

Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual

† BOOK No .B672.



PLEASE INSERT SERIAL NUMBER OF MACHINE

INSTRUCTION MANUAL FOR

C8**800mm Bandsaw****Specification**

Dia. of Wheels	800mm	(31.5in)
Width of Saw Blade, max	88mm	(1.5in)
Length of Saw Blade, max	6600mm	(220in)
Length of Saw Blade, min	5400mm	(212in)
Depth under Saw Guide	539mm	(21in)
Max. Cut Width	780mm	(30.7in)
Speed of Motor, 50 hertz	3000 rev/min	
Speed of Motor, 60 hertz	3600 rev/min	
Power of Motor	4kW	(5.5hp)
	*5.5kW	(7.5hp)
Size of Table	765 x 1100mm	(30 x 43in)
Height of Table	955mm	(37in)
Floor Space	770 x 1340mm	(30 x 52.7in)
Weight	510kg	(1124 lb)
Speed of Saw Blade	1508 m/min	(4948 ft/min)

* Optional Extra.

FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES,

CONTACT:- WADKIN CLEVELAND (Division of Wadkin Ltd.)
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HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

WADKIN LTD., supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the user's responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.
2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.
3. Only personnel trained in the safe use of a machine should operate it.
4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.
5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

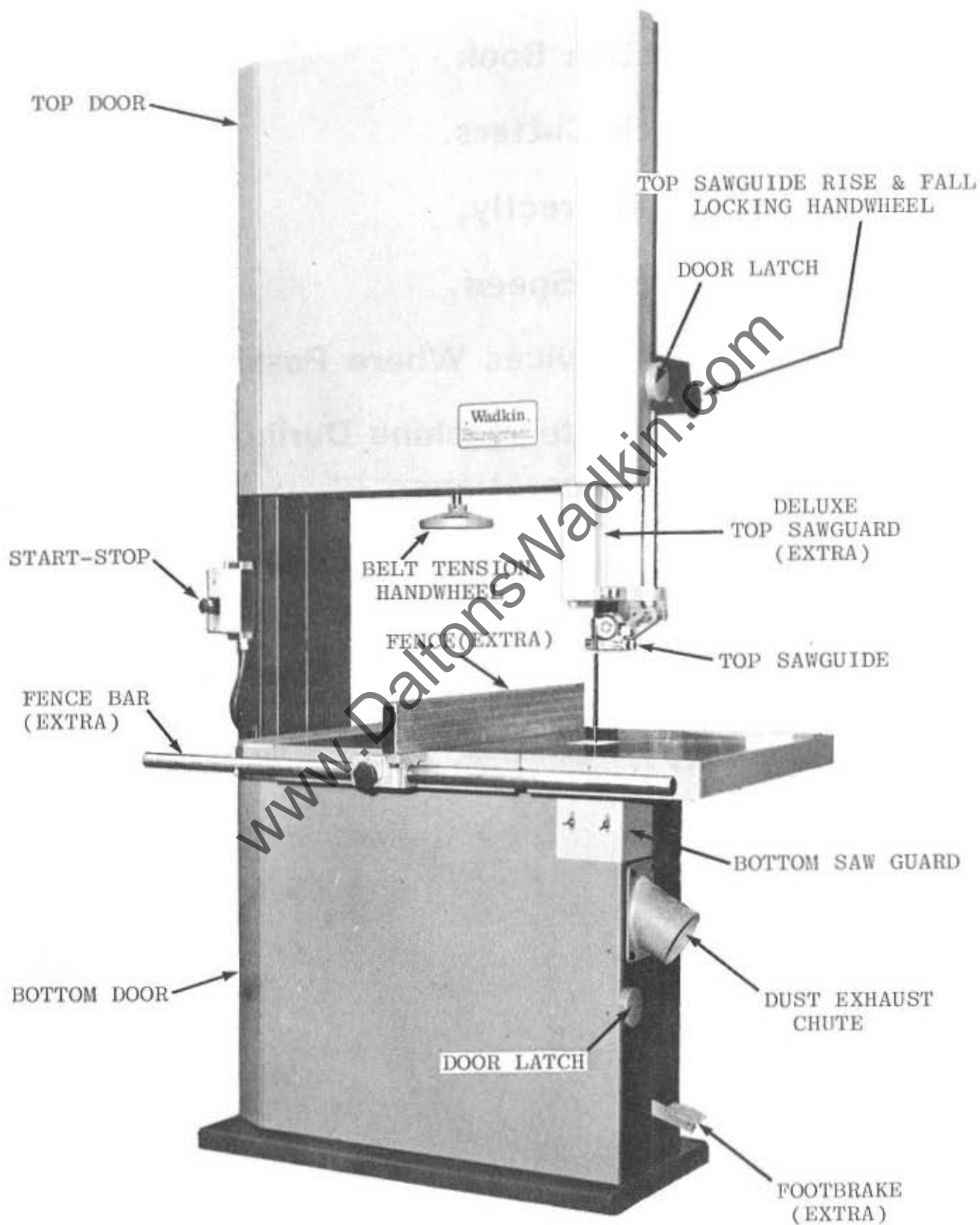
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SAFETY

- 1. Read Instruction Book.**
- 2. Securely Lock Cutters.**
- 3. Set Guards Correctly.**
- 4. Select Correct Speed.**
- 5. Use Feeding Devices Where Possible.**
- 6. Electrically Isolate Machine During Maintenance & Setting Up Operations.**
- 7. Refer To HSW Booklet No.41. (in UK) For Safety In The Use Of Woodworking Machinery.**

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800 mm Bandsaw Type C8



BANDSAW SLINGING INSTRUCTIONS.

To lift bandsaw proceed as follows:-

1. Swing top sawguard clear of guide unit then open top door of machine.
2. Position minimum length sling of 5 metres (16 feet) around top frame and behind top wheel as shown in PHOTO 1 and PHOTO 2.
NOTE: To prevent damage to sling and frame, place rags between slings and machine as shown.
3. Secure door to top sawguide rise and fall locking handwheel by strong cord as shown in PHOTO 3.
4. Proceed to slowly lift bandsaw ensuring that bandsaw is not tilting at an angle.

IMPORTANT: A MINIMUM LENGTH SLING OF 5 METRES (16 FEET) WITHIN THE SAFE WORKING LOAD MUST ALWAYS BE USED

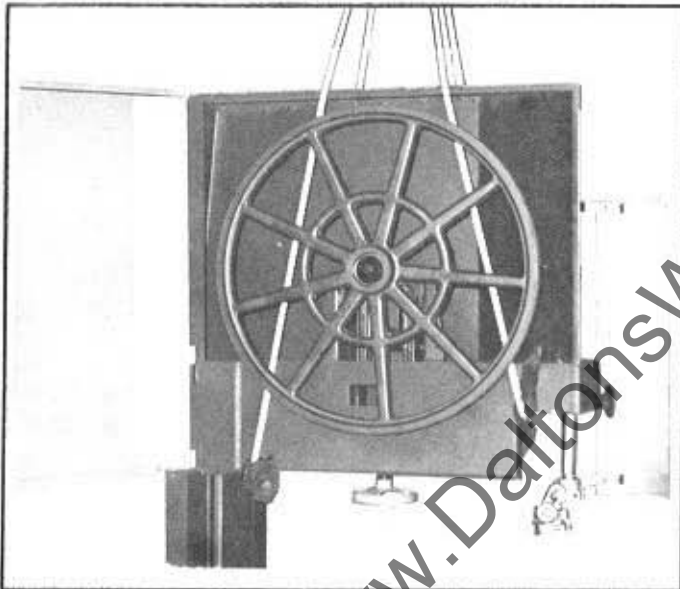


PHOTO 1

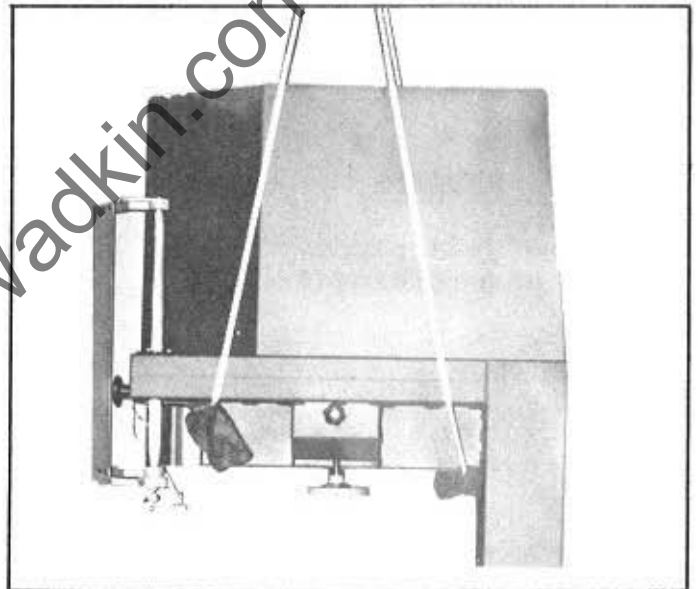


PHOTO 2

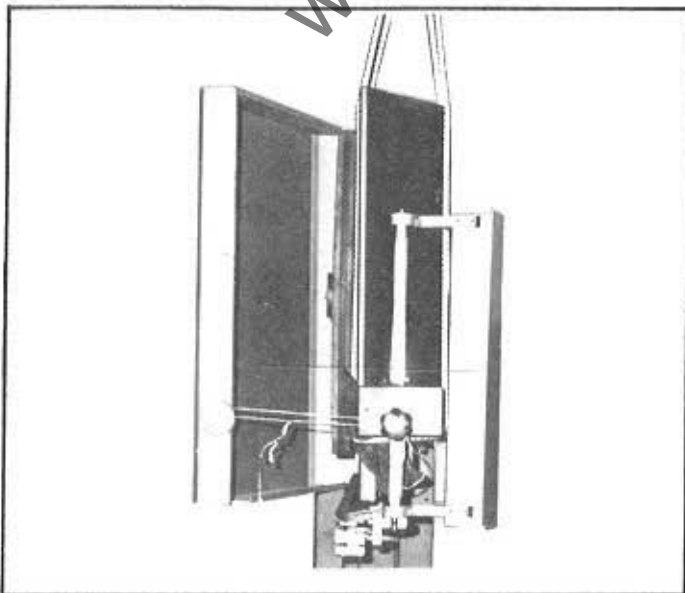


PHOTO 3

INSTALLATION.

Remove protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent. When the machine is cased for export, the top cover, top door, top wheel and table are removed and packed individually. Re-assemble machine as follows:

1. Secure top cover "A", FIG.1, to top of main frame by 4 - 12mm bolts "B".
2. Fit top wheel to spindle and secure by 1 - 12mm bolt and flange washer, See FIG.2.
3. Locate top door on hinges, FIG.3, and bottom door on hinges, FIG.4.
4. Position table on lower main frame and secure with 1 - 16mm nut and flange washer "A", FIG.5. (Table removed for export only)

FOUNDATION.

See enclosed foundation drawing for bolt positions and clearance required. When installing machine, level by packing under base. Foundation bolts are not supplied with the machine except by special order.

WIRING DETAILS.

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to the starter.

Points to note when connecting to power supply.

1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
2. It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.
3. Check the main line fuses are of the correct capacity.
4. Connect the line leads to the appropriate terminals. See Foundation Drawing for wiring details.
5. Check all connections are sound.
6. Check the rotation of the motor for the correct direction. If this is incorrect, reverse any two of the line lead connections.

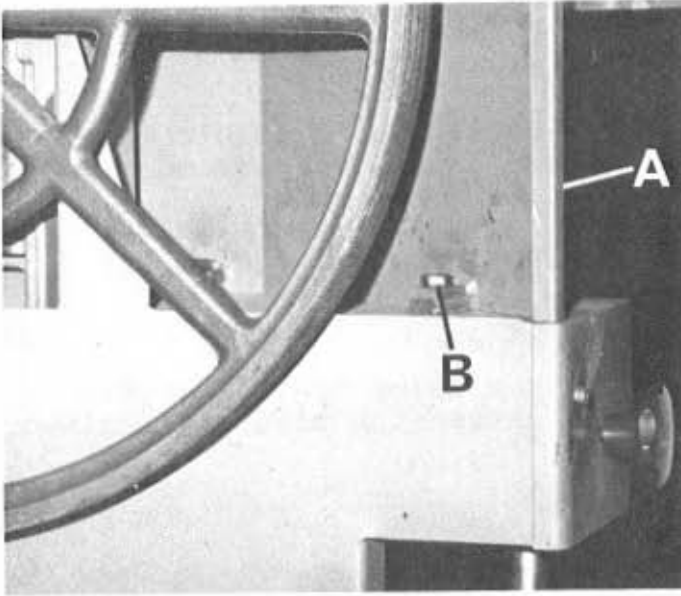


FIG 1

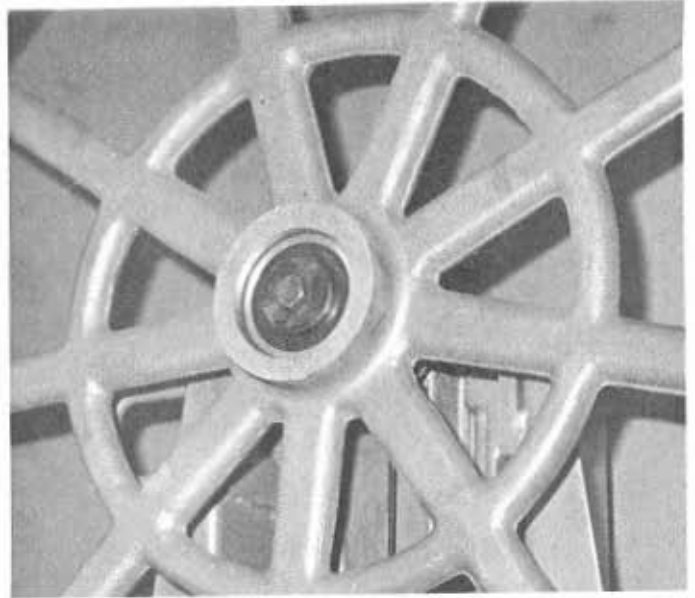


FIG 2

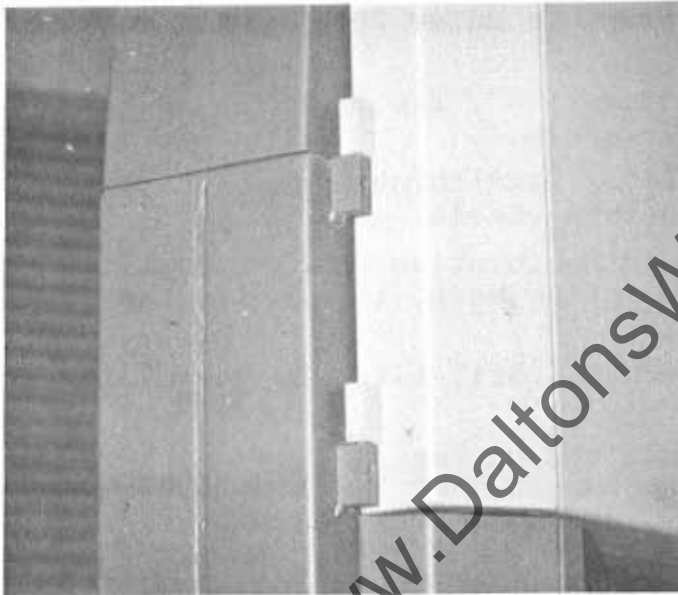


FIG 3



FIG 4

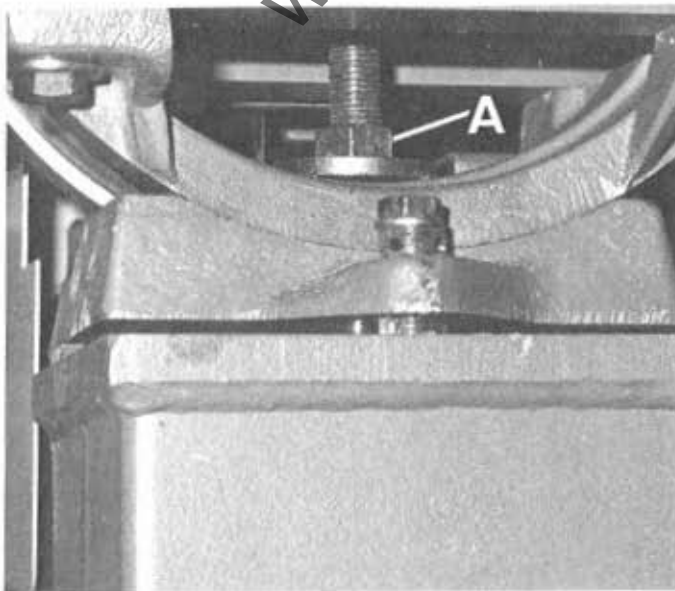


FIG 5

LUBRICATION.

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting. Clean sawdust from inside main frame weekly. See enclosed Foundation Drawing for lubrication points.

Type of Grease Recommended: CASTROL SPHEEROL AP.3. or equivalent.

DUST EXTRACTION.

The machine has a built in dust chute with a 127mm dia. exhaust outlet and can be connected to main dust extraction plant if desired.

FITTING BANDSAW BLADES.

1. Isolate machine electrically.
2. Open top and bottom doors of main frame.
3. Swing sawguard "A", FIG.6, clear of guide "B".
4. Loosen allen screw "A", FIG.7, and move guide "B" to extreme rear position.
5. Lower top wheel assembly by handwheel "A", FIG.8, sufficient to allow blade to be fitted to both wheels.
6. Insert blade through slot "A", FIG.9, and through slot in table then position blade on top and bottom wheels.

NOTE: Cutting rake of teeth should be pointing down at cutting point. If teeth are not pointing down, turn blade inside out.

7. Turn tensioning handwheel "A", FIG.8, until blade is just held on the wheels.
8. Proceed to track sawblade as explained on Page.12.

TABLE INSERT.

The table insert can be easily made from hardwood following drawing FIG.29A, on page 25.

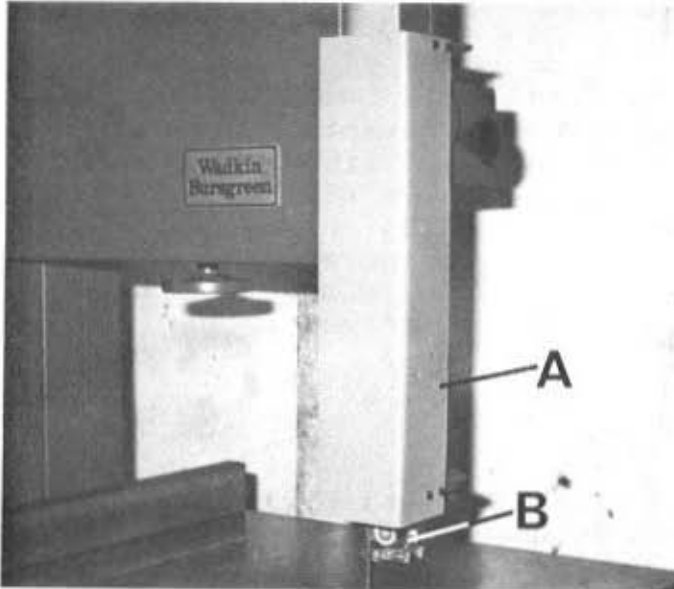


FIG 6

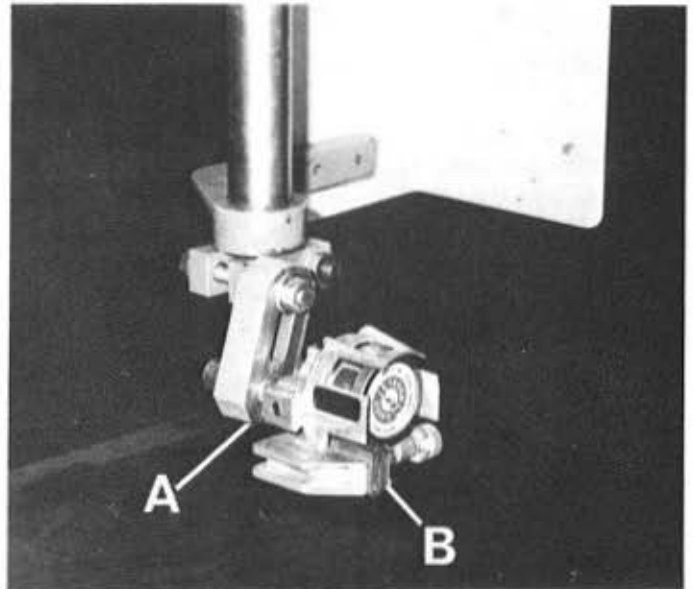


FIG 7

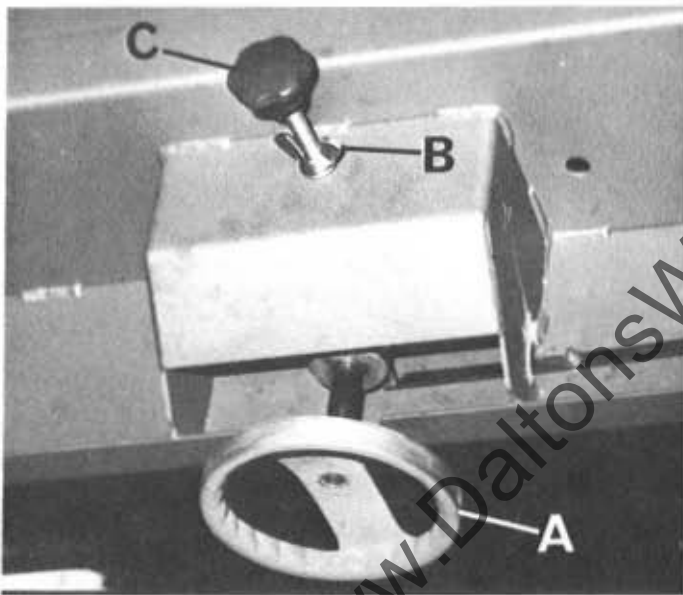


FIG 8

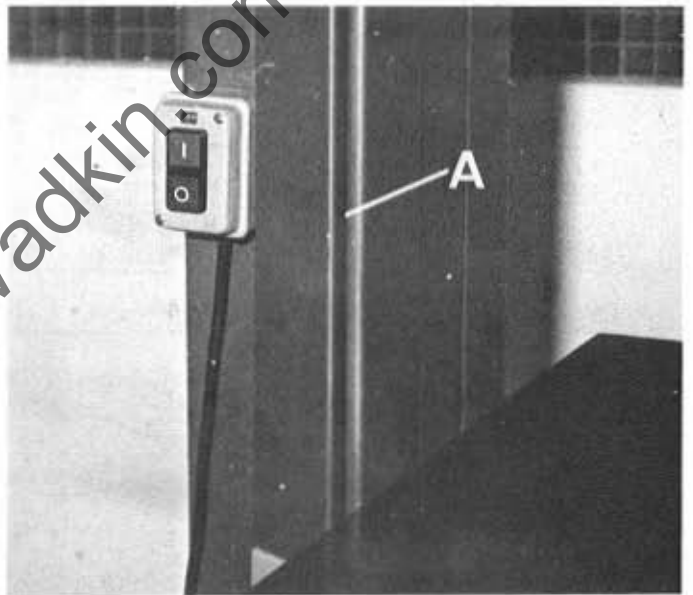


FIG 9

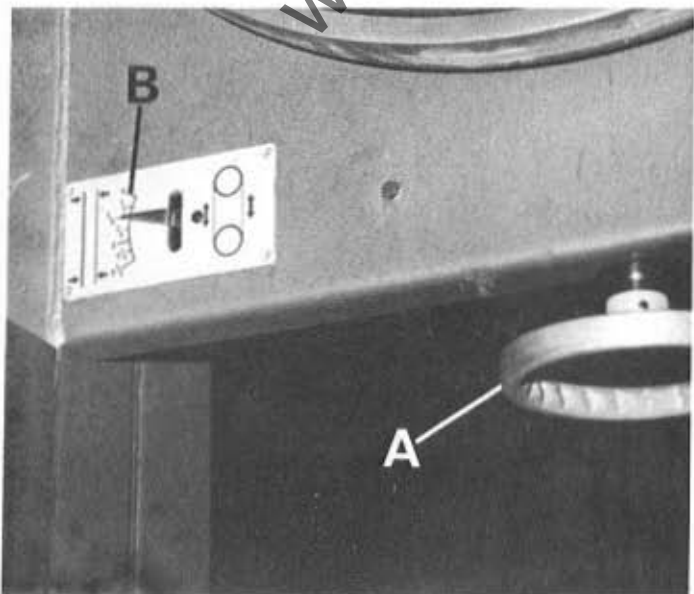


FIG 10

TRACKING OF SAWBLADE ON WHEELS.

