



WALKER-TURNER 14" METAL CUTTING BAND SAW

All Walker-Turner Band Saws are carefully inspected during manufacture and tested when final assembly is completed. It is quite possible, however, for the machines to get out of alignment while in transit. For this reason the machine should be carefully checked and adjusted, if needed, before putting the machine into operation. A carefully set-up machine will give far superior results to one that is carelessly set up.

The band saw blade should "track" on the center of the rims of both upper and lower wheels. It should run with enough tension to hold this position and to remain rigid when pressure is applied to it.

To check blade alignment or when replacing a blade the following procedure should be followed. Loosen the guide blocks in both blade guides and move them away from the blade. Loosen guide roller and slide it as far back as it will go. Turn machine by hand and note tracking position of blade. (Turn machine so that blade travels down through the table, as it does under actual working conditions.)

The blade will not track unless tension is sufficient to make the blade taut. Handwheel No. 1 in the photograph at the right controls the blade tension by moving the upper wheel assembly up or down as required. Handwheel No. 2 controls blade alignment by tilting the upper edge of the wheel in, causing the blade to run toward the back of the rim; turning the wheel to left has the opposite effect. When aligning the blade turn wheel No. 2 slowly as it is extremely sensitive.

Narrow blades require more tension and accurate aligning than wide blades. With a little experience in changing blades the operator will soon become familiar with the adjustments required and the correct tension to apply to the blade.

When replacing blades the table clip, which will be found underneath the table edge at the end of the saw slot, must be removed in order to get the blade free. Be sure to replace the clip as it is necessary to keep the table true.

The geared speed reducer built into this band saw is a precision unit and should be treated as such. The gear lever has two positions, one of which brings into action the gear train, this position marked "IN" on the gear housing. The other position is marked "OUT" and the lever in this position will disengage the gear train.

