

14" Metal/Wood Cutting Band Saw

Model 28-306



Shown with Optional Stand
and Optional Mobile Base

PART NO. 426-03-651-0011 - 06-03-03
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To learn more about DELTA MACHINERY
visit our website at: www.deltamachinery.com.

For Parts, Service, Warranty or other Assistance,

please call **1-800-223-7278** (In Canada call **1-800-463-3582**).

SAFETY GUIDELINES - DEFINITIONS

This manual contains information that is important for you to know and understand. This information relates to protecting YOUR SAFETY and PREVENTING EQUIPMENT PROBLEMS. To help you recognize this information, we use the symbols to the right. Please read the manual and pay attention to these sections.

- ▲ DANGER** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.
- ▲ WARNING** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.
- ▲ CAUTION** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.
- CAUTION** Used without the safety alert symbol indicates potentially hazardous situation which, if not avoided, may result in property damage.

▲ WARNING **SOME DUST CREATED BY POWER SANDING, SAWING, GRINDING, DRILLING, AND OTHER CONSTRUCTION ACTIVITIES** contains chemicals known to cause cancer, birth defects or other reproductive harm.

Some examples of these chemicals are:

- lead from lead-based paints,
- crystalline silica from bricks and cement and other masonry products, and
- arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, always wear **MSHA/NIOSH** approved, properly fitting face mask or respirator when using such tools.

GENERAL SAFETY RULES



▲ WARNING **READ AND UNDERSTAND ALL WARNINGS AND OPERATING INSTRUCTIONS BEFORE USING THIS EQUIPMENT.** Failure to follow all instructions listed below, may result in electric shock, fire, and/or serious personal injury or property damage.

SAVE!* IMPORTANT SAFETY INSTRUCTIONS *SAVE!

Woodworking can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, push sticks, hold-downs, featherboards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workshop. If a procedure feels dangerous, don't try it. Figure out an alternative procedure that feels safer. **REMEMBER:** Your personal safety is your responsibility.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, **DO NOT** use the machine until you have first contacted Delta to determine if it can or should be performed on the product.

Technical Service Manager
Delta Machinery
4825 Highway 45 North
Jackson, TN 38305
(IN CANADA: 505 SOUTHGATE DRIVE, GUELPH, ONTARIO N1H 6M7)

▲WARNING FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY.

- 1. FOR YOUR OWN SAFETY, READ THE INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learning the machine's application, limitations, and specific hazards will greatly minimize the possibility of accidents and injury.
- 2. USE CERTIFIED SAFETY EQUIPMENT.** Eye protection equipment should comply with ANSI Z87.1 standards, hearing equipment should comply with ANSI S3.19 standards, and dust mask protection should comply with MSHA/NIOSH certified respirator standards. Splinters, air-borne debris, and dust can cause irritation, injury, and/or illness.
- 3. DRESS PROPERLY.** Do not wear tie, gloves, or loose clothing. Remove watch, rings, and other jewelry. Roll up your sleeves. Clothing or jewelry caught in moving parts can cause injury.
- 4. DO NOT USE THE MACHINE IN A DANGEROUS ENVIRONMENT.** The use of power tools in damp or wet locations or in rain can cause shock or electrocution. Keep your work area well-lit to prevent tripping or placing arms, hands, and fingers in danger.
- 5. MAINTAIN ALL TOOLS AND MACHINES IN PEAK CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories. Poorly maintained tools and machines can further damage the tool or machine and/or cause injury.
- 6. CHECK FOR DAMAGED PARTS.** Before using the machine, check for any damaged parts. Check for alignment of moving parts, binding of moving parts, breakage of parts, and any other conditions that may affect its operation. A guard or any other part that is damaged **should be properly repaired or replaced.** Damaged parts can cause further damage to the machine and/or injury.
- 7. KEEP THE WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 8. KEEP CHILDREN AND VISITORS AWAY.** Your shop is a potentially dangerous environment. Children and visitors can be injured.
- 9. REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure that the switch is in the "OFF" position before plugging in the power cord. In the event of a power failure, move the switch to the "OFF" position. An accidental start-up can cause injury.
- 10. USE THE GUARDS.** Check to see that all guards are in place, secured, and working correctly to prevent injury.
- 11. REMOVE ADJUSTING KEYS AND WRENCHES BEFORE STARTING THE MACHINE.** Tools, scrap pieces, and other debris can be thrown at high speed, causing injury.
- 12. USE THE RIGHT MACHINE.** Don't force a machine or an attachment to do a job for which it was not designed. Damage to the machine and/or injury may result.
- 13. USE RECOMMENDED ACCESSORIES.** The use of accessories and attachments not recommended by Delta may cause damage to the machine or injury to the user.
- 14. USE THE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. See the Extension Cord Chart for the correct size depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- 15. SECURE THE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. Loss of control of a workpiece can cause injury.
- 16. FEED THE WORKPIECE AGAINST THE DIRECTION OF THE ROTATION OF THE BLADE, CUTTER, OR ABRASIVE SURFACE.** Feeding it from the other direction will cause the workpiece to be thrown out a high speed.
- 17. DON'T FORCE THE WORKPIECE ON THE MACHINE.** Damage to the machine and/or injury may result.
- 18. DON'T OVERREACH.** Loss of balance can make you fall into a working machine, causing injury.
- 19. NEVER STAND ON THE MACHINE.** Injury could occur if the tool tips, or if you accidentally contact the cutting tool.
- 20. NEVER LEAVE THE MACHINE RUNNING UNATTENDED. TURN THE POWER OFF.** Don't leave the machine until it comes to a complete stop. A child or visitor could be injured.
- 21. TURN THE MACHINE "OFF", AND DISCONNECT THE MACHINE FROM THE POWER SOURCE** before installing or removing accessories, before adjusting or changing set-ups, or when making repairs. An accidental start-up can cause injury.
- 22. MAKE YOUR WORKSHOP CHILDPROOF WITH PADLOCKS, MASTER SWITCHES, OR BY REMOVING STARTER KEYS.** The accidental start-up of a machine by a child or visitor could cause injury.
- 23. STAY ALERT, WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE. DO NOT USE THE MACHINE WHEN YOU ARE TIRED OR UNDER THE INFLUENCE OF DRUGS, ALCOHOL, OR MEDICATION.** A moment of inattention while operating power tools may result in injury.
- 24. THE DUST GENERATED** by certain woods and wood products can be injurious to your health. Always operate machinery in well-ventilated areas, and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR BAND SAWS

⚠ WARNING FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY.

1. **DO NOT OPERATE THIS MACHINE UNTIL** it is assembled and installed according to the instructions.
2. **OBTAIN ADVICE** from your supervisor, instructor, or another qualified person if you are not familiar with the operation of this tool.
3. **FOLLOW ALL WIRING CODES** and recommended electrical connections.
4. **USE THE GUARDS WHENEVER POSSIBLE.** Check to see that they are in place, properly adjusted, secured, and working correctly.
5. **USE PROPER BLADE SIZE** and type.
6. **ADJUST THE UPPER BLADE GUIDE** so that it is about 1/8" above the workpiece.
7. **PROPERLY ADJUST** the blade tension, tracking, blade guides, and blade support bearings.
8. **KEEP ARMS, HANDS, AND FINGERS** away from the blade.
9. **AVOID AWKWARD OPERATIONS** and hand positions where a sudden slip could cause a hand to move into the blade.
10. **NEVER START THE MACHINE** before clearing the table of all objects (tools, scrap pieces, etc.).
11. **NEVER START THE MACHINE** with the workpiece against the blade.
12. **HOLD WORKPIECE FIRMLY** against the table. DO NOT attempt to saw a workpiece that does not have a flat surface against the table.
13. **HOLD WORKPIECE FIRMLY** and feed into blade at a moderate speed.
14. **NEVER REACH UNDER THE TABLE** while the machine is running.
15. **TURN THE MACHINE "OFF"** to back out of an uncompleted or jammed cut.
16. **MAKE "RELIEF" CUTS** prior to cutting long curves.
17. **TURN THE MACHINE "OFF"** and wait for the blade to stop prior to cleaning the blade area, removing debris near the blade, removing or securing workpiece, or changing the angle of the table. A coasting blade can be dangerous.
18. **NEVER PERFORM LAYOUT, ASSEMBLY,** or set-up work on the table/work area when the machine is running.
19. **TURN THE MACHINE "OFF" AND DISCONNECT THE MACHINE** from the power source before installing or removing accessories, before adjusting or changing set-ups, or when making repairs.
20. **TURN THE MACHINE "OFF"**, disconnect the machine from the power source, and clean the table/work area before leaving the machine. **LOCK THE SWITCH IN THE "OFF" POSITION** to prevent unauthorized use.
21. **ADDITIONAL INFORMATION** regarding the safe and proper operation of power tools (i.e. a safety video) is available from the Power Tool Institute, 1300 Sumner Avenue, Cleveland, OH 44115-2851 (www.powertoolinstitute.com). Information is also available from the National Safety Council, 1121 Spring Lake Drive, Itasca, IL 60143-3201. Please refer to the American National Standards Institute ANSI 01.1 Safety Requirements for Woodworking Machines and the U.S. Department of Labor OSHA 1910.213 Regulations.

