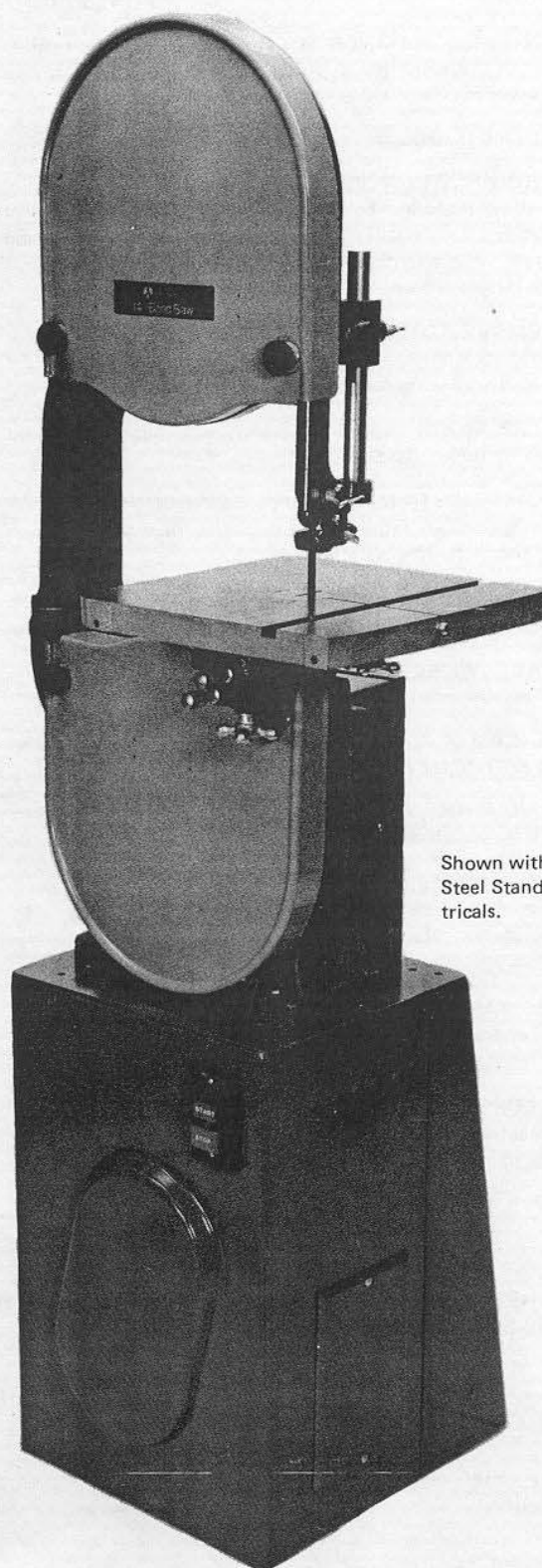


**14"** (355.6 mm)

# Metal Cutting Band Saw

## Instruction manual



Shown with enclosed  
Steel Stand and elec-  
tricals.



# 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  
TOOL GROUP  
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. **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.

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

8. **MAKE WORKSHOP CHILDPROOF** - 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 for which it was not designed.

11. **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.

12. **USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are NOT safety glasses.

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 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, etc.

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 power 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.

24. **MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.

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## 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.

## UNPACKING AND CLEANING

Carefully unpack the band saw, stand, and all loose items from the cartons. Remove the protective coating from the machined surfaces of the band saw. 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 all unpainted surfaces with a good quality paste wax.

## ASSEMBLING STAND, MOTOR PLATE, MOTOR, MOTOR PULLEY, AND SWITCH

If you purchased your band saw complete with stand and electricals factory mounted and wired, as shown in Fig. 2, it is necessary to remove the small knockout (A) located on top of the stand. The motor plate, motor, motor pulley and switch are completely assembled to the stand, as shown in Fig. 2 and Fig. 3.

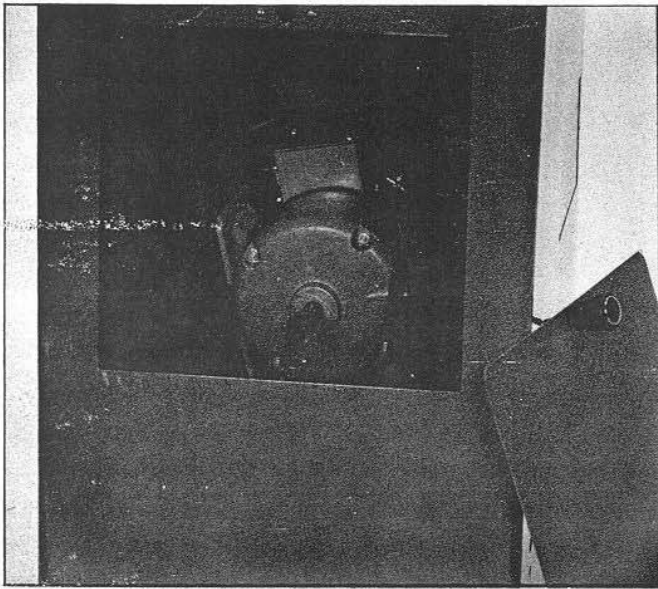


Fig. 3

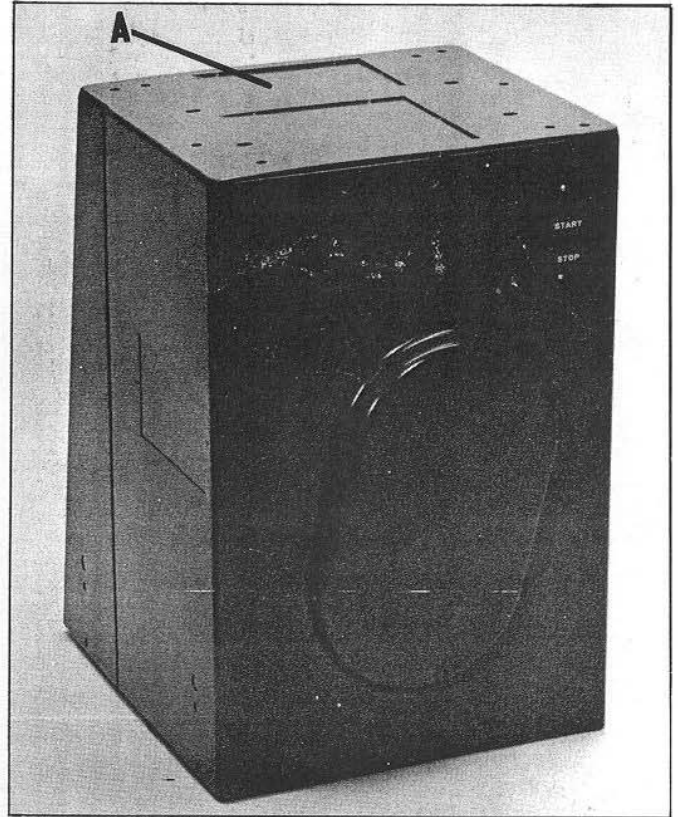
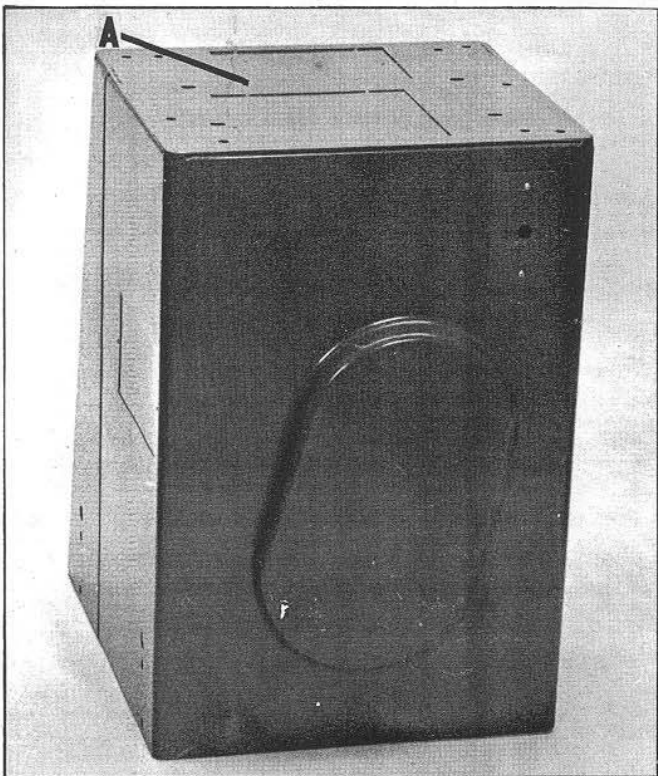


