

INSTRUCTION MANUAL

BP-16A

Wood Band Saw (240V)

1500W



W430

IMPORTANT SAFETY INSTRUCTIONS

READ ALL INSTRUCTIONS BEFORE USING THIS PRODUCT!

1. Work Area

To Avoid of personal injury, equipment damage, fire and shock. make sure your work area is:

- * Free of damp ,wet or rainy conditions
- * Free of flammable gasses or liquids
- * Childproof-use padlocks and master switches when not in use
- * Well-lit
- * Clean and uncluttered
- * Well-ventilated

2. The Operator

COMMON SENSE AND CAUTION ARE FACTORS WHICH CANNOT BE BUILT INTO ANY PRODUCT.THESE FACTORS MUST BE SUPPLIED BY THE OPERATOR. PLEASE REMAMBER:

- * Prevent body contact with grounded surfaces such as pipes or radiators.
- * Stay alert. Never operate equipment if you are tired.
- * Do not operate The product if under the influence of alcohol or drugs .Read warning labels on prescriptions to determine if your judgment reflexes might be impaired.
- * Do not wear loose clothing or jewelry as they can be caught in moving parts.
- * Non-skid footwear is recommended.
- * Weal-restrictive hair covering to contain long hair.
- * Use eye and ear protection. Always wear:
 - ANSI approved dust mask or respirator when working around metal wood, and chemical dusts and mists.
 - A full face shield if you are producing metal or wood fillings.
 - Ear protectors
- * Maintain proper footing and balance at all times.
- * Do not reach over or across running machines.

3. Before Operating

- * Know the machine. Learn its applications and limitations as well as the specific potential hazards.
- * Check for damage. If part of the machine is damaged, it should be carefully inspected to ensure that it can perform its intended function correctly. If in double the part should be replaced.
- * Be sure me switch is OFF before plugging in.
- * Make sure tool has been cleaned and properly lubricated.
- * Check for damaged parts before using any tool, any part that appears damaged should be carefully checked la determine that it will operate properly and perform its intended function.
- * Check for alignment and binding of all moving parts broken parts or mounting fixtures and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician.
- * Do not use the tool if any switch does not turn off and on properly.

IMPORTANT SAFETY INSTRUCTIONS continued...

4. Special Instructions for Band Saw

- * Adjust the upper guide of saw blade to make it higher about 1/8" than the cut material.
- * Saw after the machine rolling regularly select different speed of filling material according to the different hardness and thickness of wood. Forbid filling material too fast.
- * Check for proper blade size and type make sure that blade's tension and tracking are properly adjust according to the instruction to change saw blade.
- * The worker shouldn't leave the place when the machine is working. Don't forget to cut off the main power source when not working.
- * Use foot bolt to forbid the machine leaning to the ground.

TECHNICAL DATA

1	Saw wheel diameter		400 mm
2	Table pivot capacity		0 - 45°
3	Processing scope	Max. height	200 mm
4		Max. width	350 mm
	Length of saw blade		2950 mm
	Width of saw blade		6 - 20 mm
5	Line speed of saw blade		10 m/s
6	Necessary motor	Power	1.5 Kw
		Voltage	230V 50Hz
		Frequency	50 Hz
		Rotational speed	1400 rpm