SAVE THESE INSTRUCTIONS.

Refer to them often
and use them to instruct others.

POWER CONNECTIONS

A separate electrical circuit should be used for your machines. This circuit should not be less than #12 wire and should be protected with a 20 Amp time lag fuse. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and matching receptacle which will accept the machine's plug. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine. All line connections should make good contact. Running on low voltage will damage the motor.

⚠ DANGER DO NOT EXPOSE THE MACHINE TO RAIN OR OPERATE THE MACHINE IN DAMP LOCATIONS.

MOTOR SPECIFICATIONS

Depending on the optional stand purchased, the tool is either wired for 120 volt, or 240 volt with 60 Hz. alternating current. **Before connecting the tool to the power source, make sure the switch is in the "OFF" position.**

GROUNDING INSTRUCTIONS

⚠ DANGER THIS MACHINE MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

1. All grounded, cord-connected machines:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and matching 3-conductor receptacles that accept the machine's plug, as shown in Fig. A.

Repair or replace damaged or worn cord immediately.

2. Grounded, cord-connected machines intended for use on a supply circuit having a nominal rating less than 150 volts:

If the machine is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. A, the machine will have a grounding plug that looks like the plug illustrated in Fig. A. A temporary adapter, which looks like the adapter illustrated in Fig. B, may be used to connect this plug to a matching 2-conductor receptacle as shown in Fig. B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box. Whenever the adapter is used, it must be held in place with a metal screw.

NOTE: In Canada, the use of a temporary adapter is not permitted by the Canadian Electric Code.

⚠ DANGER IN ALL CASES, MAKE CERTAIN THAT THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE, HAVE A QUALIFIED ELECTRICIAN CHECK THE RECEPTACLE.

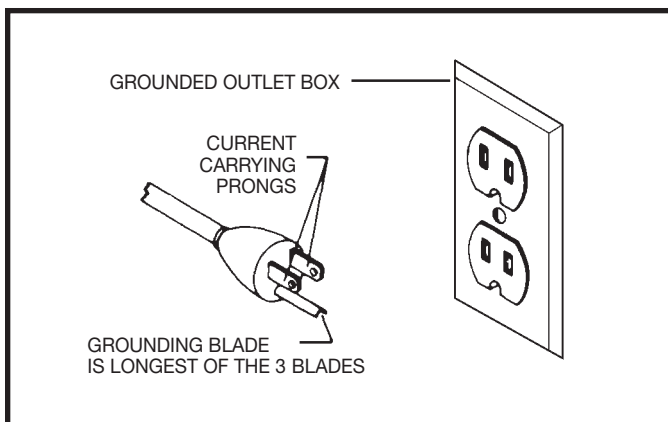


Fig. A

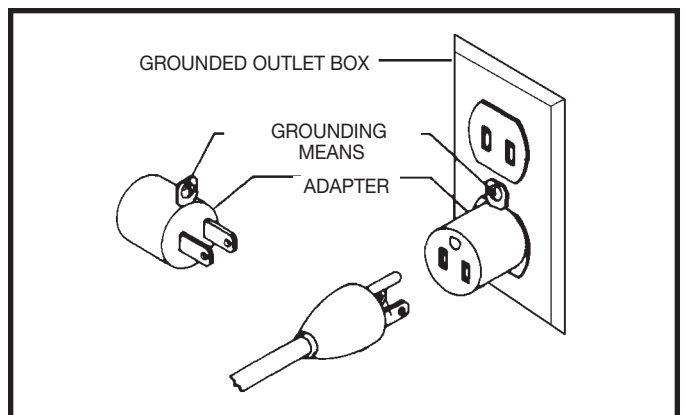


Fig. B

3. Grounded, cord-connected machines intended for use on a supply circuit having a nominal rating between 150 - 250 volts, inclusive:

If the machine is intended for use on a circuit that has an outlet that looks like the one illustrated in Fig. C, the machine will have a grounding plug that looks like the plug illustrated in Fig. C. Make sure the machine is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this machine. If the machine must be re-connected for use on a different type of electric circuit, the re-connection should be made by qualified service personnel; and after re-connection, the machine should comply with all local codes and ordinances.

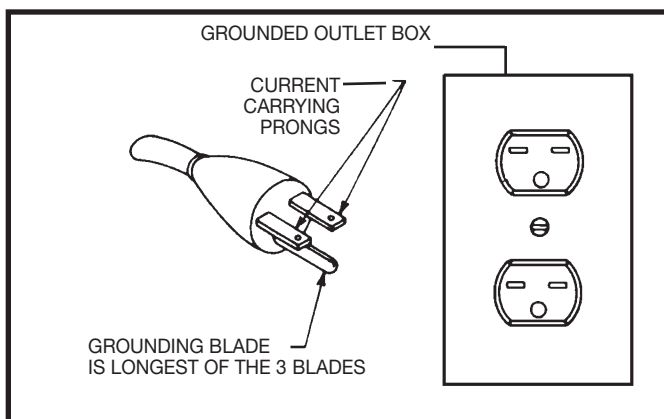


Fig. C

EXTENSION CORDS

CAUTION

Use proper extension cords. Make sure your extension cord is in good condition and is a 3-wire extension cord which has a 3-prong grounding type plug and matching receptacle which will accept the machine's plug. When using an extension cord, be sure to use one heavy enough to carry the current of the machine. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Fig. D, shows the correct gauge to use depending on the cord length. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

MINIMUM GAUGE EXTENSION CORD			
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES			
Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	120	up to 25	18 AWG
0-6	120	25-50	16 AWG
0-6	120	50-100	16 AWG
0-6	120	100-150	14 AWG
6-10	120	up to 25	18 AWG
6-10	120	25-50	16 AWG
6-10	120	50-100	14 AWG
6-10	120	100-150	12 AWG
10-12	120	up to 25	16 AWG
10-12	120	25-50	16 AWG
10-12	120	50-100	14 AWG
10-12	120	100-150	12 AWG
12-16	120	up to 25	14 AWG
12-16	120	25-50	12 AWG
12-16	120	GREATER THAN 50 FEET NOT RECOMMENDED	

Fig. D

MINIMUM GAUGE EXTENSION CORD			
RECOMMENDED SIZES FOR USE WITH STATIONARY ELECTRIC MACHINES			
Ampere Rating	Volts	Total Length of Cord in Feet	Gauge of Extension Cord
0-6	240	up to 50	18 AWG
0-6	240	50-100	16 AWG
0-6	240	100-200	16 AWG
0-6	240	200-300	14 AWG
6-10	240	up to 50	18 AWG
6-10	240	50-100	16 AWG
6-10	240	100-200	14 AWG
6-10	240	200-300	12 AWG
10-12	240	up to 50	16 AWG
10-12	240	50-100	16 AWG
10-12	240	100-200	14 AWG
10-12	240	200-300	12 AWG
12-16	240	up to 50	14 AWG
12-16	240	50-100	12 AWG
12-16	240	GREATER THAN 100 FEET NOT RECOMMENDED	

Fig. D

OPERATING INSTRUCTIONS

FOREWORD

Delta Model 28-306 is a 14" Metal and Wood Cutting Band Saw. This machine has speeds of 40, 60, 85, 115, 160, 220, 335, and 3000 SFM. Its blade to frame capacity is 13-3/4" and its under-guide and wheel capacity is 6-1/4".

