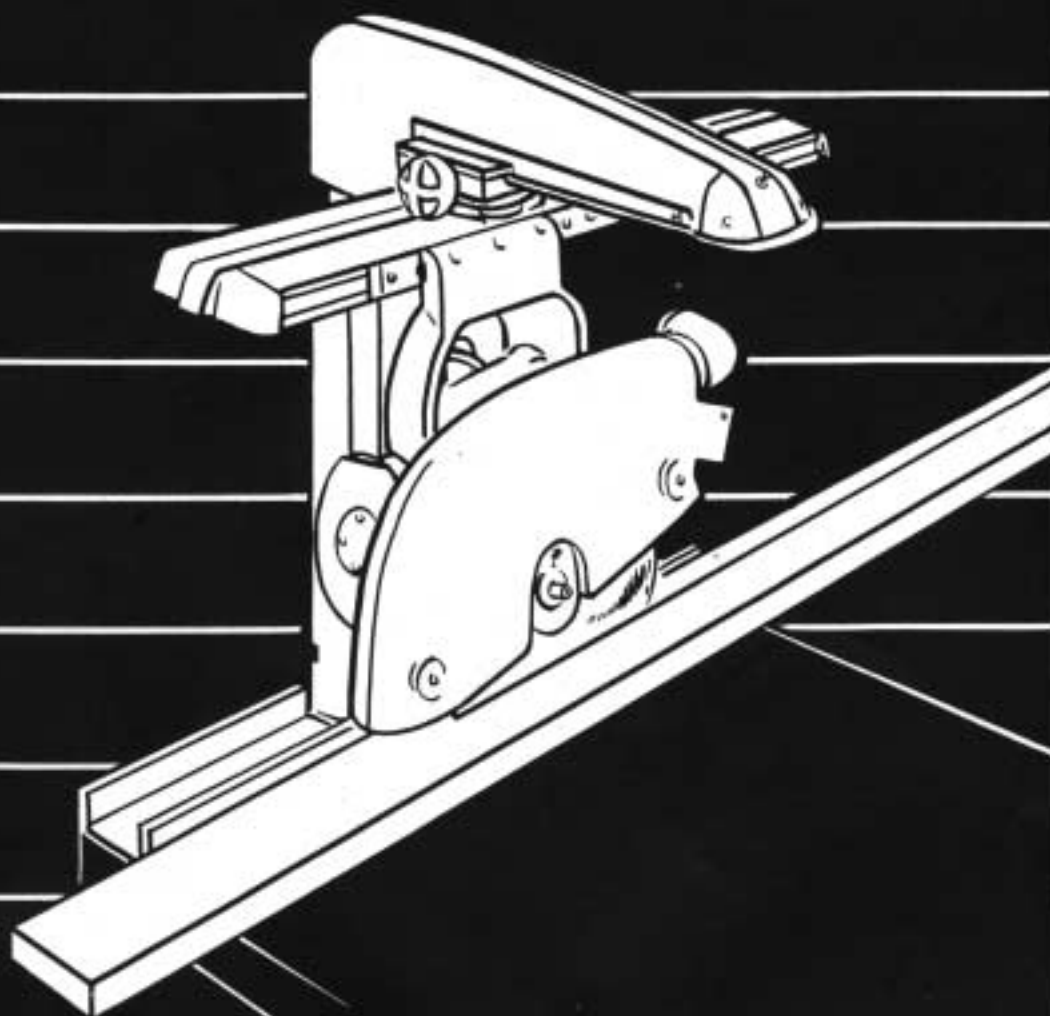


★ ★ ★ *Operating Instructions*

FOR RIPPING WITH

MULTIPLEX **RADIAL ARM SAW**



Red Star Products Inc.

3455 VEGA AVENUE
CLEVELAND 13, OHIO

THE following instructions are for the purpose of enabling the operator to set up and operate the machine correctly for ripping operations. Certain other information regarding the use and maintenance of overload protecting devices have also been included.

Rip blades should be used whenever any appreciable amount of this type of work is contemplated.

Using the correct blade for the job can increase the speed of cutting as much as 100% and its importance must therefore be emphasized.

Blades must be kept in good condition and should be filed after every 4 hours use. This of course varies considerably with the type of usage and can only be given as a guide to proper maintenance.

It is further recommended that the diameter of rip blade used be kept to the minimum diameter which will allow clearance over the work.

Best results are obtained using coarse tooth blades unless the surface quality of the cut is extremely important. From 16 to 20 teeth on a 10" diameter blade and from 18 to 24 teeth on a 12" diameter blade has proved most satisfactory for use on 2" material.


There are three important points to remember when using a machine for ripping:

1. Be sure machine is set properly and in conformance with these instructions.
2. Use the proper type of blade for the job.
3. Feed the work evenly and at a rate such as will not overload the motor.

The following general procedure should be followed:

1. Clamp the cutting head securely in its central position on the track.
2. Rotate track to within approximately $\frac{1}{2}^\circ$ of the 90° mark on the miter scale so as to obtain "lead" as illustrated in Figure 1.
3. Lock track securely in this position.
4. Check setting of blade according to check block method outlined in Fig. 2, Fig. 3, and Fig. 4.
5. Adjust guard so as to barely clear the work as noted in Fig. 5.
6. Set width of rip desired by moving track along the arm or by moving the table depending upon the model of Multiplex.
7. Lock track to arm or lock table in position depending on adjustment means used in (6) above.

