WOODFAST

Instruction Manual

BANDSAW
BS350C

IMPORTANT：

For yoursafety，read instructions carefully before assembling or using this product. Save this manual for future reference.

Original Instruction：
V.1-201807

INDEX

1. GENERAL INFORMATION

1.1 FOREWORD

This machine is professional for straight cutting and square cutting of wood material, especially for wood panels cutting.

Some information and illustrations in this manual may differ from the machine in your possession, since all the configurations inherent in the machine complete with all the optional are described and illustrated. Therefore, refer only to that information strictly connected with the machine configuration you have purchased.

With this manual we would like to provide the necessary information for maintenance and proper use of the machine. The distribution network is at your service for any technical problem, spare parts or any new requirement you many have for the development of your activity.

This manual must be read and understood before operating the machine. This will provide a better

working knowledge of the machine, for increased safety and to obtain the best results.

To better stress the importance of some basic passages, they have been marked by some preceding

symbols:

WARNING Indicates imminent risks which may cause serious injury to the operator or other persons. Be careful and scrupulously follow the instructions.

CAUTION A statement advising of the need to take care lest serious consequences result in harm to material items such as the asset or the product.

1.2 MACHINE IDENTIFICATION

There is a identification plate fixed to the machine, containing the manufacturer's data, serial number, year of construction, and technical specifications.

1.3 CUSTOMER SERVICE RECOMMENDATIONS

Apply the machine to skilled and authorized technical staff to carry out any operation dealing with parts disassembly. Keep to the instructions contained in this manual for the correct use of the machine.

CAUTION Only the skilled and authorized staff shall use the service the machine after reading this manual. Respect the accident prevention regulation s and the general safety and industrial medicine rules.

2. SAFETY PRECAUTIONS

2.1 SAFETY REGULATIONS

WARNING Read carefully the operation and maintenance manual before starting, using, servicing and carrying out any other operation on the machine.

The manufacturer disclaims all responsibilities for damages to persons or things, which might be caused by any failure to comply with the safety regulations.

- It is prohibited to use the machine when under the influence of alcohol, drugs or medication.

- The operators must carefully read the manual paying particular attention to the warning and safety notes. Furthermore, they must be informed on the dangers associated with use of the machine and the precautions to be taken, and must be instructed to periodically inspect the guards and safety devices.

- Before carrying out adjustment, repair or cleaning work, disconnect the machine from the electric power by setting the main switch to stop.

- After an initial bedding-in period or many hours of operation, the driving belts may slacken; this causes an increase in the tool stopping time (the stopping time must be less than 10 seconds). Immediately tighten them.

- The working area around the machine must be kept always clean and clear, in order to have an immediate and easy access to the switchboard.

- Never insert materials which are different from those which are prescribed for the machine utilization.

- Never process pieces which may be too small or too wide to the machine capacity.

- Do not work wood which has evident defects(cracks, knots, metal parts, etc)

- Keep hands clear from the tool; feed the piece with the aid of a pusher.

- Keep the tools tidy and far away from those not authorized persons.

- Use qualified tools, never use cracked, buckled or wrong polished tools; never use irregular, dull tools; never use distorted blade.

- Never use the tools beyond the speed limit recommended by the producer.

- Always wear gauntlets when handling the tools.

- Mount the tools in the right machining direction.

- Never start the machine before having correctly installed all protections. Without protections or damage caused by person should install and complete in time, or forbid to start machine. Never install protections.

- Connect the dust suction hoods to and adequate suction system; suction must always be activated when the machine is switched on.

- Never open the door or other protections when the machine or the system is operating.

- Before start machine, check if lock main blade and scoring blade. After starting machine, check if turning direction of main blade and scoring blade is right, start to work after revolving speed is stable.

- Never cutting on log directly

- Many unpleasant experiences have shown that anybody may wear objects which could cause serious accidents. Therefore, before starting working, take any bracelet, watch or ring off.

- Button the working garment sleeve well around the wrists.

- Take any garment off which, by hanging out, may get tangled in the MOVING UNITS.

- Always wear strong working footwear, as prescribed by the accident-prevention regulations o all countries

- Use protection glasses. Use appropriate hearing protection systems (headsets,earplugs,etc.) and dust protection masks.

- Never let unauthorized people repair, service or operate the machine.

- Any transport, assembly and dismantling is to be made only by trained staff, who shall have specific skill for the specified operation.

- The operator must never leave the machine unattended during operation.

- During any working cycle break, switch the machine off.

- In case of long working cycle breaks, disconnect the general power supply.

- When breakdown happen, please switch the machine off and pull up power line, seek help from professional person. If wood material block machine, please backward material.

- Clean offcut, saw dust timely during operation
- Keep ground around machine clear, no stack flammable and combustible materials.

WARNING Accident caused by unqualified electrical element which connect machine and unconventional installation, manufacturer assumes no responsibility

WARNING Accident cause by change machine function or change spare part arbitrarily, manufacturer assumes no responsibility

WARNING Accident caused by operation under missing part or damage condition, manufacturer assumes no responsibility

2.2 RESIDUAL RISKS

WARNING Despite observance of all the safety regulations, and use according to the rules described in this manual, residual risks may still be present, among which the most recurring are:

- Contact with tool
- Contact with moving parts (belts, pulleys, etc..)
- Recoil of the piece or part of it
- Accidents due to wood splinters or fragments
- Tool insert ejection
- Electrocution from contact with live parts
- Danger due to incorrect tool installation
- Inverse tool rotation due to incorrect electrical connection
- Danger due to dust inhalation in case of working without vacuum cleaner

2.3 SAFETY AND INFORMATION SIGNALS

This signal may be applied on the machine; in some cases they indicate possible danger conditions, in others they serve as indication. Always take the utmost care.


Risk of eye injury. Wear eye protection


Wear hearing protection systems.

