Wadkin

POWER BAND RIPSAW

MODEL "C" RANGE

OPERATING & INSTRUCTIONS MANUAL

OPERATING AND INSTRUCTION MANUAL

FOR

C RANGE

&

POWER BAND RIPSAW

Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual

BOOK No.B.684

PLEASE INSERT SERIAL NUMBER OF MACHINE

'C' range

and

Power Band Ripsaw.

600Ø

Specification

	C5	C6	C7	C8	C9
Diameter of Wheels	500mm 19.7in	600mm 23.6in	700mm 27.5in	800mm 31.5in	900mm 35.5in
Width of Saw Blade (max)	25mm 1in	30mm 1.18in	40mm 1.6in	40mm 1.6in	45mm 1.8in
Length of Saw Blade (max)	4166mm 164in	4496mm 177in	5080mm 200in	5538mm 218in	6310mm 248in
Length of Saw Blade (min)	4013mm 158in	4343mm 171in	4902mm 193in	5360mm 211in	6110mm 240in
Depth under Saw Guide	410mm 16.14in	470mm 18.5in	485mm 19in	530mm 20.75in	600mm 23.5in
Maximum cut width	480mm 18.9in	580mm 22.8in	680mm 26.7in	780mm 30.7in	780mm 34.75in
Speed of motor. 50Hz	3000rev/min	3000rev/min	3000rev/min	3000rev/min	3000rev/min
Speed of motor. 60Hz	3600rev/min	3600rev/min	3600rev/min	3600rev/min	3600rev/min
Power of motor	1.5kW 2hp	2.25kW 3hp	3kW 4hp	4kW 5.5hp	5.5kW 7.5hp
	*2.25kW 3hp	*3kW 4hp	*4kW 5.5hp	*5.5kW 7.5hp	
Size of table	500×700mm 19.7×27.5in	600×830mm 23.6×32.7in	765×1000mm 30×39in	765×1100mm 30×43in	765×1200mm 30×47in
Height of table	850mm 33.5in	850mm 33.5in	900mm 35in	955mm 37in	1000mm 39in
Floor space	550×890mm 21.7×35in	600×1020mm 23.6×40.6in	770×1340mm 30×52.7in	770×1340mm 30×52.7in	770×1440mm 30×56.7in
Weight (approximately)	220kg 485lb	260kg 573lb	483kg 1064lb	508kg 1120lb	533kg 1176lb
Speed of Saw Blade	1500m/min 5000ft/min	1500m/min 5000ft/min	1500m/min 5000ft/min	1500m/min 5000ft/min	1500m/min 5000ft/min
Table Tilts (standard)	0-45°	0-45°	0-35°	0-35°	0-35°

OPTIONAL EXTRAS.

TELESCOPIC TOP SAWGUARD
SAW TENSION INDICATOR
RIP FENCE
MITRE FENCE
FOOT BRAKE
H.P. MOTOR
ELECTRICAL INTERLOCKING FOOTBRAKE
BOTTOM GUIDE

FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES,
CONTACT:- WADKIN CLEVELAND (Divison of Wadkin Limited)
NORTH LIVERTON INDUSTRIAL ESTATE
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SALTBURN-BY-THE-SEA
CLEVELAND
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MACHINE PARTS INDEX

HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

WADKIN LTD., supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the user's responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.

2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.

3. Only personnel trained in the safe use of a machine should operate it.

4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.

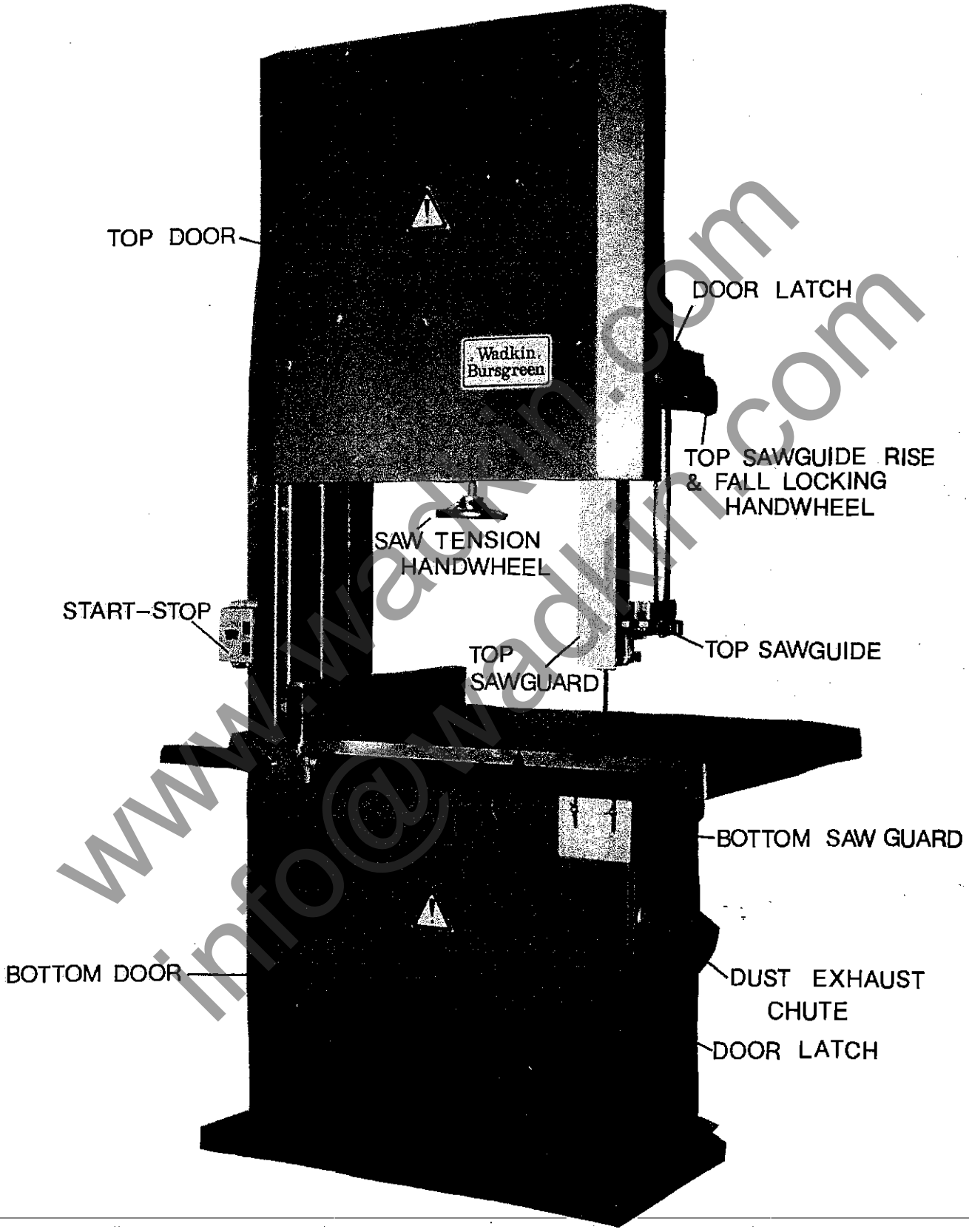
5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

SAFETY

1. Read Instruction Book.
2. Securely Lock Cutters.
3. Set Guards Correctly.
4. Select Correct Speed.
5. Use Feeding Devices Where Possible.
6. Electrically Isolate Machine During Maintenance & Setting Up Operations.
7. Refer To HSW Booklet No.41. (in UK) For Safety In The Use Of Woodworking Machinery.

500mm & 600mm Bandsaws
Types C5 & C6



BANDSAW SLINGING INSTRUCTUIONS.

To lift bandsaw proceed as follows:-

1. Open top door of machine.

2. Position minimum length sling of 5 metres (16 feet) around top frame and behind top wheel as shown in PHOTO 1 and PHOTO 2.

   NOTE:- To prevent damage to sling and frame, place rages between slings and machine as shown.

3. Secure door to top sawguide rise and fall locking handwheel by strong cord as shown in PHOTO 3.

4. Proceed to slowly lift bandsaw ensuring that bandsaw is not titling at an angle.

IMPORTANT: A MINIMUM LENGTH SLING OF 5 METRES (16 FEET) WITHIN THE SAFE WORKING LOAD MUST ALWAYS BE USED.

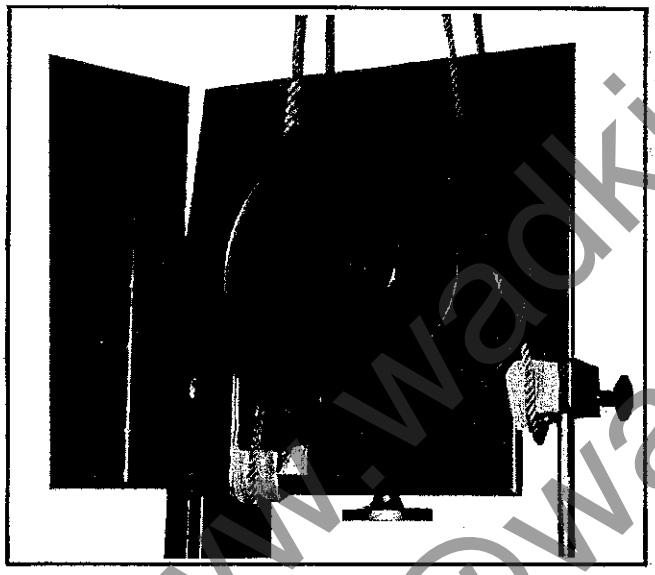


PHOTO 1

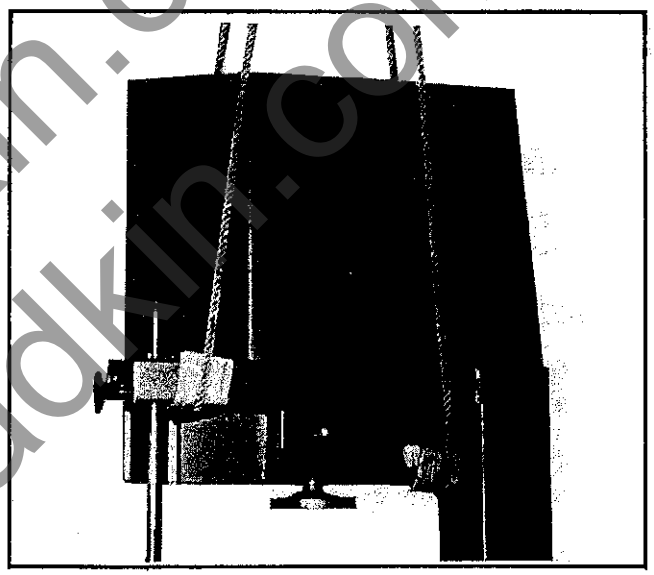


PHOTO 2

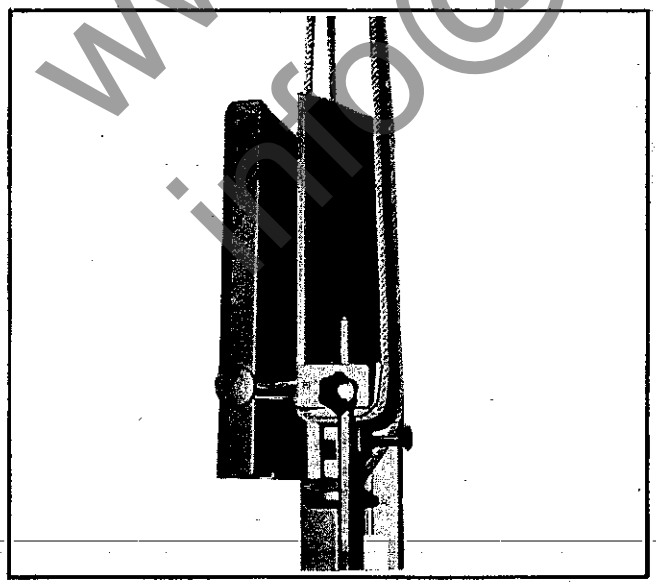


PHOTO 3

INSTALLATION.

Remove protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.
When the machine is cased for export, the top cover, top door, top wheel and table are removed and packed individually.
Re-assemble machine as follows:

1. Secure top cover "A" FIG,1, to top of main frame by bolts "B".

2. Fit top wheel to spindle and secure by 1 - bolt and flange washer, see FIG,2.

3. Locate top door on hinges, FIG.3, and bottom door on hinges, FIG,4.

4. Position table on main frame quadrant and secure by 4 - bolts and washers "A", FIG,5. (Table removed for export only).

FOUNDATION.

See enclosed foundation drawing for bolt positions and clearance required.
When installing machine, level by packing under base. Foundation bolts are not supplied with the machine except by special order.

WIRING DETAILS.

The motor and control gear have been wired in before despatch. All that is required is to connect the powsr supply to the starter.

Points to note when connecting to power supply.

1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.

2. It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.

3. Check the main line fuses are of the correct capacity. i.e.4.1 F.L.A. of motor.

4. Connect the line leads to the appropriate terminals.
See Foundation Drawing for Wiring details.

5. Check all connections are sound.

6. Check the rotation of the motor for the correct direction.
If this is incorrect, reverse any two of the line lead connections.

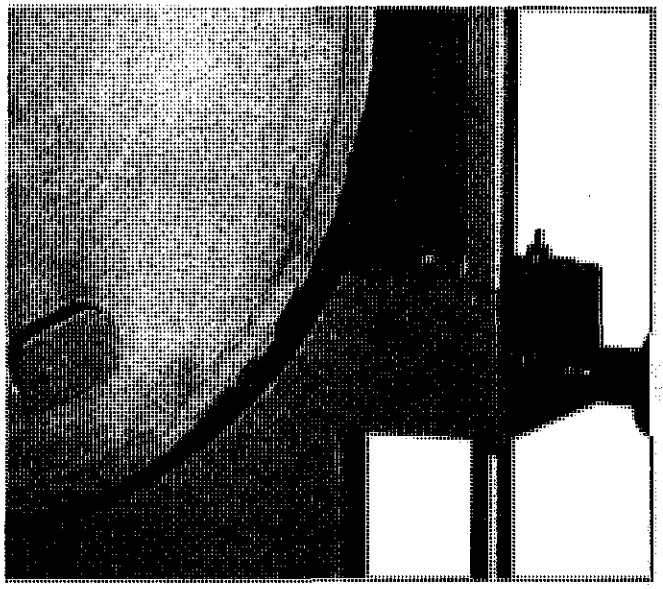


FIG 1

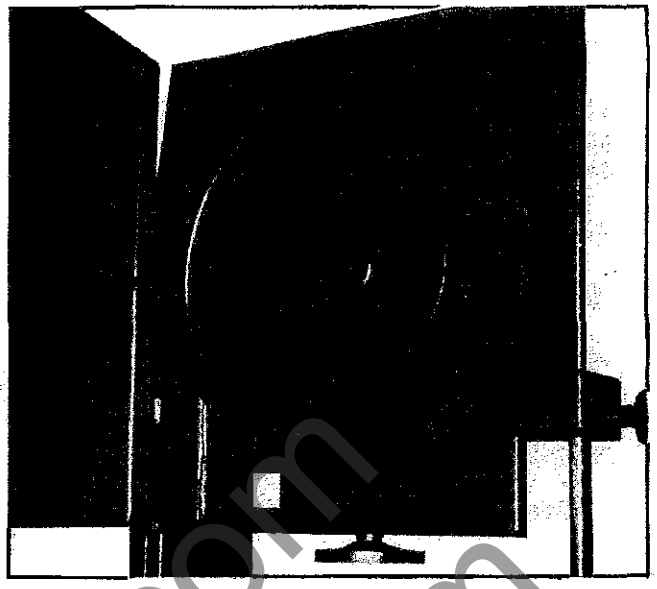


FIG 2

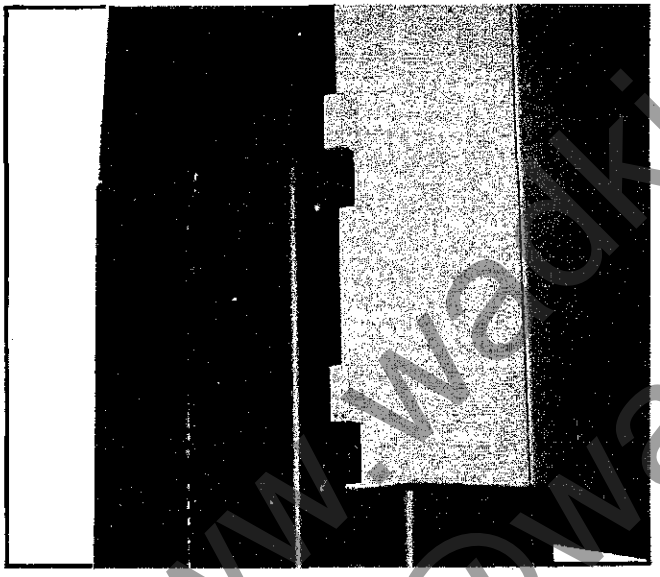


FIG 3

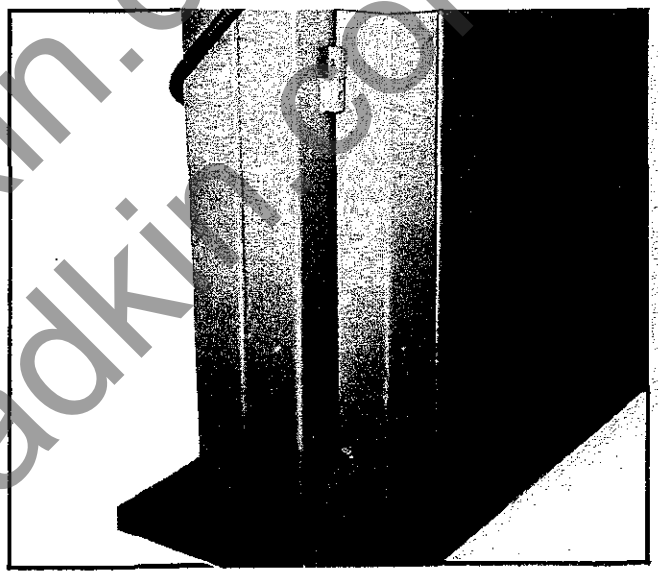


FIG 4

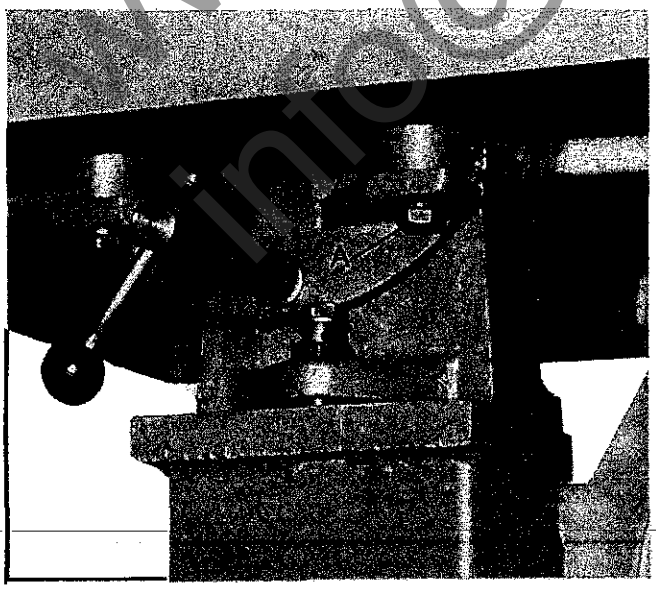


FIG 5

LUBRICATION.

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting. Clean sawdust from inside main frame weekly.
See enclosed Foundation Drawing for lubrication points.

Type fo Grease Recommended: CASTROL SPHEEROL AP.3. or equivalent.

DUST EXTRACTION.

The machine has a built in dust chute with a 100mm dia. exhaust outlet and can be connected to main dust extraction plant if desired.

FITTING BANDSAW BLADES.

1. Isolate machine electrically.

2. Open top and bottom doors of main frame.

3. Loosen cap head bolts "A", FIG.6. and remove sawguard "B".

4. Loosen thumb screw "A", FIG.7, and move guide "B" to extreme rear position.

5. Lower top wheel assembly by handwheel "A", FIG.8, sufficient to allow blade to be fitted to both wheels.

6. Insert blade through slot "A", FIG.9, and through slot in table then position blade on top and bottom wheels.

   NOTE:Cutting rake of teeth should be pointing down at cutting point. If teeth are not pointing down, turn blade inside out.

7. Turn tensioning handwheel "A", FIG.8, until blade is just held on the wheels.

8. Proceed to track sawblade as explained on Page.12.

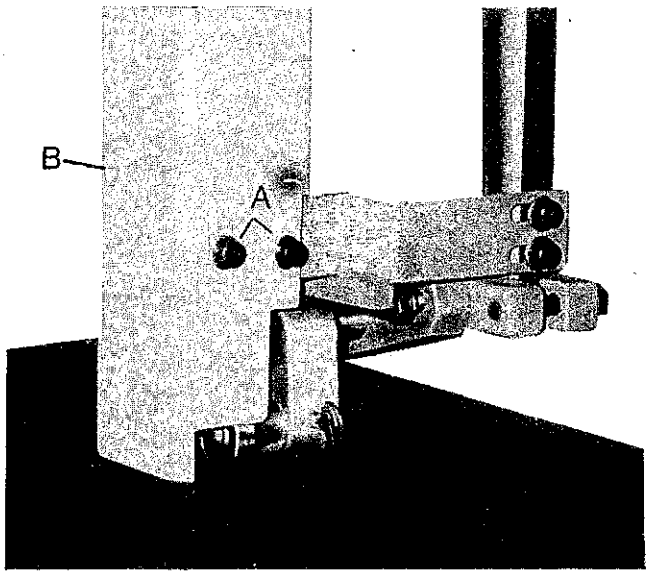


FIG 6

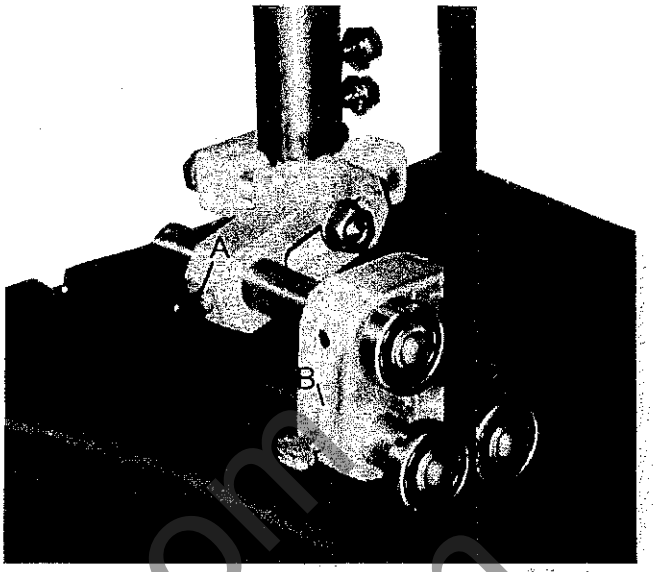


FIG 7

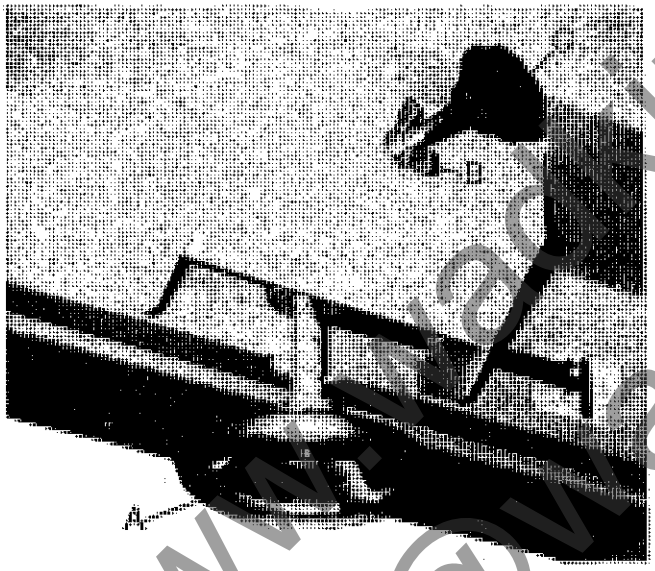


FIG 8

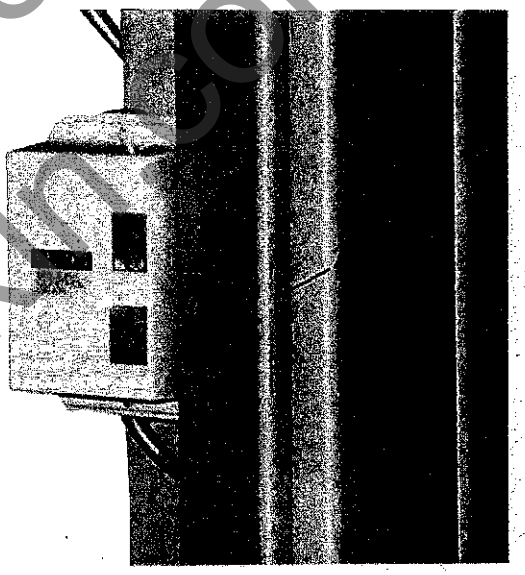


FIG 9

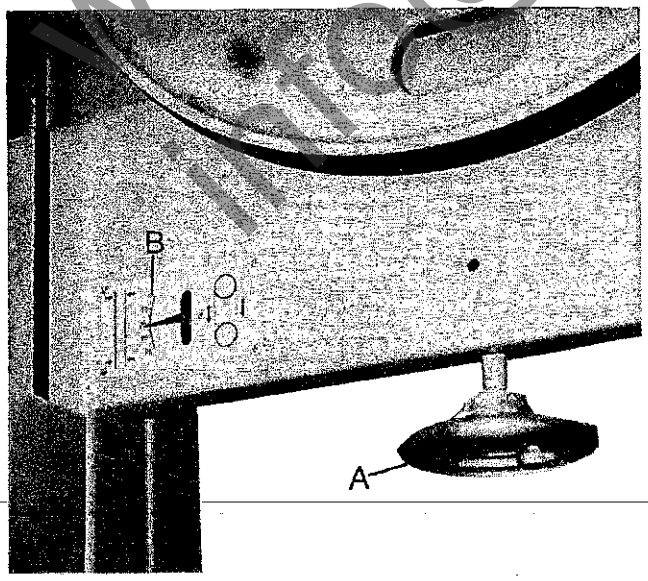


FIG 10

TRACKING OF SAWBLADE ON WHEELS.

