



Rockwell

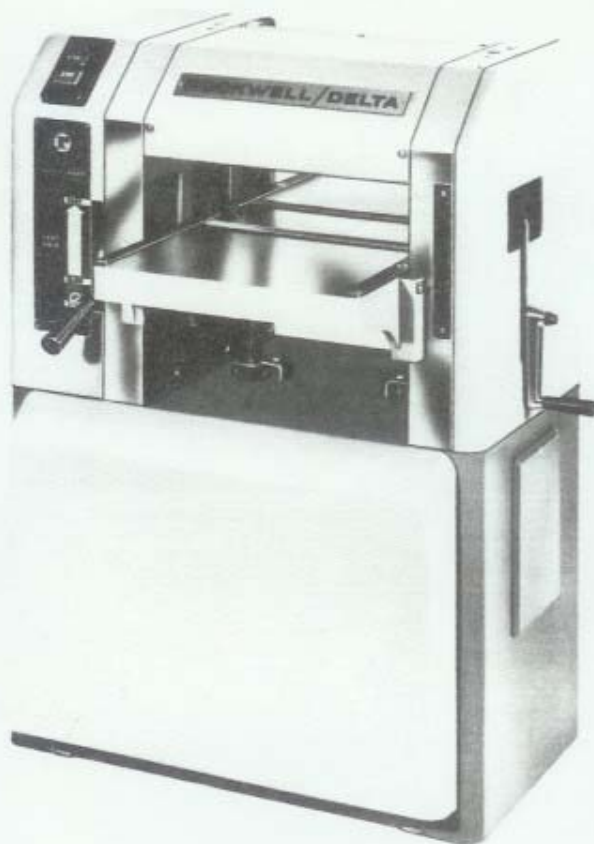
MANUFACTURING COMPANY

The Rockwell Building • Pittsburgh, Pa.

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DATED IM-1-20-70

ROCKWELL DELTA 13" x 6" PLANER



INTRODUCTION

Your new 13" x 6 Planer is ideal for use in school shops and commercial installations where safety is of prime importance. Rockwell's attention to safety, however, in no way affects the machine's function for dressing wood to exact parallel thickness.

Your planer will handle stock up at 13" wide, varying in depth from 1/16" to 6". The planer is factory set for 1/8" depth of cut, however, it can be adjusted to cut a maximum depth of cut of 1/4" when a 5 h.p. motor is used. The high speed cutterhead gives 13,500 cuts per minute, providing an exceptional smooth finish.

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ROCKWELL AUTHORIZED PARTS DISTRIBUTORS

CALIFORNIA

LOS ANGELES, 90007
Rockwell Manufacturing Company
2400 South Grand Avenue
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Phone: 415 535-2424

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4900 East 39th Avenue
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Phone: 212 CA 6-4000

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Karle Saw Company, Incorporated
138-150 Chicago Street, Cor. So. Park Avenue
Phone: 716 853-8053 or 853-8054

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CINCINNATI, 45203
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906 Dalton Street
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Rockwell Manufacturing Company
1234 East 26th Street
Phone: 216 621-6329

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Rockwell Manufacturing Company
400 North Lexington Avenue
Phone: 412 241-8400

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Post Office Box 47767
Phone: 214 631-1890

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SEATTLE, 98101
Rockwell Manufacturing Company
1918 Minor Avenue
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WISCONSIN

MILWAUKEE, 53222
Rockwell Manufacturing Company
10700 West Burleigh Street
Phone: 414 774-3650

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GUELPH, ONTARIO
Rockwell Manufacturing Company
of Canada Limited
40 Wellington Street
Post Office Box 848
Phone: 807 822-2840

Authorized Parts Distributors stock a complete line of replacement parts. To save time and shipping cost send your parts orders to your nearest distributor and in most cases they will be filled and shipped within 48 hours. We do not fill any parts orders direct from the factory.

SAFETY SUGGESTIONS

1. READ THE INSTRUCTION MANUAL BEFORE OPERATING YOUR MACHINE.
2. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF PLANERS, OBTAIN ADVICE FROM YOUR SUPERVISOR, INSTRUCTOR OR OTHER QUALIFIED PERSON.
3. REMOVE TIE, RINGS, WATCH AND OTHER JEWELRY, AND ROLL UP SLEEVES.
4. ALWAYS WEAR SAFETY GLASSES OR A FACE SHIELD.
5. MAKE SURE WIRING CODES AND RECOMMENDED ELECTRICAL CONNECTIONS ARE FOLLOWED AND THAT THE MACHINE IS PROPERLY GROUNDED.
6. MAKE ALL ADJUSTMENTS WITH THE POWER OFF.
7. KEEP CUTTERHEAD SHARP AND FREE OF ALL RUST AND PITCH.
8. CHECK MATERIAL FOR LOOSE KNOTS, NAILS AND OTHER DEFECTS.
9. REMOVE SHAVINGS ONLY WITH THE POWER OFF.
10. KEEP HANDS AWAY FROM THE TOP SURFACE OF THE BOARD NEAR THE FEED ROLLS.
11. WHEN PLANNING BOWED STOCK, ALWAYS TURN THE CONCAVE SIDE OF THE STOCK TOWARD THE TABLE AND CUT WITH THE GRAIN.
12. DISCONNECT MACHINE FROM POWER SOURCE WHEN MAKING REPAIRS.
13. BEFORE LEAVING THE MACHINE, MAKE SURE THE WORK AREA IS CLEAN.

INSTALLATION

SELECTING FLOOR SPACE

The planer should be placed in a suitable location with adequate floor space both in front and back of the machine for dressing long stock. It should be set on a level foundation and bolted permanently in place.

INSTALLING THE MOTOR

If your planer was purchased complete with a Rockwell Motor, you may disregard these instructions because the motor has been mounted and the pulley adjusted to give correct alignment of the belts.

On the other hand, if installing your own motor, the motor mounting plate will accommodate NEMA frames 182T and 184T Totally Enclosed Fan Cooled Motors. These frame motors must have the junction box located to the right of the motor shaft as shown in Fig. 2. Rockwell Catalog No 22-425 1-1/8" bore motor pulley must be used with these motors.

In regards to single phase motors, most capacitors are mounted on the top of the motor. This may cause interference between the table raising screws and the capacitor. Since motors with special capacitor locations are difficult to obtain, we recommend that only Rockwell Motors with the special capacitor location be used as shown in Fig. 2.

Proceed as follows when installing the motor:

1. Place the motor in position with the shaft extending toward the gearbox side of the machine as shown in Fig. 2, and fasten it to the motor plate.
2. Place the pulley (A) on the motor shaft with the large step of the pulley towards the motor, as shown in Fig. 2.
3. Assemble the belts (B) and (C) Fig. 2, to the pulley and adjust belt tension as described under ADJUSTING BELT TENSION.

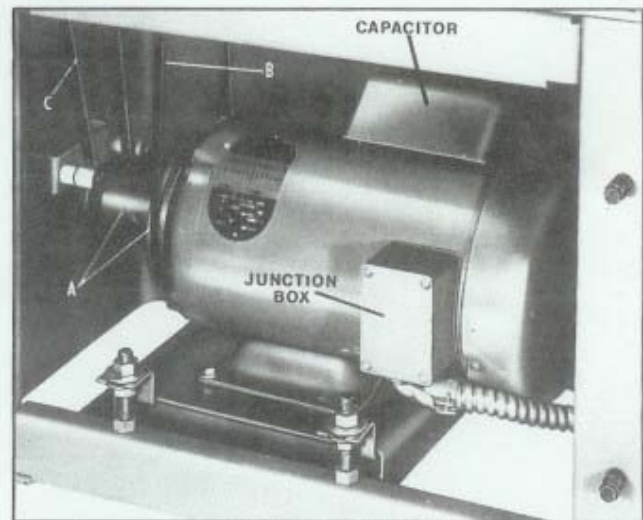


Fig. 2.

ELECTRICAL CONNECTIONS

Before connecting the motor to the power source, be sure the electric current is of the same characteristics as stamped on the motor nameplate.

Do not connect the motor to a circuit which will be overloaded. If an extension cord is used, it must have adequate capacity. All line connections should make good contact. Running on low voltage will injure the motor. ALWAYS MAKE SURE THE MACHINE IS PROPERLY GROUNDED.

OPERATION AND CONTROLS

PUSH BUTTON SWITCH CONTROL

The push button switch shown in Fig. 3, is conveniently located on the left side panel of the machine. The push buttons are color coded - green for "start" and red for "stop". The shrouded "start" button prevents accidental starts while the "stop" button is extra large for quick, emergency stops. The switch cover and buttons are made of non-conductive material for added safety



Fig. 3.

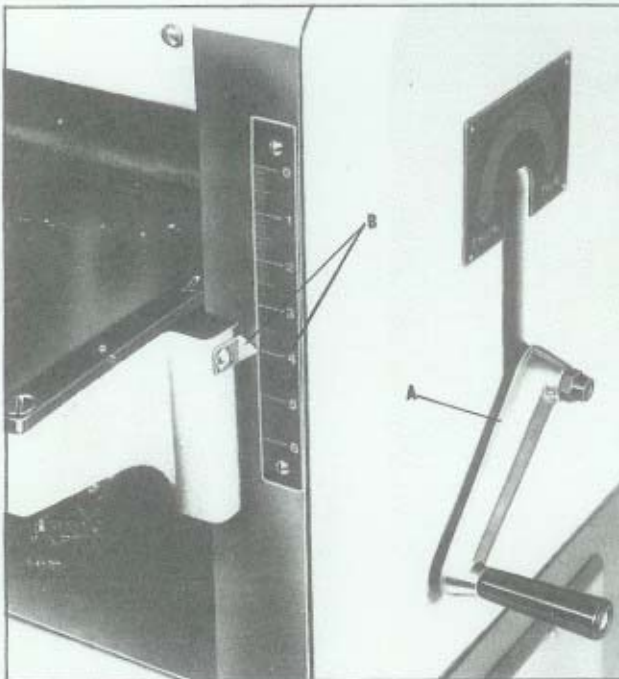


Fig. 4.

