



# OWNERS MANUAL



## B2016 – 24” WOOD BAND SAW



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## **GENERAL SAFETY INSTRUCTIONS**

**EXTREME CAUTION SHOULD BE USED IN OPERATING ALL POWER TOOLS. KNOW YOUR POWER TOOL, BE FAMILIAR WITH ITS OPERATION. READ THE OWNER'S MANUAL AND PRACTICE SAFE USAGE PROCEDURES AT ALL TIMES.**

- ❑ **CONNECT** your machine **ONLY** to the matched and specified power source.
- ❑ **WEAR SAFETY GLASSES, RESPIRATORS, HEARING PROTECTION** and **SAFETY SHOES** when operating heavy machinery. **Always wear safety glasses.**
- ❑ **DO NOT** wear loose clothing or jewellery when operating machinery.
- ❑ **A Safe Environment is important.** Keep the area free of dust, dirt and other debris in the immediate vicinity of the machine.
- ❑ **BE ALERT!** Do Not Use prescription or other drugs that may affect your ability or judgement to safely use this machine.
- ❑ **DISCONNECT** the power source when changing drill bits, hollow chisels or making other adjustments or repairs.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **NEVER** reach over the table when the tool is in operation.
- ❑ **ALWAYS** keep blades, knives or bits sharp and properly aligned.
- ❑ **ALWAYS** keep all safety guards in place and ensure their proper function.
- ❑ **ALWAYS** use push sticks and featherboards to safely feed your work through the machine.
- ❑ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❑ **ALWAYS** secure your work with the appropriate clamps or vises.
- ❑ **ALWAYS** keep bystanders safely away while operating machinery.
- ❑ **THINK SAFETY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

# **INTRODUCTION**

As part of the growing line of **Craftex** woodworking equipment, we are proud to offer the B2016. The **Craftex** name guarantees **Craft Excellence**. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The B2016 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

## **FEATURES**

- ❑ Formed and Welded High Strength Steel Frame.
- ❑ Motor – 3HP, 220-volt single phase, 2 speed belt drive.
- ❑ Motor Speed - 3450 RPM.
- ❑ Motor Switch – Magnetic.
- ❑ Blade Speeds – 2,800 & 3,500 RPM's.
- ❑ Table – Precision Ground Cast-Iron.
- ❑ Table Size – 21" x 26", Cast Iron, Surface Ground.
- ❑ Table Height – 35 1/2".
- ❑ Table Tilts – 0 – 45 Degrees Right.
- ❑ Throat Depth – 23 1/2".
- ❑ Maximum Cutting Height – 13".
- ❑ Blade Size – Up To 1 1/4" Wide x 176 1/4" Long.
- ❑ Fence – Cast-Iron, Dimensions – 17 1/2" x 3".
- ❑ Machine Height – 80".
- ❑ Miter Gauge – 'T'-Slot Included.
- ❑ Foot Brake.
- ❑ Dust Port.
- ❑ Gross Weight – 320kg.
- ❑ Crate Size – 28" x 39" x 87".

## Features Identification



## OPERATING INSTRUCTIONS

Congratulations on the purchase of your B2016, 24" Band Saw. Like all Craftex products, the B2016 will give you years of excellent service. Your B2016 has been shipped fully assembled except for the included 176 1/4" blade. Instructions for blade installation will soon follow.

### UNPACKING

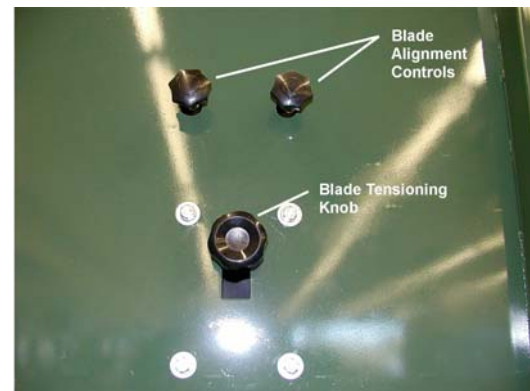
The B2016 should be placed in its final operating position in its crate due to the extreme weight of the machine. Care should be taken to unpack the band saw as the crate wood contains some very sharp nails and the rough wood may splinter. Care should be taken to position your band saw on a level surface and on solid ground which can support the B2016's 320kg weight.