Every sawblade has different running characterisitcs on a bandsaw machine due to

TRACKING OF SAWBLADE ON WHEELS.

Every sawblade has slightly different running characterisitics on a bandsaw machine due to the condition of the steel ribbon from which the blade is made, the blade joints and tension in the blade ribbon. This is compensated by using a crowned or slightly curved tyre on the wheel and providing the top wheel with slight tilting adjustment.
To check the tracking of sawblade, follow the undermentioned procedure:

1. Isolate machine electrioally.
2. Open top and bottom doors.
3. Rotate the top wheel slowly by hand in a clockwise direction and check the blade is running central on the wheels.
4. If not running central, loosen wingnut "B", FIG.8, then turn handwheel "C" untill saw is tracking correctly, i.e. in the centre of both wheels.
5. When tracking is correct, tighten wingnut "B". This adjustment is most important, that the sawblade, when tracking correctly, passes in a straight line between top and bottom wheels and does not snake, - when the latter occurs, the back of the sawblade keeps hitting the back guide roller and

DANGER: DO NOT TRACK BLADE WITH MOTOR RUNNING.

TENSIONING SAWBLADE. (Without tension scale).

The sawblade should always be tensioned correctly to achieve maximum blade life. Over-tension of blade could result in saw damage.
To tension blade correctly, proceed as follows:

1. Isolate machine electrically.
2. Turn handwheel "A" FIG.8, until blade can be pulled 6mm ($\frac{1}{4}$") from its true line at central point between wheels. Blade is then tensioned correctly.

TENSIONING SAWBLADE USING SCALE (EXTRA).

The sawblade should always be tensioned correctly to achieve maximum blade life. Over-tension or under-tension could result in saw damage.
To tension blade correctly, proceed as follows:

1. Isolate machine electrically.
2. Open top door of machine.
3. Turn handwheel "A", FIG.10, until pointer on scale "B" points to the corresponding width of blade being used.
   Blade is then tensioned correctly.

ADJUSTMENT OF SAWBLADE TENSION SCALE (EXTRA).

The scale and pointer are accurately set before despatch from the works. Should this be displaced for any reason, check the scale by the undermentioned procedure:

1. Isolate machine electrically.
2. Tension the sawblade as previously disoribed until it can be pulled $\frac{1}{4}$" (6mm) from its true line at a central point between the two wheels.
3. Check that scale indicates oorrect sawblade width. If scale is incorrect, tension sawblade to maximum tension by handwheel "A", FIG.11.
   NOTE: For safety, the blade used during this adjustment must be wider than 1" (25.4mm).
4. When maximum blade tension is attained, loosen M8 socket head grubscrew "B" Then move coller "C" until pointer on scale indicates maximum blade width of $1\frac{1}{2}$" or 40mm.
   When set, relock M8 grubscrew "B".
5. Turn tension handwheel "A" until scale corresponds to width of blade fitted.
   NOTE: When scale has been set using above procedure it will read correctly for any width of blade within the range of the machine without further alteration, even if length of sawblade varies for any given width.

For a 20mm wide blade, the pointer should read 20, etc.
If the machine is left standing for a period, e.g. overnight, the tension should be reduced, and the blade re-tensioned before putting the machine into operation again.

SETTING TOP SAWGUIDE UNIT.

A sawguide unit "A", FIG.12, is fitted above the table and is fully adjustable for adequate sawblade support. The unit is fitted with ~~TEFLON support blocks and a long life bearing~~.

NOTE: A similar guide unit for below the table can be supplied as an optional extra.

To set top guide assembly, proceed as follows:

1. Isolate machine electrically.
2. Loosen caphead screws "B", FIG11, and remove sawguard "C".
3. Loosen grubscrew "A" and M10 nut "B", FIG.12. then position guide body "C" central and parallel to blade SEE FIG.13, then tighten up grubscrew "A" and M10 nut "B", FIG.12.

   NOTE: Once the guide has been initially set up, adjustment as described in paragraph 4 should only be necessary.

4. Slacken thumb screw "Y" FIG.12, and set rear guide roller 1/64" clear of back of blade, lock up thumb screw "Y".
5. Slacken thumb screws "X" FIG.12, and move side guide foreward as positioned in FIG.14, then pivot side guide rollers on anti lock eccentrics just clear of blade FIG.13, and lock thumb screws "X"

   NOTE: It is important that side guide rollers do not nip blade are set just clear.

6. Refit sawguard "C", FIG.11 and secure with caphead "B".

TO VERTICALLY ADJUST TOP GUIDE UNIT, PROCEED AS FOLLOWS:

1. Isolate machine electically.
2. Hold guide assembly "A", FIG. 15, then loosen handwheel "B".
3. Position guide assembly "A" as required then relock handwheel "B".

SETTING BOTTOM SAWGUIDE UNIT IF FITTED AS OPTIONAL EXTRA.

The bottom sawguide unit is fitted below the machine table and is set using similar procedure to top sawguide unit.

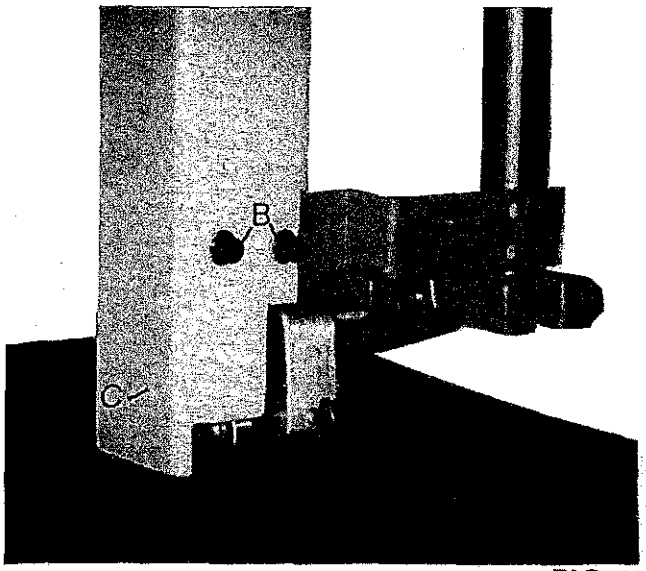


FIG 11

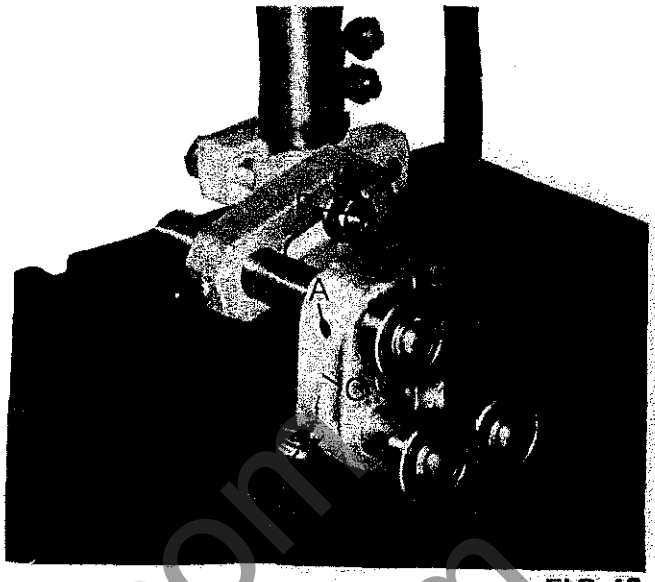


FIG 12

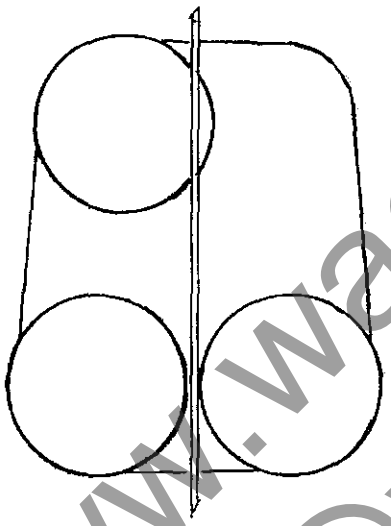


FIG 13

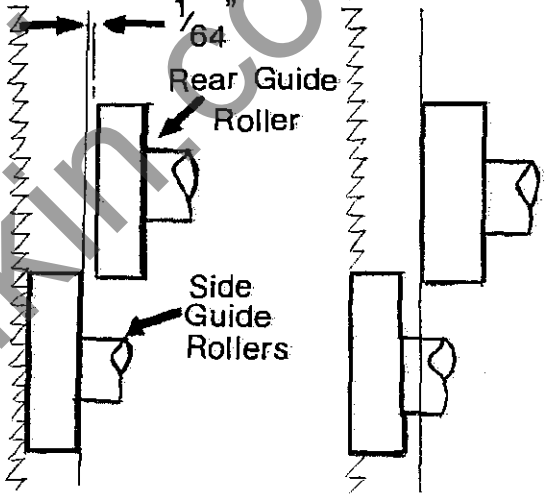


FIG 14

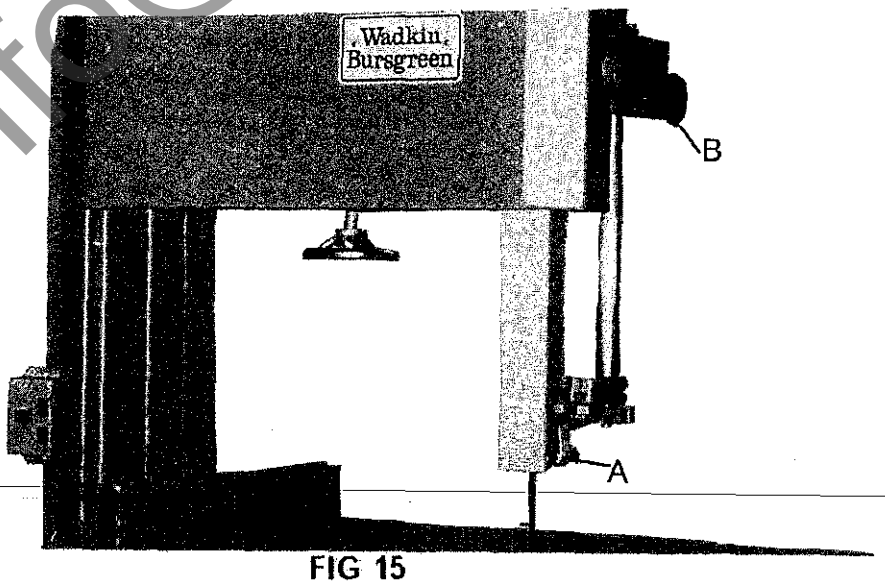


FIG 15

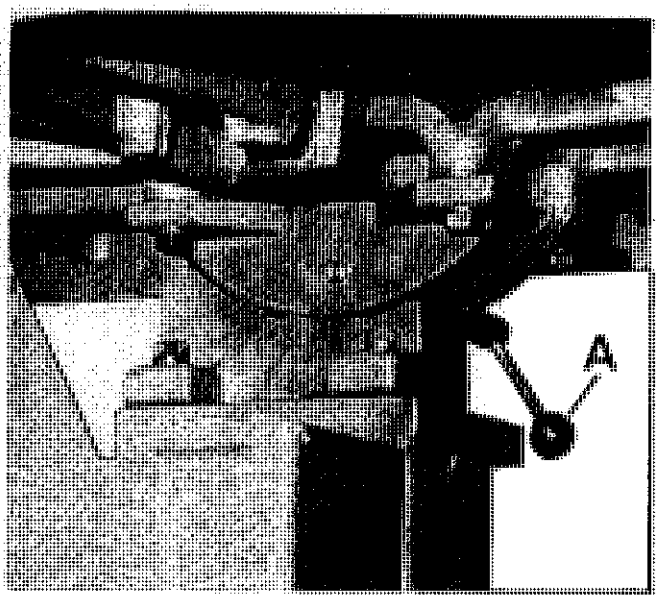


FIG 17

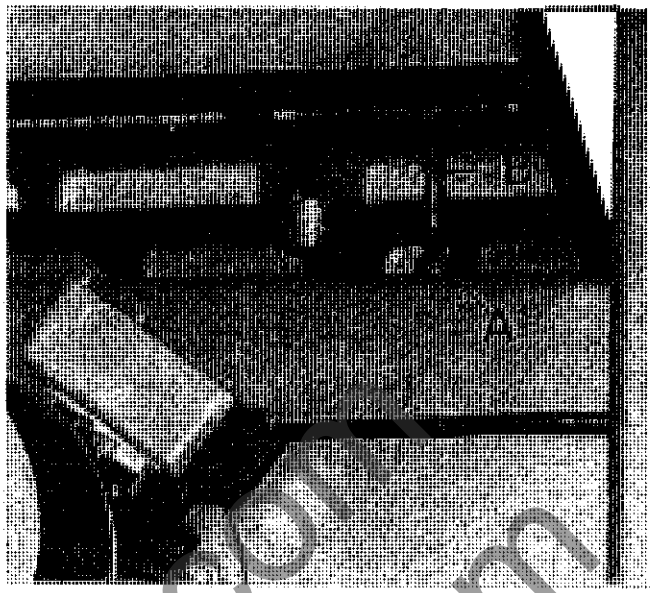


FIG 18

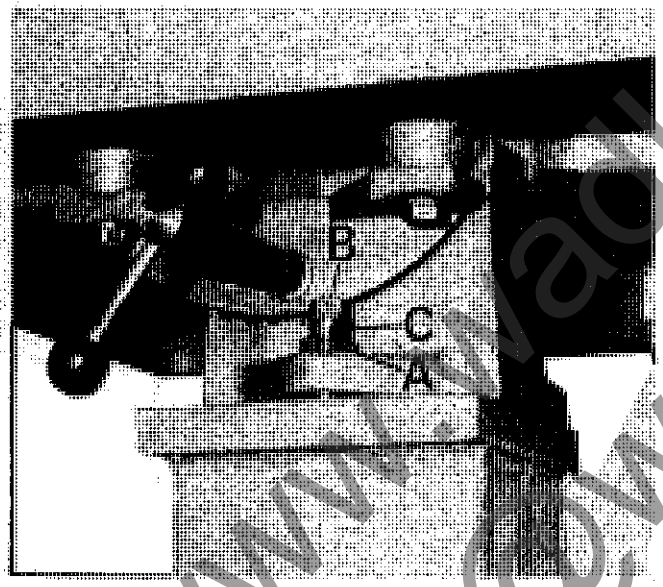


FIG 19

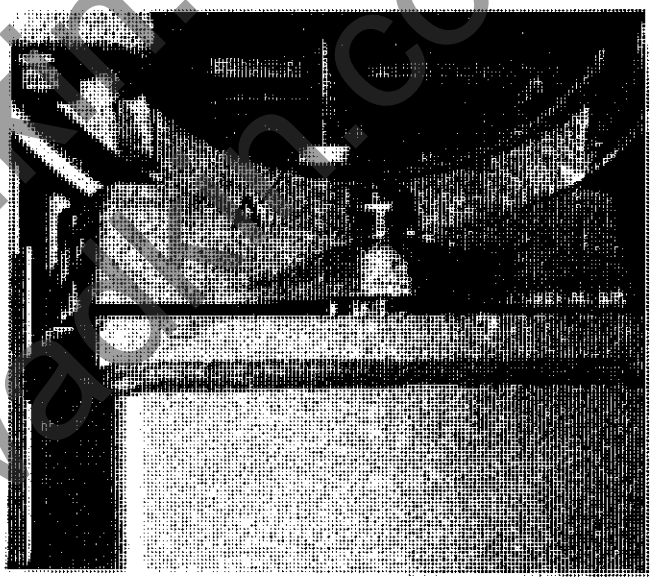


FIG 20

TABLE.

The table cants to the right.
To cant table proceed as follows:

1. Support table weight.
2. Loosen lever "A" Fig.17. (C5 & 6) Loosen Nut "A" FIG.20. (C7,8, & 9).
3. Cant table to required angle.
4. Relock "A".

TABLE 90° POSITIVE STOP ADJUSTMENT.

The table 90° positive stop is set correctly before despatch from the works but should this setting be disturbed for any reason, follow the undermentioned procedure:

1. Isolate machine electrically.
2. Ensure top guides (and bottom guides if fitted) are clear of the blade, so it is not restricted in any way.
3. Check blade is square to table by means of a steel square.
4. If adjustment is necessary, loosen lever "A",FIG.17, and M12 Locknut "A".FIG.18.
5. Set table square to sawblade by the steel square then relock lever "A",FIG.17.
6. Turn screw "B",FIG.18, until it locks against undersids of table then relock M12 Locknut "A".

TABLE SQUARE TO SAWBLADE ADJUSTMENT.

The table is set square to sawblade, from front to rear, before despatch from works. Should this setting be disturbed for any reason, check the following:

1. Isolate machine electrically.
2. Ensure top guide (and bottom guides if fitted) are clear of sawblade so blade is not restricted in any way.
3. Check blade is tracking correctly, i.e. running in the centre of each wheel, (Ses Tracking of Sawblade instructions, page 12.)
4. Check blade for square to table by means of a steel square.

If adjustment is necessary, proceed as follows:

1. Loosen M20 Locknut "A",FIG.19, and M10 bolt "B".
2. Insert small toggle (not supplied) into holes in M20 adjusting screw "C" and turn screw "C" until table is set square to sawblade.
3. When table is set square to sawblade, tighten M10 bolt "B" and M20 locknut "A".
4. Reset top guide (and bottom guide if fitted).

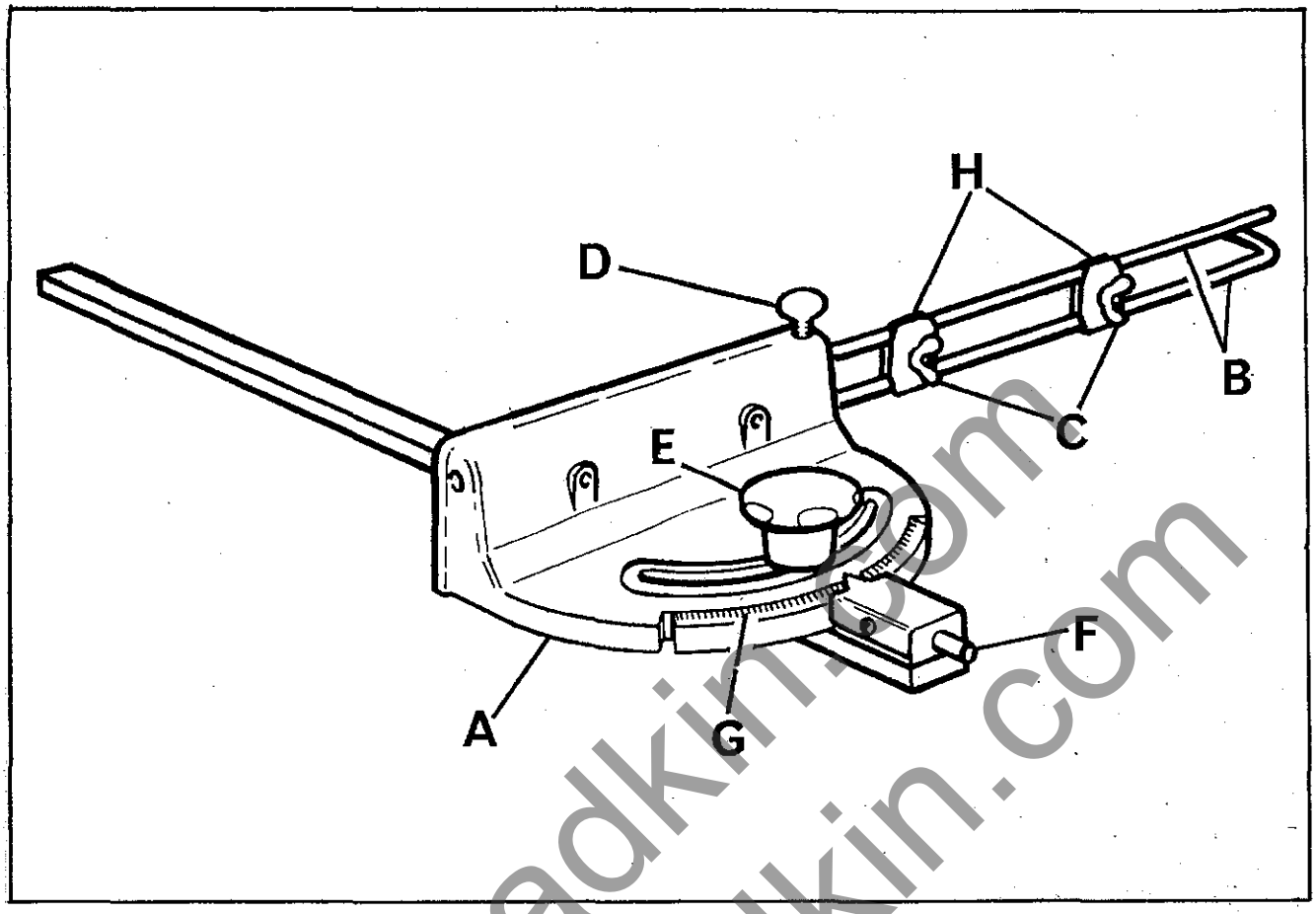


FIG 21

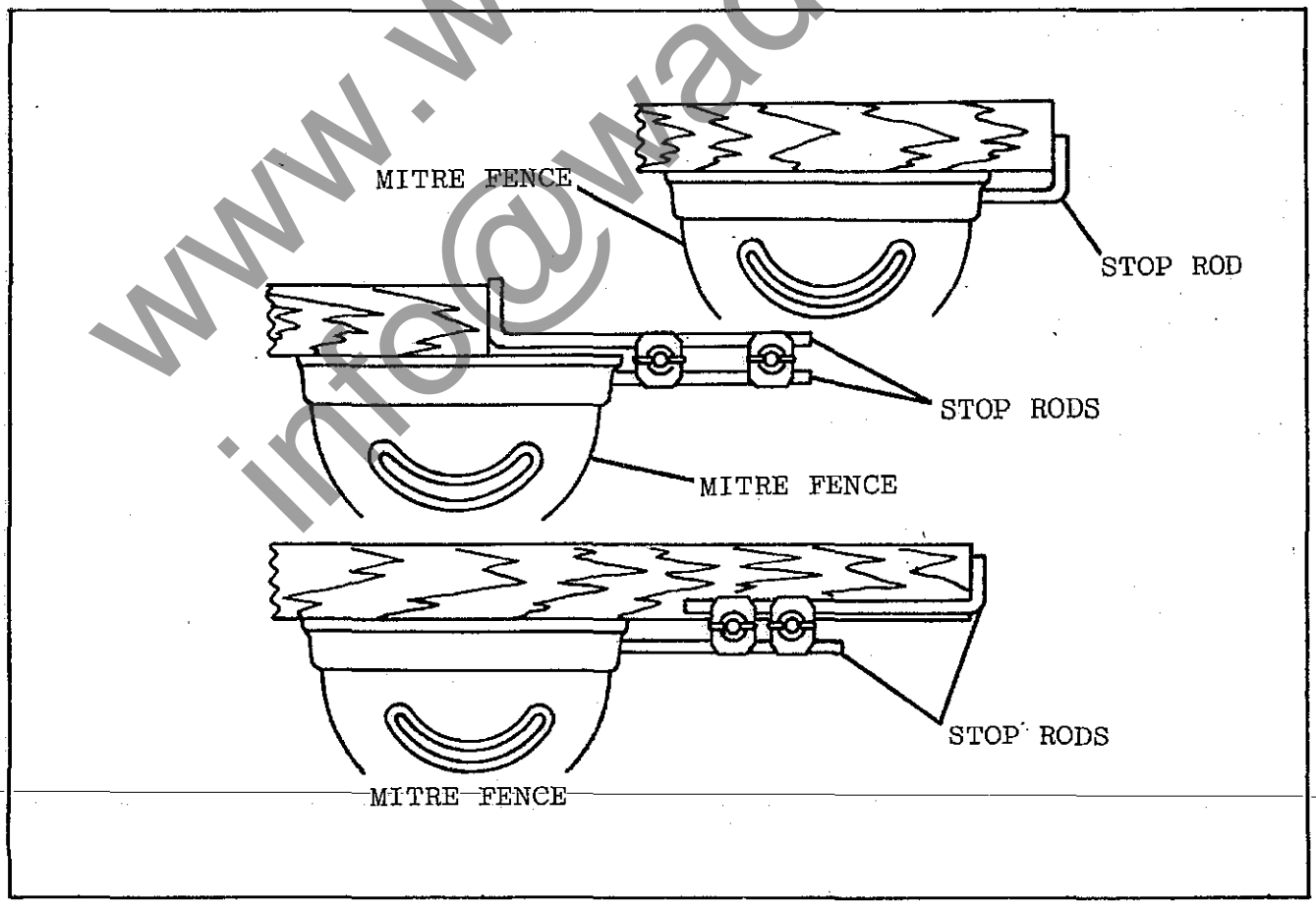


FIG 22

RIP FENCE (EXTRA).