TABLE RAISING AND LOWERING CONTRC

One turn of the depth of cut control lever (A) Fig. 4, raises or lowers the table exactly 1/16". The large up-front scale and pointer (B) help the operator obtain proper cutting depth and eliminates any unnecessary bending and eye strain when changing table settings.

VARIABLE FEED RATE CONTROL

The variable feed rate control on your planer is infinitely adjustable. The speed range is 15 to 25 feet per minute to suit the type of stock, finish and feed desired, simply by moving the speed lever (A) Fig. 5. The feed may be disengaged, without stopping the motor by moving the speed lever to the "stop" position.



Fig. 5.



Fig. 6.

QUICK - CHANGE, SNAP - ON MACHINE PANELS

A special spring-tension locking mechanism (A) Fig. 6, permits instant removal of the panels of the planer for inspection and maintenance of the motor, cutterhead and variable feed drives. Simply lift the panels up and pull them straight out as shown in Fig. 6.

SERVICE ADJUSTMENTS

Although your planer was carefully adjusted at the factory, it should be checked before being put into operation. Any inaccuracies due to rough handling in transit can easily be corrected by following these directions.

In order to check the adjustments, you will need a feeler gage, a straight edge 12" or longer and a home-made gage block made of hardwood. This gage block can be made by following the dimensions shown in Fig. 7.

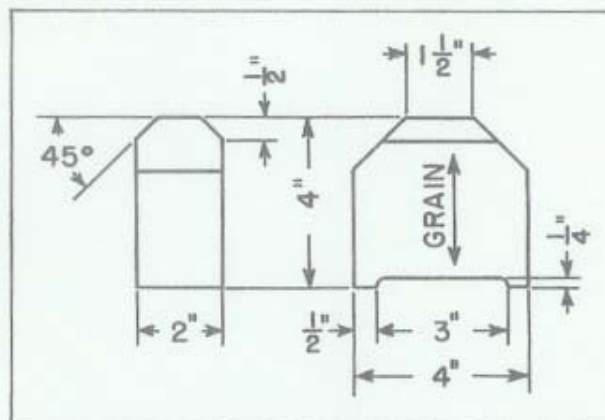


Fig. 7.

WHEN CHECKING THE ADJUSTMENTS, ALWAYS MAKE SURE THE PLANER IS DISCONNECTED FROM THE POWER SOURCE.

LEVELING TABLE

The table should be parallel to the cutterhead. To check and adjust, proceed as follows:

1. DISCONNECT THE PLANER FROM THE POWER SOURCE.

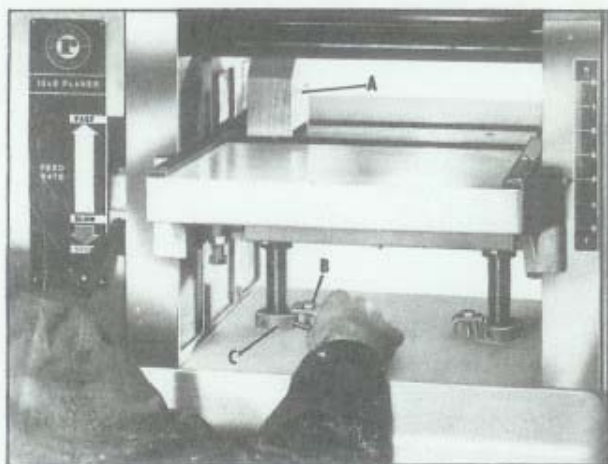


Fig. 8.

2. Place gage block (A) on the table directly under the knives at one end as shown in Fig. 8.

3. Raise the table until the knife just touches the gage block.

4. Move the gage block to the opposite side of the table. The knives should touch the gage block the same amount. If an adjustment is necessary, loosen screw (B) Fig. 8, under the end of the table that is to be adjusted and turn adjusting nut (C) the required amount until the knives touch the gage block. Then tighten screw (B).

5. Recheck this adjustment by moving the gage block to the opposite side of the table and adjust further if necessary.

6. DO NOT RAISE OR LOWER THE TABLE AFTER THIS ADJUSTMENT.

ADJUSTING PRESSURE BAR

The pressure bar is located directly behind the cutterhead and rides on the planed surface of the stock pressing it down on the table. The pressure bar must be parallel to the knives and tangent to the cutting circle as shown in Fig. 9.

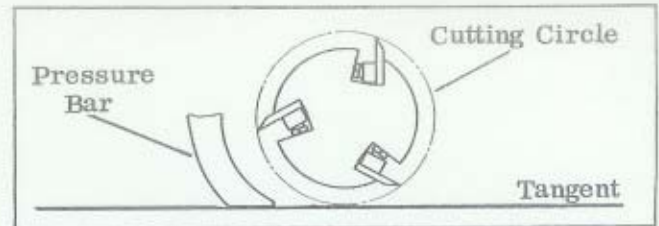


Fig. 9.

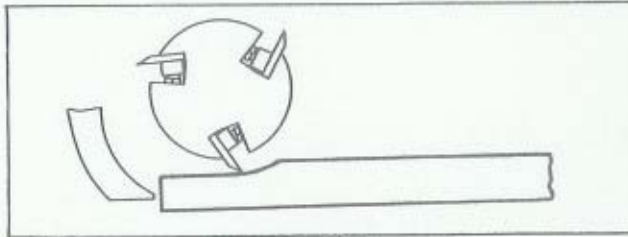


Fig. 10.

If the stock has chatter marks, the pressure bar is set too high as shown in Fig. 11.

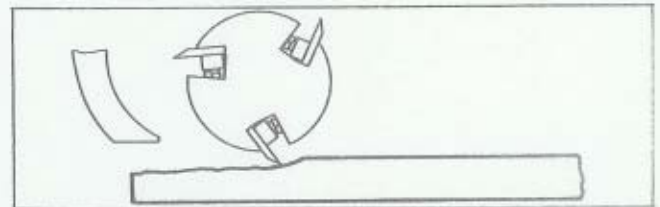


Fig. 11.

To check and adjust the pressure bar, proceed as follows:

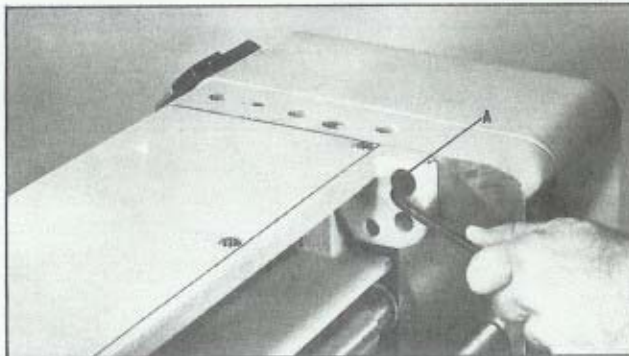


Fig. 12.

1. DISCONNECT THE PLANER FROM THE POWER SOURCE.

2. Remove the chipbreaker and cutterhead guard safety screw (A) Fig. 12.

3. The chipbreaker and cutterhead guard (A) can now be swung up towards the rear of the planer as shown in Fig. 13.

4. Place the gage block (B) Fig. 13, directly under the pressure bar at each end. REMEMBER WE CAUTIONED YOU NOT TO RAISE OR LOWER THE TABLE AFTER LEVELING THE TABLE.

5. If the pressure bar must be raised or lowered at either end, loosen the socket head screw using the 5/16" hex wrench (C) Fig. 13, and turn the special adjusting screw the required amount, using the special wrench (D), until the pressure bar just touches the gage block.



Fig. 14.

6. The socket head screw is shown at (A) Fig. 14, and the special adjusting screw is shown at (B).

7. After pressure bar is adjusted, tighten socket head screw with wrench (C) making sure the adjusting screw is not disturbed by holding it securely with wrench (D) Fig. 13. DO NOT RAISE OR LOWER THE TABLE AS IT MUST REMAIN AT THIS SETTING FOR FURTHER ADJUSTMENT.

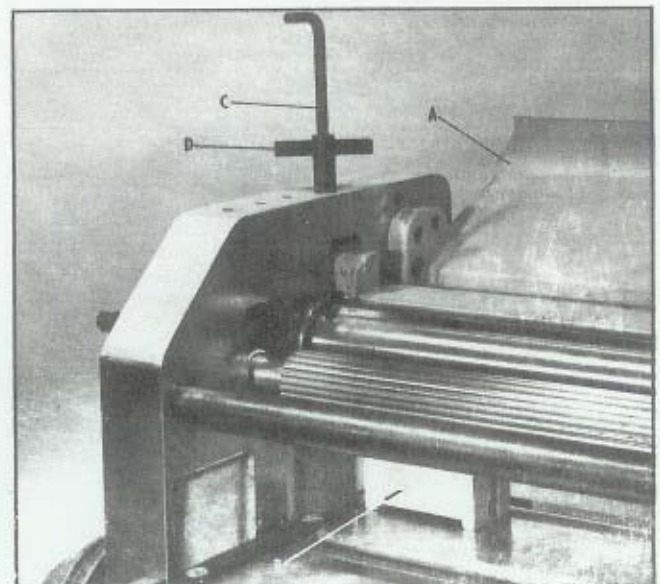


Fig. 13.

