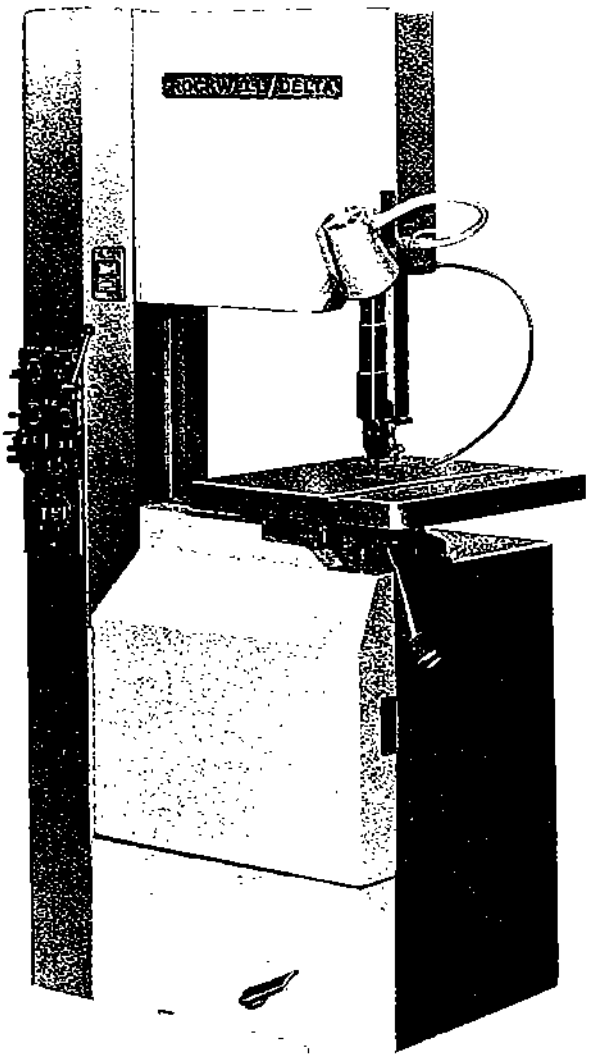
Instruction manual

Rockwell

20" Wood/ Non-Ferrous Cutting Band Saw



No. 28-340 Band Saw
Shown with Accessory 25-857 Lamp Attachment, 28-701 Blade Welder and Flash Grinder, 28-005 Blade Shear, and Electricals.

The Serial No./Model No. plate is attached to the frame of the machine. Locate this plate and record the Serial No. and Model No. in your manual for future reference.

SERIAL NO. _____

MODEL NO. _____

DATE OF PURCHASE _____

Part No. 426-04-651-5003

Dated 6-1-78

Replacement Parts

Ref. No.	Part No.	Description
150	426-04-063-5001	Table Insert
151	426-04-091-5002	Table
152	906-00-000-2438	1/8" Hex Soc. Pipe Plug
153	426-04-095-5002	Rear Trunnion
**	426-05-355-5008	Lower Blade Guide (Current Models Only, See Note A), Const. Of:
154	426-05-014-5036	Bracket
155	901-04-150-0206	5/16-18 X 5/16" Soc. Set Scr.
156	426-05-380-5001	Roller Ass'y.
157	1203002	Plate
158	904-01-010-1617	Washer
159	901-03-010-0760	1/4-20 X 1-1/4" Hex Soc. Cap Scr.
161	901-01-060-0649	5/16-18 X 1" Hex Hd. Scr.
162	426-04-095-5001	Front Trunnion
163	901-01-060-0632	7/16-14 X 2-3/4" Hex Hd. Scr.
164	426-02-027-0001	Table Clamp
165	901-01-060-0617	3/8-16 X 1-1/2" Hex Hd. Scr.
166	402-05-075-5001	Pointer
167	901-02-010-0502	1/4-20 X 1/4" Rd. Hd. Scr.
168	426-04-004-5003	Bar
169	901-04-020-0306	1/4-20 X 3/4" Sq. Hd. Set Scr.
170	902-01-120-1034	1/4"-20 Hex Nut
171	426-04-014-5012	Bracket
172	902-01-040-1004	7/16"-14 Hex Nut
173	426-05-072-5032	Scale
174	901-06-450-2252	2 X 3/16" Drive Scr.
175	904-01-010-1615	13/32 X 13/16 X 1/16" Washer
176	901-01-060-0648	3/8-16 X 1-1/4" Hex Hd. Scr.
177	426-04-112-5001	Threaded Bushing
178	901-01-060-0617	3/8-16 X 1-1/2" Hex Hd. Scr.
179	426-04-349-5004	Frame Ass'y. (Early Models Only, Prior to S/N 173-5645)
179	426-04-349-5005	Frame Ass'y. (Current Models Only, Beginning with S/N 173-5645)
180	426-05-331-5003	Upper Door, Incl:
181	901-02-010-0561	10-32 X 3/8" Rd. Hd. Mach. Scr.
182	426-05-068-5001	Latch
183	904-03-020-1775	10-Internal Tooth Lockwasher
184	902-01-120-1203	10-32 Hex Nut
185	Nameplate	By Request Only
186	901-06-450-2250	4 X 3/16" Drive Screw
187	901-02-140-0584	10-32 X 3/8" Bind. Hd. Scr.
188	904-03-020-1775	10-Internal Tooth Lockwasher
189	426-05-063-5006	Insert Handle
**	NOT SHOWN ASSEMBLED	

