

20" Variable Speed Scroll Saw

with Quickset Blade Changing Feature
(Model 40-640)

INSTRUCTION MANUAL



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PART NO. 1344248

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 **DELTA**

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SAFETY RULES

As with all machinery there are certain hazards involved with operation and use of the machine. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application DO NOT use the machine until you have written Delta Machinery and we have advised you.

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WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

- 1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.
- 2. KEEP GUARDS IN PLACE** and in working order.
- 3. ALWAYS WEAR EYE PROTECTION.**
- 4. GROUND ALL TOOLS.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.
- 5. REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on."
- 6. KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 7. DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.
- 8. KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
- 9. MAKE WORKSHOP CHILDPROOF** - with padlocks, master switches, or by removing starter keys.
- 10. DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
- 11. USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
- 12. WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Non-slip foot wear is recommended. Wear protective hair covering to contain long hair.
- 13. ALWAYS USE SAFETY GLASSES.** Wear safety glasses (must comply with ANSI Z87.1). Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty.
- 14. SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
- 15. DON'T OVERREACH.** Keep proper footing and balance at all times.
- 16. MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- 17. DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.
- 18. USE RECOMMENDED ACCESSORIES.** The use of improper accessories may cause hazards.
- 19. AVOID ACCIDENTAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord.
- 20. NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
- 21. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- 22. DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- 23. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
- 24. DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drug, alcohol or any medication.
- 25. MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
- 26. WARNING:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR SCROLL SAWS

1. **WARNING:** Do not operate your scroll saw until it is completely assembled and installed according to the instructions.
2. **IF YOU ARE NOT** thoroughly familiar with the operation of scroll saws, obtain advice from your supervisor, instructor or other qualified person.
3. **YOUR SCROLL SAW MUST** be securely fastened to a stand or workbench. If there is any tendency for the stand or workbench to move during operation, the stand or workbench **MUST** be fastened to the floor.
4. **THIS SCROLL SAW** is intended for indoor use only.
5. **MAKE SURE** blade is properly tensioned before operating saw.
6. **TO AVOID** blade breakage **ALWAYS** adjust blade tension correctly.
7. **MAKE SURE** the blade teeth point downward toward the table.
8. **NEVER** turn the saw "ON" before clearing the table of all objects (tools, scraps of wood, etc.).
9. **DO NOT** cut material that is too small to be safely supported.
10. **AVOID** awkward hand positions where a sudden slip could cause a hand to move into the blade.
11. **ALWAYS** keep hands and fingers away from the blade.
12. **ALWAYS** adjust holddown foot for each new operation.
13. **DO NOT USE** dull or bent blades.
14. **DO NOT** attempt to saw material that does not have a flat surface, unless a suitable support is used.
15. **MAKE** "relief" cuts before cutting long curves.
16. **NEVER** attempt to cut a curve that is too tight for the blade being used.
17. **WHEN** backing a blade out of a workpiece, the blade may bind in the saw kerf. This is usually caused by sawdust in the kerf. If this happens, turn "OFF" the switch and remove plug from power source outlet. Wedge open the kerf and back blade out of the workpiece.
18. **ALWAYS** hold the work firmly against the table.
19. **DO NOT** feed the material too fast while cutting. Only feed the material fast enough so that the blade will cut.
20. **NEVER** start the Scroll Saw with the stock pressed against the blade.
21. **WHEN** cutting a large workpiece **MAKE SURE** the material is supported at table height.
22. **USE CAUTION** when cutting material which is irregular in cross section, which could pinch the blade before the cut is completed. A piece of moulding, for example, must lay flat on the table and not be permitted to rock while being cut.
23. **USE CAUTION** when cutting round material such as dowel rods or tubing. They have a tendency to roll while being cut, causing the blade to "bite." Use a V-block to control the piece.
24. **ALWAYS** release blade tension before loosening the blade holder screw.
25. **MAKE CERTAIN** table tilting lock is tightened before starting the machine.
26. **NEVER** reach under the table while the machine is running.
27. **NEVER** perform layout, assembly or set-up work on the table while the saw is operating.
28. **ALWAYS STOP** the saw before removing scrap pieces from the table.
29. **SHOULD** any part of your scroll saw be missing, damaged, or fail in any way, or any electrical component fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged or failed parts before resuming operation.
30. **ADDITIONAL INFORMATION** regarding the safe and proper operation of this product is available from the National Safety Council, 444 N. Michigan Avenue, Chicago, IL 60611, in the Accident Prevention Manual for Industrial Operations and also in the Safety Data Sheets provided by the NSC. Please also refer to the American National Standards Institute ANSI 01.0 Safety Requirements for Woodworking Machinery and the U.S. Department of Labor OSHA 1910.213 Regulations.

UNPACKING AND CLEANING

Your new scroll saw is shipped complete in one carton. Carefully unpack the saw and all loose items. Fig. 2 illustrates the scroll saw and all loose items removed from the carton. Remove the protective coating from the saw table surface. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the table surface with a good quality paste wax.

WARNING: FOR YOUR OWN SAFETY, DO NOT CONNECT THE SCROLL SAW TO THE POWER SOURCE UNTIL THE MACHINE IS COMPLETELY ASSEMBLED AND YOU HAVE READ AND UNDERSTAND THE ENTIRE OWNERS MANUAL.

