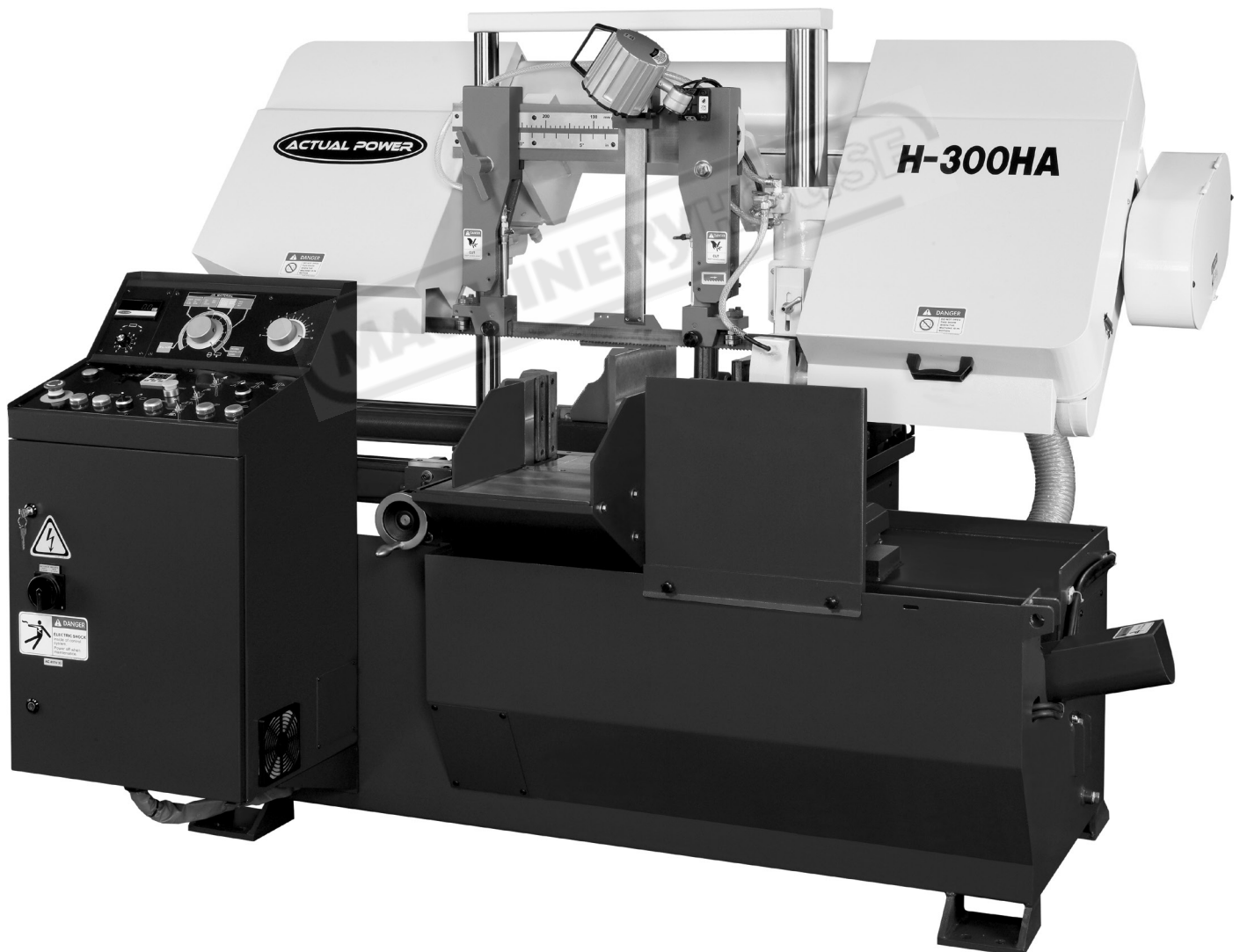


INSTRUCTION MANUAL

H-300HA-NC

Automatic Hitch Feed Double Column Metal Cutting Band Saw (415V) 300 x 300mm (W x H) Rectangle



B118

— : CHARACTERISTIC & SPECIFICATION

1. MODEL: H-300HA



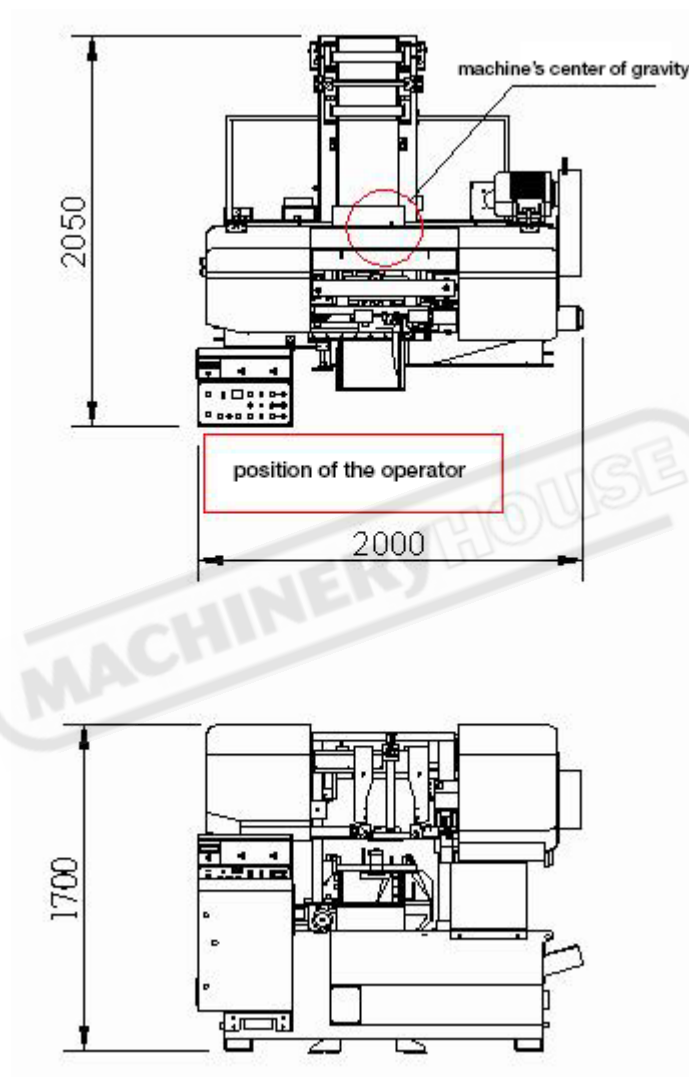
2. SPECIFICATION:

MODEL NO.		H-300HA
CAPACITY		○ 300mm
		□ 300x300mm
BUNDLE CUTTING		145x30 ~ 230x130mm(W*H)
BLADE SPEED		20 ~ 100M/min
BLADE TENSION		HYDRAULIC
BLADE SIZE		L3920xW34xT1.1mm
MOTOR	BLADE	3.7KW 5HP
	HYDRAULIC	0.75W 1HP
	COOLANT	1KW 1/8HP
TABLE HEIGHT		780mm
CLAMP VISE TYPE		HYDRAULIC
MACHINE WEIGHT (N.W./G.W.)		1650kgs
HYDRAULIC OIL CAPACITY		80L
CUTTING OIL CAPACITY		60L
MATERILA LENGTH OF SINGLE FEED		400mm x 9
FLOOR SPACE		2000 x 2050mm

二 : MACHINE INSTALLATION

1. Machine Installation

Please figure out enough space for working, inspection and maintenance afterward.
Refer to the machine floor space drawing below:

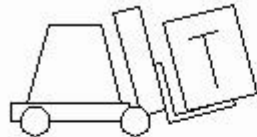


2. Machine Transportation

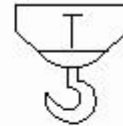
Be careful to take apart the outer package and fixing screw. Please make use of forklift truck or overhead crane to transit the machine. During the process, please keep the machine balance in the forklift truck and avoid to have any impact or tremble happened when machine was transported by the overhead crane.

