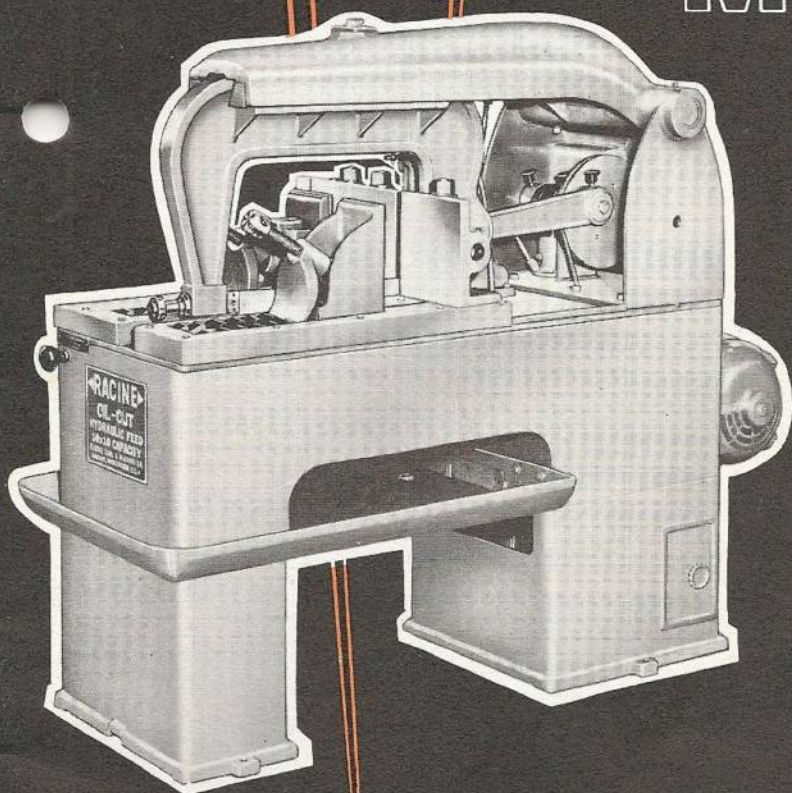




METAL CUTTING MACHINES



RACINE HYDRAULICS, INC.

1524 FREDERICK STREET RACINE, WISCONSIN

RACINE

IS THE LEADER IN PROGRESSIVE DEVELOPMENT OF
METAL CUTTING MACHINES SINCE 1906

IMPROVED DESIGN

Racine has continued to keep pace with the evolution of the art of parting metals by redesigning saws with more strength, more precision and more power year after year. As many as 25 major improvements have been made on some models in the past few years.

After extensive research it was determined that a Hydraulic Progressive "Shear-Cut" type of feed was the most ideal to obtain a clean cut with maximum blade and machine life.

CORRECT CUTTING PRINCIPLE

When cutting the full range of metals it is essential that the proper rate of feed be predetermined to get fast accurate cuts with the longest blade life. A simple, ingenious device is provided on all Racine Saws to hydraulically regulate the rate of feed and obtain the most efficient cutting. The blade is applied only as fast as the metal is removed and therefore remains sharper for a longer period to produce smooth straight blanks requiring less machining on subsequent operations.

HYDRAULIC ACTION ADVANTAGES

Hydraulic action on any machine tool produces a much smoother operation than mechanical means especially on a reciprocating type. Less moving parts are required thereby reducing maintenance costs through the years of service. Since the blade is correctly applied with an accurately controlled hydraulic feed, a Racine Saw will cut faster, straighter and last longer.

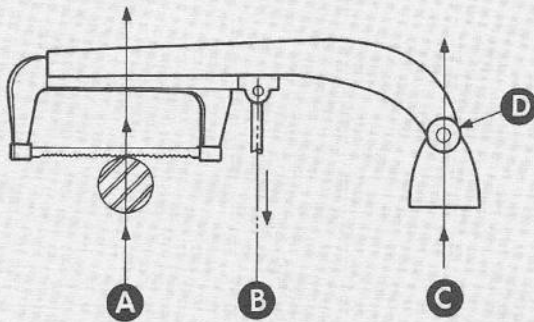
RACINE HYDRAULICS, INC.
1215 N. KILBURN STREET, RACINE, WISCONSIN

DESIGN ADVANTAGES

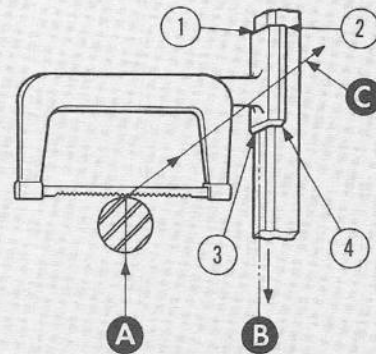
Racine "Pivoted Arm" Construction

VERSUS

"Horizontal Arm" Construction



With D as the pivot point and B the direction of feed pressure, it is apparent that opposing pressures will be straight up at A and C. Pressure from material is taken directly by saw frame slide bearing and by non-rotating pivot bearing, which never requires take-up or adjustment.

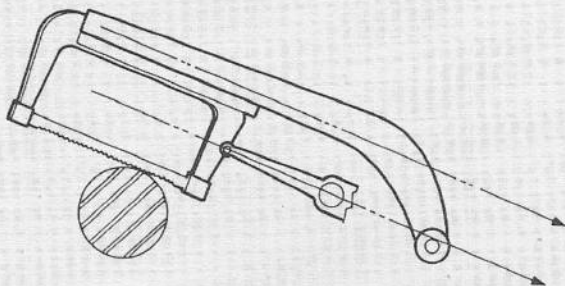


In this construction, feed pressure at B is downward. Opposing pressure at A is upward but is transmitted at right angles to C and upright column bearings, in such a manner as to cause a cocking or binding tendency. Bearings at 1, 2, 3 and 4 are subject to wear and require adjustment.

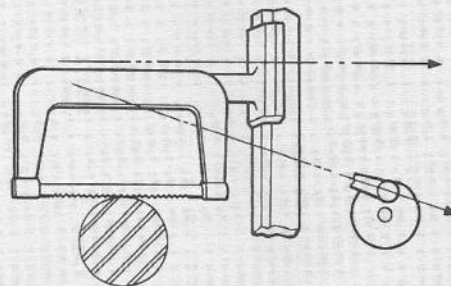
Racine "Straight Line" Connecting Rod Pull

VERSUS

"Angular" Connecting Rod Pull



Arrows show that direction of a saw frame movement and connecting rod pull are practically in the same plane. This tendency of two lines to remain parallel exists at any height of the saw arm as it passes through its arc. Construction permits connecting rod to be attached in a straight line with the saw frame and not at one side.