### CLEANING

Your B2016 band saw is packed with a protective lubricant on some of the exposed metal surfaces. This lubricant may be removed with mineral spirits and then carefully dried. A coating of paste wax should be applied to the affected areas and then buffed dry. Paste wax will help to prevent oxidation of the cast-iron surfaces in damp conditions.

### BLADE INSTALLATION

**Disconnect the band saw from the power source.** Open both the upper and lower blade wheel doors and remove the table insert. Loosen the saw blade tension control and carefully insert the band saw blade through the table slot with the saw blade teeth facing outward. **The saw blade must sit on the center of the upper and lower wheels** and between the blade bearing guides.



### FINE TUNING THE BLADE

Once the blade is on both the upper and lower wheels, the blade must be positioned between both the upper and lower blade guides. Tension the blade by turning the blade-tensioning knob in a clock-wise direction. Rotate the blade slowly by hand to determine the position of the blade on the wheels and tires.

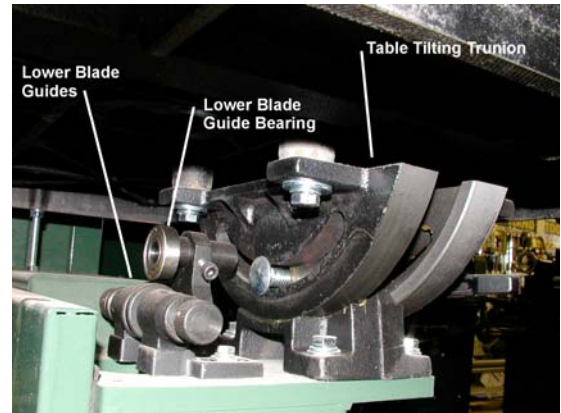
**Adjust the blade alignment controls to position the blade on the center of the crest of the tires.**

Adjust the upper and lower blade guides so that they sit just behind the gullets of the saw blade. Adjust them so that they just touch the blade and do not hinder the vertical alignment of it.



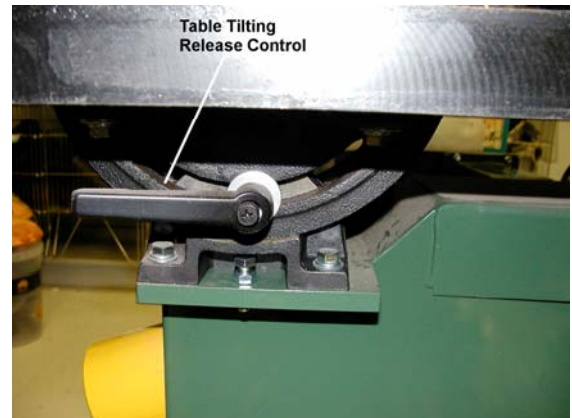
## OPERATING INSTRUCTIONS, Continued

Adjust the rear upper and lower blade guide bearings so that they just touch the rear edge of the saw blade.



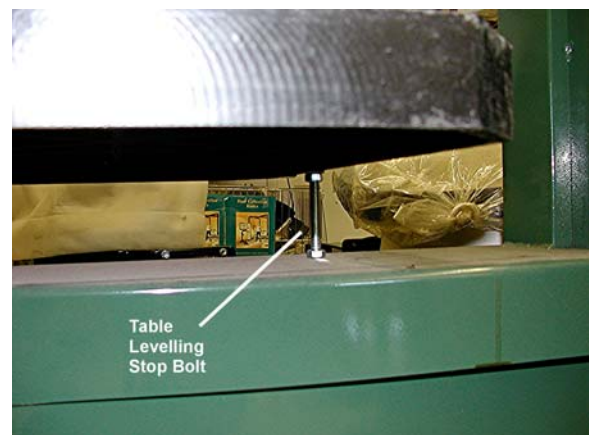
### TABLE LEVELING

Once the blade has been installed, it is now important to make sure that the cast-iron table is square to the saw blade. Raise the blade guard and use a try square to verify the accuracy. If there is any variation, loosen the table tilting trunion release lever until the table is level. Tighten the release lever.