Fig. 2



If you purchased your band saw with separate stand and electricals NOT factory mounted and wired, the stand is supplied as shown in Fig. 4. Remove the small knockout (A) Fig. 4, located on top of the stand and proceed as follows to assemble the motor plate, motor, motor pulley and switch:



1. Turn the stand upside down.

2. Assemble the motor mounting plate (A) Fig. 5, using the two hex head cap screws, flat washers and nuts (B). The other end of the motor is fastened to the side of cabinet using a carriage bolt from the outside of the cabinet and a flat washer and nut on the inside.

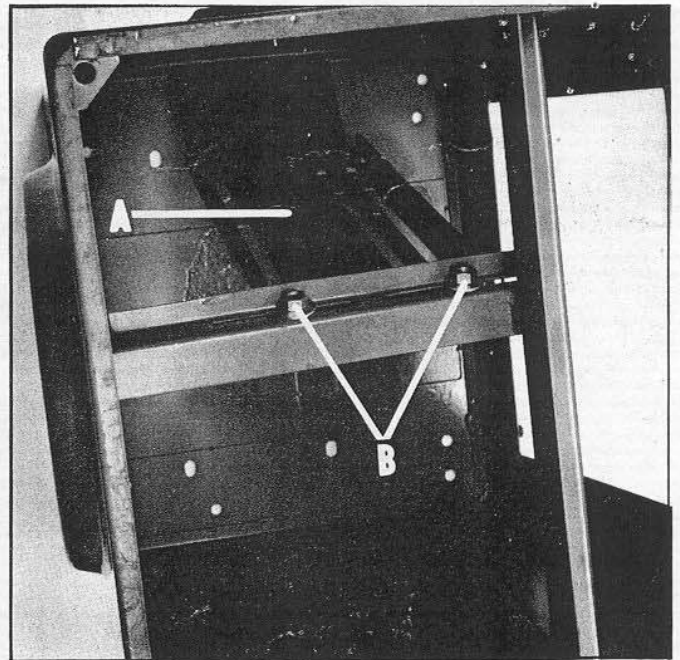


Fig. 5

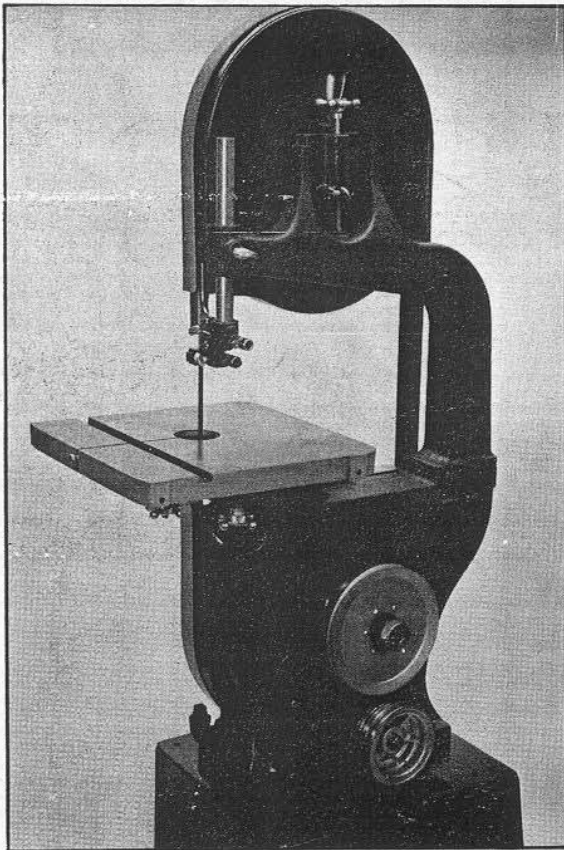


Fig. 6

3. Return the stand to the upright position and assemble band saw to stand using four 1-1/2" round head slotted screws, flat washers, lockwashers and nuts, as shown in Fig. 6.

4. Assemble the motor to the motor mounting plate, as shown in Fig. 7, using the four carriage bolts, flat washers and square nuts. Consult your Rockwell Dealer or Catalog for the recommended motor for use with your saw.

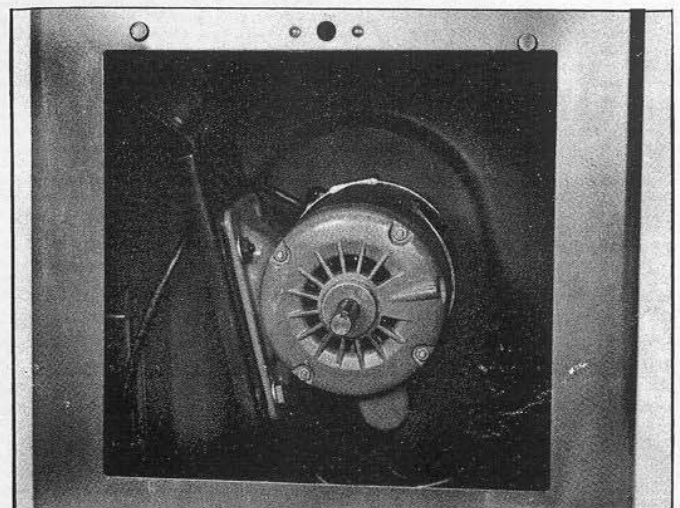


Fig. 7

5. Assemble motor pulley (A) Fig. 8, to the motor shaft as shown. When assembling the motor pulley (A) to the motor shaft it is necessary to use 3/4" to 5/8" reducing bushing on the motor shaft. NOTE: Rockwell motors recommended for use with this band saw have 5/8" motor shafts. The motor pulley (A) Fig. 8 is supplied with a 3/4" bore to enable it to be interchanged with the gear box pulley (B) as explained later in this manual.

6. Using a straight edge align the inside grooves of the pulleys (A) and (B) to the pulley (C) Fig. 8. The pulleys can be moved in or out on the shafts and also the motor mounting plate can be moved if necessary.

7. Assemble the large V-Belt (D) to the inside groove of the motor pulley (A) and to the large pulley (C). Assemble the smaller V-Belt to any one of the remaining three grooves of the motor pulley (A) and the corresponding groove of the gear box pulley (B) Fig. 8.

8. Adjust for proper belt tension by raising or lowering the motor on the motor mounting plate. Keep pulleys in alignment when doing this. Correct belt tension is obtained when there is approximately 1" deflection in the center span of the pulleys with light finger pressure.