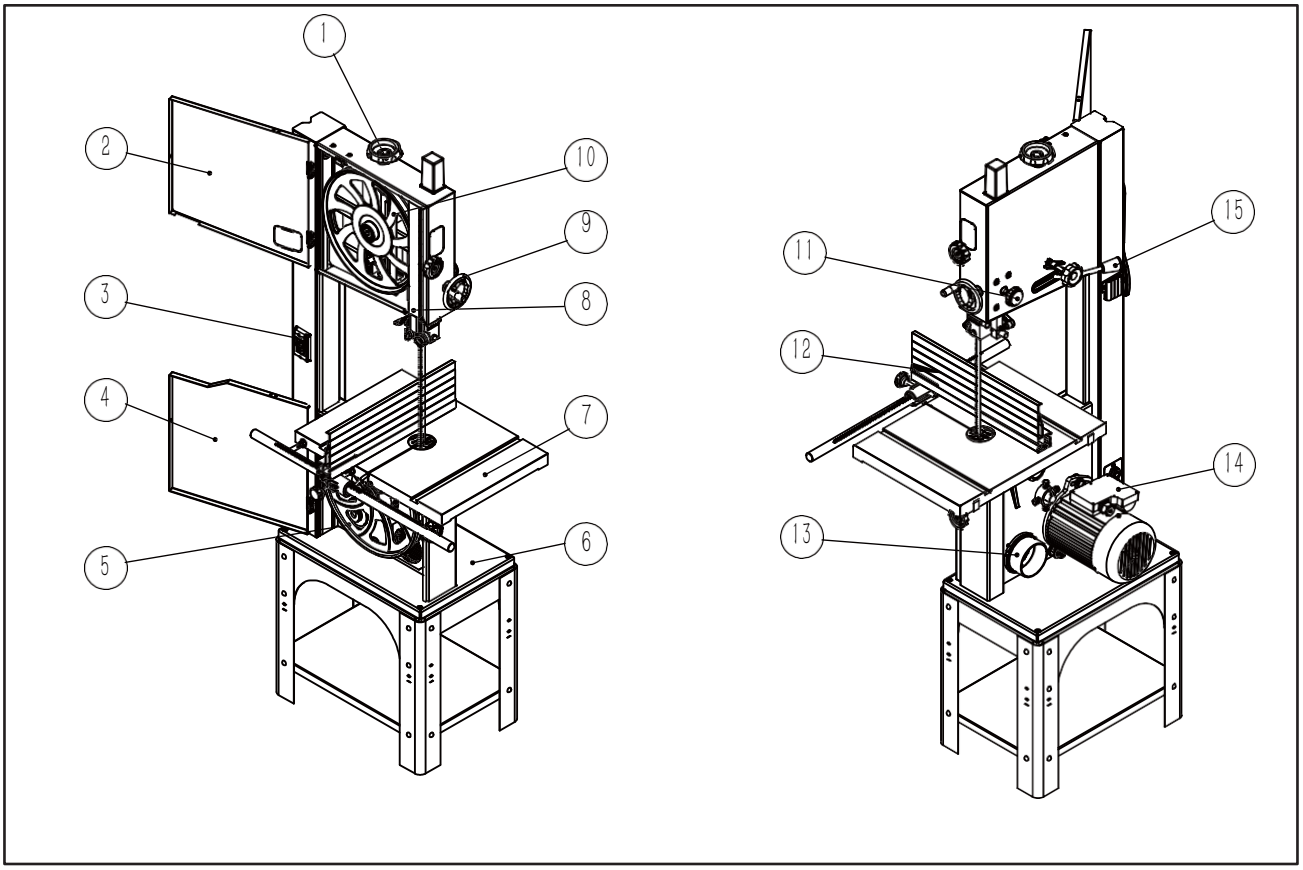

Danger of electric shock. Do not access the area when the machine is powered


Carefully read and understand the manual before using the machine

INFORMATION SIGNALS:
- Indicate the technical characteristics, direction of rotation and inclination, block and release, etc.
- Carefully following the directions to simply the use and adjustment of the machine.
- The signals are graphically described and do not require further explanation.

3. DPECIFICATIONS

3.1 MAIN COMPONENTS



1-Blade tension knob
2-Safety switch (optional)
3-Switch
4-Lower door
5-Lower wheel
6-Under carriage
7-Table
8-Blade guard
9-Lifting knob
10-Upper wheel
11-Lock handle
12-Rip fence
13-Dust port
14-Motor
15-Quick tension handle

3.2 TECHNICAL SPECIFICATION

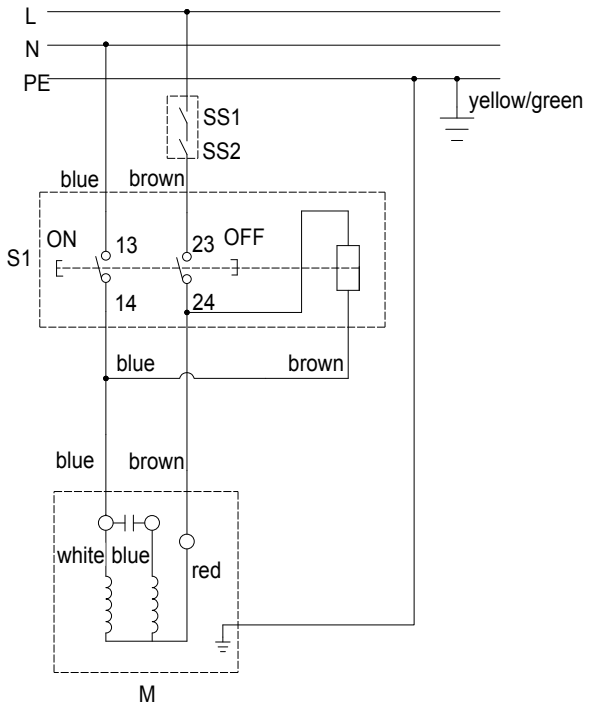
SPECIFICATION	BS350C
Motor voltage	220-240V/50Hz
Power	1-1/2HP
Blade length	2820mm
Blade width	6-19mm
Max. cut depth	330mm
Throat width	345mm
Blade speed	440/900m/min
Table size	400X546mm
Table tilt	-5-45°
Table height to floor	1000mm

3.3 ELECTRICAL CONNECTION

- Electrical installation should be carried out by competent, qualified personnel.
- The mains connection should be made using the terminal box.
- Replacement of the power supply cable should only be done by a qualified electrician.

WARNING

To avoid electrocution or fire, any maintenance or repair to electrical system should be done only by qualified electricians using genuine replacement parts.



3.4 NOISE LEVEL

	No load	load
Sound Pressure Level	< 80dB(A)	< 90dB(A)
Sound Power Level	< 90dB(A)	< 100dB(A)

The noise levels measured are emission levels and not necessarily the safe working level. Although there is a correlation between the emission levels and the exposure levels, this cannot be used reliably to determine whether or not further precautions are required. The factors which affect the actual level of operator exposure include the duration of exposure, the ambient characteristics and other sources of emission, for example, the number of machines and other adjacent machining. The permitted exposure values may also vary from country to country. Nevertheless, this information allows the user of the machine to better evaluate the dangers and risks.
Other factors which reduce exposure to noise are：
- correct tool choice
- tool and machine maintenance
- use of hearing protection systems(e.g. headsets, earplugs,…)

WARNING Please use the hearing protection systems if the above mentioned noise levels exceed 95dB(A).

3.5 DUST EXTRACTION

If this band saw is operated indoors, it is recommended to have it connected to a dust collector. The suction connector, supplied with the machine, has to be fitted to the dust ejection port of the saw for this purpose. The diameter of the suction connector is 100mm.
- People usually process oak or beech wood will have membrane mucosa nasi much easier than others
- Experience shows that skin contact with oak or beech dust does not cause cancer

WARNING Wood dust and chips, together with an ignition source and the oxygen in the ambient air, can cause fires and explosions, injuries and allergies.

4. INSTALLATION

4.1 INSTALLATION ZONE CHARACTERISTICS

WARNING

It is prohibited to install the machine in explosive environments.

The installation zone must be selected evaluating the work space required depending on the dimension of the pieces to be machined, and taking into account that a free space of at least 800mm must be left around the machine. It is also necessary to check the floor capacity and its surface, so that the machine base is evenly resting on its four supports. A power outlet and a chip-suction system connection shall be close to the selected machine setting and it must be conveniently lighted.

4.2 INSTALL OF LOOSE PARTS-INTRODUCTION

A few elements will be disassembled from the machine main structure due to packaging and shipping requirements. These loose parts should be installed as follows.

WARNING

Please tighten all bolts and nuts absolutely. Otherwise, may cause machine wobble or serious injury to the operator or other persons.

4.2.1 INSTALL TABLE

Tools required for assembly:

- Faucet spanner
- Put the table A onto the trunnion. Aline the mounting holes which are on the bottom of table to the four holes on trunnion.
- Use four hex bolt 1, four teeth washer 2 and four flat washer to mount the table A to trunnion.

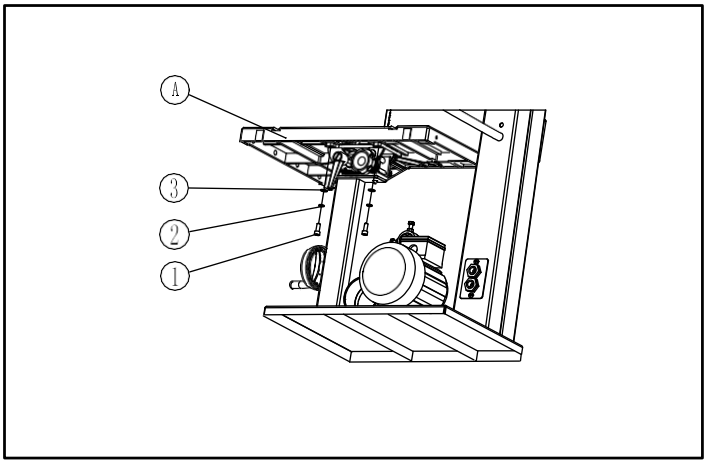


Fig.4.2.1

4.2.2 INSTALL FRONT RAIL AND RIP FENCE

- Put nut 2 and washer 3 on front rail 1
- Make front rail through table A, after leveling rail, lock by other nut and washer.
- Along with rail A, slide RIP FENCE B on the table

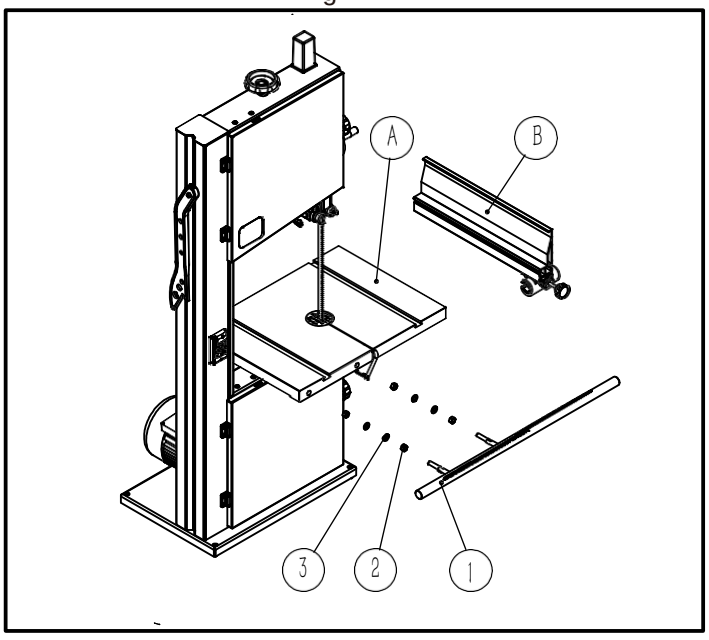


Fig.4.2.2

5. ADJUSTMENT AND OPERATION

WARNING

Handle the tools with protective gloves.

