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### BS-330FAS Fully Automatic Mitre Cutting Bandsaw Additional Instructions



**B110**

1. Turning the machine on.
2. Automatic calibration.
3. Changing the blade speed.
4. Down pressure & down feed.
5. Screens.
6. Manual operation.
7. Automatic operation.
8. Notes.

# 1. Turning the machine on.

- a) Turn on the main switch—located on the door to the electrical cabinet at the front of the machine.



FIG 1.

- b) If there is power to the machine, the power indicator lamp should light.



FIG 2.

- c) The "Title Screen" should appear after a few seconds.



FIG 3.

- d) Touch anywhere on this screen and the following screen will appear for a few seconds.



FIG 4.

- e) The "Main Screen" should now be showing.

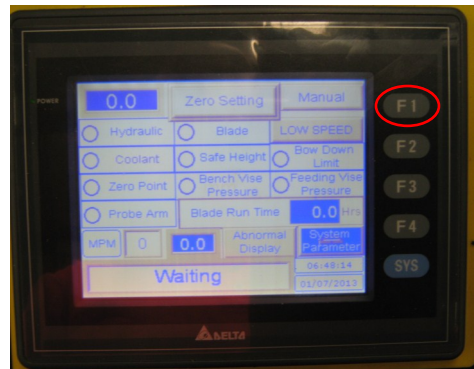


FIG 5.

not, Press "F1".



FIG 6.

- f) Press the "Start" button.
- g) The hydraulic pump should start. Its operation should also be indicated by the relevant

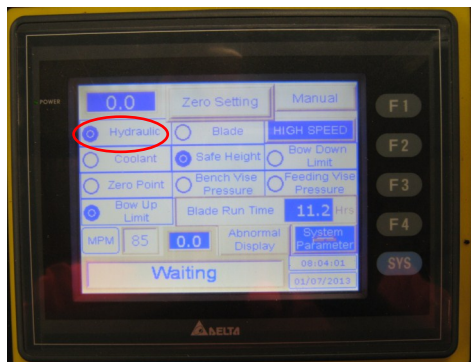


FIG 7.

operation lamp.  
Refer to the manual for more information.

## 2. Automatic Calibration.

- a) Raise bow to its maximum set height. (ie. Limit switch is actuated). Refer to “Manual Operation” to adjust bow height stop.

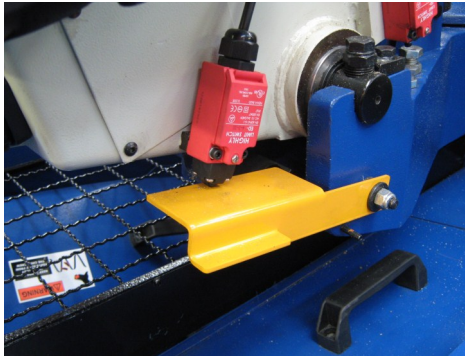


FIG 8.

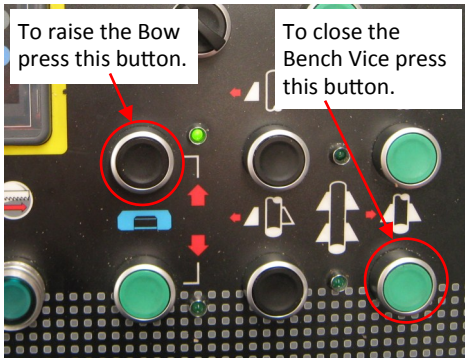


FIG 9.

- b) Remove any work pieces from the machine.  
 c) Close the Bench Vice. Refer to Fig 9. The following operational lamps should be on before calibration.

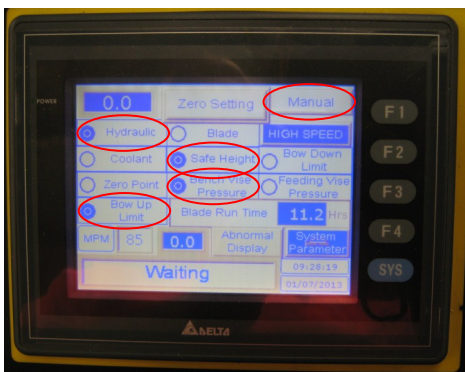


FIG 10.