To ensure that the saw table returns to a level (90°) after selecting other table angles, there is a stop-bolt situated under the rear of the cast-iron saw table. Adjust the nuts on the bolts accordingly.

The table should be checked for square periodically.



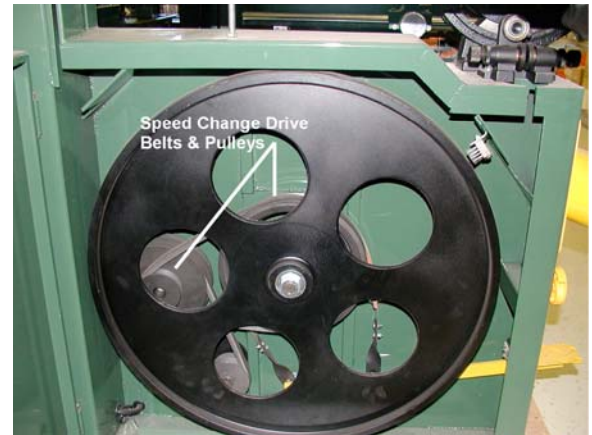
## OPERATING INSTRUCTIONS, Continued

### SAWING

The operator of the B2016 has a choice of using on of two speeds (2,800 & 3,500 RPM's) for the type of work he/she is doing or the type of wood species being cut.

To change speeds, ***disconnect the machine from its power source*** and open the lower wheel door.

The idler pulley & the motor have a tension adjustment mechanism from the back of the machine. The machine comes set on the 1<sup>st</sup> speed. (2,800 RPM) To change to the faster speed (3,500 RPM) put the belt on the larger groove on the motor pulley & the smaller on the idler pulley. Tighten before closing the door, and eye & feel for security.



### BLADE GUARD

The B2016 is equipped with a rack and pinion blade guard that is raised and lowered with a blade guard elevator wheel located on the rear side of the upper frame. Rotating the wheel in a clockwise direction will raise the guard and conversely, a counter-clockwise direction will lower it. There is a lock-knob to secure the guard where required.

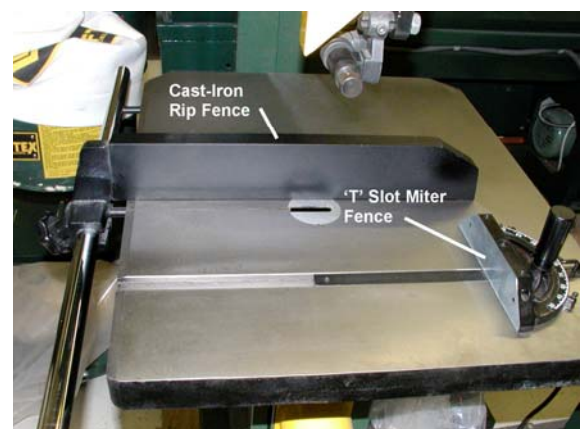
The blade guard should be positioned approximately 1/4" above the work piece.



### RIP FENCE / MITER GAUGE

The B2016 comes equipped with a cast-iron Rip Fence as standard equipment and is pre-assembled to the saw fence. The knob on the front of the fence will loosen the fence for re-positioning. The B2016 Rip Fence may be used on either side of the saw blade.

The miter gauge is also standard equipment included with the band saw. The miter gauge is the 'T' slot type and has a number of features to be utilized. There are 'positive' stops on the gauge that may be adjusted for accuracy. The 'washer' on the tail of the gauge may be removed if necessary by loosening the screw under the tail.

