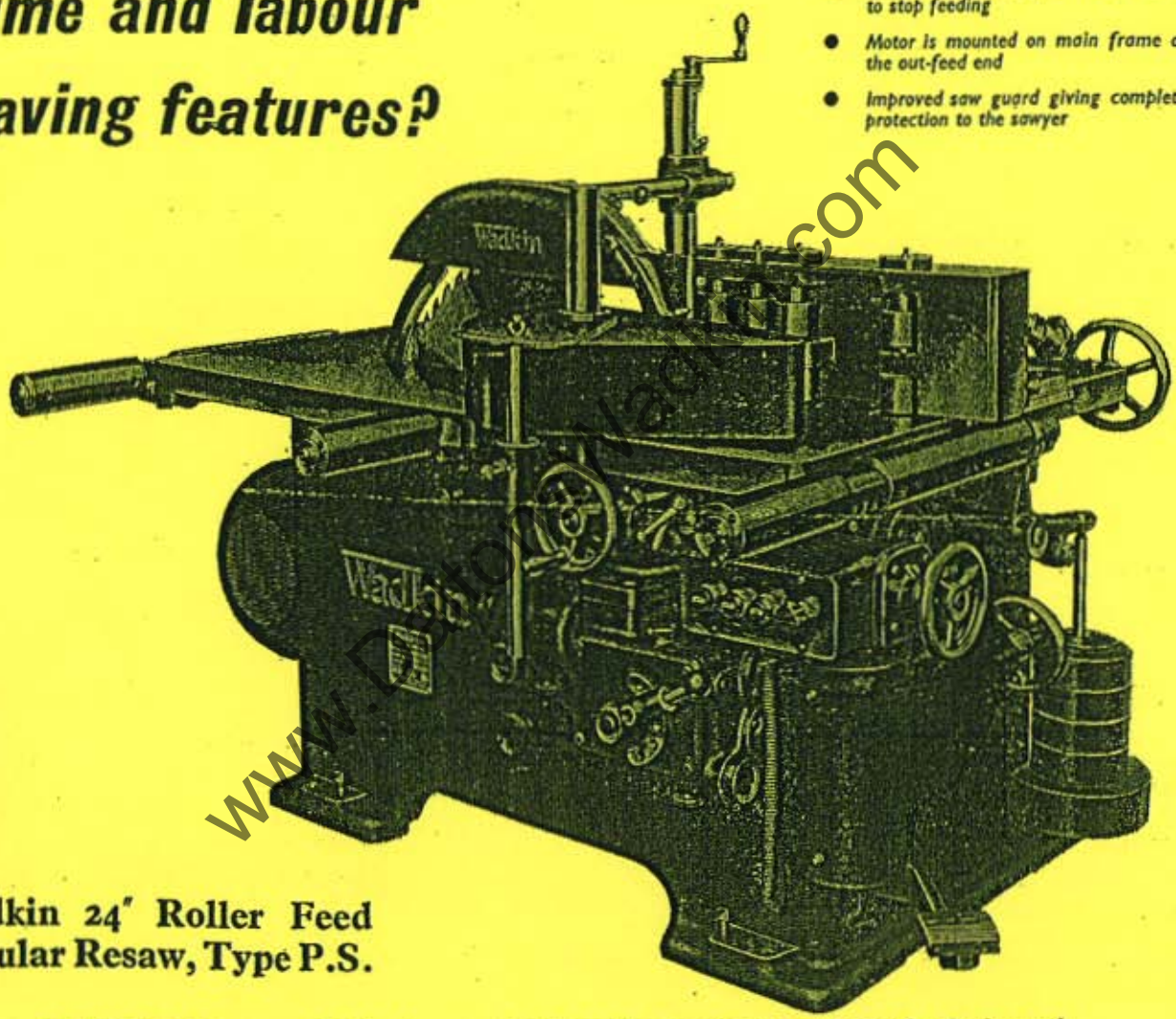
Will your NEW RESAW have all these time and labour saving features?