Every sawblade has slightly different running characteristics on a bandsaw machine due to the condition of the steel ribbon from which the blade is made, the blade joints and tension in the blade ribbon. This is compensated by using a crowned or slightly curved cork (STANDARD), or long life rubber (EXTRA) tyre on the wheel and providing the top wheel with slight tilting adjustment.

To check the tracking of sawblade, follow the undermentioned procedure:

1. Isolate machine electrically.
2. Open top and bottom doors.
3. Rotate the top wheel slowly by hand in a clockwise direction and check the blade is running central on the wheels.
4. If not running central, loosen wingnut "B", FIG.8, then turn handwheel "C" until saw is tracking correctly, i.e. in the centre of both wheels.
5. When tracking is correct, tighten wingnut "B". This adjustment is most important, that the sawblade, when tracking correctly, passes in a straight line between top and bottom wheels and does not snake, - when the latter occurs, the back of the sawblade keeps hitting the back guide roller and woodwork, resulting in damaged guides.

DANGER: DO NOT TRACK BLADE WITH MOTOR RUNNING.

TENSIONING SAWBLADE. (Without tension scale).

The sawblade should always be tensioned correctly to achieve maximum blade life. Over-tension or under-tension of blade could result in saw damage.

To tension blade correctly, proceed as follows:

1. Isolate machine electrically.
2. Turn handwheel "A" FIG.8, until blade can be pulled 6mm ($\frac{1}{4}$ ") from its true line at central point between wheels. Blade is then tensioned correctly.

TENSIONING SAWBLADE USING SCALE (EXTRA).

The sawblade should always be tensioned correctly to achieve maximum blade life. Over-tension or under-tension could result in saw damage.

To tension blade correctly, proceed as follows:

1. Isolate machine electrically.
2. Open top door of machine.
3. Turn handwheel "A", FIG.10, until pointer on scale "B" points to the corresponding width of blade being used.
Blade is then tensioned correctly.

ADJUSTMENT OF SAWBLADE TENSION SCALE (EXTRA).

The scale and pointer are accurately set before despatch from the works. Should this be displaced for any reason, check the scale by the undermentioned procedure:

1. Isolate machine electrically.
2. Tension the sawblade as previously described until it can be pulled $\frac{1}{4}$ " (6mm) from its true line at a central point between the two wheels.
3. Check that scale indicates correct sawblade width. If scale is incorrect, tension sawblade to maximum tension by handwheel "A", FIG.11.

NOTE: For safety, the blade used during this adjustment must be wider than 1" (25.4mm).

4. When maximum blade tension is attained, loosen M8 socket head grubscrew "B" then move collar "C" until pointer on scale indicates maximum blade width of $1\frac{1}{2}$ " or 40mm.
When set, relock M8 grubscrew "B".

5. Turn tension handwheel "A" until scale corresponds to width of blade fitted.

NOTE: When scale has been set using above procedure it will read correctly for any width of blade within the range of the machine without further alteration, even if length of sawblade varies for any given width.

For a 20mm wide blade, the pointer should read 20, etc.

If the machine is left standing for a period, e.g. overnight, the tension should be reduced, and the blade re-tensioned before putting the machine into operation again.

SETTING TOP SAWGUIDE UNIT.

A sawguide unit "A", FIG.12, is fitted above the table and is fully adjustable for adequate sawblade support. The unit is fitted with TEFLOY support blocks and a long life bearing.

NOTE: A similar guide unit for below the table can be supplied as an optional extra.

To set top guide assembly, proceed as follows.

1. Isolate machine electrically.
2. Swing guard "B", FIG.12, clear of guide.
3. Loosen allen screws "A", "B" and "C", FIG.13, then position guide parallel to table top ensuring sawblade is central in gap. Lock screw "B" then move guide unit either forward or back until saw teeth protrude slightly from front of support blocks as shown in FIG.14.
When positioned correctly, relock screw "A" FIG.13, ensuring guide unit is parallel to table top.
4. Move guide roller "D", FIG.13, to position shown in FIG.14. When set correctly; relock screw "C".
5. Loosen locking screw "A", FIG.15, and set guide blocks just clear of sawblade by adjusting screws "B". When set, tighten screw "A".
NOTE: Positioning of support blocks as above ensures that support is given to sawblade but blocks do not nip blade.
6. Swing guard "B", FIG.12, back to working position as shown in FIG.12.

TO VERTICALLY ADJUST TOP GUIDE UNIT, PROCEED AS FOLLOWS:

1. Isolate machine electrically.
2. Hold guide assembly "A", FIG.16, then loosen handwheel "B".
3. Position guide assembly "A" as required then relock handwheel "B".

SETTING BOTTOM SAWGUIDE UNIT IF FITTED AS OPTIONAL EXTRA.

The bottom sawguide unit is fitted below the machine table and is set using similar procedure to top sawguide unit.

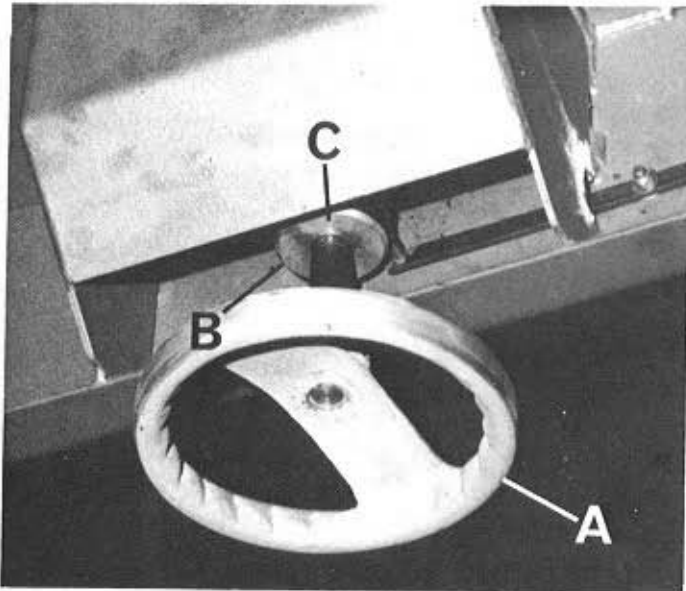


FIG 11

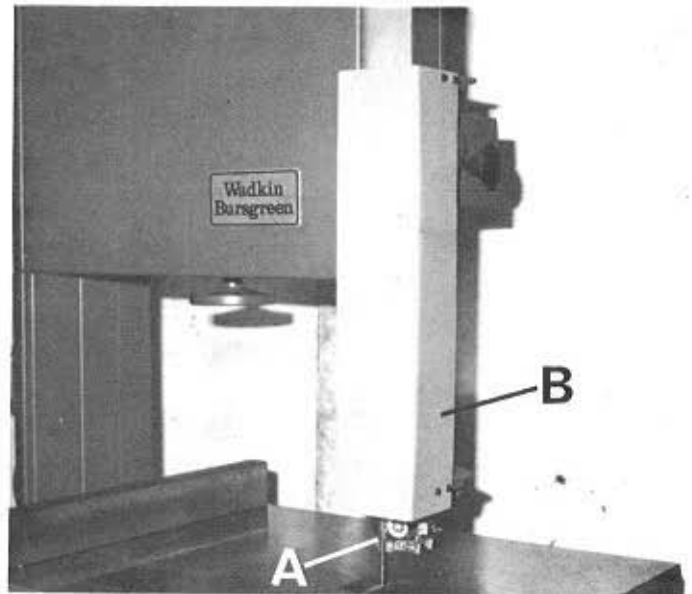


FIG 12

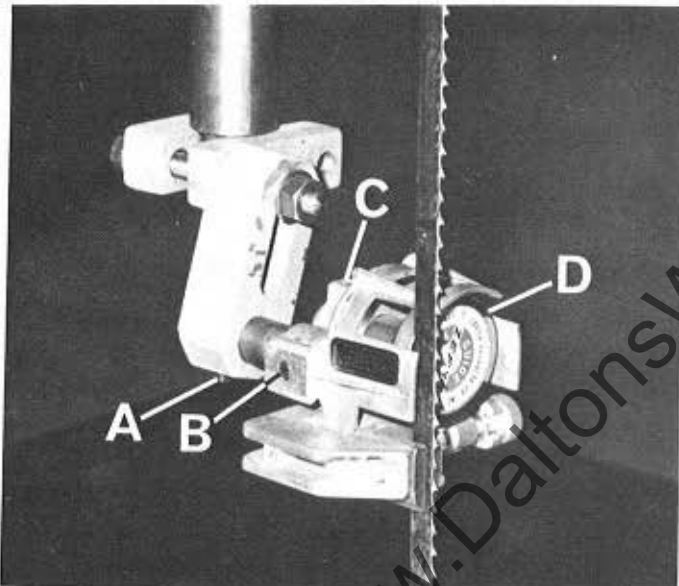


FIG 13

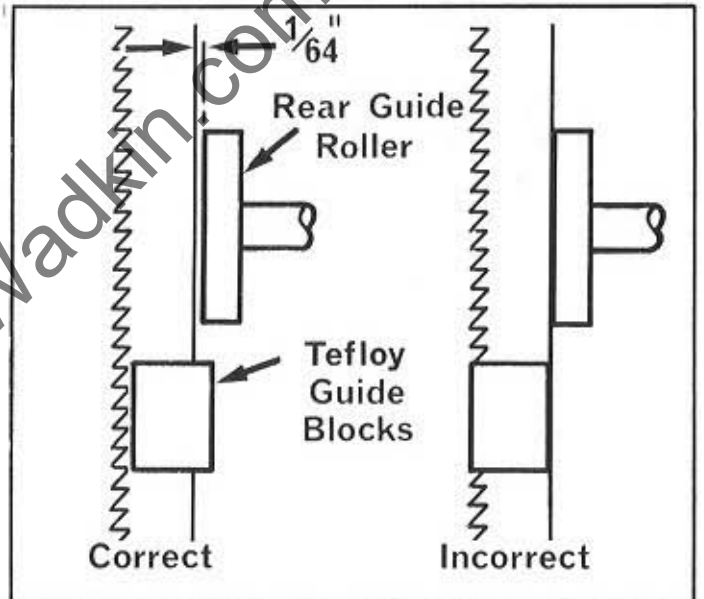


FIG 14

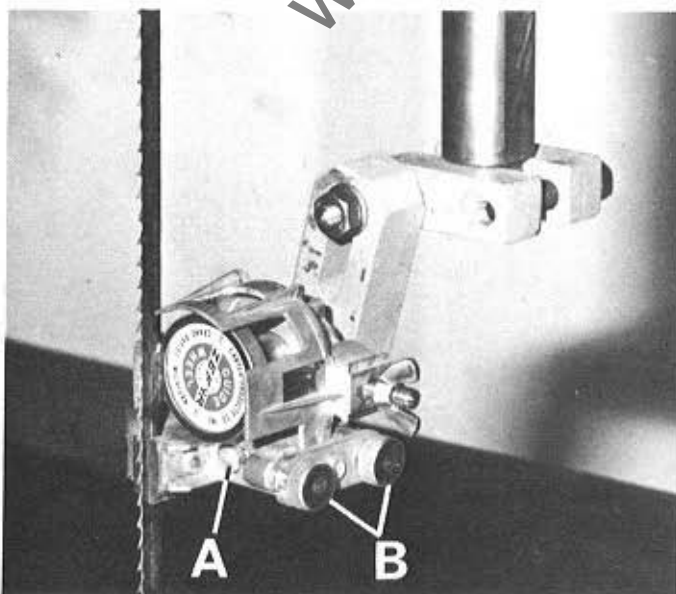


FIG 15

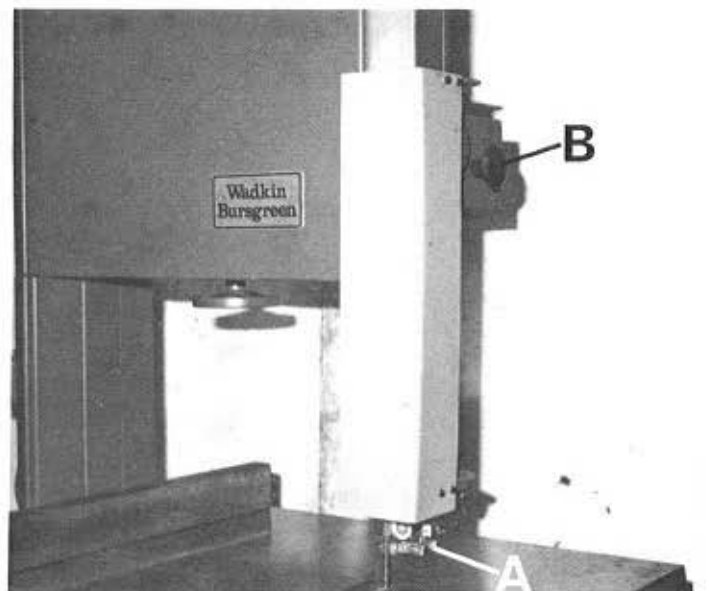


FIG 16

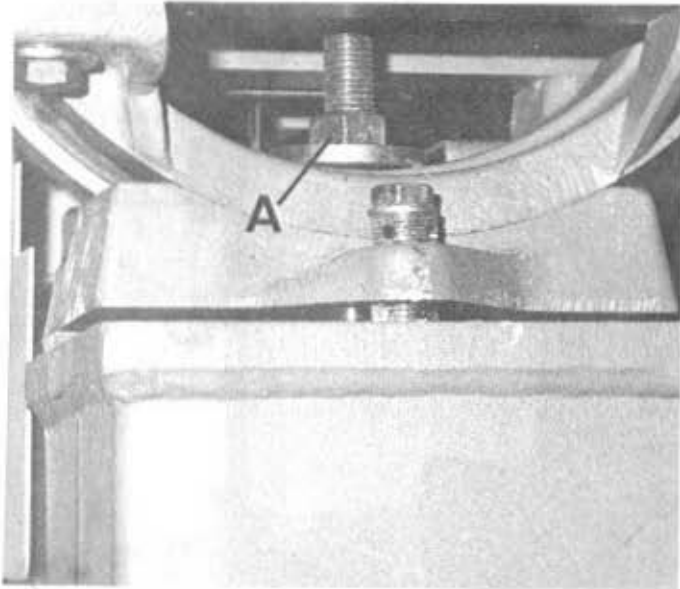


FIG 17

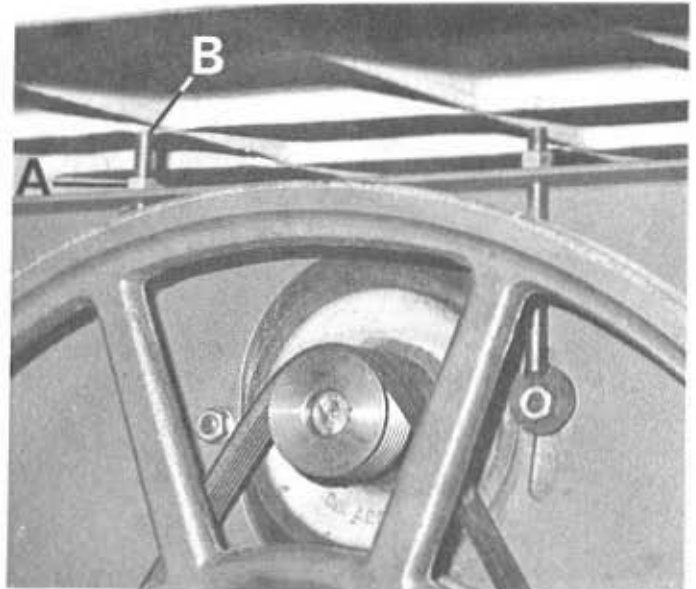


FIG 18

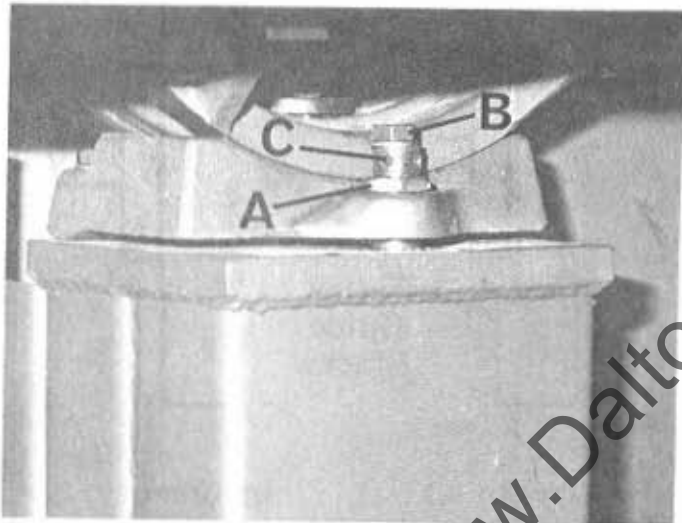


FIG 19

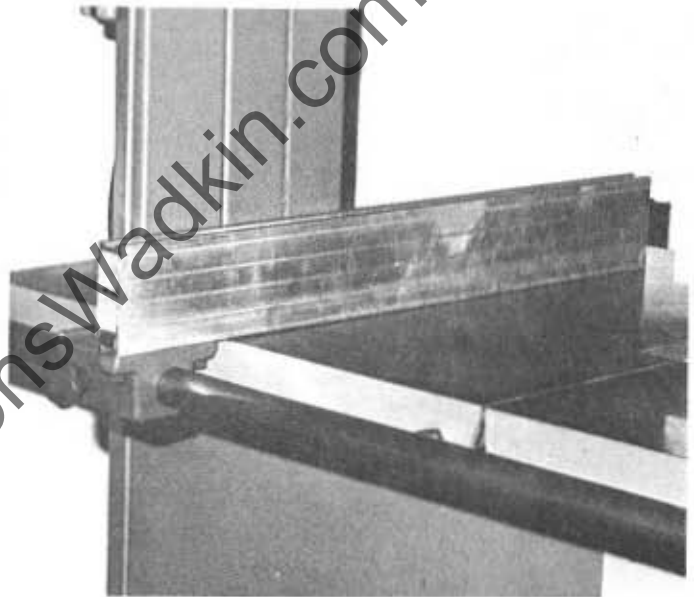


FIG 20

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TABLE.

The table cants 36° to the right.
To cant table proceed as follows:

1. Support table weight.
2. Loosen locknut "A", Fig.17.
3. Cant table to required angle.
4. Relock locknut "A".

TABLE 90° POSITIVE STOP ADJUSTMENT.

The table 90° positive stop is set correctly before despatch from the works but should this setting be disturbed for any reason, follow the undermentioned procedure:

1. Isolate machine electrically.
2. Ensure top guides (and bottom guides if fitted) are clear of the blade, so it is not restricted in any way.
3. Check blade is square to table by means of a steel square.
4. If adjustment is necessary, loosen M16 locknut "A", FIG.17, and M12 locknut "A", FIG.18.
5. Set table square to sawblade by the steel square then relock M16 nut "A", FIG.17.
6. Turn screw "B", FIG.18, until it locks against underside of table then relock M12 locknut "A".

TABLE SQUARE TO SAWBLADE ADJUSTMENT.

The table is set square to sawblade, from front to rear, before despatch from works. Should this setting be disturbed for any reason, check the following:

1. Isolate machine electrically.
2. Ensure top guide (and bottom guides if fitted) are clear of sawblade so blade is not restricted in any way.
3. Check blade is tracking correctly, i.e. running in the centre of each wheel, (See Tracking of Sawblade instructions, page 12.)
4. Check blade for square to table by means of a steel square.

If adjustment is necessary, proceed as follows:

1. Loosen M20 locknut "A", FIG.19, and M10 bolt "B".
2. Insert small toggle (not supplied) into holes in M20 adjusting screw "C" and turn screw "C" until table is set square to sawblade.
3. When table is set square to sawblade, tighten M10 bolt "B" and M20 locknut "A".
4. Reset top guide (and bottom guide if fitted).