A rigid rip fence FIG.20, is mounted on a round slide bar fitted to edge of table. This fence can be mounted to rip either to inside or outside of bandsaw blade.

MITRE FENCE (EXTRA, SUPPLIED WITH MACHINE BY SPECIAL ORDER).

The mitre fence "A" in FIG.21. slides in the table slot. Two stop rods "B" are held together by two clamps "H" and wingnuts "C". The stop rods are secured to fence body by thumbscrew "D".
NOTE: Always ensure the stop rods are set clear of the sawblade or serious damage will result when machine is operated.

The mitre fence can be rotated through 90° with positive stops at 90° and 45°. To position mitre fence at required angle, loosen handwheel "E" in FIG.21, then pull plunger "F" from location, position fence as required using scale "G" then relook handwheel "E".

NOTE: Always ensure table slot is clear when using mitre fence.

MITRE FENCE STOP RODS. (EXTRA)

Accurate repetitive cutting can be made using the stop rods, see FIG.22.
The rods are held in the fence by the thumbscrew "D" in FIG.21, and the stop rods held together by the two clamps "H".
To adjust the rods by the clamps, loosen the wingnuts "C".

STARTING - STOPING.

Start and Stop buttons are situated on the column of machine as shown in FIG.23.

FOOTBRAKE (EXTRA).

A footbrake is situated in the base of the machine as shown in FIG.24.
NOTE: Always press "STOP" button before depressing footbrake.

SAW WHEELS

Isolate machine electrically, and clear top and bottom tyres daily to prevent accumulation of sawdust which could cause blade to run from true line.

Badly worn tyres should be replaced, as worn tyres cause saw vibration resulting in uneven sawing and saw breakages.

In order to achieve best results the urethane stretch on tyres should be spot glued at intervals of 8" to 10" around peripheral diameter.

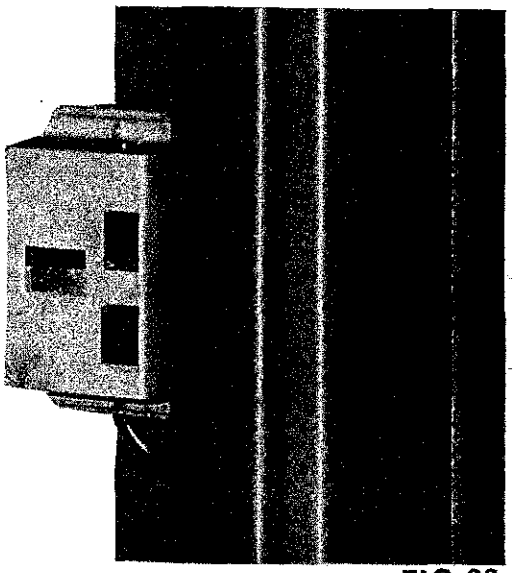


FIG 23

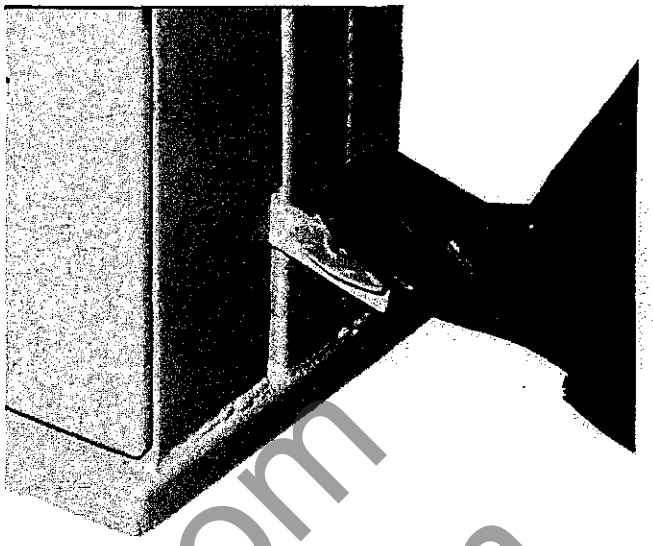


FIG 24

FIG 25

FIG 26

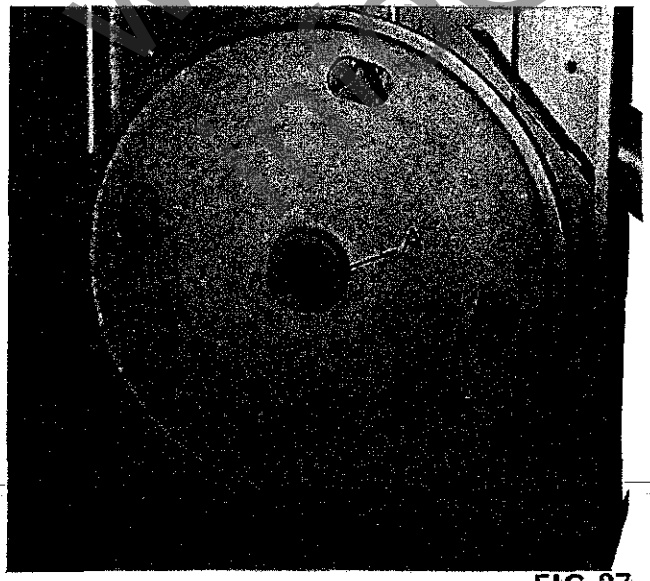


FIG 27

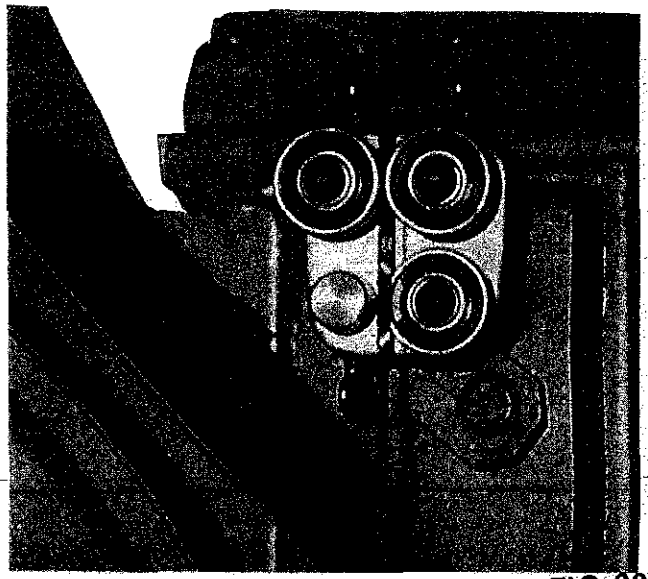


FIG 28

REMOVAL OF TOP SAW WHEEL.

To remove top saw wheel proceed as follows:

1. Isolate machine electrically.
2. Open top and bottom doors of main frame.
3. Remove bandsaw blade by reversing procedure for "Fitting Bandsaw Blade", Page.10.
4. Remove bolt and washer from centre of top wheel, FIG,25.
5. Manually support weight of wheel and carefully pull wheel from spindle.

REMOVAL OF BOTTOM SAW WHEEL.

To remove bottom saw wheel, proceed as follows:

1. Isolate machine electrically.
2. Open top and bottom doors of main frame.
3. Remove bandsaw blade by reversing procedure for "Fitting Bandsaw Blade", See Page.10.
4. Loosen 2 - M12 nuts "A", FIG.26, and M12 locknut "B".
5. Turn M12 nut "B" anti-clockwise, releasing belt tension sufficient enough for belt to be removed from pulley.
6. Remove bolt and washer "A", FIG,27, from centre of bottom saw wheel.
7. Manually support weight of saw wheel and pull wheel from spindle.

BELT TENSION.

Incorrect tension is the major cause of premature belt failure, some of its effects are as follows:

1. Under-tensioning results in incorrect driven speed caused by belt slip; this can be corrected by increasing tension.
2. Over-tensioning can be more serious. Apart from obvious damage to the belt, it can cause overheated, damage or burned out motor front end bearings. This is usually preceeded by excessive stretch or too many take ups.

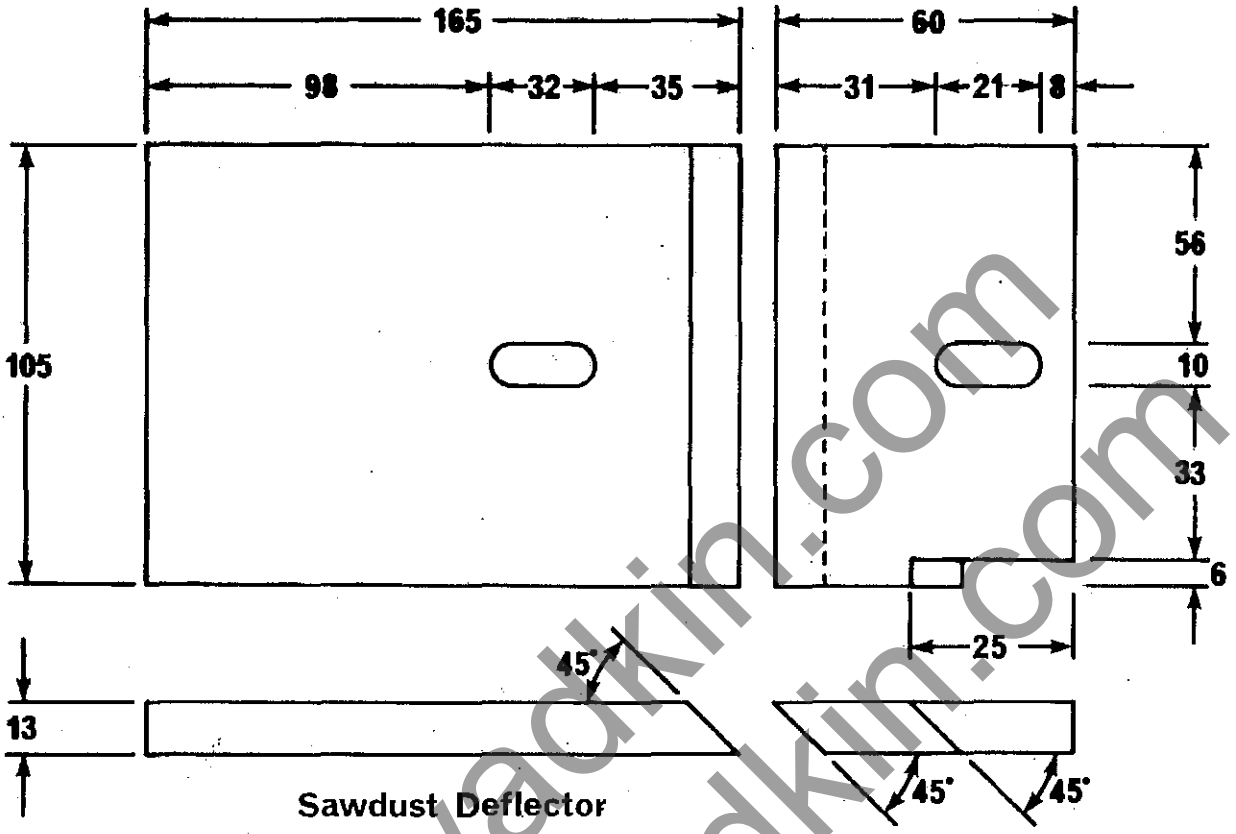
The POLY-V drive belt is correctly tensioned before the machine leaves the works.

After a period of time, the belt may start to slip due to run-in stretch and should be retensioned correctly as in "Belt Tension Adjustment".

BELT TENSION ADJUSTMENT.

TO TENSION POLY-V-BELT, PROCEED AS FOLLOWS:

1. Isolate machine electrically.
2. Open bottom door of machine.
3. Loosen 2 - M12 nuts "A", FIG.26.
4. Loosen M12 locknut "B".
5. Turn M12 nut "B" to point where belt slackness is just eliminated from pulleys. (Note: To feel belt, place hand behind wheel).
6. Turn M12 nut "B" clockwise 2 full turns when correct belt tension should be attained.
7. Relock M12 locknut "B" abd 2 - M12 nuts "A".
8. Close bottom door of machine.



Sawdust Deflector

FIG 29

SAWDUST DEFLECTOR.

When machine is operating, most of the sawdust will be passed out via the dust exhaust outlet but inevitably some dust will be carried down with the blade causing a gradual sawdust accumulation in the machine base. This sawdust acoumulation can be slowed down considerable by fitting a sawdust deflector near to the dust exhaust outlet as shown in FIG.28. These 2 sawdust deflector pads can be easily made from wood following the drawing FIG.29.B.
When fitting to machine, move deflector pads as close to blade as possible without touching blade then secure in position by 2 - hexagon head screws and washers.

MAINTENANCE OF BANDSAW BLADES.

A properly sharpened bandsaw blade will give clean, accurate cutting and this is achieved by proper setting and sharpening of the teeth. Always set the teeth before sharpening.

SETTING.

In order to cut satisfactorily, bandsaw teeth must be set by bending teeth alternately out of the line of the blade. This presents alternate pairs of teeth, wider than the thickness of the ribbon and prevents the ribbon rubbing in the wood being cut and overheating. There are two usual ways of setting bandsaw teeth depending generally upon the amount of work to be done.

1. Hand Setting. See FIG.30.

The points of the teeth are set by using a hand setting tool of the plier type. The points only of the teeth must be set and as a general rule the set on each side is .010" (.3mm). Set is applied in opposite directions for each alternate tooth.
Where hand setting is employed, it cannot be ensured that all the teeth are cutting, and in order to overcome this, the teeth should be stoned occasionally. An ordinary fine grit stone is used and the back runner guides should be temporarily brought forward until it is in contact with the back of the blade. The blade should then be run and the stone carefully applied to the teeth each side of the blade. When the saw is subsequently sharpened, it will be noted that each tooth has not been marked with the stone, and such teeth should only be filed very slightly. The remainder of the teeth which have actually been stoned should be filed in the normal manner until the flat caused by the stone disappears. Bandsaws may require stoning approximately once to every six sharpenings.

2. MACHINE SETTING.

A setting attachment can be supplied to special order for fitting, to the standard grinding machine. This attachment is shown under Bandsaws and Accessories in the rear of this manual.

SHARPENING.

This is normally done by using a triangular section file.
Again, this operation can be done by hand or machine.

HAND FILING. FIG.31.

It is essential to employ an efficient and quick acting vice and round cornered triangular file, both as illustrated in FIG.37. and FIG.38.
The face of each tooth should be filed across, and with the same strike the back of the following tooth should be filed at the same time. One stroke of the file should be sufficient to sharpen each tooth, and this stroke should be as light as possible in order to avoid producing a burr. The shape of the gullet is automatically maintained at 60° by the file. Which the angle of the hook on the tooth is depandable on the position of the file. For general work, approximately 5° of positive hook should be given. A greater or smaller hook should be applied for soft or harder woods respectively. In the case of particularly hard woods, a negative rake may be necessary, while a wider tooth pitch than standard may be required for sawing timbers of an abrasive nature, and those containing gum. Always sharpen squares across the face of each tooth and NOT on the bevel, otherwise the saw will vibrate violently, which shatters the steel and cracks appear causing saw breakages.
Use a file with rounded corners and of triangular section. It is important to keep the gullet of each tooth rounded otherwise cracks will soon appear. Saws must be sharpened at regular intervals and should never be forced to cut with teeth which have become blunt.
NOTE: WHEN RECONDITIONING BANDSAW BLADES, IT IS NECESSARY TO SET THE TEETH FIRST BEFORE SHARPENING.
This ensures that the face of the tooth is square. If the sharpening was carried out first, the subsequent setting would result in an angular tooth shape being obtained.

MACHINE FILING.

An automatic machine for filing blades is shown under Bandsaws and Accessories in the rear of this manual and can be supplied by special order.

