



ROCKWELL
MANUFACTURING COMPANY
PITTSBURGH 8, PENNSYLVANIA



40-100 HOMECRAFT 16" SCROLL SAW

The Delta Homecraft 16" Scroll Saw is designed for cutting wood, plastics, light metal sheets and similar materials in the home workshop. Because of the ability to cut curves and sharp corners, it is a handy tool for cutting designs and patterns in model making and for the construction of furniture, toys and ornamental objects of great variety.

Maximum thickness which can be cut is 2 inches. The saw will cut to the center of a 32 inch circle. For cuts greater in length than permitted by the 16 inch throat, the chucks can be turned 90 degrees so that unlimited lengths may be cut from the side of the machine. The table tilts 45 degrees to the right and 15 degrees to the left. The lower universal chuck accommodates files and sanding attachments with a shank up to 1/4-inch diameter, as well as the standard jeweler's and saber blades.

Your machine is complete with a removable table insert, 4-inch drive shaft pulley No. 5400, pulley guard, blade guard, dust blower, three assorted saw blades, Cat. No. 92, 95, 65, and wrenches. Motor, drive belt and motor pulley are available, but must be ordered separately to meet individual requirements.

CONSTRUCTION FEATURES

The crank shaft may be run in either direction, as the reciprocating motion of the lower plunger is the same either way.

One of the features of this scroll saw is the upper plunger mechanism, which automatically provides the correct blade tension at all times and provides air for dust blower.

MOTOR AND PULLEYS

We recommend a Delta Cat. No. 60-013, or 62-413, 1/3 hp, 1725 rpm motor for use on your 16" Scroll Saw.

The scroll saw should operate at a maximum speed of 1300 cutting strokes per minute, a rate which is suitable for most operations on wood, plastics and similar materials. This speed is obtained with 1725 rpm motors by using the 3-inch motor pulley No. 5300-A in connection with the 4-inch drive shaft pulley which is furnished on the machine.

Metal cutting and filing is done more effectively at lower speed, namely 900 strokes per minute. To obtain this rate from a 1725 rpm motor, use the 2-inch motor pulley No. 5200-A.

The standard single speed scroll saw can be converted into a versatile four speed model and greatly increase its job performance. By using No. 720 four step arbor pulley, which will replace single pulley furnished with machine, and No. 718 four step motor

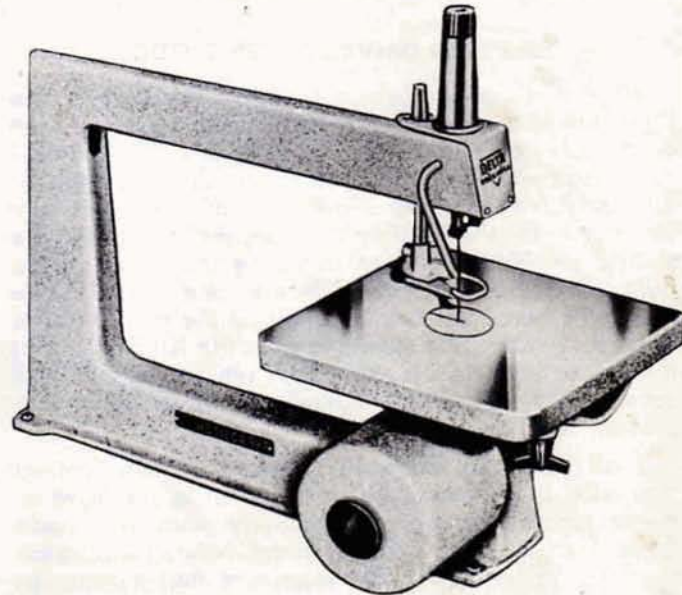


Figure 1. Delta Homecraft 16" Scroll Saw

pulley, speeds of 650, 1000, 1300 and 1725 RPM will be obtained.

POWER CONNECTIONS

Before connecting the motor to the power line, be sure that the electric current is of the same characteristics as stamped on the motor name plate.

MOUNTING SAW AND MOTOR

In choosing a location for the machine, be sure to allow clearance to the right and the left of the table for long cuts from the side, and downward to the right for work which projects beyond the table when tilted 45 degrees.

Mount the machine on a Delta No. 50-717 stand or suitable work bench. Most operators will find the best table height between 40 and 42 inches.

Locate the motor to the side of saw or on a shelf below the bench, whichever is convenient. In the latter case, run the belt through a slot in the bench top, or arrange the machine and motor so that the pulleys extend beyond the edge.

Fasten the saw to the bench top, using 5/16-inch bolts of proper length through the mounting holes in the four corners of the base. Install the motor pulley and drive belt.