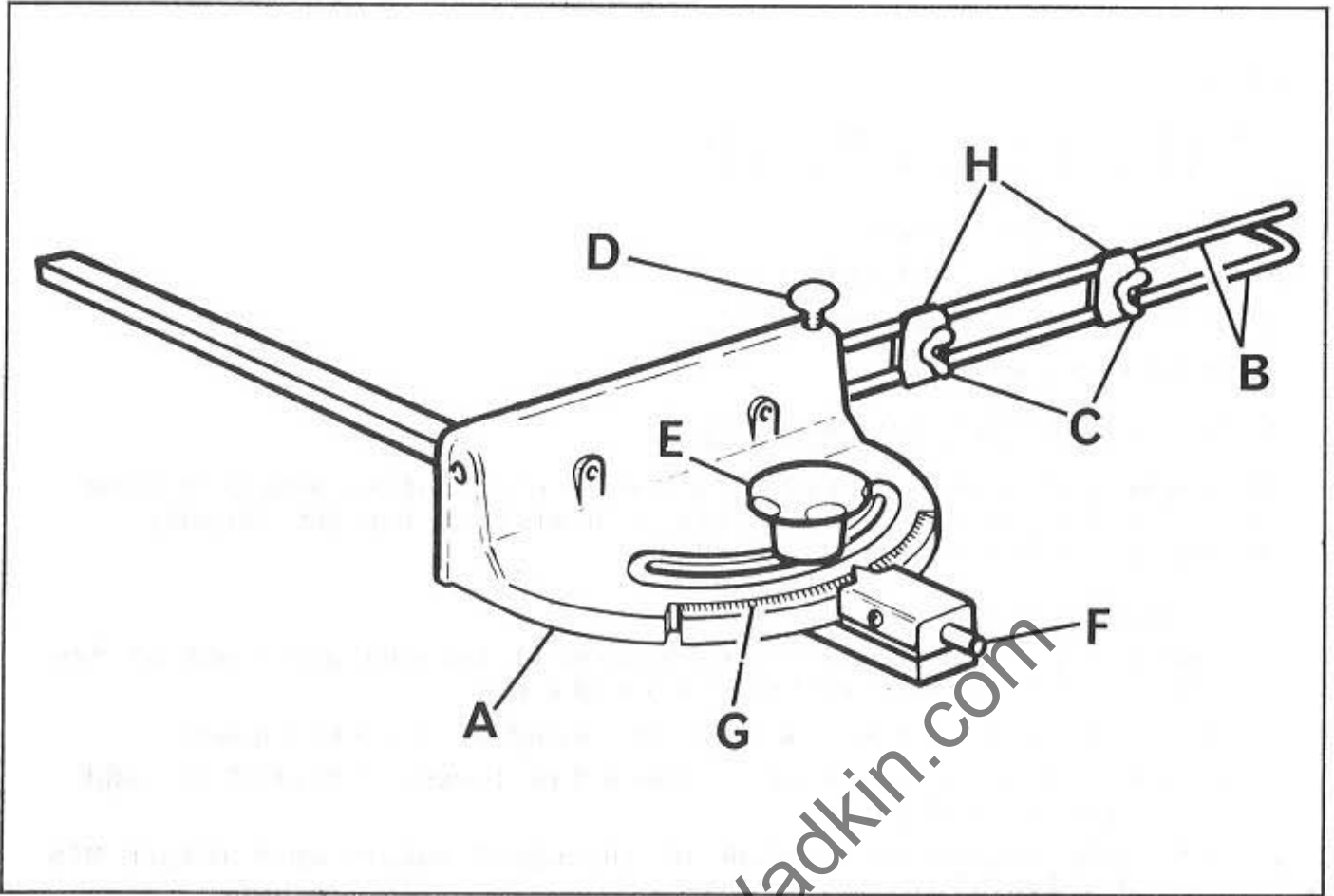


FIG 21

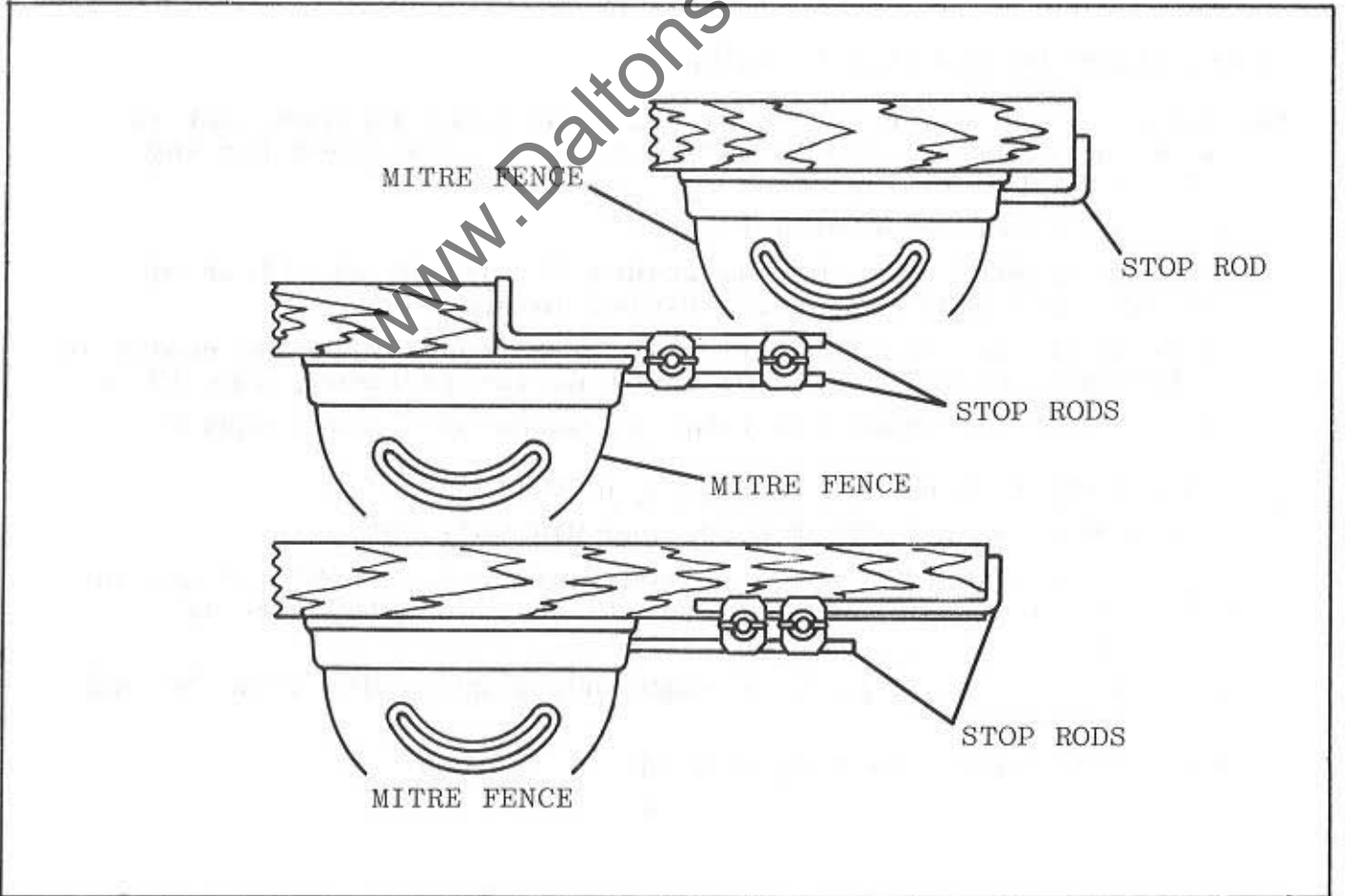


FIG 22

RIP FENCE (EXTRA).

A rigid rip fence FIG.20, is mounted on a round slide bar fitted to edge of table.

This fence can be mounted to rip either to inside or outside of bandsaw blade.

MITRE FENCE (EXTRA, SUPPLIED WITH MACHINE BY SPECIAL ORDER).

The mitre fence "A" in FIG.21, slides in the table slot. Two stop rods "B" are held together by two clamps "H" and wingnuts "C".

The stop rods are secured to fence body by thumbscrew "D".

NOTE: Always ensure the stop rods are set clear of the sawblade or serious damage will result when machine is operated.

The mitre fence can be rotated through 90° with positive stops at 90° and 45° . To position mitre fence at required angle, loosen handwheel "E" in FIG.21, then pull plunger "F" from location, position fence as required using scale "G" then relock handwheel "E".

NOTE: Always ensure table slot is clean when using mitre fence.

MITRE FENCE STOP RODS.

Accurate repetitive cutting can be made using the stop rods, see FIG.22.

The rods are held in the fence by the thumbscrew "D" in FIG.21, and the stop rods held together by the two clamps "H".

To adjust the rods by the clamps, loosen the wingnuts "C".

STARTING - STOPPING.

Start and Stop buttons are situated on the column of machine as shown in FIG.23.

FOOTBRAKE (EXTRA).

A footbrake is situated in the base of the machine as shown in FIG.24.

NOTE: Always press "STOP" button before depressing footbrake.

SAW WHEELS.

Saw wheels are fitted with cork tyres (STANDARD) or long life rubber tyres (EXTRA).

NOTE: DISC WHEELS CAN BE SUPPLIED AS AN EXTRA, SEE FIG.25.

Isolate machine electrically and clear top wheel tyre daily to prevent accumulation of sawdust which could cause blade to run from true line.

Badly worn tyres should be replaced as worn tyres cause saw vibration resulting in uneven sawing and saw breakages. We offer a re-tyring service whereby newly tyred wheels are supplied against return of worn wheels; an appropriate charge being made for re-tyring only.

To avail yourself of this service, return worn wheels to:-

WADKIN CLEVELAND(A division of Wadkin Ltd).
NORTH LIVERTON INDUSTRIAL INDUSTRIAL ESTATE.
LOFTUS.
SALTBURN-BY-THE-SEA.
CLEVELAND.
ENGLAND.
(Telephone: LOFTUS, 0287/40177).

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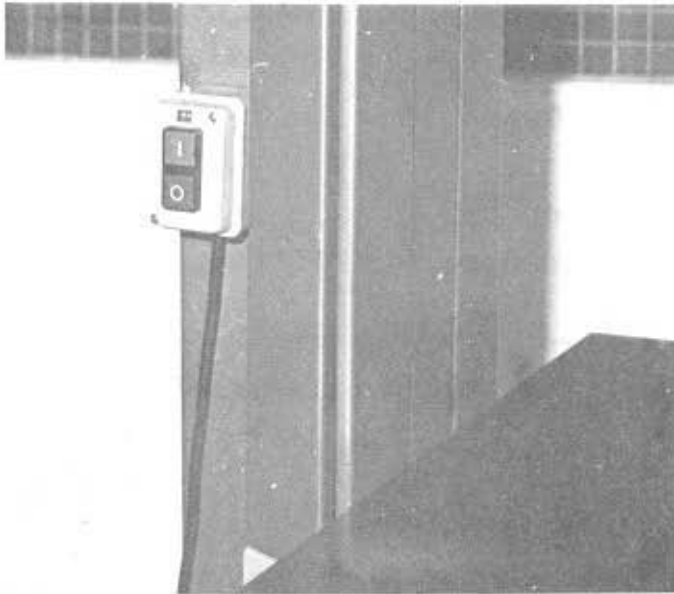


FIG 23

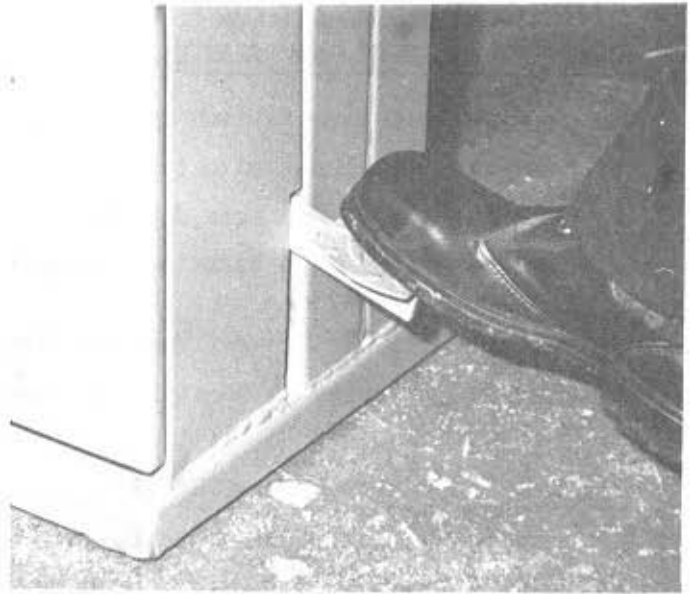


FIG 24



FIG 25

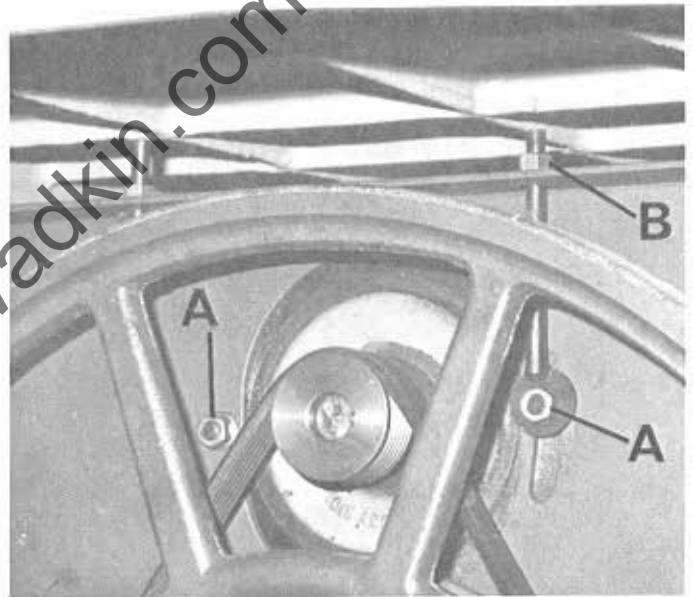


FIG 26

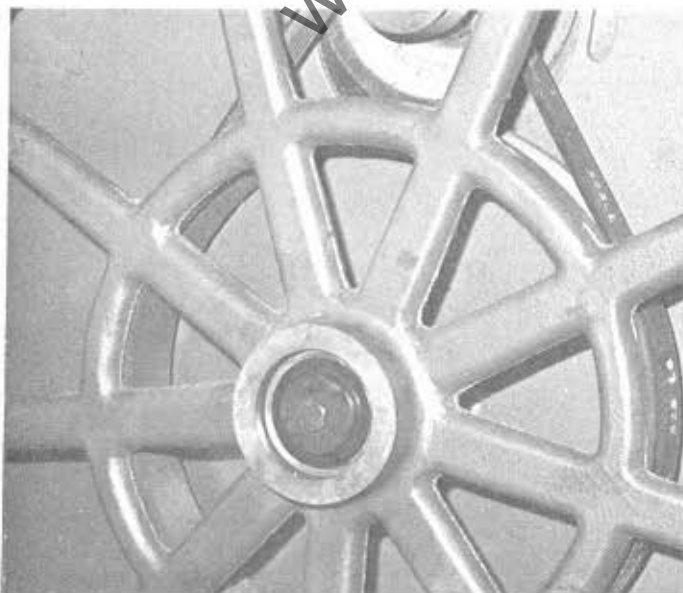


FIG 27

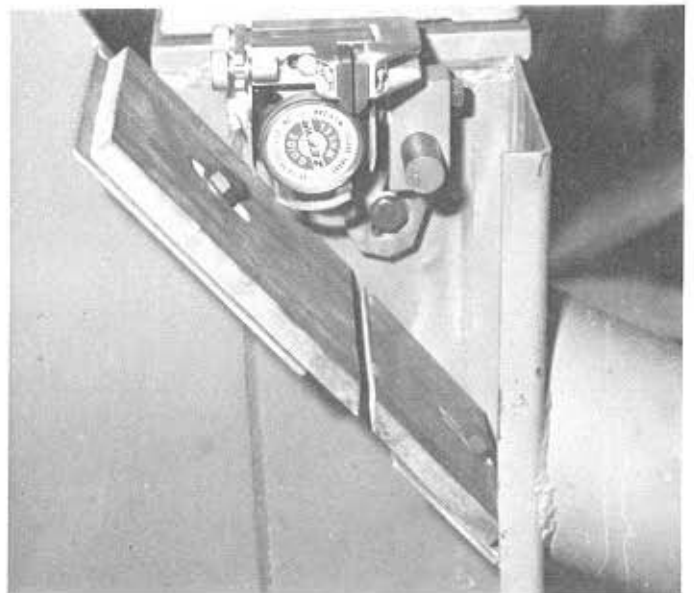


FIG 28

REMOVAL OF TOP SAW WHEEL.

To remove top saw wheel proceed as follows:

1. Isolate machine electrically.
2. Open top and bottom doors of main frame
3. Remove bandsaw blade by reversing procedure for "Fitting Bandsaw Blade", Page.10.
4. Remove M12 bolt and washer from centre of top wheel.
5. Manually support weight of wheel and carefully pull wheel from spindle.

REMOVAL OF BOTTOM SAW WHEEL.

To remove bottom saw wheel, proceed as follows:

1. Isolate machine electrically.
2. Open top and bottom doors of main frame.
3. Remove bandsaw blade by reversing procedure for "Fitting Bandsaw Blade", see Page.10.
4. Loosen 2 - M12 nuts "A", FIG.26, and M12 locknut "B".
5. Turn M12 nut "B" anti-clockwise, releasing belt tension sufficient enough for belt to be removed from motor pulley.
6. Remove M12 bolt and washer from centre of bottom saw wheel, FIG.27.
7. Manually support weight of saw wheel and pull wheel from spindle.

BELT TENSION.

Incorrect tension is the major cause of premature belt failure, some of its effects are as follows:

1. Under-tensioning results in incorrect driven speed caused by belt slip; this can be corrected by increasing tension.
2. Over-tensioning can be more serious. Apart from obvious damage to the belt, it can cause overheated, damaged or burned out motor front end bearings. This is usually preceded by excessive stretch or too many take ups.

The POLY-V drive belt is correctly tensioned before the machine leaves the works.

After a period of time, the belt may start to slip due to run-in stretch and should be re-tensioned correctly as in "Belt Tension Adjustment".

BELT TENSION ADJUSTMENT.

TO TENSION POLY "V" BELT, PROCEED AS FOLLOWS:

1. Isolate machine electrically.
2. Open bottom door of machine.
3. Loosen 2 - M12 nuts "A", FIG.26.
4. Loosen M12 locknut "B".
5. Turn M12 nut "B" to point where slackness is just eliminated from pulleys.
6. Turn M12 nut "B" clockwise 2 full turns when correct belt tension should be attained.
7. Relock M12 locknut "B" and 2 - M12 nuts "A".
8. Close bottom door of machine.