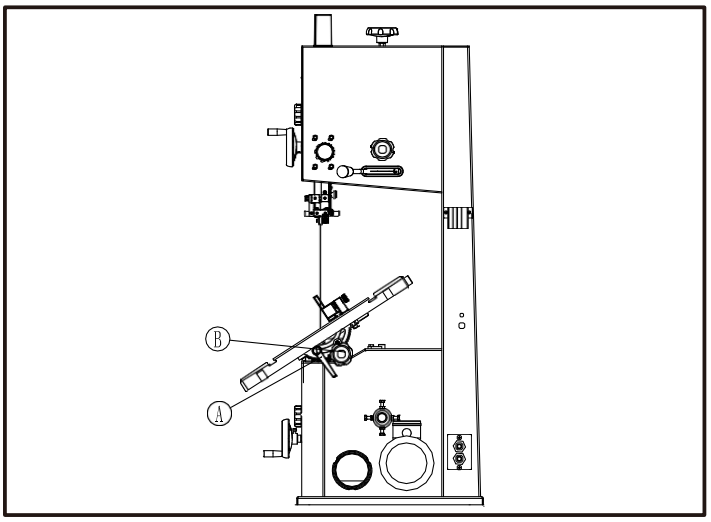


Fig.5.1

5.1 CENTERING TABLE AND TILTING

- Centering table can be adjusted. Loosen the four bolts which hold the lower table trunnion, and adjust freely. Place the blade in the middle of the faucet and make it be parallel to the slotted side of table.
- The table can be tilted from 0 to 45 degree. To tilt, loosen the wing nut A of the table trunnion. Tighten the wing nut again when we get the required angle.
- It is recommended to verify the correct angle setting by making trial cuts in scrap wood.

5.2 SETTING TABLE SQUARE WITH BLADE

- Please refer to Fig 5.1
- Loosen the wing nut on the trunnion and check the table with a square and adjust the table at 90 degree with the blade, then adjust the pointer to 0 degree.

5.3 CHANGING AND SETTING THE BLADE

- This band saw is factory-equipped with a general purpose wood cutting blade, the blade set. To change the blade, remove the connect board from the table. Then loose the quick tension handle C and blade tension handle A, take down the blade.
- After change blade, firstly adjust tension handle C, then adjust blade tension handle A, and rotate upper wheel and adjust handle B, make the blade in the middle of rubber wheel position. Then clamp the wing nut on clamp handle B.

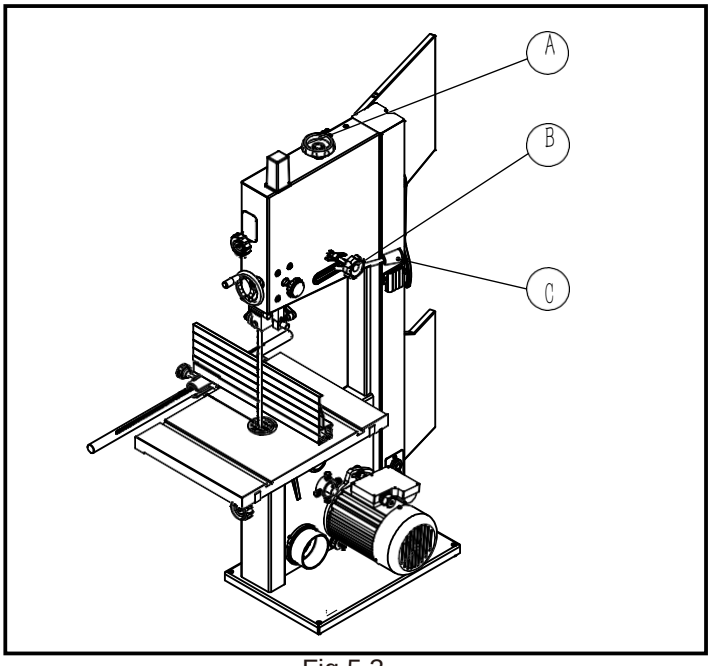


Fig.5.3

5.4 BLADE GUIDING

- The saw blades guides of this band saw ensure an exact guiding of the blade for clean cuts. When using narrow blades, ensure that the lower blade guide positively support the blade from both sides and the rear. Set bearings of the upper blade guide to within approx. 0.5mm of the blade, or the guide bearings will be easily broken.

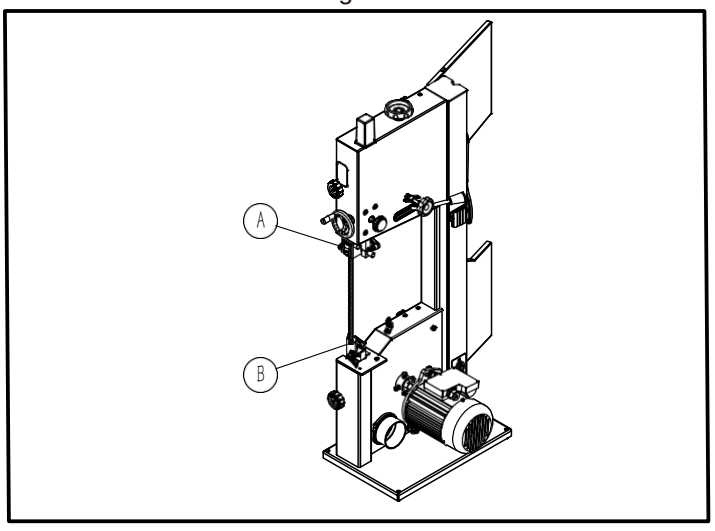


Fig.5.4

5.5 SETTING CUTTING HEIGHT

- The upper blade guide should always be set as close as practical against the work. To adjust, loosen the clamp handle B, rotate handle A to adjust upper guide close to material, tighten handle B.

