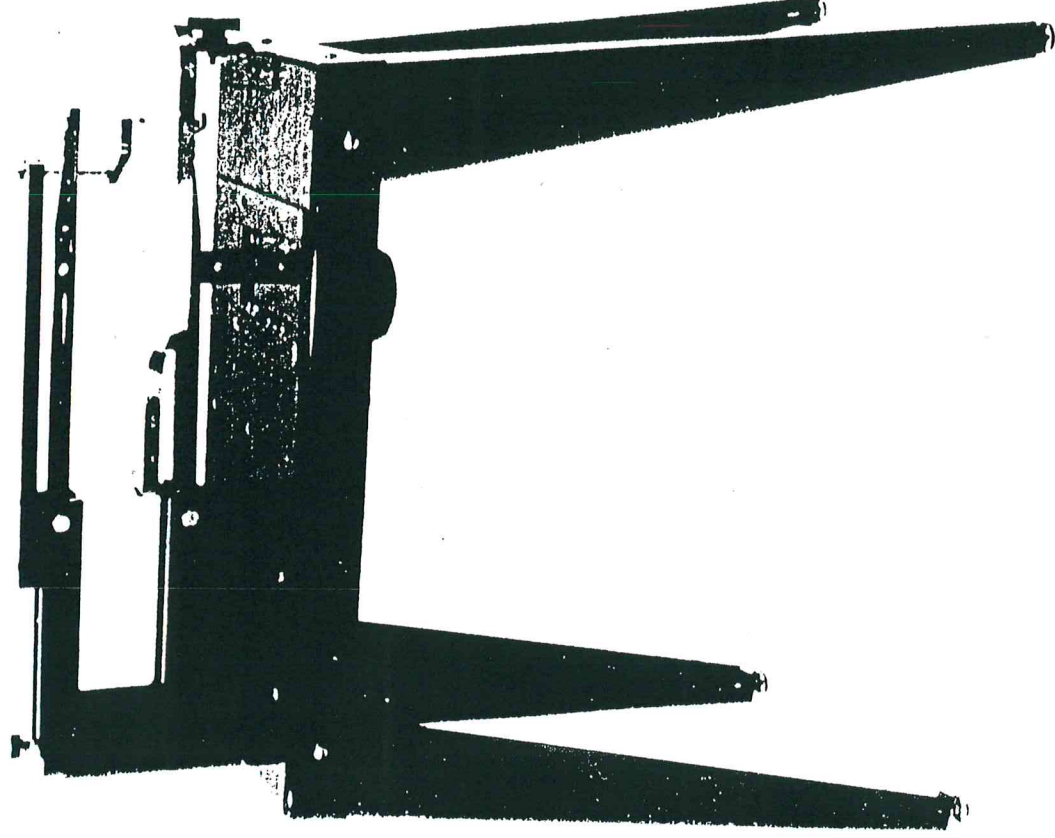




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MODEL 2526 VARIABLE SPEED PRECISION SCROLL SAW OPERATORS MANUAL



PATENT PENDING



**READ THOROUGHLY BEFORE
OPERATING**



MANUAL CD-1284

SPECIFICATIONS

LENGTH LESS LEGS: 34 $\frac{1}{4}$ "	THROAT: 26"
WIDTH LESS LEGS: 16 $\frac{1}{2}$ "	MAX. CUTTING DEPTH: 2 $\frac{1}{2}$ "
LENGTH LET AT BOTTOM: 41"	STROKE LG.: 1 $\frac{1}{16}$ "
WIDTH LEG AT BOTTOM: 24"	STROKES/MIN: 0-1650
HEIGHT WITH LEGS: 45"	TABLE ADJ.: 0° - 45° RIGHT OR LEFT
TABLE HEIGHT WITH LEGS: 29.25"	DIRECT DRIVE VARIABLE
WEIGHT: SAW & STAND - 105 #	SPEED: $\frac{1}{8}$ HP teFc D.C. MOTOR

SET-UP INSTRUCTIONS

All parts required for assembly are supplied by us.