Ref. No.	Part No.	Description
190	426-05-331-5005	Lower Door (Early Models Only, Prior to S/N 173-5645) Incl:
190	426-05-331-5012	Lower Door (Current Models Only, Beginning with S/N 173-5645) Incl:
191	901-02-010-0561	10-32 X 3/8" Rd. Hd. Mach. Scr.
192	426-05-068-5001	Latch
193	904-03-020-1775	10-Internal Tooth Lockwasher
194	902-01-120-1203	10-32 Hex Nut
195	426-05-063-5006	Insert Handle
196	901-02-140-0584	10-32 X 3/8" Bind. Hd. Scr.
197	426-05-063-5006	Insert Handle
198	1201998	Rear Cover (Current Model)
199	426-05-331-5006	Rear Door (Early Models Only), Incl:
200	901-02-140-0584	10-32 X 3/8" Bind. Hd. Scr.
201	961-04-021-5001	Hinge
202	904-03-020-1775	Lockwasher
203	902-01-120-1203	10-32 Hex Nut
204	901-05-131-7351	12 X 1/2" Rd. Hd. Scr.
205	961-04-042-3110	Spring Catch
206	426-04-026-5001	Dust Spout
207	902-01-120-1203	10-32 Hex Nut
208	901-01-060-0648	3/8-16 X 1-1/4" Hex Hd. Scr.
209	904-01-010-1615	13/32 X 13/16 X 1/16" Washer
210	902-01-040-1026	3/8-16 Hex Nut
211	426-04-036-5001	Deflector
212	901-02-010-0559	10-32 X 1/2" Rd. Hd. Scr.
213	426-05-072-5028	Motor Plate
214	426-05-106-5012	Motor Plate Shaft
215	904-15-010-7008	Retaining Ring
216	1202596	5/16-18 Stud
217	904-02-010-1703	5/16" Lockwasher
218	902-01-020-5435	5/16"-18 Hex Nut
221	904-03-030-1756	Tooth Lockwasher
222	904-02-020-1704	3/8" Lockwasher
**		Lower Blade Guide (Early Models Only, See Note A) Const. Of:
223	426-05-014-5018	Bracket
224	901-04-150-0206	5/16-18 X 5/16" Soc. Set Scr.
225	1202640	Bearing Ass'y.
226	426-05-072-5020	Plate
227	426-05-072-5021	Plate
228	904-01-031-2626	Washer
229	901-03-010-0762	5/16-18 X 5/8" Hex Soc. Cap Scr.
230	901-03-010-0770	5/16-18 X 1-1/4" Soc. Hd. Cap Scr.
231 n	901-02-010-0502	1/4 - 20 x 1/4 Rd. Hd. Scr.
232 n	426-05-031-5007	Cover
233 n	400-06-603-0001	Envelope
234 n	400-06-079-0001	Retainer

NOTE:

A - All Units After Serial Number 174-0455 Incorporate A New Blade Guide Assembly (426-05-355-5008). This Current Assembly will Replace Either The Early Model Upper Or Early Model Lower Blade Guides. The Current Guide Assembly Is Completely Interchangeable With The Early Model Guides.

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.

23. **DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drugs, alcohol or any medication.

ADDITIONAL SAFETY RULES FOR BAND SAWS

1. **ADJUST** the upper guide about 1/8" above the material being cut.

2. **MAKE SURE** that blade tension and blade tracking are properly adjusted.

3. **STOP** the machine before removing scrap pieces from the table.

4. **ALWAYS** keep hands and fingers away from blade.

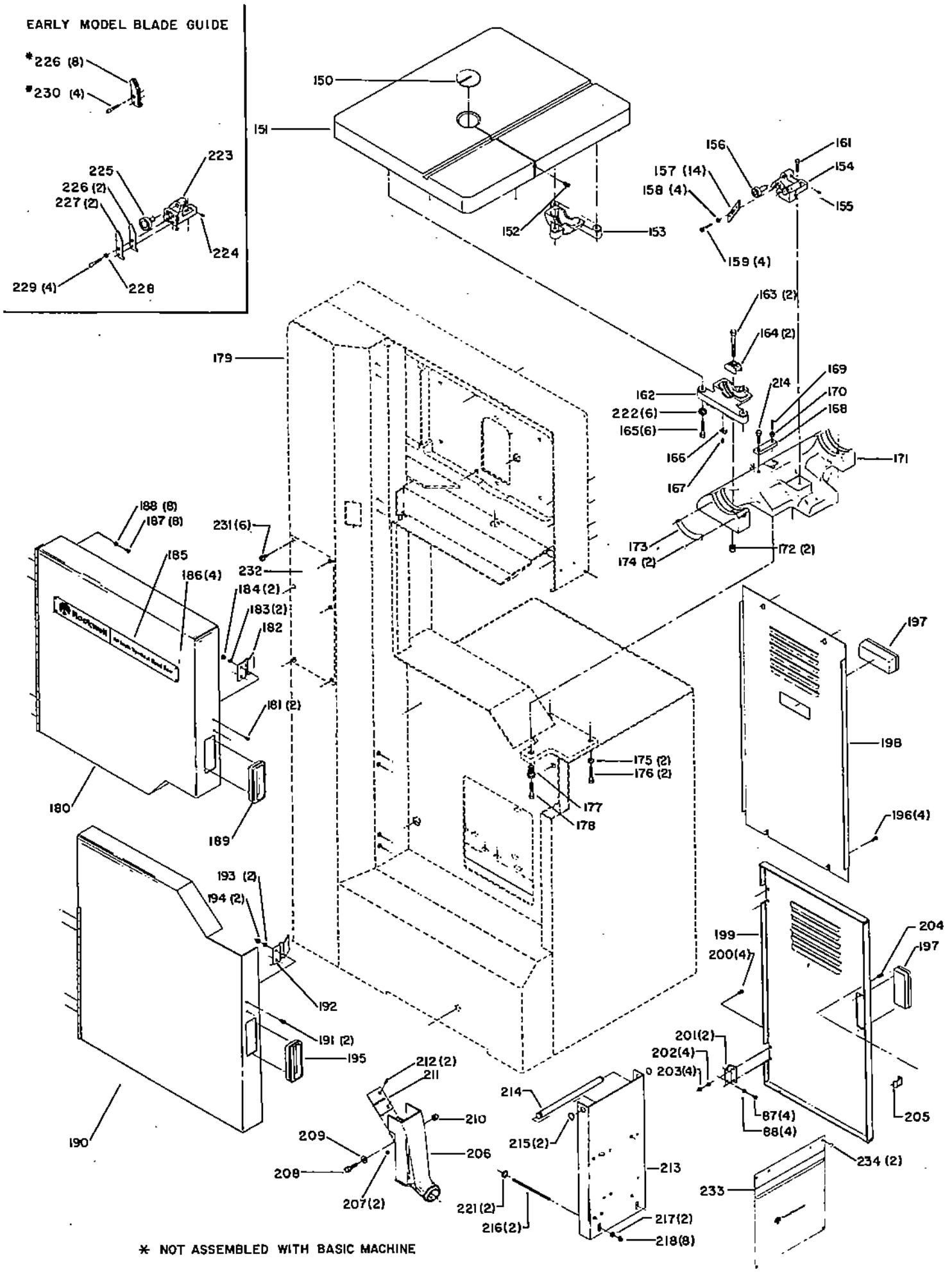
5. **CHECK** for proper blade size and type.

6. **DO NOT** attempt to saw stock that does not have a flat surface, unless a suitable support is used.

