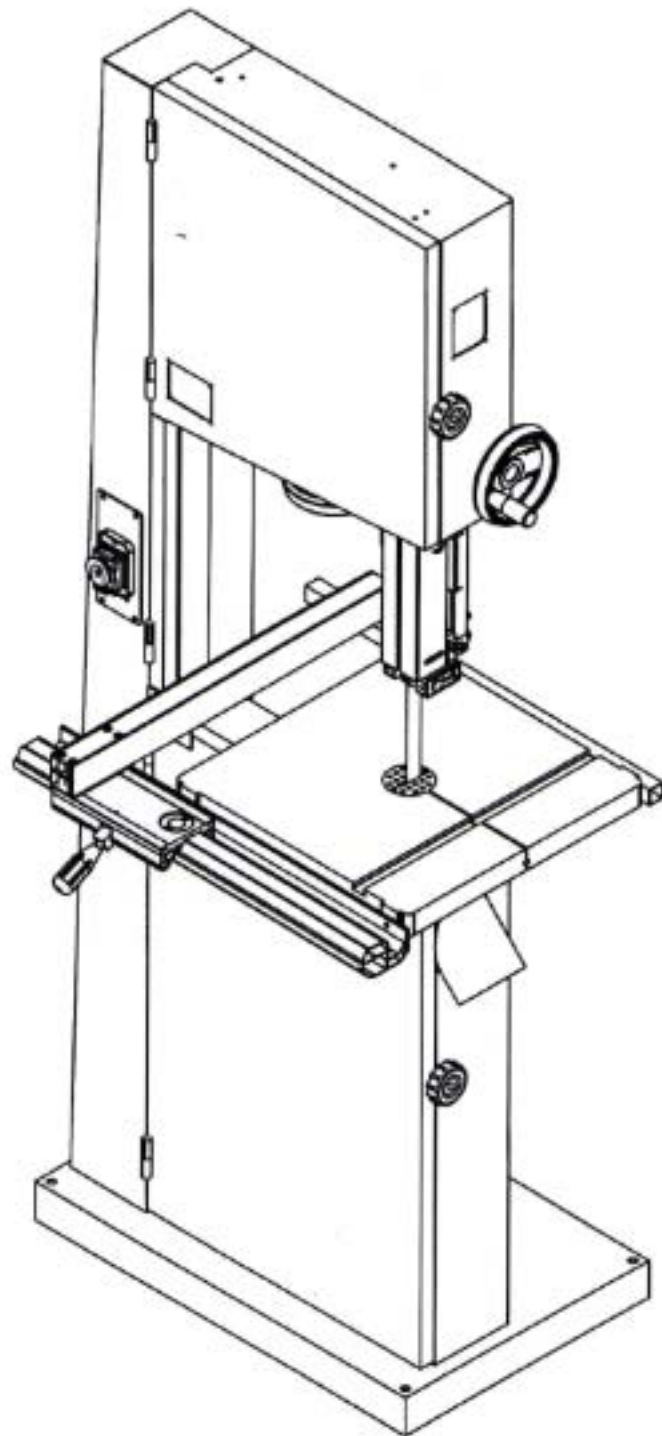


Band Saw (Wood)

Model: BP-480



PLANT SAFETY PROGRAM
NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Wood Bandsaw

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
 This program is based upon the Australian Worksafe Standard for Plant(NOHSC:1010-1994)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
A	ENTANGLEMENT	HIGH	Eliminate, avoid loose clothing / Long hair etc.
B	CRUSHING	LOW	Ensure bandsaw is on level ground to and safe place to prevent it falling.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Blade guards should always be in the closed position before starting machine. Top blade guide system should be adjusted to suit material thickness. Isolate main power switch before changing blade, cleaning or adjusting. Use a push stick to remove off-cuts. Hands must always be kept well away from blade at all times. Check blade tracking before starting.
D	SHEARING	MEDIUM	Make sure all guards are secured shut when machine is on.
F	STRIKING	LOW	Support long heavy work pieces. Remove all loose objects around moving parts. Wear safety glasses
H	ELECTRICAL	MEDIUM	Should blade break turn off machine immediately and use foot brake to stop if supplied. All electrical enclosures should only be opened with a tool that is not to be kept with the machine.
O	OTHER HAZARDS, NOISE, DUST.	LOW	Wear hearing protection as required. Must be connected to dust extraction.