(Note: please hang the machine from the hook exactly)

(Machine Weight: 1650kgs)

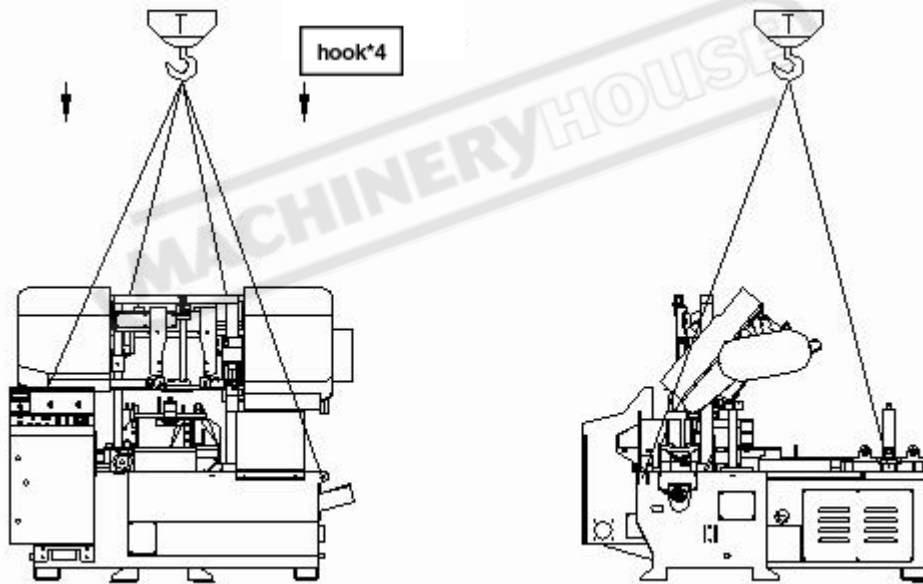


T=3t



T=3t

4



3. Clean

After positioning the machine, clean up the anticorrosive from the machine, then lay on a coat of thin oil.

(Please removes the fixing iron plate between saw frame and table before machine operation.)

4. Adjust Level And Fixing

To calibrate the machine level for the correct flow direction of cooling water and accurate saw cutting.

There are ten adjusting screws at the base for adjusting the machine level.

5. Hydraulic Oil Level

Check the oil drain port screw was tighten or not then look over the level of hydraulic oil in the oil tank from the oil gauge. If the oil level is too low, please open the oil tank cover and pour into the standard capacity. Before the machine delivery, the oil tank was loaded with enough capacity previously.

6. Cooling Water

Before the machine delivery, the cooling water should be drained out completely.

Please infuse the enough cooling water into the machine before operation.

Check the drain water port screw was tighten or not and then implant the suitable water volume.

The aperture of filling is under the meshed hole of steel blade brush.

7. Power Supply

1. Before connect the power please make sure the wire is long enough to connect between the power supply and machine. (Only certificated electricians could be appointed to do this matter.)
2. Switch OFF the power supply and connect the machine wire. Please confirm the power voltage is matched with machine. Connect the power wire and ground wire precisely.
3. Before switch ON the power supply, please check the wire connection is correct or not.
4. Draw up the emergency switch and turn on the power, at this time the lamp will be lighted up to show the power was connected completely.
5. Press the hydraulic button on the control panel.
(Note: Please removes all of the transport fixing screw before this procedure.)
6. Press the UP button of saw frame.
If it doesn't work, please exchange the wires.



7. Press the emergency switch to cut off the power supply.
8. Turn off the power supply switch.
9. Exchange the two wires of the power supply.
10. Repeat the step of 3 and 6.

8. Inspection Before Operation

After the complete machine installation, please do the final inspection properly.

The item is listed as below:

1. Take all of the fixing plate for transporting purpose off.
2. Check screws and fixing items.
3. Check water pipe and wire guide tube.
4. Make sure the cooling water is enough and hydraulic pressure is normal.
5. Tools or other materials should not be left on the machine.

MACHINERYHOUSE

≡ : OPERATION METHOD

1. The Description Of Operation Panel

MODEL: H-300HA



(1) Emergency Stop Button

Press the button to stop all of the machine function.

(picture 1)



(2) Power Light

When the emergency stop switch was drew up, the power lamp will be lighted up to show the normal connection of electric power.

(picture 2)



(3) Hydraulic Button

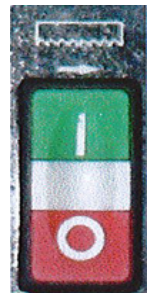
Press this button to start the hydraulic motor.



(picture 3)

(4) Blade Start Button

Press this button to start the saw blade motor and coolant pump at the same time. The saw frame will descend according to the speed of flow control valve.



(picture 4)

(5) The Switch For Choosing Cooling Water

to start the coolant pump and make the cooling water flow. The switch could be turned on independently without the start of blade motor.

* Turn to the position of **OFF** to stop the coolant pump.



(picture 5)

(6) The Switch For Work Light

For work light use only.



(picture 6)


(7) The Switch For Blade Cutting Speed


To control the rotational speed of blade cutting.
The more large number to indicate,
the more cutting speed to obtain.


(picture 7)



(8) The Switch For Circulation And Manual Mode Changeover

* Turn the position to 
Materials will be cut under the mode of circulation by repeat.


* Turn the position to 
For manual operation.


* Turn the position to 
For single circulation work.




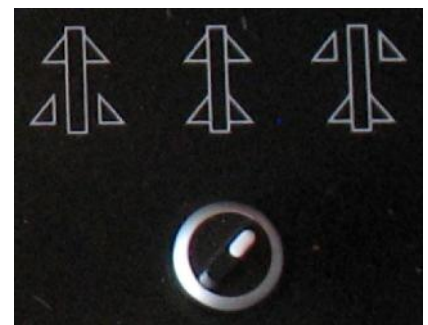
(picture 8)

(9) The Switch For Vise Exchange

Turn the position of 
To open front vise and clamp back vise tightly.

Turn the position of 
To clamp both front and back vise tightly.

Turn the position of 
To clamp front vise tightly and open back vise.



(picture 9)

(10) The Switch For Single Piece or Bundle Cutting Exchange

Turn the position of
For single work piece cutting.



Turn the position of
For bundle cutting.