- *Three rates of feed—49', 73' and 108' per minute*
- *Anti-friction roller fitted at front and rear of table for easy handling of heavy timber*
- *Anti-friction rollers fitted to near-side table edge to facilitate returning of the timber to the sawyer*
- *Handwheel and screw for easy canting of fence*
- *Fence adjusts across table by large handwheel and screw*
- *Feed roller adjustable vertically for varying depths of cut*
- *Feed roller cants up to 30°; and both roller and shaft are detachable, leaving table clear for hand feeding*
- *Foot lever releases pressure on roller to stop feeding*
- *Motor is mounted on main frame at the out-feed end*
- *Improved saw guard giving complete protection to the sawyer*



Wadkin 24" Roller Feed Circular Resaw, Type P.S.

THIS modern, power-fed circular resaw is designed for deeping up to 7", also for flatting and bevel sawing. It is particularly adaptable for general purpose sawing and ideal for working in conjunction with a modern high speed moulder. It is compact, self-contained and unussually economical in floor space, due to its principle of operation and unique drive arrangement. Powerful, convenient and easy to operate it has many technical features that guarantee fast, accurate, low-cost production.

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.

TYPE

TECHNICAL DATA

pulleys provide spindle speeds of		1,800 r.p.m.
Maximum diameter of saw at 1,800 r.p.m.	24 in.	610 mm.
Maximum depth of cut with 24in. dia. saw	7 in.	180 mm.
Bore of saw	$1\frac{3}{4}$ in.	44 mm.
Maximum distance saw to fence	in.	mm.
Maximum distance saw to feed rollers	12 in.	305 mm.
Fence tilts up to	45 degrees	
B.H.P. required	30	

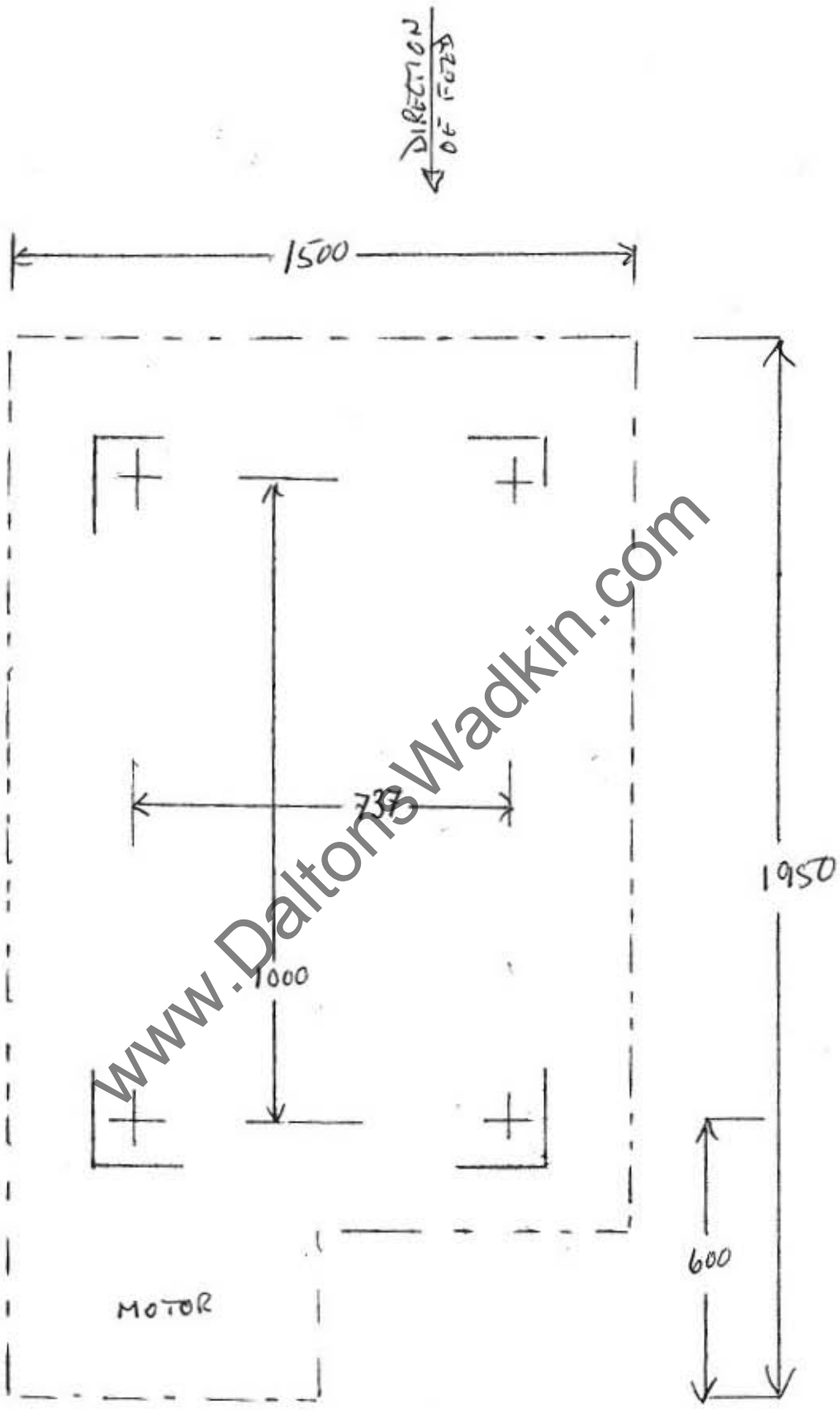
Feed rates (saw at 1,800 r.p.m.)

