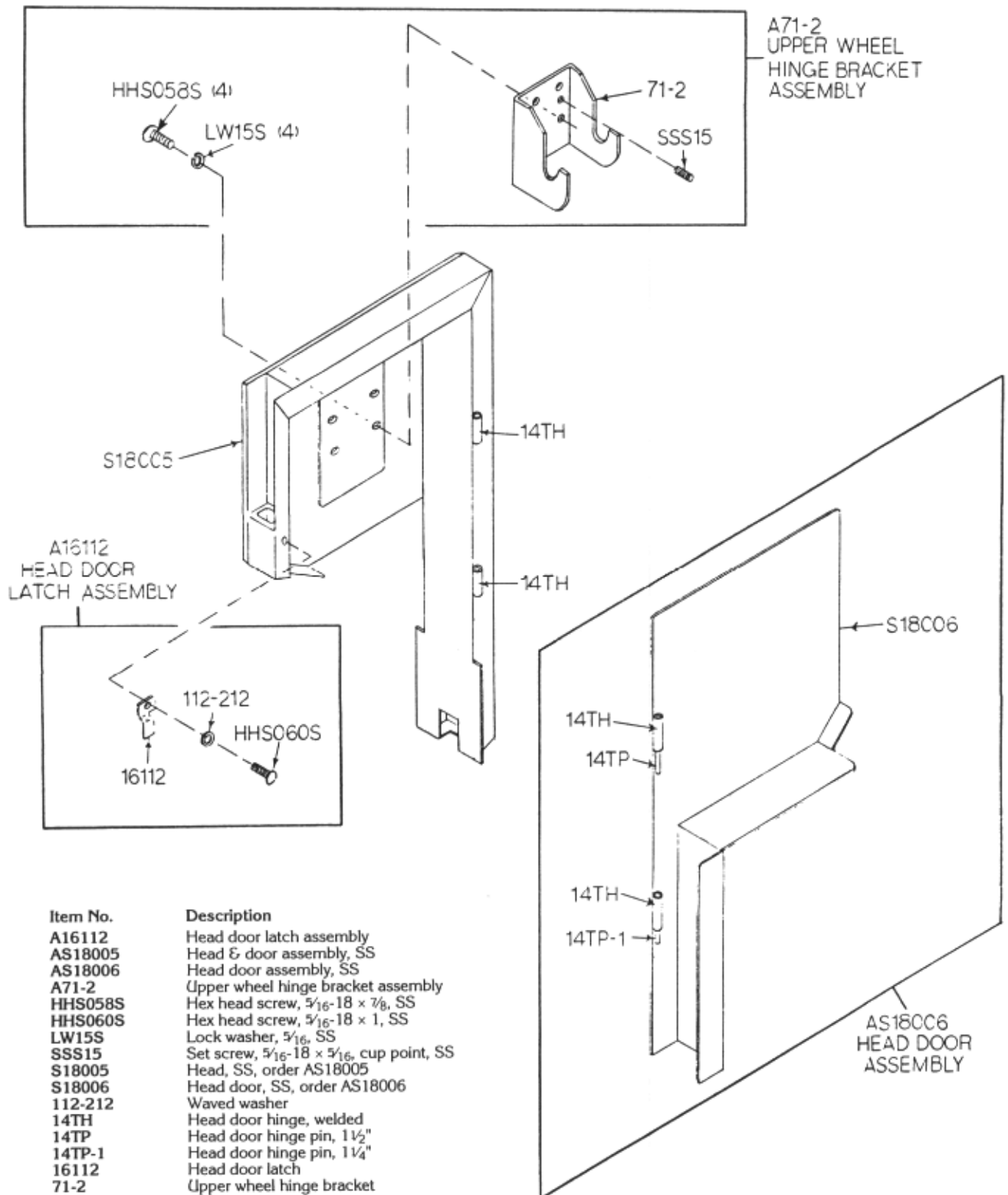
NOTE:
ALWAYS REPORT MACHINE
SERIAL NUMBER WHEN
ORDERING PARTS

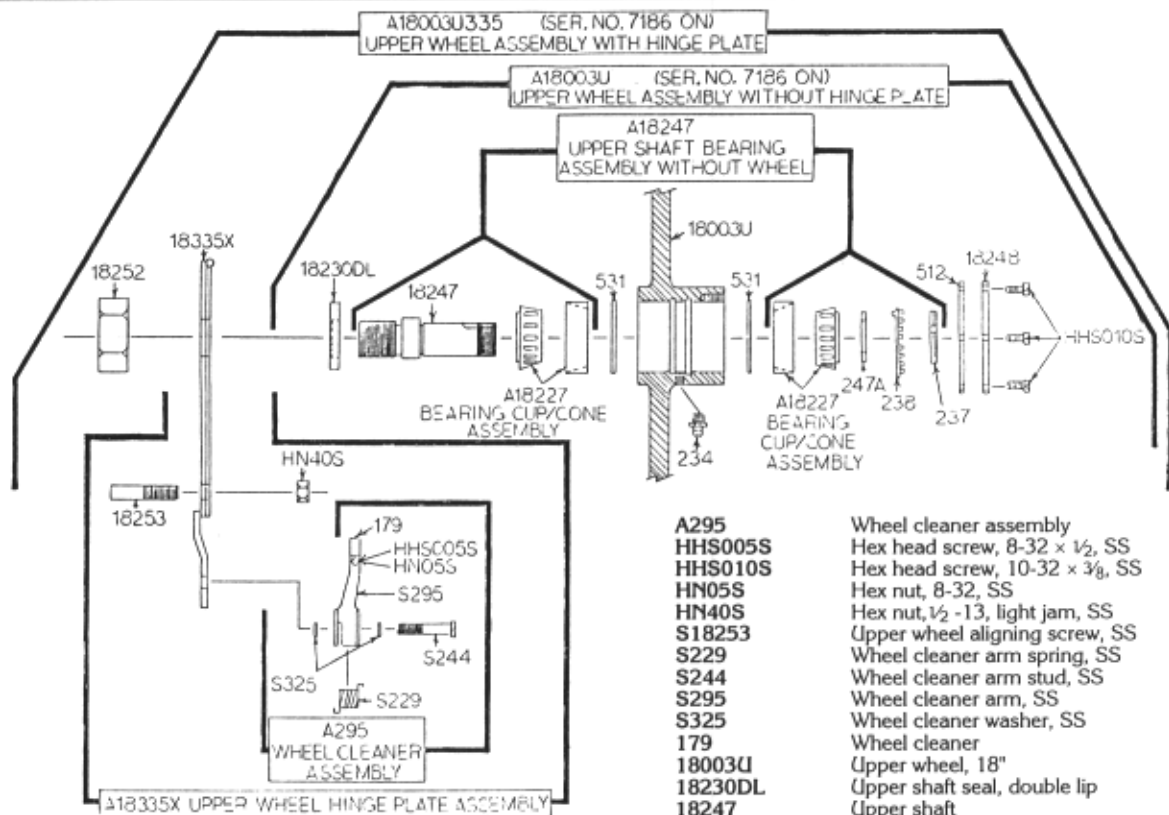


NOTE:
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SERIAL NUMBER WHEN
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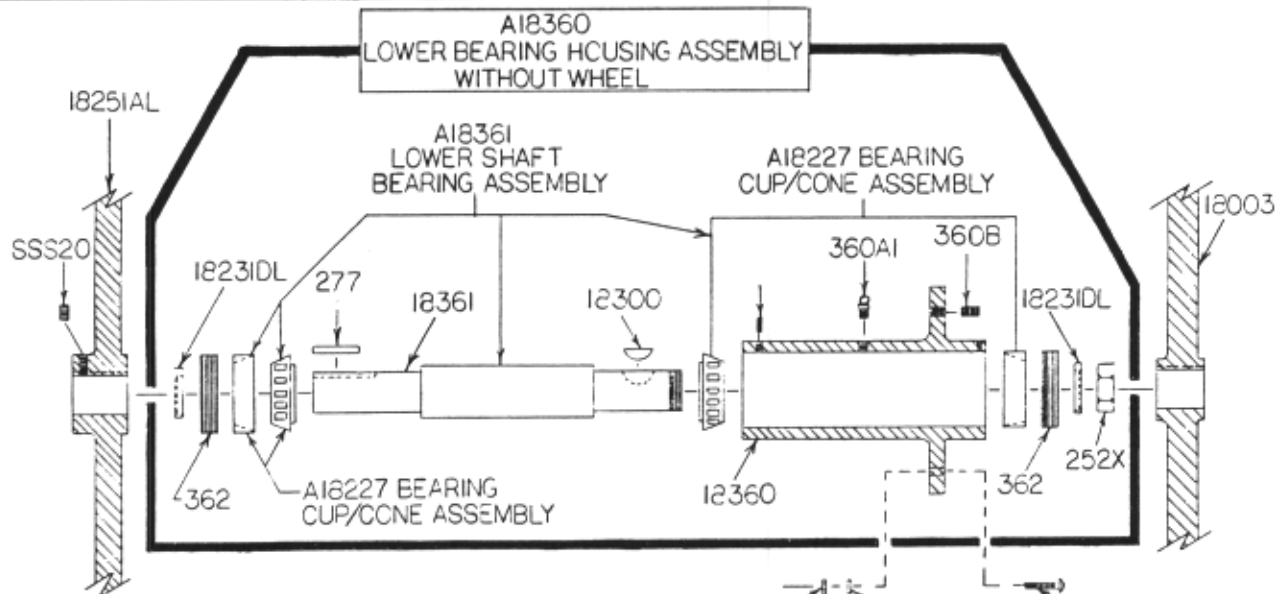
AS18006 S.S. HEAD & DOOR ASSEMBLY





Item No.	Description
A18003U	Upper wheel assembly w/o hinge plate
A1800U335	Upper wheel assembly with hinge plate
A18227	Bearing cup/cone assembly
A18247	Upper shaft and bearing assembly
A18335X	NOT SOLD AS ASSEMBLY

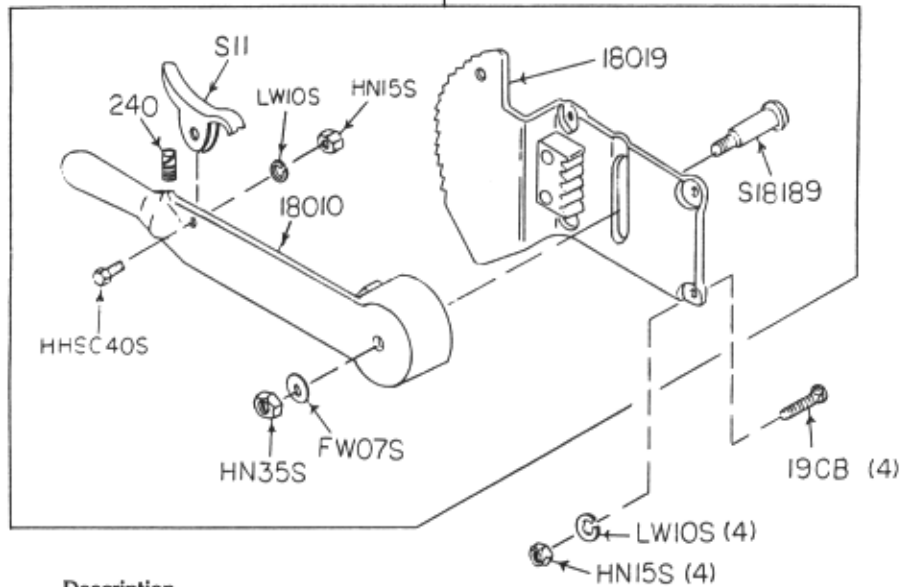
A295	Wheel cleaner assembly
HHS005S	Hex head screw, 8-32 x 1/2, SS
HHS010S	Hex head screw, 10-32 x 3/8, SS
HN05S	Hex nut, 8-32, SS
HN40S	Hex nut, 1/2 -13, light jam, SS
S18253	Upper wheel aligning screw, SS
S229	Wheel cleaner arm spring, SS
S244	Wheel cleaner arm stud, SS
S295	Wheel cleaner arm, SS
S325	Wheel cleaner washer, SS
179	Wheel cleaner
18003U	Upper wheel, 18"
18230DL	Upper shaft seal, double lip