Plant Safety Program to be read in conjunction with manufactures instructions



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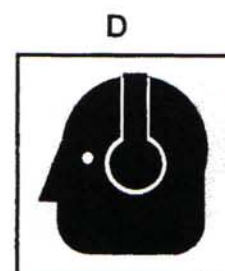
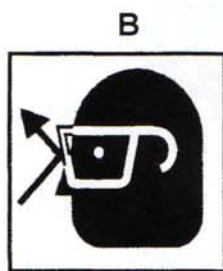
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Authorised and signed by: 
 Safety officer: 
 Manager:

Revised Date: Aug-08

3. SAFETY INSTRUCTIONS

1. Always wear leather gloves when handling saw blade. The operator shall not wear gloves when operating the machine.
2. All doors shall be closed, all panels replaced, and other safety guards in place prior to the machine being started or operated.
3. Be sure that the blades is not n contact with the workpiece when the motor is started. The motor shall be started and you should allow the saw to come up to full speed before bringing the saw blade into contact with the workpiece.
4. Keep hands away from the blade area. **See Figure A.**
5. Remove any cut off piece carefully while keeping your hands free of the blade area.
6. Saw must be stopped and electrical supply must be cut off before any blade replacement or adjustment of blade support mechanism is done, or before any attempt is made to change the drive belts or before any periodic service or maintenance is performed on the saw.
7. Remove loose performed on the unnecessary workpieces from area before starting machine.
8. Bring adjustable saw guides and guards as close as possible to the workpiece.
9. Always wear protective eye wear when operating, servicing, or adjusting machinery. Eyewear shall be impact resistant, protective safety glasses with side shields complying with ANSI Z787. 1 specifications. Use of eye wear which does not comply with ANSI87. 1 specifications could result in severe injury from breakage of eye protection. **See Figure B.**
10. Nonslip footwear and safety shoes are recommended. **See Figure C.**
11. Wear ear protectors (plugs or muffs) during extended periods of operation. **See Figure D.**
12. The workpiece, or part being sawed, must be securely clamped before the saw blade enters the workpiece.
13. Remove cut off pieces carefully, keeping hands away from saw blade.
14. Saw must be stopped and electrical supply cut off or machine unplugged before reaching into cutting area.
15. Avoid contact with coolant, especially guarding your eyes.



5. OPERATING INSTRUCTION

MOVING

- a. Use a 2000kgs wrecker hang up the machine on parts A (Fig. 1) to suitable space.
- b. To ensure sufficient upright stability of the machine and safety, you need to bolt the machine to floor on M10 screw.

ASSEMBLE THE MACHINE:

1. Attach the handle (A, Fig. 2) to the hand wheel (B, Fig. 2), lock the screw then connect to the machine.
2. To mount table, remove table insert and table pin from the table. Slide the table slot to the saw blade, slow moving to the center to table, make sure the table is located to the m8 hole (4 hole) and attach the spring washer, (Fig. 3) then replace table insert and table pin.
3. Adjust the table until the saw blade in the center of table insert, then locked with screw.

ADJUSTING 90 DEGREE TABLE STOP

1. Unplug power cord.
2. Loosen the lock knobs (A, Fig. 4) and tilting table left until it rests against table stop bolt M8.(A, Fig. 5)
3. Use a protractor placed on the table and against the blade,(A, Fig.6) to see if the table is 90 degree to the table.
4. If it is not 90 degree, you can use micro-adjust knob, please lock the lockknob.
5. Tilt table up to 45 degrees to the right or up to 10 degrees to the left.
* Optional with extension table can only adjust to 5 degrees.*

RIP FENCE

1. Setting the fixed base(A, Fig.7) to the cast iron table with two hex head bolt m6x20, two spring washer m6.
2. Setting the square tube (B, Fig.7) to the table with 2 hex socket bolt m6x16.
3. Setting the fence (A, Fig.7) to the fence body, place the fence assembly on the fixed base, slide the fence on its guides until it is the required distance from the blade.
4. Check the scale, make sure the distance between the edge of the miter slot and both the front and rear of the rip fence, adjust so both distances are equal.
5. Lock the fence by pushing the locking handle.