(picture 10)

(11) The Button For The Movement Of Feed Table

Press this button

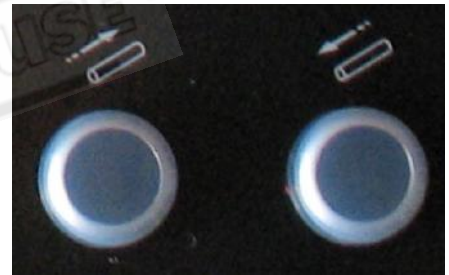


To make the feed table move forward.

Press this button



To make the feed table move backward.



(picture 11)

(12) The Button For Saw Frame UP And Down

Press this button

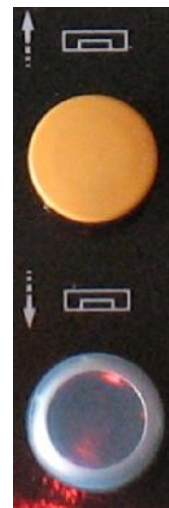


to Lift the saw frame.

Press this button



to Descend the saw frame.



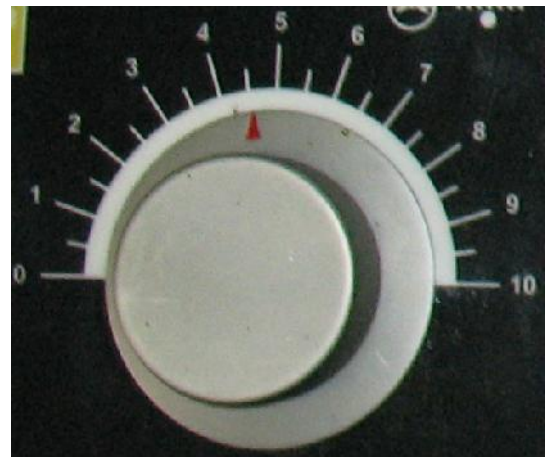
(picture 12)

10

(13) The Switch Of Hydraulic Oil Control Valve

To control the cutting speed.

The more large number to indicate,
the more cutting speed to obtain.



(picture 13)

(14) The Switch Of Pressure Control**For Blade Cutting**

To control the pressure given to the blade
during the process for different materials.

The more large number to indicate,
the more great pressure to offer.

(picture 14)



(picture 14)

2. MACHINE PARTS DESCRIPTION

(1) Worm Gear Reducer

The motor of driving pulley is 3.7 KW (5HP)

The rotation rate was adjusted by reducer and transmitted to driving pulley.



(picture 15)

(2) Chipping Discharge Device

Power Source: hydraulic motor

Banish the iron chipping from the machine.

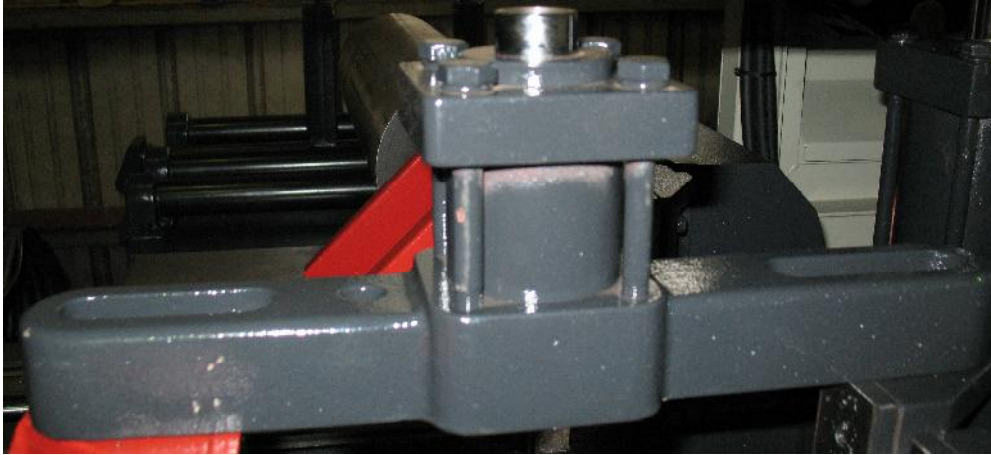


(picture 16)

12

(3) Upper Impaction Device For Bundle Cutting

It is mobile and for the purpose of prevention the material slip out of looseness during the process.



(picture 17)

(4) The Adjustment Of Movable Guide Arm

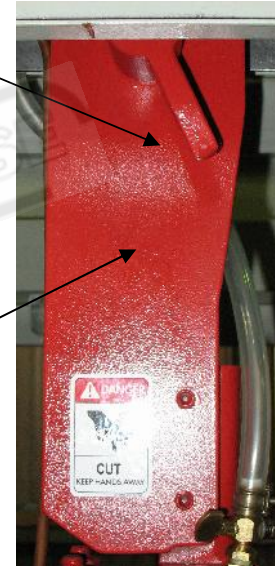
The left guide arm should be adjusted properly to close to the work piece.

Step 1: loose carbide fixture

Step 2: loose locking handle

Step 3: move the guide arm to the work piece

Step 4: lock the handle

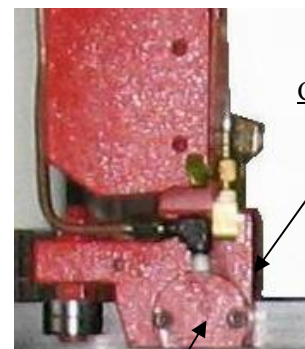
Locking HandleGuide Arm

(picture 18)

(5) The Guide Wheel Base Of Hydraulic Clipping Carbide Fixture

Hydraulic clamp system make the blade cutting more stable.

Carbide material is more wear-resisting.

Carbide Fixture

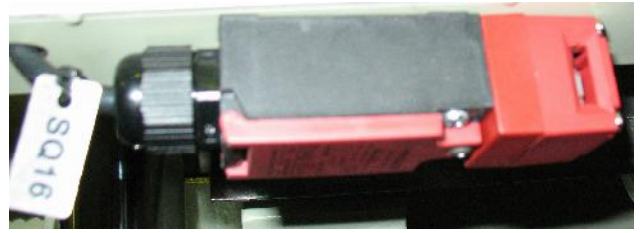
(picture 19)

Hydraulic Cylinder

13

(6) Splash Guard

When the guard cover be opened, the blade cutting will be stopped automatically.



(picture 20)

(7) Micro Clamp Device Of Table

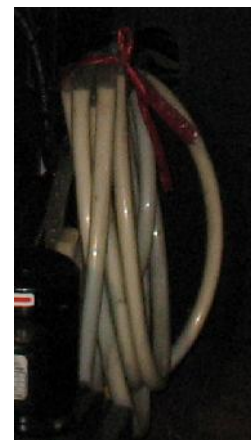
To avoid the material scrape out of the direct contact, this clamp will step back by small extent during the working.



(picture 21)

(8) Washing Gun

Flush the machine table surface or wash iron chipping away.



(picture 22)

14

2. THE INSTALLATION OF SAW BLADE



(picture 23)



(picture 24)

Step 1: Make the saw frame ascend to the position higher than the clamp.

Step 2: Open the right and left front door of the splash guard. (picture 23 and 24 above)

Step 3: Loosen the carbide fixture by manual.

Step 4: Pull the tension valve inside to release the blade tension.

Step 5: Clean up the iron chipping from the carbide fixture.

Step 6: Install the blade on the main driving pulley.