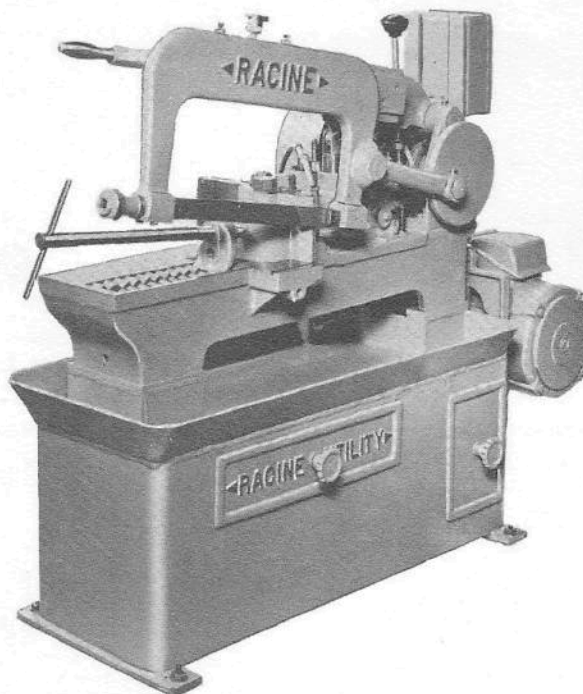
Line of travel of reciprocating frame is obviously at an angle to the line of connecting rod pull. Thus, connecting rod must be attached at the side of saw frame.

Angle of deviation between these two lines will vary according to the height of the saw arm in its vertical, unpivoted movement.

Ninety percent of all metal cutting reciprocating saws are used for the cutting of bar stock. Racine engineers, through years of research, found it desirable to incorporate in the construction of Racine Hydraulic Saws, two basic principles of construction—"Pivoted Arm" and "Straight Line" connecting rod pull.

RACINE

has "The saw for your needs"



MODELS
66W2 - 66W4 - 66D2

LOW INVESTMENT - HIGH EFFICIENCY

The smallest saw in the Racine line but, by far, not the least. This inexpensive modern shop saw is designed for all around metal cutting in the Tool Room, Crib, Maintenance Department or Production Plant. Supplementing higher priced production machines, it will do all cutting, from tough tool steel and dies to mild bars, tubing and structural shapes. All this is accomplished with the simplified Racine Hydraulic Feed Control and correct design.

CABINET BASE, WET CUT

The principle of operation and working parts of Dry Cut and Wet Cut types of machines are the same except that the Wet Cut machines run at higher speeds and have large cabinet base for coolant reservoir and coolant pump. Wet cut models are equipped with a two-speed V-belt drive or a four-speed gear shift drive. This drive is an integral part of the motor, completely enclosed with hardened steel gears running in oil and ball bearings free from dust, grit and dirt.

We recommend the four-speed model for cutting tough Alloys, tool Steels and high-speed steels and the two-speed model for general shop maintenance and auxiliary cutting.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

RACINE, WISCONSIN

specifications

	DRY CUT	WET CUT
Rated capacity	6" x 6"	6" x 6"
Actual capacity	6-5/8" Rd.	6-5/8" Rd.
Capacity at 45°	6" x 4"	6" x 4"
Blades, all models	14" long, 1-1/4" wide	4 or 6 teeth per inch
Stroke	5"	5"
Speeds - (2-speed models)	70 and 100 S.P.M.	100 and 140 S.P.M.
Speeds with transmission (4-speed models)		35-70-100-140 S.P.M.
Motor A.C. or D.C.	1 H.P. 1200 R.P.M.	1 H.P. 1200 R.P.M.
Motor characteristics 25 or 50 cycle AC	1 H.P. 1450 R.P.M.	1 H.P. 1450 R.P.M.
Floor space, motor driven	15" x 48"	17" x 48"
Height from floor to top of table	21"	21"
Shipping weights, 2-speed	550 lbs.	615 lbs.
Shipping Weight, 4-speed		630 lbs.

NOTE - 4-speed machines must be equipped with a motor at our plant. This motor will include a four-speed gearshift drive, 1-1/3 H.P. Standard or 1-1/2 H.P. Special.

TWO-SPEED MOTOR DRIVE . . . Motor at rear of machine mounted on adjustable platform for belt take-up.

FOUR-SPEED MOTOR DRIVE . . . Lima 4-speed motor on adjustable platform for belt take-up.

SAW FRAME AND GUIDE . . . The guide arm on which the saw frame slides is a rectangular cast iron bar giving exceptionally wide bearing surface.

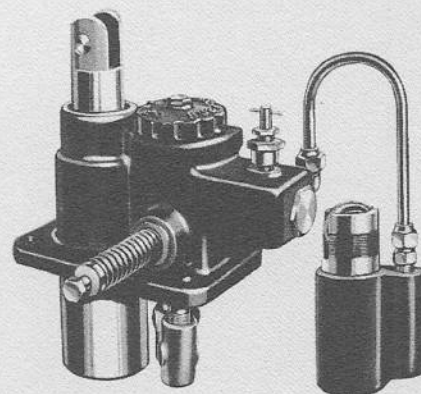
SWIVEL VISE . . . is quick acting - self-positioning type for cutting any angle up to 45°.

BEARINGS . . . Extra large bronze bushings - accurately press fitted.

HEIGHT GAUGE . . . Adjustable - limits height to which saw frame will rise.

STOCK GAUGE . . . for cutting multiple pieces of same length - substantially built - readily adjustable.

AUTOMATIC KNOCKOUT . . . At the completion of each cut - the motor is stopped and the saw frame automatically rises to its highest point.

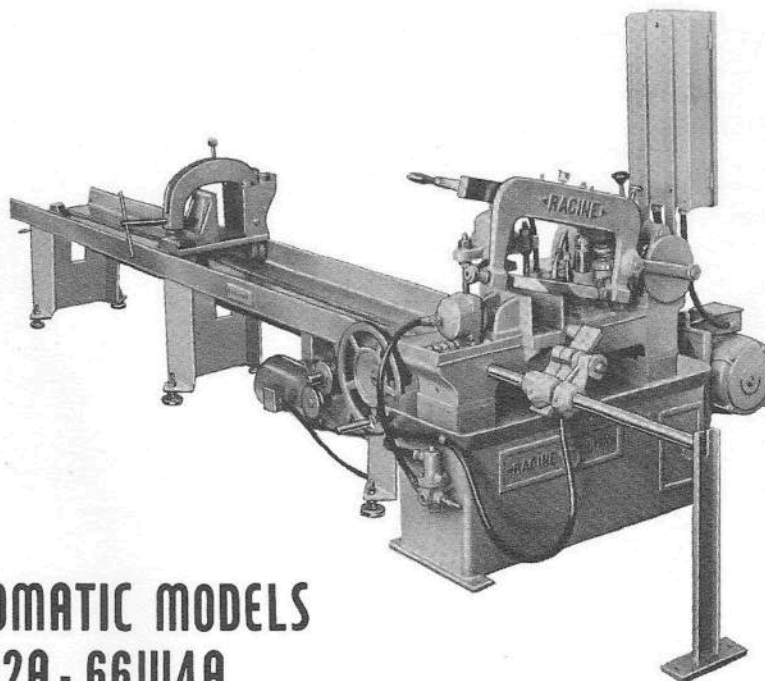


HYDRAULIC SYSTEM

The hydraulic feed and control system is built into a simple, compact assembly readily removable. The system is leak-proof and packless - all interior parts are self-lubricated - there is nothing to wear or get out of adjustment. To exert feeding pressure, a simple piston pump supplies oil under pressure to the main feed cylinder. Pressures are controlled by a single graduated dial. The rate of feed is controlled by a throttling valve. This design provides a simple, trouble free, oil-cushioned operation with longer life of blades and greater accuracy.

