

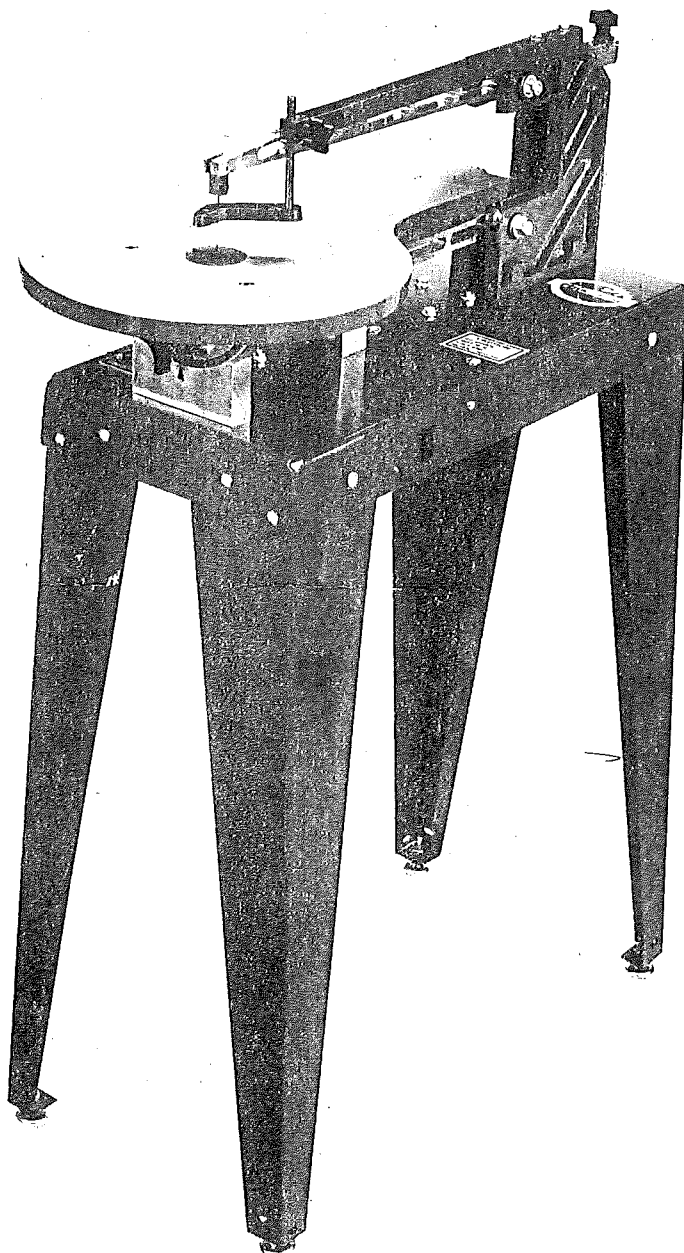


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MODEL 220 HAWK ^{Precision} SCROLL SAW OPERATORS MANUAL

Serial #2046



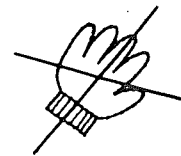
**READ THOROUGHLY BEFORE
OPERATING**





ALL ON SAFETY

SAFETY



TRAINING:

1. Read the operators manual carefully. Be thoroughly familiar with the operation of the equipment.
2. Know where the controls are and how to operate them.
3. Wear safety goggles, ear protection and mask in dusty operations.
4. Never allow children to operate equipment. Never allow adults to operate the equipment without proper instruction.
5. Keep work area clear of other persons.
6. Maintain a clean uncluttered work area.



OPERATION SAFETY:

1. Never make any adjustments while the machine is running.
2. Keep hands and feet away from rotating parts.
3. Disconnect electrical power supply before doing any adjustments on the machine.