7. **HOLD** material firmly and feed into blade at a moderate speed.

8. **TURN OFF** machine if the material is to be backed out of an uncompleted cut.

9. **MAKE** "release" cuts before cutting long curves.


EARLY MODEL BLADE GUIDE
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* NOT ASSEMBLED WITH BASIC MACHINE

INTRODUCTION

All Rockwell Band Saws are carefully inspected and tested before shipment. While in transit, however, it is possible that the machine may get out of alignment. Therefore before putting the machine into operation give it a careful check and make adjustments where necessary. A carefully set up machine will save you time, trouble and money.

SELECTING FLOOR SPACE

It is important that the Band Saw be set on a solid, level foundation. If rocking occurs, place metal shims at the corners between the cabinet and floor. Lag screws or bolts should be used to secure the machine to the floor.

CLEANING THE BAND SAW

The machined and unpainted surfaces have been protected with a coating of rust preventive. This coating should be removed with a soft cloth moistened with kerosene or mineral spirits. (Do not use acetone, gasoline or lacquer thinner for this purpose.) After cleaning, cover all unpainted surfaces with a light film of good machine oil.

INSTALLING THE MOTOR, MOTOR PULLEY AND BELT

1. Assemble the motor to the motor plate, as shown in Fig. 2.

2. Assemble the motor pulley (A) Fig. 2, to the motor shaft, with the outside groove of the motor pulley aligned with the high-speed pulley (B), and tighten the set screw that holds the motor pulley to the motor shaft.

3. Assemble the belt (C) to the two pulleys, as shown in Fig. 2, and adjust belt tension as explained under ADJUSTING BELT TENSION.

4. The "O" ring belt (D) Fig. 2, is shown assembled to the chip blower (E), which is available as an accessory, and to the round groove of the motor pulley.

