

SHARP

SW-165HT

Instruction Manual

Version 1 20211019

Safety rules



- It's essential to power on your bandsaw machine for at least one hour every two years, if you seldomly use the machine. (This period of power-on must be without proceeding with other operation) Otherwise the machine program may disappear due to not strictly follow this safety rule.
The restoration-service fee for improper use will be extra charge. Please note.



- Make sure your work area is cleared of uninvited people and obstacles every time before you start operating the machine.



- Never step or stand on the roller table. Your foot may slip or trip on the rollers and you will fall.



- Never wear gloves or loose clothing when operating the machine. It may lead to serious injury if they are caught in the running machine. Wrap or cover long hair.
- Never touch the running saw blade with gloves or not. It is dangerous if your hands, clothing or gloves are caught by the running blade.



- Make sure any use of fire is prohibited in the shop and install a fire extinguisher or other fire control device near the machine when cutting titanium, magnesium, or any other material that produces flammable chips. Never leave the machine unattended when cutting flammable materials.



- Use a water-soluble cutting fluid on this machine. Oil-based cutting fluids may emit smoke or catch fire, depending on how they are used.

Safety rules



- Never cut carbon or any other material that may produce and disperse explosive dust. It is possible that sparks from motors and other machine parts will ignite and explode the air-borne dust.



- Never adjust the wire brush or remove chips while the saw blade is still running. It is extremely dangerous if hands or clothing are caught by the running blade.

- Stop the saw blade before you clean the machine. It is dangerous if hands or clothing are caught by the running blade.

- Never start the saw blade unless the workpiece has been clamped firmly. If the workpiece is not securely clamped, it will be forced out of the vise during cutting.



- Take preventive measures when cutting thin or short pieces from the work to keep them from falling. It is dangerous if the cut pieces fall.

- Use roller tables at the front and rear sides of the machine when cutting long work. It is dangerous if the work piece falls off the machine.



- Turn off the shop circuit breaker switch before performing maintenance on the machine. Post a sign indicating the machine is under maintenance.

Table of Contents

Section 1 – Safety Information	1-1
Safety Instructions	1-1
Safeguard Devices	1-3
Emergency Stop	1-4
<i>Illustration: Emergency Stop</i>	1-5
Safety Labels	1-6
<i>Illustration: Safety Labels</i>	1-7
Hearing Protection	1-8
CE Compliance	1-8
Risk Assessment	1-8
Section 2 – General Information	2-1
Specifications	2-2
Machine Parts Identification	2-3
Floor Plan	2-5
Section 3 – Moving & Installation	3-1
Location & Environment	3-1
Unpacking & Inspecting	3-2
Lifting	3-3
<i>Illustration: Lifting Points</i>	3-5
Removing Shipping Bracket	3-6
Cleaning	3-6
Installing	3-6
Supplying Hydraulic Oil	3-7
Supplying Coolant	3-7
Connecting Electric Power	3-7
Leveling	3-8
Anchoring the Machine	3-9
Installing Roller Table (Optional)	3-9
Installing Fire Control Device	3-9
Relocating	3-9
Section 4 – Operating Instruction	4-1
Safety Precautions	4-2
Before Operating	4-3
Control Panel	4-4
Control Panel	4-4

Table of Contents

Control Buttons	4-5
Blade Descend Pressure & Speed	4-7
Standard Accessories	4-7
Optional Accessories	4-9
Blade Deviation Detector & Calibration Procedure (Optional).....	4-11
Unrolling & Installing the Blade	4-12
Adjusting Wire Brush	4-14
Adjusting Saw Arm.....	4-14
Adjusting Coolant Flow	4-15
Adjusting Blade Speed.....	4-15
Breaking-In the Blade	4-16
Test-Running the Machine	4-16
Cutting Operation	4-17
Using Top Clamp For Bundle Cutting	4-18
Terminating a Cutting Operation	4-19
Section 5 – Electrical System	5-1
Electrical Circuit Diagrams	5-1
Section 6 – Hydraulic System	6-1
Hydraulic Diagrams	6-1
Section 7 – Bandsaw Cutting: A Practical Guide	7-1
Introduction	7-2
Saw Blade Selection	7-2
Vise Loading	7-3
Blade Brake-In.....	7-4
Section 8 – Maintenance & Service	8-1
Introduction	8-1
Basic Maintenance	8-1
Maintenance Schedule	8-2
Before Beginning a Day’s Work	8-2
After Ending a Day’s Work	8-2
Every 2 weeks	8-2
First 600hrs for new machine, then every 1200hrs.....	8-2
Every Six Months	8-3
Storage Conditions	8-5
Terminating the Use of Machine	8-5
Oil Recommendation for Maintenance	8-6

Table of Contents

Section 9 – Troubleshooting	9-1
Introduction	9-1
Precautions	9-2
General Troubles & Solutions	9-2
Minor Troubles & Solutions	9-3
Motor Troubles & Solutions	9-3
Blade Troubles & Solutions	9-4
Sawing Problems & Solutions	9-5
Re-Adjusting the Roller Table	9-6
Section 10 – Parts	10-1
Spare Parts Recommendations	10-1
Part List	10-2

SAFETY INFORMATION

SAFETY INSTRUCTIONS

SAFEGUARD DEVICES

EMERGENCY STOP

SAFETY LABELS

HEARING PROTECTION

CE COMPLIANCE

RISK ASSESSMENT

Safety is a combination of a well-designed machine, operator's knowledge about the machine and alertness at all times. This band machine has incorporated many safety measures during the design process and used protective devices to prevent personal injuries and potential risks. Warning labels also serve as a reminder to the operator.

Throughout this manual, you will also see various safety-related symbols indicating important information that you should take note of prior to use of the machine or part of its functions. These important safety instructions do not cover all possible situations that might occur. It is your responsibility to take caution and follow procedures stated in this manual when installing, maintaining and operating your machine. We will not be liable for damages resulting from improper use.

SAFETY INSTRUCTIONS

What the icons and signs in this user manual mean:



This icon marks **WARNING**; hazards or unsafe practices that may result in **personal injury or damage to the machine**.



Supplementary information to the procedures described in this manual.



Call your local agent or our service center for help.



This manual has important safety information. Read through it carefully before operating this machine to prevent personal injury or machine damage. Learn the operation, limitation and the specific potential hazards peculiar to this band saw. All users must read it before performing any activity on the machine, such as replacing the saw band or doing regular maintenance.



Disconnect the power cord before making adjustment, maintenance or blade changes.



Do not operate this machine unless it is completely assembled.



Make sure the power switch is off before plugging in power cord.



Always remember to switch off the machine when the work is completed.



Use recommended accessories. Improper accessories may be hazardous.



Never hold the material by hand for cutting. Always use the vise and make sure the material is clamped securely before cutting.



When a workpiece is too long or heavy, make sure it is supported with a roller table (recommended).



Keep your work area well illuminated at minimum 500 lumen.



Remove adjusting keys, wrenches or any loose parts or items from the machine before turning on power.



Use a sharp saw blade and keep the machine in its best and safest performance by following a periodical maintenance schedule.



Wear proper apparel during operation and when servicing the machine. Some personal protective equipment is required for the safe use of the machine, e.g. protection goggles.



Moving parts should be kept in proper alignment and connection with the machine. Check for breakage, mounting and any other conditions that may affect its operation. Any damaged part or guard should be properly repaired or replaced.



It is dangerous to operate the machine when the floor is slippery. Keep the floor clean and dry. Check for ice, moisture, or grease before entering.



Do not use the machine to cut explosive material or high pressure vessels as it will generate great amount of heat during the sawing process and may ignite an explosion.



Keep your work area clean. Cluttered and slippery floors invite accidents.



Keep blade protection cover and wheel covers in place and in working order.



Never operate while under the influence of drugs, alcohol or medication.



Do not reach over or stand on any part of the machine.



Keep the work environment safe. Do not use band saw in a damp or wet location.



Keep all guards and shields in place before installing or starting up the machine.



Keep unauthorized personnel away.

SAFEGUARD DEVICES

The safeguard devices incorporated in this machine include the following two main parts:

1. Protection covers & guards
2. Safety-related switches

Protection Covers & Guards

1. Idle wheel housing cover
2. Drive wheel housing cover
3. Gear reducer cover
4. Wire brush belt cover
5. Blade guard cover (left & right)
6. Safety fence (left & right)(CE model only, as shown in Illustration: *Safety Fence*)
7. Chip conveyor cover (CE model only)



The protection devices should always be mounted on the machine whenever the machine is running.



Do not remove any of these safeguard devices under any circumstances except when servicing the machine. Even skilled service technicians should still take cautions when performing repairs or service on the machine with any of these protectors removed. It is the responsibility of the user to make sure all these elements are not lost and damaged.



Take note of the following main moving parts on the machine prior to and during machine operation:

- Saw bow assembly
- Drive and idle wheels
- Blade guide arm
- Saw blade guide rollers
- Quick approach device (optional)
- Wire brush
- Chip conveyor (optional)
- Workpiece clamping vises
- Shuttle vises and workbed rollers
- Top clamps (optional)
- Gear reducer

Safety Related Switches

To protect the operator, the following safety related switches on the machine are actuated when the machine is in operation.

Wheel motion detector	This is a proximity sensor used to detect the motion of the drive wheel. Once the saw blade is broken or as soon as it starts slipping, the sensor will detect and stop the drive wheel and the machine.
Power switch	Located on the cover of electrical cabinet, the power switch controls the main power of the machine. Up to your company's internal rules, this power switch can be locked with a padlock or a luggage lock to protect the operator and the machine.
Emergency stop button	Located on the control panel, the button when pressed will stop the machine completely.
Vise clamp switch	This switch assures firm clamping of the workpiece. If the workpiece is not clamped properly, the saw blade is not allowed to run.
Wheel cover interlock switches (CE model only)	Located on the two wheel housings, these switches are used to assure that the machine will stop whenever the wheel covers are open. This device is to protect users from being cut by the running saw blades.

Among all these safety switches, some of them are used to protect the users and some of them are used to prevent damage to saw blades, the workpiece and the machine itself, etc. We have taken every precaution to prevent injury or damage and to provide safe and economical operation of the machine.

EMERGENCY STOP

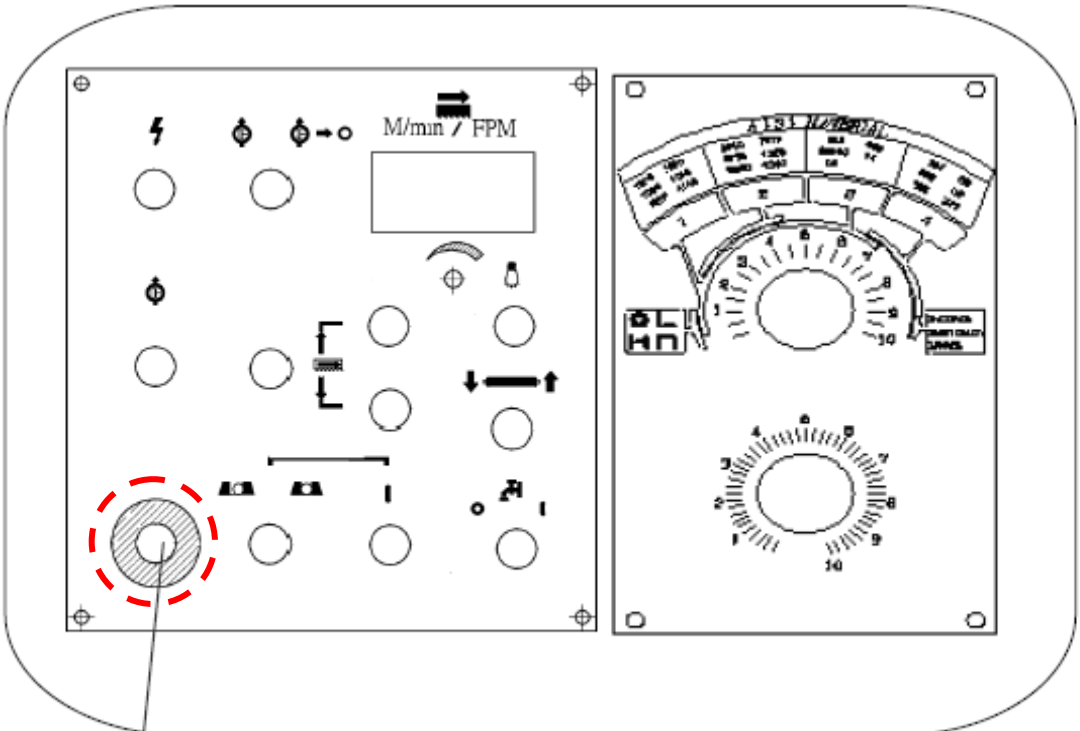
Designed to be easily accessible, the emergency stop button is located on the left bottom corner on the control panel and is made in red color and rubber material. For CE models, supplementary emergency stop button may be available at other area(s) of the machine depending on machine type. Please refer to *Illustration: Emergency Stop*.

When you press the button, the machine will immediately come to a full stop to avoid injury or damage when an accident occurs. The button will be locked when you press it. To unlock it, turn the button clockwise.

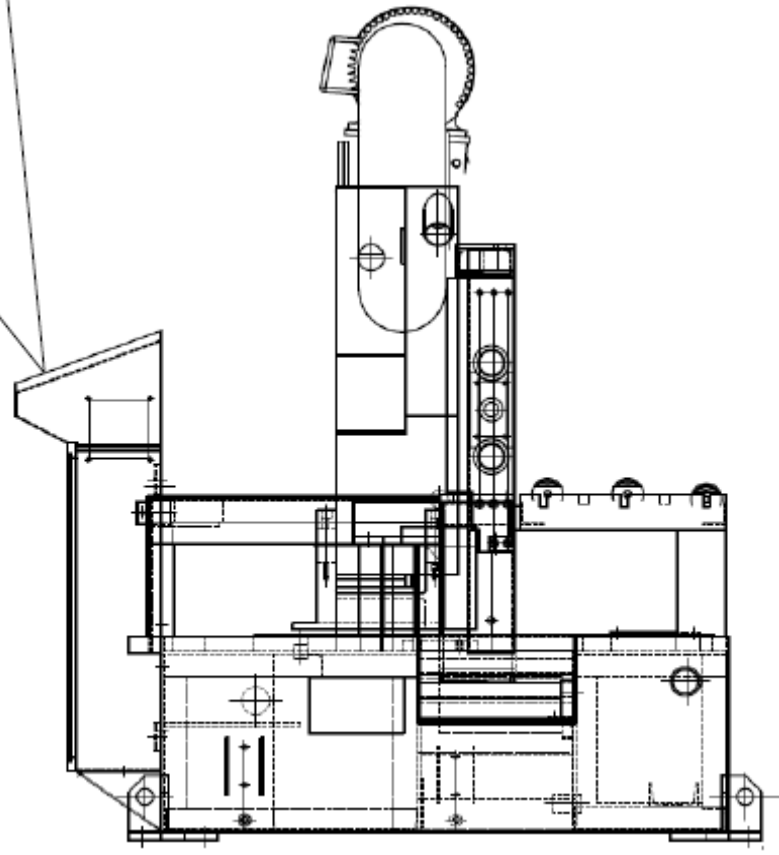
You should press it immediately without any hesitation when observing:

- An emergency situation that would cause any injury or damage
- An abnormal situation or problem such as fire, smoke, abnormal noise and etc.

Illustration: Emergency Stop



Emergency Stop

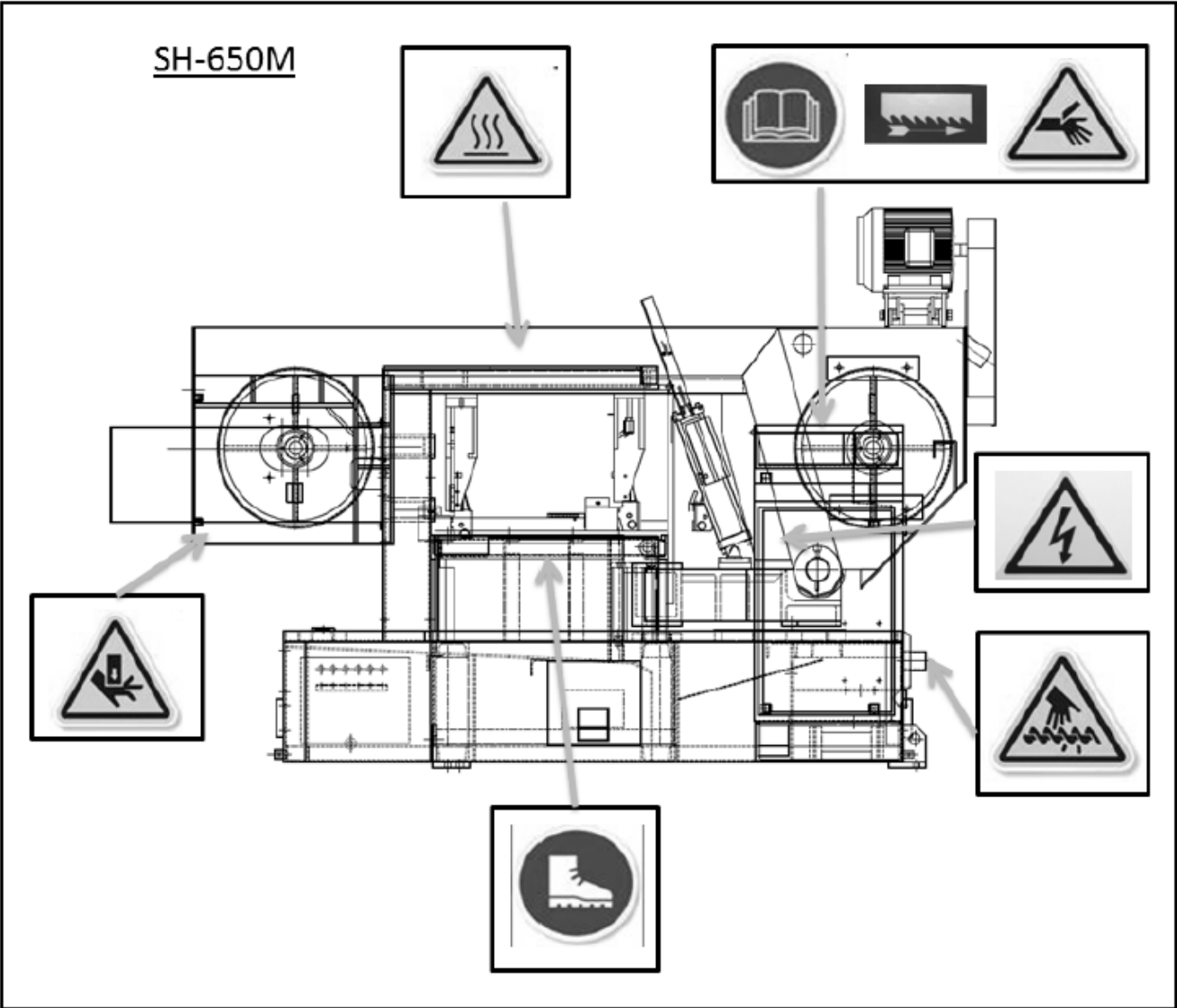


SAFETY LABELS

Please read through and understand these safety labels before operating the machine. Refer to *Illustration: Safety Labels*.

Label	Meaning	Label	Meaning
	Impact Hazard WEAR SAFETY SHOES. Do not approach dropping area during operation.		Read Operator's Manual This manual has important safety information. Read through it carefully before operating this machine to prevent personal injury or machine damage.
	Keep Unauthorized Personnel Away		Do not step. Do not stand on the machine or on the accessories!
	DANGER: Running Blade Blade runs through this area. Keep your hands away from a running blade to avoid severe injury. The arrow indicates direction of the blade.		Cutting Hazard KEEP COVER CLOSED / KEEP HAND OFF while the blade is running. Turn power off before opening cover. Failure to follow the warning can result in severe injury.
	Hazardous Voltage TURN POWER OFF before servicing. Failure to following the warning can result in severe injury.		Burn Hazard/Hot Surface
	Hand Crush/Force from Above		Crush hazard by vise
	Loose Hand Hazard KEEP HAND OFF. Do not touch chip conveyor. Failure to follow the warning can result in severe injury.		Pinch Point/Hand Entanglement
	CAUTION : Class I invisible Laser Radiation Present. Avoid direct exposure to beam.		

Illustration: Safety Labels



HEARING PROTECTION



Always use ear protection!

When your machine is running, noise generated by the machine may come from the following:

- Saw blade during cutting or material feed mechanism
- Wire brush unit
- Chip conveyor unit
- Speed reducer
- Hydraulic motor/pump
- Belt transmissions variable speed motors
- Blade motor
- Coolant pump
- Drive wheel
- Parts not assembled tightly causing mechanical vibration

Our products pass noise testing less than 78 dBA. Noise level vary according to working conditions and we recommend ear plugs or other hearing protection at all time. If your machine produces an undesirable noise while it is running, you should:

1. Make sure all maintenance tasks have been performed following the prescribed maintenance schedule (Refer to Section 8).
2. If maintenance does not seem to solve the problem, follow the troubleshooting procedures under Section 9.

CE COMPLIANCE

Our CE model is designed to satisfy regulations of the Council Directive on the approximation of the laws of the Member States relating to machinery (2006/42/EC) - Annex I Essential health and safety requirements relating to the design and construction of machinery.

RISK ASSESSMENT

Risk assessment generally takes account of intended use and foreseeable misuse, including process control and maintenance requirements. We made every effort to avoid any personal injury or equipment damage during the machine design stage. However, the operator (or other people) still needs to take precautions when handling any part of the machine that is unfamiliar and anywhere on the machine that has potential hazards (e.g. the electrical control box).

GENERAL INFORMATION

SPECIFICATION

MACHINE PARTS IDENTIFICATION

FLOOR PLAN

This band saw machine is designed by our R&D engineers to provide you the following features and advantages:

Safety

- This machine is designed to fully protect the operator from its moving parts during cutting operation.
- The machine and each component has passed strict testing (Council Directive on the approximation of the laws of the Member States relating to Machinery).
- The machine will shut off automatically when the saw blade is broken, protecting both the operator and the machine.

Convenience & High-Performance

- The machine is designed in the way that the operation and adjustment can be easily performed.
- The machine will stop automatically when out of stock.
- Dual valve system is designed to achieve optimal cutting performance with the simple setting of feed rate and perspective cutting pressure for different material.

SPECIFICATION

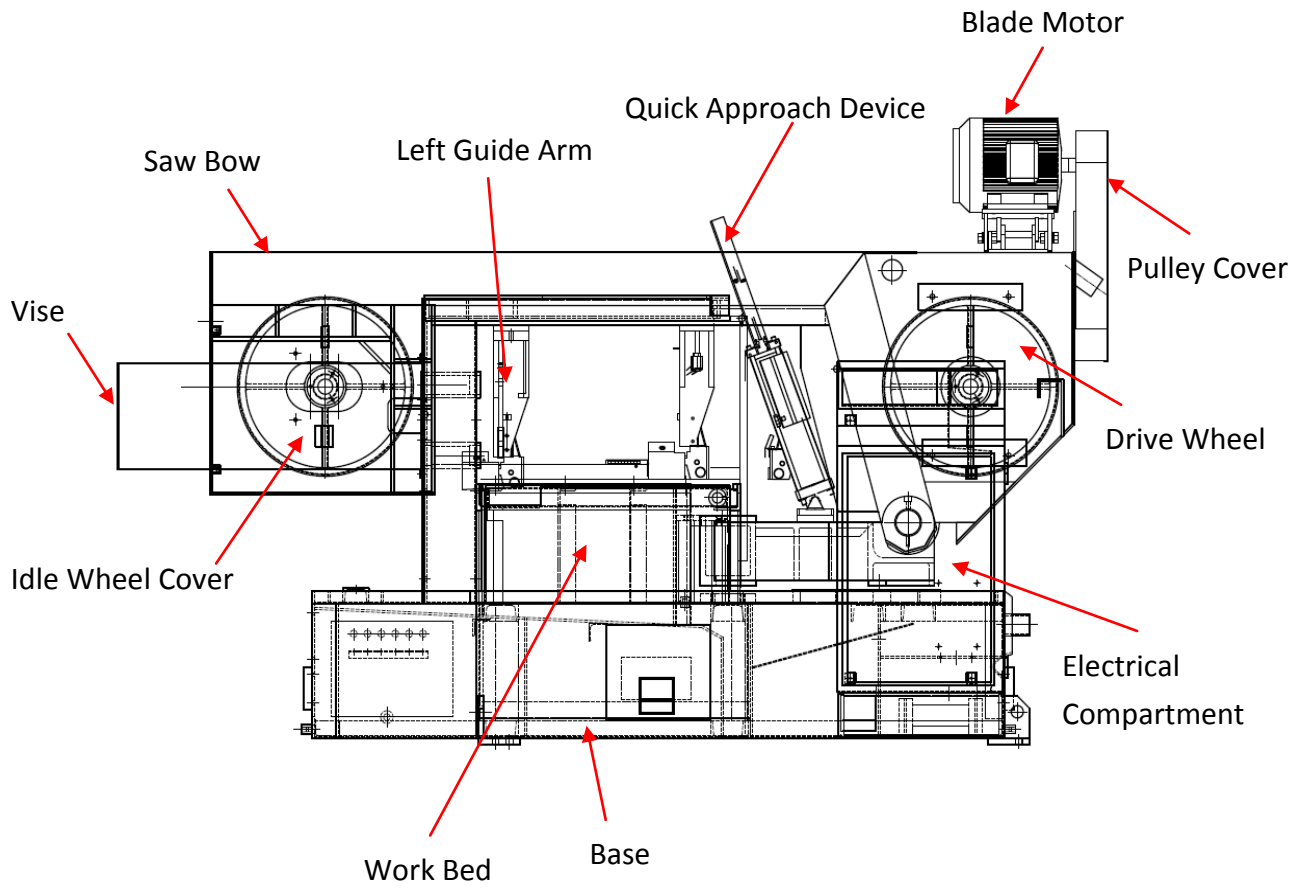
Model		SW-165HT Semi-Automatic Swivel Head Double Miterring Band Saw		
Capacity	Angle	0°	+45°	+60°
	Round	420 mm (16.5")	400 mm (15.8")	250 mm (10")
	Square	380 mm (15")	400 mm (15.8")	250 mm (10")
	Rectangular (H x W)	380 x 650 mm (15" x 25.6")	400 x 400 mm (15.8" x 15.8")	400 x 250 mm (15.8" x 9.8")
	Bundle Cutting (H x W)	445 x 670 mm (17.5" x 25.6")		
Saw Blade	Speed	15~100 m/min (50~328 fpm)		
	Size (L x W x T)	5,300 x 34 x 1.1 mm (208.7" x 1.34" x 0.042")		
	Pressure	30~34kgs / cm ² (Tolerance: +1~+2 kgs / cm ²)		
	Tension	Hydraulic with automatic blade breakage detection 2200~2300kgs / cm ² (Tolerance: +100~+150 kgs / cm ²)		
	Guide	Interchangeable tungsten carbide		
	Cleaning	Steel wire brush		
Motor Output	Saw Blade	5 HP (3.75 kW) or 7.5 HP (5.6 kW)		
	Hydraulic	1 HP (0.75 kW)		
	Coolant Pump	1/8 HP (0.09 kW)		
Tank Capacity	Hydraulic	45L (11.9 gal)		
	Coolant	60 L (15.9 gal)		
Vise Clamp	Control Method	-----		
	Minimum Clamping Capacity	0mm		
	Clamping Pressure	-----		
Feeding Length	Mode	-----		
	Single Stroke	-----		
	Multi Stroke	-----		
Workbed Height	750 mm (29.5")			
Weight	Net	1,675 kg (3,692 lb)		
	Gross	1,800 kg (3,968 lb)		
Floor Space (L x W x H)	2,850 x 1,590 x 1,766 mm (112.2" x 62.6" x 69.5")			
Operating Environment	Temperature (° C)	5~40° C (41~104° F)		
	Humidity (%)	30~85% (without condensation)		

* Please refer to the formula "Watt/Voltage = Amperage" with the information above.