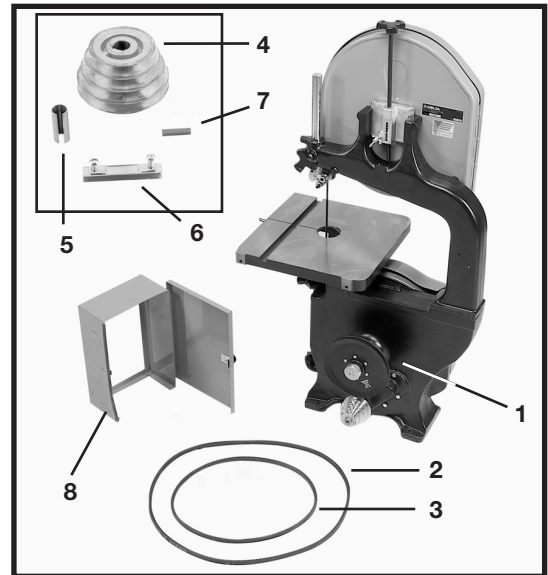
UNPACKING AND CLEANING

Carefully unpack the machine and all loose items from the shipping container(s). Remove the protective coating from all unpainted surfaces. 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 the unpainted surfaces with a good quality household floor paste wax.

NOTE: THE MANUAL COVER PHOTO ILLUSTRATES THE CURRENT PRODUCTION MODEL. ALL OTHER ILLUSTRATIONS ARE REPRESENTATIVE ONLY AND MAY NOT DEPICT THE ACTUAL COLOR, LABELING OR ACCESSORIES AND MAY BE INTENDED TO ILLUSTRATE TECHNIQUE ONLY.

CARTON CONTENTS

1. Band Saw with Pulleys attached
2. Large V-Belt
3. Small V-Belt
4. Motor Pulley
5. 3/4" to 5/8" Reducing Bushing
6. Belt and Pulley Guard Clamp
7. Key
8. Belt and Pulley Guard



ASSEMBLY

OPTIONAL STAND

The optional stand is shipped top-down in the shipping container with the motor mounted to the inside top of the stand. The on/off switch is wired to the end of the power cord.

To make the motor operational, do the following:

1. Remove the stand (A) Fig. 4 from the shipping container. Be careful not to crimp the switch cord that extends through the top of the stand. **NOTE:** Set the stand on several blocks of wood to raise the stand off the floor.
2. Take the panel (B) Fig. 4 off of the stand (A) by removing two screws (C) and loosening the two other screws (D). Remove the panel on the opposite side of the stand in the same way.
3. Remove the two mounting screws that are holding the motor (F) Fig. 5 to the top of the stand. One screw is shown at (E) Fig. 5.

IMPORTANT: DO NOT REMOVE THE CABLE TIE (G) that holds the switch cord (H) to the vertical mounting bar (J) unless the accessory height attachment will be used on the tool. This cable tie will prevent contact between the switch cord and the motor pulley or belt.

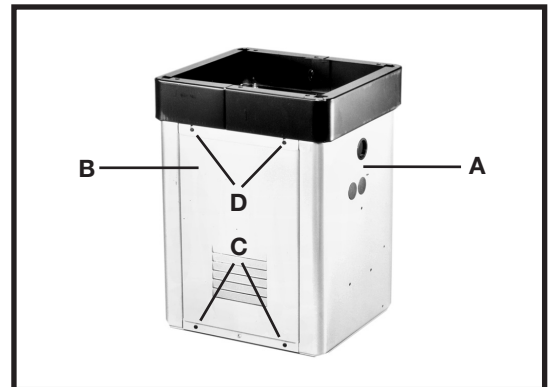


Fig. 4

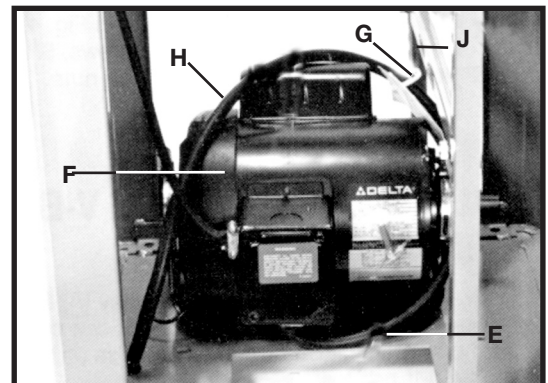


Fig. 5

ATTACHING MOTOR TO OPTIONAL STAND

1. Turn the stand on its side with the two bars (B) Fig. 6 down.
2. Position the motor (C) Fig. 6 on the two horizontal support bars (B), and fasten with the four 5/16-18 x 2" carriage bolts and flanged nuts, two of which are shown at (D).

IMPORTANT: PLACE THE MOTOR SHAFT (E) on the same side of the stand as the large opening in the top of the stand (See (B) Fig. 7) before loosely tightening the carriage bolts (D). Further alignment will be necessary after the saw is attached to the stand.

3. Carefully turn the stand right side up.

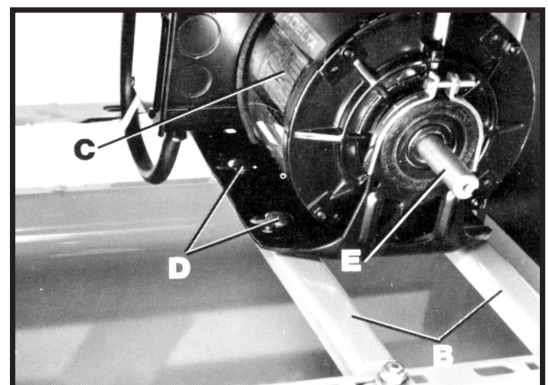


Fig. 6

ATTACHING BAND SAW TO THE OPTIONAL STAND

⚠ CAUTION The band saw is very heavy. Use a helper when attaching the saw to the stand.

Attach the band saw to the optional stand using the four holes provided (two are shown at (A) Fig. 7). Place one 5/16 -18 x 1-3/4" hex head screw with one 5/16" flat washer through each hole through the bottom of the band saw and the top of the stand, and attach with a 5/16" lock washer, and 5/16-18 hex nut.

NOTE: Screws, washers, and nuts for attaching the saw to the stand come with the optional stand.

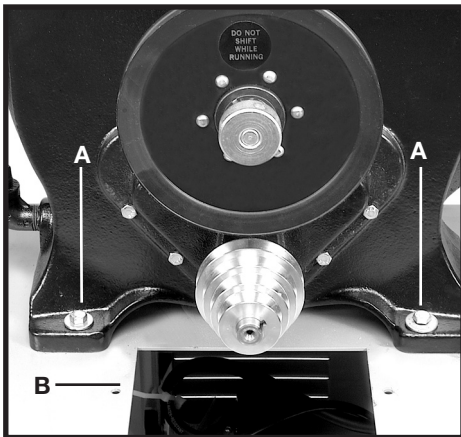


Fig. 7

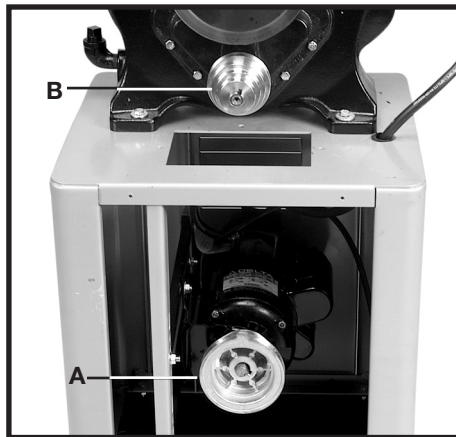


Fig. 8

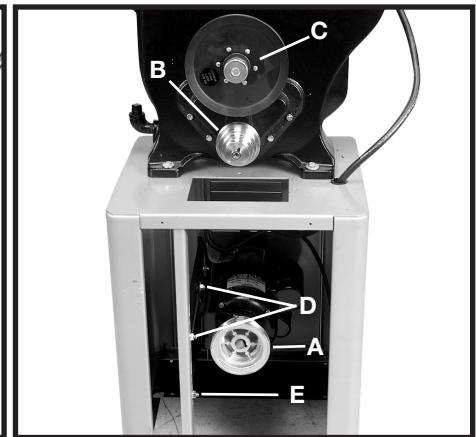


Fig. 9

ATTACHING MOTOR PULLEY

Both the motor pulley (A) Fig. 8, and the gearbox pulley (B) are four-step pulleys and should always be attached inverted to each other. Check to see if the gear box pulley (B) is attached with the largest step of the pulley in the "in" or "out" position. In this case, the largest step of the gear box pulley (B) is in the "in" position. Attach the motor pulley (A) to the motor shaft with the largest step of the motor pulley in the "out" position.

