

# **VEVOR<sup>®</sup>**

## **TOUGH TOOLS, HALF PRICE**

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# **BAND SAW USER MANUAL**

**MODEL:HBS350**

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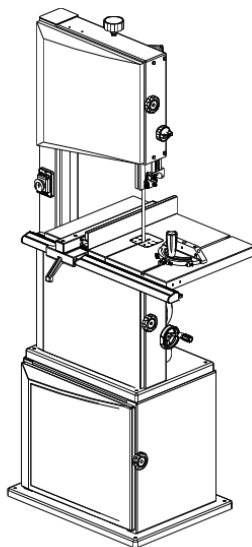
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# VEVOR®

TOUGH TOOLS, HALF PRICE

**BAND SAWR**

**MODEL:HBS350**



## NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:



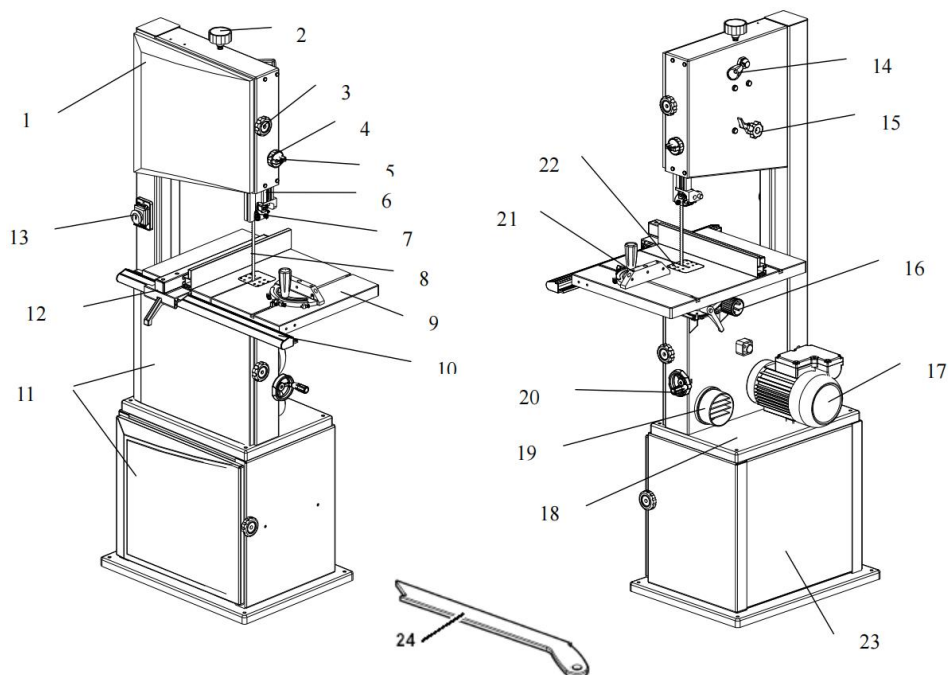
**CustomerService@vevor.com**

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.



READ THESE INSTRUCTION CAREFULLY BEFORE  
COMMISSIONING AND OPERATING THIS BAND SAW

## COMPONENTS AND PARTS (STANDARD DELIVERY )



### Front

- |  |  |
|--|--|
| 1. Upper Housing Door                      | 11. Lower Housing Door                   |
| 2. Setting Knob for Band Saw Blade Tension | 12. Rip Fence                            |
| 3. Turn-Lock Fastener, Housing Door        | 13. On/Off Switch With<br>Emergency Stop |
| 4. Setting Knob for Blade Guard            |  |
| 5. Setting Knob for Locking Blade Guard    |  |
| 6. Blade Guard                             |  |
| 7. Upper Blade Guide                       |  |
| 8. Band Saw Blade                          |  |
| 9. Saw Table                               |  |
| 10. Fence Guide Extrusion, Graduated       |  |

Back

- 14. Quick Release Lever for Band Saw Blade
- 15.Setting Knob for Blade Tracking Adjustment
- 16.Setting Knob for Table Turning Adjustment
- 17.Motor
- 18.Machine Base
- 19.Dust Extraction Port
- 20.Setting Knob for Drive Belt
- 21.Mitre
- 22.Table Insert
- 23.Stand Cabinet
- 24.Push Stick

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## PLEASE READ FIRST!

These operating instructions have been written to make it easier for you, the user, to learn how to operate this machine and to do so safely. These instructions should be used as follows:

- Read these instructions before use. Pay special attention to the safety information.
- These operating instructions are intended for people with basic technical knowledge regarding the operation of a machine like this or similar electrical power tools. Inexperienced persons are strongly advised to seek competent advice and guidance from an experienced person before operating this machine.
- Keep all documents supplied with this machine for future reference. Retain your proof of purchase in case of a future warranty claim.
- This machine must not be sold or lent to someone else without being accompanied by all machine documents supplied with it.
- The manufacturer assumes no liability for any damage caused by neglect of these operating instructions.

Information in these instructions is marked as under:

	Warning - To reduce the risk of injury, user must read instructions manual carefully.
	Alternating current
	This symbol, placed before a safety comment, indicates a kind of precaution, warning, or danger. Ignoring this warning may lead to an accident. To reduce the risk of injury, fire, or electrocution, please always follow the recommendation shown below.
	Danger! Risk of personal injury or environmental damage! Risk of electric shock! Risk of personal injury by electric shock!
	Entanglement hazard! Risk of personal injury by body parts or clothing being drawn into the rotating saw blade.

	Caution! Risk of material damage.
	Note: Additional information.
	Warning- Be sure to wear ear protectors when using this product.
	Warning- Be sure to wear eye protectors when using this product.
	Warning- Be sure to wear gloves when using this product.
	This product is of protection class II. That means it is equipped with enhanced or double insulation.
	Disposal information: This product is subject to the provision of European Directive 2012/19/EC. The symbol showing a wheeled bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to a collection point for recycling electrical and electronic devices

## SAFETY



**WARNING:** Read all safety warnings, instructions, illustrations and specifications provided with this band saw. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.  
**Save all warnings and instructions for future reference.**



### **General Power Tool Safety Warnings-Work Area Safety**

- a) Keep work area clean and well-lit. Cluttered or dark areas invite accidents.
- b) Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Power tools create sparks that may ignite dust or fumes.
- c) Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.



### **General Power Tool Safety Warnings-Electrical Safety**

- a) Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
- c) Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
- d) Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric

shock.

e)When operating a power tool outdoors, use an extension cord suitable for outdoor use. Use of a cord suitable for outdoor use reduces the risk of electric shock.

f)If operating a power tool in a damp location is unavoidable,use a residual current device(RCD)protected supply.Use of an RCD reduces the risk of electric shock.



### **General Power Tool Safety Warnings-Personal Safety**

a)Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs,alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.

b)Use personal protective equipment.Always wear eye protection. Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.

c)Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool. Carrying power tools with your finger on the switch or energizing power tools that have the switch on invites accidents.

d)Remove any adjusting key or wrench before turning the power tool on.A wrench or a key left attached to a rotating part of the power tool may result in personal injury.

e)Do not overreach.Keep proper footing and balance at all times.This enables better control of the power tool in unexpected situations.

f)Dress properly.Do not wear loose clothing or jewellery.Keep your hair and clothing away from moving parts.Loose clothes,jewellery or long hair can be caught in moving parts.

g)If devices are provided for the connection of dust extraction and collection facilities,ensure these are connected and properly used.Use of dust collection can reduce dust-related hazards.



h) Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles. A careless action can cause severe injury within a fraction of a second.

### **Power Tool Use and Care**

- a) Do not force the power tool. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.
- b) Do not use the power tool if the switch does not turn on and off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- c) Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools. Such preventive safety measures reduce the risk of starting the power tool accidentally.
- d) Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Power tools are dangerous in the hands of untrained users.
- e) Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tools operation. If damaged, have the power tool repaired before use. Many accidents are caused by poorly maintained power tools.
- f) Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- g) Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed. Use of the power tool for operations different from those intended could result in a hazardous situation.
- h) Keep handles and grasping surfaces dry, clean and free from oil and grease. Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

### **Service**

- a) Have your power tool serviced by a qualified repair person using only

identical replacement parts. This will ensure that the safety of the power tool is maintained.

### **1. Specified Conditions of Use**

The machine is suitable for cutting wood, wood-derived materials and plastics. Do not cut round stock transverse to its longitudinal axis without suitable jigs or fixtures. The rotating saw blade could turn the workpiece. When sawing thin stock lay on edge, a suitable guide must be used for firm support.

Any other use is not as specified. The manufacturer is not liable for any damage caused by unspecified use.

Alteration of the machine or use of parts not approved by the equipment manufacturer can cause unforeseeable damage!

### **3. General Safety Information**

When using this tool observe the following safety instructions, to exclude the risk of personal injury or material damage. Please also observe the special safety instructions in the respective chapters.

Where applicable, follow the legal directives or regulations for the prevention of accidents pertaining to the use of band saws.



#### **General hazards!**

Keep your work area tidy - a messy work area invites accidents.