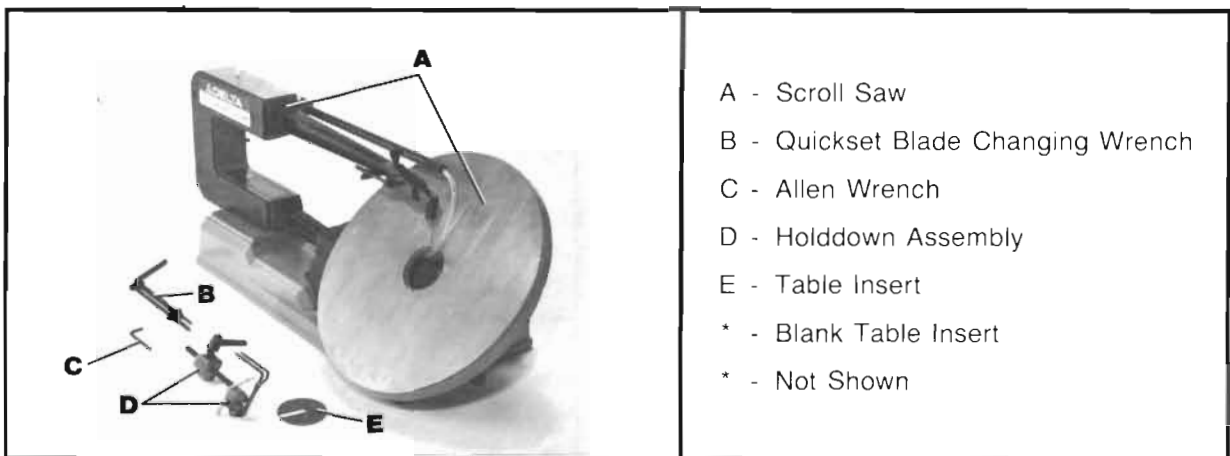


Fig. 2

ASSEMBLY INSTRUCTIONS

1. Loosen lock handle (A) Fig. 3, and move table (B) to the horizontal (level) position. Then tighten lock handle (A).



Fig. 3

2. Slide holddown assembly bracket (C) Fig. 4, onto rod (D) as shown, and tighten two screws located underneath bracket (C) using wrench (E) supplied.

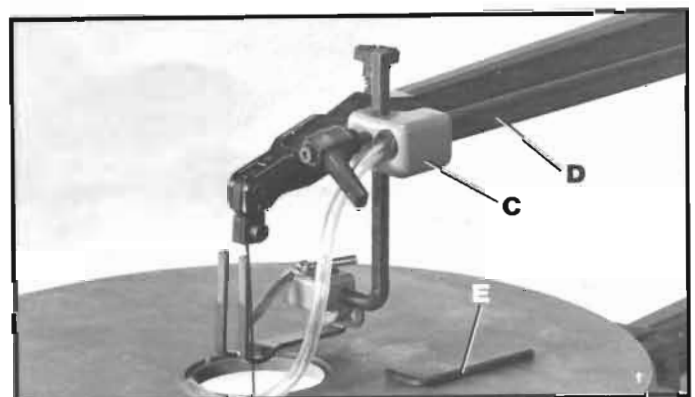


Fig. 4

3. Connect air hose (F) Fig. 5, to end of blower tube (G) as shown.

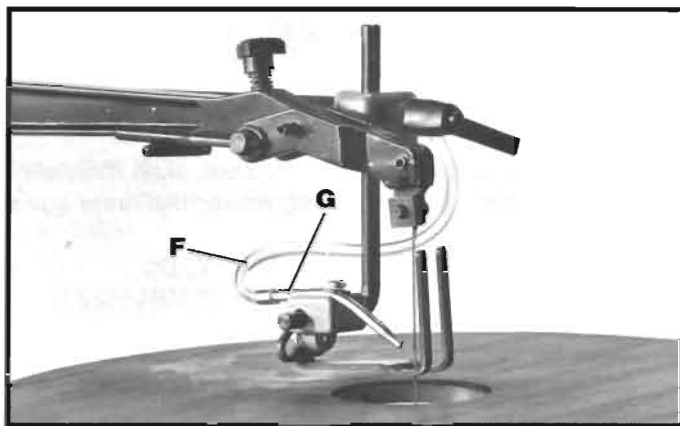


Fig. 5

4. Assemble table insert (H) Fig. 6, to opening in table, as shown.

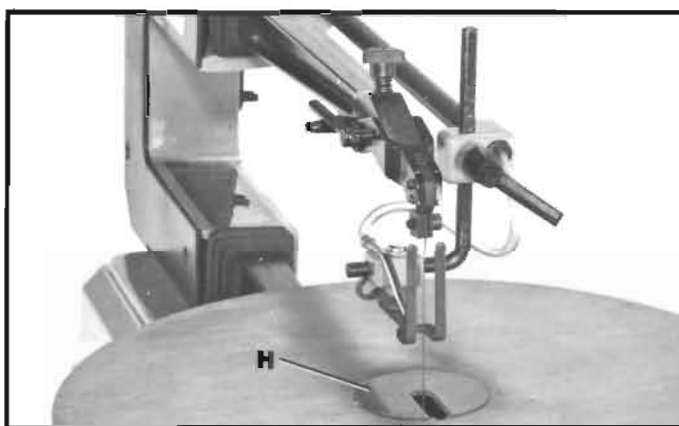


Fig. 6

FASTENING SCROLL SAW TO SUPPORTING SURFACE

Your scroll saw **MUST** be securely fastened to a stand or workbench using the three mounting holes in the base of the saw, two of which are shown at (A) Fig. 7.

IMPORTANT: If there is any tendency for the stand or workbench to move during operation, the stand or workbench must be fastened to the floor.