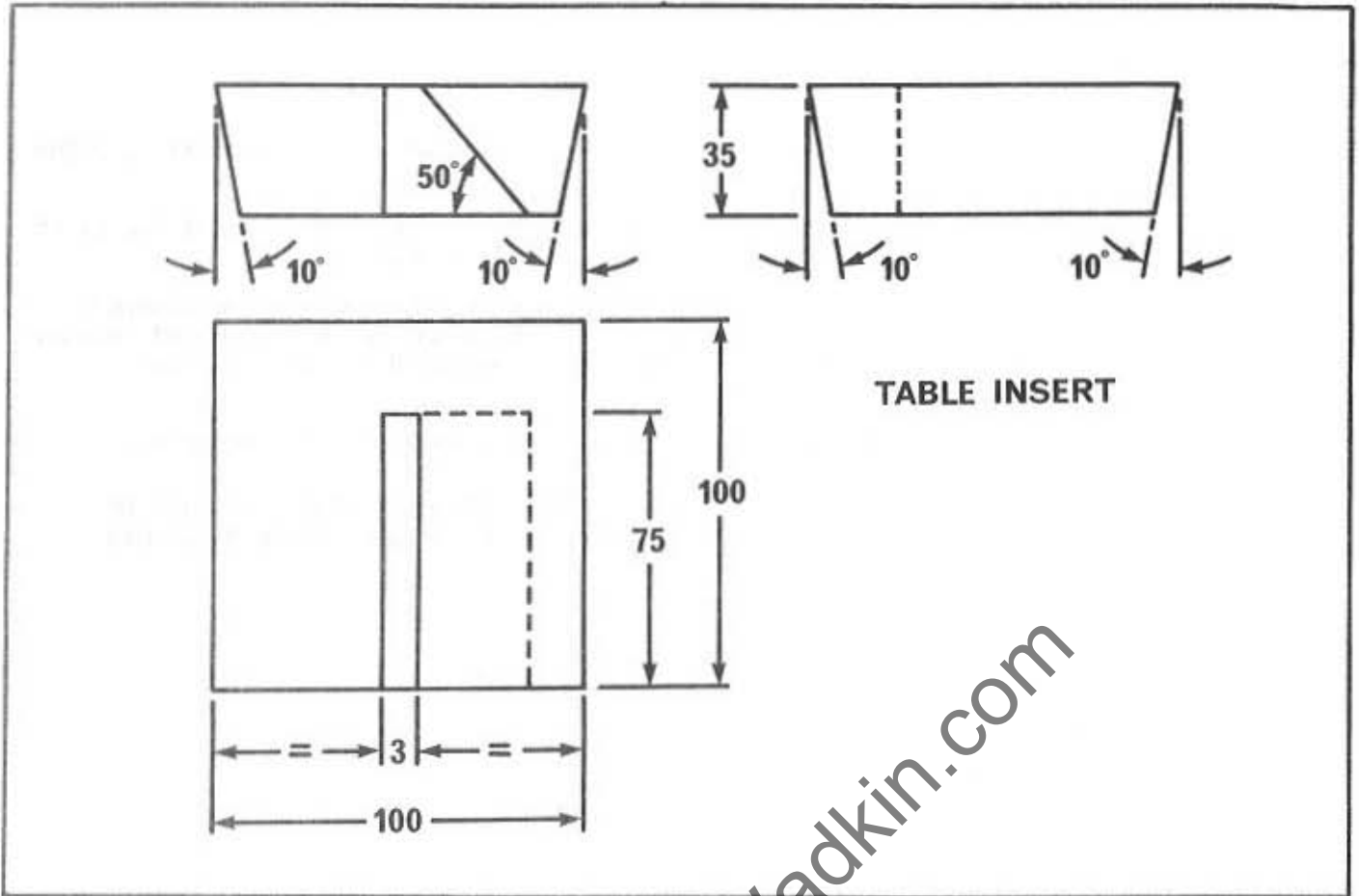


FIG 29A

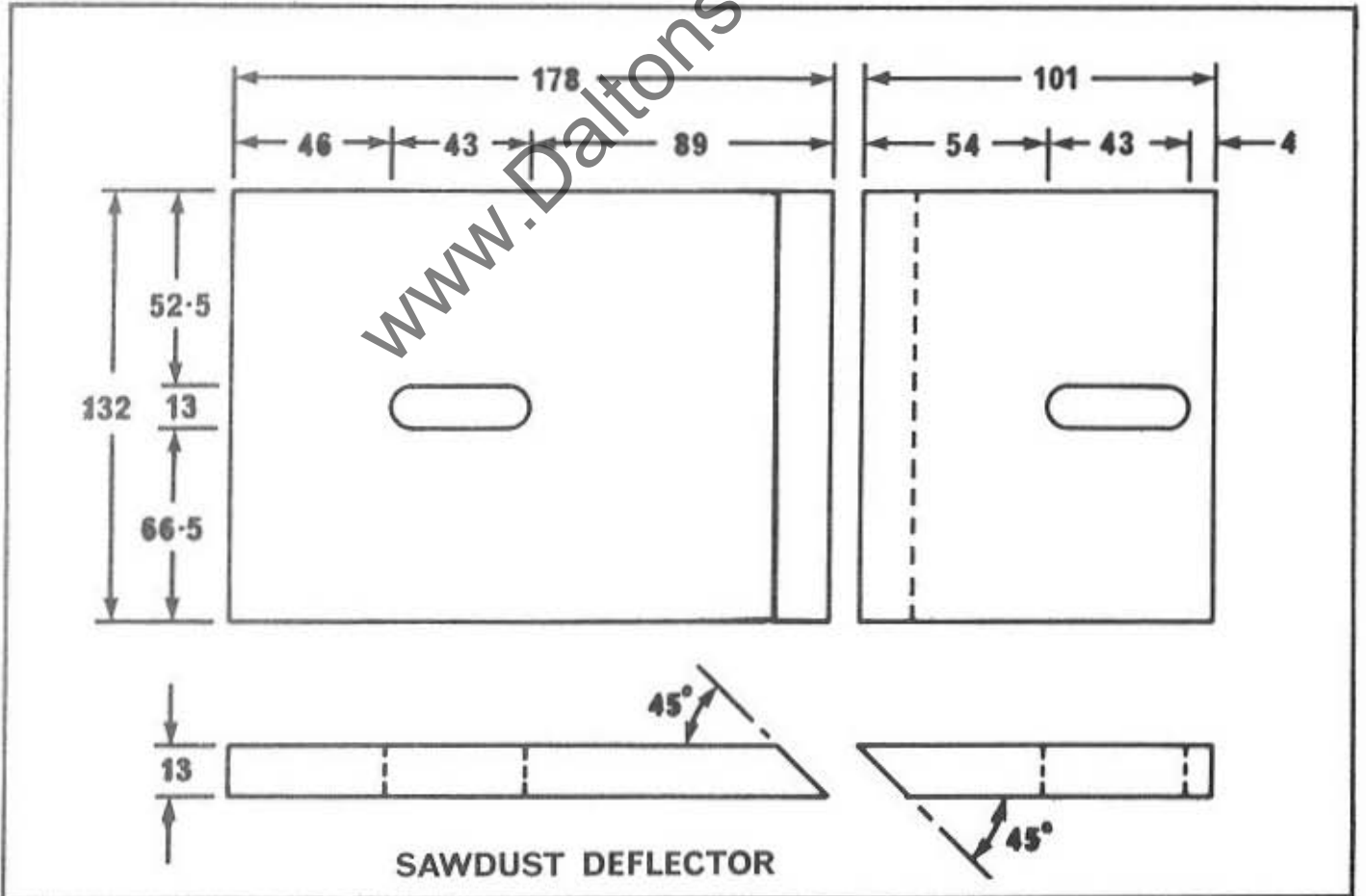


FIG 29B

TABLE INSERT.

The table insert can easily be made from hardwood following the drawing FIG.29.A.

SAWDUST DEFLECTOR.

When machine is operating, most of the sawdust will be passed out via the dust exhaust outlet but inevitably some dust will be carried down with the blade causing a gradual sawdust accumulation in the machine base. This sawdust accumulation can be slowed down considerably by fitting a sawdust deflector near to the dust exhaust outlet as shown in FIG.28. These 2 sawdust deflector pads can be easily made from wood following the drawing FIG.29.B.

When fitting to machine, move deflector pads as close to blade as possible without touching blade then secure in position by 2 - M10 x 25 long hexagon head screws and washers.

MAINTENANCE OF BANDSAW BLADES.

A properly sharpened bandsaw blade will give clean, accurate cutting and this is achieved by proper setting and sharpening of the teeth. Always set the teeth before sharpening.

SETTING.

In order to cut satisfactorily, bandsaw teeth must be set by bending the teeth alternately out of the line of the blade. This presents alternate pairs of teeth, wider than the thickness of the ribbon and prevents the ribbon rubbing in the wood being cut and overheating. There are two usual ways of setting bandsaw teeth depending generally upon the amount of work to be done.

1. Hand Setting. See FIG. 40

The points of the teeth are set by using a hand setting tool of the plier type. The points only of the teeth must be set and as a general rule the set on each side is .010" (.3mm). Set is applied in opposite directions for each alternate tooth. Where hand setting is employed, it cannot be ensured that all the teeth are cuttings, and in order to overcome this, the teeth should be stoned occasionally. An ordinary fine grit stone is used and the back runner guides should be temporarily brought forward until it is in contact with the back of the blade. The blade should then be run and the stone carefully applied to the teeth each side of the blade. When the saw is subsequently sharpened, it will be noted that each tooth has not been marked with the stone, and such teeth should only be filed very slightly. The remainder of the teeth which have actually been stoned should be filed in the normal manner until the flat caused by the stone disappears. Bandsaws may require stoning approximately once to every six sharpenings.

2. Machine Setting.

A setting attachment can be supplied to special order for fitting to the standard grinding machine. This attachment is shown under Bandsaws and Accessories in the rear of this manual.

SHARPENING.

This is normally done by using a triangular section file. Again, this operation can be done by hand or machine.

HAND FILING. FIG.31.

It is essential to employ an efficient and quick acting vice and round cornered triangular file, both as illustrated in FIG.37. and FIG.38.

The face of each tooth should be filed across, and with the same stroke the back of the following tooth should be filed at the same time. One stroke of the file should be sufficient to sharpen each tooth, and this stroke should be as light as possible in order to avoid producing a burr. The shape of the gullet is automatically maintained at 60° by the file, which the angle of the hook on the tooth is dependable on the position of the file. For general work, approximately 5° of positive hook should be given. A greater or smaller hook should be applied for soft or harder woods respectively. In the case of particularly hard woods, a negative rake may be necessary, while a wider tooth pitch than standard may be required for sawing timbers of an abrasive nature, and those containing gum. Always sharpen square across the face of each tooth and NOT on the bevel, otherwise the saw will vibrate violently, which shatters the steel and cracks appear causing saw breakages.

Use a file with rounded corners and of triangular section. It is important to keep the gullet of each tooth rounded otherwise cracks will soon appear. Saws must be sharpened at regular intervals and should never be forced to cut with teeth which have become blunt.

NOTE: WHEN RECONDITIONING BANDSAW BLADES, IT IS NECESSARY TO SET THE TEETH FIRST BEFORE SHARPENING.

This ensures that the face of the tooth is square. If the sharpening was carried out first, the subsequent setting would result in an angular tooth shape being obtained.

MACHINE FILING.

An automatic machine for filing blades is shown under Bandsaws and Accessories in the rear of this manual and can be supplied by special order.

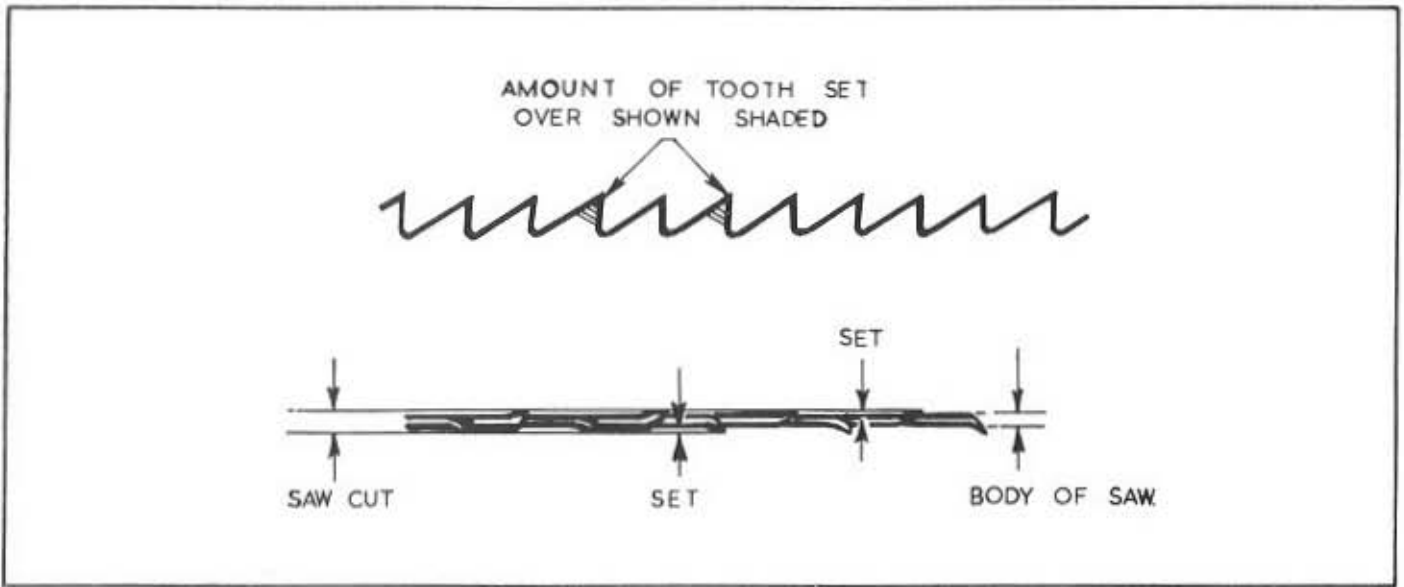


FIG 30

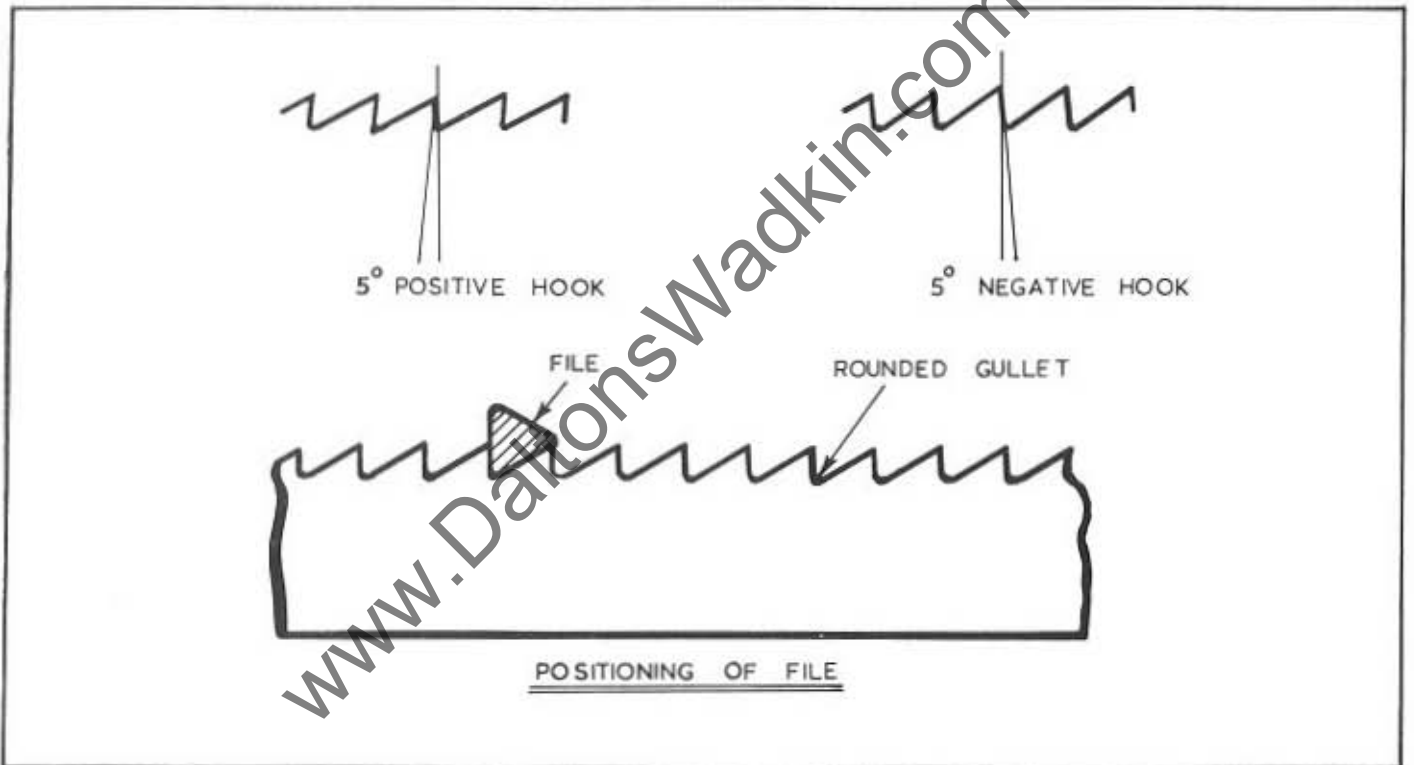


FIG 31

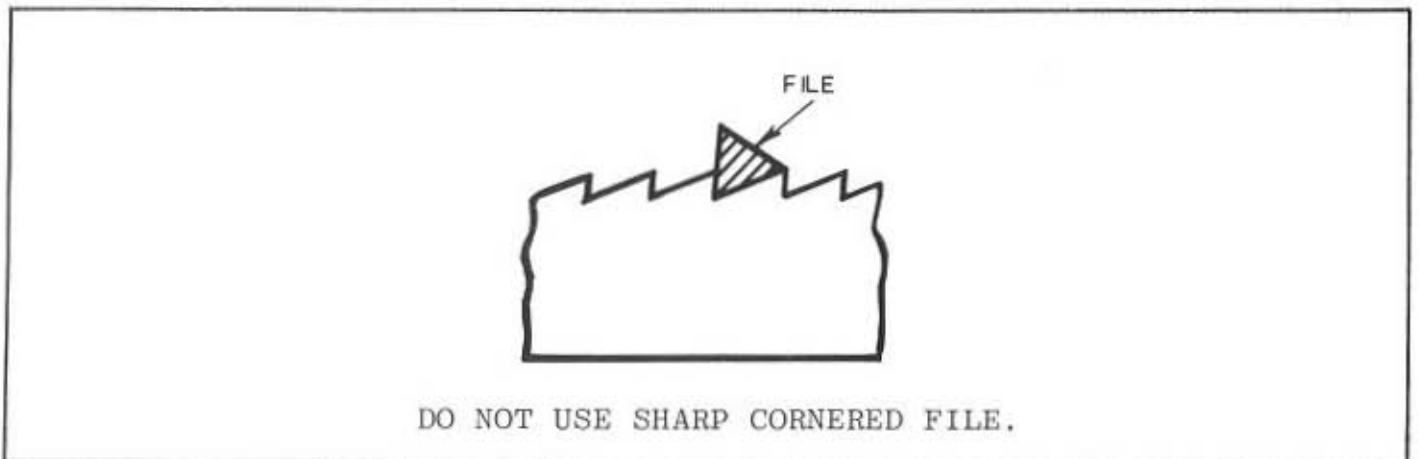


FIG 32

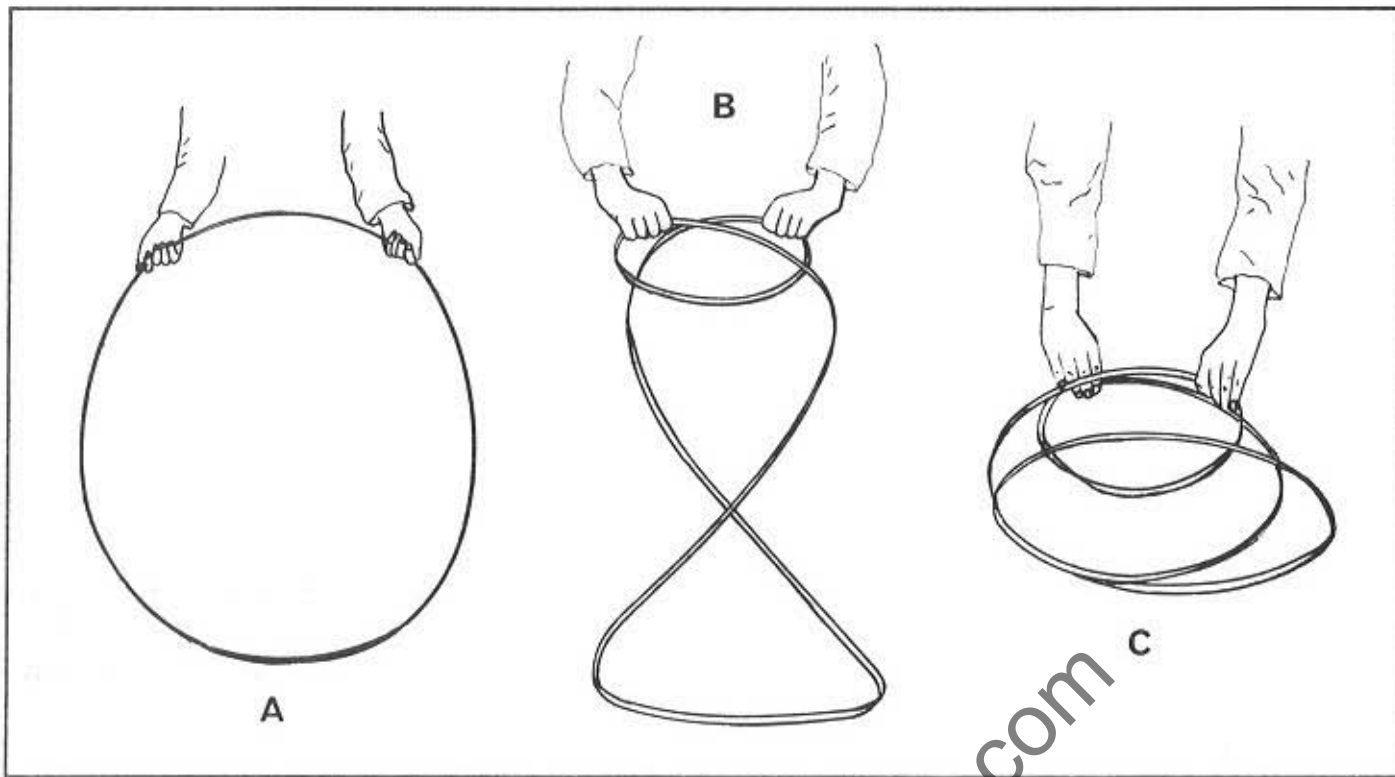


FIG 33

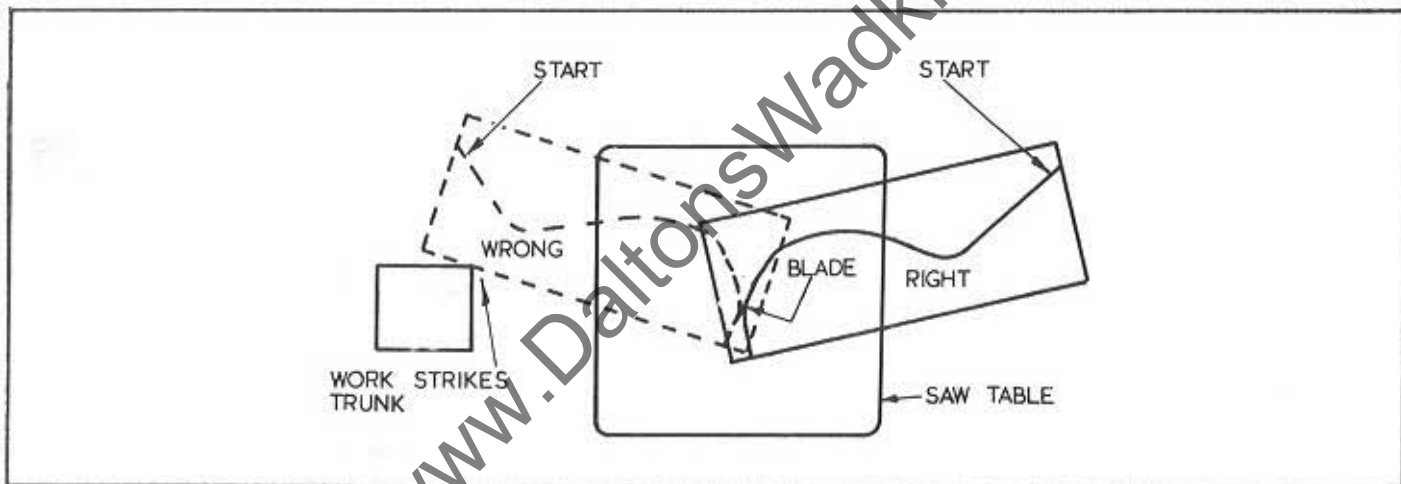


FIG 34

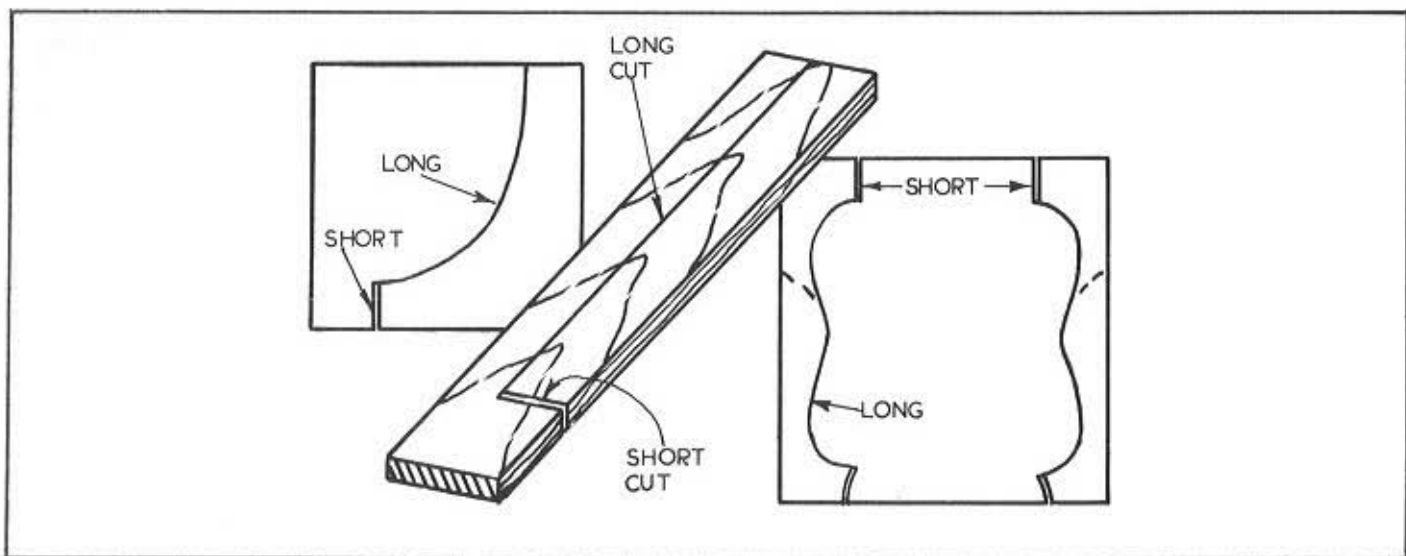


FIG 35

GENERAL CAUSES OF SAW TROUBLE.