Be alert. Know what you are doing. Set out to work with reason. Do not operate tool while under the influence of drugs, alcohol or medication.

Consider environmental conditions: keep work area well-lighted.

Prevent adverse body positions. Ensure firm footing and keep your balance at all times. When working long stock use suitable supports.

Do not operate tool near inflammable liquids or gases.

The saw shall only be started and operated by persons familiar with band saws and who are at any time aware of the dangers associated with the operation of such tool.

Keep bystanders, particularly children, out of the danger zone. Persons under 18 years of age shall use this tool only in the course of their vocational training, under the supervision of an instructor.

Do not permit other persons to touch the tool or power cable while it is running.

Do not overload tool "C" use it only within the performance range it was designed for(see"Technical specifications").



**Danger!Risk of Electric Shock!**

Do not expose tool to rain.Do not operate tool in damp or wet environment.Prevent body contact with earthed objects such as radiators,pipes,cooking stoves,refrigerators when operating this tool.  
Do not use the power cable for any purpose it is not intended for.



**Risk of personal injury and crushing by moving parts!**

Do not operate the tool without installed guards.  
Always keep a sufficient distance from the band saw blade. Use suitable feeding aids if necessary.  
Keep sufficient distance to drive components when operating this tool.Do not attempt to stop the band saw blade by pushing the workpiece against its side.  
Ensure tool is disconnected from power supply before servicing.Ensure that when switching on(e.g.after servicing)no tools or loose parts are left on or in the tool.  
Turn power off if the tool is not used.



**Cutting hazard,even with the cutting tool at a standstill!**

Wear gloves when changing cutting tools.



**Risk of kickback(workpiece is caught by the band saw blade and thrown against the operator)!**

Do not jam workpieces.  
Cut thin or thin-walled workpieces only with fine-toothed saw blades.Always use

sharp band saw blades.

If in doubt, check workpiece for inclusion of foreign matter (e.g. nails or screws).

Cut only stock of dimensions that allow for safe and secure holding while cutting. Never cut several workpieces at the same time and also no bundles containing several individual pieces. Risk of personal injury if individual pieces are caught by the band saw blade uncontrolled.

When cutting round stock, use a suitable jig to prevent the workpiece from turning.



### **Entanglement hazard!**

Ensure that no parts of the body or clothing can be caught and drawn in by rotating components (no neckties, no loose fitting clothes; contain long hair with hairnet).

Never cut workpieces containing the following materials:

- Ropes
- Strings
- Cords
- Cables
- Wires



### **Hazard generated by insufficient personal protection gear!**

Wear hearing protection.

Wear safety glasses.

Wear dust mask.

Wear suitable work clothes. When working outdoors, wearing non-slip shoes is recommended.



### **Risk of injury by inhaling wood dust!**

Dust of certain timber species(e.g.oak,beech,ash)can cause cancer when inhaled:work only with a suitable dust collector connected to the saw.



**Hazard generated by modification of the machine,or use of parts not tested and approved by the equipment manufacturer!**

Assemble tool in strict accordance with these instructions.Use only parts approved by the equipment manufacturer.Use only tools(band saw blades)conforming to EN 847-1:1997.

Do not change any parts.



**Hazard generated by tool defects!**

Keep tool and accessories in good repair.Observe the maintenance instructions.Check tool for possible damage prior to any use:

Before operating the tool all safety devices,protection devices or slightly damaged parts must be inspected for proper functioning as specified.

Check to see that all moving parts work properly and do not jam.All parts must be correctly installed and meet all conditions necessary for the proper operation of the tool.

Damaged protection devices or parts must be repaired or replaced by a qualified specialist.Have damaged switches replaced by a service centre.Do not operate tool if the switch cannot be turned ON or OFF.

Keep handles free of oil and grease.

### **3. Symbols on the Machine**



**Danger! Disregard the following warnings may lead to serious personal injury or material damage.**

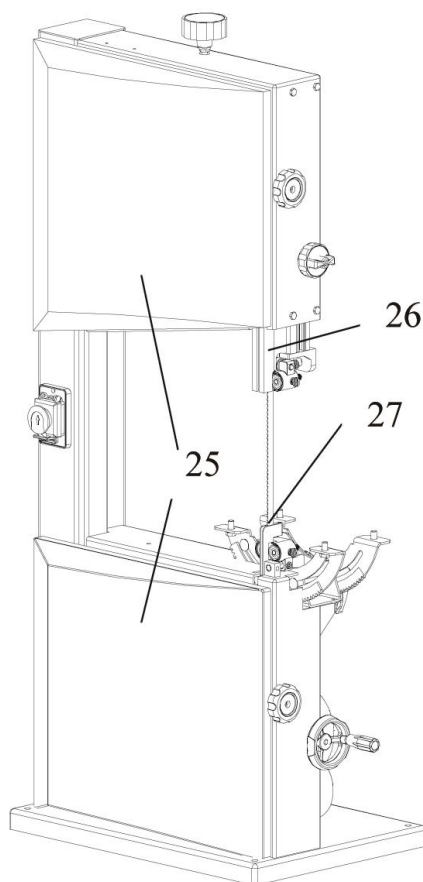


Read instructions.



Band saw blade running direction.

#### 4. Safety Devices



##### **Upper Blade Guard**

The upper blade guard(26)protects against unintentional contact with the saw blade and from chips flying about.In order for the upper blade guard to

provide adequate protection against contact with the band saw blade, it must always be set as close as possible to the workpiece (max. distance 3 mm).

### **Lower Blade Guard**

The lower blade guard(27) protects against unintentional contact with the saw blade.

The lower blade guard must always be in place and cover the band saw blade while the band saw is running.

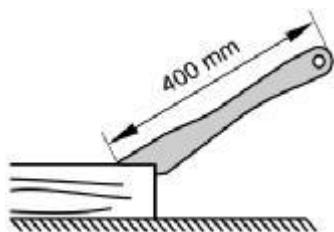
### **Housing Doors**

The housing doors(25) protect against contact with the rotating parts inside the machine. Both housing doors must be closed while the machine is in use.

### **Push Stick**

The push stick serves as an extension of the hand and protects against accidental contact with the saw blade.

The push stick must always be used if the distance between band saw blade and a rip fence is less than 120 mm. Guide the push stick at an angle of 20° ...30° against the saw table's surface.



When the push stick is not used it can be stored on the push stick holder provided at the band saw frame. Replace push stick if damaged.

## **TRANSPORT**

- Set upper blade guide to its lowest position.
- Remove projecting accessories.
- When shipping, use original packing if possible.

## MACHINE DETAILS



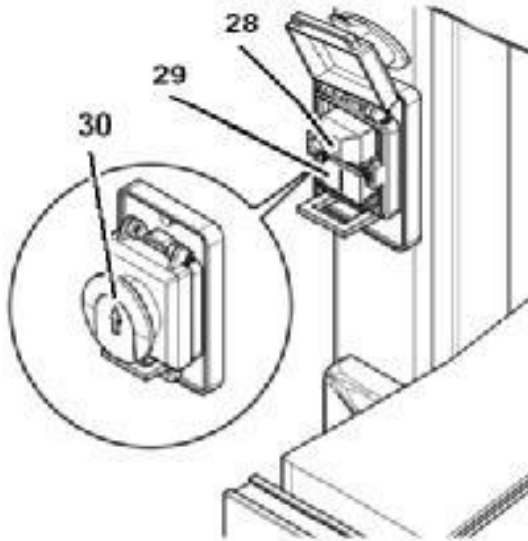
Note: In this chapter, the essential operating elements of the machine are introduced.

The proper use of the machine is described in chapter "Operation". Read this chapter before using the saw for the first time.

### **ON/OFF Switch with Emergency Stop**

- To start=press the green switch button(29).
- To stop=press the red switch button(28)or the cover(30)of the ON/OFF switch.

In the event of a voltage failure an undervoltage relay trips. This prevents

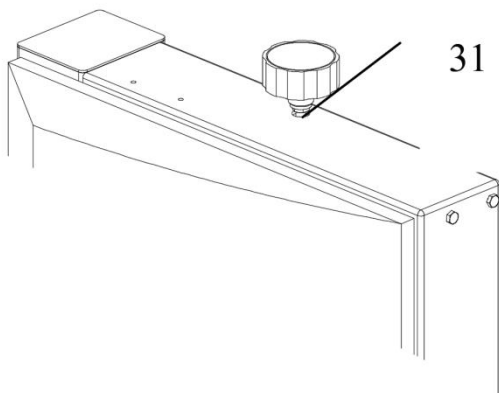


the machine from starting up when the power is restored. To restart, the green switch button must be pressed.

The cover of the ON/OFF switch(30) can be safeguarded by a padlock.