ELECTRICAL INFORMATION

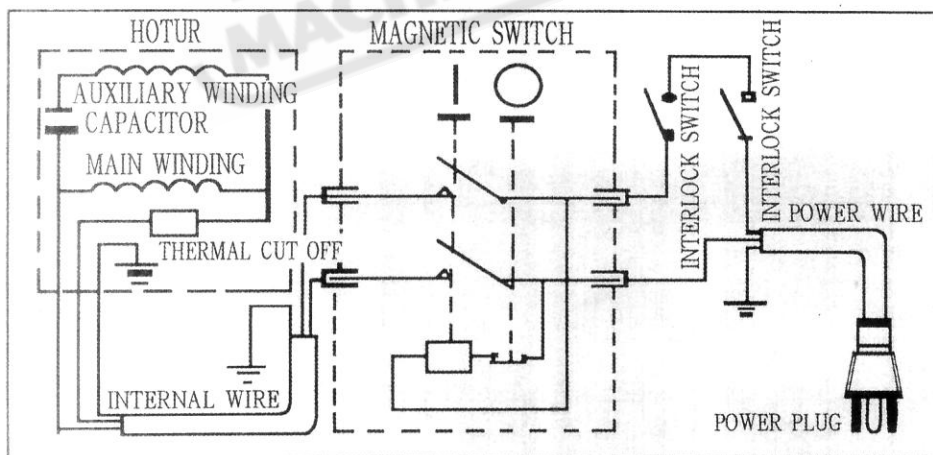
1. Instruction of Ground

- 1) This machine provides power outlet and cable. And there is grounding wire on it. The contact of outlet on the sawing machine must contact with the case of sawing machine. The other outlet should be correctly and connected with the earth.
- 2) If grounding wire cannot be connected properly, it may be struck. Change or repair cable or outlet don't connect the grounding line wrongly.
- 3) When the cable is damaged, change or repair it in time.

2. Connection of Power Source

The single electric current should be used. The protector should be set in order to protect. Assure that the line voltage should agree with the motor voltage on its plate before running machine.

3. Wiring Diagrams



ACCESSORIES

1. Mitre Gauge
 2. Manual
- Saw mouth board

TABLE INSTALLATION AND ADJUSTING

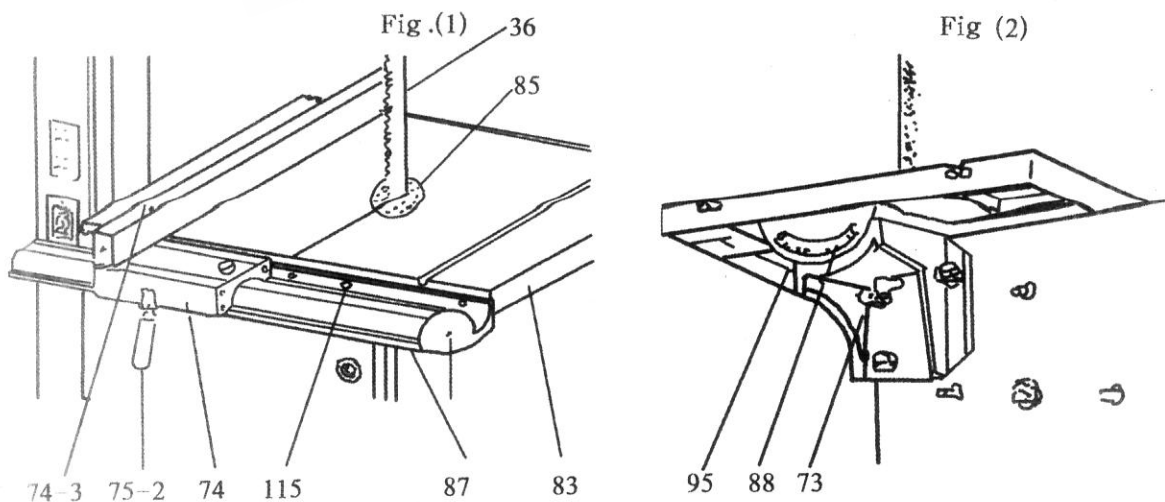
1. Installing Table (fig. 1)

- 1) Install worktable (#83) according to Fig. (1). Fix the saw mouth board (#85) into the center of worktable.
- 2) Connect the side guide board (#87) with the table use 4 Hex bolts M6x16 as Fig. (1). Then make the sliding base (#74) plug in the side guide board through its slot. Fix the upper guide board (#79) and sliding base with screw(#78) and bushing.
- 3) Put the upper guide board on the right side of saw blade. Loosen the screw (#78). Take off the upper guide board and loosen the locking handle (#75-2).
- 4) Slip the stand of upper guide board (#74) to the right side of the saw blade (#36). Then fix the upper guide board on the other side of the stand of upper guide board.