RACINE

has "The saw for your needs")



AUTOMATIC MODELS 66W2A - 66W4A

COST SAVING AUTOMATIC

In any manufacturing plant large or small the major cost item is labor. This Racine automatic metal cutting machine will increase labor efficiency by releasing the operator to use his skills on work that requires his constant attention. The saw works on automatically -- just set it and forget it!

Here is an inexpensive automatic machine that will saw all types of materials accurately. Length setting is done quickly and lengths can be held within .005 of an inch. For one and two piece lots the saw can be converted to manual operation in seconds.

There are jobs for this machine in every manufacturing plant in the country.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

RACINE, WISCONSIN

specifications

CAPACITY Rated - 6" x 6" Actual 6-5/8" Diameter
 STROKE 5"
 BLADES . . 14" long x 1-1/4" wide x .062 gauge x 6 or 10 teeth per inch
 14" long x 1-1/2" wide x .075 gauge x 4 teeth per inch
 NET . . . 66W2A Two Speeds, Arranged for motor, w/o motor, 1635#
 WEIGHTS . . 66W2A Two Speeds, Complete with standard motor, 1665#
 66W4A Four Speeds, Complete with Lima Drive, 1680#
 SPEEDS 66W2A 100 and 140 strokes per minute
 66W4A 4-speed Lima Drive, 35-70-100-140 strokes per min.
 STOCK FEED Length, standard 10 feet
 STOCK FEED MOTOR Geared Head 1/6 H.P., 3-Phase
 16 RPM at Takeoff Shaft
 LENGTH OF STOCK (Gauge Setting) . . Minimum - 0; Maximum - 18"
 SPEED OF CARRIAGE 7 feet per minute
 SPEED OF COMPLETE CYCLE with 1" Pushup 1 second
 VISE STD. MACHINE Automatically Air Operated.
 Requires separate 70 psi air supply

TWO-SPEED MOTOR DRIVE . . . 1 H.P. Motor at rear of machine
 mounted on adjustable platform for belt take-up.

FOUR-SPEED MOTOR DRIVE . . . 1-1/3 or 1-1/2 H.P. Lima 4-speed
 motor on adjustable platform for belt take-up.

SAW FRAME AND GUIDE . . . The guide arm on which the saw
 frame slides is a rectangular cast iron bar giving exceptionally wide
 bearing surface.

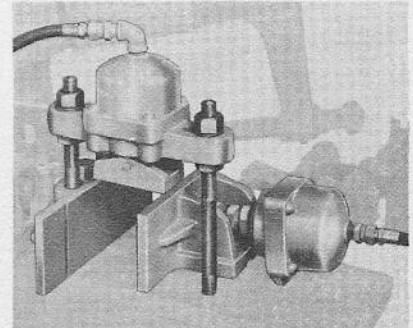
VICES . . . 6" high on both machine and stock rest carriage.

BEARINGS . . . Extra large bronze bushings - accurately press fitted.

HEIGHT GAUGE . . . Adjustable - limits height to which saw frame
 will rise.

STOCK GAUGE . . . for cutting multiple pieces of same length -
 substantially built - readily adjustable.

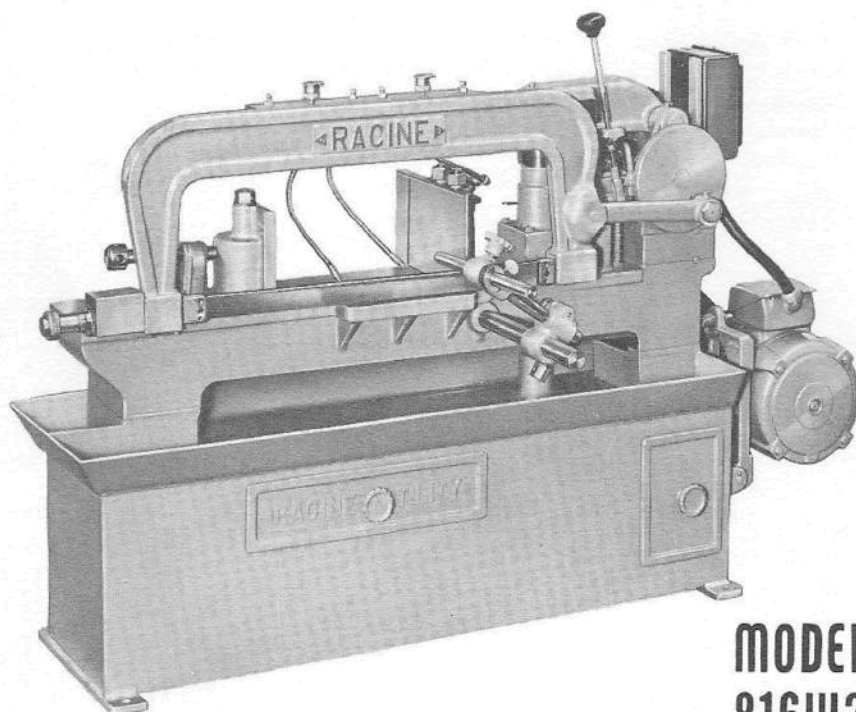
AUTOMATIC KNOCKOUT . . . At the completion of each cut -
 the motor is stopped and the saw frame automatically rises to its
 highest point.



Air operated clamps for single
 bars or bundled material are
 standard equipment. Require a
 70#-100# air supply.

RACINE

has "The saw for your needs"



**MODELS
816W2 - 816W4**

LOW COST . . . LARGE CAPACITY

The Model 816 is an inexpensive saw with a large capacity - built to handle the full range of general cut-off work from tough tool steel and dies to mild steel, tubing and structural shapes up to 8" x 16". Once again, the simplified hydraulic feed arrangement enables Racine to offer a machine that will handle material of this size which will consistently produce fast, accurate cuts with maximum blade life.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

RACINE, WISCONSIN

specifications

Rated Capacity	8" x 16"
Capacity at 45°	8" x 10-1/2"
Blades	24" long x 6 teeth per inch 21" long x 6 teeth per inch
Stroke	5"
Speeds - 2-speed model	100 and 140 SPM
Speeds - 4-speed model	35, 70, 100 and 140 SPM
Motor - 2-speed model	60 cycle, A.C. and D.C. 1 H.P., 1200 RPM
Motor - 4-speed model	60 cycle, A.C. and D.C. 1-1/3 H.P., 1200 RPM, gear shift drive
Floor space	24" x 64"
Height from floor to top of table	21-1/4"
Shipping weight - 2-speed model	800 lbs.
Shipping weight - 4-speed model	825 lbs.