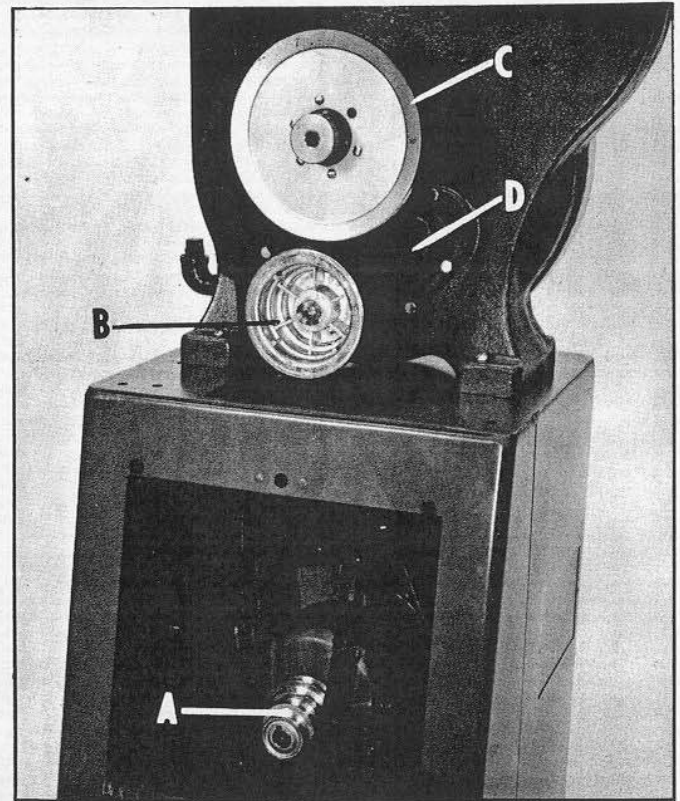


Fig. 8

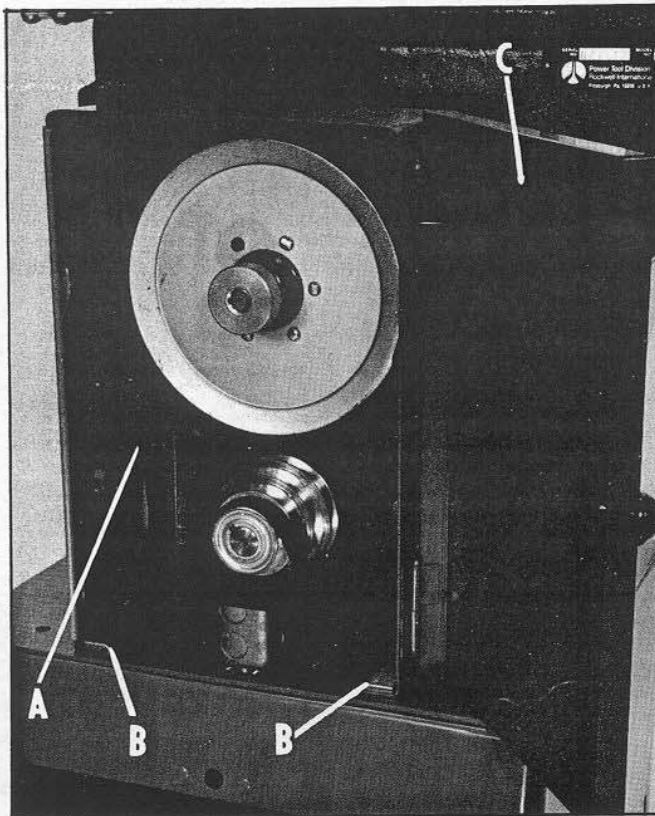


Fig. 9

## ASSEMBLING BELT AND PULLEY GUARD

1. Remove both V-belts from the pulleys.
2. Place the belt and pulley guard (A) Fig. 9, on the top shelf over the belt opening and position the two clamps (B) over the guard flanges and under the top of the stand as shown. Use the four round head screws in the bottom of clamps to fasten in place.
3. Replace both V-belts and place door (C) Fig. 9, on hinges.

## TABLE INSERT

Place table insert (A) Fig. 10, in the hole provided in the table making sure the pin in the table engages one of the indents in the table insert.

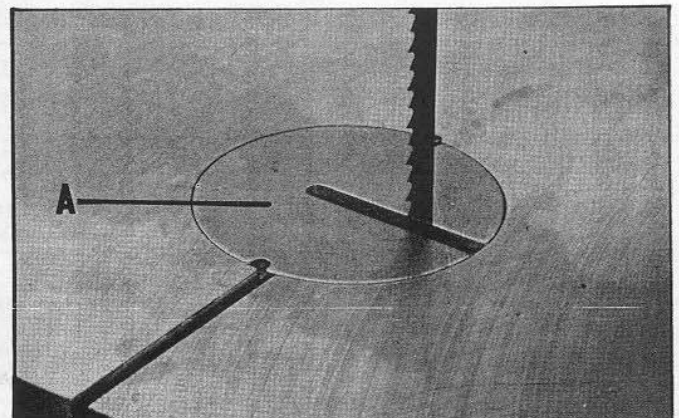


Fig. 10



## TILTING THE TABLE

The table on your band saw can be tilted 45 degrees to the right and 10 degrees to the left. To tilt the table, loosen the two star wheels (A) Fig. 11, tilt the table to the desired angle and tighten the two star wheels (A).

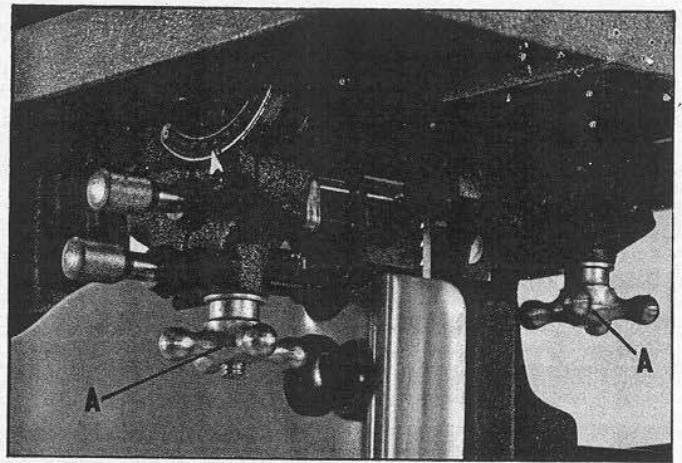


Fig. 11

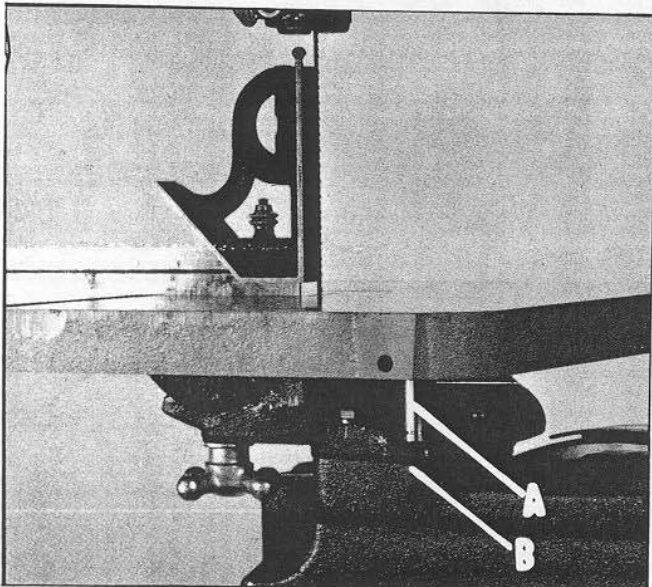


Fig. 12

## 90 DEGREE TABLE ADJUSTMENT

Your band saw is equipped with an adjustable stop to insure that the table is at 90 degrees to the blade. To adjust:

1. Tilt the table to the right slightly.
2. Place the stop (A) Fig. 12, on the adjusting screw.
3. Tilt the table until it is at 90 degree to the blade, making sure by placing a square on the table and against the blade.
4. When the table is at 90 degrees to the blade, the stop (A) should come into contact with the bottom of the table. If an adjustment is necessary, loosen nut (B) Fig. 12., and turn adjusting screw until the stop (A) contacts the table.
5. It is necessary to remove the stop (A) Fig. 12, when tilting the table to the left.