1 = 17 MPM / 2 = 24 MPM / 3 = 33 MPM

Nett weight 3,500 lb. 1590. kilos

SPARE PARTS LIST

Description	Reference Number
Main spindle bearing, saw end	SKF. RM16
Main spindle bearing, pulley end	SKF. RM13
Ball bearings for fence rollers	4X KLN51 SKF bearings / 4 x RLS7
FEED MOTOR	SKF RMS8 / SKF 2209
Vee ropes	B83 vee ropes (5 off)



FOUNDATION BOLT HOLE CENTRES

INSTRUCTIONS

All machines are tested before leaving our Works, and are not passed out unless in perfect working order. Although simple to operate, care is nevertheless necessary in their use and the following instructions should be carried out.

INSTALLATION

For every machine despatched from our Works, we supply a foundation drawing to enable our clients to make the necessary preparations for the installation of the machine prior to its delivery. The drawing gives full particulars of the space occupied, positions of the fixing bolts and the foundations we recommend.

NOTE: The latter must be taken as a general guide only, as site conditions may govern the foundation to some extent. On some machines certain modifications may be necessary if the machine is to be coupled to a dust extraction system, and before construction is commenced Exhaust Engineers should be consulted.

If the machine is to be fixed on concrete proceed as follows:-

(a) Prepare the foundation on well consolidated earth and as directed on the foundation drawing of the machine, leaving holes to receive the fixing bolts. These holes may be formed by boxes of thin timber, which can be easily removed when the concrete has set.

(b) Raise the machine so that the bolts can be suspended through the holes provided in the base or feet.

(c) Lower the machine into position, levelling by placing slate or metal packings on each side of the bolt holes.

(d) See that the moving parts are free.

(e) Place shuttering of suitable depth around machine base and run in sufficient grout to hold bolts and base.

(f) Do not attempt to tighten bolts or work machine until the grout is thoroughly hard.

IMPORTANT: Do not attempt to fix the bolts before the machine is placed in position.

OR DRILL CONCRETE AND USE 12MM X 130 ANCHOR BOLTS

ELECTRICAL CONNECTIONS made on site must be carried out by experienced electricians only. For full details see the wiring diagram.

VEE BELT INSTRUCTIONS

To ensure trouble free service from vee belts careful observance of the following rules concerning their application is important:-

(1) When fitting the belts make sure that the grooves in the two pulleys are clean, i.e. free from dirt, grease or rust preventative etc.

(2) Always mount the belts loosely by hand. Do not force them into the pulley grooves with a screwdriver or any other such implement, as this would tend to damage the outer envelope or possibly rupture the load carrying cords. Any such damage might not be immediately apparent but could result in the belts failing within a matter of hours.