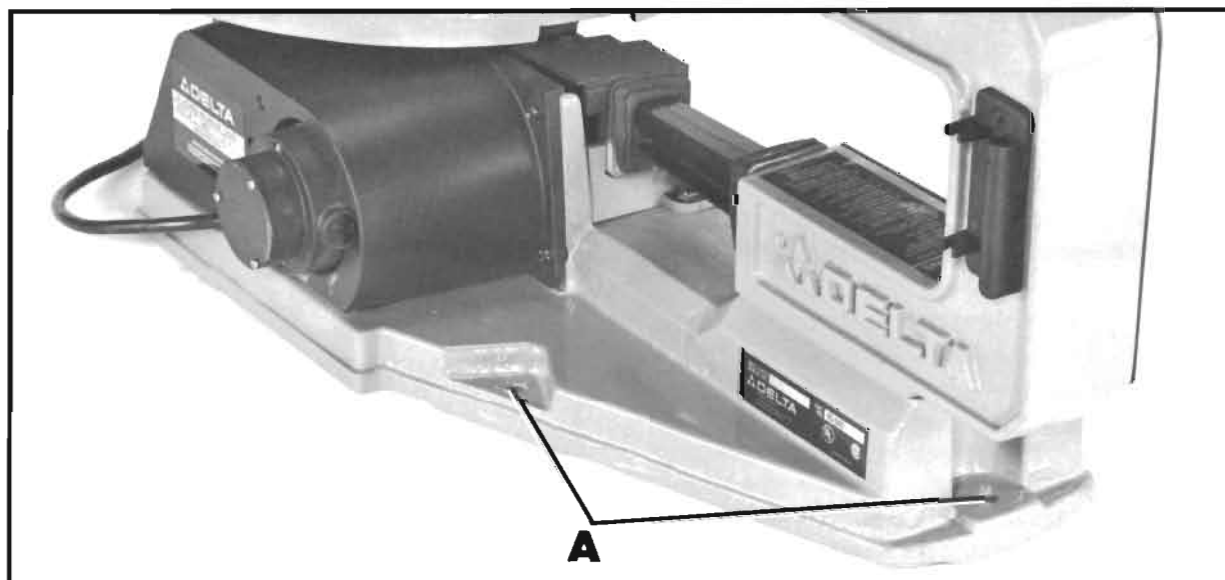


Fig. 7

CONNECTING SCROLL SAW TO POWER SOURCE

POWER CONNECTIONS

A separate electrical circuit should be used for your tools. This circuit should not be less than #12 wire and should be protected with a 20 Amp time lag fuse. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tool's plug. For distances up to 100 feet use #12 wire. For distances up to 150 feet use #10 wire. Have a certified electrician replace or repair damaged or worn cord immediately. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as stamped on motor nameplate. All line connections should make good contact. Running on low voltage will injure the motor.

GROUNDING INSTRUCTIONS

WARNING: THIS TOOL MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

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

Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-hole receptacles that accept the tool's plug, as shown in Fig. 8.

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet and a plug that looks like the one shown in Fig. 8. A temporary adapter, which looks like the adapter illustrated in Fig. 9, may be used to connect this plug to a 2-pole receptacle, as shown in Fig. 9, if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. **THIS ADAPTER IS NOT APPLICABLE IN CANADA.** The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground, such as a properly grounded outlet box, as shown in Fig. 9.

CAUTION: IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE HAVE A CERTIFIED ELECTRICIAN CHECK THE RECEPTACLE.

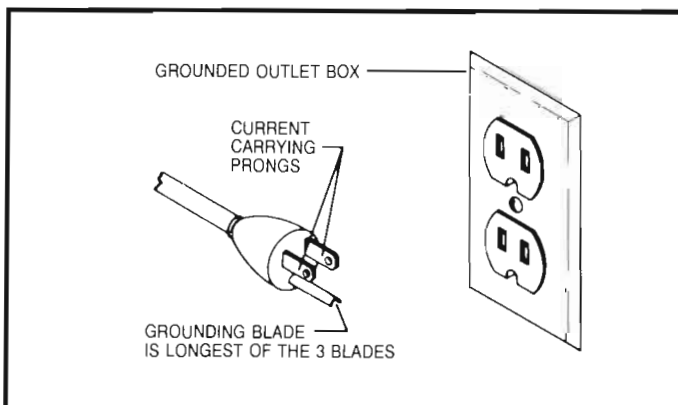


Fig. 8

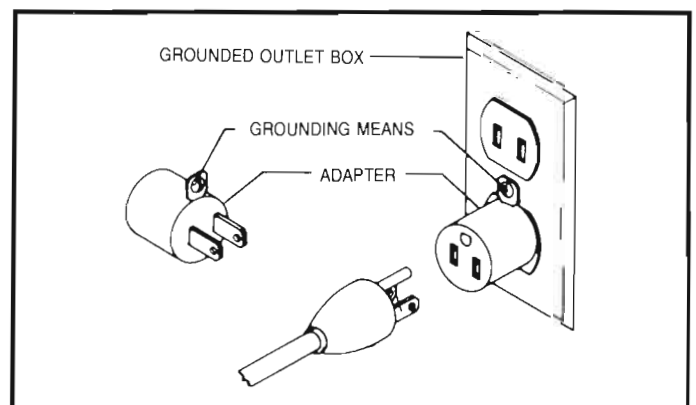


Fig. 9

OPERATING CONTROLS AND ADJUSTMENTS

ON-OFF SWITCH

The switch (A) Fig. 10, is located on the front of the saw. To turn the saw "ON," pull out switch (A) and to turn the saw "OFF" push in switch (A).

SPEED CONTROL

Your scroll saw can be operated at speeds of 400 to 1800 strokes per minutes. The strokes per minute is indicated on the nameplate and a pointer is supplied on the switch (A) Fig. 10. To increase the strokes per minute, rotate switch (A) clockwise and to decrease the strokes per minute rotate switch (A) counterclockwise.

LOCKING SWITCH IN THE "OFF" POSITION

IMPORTANT: We suggest that when the scroll saw is not in use the switch (A) Fig. 11, be locked in the "OFF" position using a padlock (B) as shown. The padlock (B) prevents the switch (A) from being pulled out to the "ON" position.

CHANGING BLADES

1. **WARNING: TO AVOID INJURY FROM ACCIDENTAL STARTING ALWAYS TURN SWITCH "OFF" AND REMOVE POWER CORD PLUG FROM ELECTRICAL OUTLET BEFORE REMOVING OR REPLACING BLADE.**

2. Remove table insert and release blade tension by pulling tension lever (A) Fig. 12, forward, as shown.

3. Insert long end of quickset blade changing wrench (B) Fig. 12, into hole (C) in upper blade holder. This will automatically align wrench (D) with blade holder screw (E).

4. Turn handle (F) Fig. 13, of quickset blade changing wrench counterclockwise to loosen blade holder screw (E) and remove blade (G).

5. Repeat this operation on the lower blade holder and remove blade.

6. Insert new blade into the lower and upper blade holders in the same manner making certain the blade teeth are pointing down toward the table.