TWO-SPEED MOTOR DRIVE . . . Motor at rear of machine mounted on adjustable platform for belt take-up.

FOUR-SPEED MOTOR DRIVE . . . Lima 4-speed motor on adjustable platform for belt take-up.

SAW FRAME AND GUIDE . . . The guide arm on which the saw frame slides is a rectangular cast iron bar giving exceptionally wide bearing surface.

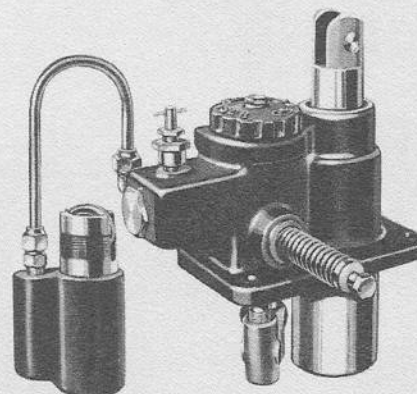
SWIVEL VISE . . . is quick acting - self-positioning type for cutting any angle up to 45°.

BEARINGS . . . Extra large bronze bushings - accurately press fitted.

HEIGHT GAUGE . . . Adjustable - limits height to which saw frame will rise.

STOCK GAUGE . . . for cutting multiple pieces of same length - substantially built - readily adjustable.

AUTOMATIC KNOCKOUT . . . At the completion of each cut - the motor is stopped and the saw frame automatically rises to its highest point.



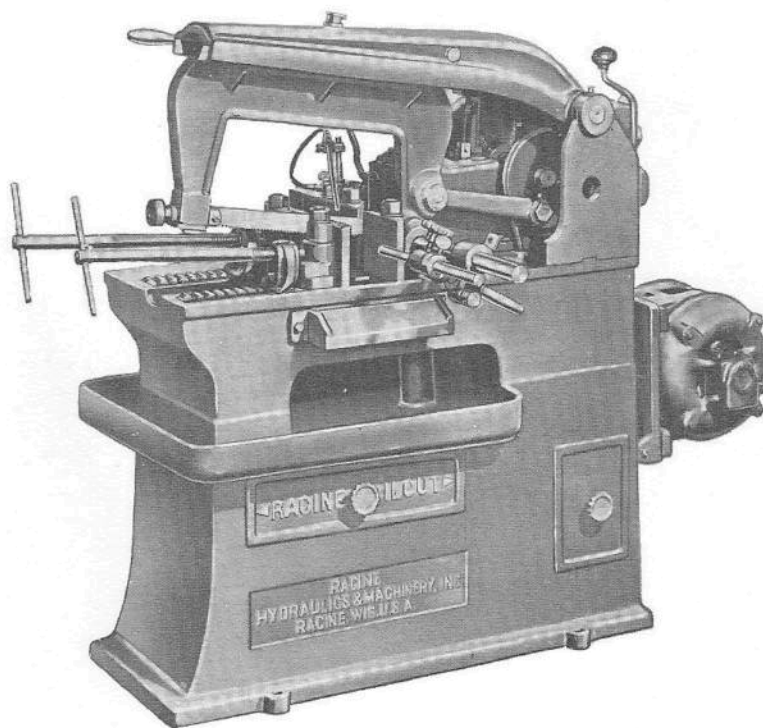
HYDRAULIC SYSTEM

The hydraulic feed and control system is built into a simple, compact assembly readily removable. The system is leak-proof and packless - all interior parts are self-lubricated - there is nothing to wear or get out of adjustment. To exert feeding pressure, a simple piston pump supplies oil under pressure to the main feed cylinder. Pressures are controlled by a single graduated dial. The rate of feed is controlled by a throttling valve. This design provides a simple, trouble free, oil-cushioned operation with longer life of blades and greater accuracy.

POWER SAW DIVISION

RACINE

has "The saw for your needs"



**MODEL
66HD**

HIGH PRODUCTION

This is the Racine Heavy Duty 6" x 6" capacity Saw which incorporates many Racine exclusive features including the smooth action, self-compensating hydraulic feed. Here is a machine built for mass production or extreme service operations.

Rugged construction, simplicity and compactness makes this precision cut-off tool a leader in its field.

For cutting high temperature alloys, a four-speed Lima Drive Motor can be furnished and is recommended to obtain lower speeds within a complete range of twelve speeds.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

RACINE, WISCONSIN

specifications

Capacity Rated	6" x 6"
Actual	6" x 6" or 6-5/8" rd.
At 45°	4" x 6"
Stroke	5"
Speeds	3-speed; 70, 100, 140 strokes per min.
Motor	2 H.P. 1200 R.P.M.
Blades	.14" x 1-1/4" or 1-1/2" - 4 to 6 teeth per inch
Floor Space	24" x 52"
Height - To Table Top	26"
Shipping Weight	1300 lbs.

CUTTING PRINCIPLE:

HYDRAULIC PRESSURE FEED, actuated by single plunger pump operated by cam on crankshaft, applies feed pressure uniformly and progressively on cutting stroke only.

SAW GUIDE:

Heavy cast saw guide, of box type, carries two cast nickel-iron gibs, one being adjustable at five points.

SAW FRAME:

Has two replaceable special iron bearing surfaces bolted to Frame Proper. Frame is of improved T section ribbed to withstand maximum blade tension without distortion of the sliding ways.

VICES:

4" high, double quick acting. Hold work on both sides of blade. One set of jaws is self-positioning and swivels to 45 degrees.

BEARINGS:

All journals bronze bushed.

CLUTCH:

Double expansion ring type, directly connected with single lever control.

COOLANT SYSTEM:

Individual geared pump circulates a supply of coolant to the blade. Pump located in dry compartment in rear of machine base.

AUTOMATIC KNOCK-OUT:

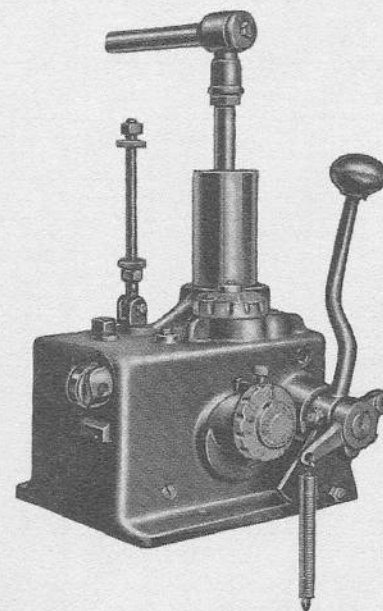
When saw feeds down to its lowest point, a lever is tripped which throws out the clutch, and the frame then rises to highest point.

STOCK GAUGE:

A length gauge is provided to permit easy gauging of stock in cutting multiple pieces of same length.

MOTOR DRIVE:

Motor driven machines are driven by means of three "V" belts from motor to drive shaft of machine.