8. When the knives are jointed, ground or replaced, the pressure bar must be readjusted.

ADJUSTING FEED ROLLS

The feed rolls are those parts of your planer that feed the stock while it is being planed. They are under spring tension and will automatically raise or lower while the stock is being fed. The feed rolls are set $1/32''$ below the cutting circle as shown in Fig. 15.

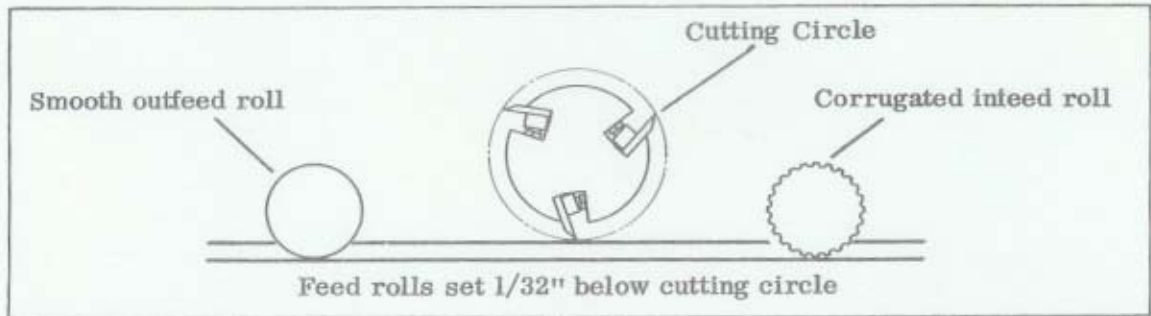


Fig. 15.

To check the feed rolls:

1. DISCONNECT THE PLANER FROM THE POWER SOURCE.
2. Turn the table raising and lowering handle counterclockwise one half turn to lower the table exactly $1/32''$
3. Place the gage block (A) Fig. 16, on the table under infeed roll (B) as shown. Check with the gage block on both the right and left side of the infeed roll.
4. If the roll must be raised or lowered, loosen the jam nut (C) Fig. 16, on the end of the infeed roll that is to be adjusted and with the $5/16''$ hex. wrench (D) rotate screw to raise or lower to desired setting and lock in position by tightening jam nut (C). NOTE: It might be necessary to remove the side panels of the planer for this adjustment.
5. Check the outfeed roll in the same manner as listed above.

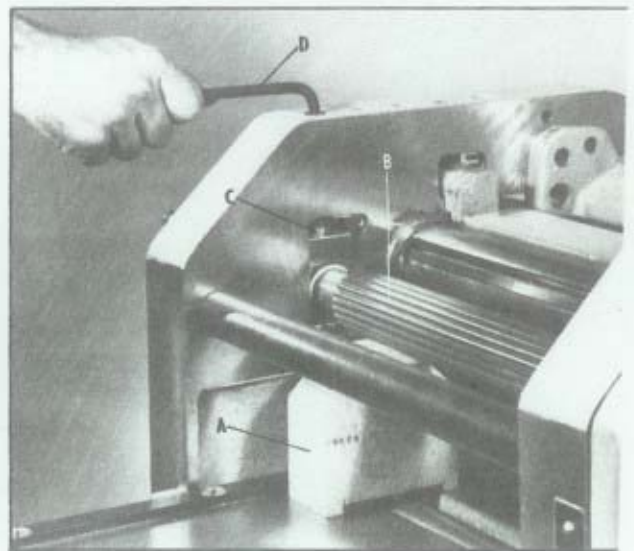


Fig. 16.

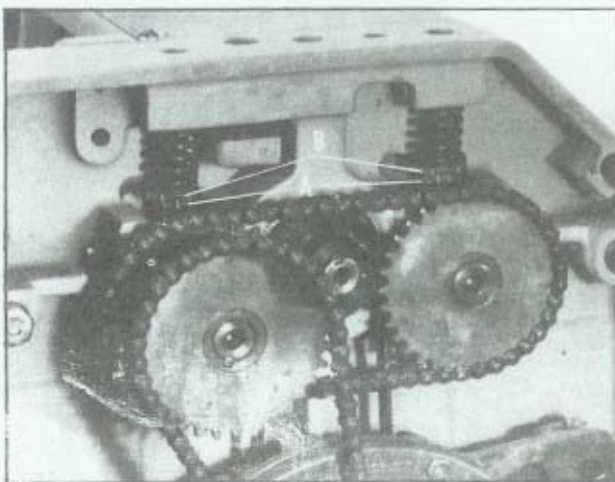


Fig. 17.

ADJUSTING SPRING TENSION OF FEED ROLLS

The feed rolls are under spring tension and this tension must be sufficient to feed the stock uniformly through planer without slipping and must be equal at both ends each roll. To adjust the spring tension of the feed roll

1. DISCONNECT PLANER FROM POWER SOURCE
2. Remove both side panels of the planer.
3. Loosen jam nut (A) Fig. 17, and rotate spring retainer (B) to increase or decrease spring tension.
4. Adjust the spring tension on the opposite end in the same manner.

ADJUSTING TABLE ROLLS

The table rolls are set parallel to and .003/.005 inches above the surface of the table. They aid in feeding the stock by reducing friction and turn as the stock is fed through the planer. When planing rough stock, it is good practice to set the bed rolls HIGH (.010" to .035"). When planing smooth stock and for average planing set the bed rolls LOW, approximately .005" above the bed.

To check and adjust:

1. DISCONNECT PLANER FROM POWER SOURCE
2. Lay a straight edge across both rolls and with a feeler gage, as shown in Fig. 18, check both the right and left sides of infeed and outfeed table to make sure both rolls are at an equal height and parallel to the bed.
3. If an adjustment is necessary, loosen nut (A) Fig. 18, underneath end of table roll that is to be adjusted and turn adjusting screw (B) until correct height of the table roll is obtained. Then tighten nut (A).

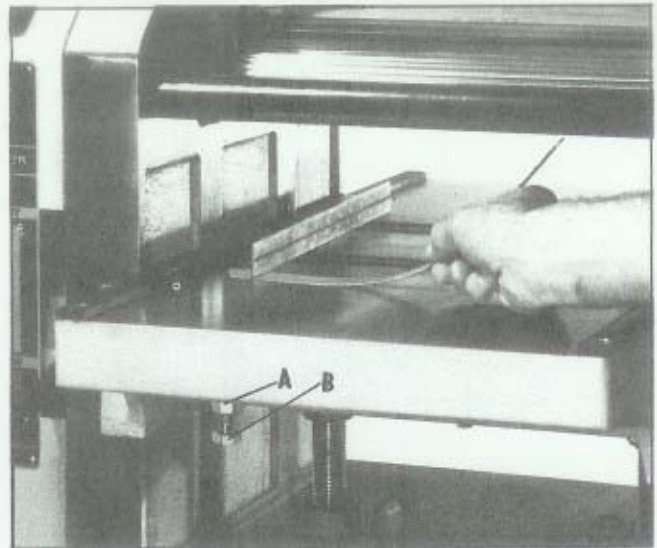


Fig. 18.

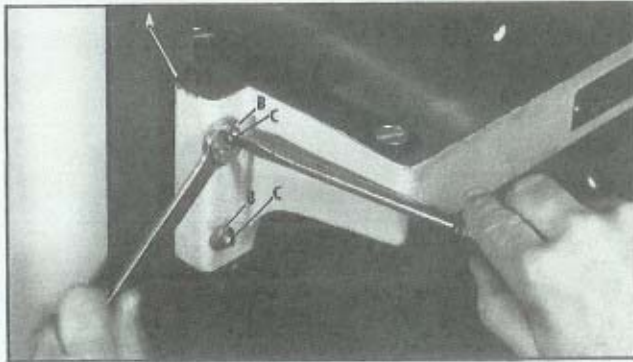


Fig. 19.

ADJUSTING TABLE GIBS

As the table raises and lowers, the table gib (A) Fig. 19, bears against the machined surfaces. Over a long period of time, these surfaces will wear. To compensate for this wear, the gibs must be adjusted.

1. If the table raises too freely, or if it fits loosely against the column, the gibs must be taken up.
2. Loosen locknuts (B) Fig. 19, and slightly tighten each screw (C) until the table can be moved without undue effort and there is no perceptible play between the table and column. Then tighten lock nuts (B).
3. If extra effort is required to move table, the gibs may be too tight. Loosen lock nuts (B) and loosen adjusting screws (C) until correct movement of the table is obtained and tighten lock nuts (B) Fig. 19.

CHIPBREAKER

The chipbreaker is the large casting on top of the planer. It raises as stock is fed through and "breaks or curls" the chips the same as the plane iron cap on a hand plane, as shown in Fig. 20. The chipbreaker requires no adjustment.