7. Apply blade tension by moving tension lever (A) Fig. 13, to the rear.



Fig. 10

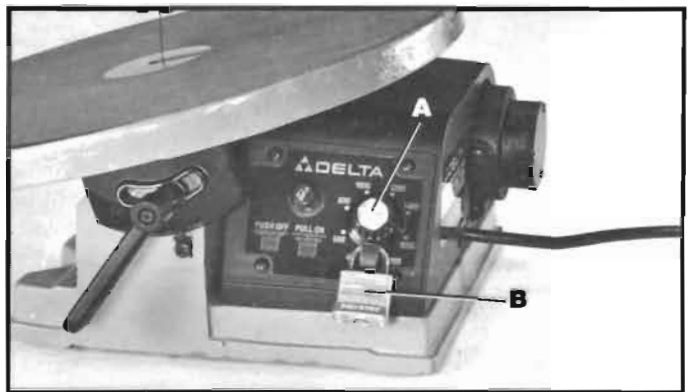


Fig. 11

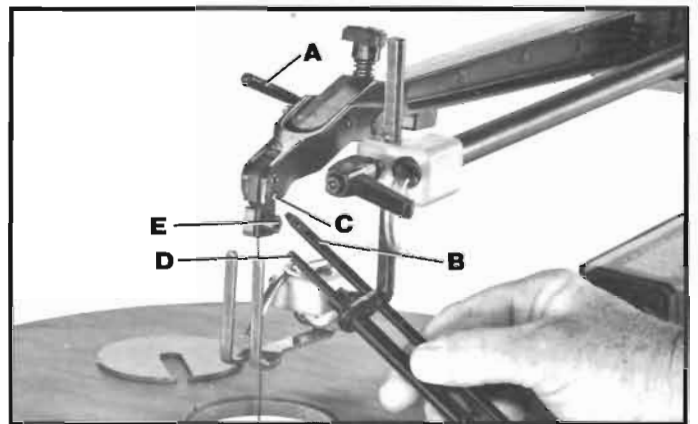


Fig. 12

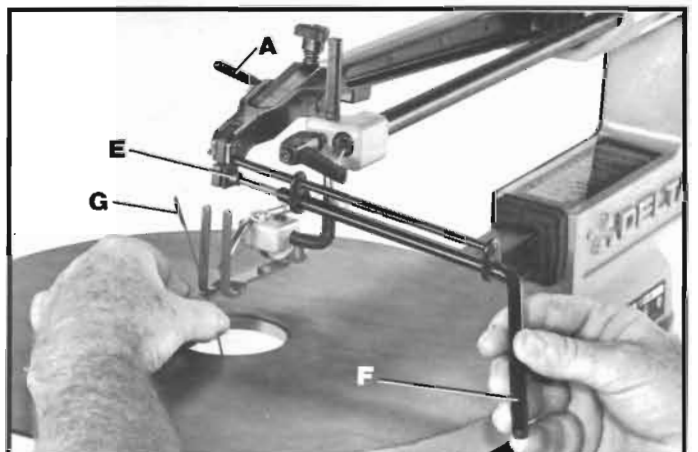


Fig. 13

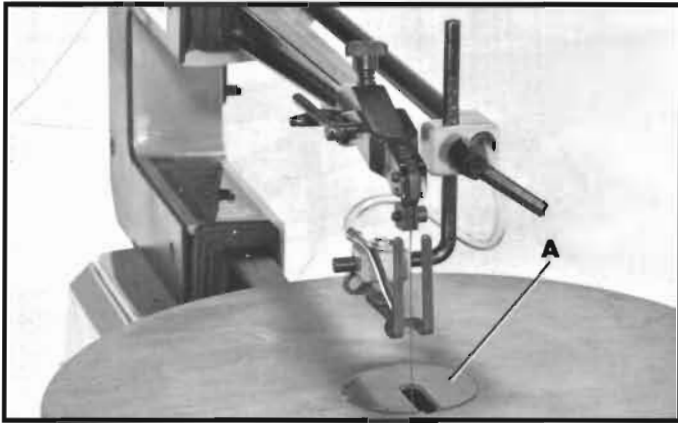


Fig. 14

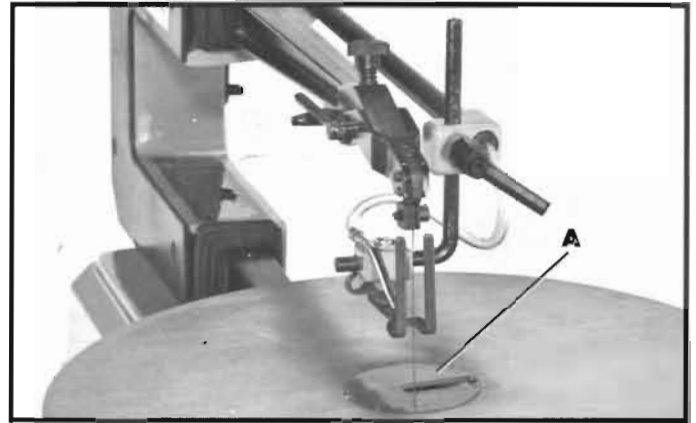


Fig. 15

TABLE INSERT

The table insert (A) can be assembled to the saw table with the opening in the insert pointing to the front of the table, as shown in Fig. 14, or to the right of the table, as shown in Fig. 15.

With the table in the level position, 90 degrees to the blade, the insert (A) should be positioned as shown in Fig. 14. This allows for the blade to be pivoted forward after it is unclamped from the top blade holder, enabling you to quickly insert the blade into the next hole in a pattern when doing inside cutting, as you will see later in this manual.

When tilting the table for bevel cutting operations, the insert (A) should be positioned as shown in Fig. 15. This allows clearance for the blade when tilting the table.

A table insert blank (B) Fig. 16, is supplied as standard equipment with your scroll saw and can be used when cutting very small workpieces to give added support to the bottom of the workpiece. Simply cut a slot into the blank and replace the standard insert (A) with the blank (B). The slot cut into the blank (B) will only be as wide as the blade giving maximum support to the bottom of the workpiece.