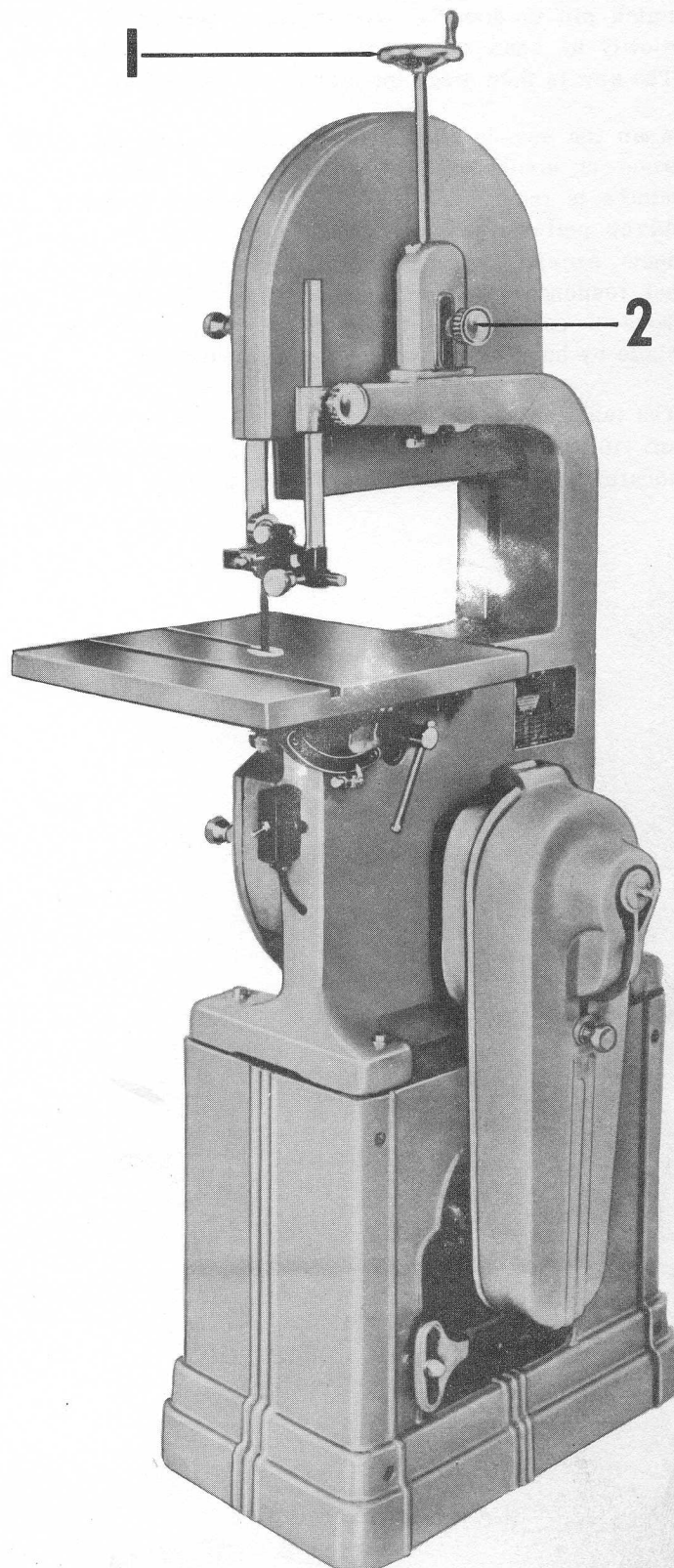


Figure 1

Removing the knurled nut and swinging back the belt guard will expose the belt, motor pulley and driven pulley. The spring plunger on the face of the driven pulley must be in coordination with the gear lever. **When the gear lever is in the "IN" position the spring plunger must be withdrawn until the catch pin can be turned out of the slot in which it fits. If the plunger is not withdrawn serious damage may result to the gears or other parts of the speed reducer.** With the gear lever in the "OUT" position the plunger should be turned until the catch pin is directly over its slot, turning the pulley slowly by hand will permit the pin to drop into place. The saw is then ready for high speed operation.

When the saw is used for high speed work, for cutting wood or similar materials, a speed of 3000 feet per minute is recommended. The two smaller steps of the driven pulley should not be used without the gear reducer except for special work. If the gear lever does not respond to normal pressure DO NOT force it, but move it easily back and forth or else move the saw blade by hand to assist the gears in meshing.

The table on this machine can be tilted 45° to the right and 10° to the left. Check table position with a tri-square resting on the table with the blade of the square

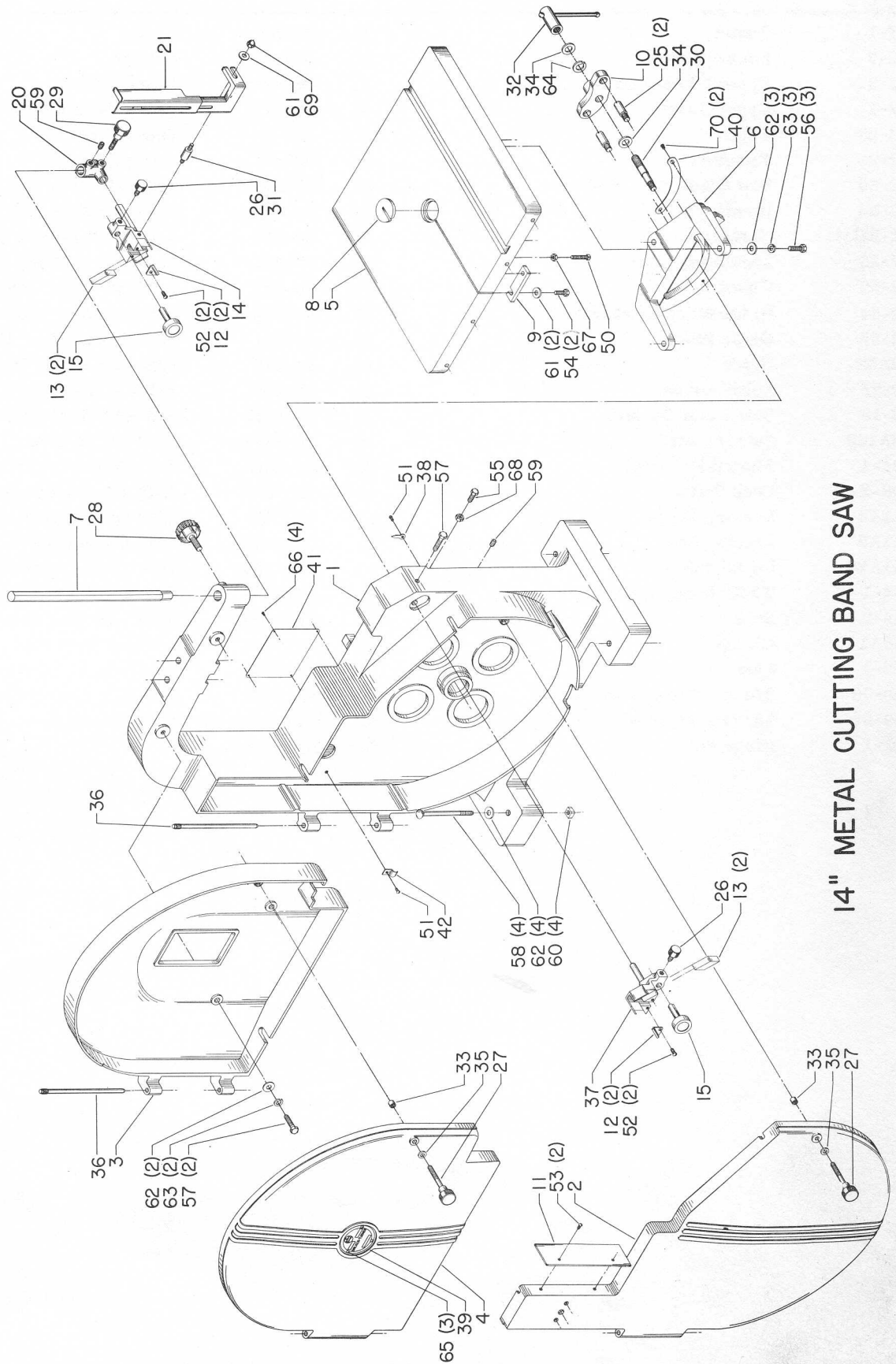
held against the side of the saw blade behind the teeth. Corrections can be made if necessary by moving the indicator point or the graduated scale. Having definitely checked the 90° position, adjust the stop screw under the table if necessary. A second stop at the 45° position should also be checked and set. To tilt the table to the left remove the knurled head which will be found on the 90° stop.