NOTE: When attaching the motor pulley (A) to the motor shaft, use the supplied 3/4" to 5/8" reducing bushing on the motor shaft. Place the supplied key in the motor shaft. Position the reducing bushing on the shaft, being sure to line the split in the reducer with the key. Position the pulley on the shaft. Line it up with the key. Secure with the two supplied 5/16-18 x 5/16" set screws.

ATTACHING BELT AND PULLEY GUARD, ATTACHING AND ALIGNING V-BELT, ADJUSTING BELT TENSION

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

1. Use a straight edge to align the inside grooves of the pulleys (A) and (B) Fig. 9 to the inside edge of the drive pulley (C). The pulleys can be moved in or out on the shafts and the motor can also be moved.
2. Place the belt and pulley guard (A) Fig. 10A over the belt opening and position the two clamps (B) over the guard flanges and under the top of the stand. Use the four 1/4-20 x 1/2" round head screws in the holes in the bottom of the clamps to fasten in place.
3. Attach the largest V-Belt to the inside groove of the motor pulley (A) Fig. 9 and to the drive pulley (C) Fig. 9. Attach 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 (A). (Fig. 10B shows belts in place. Belt and pulley guard was removed for clarity.)
4. Adjust the belt tension by raising or lowering the motor on the motor mounting bars (D) Fig. 9. If necessary, the motor mounting can be repositioned on the two posts (E) Fig. 9. Keep the pulleys in alignment when performing this operation. With light finger pressure, a 1" deflection in the belt at the center span of the pulleys indicates the proper tension.

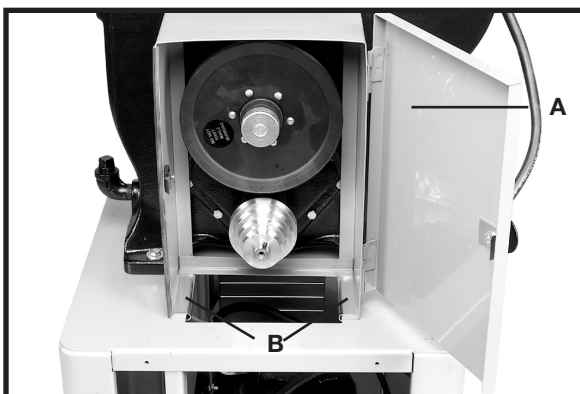


Fig. 10A



Fig. 10B

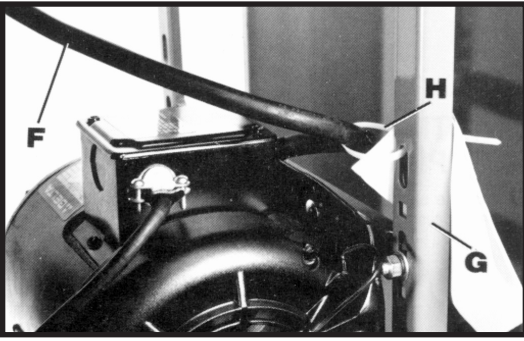


Fig. 11

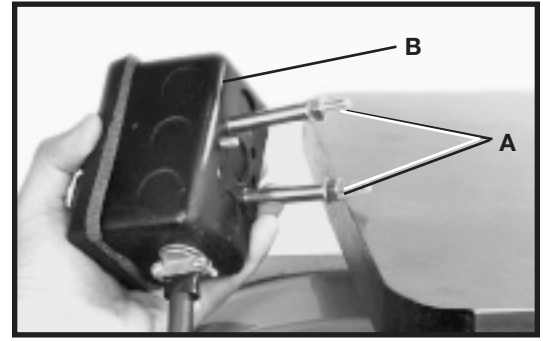


Fig. 12

ATTACHING THE SWITCH

A push-button switch (mounted in a switch box) and a cord set are supplied with the unit. To attach the switch to the band saw arm:

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

⚠ CAUTION The on/off switch-to-motor cord (F) Fig. 11 is tied to the vertical mounting post (G) opposite the motor pulley. The cable tie (H) prevents the switch-to-motor cord (F) from contacting the belt or motor pulley during operation.

IMPORTANT: LEAVE THIS CABLE TIE IN PLACE. Remove it **ONLY** when using the Accessory Height Attachment with the machine.

1. Remove the two outer hex nuts and lock washers (A) Fig. 12 from the two screws extending out from the back of the switch box (B).
2. Insert two screws (C) Fig. 13, located on back of switch box, into two holes (D) located in the band saw arm.
3. Use the two nuts and lockwashers (E) Fig. 14, removed in STEP 1, to fasten the switch box to the bandsaw arm (Fig. 14).
4. Remove the screw and cable clamp (E) Fig. 15 from the lower arm of the band saw.
5. Insert the switch cord into the clamp (E) (removed in **STEP 4**), and fasten the switch cord to the machine.

IMPORTANT: Prevent contact between the on/off switch-to-motor cord (F) Fig. 16 and the motor pulley or belt. If necessary, adjust the cord, then tighten the cable tie (H) Fig.11.