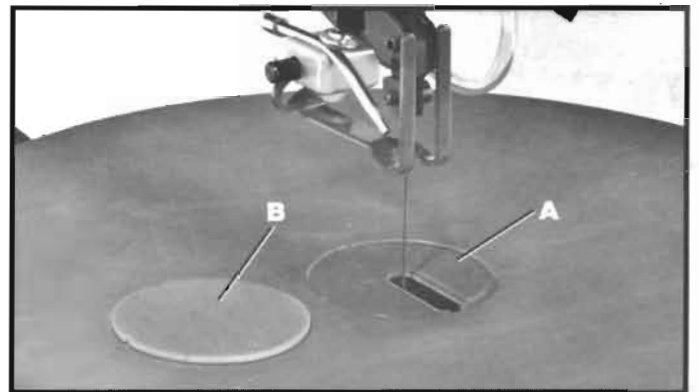


Fig. 16

BLADE BREAKAGE

Blade breakage is usually caused by one or more of the following:

1. Bending the blade during installation.
2. Improper blade tension.
3. Improper blade selection for the work being cut.
4. Forcing the work into the blade too rapidly.
5. Cutting too sharp a turn for the blade being used.
6. Improper blade speed.

ADJUSTING BLADE TENSION

Tension is applied to the blade when the blade tension lever (A) is in the rear position, as shown in Fig. 17. When the lever (A) is moved forward, as shown in Fig. 18, blade tension is released.

To increase blade tension, turn knob (B) Fig. 18, clockwise and to decrease blade tension, turn knob (B) counterclockwise. When adjusting blade tension, lever (A) should be in the forward position, as shown in Fig. 18. **NOTE:** It is necessary to adjust the blade tension knob (B) only when the blade is removed from both upper and lower blade holders and a new or different type of blade is assembled to the holders. It is not necessary to adjust blade tension when the blade is removed and replaced in only the upper blade holder as in performing inside cutting operations.

Adjusting the blade for proper tension is usually accomplished by trial and error; however, a good method to use is to pluck the rear of the blade, like a guitar string after the tension lever (A) Fig. 18, is moved to the rear. A high pitched tone of the blade should be heard and this usually indicates proper tension. Finer blades require more tensioning (a higher pitched sound) while thicker blades require less tension.

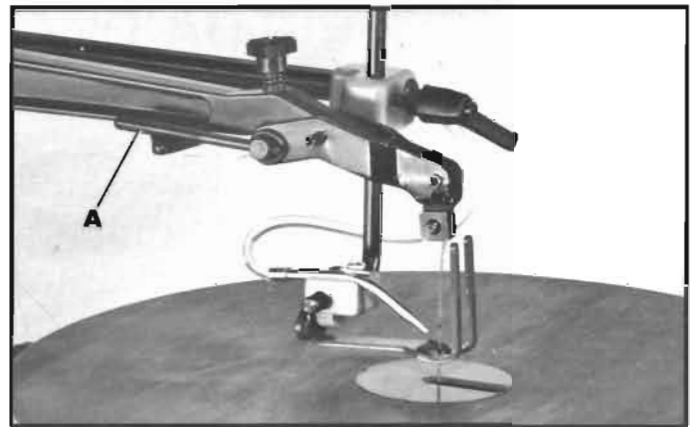


Fig. 17

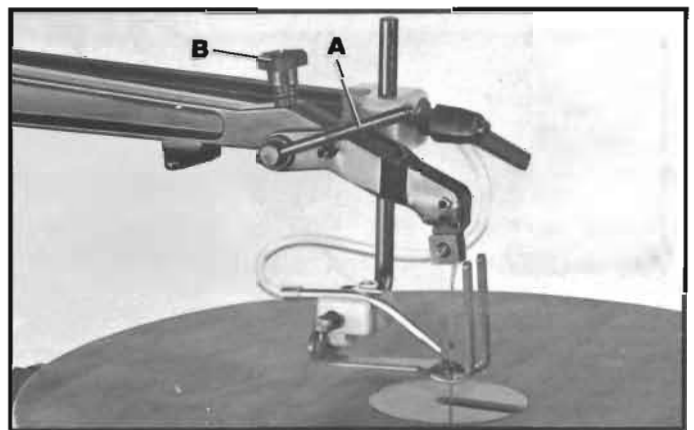


Fig. 18

TILTING THE TABLE

The table on your scroll saw can be tilted 45 degrees to the left for bevel cutting operations by loosening table lock handle (A) Fig. 19, tilt the table to the desired angle and tighten lock handle (A). **NOTE:** The table lock handle (A) can be repositioned by removing screw (D) and removing and repositioning handle (A) on the hex rod located underneath the hub of the handle.



Fig. 19

When bevel cutting, the holddown (B) Fig. 20, can be adjusted to lay flat on the stock by loosening screw (C) and tilting the holddown (B) accordingly. Then tighten screw (C).

If the workpiece is too thick, causing the stock to contact the holddown arm, the complete holddown assembly must be removed, since thick stock is heavy enough to resist lifting off the table during the blade up stroke.

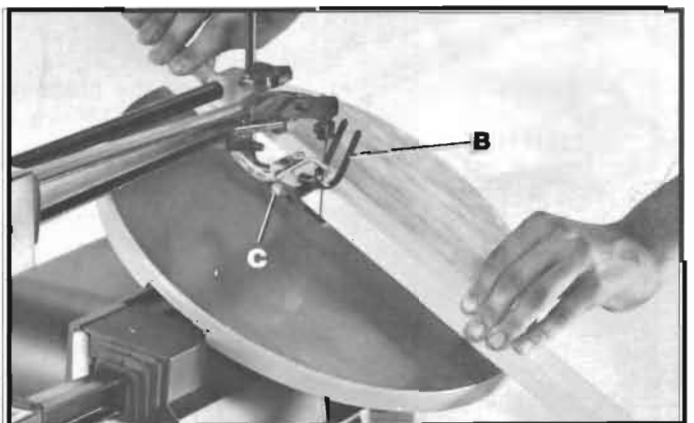


Fig. 20

LEVELING THE TABLE

1. Loosen table lock handle and move the table all the way to the right.
2. Using a square (A) Fig. 21, check to see if the table is 90 degrees to the saw blade, as shown.