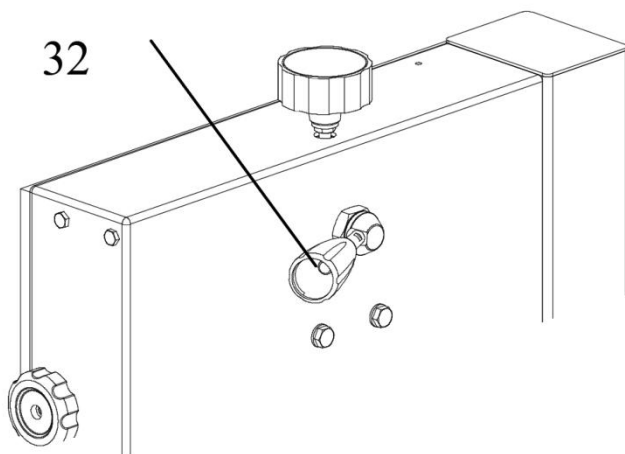
### **Setting Knob for Band Saw Blade Tension**





With the setting knob(31)the band saw blade tension is corrected,if necessary:

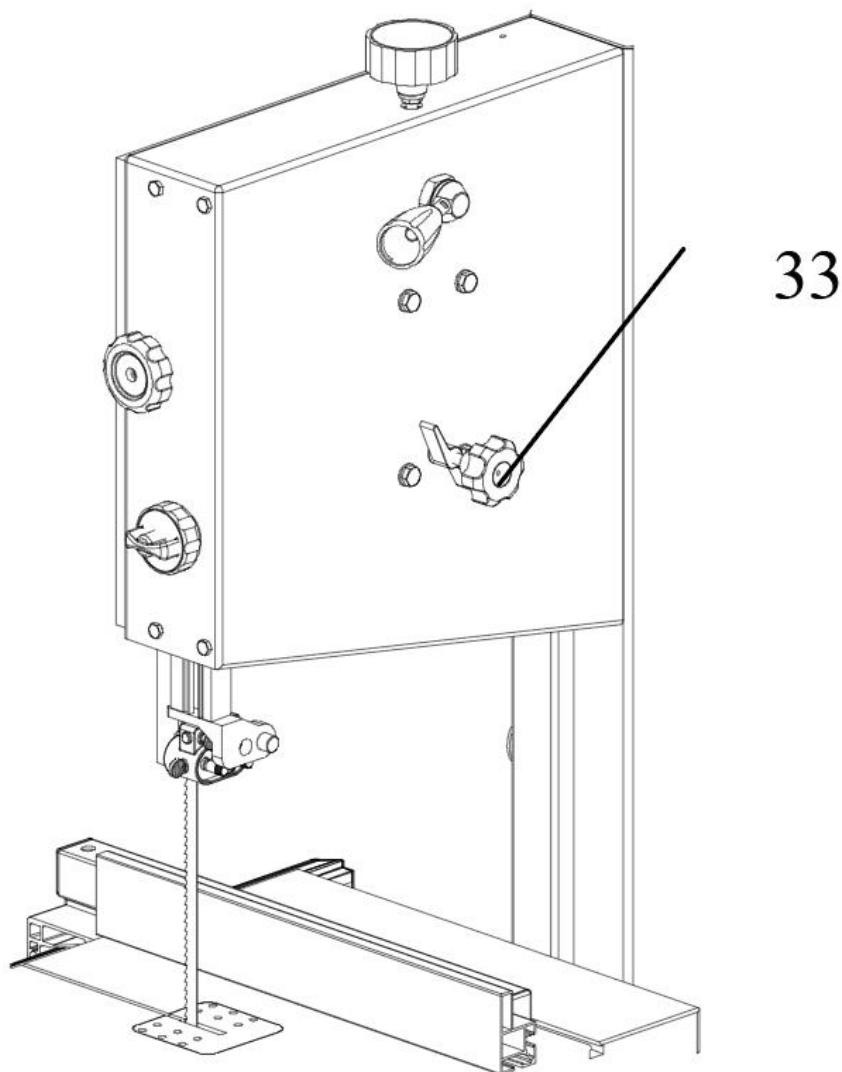
- Turning the setting knob clockwise increases the blade tension.
- Turning the setting knob counterclockwise reduces the blade tension.



### **Quick Release Lever**

With the quick release lever(32)the saw blade tension is released.

## Setting Knob for Blade Tracking Adjustment



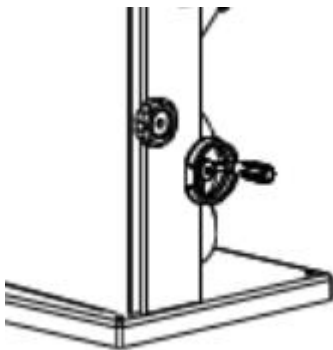
With the setting knob(33)the tilt of the upper band saw wheel can be adjusted,if necessary.This tracking adjustment is required to have the blade run dead center on the rubber tyres of the band saw wheels:

- Turning clockwise=blade moves to the rear.
- Turning counter-clockwise=blade moves to the front.

## Speed Adjustment

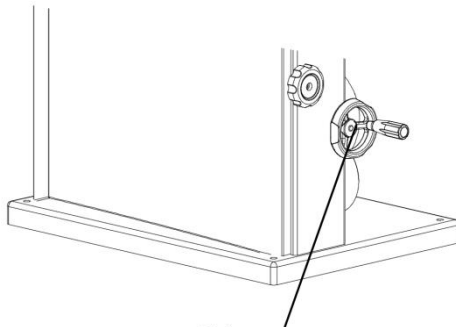
Adjust the hand wheel to adjust the speed of the band saw:

- low speed for hard wood, plastics.
- high speed for all kinds of wood.



With the setting knob(34)the drive belt tension is corrected,if necessary

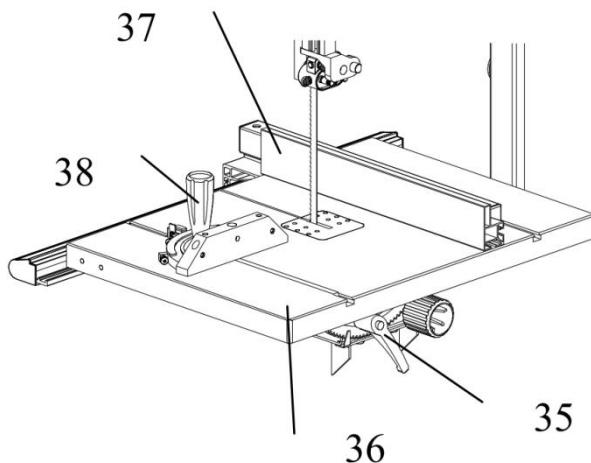
- Turning the setting knob clockwise reduces the blade tension.
- Turning the setting knob counterclockwise increases the blade tension.



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## Saw Table Tilt

After loosening the lock screw(35)the saw table(36)tilts steplessly through 45°against the blade.



### **Rip Fence**

The rip fence(37)clamps to the front of the bandsaw table;The rip fence can be used on both sides of the blade.

### **Mitre Fence**

The mitre fence is inserted into the table slot from the table's front edge.For mitre cuts the mitre fence turns to60°in both directions For 45°and 90°miters positive stops are provided.To set a mitre angle:loosen lock handle(38)by turning it counter-clockwise.



**Risk of injury!When cutting with the mitre fence the lock handle must be firmly tightened.**

## **INITIAL OPERATION**



**Danger!Start the saw only after the following preparations are completed:**

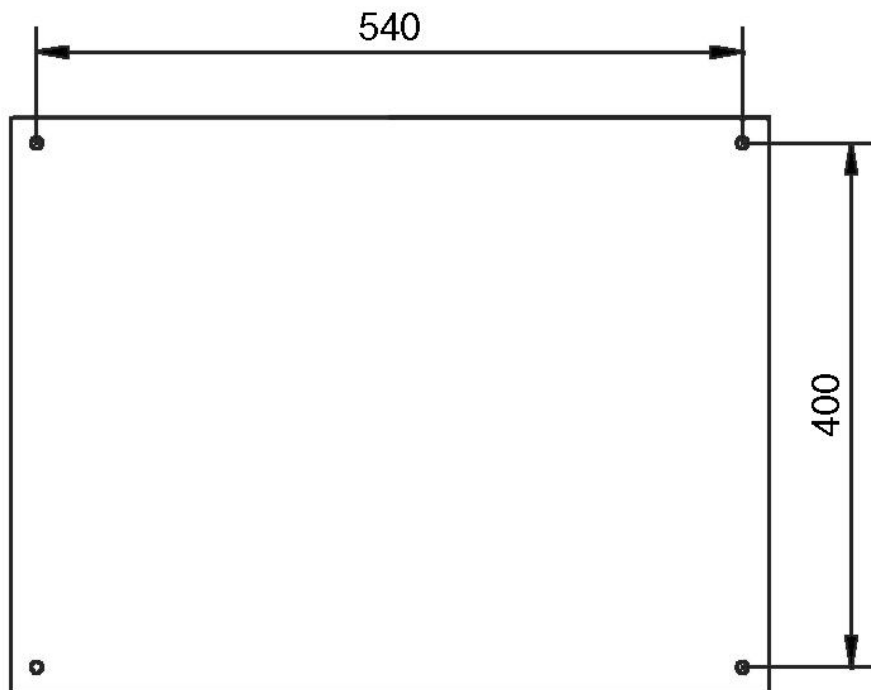
- The saw is securely mounted;
- The saw table is installed and aligned;
- The V-belt tension was checked;

-Safety devices have been checked.Connect the saw to the mains supply only after all of the above preparations are completed! Otherwise there is a risk of an unintentional starting of the saw,which can cause severe personal injury.