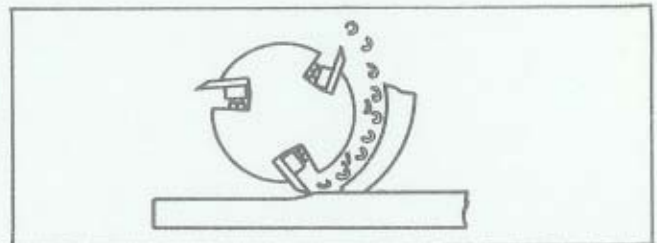


Fig. 20.

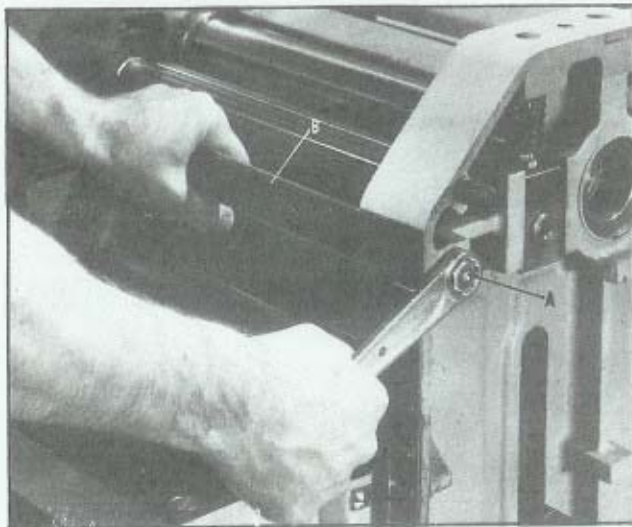


Fig. 21.

ADJUSTING DEPTH OF CUT

Your machine is factory set to cut 1/8" depth of cut. When a 5 H.P. motor is used, the planer can be adjusted to obtain 1/4" depth of cut.

1. DISCONNECT PLANER FROM POWER SOURCE.
2. Remove side panels of the planer.
3. Loosen screws (A) Fig. 21, on each end of the bar (B).
4. Rotate the bar 180 degrees and tighten screws (A) Fig. 21.

ADJUSTING BELT TENSION

The correct tension is obtained when the Polyflex belt on the planer can be flexed approximately $\frac{13}{32}$ inch out of line, using $3\frac{1}{2}$ to $4\frac{1}{2}$ pounds of pressure at the top of the planer base, as shown in Fig. 22.

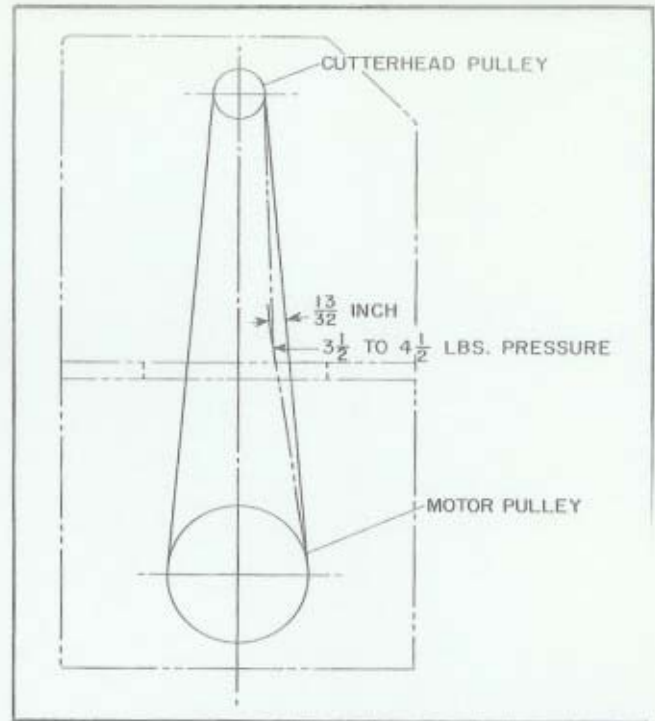


Fig. 22.

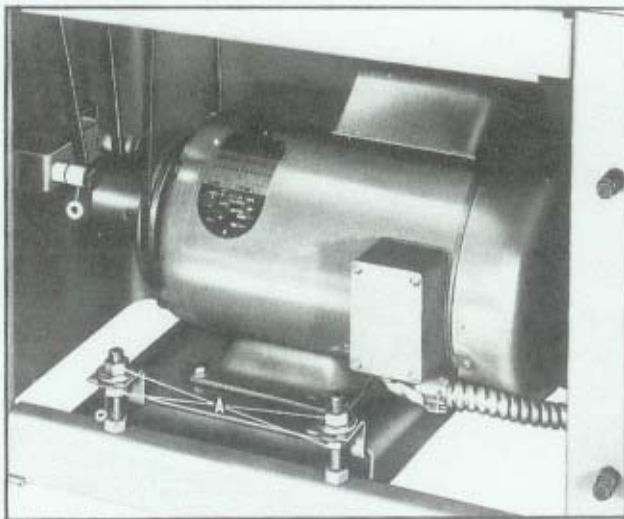


Fig. 23.

To adjust belt tension:

1. DISCONNECT PLANER FROM THE POWER SOURCE.
2. Move the motor mounting plate up or down, by adjusting hex nuts (A) 23, until correct tension is obtained.

ADJUSTING CUTTERHEAD KNIVES

If for any reason, the knives have to be adjusted in the cutterhead, proceed as follows:

1. DISCONNECT THE PLANER FROM THE POWER SOURCE, REMOVE THE CHIPBREAKER AND CUTTERHEAD GUARD SAFETY SCREW AND SWING THE CUTTERHEAD GUARD BACK OUT OF THE WAY.
2. Slightly loosen all of the knife screw (A) Fig. 24, by turning the screws clockwise using the special wrench (B).
3. Place the knife gage (C) over the knife as shown in Fig. 24 and turn the lifter screw with wrench (D) until the knife touches the gage.
4. Check all three knives at each end in the same manner and when you are certain the knives are adjusted properly, lock them in place by turning the knife screws (A) Fig. 24, counterclockwise to tighten the knives.

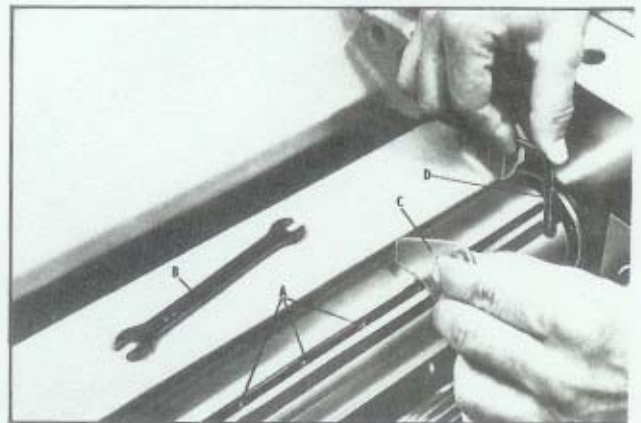


Fig. 24.

MAINTENANCE AND REPAIRS

REMOVING AND REPLACING THE CUTTERHEAD

The cutterhead can be readily removed should repairs or replacement be necessary. An extra cutterhead Rockwell Catalog No. 22-420, complete with knives, bearings and bearing housings can be installed so that production will not be interrupted.

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE.
2. Remove nuts (A) Fig. 25, and block up motor plate to release tension on the cutterhead belt (B).

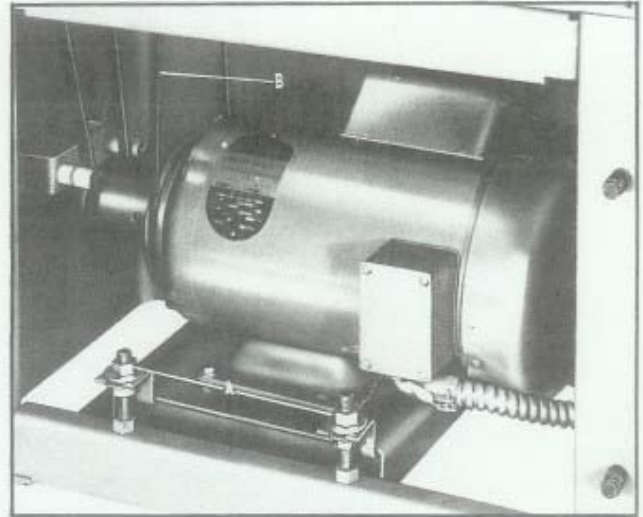


Fig. 25.

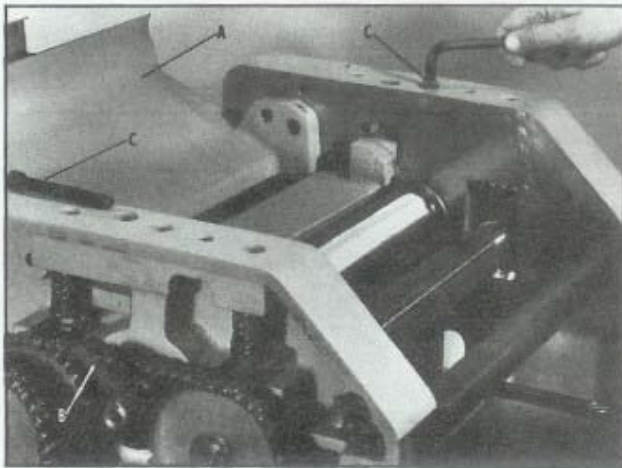


Fig. 26.