The Belt Guard 32C25 can be used in conjunction with either the vertical or horizontal belt drive set-up.

LUBRICATION

The gear housing has been packed with adhesive pressure grease at the factory. After one year of operation, remove the gear housing cover, clean out the old grease and repack with one pint of adhesive pressure grease. When lubrication of the upper wheel is required, remove the oil cap screw (105) Fig. 3 and the beveled washer (119). Apply grease through hole in shaft. Oil cup (95) is for lubrication of the lower pulley and drive gear. Light machine oil should be applied to all moving parts to keep them operating freely.

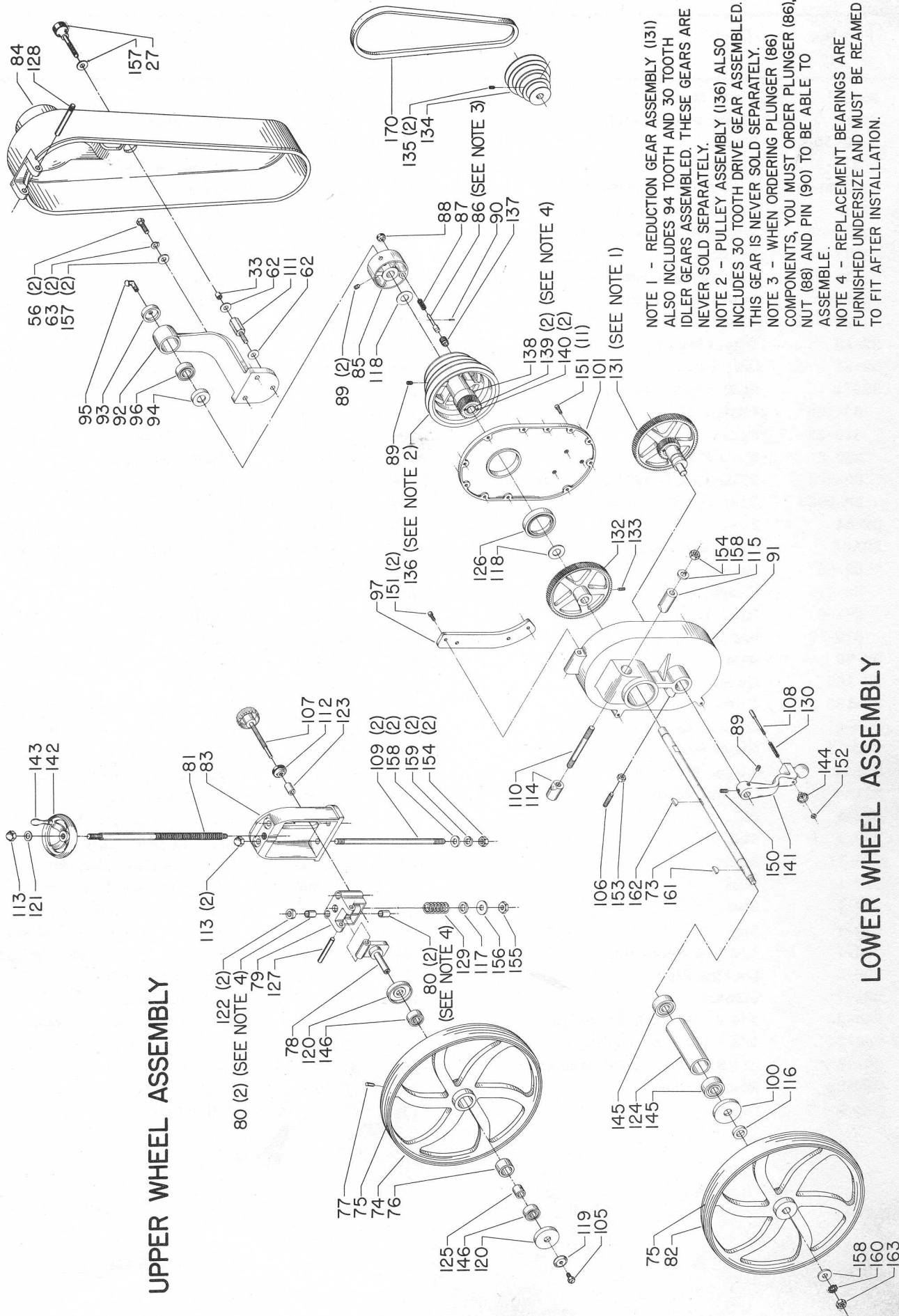
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Replacement Parts (Fig.2)

