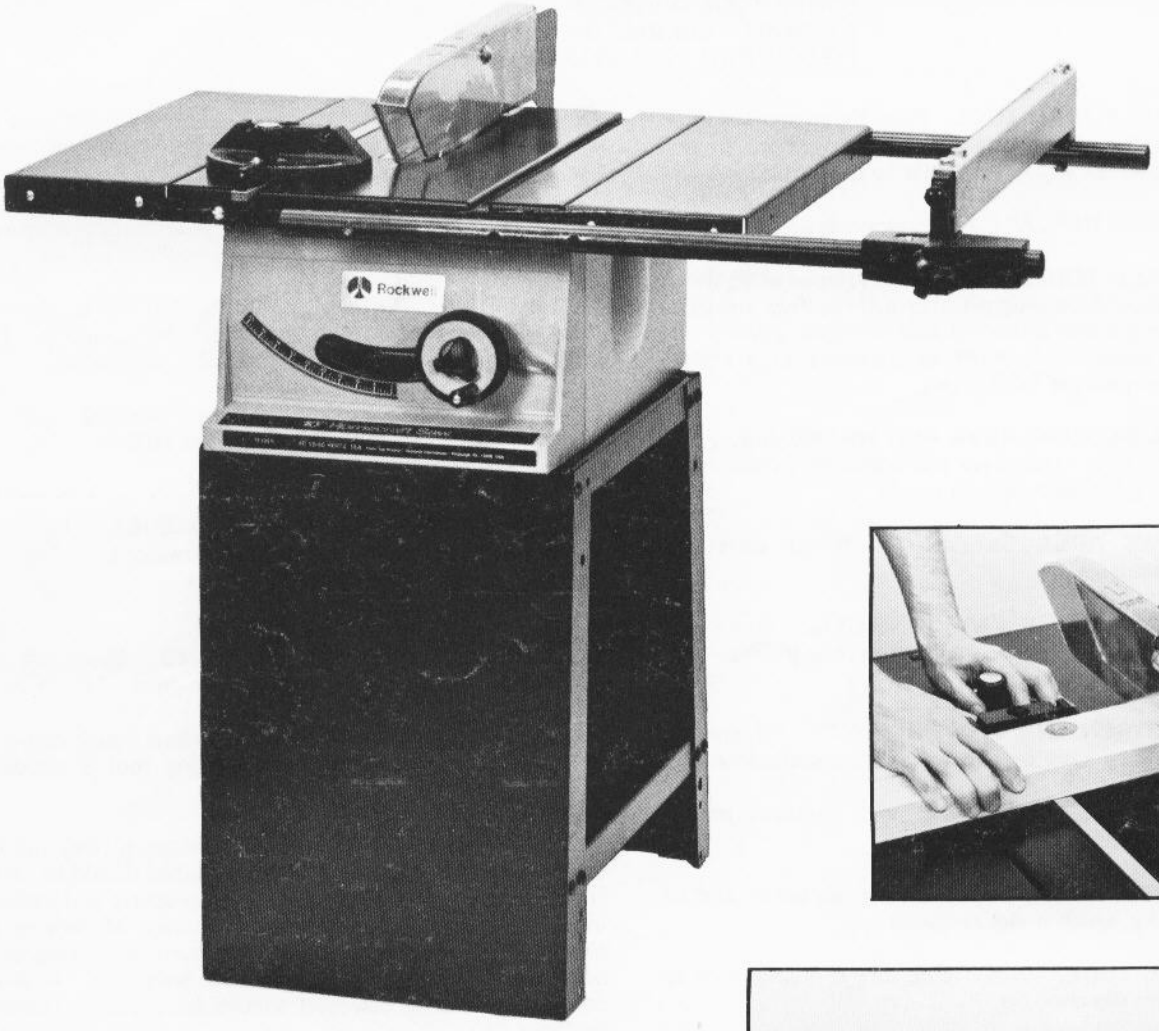
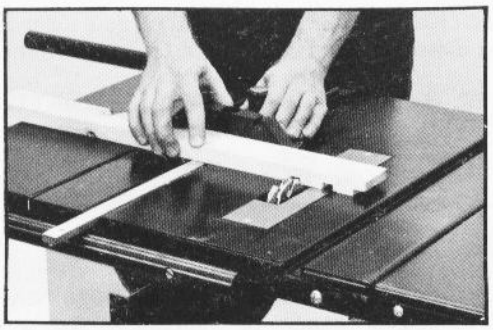
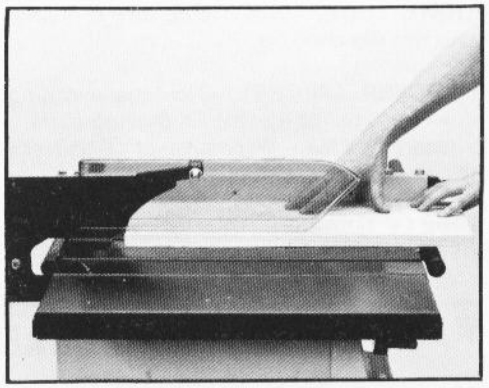
Rockwell International

PART NO. 422—22—651—0001
DATED 7—1—76

34—660 10" HOMECRAFT SAW







INTRODUCTION

Your new 10" Homecraft Saw is a quality-built machine, capable of dependable performance throughout its lifetime. In order to take full advantage of these capabilities you should thoroughly understand the construction and assembly of the saw and the proper technique for operating it. Therefore, we suggest you read this manual before operating the saw and also that you save it for future reference.

SAFETY RULES FOR ALL TOOLS

As with all power tools there is a certain amount of hazard involved with the operator and his use of the tool. Using the tool with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or completely ignored, personal injury to the operator can develop.

There are also certain applications for which this tool was designed. Rockwell strongly recommends that this tool 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 tool until you have written Rockwell and we have advised you.

ROCKWELL INTERNATIONAL
MANAGER OF PRODUCT SAFETY
POWER TOOL DIVISION
400 NORTH LEXINGTON AVENUE
PITTSBURGH, PENNSYLVANIA 15208

1. **KNOW YOUR POWER TOOL.** Read the owner's manual carefully. Learn the tools applications and limitations, as well as the specific potential hazards peculiar to it.

2. **KEEP GUARDS IN PLACE** and in working order.

3. **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.

4. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

5. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.

6. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

7. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.

8. **MAKE WORKSHOP KIDPROOF** - with padlocks, master switches, or by removing starter keys.

9. **DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.

10. **USE RIGHT TOOL.** Don't force tool or attachment to do a job it was not designed for.

11. **WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, or jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.

12. **USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty.

13. **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.

14. **DON'T OVERREACH.** Keep your proper footing and balance at all times.

15. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. **DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters.

17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause hazards.

18. **AVOID ACCIDENTAL STARTING.** Make sure switch is in "OFF" position before plugging in cord.

19. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.

20. **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.

21. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.

22. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

ADDITIONAL SAFETY RULES FOR CIRCULAR SAWS

1. **ALWAYS** use guard, splitter and anti-kickback fingers on all "thru-sawing" operations. Thru-sawing operations are those when the blade cuts completely through the work piece as in ripping or cross cutting.

2. **ALWAYS** hold the work firmly against the miter gage or fence.

3. **ALWAYS** use a push stick for ripping narrow stock. Refer to ripping applications in instruction manual where push stick is covered in detail.

4. **NEVER** perform any operation "free-hand" which means using your hands to support or guide the work piece. Always use either the fence or the miter gage to position and guide the work.

5. **NEVER** stand or have any part of your body in line with the path of the saw blade.

6. **NEVER** reach behind or over the cutting tool with either hand for any reason.

7. **MOVE** the rip fence out of the way when cross cutting.

8. **WHEN** cutting mouldings, NEVER run the stock between the fence and the moulding cutterhead. Refer to moulding applications in Instruction Manual for details.

9. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction or rotation of the blade or cutter only.

10. **NEVER** use the fence as a cut-off gage when cross cutting.

11. **NEVER** attempt to free a stalled saw blade without first turning the saw OFF.

12. **PROVIDE** adequate support to the rear and sides of the saw table for wide or long workpieces.

13. **AVOID KICKBACKS** (work thrown back toward you) by keeping blade sharp, keeping rip fence parallel to the saw blade, keeping splitter and antikickback fingers and guard in place and operating, by not releasing work before it is pushed all the way past the saw blade, and by not ripping work that is twisted or warped or does not have a straight edge to guide along the fence.

14. **AVOID** awkward operations and hand positions where a sudden slip could cause your hand to move into the cutting tool.

UNPACKING

Carefully unpack the saw and all loose items from the carton. Fig. 2 and 3, illustrate all the loose items packed with your saw.