(Note: Please wear the glove to take the blade)

Step 7: The teeth of blade was faced down and turned to the right.

Step 8: The back of saw blade was touched the edge of main driving and driven pulley.

Step 9: Pull the tension valve outside to fasten the blade tension.

Step 10: Fasten the carbide fixture by manual.

Step 11: Adjust the position of blade brush.



Correct

Wrong

Step 12: Close the splash guard and lock the safe knob.





3. OPERATION DIRECTION

There are three kinds of operation for **H-300HA**:

1. Circulation By Repeat 2. Manual Way (manual operation for every function of machine)

3. Single Circulation Work

Step as below:


- (a.) Start the hydraulic pump , and choose the mode of manual 
- (b.) By the basis of appearance, material and size of work piece to choose the proper blade cutting pressure and blade rotation rate setting.
- (c.) Confirm that the saw blade was installed well.
- (d.) Make the movable guide arm close to the work piece.
- (e.) Move the materials to the clamp.
 - * Make the saw frame ascend and the position is higher than clamp.
 - * Make the clamp open and large than the material in width.
(Optional: Hydraulic Cylinder)
 - * Move the material carefully to the position of front clamp.
 - * Press the button of front & back clamp   until the lamp was lighted on when the material was clipped tight.
- (f.) Choose the proper blade speed according to the material of work piece.

Note: Process of above should only be fulfilled when the blade stopped.


Then make the following choice:

Circulation By Repeat  or Single Circulation 

*** Take the Circulation By Repeat for example:**

- (a.) Turn the switch of circulation by repeat and manual mode to the position of 
- (b.) Press the start button of blade to deliver on the previous setting.
- (c.) After repeat of cutting, blade will be stopped when the setting was carried out.
- (d.) Take off the remainder.

*** Take the Single Circulation for example:**

- (a.) Turn the switch of circulation by repeat and manual mode to the position of 
- (b.) Press the start button of blade to deliver on the previous setting.
- (c.) After the completion of one circulation cutting, blade will be stopped directly.
- (d.) Take off the remainder.

四 : MAINTENANCE

After Every Day Work:

1. Clean up the iron chipping on the machine.
2. Clean up the iron chipping of the carbide fixture.
3. Turn off all of the machine switch.

1. Every Day

Before operate the machine, please check the following procedure:

- (1). Check the hydraulic oil level and refill the capacity if it is not enough.
- (2). Check the cutting oil level and refill the capacity if it is not enough.
- (3). Check the saw blade if it was installed on the saw frame or not.
- (4). Check the blade steel brush contact the saw blade exactly or not.

2. One Week

Refill the lubrication for: driven wheel, driving wheel, hollow shaft reducer...etc.

3. Every Six Months

Replace the gear box oil of hollow shaft reduce.

Note: please replace the gear oil of gear box after 3 months or 600 hours.

The variety of gear oil :

STORK, HIGH CLASS THUBAN 140

4. Every Year

Please leak out the used one and refill the capacity in enough.

The variety of hydraulic oil:

ISO-VG grade NO.32

Gear Oil 140 (VG460)
HYDRAULIC OIL AW32 (VG32)
High Temperature Grease NO.3

五 : SAFE MATTERS

1. Please don't approach the machine inside when the saw blade is on working.
2. Any maintenance will be forbidden during the machine operation.
3. Please offer the proper material measurement for machine cutting.
4. During the machine operation, please don't play pranks around.
5. Please don't smoke in the factory or put any flammable article nearby.
6. Please press the emergency button to stop the operation if any accident happened.



7. The guidance of qualified professional was required for the beginner of operation.
8. Please wear the glove for the saw blade installation.

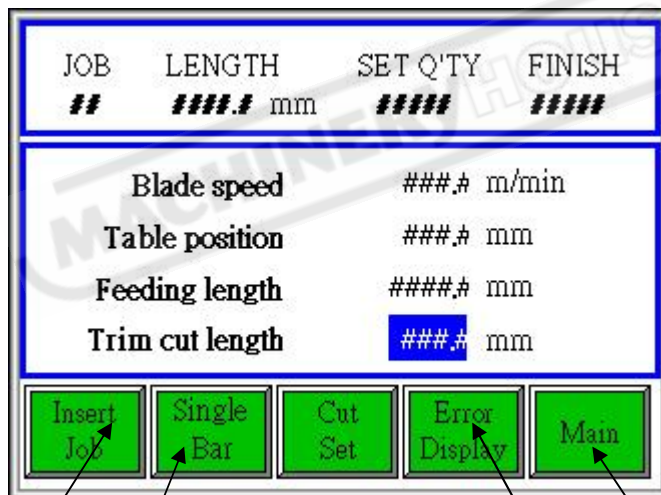
MACHINERYHOUSE

六： NC CONTROL PANEL DESCRIPTION



Return to the operating and setting page

(picture 29)



(picture 30)

Setting of inserted job

Bundle or single cutting setting

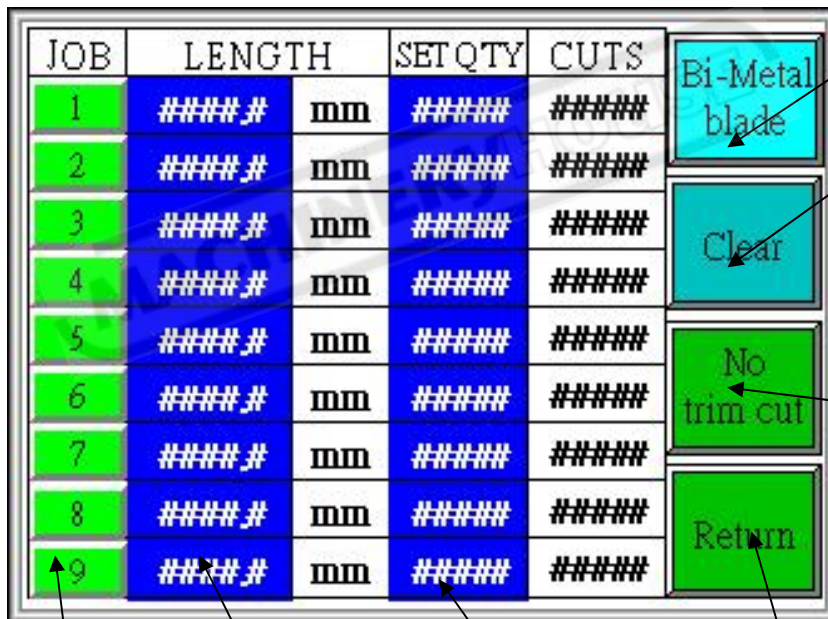
Error display

Return to the first page



(picture 31)

Return to the operating and setting page



(picture 32)