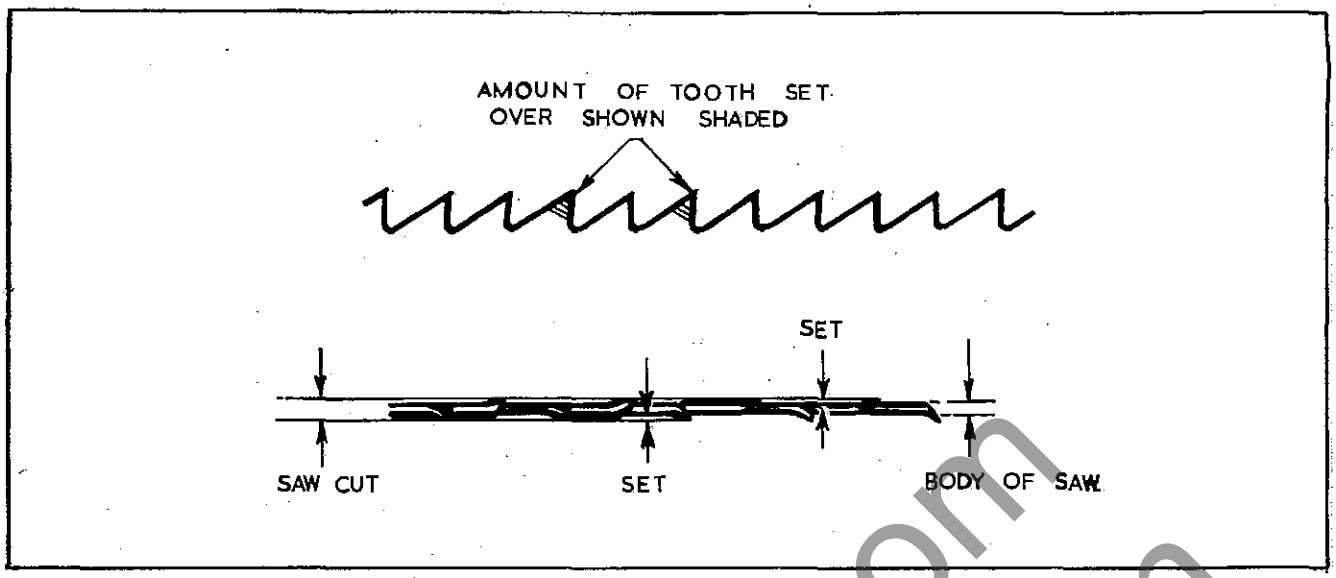


FIG 30

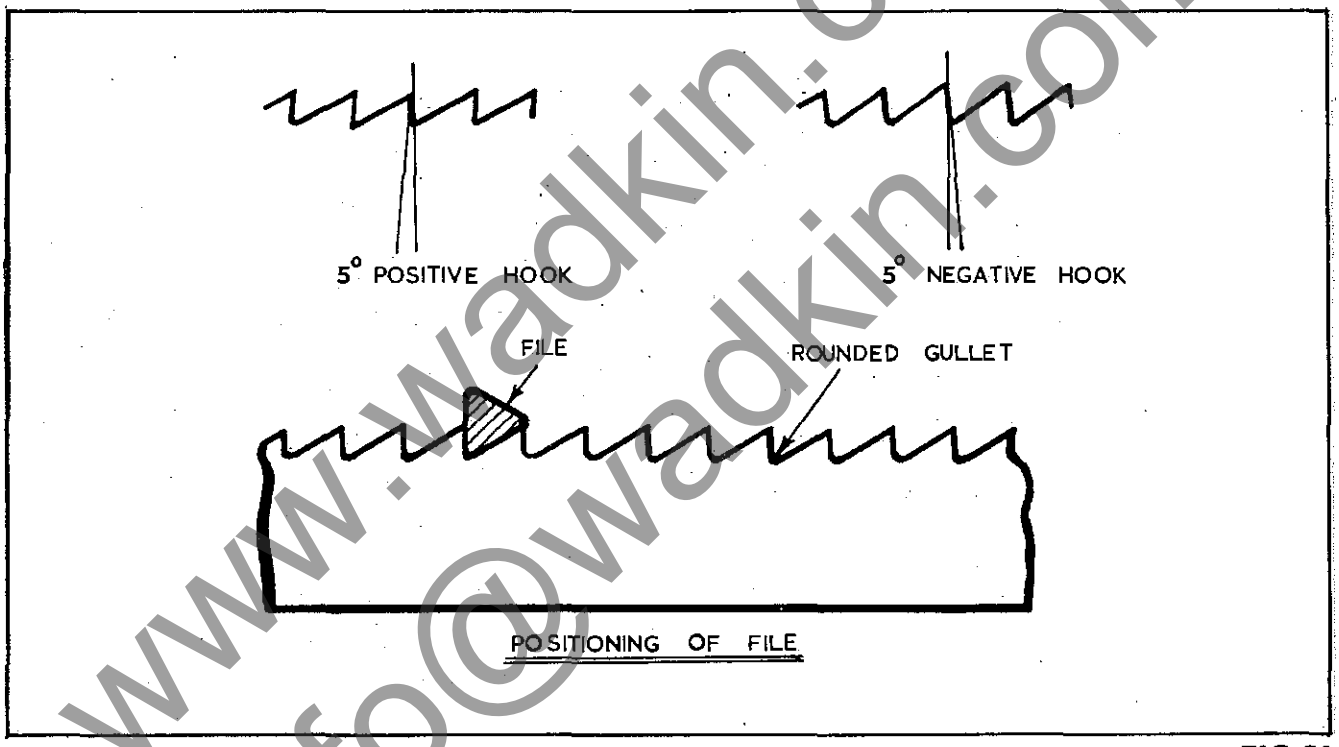


FIG 31

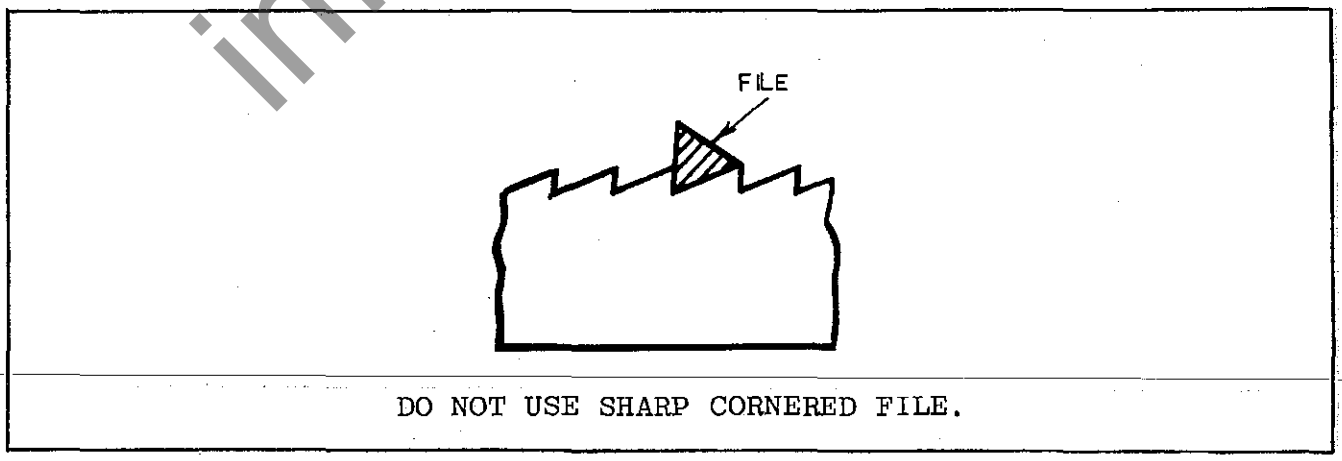


FIG 32

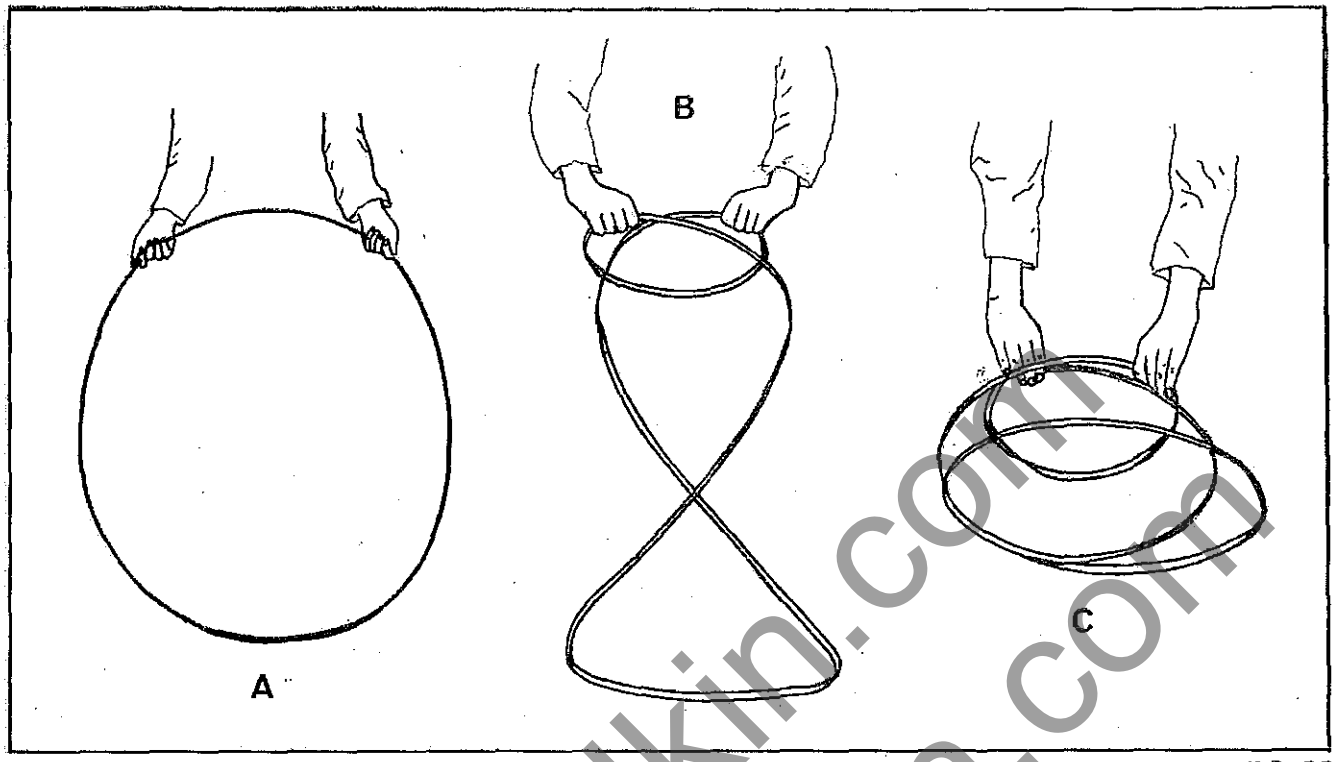


FIG 33

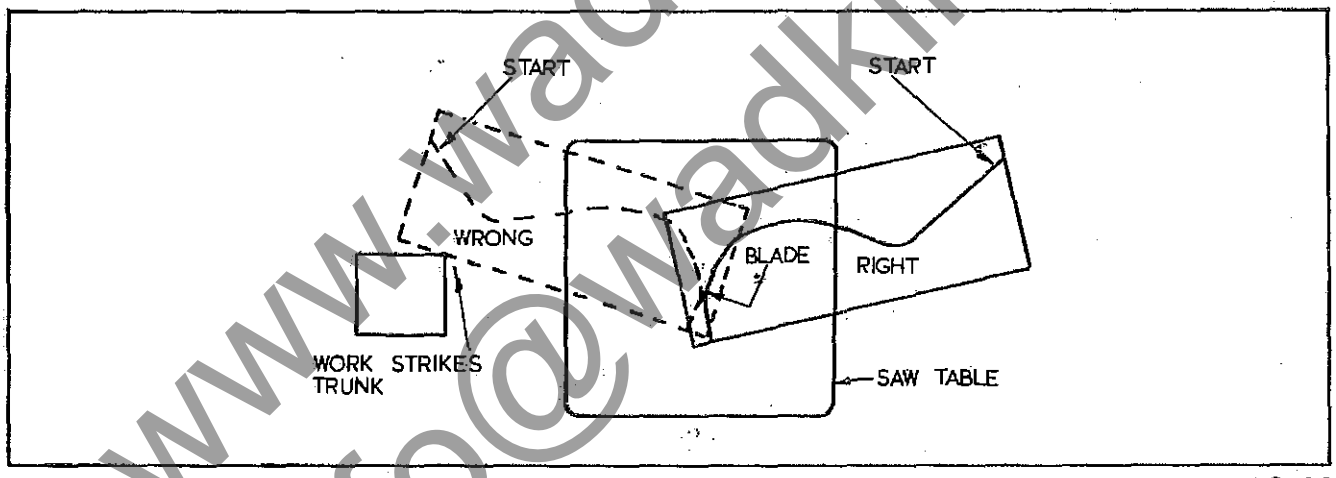


FIG 34

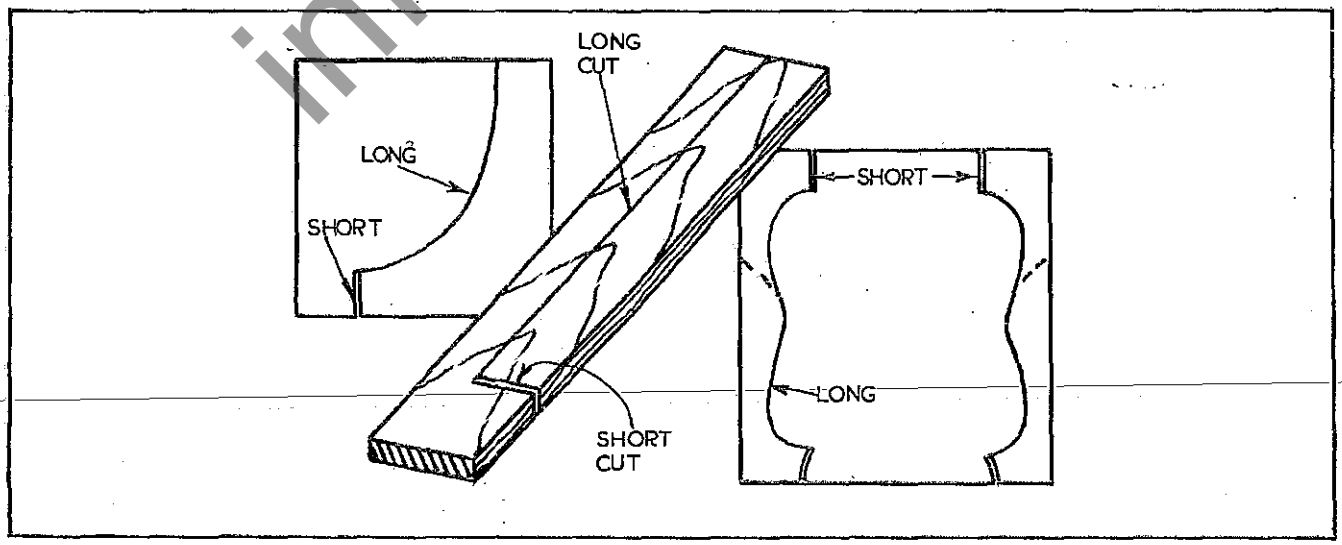


FIG 35

GENERAL CAUSES OF SAW TROUBLE.

1. Crystallisation of the ribbon, produced by the back of the saw rubbing against the back runner guide. The disc should revolve only by contact with the back edge of the saw when actually cutting.
2. Using a blade that is too wide for the radii being cut. In attempting to cut a small curve with a saw too wide, the blade tends to twist against the guides causing friction and overheating which destroys the temper in the steel.
3. Not enough set.
4. Sharpening with a sharp cornered file. See FIG.32.
5. Bad brazing due to dirty joints or badly prepared laps or incorrect positioning of the laps, causing a bump on the back of the blade at the joint. See Bandsaw and Accessories at the rear of this manual for an efficient bandsaw brazer.

SMALLEST RADII WHICH MAY BE SAWN WITH GIVEN WIDTH OF BLADE.

Width of Blade	3mm	5mm	6mm		10mm
Minimum Radius	3mm	8mm	16mm	37m	37mm
Width of Blade	13mm	16mm	19mm		25mm
Minimum Radius	64mm	95mm	138mm		184mm

FOLDING BANDSAW BLADES.

Bandsaw blades are folded in thirds. This is done by holding the blade firmly in both hands with the palms upwards as shown in FIG.33. Turn the hands over, this will twist the blade, as shown in FIG.33. Do not let blade slip or turn in the hands. The blade will almost automatically fall into three loops.
THE BLADE SHOULD BE KEPT IN A SAFE DRY PLACE.

BANDSAW BRAZING.

An efficient bandsaw brazing machine is shown under "Bandsaws and Accessories" in the rear of this maual and can be supplied by special order.

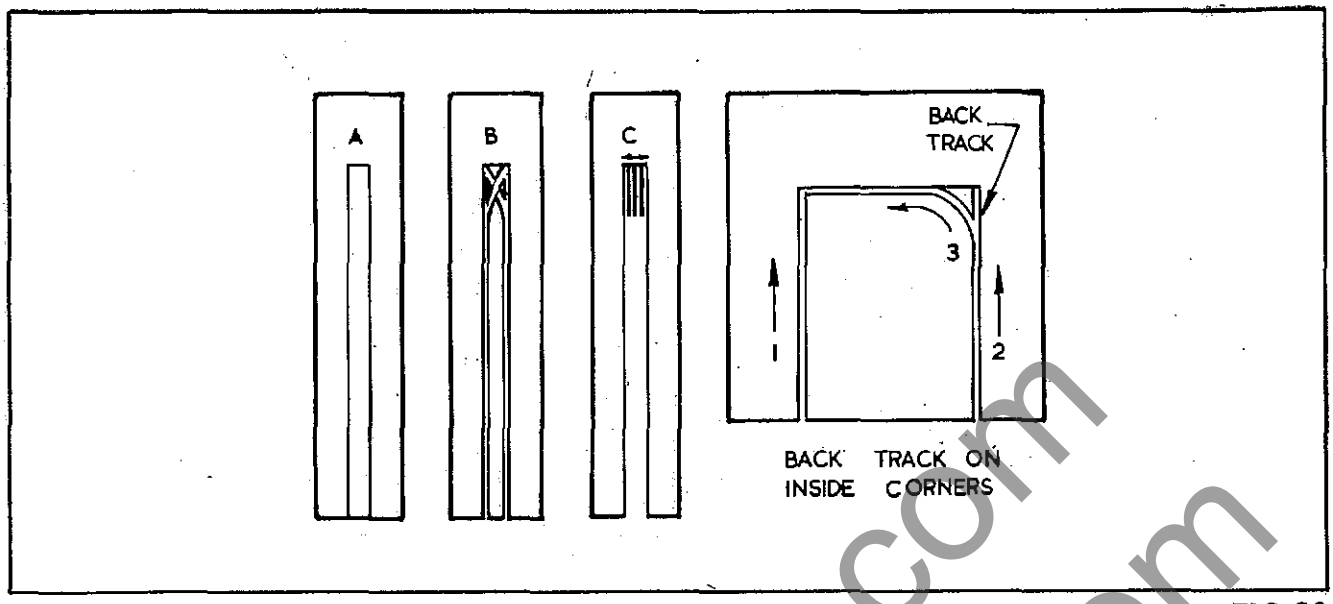


FIG 36

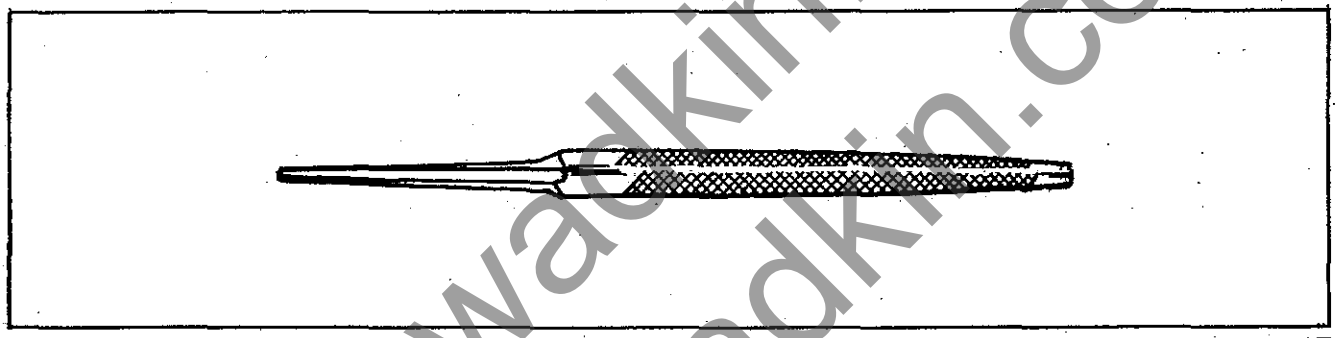


FIG 37

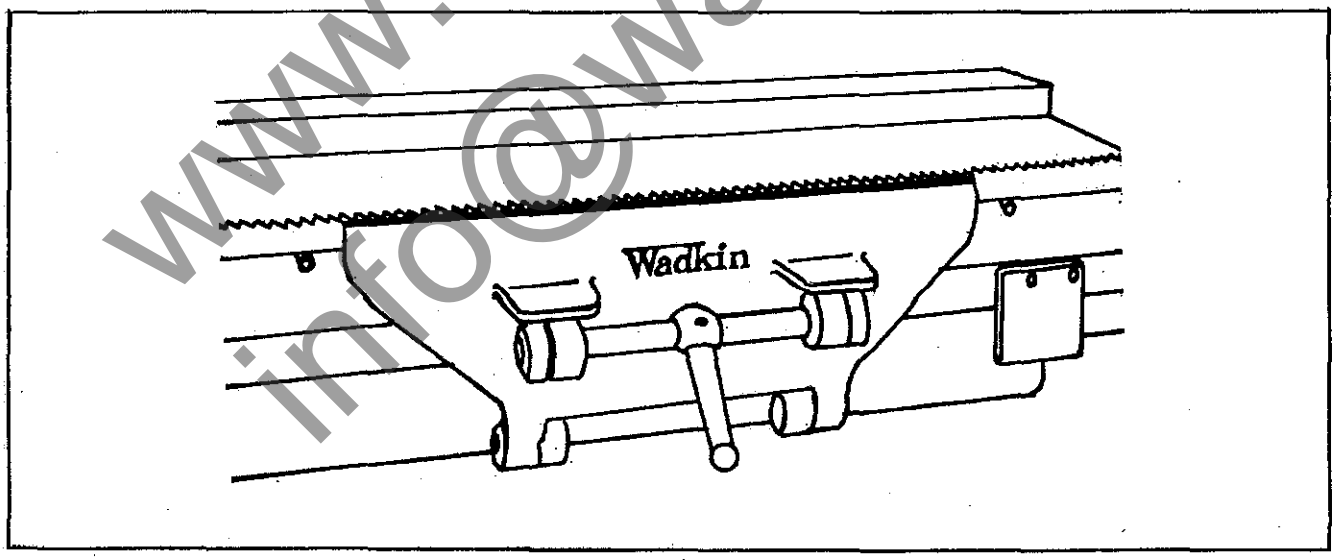


FIG 38

HINTS ON CUTTING.

1. Watch Feed Directions SEE FIG.34.

Mentally follow the path of the cut before actually cutting the work. If not started properly many pieces of work will foul against the trunk of the machine.

2. Make Short Cuts First SEE FIG.35.

When a choice of starting points is offered, always make short cuts first. Back tracking out of a short cut can be done much more quickly than backing out of a long cut.

3. Backtrack on Corners. SEE FIG.36.

Very narrow grooves must be nibbled as shown at A, B, C. On other inside corner ans then backtrack to lead the blade over to second line.

BANDSAW BLADES.

Spare bandsaw blades of the correct lenght, ready set and sharpened, for wood cutting are available from stock. Where it is preferred, bandsaw blading in strip form can be supplied for customers to make up their own blades. This bandsaw strip is offered either toothed only or toothed, sharpened and set. In addition to woodcutting, we can supply bandsaw blades for plastics, bonded wood, non-ferrous metals, meat, ect, provided that the correct machine speeds are available.

TAPER TRIANDGULAR FILES FOR HAND USE.

Length.....6", 8", 10".

The edges of these files have rounded corners to produce the round gullet which prevents saw cracks.

BANDSAW BLADES.

C5 Standard Bandsaw Blade, 4165mm (13ft.8ins) long.
C6 Standard Bandsaw Blade, 4500mm (14ft9¼ins) long.
C7 Standard Bandsaw Blade, 5080mm (16ft.8ins) long.
C8 Standard Bandsaw Blade, 5535mm (18ft.2ins) long.
C9 Standard Bandsaw Blade, 6300mm (20ft.8ins) long.

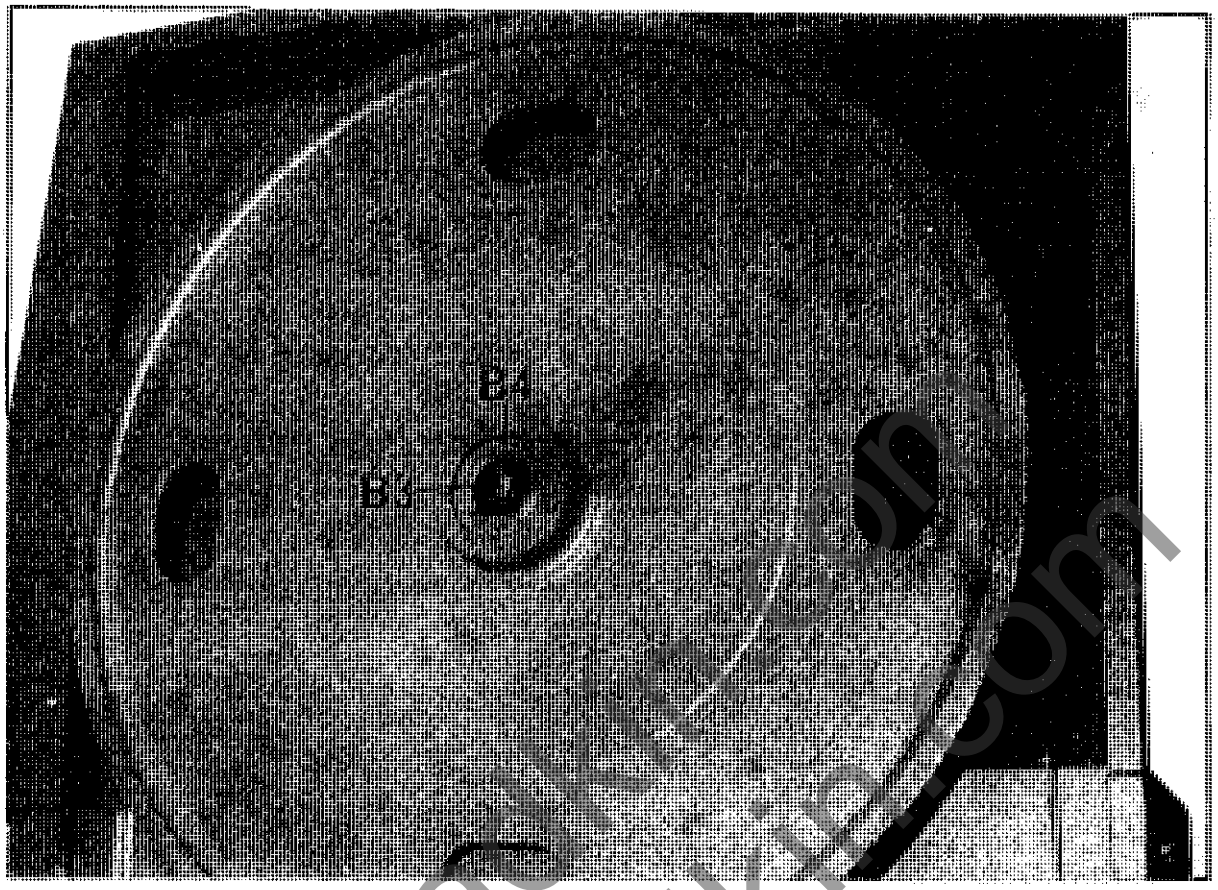
C5 Starrett Bandsaw Blade (Hardened Teeth) 4165mm (13ft.8ins) long.
C6 Starrett Bandsaw Blade (Hardened Teeth) 4500mm (14ft.9¼ins) long.
C7 Starrett Bandsaw Blade (Hardened Teeth) 5080mm (16ft.8ins) long.
C8 Starrett Bandsaw Blade (Hardened Teeth) 5535mm (18ft.2ins) long.
C9 Starrett Bandsaw Blade (Hardened Teeth) 6300mm (20ft.8ins) long.

The starrett bandsaw blade are hard edge flexible backed wood or metal cutting long life blades.

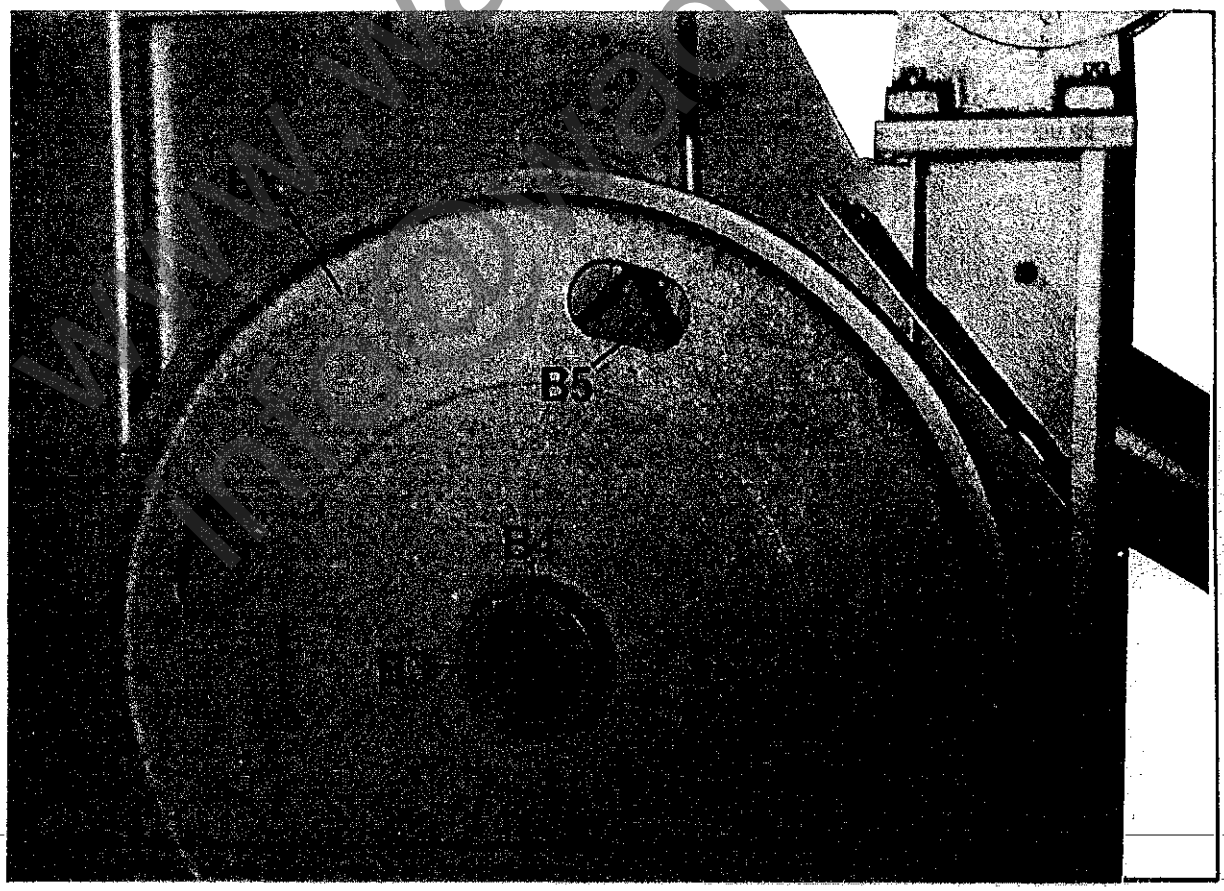
NOTE:- These blades can't be re-sharpened as they have hardened teeth.

BASE TOP COVER AND DOORS ASSEMBLY.

REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
A1	C5/24	1	Top doors (C5)
	C6/18	1	Top doors (C6)
	C7/25	1	Top Doors (C7)
	C8/28	1	Top Doors (C8)
	C9/23	1	Top Doors (C9)
A2	BH7/181	2	Boor locking cam
A3	C8/71	2	Stud for door catch
A4		2	M8 aerotight nut
A5	BH7/163	2	Top hinge pin
A6	BH7/201	2	Bottom hinge pin
A7	C5/25	1	Bottom Door (C5)
	C6/19	1	Bottom Door (C6)
	C7/28	1	Bottom Door (C7)
	C8/29	1	Bottom Door (C8)
	C9/24	1	Bottom Door (C9)
A8	C5/26	1	Top cover (C5)
	C6/20	1	Top cover (C6)
	C7/22	1	Top cover (C7)
	C8/19	1	Top cover (C8)
	C9/21	1	Top cover (C9)
A9		3	M6 nut
A10		3	6mm washer
A11	C5/28	1	Top guide adjusting plate
A12		3	(C5) M12 x 20 long hexagon head screw
		4	(C6) M12 x 20 long hexagon head screw
		4	(C7 8 & 9) M12 x 20 long hexagon head screw
A13	BH7/199	4	Washer for door hinge
A14		1	M8 x 16 long socket head capscrew
A15		4	12mm washer
A16		4	12mm washer
A17	C5/3	1	Main frame (C5)
	C6/8	1	Main frame (C6)
	C7/3	1	Main frame (C7)
	C8/7	1	Main frame (C8)
	C9/3	1	Main frame (C9)

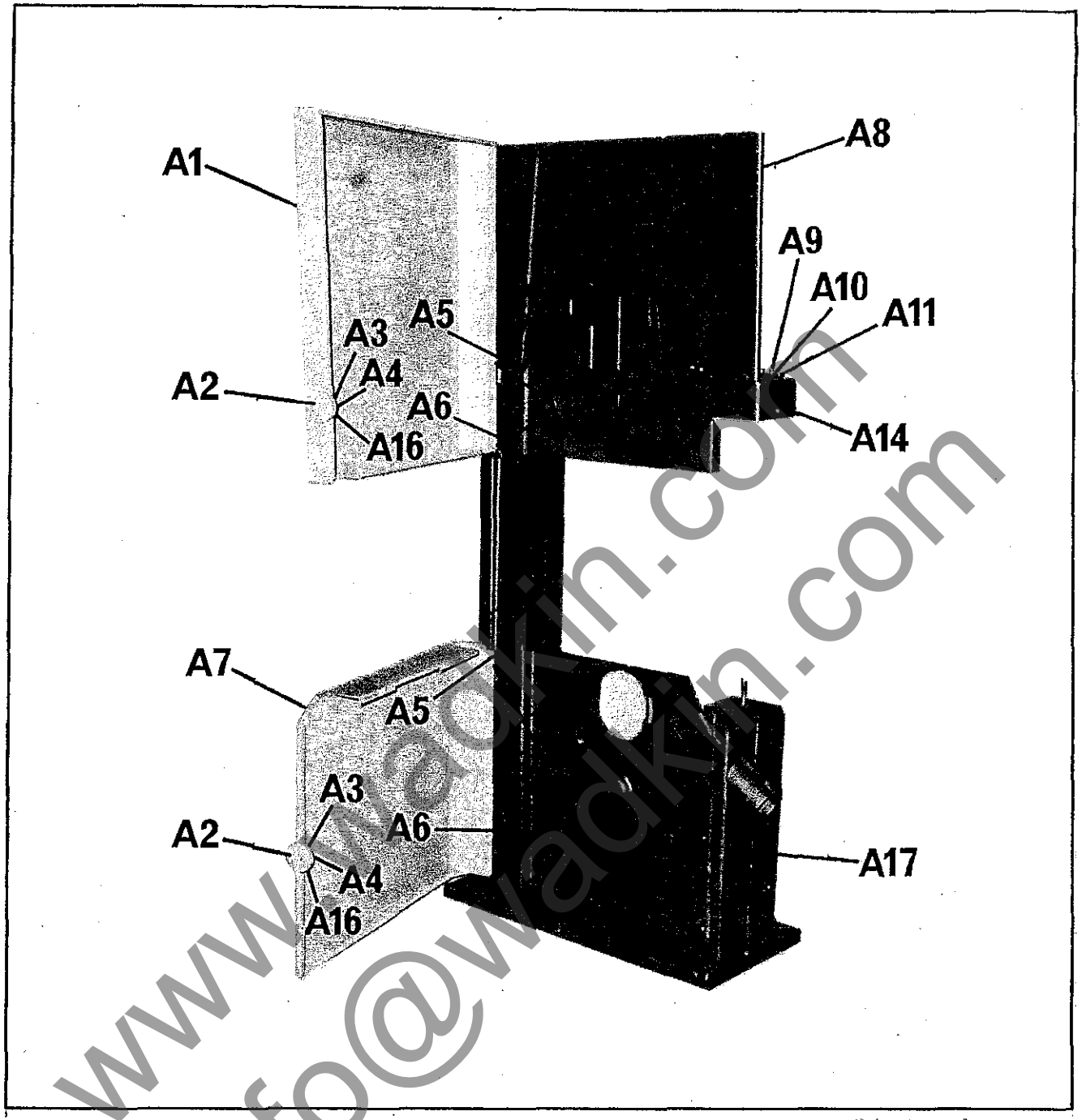


WHEELS AND BELT



FENCE ASSEMBLY.

REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
C1	C5/33	1	C5 Fence bar (Extra)
	C6/22	1	C6 Fence bar (Extra)
	C7/37	1	C7 Fence bar (Extra)
	C8/39	1	C8 Fence bar (Extra)
	C9/40	1	C9 Fence bar (Extra)
C2	C8/38	2	Fence bar distance piece (Extra)
C3		2	M10 nut (Extra)
C4	C8/68	2	Stud for fence (Extra)
C5	C5/61	1	Table insert (C5 &6)
	C8/147	1	Table insert (C7 & 8 & 9)



BASE, TOP COVER AND DOORS ASSEMBLY.

WHEELS AND BELTS

REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
B1	C5/1	1	Top Wheel (C5)
	C6/1	1	Top Wheel (C6)
	C7/1	1	Top Wheel (C7)
	C8/1	1	Top Wheel (C8)
	C9/1	1	Top Wheel (C9)
B2	C5/2	1	Bottom Wheel (C5)
	C6/2	1	Bottom Wheel (C6)
	C7/2	1	Bottom Wheel (C7)
	C8/2	1	Bottom Wheel (C8)
	C9/2	1	Bottom Wheel (C9)
B3	C5 & 6	2	M10 x 25 long hexagon bolt
	C7 & 8	2	M12 x 30 long hexagon bolt
	C9	2	M16 x 30 long hexagon bolt
B4	C5/29	2	Wheelwasher (C5 & 6)
	C8/37	2	Wheelwasher (C7 & 8)
	C9/51	2	Wheelwasher (C9)
B5	470L4	1	Poly Vee Belt (C5 & 6)
	525L6	1	Poly Vee Belt (C7 & 8)
	580L6	1	Poly Vee Belt (C9)

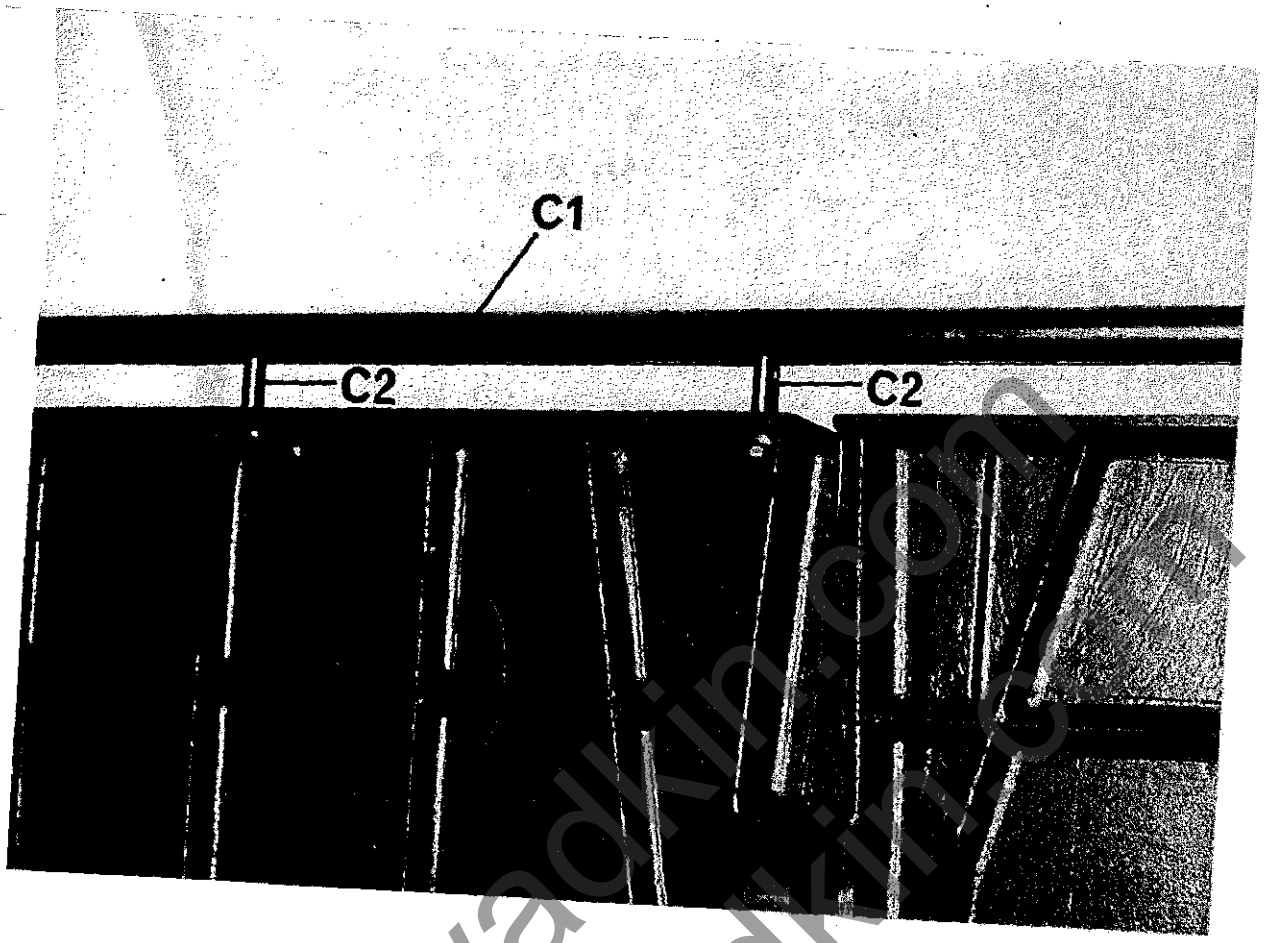
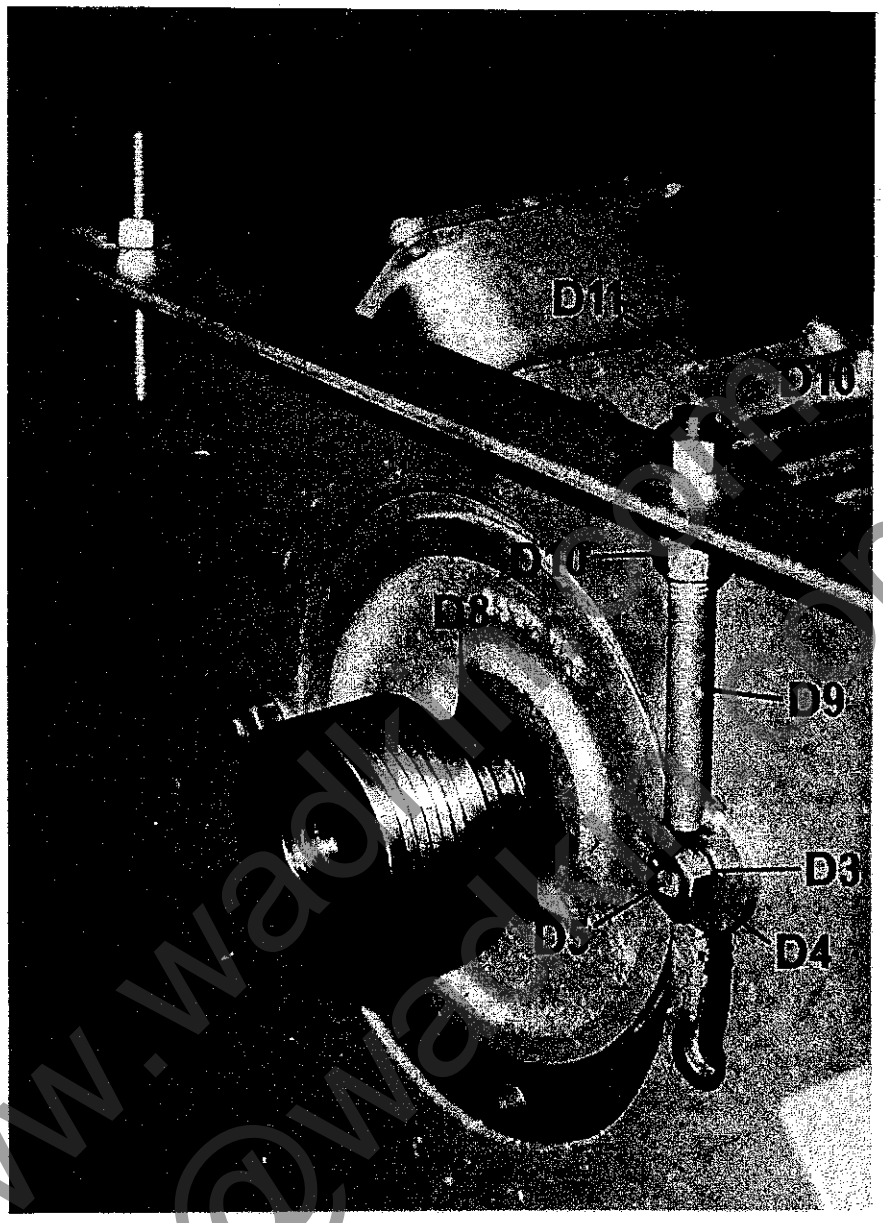


TABLE ASSEMBLY.

MOTOR MOUNTING ASSEMBLY.

REF.NO.	PART.NO.	NO.OFF.	DESCRITPION.
D1	C8/48	1	Table support stud
D2		1	M12 nut
D3		4	M10 washer (C5 & 6)
		4	M12 washer (C7 8 & 9)
D4		2	M10 nuts (C5 & 6)
		2	M10 nuts (C7 8 & 9)
D5		2	M10 x 35 long hexagon bolts (C5 & 6)
		2	M12 x 35 long hexagon bolts (C7 8 & 9)
D6		1	Motor pulley
D7		1	Key for motor pulley
D8		2	M8 x 10 long socket head grubscrew
D9	C8/46	1	Belt tension stud
D10		2	M12 nuts
D11	C5	1	Motor D80BD 1.5kw (2HP)
	C6	1	Motor D90SD 2.2kw (3HP)
	C7	1	Motor D90LD 3.0kw (4HP)
	C8	1	Motor D100LD 4.0kw (5.5HP)
	C9	1	Motor D112MD 5.5kw (7.5HP)

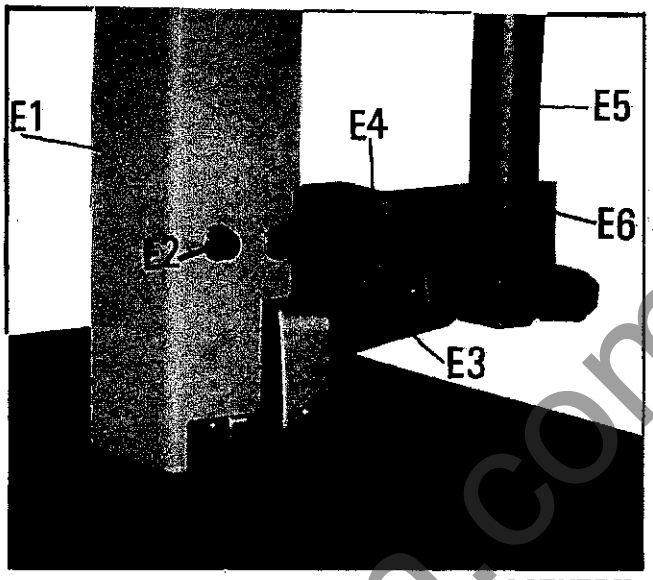
NOTE: When ordering a motor please state voltage, phase and frequency required, extra H.P. available if required.



MOTOR MOUNTING ASSEMBLY.

TOP SAWGUARD ASSEMBLY.

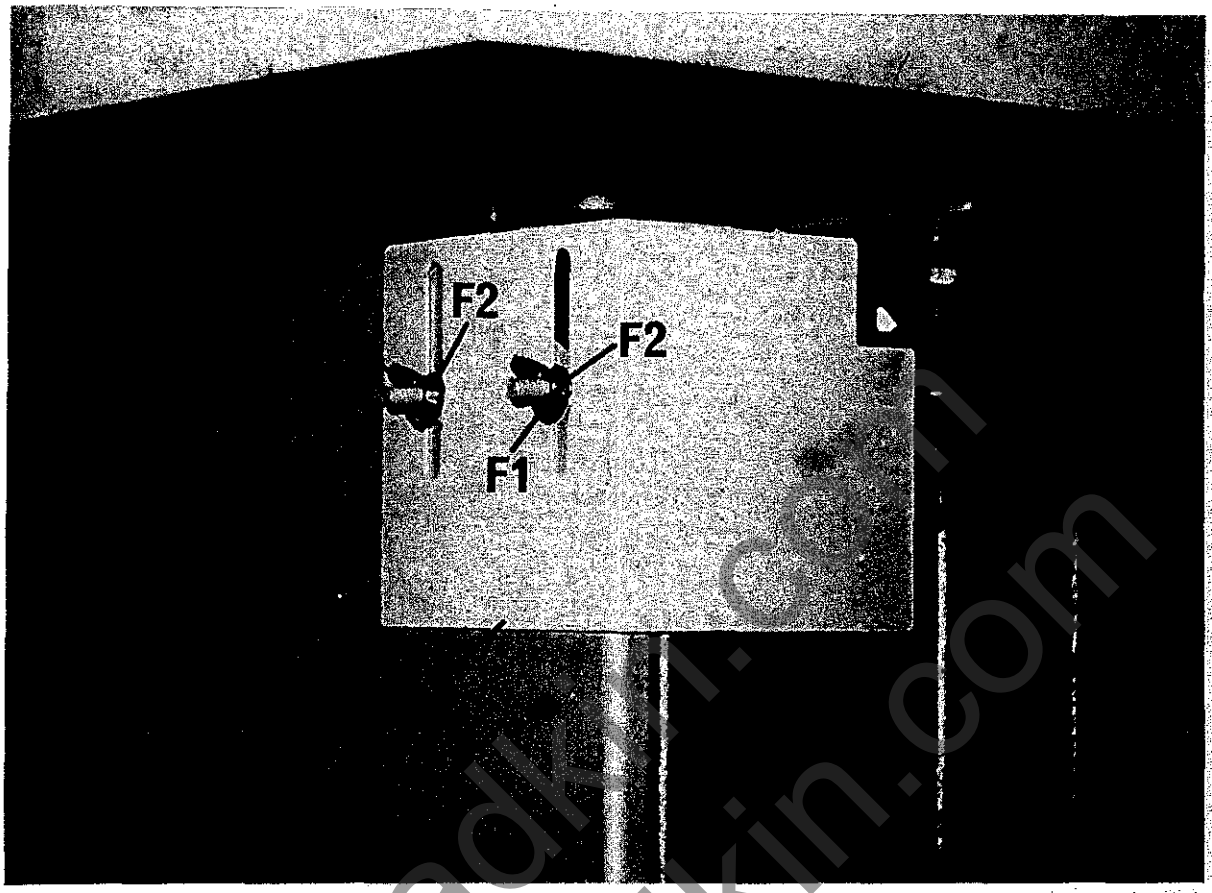
REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
E1	C5/48	1	C5 Top sawguard
	C7/40	1	C6 & 7 Top sawguard
	C8/91	1	C8 Top sawguard
	C9/47	1	C9 Top sawguard
E2		4	8mm washer
E3		2	M8 x 12 long socket head capscrew
E4	C5/49	1	Top sawguard bracket (C5 & 6)
	C8/131	1	Top sawguard bracket (C7 8 & 9)
E5	C5/34	1	C5 Guide column
	C6/23	1	C6 Guide column
	C7/31	1	C7 Guide column
	C8/26	1	C8 Guide column
	C9/38	1	C9 Guide column
E6		2	M8 x 15 long socket head capscrew



TOP SAWGUARD ASSEMBLY.

UNDER TABLE GUARD ASSEMBLY.

REF. NO.	PART NO.	NO. OFF.	DESCRIPTION.
F1		2	M8 Wingnut.
F2		2	8mm Washer.
F3	C8/62	1	Under table sawguard.



UNDER TABLE GUARD ASSEMBLY.

TABLE MOUNTING BRACKET ON BASE.(C5 & 6)

REF. NO.	PART. NO.	NO. OFF.	DESCRIPTION.
G1		4	M10 x 35 Long hexagon head bolt.
G2		6	10mm Washer.
G3	C6/5	1	Quadrant side plate with 14mm bore hole.
G4	C5/40	1	Quadrant locking handle.
	C5/44	1	Quadrant locking stud.
G5	C5/41	1	Toggle for quadrant lock.
G6		2	28mm dia. x M8 tap plastic ball (black).
G7		1	12mm Washer.
G8		1	M10 x 55 long hexagon head screw.
G9		1	10mm Washer.
G10		1	20mm Simplex adjuster (42mm long).
G11		1	20mm simplex nut.
G12	C6/5	1	Quadrant side plate with M12 tapped hole.
G13	C6/6	1	Quadrant slide bracket.
G14		2	M10 x 45 long hexagon head screw.

