Milwaukee Tool
Deep Cut Band Saw
Model Numbers: 6230, 6232, 6236, 6238

Operating Instructions

OPERATION

WARNING!

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

Blades and Blade Selection (Fig. 1)
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.

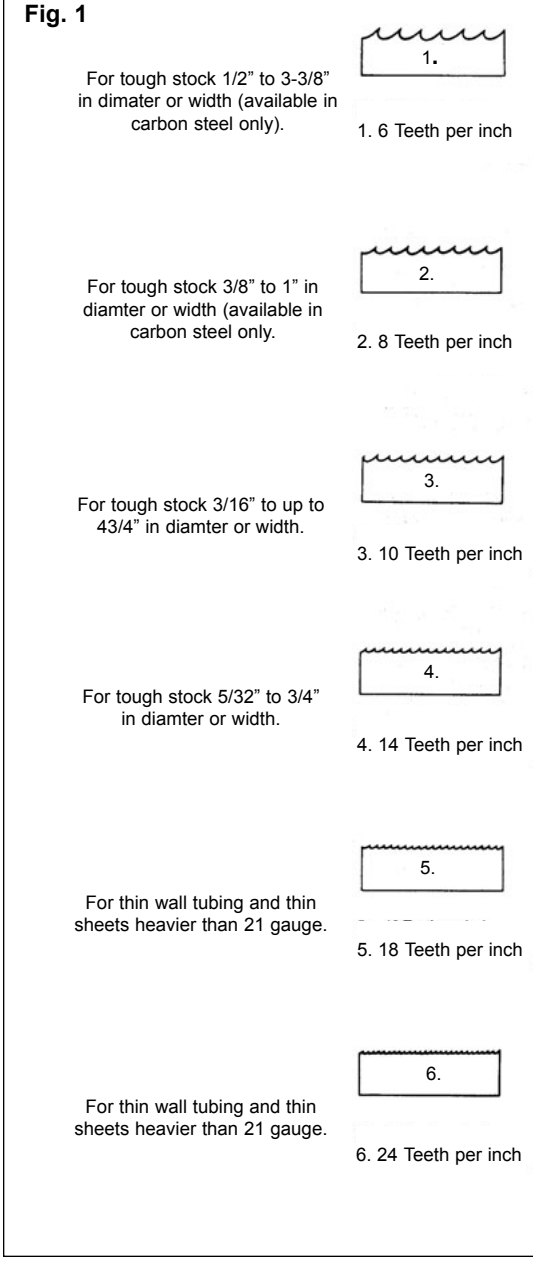
The following suggestions are for selecting the right blade for various cutting operations. Keep in mind that these are broad guidelines and that blade requirements may vary depending upon the specific size, shape and type of material to be cut. Generally, soft materials require coarse pitch blades and 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 pages 16 and 17.

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 counterclockwise. This releases the tension on the blade for easy removal.

(Continued on next page)

Fig. 1



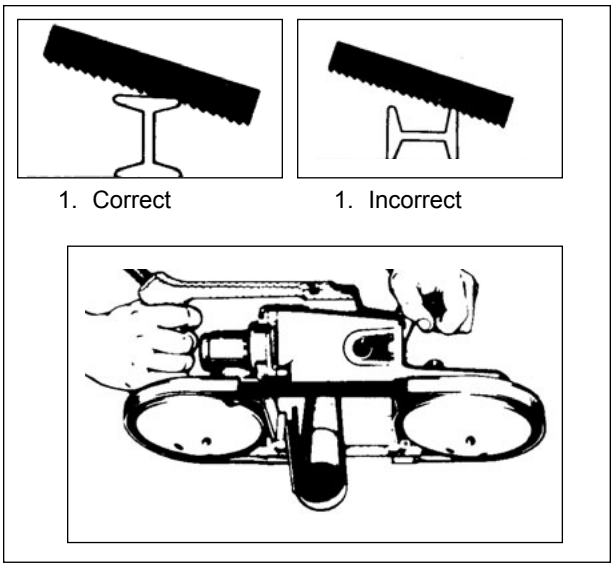
3. Remove the blades from the pulley first and then from the guides.

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. No. 6227, 6230, 6232, 6234
1. To start the tool, grasp the handle firmly and pull trigger.

2. To vary the speed, simply increase or decrease pressure on the trigger. The further 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 (Fig. 2 & Fig. 3)
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.