Job setting

Length setting

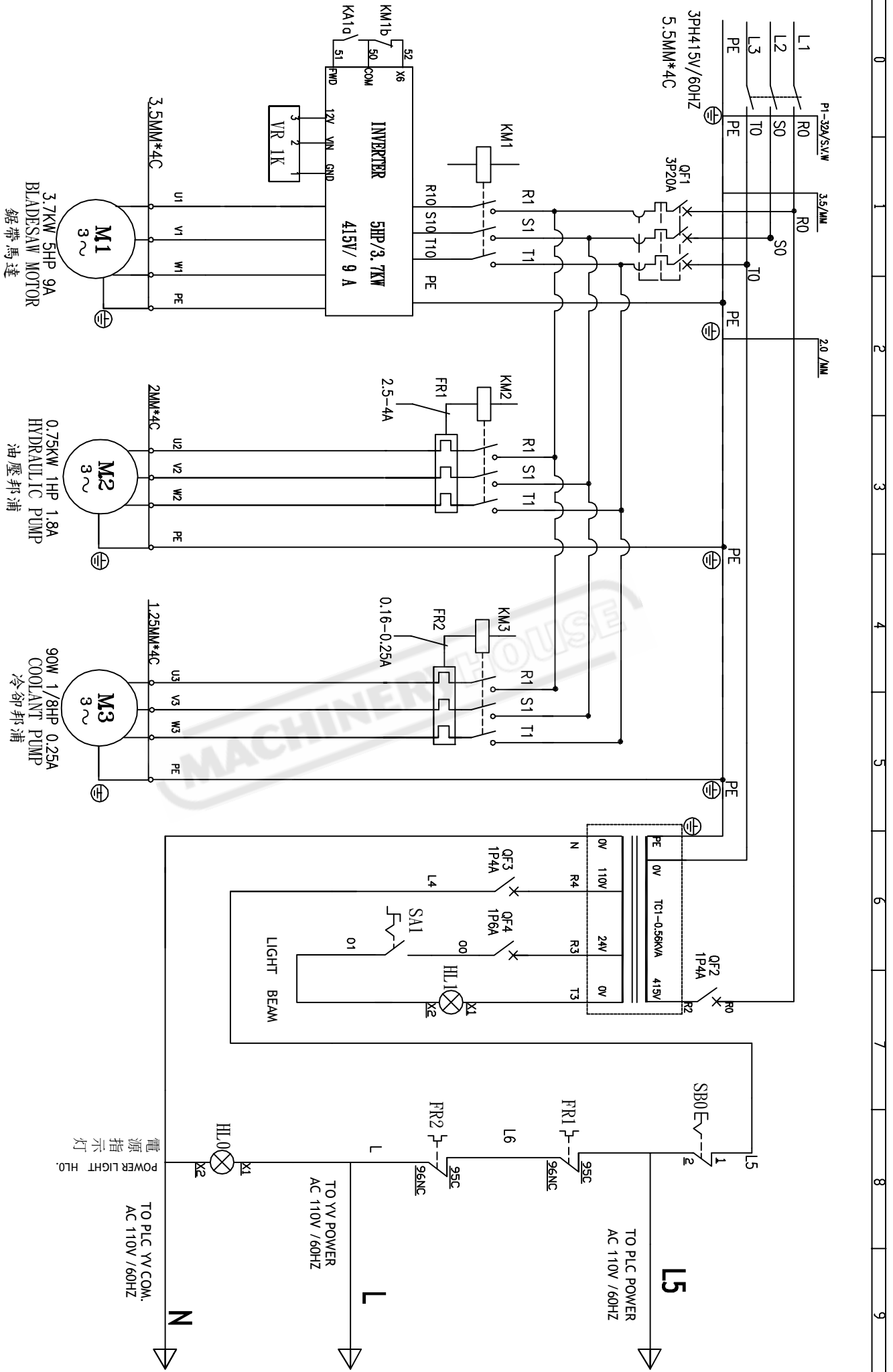
Quantity setting

Return to the operating and setting page

Bi-material blade

Clear the finished record

Trim setting

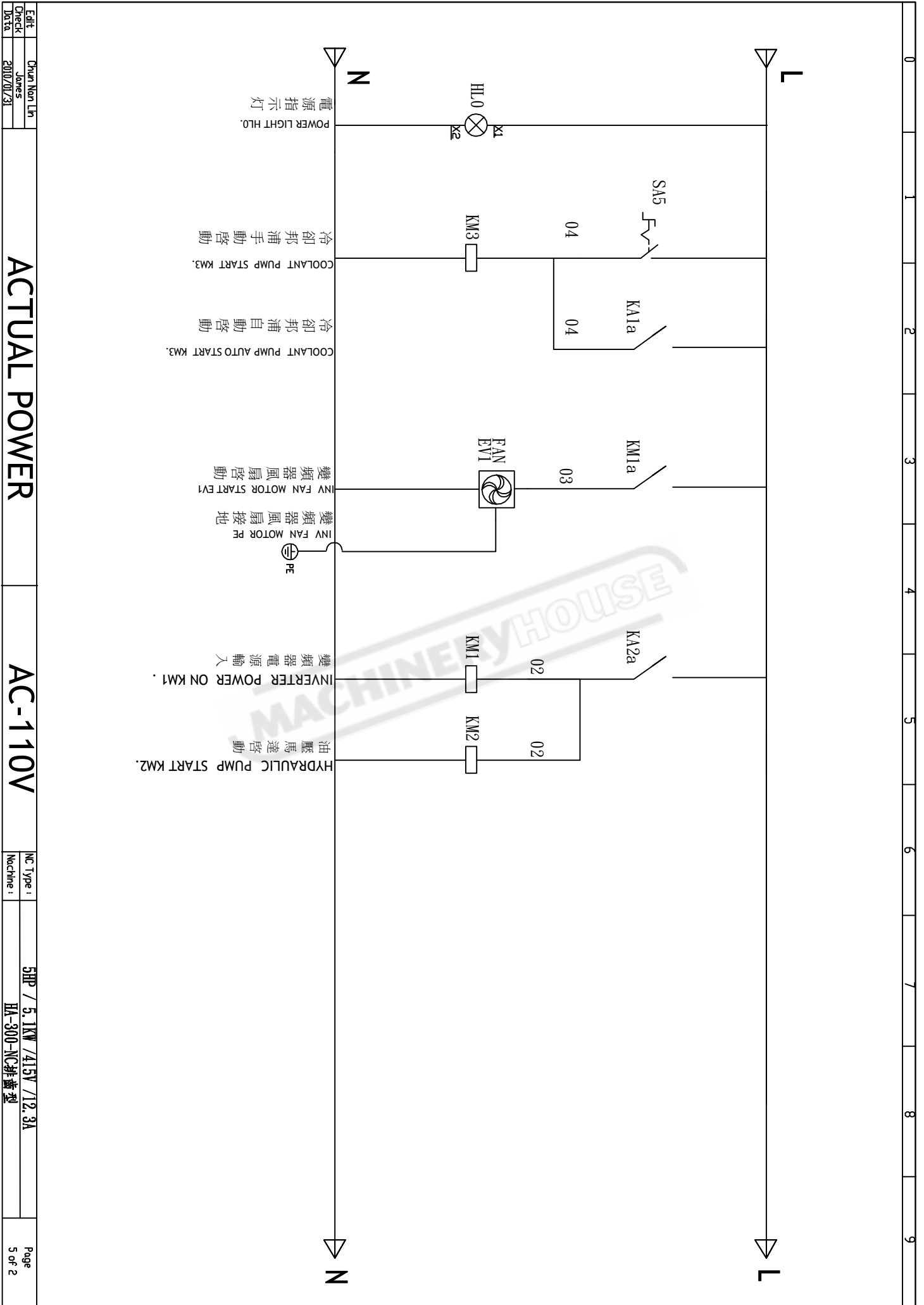