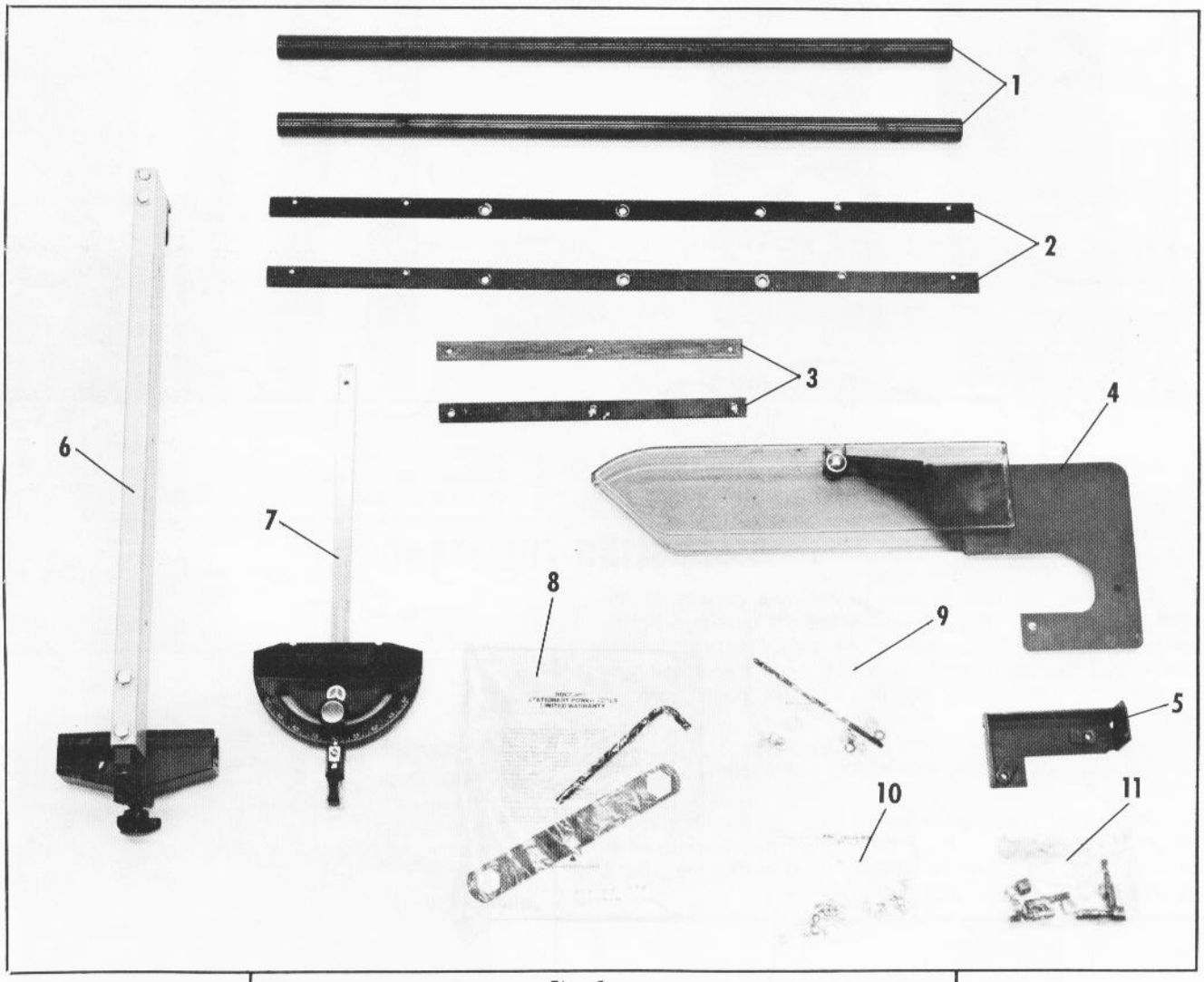


Fig. 2

1 Rip Fence Guide Rails
2 Wing Support Bars
3 Reinforcing Bars
4 See-Thru Blade Guard
5 Guard Bracket
6 Rip Fence
7 Miter Gage
8 Instruction Booklet, Parts List & Blade Wrenches
9 Hardware for Blade Guard
10 Hardware for Extension Wings
11 Hardware for Guide Rails

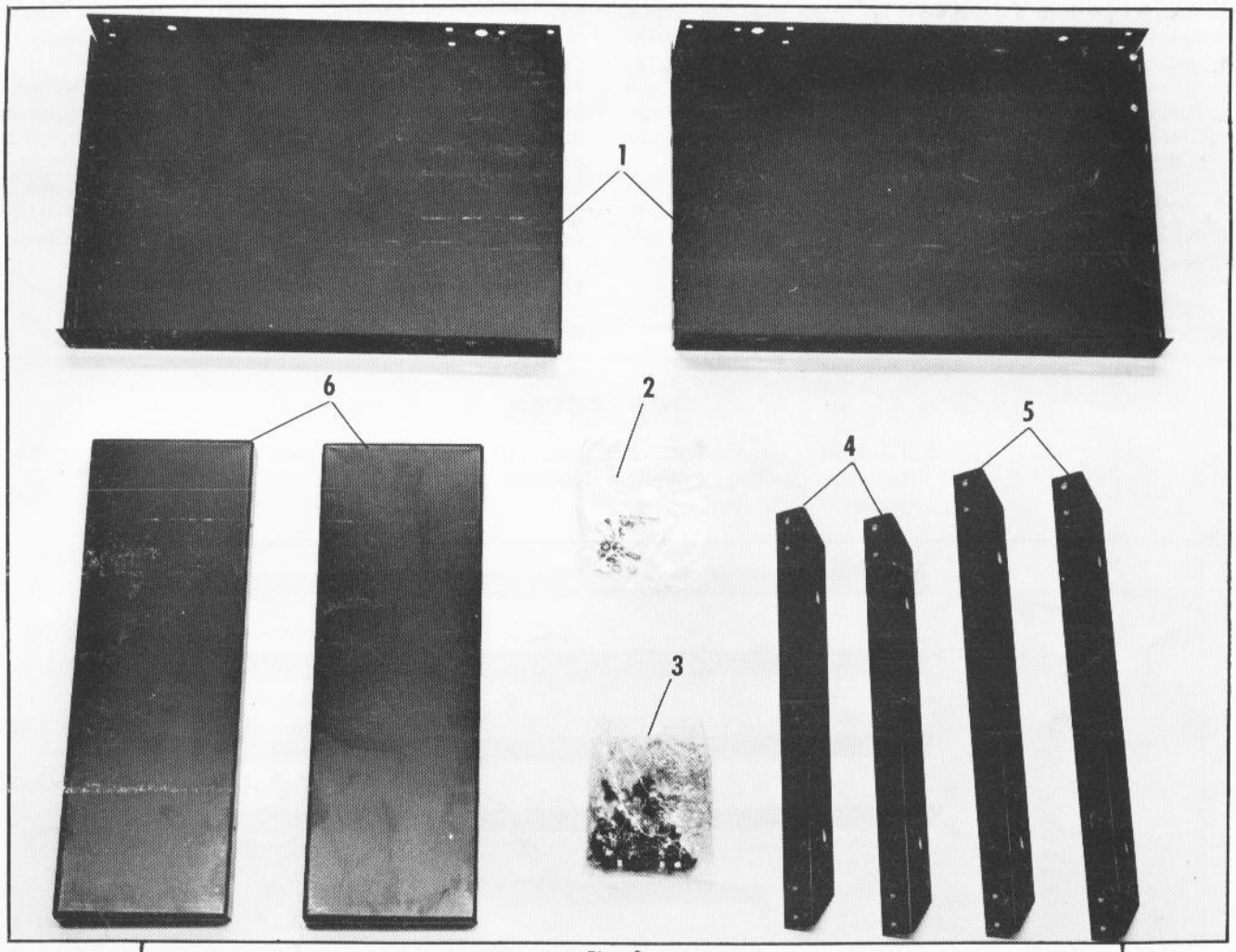


Fig. 3

1	End Panels	4	Upper Tie Bars
2	Hardware for Mounting Saw to Stand	5	Lower Tie Bars
3	Hardware for Stand	6	Extension Wings

ASSEMBLING THE STAND

1. Assemble the four braces to the two panels of the stand, as shown in Fig. 4, using the 16 carriage bolts, flat washers and locknuts. The two 19 1/8" long braces will be positioned on the top of the stand and the two 21 7/16" long braces will be positioned on the bottom.

2. Fig. 5, illustrates the stand assembled.

3. Assemble the four rubber feet to the bottom of the stand as shown in Fig. 4A. When accessory caster set, Cat. No. 50-118 is to be used with the stand, DO NOT USE THE RUBBER FEET.