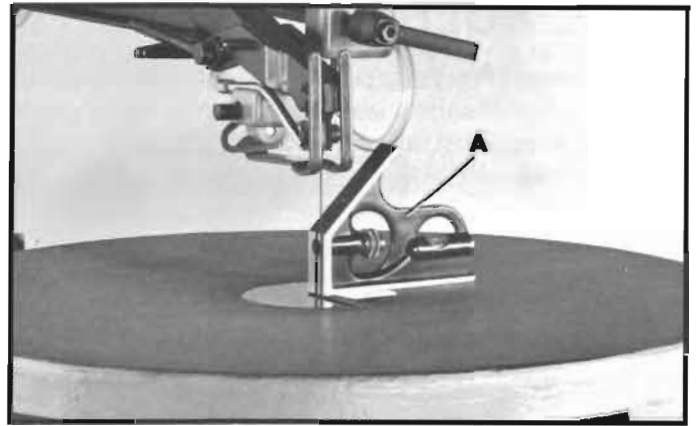


Fig. 21

3. If the table is not at 90 degrees to the blade, adjust the table accordingly making certain screw (B) Fig. 22, contacts bottom of table surface when table is 90 degrees to the blade. Screw (B) can be adjusted by loosening nut (C), thread screw (B) in or out the desired distance and tighten nut (C).



Fig. 22

ADJUSTING HOLDDOWN

The holddown (A) Fig. 23, should be adjusted so it contacts the top surface of the work being cut by loosening lock handle (B) and moving holddown rod (C) up or down. Then tighten lock handle (B). **NOTE:** Handle (B) is spring loaded and can be repositioned by pulling out the handle and repositioning it on the serrated nut located underneath the hub of the handle.

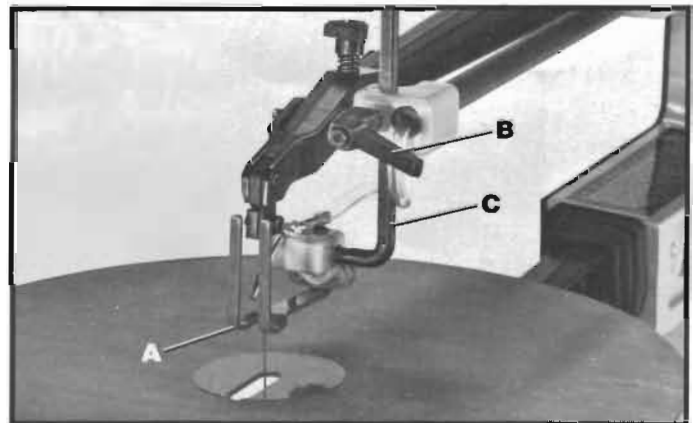


Fig. 23

ADJUSTING DUST BLOWER

The dust blower (A) Fig. 24, may be moved to direct air to the most effective point on the cutting line by loosening screw (B), adjust nozzle (A) accordingly and tighten screw (B).

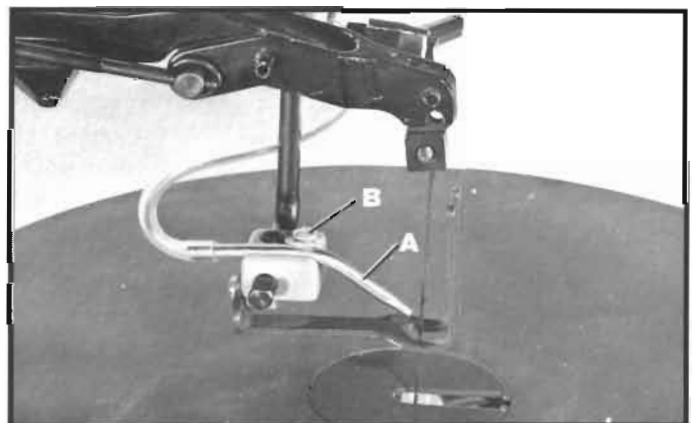


Fig. 24

TOOL HOLDER

A tool holder (A) Fig. 25, is provided on the right hand side of the saw frame and is used to hold the quickset blade changing wrench (B), allen wrench (C) and extra blades (D), as shown.