1. Crystallisation of the ribbon, produced by the back of the saw rubbing against the back runner guide. The disc should revolve only by contact with the back edge of the saw when actually cutting.
2. Using a blade that is too wide for the radii being cut. In attempting to cut a small curve with a saw too wide, the blade tends to twist against the guides causing friction and overheating which destroys the temper in the steel.
3. Not enough set.
4. Sharpening with a sharp cornered file. See FIG.32.
5. Bad brazing due to dirty joints or badly prepared laps or incorrect positioning of the laps, causing a bump on the back of the blade at the joint. See Bandsaws and Accessories at the rear of this manual for an efficient bandsaw brazer.

SMALLEST RADII WHICH MAY BE SAWN WITH GIVEN WIDTH OF BLADE.

Width of Blade	3mm	5mm	6mm	10mm
Minimum Radius	3mm	8mm	16mm	37mm
Width of Blade.	13mm	16mm	19mm	25mm
Minimum Radius	64mm	95mm	138mm	184mm

FOLDING BANDSAW BLADES.

Bandsaw blades are folded in three. This is done by holding the blade firmly in both hands with the palms upwards as shown in FIG.33. Turn the hands over, this will twist the blade, as shown in FIG.33. Do not let the blade slip or turn in the hands. The blade will almost automatically fall into three loops. THE BLADE SHOULD BE KEPT IN A SAFE DRY PLACE.

BANDSAW BRAZING.

An efficient bandsaw brazing machine is shown under "Bandsaws and Accessories" in the rear of this manual and can be supplied by special order.

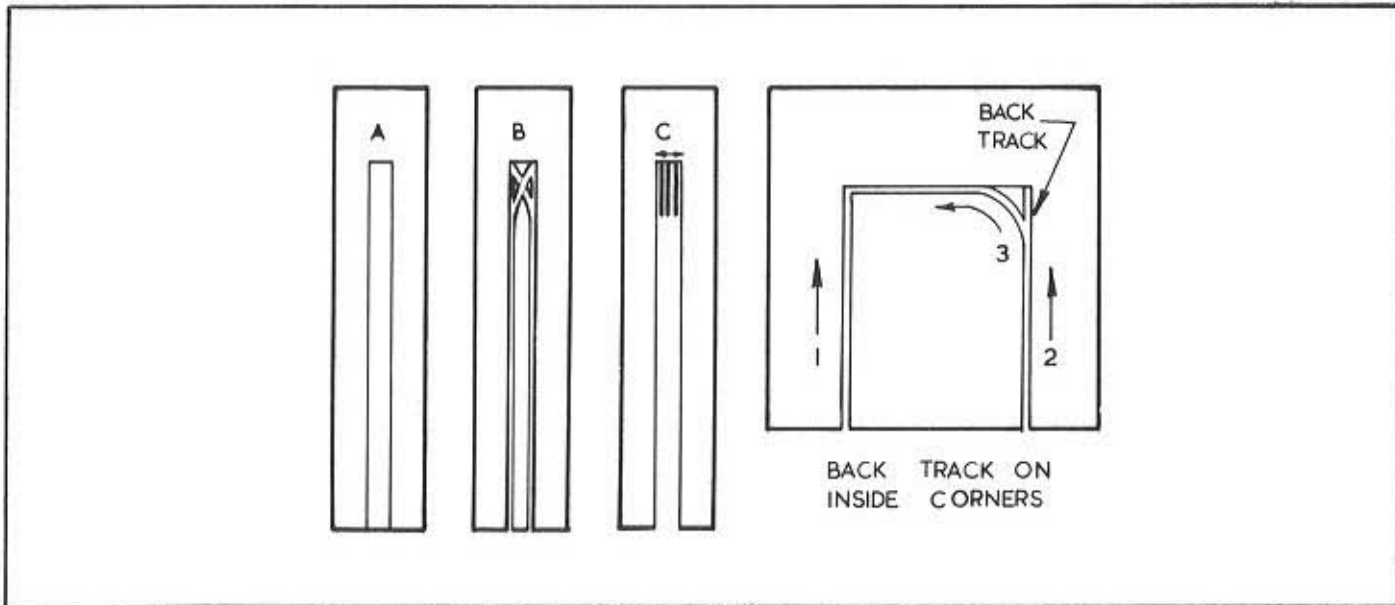


FIG 36

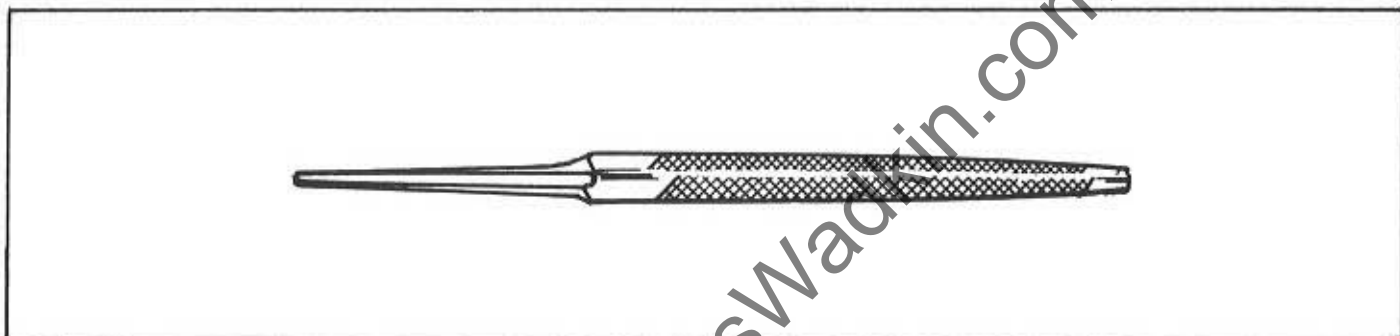


FIG 37

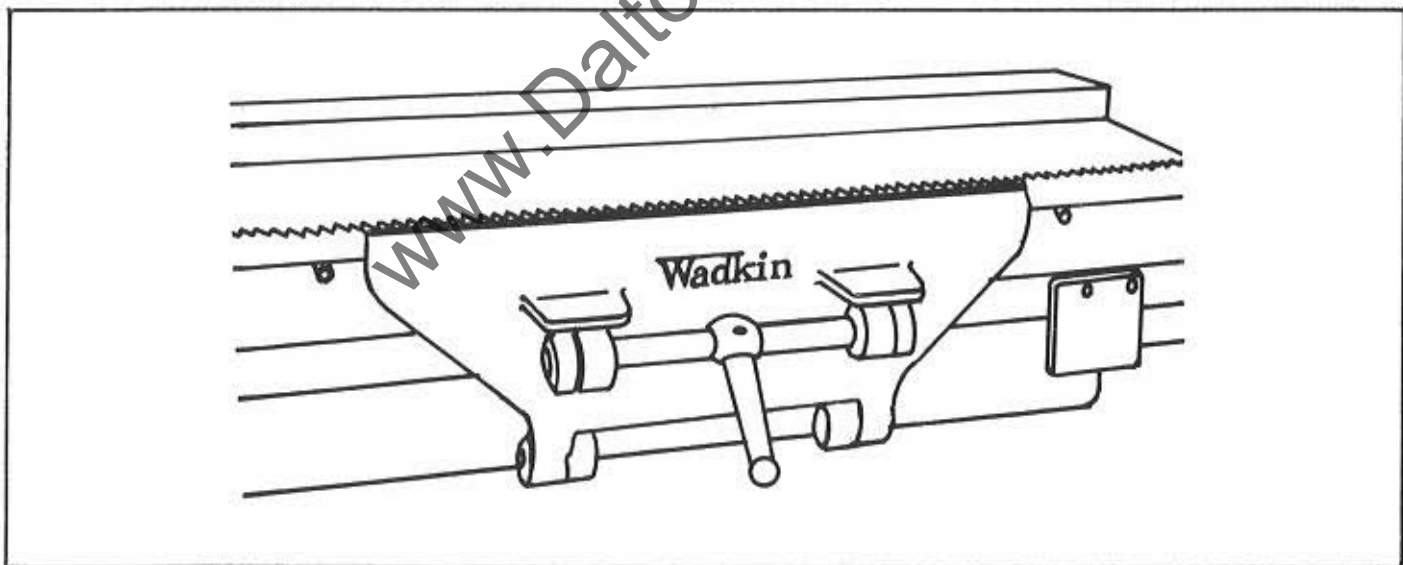


FIG 38

HINTS ON CUTTING.1. Watch Feed Directions SEE FIG.34.

Mentally follow the path of the cut before actually cutting the work. If not started properly many pieces of work will foul against the trunk of the machine.

2. Make Short Cuts First SEE FIG.35.

When a choice of starting points is offered, always make short cuts first. Back tracking out of a short cut can be done much more quickly than backing out of a long cut.

3. Backtrack on Corners. SEE FIG.36.

Very narrow grooves must be nibbled as shown at A, B, C. On other inside corners, cut to the corner and then backtrack to lead the blade over to second line.

BANDSAW BLADES.

Spare bandsaw blades of the correct length, ready set and sharpened, for wood cutting are available from stock. Where it is preferred, bandsaw blading in strip form can be supplied for customers to make up their own blades. This bandsaw strip is offered either toothed only or toothed, sharpened and set.

In addition to woodcutting, we can supply bandsaw blades for plastics, bonded wood, non-ferrous metals, meat, etc, provided that the correct machine speeds are available.

TAPER TRIANGULAR FILES FOR HAND USE.

Length..... 6", 8", 10".

The edges of these files have rounded corners to produce the round gullet which prevents saw cracks.

BANDSAW BLADES.

STANDARD BANDSAW BLADE, 5600mm (18ft 4ins) LONG.

6.3mm ($\frac{1}{4}$ ") WIDE.
 9.5mm ($\frac{3}{8}$ ") WIDE.
 12.7mm ($\frac{1}{2}$ ") WIDE.
 15.9mm ($\frac{5}{8}$ ") WIDE.
 19.0mm ($\frac{3}{4}$ ") WIDE.
 25.4mm (1") WIDE.
 31.7mm ($1\frac{1}{4}$ ") WIDE.
 38.1mm ($1\frac{1}{2}$ ") WIDE.

STARRETT BANDSAW BLADE (HARDENED TEETH) 5600mm (18ft 4ins) LONG.

6.3mm ($\frac{1}{4}$ ") WIDE.
 9.5mm ($\frac{3}{8}$ ") WIDE.
 12.7mm ($\frac{1}{2}$ ") WIDE.
 15.9mm ($\frac{5}{8}$ ") WIDE.
 19.0mm ($\frac{3}{4}$ ") WIDE.
 25.4mm (1") WIDE.
 31.7mm ($1\frac{1}{4}$ ") WIDE.

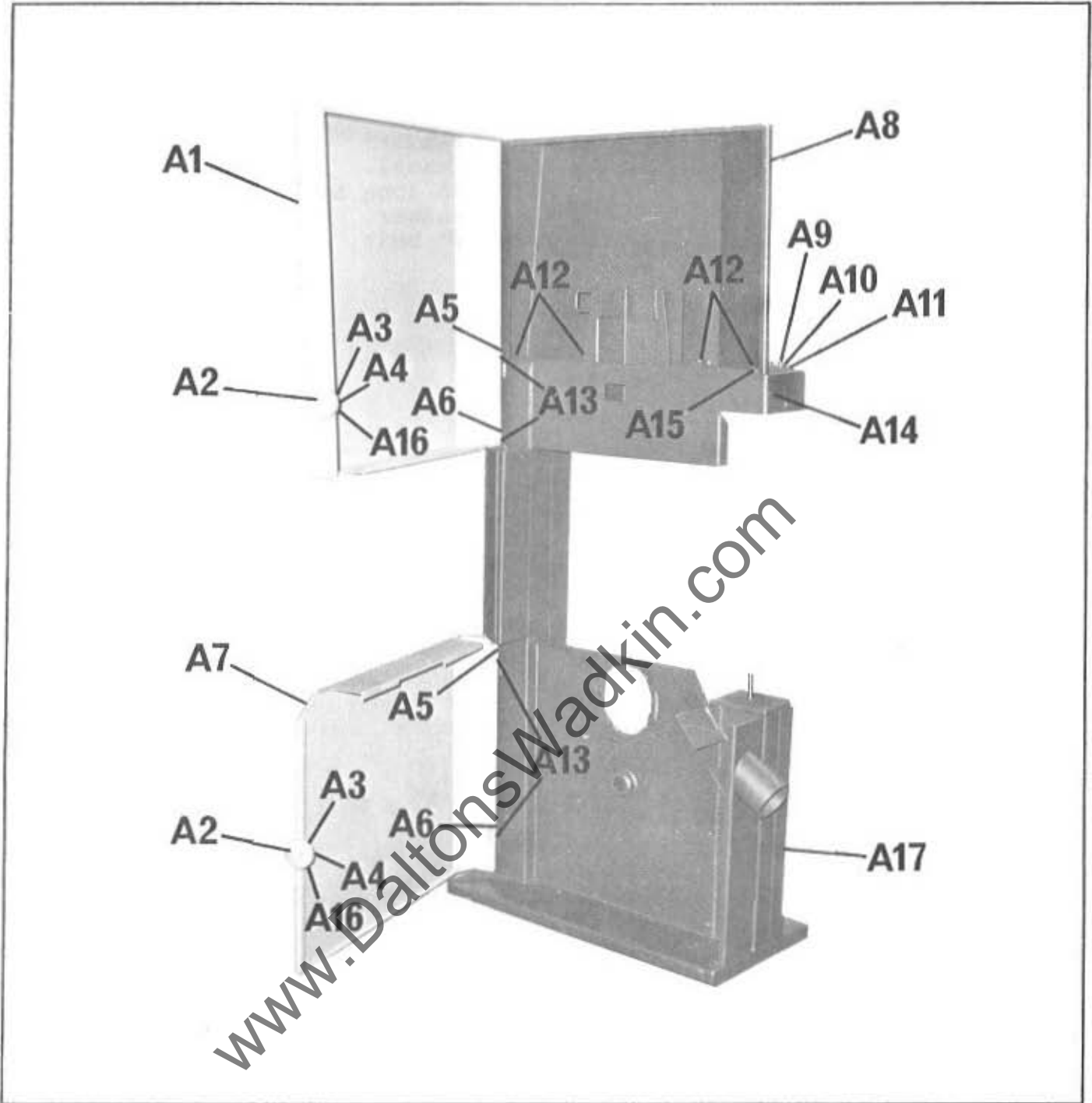
The Starrett bandsaw blades are hard edged flexible backed wood or metal cutting long life blades.

NOTE: These blades can't be re-sharpened as they have hardened teeth.

BASE, TOP COVER AND DOORS ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
A1	C8/28	1	Top door.
A2	BH7/181	2	Door locking cam.
A3	C8/71	2	Stud for door catch.
A4		2	M8 aerotight nut.
A5	BH7/163	2	Top hinge pin.
A6	BH7/201	2	Bottom hinge pin.
A7	C8/29	1	Bottom door.
A8	C8/19	1	Top cover.
A9		3	M6 nut.
A10		3	6mm washer.
A11	BH7/178	1	Top guide adjustment plate.
A12		4	M12 x 20 long hexagon head screw.
A13	BH7/199	4	Washer for door hinge.
A14		1	M8 x 16 long socket head capscrew.
A15		4	12mm washer.
A16		2	8mm washer.
A17	C8/7	1	Main frame.

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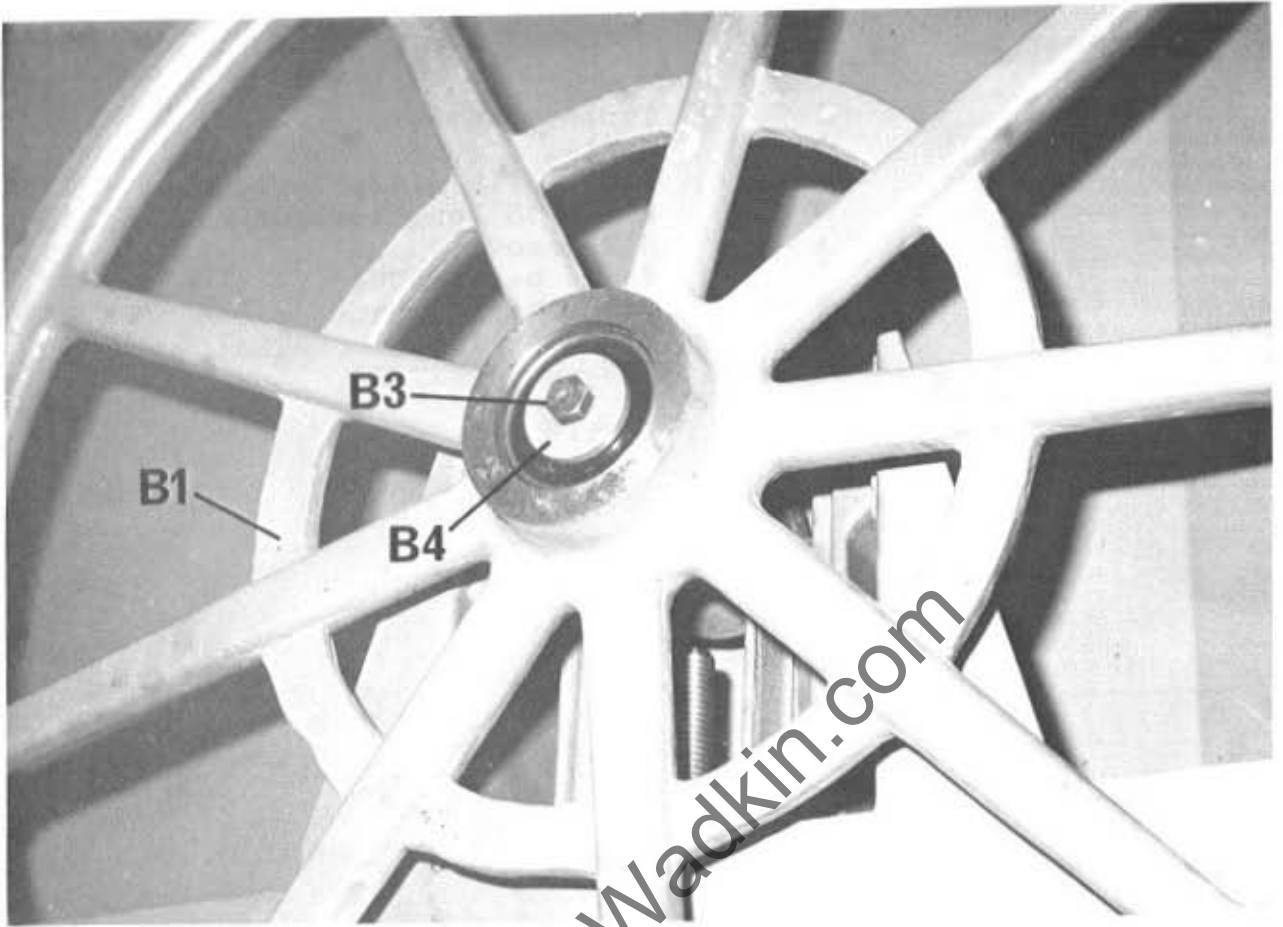


BASE, TOP COVER AND DOORS ASSEMBLY.

WHEELS AND BELT.

<u>Ref No.</u>	<u>Part No.</u>	<u>No.Off.</u>	<u>Description.</u>
B1	C8/1	1	Top wheel.
B2	C8/2	1	Bottom wheel.
B3		1	M12 x 25 long hexagon head bolt.
B4	C8/37	1	Wheel washer.
B5	525L6	1	Poly "V" belt.

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WHEELS AND BELT.