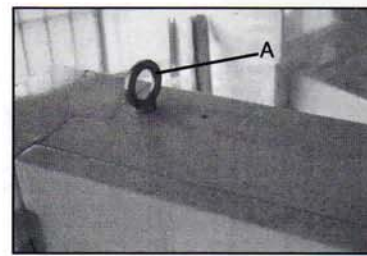


Fig. 1

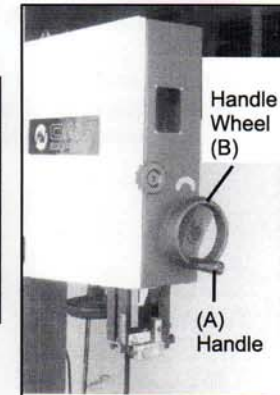


Fig. 2

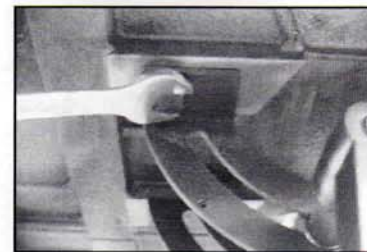


Fig. 3

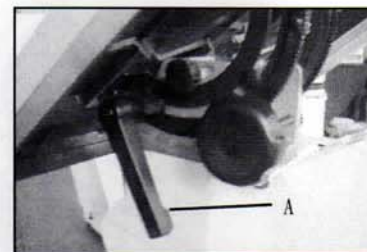


Fig. 4

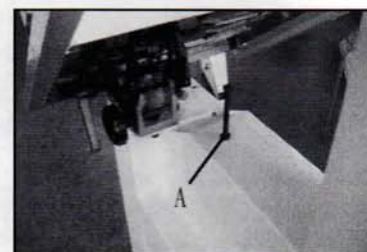


Fig. 5



Fig. 6

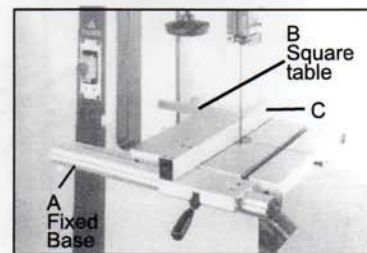


Fig. 7

BLADES CHANGING

1. Unplug power cord.
2. Remove the table insert and table pin.
3. Open upper & lower wheel cover.
4. Loosen the upper & lower blade guide system and bearing.
5. Loosen lever rod the knob (quick change saw blade system) on rear of band saw. (A, Fig. 8)
6. Remove the table to direct through slot in table.

Attention : the direction of new saw blade must be:



7. Guide new blade through table slot, place blade in upper and lower ball bearing guide system.
8. Replace blade in the middle of the upper and lower wheel, if the saw blade is not in the right position, you must relax the fixed handle and adjust the positive knob. (B, Fig. 8)
9. Replace the table insert and table pin.
10. Adjust the blade tension and blade tacking if the blade width is different.

ADJUSTING UPPER BLADE GUIDE ASSEMBLY

1. Set the bearing of upper & lower blade guide to within approx. 0.5mm of the blade, make sure the bearing the back of the blade approx. 0.5mm. (Fig.10,11) see follow instruction.(AA,BB)
2. Do not set the bearing too close, a the friction generates heat, which may have an adverse effect on the bearings and the saw blade as well.