When the motor is mounted on Delta steel stand, use (4) 5/16 x 2" round head stove bolts. Place bolt through

stand from bottom and fasten in place with hexagon nut. Place another hexagon nut on bolt, then motor base, then another hexagon nut on stove bolt, as shown in sketch "A" Figure 6.

Motor can be raised or lowered for proper belt tension by adjusting the hexagon nuts. After proper adjustment has been made, tighten all hexagon nuts to hold motor in place.

Locate the motor so that the pulleys are in line, with the shafts parallel and the belt just tight enough to prevent slipping. Avoid excessive belt tension. The correct tension is such that the belt can be flexed about one inch midway between pulleys, using finger pressure.

SHIFTING DRIVE TO RIGHT SIDE

When it is more convenient to have the drive on the right side of the machine, remove and interchange the crank case covers, (Key 13) and (Key 26), Fig. 6. Rotate the cross head (Key 15), by turning the lower plunger tube (Key 2) through 180 degrees. Be sure that the crank pin of the drive shaft (Key 25) engages the hole in the sliding pin (Key 18) when installing the cover on the right side of the crank case. Likewise, see that the guide groove of the cover (Key 26) engages the projections of the cross head when installing it on the left side. Insert the paper gaskets (Key 31) between the crank case covers, and tighten the mounting screws enough to prevent leakage of oil.

If all parts are properly installed in their correct sequence, in reverse of the order shown in the drawing, the machine will operate properly with right-hand drive. Turn the drive shaft by hand, before running the machine under power, to make sure that it operates freely.

The pulley guard (Key 27) can not be used on the right side of the machine, as it is designed for left side installation only. A suitable guard for the right hand pulley drive may easily be made of sheet metal and attached by flanges which fit under the heads of the cover plate screws.

LUBRICATION

Before operating the scroll saw, check the supply of oil in the crank case. Remove the oil filler plug (Key 32) from the cover (Key 26) and add SAE-30 machine oil to bring the level up to the hole. All parts of the mechanism in the crank case, including the drive shaft bearings and lower plunger, are constantly lubricated by splash from the eccentric counterbalance. Check frequently and keep the supply up to the level of the oil hole.

Lubricate the upper plunger occasionally by applying a few drops of oil into the hole in the safety cap (Key 33) at the top of the plunger casing. Oil the trunnions and other adjustable parts lightly from time to time, to keep them operating freely. Wipe the table surface with an oily cloth to prevent rusting.

OPERATING ADJUSTMENTS

Inserting Blades

Move the blade guide (Key 21) back as far as possible, remove the table insert and turn the drive shaft pulley until the lower plunger comes up to a con-

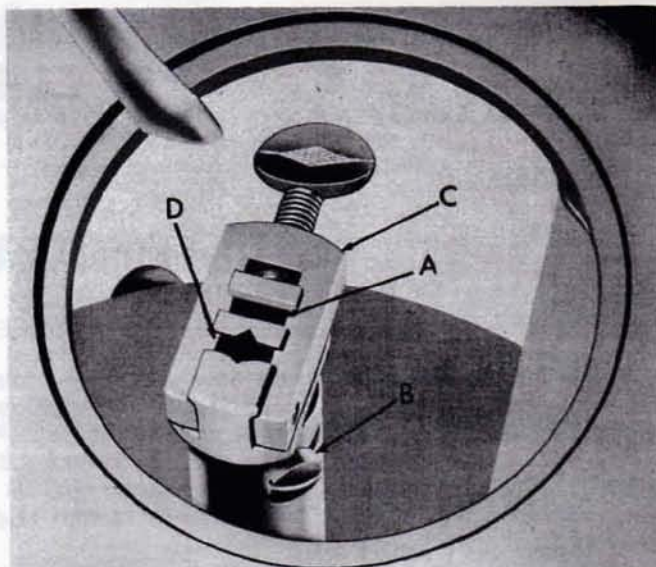


Figure 2. Lower Universal Chuck, Showing Flat and V-Jaws.

venient position. Release the lower chuck thumb screw (Key 10), insert the blade about 1/2 inch into the flat jaws, and 90 degrees to the table, (A) Fig. 2, and tighten the thumb screw. Be sure that the teeth of the blade point downward, and that the end of the blade is centered in the chuck.

Loosen the upper chuck thumb screw (Key 56), pull the upper plunger down and enter the blade about 1/2 inch into the flat jaws of the upper chuck, at the same time tightening the upper thumb screw.

Turn the drive by hand before starting the motor, to make sure that the blade is properly clamped and that the machine operates freely.

LEVELING THE TABLE

Square cuts are made with the table at right angles to the saw blade. Use a small mechanics' square or an accurately cut block to check the relation. Release the knob (Key 72) below the table, adjust table until the legs of the square are flat against the table and blade, and tighten the knob. Set pointer (Key 47) to read zero on the tilt scale (Key 29) while the table is clamped in this position.