CORRECT METHOD OF FITTING. INCORRECT METHOD OF FITTING.

(3) Tension the belts carefully. After one hour's running, and again after eight hour's running, check the tension and adjust, if necessary.

The tension applied should be just sufficient to prevent the belts slipping.

Too little tension will allow slipping and will result in loss of driving power and belt life.

Too much tension will result in short belt life.

(4) Do not use belt dressing under any circumstances. It is not necessary and would only cause deterioration of the rubber compounds, and "snatch" due to temporary localised increases in the co-efficient of friction.

(5) Do not run old and new belts in the same set. If new belts are required always order and fit a complete 'matched' set.

(6) If belts flap excessively increase tension. If the spindle shows signs of pulling up stop the machine and feel if either of the pulleys is unduly warm. Such a condition indicates incorrect tension in the drive and this should be remedied by the means provided.

LUBRICATION (See also at the end of the booklet additional notes on lubrication and recommended lubricants).

Plain bearings

Power-driven shafts. The lubricators fitted allow grease to be applied directly to the bearings by means of a grease gun. In some cases the nipples fitted are similar to those fitted to the ball bearing housings, in which case only one grease gun is supplied. This should be filled with ball bearing grease and used for charging both the ball bearing and plain bearing lubrication points.

Hand motion shafts. In most cases an oil cup, hole or groove is provided for application of oil by means of an oil can. Alternatively, a grease nipple is provided for application of grease by means of a grease gun. Apply lubricant regularly and according to usage.

Oil retaining bushes. Bushes of this type normally require no attention from the operator. After a long period of inactivity in a dusty atmosphere, however it is advisable to apply a little oil on the shaft adjacent to the bearings. This also applies if the bearings become noisy.

Phosphor-bronze bearings.

A grease nipple or oilcup with wick feeder is provided for each bearing.

When a grease nipple is fitted, grease can be applied directly to the bearing by means of a grease gun. Use the recommended grease and apply according to usage.

When an oilcup is provided, frequently check the level of oil and top up as required. Always replace the oilcup cover. Do not remove the wick feeder.

Ball and Roller Bearings

Bearings with replenishable grease

Lubricant - It is necessary to use lubricant specially prepared for ball bearings, This grease is free from acid, alkali and resin, and is supplied in 7 lb. (3.17 kilos) tins. We recommend the exclusive use of Wadkin Ball Bearing Grease for all ball bearings, but alternatives are listed on a later page.

Recharging with fresh lubricant - The lubricators fitted allow grease to be applied directly to the bearings by means of a grease gun. Great care should be taken not to charge the bearings too tightly with lubricant as this might result in their heating up.

NOTE:- Every care is taken in packing to protect the bearings from dirt, but, in spite of this, grit may obtain access during transit. To detect its presence turn each spindle slowly by hand when the slightest resistance will be noticed. If any resistance is encountered the bearings must be cleaned out. Take off the end cover and remove as much as possible of the old grease by hand. Wash out the remainder with benzine, then replace the end cover and replenish with fresh lubricant.

CAUTION:- Neither paraffin nor kerosine should be used for washing out

the bearings as they cause rust, and for the same reason persons whose han perspire should exercise care when handling bearings.

Sealed-for-life Bearings. This type of bearing requires no further attention from the operator.

Grease packed bearings. Grease which is packed in these bearings during assembly should suffice to keep them lubricated for an indefinite period of time. When it becomes necessary to re-pack the bearings use specially prepared ball bearing grease, taking the same precautions as outlined for replenishable grease type bearings.

Thrust races. Apply oil regularly and according to usage by means of an oil can to the groove, when provided, or to the seating.

Gearboxes.

Gears and bearings are splash-lubricated from the gearbox oil. Maintain the gearbox oil level, as shown on the dipstick or oil level indicator, by topping-up as necessary. The oil should be filtered every six months and changed every two years. When a breather pipe is fitted, periodically check that the small air holes in it are clear.

Chains

All chains should be periodically removed from the machine, thoroughly cleaned in a bath of benzine, dried and then immediately dipped in a bath of melted tallow before being replaced. Take care that the chain, when replaced, is mounted correctly, as shown in the illustrations.