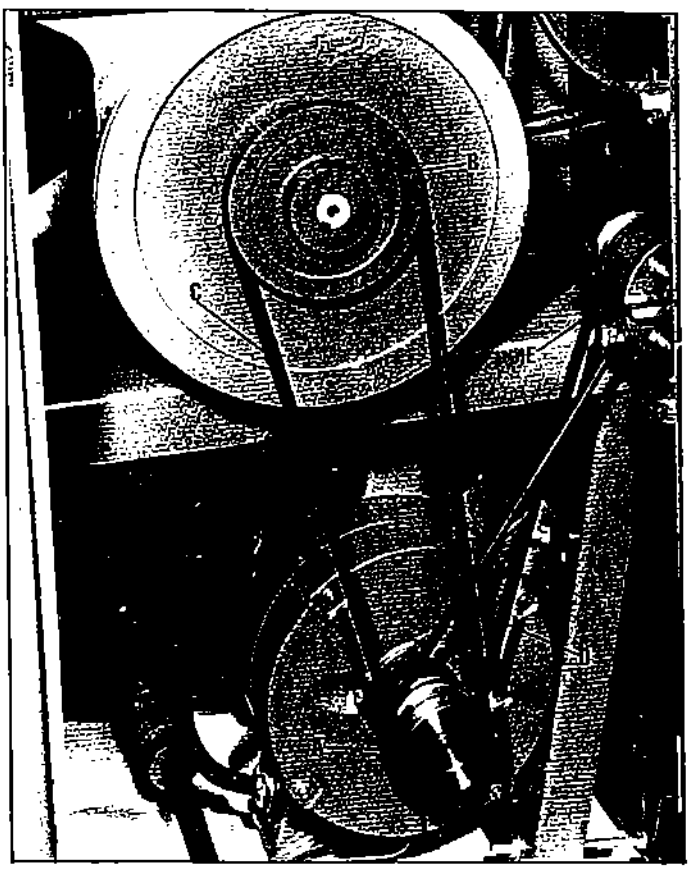

Fig. 2

Replacement Parts

Ref. No.	Part No.	Description
**	426-05-355-5008	Upper Blade Guide (Current Models Only, See Note A) Const. Of:
1	901-03-010-0760	1/4-20 X 1-1/4" Hex Soc. Cap Scr.
2	904-01-010-1617	Washer
3	1203002	Plate
4	426-05-014-5036	Bracket
5	426-05-380-5001	Roller Ass'y.
6	901-04-150-0206	5/16-18 X 5/16" Soc. Hd. Set Scr.
	426-05-354-5002	Blade Guard, Incl:
10 n	904-03-020-1775	#10 Lockwasher
11	902-01-120-1203	10-32 Hex Nut
12	901-02-010-7562	10-32 x 5/16 Scr.
13 n	901-02-010-0558	8-32 x 1/4 Rd. Hd. Scr.
14	426-05-014-5020	Guard Brkt.
15	901-01-060-0649	5/16-18 X 1" Hex Hd. Scr.
16	901-02-010-0558	8-32 X 1/4" Rd. Hd. Scr.
17	1200464	Finger Guard
18	1200465	Finger Guard Brkt.
19	904-03-030-1795	Shake Proof Lockwasher
20	902-01-120-1203	10-32 Hex Nut
21	901-02-140-0584	10-32 X 3/8" Binding Hd. Scr.
22	904-01-010-1609	13/64 X 7/16 X 1/16" Washer
23	901-02-140-0584	10-32 X 3/8" Binding Hd. Scr.
24	426-04-110-5003	Guide Post
25	426-04-014-5011	Guide Post Brkt.
26	901-02-010-0593	10-24 X 3/8" Rd. Hd. Scr.
27	904-01-010-1615	13/32 X 3/16 X 1/16" Lockwasher
28	901-01-060-3102	3/8-16 X 3/4" Hex Hd. Scr.
29	426-04-074-5002	Plug
30	928-01-041-3361	Spring
31	426-04-112-5002	Clamp Scr.
32	931-04-010-3635	Clamp Handle
33	901-02-120-7528	1/4-20 X 1/2" Truss Hd. Scr.
34	426-04-112-5001	Treaded Bushing
35	901-01-060-0617	3/8-16 X 1-1/2" Hex Hd. Scr.
36	426-04-400-5001	Up. Wheel, Incl:
37	426-04-094-5002	Tire
38	901-04-150-1133	1/2-20 X 3/4" Soc. Set Scr.
**	426-05-358-5002	Up. Wheel Headstock, Const. Of:
39	426-05-106-5005	Shaft
40	406-03-079-0001	Bearing Nut
41	920-04-020-5383	Bearing
42	426-04-079-5006	Spec. Jam Nut
43	426-05-058-5002	Headstock
44	920-08-020-5336	Bearing
45	902-01-201-2558	Spec. Hex Nut
46	901-11-010-2371	3/8-16 X 2-1/2" Sq. Hd. Bolt
47	904-01-010-1606	7/16 X 1 X 5/64" Washer
48	928-01-041-4148	Spring
49	426-04-052-5001	Gib
50	904-02-020-1704	3/8" Split Lockwasher
51	901-01-060-0642	3/8-16 X 1" Hex Hd. Scr.
52	426-04-072-5009	Tension Scale
53	901-02-010-0567	6-32 X 1/4" Rd.Hd. Scr.
54	426-05-084-5002	Slide
55	901-04-530-6149	1/2-13 X 1-15/16" Soc. Set Scr.
56	902-01-020-1266	1/2-13 Hex Jam Nut
57	904-01-010-1606	7/16 X 1 X 5/64" Washer
58	426-05-409-5001	Extension Incl:
59	905-01-010-2704	1/8 X 3/4" Roll Pin
60	426-04-072-5007	Slide Plate
61	904-02-020-1705	1/2" Split Lockwasher
62	901-01-060-0628	1/2-13 X 1" Hex Hd. Scr.
63	928-01-041-4149	Spring
64	951-01-011-3992	Pointer
65	426-04-074-5001	Plug
66	901-01-060-0617	3/8-16 X 1-1/2" Hex Hd. Scr.
67	426-04-112-5001	Treaded Bushing
68	952-01-121-3268	Tension Screw (Early Model) Threads One End Only
68	1201927	Tension Screw (Current Model) Threads Both Ends
69	905-01-010-2711	1/8 X 5/8" Roll Pin (Current Model Only)
70	422-02-100-2001	Handwheel (Current Model)
70	931-03-991-4766	Knob Ass'y., (Early Model), Incl:
70A	901-04-150-0206	5/16-18 X 5/16" Soc. Set Scr.
71	902-01-010-5900	3/8-16 Hex Nut (Current Models Only)
72	426-04-400-5002	Lower Wheel, Incl:
73	901-01-060-0623	1/4-20 X 1" Hex Hd. Scr.
74	904-02-020-1702	1/4" Split Washer
75	901-04-150-1133	1/2-20 X 3/4" Soc. Set Scr.
76	426-04-094-5002	Tire
77	426-04-015-5003	Brake Drum
**	426-04-358-5001	Lower Wheel Headstock, Const. Of:
78	426-04-079-5005	Bearing Locknut
79	426-04-079-5004	Spanner Nut
80	920-08-020-5340	Bearing
81	426-04-058-5002	Headstock
82	426-04-106-5006	Shaft
83	920-08-020-5339	Bearing
84	426-04-079-5006	Spec. Jam Nut
85	904-01-010-1615	13/32 X 13/16 X 1/16" Washer
86	901-01-060-0648	3/8-16 X 1-1/4" Hex Hd. Scr.
87	904-01-010-1606	7/16 X 1 X 5/64" Washer
88	902-01-040-1026	3/8-16 Hex Nut
89	901-01-060-0646	3/8-16 X 2" Hex Hd. Cap Scr.
90	904-01-010-1606	7/16 X 1 X 5/64" Washer
91	426-04-112-5001	Threaded Bushing
92	927-03-010-2653	1/4 X 1/4 X 1-15/16" Key
93	927-03-010-2620	1/4 X 1/4 X 1-1/2" Key
94	1201866	2 Step Drive Pulley, Incl:
95	901-04-150-6202	5/16-18 X 3/8" Set Scr.
96	49-132	V-Belt
97	1201865	Motor Pulley, Incl:
98	901-04-150-1185	1/4-20 X 5/16" Soc. Set Scr.
97	426-04-430-5001	Motor Pulley (1-1/8" Bore) Incl:
98	901-04-150-1185	1/4-20 X 5/16" Soc. Set Scr.
99	926-01-042-5514	Lo Speed Drive Pulley
100	901-04-150-6202	5/16-18 X 3/8" Set Scr.
101	926-05-022-5507	High Speed Drive Pulley
102	901-04-150-6202	5/16-18 X 3/8" Set Scr.
103	49-132	Lo Speed Belt
104	49-131	High Speed Belt
105	41-707	Motor Pulley (7/8" Bore) Incl:
106	901-04-150-0202	1/4-20 X 1/2" Hex Soc. Set Scr.
105	41-707	Motor Pulley (1 7/8" Bore) Incl:
106	901-04-150-0202	1/4-20 X 1/2" Hex Soc. Set Scr.
107	426-04-014-5003	Bracket
108	901-01-060-0648	3/8-16 X 1-1/4" Hex Hd. Scr.
109	426-04-106-5001	Steel Pin
110	905-05-040-2101	3/32 X 5/8" Cotter Pin
111	928-05-001-5878	Spring Washer
112	426-04-079-5007	Retainer
113	904-01-010-1615	13/32 X 13/16 X 1/16" Washer
114	904-02-020-1704	3/8" Split Lockwasher
115	902-02-040-1307	3/8"-16 Sq. Nut
116	426-04-315-5001	Brake Shoe w/Lining
117	902-01-040-1005	3/8"-16 Hex Jam Nut
118	904-01-010-1606	7/16 X 1 X 5/64" Washer
119	426-04-108-5003	Brake Rod
120	904-01-010-1606	7/16 X 1 X 5/64" Washer
121	928-01-301-8880	Spring
122	904-01-010-1606	7/16 X 1 X 3/64" Washer
123	426-04-067-5002	Treadle
124	901-04-020-0345	1/2-13 X 5/8" Sq. Hd. Scr.
125	426-04-017-5001	Brass Bushing
126	905-05-040-2107	Cotter Pin
127	426-04-067-5001	Brake Lever
128	901-04-150-0210	1/2-13 X 1/2" Soc. Set Scr.
129	426-04-106-5008	Shaft
130	904-10-021-2096	Set Collar
131	901-04-150-0206	5/16-18 X 5/16" Hex Soc. Set Scr.
**		Upper Blade Guide (Early Model Only, See Note A) Const. Of:
132	901-03-010-0762	5/16-18 X 5/8" Soc. Hd. Cap Scr.
133	904-01-031-2926	Washer
134	426-05-072-5021	Plate
135	426-05-072-5020	Plate
136	426-05-014-5021	Bracket
137	1202640	Bearing Ass'y.
138	901-04-150-0206	5/16-18 X 5/16" Soc. Hd. Set Scr.
139	901-03-010-0770	5/16-18 X 1-1/4" Soc. Hd. Cap Scr.