18247	Upper shaft
18248	Upper wheel hub cap
18252	Upper shaft lock nut
18335X	Upper wheel hinge plate
234	Grease fitting
237	Upper shaft castellated lock nut
238	Upper shaft castellated lock washer
247A	Upper shaft bearing back-up washer
512	Upper wheel hub cap gasket
531	Retaining ring (2 req'd.)



Item No.	Description
A18227	Bearing cup/cone assembly
A18360	Lower bearing housing assembly
A18361	NOT SOLD AS ASSEMBLY
HN25S	Hex nut, 3/8 -16, SS
LW25S	Lock washer, 3/8, SS
SSS20	Set screw, 3/8-16 x 3/8, cup point
S360CB-1	Carriage bolt, 3/16-16 x 1 1/4, SS
18003	Lower wheel, 18"
18231DL	Lower shaft seal, double lip

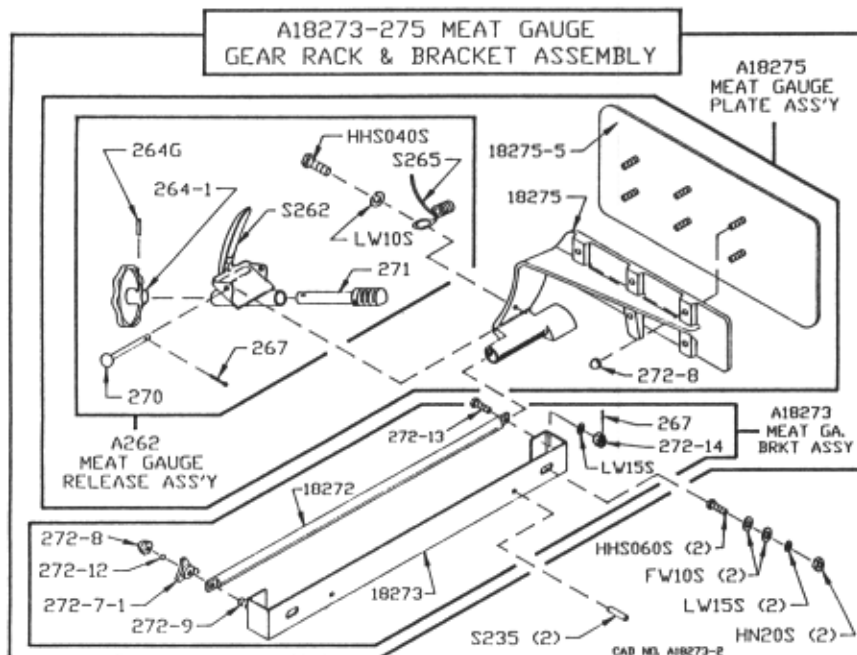
HN25S	Hex nut, 3/8 -16, SS
LW25S	Lock washer, 3/8, SS
S360CB-1	Carriage bolt, 3/16-16 x 1 1/4, SS
18251AL	Upper v-belt pulley, 12.8 x 1 1/8, AL
18300	Lower shaft woodruff key
18360	Lower bearing housing
18361	Lower shaft
252X	Shaft lock nut
277	Lower shaft pulley key
360A1	Grease fitting
360B-1	Set screw, 1/2-13 x 1/2, flat point
362	Lower bearing housing adjusting cap