Edit	Chun Nan Lin
Check	Jones
Date	2010/07/31

ACTUAL POWER

MAIN

NC Type	SHP / 5.1KW / 415V / 12.3A
Machine	HA-300-NC排盤型
Page	5 of 1



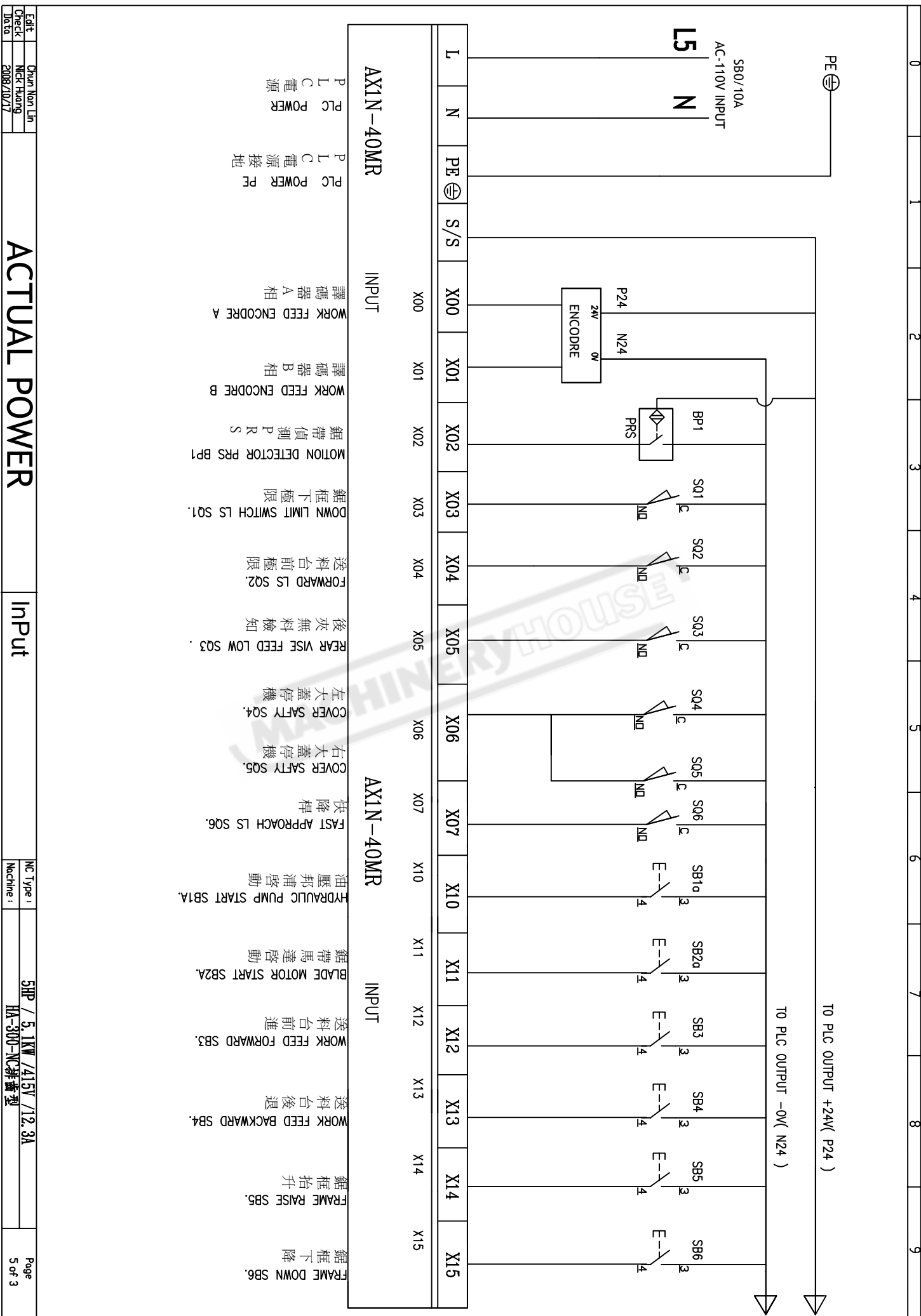
Edit	Chun Han Lin
Check	James
Date	2010/01/31