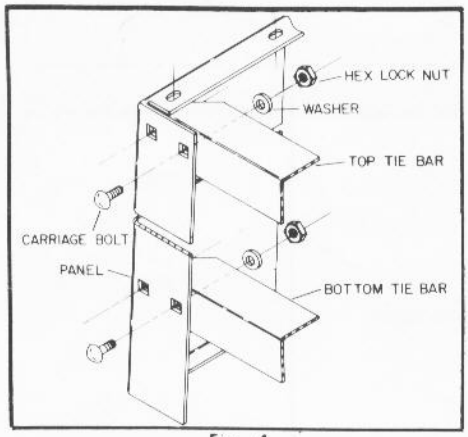


Fig. 4

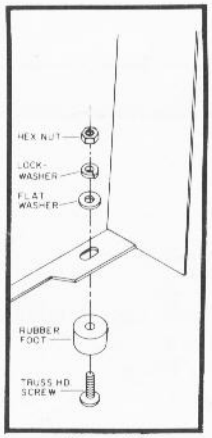


Fig. 4A

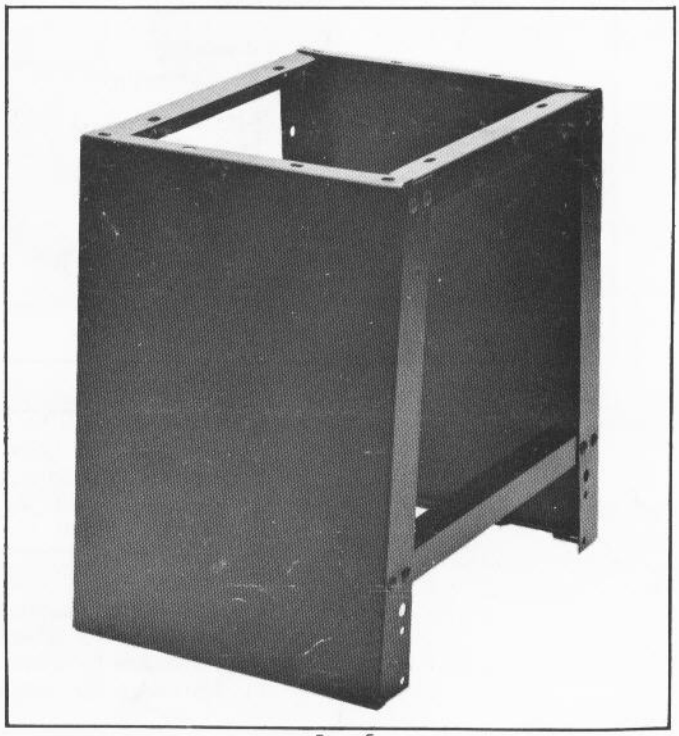


Fig. 5

ASSEMBLING EXTENSION WINGS TO SAW

1. Place the saw upside down on a flat surface, as shown in Fig. 6.

2. Remove screw (A) Fig. 6, that attaches the back panel (B) to the saw cabinet. Lift up and remove back panel (B).

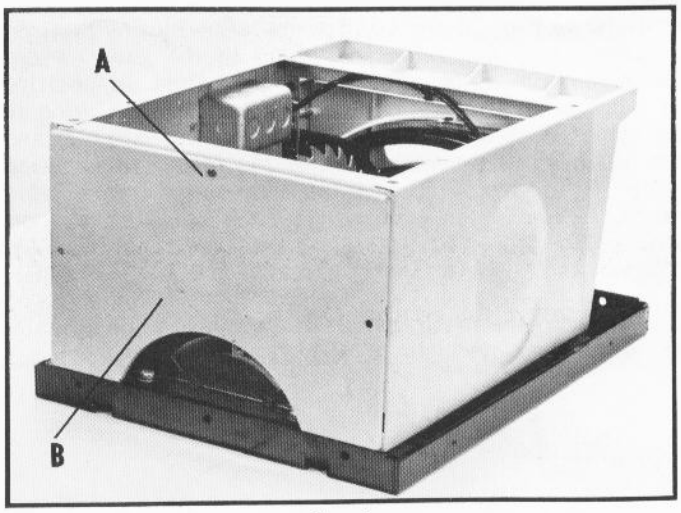


Fig. 6

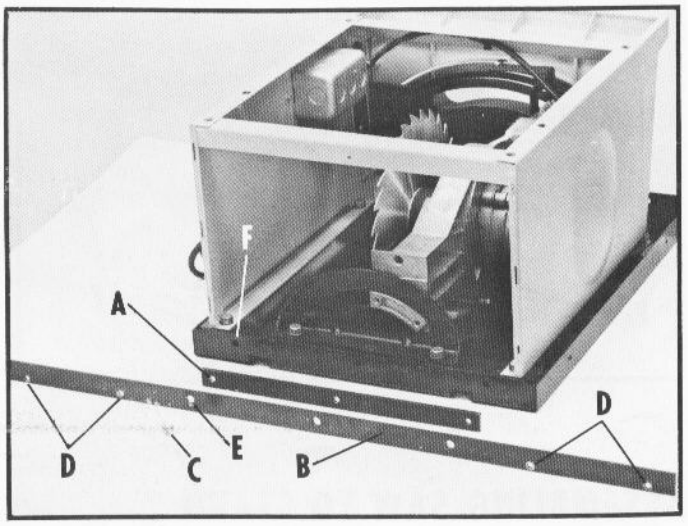


Fig. 7

3. Fig. 7, illustrates one of the reinforcing bars (A) and extension wing support bars (B) supplied with the saw along with the 5/16" x 1/2" round head screw (C). Proceed as follows to assemble these items to the rear of the saw table.

4. With the extension wing support bar (B) Fig. 7 and 8, positioned so that the small holes (D) are towards the top of the table as shown, insert the 5/16" x 1/2" round head screw (C) in the large hole (E) of the wing support bar. Place the reinforcing bar (A) behind the saw table flange so that one of the threaded end holes in the reinforcing bar (A) is in line with the left hand through hole (F) Fig. 7, in the table flange. Then place the wing support bar (B) and screw (C) against the outside of the table flange and run the screw thru the flange and into the threaded hole in the reinforcing bar (A).

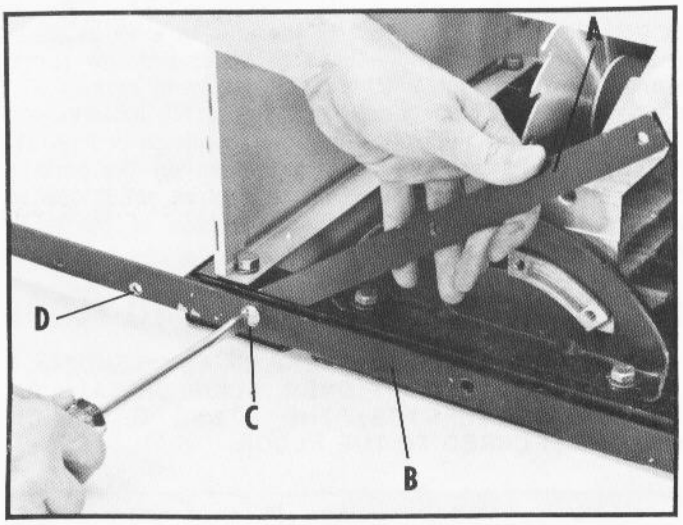


Fig. 8

5. Assemble the remaining extension wing support bar (B) Fig. 9, and reinforcing bar (A) to the front of the saw table making sure that the two small holes (C) at the ends of wing support bar (B) are towards the top of the table, as shown. The 5/16" x 1/2" round head screw (D) is to be inserted thru hole (E) of the wing support bar (B) and thru hole (F) of saw table flange and threaded into the threaded hole (G) of the reinforcing bar (A).

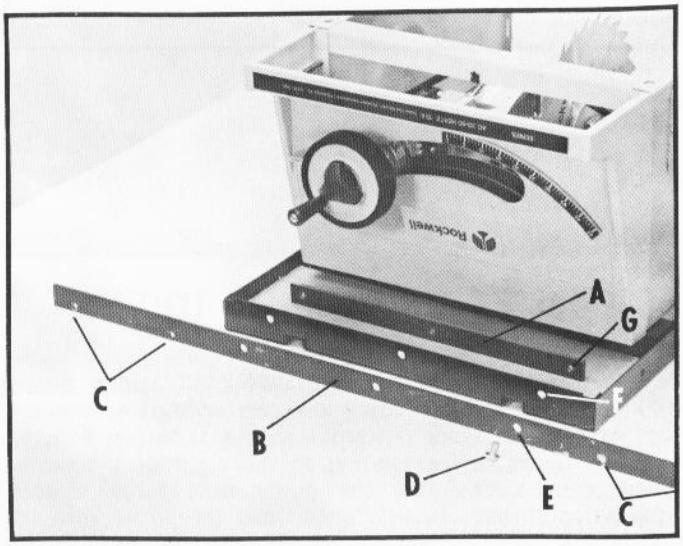


Fig. 9

6. Refer to Fig. 10 and 10A for the following instructions on assembling the extension wings to the saw. Place the extension wings (F) upside down and in position on each side of the saw table. Fasten each wing to the table using two internal tooth lockwashers (B) and two hex head sheet metal screws (A) in the two outside holes (G) of the wing and the two holes in the table flange. Then fasten each wing to the two wing support bars using four #10 x 3/8" round head screws (C), external tooth lockwashers (D) and #10 hex nuts (E).

7. Replace the back panel of the saw cabinet using the screw removed in STEP 2.

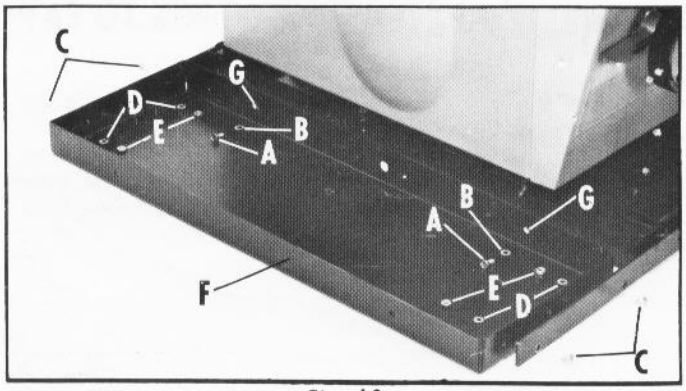


Fig. 10

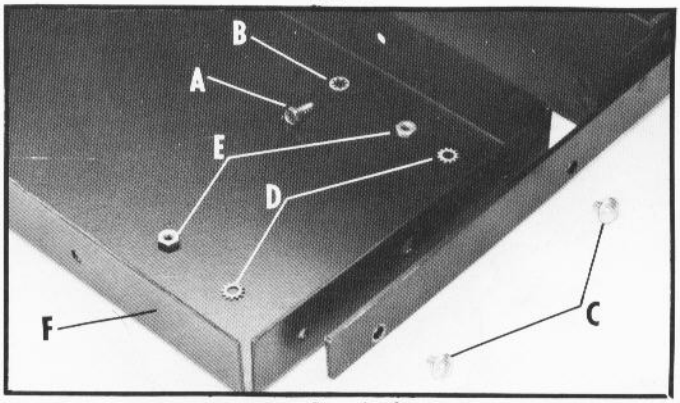


Fig. 10A

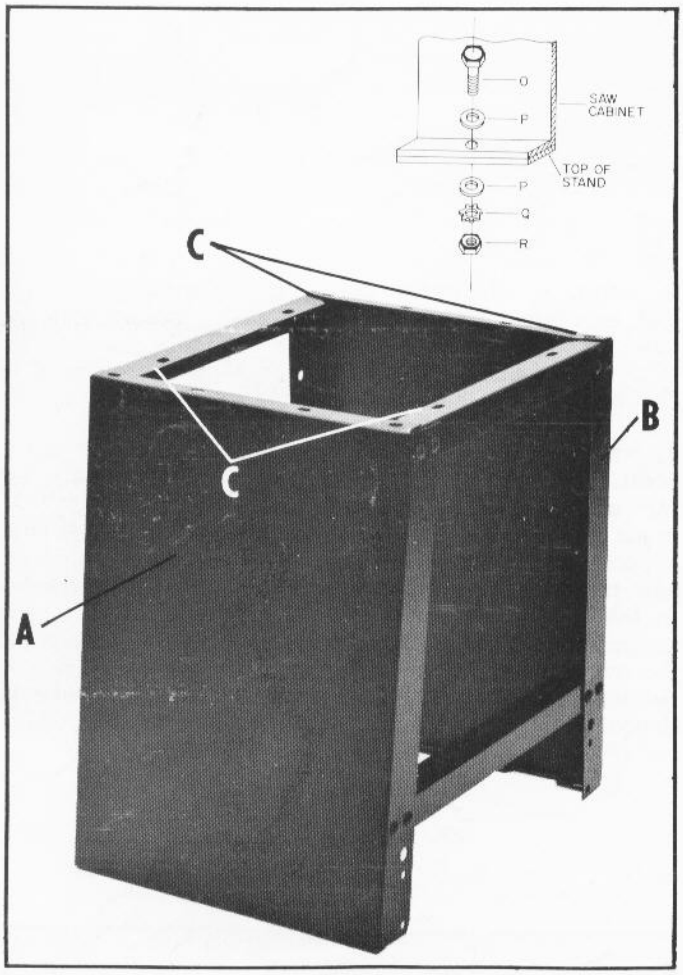


Fig. 11

ASSEMBLING SAW TO STAND

Turn the saw right side up and set it on the stand. The front of the saw can be towards either panel (A) or (B) Fig. 11. If the front of the saw is towards panel (A), the holes (C) will be used to mount the saw to the stand. Use the four 1/4" x 3/4" hex head screws (O), eight 1/4" flat washers (P), four 1/4" lockwashers (Q) and 1/4" hex nuts (R) supplied, as shown in Fig. 11. NOTE: If the saw does not sit flush on the surface of the stand, shim the bottom of the cabinet using wooden wedges before bolting to prevent warpage of the table which might cause misalignment.