* A18019
RATCHET ASSEMBLY

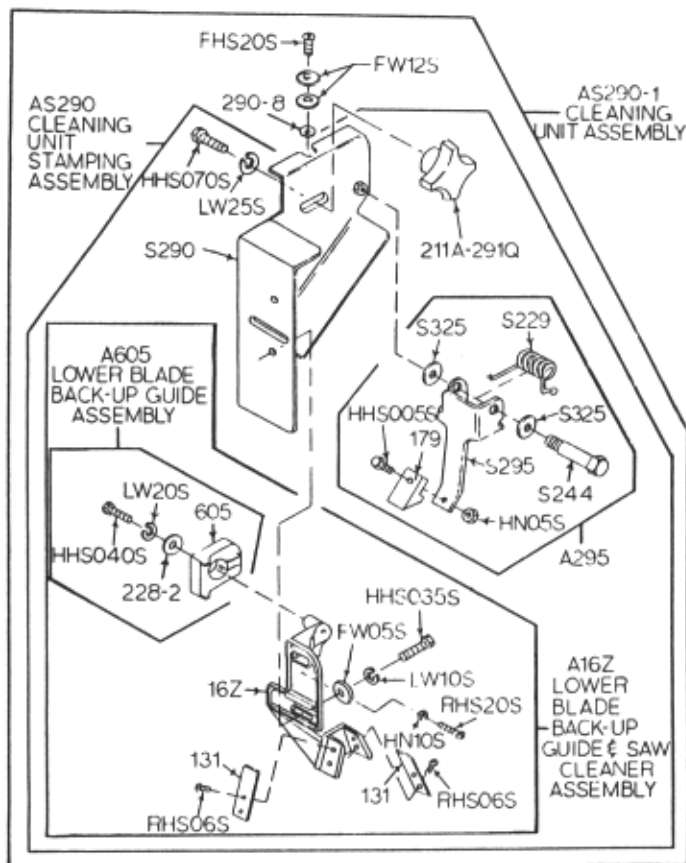


Item No.	Description	Item No.	Description
A18019	Ratchet assembly	S11	Ratchet trigger, SS
FW07S	Flat washer, $\frac{3}{8}$, SS	S18189	Ratchet arm stud, SS
HHS040S	Hex head screw, $\frac{1}{4}$ -20 x $\frac{3}{4}$, SS	S240	Ratchet trigger spring, SS
HN15S	Hex nut, $\frac{1}{4}$ -20, SS	18010	Ratchet base
HN35S	Hex nut, $\frac{3}{8}$ -16, jam, SS	18019	Ratchet arm
LW10S	Lock washer, $\frac{1}{4}$, SS	19CB	Carriage bolt, $\frac{1}{4}$ -20 x $\frac{3}{4}$, SS
		LW10S (4)	
		HN15S (4)	

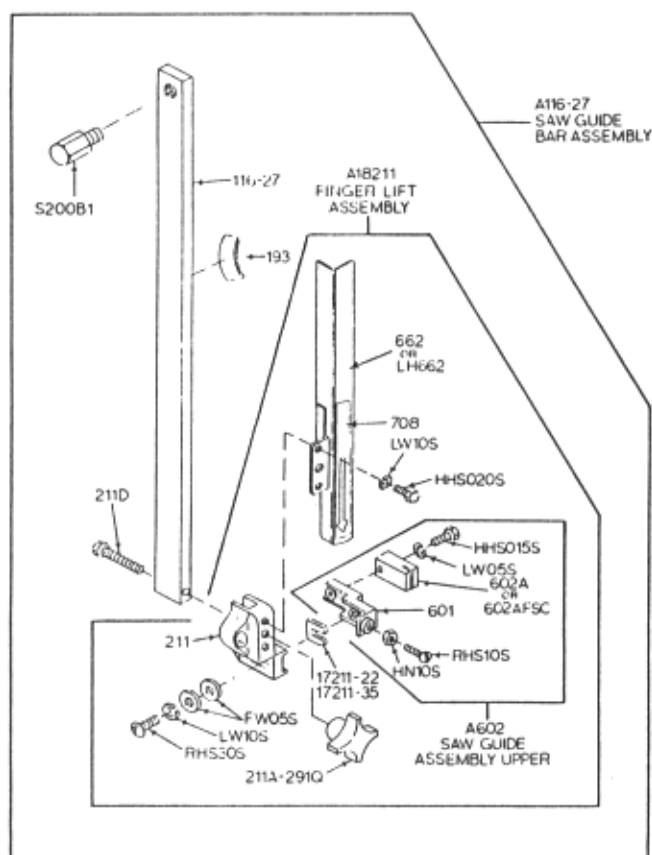
A18273-275 MEAT GAUGE
GEAR RACK & BRACKET ASSEMBLY



Item No.	Description	Item No.	Description
A18273-275	NOT SOLD AS ASSEMBLY	18272	Meat gauge gear rack
A18273	Meat gauge bracket assembly	18273	Meat gauge bracket, ORDER A18273
A18275	Meat gauge plate assembly	18275	Meat gauge arm
A262	Meat gauge release assembly	18275-5	Meat gauge plate, SS
FW10S	Flat washer, $\frac{5}{16}$, SS	264G	Meat gauge hand wheel groove pin
HHS040S	Hex head screw, $\frac{1}{4}$ -20 x $\frac{3}{4}$, SS	264-1	Meat gauge hand wheel
HHS060S	Hex head screw, $\frac{5}{16}$ -18 x 1, SS	267	Meat gauge release cotter key
HN20S	Hex nut, $\frac{5}{16}$ -18, SS	270	Meat gauge release pin
LW10S	Lock washer, $\frac{1}{4}$, SS	271	Meat gauge worm gear
LW15S	Lock washer, $\frac{5}{16}$, SS	272-7-1	Lock knob, $\frac{5}{16}$ -18, 3 point
S235	Taper pin, 4 x $\frac{3}{4}$, SS	272-8	Cap nut, $\frac{5}{16}$ -18, SS
S262	Meat gauge release handle, SS	272-9	Hex head screw, $\frac{5}{16}$ -18 x 2, SS
S265	Meat gauge release spring, SS	272-12	Brass ball, $\frac{7}{32}$ dia.
		272-13	Hex head bolt, $\frac{5}{16}$ -18 x $1\frac{1}{4}$, SS

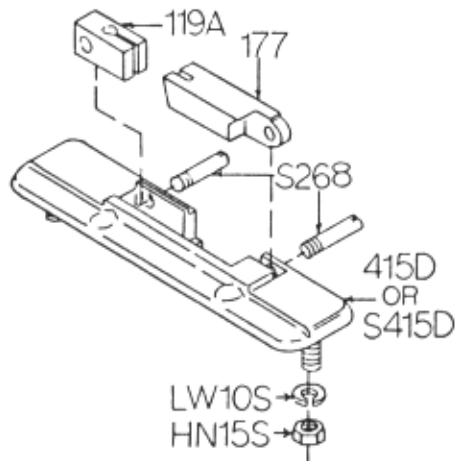


Item No.	Description
A16Z	Guide bracket saw cleaner assembly
A295	Wheel cleaner assembly
A605	Lower blade backup guide assembly
AS290	Cleaning unit stamping assembly
AS290-1	NOT SOLD AS ASSEMBLY
FHS20S	Flat head screw, 10-32 x 1/2, SS
FW05S	Flat washer, 1/4, SS
HHS003S	Hex head screw, 8-32 x 1/4, SS
HHS005S	Hex head screw, 8-32 x 1.2, SS
HHS035S	Hex head screw, 1/4-20 x 5/8, SS
HHS040S	Hex head screw, 1/4-20 x 3/4, SS
HHS070S	Hex head screw, 3/8-16 x 1, SS
HN05S	Hex nut, 8-32, SS
HN10S	Hex nut, 10-32, SS
LW10S	Lock washer, 1/4, SS
LW25S	Lock washer, 3/8, SS
RHS20S	Round head screw, 10-32 x 1 1/4, SS
S229	Wheel cleaner arm spring, SS
S244	Wheel cleaner arm stud, SS
S290	Cleaning unit stamping, SS
S295	Wheel cleaner arm, SS
S325	Wheel cleaner washer, SS
131	Saw cleaner, SS
16Z	Lower guide bracket saw cleaner holder
179	Wheel cleaner
211A-291Q	Fastener knob, 4 point
228-2	Lower guide washer
290-8	Cleaning unit locator washer, SS
605	Saw guide lower blade backup