EXERCISE CAUTION! Never force the material into the band saw. You will become familiar with the saw's feature from practice and use. If possible, practice sawing with a piece of wood.

2. Adjusting Table Angle (fig. 2)

- 1) If working table is to be used at an angle, make sure to install the angle core board.
- 2) Loosen butterfly nut (#73) and adjust working table to the desired angle using numbers on the rotating angle rule (#88).
- 3) Tighten butterfly nut (#73) securely so that the working table will not move during operating.



MANUAL TO SAW BLADE

1. To Change saw Blade

Make sure switch in "OFF" position and unplug before performing any of the steps below:

- 1) Open the upper door and lower door (#8) & (#9), loosen the flower handle (#33), then loosen hand wheel (#20).

Fig. (3)

- 2) Remove side guide board (#87) and saw blade (#36). **Fig. (1)**
- 3) Select and install the new one.
- 4) Install the side guide board (#87).
- 5) Roll the hand wheel (#20) to tighten the saw blade. Give the saw blade 3Kgs side pressure tensile deformation is about 8mm. The tension of saw blade is moderate.
- 6) Roll the upper saw blade with hand, adjust the running track of saw blade (#36) in the protective case by rolling the flower handle (#33) of the back of upper saw wheel housing as **Fig. (3)** in order to make the saw blade run in the center, then tighten the nut of flower handle (#33).

2. Blade Guiding (fig.4)

- 1) The saw blades guide of this band saw ensure an exact guiding of the blade for clean cuts. When using narrow blades ensure that the lower blade guide positively supports the blade from both sides and the rear.
- 2) Set the guide wheel (#111) of the upper blade guide and lower blade guide (#66-2) to within approx.0.5mm of the blade, and the large thrust bearing(#109), (#62) against the back of the blade, just clear of it. Do not set the bearing too close, as the friction generates heat, which ma
- 3) Have an adverse effect on the bearings and saw blade as well.

3. Setting the Cutting Height (fig.4)

- 1) The upper blade guide should always be set as close as practical against the work. To adjust, loosen the position (1) of the wing nut at the side of the upper wheel housing, and set the blade guide to the required height.
- 2) Tighten wing nut after setting.

Fig.(3)

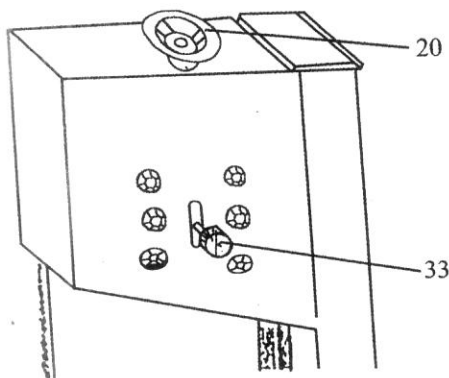
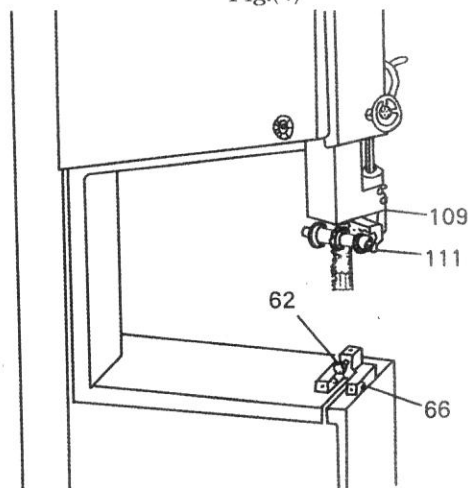


Fig.(4)