## 1. Mounting

For a firm stand the saw must be mounted on a stable supporting surface:

- 1).Drill 4 holes in the supporting surface.
- 2).Put fixing bolts through the base plate and secure it with nuts.

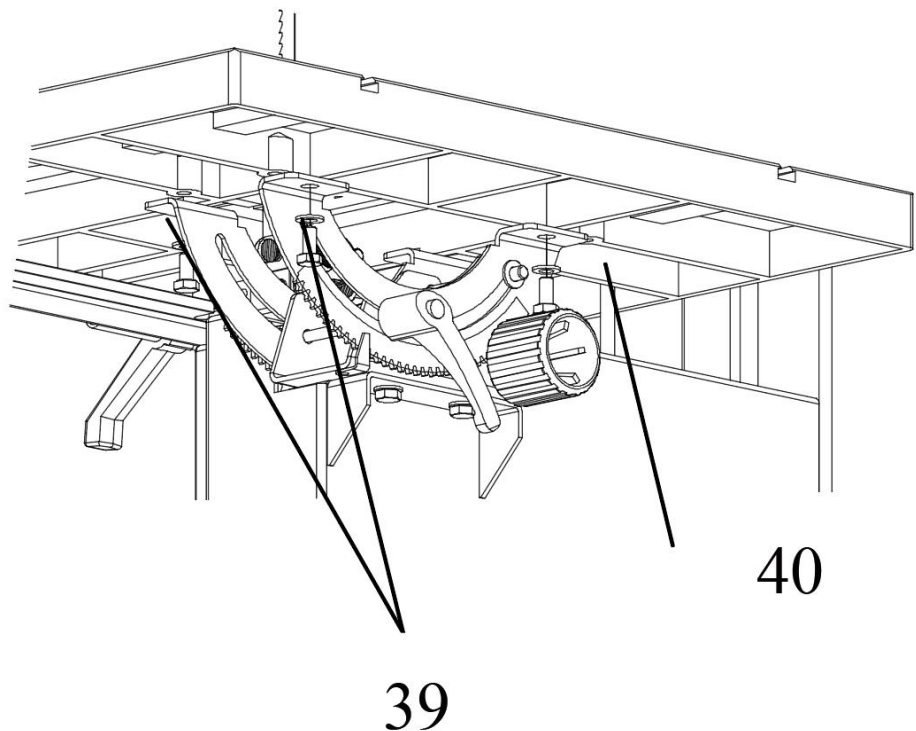


Optimal working height and stability are provided by the steel stand,which is already prepared for mounting the saw.Information regarding the assembly of the stand is given in the addendum to these operating instructions.

## 2. Installing the Saw Table

- 1).Fit limit stop screw(40)to the underside of the low house.
- 2).Guide saw table over the band saw blade and place it on the table trunnion.

3).Attach the saw table with four each screws(39)and washers to the table trunnion.



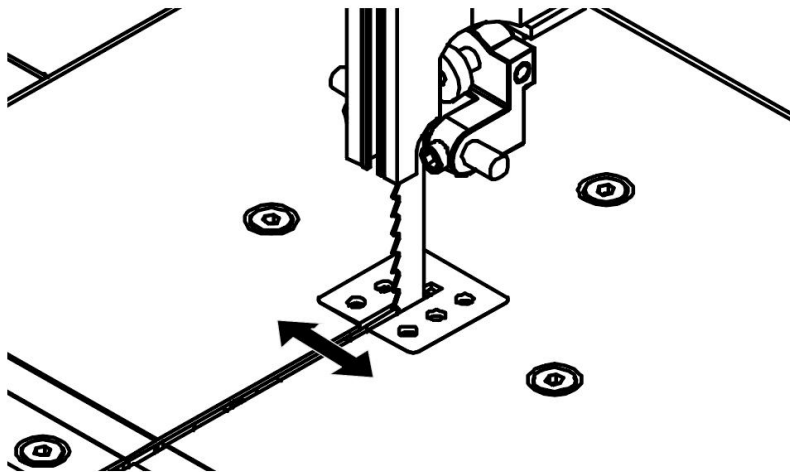
### 3. Aligning the Saw Table

The saw table needs to be aligned in two planes

- Laterally,in order for the blade to run dead centre through the table insert;
- At right angles to the band saw blade.

#### Saw Table Lateral Alignment

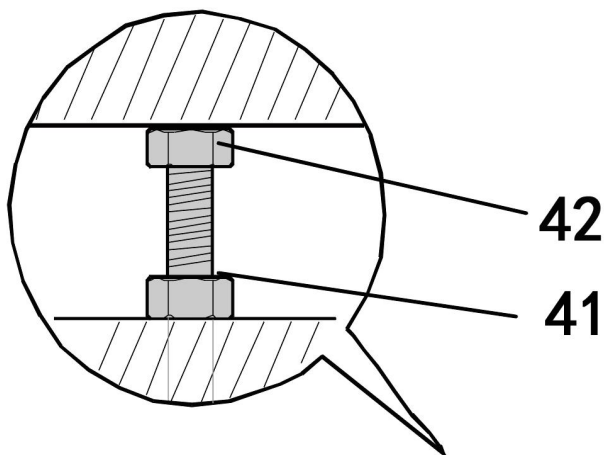
- 1).Loosen the four fastening screws(35)that hold the lower support of table trunnion.
- 2).Align the working table so that the blade runs through the centre of the table insert's slot.



3).Tighten the four fastening screws(35)again.

### **Aligning the Working Table at Right Angles to the Band Saw Blade**

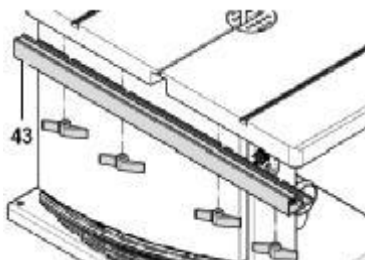
- 1).Raise upper blade guide fully(see"Operation").Check band saw blade tension(see"Initial operation").
- 2).Loosen the lock lever.
- 3).Using a try square,set the table at right angles to the blade and tighten the lock lever again.
- 4).Loosen locking nut(41)and adjust limit stop screw(42)until it touches the working table.



5).Tighten the locking nut.

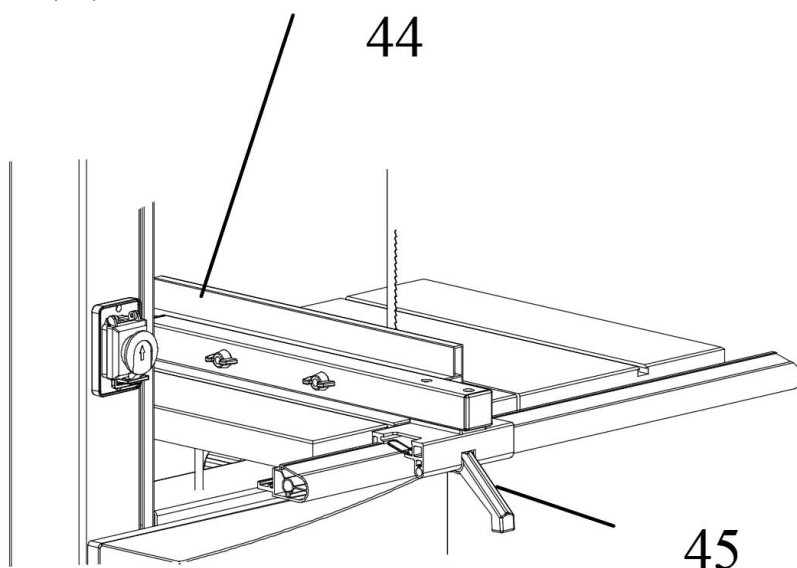
#### 4. Installing the Fence Guide Extrusion

Fasten the fence guide extrusion(58)with four thumb screws and washers to the saw table.



#### 5. Installing the Rip Fence

The rip fence can be used on both sides of the blade. When the rip fence is moved from one side of the saw blade to the other the fence extrusion(44)needs to be reversed.



Place rip fence on the rip fence guide. Tighten the lock lever(45)of the rip.

#### 6. Installing the Push Stick Holder



Note: If the saw is to be mounted on the stand, the push stick



holder can only be installed afterward.

- 1) Turn a hexagon nut on a cap screw(46),all the way up to the unthreaded part of the shank.
- 2) Turn cap screw into the hole on the left side of the band saw.
- 3) Tighten hexagon nut hand-tight only.
- 4) Hang push stick(47)on the cap screw when not in use.