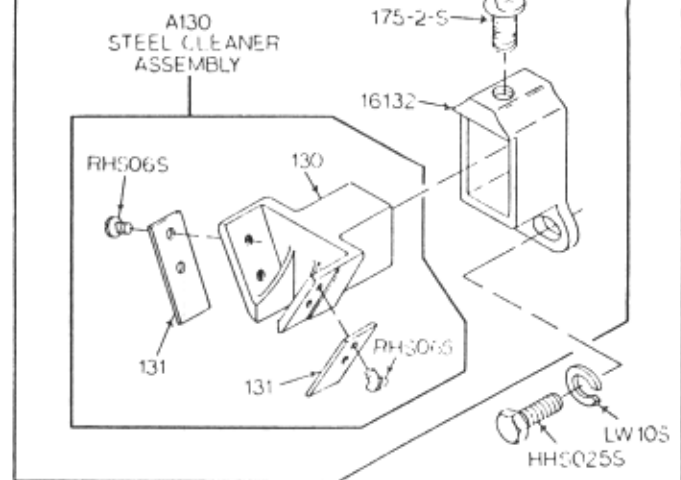
Item No.	Description
A116-27	Saw guide bar assembly, 27"
A18211	Finger lift assembly, removable
A602	Saw guide assembly, upper
FW05S	Flat washer, 1/4, SS
HHS015S	Hex head screw, 10-32 x 7/8, SS
HHS020S	Hex head screw, 1/4-20 x 3/8, SS
HN10S	Hex nut, 10-32, SS
LH662	Saw guard for true left head
LW05S	Lock washer, #10, SS
LW10S	Lock washer, 1/4, SS
RHS10S	Round head screw, 10-32 x 3/4, SS
RHS30S	Round head screw, 1/4-20 x 7/8, SS
S200B1	Stop stud on guide bar
116-27	Saw guide bar, 27"
17211-22	Finger lift shim, .022
17211-35	Finger lift shim, .035
193	Saw guide bar spring
211	Finger lift bracket
211A-291Q	Fastener knob, 4 point
211D	Finger lift fastener bolt
601	Upper saw guide bracket
602B	Upper saw guide
602AFSC	Upper saw guide, narrow, fish
662	Saw guard for stainless head, SS
663	Saw guard for aluminum head, SS
708	Decal "DANGER EXPOSED BLADE"

A415D OR AS415D
STATIONARY BAR ASSEMBLY



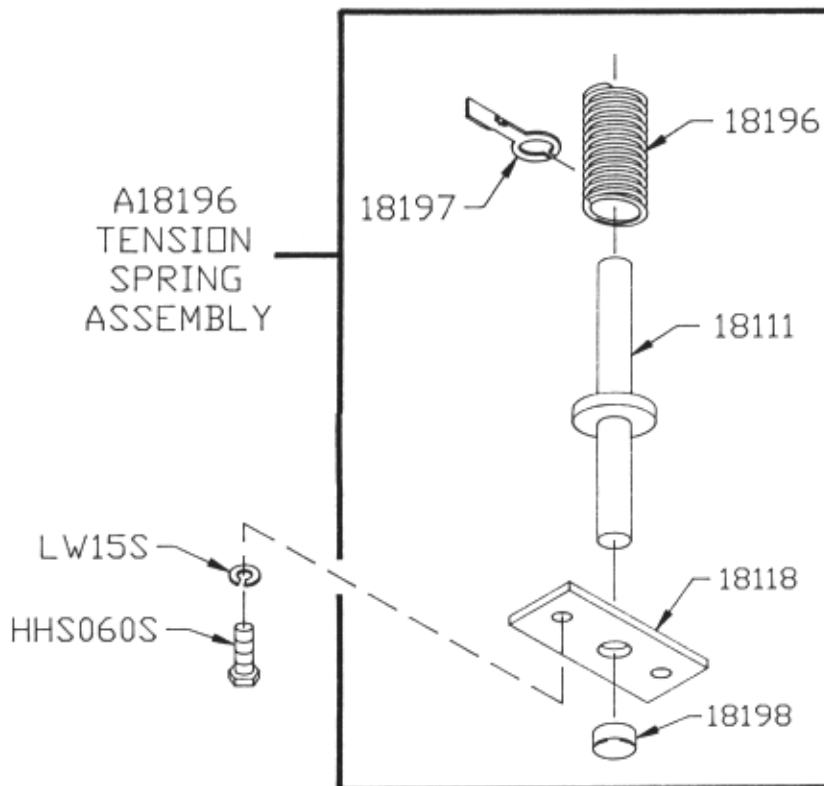
Item No.	Description
A415D	Stationary bar assembly
AS415D	SS Stationary bar assembly
HHS035S	Hex head screw, $\frac{1}{4}$ -20 x $\frac{5}{8}$, SS
HN15S	Hex nut, $\frac{1}{4}$ -20, SS
LW10S	Lock washer, $\frac{1}{4}$, SS
S286	Stationary bar headless screw
S415D	Stainless stationary bar
119A	Saw guide in stationary bar
119FSC	Saw guide in sta. bar, fish
177	Nylon filler
415D	Stationary bar

A16132
REAR STEEL CLEANER
ASSEMBLY

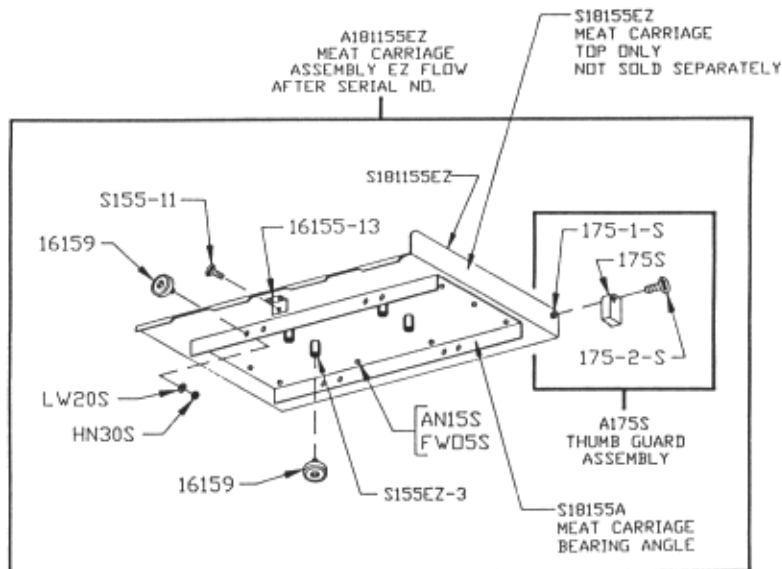


Item No.	Description
A130	Saw cleaner assembly
A16132	Steel cleaner assembly, rear
HHS003S	Hex head screw, 8 -32 x $\frac{1}{4}$, SS
HHS025S	Hex head screw, $\frac{1}{4}$ -20 x 1, SS
130	Saw cleaner bracket, rear
131	Saw cleaner, SS
16132	Saw cleaner bracket holder, rear
175-2-S	Thumb screw, $\frac{1}{4}$ -20 x $\frac{1}{2}$

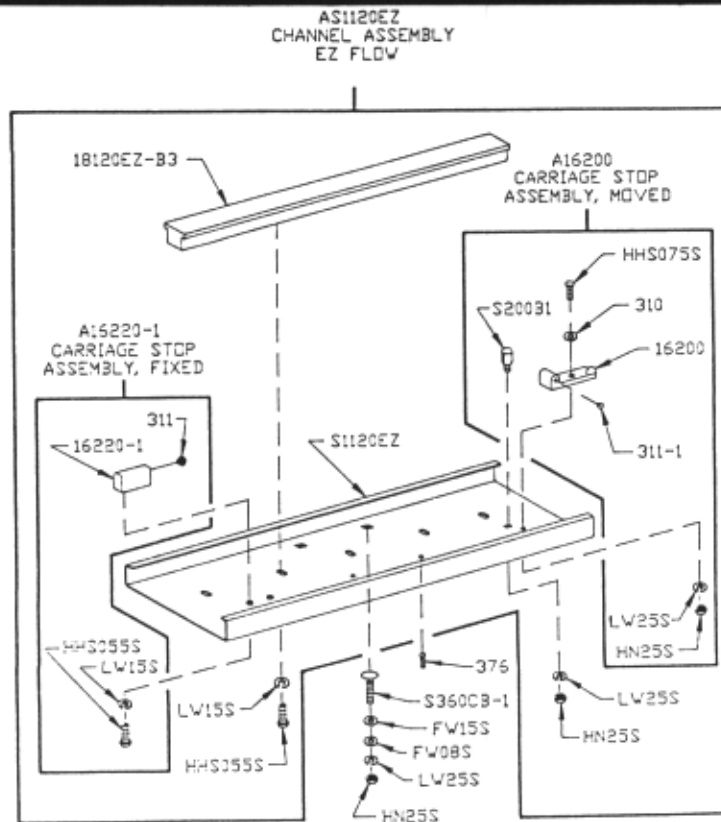
A18196
TENSION
SPRING
ASSEMBLY



Item No.	Description
A18196	Tension spring assembly
HHS060S	Hex head screw, $\frac{5}{16}$ -18 x 1, SS
LW15S	Lock washer, $\frac{5}{16}$, SS
18111	Tension spring pin
18118	Tension spring plate
18196	Saw tension spring
18197	Tension spring gauge
18198	Cap for tension pin