WADKIN 24" CIRCULAR RESAW TYPE P.S.

SEE FIG. 1

1. Handle for vertical adjustment of saw guard.

2 Handwheel for adjusting feed rollers to suit varying diameters of saw.

3 Removable filler caps for gear box.

4 Gear change lever.

5 Screws for locking support bracket for feed roller shaft when set vertical or canted to any angle up to 30°.

6 Handle for locking feed roller arm to pressure system.

NOTE: This handle must be released before the feed rollers are adjusted by (6) and made secure again after the adjustment has been made.

7 Handwheel for adjustment of feed rollers to and from the fence.

8 - to stop feed quickly, depress pedal.

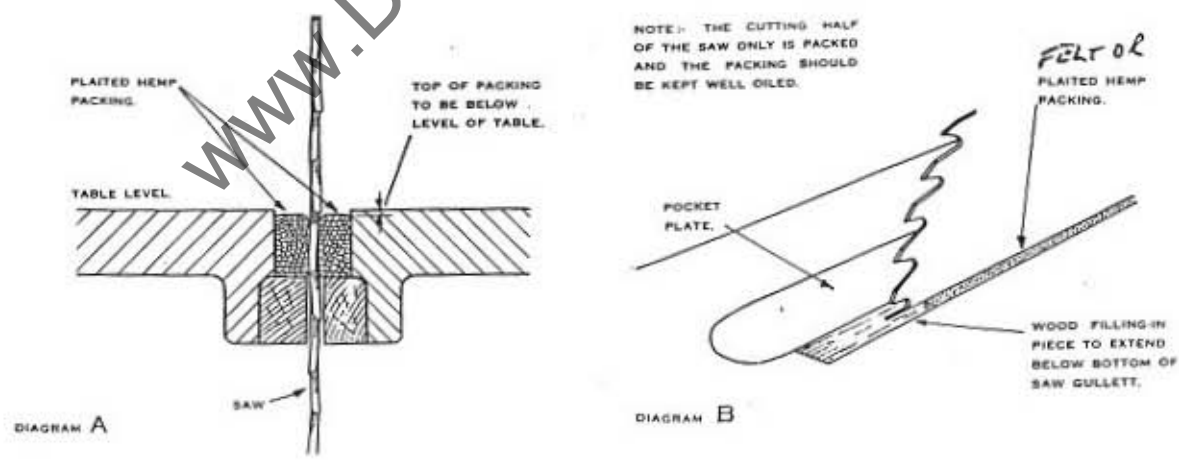
Foot lever for quick movement of feed roller to and from fence.

Adjustable pressure weight for feed rollers.

9. Handwheel for fine adjustment of fence.

24. Handwheel for tilting fence.

Saw Packings. Hardwood support pieces are provided below table level adjacent to the cutting half of the saw to allow filler pieces and packings to



Packing for Circular Saws.