## ADJUSTING BLADE TENSION

On the back of the upper wheel slide bracket there is a series of graduations. These indicate the proper tension for various widths of blades. With the blade on the wheels, turn the star wheel (A) Fig. 13, to raise or lower the wheel, until the red fiber washer (B) is in line with the proper graduation for the size of blade being used.

The graduations will be found correct for average work, and are not affected by rebracing of the saw blade. We urge you to use these graduations until you have become familiar enough with the operation of the Band Saw to vary the tension for different kinds of blades or work. Over-straining is a common cause of blade breakage and other unsatisfactory blade performance. Relax the tension when the machine is not in use.

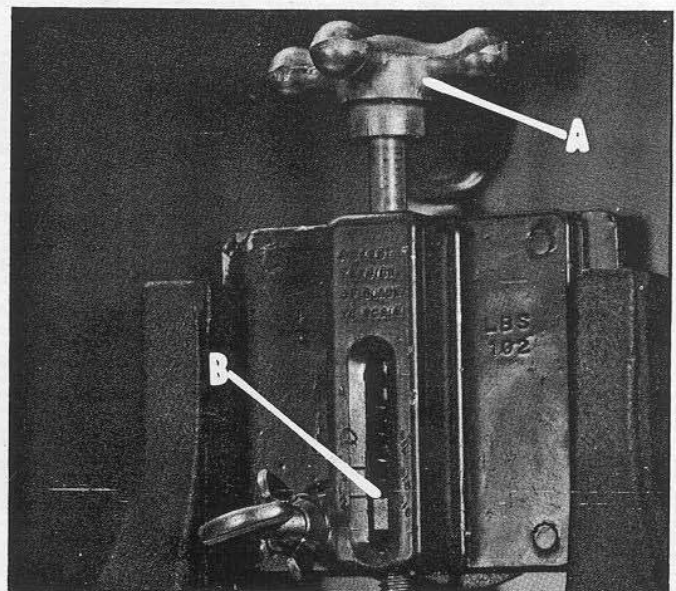


Fig. 13

## TRACKING THE BLADE

**IMPORTANT:** Before tracking the blade, make sure the blade guides and blade support bearings are clear of the blade so as not to interfere with the tracking adjustment.

After tension has been applied to the blade, revolve the wheels slowly forward by hand and watch the blade (A) Fig. 14, to see that it travels in the center of the upper tire. If the blade begins to creep toward the front edge, loosen the wing nut (B) and tighten the thumb screw (C). This will tilt the top of the wheel toward the back of the machine and will draw the blade toward the center of the tire. If the blade creeps toward the back edge, turn the thumb screw (C) in the opposite direction. Adjust the thumb screw (C) only a fraction of a turn at a time. **NEVER TRACK THE BLADE WHILE THE MACHINE IS RUNNING.** After the blade is tracking in the center of the tires, tighten the wing nut (B) Fig. 14.

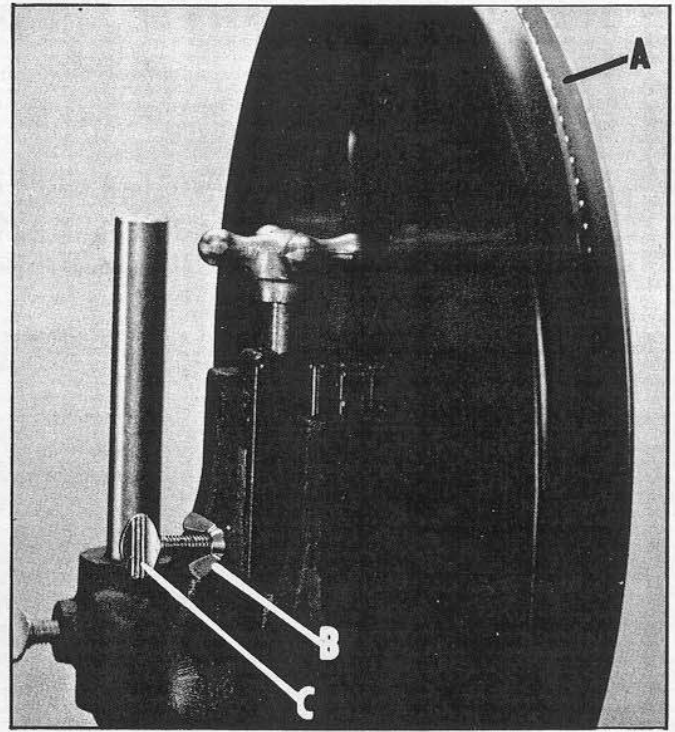


Fig. 14

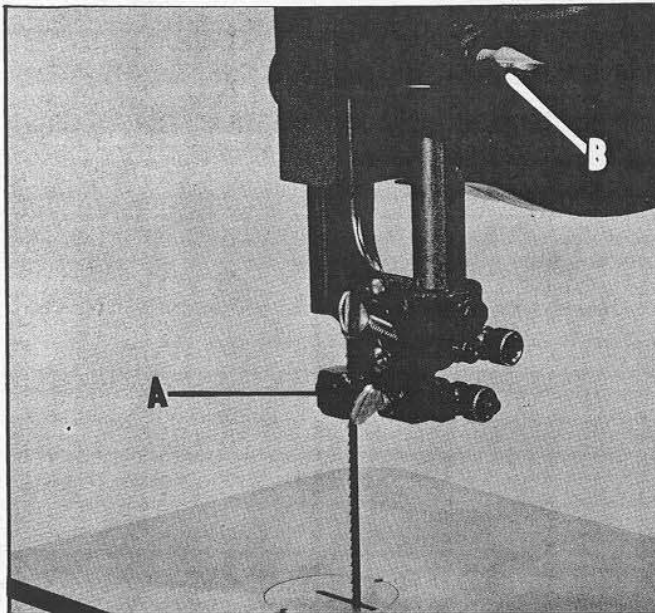


Fig. 15

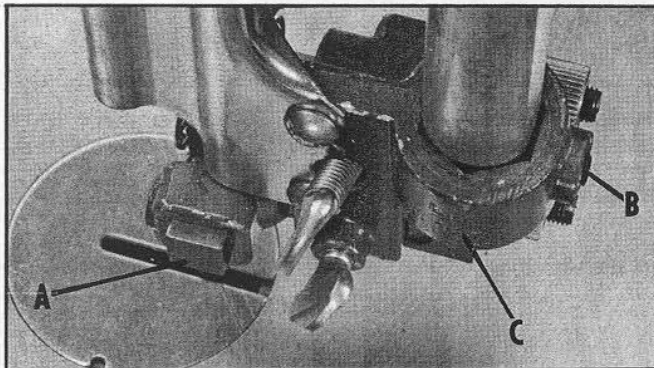


Fig. 16

## ADJUSTING UPPER BLADE GUIDE ASSEMBLY

The upper blade guide assembly (A) Fig. 15, should always be set as close as possible to the top surface of the material being cut by loosening thumb screw (B) and moving the guide assembly (A) to the desired position.

The upper blade guide assembly should also be adjusted so that the blade guides (A) Fig. 16, are flat with the blade. If an adjustment is necessary, loosen screw (B) and rotate the complete guide assembly (C) until the blade guides are flat with the blade.