SAW CARTON:

Note: Damages or shorted parts are to be reported to the transportation carrier. Manufacturer is not responsible for shipping damage.	A. Saw 1
	B. Operators Manual.....1
	C. Legs 4

SAW BLADE INSTALLATION

INSTALLATION IN THE BLADE HOLDERS

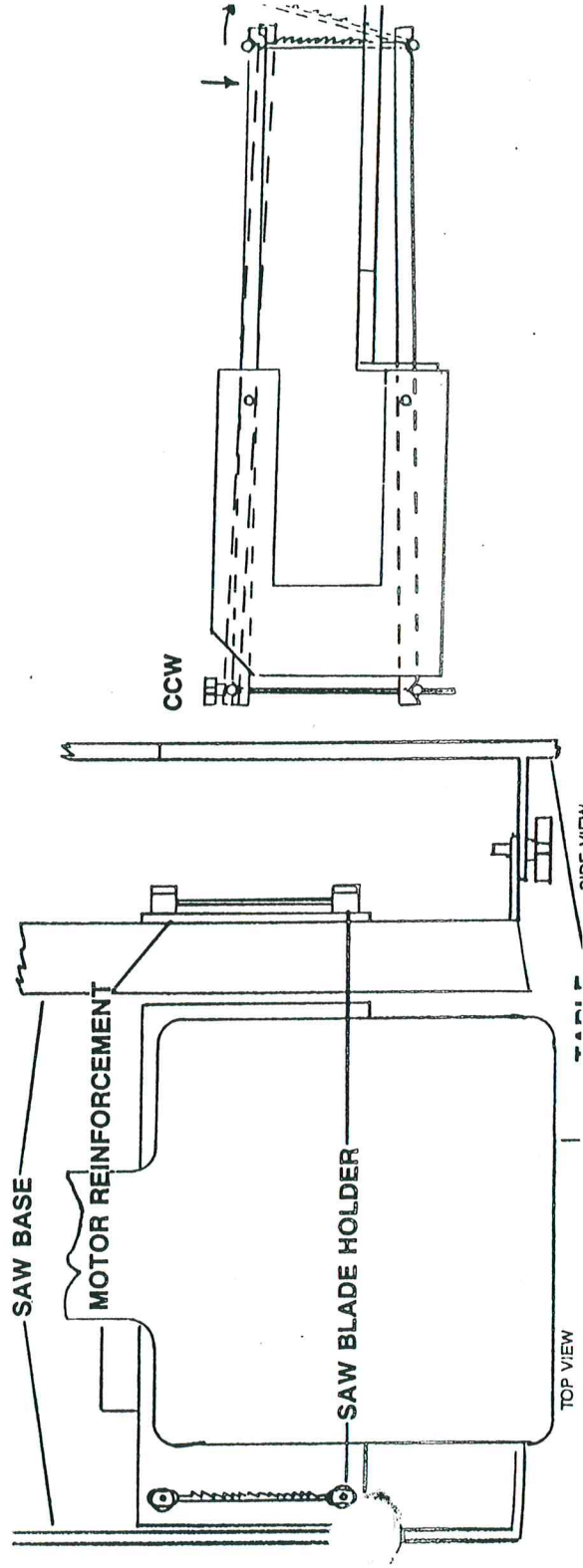
Place one end of the blade holder set in the one of the slots, located to the left of the table, on the base reinforcement plate. (See Figure.)

Slide the blade between the two halves of the holder and secure, using a $\frac{5}{16}$ " open end wrench. (See Figure) Repeat for the other end of the blade.

INSTALLATION IN THE SAW

Slide the bottom blade holder with the saw blade

installed (teeth pointed down) back through the slot in the table and lower arm until the blade rests in the V-groove on the bottom side of the lower arm. (See Figure) Loosen the rear tensioning knob to allow the top arm to pivot down and the top blade holder to slide in the slot in the top arm and allow the holder to rest in the V-groove of the top arm. (See Figure) Adjust the rear tensioning knob to apply tension to the saw blade. The proper tension is obtained when the blade sounds like a guitar string when plucked.



SCROLL / FRET SAW BLADES

R.B.I. NO.	MATERIAL CUT / USAGE	WIDTH	THICKNESS	TPI
2/0	For extremely intricate sawing. Very thin cuts in 1/16" to 3/32" materials. Excellent for cutting wood veneer, plastics, hard rubber, pearl. Very good finish with fast cutting. Excellent for tight radius cuts.	.022"	.010"	27
2	For tight radius work in thin materials 3/32" to 1/8" wood veneer, wood, bone, fiber, ivory, plastic. Good finish, fast cutting tight radius.	.029"	.012"	20
5	For close radius cutting in materials 1/8" or thicker. Great for sawing hard/soft wood, bone, horn, plastics. Good general purpose cutting with a medium finish.	.037"	.015"	16
7	Popular sizes for cutting hard and soft woods 3/16" up to 2". Also cut plastic, paper, felt, bone. Medium finish may require some sanding.	.043"	.016"	14
9		.053"	.018"	12
420-R	For smooth splinter-free finish on top and bottom sides. Excellent for hard/soft wood, Plywood with thickness of 1/4" or more Fast cutting.	.100"	.022"	9 with 3 reverse teeth