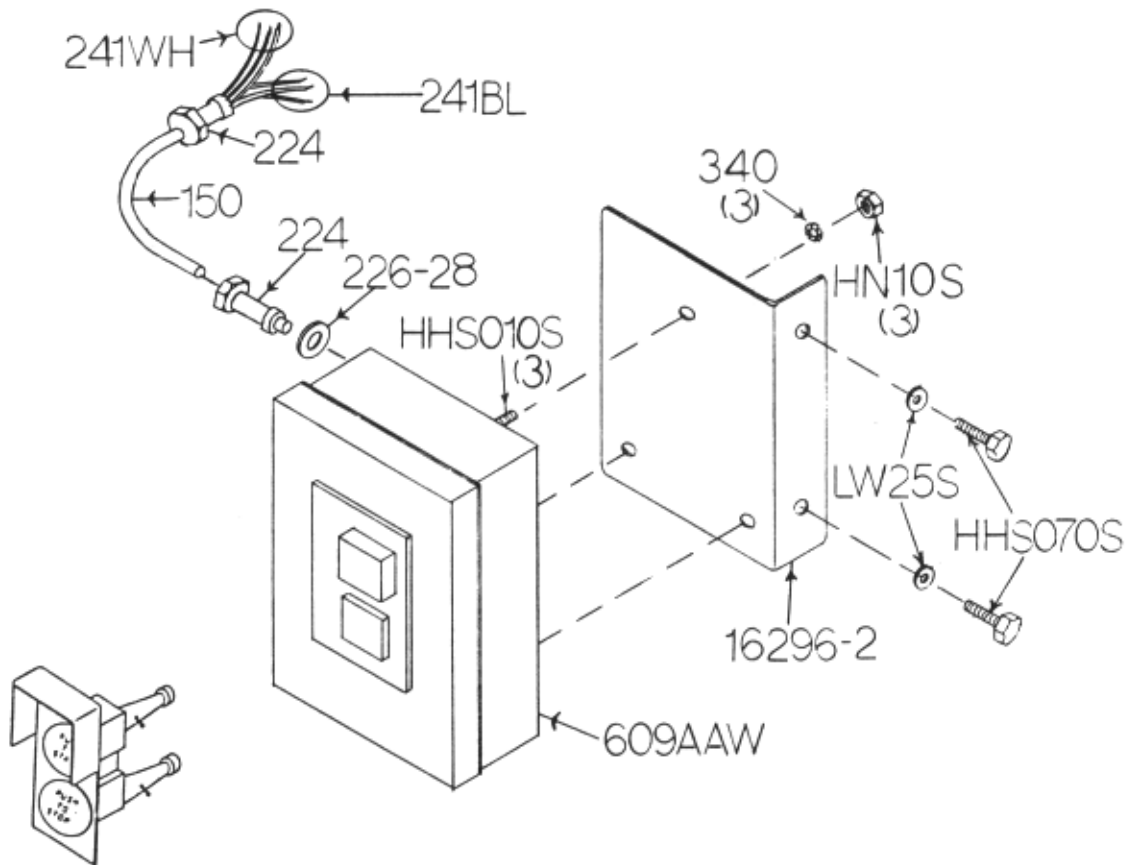


Item No.	Description	Item No.	Description
A181155EZ	Meat carriage assembly EZ flow	S155EZ-3	Hex stand off
A175S	Thumb guard assembly	S155-11	Meat carriage stop thumb screw
AN15S	Acorn nut, 1/4-20, SS	S181155EZ	Meat carriage top & angle only
FW05S	Flat washer, 1/4, SS	16155-13	Meat carriage stop angle
HN30S	Hex nut, 3/8-16 light jam, SS	16159	Meat carriage bearing, SS
LW20S	Lock washer, 3/8 light, SS	175S	Thumb guard, nylon
		175-1-S	Thumb guard nut, SS
		175-2-S	Thumb screw, 1/4-20 x 1/2



Item No.	Description	Item No.	Description
A16200	Carriage stop assembly, movable	LW15S	Lock washer, 5/16, SS
A16220-1	Carriage stop assembly, fixed	LW25S	Lock washer, 3/8, SS
AS1120EZ	Channel assembly, EZ flow	S1120EZ	Channel, 38-1/2", SS
FW08S	Flat washer, 3/8, SS	S200B1	Carriage stop stud, SS
FW15S	Flat washer, 1/2, SS	S360CB-1	Carriage bolt, 3/8-16 x 1 1/4, SS
HHS055S	Hex head screw, 5/16-18 x 3/4, SS	16200	Carriage stop only, movable
HHS075S	Hex head screw, 3/8-16 x 1 1/4, SS	16220-1	Carriage stop only, fixed
HN20S	Hexnut, 5/16-18, SS	18120EZ-B3	Guide bar, EZ flow, T-shaped
HN25S	Hex nut 3/8-16, SS	310	Waved washer
		311	Rubber bumper for fixed stop
		311-1	Rubber bumper for movable stop
		375	Drive screw, 10 x 1/2, SS