FASTENING STAND OR BENCH TO FLOOR

IF DURING OPERATION THERE IS ANY TENDENCY FOR THE TOOL TO TIP OVER, SLIDE OR WALK ON SUPPORTING SURFACE, THE STAND OR BENCH MUST BE SECURED TO THE FLOOR.

ASSEMBLING GUIDE RAILS TO SAW

1. Install the guide rail with the calibrations on the front of the saw table using the two special screws (A) and two large spacers (B) provided, as shown in Fig. 12. With the guide rail extending to the right of the table, insert each screw thru the guide rail, large spacer, wing support bar, table flange and thread it into the reinforcing bar. Tighten all screws going into the reinforcing bar.

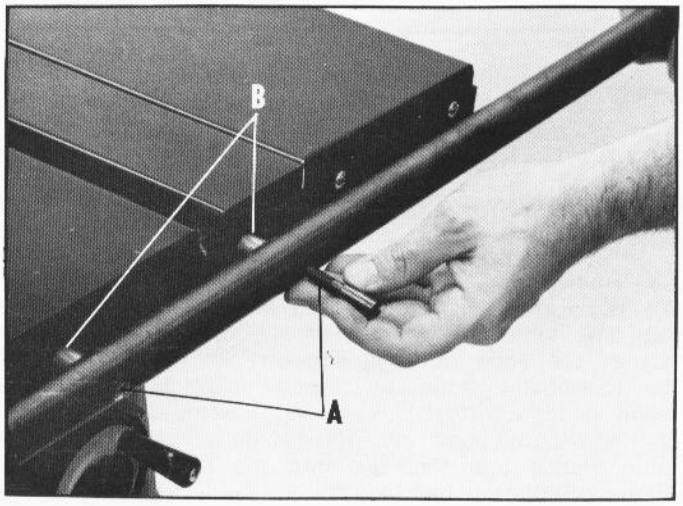


Fig. 12

2. Install the plain guide rail on the rear of the saw table using the two special screws (A) and two small spacers (B) provided, as shown in Fig. 13. With the guide rail extending to the left of the table, insert each screw thru the guide rail, small spacer, wing support bar, table flange and thread it into the reinforcing bar. Tighten all screws going into the reinforcing bar.

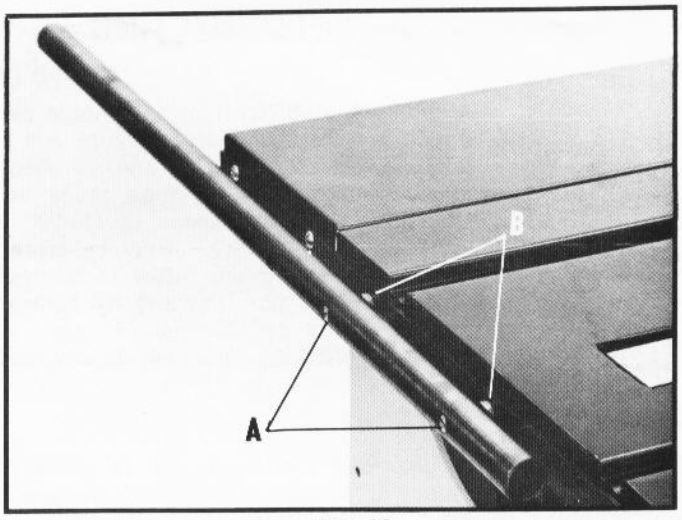


Fig. 13

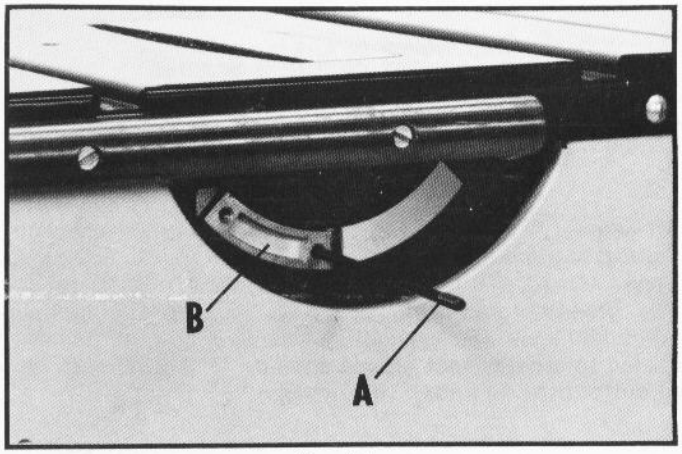


Fig. 14

ASSEMBLING BLADE GUARD AND SPLITTER ASSEMBLY

IMPORTANT: THE BLADE GUARD AND SPLITTER ASSEMBLY MUST BE ALIGNED PROPERLY TO THE SAW BLADE IN ORDER TO PREVENT KICKBACK.

1. Assemble the threaded rod (A) Fig. 14, to the right hand hole in the sliding trunnion bracket (B).

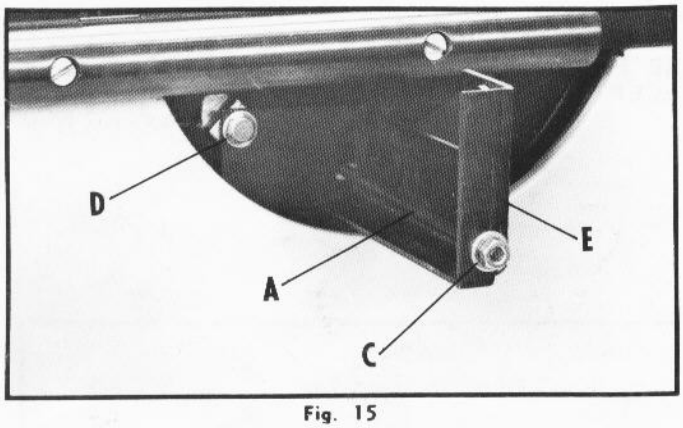


Fig. 15

2. Assemble the bracket (E) Fig. 15, to the threaded rod (A) and fasten finger tight using the washer, lockwasher and nut (C). The hex head screw, washer and lockwasher (D) are used to fasten the left side of the bracket to the sliding trunnion bracket.

3. Raise the saw blade to the highest position and assemble the splitter, guard and anti-kickback finger assembly to the bracket using the two screws and washers (F) Fig. 16. Adjust the splitter so that it does not rest against the table.

4. Using a straight edge, align the splitter (G) to the saw blade (H) Fig. 16, and tighten the screw and nut that holds the bracket (E) to the trunnion. If necessary the bracket (E) can be shifted in order to align the splitter to the saw blade.

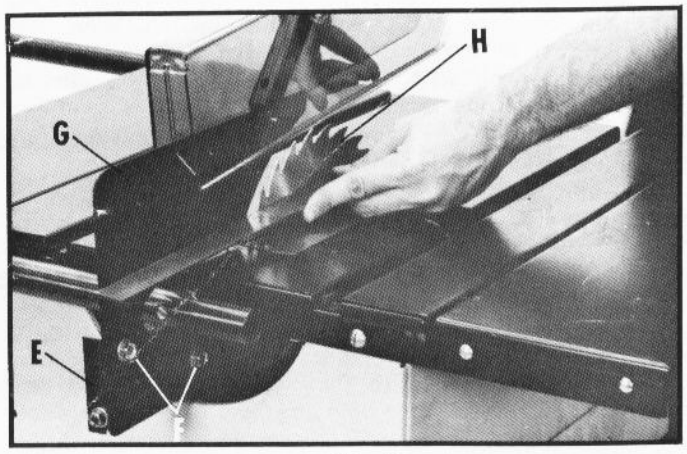


Fig. 16

CONNECTING SAW TO POWER SOURCE

POWER CONNECTIONS

A separate electrical circuit should be used for your power 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 tools plug. For distances up to 100 feet use #12 wire. For distances up to 150 feet use #10 wire. Replace or repair damaged or worn cord immediately. Before connecting the motor to the power line, make sure the saw switch is in the "OFF" position and be sure that the electric current is of the same characteristics as stamped on saw nameplate. All line connections should make good contact. Running on low voltage will injure the motor.

GROUNDING INSTRUCTIONS

This tool must be grounded while in use to protect the operator from electric shock. The motor in your saw is shipped wired for 120 Volt, Single Phase and is equipped with an approved 3-conductor cord and 3-prong grounding type plug to fit the proper grounding type receptacle, as shown in Fig. 17. The green conductor in the cord is the grounding wire. Never connect the green wire to a live terminal.