TILTING THE TABLE

For angle sawing, loosen the knob and tilt the table until the pointer indicates the required angle on the scale. Tighten the knob moderately.

UPPER CHUCK ADJUSTMENTS

The normal position of the upper chuck, when cutting from the front of the machine, is with the thumb screw (Key 56) to the right, so that it will not strike the table when tilted 45 degrees to the right.

When cutting from either side of the machine, back out the headless set screw (Key 61) from the right side of the upper frame arm and rotate the entire upper plunger casing 90 degrees clockwise, so that the thumb screw of the upper chuck points forward. Tighten the set screw to hold the casing in this new position.

Conical holes are countersunk into the body of the casing (Key 28) at two points 90 degrees apart, to receive the point of the set screw for locating the

upper plunger and chuck accurately in these two operating positions.

The chuck may be reversed on the upper plunger tube, by removing the screws (Key 4) and (Key 56), and re-assembling with the thumb screw to the left. The thumb screw will then be to the rear for side cutting. This is the proper arrangement when the drive pulley has been shifted to the right side of the machine.

LOWER CHUCK ADJUSTMENTS

Normal position of the lower chuck, when cutting from the front of the machine, is with the thumb screw (Key 10) to the left. This arrangement gives proper clearance when the table is tilted to the right.

When cutting from the side of the machine, loosen the small fillister head cap screw (Key 4), (B) Fig. 2, which is threaded through the slot of the lower plunger tube (Key 2) and rotate the lower chuck body, (C) Fig. 2, 90 degrees so that the thumb screw is to the rear. Tighten the cap screw to hold the chuck in this new position.

The lower chuck body has four tapped holes, equally spaced around its circumference, to receive the cap screw. The chuck is therefore easily shifted to the most convenient position. The purpose of the slot in the plunger is to control the two commonly used positions 90 degrees apart.

BLADE GUIDE

Blades must be supported from the rear and held in line to prevent excessive bending while cutting. Accurate work with thin blades, and minimum breakage, depend upon proper adjustment of the guide.

The guide (Key 21), furnished on the machine, has three slots which are arranged to support the blade when cutting from the front or either side. The V-shape accommodates blades of various thicknesses.

A hexagon head cap screw (Key 66) holds the guide to the bottom of the bracket (Key 23) at the lower end of the guide post (Key 24). To adjust the guide, loosen this screw, using the box wrench (Key 77). Loosen the holddown spring (Key 58), if necessary, for clearance. The bottom of the bracket is formed to engage the forked body of the guide, permitting adjustment forward but preventing rotation.

Having clamped the blade in the chucks, for cutting from the front of the machine, bring the guide forward until the V-slot barely touches the rear edge of the blade, and tighten the cap screw. The blade should not rub in the slot when running free; excessive friction work-hardens the back edge of the blade and reduces blade life. Pressure of the work will push the blade back against the guide while cutting.

When cutting from the side, loosen the headless set screw (Key 60) and turn the bracket (Key 23) slightly on the guide post to bring the side slot of the blade guide against the back of the blade. At the same time, move the guide forward to bring the slot into line. Tighten both screws, (Key 60) and (Key 66) before starting work.

If the blade is vertical, it will run true in the slot throughout its stroke. Check the adjustment, turning the machine by hand, before starting the motor. Care in making these adjustments, which take only a few min-

utes, is compensated in successful operation.

HOLDDOWN SPRING

The purpose of the holddown spring (Key 58) is to hold the work against the table so that it cannot lift with the up-stroke of the blade. It should lie flat on the work with the front prongs straddling the blade. To adjust, loosen the cap screw (Key 65) on the rear of the bracket (Key 23), lower the guide post until the holddown rests on the table, and tighten the cap screw.

GUIDE POST

Adjustment of the blade guide and holddown according to the thickness of the work is made by raising or lowering the guide post (Key 24). The keyway of the post prevents rotation, preserving the alignment of the blade guide. The thumb screw (Key 40), in the right side of the upper frame, clamps the guide post.

The holddown and blade guide should always be brought down as close to the work as possible, to give the blade maximum support. Maximum capacity under the holddown is 2 inches; this is determined by the highest position which will clear the upper plunger at the bottom of its 1-inch working stroke, rather than the upper limit of the guide post. Thickness which can be cut with the table tilted is, of course, less.

DUST BLOWER

The air nozzle may be moved as required to direct the air stream to the most effective point on the cutting line. The nozzle may be swung back, out of the way while adjusting the blade guide and holddown.

BLADE GUARD

The guard should be kept in place whenever possible. It is easily removed when changing blades, for clearance when using the sanding attachment.