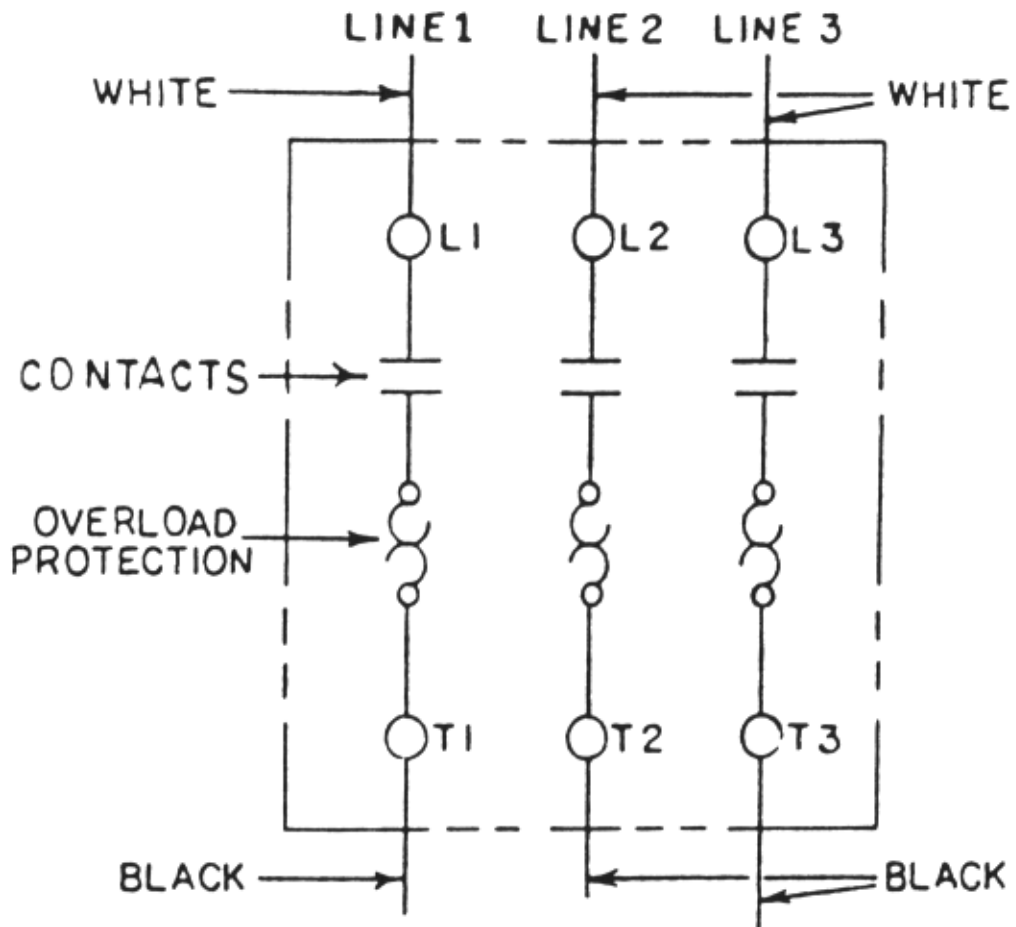
**A609AAW-18
SWITCH ASSEMBLY**



A16226A

Item No.	Description
A16226A	Green/red switch button assembly w/springs
A609AAW-16	Switch assembly, 1 & 3 ph less heater coils
HHS010S	Hex head screw, 10-32 x 3/8 SS
HHS070S	Hex head screw, 3/8-16 x 1 SS
HN10S	Hex nut, 10-32 SS
LW25S	Lock washer, 3/8 SS
16296-2	Switch bracket SS
150	Conduit, 1/2"
224	Conduit connector, 180°
226-28	Washer SS, 1 1/2 x 27/32
241BL	Wire, black, 12GA., CSA & UL
241WH	Wire, white, 12GA., CSA & UL
340	Star lock washer
609AAW	Manual switch, size 0, 1 & 3 ph

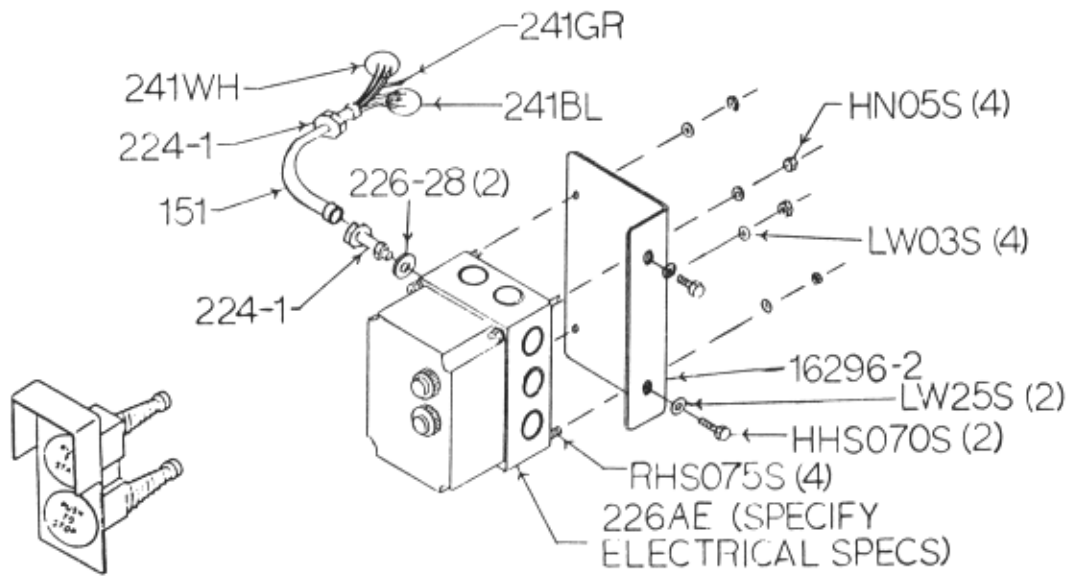
609AAW



**WATERTIGHT MAGNET SWITCH ASSEMBLIES
(AEG)
INCLUDES MOUNTING BRACKET AND WIRES**

Item No.	Description	Application
A22618AE-522	BAEG/PC-PB/C12	3HP, 208/220/230-50/60-3
A22618AE-534	BAEG/PC-PB/E6	3HP, 440/460-60-3
A22618AE-536	BAEG/PC-PB/D8	3HP, 380/415-50-3
A22618AE-538	BAEG/PC-PB/F4	3HP, 550/575-60-3
A22618AE-540	BAEG/PC-PB/C23	5HP, 208/220/230-50/60-3
A22618AE-544	BAEG/PC-PB/E12	5HP, 440/460-60-3
A22618AE-546	BAEG/PC-PB/D12	5HP, 380/415-50-3
A22618AE-548	BAEG/PC-PB/F8	5HP, 550/575-60-3

**AEG
WATERTIGHT MAGNETIC
SWITCH ASSEMBLY**



A16226A-SG

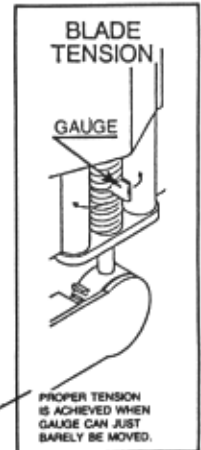
Item No.	Description	Item No.	Description
A16226A-SG	Green/red switch button assembly	226AE-F0	Contactors, SP17.10-F0, 550V
HHS070S	Hex head screw, 3/8-16 x 1 SS	226AE-506	BAEG/PC-PB/C6
HN05S	Hex nut, 8-32 SS	226AE-514	BAEG/PC-PB/C8
LW03S	Lock washer, #8 SS	226AE-516	BAEG/PC-PB/E4
LW25S	Lock washer, 3/8 heavy SS	226AE-518	BAEG/PC-PB/D6
RHS075S	Round head screw, 8-32 x 3/4 SS	226AE-520	BAEG/PC-PB/A23
16296-2	Switch bracket SS	226AE-522	BAEG/PC-PB/C12
151	Watertight conduit	226AE-524	BAEG/PC-PB/A32
224-1	Conduit connector, WT, 180°	226AE-526	BAEG/PC-PB/C17
226AE-ENCL-PB	Enclosure with button holes	226AE-530	BAEG/PC-PB/F.28
226AE-0L02H	Overload, B17S-H (1.8-2.8)	226AE-534	BAEG/PC-PB/E6
226AE-0L04I	Overload, B17S-I (2.8-4)	226AE-536	BAEG/PC-PB/D8
226AE-0L06K	Overload, B17S-K (4.6)	226AE-538	BAEG/PC-PB/F4
226AE-0L08L	Overload, B17S-L (5.6-8)	226AE-540	BAEG/PC-PB/C23
226AE-0L12M	Overload, B17S-M (8-12)	226AE-543	BAEG/PC-PB/E8
226AE-0L17N	Overload, B17S-N (11-17)	226AE-546	BAEG/PC-PB/D12
226AE-0L23O	Overload, B17S-O (15-23)	226AE-548	BAEG/PC-PB/F8
226AE-0L32P	Overload, B17S-P (22-32)	226-28	Washer, 1 1/2 x 27/32 SS
226AE-A0	Contactors, SP17.10-A0, 110V	241BL	Wire, black, 12 GA., CSA & UL
226AE-C0	Contactors, SP17.10-C0, 208/220/230V	241GR	Wire, green, 12 GA., CSA & UL
226AE-D0	Contactors, SP17.10-D0, 380/415V	241RD	Wire, red, 12 GA., CSA & UL
226AE-E0	Contactors, SP17.10-E0, 440V	241WH	Wire, white, 12 GA., CSA & UL

WARNING LABEL LOCATIONS ON MACHINE



ATTACHED TO SAW GUARD
ON SAW GUIDE BAR

P/N 708 "DANGER EXPOSED
BLADE" DECAL



P/N 710 "BLADE
TENSION" DECAL
ATTACH TO HEAD
DOOR AS SHOWN



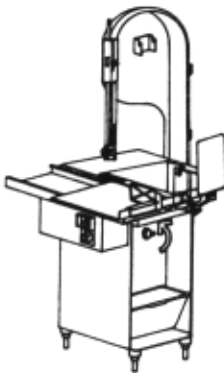
** This saw has been equipped with a "REMOVABLE" lower wheel **

ATTENTION: ELECTRICIAN / SERVICE TECHNICIAN
** READ FIRST BEFORE STARTING POWER CUTTER **

IMPORTANT

This saw has been electrically tested at the factory, but electrical phasing for proper rotation may not match your electrical supply.