ACTUAL POWER

AC-110V

NC Type :	Machine :
-----------	-----------

5HP / 5.1KW / 415V / 12.3A
 HA-300-NC排灌型

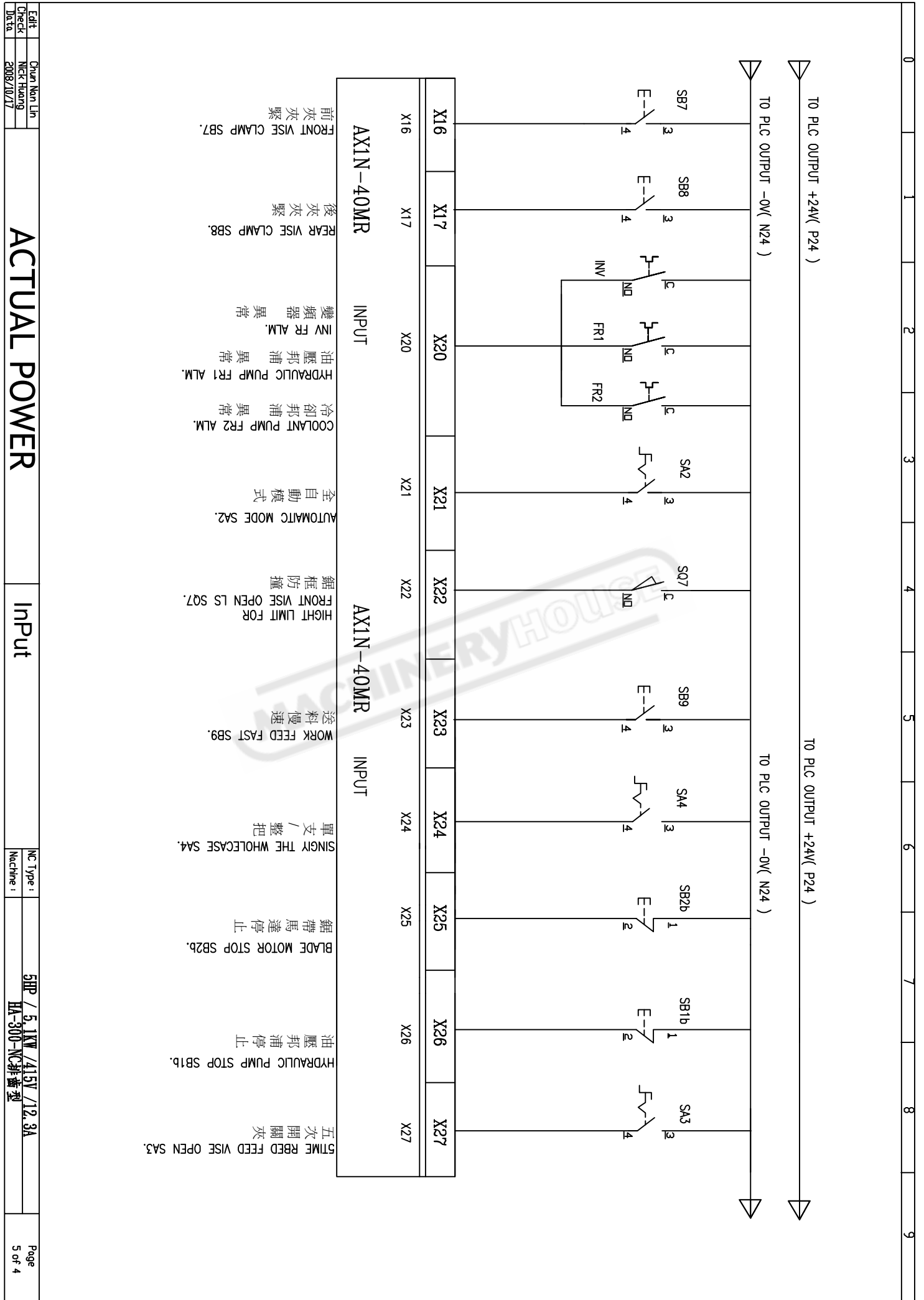


ACTUAL POWER

Input

NC Type : Machine

SHP / 5.1KW / 415V / 12.9A
HA-300-NC非齒型



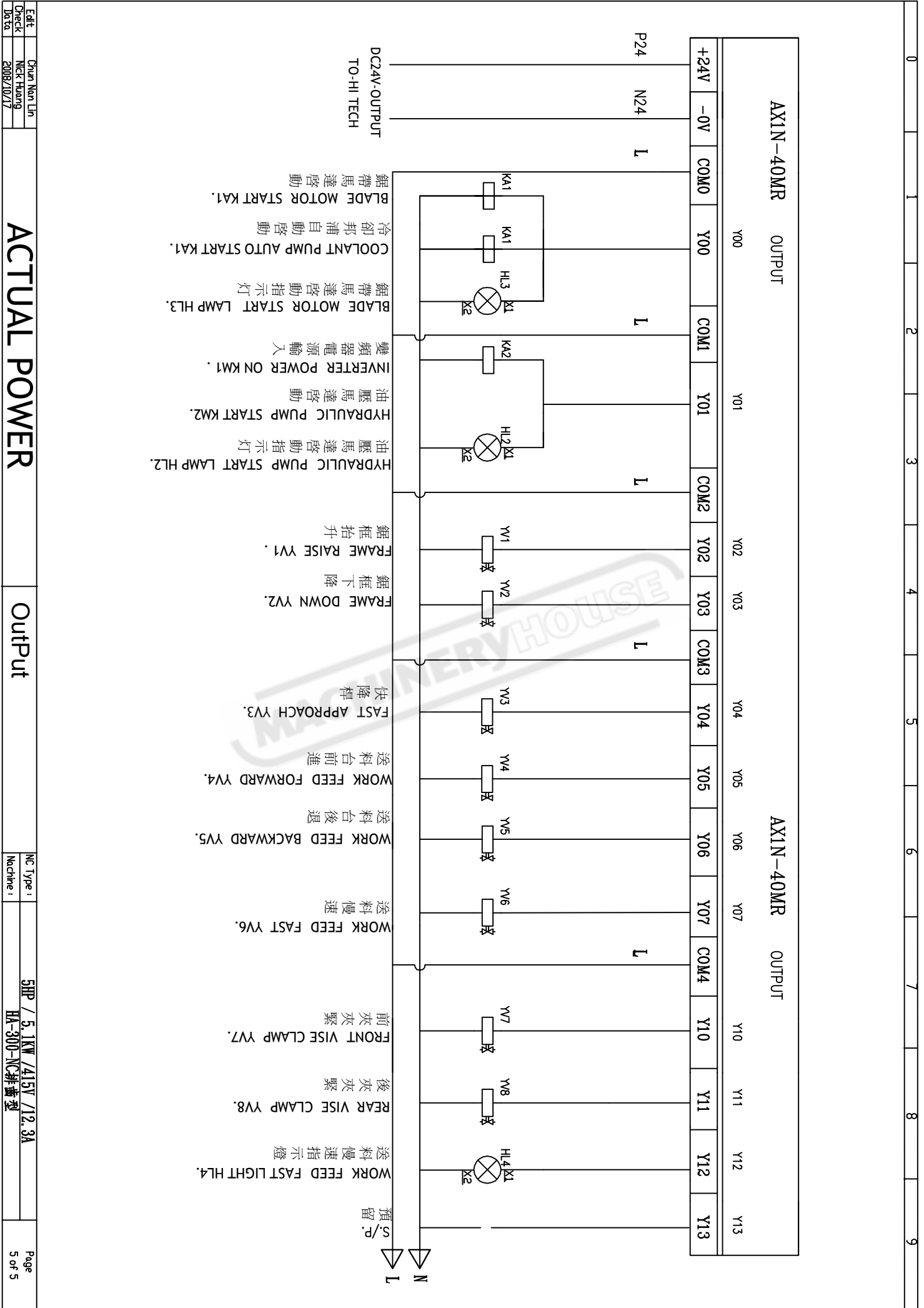
ACTUAL POWER

Input

NC Type :
Machine :