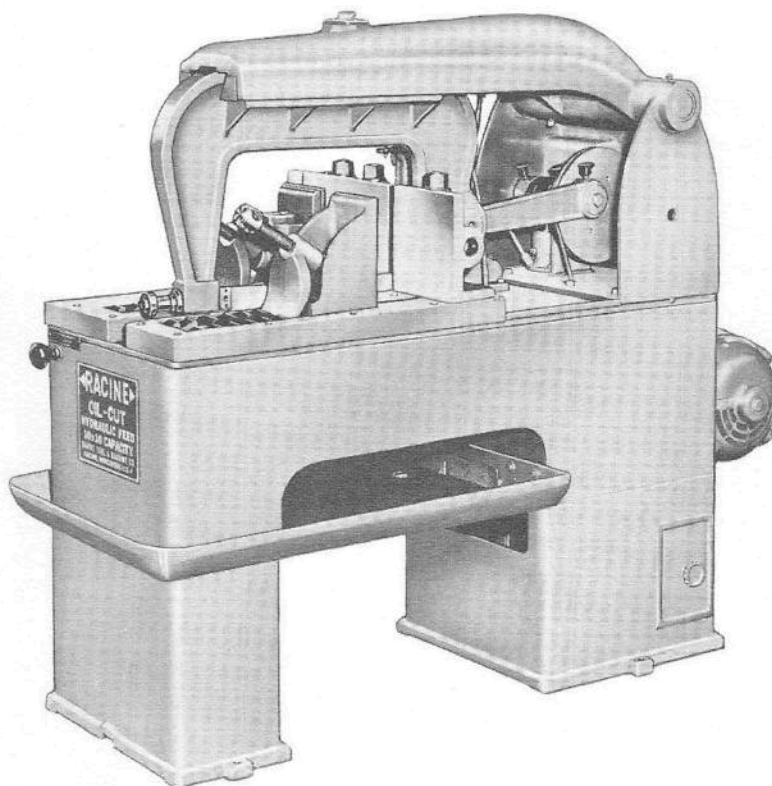


THE HYDRAULIC UNIT

In this unit is concentrated the entire hydraulic system. It is self-contained, self-lubricated, easily removable. No packing is required as complete and direct drainage to oil reservoir is provided. Single lever operates clutch into "Feed," "Neutral" and "Return" positions. Graduated dials control feed and pressure. The control is simplicity itself.

RACINE

has "The saw for your needs"



**MODEL
60**

LARGE CAPACITY - LOW COST

This is the Racine inexpensive 10" x 10" capacity with many features not found in more costly saws. A fully hydraulic machine that is a consistent and dependable performer over the wide range of general cutting demanded in the average metal working shop.

The large capacity and work holding area is also ideal for laboratory and special equipment departments.

An oil-cushioned hydraulic feed delivers the proper amount of pressure on the blade at all times. Thus, blades last longer, producing more accurate cuts at lowest cost per piece.

This machine can be supplied with hydraulic vise at extra cost to make it even more efficient.

For cutting high temperature alloys, a four-speed Lima Drive Motor can be furnished and is recommended to obtain lower speeds within a complete range of twelve speeds.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

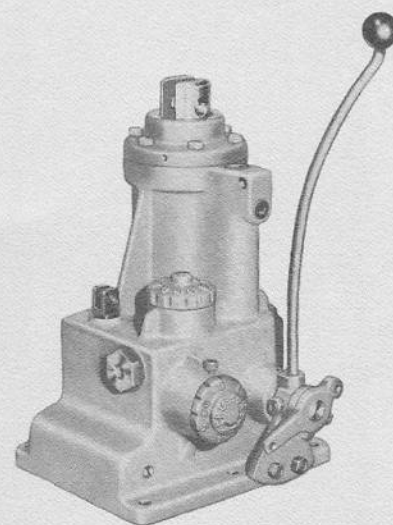
1524 FREDERICK ST.

RACINE, WISCONSIN

specifications

Rated Capacity	10" x 10"
Actual Capacity	10-3/4" Rd. Stock Only
Capacity at 45°	6" x 10"
Blade Length	18"
Stroke	5"
Strokes per Minute	70-100-140
Motor	3 H.P. - 1200 RPM
Height - floor to table top	31"
Floor Space	35" x 75"
Approximate Weight	2500 lbs;

CUTTING PRINCIPLE:	HYDRAULIC PRESSURE FEED, actuated by single plunger pump operated by cam on crankshaft, applies feed pressure uniformly and progressively on cutting stroke only.
3-SPEED TRANSMISSION:	Built in as an integral part of the machine, has heat-treated hardened steel gears throughout, running in an oil-bath and fully enclosed.
SAW GUIDE:	Heavy cast saw guide, of box type, carries two cast nickel-iron gibs, one being adjustable at six points.
SAW FRAME:	Has two replaceable special iron bearing surfaces bolted to Frame Proper. Frame is of improved T section ribbed to withstand maximum blade tension without distortion of the sliding ways.
VICES:	8" high, double quick action. Hold work on both sides of blade. One set of jaws is self-positioning and swivels to 45 degrees.
BEARINGS:	All journals bronze-bushed.
CLUTCH:	Twin Disc, directly connected with single lever control.
BASE AND TABLE:	Of cast iron, table fitted with replaceable C.I. plates.
COOLANT SYSTEM:	Individual geared pump circulates a supply of coolant to the blade. Pump located in dry compartment in rear of machine base.
AUTOMATIC KNOCK-OUT:	When saw feeds down to its lowest point, a lever is tripped which throws out the clutch, and the frame then rises to highest point.
STOCK GAUGE:	A length gauge is provided to permit easy gauging of stock in cutting multiple pieces of same length.
MOTOR DRIVE:	Motor driven machines are driven by means of four "V" belts from motor to drive shaft of machine.

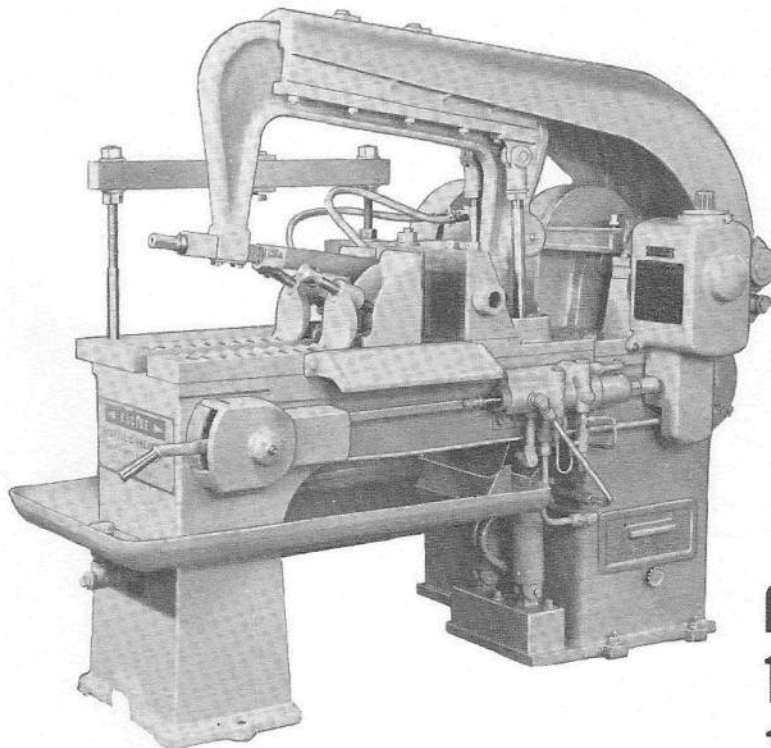


HYDRAULIC SYSTEM

The hydraulic feed and control system is built into a simple, compact assembly readily removable. The system is leak-proof and packless - all interior parts are self-lubricated - there is nothing to wear or get out of adjustment. To exert feeding pressure, a simple piston pump supplies oil under pressure to the main feed cylinder. Pressures are controlled by a single graduated dial. The rate of feed is controlled by a throttling valve. This design provides a simple, trouble free, oil-cushioned operation with longer life of blades and greater accuracy.