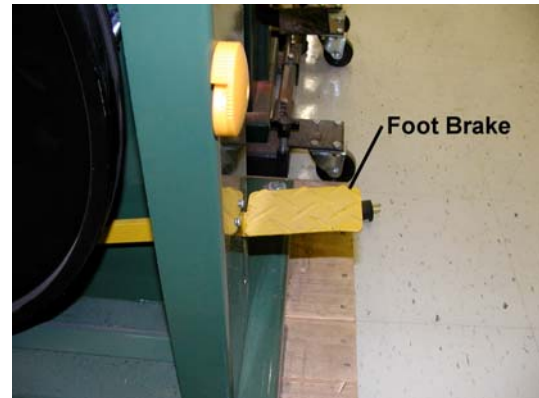




## OPERATING INSTRUCTIONS, Continued

### FOOT BRAKE

The B2016 is a well-balanced machine and as such, the wheels and blade of the machine may continue to run on for a few seconds after the magnetic power switch has been turned off. A foot brake located in the lower front of the machine has been provided so that in the event you wish to quickly stop the blade from turning, it is very accessible and easy to operate. Simply step down on the brake.



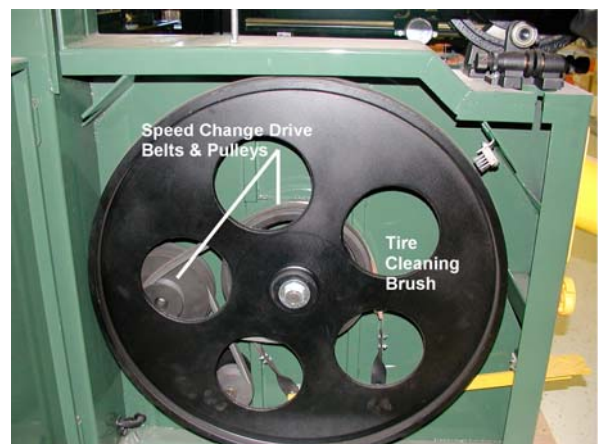
### DUST MANAGEMENT

Sawdust may be a toxic substance depending on the amount and the species of wood that is being cut. Your B2016 has a built in dust port conveniently located in the lower front of the machine. Your dust collection system may be directly connected to this port on its own through various adapters.



### TIRES

Although it is normal for a band saw to generate saw dust in its operation, that same sawdust might be damaging to the machine itself. This is especially true for those neoprene tires on the band saw wheels. Sawdust may build-up between the saw blade and the tires and may cause an imbalance and/or vibrations in the wheels. Craftex has installed a built in brush to alleviate this potential problem. However, it is important that the user of the B2016 check the efficiency of this on a regular basis. This problem is very simple to avoid. Again, when checking something of this nature, ***make sure the power source is disconnected!***