** NOT SHOWN ASSEMBLED

ADJUSTING BLADE TENSION

The blade is only under slight tension when the band saw is shipped from the factory. This is done to prevent weakening of the blade prior to its use. It is good practice to relax tension on the blade when the machine is not in use. To adjust blade tension, proceed as follows:

1. Turn the blade tension knob (A) Fig. 3, clockwise until the pointer (A) Fig. 4, is on the mark on the tension scale (B), which is equal to the blade width.

2. The tension scale (B) Fig. 4, is correct for standard blades used on average work. It is not affected by variations in blade length and is equally accurate when the blade has been shortened by welding or brazing. Experienced operators may rely upon the feel or tone of the blade for adjusting tension. We recommend the use of the scale to avoid blade breakage, by too much or too little tension. For a blade which is thicker than standard, run the tension pointer slightly higher than the mark on the scale.

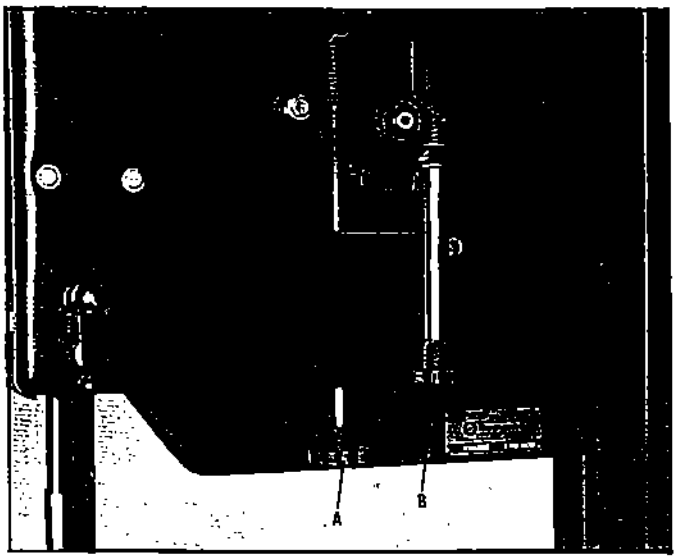

Fig. 3

TRACKING THE BLADE

For accurate work and maximum blade life, it is important that the blade be centered on the upper wheel. When this adjustment has been properly made, the blade will "track". That is, it will run steadily in the same line. Before the tracking adjustment is made, both the upper and lower blade guides must be moved away from the blade. To "track" the blade, proceed as follows:

1. Disconnect the machine from the power source and make sure that correct blade tension is applied to the blade.

2. Revolve the upper wheel forward slowly by hand and turn the tracking adjustment hand knob (B) Fig. 3, until the blade travels in the center of the upper tire.

3. Connect the machine to the power source and jog the motor switch on and off to be certain that proper tracking is being maintained.

4. Then make any minor final adjustments that may be necessary at operating speed.

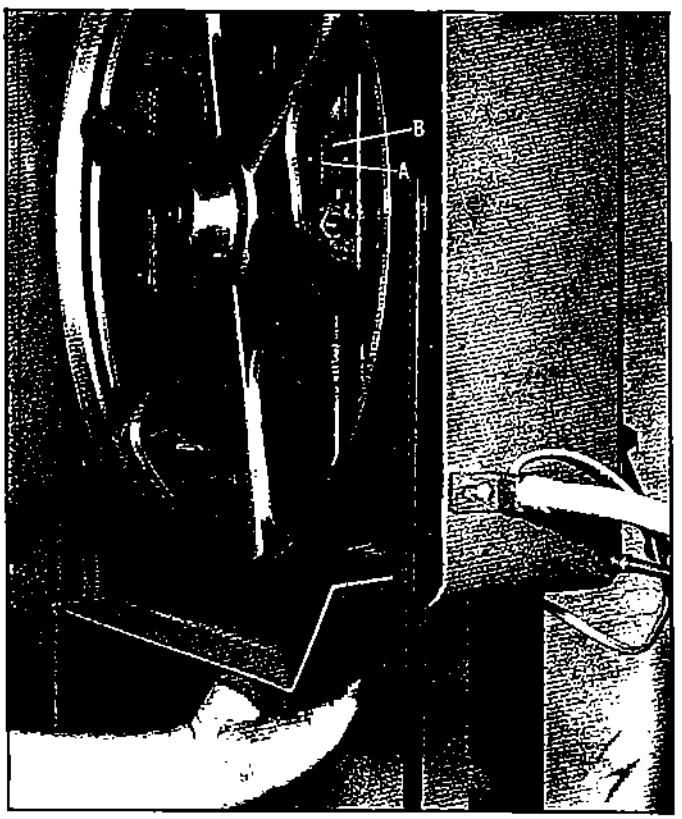

Fig. 4

NOTE: To avoid the possibility of injury to the blade or operator, the initial tracking adjustment should not be made while the machine is under power, since at high speed the blade may run off the wheel almost instantly. THE TRACKING KNOB SHOULD BE ADJUSTED ONLY A FRACTION OF A TURN AT A TIME AS VERY LITTLE TILT OF THE UPPER WHEEL IS REQUIRED TO DRAW THE BLADE ACROSS THE WHEEL. Each blade has its own tendencies, especially after welding or brazing. The blade tracking adjustment must, therefore, be repeated whenever a new or repaired blade is installed, regardless of previous adjustments.