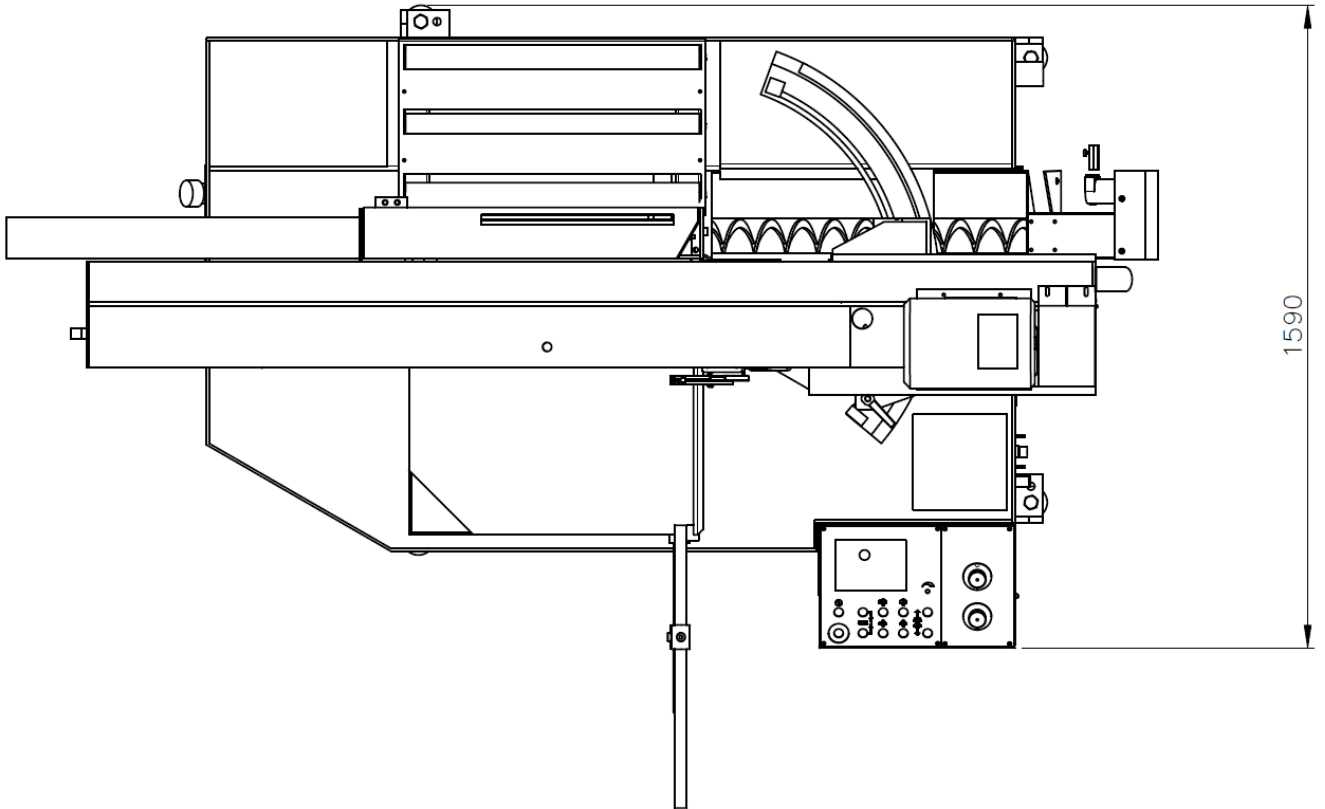
* Design and specification are subjected to change without notice.

*The saw blade pressure and tension standard above are the general values. For special saw blade, please contact to the saw blade manufacturer for the applicable values.

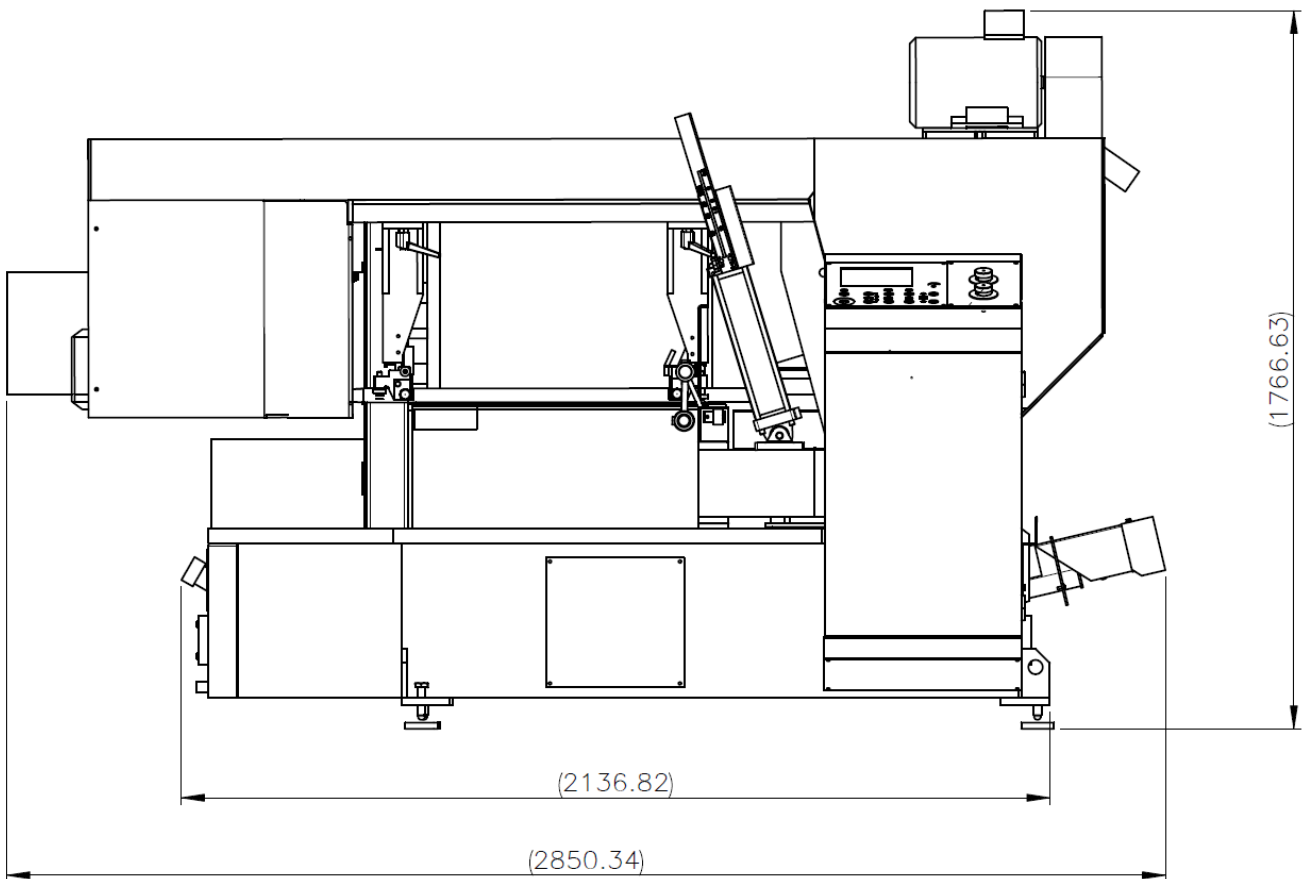
MACHINE PARTS IDENTIFICATION



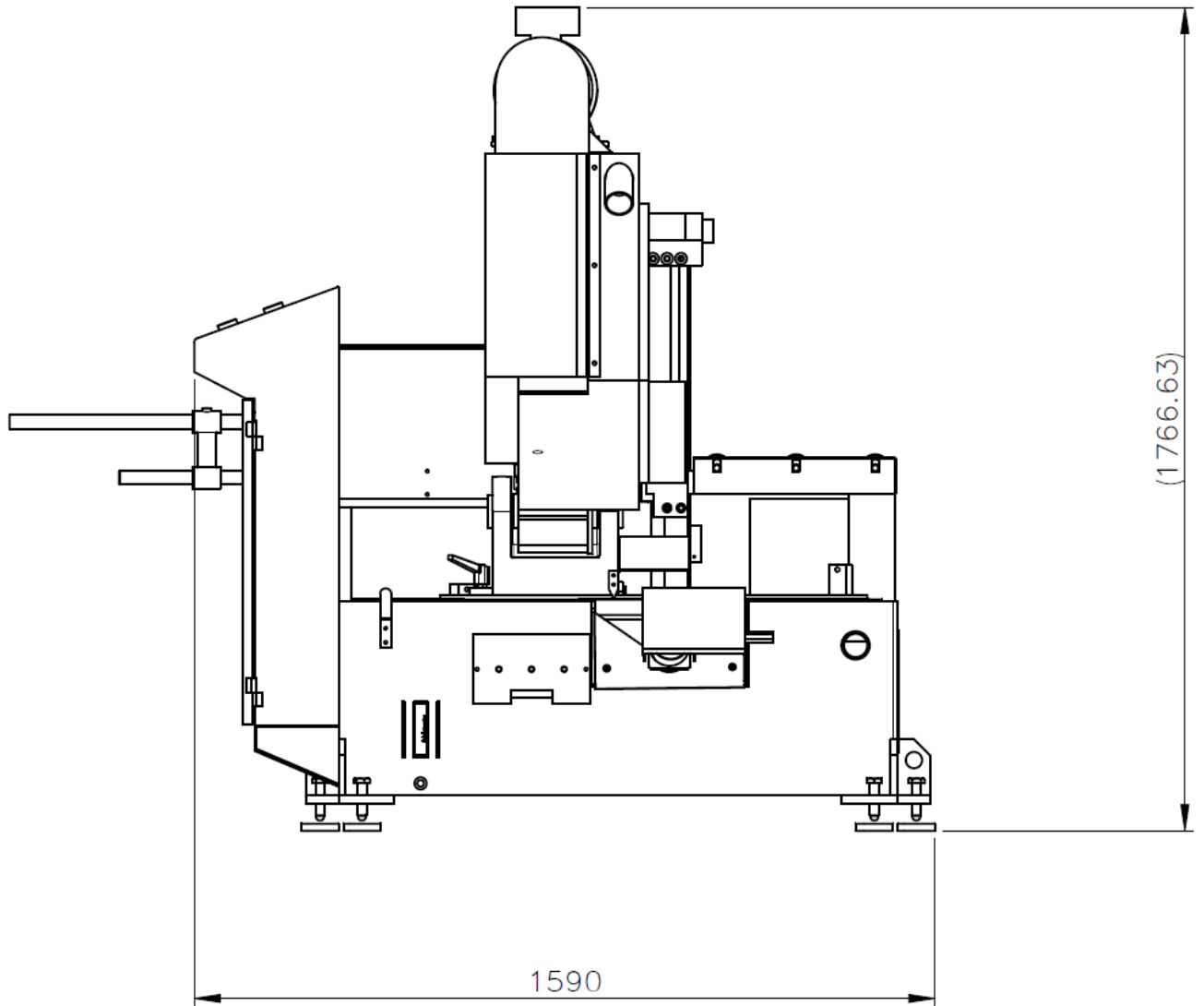
FLOOR PLAN



Machine top view



Machine front view



Machine side view

MOVING & INSTALLATION

LOCATION & ENVIRONMENT

UNPACKING & INSPECTING

LIFTING

REMOVING SHIPPING BRACKET

CLEANING

INSTALLING

RELOCATING

LOCATION & ENVIRONMENT

For your safety, please read all information regarding installation before proceeding. Install your machine in a place satisfying all of the following conditions:

Space:

- Leave enough free space around the machine for loading work and unloading cut-off pieces as well as for maintenance and inspection. Refer to *Section 2 General Information - Specification* for machine dimensions and floor space.

Environment:

- Well lighted (500 lumen at minimum).
- Floor kept dry at all times in order to prevent operators from slipping.
- Away from direct exposure to the sunlight
- Room temperature between 5°C to 40°C.
- Humidity level kept at 30%~85%“(without condensation) to avoid dew on electric installation and machine.
- Away from vibration of other machines
- Away from powders or dusts emitted from other machines
- Avoid uneven ground. Choose a solid level concrete floor which can sustain weight of both machine and material.
- Limit the operation area of the machine to staff only.

UNPACKING & INSPECTING

- Unpack your machine carefully to avoid damage to machine parts or surfaces.
- Upon arrival of your new band saw, please confirm that your machine is the correct model and it comes in the same specification you ordered by checking the model plate on the machine base.
- It is also imperative that a thorough inspection be undertaken to check for any damage that could have occurred during shipping. Pay special attention to machine surface, equipments furnished and the electrical and hydraulic systems for damaged cords, hoses and fluid leaks.
- In the event of damage caused during shipping, please contact your dealer and consult about filing a damage claim with the carrier.
- Your machine comes in with a set of tools for you to maintain the machine. The accessories furnished are as follows:
 1. Tool box 1 pc
 2. Grease gun 1 pc
 3. Screwdriver (+, -) 2 pcs
 4. Open-ended spanner 3 pcs
 5. Hexagon wrench 1 set
 6. Chip spade (only for manual models) 1 pc
 7. Operation manual 1 pc



Should you find any missing accessories, please contact your local agent immediately.

LIFTING

When moving the machine, we strongly suggest you choose any one of the methods described below to move your machine.



1. (Only applies to the machine with the design of the hanging point.)

Move the machine to its location by using a crane and a wire rope sling that can fully withstand the weight of the machine (refer to machine specification under Section 2 *General Information*).

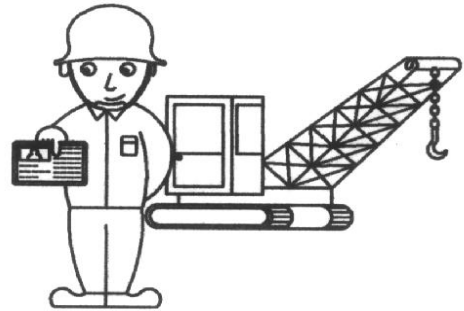


Machine hanging with a crane should be done strictly according to the hanging points designated by the original manufacturer. If there is any doubt on missing hanging points on your machine, please consult with the original manufacturer or its qualified agent before hanging the machine.

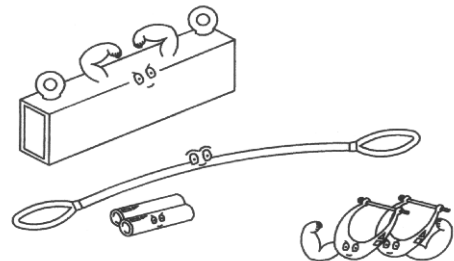
- Machine lifting is likely to damage the machine if not performed properly.



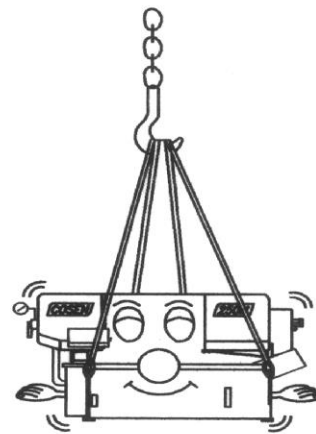
Warning: You must have a qualified crane operator to perform the job.



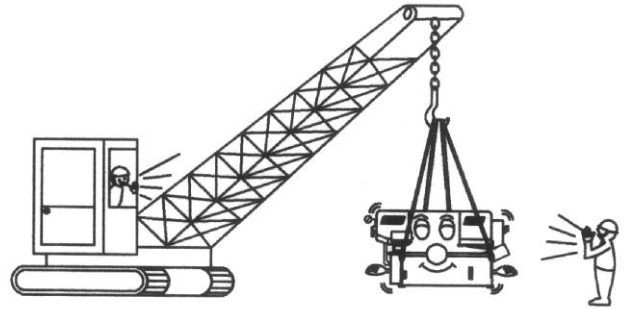
- You must use tools and equipment with the proper tensile strength and use proper method when moving your machine.



- Apply the wire rope sling to the lifting hooks on the four ends of the machine. Refer to *Illustration: Lifting Points for exact locations*.
- Slowly lift the machine. Be sure to protect the machine from impact or shock during this procedure. Also watch out your own fingers and feet to avoid injuries.
- Keep the machine well balanced during lifting process and make sure the wire rope does not interfere with the saw frame.



- When you work together with more than two people, it is best to keep constant verbal communication with each other.



2. Use a forklift (Only applies to the machine with the design of the lifting point.)

Make sure that the lifting rod can fully withstand the weight of the machine. (Refer to *Section 2 – General Information for Specifications.*)



Machine lifting with a forklift should be done strictly according to the lifting points designated by the original manufacturer. If there is any doubt on missing lifting points on your machine, please consult with the original manufacturer or its qualified agent before lifting the machine.

- Machine lifting is likely to damage the machine if not performed properly.



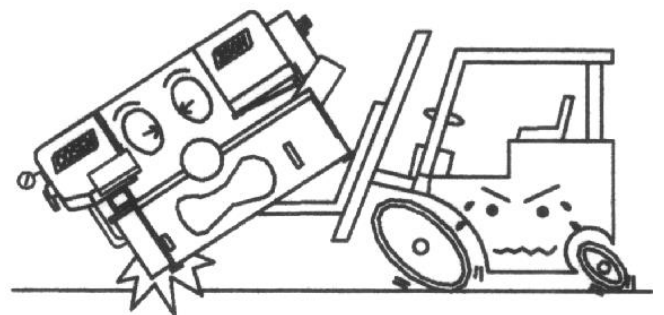
You must have a qualified forklift operator to perform the job.



- You must apply proper forklift technique to avoid damage to the machine.



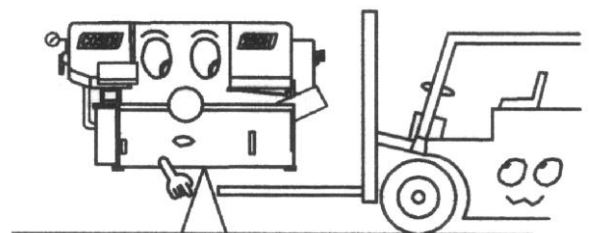
Make sure the forks are able to reach in at least 2/3 of the machine depth.



- You must keep the machine balanced at all times.



Make sure the forks are centered before use.

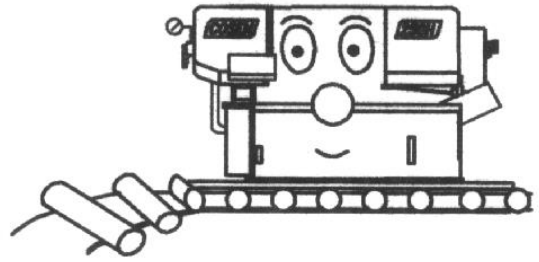


(Illustration only. Please follow user guide of your forklift.)

3. Use rolling cylinders

You can use rolling cylinders to move your machine in a small machine shop environment.

- You must use rolling cylinders made in material of proper compressive strength.

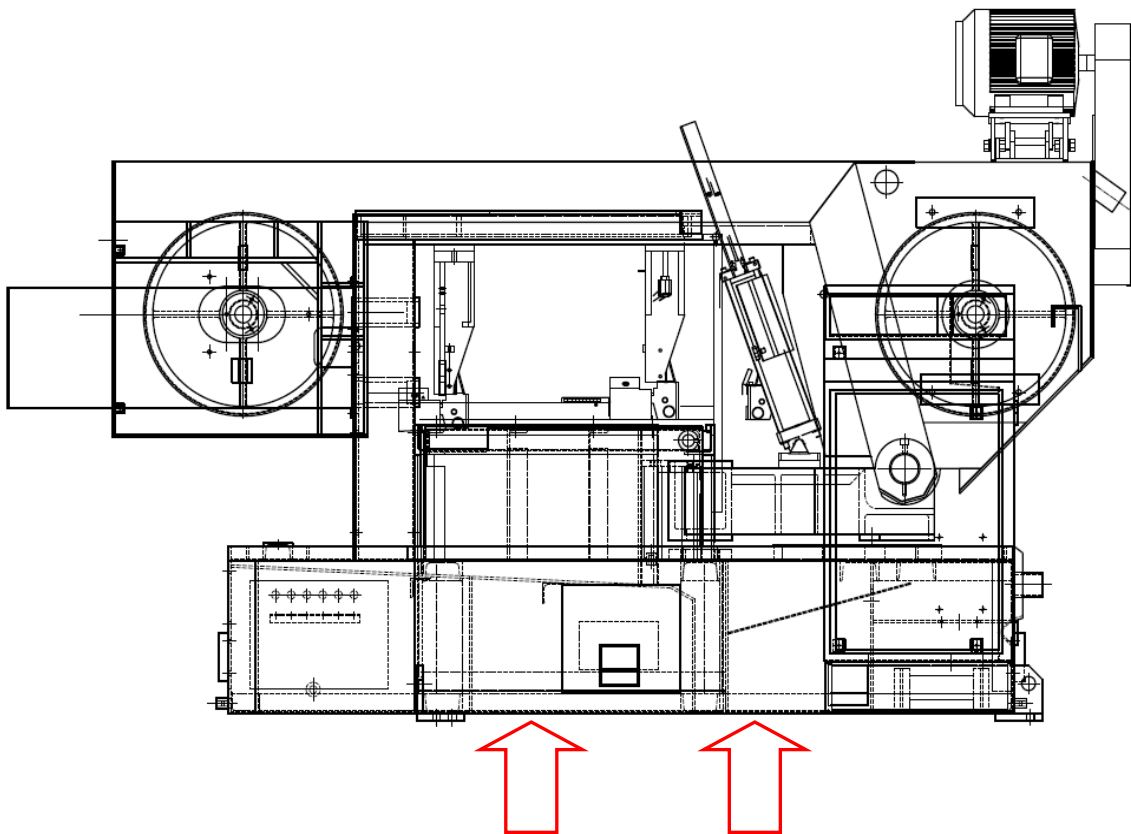


4. Other ways to move



If the machine does not have **or** stickers, please contact your local agent immediately.

Illustration: Lifting Points



Minimum weight capacity for each fork: **2.5 ton**

Total number of forklift required: **2**

REMOVING SHIPPING BRACKET

- After the machine has been properly positioned, remove the shipping bracket that is used to lock the saw frame and the saw bed.
- Retain this bracket so that it can be used again in the event that your machine must be relocated.



CLEANING

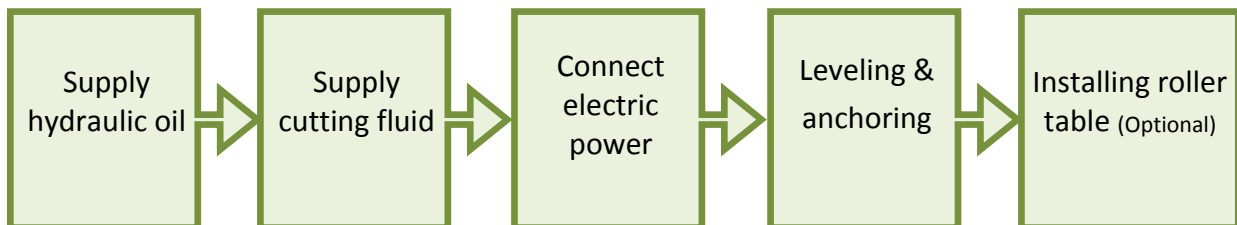
After the machine has been placed at the designated position, remove the rust-preventive grease with wiping cloth dampened with cleaning oil or kerosene. Apply machine oil to machine surfaces that are prone to rust.



Do not remove the rust-preventive grease with a metal scraper and do not wipe the painted surfaces with solvent as doing so would damage surface paint.

INSTALLING

This bandsaw machine is relatively easy to install. Follow these six easy steps to install your machine.



Supplying hydraulic oil

Open the filler cap and fill the hydraulic oil tank to above 2/3 or full level.

Check the sight gauge to make sure the oil level in the tank.



Refer to specification chart under Section 2 for tank capacity.



Supplying coolant

Fill the coolant tank to the middle level of the sight gauge by pouring the coolant from above the chip conveyor.

Use the sight gauge to check the coolant level remaining in the tank.



Always check the coolant supply before starting the machine. If the coolant pump is started without enough coolant supply in the tank, the pump and its drive motor may be damaged.



Refer to specification chart under Section 2 *General Information* for tank capacity.




Consult your coolant supplier for bandsaw use regarding coolant type and mix ratio.

Connecting electric power



Have a qualified electrician make the electrical connections.



If the power supply voltage is different from the transformer and motor connection voltage shown on the label attached to the electrical compartment of the machine, contact us or your agent immediately. 



Connect to power supply independently and directly. Avoid using the same power supply with electric spark machines such as electric welder. Unstable electric tension may affect your machine's electric installation from working properly.



Ground the machine with an independent grounding conductor.



Supply voltage: 90% - 110 % of nominal supply voltage.



Source frequency: 99% - 101 % of nominal frequency.



Refer to the specification chart under Section 2 for total electric power consumption of the motors and make sure your shop circuit breaker is capable of this consumption amount. Also use a power supply cable of proper size to suit the power supply voltage.

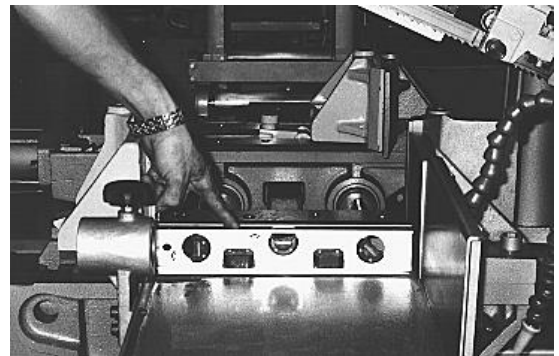
1. Turn off the shop circuit breaker.
2. Make sure the machine circuit breaker switch on the electrical compartment door is turned to OFF.
3. Remove the screw securing the electrical compartment and then open the door.
4. Pull the power supply cable and grounding conductor through the power supply inlet into the electrical compartment. (Shown right)
5. Connect the power supply cable to the circuit breaker (N.F.B.) to the R, S and T terminals, and connect the ground cable to the E terminal.
6. Close the compartment door and fasten the screw back.
7. Turn on the shop circuit breaker and then turn the machine circuit breaker switch to ON. The *Power Indicator* on the control panel will come on.
8. Pull to unlock the *Emergency Stop* button and press the *hydraulic ON* button to start the hydraulic motor.
9. Make sure the sawing area is clear of any objects. Start the blade and check the blade rotation. If the electrical connections are made correctly, the blade should run in a counterclockwise direction. If not, shut the hydraulics off, turn off the machine as well as the shop circuit breaker. Then swap the power the power cable conductors connected to R and T terminals.
10. Repeat step 6 to 9 to ensure the electrical connections are in the right order.