TROUBLE SHOOTING

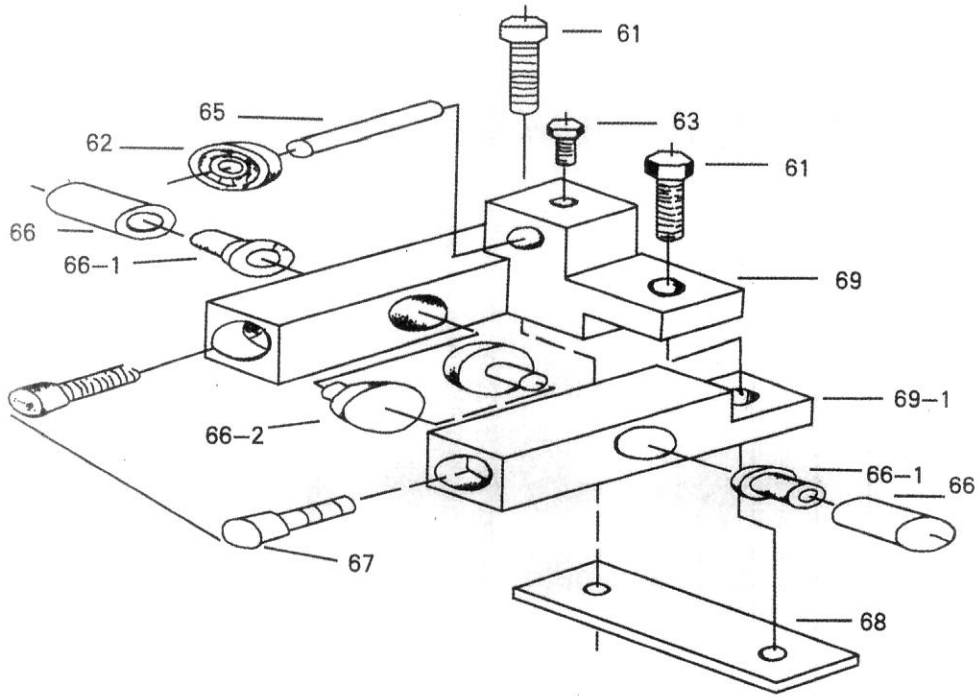
Items	Reason	Fixing Method
1. The motor can not start.	<ol style="list-style-type: none"> 1. The power isn't on. 2. The fuse of electric circuit has blown. 3. The electric cable is damaged. 4. the switch isn't "on". 5. The motor is damaged. 	<ol style="list-style-type: none"> 1. Check all the electric circuit. 2. Change the fuse. 3. Repair or change the cable. 4. Check the switch. 5. Change the motor.
2. The saw blade can not cut or the cutting speed is slow.	<ol style="list-style-type: none"> 1. The saw blade is installed on the contrary, the saw teeth cut on the same direction. 2. There are some hard things such as iron or stone etc. in the saw teeth. 3. The swa teeth is passive for long time using. 	<ol style="list-style-type: none"> 1. Turn over the saw blade and install it again. 2. Manage to remove the hard things, sharpen the saw teeth. 3. Repair and grind the sawteeth to make it sharp.
3. Slipping saw blade.	<ol style="list-style-type: none"> 1. The saw blade is not straight. 2. The upper wheel doesn't Parallel with the lower one. 3. The guiding installation of the saw blade has deflected. 	<ol style="list-style-type: none"> 1. Reinstall the up-to-standard saw blade. 2. Adjust the upper wheel to make it parallel with the lower one. 3. Adjust the guiding installation to make its running direction as same as the saw blade's.
4. The saw blade is broken.	<ol style="list-style-type: none"> 1. The direction of the guiding board is deflected. 2. The deflection of the saw is too small or the saw teeth is passive. 3. When cutting too small diameter wood, the saw blade is sprained badly. 4. Speed of filling wood is too high. 5. The saw blade is too tightened. 6. The saw blade is over warrantable period. 	<ol style="list-style-type: none"> 1. Adjust the guiding board correctly. 2. Reshape the saw route, sharpen the saw teeth. 3. Reinstall the narrow saw blade to make the saw route wide. 4. Slow the speed of sending materials. 5. Loosen the saw blade properly. 6. Renew the saw blade.