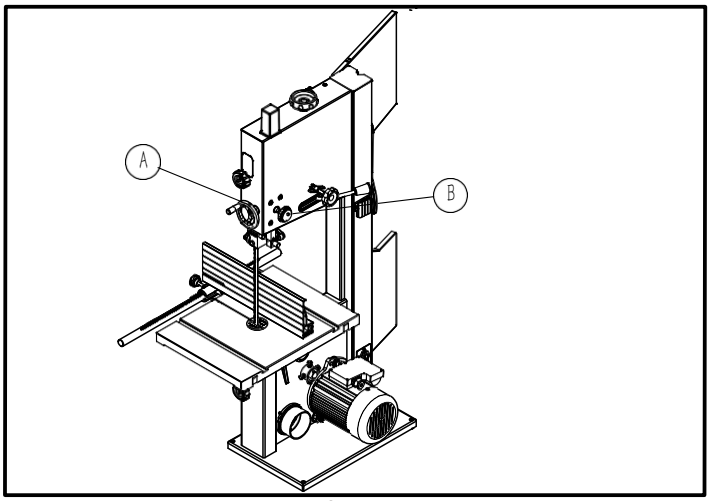


Fig.5.5

6. TROUBLE SHOOTING

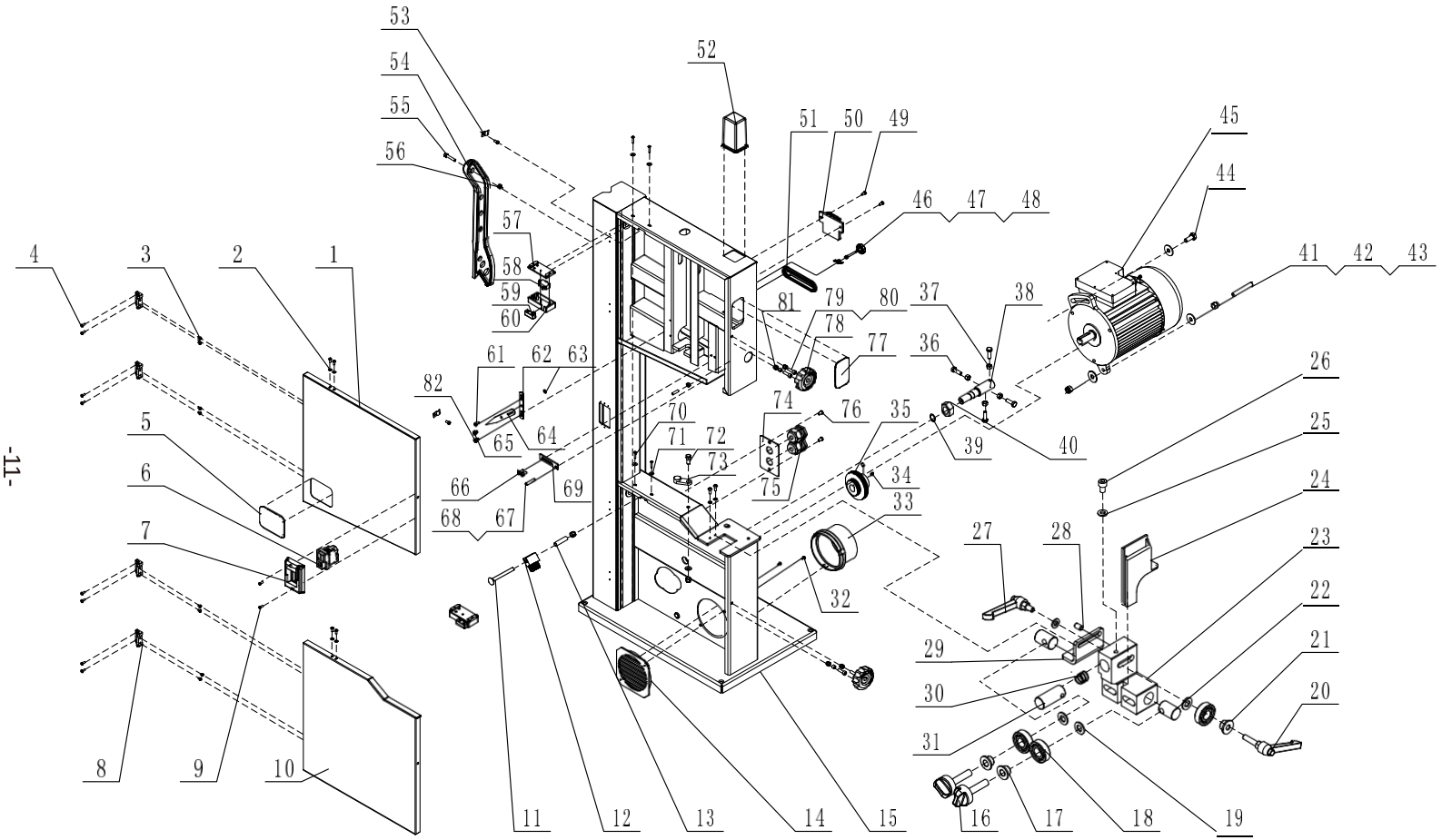
WARNING

- For any information or problem contact your area dealer or our technical service center. The necessary interventions must be carried out by specialized technical personel.
- Before carrying out any fault service or maintenance work, please always TRUN OFF THE SWITCH, UNPLUG POWER CABLE, WAIT FOR SAW BLADE TO COME TO STANDSTILL.

Trouble	Possible Cause	Solution
Saw stops or will not start	1. Saw unplugged	1.Check plug connections
	2. Fuse blown or circuit breaker tripped	2.Replace fuse or reset circuit breaker
	3.Cord damaged	3.Replace cord
Does not make accurate 45° or 90° cuts	1.Stop screw not adjust correctly	1.Adjust stop screw, check angle of blade and table with square
	2.Angle pointer not set accurately	2.Adjust pointer and check blade with square
	3.Miter gauge out of adjustment	3.Adjust miter gauge
Blade wanders during cut	1.Fence not aligned with blade	1.Check and adjust fence
	2.Warped wood	2.Select another piece of wood
	3.Excessive feed rate	3.Reduce feed rate
	4.Incorrect blade for cut	4.Change correct type blade
	5.Blade tension not set properly	5.Set blade tension according to blade size
	6.Guide bearings not set properly	6.Review guide bearing adjustment on pages 8&9
Saw makes unsatisfactory cuts	1.Dull blade	1.Replace blade
	2.Blade mounted wrong	2.Teeth should point down
	3.Gum or pitch on blade	3.Remove blade and clean
	4.Incorrect blade for cut	4.Change correct type blade
	5.Gum or pitch on table	5.Clean table
Blade does not come up to speed	1.Extension cord too light or too long	1.Replace with adequate size and length cord
	2.Low shop voltage	2.Connect with local electric company
Saw vibrates excessively	1.Base on uneven floor	1.Reposition on flat, level surface
	2.Bad V-belt	2.Replace V-belt
	3.Motor mount is loose	3.Tighten motor mount hardware
	4.Loose hardware	4.Tighten hardware