## ADJUSTING UPPER BLADE GUIDES AND BLADE SUPPORT BEARING

The upper blade guides and blade support bearings are adjusted only after the blade is tensioned and tracking properly. To adjust proceed as follows:

1. The upper blade guides (A) Fig. 17, are held in place by means of the set screws (B). Loosen the set screws (B) to move the guides (A) as close as possible to the side of the blade, being careful not to pinch the blade. Then tighten the screws (B).
2. The guides (A) Fig. 17, should then be adjusted so that the front edge of the guides are just behind the "gullets" of the saw teeth. The complete guide block bracket can be moved in or out by loosening thumb screw (C) and turning knurled knob (D) Fig. 17. When guides (A) are set properly, tighten thumb screw (C).
3. The upper blade support bearing (E) Fig. 17, prevents the blade from being pushed too far to the back which could damage the set in the saw teeth. The support bearing (E) should be set  $1/64''$  behind the blade by loosening thumb screw (F) and turning knurled knob (G) to move the support bearing (E) in or out.
4. The blade support bearing (E) should also be adjusted so the back edge of the blade overlaps the outside diameter of the ball bearing by about  $1/16''$ . The bearing (E) is set on an eccentric and to change position remove screw (H) and bearing (E) Fig. 17. Loosen thumb screw (F), back out screw (G) and re-position shaft that bearing (E) is attached to.

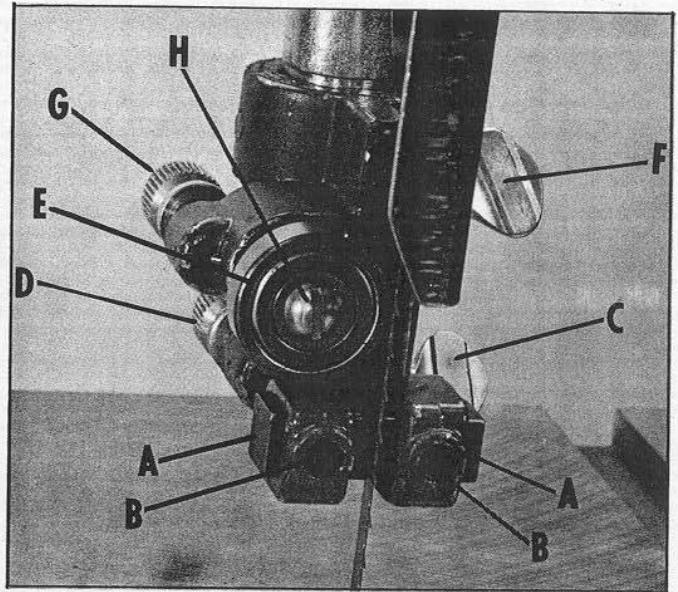


Fig. 17

## ADJUSTING LOWER BLADE GUIDES AND BLADE SUPPORT BEARING

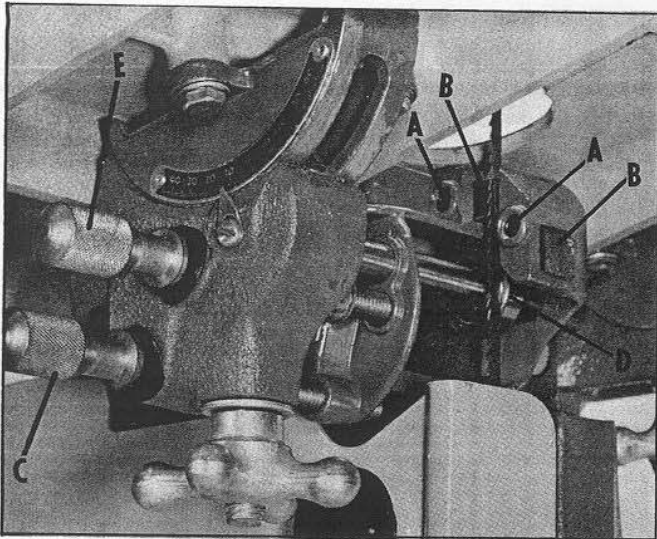


Fig. 18

The lower blade guides and blade support bearing should be adjusted at the same time as the upper guides and bearing as follows:

1. Loosen the two screws (A) Fig. 18, and move the guides (B) as close as possible to the side of the blade being careful not to pinch the blade. Then tighten screws (A).
2. The front edge of the guide blocks (B) should be adjusted so they are just behind the "gullets" of the saw teeth by turning the knurled knob (C) Fig. 18.
3. The lower blade support bearing (D) Fig. 18, should be adjusted so it is about  $1/64''$  behind the back of the blade by turning the knurled knob (E).

## CHANGING SPEEDS

One of the advantages of this saw lies in the fact that it can be changed over instantly from a slow-speed metal cutting band saw to a standard high-speed band saw for wood.

NEVER HAVE THE BAND SAW RUNNING WHEN CHARGING FROM METAL CUTTING TO WOOD CUTTING OR VISE-VERSA.



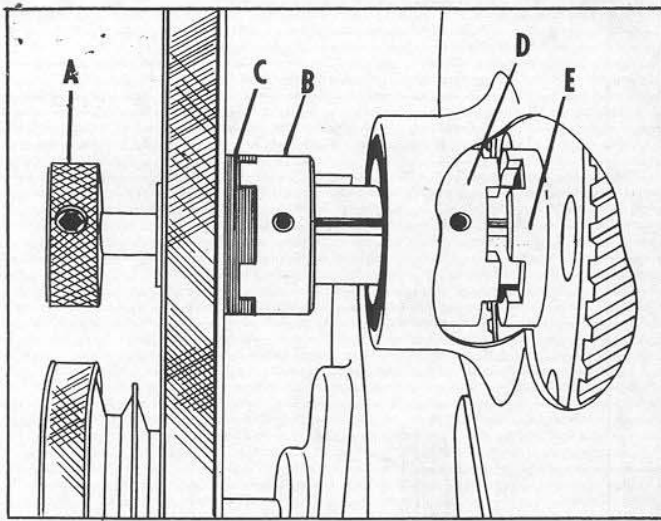


Fig. 19

When using your machine for wood cutting (3000 FPM), the shifter knob (A) Fig. 19, is always pulled out, all the way, so that the lugs of the clutch (B) are engaged with the hub (C) of the driven pulley. This will disengage the clutch (D) from the hub (E) of the gear that transmits power through the gear box, as shown in Fig. 19. It may be necessary to rotate the pulley manually in order to line up the clutch lugs with the slots in the hub of the pulley. This provides a direct drive from the motor pulley to the driven pulley, by-passing the gear box.

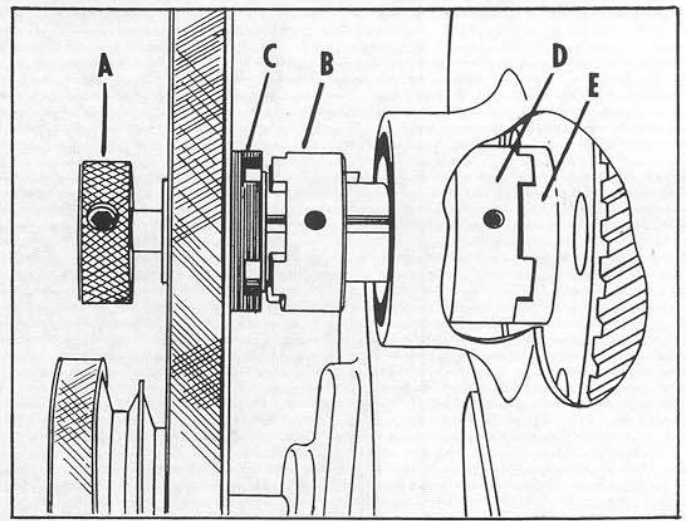


Fig. 20

When using your machine for metal cutting (40, 60, 85, 115, 160, 220 and 335 FPM), the shifter knob (A) Fig. 20, is always pushed in all the way, disengaging the clutch (B) from the hub (C) of the pulley. An additional clutch (D) is located inside the band saw and must be engaged with the hub (E) of the gear that transmits power through the gear box, as shown in Fig. 20. When pushing in on the shifter knob (A) Fig. 20, rotate the lower wheel of the band saw, and you will be able to feel when engagement occurs.