Rockwell International

28—340 20" WOOD/NON-FERROUS CUTTING BAND SAW

BS—3A

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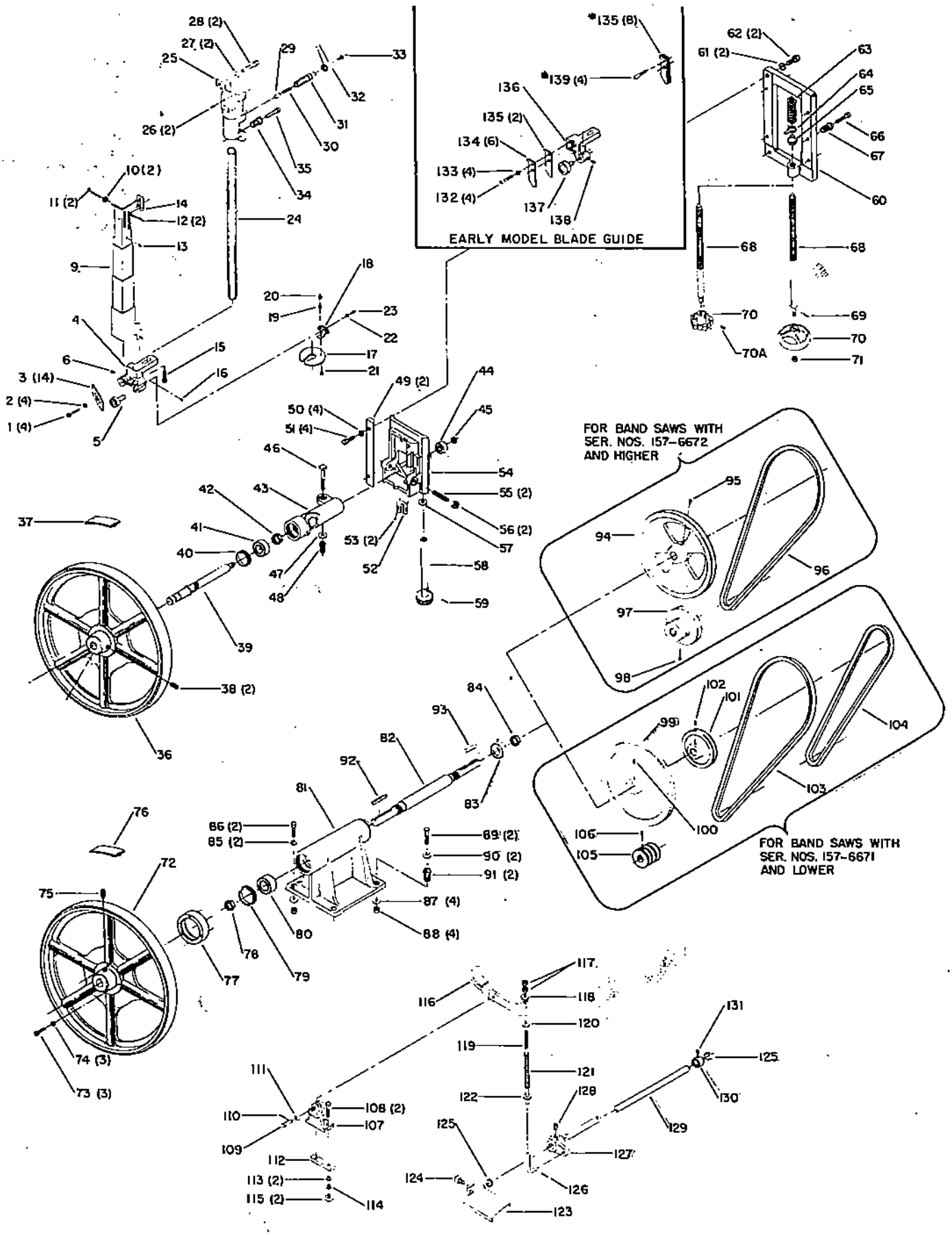
Revised 4-1-80



* NOT ASSEMBLED WITH BASIC MACHINE

ADJUSTING BLADE GUIDES

The upper and lower blade guides are to be adjusted only after the blade is tensioned and is tracking properly. The blade guide plates (A) Figs. 5 and 6, are fastened to the blade guide brackets as shown. A total of 28 individual guide plates are supplied to accomodate any blade width up to 1". Guide plates can be added or removed from the blade guide brackets depending on the width of the blade being used, as follows:

1. To add or remove guide plates (A) Figs. 5 and 6, remove the four screws and washers (B). Add or remove the necessary number of guide plates (A) until the front edge of the guide plates are just behind the bottom of the saw blade tooth gullets, leaving all of the set portion of the blade free of the guide. Then tighten the four screws (B). NOTE: This adjustment is critical since the teeth of the blade will be damaged if the guide plates are too far forward. If the guide plates are too far back the blade will not be adequately supported.

2. The upper and lower blade guide plates (A) Figs. 5 and 6, should be parallel to each other and as close as possible to the blade without binding it. Rotate the upper wheel by hand, causing the entire length of the blade to pass through the guide plates. This is done to be sure the weld or braze (where extra thickness may be found) will not bind. If necessary, separate the guide plates to accommodate the extra thickness.

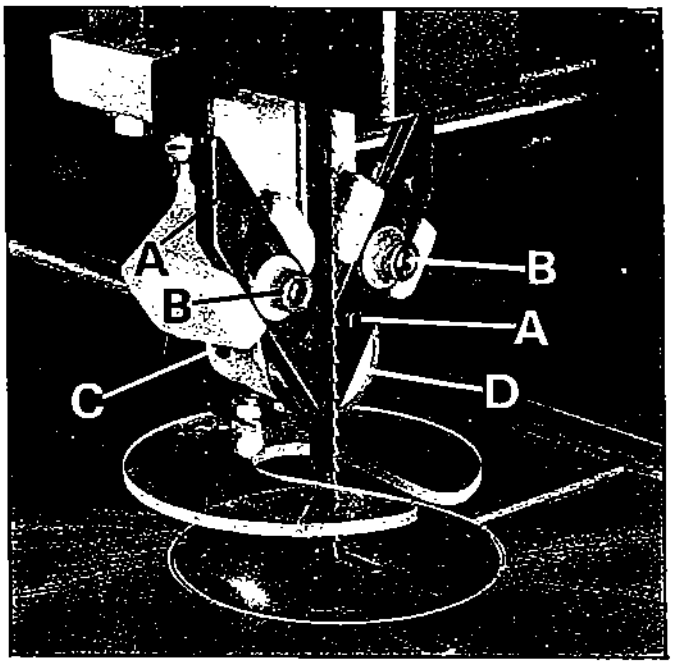


Fig. 5

ADJUSTING BLADE SUPPORT BEARINGS

1. Loosen the bearing support screw (C) Fig. 5, and adjust the support bearing (D) to within 1/64" of the blades rear edge. In essence, the blade support bearing (D) Fig. 5, should be adjusted as closely as possible to the rear edge of the blade so as not to rotate whenever the blade is running free without cutting. When the blade is cutting it will be pushed back to the rear and the support bearing will then rotate.