7. Diagrams & Components

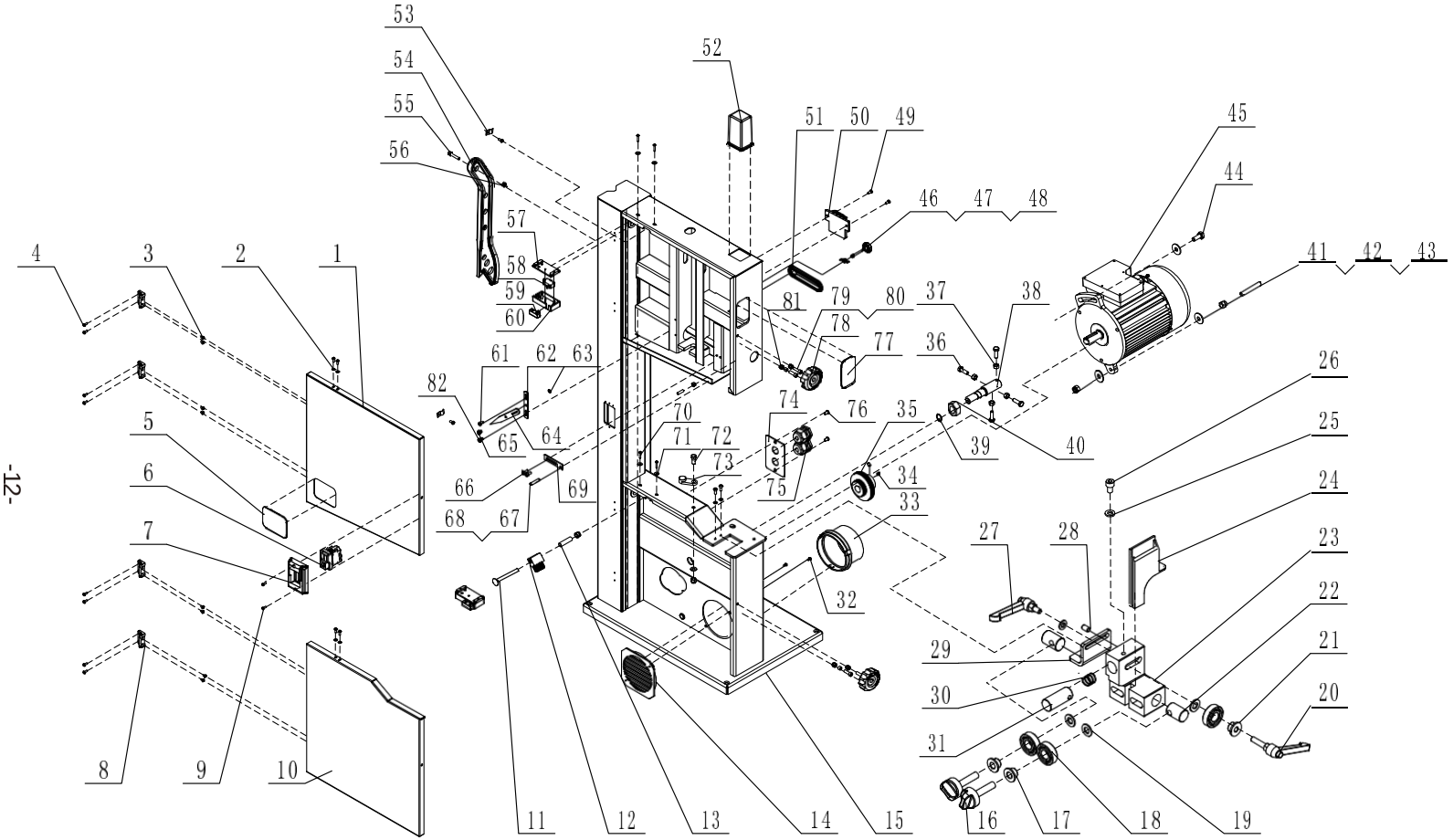
7.1 Machine body composition



No.	Description	Drawing No.	Qty'
1	Upper door	JMBS1404012001-117T	1
2	Flat washer	WSH4GB97D1B	4
3	Screw	M4X6GB818B	8
4	Screw	M4X10GB818B	12
5	Window	JXBS1804010004A	1
6	Magnetic switch	KJD20-2	1
7	Switch panel	JL22090001-001S	1
8	Hinge assy.	JMBS1001013100	4
9	Screw	M4X10GB823B	2
10	Lower door	JMBS1404012002-117T	1
11	Bolt	M8X90GB14B	1
12	Brush	JL20010004	1
13	Sleeve	JL20021008	1
14	Suction rack	JL20010019-001S	1
15	Frame	JMBS1404011000-040V	1
16	Clamp handle	JMBS1403014006-001S	2
17	Bearing bush	JMBS1404013004	2
18	Bearing	BRG6001-2RSGB276	3
19	Flat washer	WSH8GB97D1B	4
20	Adjusting handle	KTSB-1-B-M6X50X25	1
21	Upper sleeve	JMBS1404013005	1
22	Guide shaft	JMBS1404013002	2
23	Lowerguide	JMBS1404013001	1
24	Lower guide shaft	JMBS1404010004-001S	1
25	Flat washer	WSH6GB97D1B	2
26	Screw	M6X10GB70D1B	1
27	Adjusting handle	KTSB-1-B-M6X50X10	1
28	Screw	M6X10GB77B12D9	1
29	Connecting board	JMBS1404010003A	1
30	Spring	JMBS1403014005	1
31	Upper shaft	JMBS1404013003	1
32	Tap screw	ST3D5X9D5GB845B	2
33	Suction port	JL20010007-001S	1
34	Screw	M6X8GB80B12D9	2
35	Motor pulley	JMBS1401020003A	1
36	Bolt	M8X25GB5783B	4
37	Hex nut	M8GB6170B	4
38	Lower wheel axle	JL28020002A	1
39	Spring washer	CLP17GB894D1B	1
40	Hex nut	JL20020004	1
41	Screw	M10X70GB77B12D9	1
42	Nut	M10GB889D1Z-17	2
43	Washer	WSH10GB96D1Z	3
44	Bolt	M10X25GB30Z	1