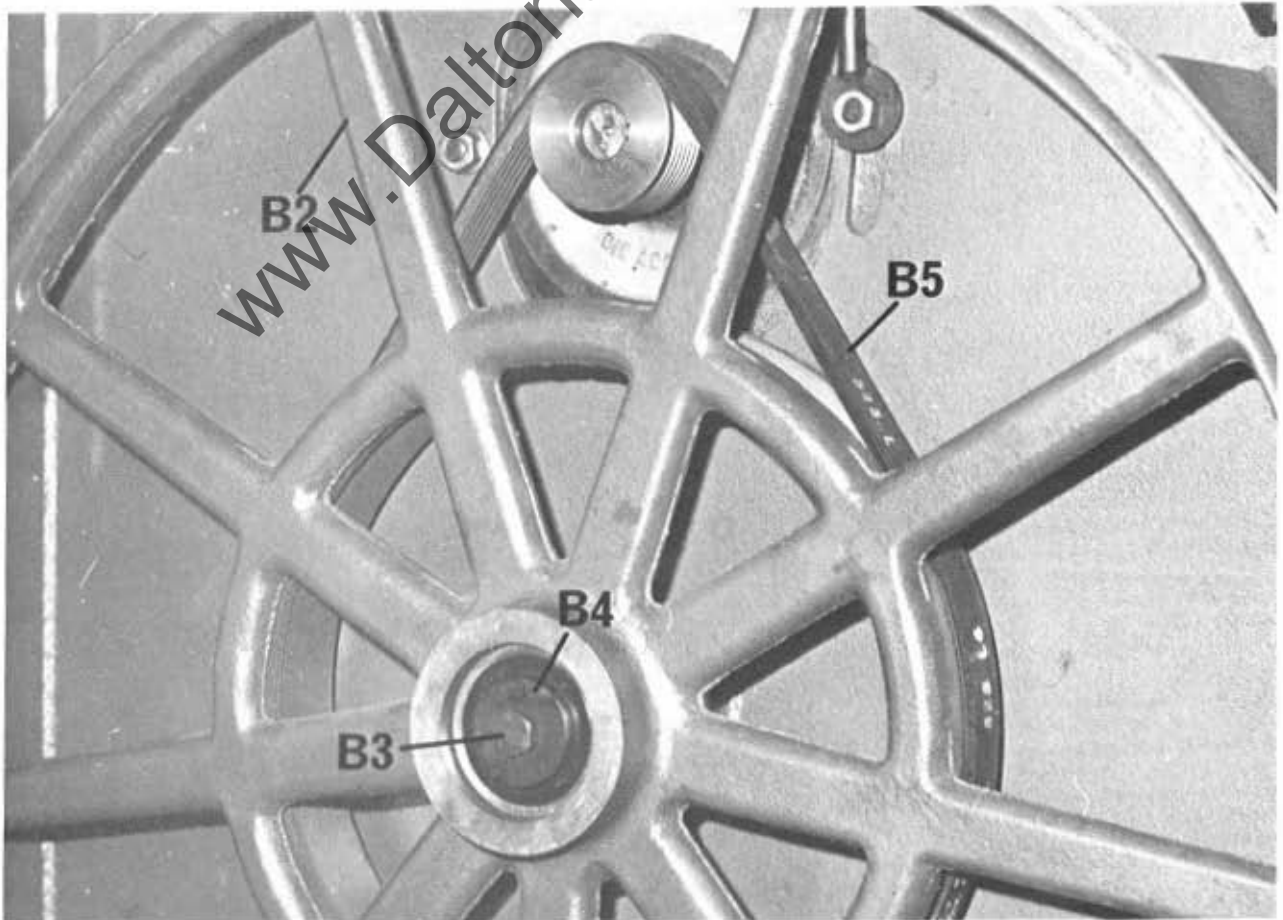


TABLE ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
C1	C8/3	1	Table quadrant.
C2	C8/5	1	Table.
	C8/104	1	Table with mitre fence slot.(EXTRA).
C3		4	M12 x 45 long hexagon head bolt.
C4		4	M12 washer.
C5	C8/39	1	Fence bar.(EXTRA).
C6	C8/38	2	Fence bar distance piece. (EXTRA).
C7	C8/68	2	Stud for fence. (EXTRA).
C8		2	M10 nut. (EXTRA).

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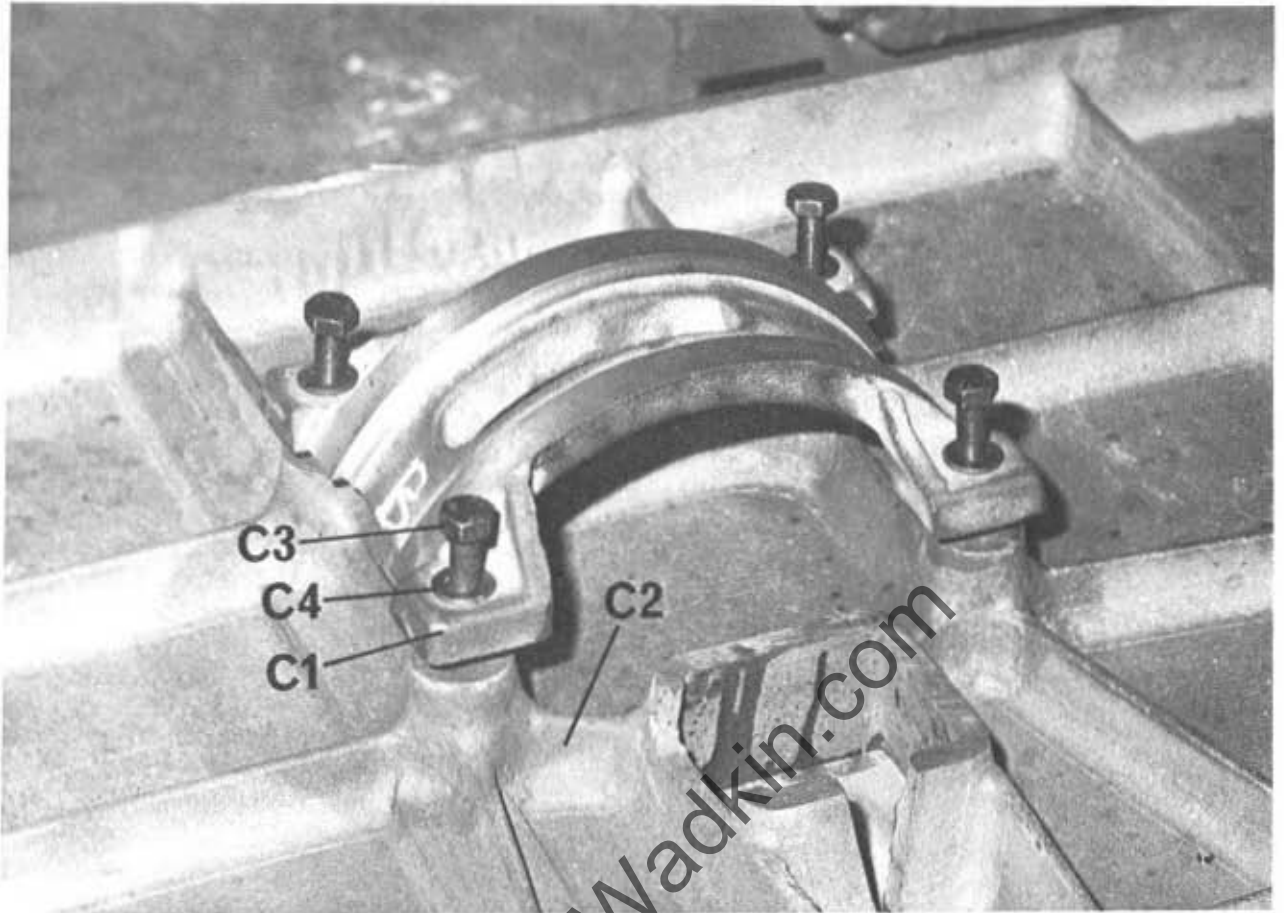
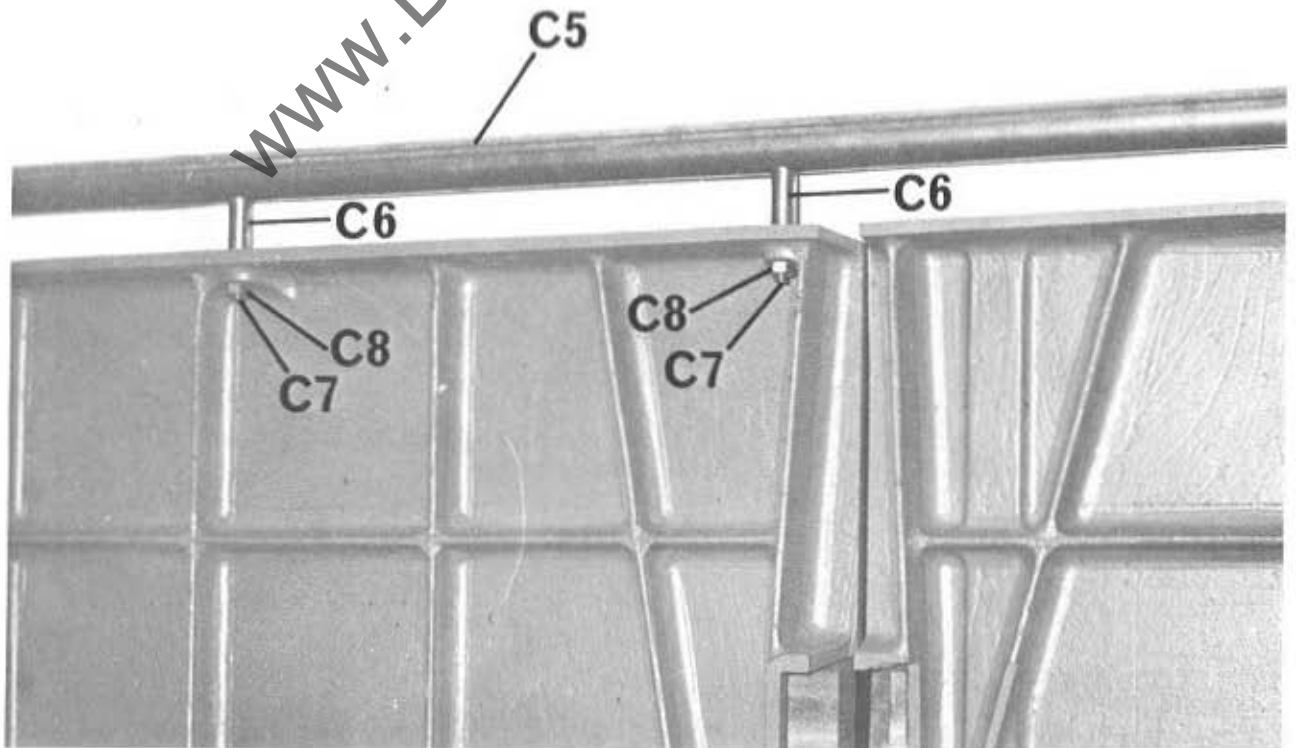
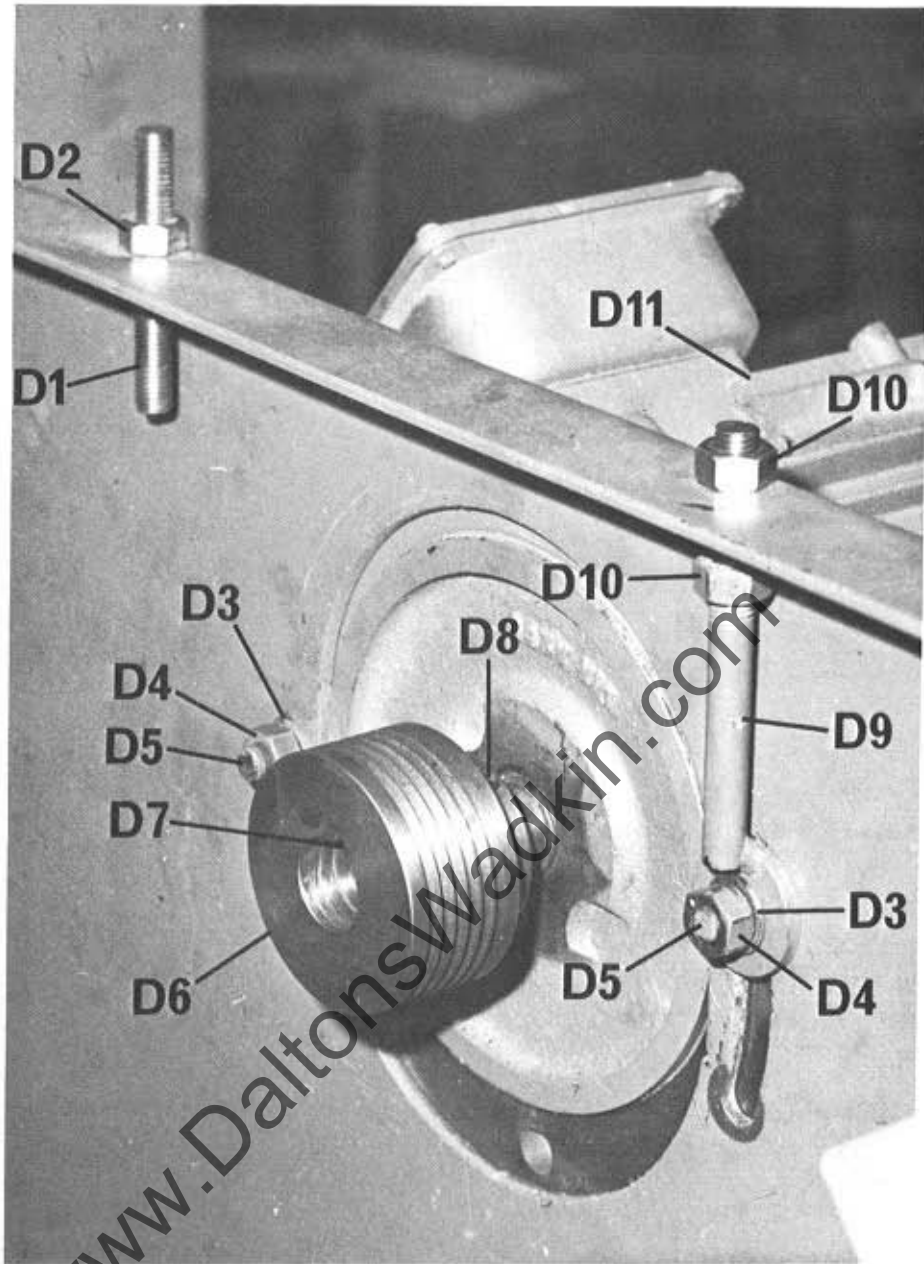


TABLE ASSEMBLY.



MOTOR MOUNTING ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
D1	C8/48	1	Table support stud.
D2		1	M12 nut.
D3		2	12mm washer.
D4		2	M12 nut.
D5		2	M12 x 35 long hexagon head bolt.
D6	C8/40	1	Motor pulley (50 cycles) standard.
	C8/87	1	Motor pulley (60 cycles) extra.
D7		1	7 x 8 x 42 long key.
D8		2	M8 socket head grubscrew.
D9	C8/35	1	Belt tension stud.
D10		2	M12 nut.
D11		1	Brook 100L, 3.7Kw (5HP), 380/420v, 50 cycle flange mounted motor, (Standard).
		1	Brook 100L, 3.7Kw (5HP), 220v, 50 cycle flange mounted motor, (Special).
		1.	Brook 100L, 3.7Kw (5HP), 208/220v, 60 cycle flange mounted motor, (Special).
		1	Brook 100L, 3.7Kw (5HP), 550v, 60 cycle flange mounted motor, (Special).
		1	Brook 112L, 5.5Kw (7.5HP), 380/420v, 50 cycle flange mounted motor, (Standard).
		1	Brook 112L, 5.5Kw (7.5HP), 220v, 50 cycle flange mounted motor, (Special).
		1	Brook 112L, 5.5Kw (7.5HP), 208/220v, 60 cycle flange mounted motor, (Special).
		1	Brook 112L, 5.5Kw (7.5HP), 550v, 60 cycle flange mounted motor, (Special).
		1	Brook 100L, 3.7Kw (5HP), 380v, 50 cycle flange mounted motor, (Special).
		1	Brook 100L, 3.7Kw (5HP), 415v, 50 cycle flange mounted motor, (Special).
		1	Brook 112L, 5.5Kw (7.5HP), 380v, 50 cycle flange mounted motor, (Special).
		1	Brook 112L, 5.5Kw (7.5HP), 415v, 50 cycle flange mounted motor, (Special).

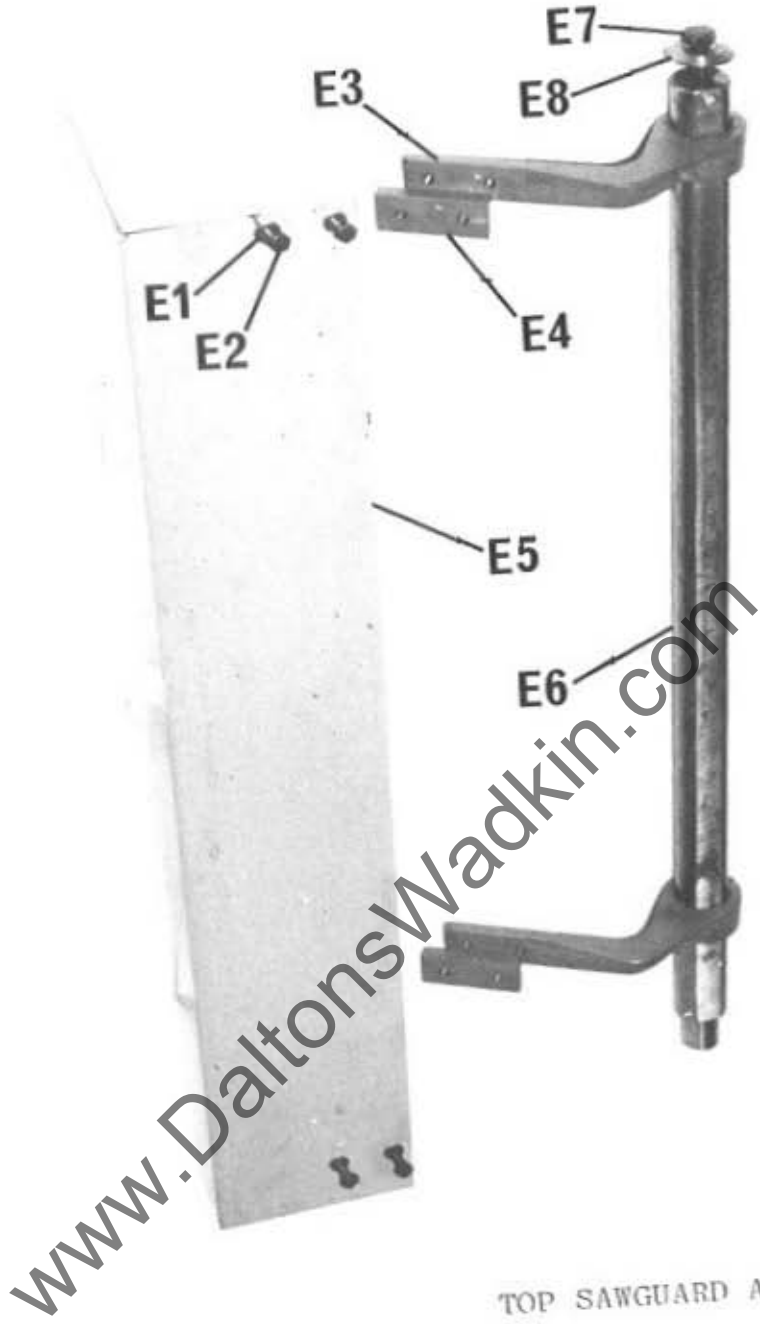


MOTOR MOUNTING ASSEMBLY.

TOP SAWGUARD ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
E1		4	6mm washer.
E2		4	M6 x 20 long hexagon head bolt.
E3	C8/18	2	Sawguard mounting bracket.
E4	C8/90	2	Sawguard spacer.
E5	C8/85	1	Sawguard.
E6	C8/26	1	Guide column.
E7		1	M10 x 20 long hexagon head screw.
E8	C8/103	1	Guide column stop.

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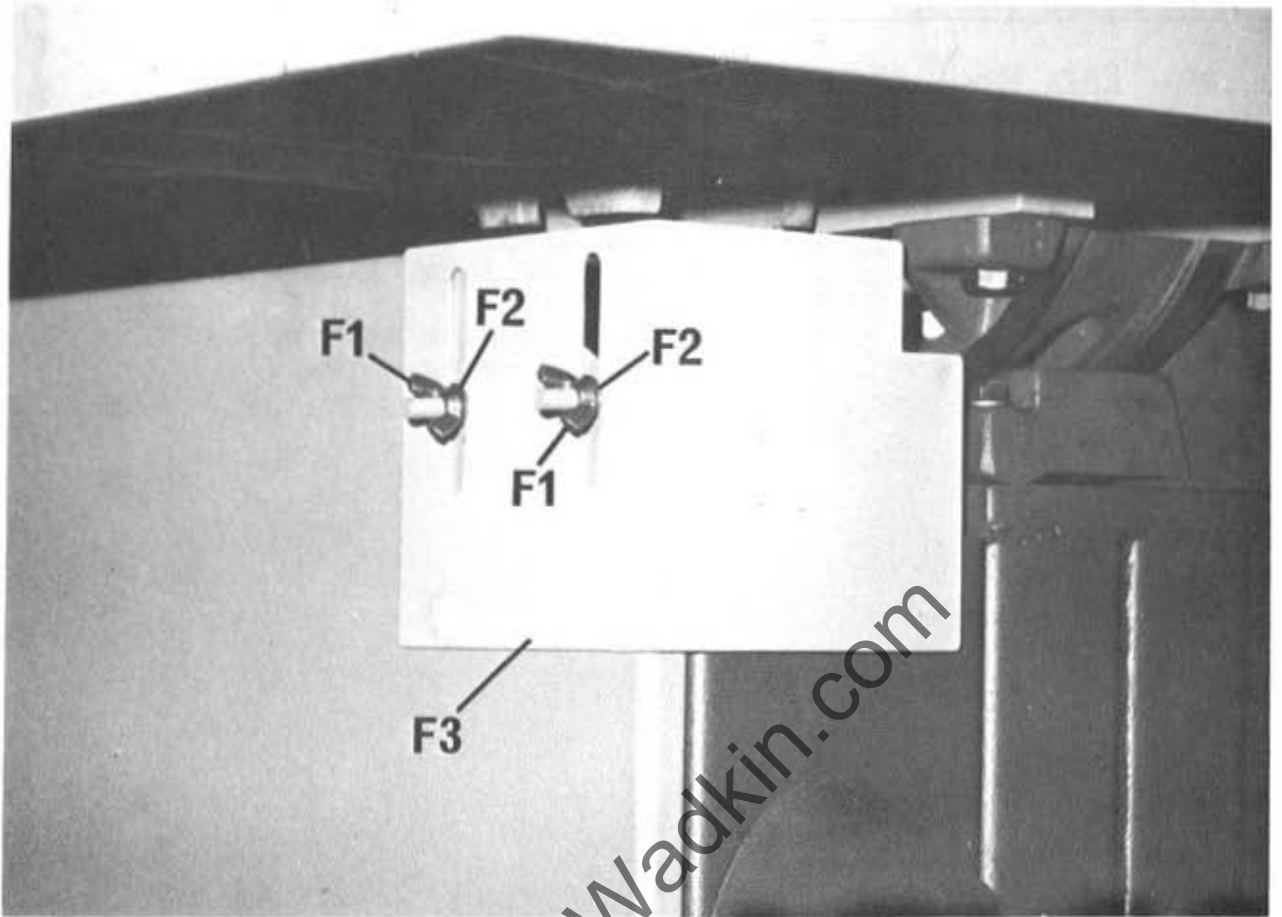


TOP SAWGUARD ASSEMBLY.

UNDER TABLE GUARD ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
F1		2	M8 wingnut.
F2		2	8mm washer.
F3	C8/62	1	Under table sawguard.