SCROLL SAW BLADES AND FILES

This scroll saw will take jeweler's blades 5 inch long, of any width up to 1/4 inch, which is the capacity of the flat chuck jaws. If longer blades are on hand they may be cut to 5-inch lengths and used successfully by flattening the ends. Pin blades may be used after driving the pins out. A wide selection of blades is available for this machine. See Delta catalog.

Standard saber blades for this machine are 5 inch long. Two widths, 3/16 and 1/4-inch, are offered.

Files for this scroll saw are 3 3/8 inches long. They are available in various shapes, with 1/8 and 1/4-inch shanks, as illustrated in Fig. 3 and 4.



Figure 3. Machine Files With 1/8-inch Shank.

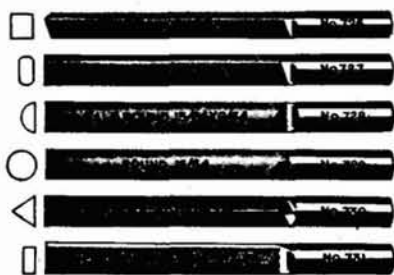


Figure 4. Machine Files With 1/4-Inch Shank.

Each size and style of blade and file is designed for a definite purpose. The small cost of additional tools is justified when various kinds of work are to be done in some quantity, especially when good results are expected. Consult your Delta dealer for information about the various blades and files to meet your requirements.

It is a mistake to use a dull or injured blade. When the blade no longer cuts freely, excessive pressure is needed to force it through the work. This increases the drag on the mechanism and motor, resulting in excessive wear. For accurate work and longer life of the machine discard dull blades and use new ones.

MAINTENANCE

To remove the drive shaft, take off the pulley and the set collar (Key 49). Also remove the cover (Key 13) from the left side of the crank case. The drive shaft may then be withdrawn from its bushings. When installing the shaft, be sure to insert the steel washer (Key 19) between the counterbalance and flanged bushing, and take up end play by means of the set collar in contact with the opposite bushing.

When the bearings and drive shaft need replacement a new cover (Key 13), can be furnished complete with bushings line reamed. Also order a new drive shaft (Key 25). These parts will restore the drive to its original condition. The bushings are also furnished separately.

Any unusual vibration or rattling noise in the crankcase should be investigated immediately, and the machine should not be operated until the cause has been corrected. The first check should be of the oil level. If lack of oil is not the cause, the noisy condition may be due to loosening of the cross head (Key 15) on the lower plunger tube. Remove crankcase cover (Key 26) from the right side of the machine and check whether the cross head is tight on the tube. In rare instances, the hexagon socket screw (Key 17) may loosen, permitting the dog point screw (Key 16) to back out. Turn this screw tight, making sure that the dog point engages the hole in the tube, and lock it securely by jamming the second screw against it. If this is not the cause of the trouble, investigate working parts for excessive wear; it may be necessary to replace the cross head (Key 15), sliding pin (Key 18) and drive shaft with crank pin (Key 25).

SCROLL SAW OPERATIONS

The following directions will give the inexperienced

operator a start on the usual scroll saw operations. Use scrap material for practice, to get the feel of the machine before attempting regular work.

Place the table insert with its slot back of the blade, so that the solid part of the insert is always in front, where it is needed to support the work. The center of the insert coincides with the line of the blade in all positions.

Turn the machine by hand, to make sure that all parts have clearance, before starting the motor. Always bring the blade guide down as far as the thickness of the work will permit, for maximum blade support.

CUTTING WITH JEWELER'S BLADES

Installation of jeweler's blades has been described above, as a necessary preliminary to operating adjustments.

Jeweler's blades are available in various widths and tooth spacings, according to the purpose for which they are designed. Wide blades are for straight or slightly curved cuts; the narrow ones are for sharp curves. Minimum radius of the curve depends upon the amount of tooth set in relation to thickness and width of the blade, as the back of the blade must run to one side of the saw kerf. Do not try to force the blade around a curve sharper than it is intended to cut smoothly; rather cut a series of short segments and finish to the correct curve by sanding or filing.

Tooth spacing is important in relation to the kind of material and thickness to be cut. Several teeth should be in the cut at all times. Coarse blades are for use on relatively thick pieces of wood and other soft materials. Blades with closely spaced teeth should be used when cutting thin metal sheets or tubes.

When cutting very thin materials, there is a tendency for the saw teeth to strike on the edge of the work because only one tooth may be in the cut at a time. This results in chatter and frequent blade breakage. Feeding the work slowly and carefully improves the operation, but it is best to sandwich the thin sheet between two pieces of thicker waste material, thus presenting a more substantial edge to the blade. This method gives a smoother cut and less burr on the thin sheet; also longer blade life.

USE OF SABER BLADES

Saber blades are clamped in the V-jaws, (D) Fig. 2, of the lower chuck, rather than in the flat jaws. The normal position of the lower chuck is therefore correct for cutting from the side of the machine. When cutting from the front, turn the chuck so that the thumb screw is to the rear.