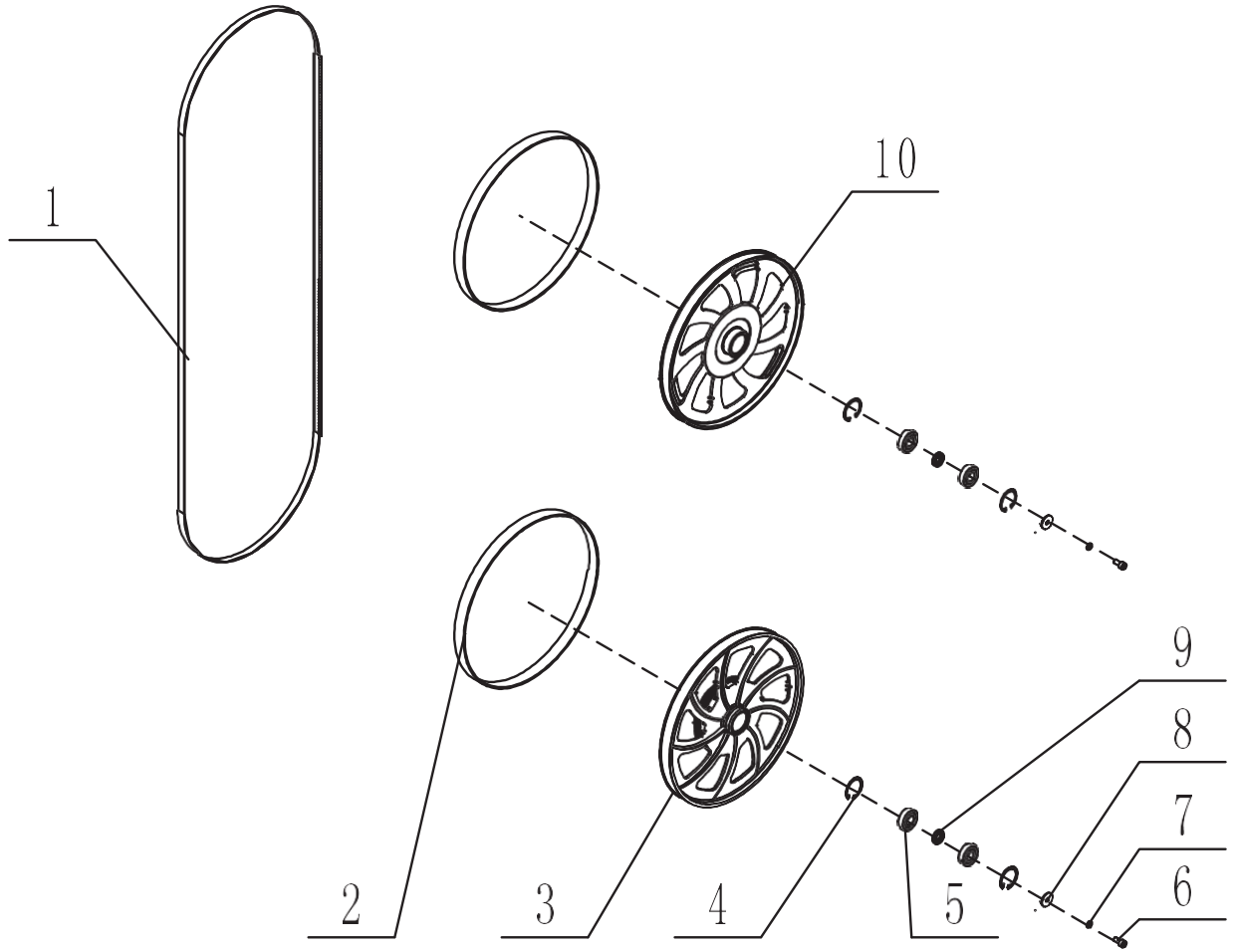
7. Diagrams & Components

7.1 Machine body composition



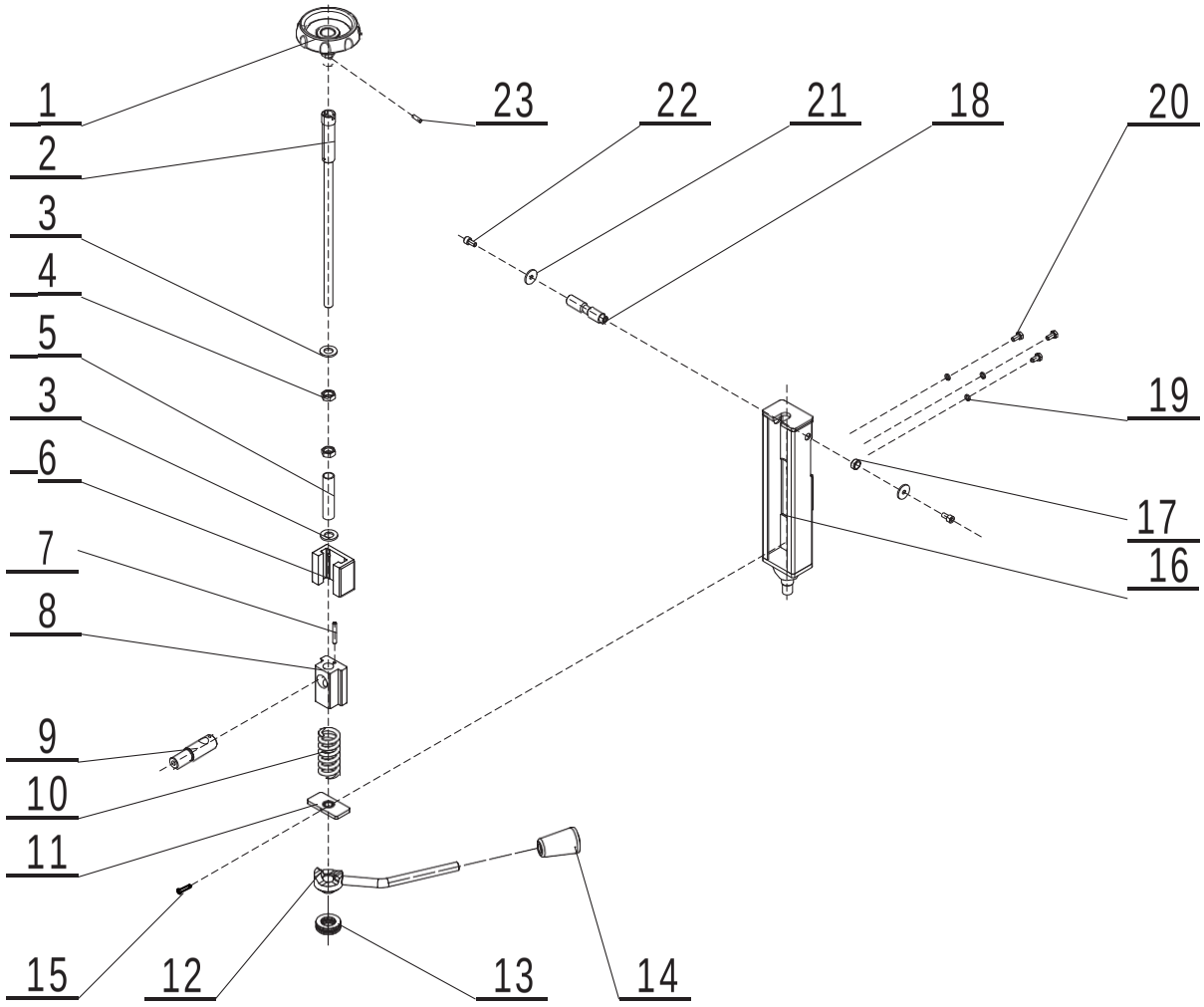
No.	Description	Drawing No.,	Qty'
45	Motor	YYH900114C	1
46	Clamp handle	JL26040015A-001S	1
47	Stud shaft	JL28030005	1
48	Nut	JL20010016A-001S	1
49	Tool rack	JL26090001	1
50	Screw	M5X10GB818B	1
51	Dust guard	JL28010005A-001S	1
52	Upper guide guard	JL28010003-001S	1
53	Pressing plate	1502014-02	1
54	Plastic push handle	JL81100003-146S	1
55	Screw	M6X30GB70D1B	1
56	Nut	M6GB6170Z	2
57	Micro switch lid	JMBS0901010015	1
58	Micro switch	KW3-0Z-2B	1
59	Crown sheet	JMBS0901010013-001S	1
60	Micro switch body	JMBS0901010016	1
61	Screw	M5X8GB818B	1
62	Pointer fix board	JL27010005	1
63	Washer	WSH5GB97D1Z	1
64	Pointer	JL27010004	1
65	Pointer screw	JL26010010	1
66	Screw	M5X12GB70D1B	2
67	Plastic pipe	JXBS2401010018	1
68	Screw	M6X30GB77B	1
69	Connecting board	JMBS1401010004	1
70	Screw	ST3D5X20GB845B	2
71	Washer	WSH4GB96D1B	2
72	Stud shaft	JL26010015	1
73	Cushion block	JL21010014	1
74	Threading board	JL26010011	1
75	Fixed seat	JL91046100	2
76	Screw	M6X10GB70D2B	2
77	Window	JMBS1404010001	1
78	Handle	JL26010006-001S	1
79	Screw	M6X20GB70D1Z	2
80	Nut	M6GB889D1Z	2
81	Cover	JL26010007	1
82	Screw	JL27010019	1
83	Nut	M8GB889D1B	1

7.2 Driving system



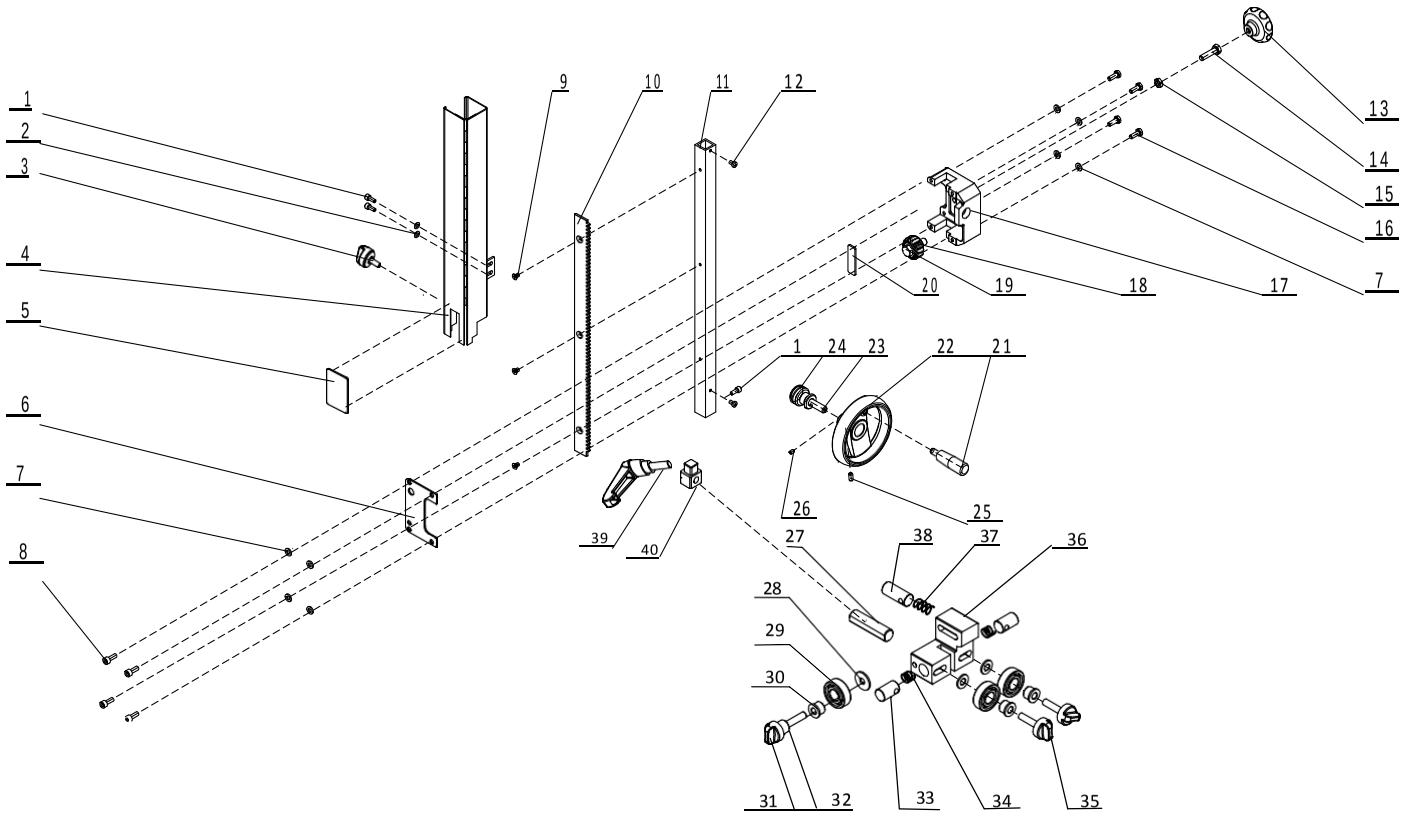
No.	Description	Drawing No.	Qty'
1	Blade	JL28020001B	1
2	Rubber wheel	JL21022002B	2
3	Lower wheel	JL21023002C	1
4	Spring washer	CLP40GB893D1B	4
5	Bearing	BRG6203-2RSGB276	4
6	Screw	M8X16GB70D1Z	2
7	Spring washer	WSH8GB93Z	2
8	Big washer	WSH8GB5287Z	1
9	Distance sleeve of bearing	JL28020004	2
10	Upper wheel	JL21022001A	1