3. Remove the cutterhead guard safety screw and swing the cutterhead guard (A) Fig. 26, out of the way.
4. Remove side panel from the planer.
5. Remove cutterhead belt (B) Fig. 26, from the cutterhead pulley.
6. Remove the two socket head screws (C) Fig. 26, which hold the bearing housings.
7. Cover each knife with masking tape for protection.

8. Use heavy gloves for further protection and slide the cutterhead out of the right side of the planer as shown in Fig. 27.
9. Replace the cutterhead by reversing the above instruction.



Fig. 27.

REPLACING AND RESETTING THE CUTTERHEAD KNIVES

The knife blades in the cutterhead are set at the factory to a true cutting circle of 2-9/16". If the knife blades are removed or need adjusted in any way, care must be exercised in resetting them. To replace and reset the knife blades in the cutterhead, proceed as follows:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE.
2. Remove the chipbreaker and cutterhead guard safety screw and swing the cutterhead guard out of the way.
3. Loosen the nine knife screws (A) Fig. 28, by screwing them into the knife bar using the special wrench supplied.
4. Thoroughly clean the knife slots, knife bars and screws. Check the screws. If the threads appear worn or stripped or if the heads are becoming rounded, replace them.
5. Inspect the cutting edge of the knives for nicks or wire edge. Hone the knives slightly using a fine stone.
6. Insert the knife and knife bar in slot and back out the knife screws just enough to hold the knife. Refer to Fig. 28, for the distance the throat bar must be maintained from edge of knife blade to insure correct cutting action.

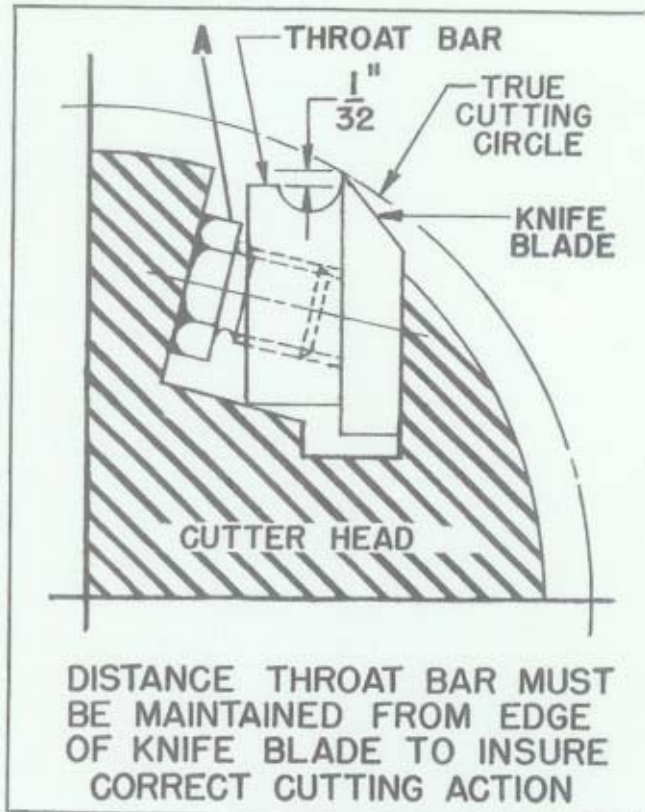


Fig. 28.

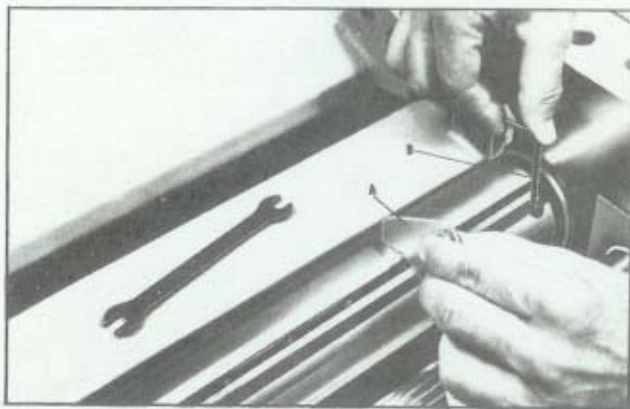


Fig. 29.

7. Place the knife gage (A) Fig. 29, over the knife and raise or lower knife by turning lifter screw with wrench (B) until the cutting edge of the knife touches the gage. Check both ends.
8. Reset the other two knives in the same manner.
9. After all three knives are set and rechecked carefully with the gage, adjust all knife screws to make sure they are tight.
10. The pressure bar will have to be rechecked and adjusted if necessary unless you are going to joint the knives.

REPLACING DRIVE CHAINS

If it becomes necessary to replace the chain due to wear, we recommend that both the chains and sprockets be replaced. When assembling a new chain, place it around the steel sprockets of the in-feed and out-feed rolls and connect its two ends together by installing the connecting link (A) Fig. 30, over the projecting ends (B) of the chain. Secure the connecting link (A) in place with the spring clip (C). The other chain is assembled in the same manner.

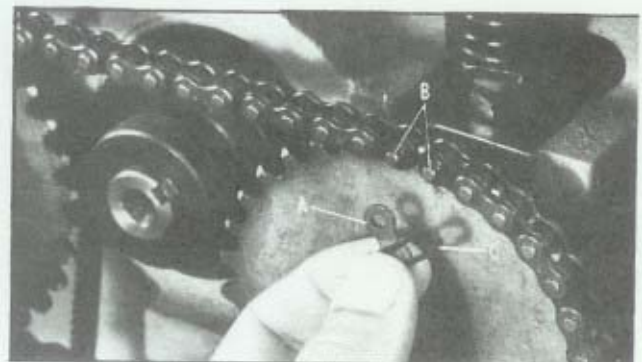


Fig. 30.

REPLACING BELTS

1. Remove two nuts (A) Fig. 31.
2. Raise up and place a block of wood under the motor mounting plate (B) Fig. 31, to release tension on the belts.
3. Remove belts (C) and (D) Fig. 31, from the motor pulley.

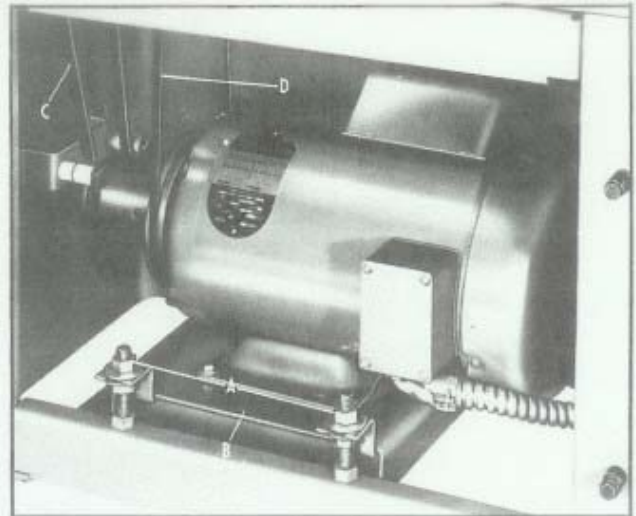


Fig. 31.

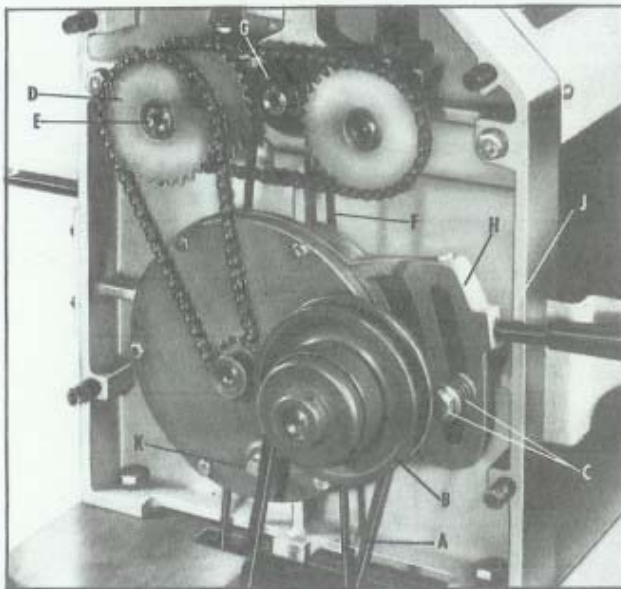


Fig. 32.

4. Remove belt (A) Fig. 32, from the variable speed pulley (B).
5. Remove cap screw, spring and washer (C) Fig. 32.
6. Remove set screw in sprocket (D) Fig. 32, and slide sprocket off shaft (E).
7. Remove cutterhead belt (F) from the cutterhead pulley (G) Fig. 32.
8. The cutterhead belt (F) Fig. 32, can now be removed from the machine by maneuvering the belt between the sliding gear box casting (H) and the frame (J).
9. Assemble the new belts by reversing the above instructions. Note that the variable speed belt (C) Fig. 31, is positioned on the pulley in such a way that the nylon rollers provide tension on the O.C. of the belt as shown in Fig. 31.
10. After the belts are assembled, replace sprocket (D), cap screw, spring and washer (C) Fig. 32, and adjust belt tension by following instructions under ADJUSTING BELT TENSION

LUBRICATION

Your planer is equipped with oil impregnated bronze bushings on all roller bearing blocks and should not require further lubrication.

The drive chains should be lubricated every six months with a good chain lubricant. Under severe applications lubricate the chains as required.

The table raising screws and gibs should be lubricated with grease as required.