4. Remove all working tools and equipment before starting machine.
5. Wear proper clothing. Avoid loose fitted clothing, long sleeves, long hair, gloves, neck ties, jewelry, watches, rings, etc.
6. Do Not operate an electrical device in a damp or wet area to avoid electrical shock.
7. Maintain all safety guards.
8. Do not operate machine while under the influence of medication, alcohol or drugs.
9. Never leave machine running unattended.
10. Don't overload machine. Follow operators instruction for safe operation.
11. Keep equipment in proper working order. Follow recommended maintenance procedures in the operators manual.

WARRANTY

We guarantee each Hawk Scroll Saw to be free from defects in material and workmanship for 1 year from date of delivery to original user. This warranty does not cover damage sustained in transit or from misuse of this piece of equipment.

This warranty does not obligate us to bear the cost of labor, or transportation charges in connection with the replacement or repair of defective parts, nor shall it apply to any saw upon which repairs or alterations have been made unless authorized by us.

We make no warranty in respect to components, not of our manufacture, including motors, such being subject to the warranties of their respective manufacturers.

We shall in no event be liable for consequential damages or contingent liabilities arising out of the failure of any saw to operate properly.

No express, implied or statutory warranty other than herein set forth is made or authorized to be made by us.

ENCLOSED WARRANTY REGISTRATION CARD MUST BE RETURNED TO VALIDATE YOUR WARRANTY.

TO VALIDATE WARRANTY

CUSTOMERS Must mail in warranty card on receipt of machine.

HAWK 220

SPECIFICATIONS:

Length 33"	Max. Cutting Depth 2"
Width 16"	Stroke $1\frac{1}{16}$ "
Height 45.5"	Strokes / Min. 1300 - 700
Weight 98 lbs.	Motor $\frac{1}{8}$ H.P. TEFC
Throat Depth 20"	Drive Belt

Remove your saw from the shipping carton: Check for damage (See note Above) The four legs come in a separate carton. Install one leg to each corner of the base using $\frac{1}{4}$ " carriage bolts and nuts. Install one $\frac{3}{8}$ " nut on each of the four glides. Insert the glides up through the hole in the bottom of the leg and install the second $\frac{3}{8}$ " nut to secure. With the legs secure to the base, set the saw upright and adjust the nuts on the glides so each glide supports the saw. Secure. (See figure)

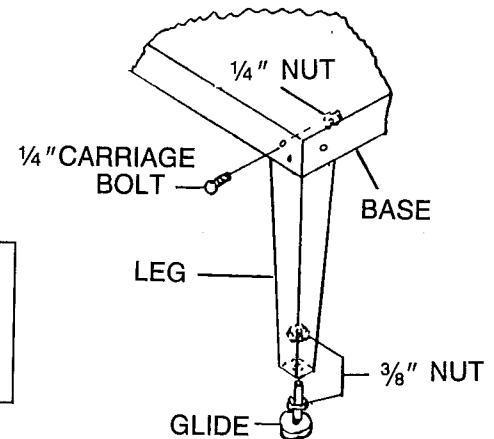
SET-UP INSTRUCTIONS

NOTE: Damages or shorted parts are to be reported to the transportation carrier. **MANUFACTURER IS NOT RESPONSIBLE FOR SHIPPING DAMAGE.**

SAW CARTON:

Box 1	Box 2
1. Saw	1. Legs
2. Operators manual	
3. Extra blades (6)	
4. Glides (leg bottom)	
5. Attaching Hardware	

NOTE: Optional Adjustable 6" Leg Extension available. Part #6LE (See parts breakdown).



BLADE SELECTION

ALL BLADES HAVE SKIP TEETH FOR GREATER CHIP CLEARANCE. ALL BLADES ARE 5" LONG

R.B.I. NO.	MATERIAL CUT / USAGE	WIDTH	THICKNESS	TPI
2/0	For extremely intricate sawing. Very thin cuts in $\frac{1}{16}$ " to $\frac{3}{32}$ " 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 $\frac{3}{32}$ " to $\frac{1}{8}$ " wood veneer, wood, bone, fiber, ivory, plastic. Good finish, fast cutting tight radius.	.029"	.012"	20
5	For close radius cutting in materials $\frac{1}{8}$ " 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 $\frac{3}{15}$ " 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 $\frac{1}{4}$ " or more. Fast cutting.	.100"	.022"	9 with 3 reverse teeth