Caution: ALWAYS FOLLOW THE INSTRUCTIONS ON THE GUARD AND FEED WORK AGAINST THE DIRECTION OF THE SAW TEETH TRAVEL. TO DO OTHERWISE MAY RESULT IN INJURY TO BOTH THE OPERATOR AND THE MACHINE.

Fig. 1. The blade should be given proper "lead" which term is best explained by the accompanying diagrams. 

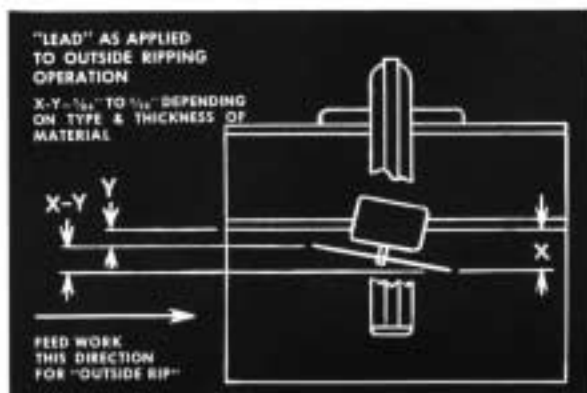




Fig. 2. No. 608009 — Because the adjustment is so important it is recommended that a test block be used to obtain such adjustment. Test block is first cut as shown in this illustration.

2

Fig. 3. No. 608011 — Take same test block and make a second cut from the opposite side of the machine so as to cut into the same cut previously made in Fig. 2.

CAUTION: Note that this cut is being made from the side of the blade which would tend to pull the work into the blade. Therefore use a large test block so that it can be held securely and make the cut carefully.

3

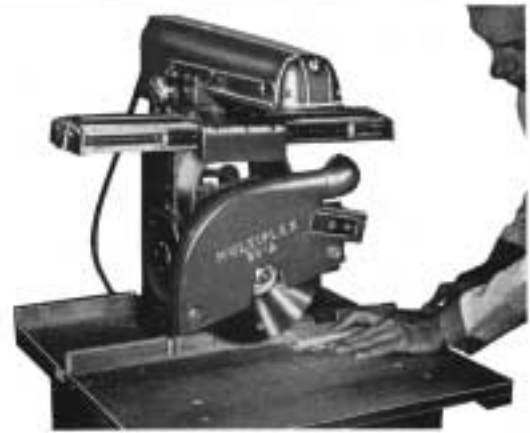


Fig. 4. No. 60810 — This illustration shows typical cuts made on the test block. Note that the cut made in Figure 3 (indicated by pencil) is outside the cut made in Figure 2 and therefore satisfies conditions set forth in Figure 1.

4

Fig. 5. No. 608005 — This illustration demonstrates normal ripping operation on Model 30A or Model 40A. Note that leading edge of guard has been lowered until it just clears the surface of the work. Also note that work is being fed from left to right against the rotation of the blade.


5





Inasmuch as most overloading of motors and consequent tripping of overload protecting devices occurs during ripping operations, the following illustrations are included for the purpose of enabling the operator to reset the device properly and to perform minor servicing of this type of equipment:

Fig. 6. No. 608014 — This illustrates the switch and reset button as furnished on 30A and 40A single phase machines. Note that motor switch is in "OFF" position at the time the reset button is being pushed. Also remember that approximately 2 minutes should elapse after Klixon has tripped before any attempt should be made to reset the device.

CAUTION: Always turn motor switch to "OFF" position and wait 2 minutes before pushing reset button. 

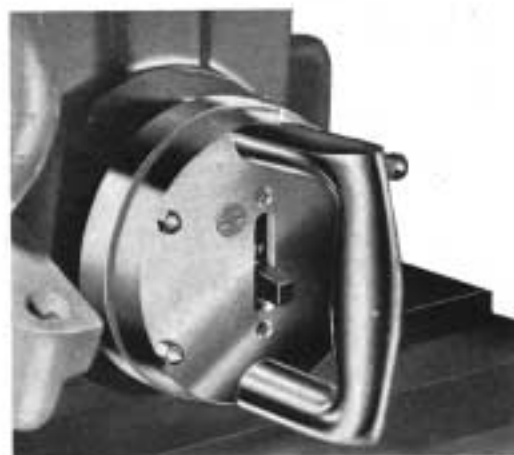


Fig. 7. No. 608013 — This illustrates the typical switch and overload protection furnished on 30A and 40A two and three phase motors. In this case the overload protecting devices are incorporated in the switch and may be reset by throwing switch to "OFF" position as noted on small round instruction plate.



CAUTION: Always wait 2 minutes after tripping before attempting to reset the switch. 

Fig. 8. No. 608007 - If it be necessary to inspect or service either the Klixon or the motor switch on 30 A and 40A machines the correct method is hereby illustrated. The table top has been removed which gives ready access to units involved, after removal of 2 metal screws holding protecting cover plate.

CAUTION: When removing table remove 4 cap screws holding table but *do not disturb* the 4 leveling screws into which capscrews were threaded. After replacing table check alignment of rear fence of table with respect to miter scale to insure obtaining accurate cross-cutting. 



Form 22

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