The gear box should be filled to the oil level plug (K) Fig. 32, with SAE 140 or SAE 600-W Oil.

CLEANING THE MACHINE

The cutterhead, rollers and machined surfaces of the castings should be cleaned with Gum and Pitch Remover. Never use a sharp instrument to remove pitch accumulation.

The edge of the pressure bar which bears on the stock should also be kept free of pitch accumulation and chips so as not to score the finished surface of the stock.


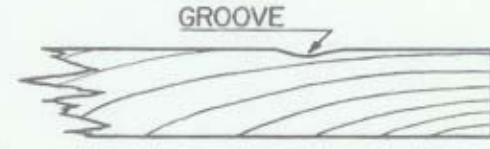
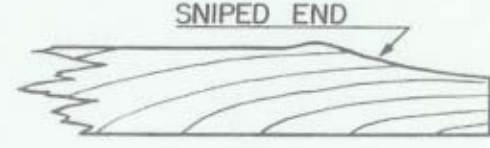

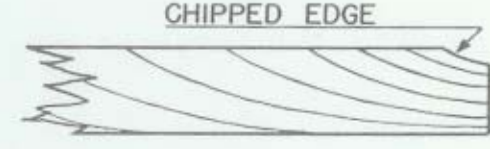
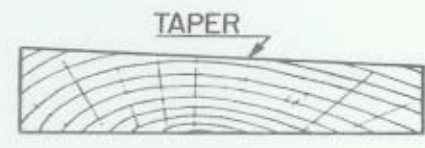
Blow out any chips which gather in the corners with an air hose.

Check motor frequently. Motor trouble usually develops from dirt and moisture. Make sure ventilating holes are clean so motor does not overheat.

TROUBLE SHOOTING GUIDE

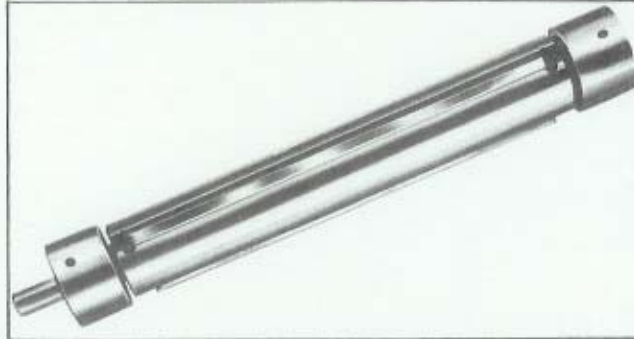
There are times when the cutterhead will make irregular or uneven cuts. This is usually a result of certain adjustments being out of line.

The most common of these and what to do to correct them are as follows:

①	<p>When a ridge appears on the work as shown, it indicates that the infeed table roll is too high. These rollers are set at the factory at .003/.005 inches above the level of the table. Refer to ADJUSTING TABLE ROLLS on page 11 to correct this condition.</p>	
②	<p>When a slight groove is cut in the planed surface as shown, it is known as a pressure bounce and indicates too great a pressure on the infeed roll. To correct this, relieve the pressure on the infeed roll by referring to ADJUSTING FEED ROLLS on page 10.</p>	
③	<p>When a piece of work is planed and the end cut is as shown, it is known as a sniped end. This indicates that the table is too loose and is corrected by tightening the table gibs. Refer to ADJUSTING TABLE GIBS on page 11.</p>	
④	<p>When the work shows feed roller marks as shown, the infeed roll pressure is too great and the pressure should be reduced by following instructions under ADJUSTING FEED ROLLS on page 10.</p>	
⑤	<p>When the stock is put through the machine wrong, i.e., against the grain, a chipped edge will result, as shown. Turn the wood around, end for end, so that the cutter will cut with the grain and you will obtain a nice, smooth, even cut.</p>	
⑥	<p>When the stock has a taper cut, that is from side to side, it indicates the table is not parallel to the cutterhead. In this case, adjust the table so that it is parallel to the cutterhead by referring to LEVELING TABLE on page 8.</p>	

ROCKWELL DELTA

13" x 6" PLANER ACCESSORIES



No. 22-420 Ball Bearing, 3-Knife Cutterhead. Includes 22-128 set of three H.S.S. knives, knife adjusting screws, bearings and bearing housings. 30 lbs.

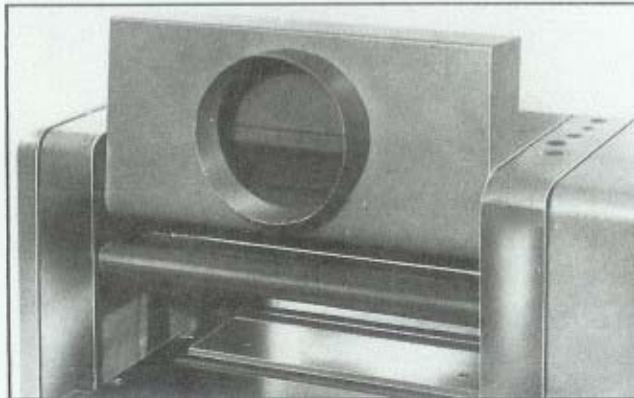
No. 22-128 High-Speed Steel Knives, extra set of three. 3 lbs.

No. 22-426 Knife Grinding and Jointing Attachment. Complete with 22-813 grinding wheel; $\frac{1}{2}$ HP, 115/230 V, 60 cycle, single phase motor and 115 V 8-foot cord with 3-prong grounding type plug. Allows you to grind new bevel edges on the planer knives without removing the cutterhead from the planer. 40 lbs.

No. 22-421 Knife Jointing Attachment. Complete with base and handles, guide bar, adjusting block and screw, and 22-423 fine jointing stone. 7 lbs.

No. 22-813 Grinding Wheel. Replacement for 22-426 Knife Grinding and Jointing Attachment. 2 lbs.

No. 22-423 Jointing Stone. Replacement for 22-426 and 22-421 Grinding and Jointing Attachments. 1 lb.

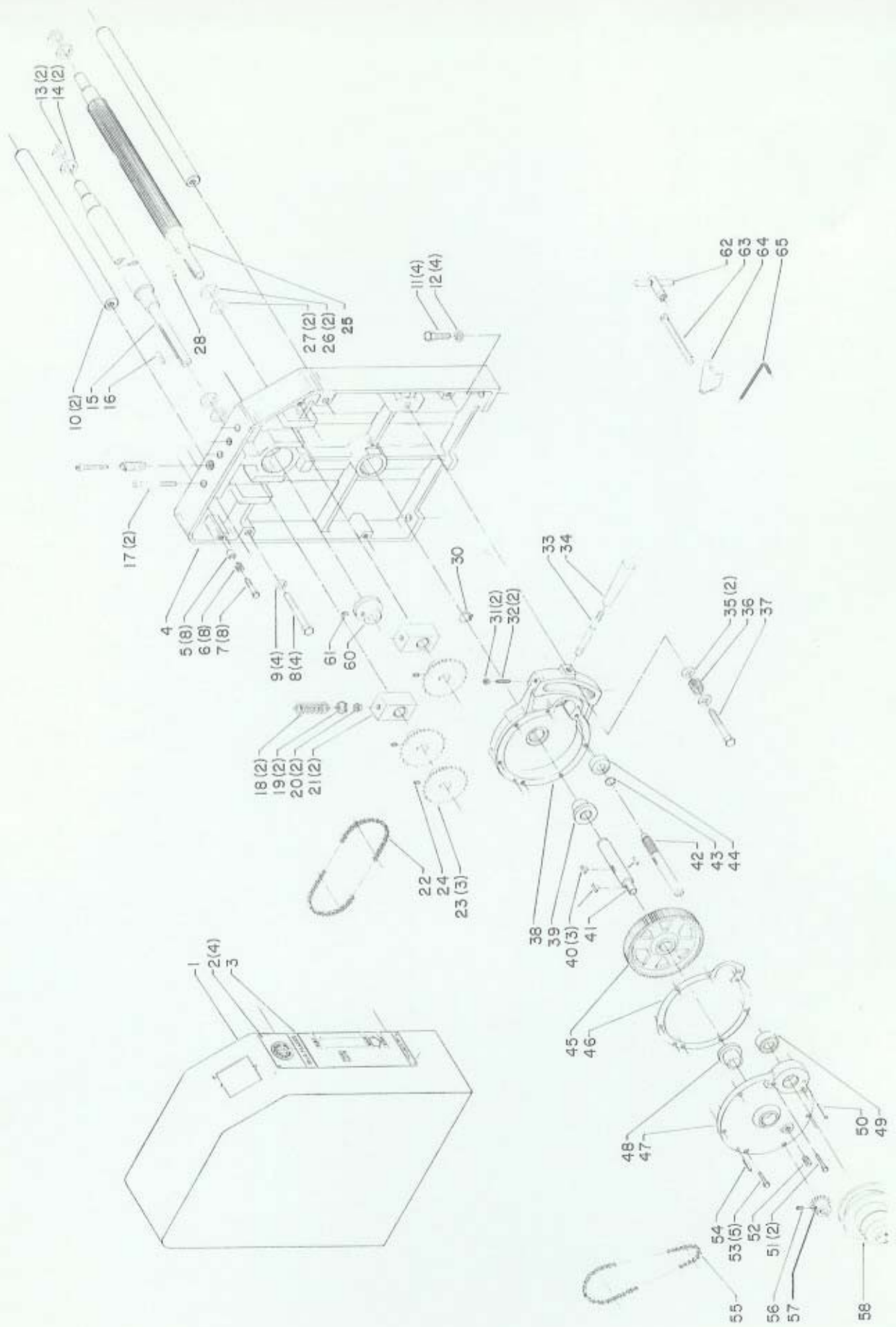


No. 22-422 Shaving Hood. For use only with dust vacuum system connecting to 6" diameter pipe. 7 lbs.