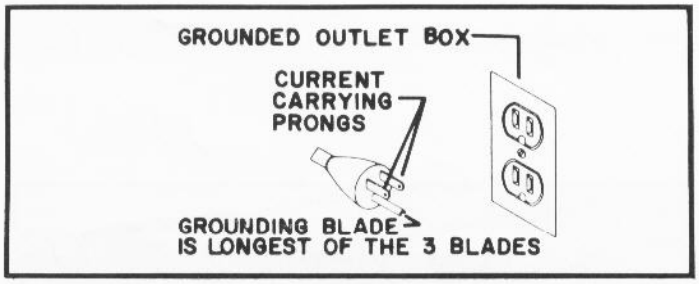


Fig. 17

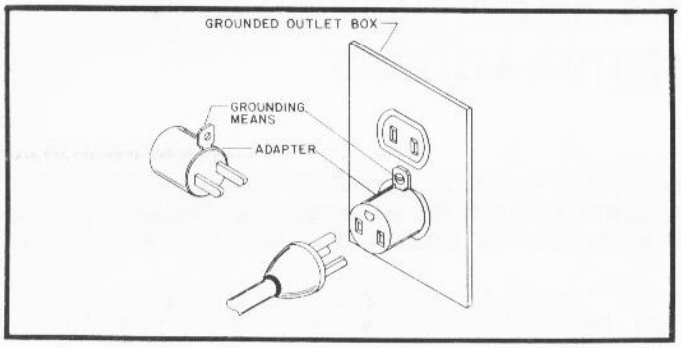


Fig. 18

An adapter, shown in Fig. 18, is available for connecting 3-prong grounding type plugs to 2-prong receptacles. THIS ADAPTER IS NOT APPLICABLE IN CANADA. The green-colored rigid ear, lug, etc., extending from the adapter is the grounding means and must be connected to a permanent ground such as to properly grounded outlet box, as shown in Fig. 18.

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

SWITCH

The switch (B) is located on the left side panel of the saw cabinet, as shown in Fig. 19. To turn the saw "ON" move the switch to the up position. To turn the saw "OFF" move the switch to the down position. WE SUGGEST THAT WHEN THE SAW IS NOT IN USE, THE SWITCH BE LOCKED IN THE "OFF" POSITION. This can be done by grasping the switch lever and pulling it out of the switch. With the switch lever removed the switch will not operate. However, should the switch lever be removed while the saw is running, it can be turned "OFF" once, but can not be restarted without inserting the switch lever.

OVERLOAD PROTECTION

Your saw is equipped with a reset overload relay button (A) Fig. 19. If the motor shuts off or fails to start due to overloading (cutting stock too fast, using a dull blade, using the saw beyond its capacity, etc.) or low voltage turn the switch to the "off" position, let the motor cool three to five minutes and push the reset button (A), which will reset the overload device. The motor can then be turned on again in the usual manner.

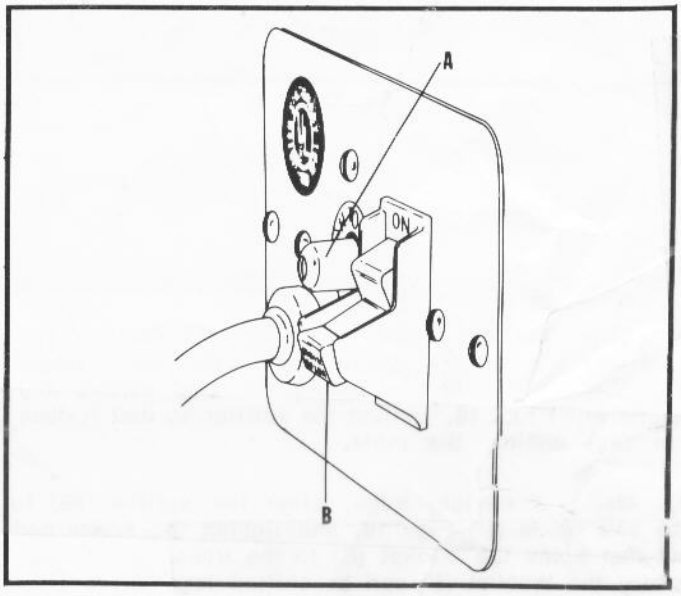


Fig. 19

RIP FENCE OPERATION AND ADJUSTMENTS

IMPORTANT: THE RIP FENCE MUST BE PROPERLY ALIGNED TO THE MITER GAGE SLOT IN ORDER TO PREVENT KICKBACK WHEN RIPPING.

The rip fence can be used on either side of the saw blade. The most common location is on the right hand side. To move the rip fence, loosen both front lock knob (A), and rear lock knob (B) Fig. 20, and move the fence to the desired position. If an adjustment to the pointer is necessary, loosen pointer screw and move pointer to the correct position.

The blade is set parallel to the miter gage slot at the factory. The fence should be adjusted so it is parallel to the miter gage slot. To check the rip fence, set it at one of the miter gage slots, as shown in Fig. 20. Tighten the front lock knob (A) and rear lock knob (B). The fence should then line up parellel with the miter gage slot. If an adjustment is necessary, loosen fence adjusting screws (D) and rear lock knob (B) Fig. 20. With the front lock knob (A) still tight, move back end of fence to the right or left lining it up to the miter gage slot. Then tighten rear lock knob (B) and fence adjusting screws (D) Fig. 20.

NOTE: Should the fence tend to bind on the guide rails, loosen the fence adjusting screws (C and D) and move the end blocks out in the slotted holes.

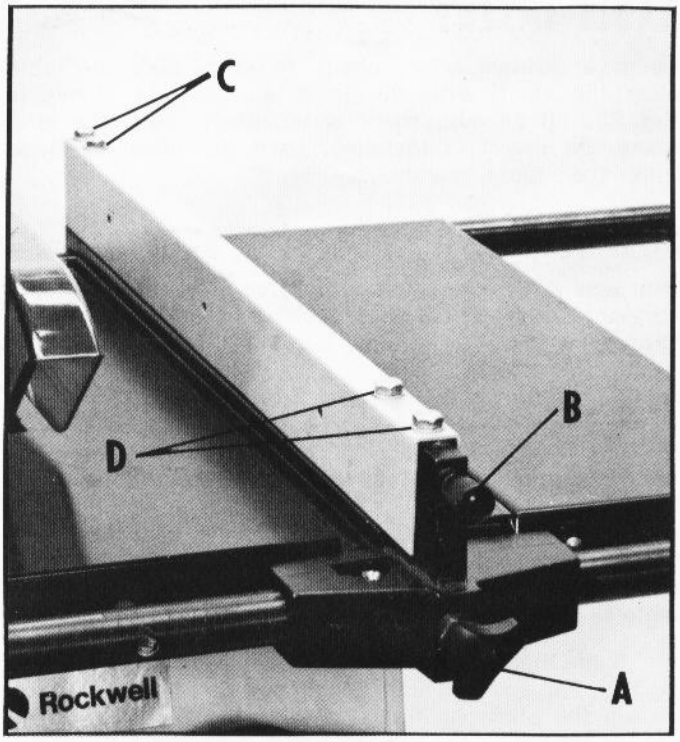


Fig. 20

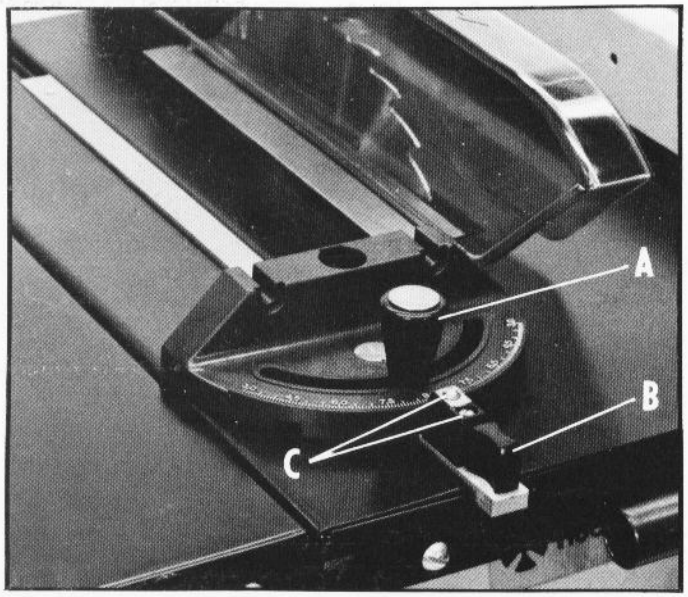


Fig. 21

MITER GAGE OPERATION AND ADJUSTMENTS

The miter gage supplied with your saw is accurately constructed and equipped with index stops at 90 degrees and 45 degrees right and left. To operate the miter gage, simply loosen the lock knob (A) Fig. 21, pull out plunger (B), rotate the miter gage to the desired angle and tighten lock knob (A). When using the miter gage at 90 degrees and 45 degrees right or left, push in on the plunger (B) so it engages the slots in the miter gage body.

To adjust the miter gage, set it at 90 degrees, as shown in Fig. 21. Make a cut on a scrap piece of wood. Then with a square, check to see if the piece of wood was cut at 90 degrees. If an adjustment is necessary, loosen two screws (C) and with the plunger (B) pushed in, move the miter gage body. Tighten two screws (C) and make another cut. Continue this adjustment until you are certain you have a 90 degree cut and set the pointer to 90 degree mark on the scale.

BLADE TILTING MECHANISM

To tilt the saw blade for bevel cutting, loosen the lock handle (B) Fig. 22, by moving it to the left, and turn the blade tilting handwheel (C). When the desired angle is obtained, tighten lock handle (B) Fig. 22.

The angle of the blade can be seen on the tilt angle scale conveniently located on the front of the cabinet.

BLADE RAISING MECHANISM

To raise or lower the saw blade, loosen the lock knob (D) and turn the raising handwheel (A) Fig. 22. When the desired blade height is obtained, tighten lock knob (D) Fig. 22. With the exception of hollow ground blades, the blade should be raised 1/8" to 1/4" above the top surface of the material being cut. With hollow ground blades the blade should be raised to the maximum to provide greater clearance.