The following is an explanation for the belt and pulley arrangements to enable you to obtain all eight speeds available on your band saw:

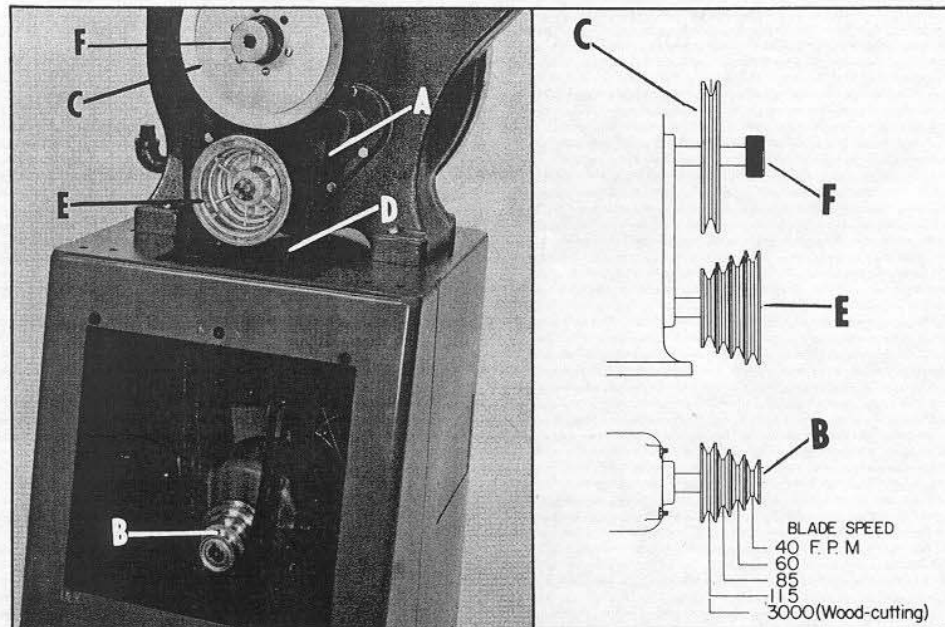


Fig. 21

With the longest belt (A) on the inside groove of the motor pulley (B) and on the driven pulley (C), as shown in Fig. 21, and the small belt (D) on one of the remaining three grooves of the motor pulley and the corresponding groove of the gear box pulley (E), speeds of 40, 60, 85, and 3000 FPM are readily available. To obtain speeds of 40, 60 and 85 FPM, the shifter knob (F) Fig. 21, must be pushed in all the way, as previously explained, and the small belt positioned on one of the three outside grooves of the motor pulley (B) and the gear box pulley (E).

To obtain a blade speed of 3000 FPM, simply pull out the shifter knob (F) Fig. 21.

The blade speed of 115 FPM is obtained by pushing in the shifter knob (F) Fig. 21, removing the long belt (A) from the pulleys and placing the small belt on the inside groove of the motor pulley (B) and the inside groove of the gear box pulley (E).

Except for the one speed of 115 FPM, both belts may be left on the machine regardless of the speed being used.

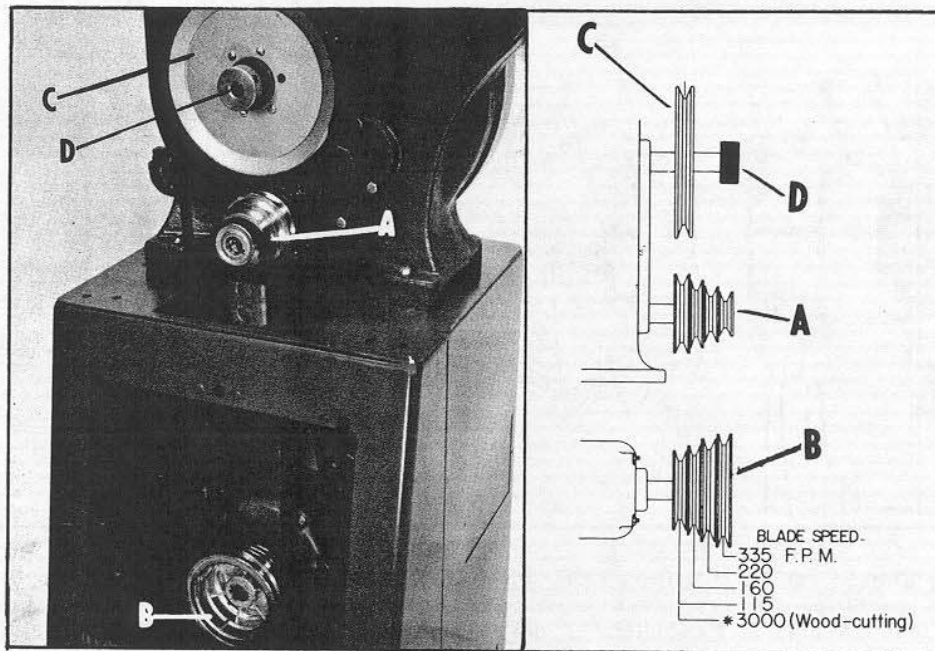


Fig. 22

Blade speeds of 115, 160, 220, 335 and 3000 FPM are available by simply interchanging the positions of the motor pulley and the gear box pulley. Fig. 22 shows the motor pulley (A) positioned on the gear box shaft and the gear box pulley (B) positioned on the motor shaft. Then with the long belt positioned on the inside groove of pulley (B) and pulley (C) and the small belt positioned to one of the remaining three grooves of the pulleys (A) and (B) Fig. 22, speeds of 160, 220, and 335 FPM are obtained when the shifter knob (D) is pushed in. To obtain the 3000 FPM blade speed simply pull out the shifter knob (D) Fig. 22. Blade speed of 115 FPM is obtained by pushing the shifter knob (D), removing the long belt from pulleys (B) and (C) and placing the small belt on the inside groove of the motor pulley (B) and gear box pulley (A).

Except for the one speed of 115 FPM, both belts may be left on the machine regardless of the speed being used.

## CHANGING BLADES

To change blades, proceed as follows:

1. Remove upper and lower wheel guards.
2. Release tension on the band saw blade.
3. Remove the table adjustment pin and table insert.
4. Slip the blade off the wheel and guide it out through the slot in the table.
5. To install a new blade, reverse the above procedure.



