Delta 5” x 6” Horizontal Bandsaw

<table>
<thead>
<tr>
<th>Description</th>
<th>Horizontal Bandsaw – Model: 20-330</th>
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<tbody>
<tr>
<td>Size / Horse power</td>
<td>5” x 6” / 1/3 HP / 235 FPM</td>
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<tr>
<td>Power source</td>
<td>115 Volts</td>
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<tr>
<td>Uses</td>
<td>Cutting metal stock</td>
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**Safety Precautions**

**Hazards**
- Flying debris (potential eye damage)
- Electrical shock
- Amputation
- Entanglement of hair or clothing

**Training**
- Shop Safety Fundamentals
- Site Specific Training

**Protective Equipment**
- Safety glasses
- Hearing protection
- Avoid loose fitting clothing
- Tie back long hair

**Operation**

**Startup**
1. Put on PPE listed above
2. Ensure work area is clean and free of obstacles
3. Clamp the workpiece in the vise
4. Start the by moving the switch to the “UP” position (Saw must be in the “UP” position)
5. Slowly set the saw down onto the workpiece and adjust cutting speed with the feed control knob
6. Do not drop the saw head or force the cut, the weight of the saw head will provide the cutting force

**Shutdown**
1. The saw will automatically shut off at the end of the cut, moving the switch to the “DOWN” position to turn off the power
2. Allow the blade to come to a complete stop on its own
3. Remove work piece for table top

**Adjusting Feed Rate**
1. **Disconnect the saw from the power source**
2. Turn the control arm (A) counterclockwise to increase feed rate and clockwise to decrease feed rate
3. Do not turn the control arm more than one turn at a time
Changing Blades - **Performed By Authorized Personnel ONLY**
1. Disconnect the saw from the power source
2. Raise the saw arm to the vertical position and open the blade wheel cover (A)
3. Release blade tension by turning blade tension hand knob (B)
4. Remove the two finger guards (C)
5. Carefully slip blade (D) off both wheels (E), and guide assemblies (F)
6. Place the new blade between each of the blade guide bearings (F) and around both wheels (E). The teeth must be pointing down on the right hand side, as shown
7. Replace finger guards (C) and adjust blade tension by turning hand knob (B)
8. Close the blade wheel cover (A)

Blade Tracking Adjustment - **Performed By Authorized Personnel ONLY**
1. Refer to the Owner’s Manual

Changing Belt Speeds and Belt Tension - **Performed By Authorized Personnel ONLY**
1. Disconnect the saw from the power source
2. Loosen lock nut (C) and turn adjusting screw (D) counterclockwise to release tension on the belts
3. Open the belt and pulley guard cover
4. Refer to the speed chart to determine belt placement
5. Turn the adjusting screw (D) clockwise to put tension on the belt, proper tension is met when a 1/4" deflection of the belt when pressure is applied
6. Close belt and pulley guard cover

Adjusting Blade Tension
1. Disconnect the saw from the power source
2. Turn blade tension handwheel (A) clockwise to increase or counterclockwise to decrease blade tension
3. Correct tension is obtained when the blade is tight enough that no slippage occurs
4. When the machine is not in use, release the blade tension

Maintenance

<table>
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<tr>
<th>Storage</th>
<th>Care</th>
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<tr>
<td>Clean off saw after you are done using. Always use a sharp blade.</td>
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<tr>
<td>• Coat machined surfaces with machine oil, reapply every 6 months</td>
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<td>• Clean chip sludge from coolant tank</td>
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| Accessories | Work Stop |