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UNDER TABLE GUARD ASSEMBLY.

TABLE MOUNTING BRACKET ON BASE.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
G1	C8/4	1	Quadrant slide bracket.
G2		3	10mm washer.
G3		2	M10 x 45 long hexagon head screw.
G4	1041/125	1	20mm Simplex adjuster, 42mm long
G5		1	M10 x 55 long hexagon head screw.
G6		1	M16 nut.
G7	C8/36	1	Table locking washer.
G8	C8/67	1	Table locking screw.

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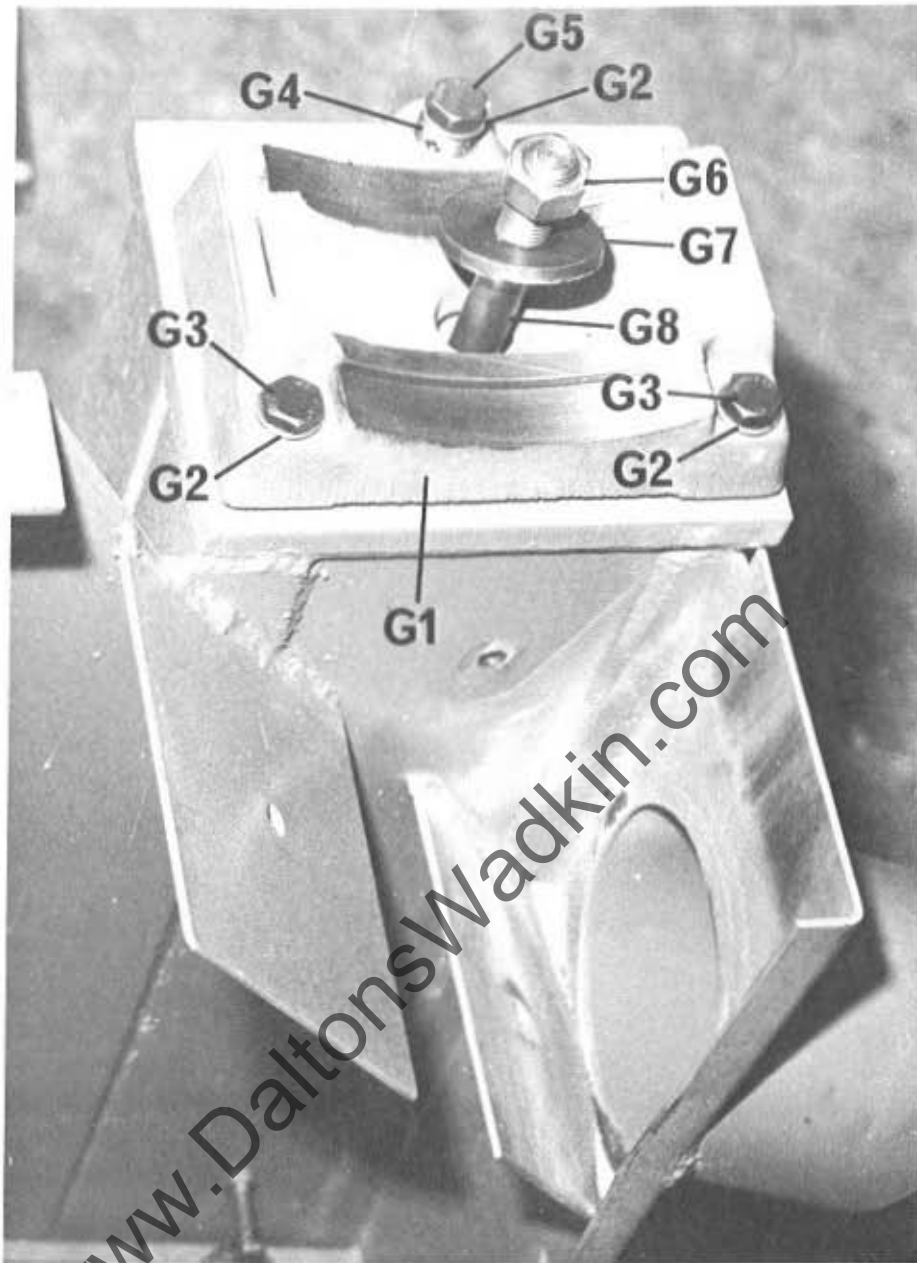
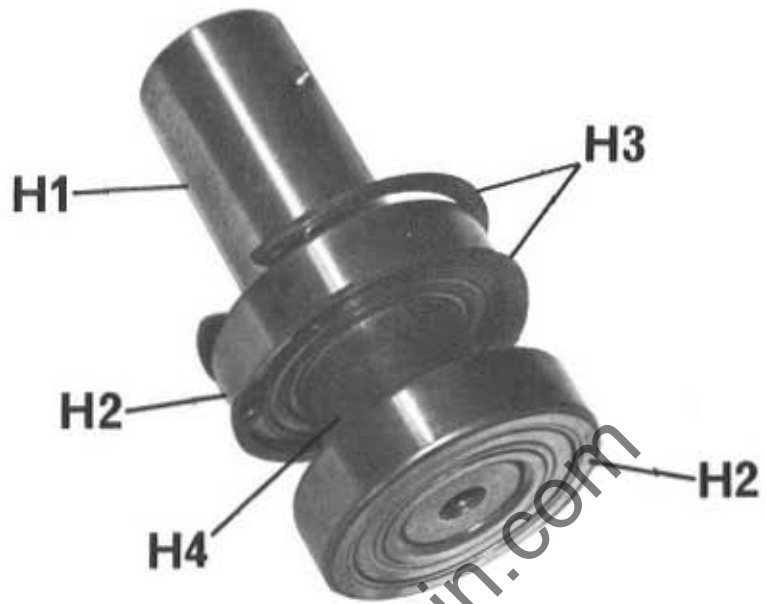


TABLE MOUNTING BRACKET ON BASE.

BOTTOM SPINDLE ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
H1	C8/24	1	Bottom wheel spindle.
H2	6307-2RS	2	Spindle bearing.
H3	7000-080	2	Internal circlip.
H4	C8/27	1	Bearing spacer.

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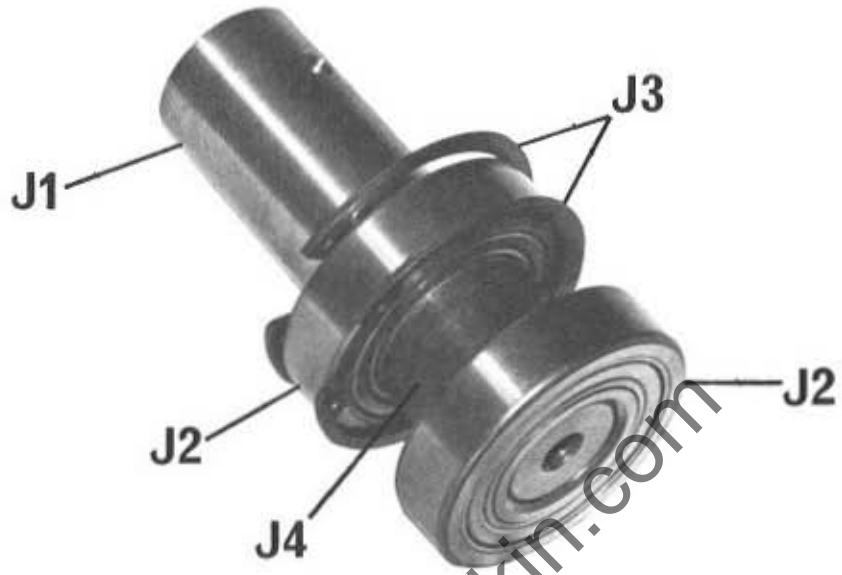


BOTTOM SPINDLE ASSEMBLY.

TOP SPINDLE ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
J1	C8/25	1	Top wheel spindle.
J2	6307-2RS	2	Spindle bearing.
J3	7000-080	2	Internal circlip.
J4	C8/27	1	Bearing spacer.

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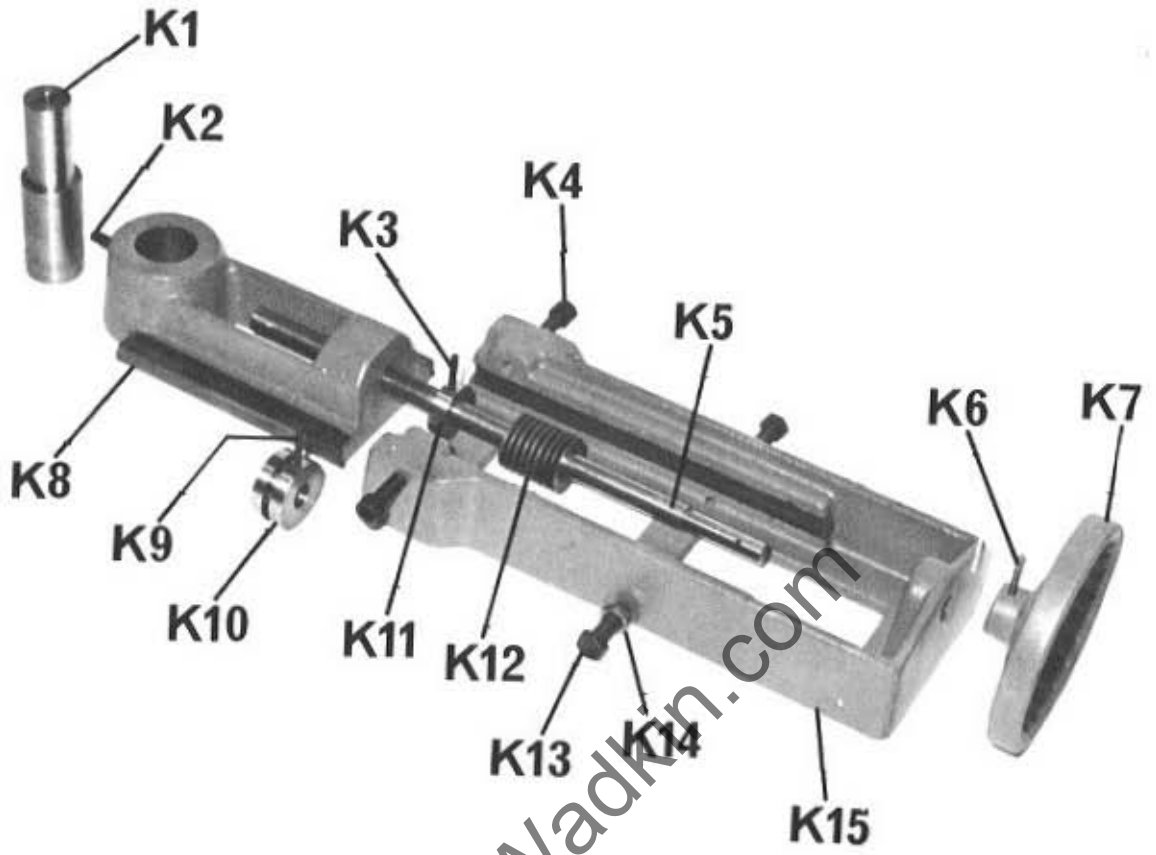
TOP SPINDLE ASSEMBLY.

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TOP SLIDE ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No.Off.</u>	<u>Description.</u>
K1	C8/25	1	Top wheel spindle.
K2		1	M10 x 25 long socket head grubscrew.
K3		1	5mm dia x 35 long groverlok spring dowel.
K4		2	M12 x 40 long socket head capscrew.
K5	C8/44	1	Saw tension screw.
K6		1	5mm dia x 35 long groverlok spring dowel.
K7	BH7/2	1	Saw tension handwheel.
K8	C8/23	1	Top wheel slide.
K9		1	M8 x 16 long socket head grubscrew (EXTRA; used with saw tension indicator.)
K10	C8/77	1	Collar for saw tension indicator (EXTRA).
K11	C8/47	1	Saw tension collar
K12	04020415	17	Bellville washer.
K13		2	M12 x 35 long hexagon head screw.
K14		2	M12 nut.
K15	C8/22	1	Top wheel slide frame.

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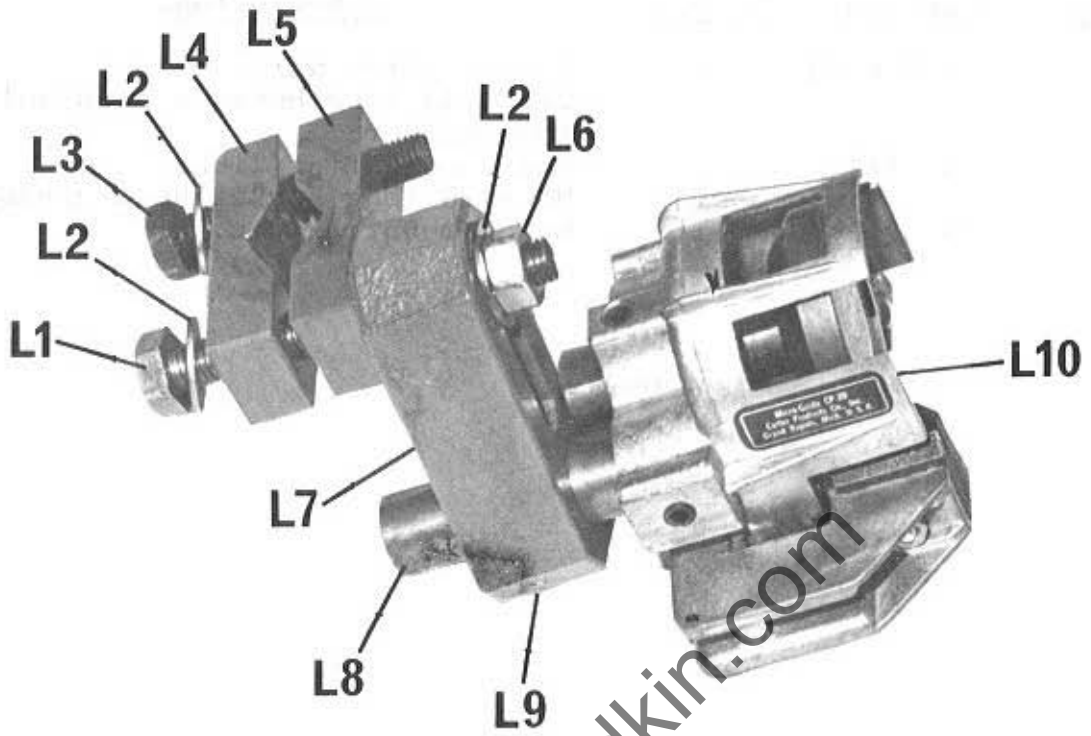
TOP SLIDE ASSEMBLY.

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TOP GUIDE ASSEMBLY.

<u>Ref No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
L1		1	M10 x 90 long hexagon head bolt.
L2		3	10mm washer.
L3		1	M10 x 55 long hexagon head bolt.
L4	C8/50	1	Guide clamp bracket.
L5	C8/49	1	Guide clamp bracket.
L6		1	10mm nut.
L7	BH7/182	1	Guide adjusting link.
L8	C8/57	1	Guide mounting pin.
L9		1	M8 x 10 long socket head grubscrew
L10	CP20.No.0.	1	Carter top guide.

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TOP GUIDE ASSEMBLY.

BOTTOM GUIDE ASSEMBLY.

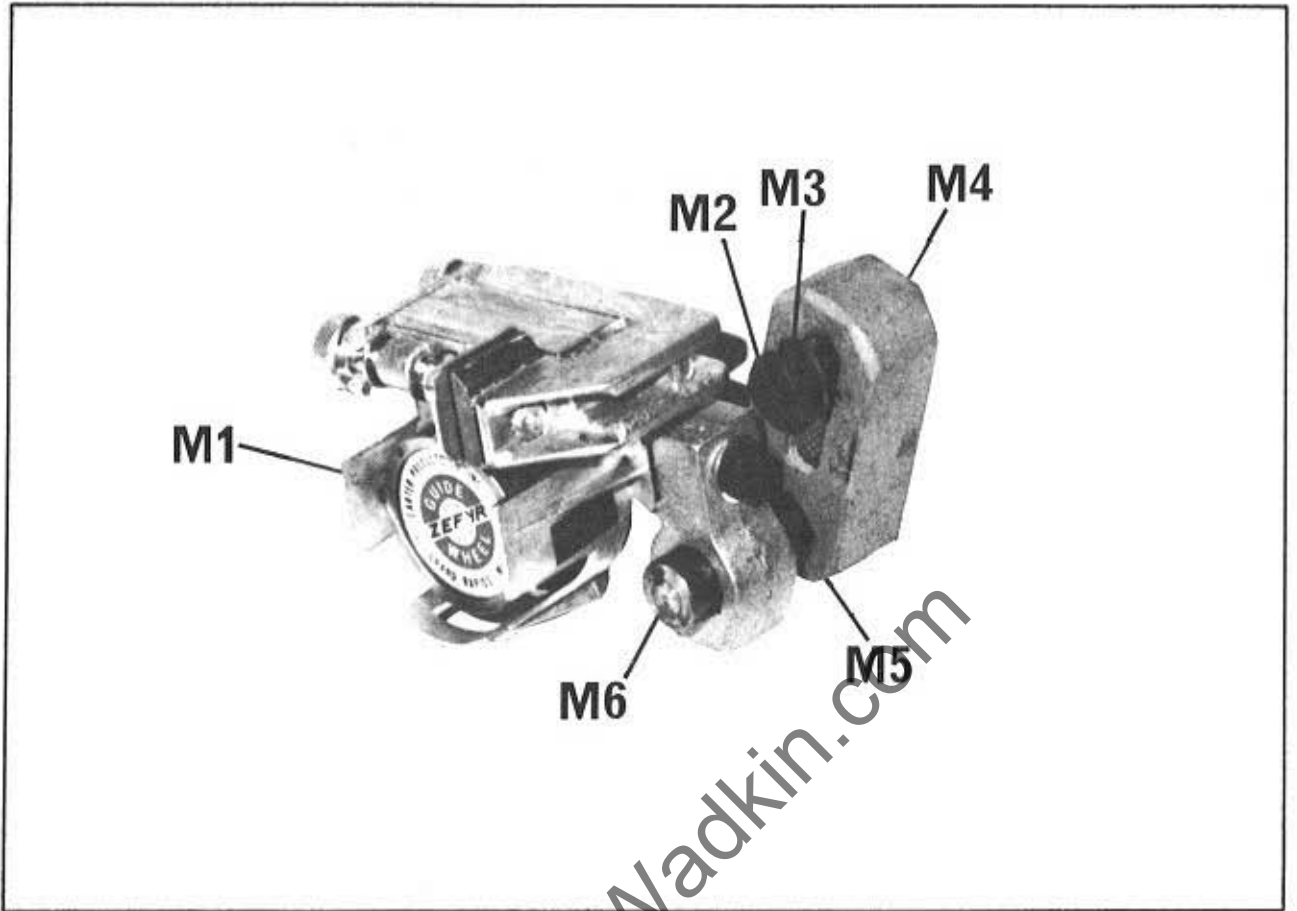
<u>Ref.No.</u>	<u>Part.No.</u>	<u>No.Off.</u>	<u>Description.</u>
M1	CP20LNo.0	1	Bottom guide unit.
M2		1	M10 x 45 long hexagon head bolt.
M3		1	10mm washer.
M4	BH7/182	1	Guide adjusting link.
M5		1	M8 x 10 long socket head grubscrew.
M6	C8/57	1	Guide mounting pin.

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TRACKING ASSEMBLY.

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
N1		1	2 1/8" dia, tracking handwheel, M12 tap.
N2	C8/41	1	Tracking screw.
N3		1	M12 wingnut
N4		1	12mm washer.

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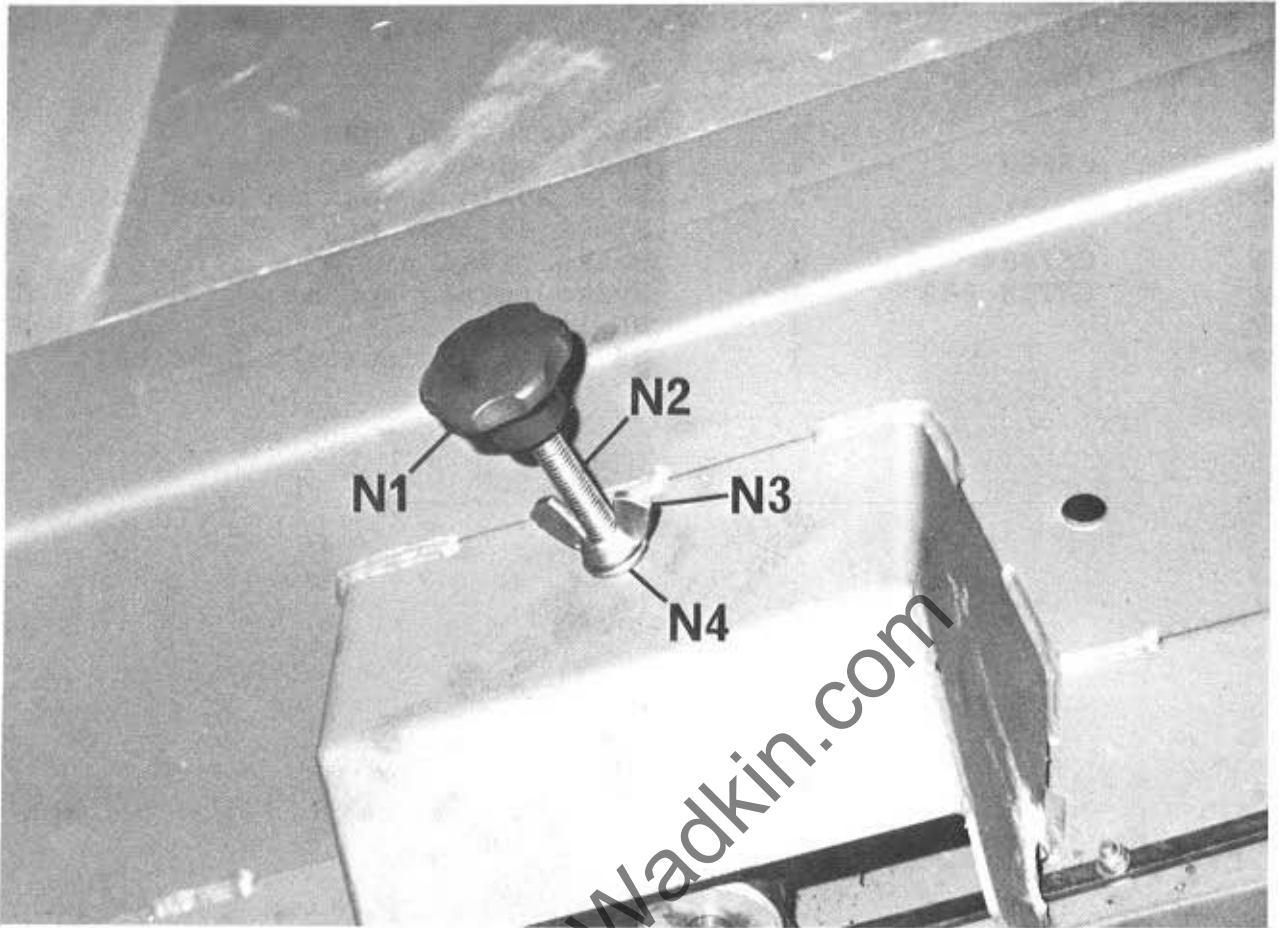


BOTTOM GUIDE ASSEMBLY.