- d) Press the “Zero Setting” button. The Feeding Vice may move forward during calibration.



FIG 11.

- e) The screen should now be showing this. Fig 12. The machine is ready to operate.



FIG 12.

Refer to the manual for more information. (Page 5.)

## 3. Changing the Blade Speed.

This can be done in 2 ways;

- 1) a) Press this button (Fig 13.).



FIG 13.

- b) A keypad will appear—just type in the required blade speed & press “Enter”.



FIG 14.

- 2) a) Enter this screen by pressing “F2”. Then press the “+” or “-” buttons to increase or decrease the blade speed.

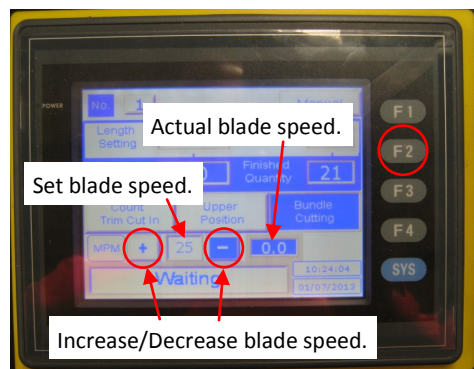


FIG 15.

Refer to the manual for further information. (Page 7.)

## 4. Down Pressure & Down Feed.

Down feed is the speed at which the bow moves. Down pressure is the pressure that will be applied when the bow encounters resistance to downward movement in order to maintain down feed speed.

Adjust “Down Pressure” and “Down Feed” knobs to suit material and section being cut.



FIG 16.

Refer to tables in manual for further information. (Pages 16 & 17.)

## 5. Screens.

“F1” - Shows the real time status of limit switches, blade speed etc. during operation in both Manual and Automatic modes.

Is the screen for calibration or zero setting.

Is the best screen for manual cutting as it shows the position of the Feeding Vice.

“F2” - Shows the basic operating parameters such as feed length, cut quantity, blade speed.

Is the best screen for automatic cutting as it allows selection of “Trim Cut”. See notes.

“F3” - Shows the Data Entry screen for automatic cutting.

“F4” - Shows the language selection screen.

## 6. Manual Operation.

Saw must be calibrated (Section 2.) and switched to “Manual”. (Fig 10. & Fig 17.) Turn on coolant & work light if required and set Down Feed & Speed (Section 4.) Set the blade speed (Section 3.). Blade feeds and speeds can be adjusted at any time.

See “Notes” for bundle cutting.

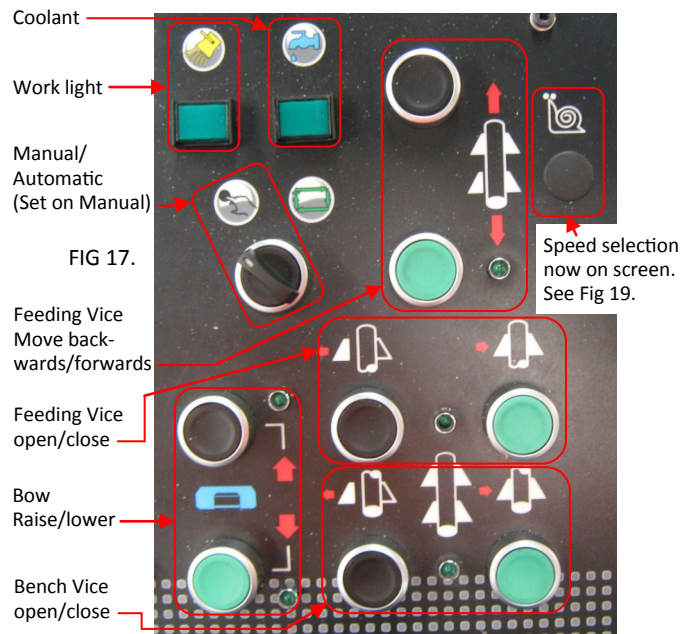


FIG 17.

Speed selection now on screen. See Fig 19.