6. Attach the two side panels removed earlier.

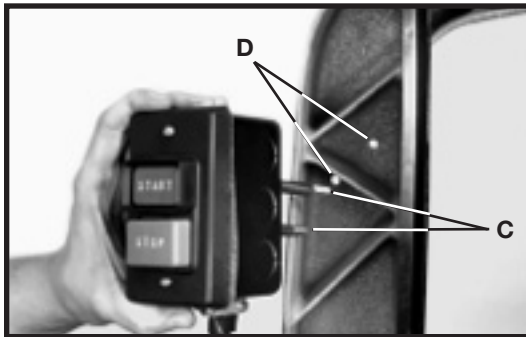


Fig. 13

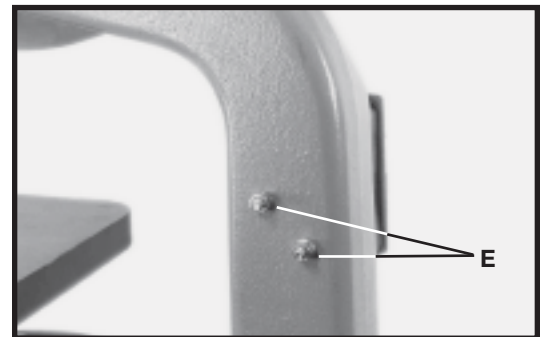


Fig. 14

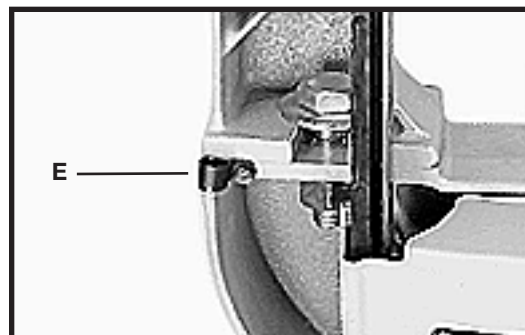


Fig. 15

STARTING AND STOPPING SAW

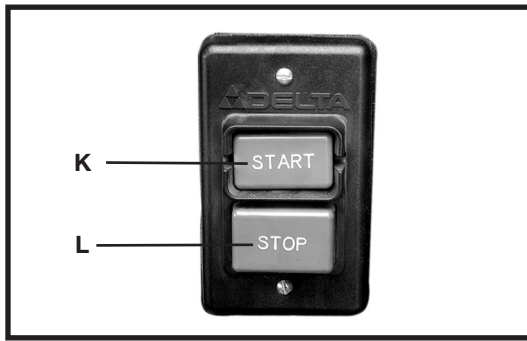


Fig. 17

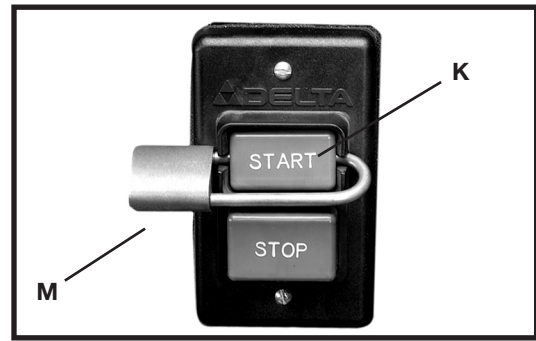


Fig. 18

To start the machine, press the "START" button (K) Fig. 17. To stop the tool, press the "STOP" button (L) Fig. 17.

CAUTION When the machine is not in use, the switch should be locked in the "OFF" position to prevent unauthorized use, using a padlock (M) Fig. 18 with a 3/16" diameter shackle

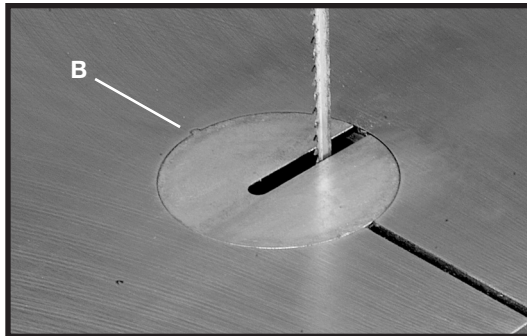


Fig. 19

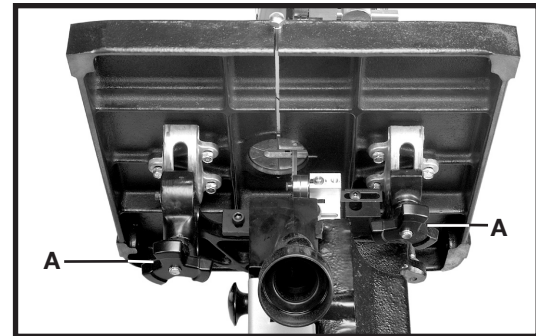


Fig. 20

TABLE INSERT

Place the table insert (A) Fig. 19 in the hole provided in the table. Engage the protrusion on the insert in the indent (B) in the table.

TILTING THE TABLE

1. The table on the machine can be tilted 45 degrees to the right and 10 degrees to the left. To tilt the table to the right, loosen the two locking knobs (A) Fig. 20, tilt the table to the desired angle, then re-tighten two locking knobs (A).
2. To tilt the table to the left, loosen the two locking knobs (A) Fig. 20, and tilt the table to the right until the table stop (A) Fig. 21 is accessible. Remove the table stop (A) Fig. 21, and tilt the table to the left. Tighten the two locking knobs (A) Fig. 20.

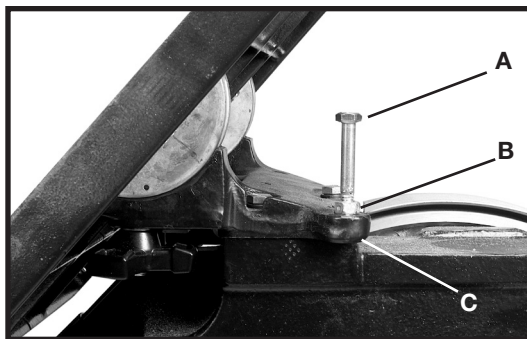


Fig. 21



Fig. 22

ADJUSTING THE TABLE STOP

The machine is equipped with an adjustable table stop (A) Fig. 21 that allows the table to be set at 90 degrees to the blade.

Tilt the table to the right until the table stop (A) Fig. 21 contacts the table. Place a square on the table against the blade (Fig. 22). Check to see if the blade is 90 degrees to the table surface. If not, do the following:

1. Tilt the table slightly to the left and tighten the table lock knobs.
2. Loosen the locknut (B) Fig. 21 to free the adjustment nut (A) Fig. 21. Turn the adjustment nut (A) right or left to raise or lower the table stop.
3. Lower the table. Check to see that the table is 90 degrees to the blade (Fig. 22). If it is, raise the table, hold the stop (A) Fig. 21 and tighten nut (B).

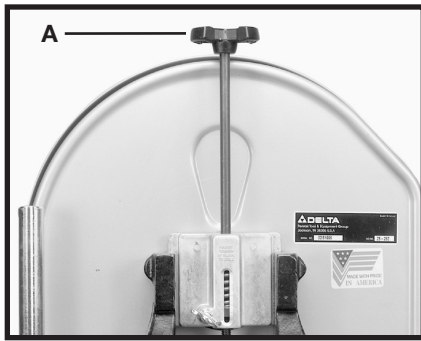


Fig. 23

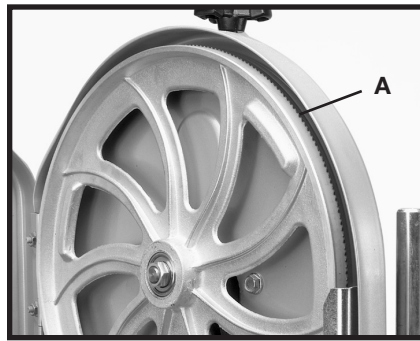


Fig. 24

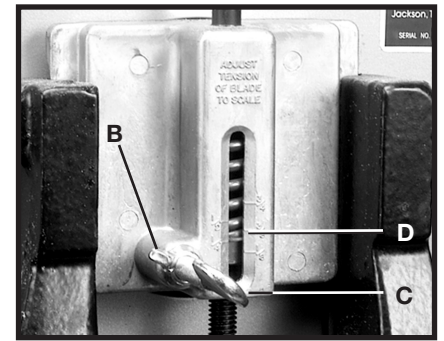


Fig. 25

ADJUSTING BLADE TENSION

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

A series of graduations is located on the back of the upper wheel slide bracket. These graduations indicate the proper tension for various widths of blades. With the blade on the wheels, turn the knob (A) Fig. 23 to raise or lower the wheel, until the red fiber washer (D) Fig. 25 is in line with the proper graduation for the size of the blade used.

These graduations are correct for average work, and will not be affected by rebrazing of the saw blade. Use these graduations until you become familiar enough with the operation of the band saw to vary the tension for different kinds of blades or work.

IMPORTANT: **OVER-STRAINING** is a common cause of blade breakage and other unsatisfactory blade performance. Release the blade tension when the machine is not in use.

TRACKING THE BLADE

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

IMPORTANT: Before tracking the blade, be certain that the blade guides and blade support bearings do not touch the blade.

After applying tension to the blade, rotate the wheels slowly forward by hand and observe the blade's movement. The blade (A) Fig. 24 should travel just to the front of the center of the upper tire. If the blade creeps toward the front edge, loosen the wing nut (B) Fig. 25, and tighten the thumb screw (C). This will draw the blade toward the center of the tire. If the blade creeps toward the back edge, turn the thumb screw in the opposite direction. Adjust the thumb screw (C) Fig. 25 only a fraction of a turn each time. **NEVER TRACK THE BLADE WHILE THE MACHINE IS RUNNING.** After the blade is tracking just to the front of the center of both tires, tighten the wing nut (B) Fig. 25. Adjust the Blade Guides and Bearings.