**SUGGESTED SPEEDS AND BLADES**

SUGGESTED METAL CUTTING BLADES AND SPEEDS							SUGGESTED SKIP TOOTH BLADES AND SPEEDS						
MATERIAL	THICKNESS OF MATERIAL						MISCELLANEOUS	THICKNESS OF MATERIAL					
	UNDER 1/4"	1/4" TO 3/4"	1/2" TO 2"	2" & UP	Teeth Per Inch	Feet Per Minute		UNDER 1/2"	1/2" TO 2"	2" & UP	Teeth Per Inch	Feet Per Minute	
<b>STEELS</b>	Teeth Per Inch	Feet Per Minute	Teeth Per Inch	Feet Per Minute	Teeth Per Inch	Feet Per Minute	Teeth Per Inch	Feet Per Minute	Teeth Per Inch	Feet Per Minute	Teeth Per Inch	Feet Per Minute	
Angle Iron	24	160	14	160	10	40	3	3000	3	3000	3	3000	
Armor Plate	18	40	14	40	14	40	4	3000	4	3000	4	3000	
Carbon Steel	24	85	14	60	14	40	4	3000	3	3000	3	3000	
Chromium Steel	24-18	85	14	60	14	40	6	3000	4	3000			
Cold Rolled Steel	24-18	220	14	220	14	160	4	3000	3	3000	3	3000	
Drill Rod	14	85	14	60			6	3000	4	3000			
Graphite Steel	18	60	14	40	14	40	4	3000	3	3000	3	3000	
High Speed Steel	24	85	14	60	14	40	6	3000	4	3000	4	3000	
Machinery Steel	18	160	14	160	14	160	3	3000	3	3000	3	3000	
Molybdenum Steel	18	85	14	60	14	40	6	3000	4	3000	4	3000	
Nickel Steel	18	40	14	40	14	40	3	3000	3	3000	3	3000	
Silicon Manganese	18	85	14	85	14	60	6	3000	4	3000	4	3000	
Stainless Steel	24	40	14	40	10	40	6	3000	4	3000	4	3000	
Structural Steel	24	160	14	160	14	115	6	3000	4	3000	4	3000	
Tungsten Steel	18	40	14	40	10	40	6	3000	4	3000	4	3000	
<b>FOUNDRY METALS</b>													
Brass-Hard & Soft	18	335	14	335	10	335	3	3000	3	3000	3	3000	
Bronze-Aluminum	18	335	14	335	14	335	4	3000	4	3000	4	3000	
Bronze-Manganese	18	160	14	115	14	85	4	3000	3	3000	3	3000	
Bronze-Naval	18	160	14	115	14	85	4	3000	3	3000	3	3000	
Bronze-Phosphorus	18	335	14	335	14	220	4	3000	4	3000	4	3000	
Cast Iron-Gray	18	115	14	85	10	60	6	3000	4	3000	4	3000	
Cast Iron-Malleable	18	160	14	115	14	85	6	3000	4	3000	4	3000	
Cast Steel	18	160	14	115	14	85	6	3000	4	3000	4	3000	
Copper-Beryllium	18	160	14	85	10	40	6	3000	4	3000	4	3000	
Gunnite	24	335	18	220	14	160	6	3000	4	3000	4	3000	
Meehanite	18	160	14	115	10	85	6	3000	4	3000	4	3000	
Monel	18	115	14	85	10	60	6	3000	4	3000	4	3000	
Nickel-Cold Rolled	14	60	10	40	10	40	6	3000	4	3000	4	3000	
Nickel Silver	18	220	14	220	14	220	6	3000	4	3000	4	3000	
Silver	24	220	18	220	14	220	6	3000	4	3000	4	3000	
<b>NON-METALS</b>													
Bakelite	10	335	10	220	10	160							
Cork	10	3000	10	3000	10	3000							
Fibre	14	3000	10	3000	10	3000							
Hose-Canvas, Rubber	10	3000											
Hose-Metallic	24	220											
Mica	24	335	18	220	14	220							
Plastics	14	3000	14	3000	10	3000							
Porcelain	24	160	18	115									
Slate	24	335	18	220	14	160							
Transite	24	335	18	220	14	85							

SUGGESTED WOODCUTTING BLADES (3000 FPM)			
USE BLADE WIDTH TO SUIT DESIRED RADIUS			
WIDTH	MIN CUTTING RADIUS	WIDTH	MIN CUTTING RADIUS
1/8"	1/4"	3/8"	1"
3/16"	1/2"	1/2"	1-1/4"
1/4"	3/4"	3/4"	1-3/4"

Fig. 23

## BAND SAW BLADES

A band saw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain long use from a band saw blade if you give it fair treatment. Be sure you use blades of the proper thickness, width, and temper for the various types of material to be cut.

Always use the widest blade possible. Use the narrow blades only for sawing small, abrupt curves and for fine delicate work. This will save blades and will produce better work. Band saw blades may be purchased, welded, set and sharpened ready for use. For cutting wood and similar materials we can supply them in widths of 1/8, 3/16, 1/4, 3/8, 1/2 and 3/4 inches.

Blades for metal cutting should be selected for the particular job they are to do. Blades for cutting thin metal, for example, should be selected so that there will always be at least two teeth in contact with the edge of the work. If the teeth are allowed to straddle the work they will be torn off and the blade ruined. Generally speaking, thick stock requires larger teeth and a slower cutting speed than thin stock. See Fig. 23, for recommendations of blades and cutting speeds, for different materials and thickness.

File and set the wood cutting blades whenever you find it requires pressure to make them cut. If a blade is broken it can be brazed or welded; however, if it has become badly work-hardened it will soon break in another place. If you are not equipped to file, set and braze or weld blades take them to a saw filer for reconditioning.

It is not practical to re-sharpen either the skip tooth blades or the regular hard-edge flexible-back metal cutting saw blades.

Any one of a number of conditions may cause a band saw blade to break. Blade breakage is, in some cases, unavoidable, being the natural result of the peculiar stresses to which such blades are subjected. It is, however, often due to avoidable causes, most often to lack of care or judgment on the part of the operator in mounting or adjusting the blade or guides. The most common causes of blade breakage are: (1) faulty alignments and adjustments of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding too fast, (4) dullness of the teeth or absence of sufficient set, (5) excessive tightening of the blade, (6) top guide set too high above the work being cut, (7) using a blade with a lumpy or improperly finished braze or weld and, (8) continuous running of the saw blade when not in use for cutting.

New blades for the standard 14 inch Band Saw are 93½ inches long. The adjustment will accommodate blades up to a maximum length of 94 inches and to a minimum length of 91½ inches. When equipped with the No. 28-984 Height Attachment, new blades should be 105 inches long; maximum and minimum lengths are 106 and 103½ inches.

## OPERATING THE BAND SAW

Before starting the machine, see that all adjustments are properly made and the guards are in place. Turn the pulley by hand to make sure that everything is correct BEFORE turning on the power.

Keep the top guide down close to the work at all times. Do not force the material against the blade too hard. Light contact with the blade will permit easier following of the line and prevent undue friction, heating and work-hardening of the blade at its back edge.

KEEP THE SAW BLADE SHARP and you will find that very little forward pressure is required for average cutting. Move the stock against the blade steadily and no faster than will give an easy cutting movement.

Avoid twisting the blade by trying to turn sharp corners. Remember you must saw around corners.

## CUTTING CURVES

When cutting curves, turn the stock carefully so that the blade may follow without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, either a narrow blade is needed or a blade with more set is required. The more set a blade has, the easier it will allow the stock to be turned, but the cut is usually rougher than where a medium amount of set is used.

In withdrawing the piece being cut, in order to change the cut, or for any other reason, the operator must be careful that he does not accidentally draw the blade off the wheels. In most cases it is easier and safer to turn the stock and saw out through the waste material, rather than try to withdraw the stock from the blade.

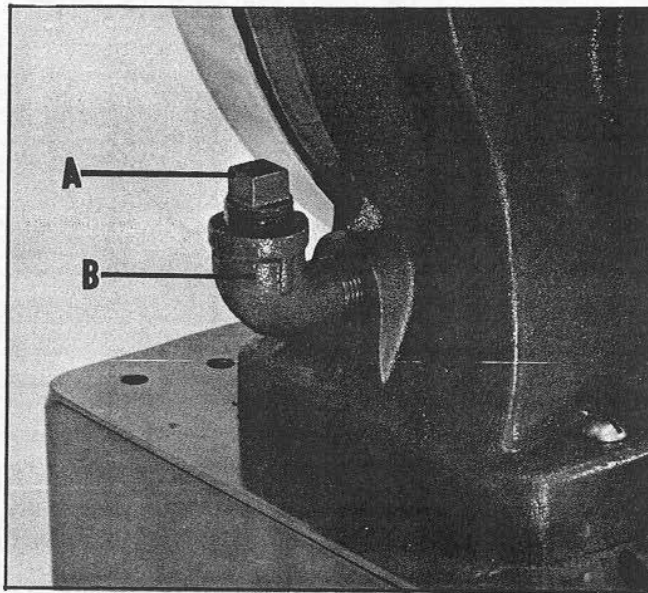


Fig. 24

## LUBRICATION

The gear case is filled at the factory with 1½ quarts of oil. It should be drained after 1500 to 2000 hours of operation and refilled with a good grade of heavy adhesive gear oil. A pipe plug is provided underneath the band saw and is removed when draining the oil.