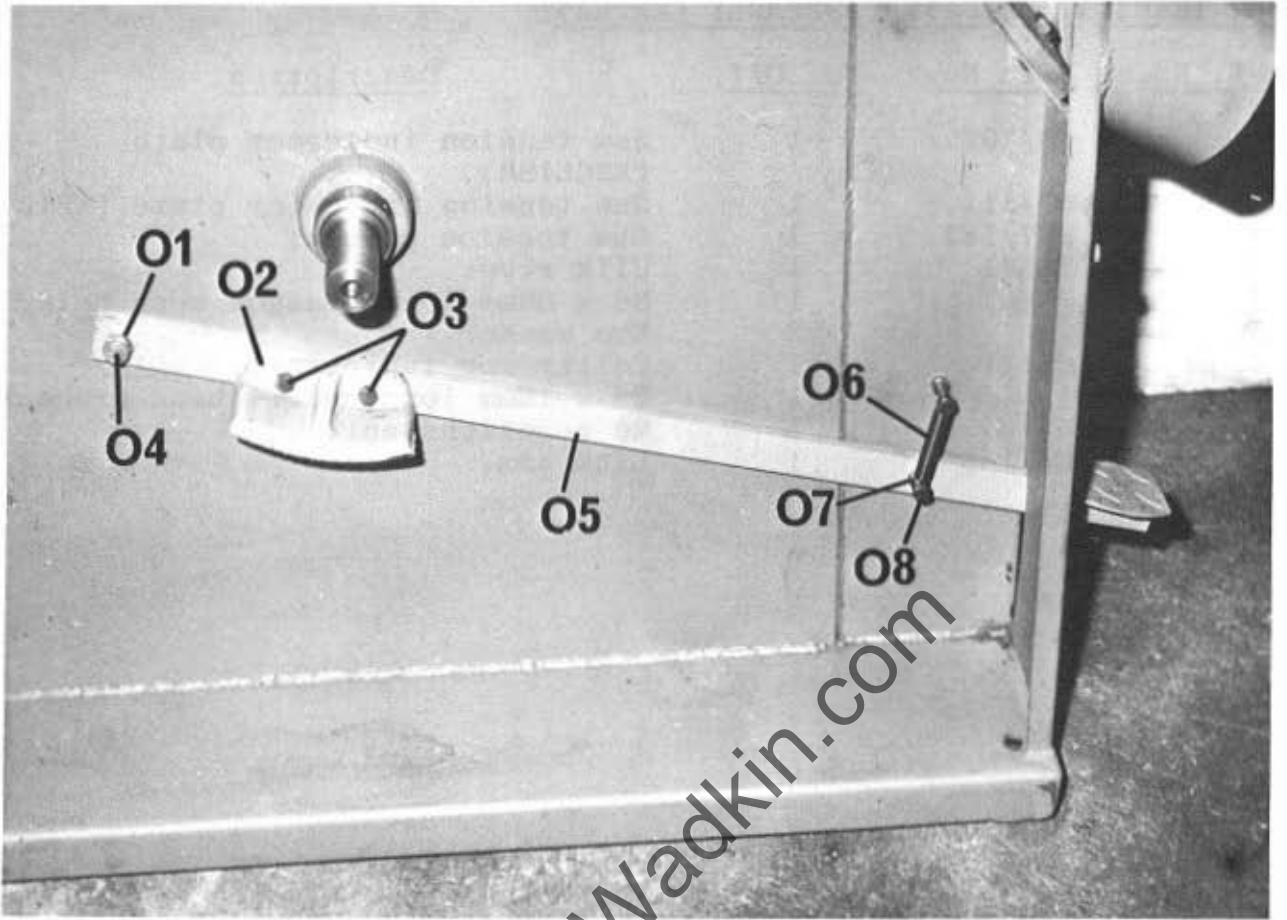
BRAKE ASSEMBLY (EXTRA).

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
01		1	M12 aerotight nut.
02	C8/63	1	Brake shoe.
03		2	M8 x 20 long hexagon head bolt.
04		1	M12 x 40 long stud.
05	C8/89	1	Brake pedal arm.
06	ENTEX 568	1	Brake return spring.
07		1	M8 locknut.
08		1	M8 x 30 long hexagon head bolt.

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TRACKING ASSEMBLY.



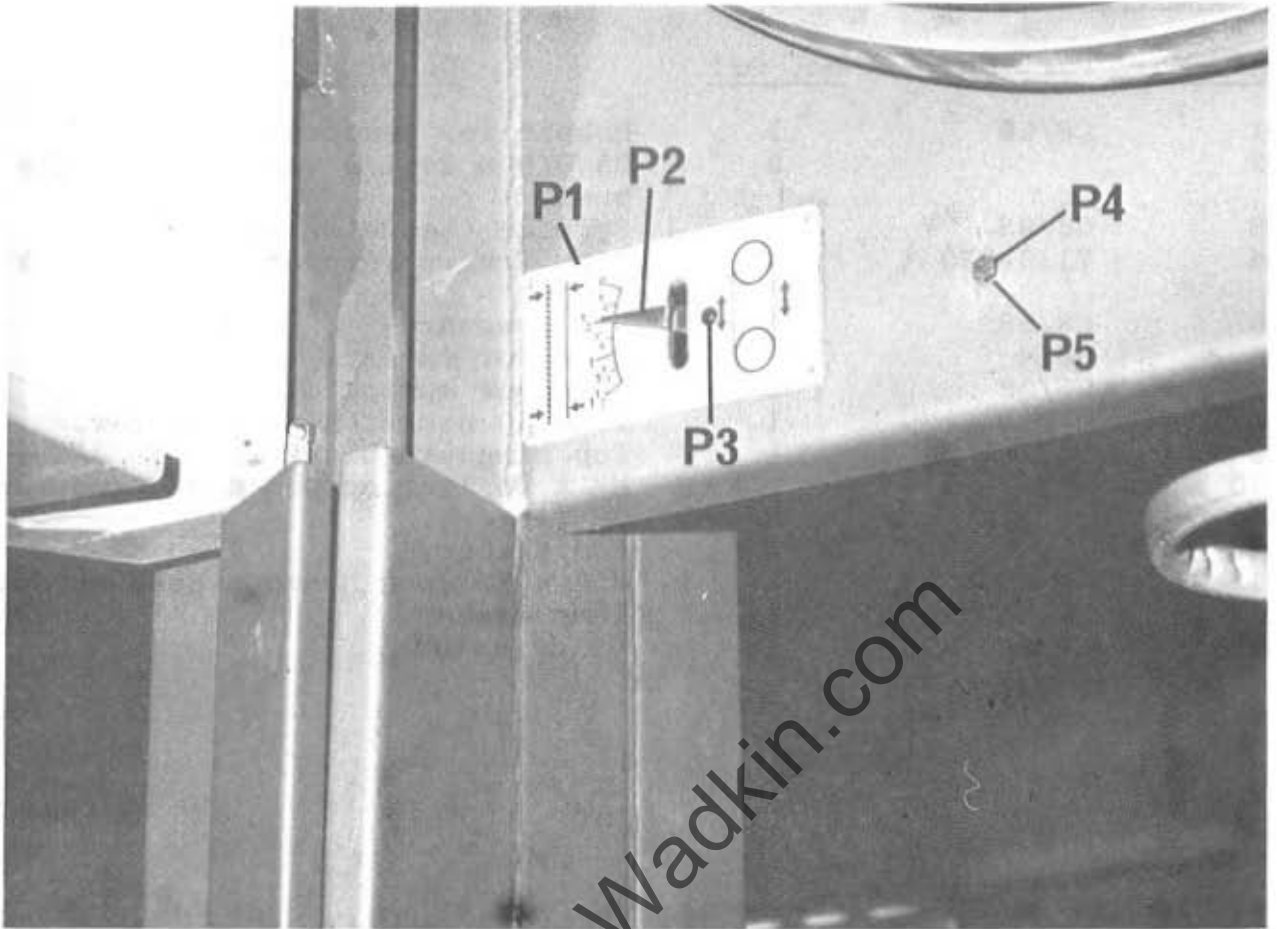
BRAKE ASSEMBLY (EXTRA).

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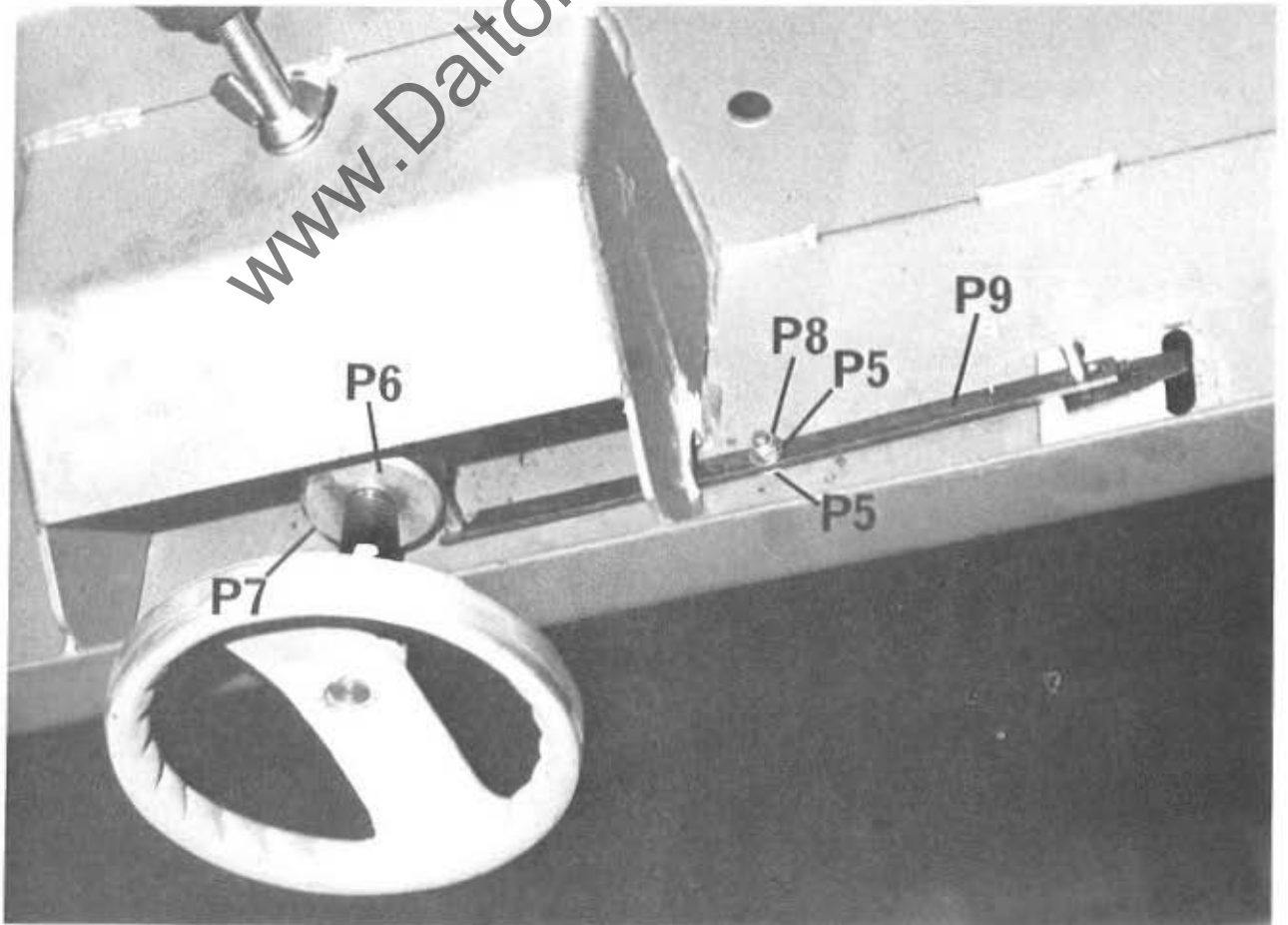
SAW TENSION INDICATOR ASSEMBLY (EXTRA).

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
P1	C8/107	1	Saw tension indicator plate. (ENGLISH).
	C8/111	1	Saw tension indicator plate.(METRIC).
P2	BH7/187	1	Saw tension pointer
P3	TS541	1	Clik rivet.
P4		1	M6 x 20mm long hexagon head bolt.
P5		3	8mm washer.
P6	C8/77	1	Collar for indicator.
P7		1	M8 x 16mm long socket head grubscrew.
P8		1	M6 aerotight nut.
P9	C8/108	1	Link arm.

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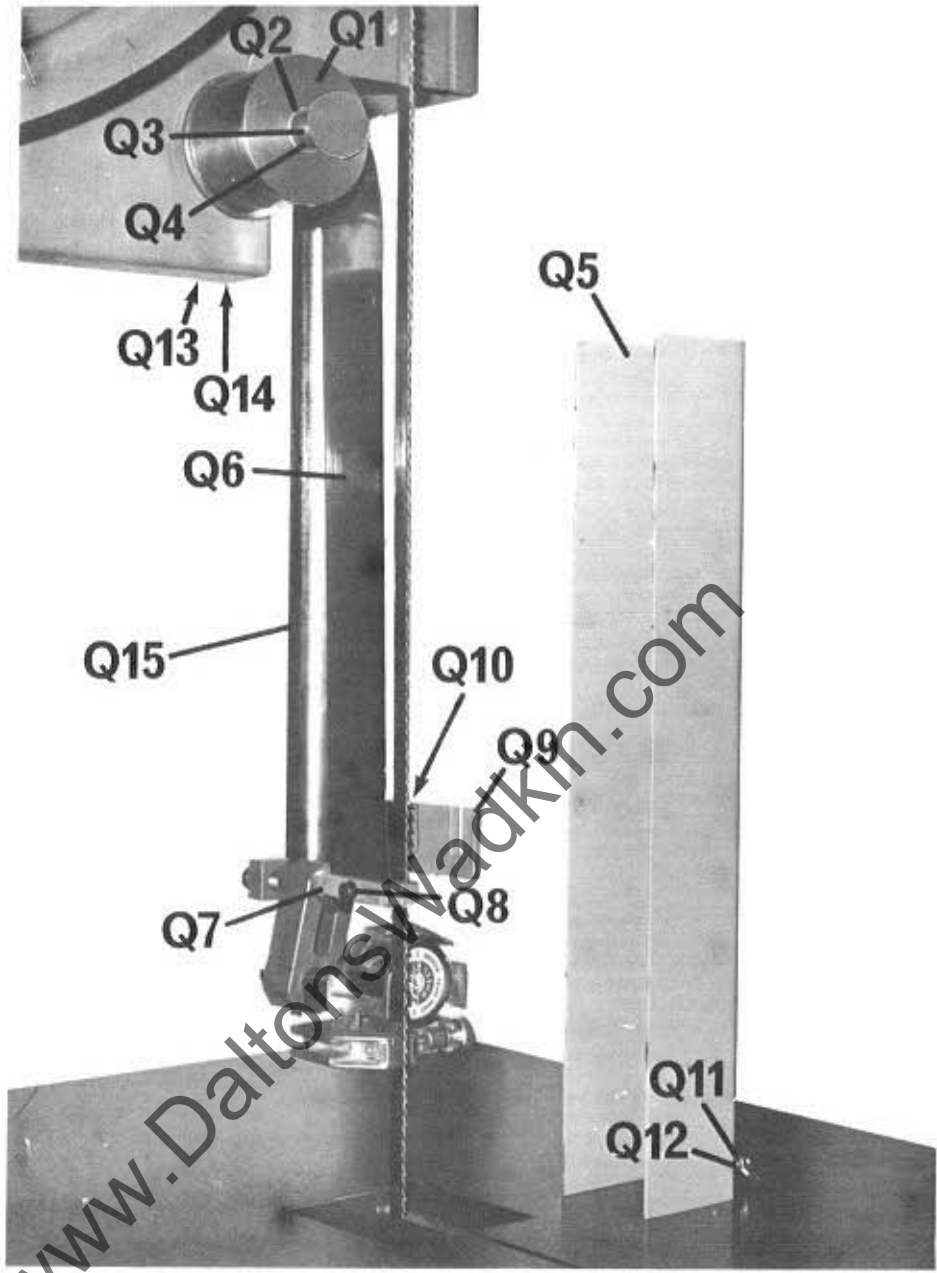
SAFETY TENSION INDICATOR ASSEMBLY (EXTRA).



DELUXE TOP SAWGUARD. (EXTRA).

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
Q1	C8/56	1	Bobbin for tensator spring.
Q2		2	25 O/D x 20 I/D x 20 long oilite bush.
Q3	C8/98	1	Spindle (tensator spring).
Q4	7115-020	1	20mm Truarc reinforced self locking ring.
Q5	C8/58	1	Top sawguard.
Q6	CD14	1	Tensator spring.
Q7	C8/59	1	Tensator spring clamp.
Q8		1	M6 x 10 socket head capscrew.
Q9	C8/101	1	Top sawguard bracket.
Q10		2	M8 x 15 long socket head capscrew.
Q11		2	M6 wingnut.
Q12		2	6mm washer.
Q13		1	M10 x 25 long hexagon head screw.
Q14		1	10mm washer.
Q15	C8/26	1	Guide column.

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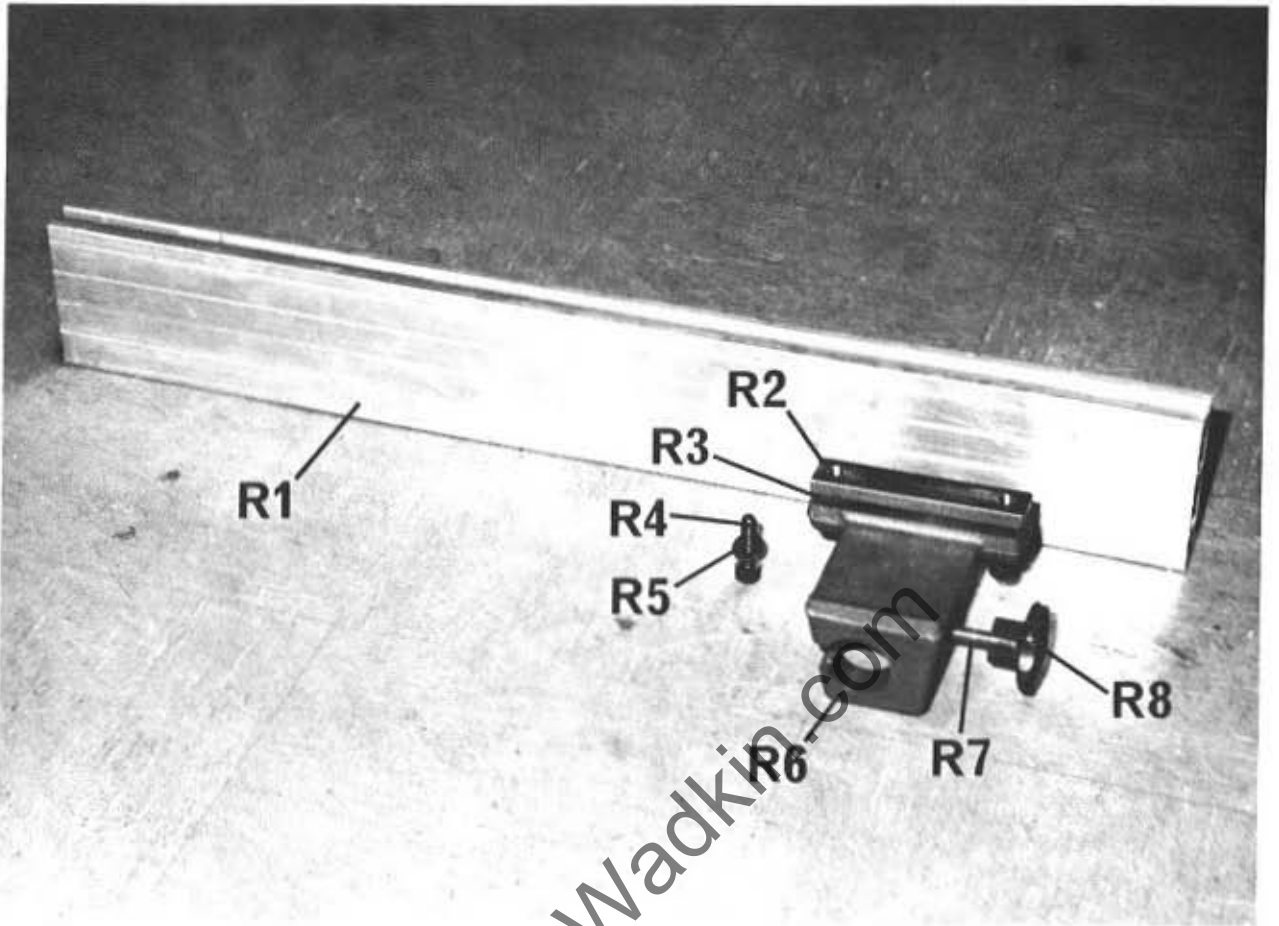


DELUXE TOP SAWGUARD (EXTRA).

RIP FENCE ASSEMBLY. (EXTRA).

<u>Ref. No.</u>	<u>Part No.</u>	<u>No. Off.</u>	<u>Description.</u>
R1	C8/61	1	Fence plate.
R2	C8/93	1	Fence clamp plate.
R3	C8/94	1	Fence spacer.
R4		2	M10 x 35 long socket head capscrew.
R5		2	10mm washer.
R6	C8/6	1	Fence bracket.
R7		1	Stud for fence.
R8		1	M10 x 2,1/8" dia, fence locking handwheel.

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RIP FENCE ASSEMBLY. (EXTRA).

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