SELECTING THE CORRECT BLADE

Basic rules to follow:

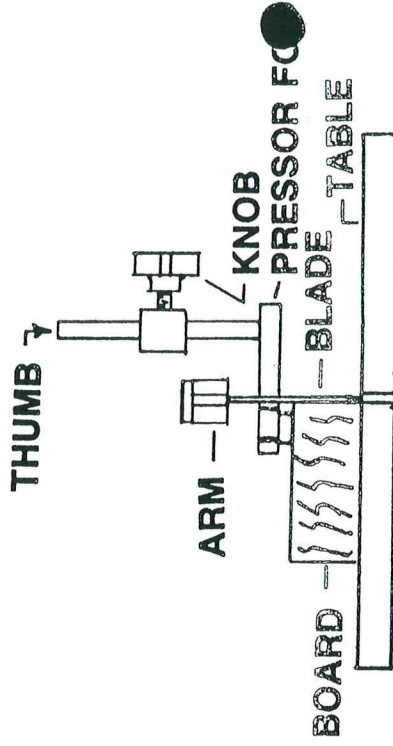
Have at least 2 teeth in the material at all times. For Example: 1/8" thick wood will be cut best with a blade having at least 16 teeth per inch. More teeth per inch will cut slower but provide a smoother, finer finish that will

require virtually no sanding.

Use narrower blades for intricate or tight radius (scroll) cutting and wider blades for straight and large contour cutting.

ADJUSTING THE BOARD HOLDDOWN

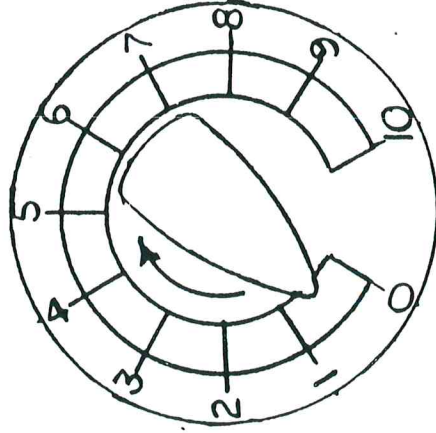
Place the board to be sawn at the left of the saw blade. Loosen the holddown tightening knob on the holddown arm and swing the pressor foot around until it is within 1/8" of the saw blade and the plastic foot, on the bottom, is resting on the board. Grasp the holddown arm with the left hand; with the thumb push down on the pressor foot rod and tighten the adjusting knob. This will give a slight down pressure on the board as it is fed under the pressor foot. NOTE: (Check the clearance of the arm to make sure it doesn't hit the pressor foot. Approximately 1 3/4" board thickness maximum using the holddown. If board thickness is greater than 1 3/4" the board must be held down by hand.)



VARIABLE SPEED ADJUSTMENT

The on-off switch is used to supply power to the machine and must be used to turn the machine off. The variable speed dial is used to adjust the speed of cutting from 0 to 1650 R.P.M.

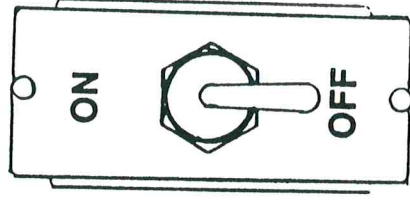
The lower numbers on the dial, 0 - 5, are used for sawing very thin ($1/16$ " or thinner) woods; thin metals by themselves or applied to wood. The upper numbers of the scale, 5 - 10, are used for general wood sawing. The faster the



FASTER



REMOVAL



FUSE REMOVAL & ELECTRICAL CHECKING

There are two fuses located between the variable speed dial and the on-off switch. The upper fuse is the line fuse (ABC-6A). The lower fuse is the armature fuse MDA-11 $\frac{1}{4}$. If your machine does not operate with the on-off switch in the on position and the variable speed knob in the fast