## **OPERATING INSTRUCTIONS, Continued**

### **POWER**

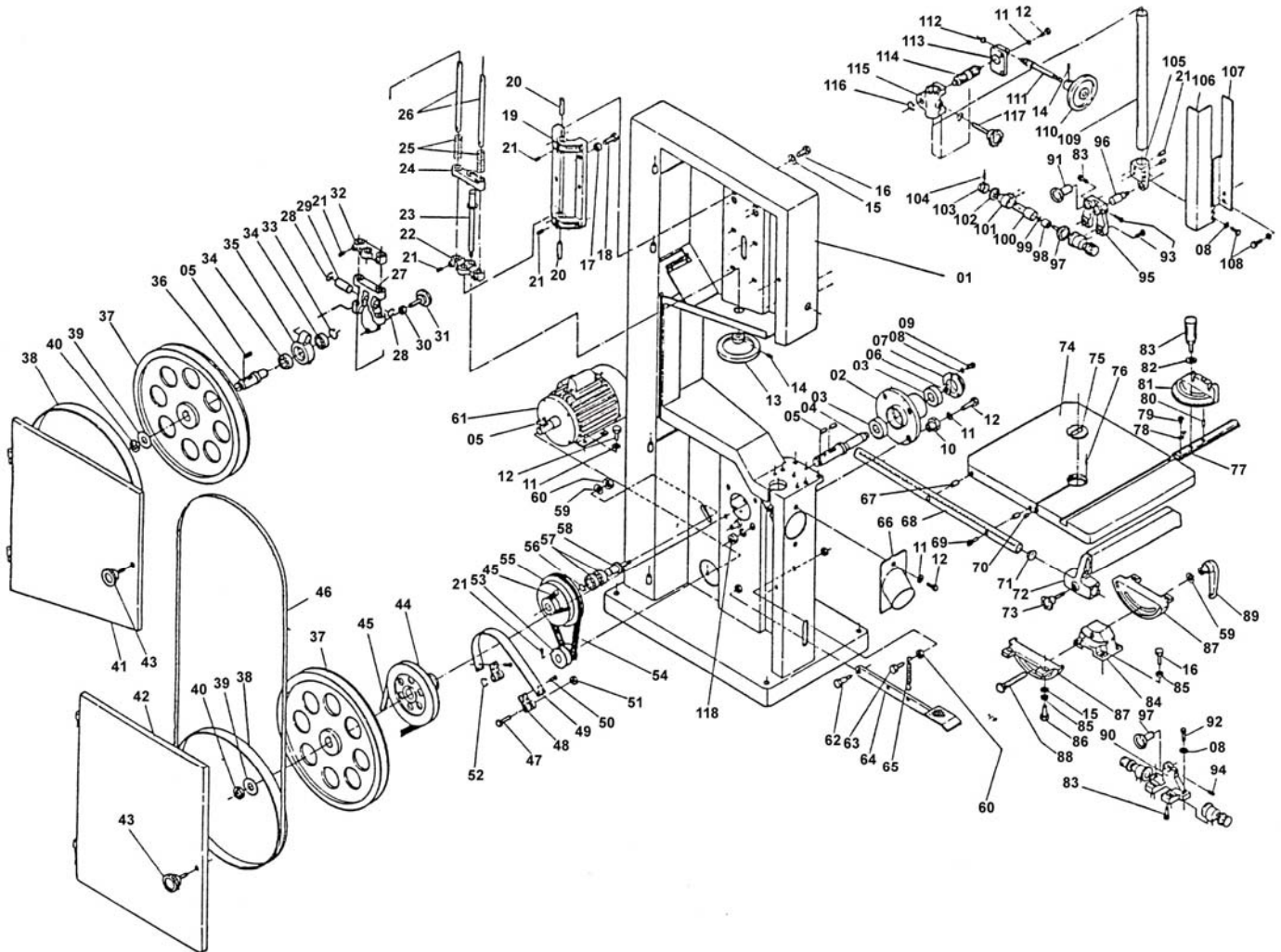
A powerful three horsepower, 220-volt, single-phase motor that is activated by a magnetic switch mounted on the frame of the machine powers the B2016. The switch is pre-wired but must be hard-wired to your electrical power source.