Leveling

Place spirit level on the vise slide plates and the work feed table.

Level the machine in both directions i.e. along and across the machine. Adjust the level of the machine by turning the leveling bolts.



Make sure all leveling bolts evenly support the machine weight.

Anchoring the machine

Normally there is no need to anchor the machine. If the machine is likely to vibrate, fix the machine to the floor with anchor bolts.

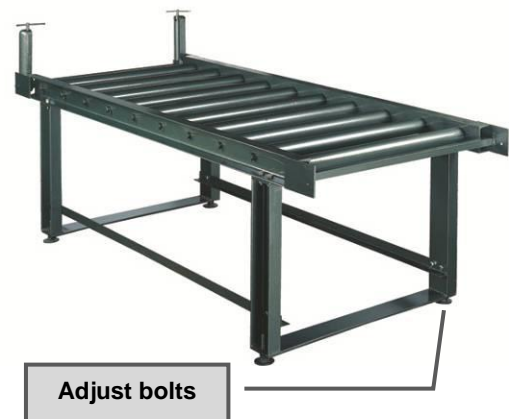
Shock absorption steel plates are provided and can be placed under each leveling bolt to prevent their sinking into the concrete floor.

Installing roller table (optional)

The roller table is used to support long material at the rear and/or the front of the machine.

If you have ordered the optional roller table for cutting long material, position it before or behind the machine.

Level the roller table and the stand with the machine by adjusting the leveling bolts.



Installing Fire Control Device

Install a fire extinguisher or any other fire control device in the shop in case a fire breaks out.

RELOCATING

We recommend you follow these procedures when relocating or shipping your machine to other place:

1. Descend the saw frame to its lowest position then turn off the power.
2. Fix the saw frame using the shipping bracket that originally came with the machine.
3. If you are shipping the machine, pack the machine carefully with industrial plastic wraps to protect it from dust.
4. Use a crane or forklift to raise it. If a crane is used to lift the machine, ensure that the lifting cable is properly attached to the machine.
5. Do not forget to include the equipments originally furnished including the shock absorption steel plates and the instruction manual.

OPERATING INSTRUCTION

SAFETY PRECAUTIONS

BEFORE OPERATING

CONTROL PANEL

STANDARD ACCESSORIES

OPTIONAL ACCESSORIES

UNROLLING & INSTALLING THE BLADE

ADJUSTING WIRE BRUSH

ADJUSTING SAW ARM

ADJUSTING COOLANT FLOW

ADJUSTING BLADE SPEED

BREAKING-IN THE BLADE

TEST-RUNNING THE MACHINE

CUTTING OPERATION

USING TOP CLAMP FOR BUNDLE CUTTING

TERMINATING A CUTTING OPERATION

SAFETY PRECAUTIONS

For your safety, please read and understand the instruction manual before you operate the machine. The operator should always follow these safety guidelines:



- The machine should only be used for its designated purpose.
- Do not wear gloves, neckties, jewelry or loose clothing/hair while operating the machine.



- For eye protection, always wear protective safety glasses.
- Check the blade tension and adjust blade guides before starting the machine.
- Use auxiliary clamping or supporting devices to fix material in place before cutting long workpieces. Always make sure the material is clamped firmly in place before starting to cut.
- Do not remove jammed or cut-off pieces until the blade has come to a full stop.
- Keep fingers away from the path of the blade.



- Protection devices should be in place at all times. For your own safety, never remove these devices.
- Disconnect machine from the power source before making repairs or adjustments.



- Wear protection gloves only when changing the blade.



- Do not operate the machine while under the influence of drugs, alcohol or medication.



- Do not take your eyes off the machine while in operation.
- Do place warning signs to mark out machine work zone and restrict entry to be staff-only.

BEFORE OPERATING

Choosing an appropriate saw blade and using the right cutting method is essential to your cutting efficiency and safety. Select a suitable saw blade and cutting method based on your work material and job requirements e.g. cutting accuracy, cutting speed, economic concern, and safety control.

Wet cutting

If you choose dry cutting or low-speed cutting, the chips may accumulate in machine parts and may cause operation failure or insulation malfunction. We suggest you choose wet cutting to avoid machine damage.

Cutting unknown materials

Before cutting an unknown material, consult the material supplier, burn a small amount of chips from the material in a safe place, or follow any other procedure to check if the material is flammable.



Never take your eyes off the machine while in operation.

Cutting fluid

For cooling and lubrication purpose, we recommend you use water-soluble cutting fluids. The following table lists out its pros and cons for your reference.

Pro	Con
<ul style="list-style-type: none">• Have a high cooling effect• Not flammable• Economical• Does not require cleaning of the cut products	<ul style="list-style-type: none">• Remove machine paint• Lose its rust protection effect if deteriorated• Tend to create foam• Subject to decay• Decline in performance, depending on the quality of the water used for dilution



Never use water as your coolant.



Always add coolant into water for better mix result.



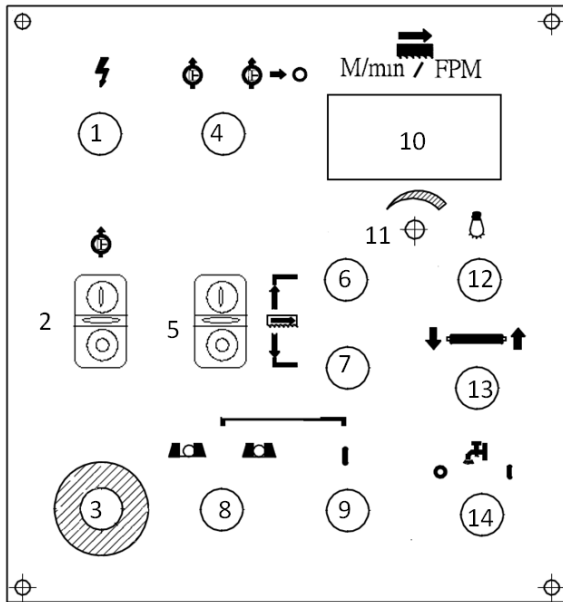
Consult your coolant supplier for bandsaw use regarding coolant type and mix ratio.



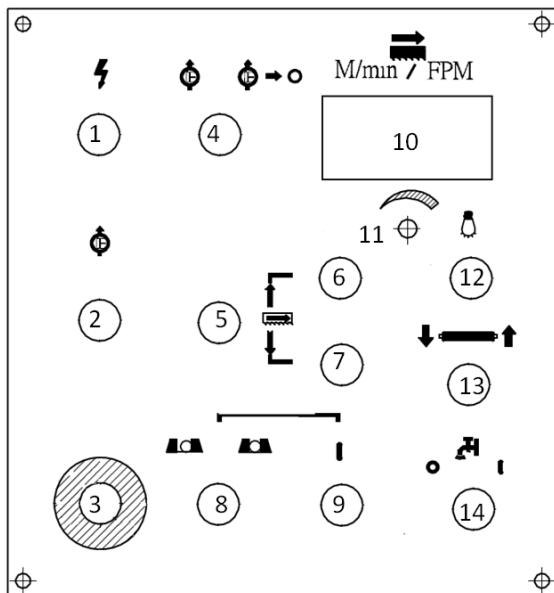
Before starting a cutting job, make sure there is sufficient amount of coolant in the tank. Check the fluid level through the sight gauge. Please refer to machine specifications in this manual (Section 2) for tank capacity.

CONTROL PANEL

The control panel is located on the top of the electrical box. It includes the following function: power system, hydraulic system, cooling system and the light system. The operator must fully understand the function of each switch and button before operating the machine.



CE model



Non-CE model

No.	Name
1	Power indicator lamp
2	Hydraulic start/stop buttons with built-in lamp (CE model) Hydraulic start button with built-in lamp (non-CE model)
3	Emergency stop button
4	Last cut function on/off switch
5	Saw blade start/stop buttons with built-in lamp (CE model) Saw blade start button with built-in lamp (non-CE model)
*6	Saw bow up button
7	Saw bow down button
8	Vise open/clamp selector switch
9	Vise operation button
10	Blade speed indicator
11	Blade speed control knob
12	Work light button (N/A)
13	Lift rollers up/down switch (N/A)
14	Coolant on/off switch

Control Buttons

1. Power indicator lamp

When the lamp is on, it indicates the power to the machine is turned on.

2. Hydraulic start/stop buttons with built-in lamp (CE model)

Hydraulic start button with built-in lamp (non-CE model)

CE model

When the green button is pressed, the built-in-lamp will come on and the hydraulic motor starts to operate. When the red button is pressed, the hydraulic motor turns off immediately.

Non-CE model

When this button is pressed, the built-in-lamp will come on and the hydraulic motor starts to operate. Press *emergency stop* button to stop the hydraulic motor.




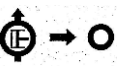
When the hydraulic motor is ON, the chip conveyor will run at the same time, please keep your hands away from the chip conveyor.

3. Emergency stop button

Press this button to stop the machine in an emergency. When the button is pressed, it brings the machine to a full stop. The button locks when pressed. In order to unlock it, please turn the button clockwise.

4. Last cut function on/off switch

When this mode  is selected, the blade will automatically stop as it completes the current job and triggers the lower limit switch, but the hydraulic system will remain ON.

When this mode  is selected, the blade will automatically stop as it completes the current job and triggers the lower limit switch, and the hydraulic system will shut down (in 10 seconds).

5. Saw blade start/stop buttons with built-in lamp (CE model)

Saw blade start button with built-in lamp (non-CE model)

CE model

When the green button is pressed, the built-in-lamp will come on and the blade motor starts to operate. When the red button is pressed, the blade motor stops.

Non-CE model

When this button is pressed, the built-in-lamp will come on and the blade motor starts to operate. Press *saw bow up* button to stop the blade motor.



The *vise open/clamp switch* must be turned to the right to “clamp” position before the blade can start running.

6. *Saw bow up button

When this button is pressed, the saw bow rises until the operator release the button.

***If the optional angle display is installed:**

DO NOT rise the saw bow **over 420mm height**, otherwise the angle display sensor beside angle scale will get pressed by saw bow and caused damage.

*Please refer to the optional accessory in page. 4-11 for more details.





While pressing the *saw bow up* button, it will also stop the running blade; please use the *emergency stop* button in an emergency.

7. Saw bow down button

When this button is pressed, the saw bow descends until the operator lets go of the button or until the saw bow touches the lower limit switch.

8. Vise clamp/unclamp selector switch

This selector switch works with the No. 9 *Vise operation* button. This selector switch is used to select if the vise will clamp  or unclamp  after pressing the *vise operation* button.



For the blade to start running, the vise must be clamped.

9. Vise operation button

Press this button and the vise will clamp or unclamp according to No. 8 Vise clamp/unclamp selector switch.

10. Blade speed indicator

Blade speed is shown here in predetermined unit (M/min or fpm).



All parameter settings have been done by our factory before shipment. Please do not make any random change to the parameter as it may affect the accuracy of the blade speed reading. Please consult your agent shall there be any need to reset machine parameters.

11. Blade speed control knob

Blade speed is controlled by the inverter located under the workbed. Turning the knob clockwise increases the blade speed.

12. Work light button (Not available)

13. Lift rollers up/down switch (Not available)

14. Coolant on/off button

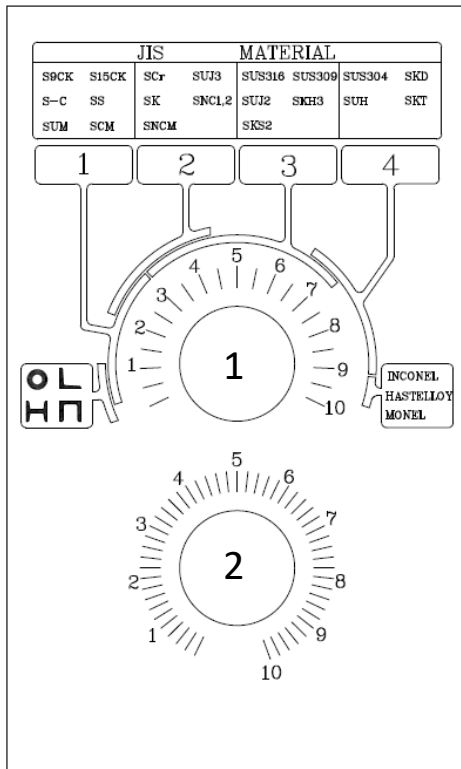
Flip the switch to the right to turn on the coolant pump; to the left to turn it off.



A started blade will also start the coolant automatically.

Blade Descend Pressure and Speed

The part of control panel is where cutting pressure and saw blade descend speed can be adjusted.



Cutting pressure and speed control panel

1. Cutting pressure control knob

- This pressure control knob is used to adjust the cutting pressure of the blade.
- Turning the knob clockwise increases the cutting pressure.
- To obtain a good cutting result, choose the right cutting pressure by turning the knob until it points to your material on the color chart.




2. Blade descend speed control knob

- This knob is used to adjust the descend speed of the saw blade.
- Turning the knob clockwise increases the blade descend speed.
- Blade descend speed is a determining factor to a good cutting time and quality cutoff surface.
- Set the blade descend speed in accordance with the *cutting pressure control* knob.
- Also commonly known as the flow control valve

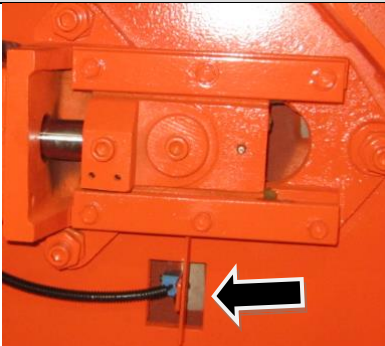
STANDARD ACCESSORIES

Blade tension device



- This blade tension device equipped with hydraulic cylinder provides appropriate tension to the saw blade.
- To tighten the saw blade, turn the selector to .
- Upon saw blade breakage, the safety device will activate and automatically stop all machine operation.
- The limit switch of the safety device can be reset by turning the blade tension selector to .
- To change the blade, turn the handle to  to release saw blade tension.

Blade speed/motion detector



- Besides detecting the blade speed, the speed/motion detector also functions as a safety device.
- The speed/motion detector protects operators and the machine by preventing blade overloads and consequent damages if a saw blade breaks or skids.
- Once blade breakage or slippage is detected, the drive wheel will stop in 10 seconds.

Inverter



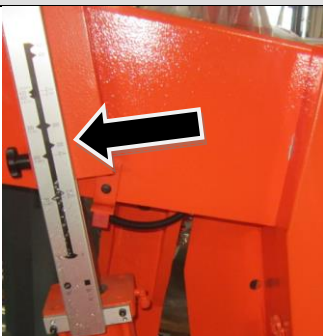
- The inverter is installed under the workbed. The inverter is used to control and stabilize the saw blade speed during cutting.
- To adjust blade speed, use the *blade speed control knob* on the control panel.



Note:

1. Make sure the terminal points are connected.
2. Make sure the ambient temperature is within acceptable range and keep the surroundings well ventilated.
3. Keep the inverter away from dust.
4. For repair or maintenance, please contact your local agent.

Quick approach device



This device allows the blade to quickly descend to just right above the material to save you operation time.

Gear reducer



The specially designed gear reducer can work toward your preset blade speed and torque.



Please refer to section 8 for information on maintenance.

Coolant pump



The coolant pump supplies coolant to cool off cutting temperatures during cutting. Also, it can be used to wash off chips.

Powered wire brush



The wire brush is hydraulically driven to rotate at the same speed as the blade motor. It removes the metal chips on the saw blade teeth so that blade life can be extended.

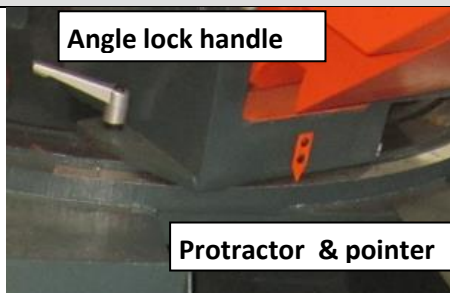


Keep hands away from the transmission shaft and the brush while the wire brush is running



Turn off the hydraulic motor or the main power switch before performing maintenance or cleaning on the wire brush drive system.

Miter cut angle

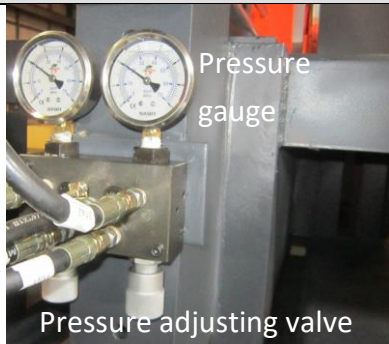


The *swivel sawhead* allows the user to cut at any angle between 0° (straight cut) and 60° (miter cut). The angles have been accurately configured before machine shipment.

For your miter-cutting jobs, simply loosen the angle lock handle, swivel the saw bow until the pointer points to your desired angle and lock the saw bow via angle lock handle.

OPTIONAL ACCESSORIES

Vise pressure regulator



- This adjustment valve is used to control vise pressure.
- Adjust vise pressure based on the material of your workpiece.
- When cutting pipes or soft materials, reduce vise pressure to prevent exerted pressure from damaging the workpiece shape or exterior.



Do not adjust vise pressure at any time during cutting.



Vise pressure should never be lower than 8 kg/cm².

Hydraulic top clamp



The top clamp device is installed on the vise. Before executing bundle cutting, open the adjustment valve so the top clamp can move in sync with the vise.



Note the allowable clamping width and height. (Refer to Specifications of section 2 – General Information.)

Chip conveyor



Chip conveyor is a spiral device to bring chips out during cutting.



As a regular maintenance, remove the chip conveyor and clean all chip deposits inside.

2M roller table

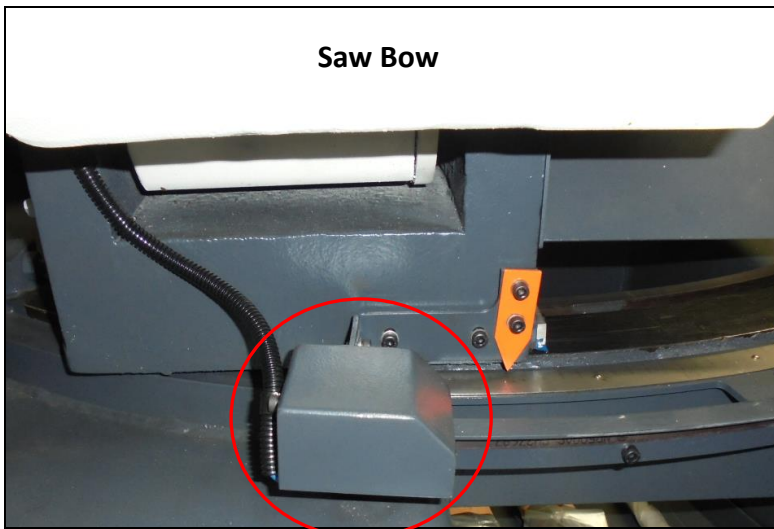


- The optional 2M roller table supports the work material and ensures the material is fed in smoothly.
- Refer to Section 9 for further information on adjusting the roller table.

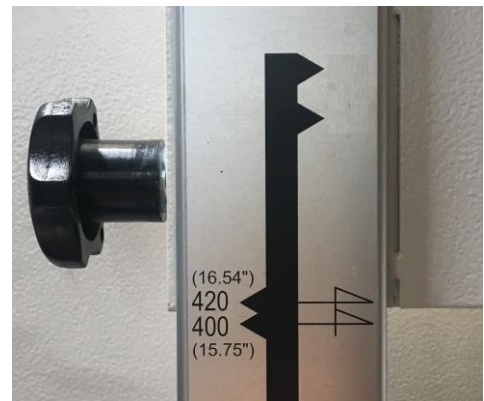
Angle Display Device



- The angle display shows the current saw bow angle, it's easier to process miter cutting when you have angle display.
- ***To prevent the angle display sensor from pressed damage by saw bow:**
 - 1) ***DO NOT** rise the saw bow over 420mm height, otherwise the angle display sensor beside the angle scale will get pressed by saw bow and caused damage.
 - 2) Please **set the height ruler under 420mm height**; when cutting finished, the saw bow will rise automatically until it reaches the point you have set on the ruler.



(angle sensor beside the angle scale)



Blade Deviation Detector & Calibration Procedure (Optional)



Blade Deviation Detector

This device detects blade deviation. If the blade deviates out of the tolerance range, the machine will stop automatically.

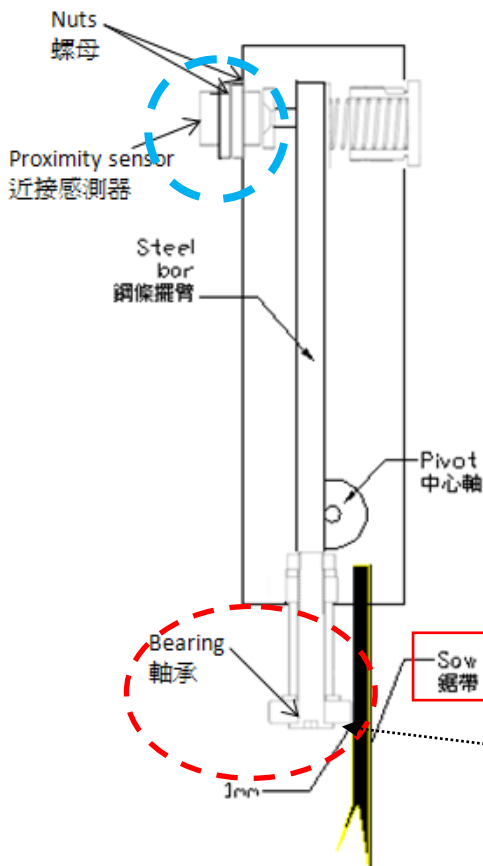
※ [Remark] When this device is installed, the cutting width will be reduced.

The blade deviation detected value and present values are displayed on the HMI screen.

Before cutting, please make sure if the deviation value is "Zero". If not, please calibrate the deviation detector before proceeding to cutting.

****Deviation Tolerance (Recommended):**
±0.1~0.5 mm (±0.004"~0.02 ")。

*Set up according to the tolerance range the users need.



Deviation Detector Side Section

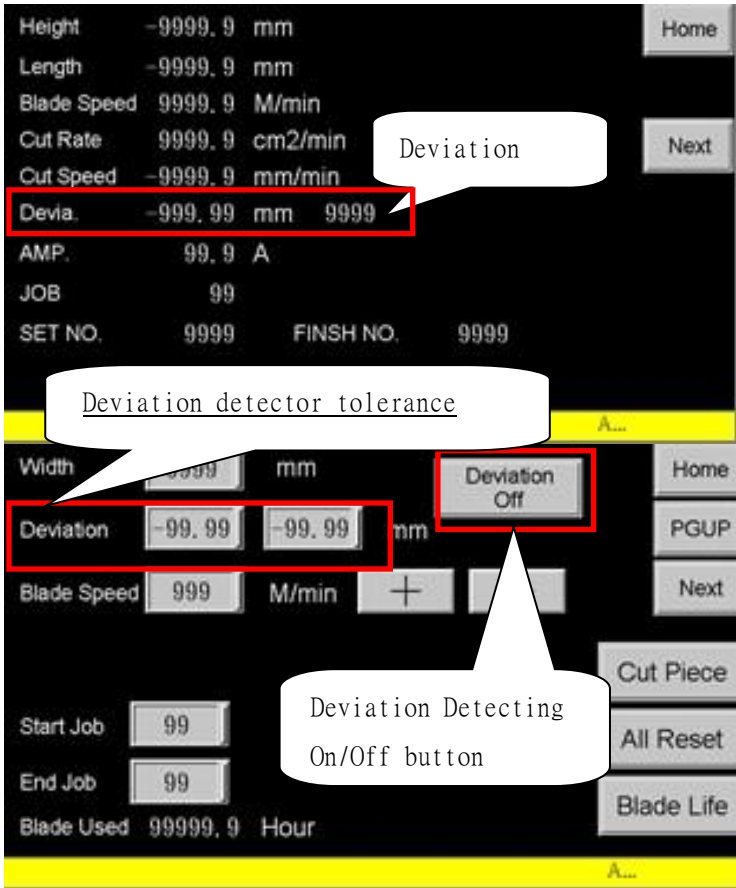
How to Adjust

1. Loosen the nuts.
2. Adjust the proximity sensor until the blade deviation value shown the display returns to zero. (Please refer to the next page.)
3. Tighten the nuts.

How to Check

Put a thick ruler (0.1mm) between saw blade and deviation roller for measurement. Also, check the deviation tilt value; it should be 0.1mm.

- Adjust the proximity sensor until the blade deviation displayed on the control panel is zero.
- If the deviation value not changed when adjusting the proximity sensor or **bearing**, it means the deviation detector with malfunction. Need to replace a new one.
- Please clean the internal shell of deviation detector sometimes for keeping dry and clean.



Picture B : Deviation calibration Value Display

- Make the proximity sensor connect with power & adjust the proximity sensor until the blade deviation displayed on the control panel is 0 mm °
- Tolerance: ± 0.03 mm (0.0012") °

Picture C: Deviation detector tolerance Set-Up & On/Off button

- Deviation Value Set-Up:
 - Set up the tolerance of deviation value; if the value out of range when blading for 15 seconds, the machine will be automatically full stopped with alarm message.
- Deviation Detecting On/Off button:
 - Turn On/Off the deviation detecting function.

***Deviation Detector Tolerance (Recommended):**
 $\pm 0.1 \sim 0.5$ mm ($\pm 0.004'' \sim 0.02''$) °

[NOTE]

The information shown on HMI display: The format of HMI interface will be different from the difference of model and software design.