All models are equipped with a ½ inch street elbow (B) Fig. 24, and a pipe plug (A).

Remove the pipe plug (A) Fig. 24, to check the level of oil in the gear case from time to time and keep it filled to insure proper gear lubrication.

The wheels of the band saw are carried on sealed for life ball bearings, which require no lubrication. Ball bearing blade supports are of the same type. Oil of every kind should be kept away from the blade supports.



# ACCESSORIES

**No. 41-713 Motor Pulley**, 4-step,  $\frac{5}{8}$ " bore. 1 lb.

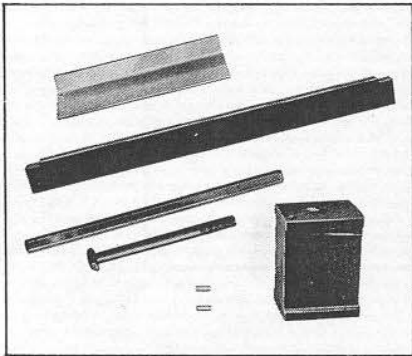
**No. 41-714 Motor Pulley**, 4-step,  $\frac{3}{4}$ " bore. 1 lb.

**No. 49-111 V-Belts**, matched set of two, 41" and  $58\frac{5}{8}$ " O.C. Used with 50-122 and 50-891 stands. 1 lb.

**No. 50-122 Enclosed Steel Stand**. Includes 50-139 basic stand, 50-136 motor plate and 50-135 belt guard. 54 lbs.

**No. 40-882 (old 882) Lamp Attachment**  
—Uses standard 15 or 25-watt bulb (not included). Includes mounting bracket, shade, socket and 115 V 8-foot cord with plug.  $1\frac{1}{2}$  lbs.

**Height Attachment**—Increases capacity of 14" Band Saw from  $6\frac{1}{4}$ " to  $12\frac{1}{4}$ " under the guide. Add at any time. Needs 105" blades.



**No. 28-984 (old 894) Height Attachment** with cast block, dowels and bolt, extension front blade guard, wood back blade guard. 12 lbs.

**No. 34-895 Miter Gage**—For straight and angle operations. Has  $\frac{3}{8}$  x  $\frac{3}{4}$  x 18" guide bar and pivoting work support body with pointer and calibrations reading through  $120^\circ$  swing. Adjustable, positive stops at  $90^\circ$  and  $45^\circ$  positions. 4 lbs.

**No. 34-568 (old 865) Clamp Attachment for Sliding Jig**—With clamp bar, two sliding clamp screws, and front and rear posts.  $1\frac{1}{2}$ " lbs.

**No. 34-873 (old 873) Extra Clamp Screw and Block**—For Clamp Attachment.  $\frac{1}{2}$  lb.

## WOOD CUTTING BAND SAW BLADES

**For 14" Band Saws:** 93 $\frac{1}{2}$ " blades are standard; 105" blades used with 28-984 Height Attachment.  $\frac{1}{2}$  lb.

Number (93 $\frac{1}{2}$ " Long)	Number (105" Long)	Width	Min. Cut. Rad.	Teeth per In.
28-032 (old 1032)	28-045 (old 1045)	$\frac{1}{8}$ "	$\frac{1}{4}$ "	6
28-033 (old 1033)	28-046 (old 1046)	$\frac{1}{16}$ "	$\frac{3}{16}$ "	6
28-034 (old 1034)	28-047 (old 1047)	$\frac{1}{4}$ "	$\frac{3}{8}$ "	6
28-036 (old 1036)	28-048 (old 1048)	$\frac{1}{8}$ "	$1\frac{1}{16}$ "	5
28-038 (old 1038)	28-050 (old 1050)	$\frac{1}{2}$ "	$2\frac{1}{2}$ "	5
28-040 (old 1040)	28-052 (old 1052)	$\frac{3}{4}$ "	$5\frac{1}{16}$ "	4

## METAL CUTTING BAND SAW BLADES

These are regular set, hard-edge, flexible-back standard blades for cutting all metals.

**For 14" Metal Cutting Band Saw:** All blades are 93 $\frac{1}{2}$ " long.  $\frac{1}{2}$  lb.

Number	Width	Minimum Cut. Rad.	Teeth Per In.
28-058 (old 1058)	$\frac{1}{2}$ "	$2\frac{1}{2}$ "	10
28-060 (old 1060)	$\frac{1}{2}$ "	$2\frac{1}{2}$ "	14
28-062 (old 1062)	$\frac{1}{2}$ "	$2\frac{1}{2}$ "	18
28-064 (old 1064)	$\frac{1}{2}$ "	$2\frac{1}{2}$ "	24

## SKIP TOOTH BAND SAW BLADES

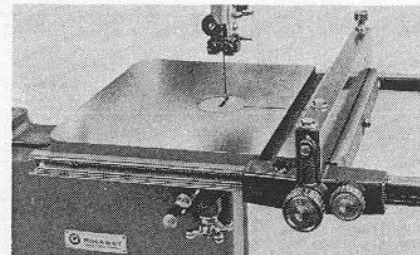
**For 14" Band Saws:** For cutting aluminum, magnesium, plastics and all kinds of wood. All blades are 93 $\frac{1}{2}$ " long.  $\frac{1}{2}$  lb.

Number	Width	Minimum Cut. Rad.	Teeth Per In.
28-884	$\frac{1}{4}$ "	$\frac{3}{8}$ "	6
28-885	$\frac{3}{8}$ "	$1\frac{1}{16}$ "	4
28-886	$\frac{1}{2}$ "	$2\frac{1}{2}$ "	4
28-887	$\frac{3}{4}$ "	$5\frac{1}{16}$ "	4

**No. 28-810 Sanding Attachment**—Includes flat and curved platens with guides and mounting brackets. 1 lb.

**No. 28-836 Sanding Belt**—Garnet type, five, No. 80 grit, fine,  $\frac{1}{2}$ " wide, 91" long. 1 lb.

**No. 28-837 Sanding Belt**—Garnet type, five, No. 40 grit, medium,  $\frac{1}{2}$ " wide, 91" long. 1 lb.



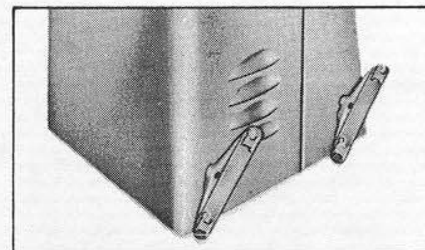
**No. 28-843 Rip Fence**—With 18" guide bars and mounting screws. 13 lbs.

**No. 28-845 Rip Fence**—With 32" guide bars and mounting screws. 10 lbs.

## RETRACTABLE CASTER SETS

Make your Rockwell Delta Band Saws mobile and increase their usefulness to your operation.

With Delta Retractable Casters on your machines, you can easily wheel them about your plant or shop—right to the job site. 13 lbs.



**No. 50-111 Retractable Caster Set**—For 50-122 enclosed steel stand. Has built-in leveling screws. 13 lbs.

## **HOW TO ORDER REPLACEMENT PARTS**

Even quality built tools such as the Rockwell power tool you have purchased, might need occasional replacement parts to maintain it in good working condition over the years. To order replacement parts, contact or write your nearest Rockwell Service Center listed on the back page of this manual.

Please give the following information:

1. Model No. and Serial No. and all specifications shown on the Model No./Serial No. plate.
2. Part number or numbers as shown in the Replacement Parts list supplied with your power tool.
3. A brief description of the trouble with the power tool.