7.3 Tension system



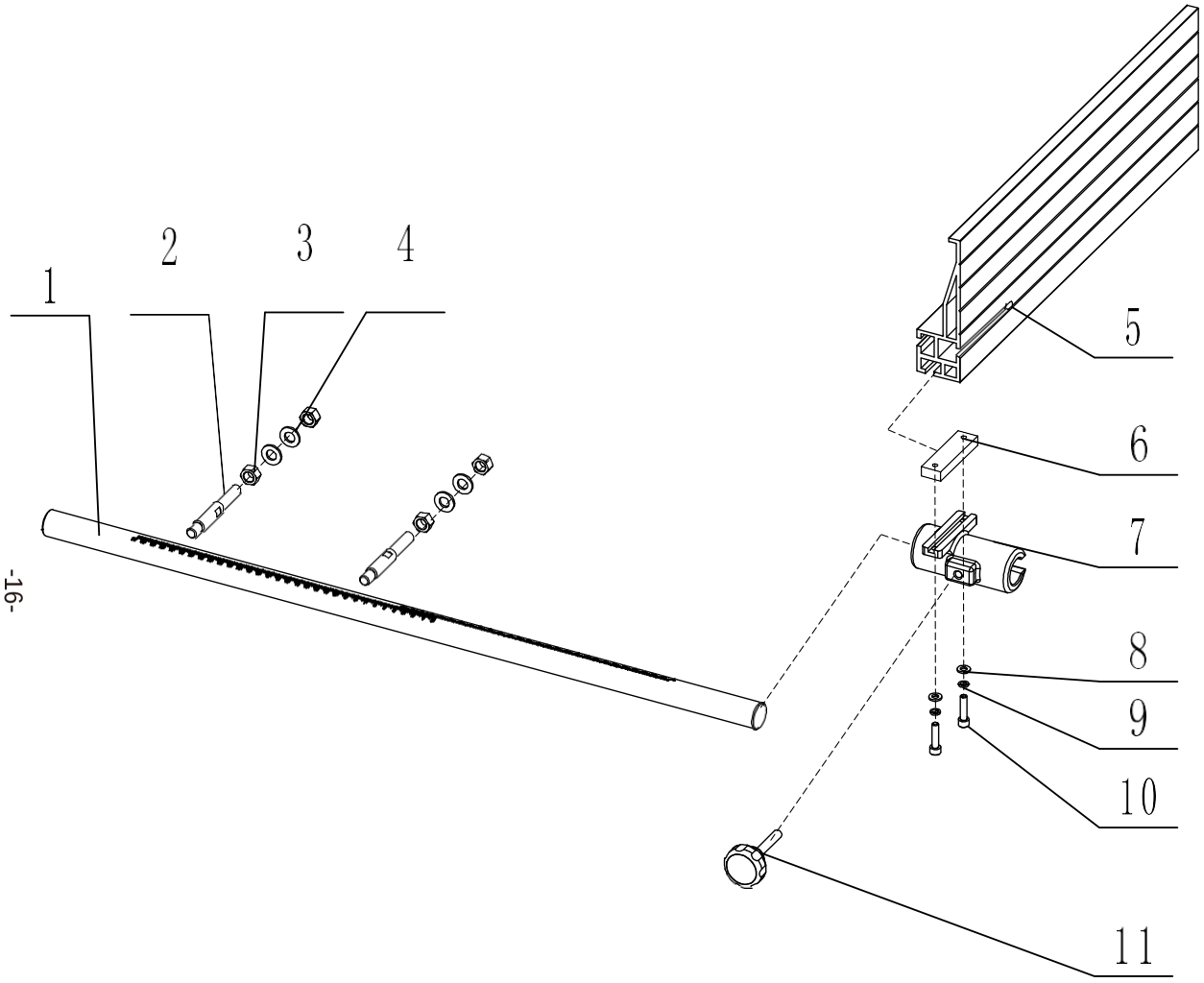
No.	Description	Drawing No.	Qty'
1	Tension handle	JL21025000A-001S	1
2	Connect board	JL28032000B	1
3	Flat washer	WSH12GB97D1Z	2
4	Nut	JL28030003	2
5	Sleeving tube	JL28030001	1
6	Rail	JL28030010	1
7	Pin	PIN5X24GB879D1B	1
8	Sliding block	JL28030007	1
9	Upper shaft	JL28030004	1
10	Spring	JL27030011	1
11	Support board	JMBS1404040100	1
12	Lower block	JL28033000	1
13	Bearing	BRG51104GB301	1
14	Ball	1904011	1
15	Screw	M3X16GB70D2B	1
16	Tension support	JL28031100	1
17	Washer	JL28030009	1
18	Support shaft	JL28030008	1
19	Spring washer	WSH6GB93B	3
20	Bolt	M6X12GB5781B	3
21	Big washer	WSH6GB5287Z	2
22	Screw	M6X12GB70D1Z	2
23	Round pin	JL21025002	1