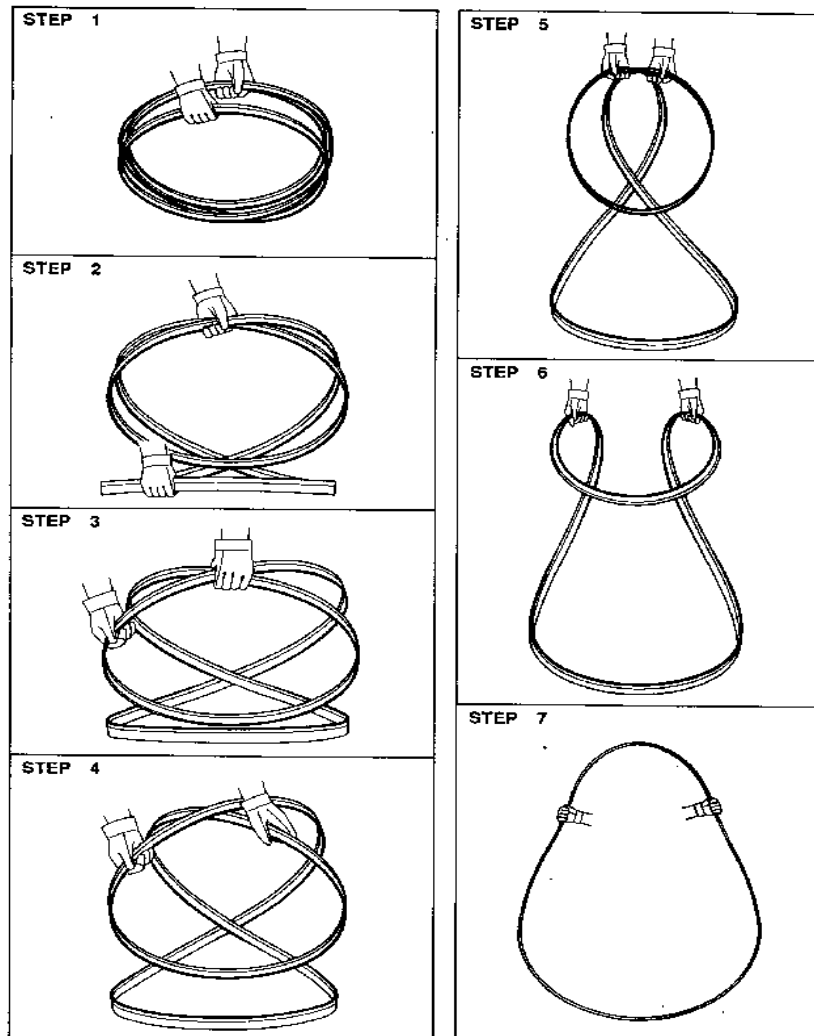
UNROLLING & INSTALLING THE BLADE



Always wear leather gloves and protection glasses when handling a blade.

Unrolling the blade

Please follow the procedures illustrated below.





Unroll and roll the blade

Installing a new blade

Step 1 - Select the most suitable saw blade for your workpiece considering the size, shape and material.

Step 2 - Turn on the machine power by switching to *ON*.

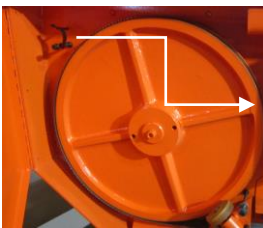
Step 3 - Press the *saw bow up* button and elevate the saw bow until the right insert holder is clear of the fixed vise.

Step 4 - Turn the tension controller handle from “” to “” position to release tension. The idle wheel will then move slightly toward the direction of the drive wheel.



Step 5 - Open the idle and drive wheel cover.

Step 6 - Press the *Blade Clip* device to hold onto the blade. This device makes blade changing easy and feasible even with only one operator available.

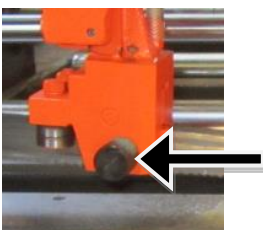


Blade Clip

Step 7 - Loosen the wire brush assembly fixed nuts and pull the wire brush away from the blade.



Step 8 - Loosen the left and right carbide inserts by **loosening the “lock nut”** shown below. Detach the old blade from below the left and right guide seat and then pull the entire blade out.



Step 9 - If necessary, clean the carbide inserts before installing a new saw blade.

Step 10 - Place the new blade around the idle wheel and the drive wheel


Step 11 - Insert the blade into the left and right tungsten carbide inserts. The back and the sides of the blade need to be touching the inserts as well as the adjacent rollers.

Step 12 - Place the blade to the drive wheel and press the back of the blade against the flange of the drive wheel. Use the *Blade Clip* device to tightly hold the blade from falling out of the drive wheel.



When saw blade begins to rotate, the blade holder will automatically release the blade and fall back to its original position.

Step 13 - Make sure the back of the blade is also pressed against the flange of the idle wheel.

Step 14 - Turn the tension controller handle to [] position to obtain blade tension.

Step 15 - Make sure the sides of the blade are in close contact with the carbide inserts and then tighten the left and right carbide inserts by **tightening the “lock nut.”**

Step 16 – Gently close the idle and drive wheel covers.

Step 17 - Press the *saw blade start* button to start the blade. Allow the blade to run for a few rotations then press the *saw bow up* button to elevate the saw bow. Open the wheel covers and make sure the blade has not fallen off the drive and idle wheels. If the blade has shifted, follow the same procedure to reinstall the blade again.

Step 18 - Adjust wire brush to a proper position. Refer to *Adjusting wire brush* in this section.

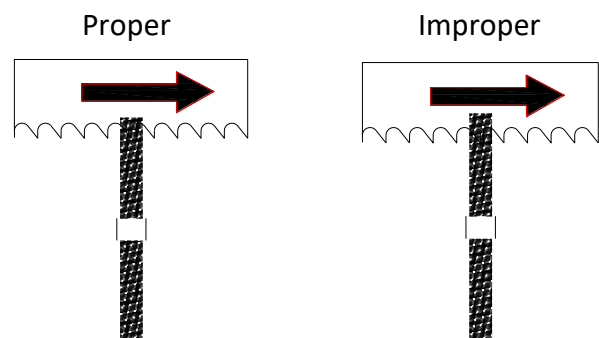
ADJUSTING WIRE BRUSH

Follow these steps to adjust wire brush to appropriate position:

Step 1 - Open the drive wheel cover.

Step 2 - Adjust the fixed nuts to make brush move up / down until it makes proper contact with the saw blade (see below illustration).

Step 3 - Close the drive wheel cover.



ADJUSTING SAW ARM

Adjust the blade guide (guide arm) position based on the size of your workpiece:

Step 1 – Loosen the inserts by unlocking the lock nut.

Step 2 – Loosen the blade guide locking handle. Then adjust the guide arm to a position suitable for your workpiece size.

Step 3 – After adjustment is made, tighten the blade guide locking handle.

Step 4 – Clamp the inserts back by tightening the lock nut.



Locking Handle

Inserts Lock Nut

ADJUSTING COOLANT FLOW

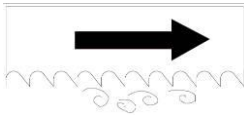
Step 1 – Press the *saw blade start* button to start the saw blade drive motor.

Step 2 – Press the *saw bow down* button to lower the saw bow.

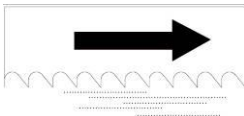
Step 3 – Use the flow control valve (shown below) to adjust the amount of fluid flowing to the cutting area.



Adjust the flow amount if you observe the following changes to the chips generated from cutting.



If the chips are sharp and curved, increase the coolant flow amount.



If the chips are granulated, decrease the coolant flow amount.

ADJUSTING BLADE SPEED

Step 1 – Set the flow control to “0” position.

Step 2 – Press the *saw blade start* button to start the blade..

Step 3 – Turn the *blade speed control knob* to adjust the blade speed. The blade speed should be adjusted based on the size and the material of the workpiece.

BREAKING-IN THE BLADE

When a new saw blade is used, be sure to first break in the blade before using it for actual, extended operation. Failure to break in the blade will result in less than optimum efficiency. To perform this break-in operation, the following instructions should be followed:

Step 1 - Reduce the blade speed to one-half of its normal setting.

Step 2 - Lengthen the cutting time to 2-3 times of what is normally required.

Step 3 - Start the break-in operation.

Step 4 - After the break-in operation is completed, set all parameters back to normal settings.

TEST-RUNNING THE MACHINE

Test-running this machine can ensure good machine performance in the future. We suggest you run the following tests on the machine before first use:

Testing machine performance:

Turn on the power and run a basic performance test after you finish installing the machine. Follow these steps to test machine performance:

Step 1 – Disassemble shipping brackets and bolts.

Step 2 – Install roller table (optional)

Step 3 – Turn on the relay switch in the control box.

Step 4 – Elevate the saw bow. (If your coolant pump is in reverse and the machine cannot run, please change the electrical phase.)

Step 5 – After the saw bow ascends, extend the quick approach device.

Step 6 – Remove the rust-prevention grease with cleaning oil or kerosene.

Step 7 – Start the coolant pump.

Step 8 – Test these functions under manual mode:

- vise clamping/unclamping
- saw bow ascending/descending

CUTTING OPERATION

Step 1 – Check before you cut

- **Power:** Check the voltage and frequency of your power source.
- **Coolant:** Check if you have sufficient coolant in the tank.
- **Hydraulic:** Check if you have sufficient (at least two-thirds or higher) hydraulic oil.
- **Workbed:** Check if there is any object on the feeding bed that may cause interference.
- **Blade:** Check the blade teeth and make sure there is no worn out teeth along the blade.
- **Light:** Check the work lamp or laser light (optional) and make sure there is sufficient lighting.
- **Roller:** Check all the rollers on the front and rear workbed can roll smoothly.
- **Saw bow:** Check the saw bow to see if it can be elevated and lowered smoothly

Step 2 – Place your workpiece onto the workbed manually or by using a lifting tool e.g. a crane.



Before loading, make sure the vises are opened to at least wider than the width of the workpiece.

Step 3 – Position your workpiece.

Step 4 – Clamp the workpiece.

Step 5 – Turn the *cutting pressure control* knob to adjust cutting pressure according to the material.

Step 6 – Adjust *blade descend speed control* knob to obtain a suitable blade descend speed for your material.

Step 7 – Start running the blade.



Before you start cutting, check again that there is no other object in the cutting area.

Step 8 – While the blade descends, adjust the blade speed if necessary. You can do so by turning the *blade speed control* knob, clockwise to speed up and counterclockwise to slow down. The blade speed is displayed in the blade speed indicator.

Step 9 – Select the proper cutting condition according to different material.

Step 10 – After the entire cutting job is completed, elevate the saw bow to the top and open the vises to remove the workpiece.

Step 11 – Clean the workbed by removing chips and cutting fluids.

Step 12 – Lower the saw bow to a proper position then turn off the power.

USING TOP CLAMP FOR BUNDLE CUTTING



Before Cutting , Make sure that the bundle is properly tightly clamped but not being distorted by clamp force.

Any improper bundle cutting can cause damage to the blade, reduce the blade life.

Notice: There are several factors to makes bundle cutting more difficult and unstable, such as vibration, wide guide spacing, coolant getting to the teeth and cutting through work hardened chips.

1. Each bar of the bundle is suggested to be the same size for being firmly clamped in the bundle.
2. Make sure that the bundle is properly placed (before cutting) to refrain from vibration, spinning and changing length position during cutting.
3. Tack welding ends of bars will prevent spinning but not vibration.

Installing top clamp

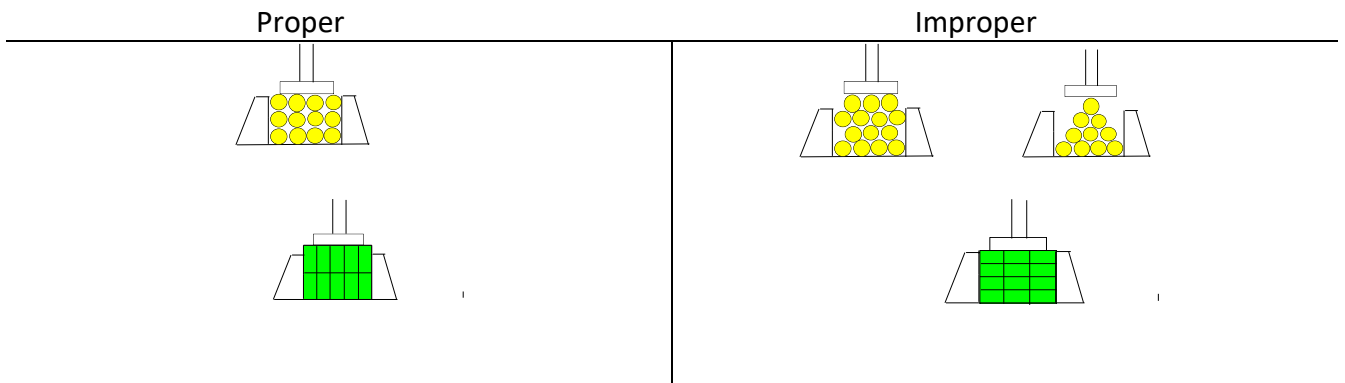
To perform bundle cutting, use the top clamps and take the following installation procedures.

Step 1 – Position the workpiece for bundle cutting.



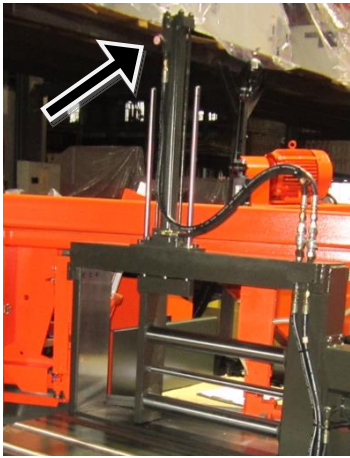
Note the allowable clamping width and height. (Refer to *Section 2 – General Information, Specifications*)

Proper and improper stacking of workpieces



Step 2 – Align the top clamp cylinders with the center of the workpiece and tighten the lock nuts.

Step 3 – Open the adjustment valve (pointed by the arrow), which is used to adjust the top clamp speed during clamping/unclamping.



Step 4 – Install the bundle-cutting fence to the work tray. The fence is designed to prevent cut pieces from scattering across the work tray. Adjust the width of the fence to be slightly larger than the width of the bundle.

Step 5 – For subsequent cutting procedures, refer to the instructions under manual operation and automatic operation.



TERMINATING A CUTTING OPERATION

- To terminate a cutting operation, press either the *saw bow up* button or the *emergency stop* button.
- The saw blade will stop running when the *saw bow up* button is pressed.
- Both the saw blade and hydraulic pump motors will stop running when the *emergency stop* button is pressed.

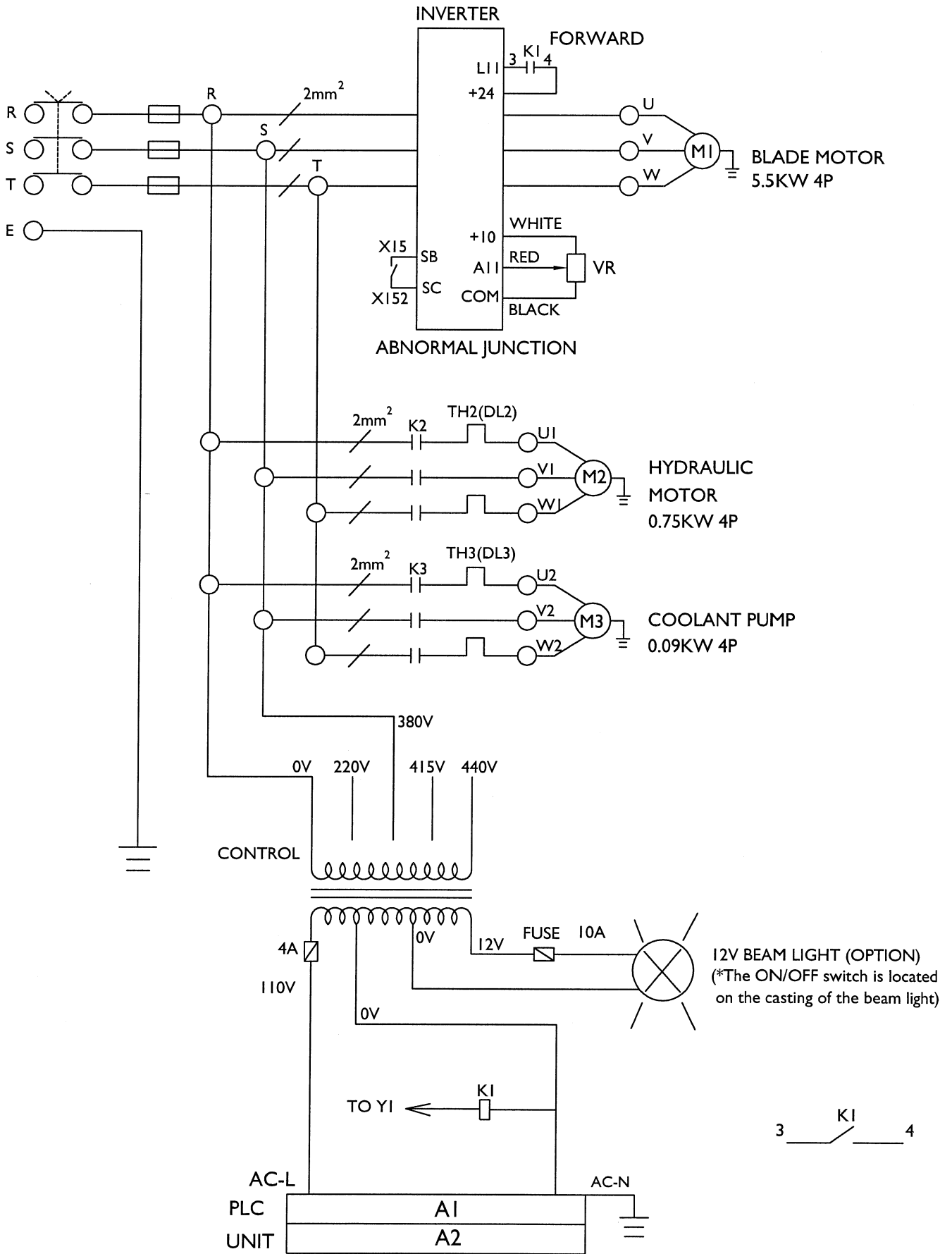
Section 5

ELECTRICAL SYSTEM

ELECTRICAL CIRCUIT DIAGRAMS

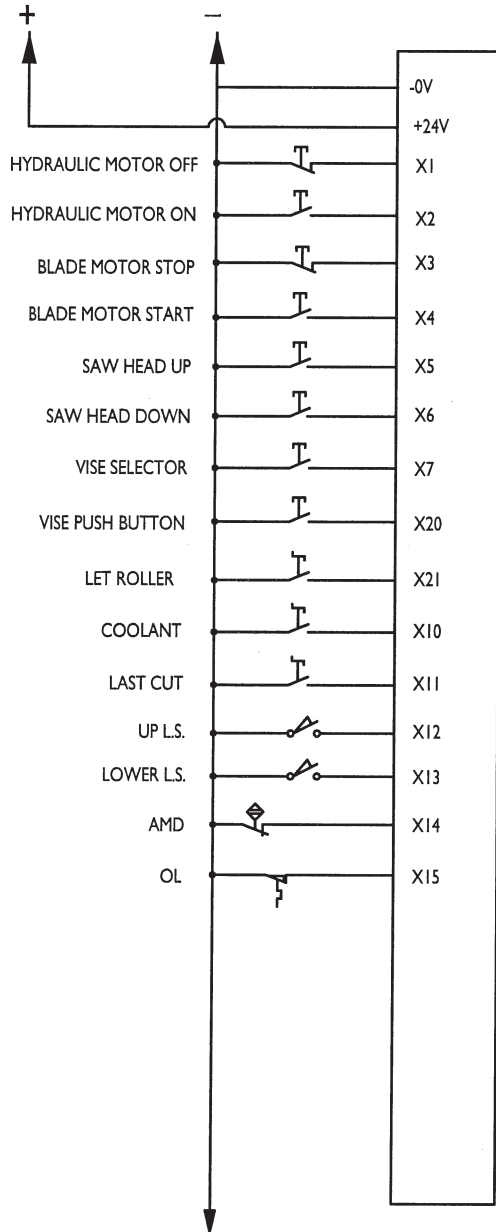
Non-CE model: p. 5-2~5-5

CE model: p.5-6~5-9

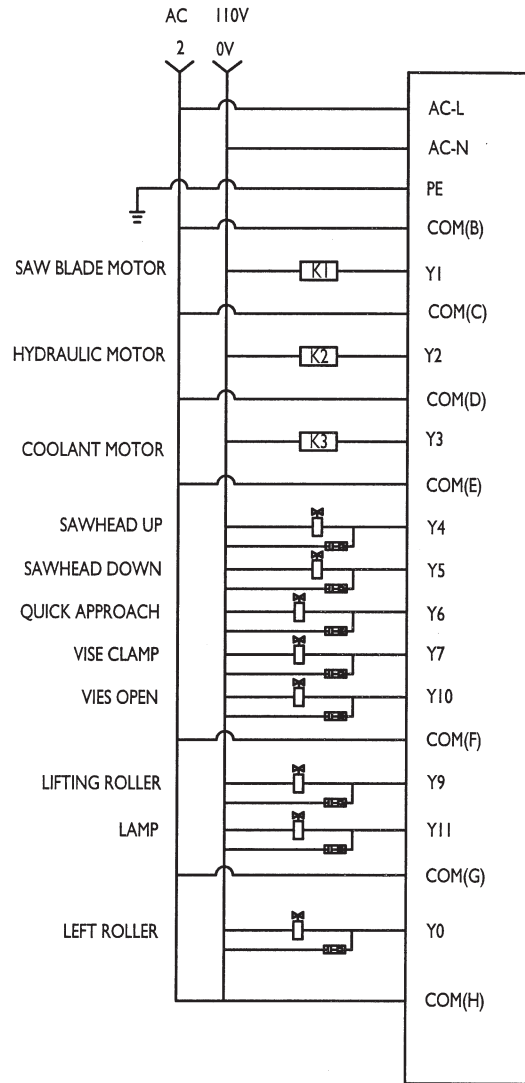


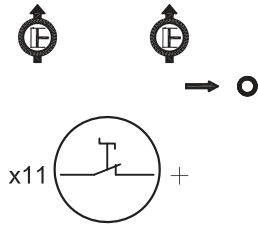
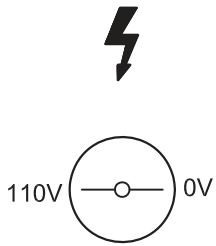
PLC INPUT MODULE A1

TO ENCODER

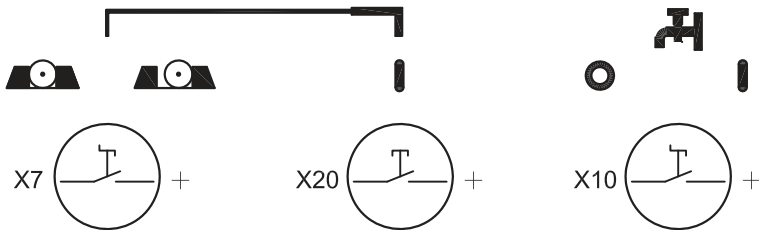
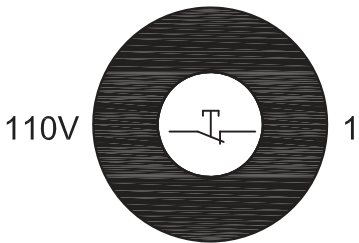
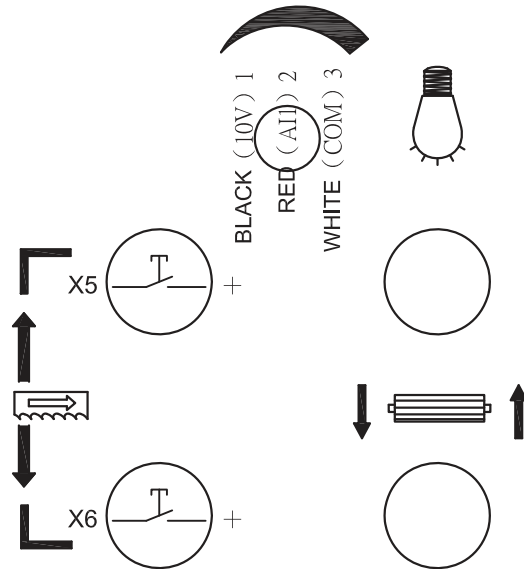
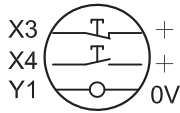
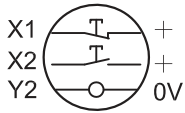
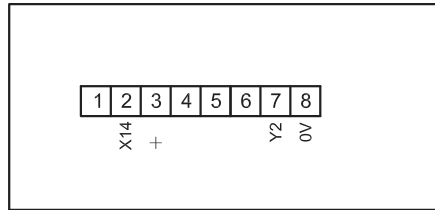