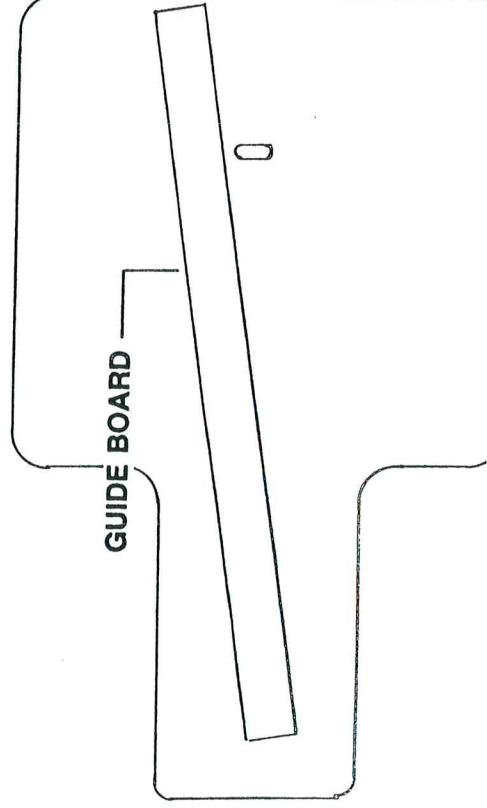
position, check the power to the plug in. If everything else checks O.K., check the fuses. If one is blown, replace it. If it blows again, have the electrical checked by an electrician. (Wiring diagram on the back of the electrical box cover and in the parts breakdown of the operators manual.)

SAWING

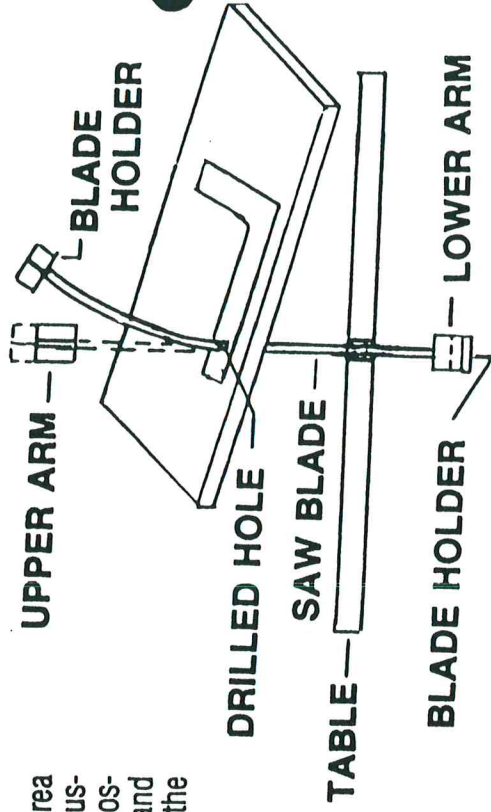
Feed the material to be cut slowly into the saw blade. Maintain downward pressure (this may be done by hand or by the holddown foot provided) on the material as you guide it along the table surface. **NOTE:** Always keep hands away from the saw blade and out from under the arm.

SAWING BOARDS STRAIGHT USING A GUIDE BOARD

To saw a straight line, it is necessary to angle the guide board approximately 4° from right to left. (See drawing) This is necessary due to the manufacture of all scroll saw blades.



To saw inside cuts, drill a hole in the board, in the area to be cut out, slightly larger than the blade you are using. Remove the blade from the saw upper arm and loosen the blade holder. Slide the blade through the hole and reinstall the blade holder. Install the blade holder in the upper arm and tension.



MAINTENANCE

ARM PIVOT

Add 3 to 4 drops of oil (light machine oil) to each side of the parallel arm pivot point bushings both upper and lower arm.

TABLE

Keep the table work surface waxed to prevent rust

and allow easier movement of the wood on the table surface.

TENSIONING ROD

Add 1 or 2 drops of oil (light machine oil) to the threads of the blade tensioning rod at the bottom arm.

TROUBLE SHOOTING

Saw does not saw straight

Consider using a guide board to saw straight lines

Saw picks up the board on the up stroke.

1. Check blade installation for teeth pointing down
2. Not feeding the blade straight
3. Pushing sideways on the blade

Excessive blade breakage

1. Pushing sideways on the blade causing it to bind
2. Wrong size blade for the size of wood
3. Using a wood blade to saw metal
4. Excess tension, consult blade tensioning
5. Not enough tension, consult blade tensioning

Saw running too fast or too slow

1. Adjust the variable speed knob to obtain the proper R.P.M. 0 - 1650

Radius of the turn is too large

1. Using too large of blade to cut the smaller radius

Saw does not operate when the on-off switch is turned on

1. Variable speed control is in the lowest setting.
2. Fuse blown (2) check & replace if required

Saw doesn't set level

1. Adjust the glides on the bottom of the legs to level

Saw table not high enough

1. Purchase optional 6" leg extensions and install. Adjustable in 2" increments