The blade guide must be used to support the upper end of the saber blade. Adjustments for correct position of the V-slot are the same as for jeweler's blades.

Since the upper chuck is not used with saber blades, the upper plunger remains at the top of its stroke, out of the way. The blade guide should, however, be set no higher than about 1/4 inch below the upper end of the blade at the lower end of the stroke.

Saber blades are necessarily wider and heavier than the fine jeweler's blades. Because of their more rapid cutting action they should be used for the majority of scroll saw operations. They offer a distinct advantage in the case of shifting from one opening to another in pierced work and in connection with odd-shaped pieces which can not be run under the upper plunger when using jeweler's blades.

FILING

Insert the file in the V-jaws (D) Fig. 2, of the lower chuck. When cutting from the front of the machine, turn the chuck so that the thumb screw is toward the front; pressure of the work will then be against the solid back of the chuck. Move the guide post up to the top of its travel, so that the guide and holddown are out of the way.

Only the smaller files will pass through the slot of the table insert. An extra insert with a hole large enough to take the largest file may be made of sheet metal. Another good method is to use a piece of plywood with a closely fitting bored hole, clamped to the top of the table.

Some machine files are not perfectly straight, and they may not line up square with the table. In the case of a round or square file this can often be adjusted by turning the file in the chuck. If a square position cannot be found, it is best to work from the side of the machine and tilt the table slightly so that it is square with the file.

SANDING

The sanding attachment No. 711, has a 1/4-inch shank so that it may be clamped in the lower chuck in the same manner as the machine files. It is useful for finishing the edges of work which has been cut on the scroll saw or band saw. The combination of a curved and a flat face, with fairly sharp edges, makes it possible to do accurate sanding of various patterns, saving tedious hand work.

Medium and fine grained sanding sleeves are available to fit this attachment. The knurled knob controls the expanding body, making the sleeves instantly interchangeable and holding them securely when tightened.

Slow speed, 900 strokes per minute, should be used for sanding operations. The blade guide, holddown spring and blade guard must be removed for clearance. The standard table insert should be replaced by a special insert, cut out to the shape of the sander, or a plywood table top with suitable fitted hole.

RIPPING

While intended primarily for free-hand cutting of curved designs, the scroll saw can be used within reasonable limits for ripping, as with a circular saw. An effective rip fence may be made by clamping a straight edge on the table, parallel to the saw blade. Material can be ripped straight by feeding it along the fence. This is a useful procedure in preparing stock, such as plywood or plastic sheets, for various projects, and may be applied where portions of the design call



Figure 5. Individual Blade Guides With Rectangular Blade Slots.

for straight cuts. The fence is also a handy guide when set at right angles to the blade for cutting thin tubes square.

CUTTING CIRCLES

Circles may be cut with the scroll saw by means of a circle jig. Clamp a plywood sheet on the table, as an auxiliary top. Use a pin through the plywood as the center of the circle. The pin should be on a line drawn at right angles to the flat of the blade even with the teeth, and its distance from the blade should be equal to the radius of the desired circle. Drill a hole in the work piece to fit the pin, and rotate the piece on the pin while cutting the circle.

USE OF SPECIAL BLADE GUIDES

The blade guide with 90-degree V-slots will handle practically any blade and is satisfactory for most purposes. Many operators prefer, however, to use sets of special guides with rectangular notches to fit each blade thickness. The set of six guides, No. 40-805, offered for use with this machine, is shown in Fig. 5.

In using these special guides, the operator selects the one which best fits the blade, allowing just enough slot width for free action. The guide is mounted on the bracket, in place of the standard guide. The sides of these rectangular slots offer greater support to the blade than is given by the V-slot, holding it true in the cut and reducing weaving to a minimum. These special guides are therefore valuable in the most accurate scroll saw work.

SELF-CENTERING LOWER CHUCK

The self-centering lower chuck, No. 715, is handy for clamping very fine blades. It is easily attached to the lower plunger tube, in place of the standard lower universal chuck.

LAMP ATTACHMENT

The mounting bracket of the lamp attachment can be mounted on the right hand side of the scroll saw head. Two tapped holes are provided and bracket is mounted with two No. 10-32 x 1/2 round head machine screws.

ACCESSORIES AND TOOLS

Consult your Delta dealer for additional information about the scroll saw accessories and tools, such as blades, files, abrasive sleeves, guides and chucks which will make this machine most useful to you.

Remember that the cutting tool does the work; the scroll saw merely drives the tool. Good results can be obtained only with sharp tools of the right kind.

How to Select and Use the Right Scroll-Saw Blade

When compared casually with one another, many blades look so much alike that the average person mistakenly thinks them to be the same. Actually, there is a great difference in how they cut — in the number of teeth per inch, the set of the teeth, the thickness of the blade and its width.

