

## 10" HIGH SPEED HACKSAWING MACHINE

MADE IN ENGLAND

PATENT APPLIED FOR

- ★ Hydraulic feed control.
- ★ Two speeds with automatic cut-out at completion of operation.
- ★ Drive by twin Vee belts and helical gears.
- ★ Motor and drive completely built in to machine.

The VELOX 10" capacity Hacksaw has been designed to meet the demand for a small robust machine capable of cutting quickly, accurately and economically. Production has been planned with a view to economy in order to offer them at an attractive price. They are built for continuous duty and have a clean modern appearance. Controls are simple and easy to operate and an automatic cut-out operates at the completion of an operation when the bow has returned to the top position.

**THE BED** is a rigid box-shaped casting with a wide trough for collection of returning coolant and swarf. It also houses the motor and initial vee belt drive, as well as the vane type coolant pump and removable coolant tank.

**THE SAW BOW.** Wide prismatic guides ensure absence of twist and give a parallel cut. A gib is fitted for adjustment of the guides should wear be apparent after long usage. Both crank pins are mounted in self-aligning ball bearings.

**THE DRIVE** is from the enclosed motor by twin vee belts and helical gears. The pulley shaft and main drive shaft run in ball bearings to eliminate friction. The vee belt drive is arranged on stepped pulleys to provide two cutting speeds of 75 and 100 strokes per minute.

- ★ Automatic raise and lower of bow.
- ★ Prismatic bow guides.
- ★ Modern stream-lined design manufactured to precision limits.
- ★ Angular cuts up to 45°.

**TWO SPEEDS** are provided and the following is recommended :—

|                   |                                                                          |
|-------------------|--------------------------------------------------------------------------|
| <b>Low Speed</b>  | for High Speed Steel, Stainless and High Tensile Alloy Steel, Cast Iron. |
| <b>High Speed</b> | for Mild Steel, Brass, Bronze, Copper, etc.                              |

**THE FEED OF THE SAW** is hydraulically controlled from a small lever on the dashpot, and adjacent lever giving automatic raise and lower. Cutting takes place on the pull stroke but can be arranged so take place on the push stroke, so that the whole of the blade may be used. On the return stroke the saw blade is automatically lifted from the work.

**THE VICE** is of exceptionally robust construction and adjustable along the bed to centralize the work of varying size relative to the saw stroke. Both jaws may be swivelled for angular settings up to 45°, the back jaw being clamped in position by three tie bolts. The vice jaws can be removed to enable the use of special work-holding fixtures.

**A BAR SUPPORT STAND** is available as extra equipment, and this is necessary when sawing long lengths of material.

## SPECIFICATION

|                                                   |                   |                   |
|---------------------------------------------------|-------------------|-------------------|
| Cuts round material up to a dimension of .. .. .  | 10" diam.         | 254 mm. diam.     |
| Angular cuts at 45° up to .. .. .                 | 5" square         | 127 mm. carré     |
| Length and breadth of saw blade .. .. .           | 18" x 1½"         | 457 x 38 mm.      |
| Cuts square material up to a dimension of .. .. . | 9" x 9"           | 229 x 229 mm.     |
|                                                   | 7½" x 11½"        | 190 x 292 mm.     |
| Cutting speeds .. .. .                            | 75 and 100 s.p.m. | 75 and 100 c.p.m. |
| Length of stroke .. .. .                          | 5"                | 127 mm.           |
| Power required .. .. .                            | 1½ h.p.           | 1½ ch.            |
| Motor speed .. .. .                               | 1400 r.p.m.       | 1400 tr/mn.       |
| Net weight (approx.) .. .. .                      | 840 lb.           | 381 kg.           |
| Gross weight (approx.) .. .. .                    | 1008 lb.          | 458 kg.           |
| Case dimensions .. .. .                           | 50" x 26" x 42"   | 0.91 m³           |
| Code word .. .. .                                 | VENAU             | VENAU             |

**STANDARD EQUIPMENT.** Coolant pump and tank, one saw blade, set of spanners, vice, tommy bar, grease gun, operating instruction book.

**EXTRA EQUIPMENT.** Bar support stand, H.S.S. blades.

# Power Hacksaw Manual

**United States Department of the Army**

A red circular graphic with a gradient, appearing as a stylized arrow or a light effect, positioned to the right of the text 'United States Department of the Army'.

## **Power Hacksaw Manual:**

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