METAL CUTTING (FINIS) BLADES [CAUTION: Must be run on slow speed]

Pitch	T.P.I.	Thick	Wide
#0	50	.011"	.024"
#1	46	.012"	.025"
#2	43	.013"	.029"
#3	41	.014"	.031"
#4	38	.015"	.034"
#5	33	.016"	.035"
#7	28	.019"	.048"

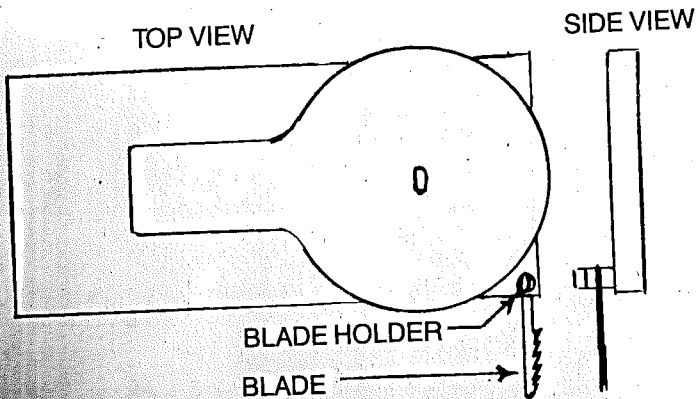
SLOWER, FINER, SMOOTHER FINISH WITH A SMALLER TURN RADIUS

FASTER, COARSER, ROUGHER FINISH AND LARGER TURN RADIUS

OPERATION

A. Blade installation in the blade holder

Place the blade holder in the oblong slot in the base (right side of the saw base near the front.) Slide the bottom of the blade (direction the teeth point) between the two halves of the holder to the center screw. (Run your finger across the teeth to determine the direction the teeth point.) Center and secure using a 5/16" open end wrench. (See Figure.)



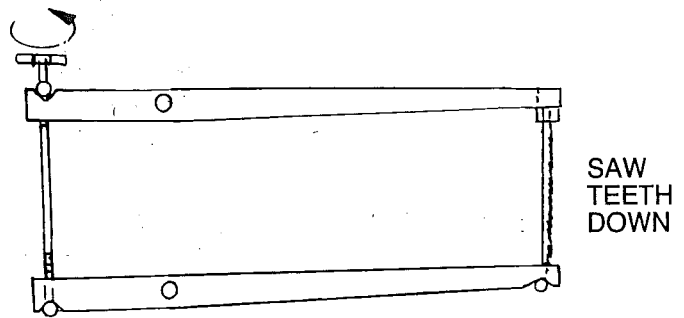
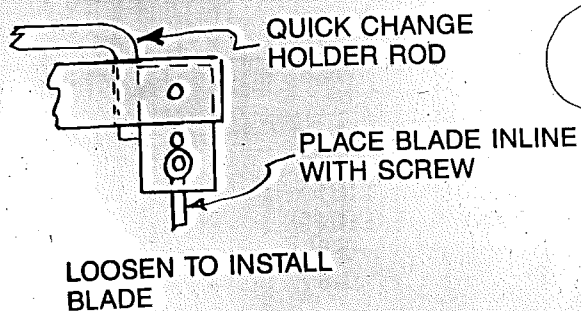
B. Blade installation in the saw

Place the quick change holder rod in the slot of the upper arm behind the quick change blade holder. Slide the blade up from the bottom thru the hole in the center of the table. Pull the blade up until the holder is at the bottom of the lower arm. Slide the blade and holder back in the lower arm slot until the holder rests in the "V" at the bottom of the lower arm between the arm and clip.

Pull the upper arm down until the upper arm blade holder assembly will slide over the blade (it may be necessary to loosen the adjusting knob at the rear of the saw to allow the upper arm to come down). Center the blade in the blade holder and slide upward to the screw. (See Figure.)

Using the Allen wrench supplied, left side in the rubber grommet, secure the blade at the top.