TABLE MOUNTING BRACKET ON BASE. (C7 8 & 9)

REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
G1	C8/4	1	Quadrant slide bracket
G2		3	10mm washer
G3		2	M10 x 45 long hexagon head screw
G4	1041/125	1	20mm Simplex adjuster, 42mm long
G5		1	M10 x 55 long hexagon head screw
G6		1	M16 nut
G7	C8/36	1	Table locking washer
G8	C8/67	1	Table locking screw

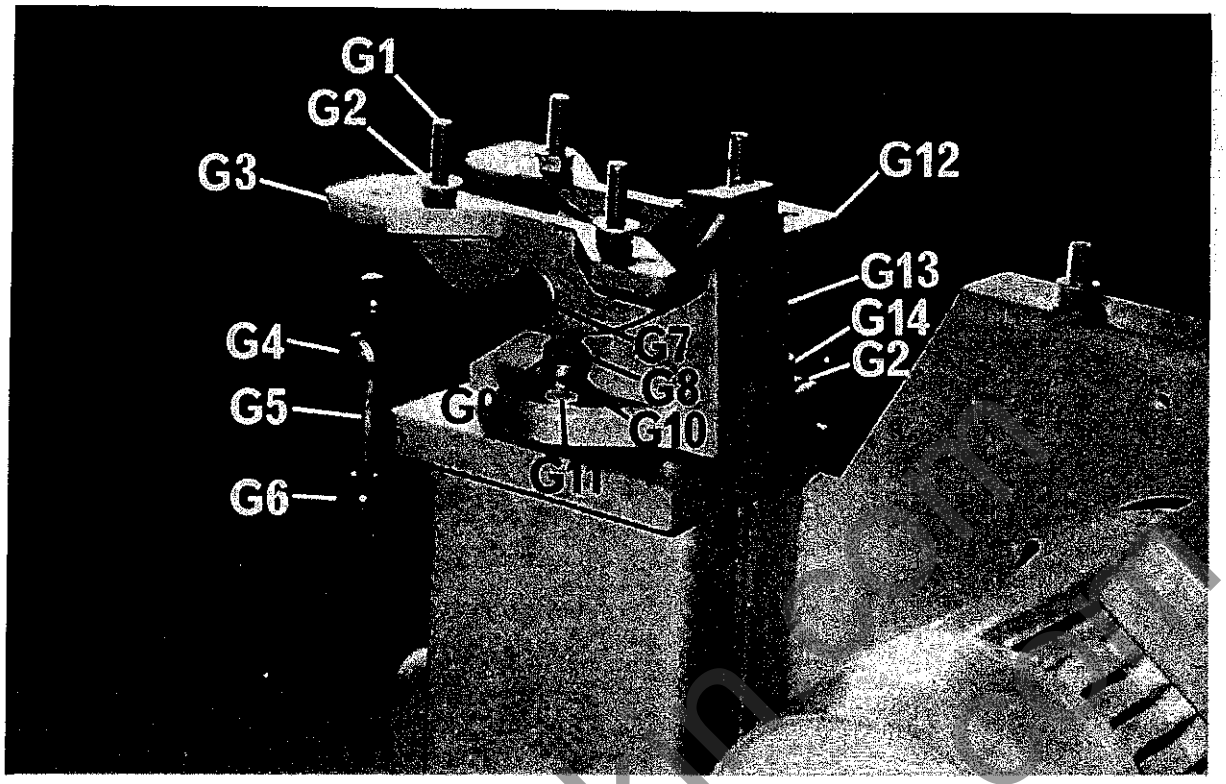


TABLE MOUNTING BRACKET ON BASE. (C5&6)

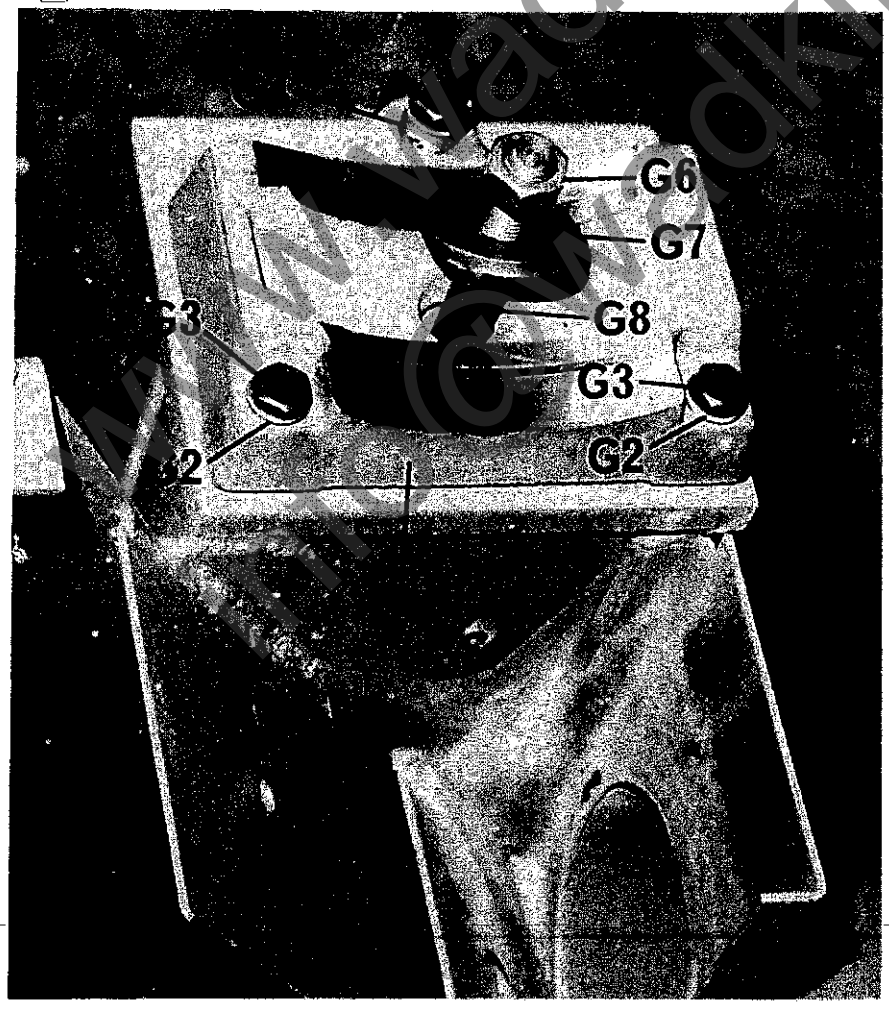
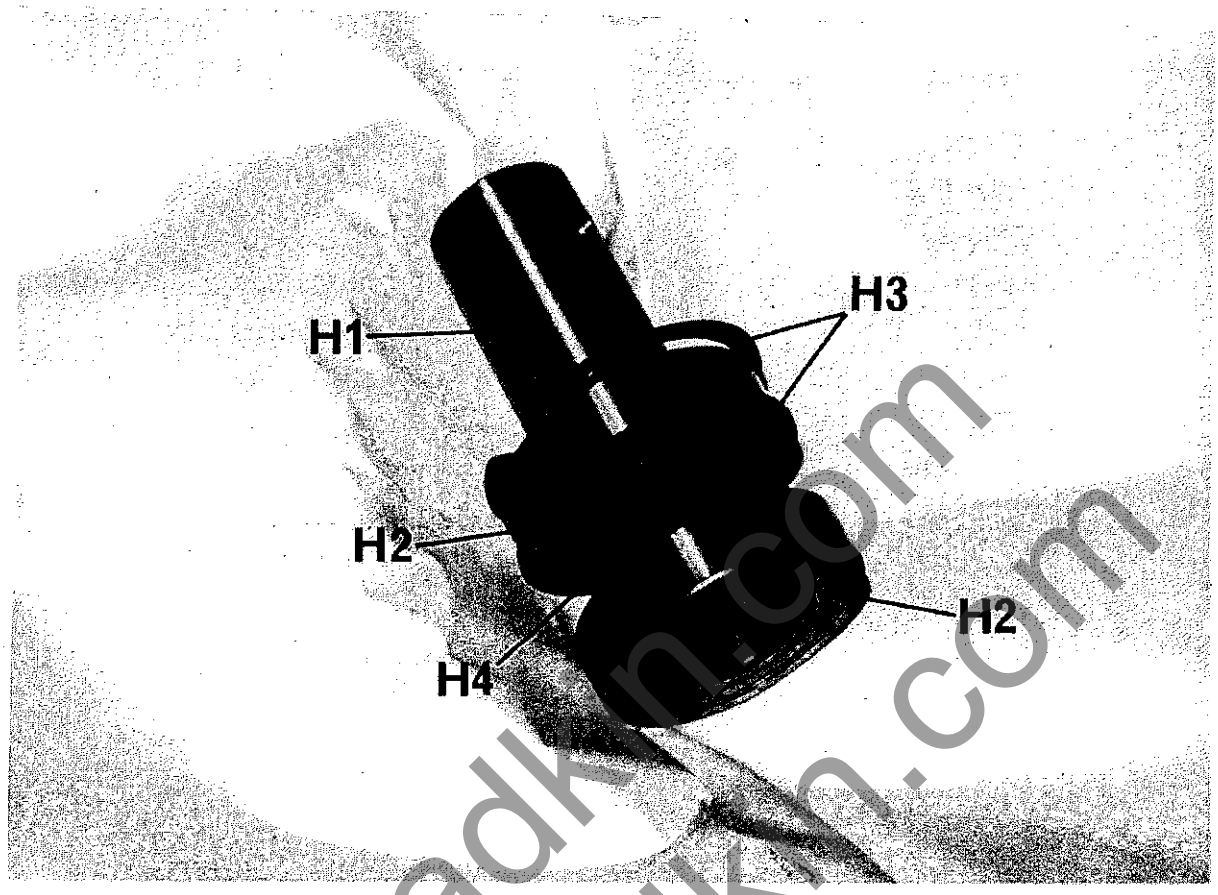


TABLE MOUNTING BRACKET ON BASE. (C7,8&9)

BOTTOM SPINDLE ASSEMBLY.

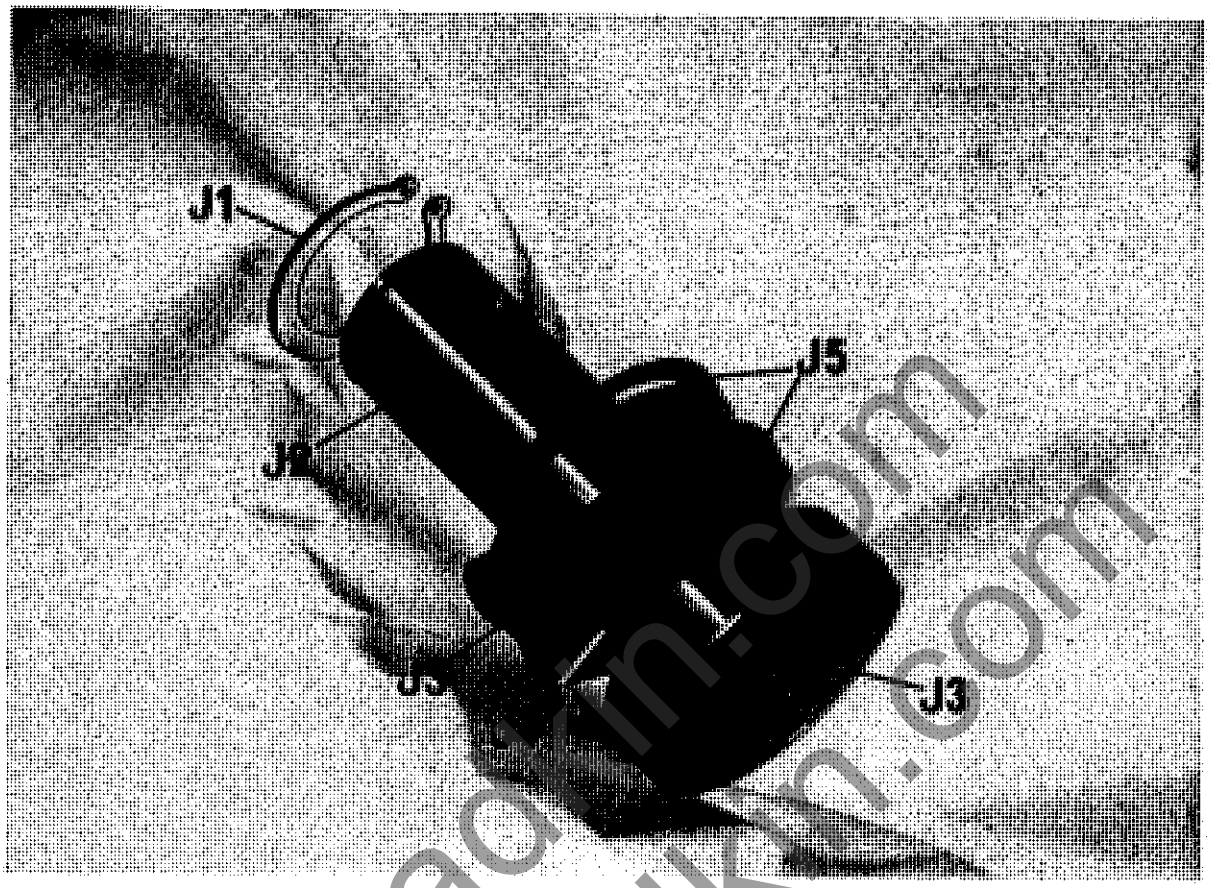
REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
H1	C5/32	1	Bottom wheel spindle (C5 & 6)
	C8/24	1	Bottom wheel spindle (C7 & 8)
	C9/37	1	Bottom Wheel Spindle (C9)
H2	6206-2RS	2 KC060214	Wheel bearings (C5 & 6)
	6307-2RS	2	Wheel bearings (C7 & 8)
	6308-2RS	2	Wheel bearings (C9)
H3	7000-062	2	Internal circlips (C5 & 6)
	7000-080	2	Internal circlips (C7 & 8)
	7000-090	2	Internal circlips (C9)
H4	C5/30	1	Bearing spacer (C5 & 6)
	C8/27	1	Bearing spacer (C7 & 8)
	C9/44	1	Bearing spacer (C9)



BOTTOM SPINDLE ASSEMBLY.

TOP SPINDLE ASSEMBLY.

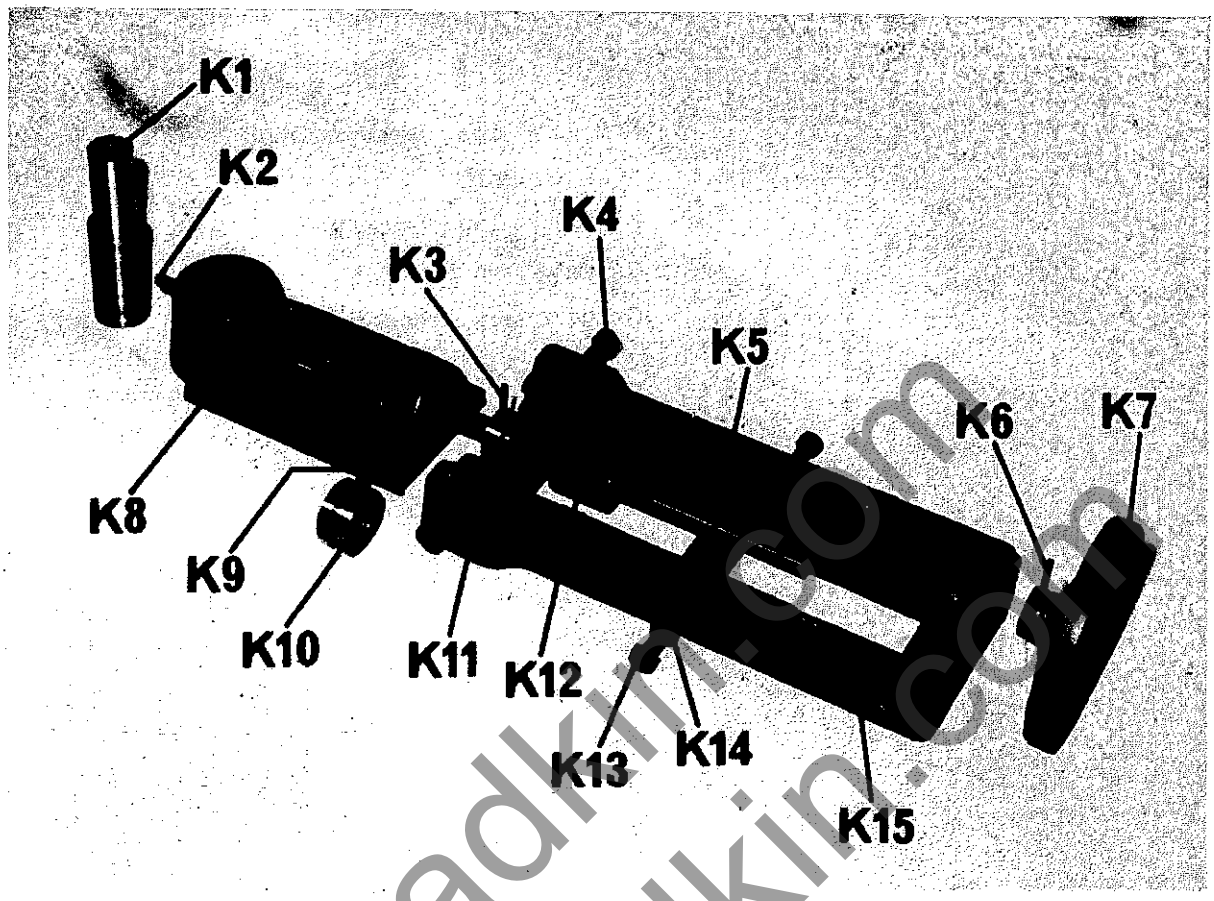
REF.NO.	PART.NO.	NO. OFF.	DESCRIPTION.
J1	7100-035	1	External circlips (C5 & 6)
	7100-045	1	External circlips (C7 & 8)
	7100-50	1	External circlips (C9)
J2	C5/31	1	Top wheel spindle (C5 & 6)
	C8/25	1	Top wheel spindle (C7 & 8)
	C9/36	1	Top wheel spindle (C9)
J3	6206-2RS	2	Wheel bearings (C5 & 6)
	6307-2RS	2	Wheel bearings (C7 & 8)
	6308-2RS	2	Wheel bearings (C9)
J4	C5/30	1	Bearing spacer (C5 & 6)
	C8/27	1	Bearing spacer (C7 & 8)
	C9/44	1	Bearing spacer (C9)
J5	7000-062	2	Internal circlips (C5 & 6)
	7000-080	2	Internal circlips (C7 & 8)
	7000-090	2	Internal circlips (C9)



TOP SPINDLE ASSEMBLY.

TOP SPINDLE ASSEMBLY.

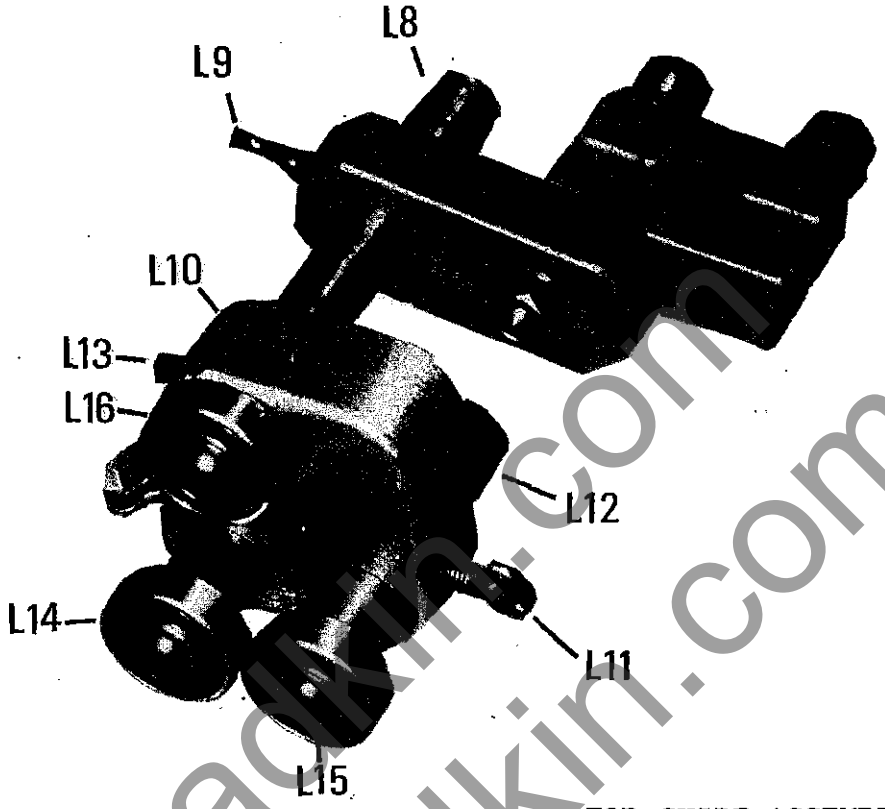
REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
K1	C5/31	1	Top wheel spindle (C5 & 6)
	C8/24	1	Top wheel spindle (C7 & 8)
	C9/36	1	Top wheel spindle (C9)
K2		1	M10 x 35 long socket head grubscrew
K3		1	5mm dia x 35 long groverlok spring dowel
K4		2	M12 x 40 long socket head capscrew
K5	C6/24	1	Saw tension screw(C5 & 6)
	C7/32	1	Saw tension screw (C7)
	C8/44	1	Saw tension screw (C8)
	C9/39	1	Saw tension screw (C9)
K6		1	5mm dia x 35 long groverlok spring dowel
K7		1	Saw tension handwheel
K8	C6/3	1	Top wheel slide (C5 & 6)
	C8/23	1	Top wheel slide (C7 & 8)
	C9/35	1	Top wheel slide (C9)
K9		1	M8 x 16 long socket head grubscrew (EXTRA: used with saw tension indicator)
K10	C8/77	1	Collar for saw tension indicator (Extra)
K11	C8/47	1	Saw tension collar
K12	04020415	18	Bellville washer
K13		2	M12 x 35 long hexagon head screw
K14	2	2	M12 nut
K15	C6/4	1	Top wheel slide frame (C5 & 6)
	C8/22	1	Top wheel slide frame (C7 & 8 & 9)



TOP SLIDE ASSEMBLY.

TOP GUIDE ASSEMBLY

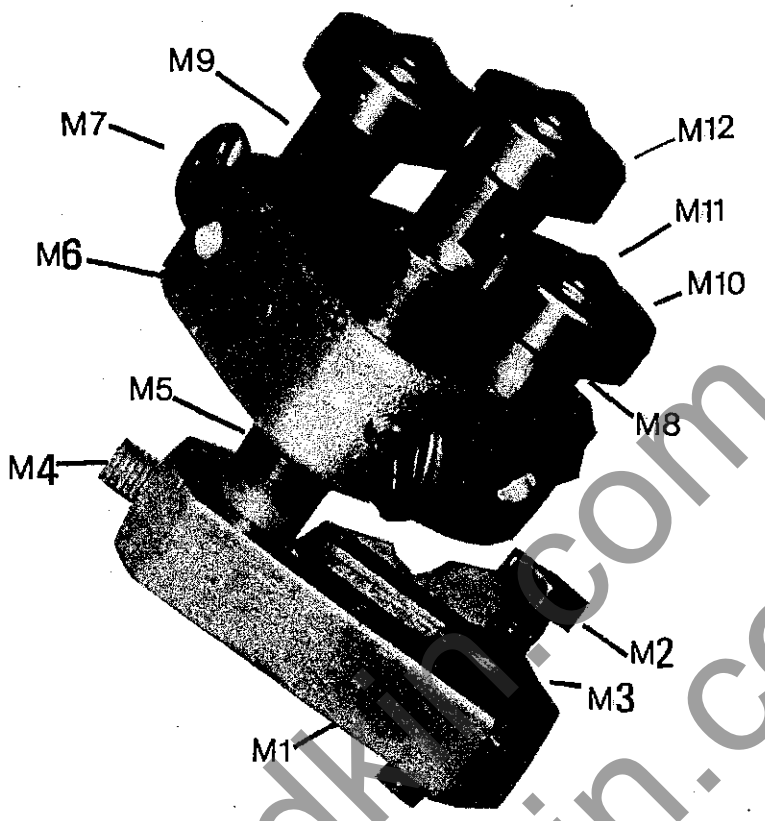
REF.NO.	PART. NO.	NO. OFF.	DESCRIPTION
L1		1	M10 x 90 long hexagon head bolt
L2		3	10mm washer
L3		1	M10 x 55 long hexagon head bolt
L4	C8/50	1	Guide clamp bracket
L5	C8/49	1	Guide clamp bracket
L6		1	10mm nut
L7	BH7/182	1	Guide adjusting link
L8	C6/47	1	Guide mounting pin (C5 & 6)
	C8/141	1	Guide mounting pin (C7 & 8)
	C9/68	1	Guide mounting pin (C9)
L9		1	M10 Thumbscrew
L10	C6/51	1	Guide Bracket (C5 & 6)
	C8/151	1	Guide Bracket (C7 & 8)
	C9/66	1	Guide bracket (C9)
L11		2	M8 Thumbscrew
L12	C6/42	2	Guide Eccentrics (C5 & 6)
L13		1	M8 x 10 long socket head grubscrew
L14		3	M6 washer
L15		3	M6 x 12 Long button head allenscrew
L16		3 K060172	6200-2RS Bearings (C5 & 6)
		3 K060185	6202-2RS Bearings (C7 & 8)
		3 K060192	6203-2RS Bearings (C9)



TOP GUIDE ASSEMBLY.

BOTTOM GUIDE ASSEMBLY (EXTRA).

REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
M1	BH7/182	1	Guide adjusting link
M2		1	M10 x 45 Hexagon head bolt
M3		1	10mm washer
M4		1	M8 x 10 long socket head grubscrew
M5	C8/150	1	Guide mounting pin
M6	C6/51B	1	Bottom guide bracket (C5 & 6)
	C8/151B	1	Bottom guide bracket (C7 & 8)
	C9/66B	1	Bottom guide bracket (C9)
M7		2	M8 Thumbscrew
M8	C6/48	1	Back guide pin (C5 & 6)
	C8/148	1	Back guide pin (C7 & 8)
	C9/70	1	Back guide pin (C9)
M9	C6/49	2	Bottom guide eccentrics (C5 & 6)
	C8/149	2	Bottom guide eccentrics (C7 & 8)
	C9/69	2	Bottom guide eccentrics (C9)
M10		3	M6 washer
M11		3	M6 x 12 long button head allenscrew
M12		3	6200-2RS Bearings (C5 & 6)
		3	6202-2RS Bearings (C7 & 8)
		3	6203-2RS Bearings (C9)



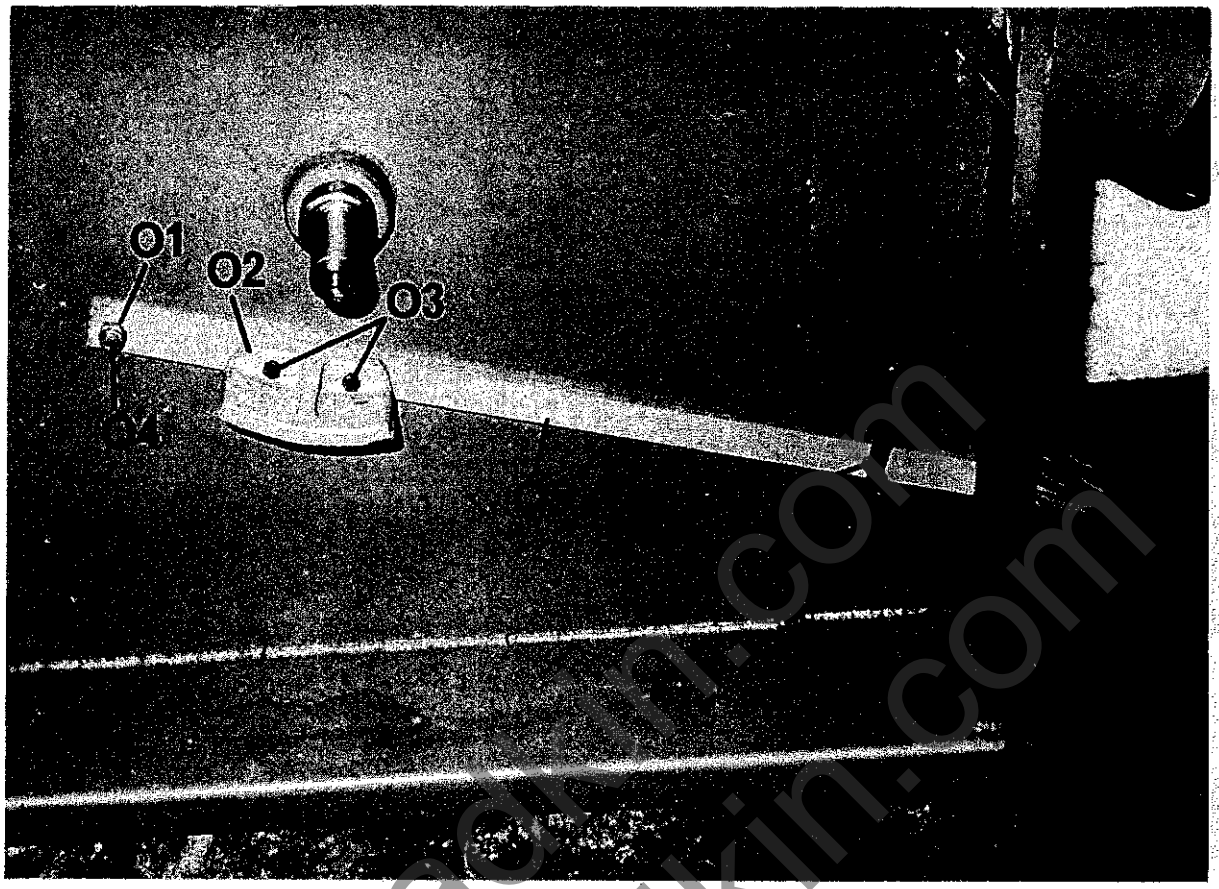
BOTTOM GUIDE ASSEMBLY.