On this page is a complete guide you can follow in selecting the proper scroll-saw blades.

The table below recommends — by blade number — the blade you should use to cut various materials. And it gives the speed at which you should run the scroll saw to do the best job.

The recommendations given are average recommendations. You will find that there are differences in material and for different thicknesses or even for the variation in the material itself, different blades should be chosen to do the best cutting job. In almost all cases, however, the blades shown here and recommended are the blades that will give you the finest cuts possible when run at the proper speeds. It may be necessary if you do run across variations to do a little experimenting with the speed at which the saw is run and also in the blade itself.

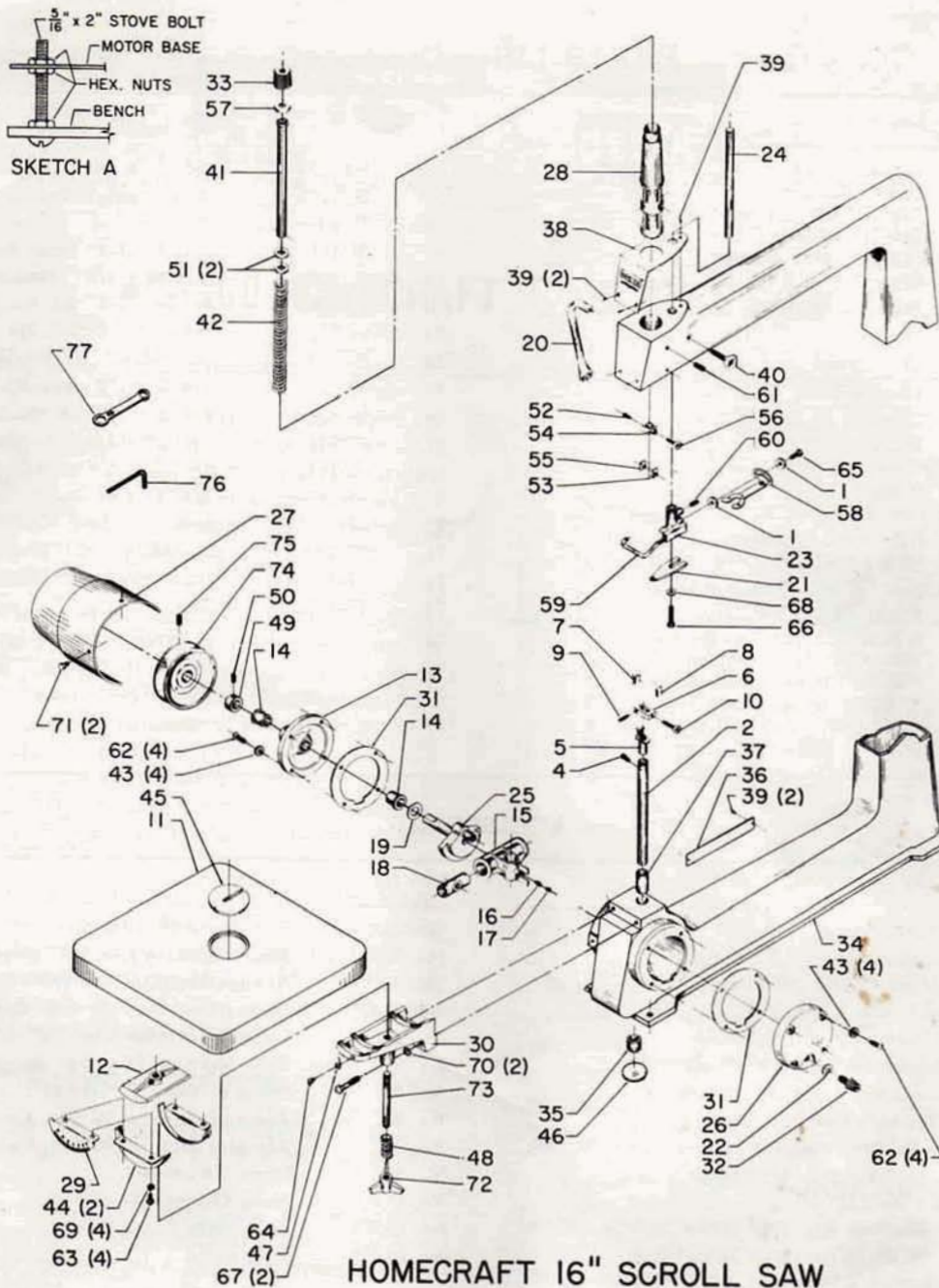
We suggest that you keep this page, as a handy aid in selecting and using the right scroll-saw blade for your job.

Below are full-sized profiles of Delta Scroll-Saw Blades. Blade number, dimensions, and number of teeth per inch are given for each.