Remove the quick change blade holder rod. Center the tension adjusting rod angle and tighten until the blade has a ring like a guitar string when plucked. (See Figure.)

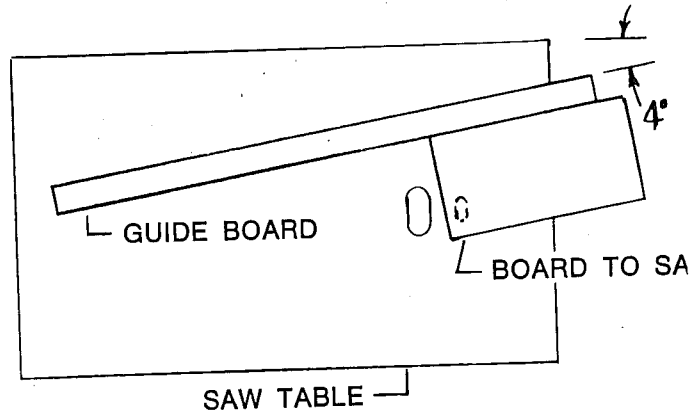


C. Sawing (Remember, let the saw blade do the work)

Feed the material to be cut slowly into the saw blade while maintaining downward pressure. (This may be done by hand or by adjusting the holddown foot on the material.) Note: Always keep hands away from the saw blade and out from under the moving arm.

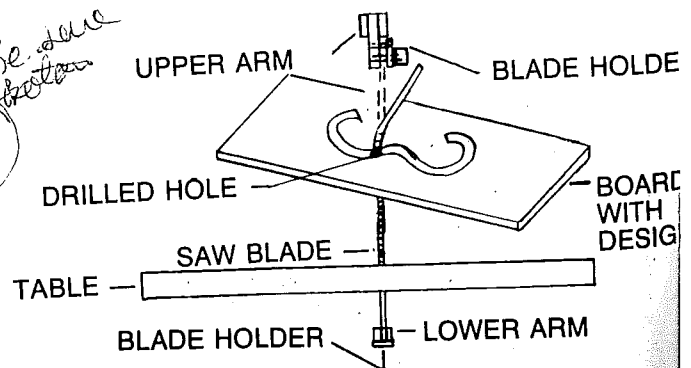
D. Using a guide board to saw a straight line

It is necessary to angle your guide board approx. 4° from right to left. This is necessary due to the manufacture of all scroll saw blades with a small amount of set on one side of the blade only.



E. Sawing inside cuts

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 saw top arm. Loosen the knob at the rear of the arms and cap screw holding blade in holders. Insert the blade up through the hole drilled in your board and back into the blade holder. (See blade installation for more details) This allows quick and easy inside cuts to be made.