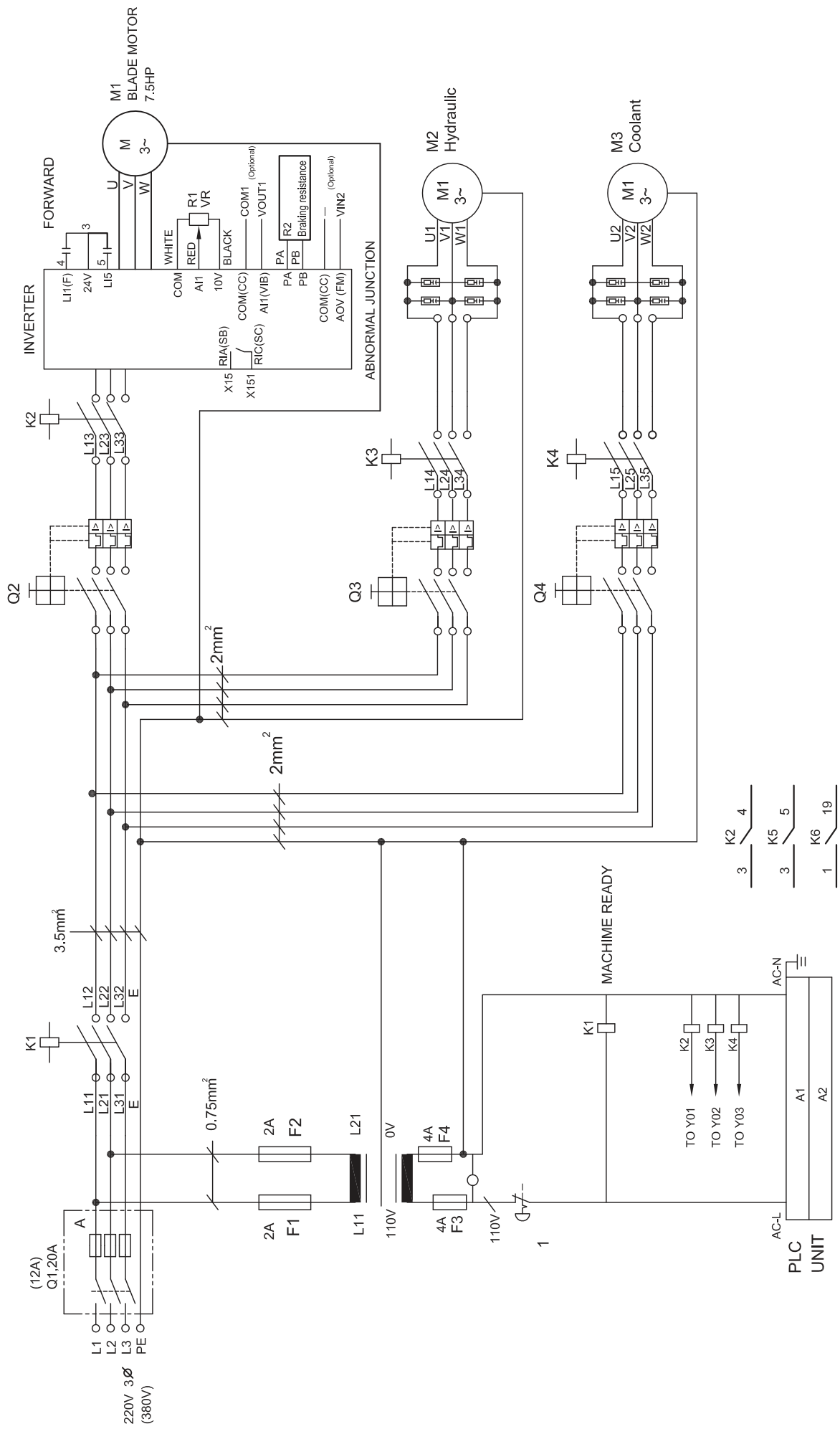
PLC OUTPUT MODULE A2



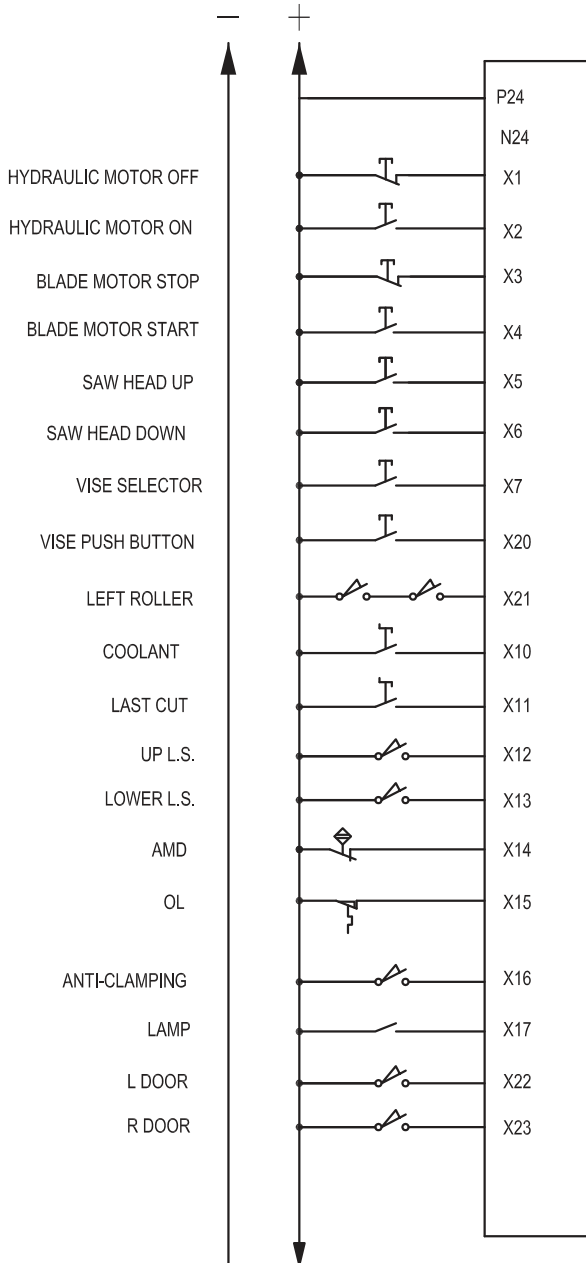


M/Min / FPM

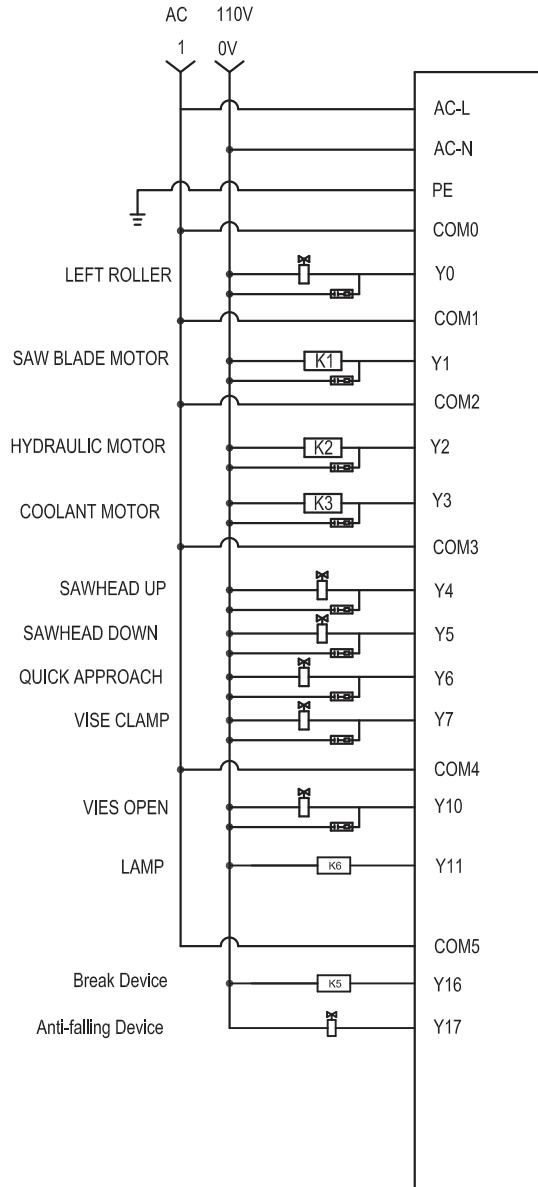




PLC INPUT



PLC OUTPUT

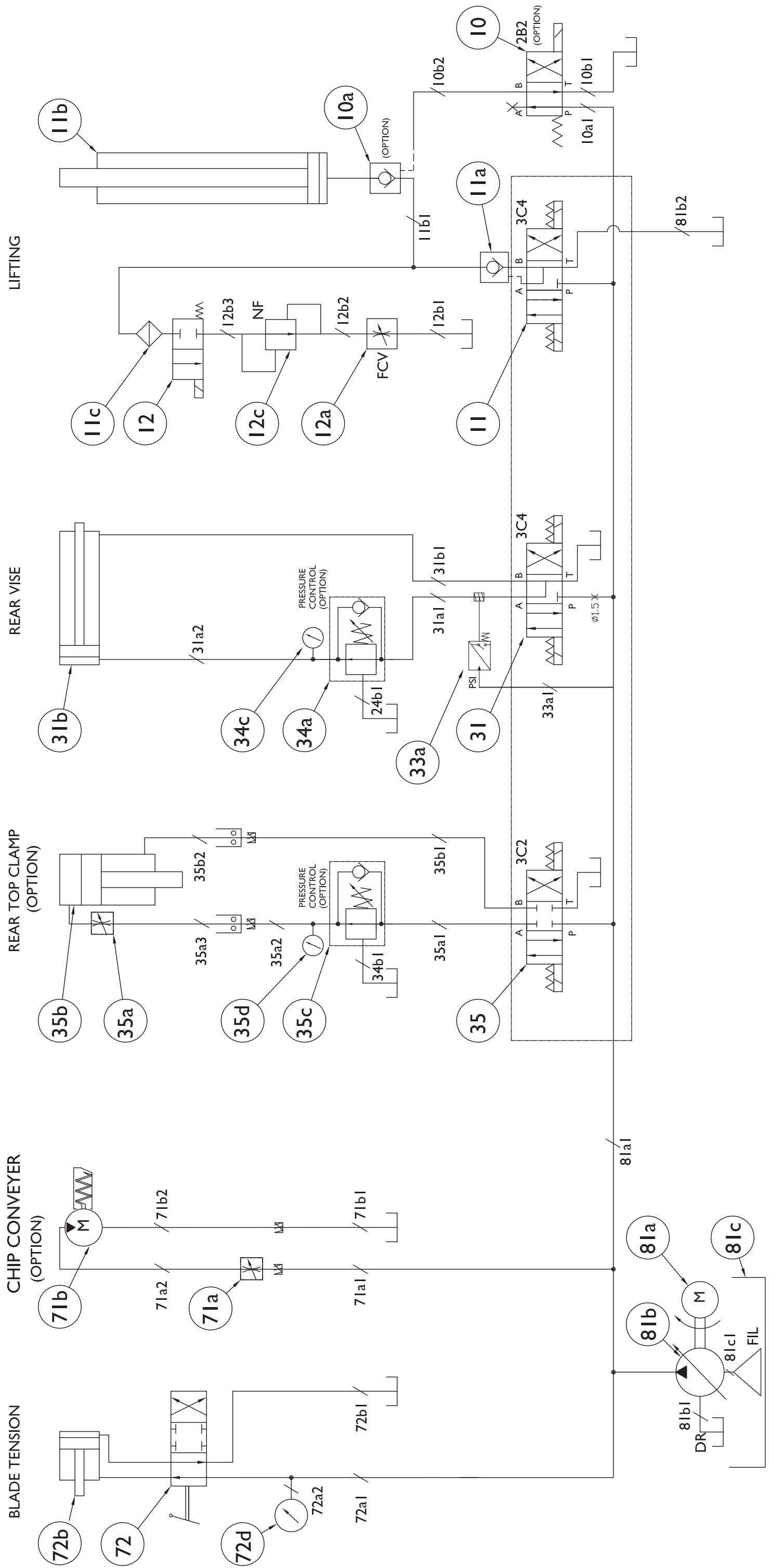


Section 6

HYDRAULIC SYSTEM

HYDRAULIC DIAGRAMS

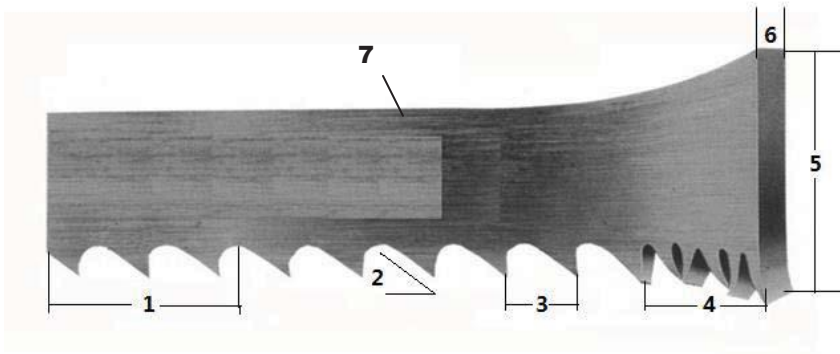
HYDRAULIC CIRCUIT



BANDSAW CUTTING: A PRACTICAL GUIDE

**INTRODUCTION
SAW BLADE SELECTION
VISE LOADING
BLADE BREAK-IN**

INTRODUCTION



- 1. TPI:** The number of teeth per inch as measured from gullet to gullet.
- 2. Tooth Rake Angle:** The angle of the tooth face measured with respect to a line perpendicular to the cutting direction of the saw.
- 3. Tooth Pitch:** Tooth pitch refers to the number of teeth per inch (tpi). 1 inch equates to 25.4 mm.

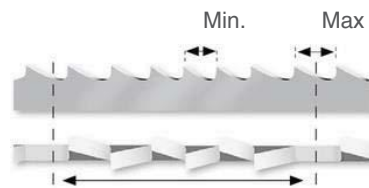
A distinction is made between constant tooth pitches with a uniform tooth distance, 2 tpi for example, and variable tooth pitches with different tooth distances within one toothing interval.

Variable tooth pitches, for instance 2-3 tpi, can be characterized by two measures: 2 tpi stands for the maximum tooth distance and 3 tpi stands for the minimum tooth distance in the toothing interval.

Constant



Variable



- 4. Set:** The bending of teeth to right or left to allow clearance of the back of the blade through the cut.
- 5. Width:** The nominal dimension of a saw blade as measured from the tip of the tooth to the back of the band.
- 6. Thickness:** The dimension from side to side on the blade.
- 7. Gullet:** The curved area at the base of the tooth. The tooth tip to the bottom of the gullet is the gullet depth.

SAW BLADE SELECTION

1. Band length

The dimensions of the band will depend on the band saw machine that has been installed.

Please refer to Section 2 – General Information

2. Band width

Band width: the wider the band saw blade, the more stability it will have.

3. Cutting edge material

The machinability of the material to be cut determines what cutting material you should choose.

4. Tooth pitch

The main factor here is the contact length of the blade in the workpiece.

If it is 4P, $25.4 \div 4 P = 6.35$ mm, that is, one tooth is 6.35 mm.

If it is 3P, $25.4 \div 3 P = 8.46$ mm If the number is small, it means that the tooth is large.

What is written as 3/4 is that it is a variable pitch of large (3) / small (4).

The saw blade must contact the cutting material at least two pitches. In the case of a thickness of 15 mm, 4P = OK, 3P = NG.

- The surface conditions will also affect the cutting rate. If there are places on the surface on the material which are hard, a slower blade speed will be required or blade damage may result.
- It will be slower to cut tubing than to cut solids, because the blade must enter the material twice, and because coolant will not follow the blade as well.
- Tough or abrasive materials are much harder to cut than their machinability rating would indicate.
- Tooth spacing is determined by the hardness of the material and its thickness in cross section.
- Tooth set prevents the blade from binding in the cut. It may be either a "regular set" (also called a "raker set") or a "wavy set".
- The regular or raker set is most common and consists of a pattern of one tooth to the left, one tooth to the right, and one which is straight, or unset. This type of set is generally used where the material to be cut is uniform in size and for contour cutting.
- Wavy set has groups of teeth set alternately to right and left, forming a wave-like pattern. This reduces the stress on each individual tooth, making it suitable for cutting thin material or a variety of materials where blade changing is impractical. Wavy set is often used where tooth breakage is a problem. This is shown in Fig. 7.2 as follows:

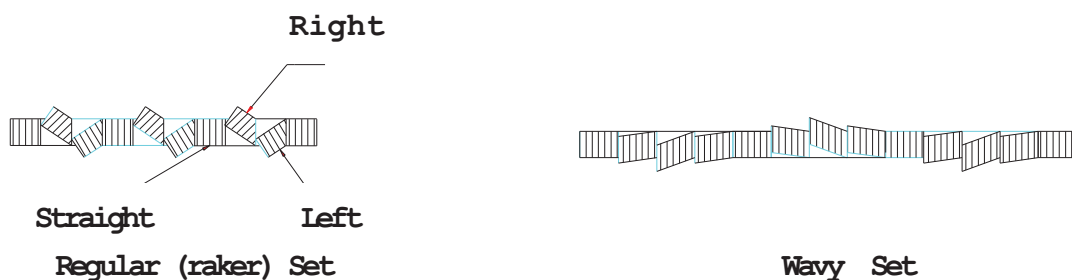


Fig. 7.2 The Saw Set

WISE LOADING

The position in which material is placed in the vise can have a significant impact on the cost per cut.

Often, loading smaller bundles can mean greater sawing efficiency.



When it comes to cutting odd-shaped material, such as angles, I-beams, channel, and tubing, the main point is to arrange the materials in such a way that the blade cuts through as uniform a width as possible throughout the entire distance of cut.

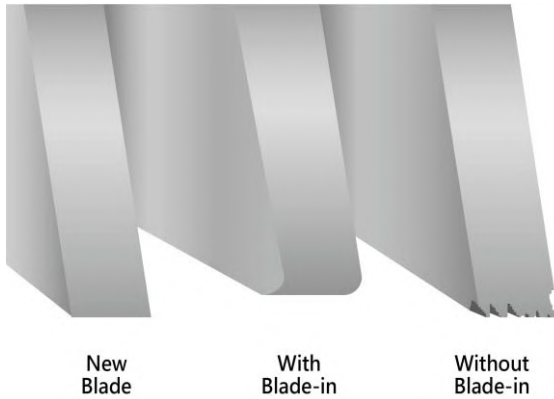
The following diagrams suggest some costeffective ways of loading and fixturing. Be sure, regardless of the arrangement selected, that the work can be firmly secured to avoid damage to the machine or injury to the operator.



BLADE BREAK-IN

Completing a proper break-in on a new band saw blade will dramatically increase its life.

1. Select the proper band speed for the material to be cut.



2. Reduce the feed force/rate to achieve a cutting rate 20% to 50% of normal (soft materials require a larger feed rate reduction than harder materials).

3. Begin the first cut at the reduced rate. Make sure the teeth are forming a chip. Small adjustments to the band speed may be made in the event of excessive noise/vibration. During the first cut, **increase feed rate/force** slightly once the blade fully enters the workpiece. With each following cut, **gradually increase feed rate/force** until normal cutting rate is reached.

MAINTENANCE & SERVICE

INTRODUCTION

BASIC MAINTENANCE

MAINTENANCE SCHEDULE

BEFORE BEGINNING A DAY'S WORK

AFTER ENDING A DAY'S WORK

Every 2 weeks

First 600hrs for new machine, then every 1200hrs **for routine change**

EVERY SIX MONTHS

STORAGE CONDITIONS

TERMINATING THE USE OF MACHINE

OIL RECOMMENDATION FOR MAINTENANCE

INTRODUCTION

For the best performance and longer life of the band saw machine, a maintenance schedule is necessary. Some of the daily maintenance usually takes just a little time but will give remarkable results for the efficient and proper operation of cutting.

BASIC MAINTENANCE

It is always easy and takes just a little effort to do the basic maintenance. But it always turns out to be a very essential process to assure the long life and efficient operation of the machine. Most of the basic maintenance requires the operator to perform it regularly.

MAINTENANCE SCHEDULE

We suggest you do the maintenance on schedule.

Before beginning a day's work

1. Please check the hydraulic oil level. If oil level volume is below 1/2, please add oil as necessary. (Filling up to 2/3 level is better for system operation.)
2. Please check the cutting fluid level, adding fluid as necessary. If the fluid appears contaminated or deteriorated, drain and replace it.
3. Please check the saw blade to ensure that it is properly positioned on both the drive and idle wheels.
4. Please make sure that the saw blade is properly clamped by the left and right inserts.
5. Please check the wire brush for proper contact with the saw blade. Replace the wire brush if it is worn out.

After ending a day's work

Please remove saw chips and clean the machine with discharging the cutting fluid when work has been completed.



Do not discharge cutting fluid while the saw blade is operating because it will cause severe injury on operator's hand.



Be sure the saw blade is fully stop, it will be performed after working inspection.

Every 2 weeks

Please apply Grease to the following points:

1. Idle wheel
2. Drive wheel
3. Blade tension device

Recommended Grease:

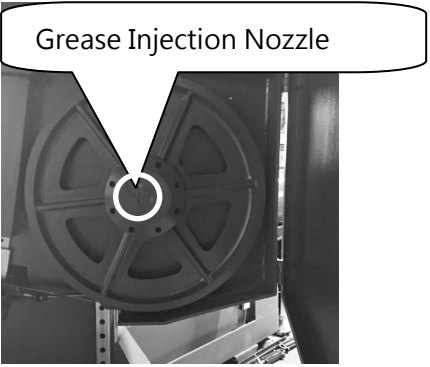

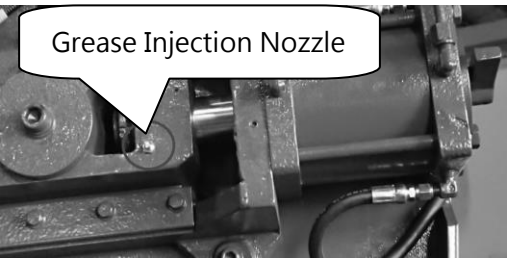

- Shell Alvania EP Grease 2
- Mobil Mobilplex 48

Please apply lubricating oil to the following points: (if applicable)
Main shaft (double column)

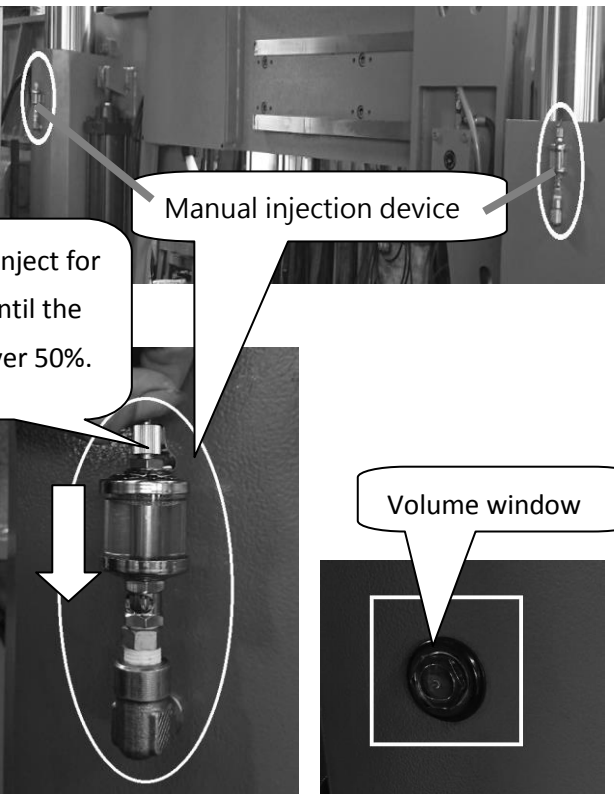

Recommended Lubricating Oil:

- CPC Circulation oil R68

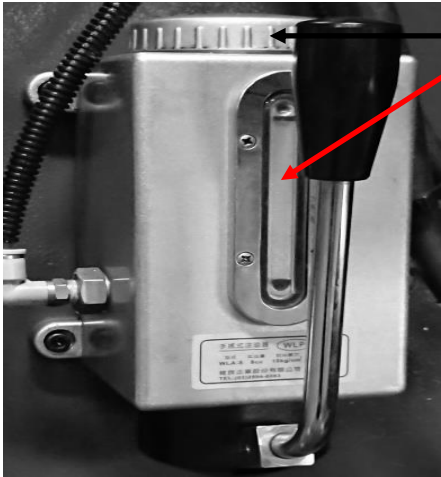


Grease Injection Hole:

	<ol style="list-style-type: none"> Grease Injection Nozzles at the middle of drive wheel and idle wheel; (You need to rotate the wheel until you see the Grease injection nozzle.)  : The position of injection indicating. <ol style="list-style-type: none"> Please inject the grease into the Nozzle.
	<ol style="list-style-type: none"> Grease Injection Nozzle on the blade tension device.  : The position of injection indicating. <ol style="list-style-type: none"> Please inject the grease into the Nozzle.

Lubricating Oil Injection for Main shaft (double column) (if applicable):

	<ol style="list-style-type: none"> Two manual injection device for two main shafts (double column)  : The position of injection indicating. <ol style="list-style-type: none"> Pull up & inject lubricating oil for seconds Recommend always keeping the volume over 50% inside the vessel of volume window. °
---	--

Manual Lubrication Injection Device: (if applicable)

	<p>Lubrication volume indicator. Recommend keeping the volume over 50% inside the vessel.</p>
	<p> Please take down this vessel cap to replenish the lubrication.</p> <p>For the prevention of working environment pollution, DO NOT replenish too much volume of lubrication while supplying the lubrication into the vessel.</p> <p>Under the circumstances of normal operation, replenish the lubrication once every three days.</p> <p>It may be adjusted the schedule of replenishing whenever the user needs.</p> <p>The main function is to lubricate the slide rail and block. (The liner guideway for saw bow).</p>

First 600hrs for new machine, then every 1200hrs **for routine change**

Replace the transmission oil after operating for first 600hrs for new machine, then every 1200hrs

Recommended gear oil

- Shell Omala oil HD220
- Mobil gear 630

Recommended hydraulic oil

- ShellTellus 32
- Mobil DTE Oil Light Hydraulic 24

Every six months

1. Clean the filter of the cutting fluid.
2. Replace the transmission oil for every half of a year (or 1200 hours).
Check the sight gauge to ascertain the transmission level.

Recommended TRANSMISSION OIL

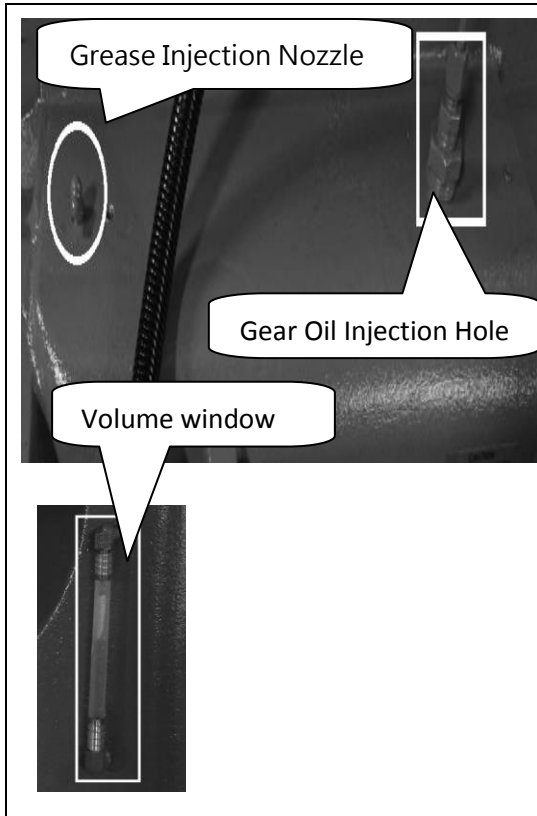
- Omala oil HD220
- Mobil comp 632 600W Cylinder oil

3. Replace the hydraulic oil.

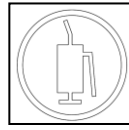
Recommended HYDRAULIC OIL

- ShellTellus 32
- Mobil DTE Oil Light Hydraulic 24

Gear Oil & Grease Injection Hole:



1. A grease injection hole and a gear oil injection hole on the top of gear reducer.



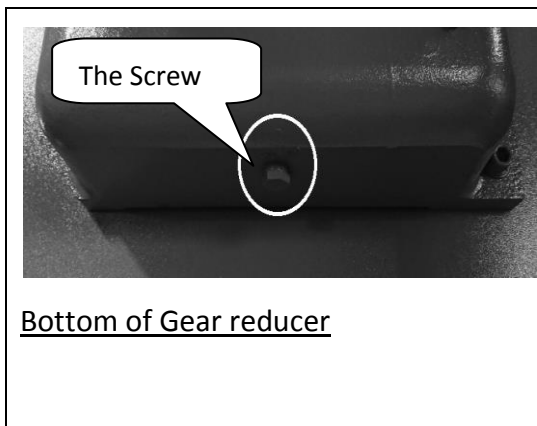
: The position of injection indicating.

2. Recommend keeping the volume under 50% inside the vessel of volume window. °

***NOTE: Over 50% oil in the gear box will cause oil spilling out.**

3. To use the machine in a sub-zero environment, please add antifreeze into gear reducer.

To unload the waste fluid:



1. Put the waste oil container in the bottom of the reducer for unloading waste fluid
2. Use the wrench to open the screw for unloading the waste fluid.
3. Make sure the screw bolted tightly after unloading completed,

STORAGE CONDITIONS

Generally, this machine will be stored on the following conditions in future:

- (1) Turn off the power.
- (2) Ambient temperature: 5°C ~ 40°C
- (3) Relative humidity: 30%~85% (without condensation)
- (4) Atmosphere: use a plastic canvas to cover machine to avoid excessive dust, acid fume, corrosive gases and salt.
- (5) Avoid exposing to direct sunlight or heat rays which can change the environmental temperature.
- (6) Avoid exposing to abnormal vibration.
- (7) Must be connected to earth.