WITH LOWER SAW WHEEL REMOVED, check rotation of shaft. Rotation must be counterclockwise when facing shaft. Failure to confirm correct rotation could result in the wheel dislodging.



ATTACH TO HINGED
RIGHT BASE DOOR

P/N 16716 CAUTION LABEL
USE ON MACHINES WITH
REMOVABLE LOWER WHEEL

WARNING LABEL LOCATIONS ON MACHINE

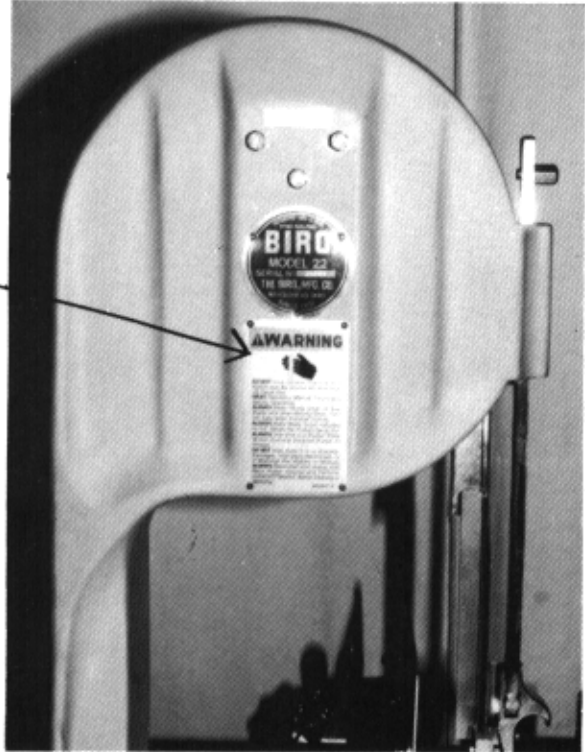


! WARNING

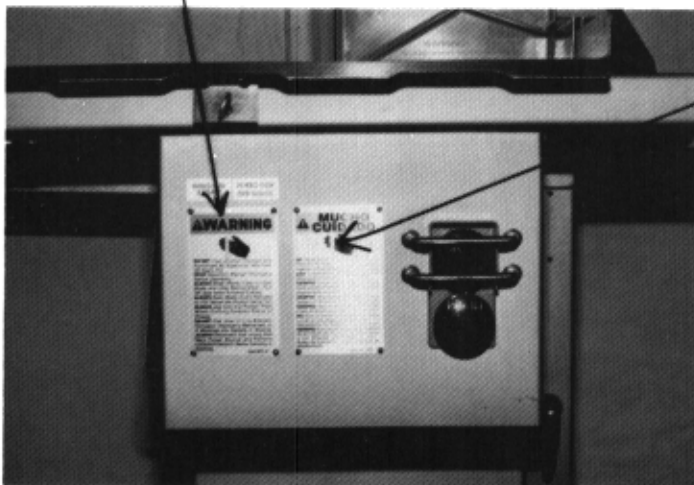
DO NOT Use Unless Trained and Authorized By Supervisor And Over 18 Years Old.
Read Operation Manual Thoroughly Before Operating.
ALWAYS Keep Hands Clear of Saw Blade and Other Moving Parts. Turn Off Saw when Finished Cutting.
ALWAYS Keep Blade Guard Adjusted to 1/2" Above the Product being Cut.
ALWAYS Use End Cut Pusher Plate When Cutting Smaller Piece of Product.
DO NOT Use Saw if it is Altered, Damaged, Improperly Maintained, or If Warnings Are Illegible or Missing.
ALWAYS Disconnect and Unplug from Main Power Source and Perform LOCKOUT/TAGOUT Before Cleaning or Servicing.

#653PC-E

Item No. 653PC-E



ATTACH ON HEAD STRUCTURE BELOW
MODEL/SERIAL NUMBER TAG



ATTACHED TO CHANNEL BRACKET NEXT TO
SWITCH CONTROL BUTTONS



! MUCHO CUIDADO

NO Opere Esta Sierra Sin Haber Sido Entrenado Para Ello Ni Tampoco Sin Autorizacion de un Supervisor. Uno Tiene que Haber Cumplido 18 Anos Para Operarla.
LEA Cuidadosamente el Manual de Operacion Antes de Usar Este Equipo.
SIEMPRE Guarde las Manos a Salvo de la Hoja de Serrar y de Otras Partes Moviles. Cirre el Interruptor Despues de Terminar de Cortar.
SIEMPRE Tenga Adjustado el Guardasierra Para que Quede a 1/2" Por Encima del Producto que se Corta.
SIEMPRE Haga Uso de la Placa de Empuje Para Cortes de Extremos al Cortar Trocitos Pequenos.
NO Utilice la Sierra si se Halla Alterada, Danadao si No ha Sido Debidamente Mantenido o si la Advertencia es Alegible o si Falta Esta.
SIEMPRE Desconecte el Equipo Decenchifandolo de la Fuente de Fuerza. Dejelo Bajo Llave o con Etiqueta que Prohiba su Uso Antes de Limpiarlo o Hacer Trabajos de Mantenimento.

#653PC-SP

Item No. 653PC-SP

MODEL 44 PARTS NUMBERS AND DESCRIPTIONS

SEND IN MODEL NO. AND SERIAL NO. WHEN ORDERING PARTS

MOTOR SECTION

Item No.	Description	Item No.	Description
M79-G56111-U	Motor, 3HP, 208/220/440-50/60-3 open	S268	Stationary bar headless screw, SS
M82-G65113-U	Motor, 3HP, 208/220/440-50/60-3 moisture resistant	S290	Cleaning unit stamping, SS
M88-G56215-U	Motor, 5HP, 220/440-60-3 moisture resistant	S295	Wheel cleaner arm, SS
M89-G56214-U	Motor, 5HP, 575-60-3 moisture resistant	S325	Wheel cleaner washer, SS
		S360CB-1	Carriage bolt, 3/8-16 x 1 1/4, SS
		S415D	Stainless stationary bar
		S416	Platter locator weld pin, SS
		10A	Ratchet arm taper pin
		11	Ratchet trigger, ORDER S11
		112-212	Waved washer, 2 1/64 x 5/8
		116-27	Saw guide bar, 27"
		119A	Saw guide in stationary bar
		119FSC	Saw guide in sta. bar, fish
		120E	Flat head screw, 5/16-18 x 2, SS
		130	Saw cleaner bracket, rear
		131	Saw cleaner, SS
		14TH	Head door hinge, welded
		14TP	Hinge pin, long, 1 1/2"
		14TP-1	Hinge pin, short, 1 1/4"
		16Z	Lower guide bracket saw cleaner holder
		16112	Head door latch
		16132	Saw cleaner brkt. holder, rear
		16155-13	Meat carriage stop angle
		16155-2A	Meat carriage guide, prior to EZ flow
		16155-2B	Carriage guide spacer, 1/64"
		16115-2C	Carriage guide spacer, 1/32"
		16159	Meat carriage bearing, SS
		16200	Carriage stop only, movable
		16220-1	Carriage stop only, fixed
		16296-2	Switch mtg. bracket, SS
		163A	Platter rod clip
		17211-22	Finger lift shim, .022"
		17211-35	Finger lift shim, .035"
		175-1-S	Thumb guard nut, SS
		175-2-S	Thumb screw, 1/4-20 x 1/2
		175S	Thumb guard, nylon
		177	Sta. bar nylon filler
		179	Wheel cleaner
		18001	Upper bearing spacer, prior to snap ring spacers
		18003	Lower wheel, 18"
		18003U	Upper wheel w/snap rings, 18"
		18005	Head, aluminum, ORDER AS18005
		18006	Head door, aluminum, ORDER A18006
		18007	Channel bracket to #3849
		18010	Ratchet arm
		18019	Ratchet base
		18111	Tension spring pin
		181155	Meat carriage, #3850 to #7989 ORDER 18115EZ-RPL
		18118	Tension spring plate
		18120B1	Carriage guide bar, to #3849
		18120B2	Carriage guide bar spacer, to #3849
		18120EZ-B3	Guide bar, EZ flow, T-shaped, #7990
		18154	Table extension
		18155-OS	Meat carriage top & angle, to #3849
		18163B	Platter neck guard
		18163L	Platter spacer channel strip, SS
		18196	Saw tension spring
		18197	Tension spring gauge
		18198	Cap for tension pin
		18212W	Platter rod
		18230DL	Upper shaft seal, double lip
		18231DL	Lower shaft seal, double lip
		18232	Scrap bucket
		18247	Upper shaft
		18248	Upper wheel hub cap
		18251AL	Upper v-belt pulley, 12.8 x 1 1/8"
		18252	Upper shaft lock nut
		18260	Slide gib, aluminum
		18272	Meat gauge gear rack
		18273	Meat gauge bracket, ORDER A18273
		18275	Meat gauge arm
		18275-5	Meat gauge plate, SS
		18280	Motor shaft key
		18300	Lower shaft woodruff key
		18301	Model & S/N plate, S/N required