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

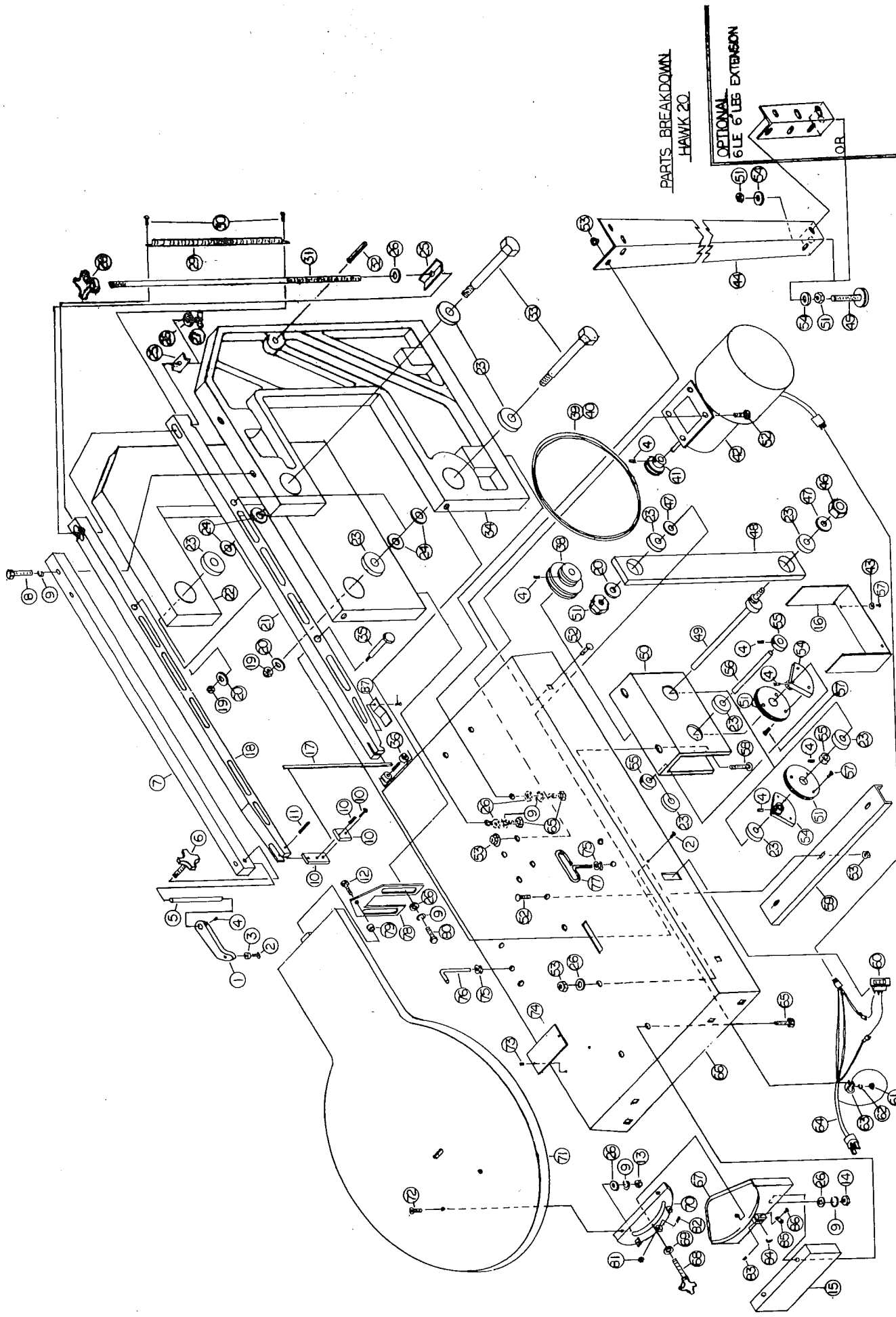
Keep the table work surface waxed to prevent rust and allow easier movement of the wood on the table surface.