TRACKING ASSEMBLY.

REF. NO.	PART. NO.	NO. OFF.	DESCRIPTION.
N1		1	2⅛" dia, tracking handwheel M12 tap.
N2	C8/41	1	Tracking screw.
N3		1	M12 wingnut.
N4		1	12mm washer.

BRAKE ASSEMBLY (EXTRA).

REF NO.	PART NO.	NO. OFF.	DESCRIPTION.
01		1	M12 Aerotight nut.
02	C5/37	1	Brake Shoe (C5 & 6)
	C8/63	1	Brake Shoe (C7, 8 & 9)
03		2	M8 x 20 long hexagon head bolt.=
04		1	M12 x 40 long stud
05	C5/36	1	Brake pedal arm (C5)
	C6/25	1	Brake pedal arm (C6)=
	C7/35	1	Brake Pedal Arm (C7)
	C8/89	1	Brake Pedal Arm (C8)
	C9/57	1	Brake Pedal Arm (C9)
06	Entex 568	1	Brake return spring
07		1	M8 locknut
08		1	M8 x 30 long hexagon head bolt

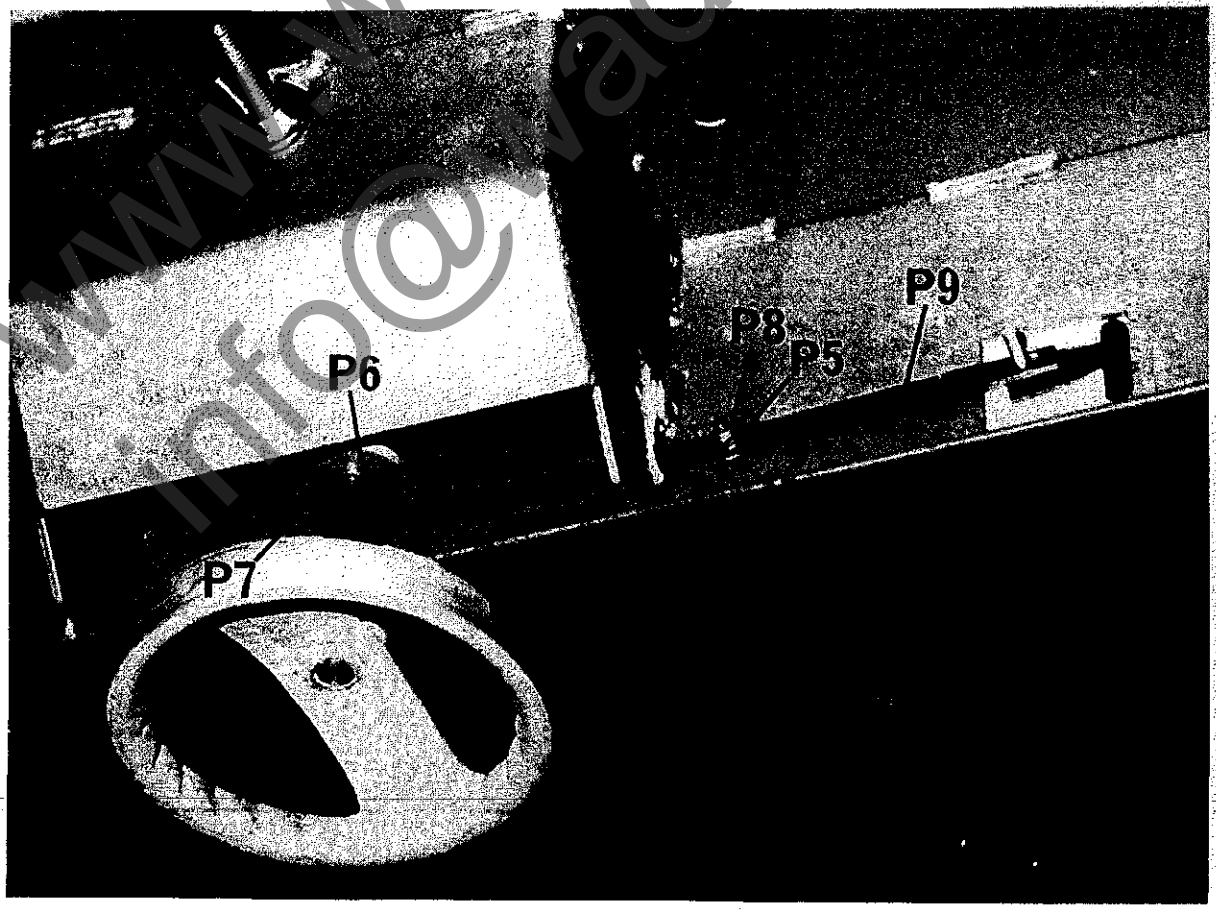


BRAKE ASSEMBLY (EXTRA).

SAW TENSION INDICATOR ASSEMBLY (EXTRA).

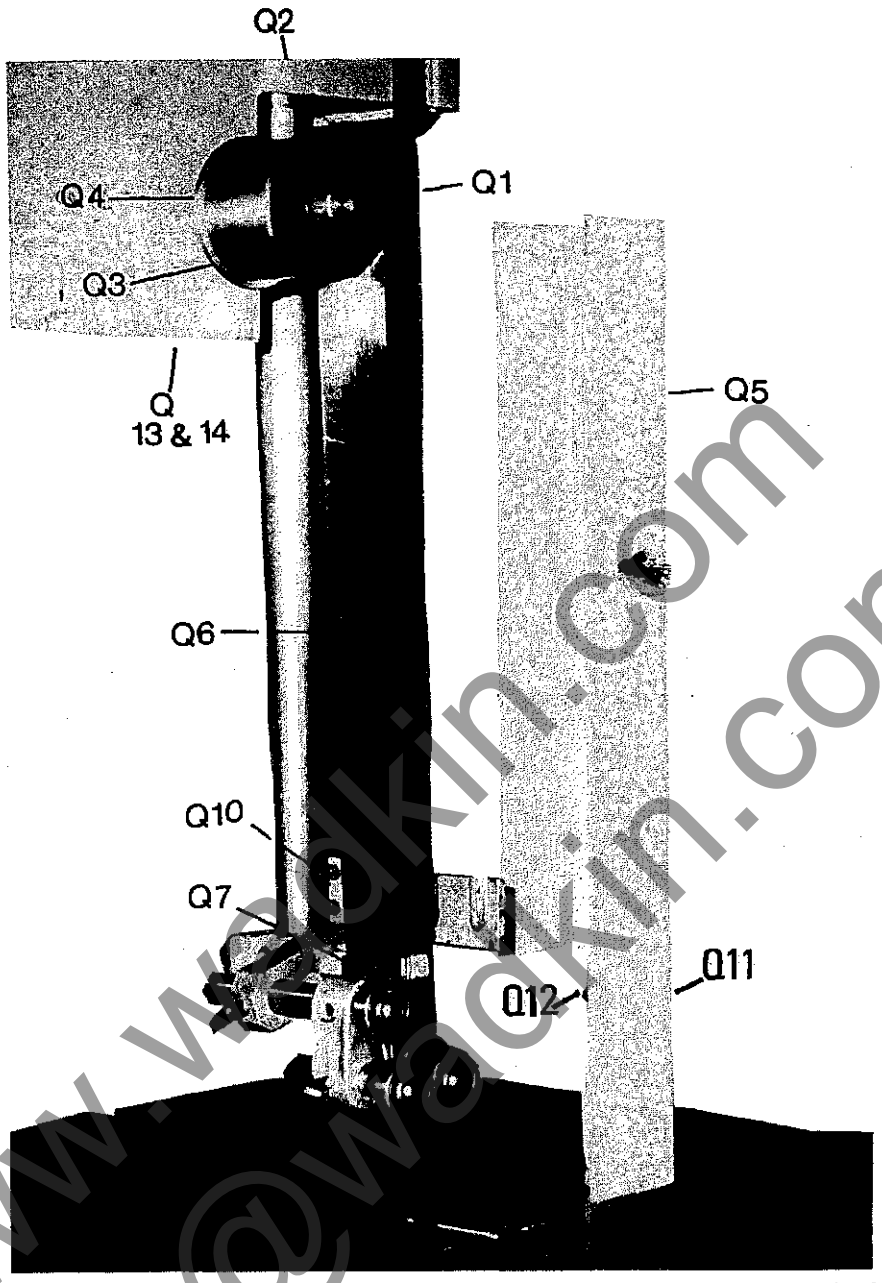
REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
P1	C8/107	1	Saw tension indicator plate (English)
	C8/111	1	Saw tension indicator plate (Mrtric)
P2	BH7/187	1	Saw tension pointer
P3	TS541	1	Clik rivet
P4		1	M6 x 20mm long hexagon head bolt
P5		3	8mm washer
P6	C8/77	1	Collar for indicator (C7 8 & 9)
	C6/40	1	Collar for indicator (C5 & 6)
P7		1	M8 x 16 long socket head grubscrew
P8		1	M6 aerotight nut
P9	C5/45	1	Link arm (C5)
	C6/27	1	Link arm (C6)
	C7/44	1	Link arm (C7)
	C8/108	1	Link arm (C8)
	C9/56	1	Link arm (C9)

SAW TENSION INDICATOR ASSEMBLY (EXTRA).



DELUX TOP SAWGUARD (EXTRA)

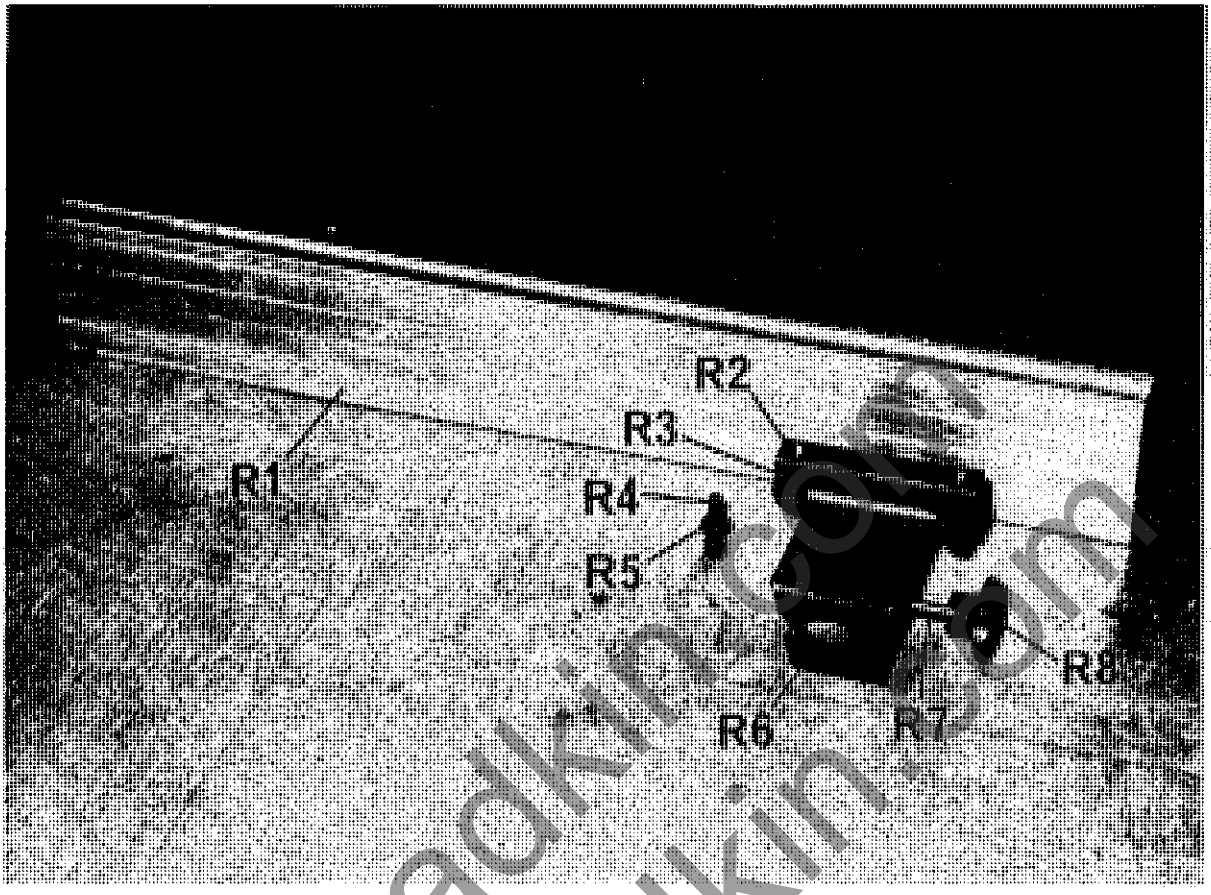
REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION
Q1	C6/32	1	Bobbin for tensator spring (C5 & 6)
	C8/56	1	Bobbin for tensator spring (C7 & 8 & 9)
Q2		2	25 O/D x 20 I/D x 20 long oilite bush
Q3	C8/98	1	Spring (Tensator Spring)
Q4	7115-020	1	20mm Truarc reinforced self locking ring
Q5	C5/46	1	C5 Top Sawguard
	C7/39	1	C7 Top sawguard
	C9/59	1	C9 Top sawguard
	C6/31	1	C6 Top sawguard
	C8/58	1	C8 Top sawguard
Q6	SR46	1	Tensator spring
Q7	C6/34	1	Tensator spring clamp
Q8		1	M6 x 10 long socket head capscrew
Q9	C6/30	1	Top sawguard bracket (C5 & 6)
	C8/101	1	Top sawguard bracket (C7 8 & 9)
Q10		2	M8 x 15 long socket head capscrew
Q11		2	M8 x 12 long socket head capscrew
Q12		2	8mm washer
Q13		1	M10 x 25 long hexagon head screw
Q14		1	10mm washer



DELUXE TOP SAWGUARD (EXTRA).

RIP FENCE ASSEMBLY (EXTRA)

REF.NO.	PART.NO.	NO.OFF.	DESCRIPTION.
R1	C5/46	1	Fence plate (C5 &6)
	C8/61	1	Fence plate (C7 8 & 9)
R2	C8/93	1	Fence clamp plate
R3	C8/94	1	Fence spacer
R4		2	M10 x 35 long socket head capscrew
R5		2	10mm washer
R6	C8/6	1	Fence bracket
R7		1	Stud for fence
R8		1	M10 x 2⅛" dia, fence locking handwheel



RIP FENCE ASSEMBLY.(EXTRA).

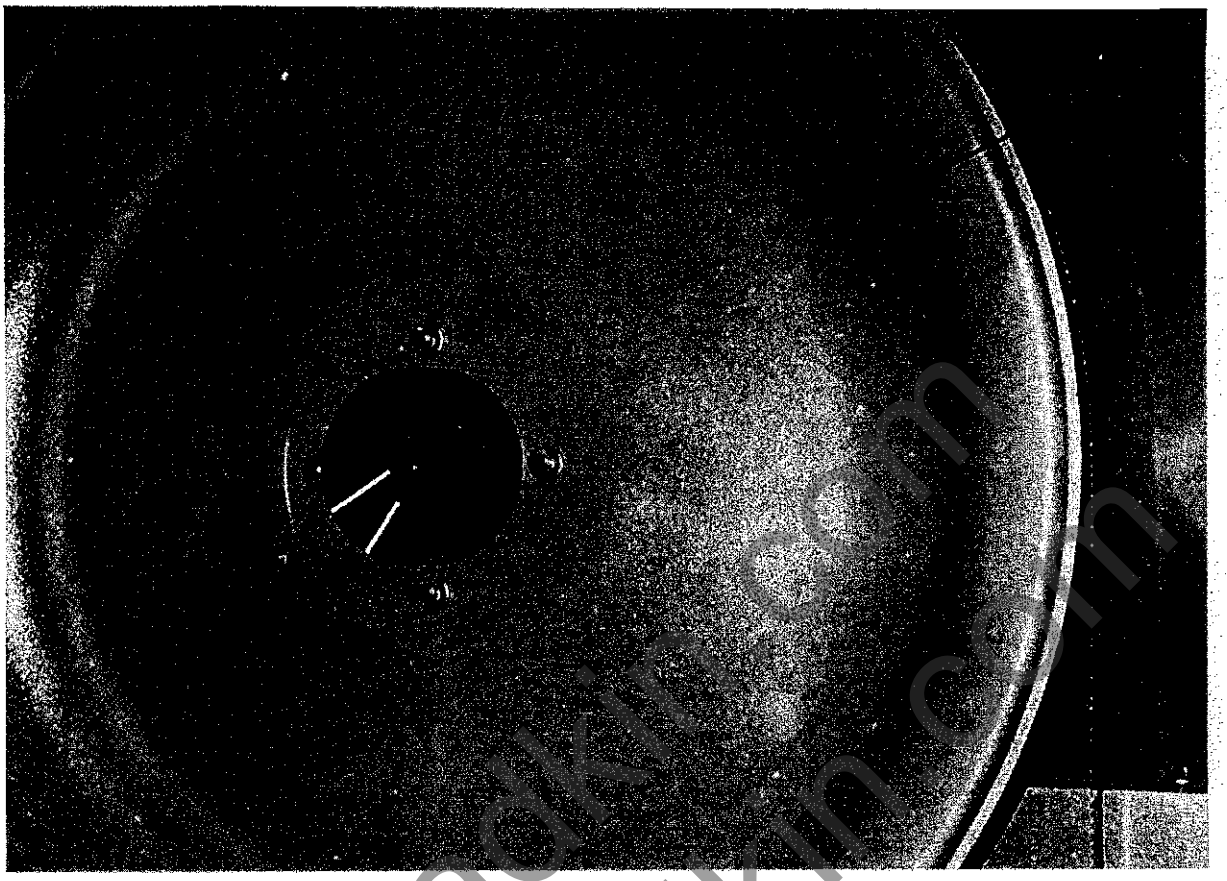
EXTENSION TABLE ASSEMBLY.

Ref No.	Part No.	No. Off.	Description.
S1	C9/60	1	Extension table.
S2		2	M10 x 30 long hexagon head bolt.
S3		4	10mm washer.
S4		2	10mm nut.
S5		2	M6 x 10 long socket head grubscrew.

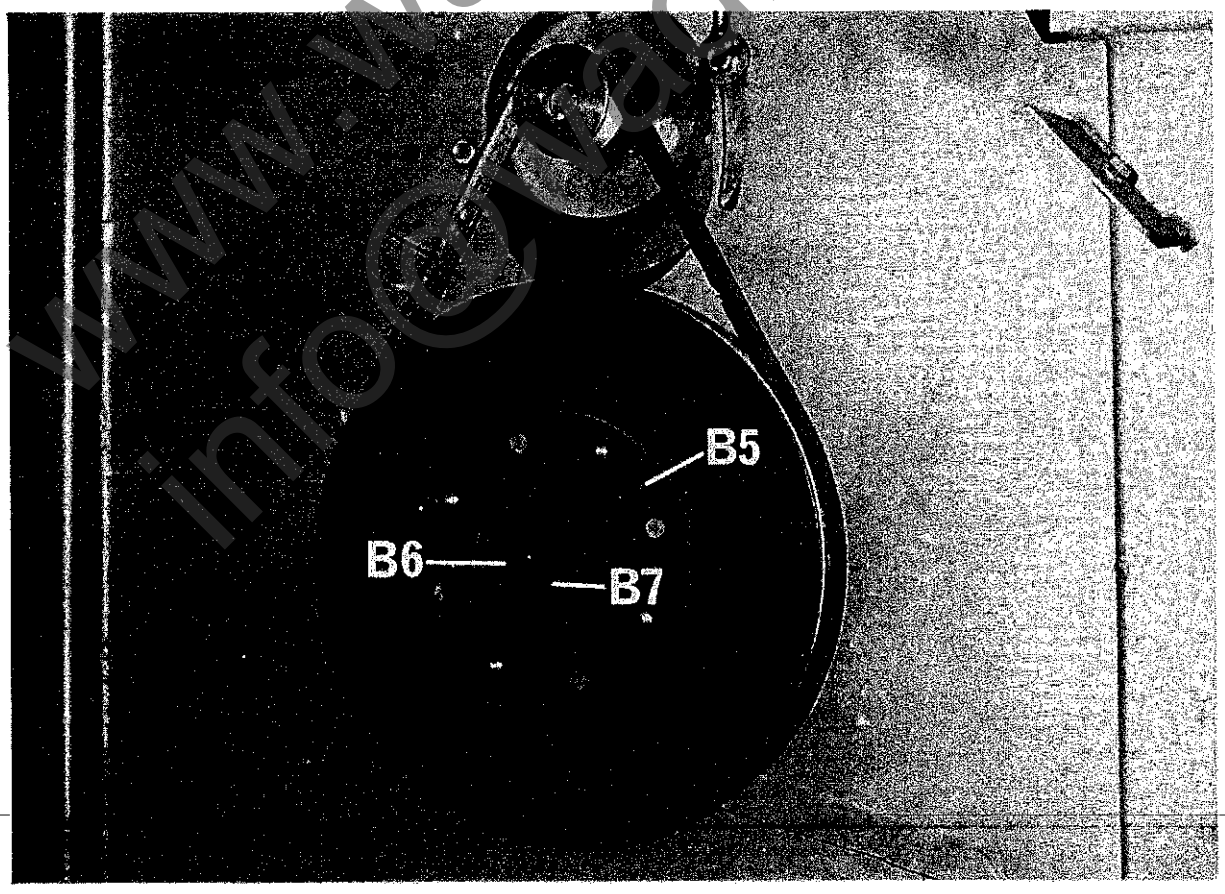
EXTENSION TABLE ASSEMBLY (UNDERSIDE VIEW).

WHEELS AND BELT ASSEMBLY.

Ref.No.	Part No.	No. Off.	Description.
B1	DR/81	1	Top wheel.
	DR/81	1	Bottom wheel.
B2		4	M12 hexagon head nut.
B3		4	12mm washer.
B4	C9/52	1	Top wheel hub.
B5		1	
B6		1	M16 x 30 long hexagon head bolt.
B7	C9/51	1	Wheel washer.
B8	580-L6	1	Poly "V" belt.
B9	C9/53	1	Bottom wheel hub.



WHEELS AND BELT ASSEMBLY.