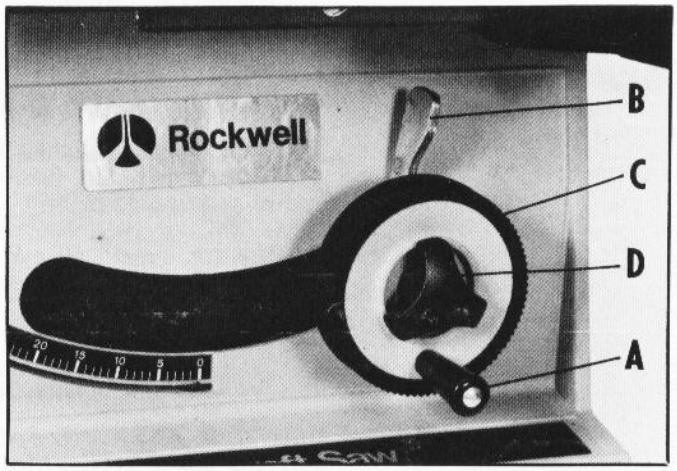


Fig. 22

TABLE INSERT

Using a straight edge, check to make sure the table insert is flush with the table surface, as shown in Fig. 23. If an adjustment is necessary, bend the tabs where the insert is fastened, until the insert is flush with the table surface.

ADJUSTING 90° POSITIVE STOP

Your saw is equipped with a positive stop at 90 degrees To check and adjust the positive stop, proceed as follows:

1. Raise the saw blade to its maximum.

2. Set the blade at 90 degrees to the table by turning the blade tilting handwheel counterclockwise as far as it will go.

3. Place a square on the table as shown in Fig. 23, and check to see if the blade is at a perfect 90 degree angle to the table.

4. If the blade is not at 90 degrees, back off set screw (A) Fig. 23. and turn the tilting handwheel until you are certain the blade is at 90 degrees to the table. Then tighten set screw (A) Fig. 23, until it contacts the stop. Recheck and adjust further if necessary.

5. When you are sure the blade is at 90 degrees, make sure the pointer on the tilting angle scale reads 0 degrees.

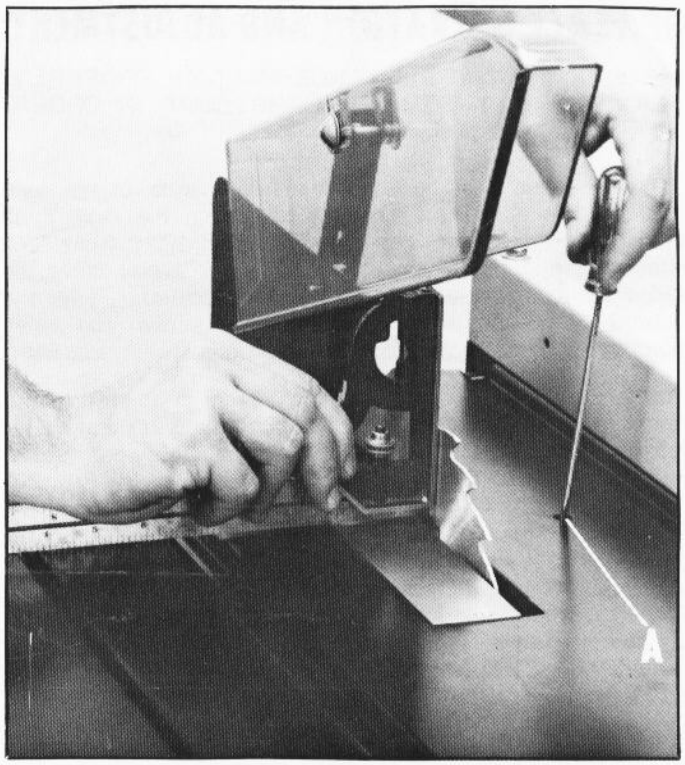


Fig. 23

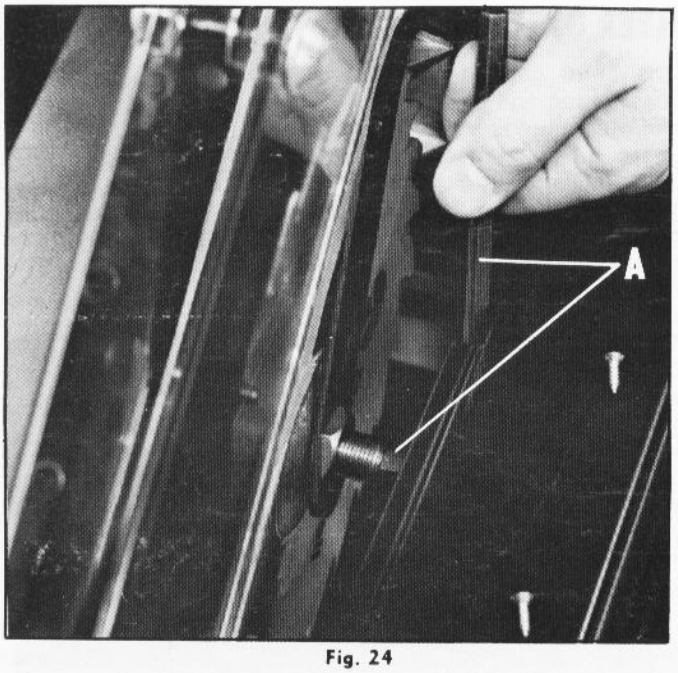


Fig. 24

REMOVING SAW BLADE

1. To remove the saw blade from your saw, first disconnect the saw from the power source and raise the saw blade to the maximum height.

2. Remove the table insert.

3. Place the hex wrench (A) in the hex slot in the end of the arbor and, with a wrench, turn the arbor nut toward you, as shown in Fig. 24.

SAW BLADES

The saw blade furnished with your saw is a Combination Blade suitable for both crosscutting (across the grain) and ripping (with the grain.)

Saw blades should always be sharp and unless you are capable of properly sharpening or setting saw blades, we suggest you locate a reputable sharpening service to sharpen your blade.

Always keep saw blades clean.

CAUTION: ABRASIVE WHEELS OF ANY KIND SHOULD NOT BE USED WITH YOUR SAW.

BELT REPLACEMENT

Should you find it necessary to remove or replace the drive belt of your saw, proceed as follows:

1. Disconnect the saw from the power source.

2. Remove the table insert and saw blade.

3. Slide the belt (A) Fig. 25, off the motor shaft and at the same time slide off the blade arbor flange (B).

4. Reassemble in the reverse order.

BRUSHES

Brush life varies. It depends on the load on the motor. For a new machine or after a new set of brushes has been installed, check the brushes after the first 50 hours of use.

After the first check, examine them after about every 10 hours of use until such time that replacement is necessary.

When carbon on either brush is worn to 3/16" in length or if either spring or shunt wire is burned or damaged in any way, replace both brushes.

The brush holders are located on the end of the motor housing opposite each other. If the brushes are found servicable after removing, reinstall them in the same position as removed.

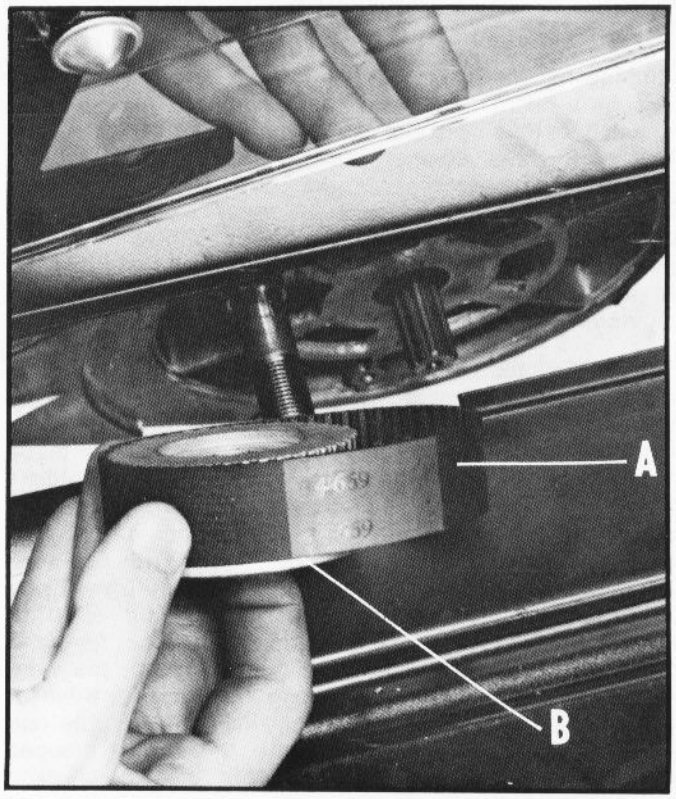


Fig. 25

OPERATION

Plain sawing includes ripping and cross cutting, plus a few other standard operations of a fundamental nature. The following methods feature safety. As with all power tools there is a certain amount of hazard involved with the operator and his use of the tool. Using the tool with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or completely ignored, personal injury to the operator can develop.

CROSS CUTTING

Cross cutting requires the use of the miter gage to position and guide the work. Place the work against the miter gage and advance both the gage and work toward the saw blade, as shown in Fig. 26. The miter gage may be used in either table slot, however, most operators prefer the left groove for average work. When bevel cutting (blade tilted), use the table groove that does not cause interference of your hand or miter gage with the saw blade guard.

Start the cut slowly and hold the work firmly against the miter gage and the table. One of the rules in running a saw is that you never hang onto or touch a free piece of work. Hold the supported piece, not the free piece that is cut off. The feed in cross cutting continues until the work is cut in two, then the miter gage and work are pulled back to the starting point. Before pulling the work back, it is good practice to give the work a little sideways shift to move the work slightly away from the saw blade. Never pick up any short length of free work from the table while the saw is running. A smart operator never touches a cut-off piece unless it is at least a foot long. Never use the fence as a cut-off gage when cross cutting.