**IMPORTANT – DO NOT MAKE ANY ALTERATIONS TO THE B2016 WHILE CONNECTED TO THE ELECTRICAL POWER SOURCE.**



# B2016 – SCHEMATIC DIAGRAM



# B2016, 24" WOOD CUTTING BANDSAW

## Parts List

Part No.	Description	Qty.	Part No.	Description	Qty.
01	Body	1	60	Hex Nut 1/2"	4
02	Bearing Base	1	61	Motor	1
03	Bearing – 6305z	2	62	Hex Screw – 1/2 x 1 1/2	1
04	Shaft	1	63	Hex Screw – 1/2 x 1 1/2	1
05	Key – 7 x 7 x 30	4	64	Brake Pedal	1
06	Hex Nut – 3/4" 16NF, RH	1	65	Spring	1
07	Bearing Cover	1	66	Dust Chute	1
08	Spring Washer – 1/4"	13	67	Bushing	2
09	Pan Screws – 1/4" x 1/2"	7	68	Fence Guide Rod	1
10	Cover	1	69	Bolt Screw	2
11	Washer	10	70	Set Screw	1
12	Hex Screw – 3/8" x 1"	10	71	Rod Bushing	2
13	Adjusting Wheel	1	72	Fence	1
14	Set Screw – 1/4" x 3/8"	2	73	Locking Screw	1
15	Washer	10	74	Saw Table	1
16	Bolt 3/8" x 1"	10	75	Table Insert	1
17	Hex Nut - 5/16"	2	76	Spring Pin	2
18	Hex Screw – 5/16" x 1/2"	2	77	Miter Gauge Bar	1
19	Upper Wheel Bracket Base	1	78	Pointer	1
20	Bracket Shaft	2	79	Pan Screw – 2/16" x 3/8"	1
21	Set Screw – 5/16" x 3/8"	9	80	Pin	
22	Adjustable Bracket	1	81	Miter Gauge	1
23	Adjusting Screw	1	82	Washer	1
24	Elevator Bracket	1	83	Locking Screw	1
25	Spring	2	84	Table Gauge Brkt.	1
26	Guide Spindle	2	85	Spring Washer	8
27	Upper Wheel Guide Brkt	1	86	Hex Screw – 3/8" x 1 1/4"	4
28	'C' ring – S-20	2	87	Trunion	2
29	Lever Shaft	1	88	Carriage Bolt	1
30	Hex Nut – 3/8"	1	89	Locking Handle	1
31	Lock Screw – 3/8" x 1 1/2"	1	90	Lower Guide Bracket	1
32	Upper Adjustable Bracket	1	91	Blade Support Shaft	2
33	'C' ring – s-25	1	92	Hex Screw – 1/4" x 1"	2
34	Bearing – 6205z	2	93	Bolt – 1/4" x 1/2"	10
35	Upper Wheel Bearing Base	1	94	Set Screw – 1/4" x 1/2"	1
36	Upper Wheel Shaft	1	95	Upper Guide Bracket	1
37	Blade Wheel	2	96	Locking Shaft	1
38	Rubber Tire	2	97	Guide Wheel	6
39	Washer	2	98	Bushing	6
40	Hex Nut 3/4" 16NF, LH	2	99	E-Ring – E-6	6
41	Upper Guard	1	100	Adjustable Guide Shaft	4
42	Lower Guard	1	101	Guide Bracket	4
43	Cross Knob	2	102	Locking Nut	4
44	Brake Wheel	1	103	Adjustable Bushing	4
45	V-Belt B36	1	104	Pin	4
46	Blade	1	105	Guide bar bracket	1
47	Hex Screw – 1/4" x 1 1/2"	1	106	Blade Guard	1
48	Brake Belt Lock	2	107	Blade Inter Guard	1
49	Brake Belt	1	108	Hex Screw – 1/4" x 5/8"	4
50	Rivet	6	109	Guide Bar	1
51	Hex Nut	1	110	Elevator Hand Wheel	1
52	C-ring – S-12	1	111	Worm Gear	1
53	Motor Pulley	1	112	C-ring S-12	1
54	V-Belt B-36	1	113	Gear Base	1
55	Intermediate Wheel	1	114	Gear	1
56	C-ring S-20	1	115	Guide bar case Bracket	1
57	Bearing 6204z	2	116	C-ring S-15	1
58	Intermediate Wheel	1	117	Locking Screw	
59					

## B2016, 24" WOOD BAND SAW

*Accessories available from Busy Bee Tools for your B2016*

<u>BLADES</u>	<u>WIDTH</u>	<u>PITCH</u>	<u>GAUGE</u>
B2016014	¼"	6 Hook	0.25"
B2016038	3/8"	4 Hook	0.25"
B2016012	½"	3 Hook	0.25"
B2016034	¾"	3 Hook	0.32"
B2016100	1"	2 Hook	0.35"
B2016114	1 ¼"	¾ Hook	0.35"



### SAW BLADE LUBRICANT STICK

This wax stick is specially compounded to keep metal, plastic and wood cutting blades from clogging because of chips or pitch. Smoother, quicker, cuts on metal, plastic or wood. Use on band, scroll, circular, hack or jeweler's saws. Round – 1" x 8" approx.