2. The lower blade support bearing (D) Fig. 6 is adjusted in the same manner.

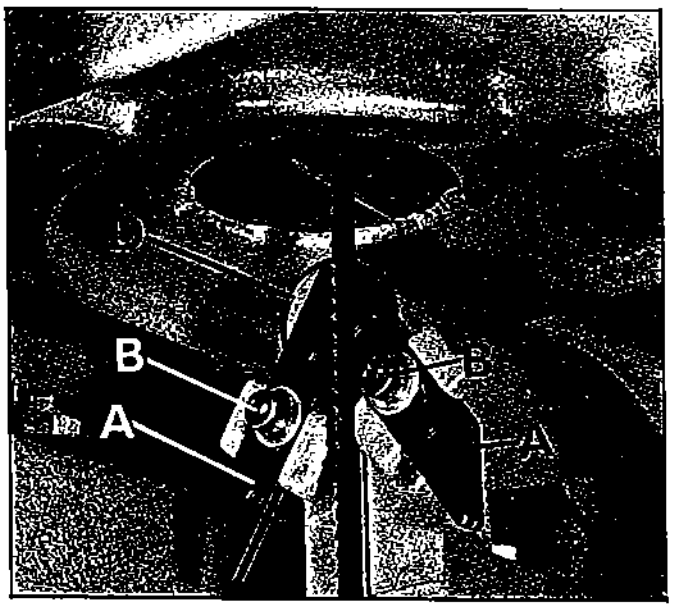


Fig. 6

ADJUSTING BELT TENSION

The correct tension is obtained when the belt on the band saw can be flexed approximately 1/4 inch out of line, using 6 pounds of pressure at the center span of the pulleys.

To adjust belt tension:

1. DISCONNECT BAND SAW FROM POWER SOURCE.

2. Move the motor mounting plate (A) Fig. 7, to the right or left, by turning the adjusting nuts, one of which is shown at (B) Fig. 7, until correct tension is obtained.

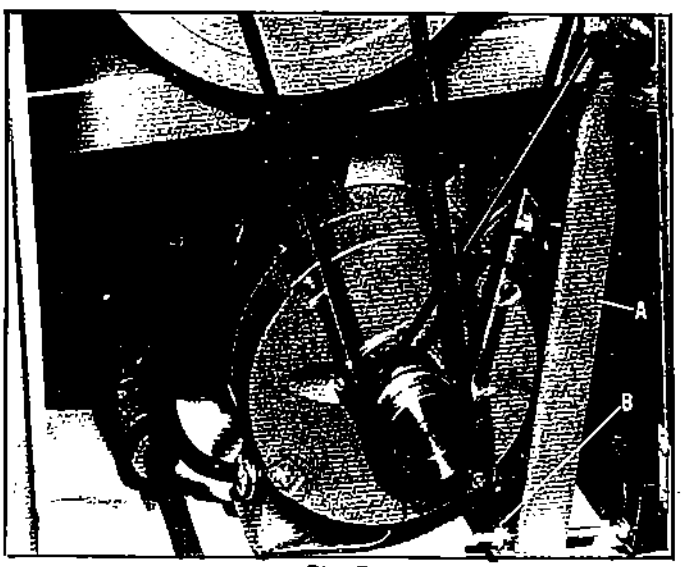


Fig. 7

ROCKWELL AUTHORIZED PARTS DISTRIBUTORS

The Authorized Rockwell Parts Distributors or Service Centers listed below stock a complete line of replacement parts. To save time and shipping costs, send your parts orders to your nearest Distributor or Rockwell Branch. In most cases they will be filled and shipped within 48 hours. Parts orders are not filled direct from the factory.

ATLANTA, GEORGIA 30340
Rockwell International
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Phone: 404 458-2263

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414 Cambridge Street
Phone: 617 782-1700

BUFFALO, NEW YORK 14204
Karle Saw Company, Inc.
138-150 Chicago St., Cor. So. Park Ave.
Phone: 716 853-8053 or 8054

CHICAGO, ILLINOIS 60160
Rockwell International
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Melrose Park, Illinois
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ROCKWELL

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GRAY PRINTING CO.

LITHO U. S. A.

TABLE ADJUSTMENTS

The table may be tilted 45 degrees to the right and 12 degrees to the left. To tilt the table to the left, first tilt it to the right, swing the stop bar (A) Fig. 8, to the rear for clearance, and tilt the table to the left to the desired angle.

Although the table is adjusted at the factory to be at right angle with the blade, this adjustment should be checked out as follows:

1. With the blade under tension, place an accurate square on the table with one end of the square against the flat side of the blade to the rear of the tooth gullets.

2. If the table is not square, left to right, loosen nut (B) Fig. 8, and adjust the set screw (C) up or down as the case may be until the table is square and tighten nut (B).

3. When the table has been set at right angle to the blade, set the pointer on the tilt angle scale to read zero.

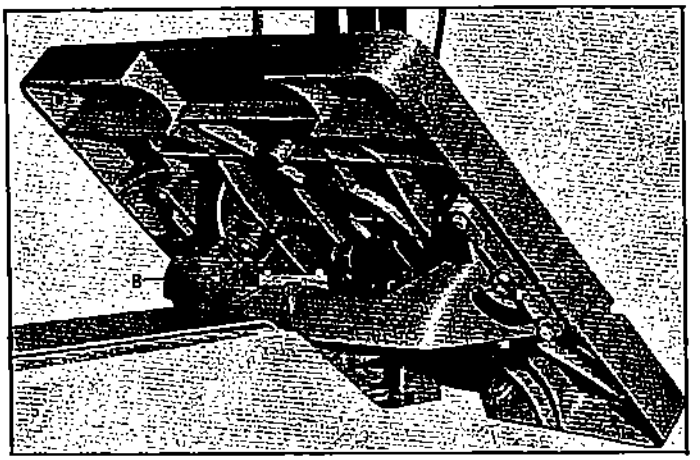

Fig. 8

CHANGING SPEEDS

With a 1725 rpm motor you can obtain a cutting speed of 2000 fpm for non-ferrous cutting, and 4500 fpm for wood cutting.

When the belt (A) Fig. 9, is assembled to the outside groove of the motor pulley (B) and the small driven pulley (C), the cutting speed will be 4500 fpm.

For 2000 fpm, non-ferrous cutting, simply remove the belt (A) Fig. 9, and assemble the longer belt, which is supplied with your machine, to the center groove of the motor pulley (B) and the large driven pulley (D). Then adjust belt tension as explained under ADJUSTING BELT TENSION.