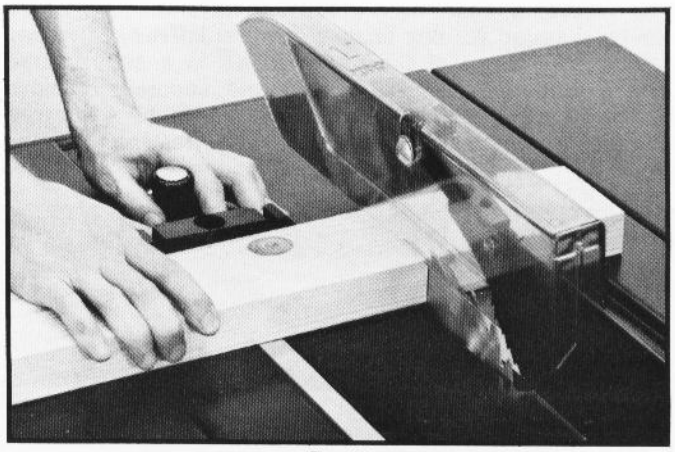


Fig. 26

For added safety and convenience the miter gage can be fitted with an auxiliary wood-facing that should be at least 1 inch higher than the maximum depth of cut, and should extend 12 inches or more on either side of the blade. This auxiliary wood-facing can be fastened to the front of the miter gage by using two wood screws through the holes provided in the miter gage body and into the wood-facing.

RIPPING

Ripping is the operation of making a lengthwise cut through a board, as shown in Fig. 27, and the rip fence is used to position and guide the work. One edge of the work rides against the rip fence while the flat side of the board rest on the table. Since the work is pushed along the fence, it must have a straight edge and make solid contact with the table. The saw guard must be used. The guard has anti-kickback fingers and a splitter to prevent the saw kerf from closing and binding the blade.

Start the motor and advance the work holding it down and against the fence. Never stand in the line of the saw cut when ripping. Hold the work with both hands and push it along the fence and into the saw blade as shown in Fig. 27. The work can then be fed through the saw blade with one or two hands. After the work is beyond the saw blade and anti-kickback fingers the hand is removed from the work. When this is done the work will either stay on the table, tilt up slightly and be caught by the rear end of the guard or slide off the table to the floor. Alternately, the feed can continue to the end of the table, after which the work is lifted and brought back along the outside edge of the fence. The waste stock remains on the table and is not touched with the hands until the saw is stopped unless it is a large piece allowing safe removal.

If the ripped work is less than 3 inches wide, a push stick should be used to complete the feed, as shown in Fig. 28. The push stick can easily be made from scrap material. When ripping 2 inches or narrower, make an auxiliary guide and fasten it to the rip fence, and use a push stick.

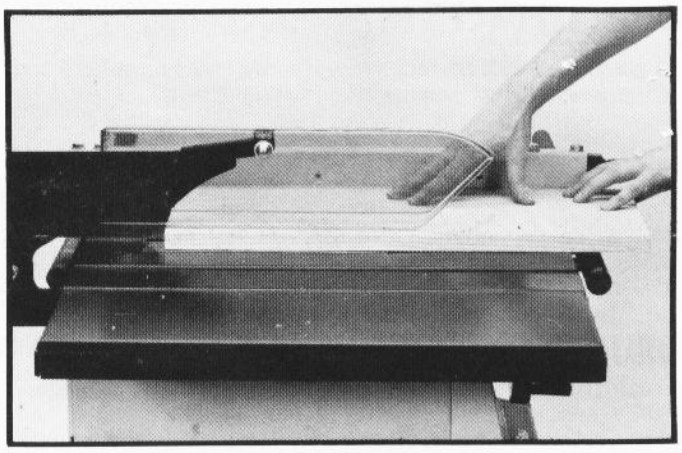


Fig. 27

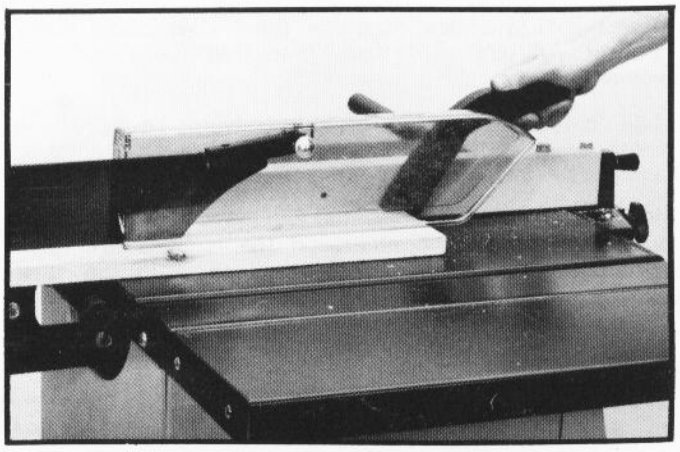


Fig. 28

USING ACCESSORY MOULDING CUTTERHEAD

Moulding is cutting a shape on the edge or face of the work. Cutting mouldings with a moulding cutterhead in the circular saw is a fast, safe and clean operation. The many different knife shapes available make it possible for the operator to produce almost any kind of mouldings, such as various styles of corner moulds, picture frames, table edges, etc.

The moulding head consists of a cutterhead in which can be mounted various shapes of steel knives, as shown in Fig. 29. Each of the three knives in a set is fitted into a groove in the cutterhead and securely clamped with a screw. The knife grooves should be kept free of sawdust which would prevent the cutter from seating properly.

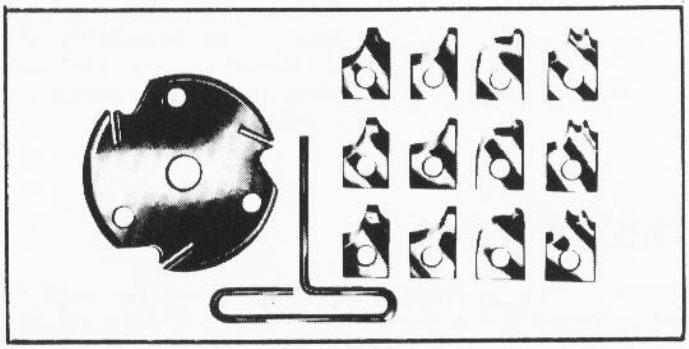


Fig. 29

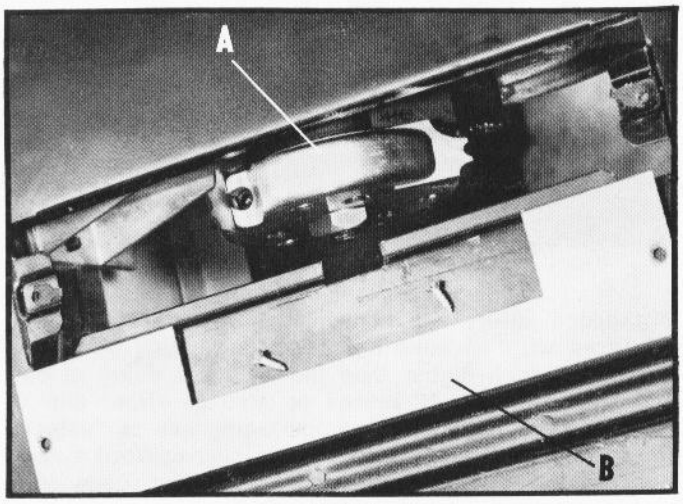


Fig. 30

The moulding cutterhead (A) Fig. 30, is assembled to the saw arbor in the same manner as the saw blade. The guard, splitter and anti-kickback finger assembly can not be used when moulding and must be removed from the saw as shown. Also, the Cat. No. 34-668 accessory moulding cutterhead table insert (B) Fig. 30, must be used in place of the standard table insert.

It is necessary when using the moulding cutterhead to add wood-facing to one or both sides of the rip fence as shown in Fig. 31. The wood-facing is attached to the fence with wood screws through the holes provided in the fence. 3/4 inch stock is suitable for most work although an occasional job may require 1 inch facing.

Position the wood-facing over the cutterhead with the cutterhead below the surface of the table. Turn the saw on and raise the cutterhead. The cutterhead will cut its own groove in the wood-facing. Fig. 31 shows a typical moulding operation. NEVER USE MOULDING CUTTERHEAD IN A BEVEL POSITION.

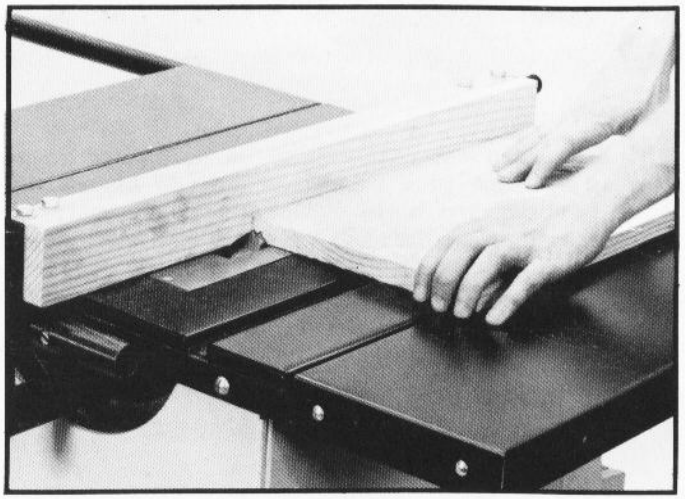


Fig. 31

IMPORTANT: NEVER RUN THE STOCK BETWEEN THE FENCE AND THE MOULDING CUTTERHEAD AS IRREGULAR SHAPED WOOD WILL CAUSE KICK-BACK.

When moulding end grain, the miter gage is used. The feed should be slowed up at the end of the cut to prevent splintering.

In all cuts, attention should be given the grain, making the cut in the same direction as the grain whenever possible.

ALWAYS INSTALL BLADE GUARD AFTER OPERATION IS COMPLETE.

USING ACCESSORY DADO HEAD

Dadoing is cutting a rabbet or a wide groove into the work. Most dado head sets are made up of two outside saws and four or five inside cutters, as shown in Fig. 32. Various combinations of saws and cutters are used to cut grooves from 1/8" to 13/16" for use in shelving, making joints, tenoning, grooving, etc. The cutters are heavily swaged and must be arranged so that this heavy portion falls in the gullets of the outside saws, as shown in Fig. 33. The saw and cutter overlap is shown in Fig. 34, (A) being the outside saw, (B) and inside cutter, and (C) a paper washer or washers which can be used as needed to control the exact width of groove. A 1/4" groove is cut by using the two outside saws. The teeth of the saws should be positioned so that the raker on one saw is beside the cutting teeth on the other saw.

