

OPERATION

WARNING!

To reduce the risk of injury, always unplug tool before attaching or removing accessories. Only use specifically recommended accessories. Others may be hazardous.

Blades and Blade Selection

Every MILWAUKEE Portable Bandsaw is furnished with a 14-teeth-per-inch Bi-metal blade which is suitable for most applications. The blade dimensions required for the band saws are: .020" thickness, 1/2" width and 44-7/8" in length. The special .020" thickness reduces flexure fatigue and provides maximum tooth life. To maximize cutting life, use a blade with the correct pitch (teeth per inch) for the specific cutting job.

Blades are available in several pitches. To select the proper blade, three factors should be considered: The size, shape, and type of material to be cut.

The following suggestions are for selecting the right blade for various cutting operations. Keep in mind that these are broad guidelines and that blade requirements may vary depending upon the specific size, shape and type of material to be cut. Generally, soft materials require coarse pitch blades and hard materials require fine pitch blades. Use coarse pitch blades for thick work and fine pitch blades for thin work. It is important to keep at least three teeth in the cut. See "Typical Application" on page 10.

	For tough stock 1/2" to 3-3/8" in diameter or width (available in carbon steel only)
	For tough stock 3/8" to 1" in diameter or width (available in carbon steel only)
	For tough stock 3/16" up to 4-3/4" in diameter or width
	For tough stock 5/32" to 3/4" in diameter or width
	For thin-wall tubing and thin sheets heavier than 21 gauge
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Changing Blades

1. **UNPLUG THE TOOL BEFORE REMOVING OR INSTALLING BLADES.**
2. Turn the tension lock handle located on the front of the saw 180-degrees counter-clockwise. This releases the tension on the blade for easy removal.
3. Remove the blades from the pulley first and then from the guides.
4. To install a new blade, with the pulleys facing up, insert the blade between the rollers and the faces of the guides, making sure that the teeth on the left side of the tool point towards the rear of the tool.
5. With one hand, hold the blade in place between the rollers and the guides and use the other hand to position the blade around the pulleys. Be sure that the blade lies freely within the guard channel before starting the tool motor.
6. Turn the tension lock handle 180-degrees clockwise to lock the position. This will secure the blade on the pulleys.

BE SURE THAT THE BLADE IS PROPERLY SEATED ON THE PULLEYS BEFORE STARTING THE CUT.

Two Speed Switch for Cat. Nos. 6223, 6224, 6225, 6226, 6236, 6238

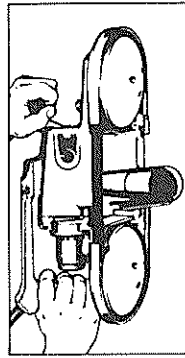
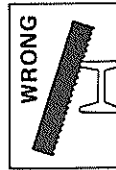
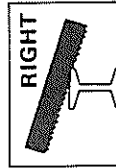
MILWAUKEE Two-Speed Band Saws are equipped with a speed change switch located below the trigger on the handle. To change speeds, stop the motor and slide the speed change switch to "HI" or "LO" as indicated on the tool. For cutting problem materials, use "LO" speed. Never change from one speed to the other while the motor is running.

Starting, Stopping, and Controlling Speed for Cat. Nos. 6227, 6230, 6232, and 6234

1. To start the tool, grasp the handle firmly and pull the trigger.
2. To vary the speed, simply increase or decrease pressure on the trigger. The further the trigger is pulled, the greater the speed.
3. To select a maximum preset speed at any point within the speed range, rotate the red knurled knob located on the trigger to the desired position.
4. To stop the tool, release the trigger. Allow the tool to come to a complete stop before removing the blade from a partial cut or laying the tool down.

Typical Application

1. Keep the blade off the workpiece until the motor has reached the selected speed.
2. Start cutting on a surface where the greatest number of teeth will be in contact with the workpiece at one time.
3. Place the work steady rest against the workpiece and lower the moving saw blade into the cut.
4. Do not bear down while cutting. The weight of the tool will supply adequate pressure for the fastest cutting.
5. When completing a cut, hold the tool firmly so it will not fall against the workpiece.



MAINTENANCE

WARNING!

To reduce the risk of injury, always unplug your tool before performing any maintenance. Never disassemble the tool or try to do any rewiring on the tool's electrical system. Contact a **MILWAUKEE** service facility for ALL repairs.

Maintaining Tools

Keep your tool in good repair by adopting a regular maintenance program. Before use, examine the general condition of your tool. Inspect guards, switches, tool cord set and extension cord for damage. Check for loose screws, misalignment, binding of moving parts, improper mounting, broken parts and any other condition that may affect its safe operation. If abnormal noise or vibration occurs, turn the tool off immediately and have the problem corrected before further use. Do not use a damaged tool. Tag damaged tools "DO NOT USE" until repaired (see "Repairs").

Under normal conditions, relubrication is not necessary until the motor brushes need to be replaced. After six months to one year, depending on use, return your tool to the nearest **MILWAUKEE** service facility for the following:

- Lubrication
- Brush inspection and replacement
- Mechanical inspection and cleaning (gears, spindles, bearings, housing, etc.)
- Electrical inspection (switch, cord, armature, etc.)
- Testing to assure proper mechanical and electrical operation

WARNING!

To reduce the risk of injury, electric shock and damage to the tool, never immerse your tool in liquid or allow a liquid to flow inside the tool.

Cleaning

Clean dust and debris from vents. Keep the tool handles clean, dry and free of oil or grease. Use only mild soap and a damp cloth to clean your tool since certain cleaning agents and solvents are harmful to plastics and other insulated parts. Some of these include: gasoline, turpentine, lacquer thinner, paint thinner, chlorinated cleaning solvents, ammonia and household detergents containing ammonia. Never use flammable or combustible solvents around tools.

Repairs

If your tool is damaged, return the entire tool to the nearest:

Milwaukee Branch Office/Service Center,
Milwaukee Authorized
Portable Electric Tool Service Station

or
Milwaukee Electric Tool Corporation
13135 West Lisbon Road
Brookfield, WI 53005
(414) 781-3600