## TRIM CUT.

- Raise the Bow. The maximum height of the Bow can be adjusted by moving the Bow Height Adjusting Plate up or down by hand (Fig 18).

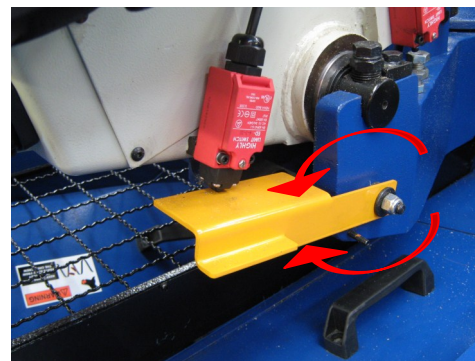


FIG 18.

- Open Bench Vice and Feeding Vice and insert work piece.
- Move Feeding Vice backwards and close it. The speed of the Feeding Vice can be adjusted by pressing this button (Fig 19.). It will toggle between “HIGH SPEED” & “LOW SPEED”.

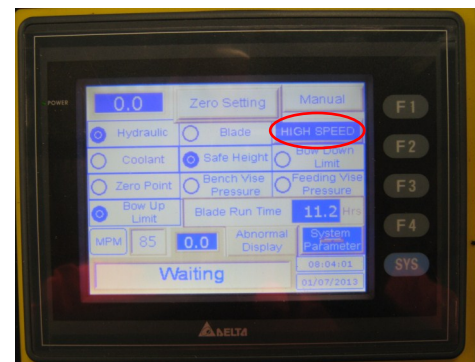


FIG 19.

- Move the Feeding Vice forwards or backwards to position the work piece for the trim cut.
- Close the Bench Vice.
- Press the “Operation Start” button.

The blade will start. The Bow will lower, beginning the cutting operation. Once finished, the Bow will rise and the blade will stop.

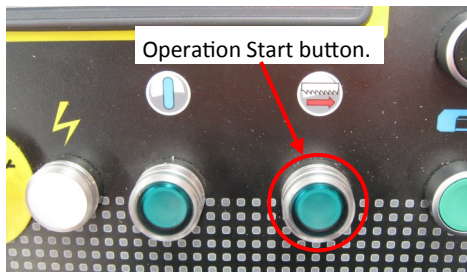


FIG 20.

**CUT.**

- a) Open the Feeding Vice, leave the Bench Vice closed.
- b) Move the Feeding Vice back until the required cut dimension is displayed. (Fig 21.) *It will be necessary to jog the forwards/backwards buttons in Slow Speed to obtain an exact*

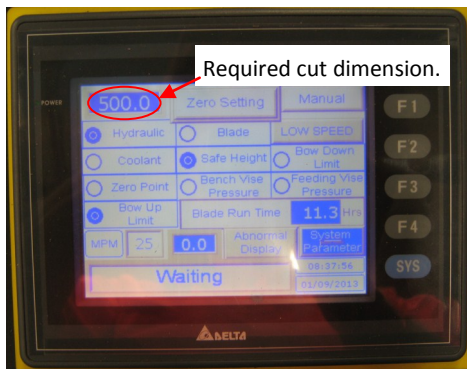


FIG 21.

*dimension.* Close the Feeding Vice.

- c) Open the Bench Vice.
- d) Move the Feeding Vice all the way forward until the dimension in fig 21. is 0.0.
- e) Close the Bench Vice.
- f) Press the “Operation Start” button.

If a cut dimension greater than 700mm is required it will be necessary to add 2 or more movements together. Eg. To cut 1000mm after the trim cut; Open Feeding Vice. Keep Bench Vice closed. Move Feeding Vice back to 700mm. Close Feeding Vice. Open Bench Vice. Move Feeding Vice forward 700mm, until 0.0mm is displayed. Close Bench Vice. Open Feeding Vice. Move Feeding Vice back until 300mm is displayed. (700+300=1000). Close Feeding Vice. Open Bench Vice. Move Feeding vice forward until 0.0mm is displayed. Close Bench Vice and cut.

**7. Automatic Operation.**

Saw must be calibrated (Section 2.) Both vices must be closed (in “Manual” mode). (Fig 10. & Fig 17.) Turn on coolant & work light if required and set Down Feed & Speed (Section 4.) Set the blade

speed (Section 3.) Blade feeds and speeds can be adjusted at any time.