Item No.	Description	Item No.	Description
18302	Saw blade, 135", 420	272-8	Cap nut, 5/16-18, SS
18302HT	Saw blade, 135", 322 hard tooth	272-9	Hex head screw, 5/16-18 x 2, SS
18305	Saw guide bar stop in head, to #4511	272-12	Brass ball, 7/32 dia.
18308	Babbitt pocket shield, to #4511	272-13	Hex head bolt, 5/16-18 x 1 1/4, SS
18311	Bumper for stops, to #3850	272-14	Castle nut, 5/16-18, SS
18313-105	Operating and Parts Manual	275THS	Truss head screw, 1/4-20 x 3/8
18335X	Upper wheel hinge plate	275THS-1	Truss head screw, 1/4-20 x 1
18360	Lower bearing housing	277	Lower shaft key
18361	Lower shaft	290-7	Cleaning unit locator
19CB	Ratchet base carriage bolt, 1/4-20 x 3/4, SS	290-8	Cleaning unit locator washer
193	Saw guide bar spring	290-8K	Cleaning unit locator kit
211	Finger lift bracket	299L	Saw guide bar stop, long, to #4510
211A-291Q	Finger lift fastener knob, 4 point, plastic	310	Waved washer
211D	Finger lift fastener stud, 3/8-16 x 1 3/4, SS	311	Bumper for fixed carriage stop
212CP	Platter rod cotter pin	311-1	Bumper for movable carriage stop
221-	V-belt *ADVISE SIZE*	324A	Motor shim, 1/8"
228-2	Lower guide washer	340	Star external lock washer
234	Grease fitting for upper wheel	360A1	Grease fitting
237	Upper shaft castellated lock nut	360B	Set screw, 3/8-16 x 1/2, flat point
238	Upper shaft castellated lock washer	360B-1	Set screw, 1/2-13 x 1/2, flat point
239-B30-1	Base foot, carbon, ORDER AS239-B30-B	362	Lower bearing housing adjusting cap
239-B31-2	Pipe leg, 6", aluminum	375	Drive screw for name plate
239-B32-AR	Pipe leg cap	376	Drive screw, 10 x 1/2, SS
240	Ratchet trigger spring, ORDER S240	4-40AL	Motor pulley, 5 x 1, 60 cycle
242R	Base door lock, right	4-50AL	Motor pulley, 6 x 1, 50 cycle
247A	Upper shaft washer	415D	Stationary bar
249	Base door handle	512	Upper wheel hub gasket
252X	Shaft lock nut	531	Upper wheel snap ring
256P	Safety end cut pusher plate, composition	601	Upper saw guide bracket
256PM	Safety end cut pusher plate, aluminum	602B	Upper saw guide
264-1	Meat gauge hand wheel	602AFSC	Upper saw guide, narrow, fish
264G	Meat gauge hand wheel groove pin	605	Lower blade back-up guide
265	Meat gauge release spring, ORDER S265	661-1	Saw guard on head door, to #4510
267	Meat gauge release cotter key	662	Saw guard w/708 for Stainless head, SS
270	Meat gauge release pin	663	Saw guard w/708 for Aluminum head, SS
271	Meat gauge worm gear	671	Wall poster, "BANDSAW SAFETY GUIDELINES"
272-6-S	Meat gauge wing nut	708	Decal "DANGER EXPOSED BLADE"
272-7-1	Lock knob, 5/16-18, 3 point	71-2	Upper wheel hinge bracket

COMPLETE ASSEMBLIES FOR MODEL 44

Item No.	Description	Item No.	Description
AS1120EZ	Channle assembly, EZ flow, SS	A16220-1	Carriage stop assembly, fixed
AS18005	Head E door assembly, SS	A16132	Saw cleaner assembly, rear
AS18006	Head door assembly, SS	A175S	Thumb guard assembly
AS290	Cleaning unit stamping assembly	A18003U	Upper wheel assembly w/o hinge plate
AS290-1	NOT SOLD AS ASSEMBLY	A18003U335	Upper wheel assembly w/hinge plate
AS415D	SS stationary bar assembly	A18006	Head door assembly, aluminum, to #4511
A112	Head door handle assembly, to #4511	A18019	Ratchet assembly
A116-27	Saw guide bar assembly, 27"	A181155	ORDER A18115EZ-RPL
A130	Saw cleaner assembly	A18115EZ	Meat carriage assembly, EZ flow, #7990 on
A16Z	Guide bracket saw cleaner assembly	A18115EZ-RPL	Meat carriage assembly, #3850 to #7989
A16112	Head door latch assembly, after #4511	A18155-OS	Meat carriage assembly, to #3850
A16200	Carriage stop assembly, movable	A18163	Stationary platter assembly
		A18196	Tension spring assembly

LIMITED WARRANTY

WARRANTY: The Biro Manufacturing Company warrants that Model 44 Power Cutter will be free from defects in material and workmanship under normal use and with recommended service. BIRO will replace defective parts, which are covered by this limited warranty, provided that the defective parts are authorized for return, shipping charges prepaid, to a designated factory for inspection and/or testing.

DURATION OF WARRANTY: The warranty period for all parts covered by this limited warranty is one (1) year from inspection/demonstration advised on the returned Warranty registration card, or eighteen (18) months from original factory ship date, whichever occurs first, except as noted below.

PARTS NOT COVERED BY WARRANTY: The following are **not** covered by this limited warranty: steel saw cleaners, item number 131; wheel cleaners, item number 179; steel guide, item number 119A; upper saw guide, item number 602B; lower back guide, item number 605; nylon filler, item number 177. This limited warranty does not apply to machines sold as used, rebuilt, modified, or altered from the original construction in which the machine was shipped from the factory. (Water contaminated electrical systems are not covered under this limited warranty.) BIRO is not responsible for electrical connection of equipment, adjustments to switch gear or any other electrical requirements, which must be performed only by a certified electrician. BIRO is not responsible for service charges or labor required to replace any part covered by this limited warranty or for any damages resulting from misuse, abuse, lack of proper or recommended service.

EXCLUSION OF WARRANTIES AND LIMITATION OF REMEDIES: BIRO gives no warranties other than those expressly stated in this limited warranty. THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR PROCESSING OF FOOD PRODUCTS, AND ALL OTHER IMPLIED WARRANTIES ARE SPECIFICALLY EXCLUDED. BIRO IS NOT LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES, EXPENSES, OR LOSSES. THE REMEDIES PROVIDED IN THIS BIRO LIMITED WARRANTY ARE PURCHASER'S SOLE AND EXCLUSIVE REMEDIES AGAINST BIRO.

REGISTRATION CARDS: You must sign, date and complete the warranty card supplied with each machine. The warranty card must be returned to The BIRO Manufacturing Company for proper registration. If no warranty card is returned to BIRO, the warranty period will begin from the date the machine was originally shipped from the factory.

HOW TO GET SERVICE:

1. Contact the agency from whom you purchased the machine.
2. Consult the yellow pages of the phone directory for the nearest authorized dealer.
3. Or call BIRO Service Department (419) 798-4451 which will put you in contact with the nearest service agency.