## **7. Dust Collector Connection**



**Danger!Dust of certain timber species(e.g.oak,beech,and ash)can cause cancer when inhaled:always use a dust collector when working in enclosed spaces(air speed at the saw's dust extraction port $\geq$ 20 m/s).**



**Caution!Operation without a dust collector is only possible:**

- Outdoors;
- For short-term operation(up to max.30 minutes);
- With dust respirator.
- If no dust collector is used chips will accumulate,which need to be removed periodically.

Connect dust collector or industrial vacuum with a suitable adaptor to the dust extraction port.

## **8. Tensioning the Band Saw Blade**

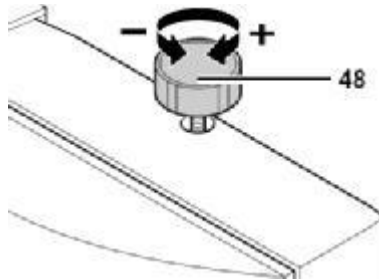


**Danger!Too much tension can cause the band saw blade to break.Too little tension can cause the driven band saw wheel to slip and the band saw blade to stop.**

1. Raise upper blade guide fully(see"Operation").
  2. Checking the blade tension:-Check tension by pushing with a finger,halfway between table and upper blade guide,against the side of the blade(the blade should flex not more than 1-2 mm).
- Check adjustment at the blade tension indicator.The scale indicates

the correct adjustment in dependence on the band saw blade width.

3. Correct tension if necessary: turning the setting knob(48) counter-clockwise increases the blade tension. Turning the setting knob(48) counter-clockwise reduces the blade tension.



4.

## 9. Connection to Power Mains



**Danger! High Voltage Operate the saw only in a dry environment.**

Operate the saw only on a power source matching the following requirements(see also "Technical Specifications"):

- Mains voltage and system frequency conform to the voltage and frequency shown on the machine's nameplate;
- Fuse protection by a residual current operated device(RCD) of 30 mA sensitivity;
- Outlets properly installed, earthed and tested;



### **Note:**

Check with your local Electricity Board or your electrician if in doubt whether your house service connection meets the requirements.

- Make sure the power supply cable is out of the way, so that it does not interfere with the work and does not pose a tripping hazard or will get damaged.
- Protect the power supply cable from heat, aggressive liquids and sharp edges.
- Use only rubber-insulated extension cables of sufficient lead cross

section(3 x 1.5 mm<sup>2</sup>,for machines with 3-phase motor:5 x 1.5 mm<sup>2</sup>).

- Do not pull on the power supply cable to unplug.
- 1. When the saw is assembled and all safety devices are installed,connect it to the power supply.
- 2. Start saw briefly and turn OFF immediately again.
- 3. Check the band saw blade's direction of rotation:in the cutting area it must run from the top downwards.
- 4. If the band saw blade turns in the wrong direction,unplug the power supply cable at the saw.
- 5. Have the electrical connection changed by a qualified electrician!

## **10. Connection to Power Mains**

Assembly the cabinet stand

- Check contents against the parts list.
- Locate back panel and right&left end panels onto the base panel,secure using hex bolts and washers.
- Fasten the right&left end panels to the back panel,secure using hex bolts and washers.
- Fasten the front bracing member onto the right&left end panels assemble using hex bolts and washers.Fasten the shelf on the right&left end panels using remaining hex bolts and washers.
- Fit the door onto the end panel.
- With assistance, lift the band saw and carefully position it in place on top of the work-stand.
- Fix in position using hex bolts,through washer,cabinet stand,washer, hex nut,band saw and lock-8-washer then secure on upper side with hex nut.Repeat procedure for all four corners before tightening fully.

## **OPERATION**



**Danger!**To reduce the risk of personal injury as much as possible,the following safety recommendations should be observed when operating the saw.

Use personal protection gear:

- Dust respirator;
- Hearing protection;
- Safety goggles.

Cut only one workpiece at a time.

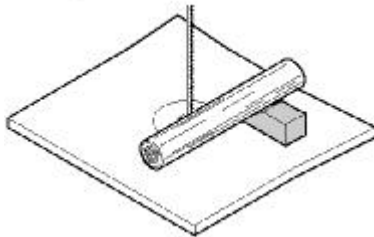
Always hold the workpiece down on the table.

Do not jam the workpiece.

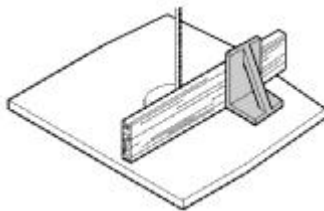
Do not attempt to stop the band saw blade by pushing the workpiece against its side.

If the type of work requires, use the following:

- Work support for long stock, which would otherwise fall off the table on completion of the cut;
- Push stick—if distance rip fence—band saw blade  $\geq 120$  mm;
- Dust collector;
- An appropriate jig when cutting round stock, to keep it from turning;



- A suitable guide for firm support when cutting thin stock lay on edge.



Before starting work, check to see that the following are in proper working order:

- Band saw blade;
- Upper and lower blade guard.
- Replace damaged parts at once!

- Assume correct work position(the band saw blade's teeth must point towards the operator).
- Never cut several workpieces at the same time, and also, any bundles containing several individual pieces. Risk of personal injury if individual pieces are caught by the saw blade uncontrolled



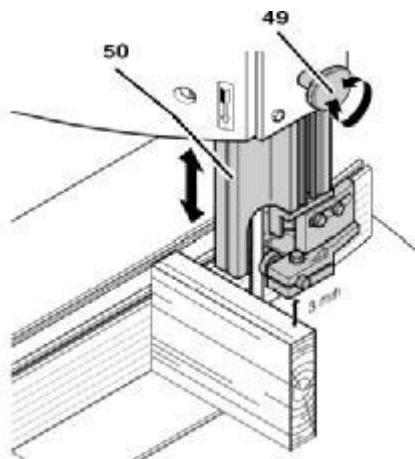
### **Drawing-in/trapping hazard!**

- Do not wear loose clothing,jewellery,or gloves,which may get caught and wound up by revolving machine parts.
- Contain long hair with a hairnet.
- Never cut stock to which ropes,cords,strings,cables and wires are attached or which contain such materials.

### **Upper blade guide adjustment**

The height of the upper blade guide (50) needs to be adjusted:

- Prior to every cutting operation,to accommodate the height of the workpiece(the upper blade guide should be set approx.3 mm above the workpiece);



- After adjustments of band saw blade or saw table(e.g.band saw blade change,tensioning of the band saw blade,saw table alignment).



**Danger!Before adjusting the upper blade guide and saw table**

### tilt:

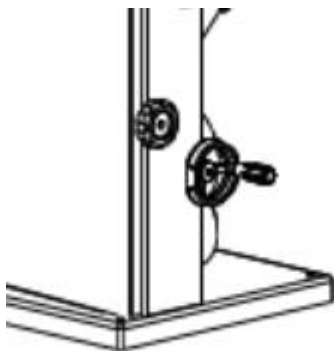
- Switch machine OFF.
- Wait until the band saw blade has come to a complete stop. Set upper blade guide(50) with the adjusting knob(49) to the desired

### Cutting Speed Adjustment

1. Adjust the hand wheel to adjust the speed of the band saw.
2. Clockwise rotation speed increased.
3. Counterclockwise rotation speed decreases.
4. Speed range:

50Hz:500-880m/min

60Hz:600-1050m/min



### 1. Sawing

- 1) Choose and install a table insert extrusion suitable for the type of cut to be performed:
  - Table insert extrusion with a narrow slot for standard cross-cuts only;
  - Table inserts extrusion with a beveled slot for bevel cuts also.
- 2) Adjust the band saw blade speed.
- 3) If necessary, adjust the table tilt.



**Risk of kickback(workpiece is caught by the band saw blade and thrown against the operator)!Do not jam any workpieces.**

- 4) Select rip fence and table tilt for the type of cutting operation to be carried out.
- 5) Set upper blade guide 3 mm above the workpiece.



**Note:** Always make a trial cut in a piece of scrap to verify settings; correct if necessary before cutting the workpiece.

- 6) Place workpiece on the saw table.
- 7) Plug in.
- 8) Start saw.
- 9) Cut workpiece in a single pass.
- 10) Switch off if no further cutting is to be done immediately afterwards.

## CARE AND MAINTENANCE



**Danger! Prior to all servicing:**

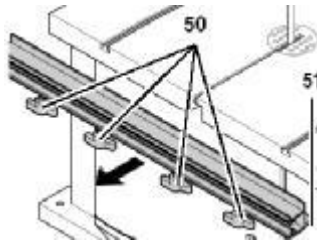
- Switch machine OFF.
- Unplug power cable.
- Wait until the saw has come to a complete stop.
- Check that all safety devices are operational again after each service.
- Replace defective parts, especially safety devices, only with genuine replacement parts. Parts not tested and approved by the equipment manufacturer can cause unforeseen damage.
- Repair and maintenance work other than described in this section should only be carried out by qualified specialists.