PARTS LIST

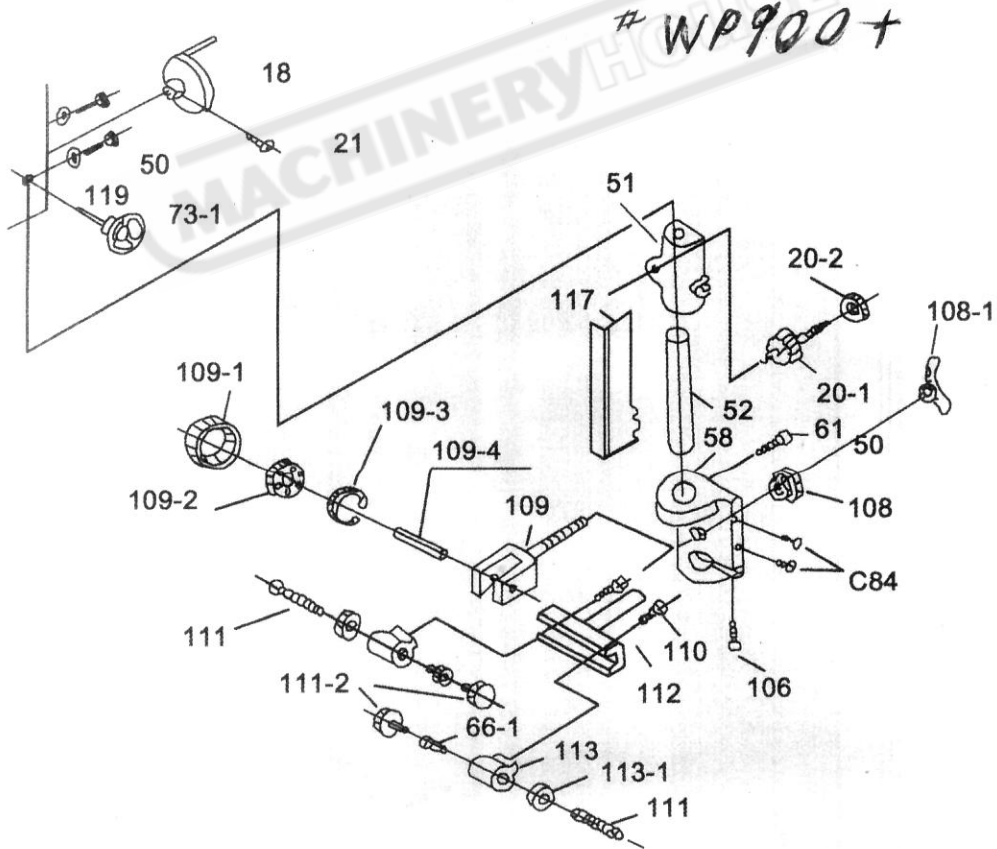
NO.	Description	QTY	NO.	Description	QTY
2	Saw body	1	41	Hex nut M16	1
4	Switch	1	42	Hex nut M12	3
5	Hex bolt M8x25	4	43	Motor pulley	1
6	Motor	1	44	Flat washer 16	3
7	Suction connector (plastic)	1	45	Adjusting bush (lower wheel)	3
8	Upper door	1	46	Lower shaft bracket	1
9	Lower door	1	47	Rubber bush	2
10	Plastic nut M24x1.5	4	48	Set screw M6x16	1
11	Door axle	4	49	Flat washer 10	1
12	Washer 10	8	50	Hex bolt M8x16	3
13	Axle bush	4	51	Rack bar support (upper)	1
14	Closing door plate	4	52	Rack bar	1
15	Hex bolt M6x8	4	54	Screw ST2.9x9.5	4
17	Flat washer 5	5	55	Double-end bolt	4
18	Hand wheel for upper blade guide moving	1	58	Rack bar support (lower)	1
19	Hex nut M5	3	60	Flat washer 6	12
20	Hand wheel for tightening blade	1	61	Screw M6x35	2
20-1	Gear	1	62	Bearing 80027	2
20-2	Flat washer	1	63	Screw M4x6	3
21	Set screw 8x12	3	65	Eccentric bar	1
22	Flat washer 12	1	66	Shaft (lower blade guide)	2
23	Threaded bar	1	66-1	Bush	2
24	Spring	1	66-2	Lower blade guide	2
25	Square nut	1	67	Screw M6x12	5
26	Adjusting shaft (upper wheel)	2	68	Lower blade guide fix plate	1
27	Guide plate	2	69	Lower blade guide base (1)	1
28	Flat washer 8	12	69-1	Lower blade guide base (2)	1
29	Hex bolt M8x25	6	73	Butterfly nut (plastic)	1
30	Upper bracket frame	1	74	Sliding base	1
31	Shaft bracket (upper wheel)	1	74-1	Connecting plate	1
32	Shaft (upper wheel)	1	74-2	Pointer with magnifier	1
33	Flower handle screw M8x25	1	74-3	Screw	2
34	Bearing 80104	4	75	Spring sheet	1
35	Upper wheel	1	75-1	Locking eccentric block	1
36	Saw blade 2950	1	75-2	Locking handle	1
37	Hex nut M16	2	75-3	Pivot for locking	1
38	Lower wheel	1	78	Screw M6x65	4
40	Shaft (lower wheel)	1	78-1	Push	4
			79	Fence extrusion aluminium	1