RACINE

has "The saw for your needs"



MODELS
1010-1212
1216-1415

EXTRA HEAVY DUTY

Racine heavy duty metal cutting machines are truly modern saws for modern industry. Available in capacities of 10" x 10" - 12" x 12" - 12" x 16" and 14" x 15" they are precision built to meet the highest standard of machine tool design.

Extra heavy construction and a simplified, accurately controlled hydraulic feed arrangement enables this machine to cut straighter and faster for a longer period of time than other machines.

Over 25 improvements to increase accuracy and production have been made on these models in the past few years.

When provided with a 4-speed motor to obtain the lower speeds, it is the most satisfactory machine for the modern high tensile - high temperature alloys.

Hydraulic chucks are also available at extra cost.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

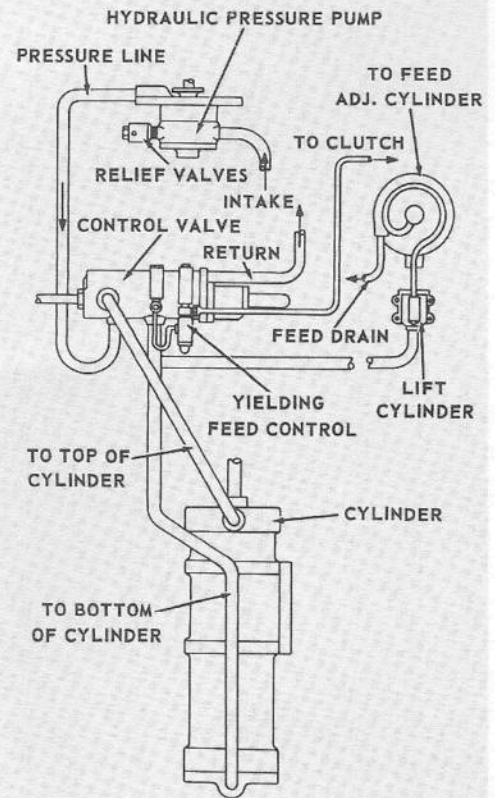
RACINE, WISCONSIN

specifications

Racine Models 1010, 1212, 1216 Heavy Duty Hydraulic Saws

MACHINE MODEL NUMBER	1010	1212	1216	1415
Rated Capacity	10" x 10"	12" x 12"	12" x 16"	14" x 15"
Actual Capacity	10" x 10"	12" x 12"	12" x 16"	14" x 15"
Capacity with Swivel Vise at 45°	10" x 6-1/2"	12" x 7"	12" x 9"	14" x 9"
Blade Length	18"	21" & 18"	24" x 21"	24" x 21"
Length of Stroke		6"		
Strokes Per Min.		150-110-85-80-60 & 45		
Motor H. P. (Std. 1200 R. P. M.)		5		
Height, Floor to Table Top		32"		
Floor Space		48" x 84"		
Shipping Weight	3600	3750	3800	3850

- SAW GUIDE:** Rigid one-piece construction pivoted 10" back of crankshaft. Double slide bearings on top and on both sides of frame.
- SAW FRAME:** Heavy cast iron construction. Cannot distort from heavy blade tension.
- GEARED HEAD:** Built in as integral part of the machine. Gears all steel and hardened.
- FEED:** Two types of feed are available on all machines - flexible (constant pressure feed) and positive feed. Low pressure hydraulic system. Single plunger metering pump, with variable stroke and with graduated dial adjustment regulates exact amount of feed desired throughout each cutting stroke.
- SINGLE LEVER CONTROL:** Single lever controls all operating phases of machine. Governs rapid traverse of saw guide up and down, clutch engagement, and rest positions.
- ADJUSTABLE AUTOMATIC KNOCKOUT:** At the finish of the cut a valve releases hydraulic pressure to move the control lever upward. Clutch is disengaged and saw frame rises to its highest position after each cut.
- DOUBLE SWIVEL VISES:** Grip stock on both sides of blade. Vises quick acting, engage slots in table plates. Height of jaws 8". Vises that swivel for cutting angles up to 45° are furnished as standard equipment. Manual overhead clamp is furnished for clamping bundled material. Hydraulic vises available at extra cost.
- TABLE PLATES:** Two special cast nickel iron table plates on machine are replaceable.
- COOLANT PUMP:** Simple constant pressure gear pump supplies coolant through two flexible steel hose connections to saw blade.
- CLUTCH:** Twin Disc; held in engagement by hydraulic pressure.
- LENGTH GAUGE:** Adjustable to permit duplicating cuts of the same length, without resetting.
- BEARINGS:** All main bearings and revolving bearings bronze bushed.
- DRIVE:** Direct from motor to main drive pulley of machine through 2 step Poly Vee Belt Drive. Motor platform adjustable for belt take up.

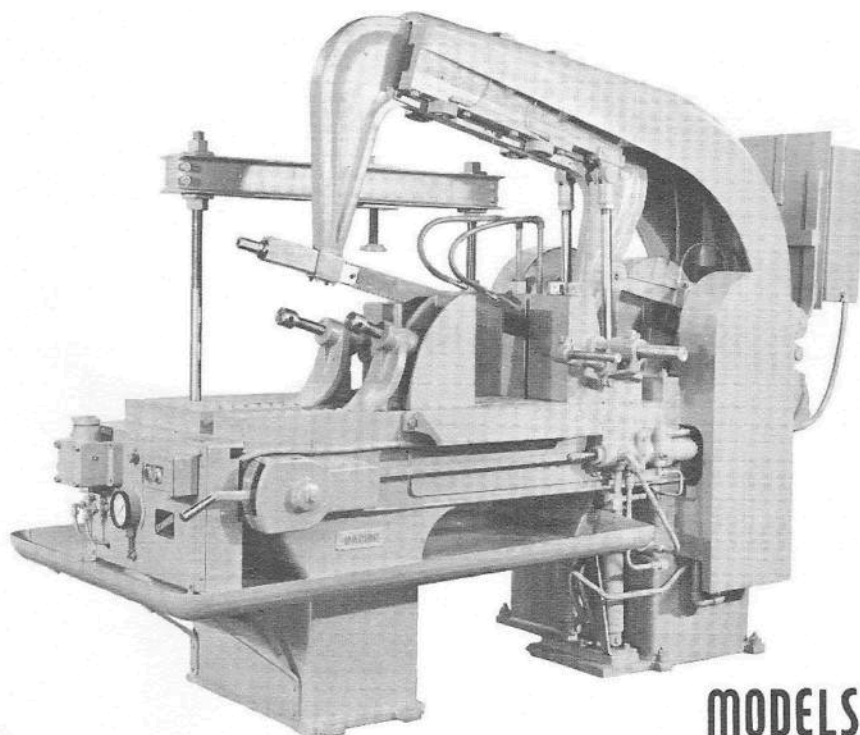


LOW PRESSURE HYDRAULIC SYSTEM - The simple low pressure pump that furnishes pressure to the entire hydraulic system is located in the oil reservoir. Large cylinder areas and the application of hydraulic power make possible the reduction of pressures in the system to less than 120 pounds per square inch - a positive assurance against leaks, wear in valves, pistons, ports and pump.