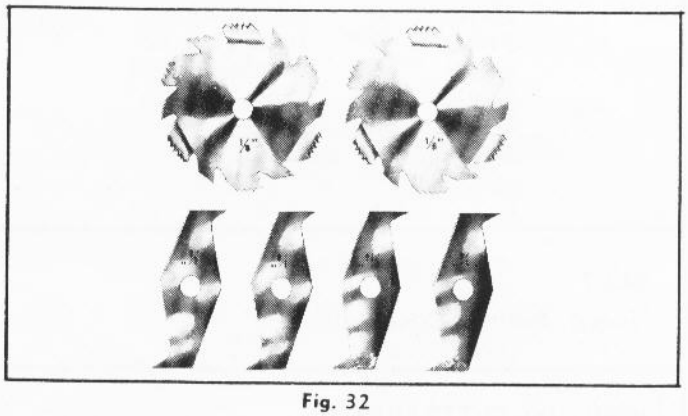


Fig. 32

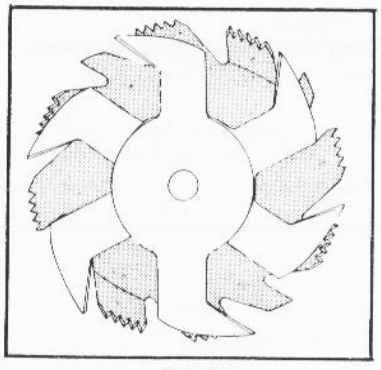


Fig. 33

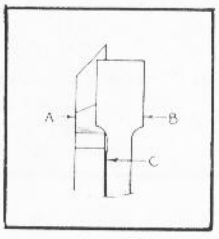


Fig. 34

The dado head set (A) Fig. 35, is assembled to the saw arbor in the same manner as the saw blade. The guard, splitter and anti-kickback finger assembly can not be used when dadoing and must be removed from the saw, as shown. Also, the Cat. No. 34-667 accessory dado head table insert (B) Fig. 35, must be used in place of the standard table insert.

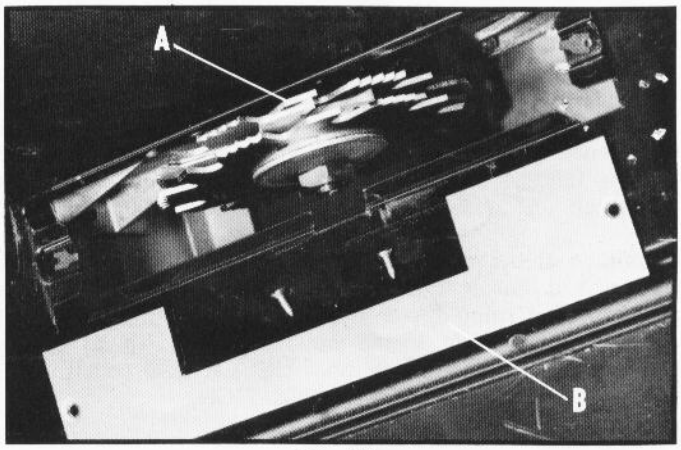


Fig. 35

A typical dado operation is shown in Fig. 36.

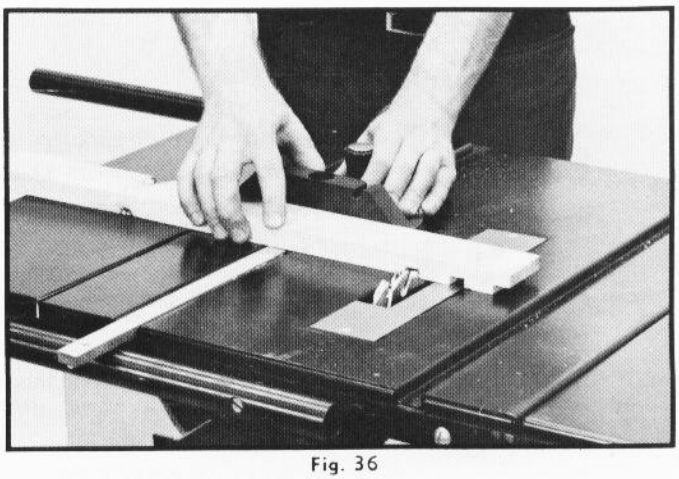


Fig. 36

NEVER USE THE DADO HEAD IN A BEVEL POSITION.

ALWAYS INSTALL BLADE GUARD AFTER OPERATION IS COMPLETE.

ACCESSORIES

SAW BLADES
ALL WITH 5/8" DIAMETER ARBOR HOLE

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34-105	10"	Combination
34-016	10"	Hollow Ground
34-841	10"	Carbide Tipped
34-018	10"	Cross Cut
34-017	10"	Rip

BELT

34-669 Positive Drive Belt

MOULDING CUTTERHEADS

No. 34-562 Moulding Cutterhead
No. 34-821 Basic Moulding Cutterhead Set. Includes 34-562 Cutterhead, 34-521 Wrench and 35-102 Knives.
No. 34-813 Deluxe Moulding Cutterhead Set. Same as above except with 35-102, 35-103, 35-221 and 35-222 Knives.

TABLE INSERTS

No. 34-668 Moulding Cutterhead Table Insert
No. 34-667 Dado Head Table Insert

DADO HEAD SETS

No. 34-333 Production Type Dado Head Set. With 5/8" arbor hole. Consists of two hollow-ground outer blades (6" dia. X 1/8" thick) and four inside cutters (one 1/4" thick; two 1/8" thick; one 1/16" thick)

No. 34-334 Economy Dado Head Set. With 5/8" arbor hole. Consists of two flat-ground outer blades (6" dia. X 1/8" thick) and five inside cutters (four 1/8" thick; one 1/16" thick)

No. 50-118 Caster Set for Stand

No. 34-578 Miter Gage

No. 34-569 Clamp Attachment for 34-578 Miter Gage

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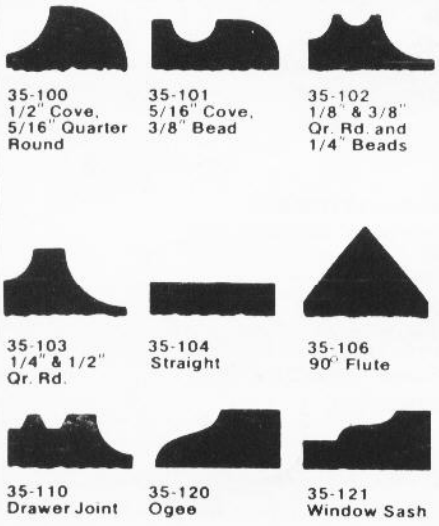


35-100 1/2" Cove, 5/16" Quarter Round

35-101 5/16" Cove, 3/8" Bead

35-102 1/8" & 3/8" Qr. Rd. and 1/4" Beads

35-103 1/4" & 1/2" Qr. Rd.

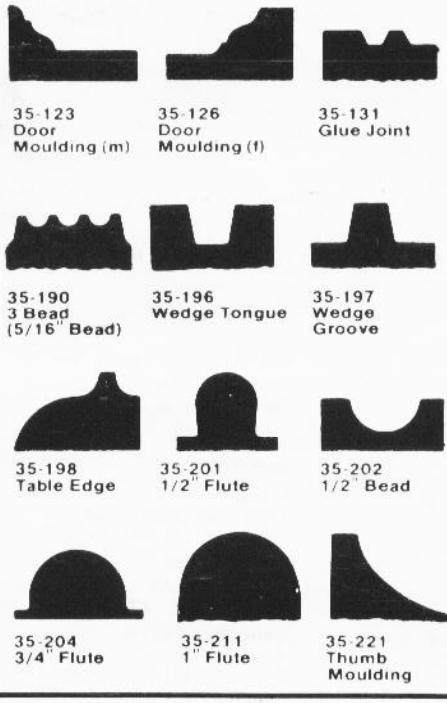
35-104 Straight

35-106 90° Flute

35-110 Drawer Joint

35-120 Ogee

35-121 Window Sash



35-123 Door Moulding (m)

35-126 Door Moulding (f)

35-131 Glue Joint

35-190 3 Bead (5/16" Bead)

35-196 Wedge Tongue

35-197 Wedge Groove

35-198 Table Edge

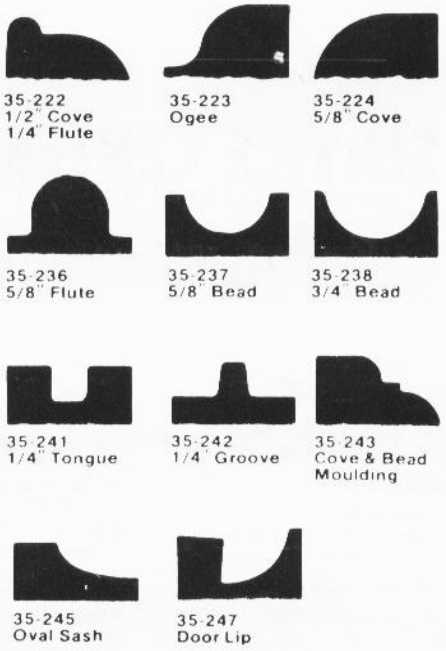
35-201 1/2" Flute

35-202 1/2" Bead

35-204 3/4" Flute

35-211 1" Flute

35-221 Thumb Moulding



35-222 1/2" Cove 1/4" Flute

35-223 Ogee

35-224 5/8" Cove

35-236 5/8" Flute

35-237 5/8" Bead

35-238 3/4" Bead

35-241 1/4" Tongue

35-242 1/4" Groove

35-243 Cove & Bead Moulding

35-245 Oval Sash

35-247 Door Lip

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