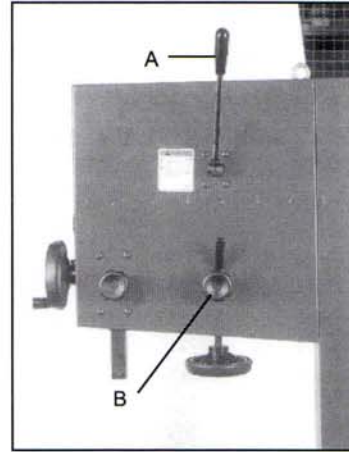


Fig. 8

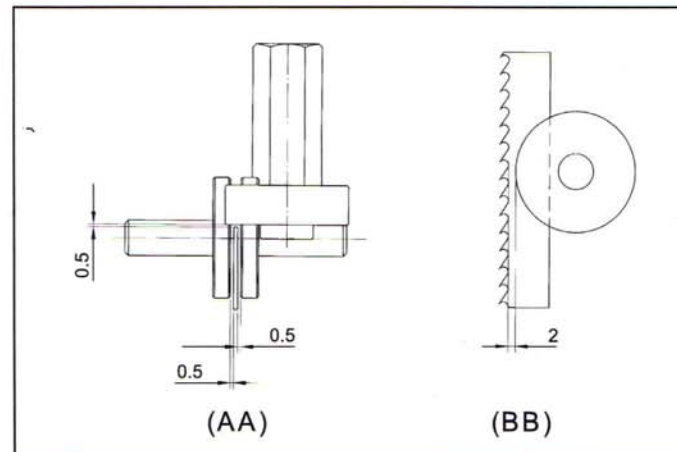


Fig. 9

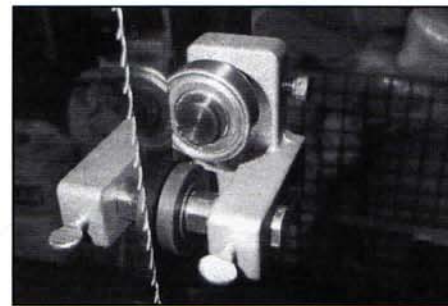


Fig. 10

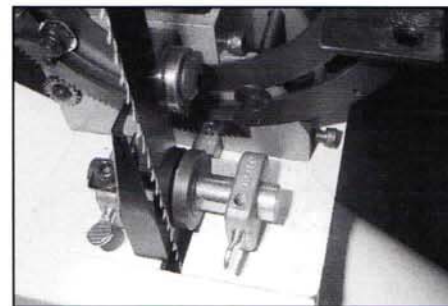


Fig. 11

ADJUSTING THE SPEED OF SAW BLADE

1. Loosen the two screw (A, B, Fig. 12), change the belt to the belt to the required belt solt.
2. Until the saw blade speed to 850m/min or 430m/min (3300SFPM, 1600SFPM)
3. Locked the two screw.

ADJUSTING THE TENSION OF THE BLADE

Blade tension is set by a spring loaded tension mechanism on the upper drive wheel. Check the level of the tension device before cutting. The tension for various blade widths as indicated on the window of upper wheel cover.

Turn the blade tension hand wheel (A, Fig. 13) and see the saw tension instruction (A, Fig. 14) indicated on the window of upper wheel cover.

DUST COLLECTION

The band saw is recommended to connected to dust collect, there are two 4" dust port (A, Fig. 15) to attach with 4" steel clamping.

SETTING THE CUTTING HEIGHT

The upper blade guide should always be set as closes practical against the work. To adjust, loosen the hand wheel (A, Fig. 2) at the side of housing and see the blade guide to the required height then tighten after setting.