No. 22-424 Cutterhead Drive Belt, 7M Polyflex, 68.9" O.C. Included with basic machine. 2 lbs.

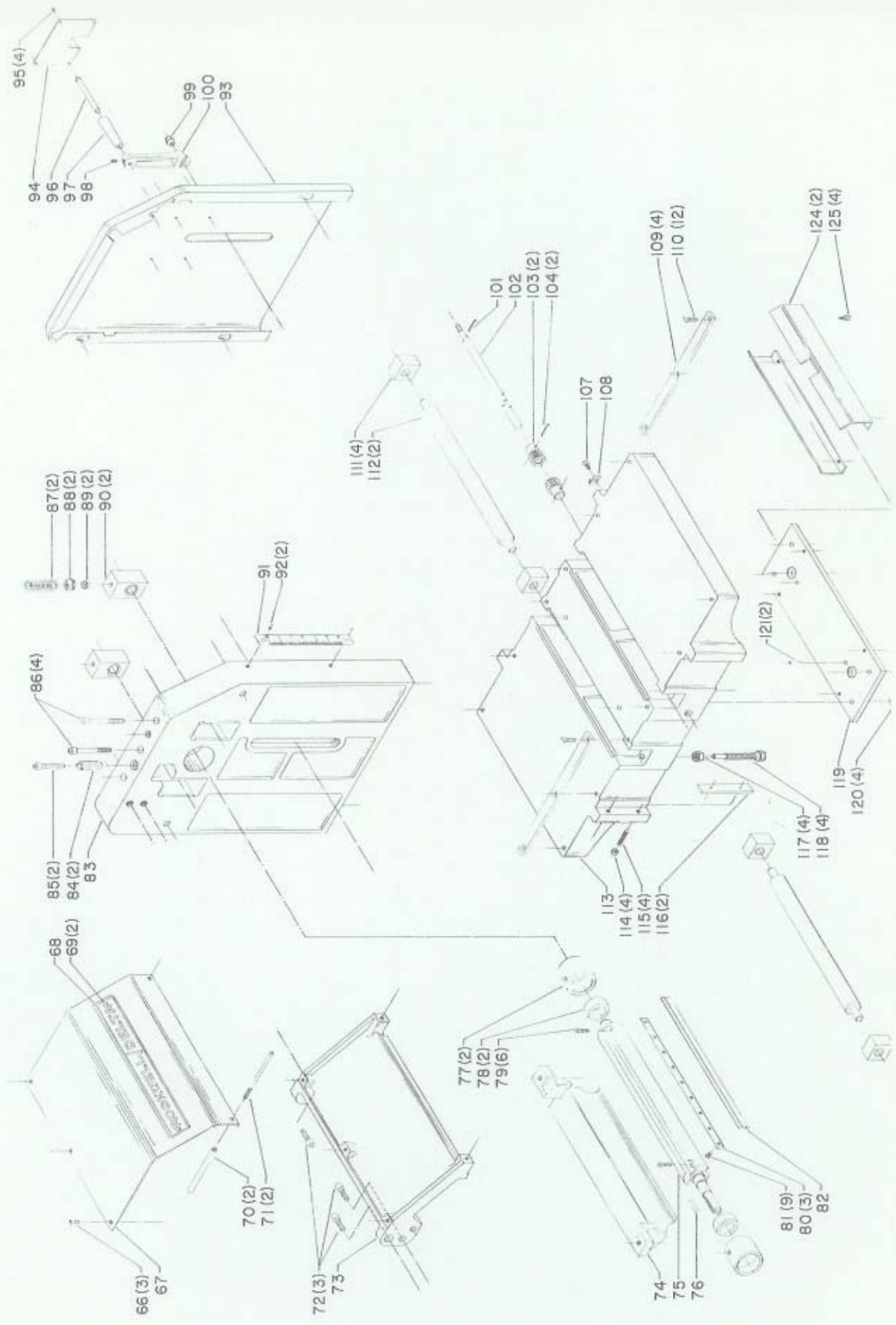
No. 49-169 Variable Feed Drive V-belt, 50" O.C. Included with basic machine. 2 lbs.

No. 22-425 Motor Pulley, special type, $1\frac{1}{2}$ " bore. Included with basic machine. 8 lbs.