TERMINATING THE USE OF THE MACHINE

Waste disposal:

When your machine can not work anymore, you should **drain** the oil from machine body. Please **store** the oil in safe place with bottom **tray**. Ask a environment specialist to handle the oil. It can avoid soil pollution. The oil list in machine:

- Hydraulic oil
- Cutting fluid
- Drive wheel gear oil

OIL RECOMMENDATION FOR MAINTENANCE

Item	Method	Revolution	Suggest oil
Dovetail guide	Keep grease covered. Antirust.	Daily	Shell R2
Roller bearing	Sweep clean and oil with lubricant.	Daily	SAE #10
Bed roller / surface	Sweep clean and oil with lubricant.	Daily	SAE #10
Nipples of bearing	Use grease gun, but not excess.	Monthly	Shell R2
Blade tension device	Use grease gun, but not excess.	Monthly	Shell Alvania EP Grease 2, Mobil Mobilplex 48
Reducer	Inspect once a week. Change oil of 600 hours of using. Change it every year.	Regularly	Omala oil HD220 Mobil Gear 630
Hydraulic system	Inspect half a year. Change oil every year.	Regularly	Shell Tellus 32 Mobil DTE oil Light Hydraulic 24
Bearing	Inserts	Oil with lubricant, but not excess.	Daily
	Band wheel	Oil with lubricant, but not excess.	Weekly
	Cylinder	Oil with lubricant, but not excess.	6 Monthly
	Wire brush	Oil with lubricant, but not excess.	6 Monthly



- 1. Turn off the stop circuit breaker switch before servicing the machine.**
- 2. Then post a sign to inform people that the machine is under maintenance.**
- 3. Drain all of the cutting fluid and oil off and carefully treat them to avoid pollution.**
- 4. The machine must be either LOCKED OUT OR TAGGED OUT while under maintenance.**

TROUBLESHOOTING

INTRODUCTION

PRECAUTIONS

GENERAL TROUBLES & SOLUTIONS

MINOR TROUBLES & SOLUTIONS

MOTOR TROUBLES & SOLUTIONS

BLADE TROUBLES & SOLUTIONS

SAWING PROBLEMS & SOLUTIONS

RE-ADJUSTING THE ROLLER TABLE

INTRODUCTION

All the machines manufactured by Clausing pass a 72 hours continuously running test before shipping out and we are responsible for the after sales service problems during the warranty period if the machines are used normally. However, there still exist the some unpredictable problems which may disable the machine from operating.

Generally speaking, the system troubles in this machine model can be classified into three types, namely GENERAL TROUBLES, MOTOR TROUBLES and BLADE TROUBLES. Although you may have other troubles which can not be recognized in advance, such as malfunctions due to the limited life-span of mechanical, electric or hydraulic parts of the machine.

We have accumulated enough experiences and technical data to handle all of the regular system troubles. Meanwhile, the engineering department of Clausing had been continuously improving the machines to prevent all possible troubles.

It is hoped that you will give us your maintenance experience and ideas so that both sides can achieve the best performance.

PRECAUTIONS

When an abnormality occurs in the machine during operation, you can do it yourself safely. If you have to stop machine motion immediately for parts exchanging, you should do so according to the following procedures:

- Press HYDRAULIC MOTOR OFF button or EMERGENCY STOP button.
- Open the electrical enclosure door.
- Turn off breaker.



BEFORE ANY ADJUSTMENT OR MAINTENANCE OF THE MACHINE, PLEASE MAKE SURE TO TURN OFF THE MACHINE AND DISCONNECT THE POWER SUPPLY.

GENERAL TROUBLES AND SOLUTIONS



DISCONNECT POWER CORD TO MOTOR BEFORE ATTEMPTING ANY REPAIR OR INSPECTION.

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Motor stalls	Excessive belt tension	Adjust belt tension so that belt does not slip on drive pulley while cutting (1/2" Min. deflection of belt under moderate pressure.)
	Excessive head pressure	Reduce head pressure. Refer to Operating Instructions "Adjusting Feed".
	Excessive blade speed	Refer to Operating Instructions "Speed Selection".
	Improper blade selection	Refer to Operating Instructions "Blade Selection".
Cannot make square cut	Dull blade	Replace blade.
	Guide rollers not adjusted properly	Refer to Adjustments.
	Rear vise jaw not adjusted properly	Set fixed vise jaw 90° to blade.
	Excessive head pressure	Reduce head pressure. Refer to operating instructions "Adjusting Feed."
Increased cutting time	Dull blade	Replace blade
	Insufficient head pressure	Increase head pressure. Refer to Operating Instructions "Adjusting Feed."
	Reduce blade speed	Refer to Operating Instructions "Speed Selection."
Will not cut	Motor running in wrong direction	Reverse rotation of motor. (Motor rotation C.C.W. pulley end.)
	Blade teeth pointing in wrong direction	Remove blade, turn blade inside out. Re-install blade. (Teeth must point in direction of travel.)
	Hardened material	Use special alloy blades. (Consult your industrial distributor for recommendation on type of blade required.)

MINOR TROUBLES & SOLUTIONS

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Saw blade motor does not run even though blade drive button is pressed.	Overload relay activated	Reset
	Saw blade is not at forward limit position.	Press SAW FRAME FORWARD button

MOTOR TROUBLES & SOLUTIONS

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Motor will not start	Magnetic switch open, or protector open.	Reset protector by pushing red button (inside electric box.)
	Low voltage	Check power line for proper voltage.
	Open circuit in motor or loose connections.	Inspect all lead terminations on motor for loose or open connections.
Motor will not start, fuse or circuit breakers "blow".	Short circuit in line, cord or plug.	Inspect line, cord and plug for damaged insulation and shorted wire.
	Short circuit in motor or loose connections	Inspect all lead terminations on motor for loose or shorted terminals or worn insulation on wires.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
Motor fail to develop full power. (Power output of motor decreases rapidly with decrease in voltage at motor terminals.)	Power line overloaded with lights, appliances and other motors.	Reduce the load on the power line.
	Undersize wires or circuit too long.	Increase wire sizes, or reduce length of wiring
	General overloading of power company's facilities.	Request a voltage check from the power company
Motor overheat	Motor overloaded.	Reduce load on motor
	Air circulation through the motor restricted.	Clean out motor to provide normal air circulation through motor.
Motor stalls (Resulting in blown fuses or tripped circuit breakers)	Short circuit in motor or loose connections.	Inspect terminals in motor for loose or shorted terminals or worn insulation on lead wires.
	Low voltage	Correct the low line voltage conditions.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses circuit breakers.
	Motor overloaded	Reduce motor load.
Frequent opening of fuses or circuit breakers.	Motor overloaded	Reduce motor load
	Incorrect fuses or circuit breakers.	Install correct fuses or circuit breakers.

BLADE TROUBLES AND SOLUTIONS



DISCONNECT POWER CORD TO MOTOR BEFORE ATTEMPTING ANY REPAIR OR INSPECTION.

TROUBLE	PROBABLE CAUSE	SUGGESTED REMEDY
Teeth strippage	Too few teeth per inch	Use finer tooth blade
	Loading of gullets	Use coarse tooth blade or cutting lubricant.
	Excessive feed	Decrease feed
	Work not secured in vise	Clamp material securely
Blade breakage	Teeth too coarse	Use a finer tooth blade
	Misalignment of guides	Adjust saw guides
	Dry cutting	Use cutting lubricant
	Excessive speed	Lower speed. See Operating Instructions "Speed selection."
	Excessive speed	Reduce feed pressure. Refer to Operating Instructions "Adjusting Feed."
	Excessive tension	Tension blade to prevent slippage on drive wheel while cutting.
Blade line Run-out or Run-in	Wheels out of line	Adjust wheels
	Guides out of line	For a straight and true cut, realign guides, check bearings for wear.
	Excessive pressure	Conservative pressure assures long blade life and clean straight cuts.
	Support of blade insufficient	Move saw guides as close to work as possible.
	Material not properly secured in vise	Clamp material in vise, level and securely.
Blade twisting	Blade tension improper	Loosen or tighten tension on blade.
	Blade not in line with guide bearings	Check bearings for wear and alignment.
	Excessive blade pressure	Decrease pressure and blade tension
Premature tooth wear	Blade binding in cut	Decrease feed pressure
	Dry cutting	Use lubricant on all materials, except cast iron
	Blade too coarse	Use finer tooth blade
	Not enough feed	Increase feed so that blade does not ride in cut
	Excessive speed	Decrease speed

SAWING PROBLEMS AND SOLUTIONS

Other than this manual, the manufacturer also provides some related technical documents listed as follows:

Sawing Problems and Solutions

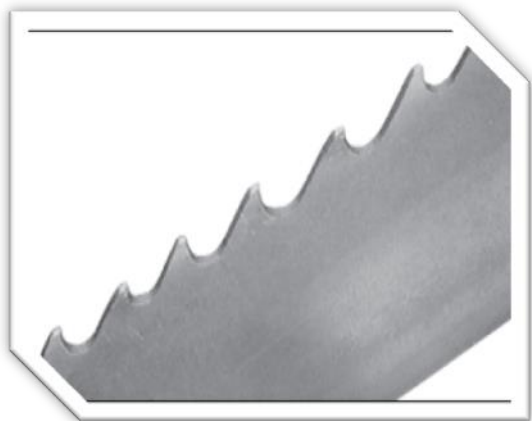
					Vibration during cutting	Failure to cut	Short life of saw blade	Curved cutting	Broken blade		
✓	✓	✓	✓	✓						Use of blade with incorrect pitch	Use blade with correct pitch suited to workpiece width
✓	✓	✓	✓	✓						Failure to break-in saw blade	Perform break-in operation
✓	✓	✓								Excessive saw blade speed	Reduce speed
			✓	✓						Insufficient saw blade speed	Increase speed
✓		✓	✓	✓						Excessive saw head descending speed	Reduce speed
✓		✓	✓							Insufficient saw head descending speed	Increase speed
		✓	✓							Insufficient saw blade tension	Increase tension
✓		✓	✓	✓						Wire brush improperly positioned	Relocate
✓		✓	✓							Blade improperly clamped by insert	Check and correct
✓	✓	✓	✓	✓						Improperly clamped workpiece	Check and correct
	✓	✓	✓							Excessively hard material surface	Soften material surface
		✓	✓	✓						Excessive cutting rate	Reduce cutting rate
	✓	✓								Non-annealed workpiece	Replace with suitable workpiece
✓		✓	✓	✓						Insufficient or lean cutting fluid	Add fluid or replace
✓		✓	✓	✓						Vibration near machine	Relocate machine
		✓	✓							Non-water soluble cutting fluid used	Replace
✓		✓	✓							Air in cylinder	Bleed air
✓		✓		✓						Broken back-up roller	Replace
✓	✓	✓	✓	✓						Use of non-specified saw blade	Replace
✓	✓	✓	✓	✓						Fluctuation of line voltage	Stabilize
✓		✓	✓							Adjustable blade guide too far from workpiece	Bring blade guide close to workpiece
✓		✓	✓	✓						Loose blade guide	Tighten
		✓		✓						Blue or purple saw chips	Reduce cutting rate
✓		✓		✓						Accumulation of chips at inserts	Clean
	✓									Reverse positioning of blade on machine	Reinstall
✓		✓	✓							Workpieces are not bundled properly	Re-bundle
✓		✓		✓						Back edge of blade touching wheel flange	Adjust wheel to obtain clearance
✓	✓	✓								Workpiece of insufficient diameter	Use other machine, suited for diameter of workpiece
	✓	✓	✓							Saw blade teeth worn	Replace

SOLUTIONS TO SAWING PROBLEMS

Table Of Contents

#1. Heavy Even Wear On Tips and Corners Of Teeth	#11. Uneven Wear Or Scoring On The Sides Of Band
#2. Wear On Both Sides Of Teeth	#12. Heavy Wear And/Or Swagging On Back Edge
#3. Wear On One Side Of Teeth	#13. Butt Weld Breakage
#4. Chipped Or Broken Teeth	#14. Heavy Wear In Only The Smallest Gullets
#5. Body Breakage Or Cracks From Back Edge	#15. Body Breaking – Fracture Traveling In An Angular Direction
#6. Tooth Strippage	#16. Body Breakage Or Cracks From Gullets
#7. Chips Welded To Tooth Tips	#17. Band is Twisted Into A Figure "8" Configuration
#8. Gullets Loading Up With Material	#18. Used Band Is "Long" On The Tooth Edge
#9. Discolored Tips Of Teeth Due To Excessive Frictional Heat	#19. Used Band Is "Short" On The Tooth Edge
#10. Heavy Wear On Both Sides Of Band	#20. Broken Band Shows A Twist In Band Length.

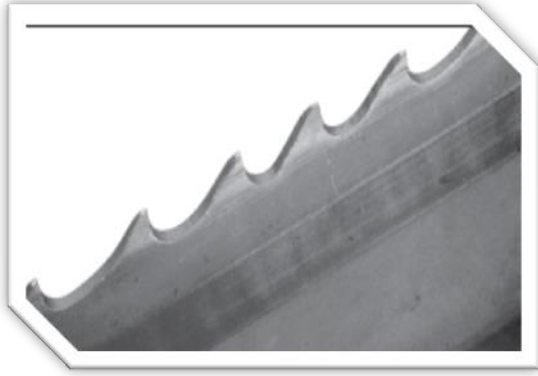
#1. Heavy Even Wear On Tips and Corners Of Teeth



Probable Cause :

- A.** Improper break-in procedure.
- B.** Excessive band speed for the type of material being cut. This generates a high tooth tip temperature resulting in accelerated tooth wear.
- C.** Low feed rate causes teeth to rub instead of penetrate. This is most common on work hardened materials such as stainless and toolsteels.
- D.** Hard materials being cut such as "Flame Cut Edge" or abrasive materials such as " Fiber Reinforced Composites".
- E.** Insufficient sawing fluid due to inadequate supply, improper ratio, and/or improper application

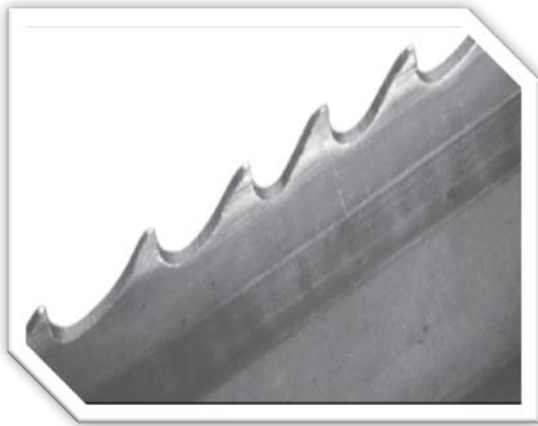
#2. Wear On Both Sides Of Teeth



Probable Cause :

- A. Broken, worn or missing back-up guides allowing teeth to contact side guides.
- B. Improper side guides for band width.
- C. Backing the band out of an incomplete cut.

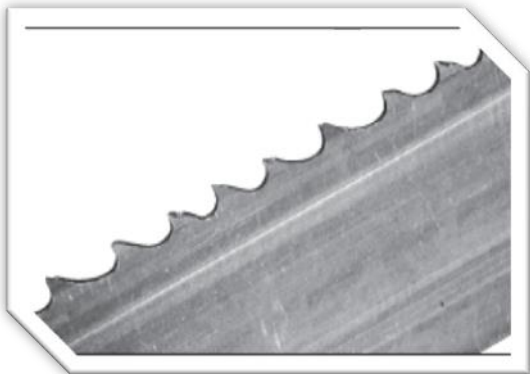
#3. Wear On One Side Of Teeth



Probable Cause :

- A. Worn wheel flange, allowing side of teeth to contact wheel surface or improper tracking on flangeless wheel.
- B. Loose or improperly positioned side guides.
- C. Blade not perpendicular to cut.
- D. Blade rubbing against cut surface on return stroke of machine head.
- E. The teeth rubbing against a part of machine such as chip brush assembly, guards, etc.

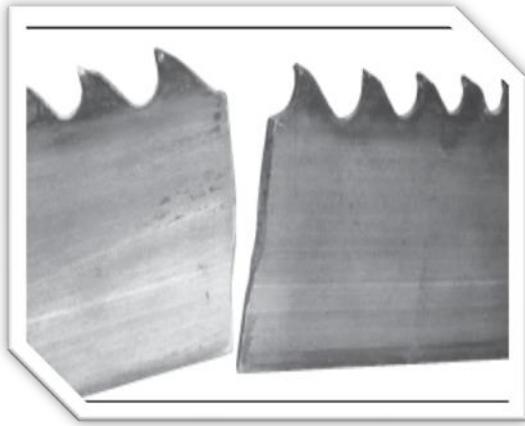
#4. Chipped Or Broken Teeth



Probable Cause :

- A. Improper break-in procedure.
- B. Improper blade selection for application.
- C. Handling damage due to improper opening of folded band.
- D. Improper positioning or clamping of material.
- E. Excessive feeding rate or feed pressure.
- F. Hitting hard spots or hard scale in material

#5. Body Breakage Or Cracks From Back Edge



Probable Cause :

- A. Excessive back-up guide "preload" will cause back edge to work harden which results in cracking.
- B. Excessive feed rate.
- C. Improper band tracking – back edge rubbing heavy on wheel flange.
- D. Worn or defective back-up guides.
- E. Improper band tension.
- F. Notches in back edge from handling damage

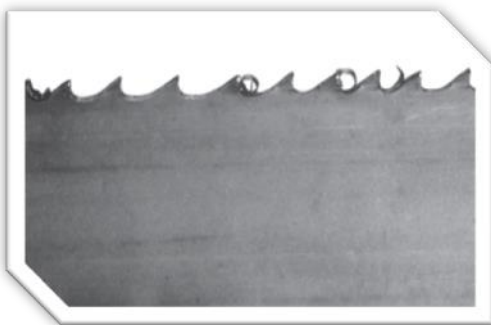
#6. Tooth Strippage



Probable Cause :

- A. Improper or lack of break-in procedure.
- B. Worn, missing or improperly positioned chip brush.
- C. Excessive feeding rate or feed pressure.
- D. Movement or vibration of material being cut.
- E. Improper tooth pitch for cross sectional size of material being cut.
- F. Improper positioning of material being cut.
- G. Insufficient sawing fluid due to inadequate supply, improper ratio and/or improper application.
- H. Hard spots in material being cut.
- I. Band speed too slow for grade of material being cut.

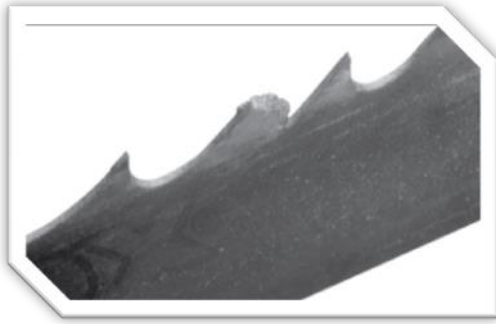
#7. Chips Welded To Tooth Tips



Probable Cause :

- A. Insufficient sawing fluid due to inadequate supply, improper ratio and/or improper application.
- B. Worn, missing or improperly positioned chip brush.
- C. Improper band speed.
- D. Improper feeding rate.

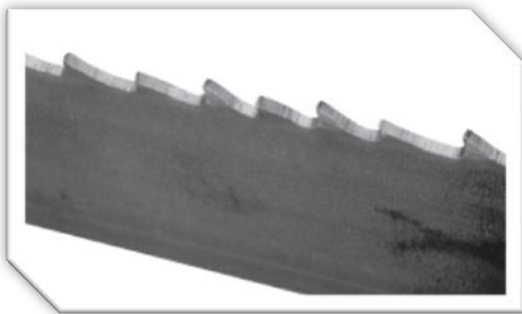
#8. Gullets Loading Up With Material



Probable Cause :

- A. Too fine of a tooth pitch – insufficient gullet capacity.
- B. Excessive feeding rate producing too large of a chip.
- C. Worn, missing or improperly positioned chip brush.
- D. Insufficient sawing fluid due to inadequate supply, improper ratio and/or improper application.

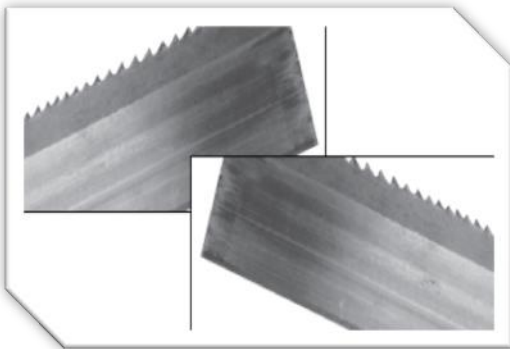
#9. Discolored Tips Of Teeth Due To Excessive Frictional Heat



Probable Cause :

- A. Insufficient sawing fluid due to inadequate supply, improper ratio and/or improper application.
- B. Excessive band speed.
- C. Improper feeding rate.
- D. Band installed backwards.

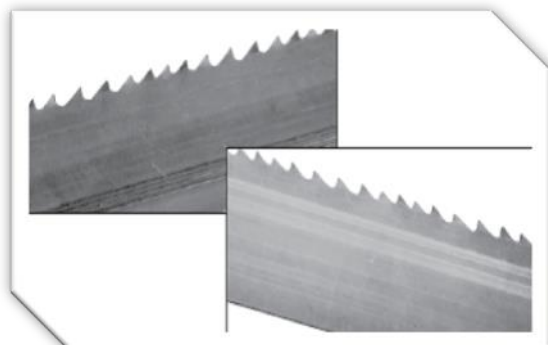
10. Heavy Wear On Both Sides Of Band



Probable Cause :

- A. Chipped or broken side guides.
- B. Side guide adjustment may be too tight.
- C. Insufficient flow of sawing fluid through the side guides.
- D. Insufficient sawing fluid due to inadequate supply, improper ratio and/or improper application.

#11. Uneven Wear Or Scoring On The Sides Of Band



Probable Cause :

- A. Loose side guides.
- B. Chipped, worn or defective side guides.
- C. Band is rubbing on part of the machine.
- D. Guide arms spread to maximum capacity.
- E. Accumulation of chips in side guides.

#12. Heavy Wear And/Or Swagging On Back Edge



Probable Cause :

- A. Excessive feed rate.
- B. Excessive back-up guide "preload".
- C. Improper band tracking – back edge rubbing heavy on wheel flange.
- D. Worn or defective back-up guides.

#13. Butt Weld Breakage



Probable Cause :

- A. Any of the factors that cause body breaks can also cause butt weld breaks.
- (See Observations #5, #15 and #16)**

#14. Heavy Wear In Only The Smallest Gullets



Probable Cause :

- A. Excessive feeding rate.
- B. Too slow of band speed.
- C. Using too fine of a tooth pitch for the size of material being cut.

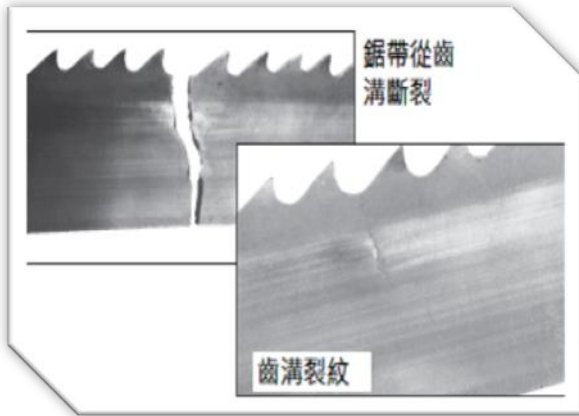
#15. Body Breaking – Fracture Traveling In An Angular Direction



Probable Cause :

- A. An excessive twist type of stress existed.
- B. Guide arms spread to capacity causing excessive twist from band wheel to guides.
- C. Guide arms spread too wide while cutting small cross sections.
- D. Excessive back-up guide "preload".

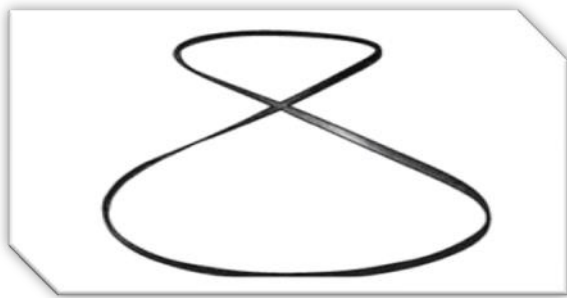
#16. Body Breakage Or Cracks From Gullets



Probable Cause :

- A. Excessive back-up guide "preload".
- B. Improper band tension.
- C. Guide arms spread to maximum capacity.
- D. Improper beam bar alignment.
- E. Side guide adjustment is too tight.
- F. Excessively worn teeth.

#17. Band is Twisted Into A Figure "8" Configuration



Probable Cause :

- A. Excessive band tension.
- B. Any of the band conditions which cause the band to be long (#18) or short (#19) on tooth edge.
- C. Cutting a tight radius.

#18. Used Band Is "Long" On The Tooth Edge



Probable Cause :

- A. Side guides are too tight – rubbing near gullets.
- B. Excessive "preload" – band riding heavily against back-up guides.
- C. Worn band wheels causing uneven tension.
- D. Excessive feeding rate.
- E. Guide arms are spread to maximum capacity.
- F. Improper band tracking – back edge rubbing heavy on wheel flange.

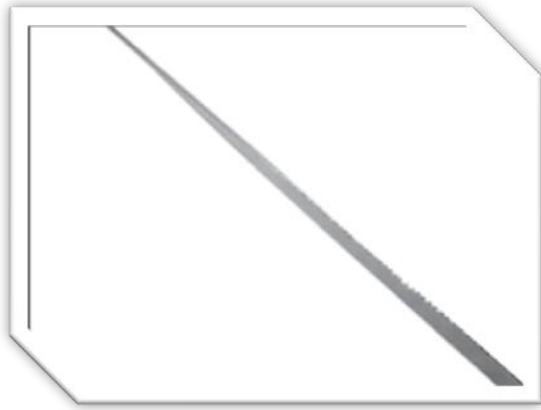
#19. Used Band Is "Short" On The Tooth Edge



Probable Cause :

- A. Side guides are too tight – rubbing near back edge.
- B. Worn band wheels causing uneven tension.
- C. Guide arms are spread too far apart.
- D. Excessive feeding rate.

#20. Broken Band Shows A Twist In Band Length



Probable Cause :

- A. Excessive band tension
- B. Any of the band conditions which cause the band to be long (#18) or short (#19) on tooth edge.
- C. Cutting a tight radius.

RE-ADJUSTING THE ROLLER TABLE

If the feeding table suffers the huge stroke and the alignment is effected, follow the below procedure to adjust.

TOOL, measuring

Measurement, Horizontal balance

Procedure

1. Screw or loosen the adjusting bolt to attain the horizontal balance (leveling) between the roller table and the machine frame.
2. Ensure that the machine frame is not struck by the loaded material on the feeding table.
3. Check the leveling by the measuring tool.
4. After finished the adjusting, fix the roller table.



If the feeding table and the machine frame are not positioned under the horizontal balance, the loaded material may be going up gradually and affect the cutting effect.