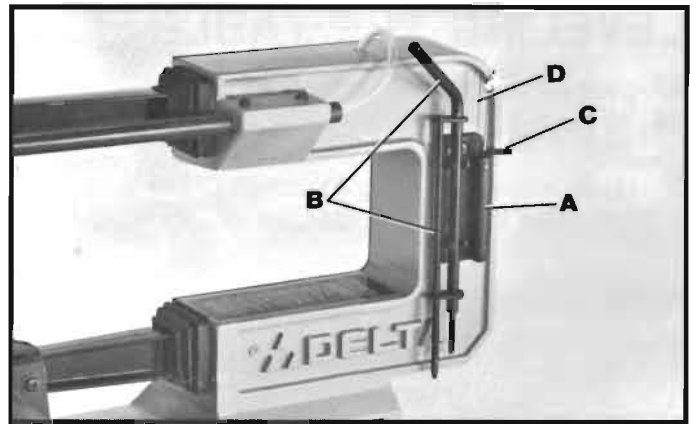


Fig. 25

OPERATION

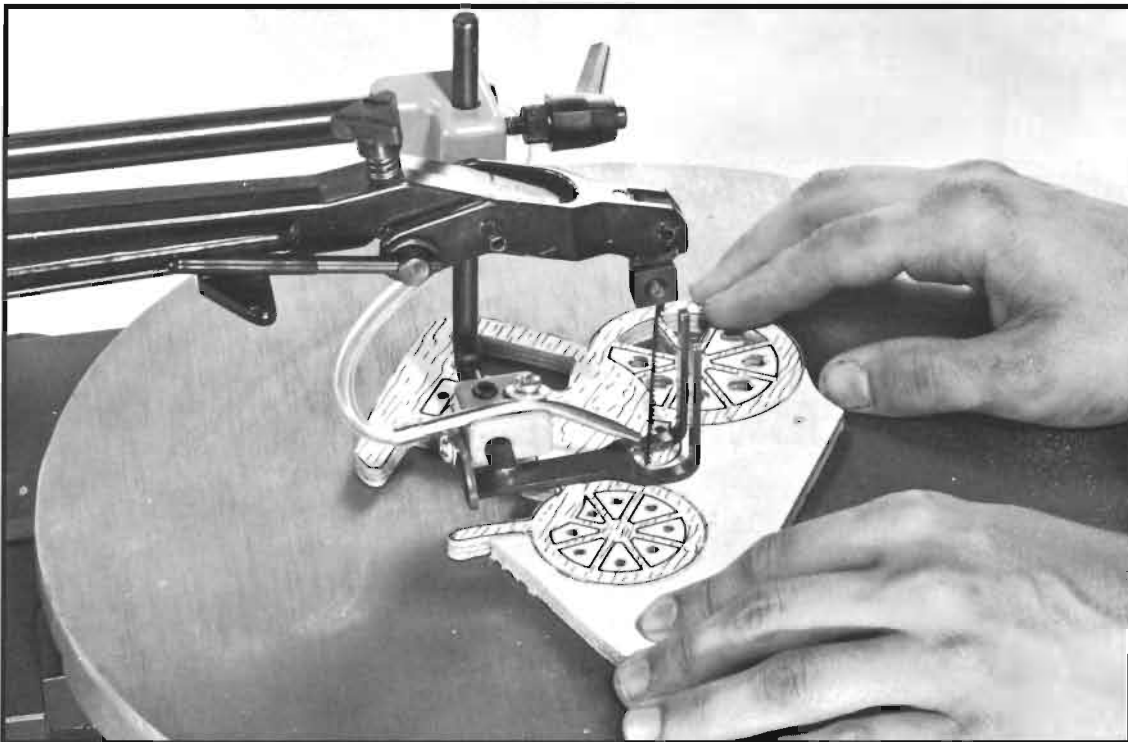


Fig. 26

FOLLOWING A LINE

Fig. 26 illustrates a typical scroll saw operation being made following the outside line on a pattern. With your scroll saw you should be able to cut a straight or curved line with ease. Most beginners will experience blade wandering; however, they eventually learn to control it as they become more familiar with the machine. Use scrap material to practice cuts before starting a project. This enables you to develop your own way of cutting and you will find out what you can and cannot do with your saw. Always hold the workpiece firmly against the table and do not feed the workpiece too fast while cutting. Feed the workpiece only fast enough so that the blade will cut. Scroll saws cut faster across the grain than they do with the grain. Allow for this tendency when cutting patterns that shift rather quickly from with-the-grain cuts to cross-grain cuts. Make "relief" cuts before cutting long curves and never attempt to cut a curve that is too tight for the blade being used.

INSIDE CUTTING

Inside cutting is where the blade must be threaded through a hole in the workpiece. The Delta 20" Scroll Saw has the capability of performing this operation quickly and easily as follows:



Fig. 27

1. Let's assume you are performing an inside cutting operation on a project, similar to the one shown in Fig. 27, that has numerous inside cuts to be made. This can be accomplished quickly with the Delta saw. In Fig. 27, the operator has just completed one of the inside cuts and must move to the next hole.

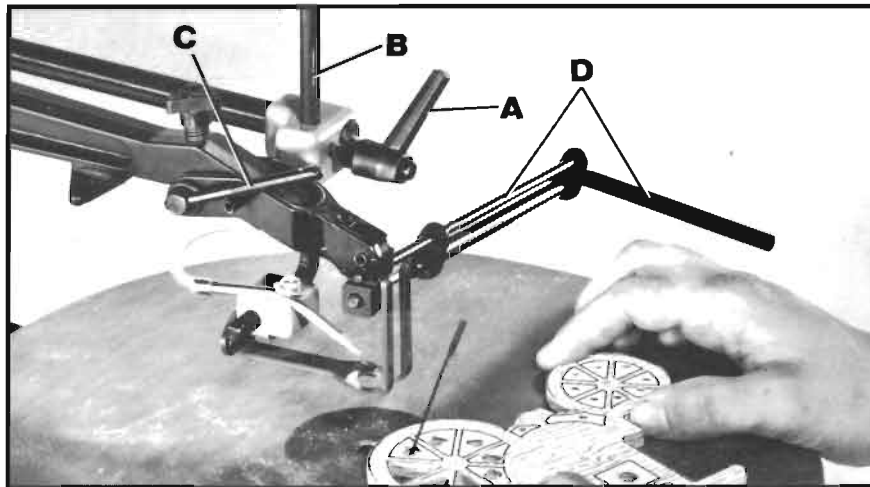


Fig. 28

2. Loosen lock handle (A) Fig. 28, and raise hold-down bar (B). Release blade tension by moving tension lever (C) forward and loosen upper blade holder screw using the quickset blade changing wrench (D). Move the blade forward and insert it into the next hole in the pattern, as shown. Reassemble blade back into upper blade holder and tighten upper blade holder screw with wrench (D).

3. Remove quickset blade changing wrench and move tension lever (C) Fig. 29, to the rear, as shown. Lower hold-down and you are ready to make the next inside cut.



Fig. 29

MAINTENANCE

LUBRICATION

To keep the scroll saw operating at peak efficiency, we recommend that a simple maintenance procedure be performed after approximately each 20 hours of use. Proceed as follows:

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.**

2. Remove four screws (A) Fig. 30, and remove side panel (B) from the scroll saw.

3. Release blade tension by pulling tension lever (C) Fig. 31, forward as shown.

4. Lubricate the shafts of the two special screws (D) Fig. 32, with a few drops of light machine oil in the areas where they pass through the connecting link (E). **NOTE: DO NOT REMOVE SPECIAL SCREWS TO LUBRICATE.**

5. Remove two pivot bolts (F) Fig. 32.

6. Thoroughly clean grease from shafts (G) Fig. 33, of both pivot bolts (F) and lubricate shafts (G) with a few drops of light machine oil.