### 1. Changing the Band Saw Blade

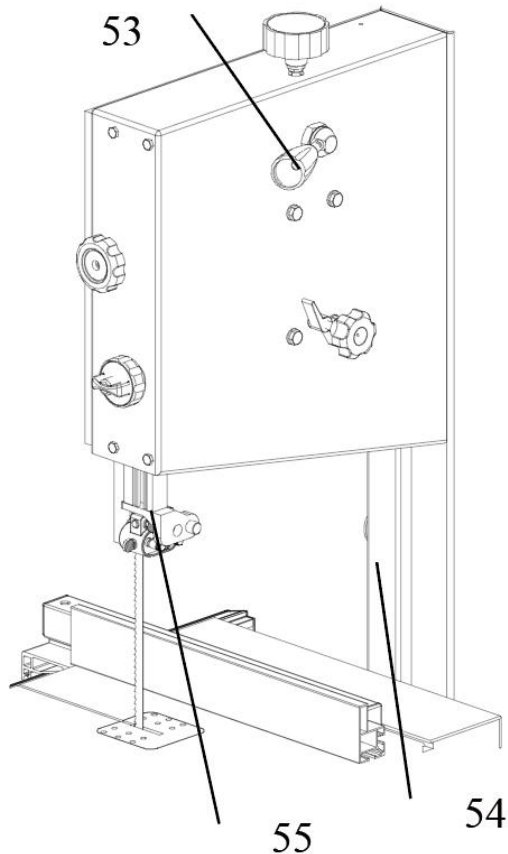


**Danger! Risk of injury, even with the band saw blade at a standstill. Wear gloves when changing blades. Use only suitable band saw blades (see "Technical specifications").**

1. Loosen the four thumb screws (50) and remove the fence guide extrusion (51).



2. Open both housing doors.



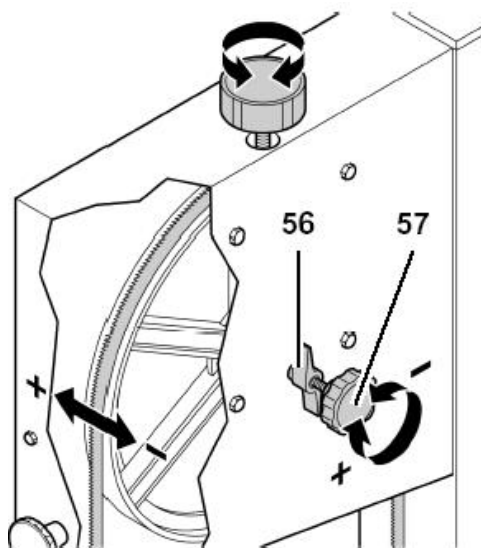
3. Set the upper blade guide(55)to its lowest position.
4. Loosen quick release lever(53)until the band saw blade has slackened.
5. To remove the band saw blade,guide it through
  - The slot in the saw table
  - The blade guard on the upper blade guide



- The blade cover on the saw housing(54)and
  - The blade guides.
6. Fit a fresh band saw blade.Observe correct position:the teeth point towards the front(door)side of the saw.
  7. Center band saw blade on the rubber tyres of the band saw wheels.
  8. Tighten quick release lever until blade no longer slip off the band saw wheels.
  9. Close both housing doors.
  - 10.Then:
    - Tension band saw blade(see"Initial operation").
    - Align band saw blade(see"Care and maintenance");
    - Align blade guides(see"Care and maintenance");
    - Let saw test run for at least one minute;
    - Stop saw,unplug and recheck settings.

## 2. Aligning the Band Saw Blade

If the band saw blade does not run in the centre of the rubber tyres,the tracking needs to be corrected by adjusting the tilt of the upper band saw wheel:



1. Loosen lock nut(56).
2. Turn setting knob(57):

-Turn setting knob(57)clockwise if the band saw blade runs towards the front of the saw.

-Turn setting knob(57)counterclockwise if the band saw blade runs towards the rear of the saw.

3. Tighten lock nut(56).

### 3. Aligning the Upper Blade Guide

The upper blade guide consists of:

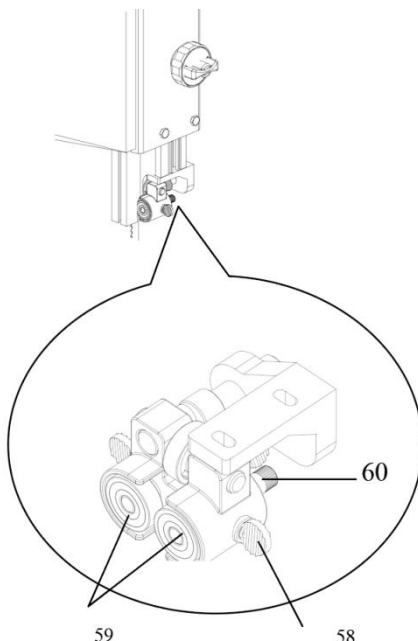
- A thrust bearing(supporting the band saw blade from the rear)
- Two guide bearings(providing lateral support).

All bearings need to be readjusted after every band saw blade change and/or tracking adjustment.



**Note:**Periodically check all bearings for wear. If necessary, replace both guide bearings at the same time.

#### Adjusting the Thrust Bearing



1.If necessary,align and tighten the band saw blade.

2. Loosen fixing screw of the upper blade guide.
3. Align upper blade guide
4. Tighten the upper blade guide's fixing screw.
5. Loosen the thrust bearing's lock screw.
6. Adjust thrust bearing position (distance thrust bearing-band saw blade = 0.5 mm—if the band saw blade is turned by hand, it must not touch the thrust bearing).
7. Tighten the thrust bearing lock screw.

### **Adjusting the Guide Bearings**

1. Loosen locking bolt(58).
2. Set guide bearings(59) with the shaft(60) against the band saw blade.
3. Turn band saw wheel by hand in a clockwise direction several times to bring the guide bearings in correct position—both guide bearings should just touch the band saw
4. Retighten locking bolt(58) to lock the shaft(60).

## **4. Aligning the Lower Blade Guide**

The lower blade guide consists of:

- A thrust bearing (supporting the band saw blade from the rear)
- Two guide bearings (providing lateral support). These parts need to be readjusted after every band saw blade change or tracking

### **Adjusting the Thrust Bearing**

See “Aligning the Upper Blade Guide”

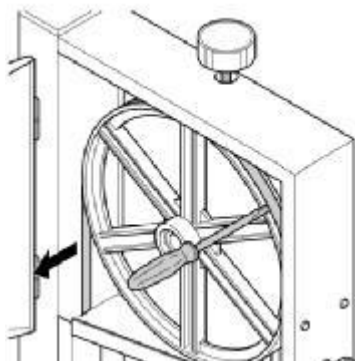
### **Adjusting the Guide Bearings**

See “Aligning the Upper Blade Guide”

## **5. Replacing the Band Saw Tyre**

Periodically check band saw tyres for wear. Replace only in pairs:

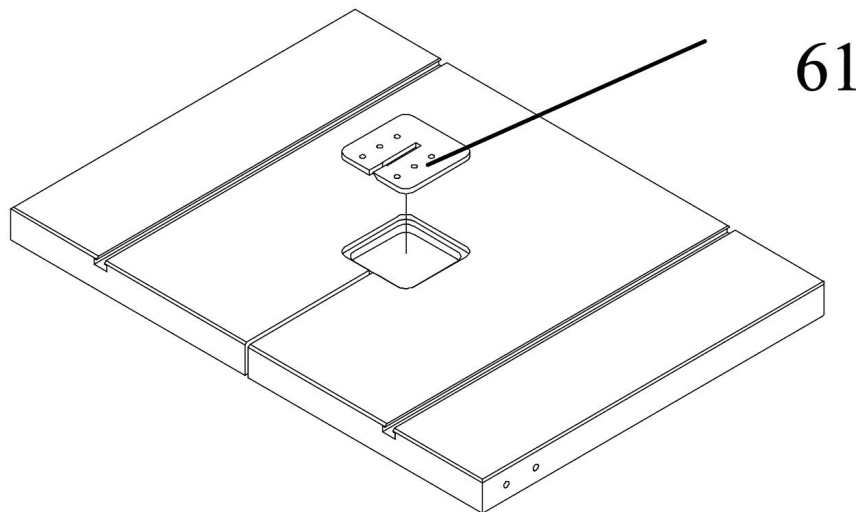
1. Remove band saw blade (see “Care and Maintenance”);
2. Lift band saw tyre with a small screwdriver, then pull off the band saw wheel.
3. Mount new band saw tyres and reinstall the band saw blade.



## 6. Replacing the Table Insert

The table insert needs replacement when its slot has become enlarged or damaged.

1. Remove table insert(61)from saw table(push up from underneath).
2. Fit new table insert.



## 7. Cleaning the Saw

1. Open the housing doors.
2. Remove chips and sawdust with brush or vacuum cleaner.
3. Close the housing doors.

## 8. Storage



### **Danger! Store saw where**

- It cannot be used or tampered with by unauthorized persons and
- Nobody can get hurt by the machine.