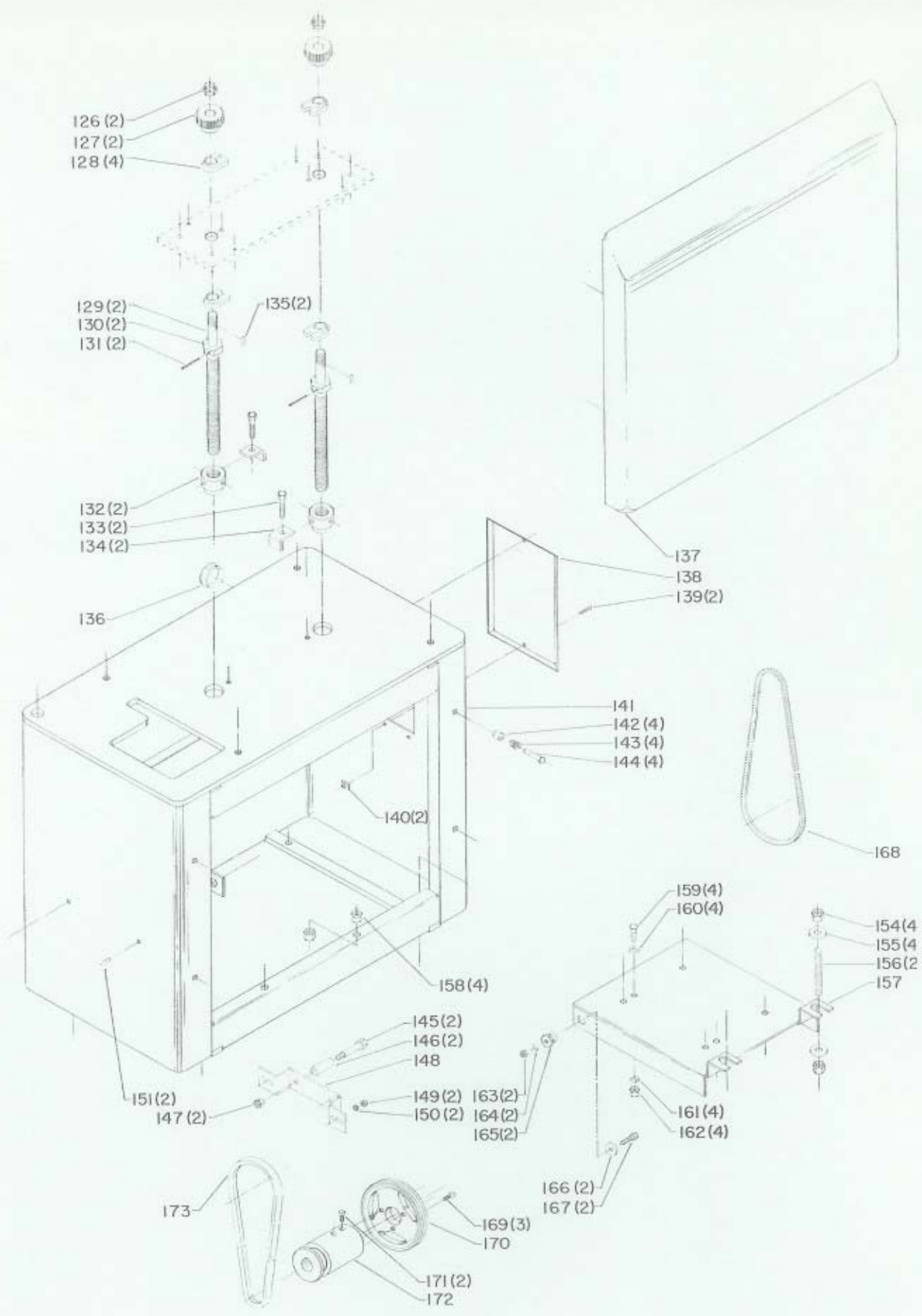
Replacement Parts

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	428-01-031-0021	Cover - L. H.	34	931-01-052-0472	Handle
2	SP-2250	#4 x 3/16" Drive Screw	35	SP-1636	17/32 x 1 1/16 x .095 Washer
3	428-01-072-0007	Feed Rate Plate	36	428-01-001-0003	Spring
4	428-01-049-0001	Frame - L. H.	37	SP-624	1/2 - 13 x 2 3/4" Hex. Hd. Scr.
5	428-01-017-0003	Bushing	38	428-01-313-0001	Gear Box, including:
6	NCS-33	Spring	39	428-01-017-0005	Bushing
7	428-01-112-0006	Special Scr.	40	927-01-010-2634	Woodruff Key
8	SP-3103	1/2 - 13 x 3 1/4" Hex. Hd. Scr.	41	428-01-106-0007	Shaft
9	SP-1705	1/2" Split Lockwasher.	42	428-01-051-0014	Pinion Gear
10	428-01-004-0007	Bar	43	SP-7008	Retaining Ring
11	SP-620	1/2 - 13 x 1 1/4" Hex. Hd. Scr.	44	SP-5335	Bearing
12	SP-1705	1/2" Lock Washer	45	428-01-051-0013	Gear
13	TAM-184	Wave Washer	46	428-01-116-0003	Gasket
14	HDP-122	Fiber Washer	47	428-01-331-0003	Gear Box Cover, including:
15	428-01-080-0007	Outfeed Roller	48	428-01-017-0005	Bushing
16	SP-2695	3/16 sq. x 1" Key	49	920-04-022-4027	Bearing
17	SP-777	3/8 - 16 x 3" Soc. Hd. Scr.	50	SP-2712	1/4 x 1 1/4" Roll Pin
18	928-01-601-8900	Spring	51	SP-614	1/4 - 20 x 1 1/4 Hex. Hd. Scr.
19	428-01-079-0012	Bushing	52	SP-2436	1/4" Sq. Hd. Pipe Plug
20	SP-1005	3/8" - 16 Hex. Jam Nut	53	SP-623	1/4 - 20 x 1" Hex. Hd. Scr.
21	428-01-317-0001	Block w/Bushing	54	SP-2720	1/4 x 1" Roll Pin
22	428-01-023-0001	Chain - 62 Pitches Lg.	55	428-01-023-0002	Chain - 64 Pitches Lg.
23	428-01-351-0005	Sprocket, including:	56	SP-205	5/16 - 18 x 1/4" Soc. Set Ser.
24	SP-205	5/16 - 18 x 1/4" Soc. Set Scr.	57	428-01-051-0018	Sprocket
25	428-01-080-0001	Infeed Roller	58	926-05-992-5534	Variable Speed Pulley
26	HDP-122	Fiber Washer	60	428-01-400-0002	Cutter Head Pulley, including:
27	TAM-184	Wave Washer	61	SP-205	5/16 - 18 x 1/4" Soc. Set Scr.
28	SP-2695	3/16 Sq. x 1" Key	62	428-01-301-0002	Wrench Assembly
30	SP-7025	Retaining Ring	63	Cat. #1522	Double End Wrench
31	SP-9152	1/4" - 20 Jam Nut	64	PLR-150	Gage
32	901-04-091-3640	1/4 - 20 x 1" H'dless Set Ser.	65	Cat. #1536	5/16" Hex. Wrench
33	428-01-111-0006	Stud			



Replacement Parts

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
66	SP-7528	1/4 - 20 x 1/2" Truss Hd. Scr.	94	428-01-072-0008	Thick/Thin Plate
67	428-01-031-0016	Cover	95	SP-2250	#4 x 3/16" Drive Scr.
68	960-02-012-1422	Nameplate	96	424-02-371-0002	Pin
69	SP-2250	#4 x 3/16" Drive Screw	97	931-01-051-6381	Handle
70	428-01-104-0004	Spacer	98	SP-208	1/4 - 20 x 1/4" Soc. Set Scr.
71	SP-912	1/4 - 20 x 4 1/2" Rd. Hd. Scr.	99	424-02-379-0002	Special Retainer
72	SP-775	3/8 - 16 x 1" Soc. Hd. Scr.	100	424-02-033-0004	Crank
73	428-01-036-0006	Deflector	101	SP-2732	5/32 x 1" Roll Pin
74	428-01-060-0003	Pressure Bar	102	428-01-106-0008	Shaft
	Cat. #22-420	Cutter Head Assembly, consisting of:	103	428-01-051-0017	Gear
75	428-01-057-0002	Cutter Head	104	SP-2706	3/16 x 1" Roll Pin
76	SP-2695	3/16 sq. x 1" Key	107	SP-7528	1/4 - 20 x 1/2" Truss Hd. Scr.
77	428-01-060-0002	Bearing Holder	108	951-01-021-7019	Pointer
78	SP-5360	Bearing	109	428-01-055-0007	Guide
79	SP-8013	1/4 - 20 x 3/4" Flat Soc. Hd. Scr.	110	SP-408	5/16 - 18 x 3/4" Flat Hd. Scr.
80	PIR-59-S	Lock Bar, including	111	428-01-317-0002	Table Block w/Bushing
81	J-23	Special Scr.	112	428-01-080-0008	Table Roller
82	Cat. #22-128	Set of 3 Knives	113	428-01-091-0002	Table
83	428-01-049-0002	Frame - R. H.	114	SP-1228	5/16 - 24 Hex. Jam Nut
84	428-01-112-0008	Screw for Pressure Bar	115	PIR-113	5/16 - 24 x 1 1/2" H'dless Set
85	SP-774	3/8 - 16 x 2" Soc. Hd. Scr.	116	428-01-052-0003	Gib
86	SP-777	3/8 - 16 x 3" Soc. Hd. Scr.	117	SP-1227	1/2" - 20 Jam Nut
87	928-01-601-8900	Spring	118	428-01-112-0009	Special Scr.
88	428-01-079-0012	Bushing	119	428-01-072-0001	Plate
89	SP-1005	3/8" - 16 Hex. Jam Nut	120	SP-607	5/16 - 18 x 3/4" Hex. Hd. Scr.
90	428-01-317-0001	Block w/Bushing	121	SP-6721	1/4 x 7/8" Roll Pin
91	428-01-072-0006	Depth Scale	124	428-01-031-0022	Plate Cover
92	SP-561	#10-32 x 3/8" Rd. Hd. Scr.	125	SP-611	1/4 - 20 x 1/2 Hex. Hd. Scr.
93	428-01-031-0020	Cover - R. H.			



Replacement Parts

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
126	SP-1036	3/4" - 16 Stop Nut	150	SP-1757	1/4" External Tooth Washer
127	428-01-051-0016	Gear	151	SP-7528	1/4-20 x 1/2" Truss Hd. Scr.
128	428-01-017-0004	Bushing	154	SP-1028	1/2" - 13 Hex. Nut
129	428-01-412-0001	Screw Assembly, including:	155	SP-1618	9/16 x 1 3/8 x 12 ga. Washer
130	428-01-104-0008	Spacer	156	901-07-120-8416	1/2 - 13 x 3 1/2" Stud
131	SP-2730	3/16 x 1 1/2" Roll Pin	157	428-01-372-0002	Motor Plate
132	428-01-079-0011	Retainer	158	SP-1028	1/2" - 13 Hex. Nut
133	SP-617	3/8 - 16 x 1 1/2" Hex. Hd. Scr.	159	SP-640	3/8 - 16 x 3/4" Hex. Hd. Scr.
134	428-01-027-0001	Clamp	160	SP-1615	13/32 x 13/16 x 1/16" Washer
135	927-01-010-2634	Woodruff Key	161	SP-1704	3/8" Split Lock Washer
136	438-01-011-0020	Plastic Bushing	162	SP-5900	3/8" - 16 Hex. Nut
137	428-01-031-0019	Front Cover	163	SP-5435	5/16" - 18 Hex. Jam Nut
138	438-01-021-0130	Box Cover	164	SP-1703	5/16" Split Lock Washer
139	SP-541	#10 - 24 x 7/8" Rd. Hd. Scr.	165	428-01-017-0001	Bushing
140	428-01-079-0013	Speed Nut	166	904-01-031-0017	21/64 x 1 1/16 x 3/32" Washer
141	428-01-318-0001	Cabinet	167	SP-649	5/16 - 18 x 1" Hex. Hd. Scr.
142	428-01-017-0003	Bushing	168	Cat. #22-424	Cutter Head Drive Belt
143	NCS-33	Spring		Cat. #22-425	Motor Pulley Assy., consisting of:
144	428-01-112-0006	Special Screw	169	SP-8013	1/4 - 20 x 3/4" Flat Soc. Hd. Scr.
	428-01-314-0001	Idler Bracket, consisting of:	170	428-01-100-0002	Pulley
145	428-01-111-0002	Stud	171	SP-302	5/16 - 18 x 1/2" Sq. Hd. Set Scr.
146	428-01-080-0009	Roller	172	428-01-100-0001	Pulley, 1 1/8" Bore
147	SP-1026	3/8" - 16 Hex. Nut	173	Cat. #49-169	Variable Feed Drive Belt
148	428-01-014-0014	Bracket			
149	SP-1034	1/4" - 20 Hex. Nut			



YOUR ROCKWELL WARRANTY

Rockwell is proud of the quality of the power tools which it sells. The component parts of our tools are inspected at various stages of production, and each finished tool is subjected to a final inspection before it is placed in its specially designed carton to await shipment. Because of our confidence in our engineered quality, Rockwell agrees to repair or replace any part or parts of Rockwell Power Tools or Rockwell Power Tool Accessories which examination proves to be defective in workmanship or material. In order to take advantage of this guarantee, the complete portable power tool or accessory, or in the case of machinery, the part must be returned prepaid to the appropriate factory, Rockwell service center, or authorized service station for examination. This guarantee, of course, does not include repair or replacement required because of misuse, abuse, or normal wear and tear. Repairs made by other than our factory, service center, or authorized service station, relieves Rockwell of further liability under this guarantee. THIS GUARANTEE IS MADE EXPRESSLY IN PLACE OF ALL OTHER GUARANTEES OR WARRANTIES, EXPRESS OR IMPLIED, WITH RESPECT TO QUALITY, MERCHANTABILITY, OR FITNESS FOR A PARTICULAR PURPOSE.