Model AC70010



## SAFETY EQUIPMENT

### Safety Push Stick

Keep your hands safe while still supporting your work piece.

Model B2007



### Disposable Dust Masks

Lightweight, elastic headband, disposable, custom fitting.

Model

B13585 Pkg. of 5

B135850 Pkg. of 50



### Safety Goggles

Flexible impact goggles can be worn over eyeglasses.

Model B547



## CRAFTEX - Dust Collection Systems

These powerful lower noise factor dust collection systems are portable or may be set up in semi-permanent locations. Rigid pipe connectors are ideal for fixed installations with flex pipe to machine. Shake dust from top bag and remove dust and chips from lower bag only. New dust bags reduce to 1 micron the size of dust particles entering your workplace from the collector. New polyethylene (lower) bags are transparent and allow visual inspection of the contents. For more dust collection systems and air purification mechanisms, please visit our web site @ [busybeetools.com](http://busybeetools.com) or call us Toll Free – **1-800-461-BUSY (2879)**



**CT029N**  
1HP, 110V,  
1PH  
825 CFM,  
62dB  
1 micron  
**3 Year**  
**Warranty**



**CT030**  
2HP, 220V,  
1PH  
1596 CFM,  
77dB  
1 micron  
**3 Year**  
**Warranty**



**CT031**  
3HP, 220V,  
1PH  
2300 CFM,  
85dB  
1 micron  
**3 Year**  
**Warranty**



## ***CRAFTEX 2 YEAR LIMITED WARRANTY***

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **two years** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.

*Proof of purchase is necessary.*

All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.

This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etceteras. Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

### **RETURNS, REPAIRS AND REPLACEMENTS**

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom. Craftex is a brand of equipment that is exclusive to Busy Bee Tools.

For replacement parts directly from Busy Bee Tools, for this machine, please call 1-800-461-BUSY(2879), and have your credit card and part number handy.

- All returned merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.
- Returns must be pre-authorized by us in writing.
- **We do not accept collect shipments.**
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse (see locations on inside back cover of this manual).
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labour.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.
- For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repairs.

**BUSY BEE TOOLS - - SHOWROOMS -Coast to Coast****Head Office**

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**Ottawa**

2251 Gladwin Crescent, Ottawa, Ontario, K1B 4K9  
Tel. – 613-526-4696, Fax – 613-731-8636

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1398 Wellington Road, London, Ontario, N5E 1M5  
Tel. – 519-659-9868, Fax – 519-659-0771

**Dartmouth**

133 Ilsley Avenue, Dartmouth, Nova Scotia, B3B 1S9  
Tel. – 902-468-8088, Fax – 902-468-8830

**Barrie**

21 Commerce Park Drive, Barrie, Ontario, L4N 8X1  
Tel. – 705-730-0498, Fax – 705-730-0495

**Pickering**

1064 Salk Road, Pickering, Ontario, L1W 4B5  
Tel. – 905-831-9582, Fax – 905-831-4292

**Calgary**

2611 Hopewell Place, N.E, Unit#109, Calgary, Alberta, T1Y 7K3  
Tel – (403) 250-1986, Fax – (403) 250-7768

**We have been serving the Canadian woodworking and metalworking industry for over 27 proud years. We stand behind all of our machines. If you have any questions, comments, or concerns, please call or write to our head office or call toll free at 1-800-461-BUSY.**

**Email us at [busybee@busybeetools.com](mailto:busybee@busybeetools.com) or contact us though our web site at**

**busybeetools.com**