### **Note:**

The ON/OFF switch can be safeguarded by a padlock.



### **Caution!**

Do not store the saw outdoors, in unprotected areas or in damp or wet locations.

## 9. Belt Replacement

1. Turn the handwheel and loosen the belt.



2. Loosen the quick rise at the back of the band saw and loosen the saw blade.



3. Loosen the spring with a spring clamp.



4. Take off the lower wheel and replace the belt



## REPAIRS



### **Danger!**

Repairs to electric tools must be carried out by qualified electricians only!  
Electric tools in need of repair can be sent to the service center of your country. Refer to the spare parts list for the address.  
Please attach a description of the fault to the electric tool.

## ENVIRONMENTAL PROTECTION

All packaging materials are 100% recyclable. Worn out power tools and accessories contain considerable amounts of valuable raw and rubber materials, which can be recycled.

These instructions are printed on paper produced with elemental chlorine-free bleaching process.

## TROUBLE SHOOTING



### **Danger!**

**Before carrying out any fault service or maintenance work always:**

- Switch machine OFF
- Unplug power cable.
- Wait until the band saw blade has come to a complete stop.

Check to see that all safety devices are operational after each fault service.

### **Motor does not run**

Under voltage relay tripped by power failure:

- Switch on again.

No mains voltage

- Check cables, plug, outlet and mains fuse.

Motor overheated,e.g.by a blunt band saw blade or chip build-up in the housing:

- Remove cause for overheating,let cool down for a few minutes,then start again.

### **Band saw blade wanders off the line of cut or runs off the band saw wheels**

Band saw blade is not running dead center on the band saw wheels:

- Correct tracking(see"Care and maintenance").

### **Band saw blade breaks**

Incorrect tension:

- Correct band saw blade tension(see"Initial operation").

Load too high:

Reduce pressure against band saw blade(reduced feed speed).

Incorrect band saw blade:

- Replace band saw blade(see"Care and maintenance"):

Thin stock=narrow band saw blade

Thick stock=wide band saw blade.

### **Band saw blade warped**

Load too high:

- Avoid lateral pressure on the band saw blade.

### **Saw vibrates**

Insufficient mounting:

- Fasten saw properly to a suitable surface(see"Initial operation").

Saw table loose:

- Align and fasten saw table.

Motor mount loose:

- Check fastening screws,tighten if necessary.

### **Dust extraction port blocked**

No dust collector connected or suction capacity insufficient:

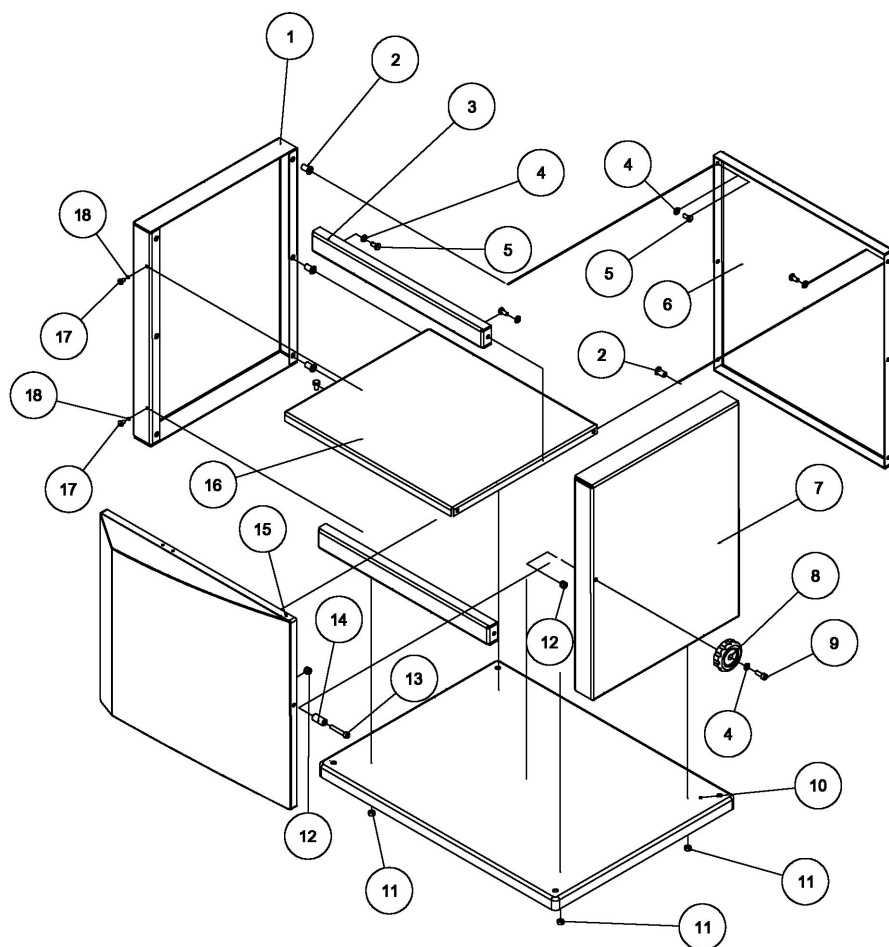
- Connect a dust collector or increase suction capacity(air speed $\geq$ 20 m/sec at dust extraction port).



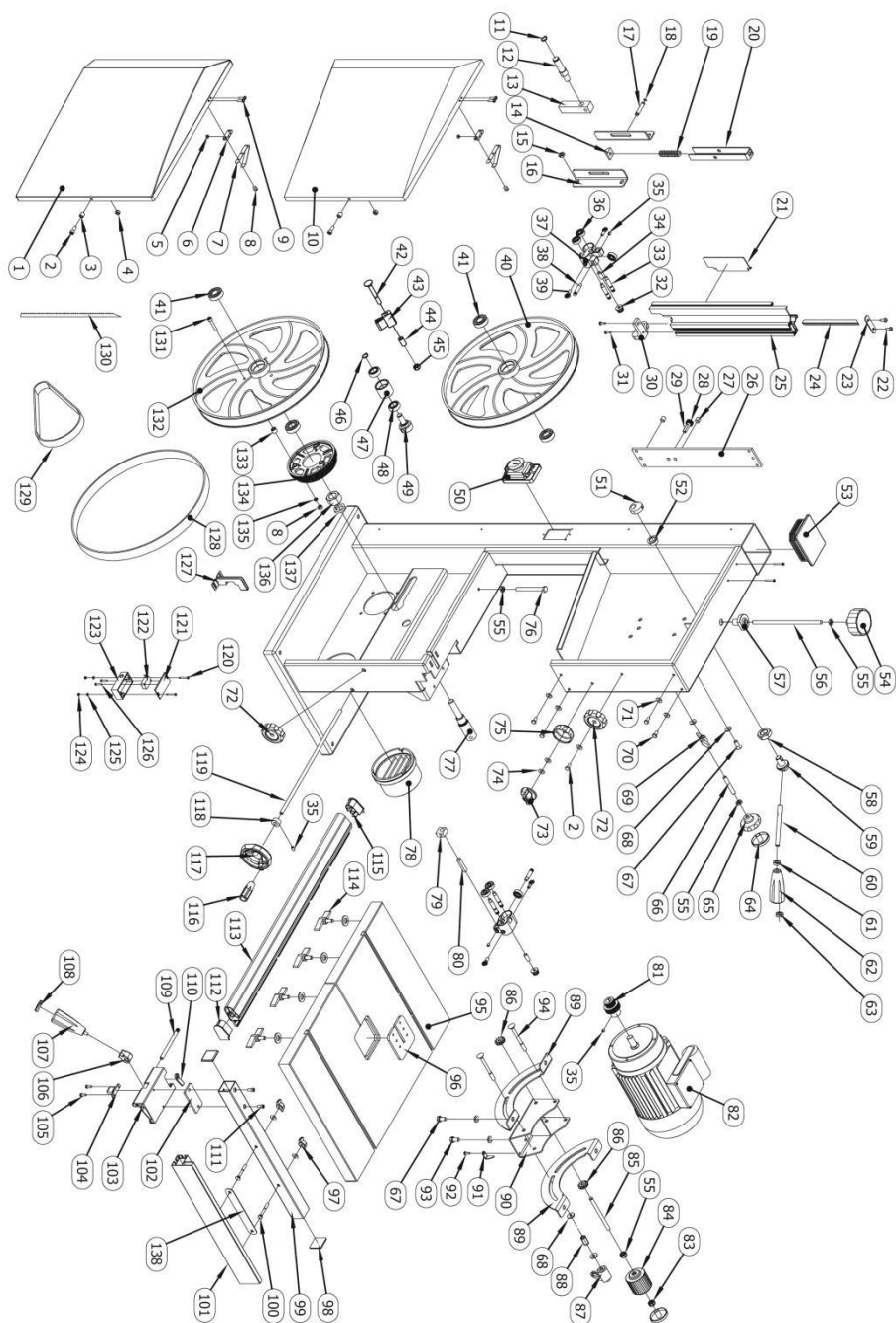


## EXPLODED VIEW DRAWING AND PART LIST

### Band Saw Cabinet Stand



Item	Drawing No.	Name	Q'TY
1	DJ350A01012	Left End Panel	1
2	GB/T17880.1 M6X13.5	Nut	12
3	DJ350A01014	Front Bracing Member	2
4	GB97.1-85 6	Washer	21
5	GB5783-86 M6×16	Hex Bolt	16
6	DJ350A01013	Back Panel	1
7	DJ350A01011	Right End Panel	1
8	DJ350A03002	Turn-Lock Fastener	1
9	GB70-85 M6×16	Bolt	1
10	DJ350A01015	Base	1
11	GB6170-86 M6	Hex Nut	4
12	GB889-86 M6	Hex. Locking Nut	2
13	GB70-85 M6×35	Bolt	1
14	DJ350A04005	Gap Pipe	1
15	DJ350A04100	Low Door	1
16	DJ350A01016	Shelf	1
17	GB818-85 M5×6	Screw	2
18	GB97.1-85 5	Washer	2