MATERIAL TO BE CUT	SPEED	THICKNESS OF MATERIAL TO BE CUT							
		Up to 1/4	1/4 to 1/4	1/4 to 1/4	1/4 to 1/2	1/2 to 1/4	1/2 to 1/2	1/2 to Cap. of Saw	1/4 to Cap. of Saw
ALUMINUM, BRASS	SLOW	58 95 96	64 59	98	65	60	91		
COPPER	SLOW	58	59 64	65	65	91	91		
SILVER, GOLD	MEDIUM	95	96	98					
LEAD, PEWTER	SLOW	58	59 64	65	65	60	91		
SHEET IRON, MILD STEEL	SLOW	58	59 64	65		60			
ASBESTOS	MEDIUM	58	59 64	65	65	60	65		
BAKELITE CELLULOID PLASTICS	SLOW	84	83	82	85	86 81	86 81		88
LAM'D PLASTICS FIBERTEX MICARTA	SLOW					91	91	91 to 1"	92 to 1" 94 to 2"
IVORY	SLOW	84	83	82	85	86 81	86 81		88
BONE	SLOW					91	91	91 to 2"	91 to 2"
PEARL	MEDIUM	95 96	96	98					
BRAKE LINING	SLOW		65	65	65	65	65		
MICA	MEDIUM	95	96	98	65	65	65		
FELT	SLOW	58	59			91	91	91	91
HARD LEATHER	MEDIUM	95	96	98		98			
HARD RUBBER	SLOW	84	82	85	85	81 86	81 86		88
INLAYS	SLOW	84	83						
VENEER	FAST	84							
PRESSED WOOD PLYWOOD WALL BOARD	FAST	96	77 98	77 98		91	91	703 92, 704	92, 703 94, 704
HARDWOOD	MEDIUM	84	82	82		91	91	91 to 1" 92	92 94
SOFTWOOD	FAST	84	83			91, 703 704	91, 703 704	91, 703 92, 704	94
PAPER	FAST	58	59			91	91	91	91

SPEEDS: SLOW, 650 to 900 R.P.M.—MEDIUM, 900 TO 1300 R.P.M.—FAST, 1300 TO 1750 R.P.M.

Pkg. No.	Thick-ness	Width	No. of teeth per inch
58	.020	.070	32
59	.020	0.70	20
60	.020	0.70	15
61	.020	.085	15
64	.020	.110	20
65	.028	.250	20
77	.010	.048	18
81	.010	.070	14
82	.010	.055	16
83	.010	.045	18
84	.008	.035	20
85	.019	.050	15
86	.019	.055	12
87	.020	.070	7
88	.020	.110	7
91	.020	.110	15
92	.020	.110	10
93	.028	.187	10
94	.028	.250	7
95	.016	.054	30
96	.016	.054	20
97	.020	.070	15
98	.020	.085	12
703	.025	.187	9
704	.035	.250	7



HOME-CRAFT 16" SCROLL SAW

Figure 6

PARTS LIST

Key No.	Part No.	Description	Key No.	Part No.	Description
1	DDL-256	Steel Washer	18	HSS-510	Cross Head Pin
2	DSS-21-S	Lower Plunger, Including:	19	HSS-513	Steel Washer
X		DSS-23 Cork Plug	20	HSS-525	Air Nozzle
X	DSS-326-R	Chuck, Consisting of:	21	HSS-528	Saw Blade Guide
4		DSS-51 Fil. Hd. Cap Screw	22	HSS-535	Washer
5		DSS-326 Lower Chuck Body	23	HSS-541	Upper Saw Guide Bracket
6		DSS-327 Lower Chuck Clamp	24	HSS-542	Saw Guide Post
7		DSS-328 Grooved Jaw	25	HSS-544-S	Drive Shaft with Counterbalance
8		DSS-329 Plain Jaw	26	HSS-802-R	Crankcase Cover
9		DSS-330 Clamp Pin	27	HSS-803-R	Pulley Guard
10		SP-1543 No. 10-32 x 5/8" Thumb Screw	28	HSS-805	Upper Plunger Housing
11	HSS-502-R	Table	29	HSS-807	Tilt Scale
12	HSS-504-3	Trunnion Clamp	30	HSS-811-R	Trunnion Bracket
13	HSS-505-A3	Housing, Including:	31	HSS-813	Gasket
14		HSS-512 Bronze Bushing	32	HSS-814	Oil Filler Plug
15	HSS-507-S	Cross Head, Including:	33	HSS-817	Safety Cap
16		NSS-274 Screw			
17		SP-276 1/4-28 x 1/8" Set Screw			

PARTS LIST (Continued)