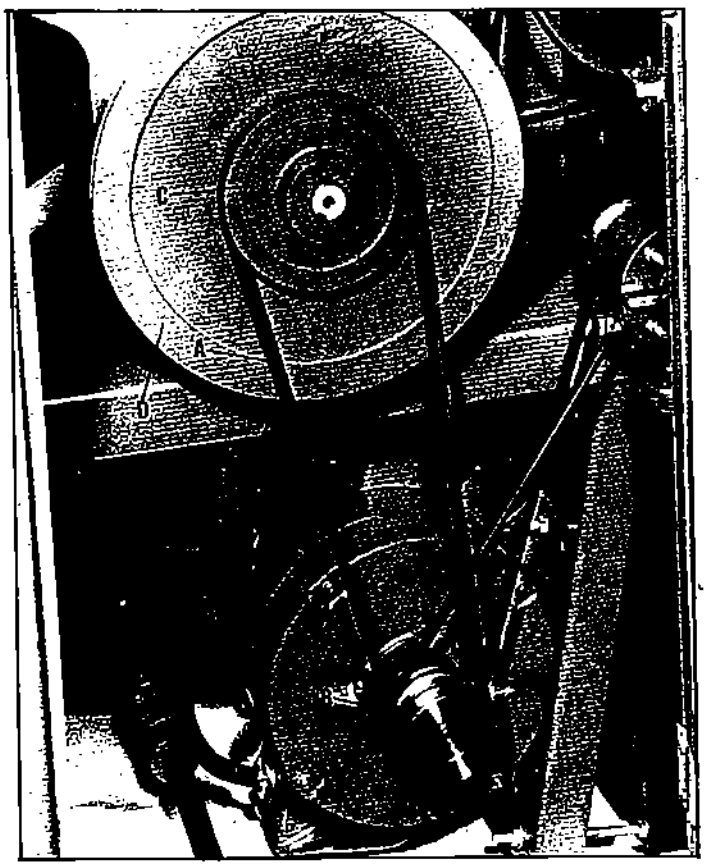

Fig. 9

TABLE INSERT

The table insert is furnished with a little lug or protrusion that fits into the blade removal slot of the table and prevents the insert from vibrating loose and turning.

BLADE REMOVAL SLOT

The blade removal slot of the table is furnished with a threaded plug. This plug is used for aligning the front and rear halves of the groove in the table of your band saw. CAUTION: CARE SHOULD BE TAKEN AGAINST EXCESSIVE TIGHTENING OF THIS PLUG SINCE THIS CAN CREATE STRESSES WHICH COULD RESULT IN THE TABLE BECOMING CRACKED.

Whenever the miter gage is used, the plug should be turned just far enough to allow the miter gage bar to slide freely in the table groove.

WHEEL ALIGNMENT

Wheels are adjusted at the factory so that they are both in alignment. The upper wheel slide plate is fastened to the frame with three cap screws and one threaded bushing. This forms a three point mounting feature. If the two wheels are not parallel and in alignment when viewed from above, proceed as follows:

1. Loosen screw (64) page 8, and turn threaded bushing (65) in and out until the upper wheel is parallel to the lower wheel, then tighten cap screw.

2. The blade must ride in the center of the wheel (on the crown). The upper wheel as explained previously can be tilted for this reason. If the blade is not riding in the center of the lower wheel, the wheel can be tilted. The lower wheel mounting plate also contains the three point mounting features. To adjust, loosen Cap Screw (88) page 8, and turn threaded bushing (87) in or out the required amount, then tighten cap screw.

REPLACING TIRES

When a tire needs replacing, first remove the old tire from the wheel. After removing, clean the surface of the wheel, and apply the new tire as follows:

1. Place one portion of the tire completely on the wheel and fasten using a clamp, as shown in Fig. 10.

2. Work the tire onto the wheel by hand as far as possible.

3. Pry the remainder of the tire onto the wheel using two screwdrivers or other suitable instruments, as shown in Fig. 11.

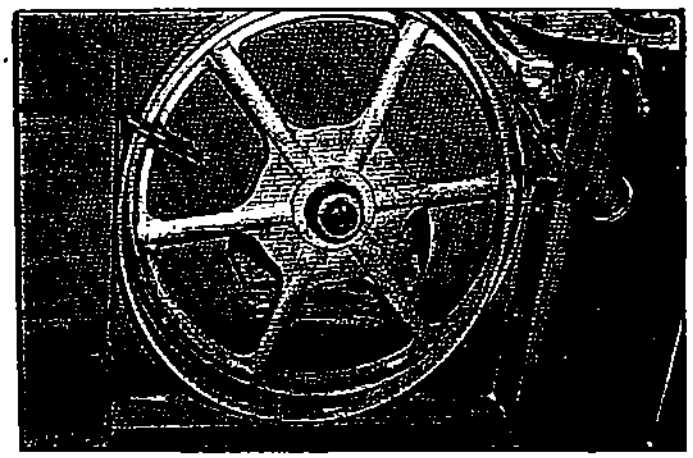

Fig. 10

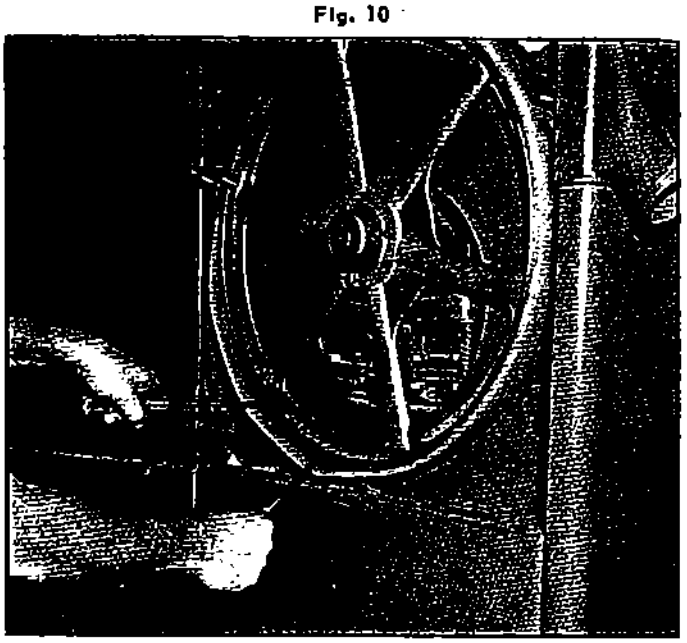

Fig. 11

MAINTENANCE

Clean tires frequently by scraping off accumulations of chips, gum and pitch.

Lubricate sliding parts with a few drops of light oil. All bearings and motors are lubricated for their life, sealed and required no further lubrication.