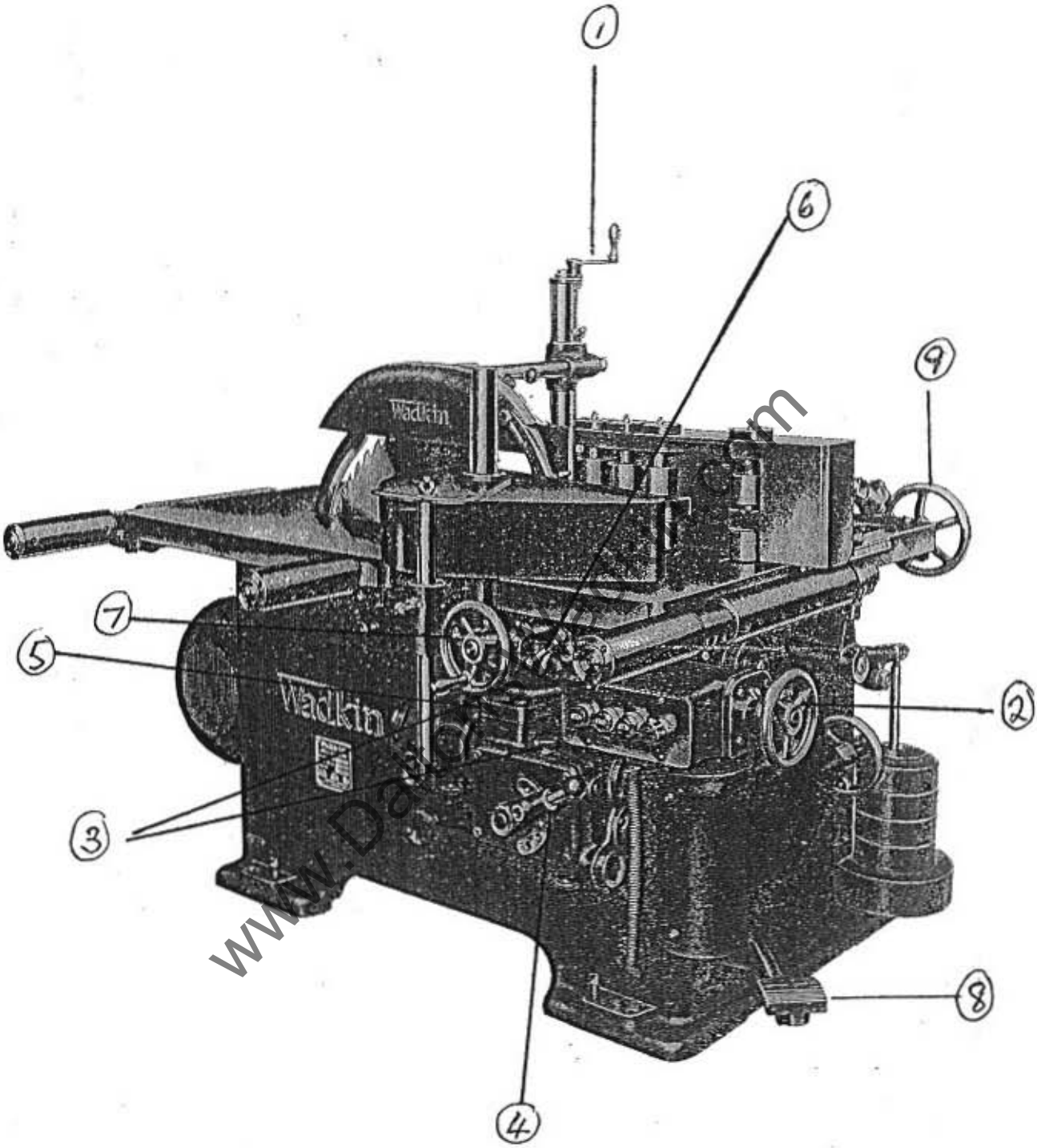
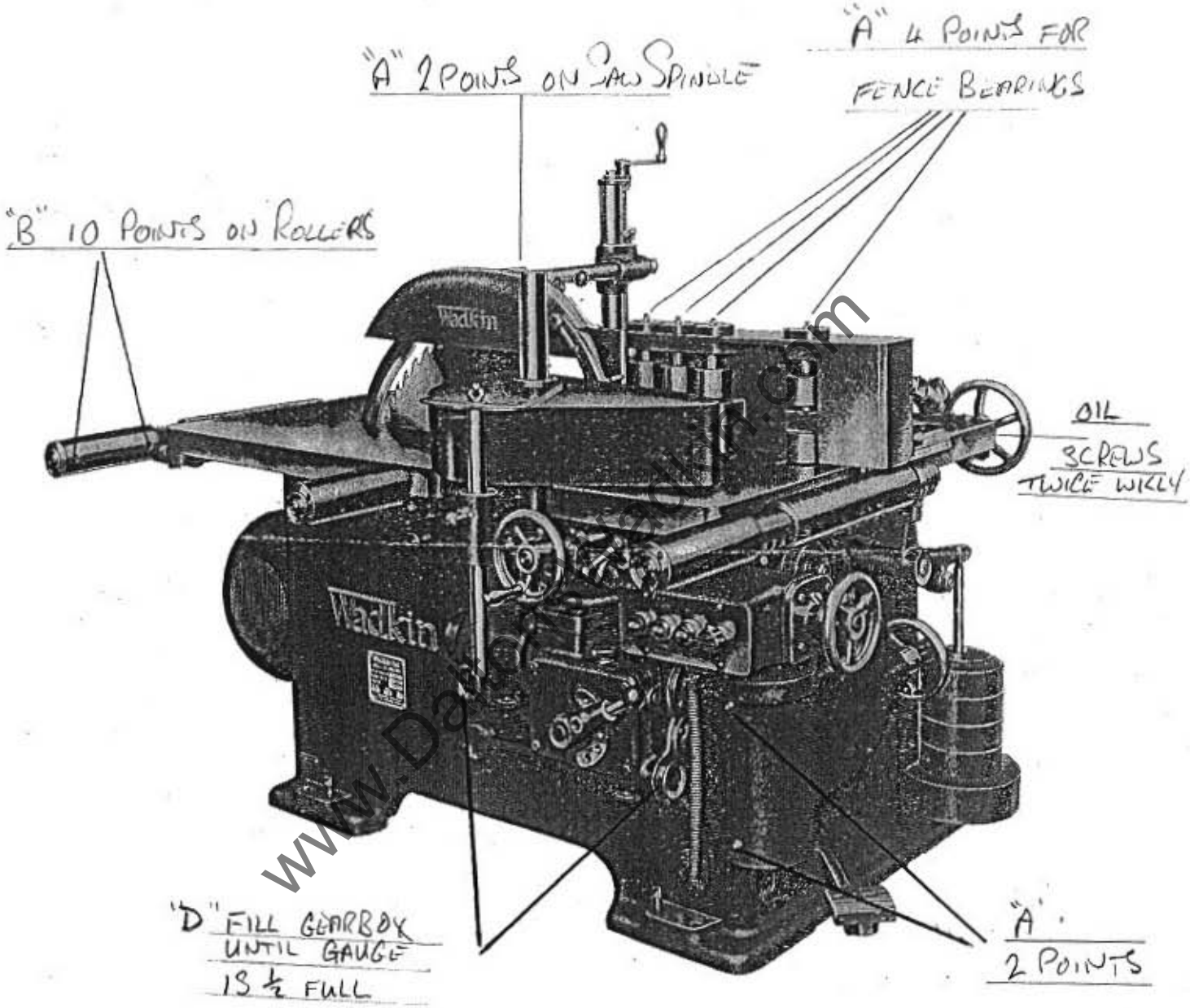