7. Reassemble two pivot bolts (F) Fig. 33, to machine.

8. Replace side panel removed in **STEP 2** and reapply tension to the blade.

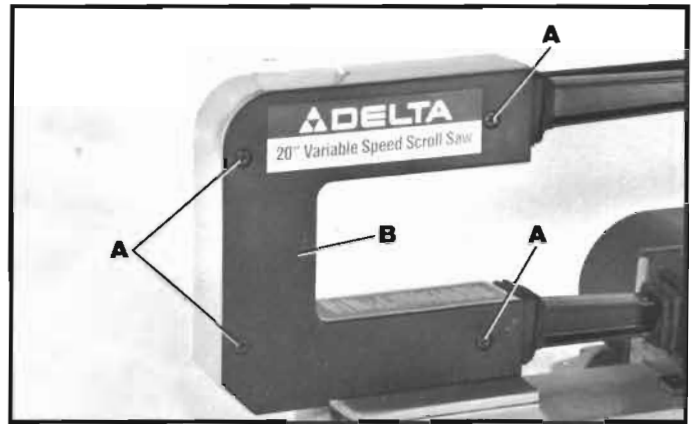


Fig. 30

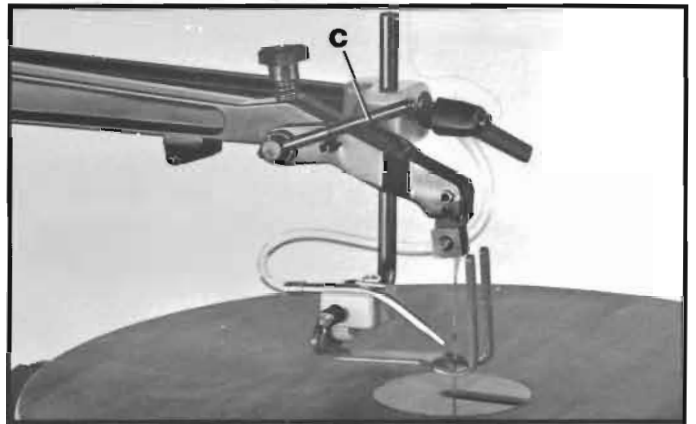


Fig. 31

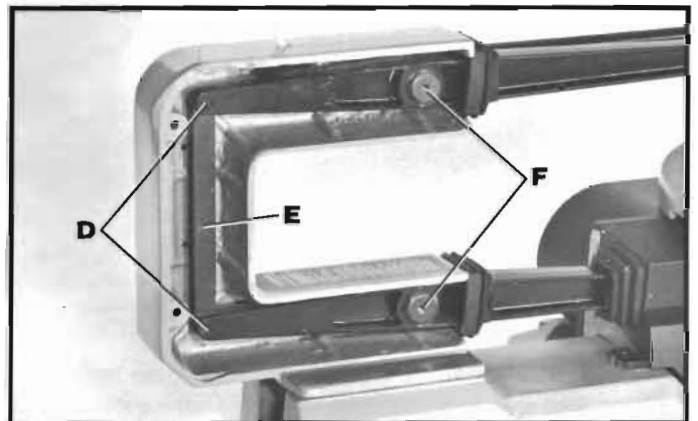


Fig. 32

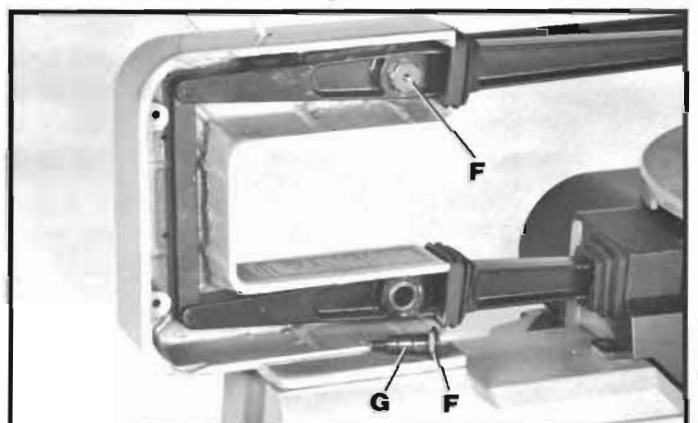


Fig. 33

BRUSH INSPECTION AND REPLACEMENT

CAUTION: BEFORE INSPECTING THE BRUSHES, DISCONNECT THE MACHINE FROM THE POWER SOURCE.

Brush life varies. It depends on the load on the motor. Check the brushes after the first 50 hours of use for a new machine or after a new set of brushes has been installed. After the first check, examine them after about 10 hours of use until such time that replacement is necessary.

The brush holders, one of which is shown at (A) Fig. 34, are located on the motor housing opposite each other. Fig. 35, illustrates one of the brushes removed for inspection. When the carbon (B) on either brush is worn to 3/16" in length or if either spring (C) or shunt wire is burned or damaged in any way, replace both brushes. If the brushes are found serviceable after removing, reinstall them in the same position as removed.



Fig. 34

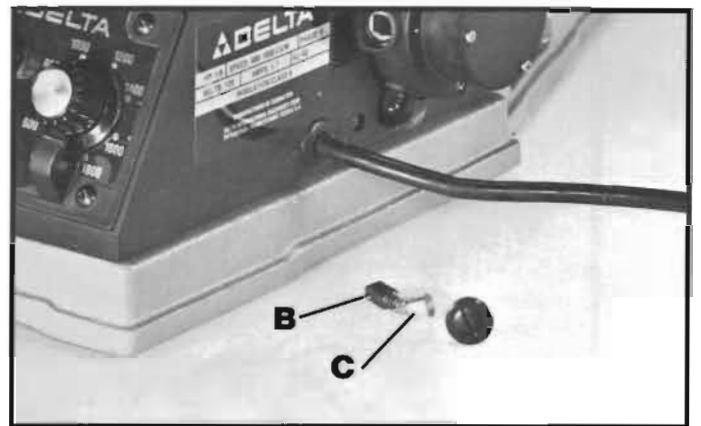


Fig. 35

REPLACING FUSE

If due to overloading it becomes necessary to replace the fuse in your scroll saw, **DISCONNECT THE MACHINE FROM THE POWER SOURCE** and unscrew and remove the fuse holder (A) Fig. 36.



Fig. 36

Fig. 37, illustrates the fuse holder (A) and fuse (B) removed. **NOTE: Use only 3 amp AG type fuse for replacement.**



Fig. 37



PARTS, SERVICE OR WARRANTY ASSISTANCE

All Delta Machines and accessories are manufactured to high quality standards and are serviced by a network of factory service centers and authorized service stations listed in your owner's manual. To obtain additional infor-

mation regarding your Delta quality product or to obtain parts, service or warranty assistance, please call or fax Delta's toll-free 'hotline' number.



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