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 GUIDE

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
EXCESSIVE BLADE BREAKAGE	IMPROPER BLADE SIZE TO WOOD THICKNESS CUTTING TOO TIGHT OF A RADIUS FOR BLADE SIZE	SELECT PROPER BLADE SIZE INCREASE RADIUS SIZE OR REDUCE BLADE SIZE
BLADE BURNS THE WOOD	WRONG BLADE SIZE CUTTING TOO SMALL A RADIUS IMPROPER FEEDING PUSHING SIDE WAYS ON THE BLADE FEED FEEDING TOO FAST IMPROPER BLADE TENSION	INCREASE BLADE SIZE INCREASE RADIUS OR DECREASE BLADE SIZE FEED MATERIAL AT 4° R. TO L. STRAIGHT SO AS NOT TO BEND BLADE L. OR R. REDUCE FEED RATE INCREASE BLADE TENSION
BLADES BEND BACK EXCESSIVELY OR TWISTS WHILE SAWING	IMPROPER BLADE TENSION IMPROPER BLADE SIZE FEEDING TOO FAST	INCREASE BLADE TENSION INCREASE BLADE SIZE SLOW FEED RATE
BLADE CUTTING TOO LARGE A RADIUS	BLADE TOO LARGE BLADE TENSION LOW IMPROPER FEEDING	USE SMALLER BLADE INCREASE BLADE TENSION TURN BOARD PROPERLY
BOARD SPLINTERING ON THE BOTTOM	WRONG BLADE SIZE WOOD GRAIN STRINGY OR KNOTTY	USE SMALLER BLADE USE MASKING TAPE ON THE BOTTOM AT THE SAW LINE
ROUGH CUT ON THE SAWED EDGE	BLADE TOO LARGE BLADE TENSION LOW POOR QUALITY WOOD FEEDING TOO FAST	USE SMALLER BLADE INCREASE BLADE TENSION USE BETTER QUALITY WOOD SLOW FEED RATE
BLADE DOESN'T FOLLOW PATTERN LINE	IMPROPER FEEDING (FEED AT AN ANGLE R. TO L. OF APPROX 4° STRAIGHT INTO THE BLADE) BLADE DULL BLADE TOO SMALL IMPROPER BLADE TENSION FORCING MATERIAL INTO THE BLADE	PRACTICE REPLACE BLADE INCREASE BLADE SIZE INCREASE TENSION REDUCE FEED SPEED
WOOD JUMPS ON THE TABLE	IMPROPER HOLDDOWN ADJUSTMENT BLADE INSTALLED UPSIDE DOWN TURNING TOO TIGHT OF A RADIUS NOT USING HOLDDOWN AND NOT HOLDING BOARD DOWN FIRMLY SAWING TOO FAST PRESSING SIDEWAYS ON THE BLADE	ADJUST THE HOLDDOWN TO APPLY PRESSURE TO THE BOARD. INSTALL BLADE PROPERLY TEETH POINTING DOWN INCREASE RADIUS SIZE HOLD BOARD FIRMLY ON THE TABLE ESPECIALLY WHEN TURNING FEED PROPERLY (FEED AT AN ANGLE R. TO L. OF APPROX. 4° & STRAIGHT INTO THE BLADE.) REDUCE FEED SPEED FEED AT 4° ANGLE R. TO L. AND STRAIGHT