FIG 1



FOR GEARBOXES USE WADKIN GEAR OIL L2 (SAE 80)
FOR ALL BALL BEARINGS USE WADKIN GRADE L6 (ALVANIA 3)

POINTS "A" 4 TO 6 DEPRESSIONS OF GREASE GUN EVERY 3 TO 6 MONTHS
POINTS "B" ONE DEPRESSION OF GREASE WEEKLY
POINTS "C" OIL TWICE WEEKLY WITH MACHINE OIL
POINTS "D" GEAR OIL L2 (SAE 80) CHANGE EVERY 12 MONTHS

LUBRICATION				
Machine part	Point **	Type of Lubricant	Amount	Frequency of application
General Horizontal rollers	-	GREASE	SMALL CHARGE *	MONTHLY *
Feed roller guards, screws, slides and other working parts	-	General oil can oil	As required	According to use.
Fence adjustment shafts - plain bearings			Small charge	WEEKLY

* See notes on lubrication

** Lubrication points are shown on

RECOMMENDED LUBRICANTS

Make	Application		
	Gear Boxes	Hydraulics	Plain Bearings
Shell-Mex & B.P. Ltd.	Vitrea Oil 69	Tellus Oil 27	Unedo Grease 1 or Alvania Grease 3.
Esso Petroleum Co. Ltd.	Esstic 50	Esstic 42	Cazar K2 Grease
Castrol Limited	Perfecto T.T.	Hyspin 70	Spheerol L or Spheerol AP. 3 Grease
Mobil Oil Co. Ltd.	Vactra Extra Heavy	DTE Oil Light	Mobilgrease AA No. 2
Sternol Ltd.	-	-	Sternoline