Key No.	Part No.	Description	Key No.	Part No.	Description
34	HSS-820-R	Frame, Including:	57	NSS-262	Rubber Washer
35		DSS-9 Bushing	58	NSS-305	Hold Down Spring
36		HDP-133 Nameplate	59	NSS-308	Blade Guard
37		HSS-515 Bushing	60	SP-102	1/4-20 x 3/8" Headless Set Screw
38		HSS-819 Nameplate	61	SP-106	5/16-18 x 1/2" Headless Set Screw
39		SP-2252 No. 2 x 3/16" Drive Screw	62	SP-509	1/4-20 x 1/2" Rd. Hd. Mach. Screw
40	HSS-821	Thumb Screw	63	SP-514	1/4-20 x 3/8" Rd. Hd. Mach. Screw
41	HSS-822-S	Plunger	64	SP-569	No 8-32 x 3/16" Rd. Hd. Mach. Screw
42	HSS-823	Coil Spring	65	SP-611	1/4-20 x 1/2" Hex. Hd. Cap Screw
43	HSS-824	Fiber Washer	66	SP-655	1/4-28 x 1" Hex. Hd. Cap Screw
44	LBS-52	Trunnion	67	SP-711	5/16-18 x 1 1/4" Fil. Hd. Mach. Screw
45	LBS-56	Insert	68	SP-1603	1/4" Steel Washer
46	LBS-222	Expansion Plug	69	SP-1702	1/4" Lockwasher
47	MH-3417-1	Pointer	70	SP-1752	5/16" Int. Tooth Lockwasher
48	NCS-33	Coil Spring	71	SP-2309	No. 10-24 x 3/8" Hex. Hd. Mach. Screw
49	NCS-35-S	Set Collar, Including:	72	SP-3610	Handknob
50		SP-205 5/16-18 x 1/4" Set Screw	73	SP-4155	Stud
51	NSS-254	Square Hole Fiber Washer	74	No. 5400-B	Pulley, Including:
X	NSS-258-R	Upper Chuck, Consisting of:	75		SP-201 5/16-18 x 5/16" Set Screw
52		DSS-51 Fil. Hd. Cap Screw	76	Cat. No. 194	Hex. Wrench
53		NSS-257-S Jaw with Pin	77	Cat. No. 1526	Wrench
54		NSS-258 Upper Chuck Body			
55		NSS-259 Upper Chuck jaw			
56		SP-1542 No. 10-32 x 1/2" Thumb Screw			

X Not Shown

ACCESSORIES

Part No.	Description	Part No.	Description
No. 711	Sanding Attachment	No. 753	Half Round Machine File, 1/8" Shank
No. 715	Self Centering Lower Jaw Chuck	No. 754	Round Machine File, 1/8" Shank
No. 718	4-Step Motor Pulley, 1/2" Bore	No. 755	Triangle Machine File, 1/8" Shank
No. 720	4-Step Arbor Pulley, 5/8" Bore	No. 756	Oblong Machine File, 1/8" Shank
No. 726	Square Machine File, 1/4" Shank	No. 757	Lozenge Machine File, 1/8" Shank
No. 727	Crochet Machine File, 1/4" Shank	No. 758	Knife Machine File, 1/8" Shank
No. 728	Half Round Machine File, 1/4" Shank	No. 760	Set of 8 Files, 1/8" Shank
No. 729	Round Machine File, 1/4" Shank	No. 841	Abrasive Sleeves, 50 Grit, Package of 6
No. 730	Triangle Machine File, 1/4" Shank	No. 842	Abrasive Sleeves, 80 Grit, Package of 6
No. 731	Oblong Machine File, 1/4" Shank	No. 882	Lamp Attachment
No. 740	Set of 6 Files, 1/4" Shank	No. 40-805	Blade Guides, Set of 6
No. 751	Square Machine File, 1/8" Shank	No. 49-363	Retractable Caster Set
No. 752	Crochet Machine File, 1/8" Shank	No. 50-717	Steel Stand

Replacement parts can be ordered through your Delta Dealer. Always give both the part number and the description of each part when ordering. Also the serial number of the machine on which the parts are to be used. Many of the standard parts such as screws, nuts, washers, etc., are usually available from local Mill Supply or Hardware Dealers.

Standard electrical parts such as switches, condensers, cords and plugs, etc., can be obtained from Local Electrical Supply Dealers or Motor Repair Shops. When ordering refer to manufacturer part number which appears on the part.

Delta motors are made by leading motor manufacturers whose name also appears on the motor nameplate. These manufacturers are represented by motor service stations throughout the United States and some foreign countries.

The right is reserved to make changes in design or equipment at any time without incurring any obligation to install these on machines previously sold and to discontinue models of machines, motors or accessories at any time without notice.



Rockwell MANUFACTURING COMPANY

DELTA POWER TOOL DIVISION

PITTSBURGH 8, PENNSYLVANIA