PARTS

SPARE PARTS RECOMMENDATIONS

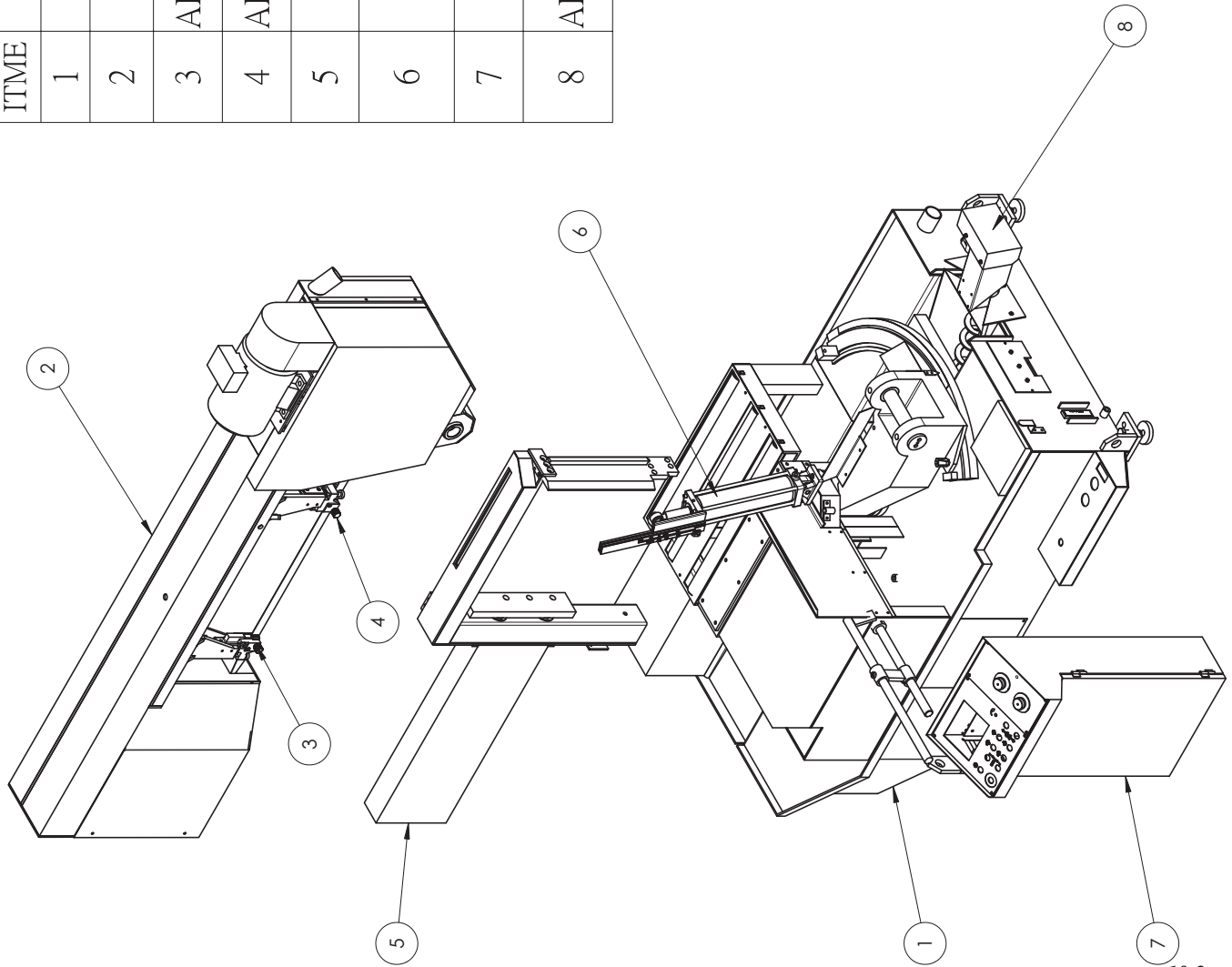
PART LIST

SPARE PARTS RECOMMENDATIONS

The following table lists the common spare parts we suggest you purchase in advance:

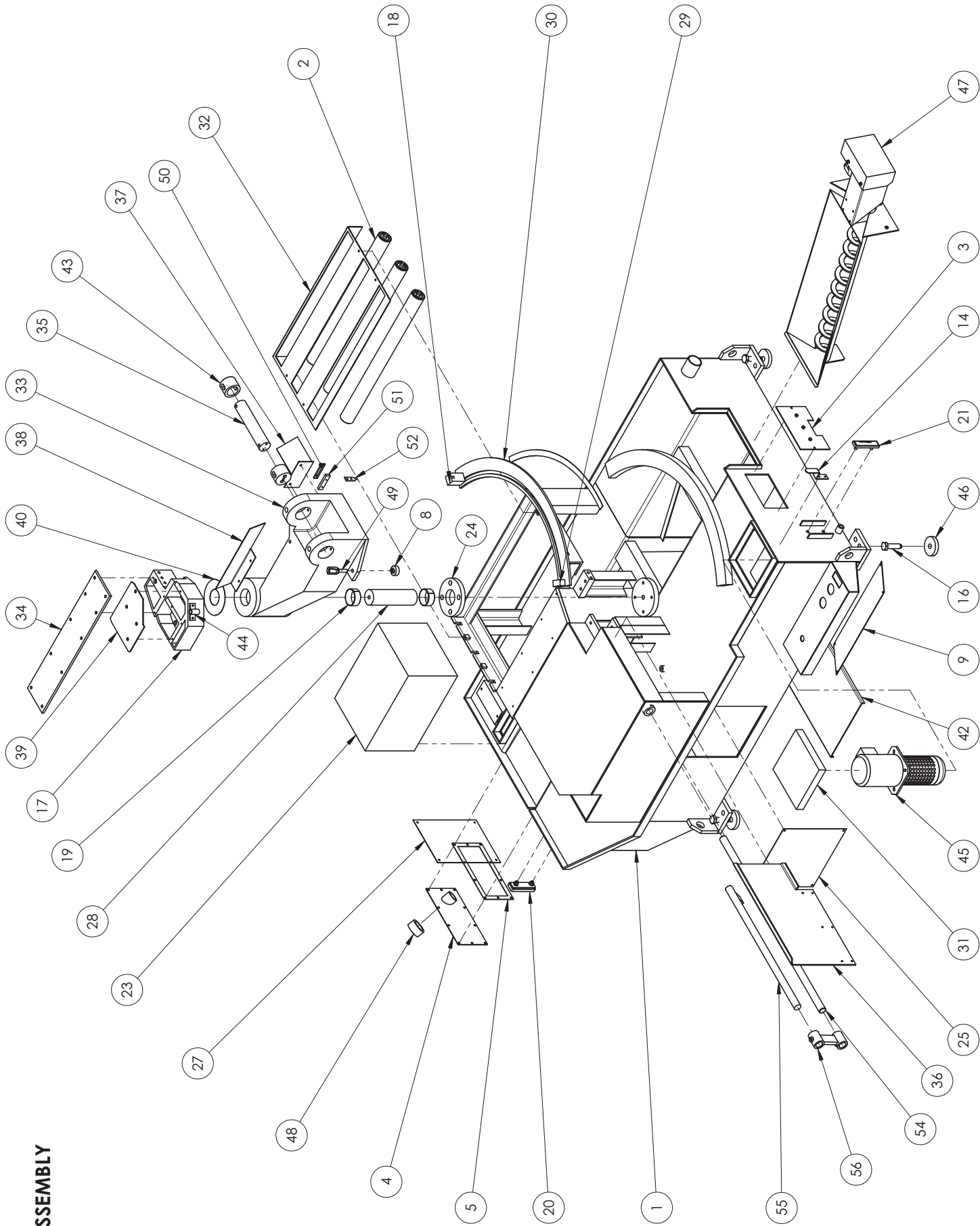
Part Name	Part Name
Saw blade	Coolant tank filter
Wire brush	Steel plates
Carbide inserts	Rollers
Bearings	Coolant pump
Hydraulic tank leak-proof gasket	Belt
Rubber washer	Duster seal
Gear reducer	Oil seal
O-ring	Snap ring
Drive wheel	Idle wheel

總組立



ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1		Base assembly	底座組		1
2		Saw bow assembly	鋸弓組		1
3	AHA-07120	Left guide roller assembly	左導輪座組		1
4	AHA-07480	Right guide roller assembly	右導輪座組		1
5		Fixed vise assembly	固定虎鉗組		1
6		Saw bow hydraulic cynder assembly	鋸弓油壓缸組		1
7		Control box assembly	控制箱		1
8	AEE-C001	C-650DM除屑裝置			1

BASE ASSEMBLY
底座組



ITEM	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	SEE-1001A-CE	Base	底座		1
2	AEE-1004	Infeed roller	料架滾輪		3
3	AEE-1022	Base side cover	底座右蓋		1
4	AHA-0102	Oil tank cover	油箱蓋		1
5	AHA-0108A	Leak-proof asbestos	油箱蓋防漏墊片		1
6	AHA-1105A	Washer	活動軸墊圈		2
7	SEE-1039	upper slider nut	上限滑桿螺母		1
8	SEE-1053	track fixed block	軌道固定塊		2
9	SEE-1075	Cover	蓋板		2
10	SEE-1083	Positioning angle iron	定位角鐵		1
11	SEE-1035	Sliding seat	上限滑座		1
12	AHA-0611	Adjusting nut	調整螺母(染黑)		1
13	AHA-0610	Adjusting screw	調整螺絲		1
14	AHA-1309	Hose bracket	軟管架		1
15	AHC-0135-CE	base plate (Control Panel)	控制面板底板(二)		1
16	AHC-0153	base stand adjusting bolt	底座調整螺桿		4
17	SEE-1021	Bed	床面		1
18	MER-2007A	angle position plate	角度定位板		1
19	PP-13259	DU bushing	乾式軸承		2
20	PP-21030	Oil gauge	油面計	3"	1
21	PP-21030A	water gauge	水面計	3"	1
22	PP-43335	Filter	濾油網	MF-06	1
23	S650M-1011	Solenoid valve cover	電磁閥護蓋		1
24	S650M-1174A	Swivel shaft block	旋轉軸墊塊		1
25	SEE-1007	Base side cover	底座右蓋		1

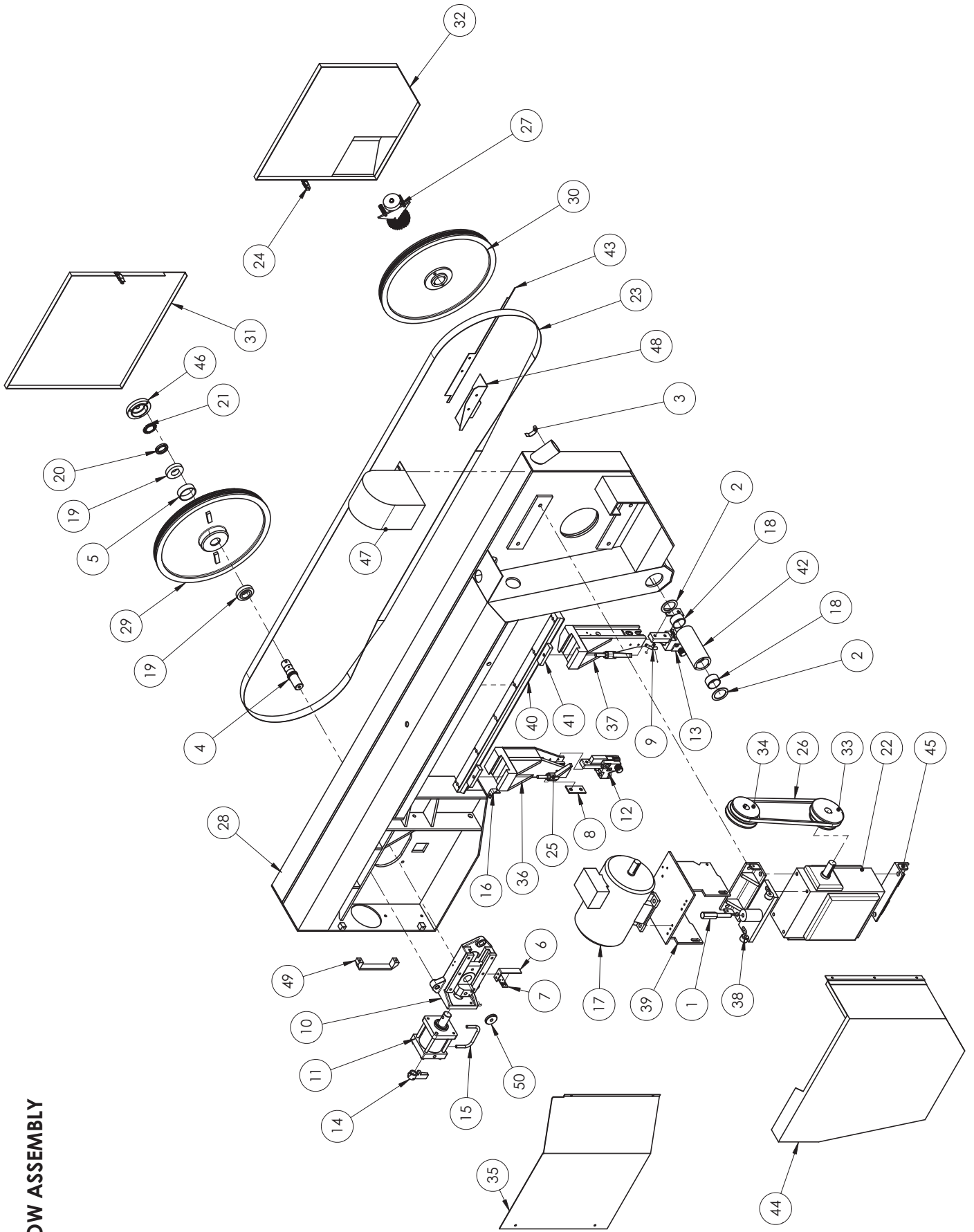
BASE ASSEMBLY
底座組

ITEM	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
BASE ASSEMBLY 底座組					
26	SEE-1009	Back cover	底座後蓋		1
27	SEE-1008	Front cover	底座前蓋		1
28	SEE-1010	Shaft	轉軸		1
29	SEE-1014	Swivel positioning plate	旋轉定位板		1
30	SEE-1016	Swivel track	旋轉軌道		1
31	SEE-1018A	Coolant pump cover	水泵護蓋		1
32	SEE-1017A	Roller rack top	料架遮板		1
33	SEE-1020	Joint seat	關節座		1
34	SEE-1027	Bed steel plate	床面鋼板		1
35	SEE-1028	Joint shaft	關節軸		1
36	SEE-1042	Side cover plate	托架側護板		1
37	SEE-1044	Track shield	軌道屑擋		1
38	SEE-1045	Join bracket shield	關節座擋屑		1
39	SEE-1049	Base sink	底座屑槽		1
40	SEE-1073	Joint shaft gasket	關節軸墊片		1
41	SEE-1065	Base rear cover	底座後右蓋		1
42	SEE-1082	Inverter base plate	變頻器底板		1
43	SEE-1030	Shaft sleeve	關節軸套		2
44	SEE-1023B	Movable vise	活動虎鉗		1
45	PP-32121A-CE	Pump	浸水幫浦(過濾式)(CE)	1/4HP 220L- 你好(振聲鐵工)	1
46	AHR-1055	table stand pad	底座墊塊		4
47	AEE-C001	Chip conveyor	C-650DM除屑裝置		1
48	PP-90857	Hydraulics tank cover nut	油箱蓋螺帽		1
49	PP-52111F	Saw arm handle	鋸臂把手	M12x45L	1
50	SGB-71144	Way wiper	刮刷片	H18*80L	1

BASE ASSEMBLY
 底座組

ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
51	SGB-71145	Way wiper fixed block	刮刷片固定塊		1
52	SEE-1046	Angle indicator	旋轉指針		1
53	S650M-1181	Angle nameplate	角度銘牌		1
54	ACA-1054	Length setting bar	定寸桿		1
55	SEE-1034	Length setting bar	定寸桿		1
56	MBR-9036	Stopper sliding seat	定寸滑座		1

SAW BOW ASSEMBLY
鋸弓組



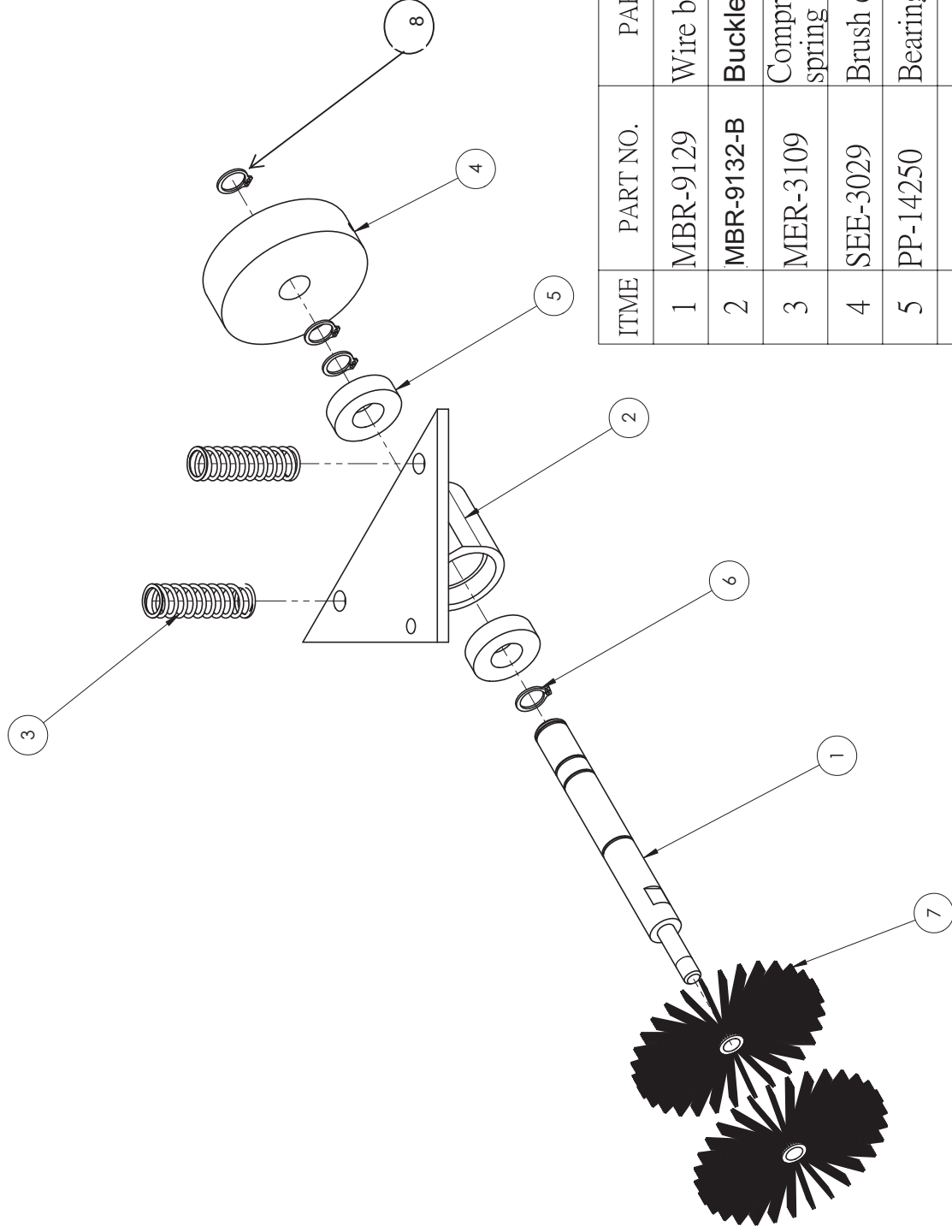
SAW BOW ASSEMBLY
 鋸弓組

ITEM	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
1	AGC-1030	Lower limit positioning rod	下限定位支桿		1
2	AHA-0324	Teflon washer	鐵弗龍墊圈		2
3	AHA-0414	Plate(for installing blade)	鋸片安裝板		1
4	AHA-0635	Idle wheel shaft	上輪軸		1
5	AHA-0637	Bearing washer (idle wheel)	軸承墊圈(上輪)		1
6	AHA-0670A	Sensor seat	感應器底板座		1
7	AHA-0672	Sensor base plate	感應器底板		1
8	AHA-0719	Guide roller seat pad	導輪座墊板		2
9	AHA-0745	Spray nozzle	冷卻水噴嘴		1
10	AHA-06029	Tensioner sliding plate assembly	張力滑座滑板組		1
11	AHA-06189	tensioner cylinder assembly	張力油壓缸組		1
12	AHA-07120	Left guide roller assembly	左導輪座組		1
13	AHA-07480	Right guide roller assembly	右導輪座組		1
14	AHB-0653	handle	切換把手		1
15	C320H-3341	Model plate	張力油缸鋼管		1
16	MJA-2041	faucet base plate	水龍頭座板		1
17	PBH5-D417-N	Motor	馬達		1
18	PP-13242	DU bushing	乾式軸承	5030	2
19	PP-14613	Ball bearing	滾珠軸承		2
20	PP-14907	Fixed nuts	固定螺母	AN07	1
21	PP-14957	Stop ring	止動環	AW07	1
22	PP-16030A	Gear reducer	減速機		1
23	PP-18307	Saw blade	鋸帶		1
24	PP-52090	Cover clip (small)	蓋扣(小二合一)		3
25	PP-52111F	Saw arm handle	鋸臂把手	M12x45L	2

SAW BOW ASSEMBLY
 鋸弓組

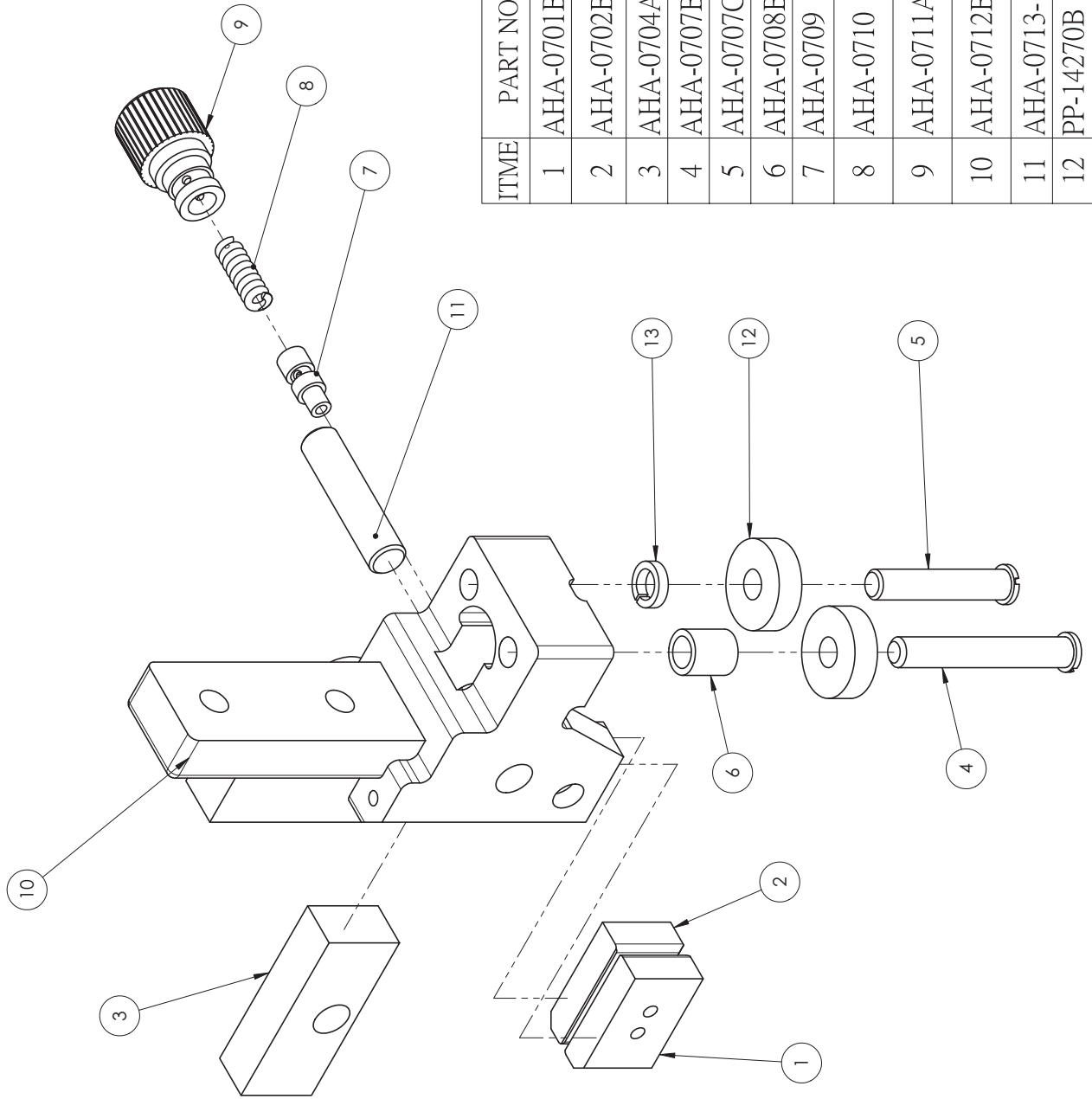
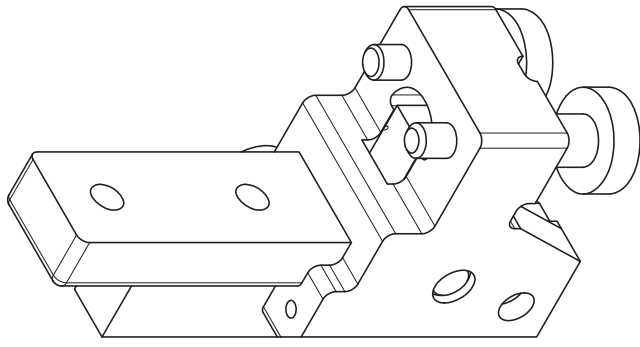
ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
26	PP-56293	Belt	皮帶		1
27	S650M-32200	Wire brush assembly	鋼刷組		1
28	SEE-3001	Saw bow	鋸弓		1
29	SEE-3002	Idle wheel	上輪		1
30	SEE-3003	Drive wheel	下輪		1
31	SEE-3004	Idle wheel cover	上輪箱蓋		1
32	SEE-3005	Drive wheel cover	下輪箱蓋		1
33	SEE-3006	gear reducer pulley	減速機普利		1
34	SEE-3007	motor pulley	馬達普利		1
35	SEE-3008	Tension cover	張力護蓋		1
36	SEE-3009	Left guide arm	左鋸臂		1
37	SEE-3010	Right guide arm	右鋸臂		1
38	SEE-3011B	motor base seat	馬達底板		1
39	SEE-3012B	Motor base plate	馬達底板		1
40	SEE-3013	Guide arm sliding palte	鋸臂滑板		1
41	MJA-2041	Faucet base plate	水龍頭座板		2
42	SEE-3015	Saw bow shaft sleeve	鋸弓軸套		1
43	SEE-3022	Idle wheel shield	下輪屑擋		1
44	SEE-3025A	Gear reducer cover	減速機護蓋		1
45	SEE-3031	Left saw blade cove	左鋸片護蓋		1
46	SEE-3033	gear reducer feet seat	減速機腳座		2
47	SHA-04140	Idle wheel shaft cover	上輪軸蓋		1
48	SEE-3035A	Pulley cover	普利護蓋		1
49	PP-52081A	U-shaped handle	U型把手		1
50	AHA-0403	Washer	下輪鎖緊墊圈		1