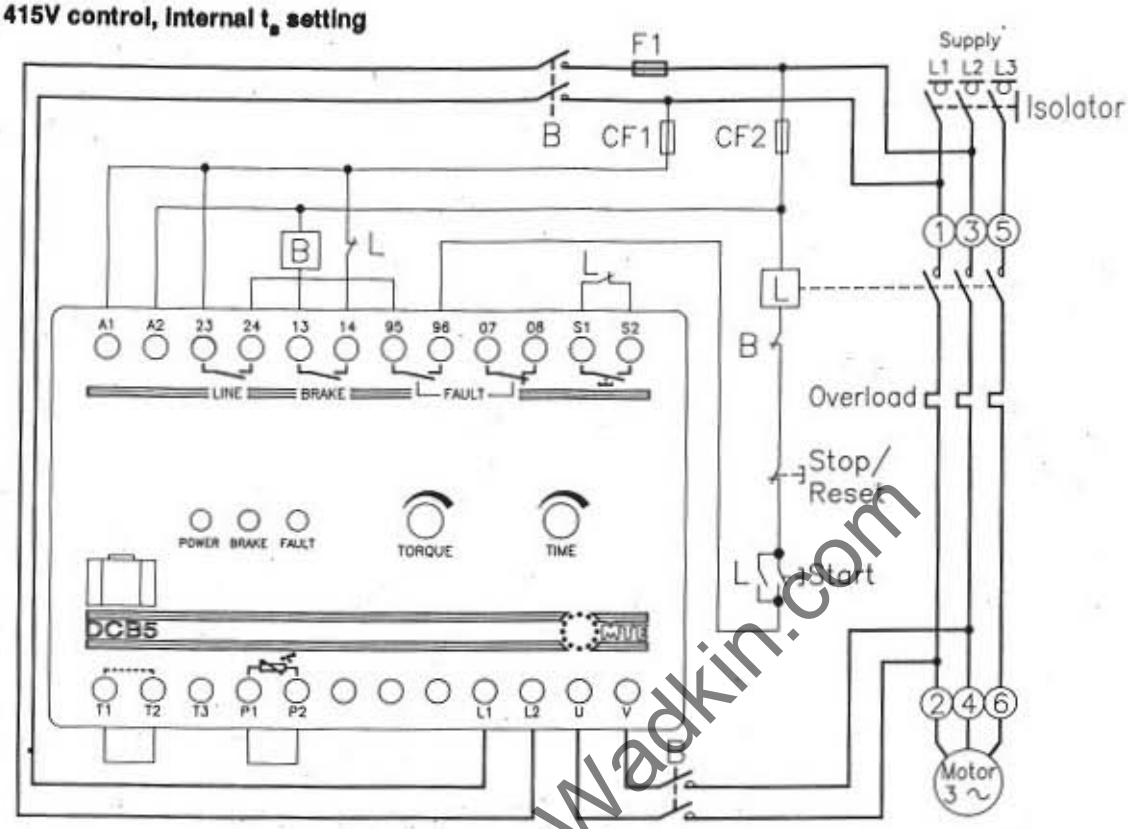
Make	Application		
	Open Gears	General Oilcan use	Ball & Roller Bearings
Shell-Mex & B.P. Ltd.	Cardium Compound 'D'	Carnea Oil 35	Alvania Grease 2.
Esso Petroleum Co. Ltd.	Surett 800	Coray 55	T.S.D. 807
Castrol Limited	Grippa 33/5	Perfecto TT	A.P. 2
Mobil Oil Co. Ltd.	Mobil Dorcia 150	Rubrex 500	Mobilux Grease No. 2

NOTE: The Skefko Ball Bearing Co. Ltd. approve Alvania Grease 2 and Mobilux No. 2, but are unable to comment on the suitability of the others for Ball and Roller Bearings.

Technical Specification

Typical wiring diagrams

DOL starter, 415V control, internal t_e setting



Star-Delta starter, 240V control, external t_e setting