Fig. 12

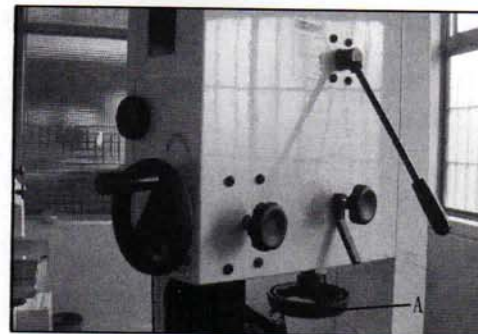


Fig. 13

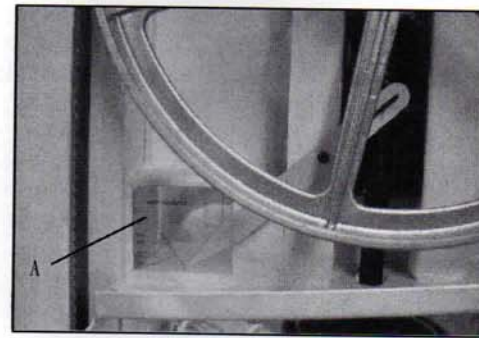


Fig. 14

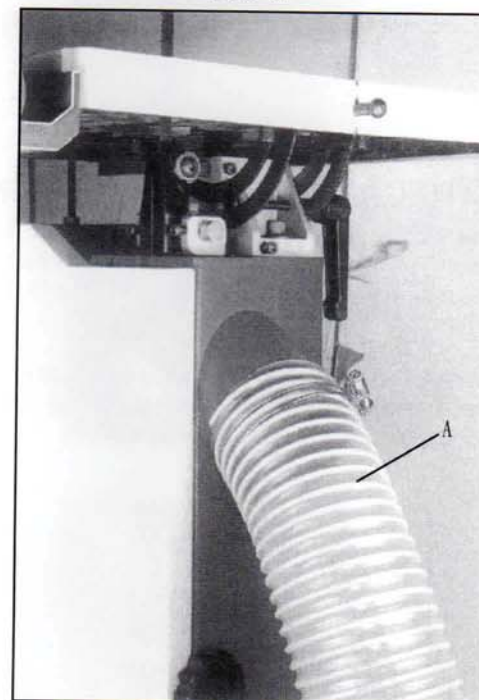


Fig. 15

MITER GAUGE ADJUSTMENT (optional)

1. Place the miter gauge in the table slot.
2. Loosen the clamp screw on the miter gauge.
3. Adjust to the desired angle of cutting on miter gauge.
4. Tighten the clamp screw (Fig. 16).

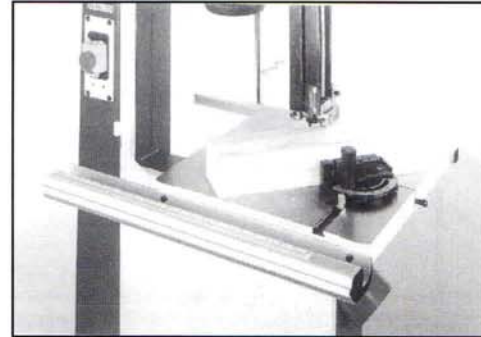


Fig. 16

SAFETY DEVICE

Limit switch(A, Fig. 17) inside the machine body for cutting off the power while door opening during operation.

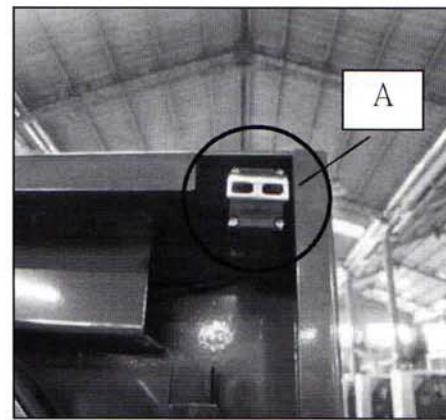


Fig.17

Added door lock (A, Fig. 18) to link upper and lower door in between. To prevent the door been suddnely open during operation.

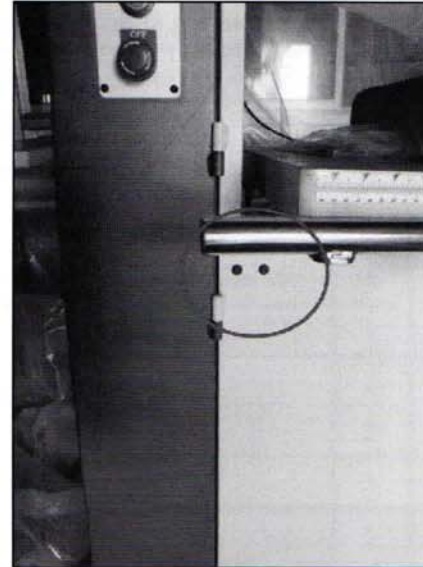


Fig.18