PARTS BREAKDOWN
HAWK 20

OPTIONAL
GLE 6 LES EXTENSION

OR

PARTS LIST FOR HAWK 220

	PART#	QUANT.		PART#	QUANT.
1. Foot	ES-09	1	45. Glides (4) w/(8) Nuts	ES-57-S	4
2. Machine Screw	RB-106	2	46. 1/2" Jam Nut	HA-68	1
3. Foot Seat Pod	ES-10	1	47. Spacer	HA-14	2
4. 1/4"-20 x 1/4" Set Screw	RZ-83	7	48. Pitman Arm	HA-69	1
5. Shaft (Foot to arm)	ES-08	1	49. Pitman Shaft	ES-12-Z	1
6. Knob	ES-40	1	50. Housing Weldment	ES-95	1
7. Holddown arm	HA-66	1	51. Gear	ES-92	2
8. 1/4 x 1 Hex Hd Bolt	PS-80	2	52. 1/4-20 x 5/8" Carriage Bolt	RB-99	19
9. 1/4" L/W	RBZ-207	12	53. 1/4" Whiz Nut	RB-223	21
10. Top Blade Holder Ass'y	FA-45	1	54. Counter Wt.	ES-91	2
11. Roll Pin 1/8 x 3/4" Lg.	FA-42	1	55. Collar	ES-15	3
12. 5/16 x 1 1/4" Hex Hd Bolt	RZ-181	1	56. Shaft	ES-97	1
13. 1/4-28 Hex Nut	ES-49	2	57. #10-32 x 1/2 Socket Hd.		
14. 1/4-20 Hex Nut	RBZ-208	2	Cap Screw	ES-35	8
15. Spacer Block Base Tilt	HA-22	1	58. 1/4-20 x 1 1/4 Crg. Bolt	RBZ-211	2
16. Cover	ES-96	1	59. Base Braces	HA-12	1
17. Saw Blades			60. Switch	HA-61	1
(order by # or pitch)			61. 10-32 Hex Nut	RB-107	1
18. Top Arm	HA-52	1	62. 10-32 L/W	RB-519	1
19. 3/8" L/N	FA-08	2	63. Cable Clamp	HA-63	1
20. 5/16" F/W	RB-150	3	64. Cord Set	HA-60	1
21. Lower Arm	HA-53	1	65. 1/4-20 x 1" Hex Hd Bolt	PS-52	6
22. R.H. Arm Supt.	HA-50	1	66. Base 2-Spd	HA-64	1
23. Bearing	PS-07	10	67. Table Tilt Base Brkt.	HA-21	1
24. Spacers	HA-67	4	68. Knob Table Tilt	ES-42	1
25. Connector Rod Pivot	HA-18	2	70. Table Tilt Table Brkt	HA-20	1
26. 1/4" F/W	RB-177	14	71. Table	ES-05	1
27. 1/4" Wing Nut	RB-176	1	72. 1/4" Socket Flat Head	RZ-182	2
28. Knob	RB-507	1	73. #7 Drive Screw	FA-12	2
29. Spring	FA-36	1	74. Serial Tab	HA-70	1
30. 10-32 x 1/4" Rd. Hd. Slotted			75. Rubber Grommet	HA-16	2
Screw	FA-35	3	76. Quick Change Hold Rod	HA-65	1
31. Rod	CD-21	1	77. 9/16" "T" Allen Wrench	ES-86	1
32. Roll Pin 1/4" x 1 1/8"	RZ-59	1	78. Rear Table Support	CD-13	1
33. Shoulder Bolt	HA-71	2	79. Spacer Slide Nylon	RB-517	1
34. L.H. Arm Supt.	HA-51	1	80. 1/4"-20 x 3/4" Hex Hd Bolt	RBZ-206	2
35. Shoulder Bolt	HA-13	1	81. Nut	HA-34	3
36. Saw Blade Holder	ES-65	1	82. Screw	HA-33	3
38. V-Pulley (Dual Polyflex)	ES-71	1	84. Pointer	HA-29	1
39. Poly Flex Belt (FAST) 5M425	ES-72	1	85. Stop	HA-31	1
40. Poly Flex Belt (Slow) 5M450	ES-73	1	86. Screw	HA-32	1
41. Sheave, Motor (Poly Flex)	ES-70	1	87. Clip	FA-02	1
42. Motor	ES-44-Z	1			
43. Rivit Burr	RB-112	2			
44. Leg	CD-07	4			

ACCESSORIES

LIGHT

2LK STANDARD LIGHT

Heavy duty flexible arm, 16" long which uses a maximum 60 watt incandescent bulb with metal globe. Allows light to be put close to the work and maintain this position. Comes complete with everything to mount on your saw.

2MK MAGNIFIER LIGHT

Flexible arm light with built-in 2 to 1 magnification lens and scale to measure through the lens. Comes with bracket to attach to a work bench edge. Uses 60 Watt Incandescent bulb maximum.

2BK BLOWER

Kit comes complete with blower, tubing, and attaching hardware to mount on your saw. Maintains an area the size of a quarter, around the saw blade, free of dust so you can see lines to saw. Blower is a vibrating diaphragm type.

6LE LEG EXTENSION KIT

Bottom mounted Leg Extension which increases the height of your saw up to six inches, with 2" increment adjustments.

HOW AND WHERE TO ORDER REPLACEMENT PARTS AND ACCESSORIES
TO SPEED DELIVERY AND REDUCE ERROR OF REPLACEMENT PARTS,
ALWAYS INCLUDE THE FOLLOWING INFORMATION:

1. Give the complete identification of the machine.

A. Machine Name

B. Model Number

C. Serial Number

2. Give the identification of the part.

A. Part Number

B. Part Name

C. If necessary, return the old part as a sample.

3. Give us an address to return the part to

Ship to:
Your Name (Please Print)

Address
Street P. O. Box Rural Route

City

State Zip

Country

4. Send your order to:

rbiindustries, inc.

SALES OFFICE

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Centerville, Ohio 45459
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PLANT

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