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	32-1	Frame	37	292A3	Guide
2	32-2	Lower Guard	38	321-8	Pointer
3	32-3	Upper Wheel Housing	39	380-7-2	Name Plate
4	32-4	Upper Guard	40	381-1	Table Tilting Gage
5	32-28	Table	41	382-1	Speed Chart
6	32-29	Trunnion	42	396-81	Cable Clip
7	32-30	Saw Guide Adj. Post	50	SP-303	5/16-18 x 1 1/4" Sq. Hd. Set Scr.
8	32-31	Insert	51	SP-552	#10-32 x 5/16" Rd. Hd. Scr.
9	32-32	Clamp	52	SP-559	#10-32 x 1/2" Rd. Hd. Scr.
10	32-50	Locking Bracket	53	SP-561	#10-32 x 3/8" Rd. Hd. Scr.
11	32-52	Guard	54	SP-607	5/16-18 x 3/4" Hex. Hd. Scr.
12	32-54	Guide Block Retainer	55	SP-640	3/8-16 x 3/4" Hex. Hd. Scr.
13	32-55	Guide Block	56	SP-642	3/8-16 x 1" Hex. Hd. Scr.
14	32A58	Guide	57	SP-648	3/8-16 x 1 1/4" Hex. Hd. Scr.
15	32-75	Roller Guide	58	SP-890	3/8 x 4" Carriage Bolt
20	33-18	Saw Guide Backing	59	SP-1111	3/8-16 x 3/8" Soc. Hd. Set Scr.
21	33A109	Safety Guard	60	SP-1307	3/8"-16 Sq. Nut
25	201-1	Slotted Hd. Screw	61	SP-1605	3/8 x 7/8 x 1/16" Washer
26	206-2	Lock Screw	62	SP-1606	7/16 x 1 x 5/64" Washer
27	211A4	Locking Screw	63	SP-1704	3/8" Lockwasher
28	211A6	Locking Stud	64	SP-2063	5/8" Lockwasher
29	211A28	Locking Stud	65	SP-2250	#4 x 3/16" Drive Screw
30	214-1	Table Locking Stud	66	SP-2252	#2 x 3/16" Drive Screw
31	214-2	Stud	67	SP-5435	5/16"-18 Hex. Jam Nut
32	216A1	Clamp	68	SP-5900	3/8"-16 Hex. Nut
33	222-1	Stop	69	SP-5903	5/16"-18 Acorn Nut
34	240-70	3/4 x 1 1/2 x 1/16" Washer	70	SP-7529	#10-32 x 1/4" Truss Hd. Screw
35	240-81	25/64 x 11/16 x 3/32" Washer	*	Cat. #424-24	Band Saw Blade
36	291-1	Hinge Pin	*	Not Shown	



UPPER WHEEL ASSEMBLY

LOWER WHEEL ASSEMBLY

NOTE 1 - REDUCTION GEAR ASSEMBLY (131) ALSO INCLUDES 94 TOOTH AND 30 TOOTH IDLER GEARS ASSEMBLED. THESE GEARS ARE NEVER SOLD SEPARATELY.

NOTE 2 - PULLEY ASSEMBLY (136) ALSO INCLUDES 30 TOOTH DRIVE GEAR ASSEMBLED. THIS GEAR IS NEVER SOLD SEPARATELY.