7.4 Upper guide frame



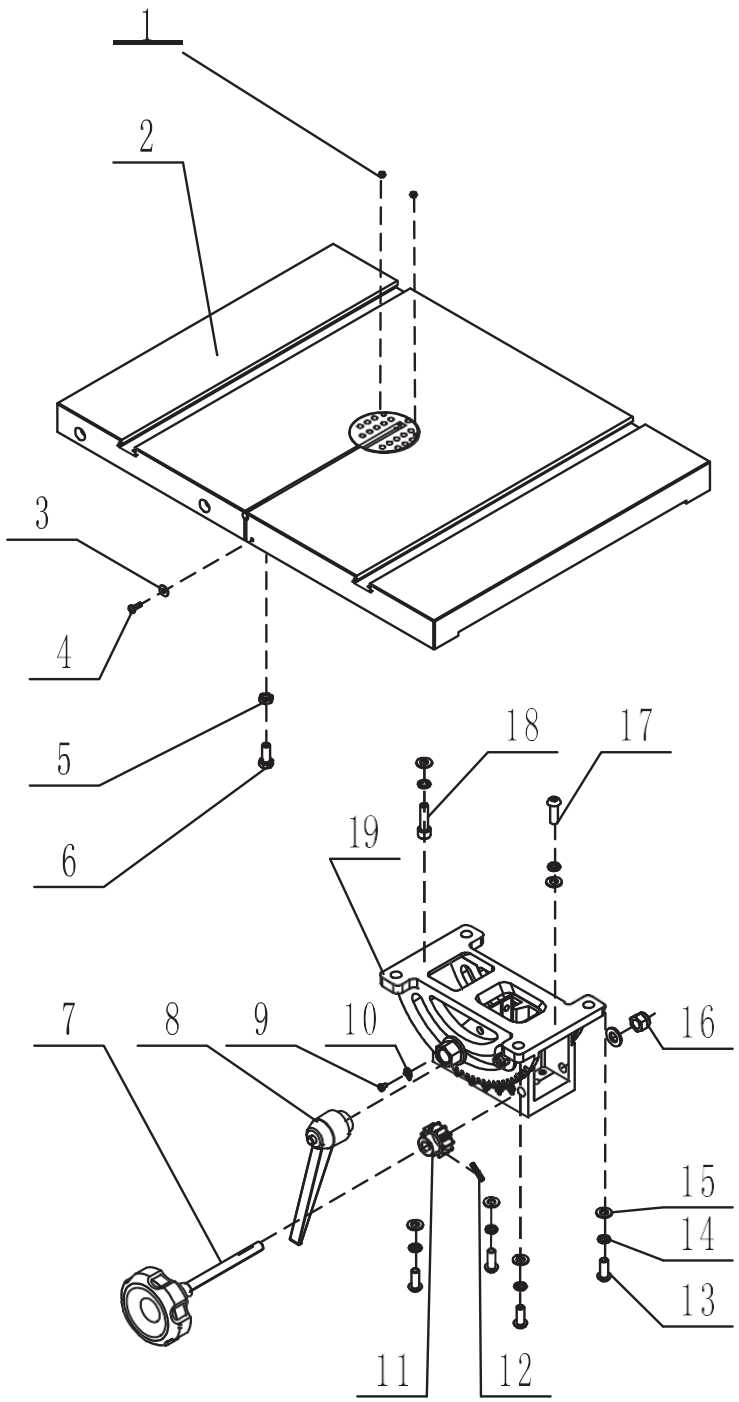
No.	Description	Drawing No.	Qty'
1	Screw	M5X12GB70Z	2
2	Flat washer	WSH5GB97D1Z	2
3	Clamp handle	JL82240011-001S	1
4	Blade guard board	JMBS1404051000A-126T	1
5	Cover	JMBS1404050001	1
6	Base cover	JL27040002A	1
7	Flat washer	WSH6GB97D1Z	8
8	Screw	M6X16GB70Z	4
9	Screw	M5X8GB819B	3
10	Rack	JL28040001A	1
11	Sliding rob	JMBS1404050004	1
12	Screw	M5X8GB818B	2
13	Clamp handle	JL82240011-001S	1
14	Bolt	M8X30GB5781Z	1
15	Nut	M8GB6172Z	1
16	Screw	M6X16GB5783B	4
17	Pinion mount	JL27040006	1
18	Pinion	1501006	1
19	Bolt	JL26040006	1
20	Base plate	JL26040007	1
21	Tiny handle assy.	JL26020014B-001S	1
22	Plastic steel handle	SGSL-D100-d10A	1
23	Worm	JL27040004	1
24	Axle sleeve	JL27040003	1
25	Screw	M6X12GB77B	2
26	Screw	M5X8GB71Z	1
27	Upper guide bar	JMBS1401051002	1
28	Big washer	WSH8GB96D1B	3
29	Bearing	BRG6202-2RSGB276	3
30	Upper bearing bush	JMBS1403014002	3
31	Long clamp handle	JMBS1801052002-001S	1
32	Cushion block	JMBS1403014007	1
33	Guide shaft	JMBS1403014003	2
34	Spring	JMBS1403014005	2
35	Clamp handle	JMBS1403014006-001S	2
36	Upper guide	JMBS1401051001	1
37	Spring	JMBS140301400	1
38	Back guide shaft	8	1
39	Adjusting handle	KTSB-1-B-M8X50X15	1
40	Pressure pin base	JMBS1401050001	1

7.5 Rip fence assembly



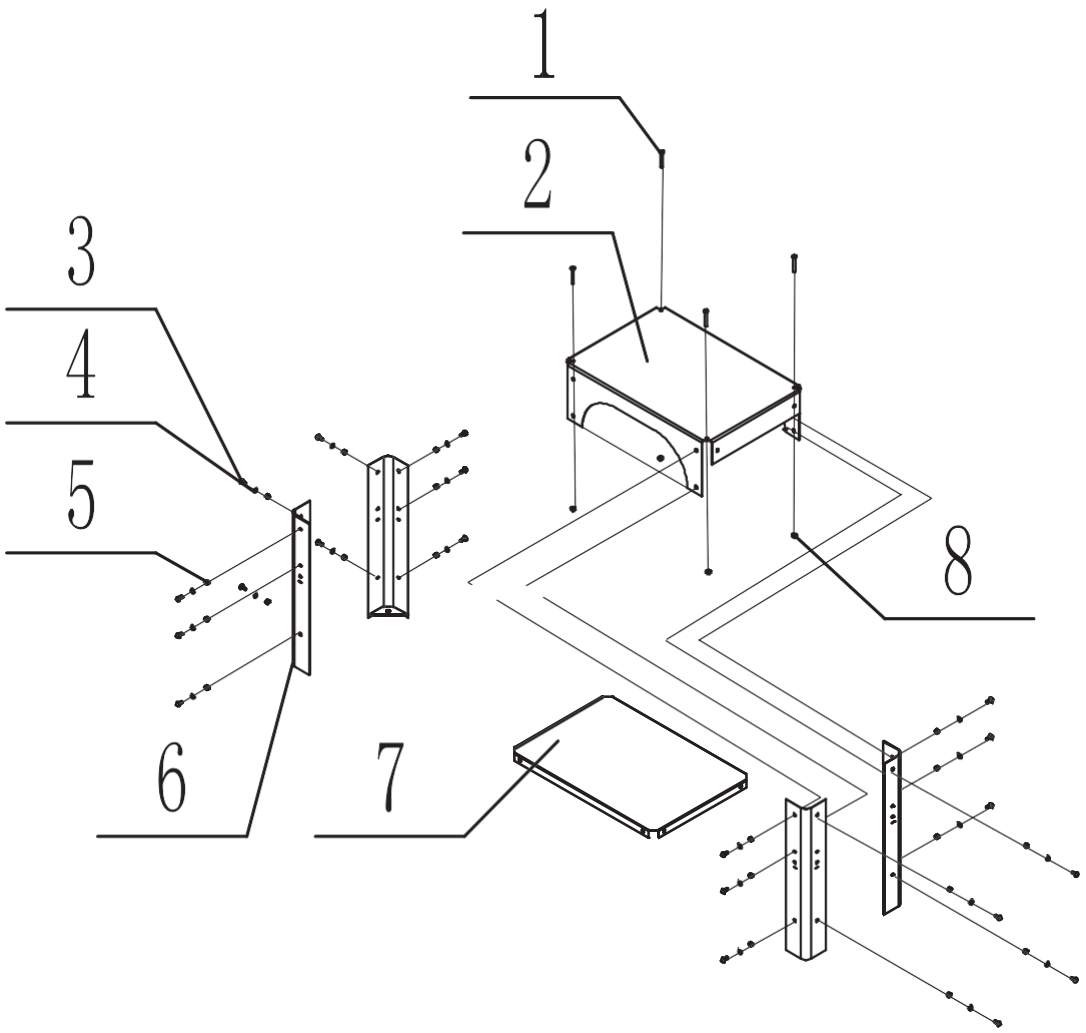
No.	Description	Drawing No.	Qty'
1	Front rail	JMBS1404060004	1
2	Joint lever	JXBS2001060003	2
3	Nut	M10GB6170Z	4
4	Flat washer	WSH10GB97D1Z	4
5	Fence	BS5001060001	1
6	Clamp board	JMBS1404060003	1
7	Handle base	JMBS1601060003	1
8	Flat washer	WSH6GB97D1Z	2
9	Spring washer	WSH6GB93Z	2
10	Screw	M6X25GB70D1Z	2
11	Brass bolt handle	JL28060017	1

7.6 Table



No.	Description	Drawing No.	Qty'
1	Screw	M6X4GB77B12D9	2
2	Table	JMBS1404030100A-001G	1
3	Big washer	WSH4GB96D1Z	1
4	Screw	M4X10GB818Z	1
5	Hex nut	M8GB6170B	1
6	Hex bolt	M8X20GB5781B	1
7	Handle	JL26050006-001S	1
8	Clamp handle	KTSB-1-A-M12X95	1
9	Tap Screw	ST2D9X6D5GB845B	1
10	Pointer	JL26050005A	1
11	Steering gear	JL28070003	1
12	Pin	PIN3X18GB879D1B	1
13	Screw	M8X20GB70D2B	4
14	Spring washer	WSH8GB93B	6
15	Flat washer	WSH8GB97D1Z	7
16	Nut	M8GB889D1Z	1
17	Screw	M8X25GB70D2Z	1
18	Screw	M8X25GB70D1Z	1
19	Bogie base assy.	JL27054100	1

7.7 Box-type under carriage



No.	Description	Drawing No.	Qty'
1	Screw	M6X40GB70D3Z	4
2	Upper frame	JMBS1404100001A	1
3	Screw	M6X16GB12Z	20
4	Flat washer	WSH6GB97D1Z	20
5	Nut	M6GB6170Z	20
6	Support assy.	JMBS1404100300A	1
7	Clap board	JMBS1404100008	1
8	Nut	M6GB6177D1Z	4