ITEM	PART NO.	NAME	Q'ty
1	DJ350A04100	Lower Door	1
2	GB70-85 M6×16	Hex. Socket Set Columned Head Bolt	4
3	DJ350A04004	Spacer Bushing	2
4	GB889-86 M6	Locking Nut	4
5	GB6170-86 M4	Nut	8
6	DJ350A03102	Joining Block	2
7	31503035	Spring Plate	2
8	GB12618-90 4×10	Rivet	4
9	GB818-85 M4×16	Cross Recessed Pan Head Screw	4
10	DJ350A03100	Upper Door	1
11	GB894.1-86 15	Circlip for Shaft	2
12	DJ350A03006	Bearing Bolt Upper	1
13	DJ38003003	Bearing Bolt Support Upper	1
14	DJ250A03009	Nut	1
15	GB6177-86 M8	Hex. Flanged Nut	4
16	DJ350A03008	Guiding Plate	2
17	DJ250A03007	Shaft	1
18	GB896-86 6	Split Washer	2
19	DJ38003010	Spring	1
20	DJ38003011	Tension Bracket Frame	1
21	DJ350A03005	Slider	1
22	GB845-85ST4.8×16	Cross Recessed Pan Head Tapping Screw	2
23	31503034	Cover Board	1
24	31503018	Rack	1
25	DJ350A03001	Guide Carrier Extrusion	1
26	DJ350A03003	Pressure Plate	1
27	DJ350A03004	Pin	2
28	DJ31703113	Gear	1
29	DJ350A03007	Shaft for Gear	1

30	31503014B	Guide Carrier System	1
31	GB845-85 ST4.8×22	Cross Recessed Pan Head Tapping Screw	2
32	DJ315S03012A-1	Adjusting Nut	2
33	DJ315S03012A-2	Guiding Shaft	4
34	GB77-85 M8×30	Hex. Socket Set Columned Head Bolt	2
35	GB77-85 M6×6	Hex. Socket Set Screw	4
36	GB/T278-89 80027	Bearing	6
37	DJ315S03012A	Three Roller Guide Housing	2
38	DJ315S03012A-3	Shaft For Pilot	2
39	DJ35003025A	Setting Knob for Locking	4
40	DJ35003001A	Upper Wheel	1
41	GB/T276-94 6202-2Z	Bearing	4
42	GB14-88 M8×16	Cup Head Square Neck Bolt	4
43	31504015	Brush Strip	1
44	31504014	Spacer Bushing	1
45	GB6177-86 M8	Hex. Flanged Nut	1
46	GB894.1-86 12	Circlip for Shaft	1
47	31504012	Tension Wheel	1
48	GB/T278-89 80101	Ball Bearing	2
49	31504013	Sliding Shaft	1
50	CK-5	Switch	1
51	DJ31703008	Cam	1
52	DJ31703009	Spacer Bushing	1
53	DJ350A05002	Lamello Plug	1
54	31503006	Setting Knob	1
55	GB6172-86 M8	Hex. Thin Nut	2
56	DJ38003004-01	Thread Bolt	1
57	DJ38003002	Tension Pan	1
58	GB6173-86 M20×1.5	Hex. Nut	1
59	DJ31703010	Seat for Quick Release Shaft	1

60	DJ38003007	Quick Release Shaft	1
61	GB6172-86 M10	Hex. Thin Nut	1
62	TJ315B03002-1	Locking Handle	1
63	GB6170-86 M10	Hex. Nut	1
64	31503008-2	Setting Knob	1
65	31503008-1	Cap	1
66	GB5783-86 M8x45	Hex. Bolt	1
67	GB5783-86 M8x 16	Hex. Bolt	8
68	GB97.1-85 8	Washer	13
69	31503007	Wing Nut	5
70	GB5783-86 M6X10	Hex. Bolt	4
71	GB97.1-85 6	Washer	8
72	DJ350A03002	Locking Door Knob	2
73	DT/SB030	Locking Knob	1
74	GB/T1792 A16	Butterfly Washer	2
75	DJ250A03016B-2	Base of Adjusting Knob	1
76	GB5783-86 M8×80	Hex. Bolt	1
77	DJ350A04003	Bearing Bolt Lower	1
78	31604006	Suction Connector	1
79	DJ350A04009	Seat Lower Guide	1
80	DJ315B03024	Locking Pin	1
81	RWL1000F0216	Motor Pulley	1
82	YYL8024E-T	Motor	1
83	DJ315D03001	Nut	1
84	TJ31502012	Hand Wheel	1
85	DJ350A02003	Shaft for Gear	1
86	TJ31503014	Gear	2
87	DJ315B02008	Locking Handle	1
88	DJ315B03036	Spacer Bushing	1

89	DJ350A02002	Table Trunnion	2
90	DJ350A02100	Table Trunnion Lower	1
91	DJ350A02006	Pointer	1
92	GB818-85 M4×6	Cross Recessed Pan Head Screw	1
93	GB5783-86 M6X6	Hex. Bolt	4
94	DJ315S02014	Cup Head Square Neck Bolt	2
95	DJ350A02001	Table	1
96	DJ350A02004	Table Insert	1
97	DJ315S02001-16	Wing Nut	2
98	DJ315S02001-18	Cap	2
99	DJ315S02001-09	Fence Bracket	1
100	GB/T801-98 M6×45	Cup Head Square Neck Bolt	2
101	DJ315S02001-10	Fence	1
102	DJ315S02001-05	Pressure Plate	1
103	DJ350A02007	Fence Carrier	1
104	RTS250G04012	Plastic Pressure Plate	1
105	GB845-85 ST3.5×9.5	Cross Recessed Pan Head Tapping Screw	2
106	RTS250G04011	Cam	1
107	TJ315B03002-1	Handle	1
108	TJ315B03002-2	Cap	1
109	DJ315S02001-08	Shaft	1
110	RTS250G06010	Pointer	1
111	GB70-85 M6X35	Hex. Socket Set Columned Head Bolt	1
112	RTS250G04002-2	Cover Board Right	1
113	DJ350A04001	Fence Carrier Extrusion	1
114	31502015	Wing Bolt	4
115	RTS250G04002-1	Cover Board Left	1
116	TJ25003004A-2	Handle	2
117	TJ25003004A-1	Hand Wheel	2



118	31504019	Setting Collar	1
119	DJ350A04006	Shaft For Belt Tension	1
120	GB818-85 M4×35	Cross Recessed Pan Head Screw	4
121	DJ31705002	Microswitch Cover	2
122	HY50	Microswitch	2
123	RWLD0120	Microswitch Box	2
124	GB6170-86 M4	Hex. Nut	4
125	GB862.1-87 3	Lock Washer	4
126	GB845-85 ST3.5×9.5	Cross Recessed Pan Head Tapping Screw	2
127	DJ350A04002	Blade Guard	1
128	DJ35003003	Rubber Tyre	2
129	31504010A	J-Belt	1
130	DJ350A05001	Blade	1
131	GB70-85 M6X35	Hex. Socket Set Columned Head Bolt	3
132	DJ350A04008	Lower Wheel	1
133	DJ350A04004	Spacer Bushing	1
134	DJ38003005	Pully	1
135	GB93-87 6	Spring Washer	3
136	GB6173-86 M20×1.5	Hex. Nut	1
137	GB93-87 20	Spring Washer	1
138	DJ315S02001-20	Fixing Plate	1

**Importer:** WAITCHX

**Address:** 250 bis boulevard Saint-Germain 75007 Paris

**Importer:** FREE MOOD LTD

**Address:** 2 Holywell Lane, London, England, EC2A 3ET

**Manufacturer:** Laizhou Hengji Electromechanical Technology Co. , Ltd.

**Address:** No. 1858, Kaiming Road, Lai zhou, Yantai, Shandong Province

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