WIRE BRUSH ASSEMBLY
鋼刷組



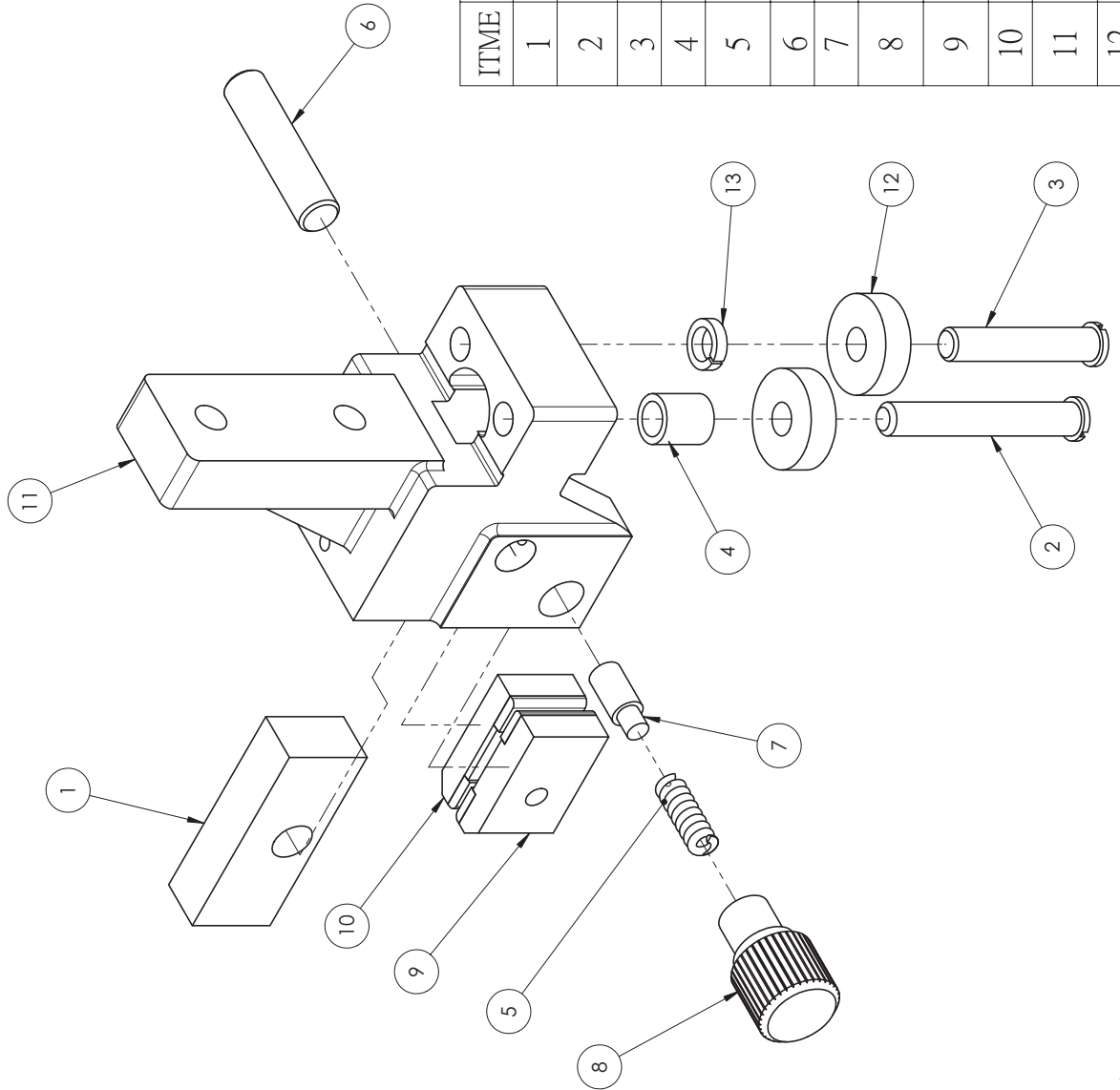
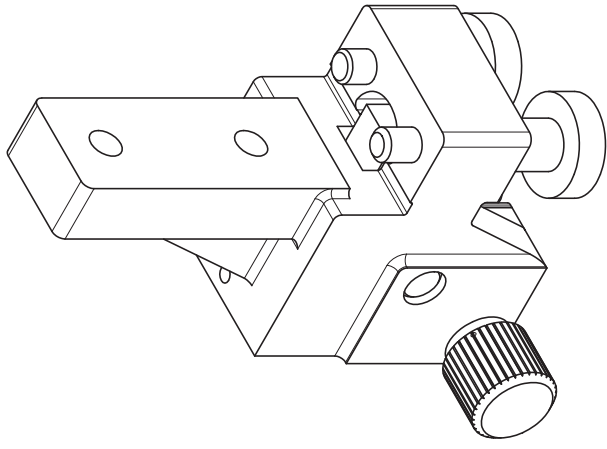
ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	MBR-9129	Wire brush shaft	鋼刷軸		1
2	MBR-9132-B	Buckle	鋼刷軸承座	S15	1
3	MER-3109	Compressioniog spring	鋼刷壓縮彈簧		2
4	SEE-3029	Brush drive wheel	鋼刷傳動輪		1
5	PP-14250	Bearing	軸承	6002ZZ	2
6	PP-52085	Snap ring	扣環	S12	4
7	PP-58002	Wire brush	鋼刷		2
8	PP-52097	Snap ring	扣環	S15	4

AHA-07120
LEFT GUIDE ROLLER ASSEMBLY
 左導輪座組



ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	AHA-0701B	Left fixed insert	左固定鎢鋼片		1
2	AHA-0702B	Left movable insert	左活動鎢鋼片		1
3	AHA-0704A	Pressure block	下壓座		1
4	AHA-0707B	Guide wheel shaft	導輪軸		1
5	AHA-0707C	Guid wheel shaft	導輪軸(三)		1
6	AHA-0708B	Washer	墊圈		1
7	AHA-0709	Left spring plug	左簧塞		1
8	AHA-0710	Carbide insert spring	彈簧(鎢鋼片)		1
9	AHA-0711A	Adjusting screw-left	左調整螺絲		1
10	AHA-0712B	Left guide roller seat	左導輪座(1 1/4")		1
11	AHA-0713-1	Fixed shaft	軸承座固定銷		1
12	PP-14270B	bearing	軸承	6200DDU	2
13	PQA-10	Spring washer	彈簧華司(公)	M10	1

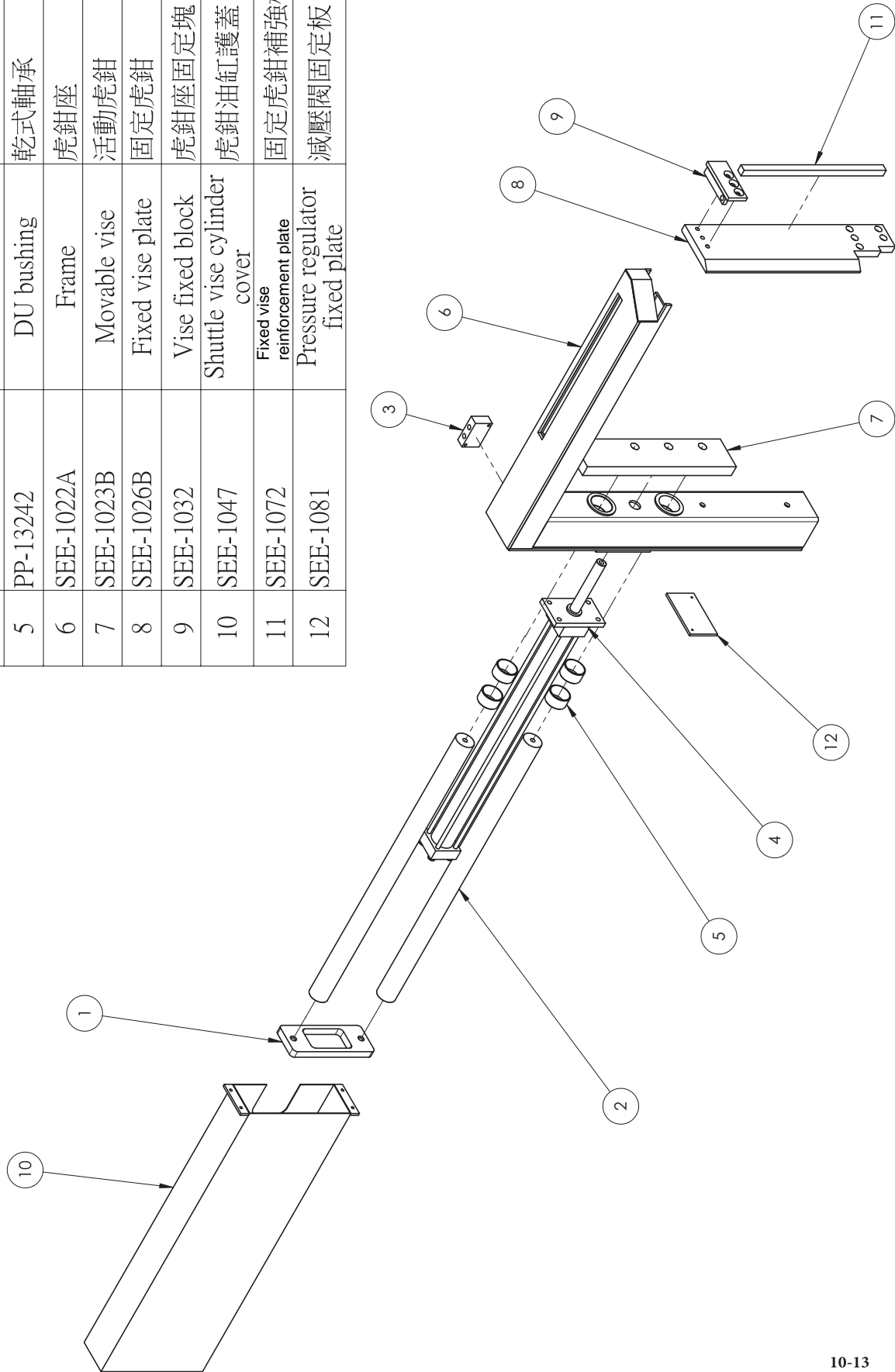
**AHA-07480
RIGHT GUIDE ROLLER ASSEMBLY
右導輪座組**



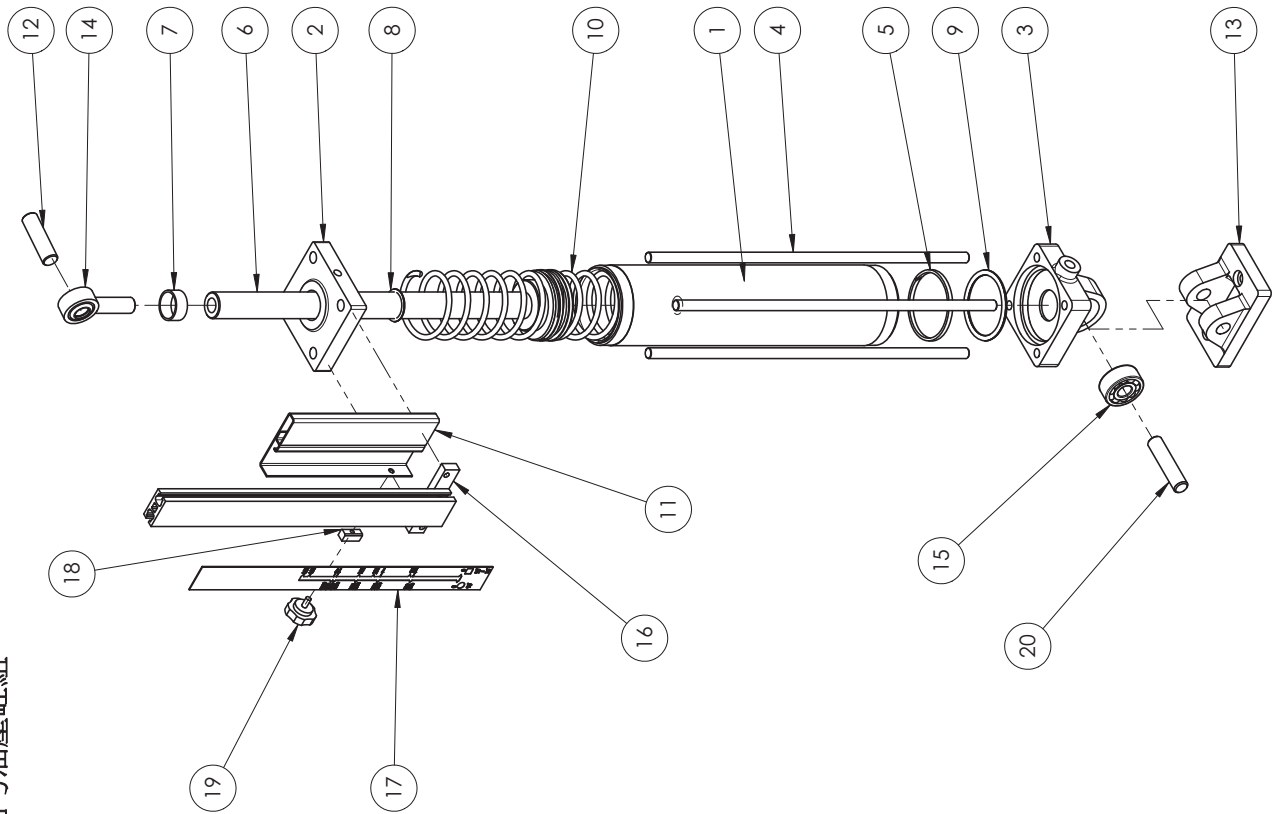
ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	AHA-0704A	Pressure block	下壓座		1
2	AHA-0707B	Guide wheel shaft	導輪軸		1
3	AHA-0707C	Guid wheel shaft	導輪軸(三)		1
4	AHA-0708B	Washer	墊圈		1
5	AHA-0710	Carbide insert spring	彈簧(鎢鋼片)		1
6	AHA-0713-1	Fixed shaft	軸承座固定銷		1
7	AHA-0741	Right spring plug	右簧塞		1
8	AHA-0742A	Adjusting screw-right	右調整螺絲		1
9	AHA-0743B	Right movable insert	右活動鎢鋼片		1
10	AHA-0744B	Right fixed insert	右固定鎢鋼片		1
11	AHA-0748B	Right guide roller seat	右導輪座(1 1/4")		1
12	PP-14270B	bearing	軸承	6200DDU	2
13	PQA-10	Spring washer	彈簧華司(公)	M10	1

FIXED VISE ASSEMBLY
固定虎鉗組

ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	C650M-2213	front sliding auxiliary plate	滑軸輔助板		1
2	C650M-2232	Vise sliding shaft	虎鉗滑軸		2
3	CGK-2024	connecting plate	油路接板		1
4	HFA50L680E165A	Cylinder	油壓缸(虎鉗用)		1
5	PP-13242	DU bushing	乾式軸承	5030	4
6	SEE-1022A	Frame	虎鉗座		1
7	SEE-1023B	Movable vise	活動虎鉗		1
8	SEE-1026B	Fixed vise plate	固定虎鉗		1
9	SEE-1032	Vise fixed block	虎鉗座固定塊		1
10	SEE-1047	Shuttle vise cylinder cover	虎鉗油缸護蓋		1
11	SEE-1072	Fixed vise reinforcement plate	固定虎鉗補強板		1
12	SEE-1081	Pressure regulator fixed plate	減壓閥固定板		1

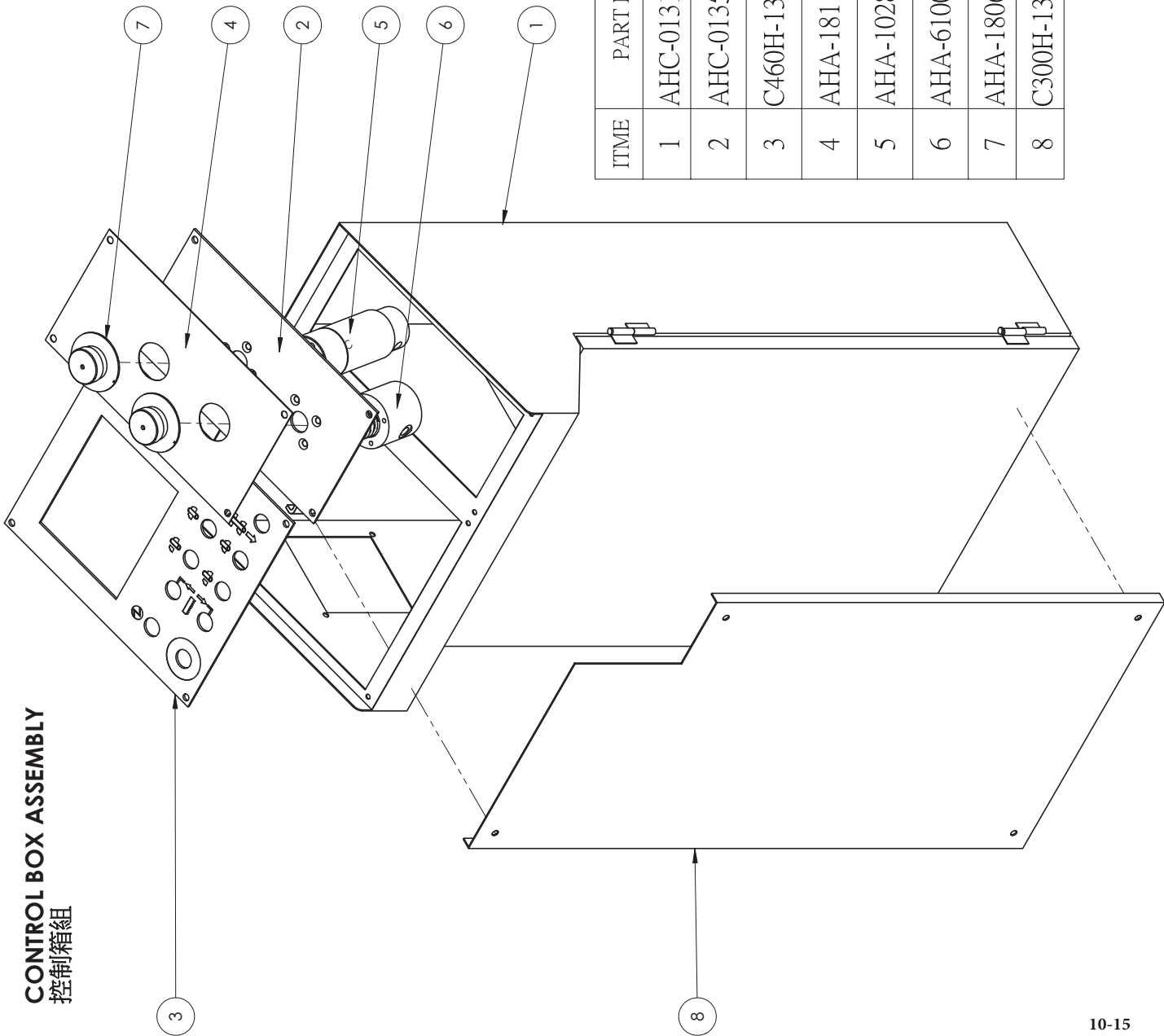


SAW BOW HYDRAULIC CYLINDER ASSEMBLY 鋸弓油壓缸組

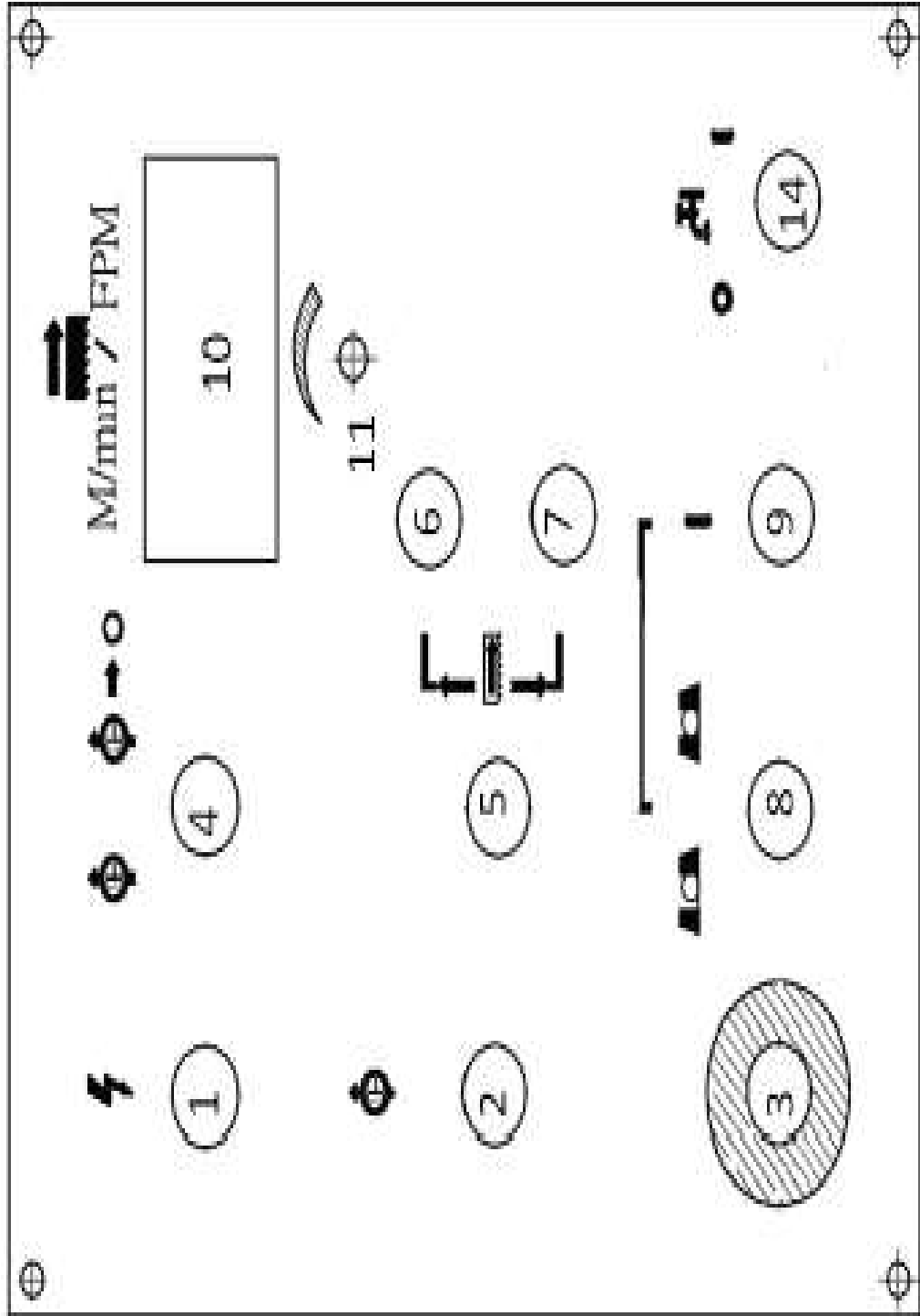


ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	AGC-1020	Cylinder	鋸弓油缸管		1
2	AGC-1021	Cylinder front cap	鋸弓油缸前蓋		1
3	AGC-1024	Hydraulic cylinder rear cap	鋸弓油缸後蓋		1
4	AGC-1027	Hydraulic cylinder rod	鋸弓油缸連桿		4
5	AHA-1117	Teflon washer	鐵弗龍墊圈		1
6	SEE-1005	Cylinder piston	鋸弓油缸活塞		1
7	PP-13190	DU bushing	乾式軸承	3015	1
8	PP-59110	o-ring	O型環	NOK P-30	1
9	PP-59170	O-ring	O型環	NOK P-70	1
10	SEE-1019	Spring	彈簧(鋸弓油壓缸)		1
11	AEE-1043	Upper limit sliding seat	上限滑板		1
12	AGB-70304A	Pin	上鋸弓油缸插銷		1
13	AGB-70735	cylinder seat	油壓缸固定座		1
14	PP-14480	Connexing rod bearing	連桿軸承	POS18	1
15	PP-14510	Bearing	滾珠軸承	2303	1
16	SEE-1035	sliding seat	上限滑座		1
17	SEE-3032B	Height scale plate	高度銘板		1
18	SEE-1039	upper slider nut	上限滑桿螺母		1
19	PP-53021	Knob screw	梅花螺絲		1
20	AGB-70304B	pin	下插梢		1

CONTROL BOX ASSEMBLY
控制箱組



ITME	PART NO.	PART NAME	PART NAME CHINESE	PART SPEC.	QTY
1	AHC-0131-CE	Control box	控制箱		1
2	AHC-0135-CE	base plate (Control Panel)	控制面板底板(二)		1
3	C460H-1321D	control pane	控制面板(7吋)- 全行程用		1
4	AHA-1811	Flow valve control panel	流量閥控制面板		1
5	AHA-10289	Adjusting valve assembly	調壓閥整組		1
6	AHA-6100	Flow valve assembly	流量閥組立		1
7	AHA-1806	control knob	流量閥旋鈕		2
8	C300H-1302	Circuit board	線路板		1



SERIES PART LIST

CONTROL PANEL BUTTONS

No.	PART NUMBER_NON-CE	PART Name IN ENG.	PART Name IN CHI.	Q'TY
1	EP-90755-1	Power indicator lamp	電源指示燈	1
2	EP-90761 & EP-90762A	Hydraulic start/stop buttons with built-in lamp (CE model) Hydraulic start button with built-in lamp (non-CE model)	油壓開啟/停止按鈕_含內建燈 (CE 機種) 油壓開啟/停止鈕_含內建燈 (NON-CE 機種)	1
3	EP-90763A & EP-90760	Emergency stop button	緊急停止按鈕	1
4	EP-90757 & EP-90760	Last cut function on/off switch	最後鋸切功能開關	1
5	EP-90761 & EP-90762A	Saw blade start/stop buttons with built-in lamp (CE model) Saw blade start button with built-in lamp (non-CE model)	鋸刀開始/停止按鈕_含內建燈 (CE 機種) 鋸刀開始鈕_含內建燈 (NON-CE 機種)	1
6	EP-90758 & EP-90759	Saw bow up button	鋸弓上升按鈕	1
7	EP-90758 & EP-90759	Saw bow down button	鋸弓下降按鈕	1
8	EP-90757 & EP-90759	Vise open/clamp selector switch	虎鉗釋放/夾持按鈕	1
9	EP-90758 & EP-90759	Vise operation button	虎鉗啟動按鈕	1
10	EP-90416	Blade speed indicator	鋸刀速度顯示器	1
11	EP-90769	Blade speed control knob	鋸刀切屑速度控制旋鈕	1
14	EP-90757 & EP-90759	Coolant on/off switch	冷卻泵浦 ON/OFF 開關	1

SHARP