VERTICAL ADJUSTMENT OF THE UPPER BLADE GUIDE ASSEMBLY

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

Set the upper blade guide assembly (A) Fig. 26 as close as possible to the top surface of the workpiece. Loosen the lock knob (B) and move the guide assembly (A) to the desired position.

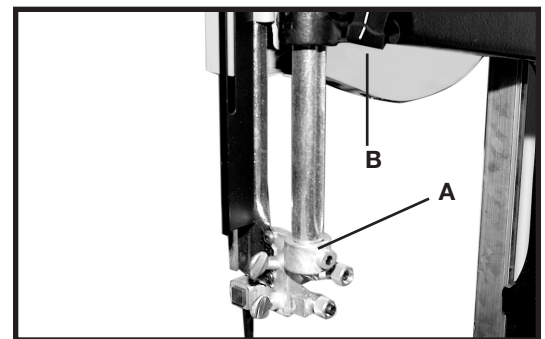


Fig. 26

ADJUSTING THE UPPER BLADE GUIDES AND BLADE SUPPORT BEARING

Adjust the upper blade guides and blade support bearings **ONLY AFTER** the blade has the correct tension and is tracking properly. To adjust:

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

1. Make sure that the bottom blade guides and support bearings do not touch the blade.
2. Check the upper blade guide assembly. The blade guides (A) Fig. 27 should be parallel to the blade. To adjust, loosen the screw (B) and rotate the complete guide assembly (C). When the blade guides are parallel with the blade, tighten the screw (B).

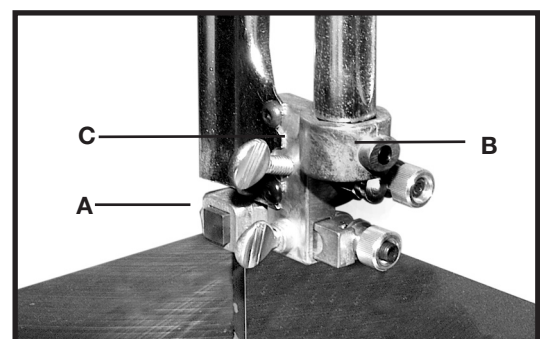


Fig. 27

- Adjust the guides (A) Fig. 28, 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 the thumb screw (C) Fig. 28 and turning the knurled knob (D) Fig. 28. When the guides (A) are set properly, tighten thumb screw (C).
- Two set screws (B) Fig. 28 hold the upper blade guides (A) in place. Loosen the set screws (B) to move the guides (A). Place them as close as possible to the side of the blade. (Be careful not to pinch the blade). Tighten the screws (B).
- When the blade guide wears to a point that it cannot be adjusted close to the blade, loosen screw (B) Fig. 28 and reverse the blade guides (A) Fig. 28.
- The upper blade support bearing (E) Fig. 28 prevents damage to the set in the saw teeth by keeping the blade from being pushed too far toward the back. The support bearing (E) should be set $1/64$ " behind the blade by loosening the thumb screw (F) and turning the knurled knob (G) to move the support bearing (E) in or out.
- Adjust the blade support bearing (E) so that 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. To change the position, remove the screw (H) and bearing (E) Fig. 28. Loosen the thumb screw (F), back out the knurled knob from the set screw. Remove the hex shaft from the hole, and rotate it to move the eccentric for the bearing.

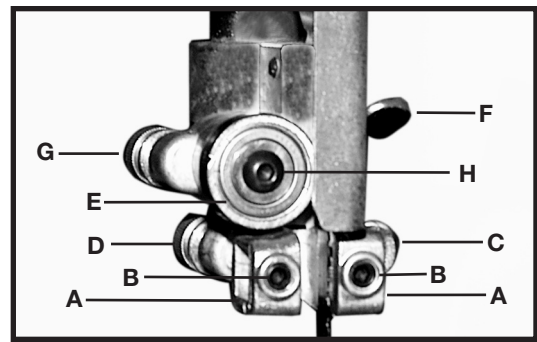


Fig. 28

ADJUSTING LOWER BLADE GUIDES AND BLADE SUPPORT BEARING

Adjust the lower blade guides and blade support bearing after the the upper guides and bearing have been adjusted.

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

- Adjust the front edge of the guide blocks (B) so that they are just behind the "gullets" of the saw teeth. Turn the knurled knob (C) Fig. 29 to make this adjustment. Check the support bearing. It should not be touching the back of the blade.
- Loosen the two screws (A) Fig. 29. Move the guides (B) as close as possible to the side of the blade, being careful not to pinch the blade. Tighten screws (A).
- Turn the other knurled knob (E) to adjust the lower blade support bearing (D) Fig. 29 so that it is about $1/64$ " behind the back of the blade.

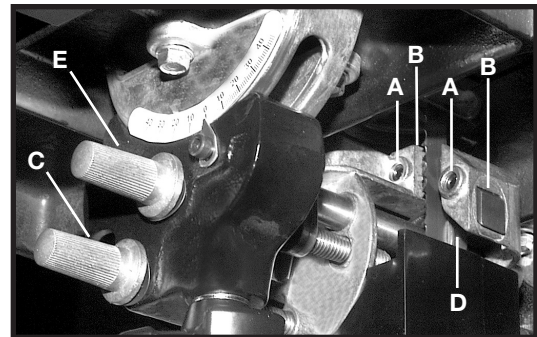


Fig. 29

CHANGING SPEEDS

An advantage of this machine is that it can be changed instantly from a slow-speed metal cutting band saw to a standard high-speed wood cutting band.

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

Be certain that the band saw is in the "off" position and the power is disconnected when changing from either metal-to-wood cutting or from wood-to-metal cutting.

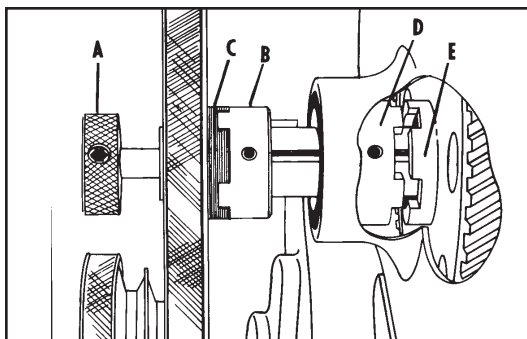


Fig. 30

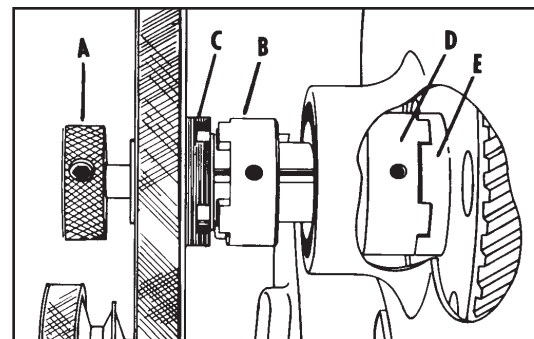


Fig. 31

When using the machine for wood cutting (3000 SFM), pull the shifter knob (A) Fig. 30 all the way out so that the lugs of the clutch (B) are engaged with the hub (C) of the drive pulley. This action will disengage the clutch (D) from the hub (E) of the gear that transmits power through the gear box. 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 action provides a direct drive from the motor pulley to the drive pulley, by-passing the gear box.

When using the machine for metal cutting (40, 60, 85, 115, 160, 220, and 335 SFM), push the shifter knob (A) Fig. 31 all the way in, disengaging the clutch (B) from the hub (C) of the pulley. An additional clutch (D) is located inside the band saw. It must be engaged with the hub (E) of the gear that transmits power through the gear box. When pushing in on the shifter knob (A) Fig. 31, rotate the lower wheel of the band saw to feel when the engagement occurs.