An adjustable, simple plunger metering device, with graduated dial, controls the EXACT amount of oil delivered for each cutting stroke.

RACINE

has "The saw for your needs"



**MODELS
2020NF - 2424**

LARGE CAPACITY - HEAVY DUTY

Racine large capacity heavy duty saws are carefully designed and precision built for the cutting of extra large materials with a moderate capital investment.

A sensitively controlled hydraulic feed insures accurate sawing of all metals from thin-walled tubing and soft metals through the toughest bars, tool steels and die blocks within the capacities of the machines.

This is not a bleed-off type feed system because a predetermined amount of oil under pressure is applied to the top of the main cylinders on every cutting stroke, thus, the blade is kept in the cut which reduces wear and provides faster, less costly cuts.

The smooth hydraulic operation requiring fewer moving parts also reduces maintenance to a minimum.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

RACINE, WISCONSIN

specifications

MODEL NO.	2020NF	2424
Rated Capacity	20" x 20"	24" x 24"
Actual Capacity	20" x 20"	24" x 24" or 25" DIA.
Blade Length	24" & 30"	30" & 36"
Length of Stroke	6"	6"
Strokes Per Min.	20-25-35-40-50-60 70-80-105-110-145	12-17-22-25-35-50 65-85-90-105-145
Motor H.P.		
Drive Motor	7-1/2	10
Oil Pump Motor	1	1
Coolant Pump Motor	1/6	1/6
Height, Floor to Table Top	32"	32"
Floor Space	51" x 110"	51" x 112"
Shipping Weight	6300#	6900#

SAW GUIDE:	Rigid one-piece construction pivoted 10" back of crankshaft. Adjustable gib on one side, two adjustable bottom gibs.
SAW FRAME:	Heavy cast iron construction. Side bearing plates 1-1/8" thick, 5" wide, are bolted through frame and accurately ground.
GEARED HEAD:	Built in as integral part of the machine. Gears all steel and hardened.
FEED:	Hydraulic pressure feed, actuated by single plunger pump operated by cam on crankshaft, applies feed pressure uniformly and progressively on cutting stroke only.
ADJUSTABLE AUTOMATIC KNOCKOUT:	At the finish of the cut a valve releases hydraulic pressure to move the control lever upward. Clutch is disengaged and saw frame rises to its highest position after each cut.
VICES: (2424)	Rear jaws on both sides of blade are 20" high. Clamping is done with Quick Acting Screw Clamp on both sides of blade. Hydraulic vise available as an accessory.
VICES: (2020NF)	Grip stock on both sides of blade. Rear vises bolted to table, front vises quick acting, engage slots in table plates. Height of jaws 14". Vises that swivel for cutting angles up to 45° are furnished as standard equipment. Manual overhead clamp is furnished for clamping bundled material. Hydraulic vise available as an accessory. Capacity at 45° is 20" x 14". Table plates on 2424 and 2020 NF machines are replaceable.
TABLE PLATES:	
COOLANT PUMP:	Coolant pump, electric drive motor and reservoir is a self-contained unit that fits into base of machine and can be easily removed for cleaning.
DRIVE:	Direct from motor to main drive pulley of machine through Poly Vee Belt. Motor attached to heavy steel platform hinged to rear of machine base. Motor platform adjustable for belt take-up.



Features

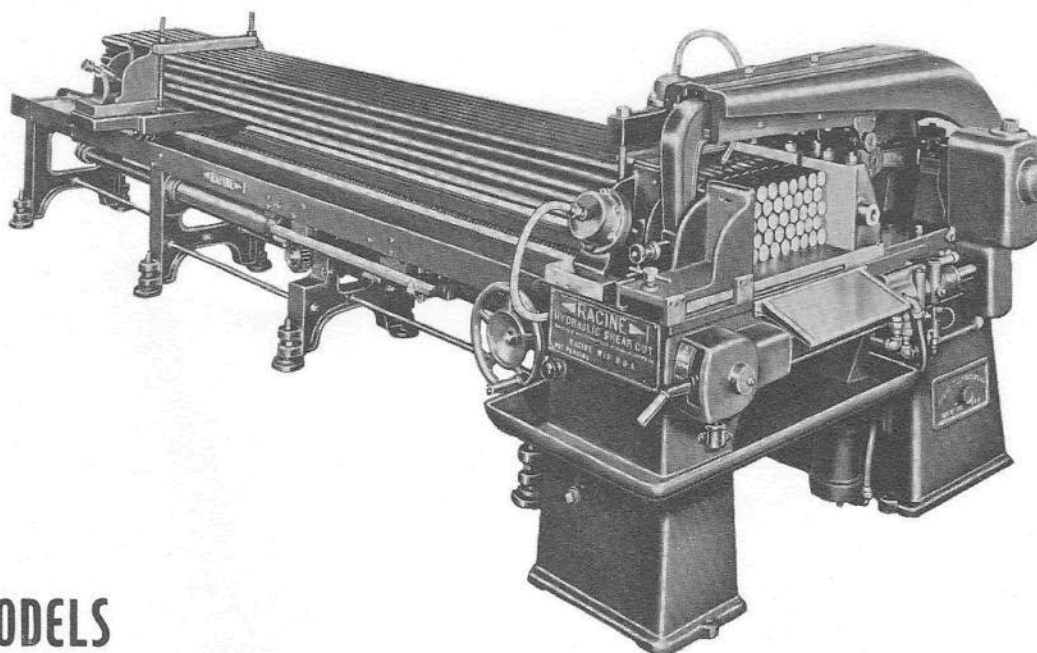
(Both Models)

Fully Hydraulic Feed
Adjustable Feed Pressure
Front Control Panel
Twelve Speeds
Heavy Duty Triple Chain Drive
Automatic Lubrication
Removable Coolant Tank
Easy Chip Removal

POWER SAW DIVISION

RACINE

has "The saw for your needs"



MODELS
1010A - 1212A - 1216A - 1415A

AUTOMATIC - HEAVY DUTY

Automatic operation makes these heavy duty Racine Saws the most efficient method of parting multiple lengths of material.