NOTE 3 - WHEN ORDERING PLUNGER (86) COMPONENTS, YOU MUST ORDER PLUNGER (86), NUT (88) AND PIN (90) TO BE ABLE TO ASSEMBLE.

NOTE 4 - REPLACEMENT BEARINGS ARE FURNISHED UNDERSIZE AND MUST BE REAMED TO FIT AFTER INSTALLATION.

Replacement Parts (Fig.3)

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
73	32-6	Drive Shaft	121	244-2	Key Washer
74	32M7	Upper Wheel, Incl;	122	246-1	Felt Washer
75	32-15	Tire	123	250-1	Spacer
76	251-7	Spacer	124	251-5	Bearing Spacer
77	SP-6868	3/16 x 1/2" Groove Pin	125	252-3	Spacer
78	32A9	Idler Shaft Bracket	126	270-6	Grease Retaining Washer
79	32C10-2	Wheel Adj. Bracket, Incl;	127	290-4	Pin
80	377-9	Bearing	128	291-2	Bracket Pin
81	32-11	Raising and Lowering Screw	129	310-1	Spring
82	32M13	Lower Wheel, Incl;	130	310-21	Spring
75	32-15	Tire	131	330C11	Reduction Gear
83	32-19	Wheel Bracket	132	330A13	Reduction Drive Gear, Incl;
84	32-24	Belt Guard	133	SP-202	1/4-20 x 1/2" Soc. Hd. Set Scr.
85	32A60	Pulley Hub, Incl;	134	344A8	Pulley, Incl.
86	33-105	Plunger Pin	135	SP-232	1/4-20 x 3/8" Soc. Hd. Set Scr.
87	310-22	Spring	136	344A27	Pulley, Incl;
88	360-6	Hand Knob	137	252-14	Plunger Bushing
89	SP-206	5/16-18 x 5/16" Soc. Hd. Set Scr.	138	252-15	Drive Gear Spacer
90	SP-5033	3/32 x 3/8" Groove Pin	139	377-16	Bearing
91	32-64	Box	89	SP-206	5/16-18 x 5/16" Soc. Hd. Set Scr.
92	32A65	Drive Shaft Bracket, Incl;	140	SP-208	1/4-20 x 1/4" Soc. Hd. Set Scr.
93	32-66	Cover	141	362-6	Gear Shift Lever
94	32-67	Cover	142	363A3-4	Handwheel, Incl;
95	271-9	Oil Cup	143	364-1	Handle
96	370-12	Bearing	144	365-18	Knob
97	32-70	Stop	145	370-8-1	Bearing
100	33-107	Cover	146	370-22-2	Bearing
101	33-133	Cover	89	SP-206	5/16-18 x 5/16" Soc. Hd. Set Scr.
105	200-11	Oil Cap Screw	150	SP-217	5/16-18 x 1/2" Soc. Hd. Set Scr.
106	202-10	Guide Screw	56	SP-642	3/8-16 x 1" Hex. Hd. Scr.
107	211A2	Align. Screw	151	SP-715	1/4-20 x 1/2" Fil. Hd. Scr.
27	211A4	Locking Screw	152	SP-1203	#10-32 Hex. Nut
108	212-13	Pin	153	SP-1270	3/8"-24 Hex. Jam Nut
109	213-1	Stud	154	SP-1282	1/2"-13 Hex. Nut
110	213-11	Stud	155	SP-1366	7/16"-24 Hex. Jam Nut
111	217-1	Stud	62	SP-1606	7/16 x 1 x 5/64" Washer
33	222-1	Stop	156	SP-1607	1/2 x 1 1/4 x 5/64" Washer
112	223-1	Stop	157	SP-1615	13/32 x 13/16 x 1/16" Washer
113	226-7	1/2"-24 Acorn Nut	158	SP-1636	17/32 x 1 1/16 x .095" Washer
114	230-5	Locking Plug	63	SP-1704	3/8" Lockwasher
115	231-7	Sleeve	159	SP-1705	1/2" Lockwasher
116	240-30	3/4 x 1 1/4 x 1/4" Spacer	160	SP-1755	1/2" Ext. Tooth Lockwasher
117	240-74	5/8 x 1 x 1/8" Washer	161	SP-2613	#7 Woodruff Key
118	241-4	3/4 x 1 1/2 x 1/16" Washer	162	SP-2697	#8 Woodruff Key
119	242-22	Bevel Washer	163	SP-9102	1/2"-24 Hex. Jam Nut
120	243-1	Cover	170	Cat. #49-142	Pulley Belt