BELT AND PULLEY ARRANGEMENTS FOR ALL EIGHT AVAILABLE SPEEDS

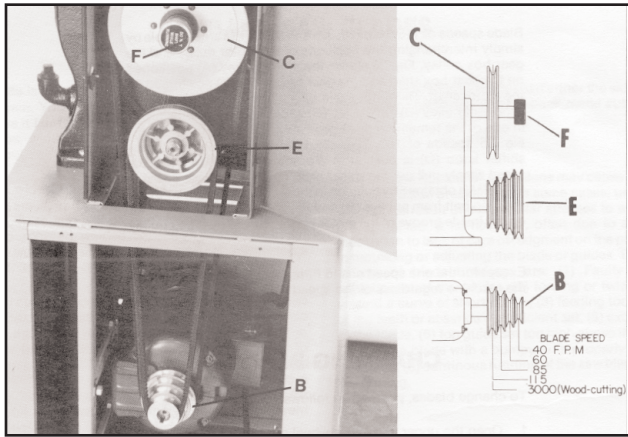


Fig. 32

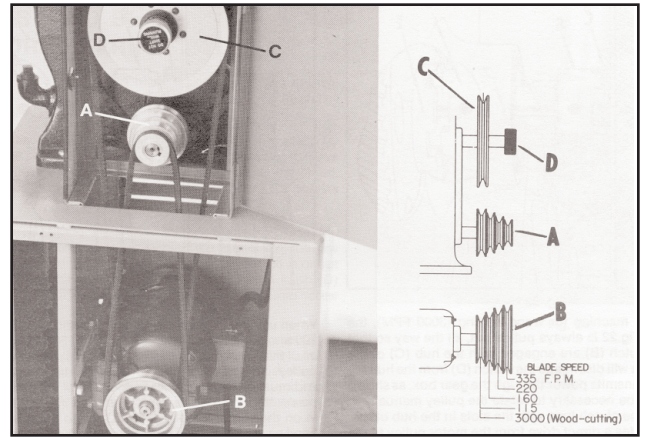


Fig. 33

With the longest belt on the inside groove of the motor pulley (B) Fig. 32 and on the drive pulley (C), and the small belt in 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 SFM are readily available. To obtain speeds of 40, 60, and 85 SFM, push the shifter knob (F) Fig. 32 all the way in, and position the small belt on one of the three outside grooves of the motor pulley (B) and the gear box pulley (E).

Blade speeds of 115, 160, 220, 335, and 3000 SFM are available by simply interchanging the positions of the motor pulley and the gear box pulley. Fig. 33 shows the motor pulley (A) positioned on the gear box shaft and the gear box pulley (B) positioned on the motor shaft. With the long belt positioned on the inside groove of the pulley (B) and the pulley (C), and the small belt positioned in one of the remaining three grooves of the pulleys (A) and (B) Fig. 33, speeds of 160, 220, and 335 SFM are obtained when the shifter knob (D) is pushed in.

To obtain a blade speed of 115 SFM, push in the shifter knob (D), remove the long belt from the pulleys (B) and (C), and place the small belt on the inside groove of the motor pulley (B) and the inside groove of the gear box pulley (A).

Except for the one speed of 115 SFM, both belts may be left on the machine, regardless of the blade speed.

TROUBLESHOOTING GUIDE

Even though a band saw is well-maintained, problems can occur. This troubleshooting guide can help you solve the more common problems:

Trouble: **SAW WILL NOT START.**

Probable Cause

1. Saw not plugged in.
2. Fuse blown or circuit breaker tripped.
3. Cord damaged.

Remedy

1. Plug in saw.
2. Replace fuse or reset circuit breaker.
3. Have cord replaced.

Trouble: **SAW WILL RUN, BUT BLADE WILL NOT TURN**

Probable Cause

1. Gearbox is disengaged.

1. Properly engage the shifter knob.

Trouble: **BREAKER KICKS OUT FREQUENTLY.**

Probable Cause

1. Extension cord too light or too long.
2. Feeding stock too fast.
3. Blade in poor condition (dull, warped, gummed).
4. Low voltage supply.

Remedy

1. Replace with adequate size cord.
2. Feed stock more slowly.
3. Clean or replace blade.
4. Contact an electrician.

Trouble: **BAND SAW VIBRATES EXCESSIVELY.**

Probable Cause

1. Machine not mounted securely to stand.
2. Stand on uneven surface.
3. Worn belt.
4. Pulley not aligned.
5. Motor not fastened securely.

Remedy

1. Tighten all mounting hardware.
2. Reposition on flat level surface.
3. Replace belt.
4. Adjust pulleys.
5. Tighten all mounting hardware.

Trouble: BAND SAW DOES NOT COME UP TO SPEED.

Probable Cause

1. Low voltage due to improper extension cord size.
2. Low voltage.

Remedy

1. Replace with adequate size cord.
2. Contact an electrician.

Trouble: BLADES BREAK.

Probable Cause

1. Blade not tensioned properly.
2. Blade guides improperly adjusted.
3. Blade support bearing improperly adjusted.
4. Blade wheel tracking adjustment improperly set.
5. Bad weld on blade.
6. Worn tires.
7. Forcing wide blade around short radius.
8. Dull blade or insufficient set.
9. Upper blade guide set too high.
10. Continuous running of machine when not actually cutting.

Remedy

1. Adjust blade tension.
2. Check and adjust blade guides.
3. Adjust blade support bearing.
4. Check and adjust blade tracking.
5. Replace the blade.
6. Replace tires.
7. Change to a narrower blade.
8. Replace blade.
9. Set upper blade guide within 1/8" of workpiece.
10. Turn off machine when not performing cutting operation.

Trouble: BLADE WILL NOT TRACK.

Probable Cause

1. Blade too loose
2. Upper wheel not properly adjusted.
3. Improperly adjusted blade support bearing.

Remedy

1. Adjust tension
2. Adjust upper wheel.
3. Adjust blade support bearing.

Trouble: CUT DOES NOT AGREE WITH SETTING ON THE TILT SCALE.

Probable Cause

1. Pointer out of adjustment

Remedy

1. Adjust pointer.

Trouble: BLADE WILL NOT STAY ON WHEEL.

Probable Cause

1. Blade not tensioned properly.
2. Blade guides improperly adjusted.
3. Blade support bearing improperly adjusted.
4. Blade wheel not tracking properly.
5. Bad weld on blade.
6. Worn tires.

Remedy

1. Adjust blade tension.
2. Check and adjust blade guides.
3. Adjust blade support bearing.
4. Check and adjust blade tracking.
5. Replace the blade.
6. Replace tires.

Trouble: BAND SAW MAKES UNSATISFACTORY CUTS.

Probable Cause

1. Blade not tensioned properly.
2. Blade guides improperly adjusted.
3. Blade support bearing improperly set.
4. Blade wheel not tracking properly.
5. Bad weld on blade.
6. Worn tires.
7. Incorrect blade for work being done.
8. Dull blade or insufficient set.
9. Upper blade guide set too high.
10. Adjustable speed set incorrectly.

Remedy

1. Adjust blade tension.
2. Check and adjust blade guides.
3. Adjust blade support bearing.
4. Check and adjust blade tracking.
5. Replace the blade.
6. Replace tires.
7. Change the blade.
8. Replace blade.
9. Set upper blade guide within 1/8" of work piece.
10. Check and adjust speed.

OPERATING THE BAND SAW

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

Before starting the machine, make all adjustments and put all guards in place. Turn the upper wheel clockwise by hand to be sure that everything is correct before providing power to the tool.

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

Keep the saw blade sharp and very little pressure will be required for average cutting.

Avoid twisting the blade by turning abrupt 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 repeated new kerfs are needed, then use either a narrower blade or one that has more set. The more set a blade has, the easier the stock is to turn. However, the cut is usually rougher than when using a medium set.

When withdrawing the blade, be careful not to draw the blade off of the wheels. In most cases, it is easier and safer to turn the workpiece and saw out through waste material. Do not back the blade out while the saw is running.