Necessary clamping attachments are available to permit bundling of smaller sizes of bars.

The operator merely loads the machine and the cuts are made automatically one after another without attention. One operator could operate several machines or do other important work while the pieces are being cut to length. The machine can also be operated manually for short runs or single cuts.



RACINE HYDRAULICS, INC.

POWER SAW DIVISION

1524 FREDERICK ST.

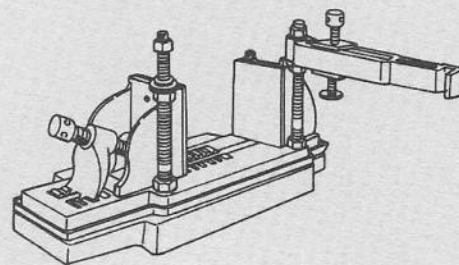
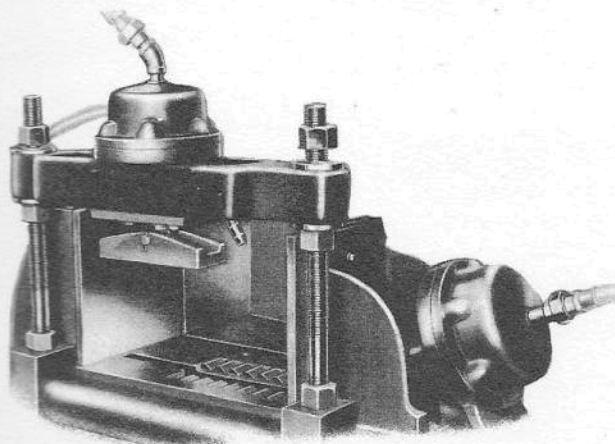
RACINE, WISCONSIN

specifications

MACHINE MODEL NUMBERS	1010A	1212A	1216A	1415A
RATED CAPACITY	10" x 10"	12" x 12"	12" x 16"	14" x 15"
BLADE LENGTH	18"	18" & 21"	21" & 24"	21" & 24"
LENGTH OF STROKE	6" for all sizes			
STROKES PER MINUTE	45-60-80-85-110-150 for all sizes			
MOTOR 3 Phase-60 cycle-1200 R.P.M.	5 H.P. for all sizes			
HEIGHT OF TABLE TOP	31" for all sizes			
FLOOR SPACE Machine only	48" x 84" for all sizes			
FLOOR SPACE Stock Feed (Attachment only)	Standard stock rests 14' long by 25-1/4" wide. Extra length rests - 18' and overall.			
SHIPPING WEIGHT Standard Stock Feed and Machine Motor Driven	5700 lbs. for all sizes			
RANGE OF Length Gauge Setting on Stock Feed	1/64" to 54" for all sizes			

AUTOMATIC SIDE AND OVERHEAD HYDRAULIC CHUCK ON MACHINE

To complete fully automatic installation, the Automatic Overhead Hydraulic Chuck firmly holds bundled material. Overhead chuck, necessary for bundled stock is furnished as extra equipment. Hydraulic vise is standard on bar feed machines.

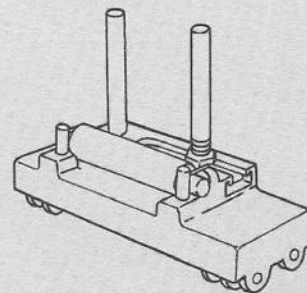


TRAVELING CARRIAGE WITH MANUAL OVERHEAD CLAMP

Traveling Carriage with Manual Overhead Clamp holds bundled or single bar stock. Overhead clamping device, necessary for all bundled material, is optional at extra cost.

AUXILIARY STOCK SUPPORT CARRIAGE

Auxiliary stock support carriage for supporting stock between machine and traveling carriage assures greater accuracy of cut, where sagging of light stock may occur. Removable without interrupting cutting. Available as an extra.





SAW MODEL SELECTION CHART

Model No.	Capacity (Inches)	Type	Standard Speed	Recommended Blade Size (Inches)	Comparative Cutting Rate (1020 Steel) Sq. Inches Per Minute
66D2	6 x 6	2-Speed Dry Cut	70-100	14 x 1 1/4 x .062 x 6T	2
66W2	6 x 6	2-Speed Wet Cut	100-140	14 x 1 1/4 x .062 x 6T	3
66W4	6 x 6	4-Speed Wet Cut	45-70 100-140	14 x 1 1/4 x .062 x 6T	3
66W2A	6 x 6	2-Speed Automatic	100-140	14 x 1 1/4 x .062 x 6T	3
66W4A	6 x 6	4-Speed Automatic	45-70 100-140	14 x 1 1/4 x .062 x 6T	3
816W2	8 x 16	2-Speed	100-140	21 x 1 1/2 x .062 x 6T 24 x 1 1/2 x .062 x 6T	2 1/2
816W4	8 x 16	4-Speed	45-70 100-140	21 x 1 1/2 x .062 x 6T 24 x 1 1/2 x .062 x 6T	2 1/2
66HD	6 x 6	3-Speed Heavy Duty	70-100-140	14 x 1 1/4 x .062 x 6T 14 x 1 1/2 x .075 x 4T	4
60	10 x 10	3-Speed Inexpensive	70-100-140	18 x 1 3/4 x .088 x 4T	5
1010	10 x 10	6-Speed Heavy Duty	45-60-80 85-110-150	18 x 1 3/4 x .088 x 4T	7
1212	12 x 12	6-Speed Heavy Duty	45-60-80 85-110-150	18 x 1 3/4 x .088 x 4T 21 x 1 3/4 x .088 x 4T	7
1216	12 x 16	6-Speed Heavy Duty	45-60-80 85-110-150	21 x 1 3/4 x .088 x 4T 24 x 1 3/4 x .088 x 4T	7
1415	14 x 15	6-Speed Heavy Duty	45-60-80 85-110-150	21 x 1 3/4 x .088 x 4T 24 x 1 3/4 x .088 x 4T	7
1010A	10 x 10	Automatic Heavy Duty	45-60-80 85-110-150	18 x 1 3/4 x .088 x 4T	7
1212A	12 x 12	Automatic Heavy Duty	45-60-80 85-110-150	18 x 1 3/4 x .088 x 4T 21 x 1 3/4 x .088 x 4T	7
1216A	12 x 16	Automatic Heavy Duty	45-60-80 85-110-150	21 x 1 3/4 x .088 x 4T 24 x 1 3/4 x .088 x 4T	7
1415A	14 x 15	Automatic Heavy Duty	45-60-80 85-110-150	21 x 1 3/4 x .088 x 4T 24 x 1 3/4 x .088 x 4T	7
2020NF	20 x 20	12-Speed Heavy Duty	20 to 145	24 x 1 3/4 x .088 x 4T 30 x 2 1/2 x .100 x 4T	5
2424	24 x 24	12-Speed Heavy Duty	12 to 145	30 x 2 1/2 x .100 x 4T 36 x 4 1/2 x .125 x 2 1/2 T	5

OVER 60 YEARS OF EXPERIENCE