PARTS LIST

NO.	Description	QTY	NO.	Description	QTY
79-1	Bung	2	113	Socket for side guide wheel	2
79-2	Small shaft for bearing	1	113-1	Nut	2
80	Pin	1	115	Hex bolt M6x16	4
82	Guide plate for mitre gauge	1	115-1	Hex socket head screw M6x12	4
83	Table	1	117	Saw blade protection cover	1
84	Screw M6x8	3	119	Flat washer 8	8
85	Blade mouth (plastic)	1	120	Nut M8	11
87	Slide guide plate	1	121	Pin 6x20	1
87-1	Support plate	1	122	Plastic washer	4
87-2	Slide guide end plate	2	123	Bush	1
88	Scale for slide guide plate	1	124	Set screw M5x6	1
89	Table support	1	125	Screw M5x6	1
90	Screw M8x20	4	126	Screw M6x12	1
91	Pointer for mitre gauge	1	128	Lock washer 4	4
92	Handle for mitre gauge	1	129	Flat washer 4	8
93	Scale for mitre gauge	1	131	Screw M4x35	4
95	Swivel mounting base	1	132	Safety switch	2
97	Nut M12	3	133	Nut M4	4
98	Belt 1727	1			
99	C-ring 12	1			
100	Bearing 80101	2			
101	Jockey wheel	1			
102	Jockey wheel axle	1			
103	Jockey wheel pole	1			
104	Set screw M6x12	1			
105	Handle	1			
106	Screw M6x16	5			
108	Locking nut	1			
108-1	Butterfly nut	1			
109	Bearing parts for spacing	1			
109-1	Blade guide wheel sleeve	1			
109-2	Bearing 80016	1			
109-3	C-ring	1			
109-4	Shaft for bearing	1			
110	Screw M8x12	2			
111	Adjusting bar	2			
111-2	Guide wheel	2			
112	Side blade guide bracket	1			



Lower saw blade guide



Upper saw blade guide

NEW UPPER GUIDE FITTED TO MODELS SOLD AFTER APROX JANUARY 2006