SUGGESTED METAL CUTTING BLADES AND SPEEDS

MATERIAL STEELS	UNDER 1/4"		1/ TO 3/4"		1 "AND UP	
	TEETH PER INCH	FPM	TEETH PER INCH	FPM	TEETH PER INCH	FPM
Angle Iron	24	160	14	160		
Armor Plate	18	40	14	40	10	40
Carbon Steel	24	85	14	60	14	40
Chromium Steel	24-18	85	14	60	14	40
Cold Rolled Steel	24-18	220	14	220	14	160
Drill Rod	14	85	14	60		
Graphite Steel	18	60	14	40	14	40
High speed Steel	24	85	14	60	14	40
Machinery Steel	18	160	14	160	14	160
Molybenium Steel	18	85	14	60	14	40
Nickel Steel	18	40	14	40	14	40
Silicon Manganese	18	85	14	85	14	60
Stainless Steel	24	40	14	40	10	40
Structural Steel	24	160	14	160	14	115
Tungsten Steel	18	40	14	40	10	40
FOUNDRY METALS						
Brass-hard and soft	18	335	14	335	10	335
Bronze - Aluminum	18	335	14	335	14	335
Bronze - Manganese	18	160	14	115	14	85
Bronze - Naval	18	160	14	115	14	85
Bronze - Phosphorus	18	335	14	335	14	220
Cast Iron - Gray	18	115	14	85	10	60
Cast Iron - Malleable	18	160	14	115	14	85
Cast Steel	18	160	14	115	14	85
Copper - Beryllium	18	160	14	85	10	40
Gunnite	24	335	18	220	14	160
Meehanite	18	160	14	115	10	85
Monet	18	115	14	85	10	60
Nickel - Cold Rolled	14	60	10	40	10	40
Nickel Silver	18	220	14	220	14	220
Silver	24	220	18	220	14	220
NON-METALS						
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 - Mettalic	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 SKIP TOOTH BLADES AND SPEEDS

MATERIAL STEELS	UNDER 1/2"		1/2" TO 2"		2" AND UP	
	TEETH PER INCH	FPM	TEETH PER INCH	FPM	TEETH PER INCH	FPM
Aluminum	3	3000	3	3000	3	3000
Asbestos	4	3000	4	3000	4	3000
Babbitt	4	3000	3	3000	3	3000
Brake Lining	6	3000	4	3000		
Carbon	4	3000	3	3000	3	3000
Copper - Drawn	6	3000	4	3000	4	3000
Duralumin	3	3000	3	3000	3	3000
Lead	6	3000	4	3000	4	3000
Magnesium	3	3000	3	3000	3	3000
Paper Board	6	3000	4	3000	4	3000
Rubber - Hard	6	3000	4	3000	4	3000
Zinc	6	3000	4	3000	4	3000
Plastics	See note		4	3000	4	3000
Builders Board	6	3000	4	3000	4	3000
Hardwoods	6	3000	4	3000	4	3000
Plywoods	6	3000	4	3000	4	3000
Softwoods	6	3000	4	3000	4	3000

NOTE: Some types of plastics lend themselves to more pronounced results with the regular saw blades. Sheets under 1/4" thickness and tubing under 1/4" wall thickness are not adapted to skip tooth blades.

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"

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 use it properly. Be sure you use blades of the proper thickness, width, and temper for the various types of material and cuts.

Always use the widest blade possible. Use narrow blades only for sawing small, abrupt curves and for fine, delicate work. This will save blades and will produce better cuts. For cutting wood and similar materials, Delta offers blades in widths of 1/8", 1/4", 3/8", and 1/2".

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 blades are subjected. Blades will break often due to avoidable causes, such as the lack of care to the blade or the blade not being properly adjusted to the band saw. 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 the work piece too fast into the blade.
- (4) dullness of the teeth, or absence of sufficient set.
- (5) improperly tensioned blade.
- (6) top guide set too high above the work piece being cut.
- (7) using a blade with a lumpy or improperly finished braze or weld.
- (8) continuous running of the saw blade when not cutting.

Use blades that are 93 1/2" in length on this machine.

Always use a sharp blade. Keep it free from gum and pitch. Clean frequently with a stiff fiber brush.

Narrow blades are used for cutting small circles or curves while the wider blades are best suited for straight cutting such as ripping.

A new blade, in most cases, will perform better and last longer than a re-sharpened blade.

Ensure that the blade guides are adjusted properly.

Do not force or twist the blade around a curve or a very short radius.

Feed the workpiece through the blade at a consistent rate, allow the blade to do the cutting – do not feed the work piece too fast.

Do not apply excessive tension to the blade. Set the tension only so that it drives the blade without slipping on the wheels. Narrow blades require less tension than wider blades.

CHANGING THE BLADES

⚠ WARNING DISCONNECT MACHINE FROM POWER SOURCE.

1. Open the upper and lower wheel guards.
2. Release tension on the saw blade.
3. Loosen the table alignment pin with a wrench and pull out. Remove table insert.
4. Take the blade off the wheel, and guide it through the slot in the table.
5. Install the new blade by reversing the procedure. Table alignment pin should be re-seated by gently tapping it with a hammer.

LUBRICATION

The gear case is filled at the factory with 1-1/2 quarts of oil. The case should be drained after 1500 to 2000 hours of operation and filled with a good grade of heavy adhesive gear oil. A pipe plug is located underneath the machine in line with the gear pulley. Remove this plug to drain the oil.

This machine is equipped with a 1/2" street elbow (B) Fig. 35 and a pipe plug (A). Remove the plug (A) to check the oil level and, when necessary, to add oil.

The sealed-for-life ball bearings on the wheels of the bandsaw and the blade supports require no lubrication.

NOTE: Keep all oils away from blade supports.

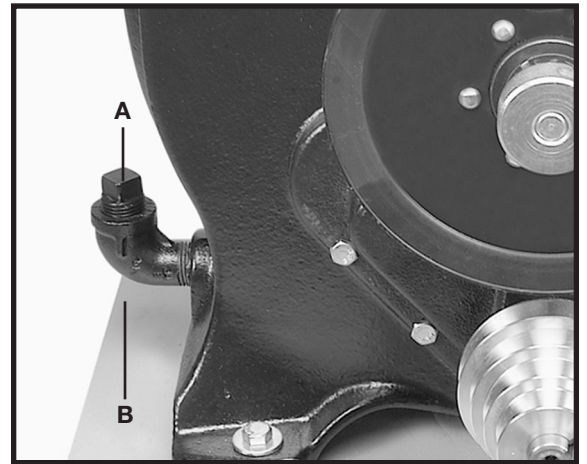


Fig. 35

ACCESSORIES

A complete line of accessories is available from your Delta Supplier, Porter-Cable • Delta Factory Service Centers, and Delta Authorized Service Stations. Please visit our Web Site www.deltamachinery.com for a catalog or for the name of your nearest supplier.

▲ WARNING Since accessories other than those offered by Delta have not been tested with this product, use of such accessories could be hazardous. For safest operation, only Delta recommended accessories should be used with this product.



PARTS, SERVICE OR WARRANTY ASSISTANCE

All Delta Machines and accessories are manufactured to high quality standards and are serviced by a network of Porter-Cable • Delta Factory Service Centers and Delta Authorized Service Stations. To obtain additional information regarding your Delta quality product or to obtain parts, service, warranty assistance, or the location of the nearest service outlet, please call 1-800-223-7278 (In Canada call 1-800-463-3582).



Two Year Limited New Product Warranty

Delta will repair or replace, at its expense and at its option, any new Delta machine, machine part, or machine accessory which in normal use has proven to be defective in workmanship or material, provided that the customer returns the product prepaid to a Delta factory service center or authorized service station with proof of purchase of the product within two years and provides Delta with reasonable opportunity to verify the alleged defect by inspection. For all refurbished Delta product, the warranty period is 180 days. Delta may require that electric motors be returned prepaid to a motor manufacturer's authorized station for inspection and repair or replacement. Delta will not be responsible for any asserted defect which has resulted from normal wear, misuse, abuse or repair or alteration made or specifically authorized by anyone other than an authorized Delta service facility or representative. Under no circumstances will Delta be liable for incidental or consequential damages resulting from defective products. This warranty is Delta's sole warranty and sets forth the customer's exclusive remedy, with respect to defective products; all other warranties, express or implied, whether of merchantability, fitness for purpose, or otherwise, are expressly disclaimed by Delta.

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Parts and Repair Service for Porter-Cable • Delta Machinery are Available at These Locations
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