Application	Approved Lubricant					
	Castrol	B. P.	Shell	Esso	Texaco/ Caltex	Wadkin
Worm Boxes	Alpha 617	Energol CS425	Vitrea 75	Pen-O-Led E. P.3	Regal Oil J	L. 2.
General Lubrication	Magna ED	Energol HP. 20	Vitrea 33	Esstic 50	Ursa Oil P. 20	L. 4.
Pneumatic Lubricators	Hyspin AWS 32	Energol HL 65	Tellus 27	Nuto H 44	Rando Oil HDA	
Grease	Spheerol AP. 3	Energrease LS. 3	Alvania 3	Beacon 3 Starfak Premium 3	Regal	L. 6.
Brake Cables	Brake cable grease	Energrease L21M	Alvania 3	Multi-purpose grease H		

Modifications are made to these books from time to time and it is important therefore that only the book sent with the machine should be used as a working manual

PLEASE INSERT SERIAL NUMBER OF MACHINE

PBR

Power Band Rip Saw

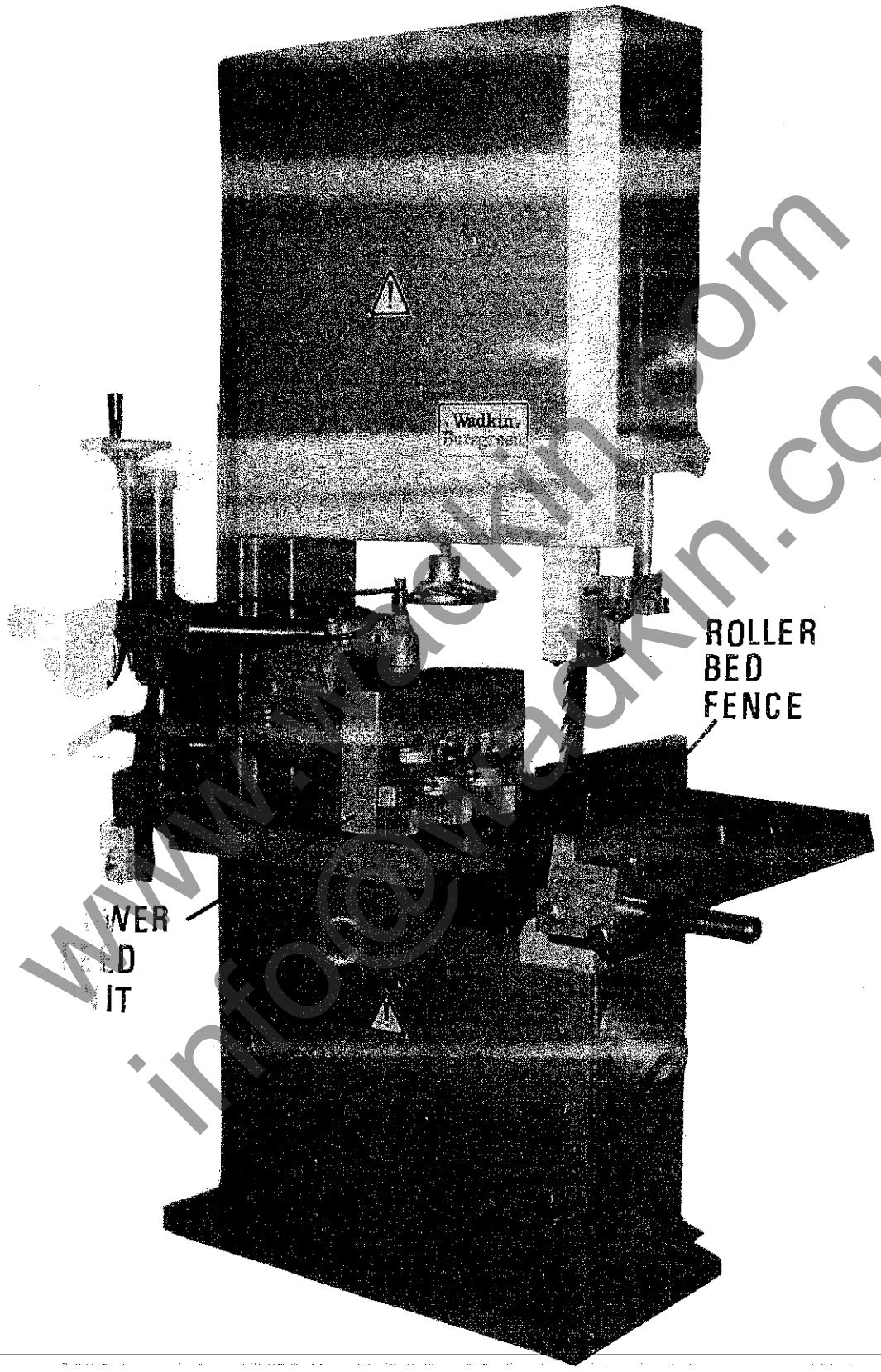
SPECIFICATION

Diameter of saw wheels	700mm	27.5in
Maximum depth under saw guide	485mm	19in
Maximum depth of cut	300mm	12in
Maximum distance saw to body	680mm	26.7in
Mimimum width of blade	3mm	$\frac{1}{8}$in
Maximum width of blade	65mm	$2\frac{1}{2}$in
Maximum length of blade	5080mm	16ft8in
Mimimum length of blade	4940mm	16ft$2\frac{1}{2}$in
Speed of motor. 50Hz	3000rev/min	3000rev/min
Speed of motor. 60Hz	3600rev/min	3600rev/min
Power of motor	7.5KW	10Hp
Speed of saw blade	1500M/min	5000ft/min
Eight feed speeds	2-29M/min	6-98ft/min
Size of table	765x1000mm	30x39in
Height of table	900mm	35in
Floor space (No pit required)	800x1600mm	31$\frac{1}{2}$x63in
Weight (Approximately)	605kg	1331lb
Table cants with feed unit	25°	25°
Table cants without feed unit	35°	35°

OPTIONAL EXTRAS.

AUTOMATIC STAR DELTA STARTER.
FINE ADJUSTMENT TO TABLE CANTING BY SCREW AND HANDWHEEL.
ELECTRIC INTERLOCK ON FOOT BRAKE.
SPOT LIGHTING EQUIPMENT.
INFEED AND OUTFEED ROLLER TABLES.

FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES,
CONTACT:- WADKIN CLEVELAND (Div Of Wadkin Ltd)
NORTH LIVERTON IND EST
LOFTUS
SALTBURN-BY-THE-SEA
CLEVELAND
ENGLAND
(Telephone: Guisborough 0287/40177)



NOTE:- THIS BOOK TO BE USED IN CONJUNCTION WITH THE "C" RANGE BANDSAW AND AUTOMATIC FEEDER INSTRUCTION BOOK AND ALL INSTRUCTION BOOKS SHOULD BE READ BEFORE USING THE MACHINE.

FOR OPTIMUM BLADE LIFE THE FOLLOWING FEED SPEEDS ARE RECOMMENDED.

DEPTH OF CUT	1"	2"	3"	4"	6"	8"	10"	12"	
SOFT WOOD	98	49	39	33	20	16	13	6	FT/MIN
HARD WOOD	33	20	16	13	6	--	--	--	FT/MIN

MACHINE MUST BE BOLTED DOWN.

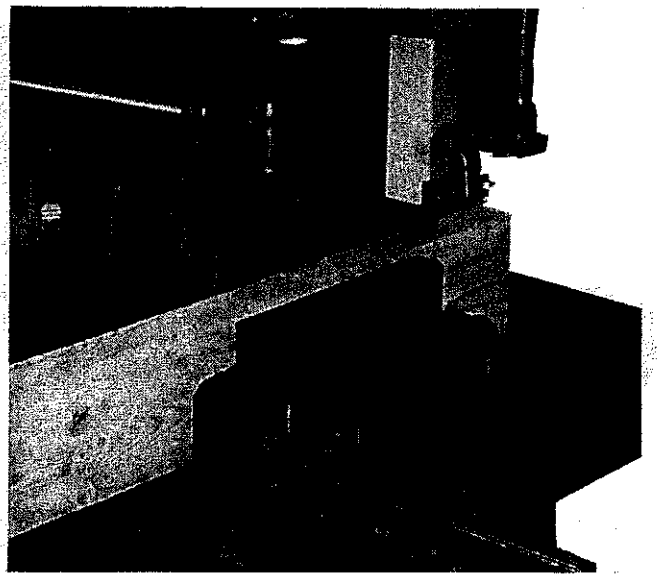


FIG 1

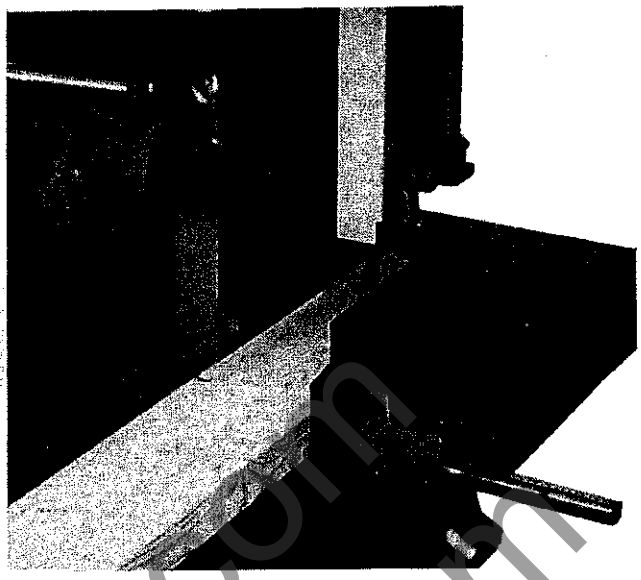


FIG 2

FIG 3

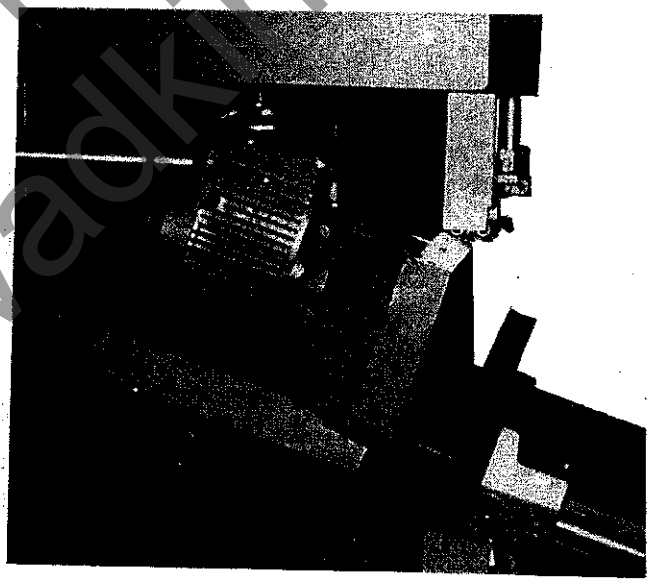


FIG 4

NOTE:- Figures 1-4 show the position the Feed Unit can be set to accommadate various stock sizes,

NOTE:- The Top Guide should always be set close as possible to the stock.

FIG. 5. Top Saw Guide (See Setting Instructions)

FIG. 6. Bottom Saw Guide (See Setting Instructions)

FIG. 7. Tension Indicator

FIG. 8. Tracking Saw Blade

FIG. 9. Top Door Open To Allow Removal Of Blade

FIG.10. Feed Unit Locks And Adjustment

FITTING OF RIP SAW BLADES. (See also page 10 - "C" Range instruction book.)

1) Isolate machine electrically.
2) Swing power feed unit out and open top door together until door clears blade guard aperture on main column of machine.
3) Traverse roller bed fence to the right hand side of machine until it clears saw slot in table, open bottom door and remove top saw guard.
4) Adjust top wheel sufficient to allow blade to be fitted to both wheels, tension saw blade until pointer on tension indicator (See fig 7, page 9.) indicates P.B.R.
5) Tracking of the saw blade is done by rotating the top wheel slowly by hand in a clockwise direction, the root of the saw tooth should overhang the rim of the wheel by approximately 2mm (see fig's 8 & 12).

Should blade not track correctly, lossen wing nut "B", fig 11 then turn handwheel "C" until saw is tracking correctly then tighten wingnut "B".

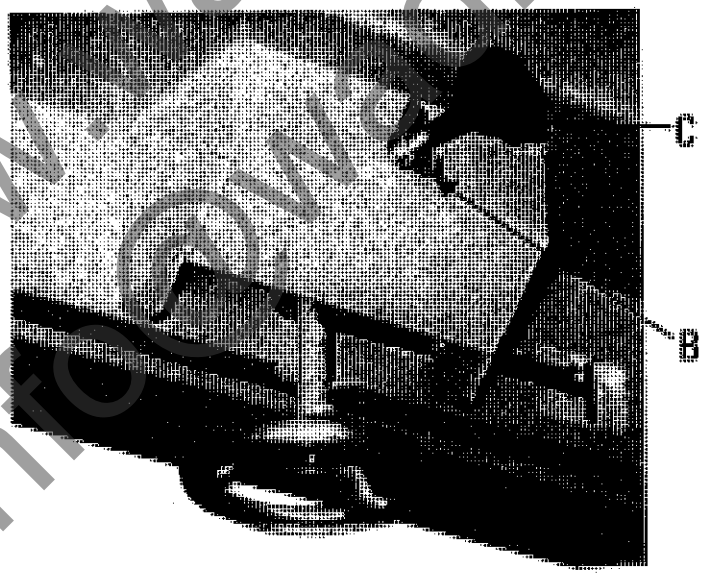


FIG 11

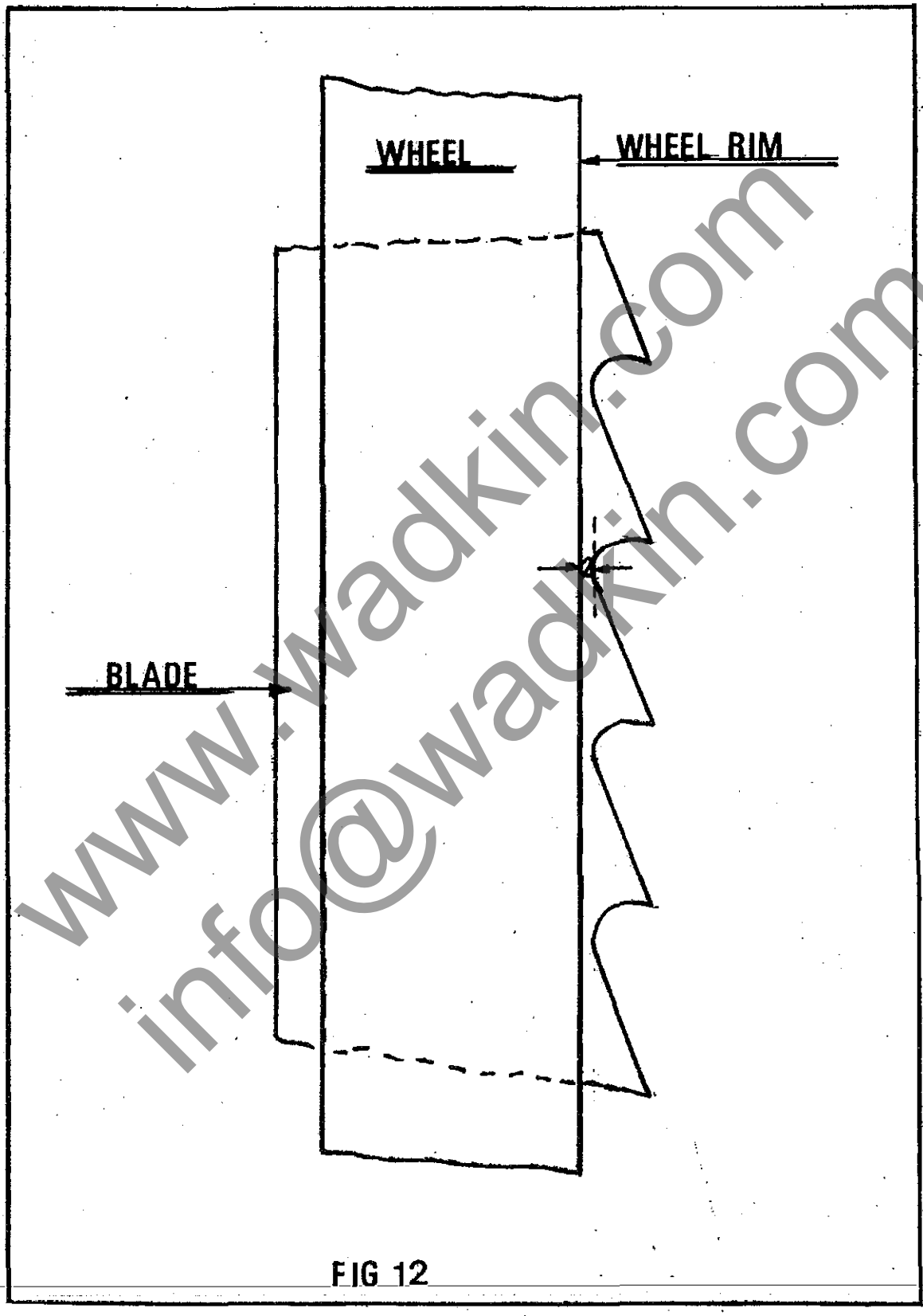


FIG 12

SETTING SAW GUIDES

The top and bottom guide units Fig 5 & 6 should be set up as follows with the top saw guide as close to the stock as practical.

1) Loosen grubscrew "A" and M10 "B" Fig 13. then position guide body "C" central and parrellel to blade see Fig 14, then tighten up grubscrew "A" and M10 Nut "B".

NOTE:- Once the guide bracket has been intially set up, only the adjustment described in paragraphs 2 & 3 should be necessary.

2) Slacken thumb screw "Y" Fig 13, and set near guide roller approximately 5mm clear of back of blade (See Fig 15) and lock up thumb screw securely.

3) Slacken thumb screws "X" Fig 13, and move side guide rollers forward as positioned in Fig 15, then pivot side guide rollers on anti lock eccentrics until they are just clear of blade and lock thumbscrew "X".

NOTE:- It is important to check that the side guide rollers do not nip the blade when locked up, and that the guide assembly is square to the natural line of the blade (see Fig 16).

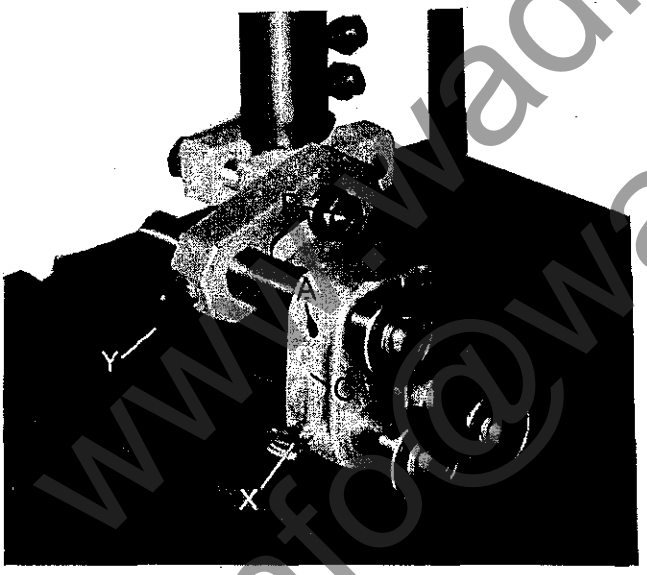


FIG 13

FIG 14

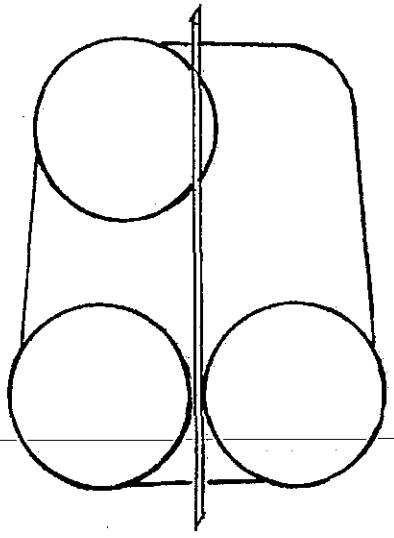
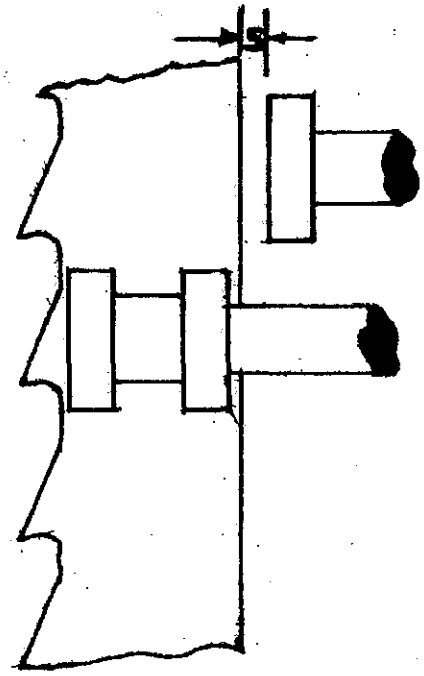
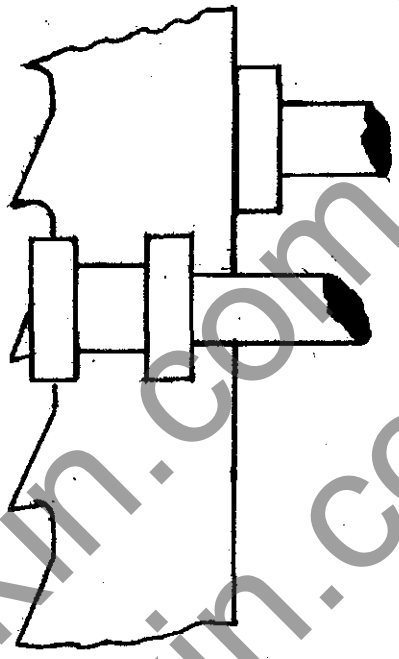


FIG. 15

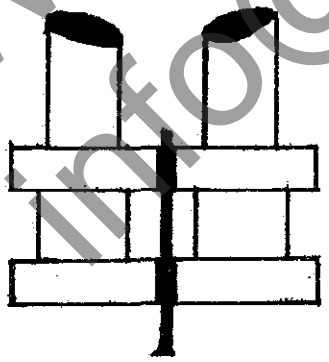


CORRECT

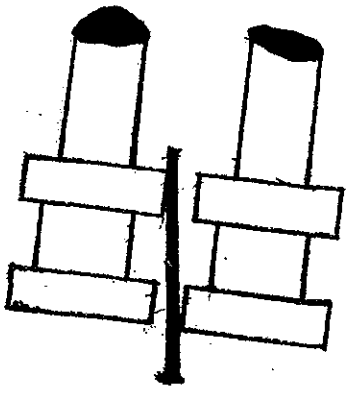


INCORRECT

FIG. 16



CORRECT



INCORRECT

FEEDER UNIT. Fig 17.

The feeder unit can operate in both directions and has 8 speeds attained by:-

A) Two speed motor with switch positions 1 and 2.

B) Gear lever with positions I and II.

C) Inter changing gears Nos 44 and 65.

The feeder unit should always be operated in accordance with the instructions supplied.

Best feeding results are obtained when face of feed rollers are parrallel to timber.

IMPORTANT. All locking points (Fig 18) must be secured before feeding, otherwise unit may pull itself into blade.

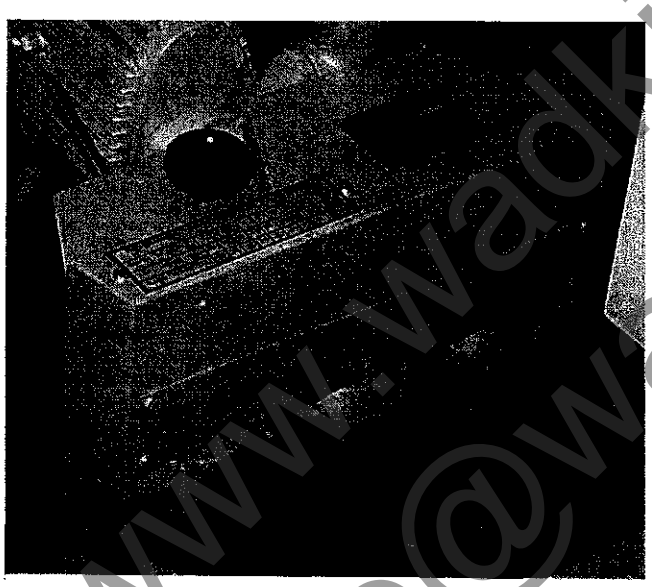


FIG 17

NOTE:- Feeder will not operate unless machine is running.

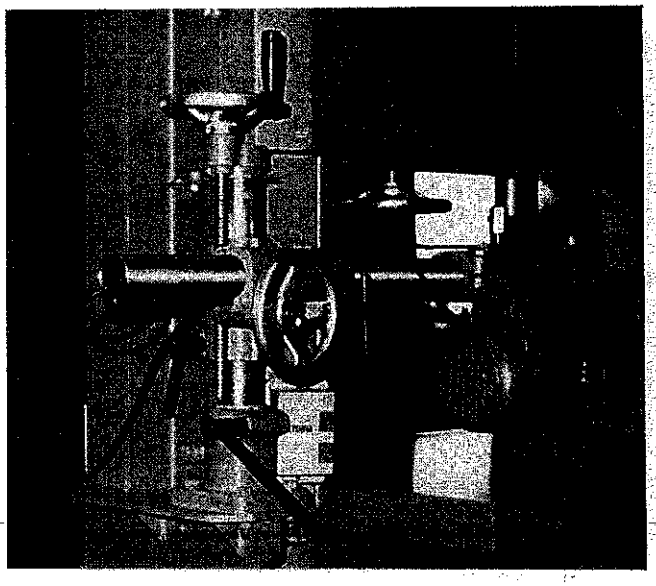


FIG 18

ROLLER BED FENCE.

The roller bed fence incorporates an adjustable pointer and fine adjustment mechanism, together with secure fence lock for accurate stock control. (see fig. 19).

The infeed bracket (fig. 19) on the fence incorporates a feeder setting scale (fig. 20) which is used as follows:-

1) Set fence to finished stock size desired.
2) Measure average width of stock to be ripped i.e. 100mm.
3) Aligne face of feed rollers to width indicated on feeder setting scale i.e. 100mm.

This setting method automatically gives 5mm motoring over pressure, and allows the unit to accommadate approximately 8mm stock variance without continual adjustment of feeder unit.

FIG 20

FIG 19