Switch to “Automatic” (Fig 17.)

**PROGRAMMING.**

- a) Press “F3” to enter “Programming Screen”.

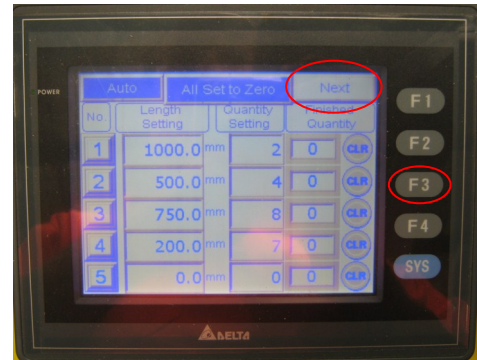


FIG 22.

- b) Enter dimensions and quantities as required by tapping on the required position in the table. A keypad will appear — enter data here.



FIG 23.

- c) Continue until your cutting list is complete. Fig 22. (There is a second page in the table. This gives the option of programming up to 10 different lengths. This page is accessed by pressing the “Next” button. Fig 22.)

**OPERATION.**

- a) Press “F3” to get to the “Data Entry Screen”.
- b) Select the lengths you wish to cut by pressing



FIG 24.

- c) the corresponding number.
- c) Press “F2” to get to the “Operating Screen”.
- d) Press the “Count Trim Cut In”/”Count Trim Cut Out” button.

“Count Trim Cut In” will include the trim cut as a part.

“Count Trim Cut Out” will not include the trim cut as a part.



FIG 25.

- e) Press the “Operation Start” button. (Fig 20.).
- f) The machine will cycle through the selected lines in the cut table and cut the required number of parts at the required length.

Refer to the manual for further information.

## 8. Notes.

- 1) **BOW UP.** Pressing the “Bow Up” button (Fig 17.) during a cut in “Manual” mode or a cycle in “Automatic” mode will cancel the cut and raise the Bow to its set limit.
- 2) **TRIM CUT.** The “Trim Cut” will be performed where ever the work piece is positioned. Position the work piece as per “Manual Operation” on page 4. “Count Trim Cut Out” is used where a trim cut is required. “Count Trim Cut In” is only used where one complete part length is already protruding past the blade.
- 3) **BUNDLE CUTTING.** Bundle cutting is controlled by these valves (shown below in the “off” position) (Fig 26.). With the valves opened the Bundle Clamps will operate at the same time as the vices.

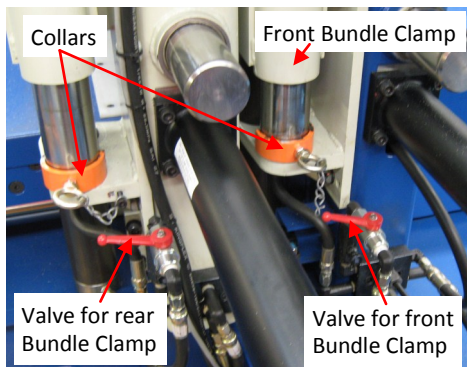


FIG 26.

The Collars must remain in position. They set the lowest position for the Bundle Clamps. Fig.27 shows the rear Bundle Clamp — viewed

from the rear of the machine.



FIG 27.

- 4) **PROGRAMMING.** Once a line in the cut list (Fig 22.) has been completed, it cannot be reused. To overcome this follow these steps;
  - a) Touch either the “Length Setting” or “Quantity Setting” box on the line in the cutting list you wish to reuse. The keypad will appear. (Fig 23.).
  - b) Press “Enter”.
  - c) Repeat this process for every line you wish to reuse.

Now you will be able to select these lines. One line in this table is referred to by the machines system as a “Job”.

“Waiting” at the bottom of the display indicates the machine is waiting for the operator.

- 5) **VICES.**
  - a) The Bench Vice must be closed before you can start the blade.
  - b) If the Bench Vice is closed and the Feeding Vice is closed, the Feeding Vice will not move backwards or forwards.
  - c) Both vices must be closed before operation in “Automatic” mode can commence.