SHP / 5.1KW / 415V / 12.3A
HA-300-NC排齒型

Page
5 of 4



ACTUAL POWER

Output

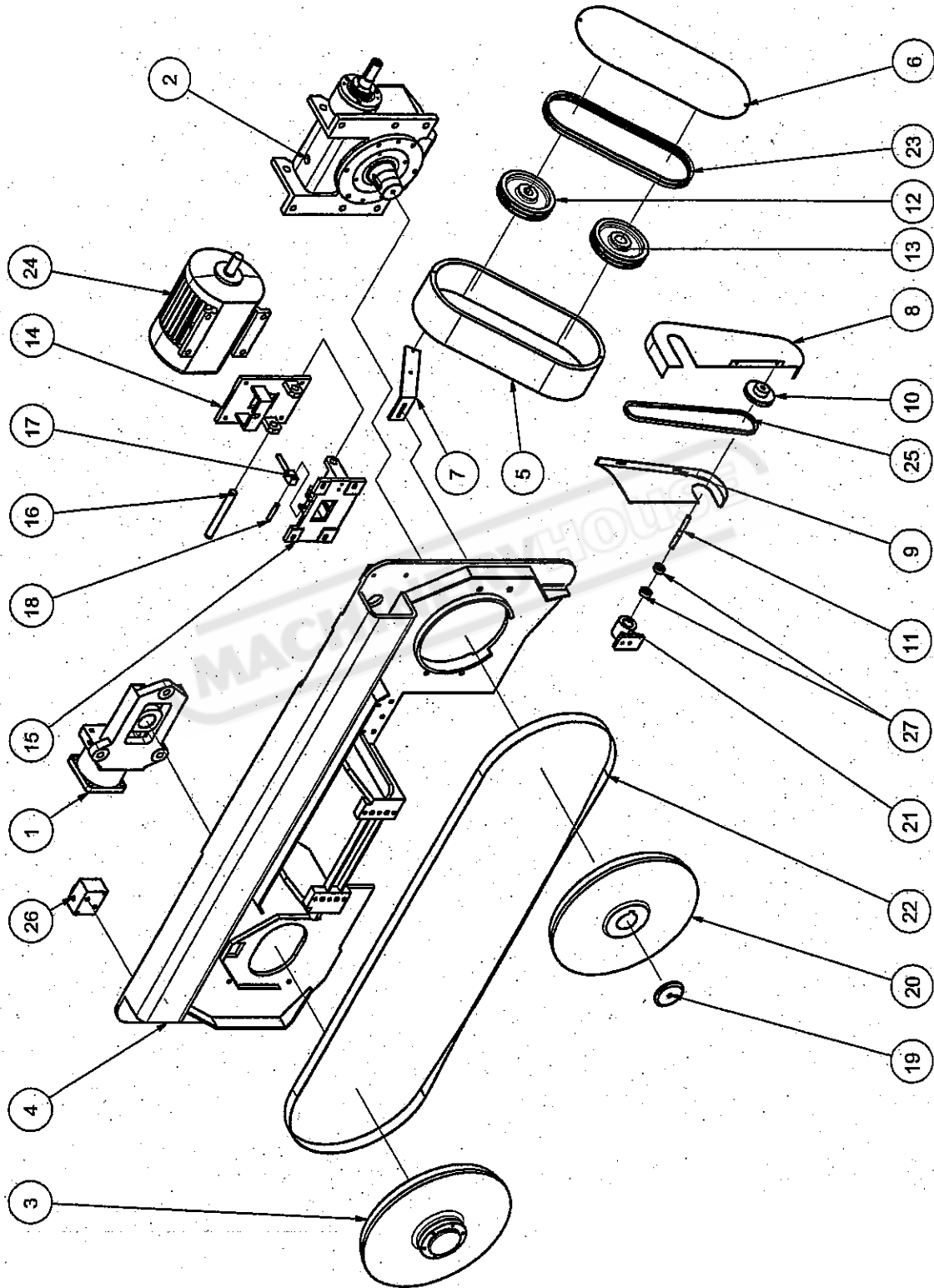
NC Type 1
Machine 1

SHP / 5.1KW / 415V / 1/2.3A
HA-300-NC排插型

Page 5 of 5

Edt: Chun Nuan Lin
Check: Nick Huang
Date: 2008/10/17

A010002

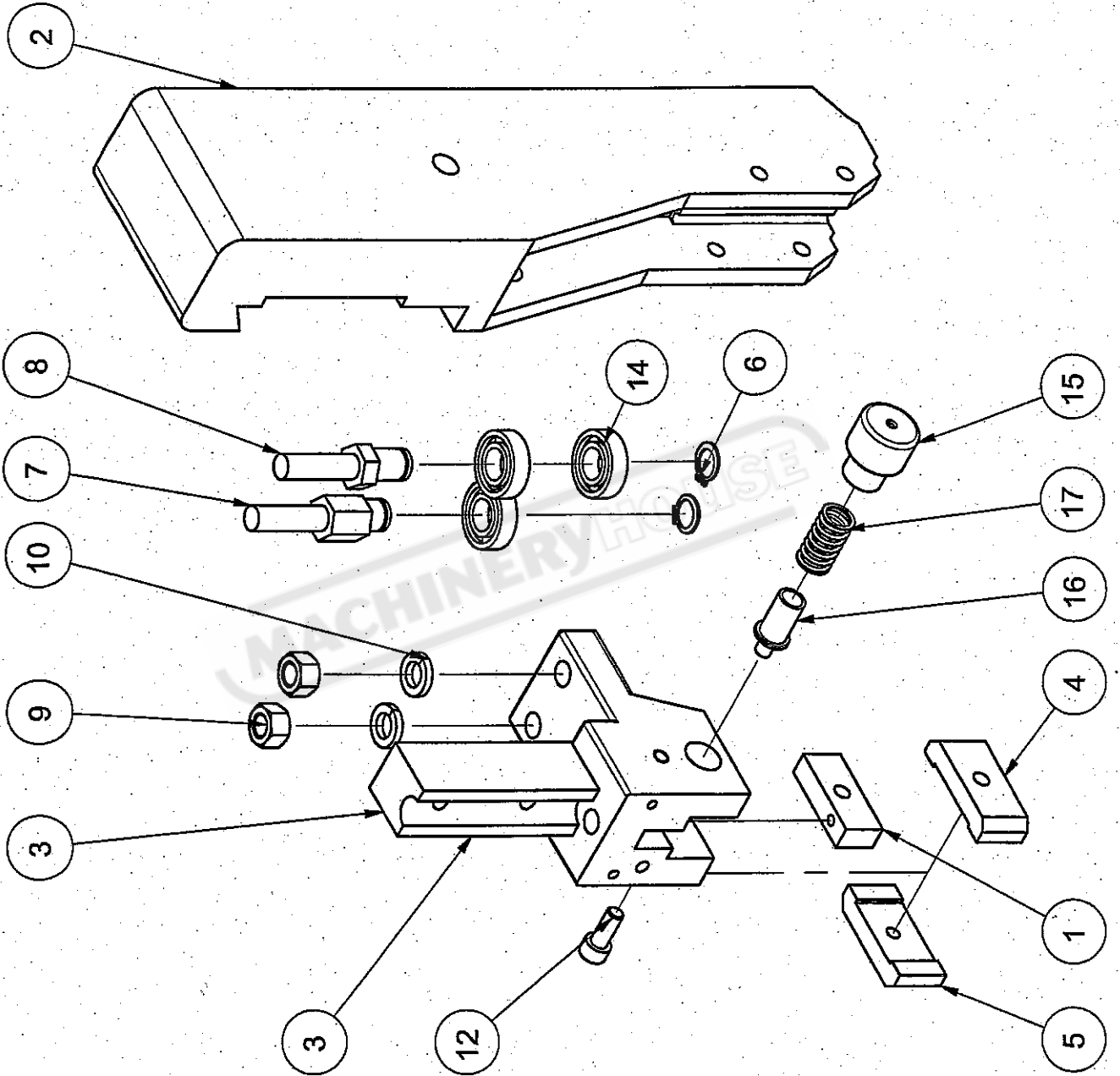


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0.2	1.5	6.3	25	▽

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	A032001	TENSION BASE UNIT	26	1		VALVE
2	1	A010070	GEAR BOX UNIT	27	2	6201	BALL BEARING
3	1	A022017	DRIVED WHEEL UNIT				
4	1	B01010100	SAW BOW				
5	1	B01011400	PULLEY COVER				
6	1	B01011400-2					
7	1	B01011700	FIXING PLATE				
8	1	B01011800	PULLEY COVER				
9	1	B01011900	BACK COVER				
10	1	B02022100	PULLEY				
11	1	B02022200	SHAFT				
12	1	B02120100	PULLEY				
13	1	B02120200	PULLEY				
14	1	B02120301	MOTOR STAND				
15	1	B02120401	BASE				
16	1	B02120500	SHAFT				
17	1	B02120600	ADJUSTING SCREW				
18	1	B02120700	PIN				
19	1	B02043300	WASHER				
20	1	H02240300	DRIVING WHEEL				
21	1	H03221800	BASE				
22	1	SW-34Wx3920x1.1E	SAW BLADE				
23	2	3V x 450	BELT				
24	1	5HP	MOTOR				
25	1	3M x 375L	BELT				

A010002 SAW BOW

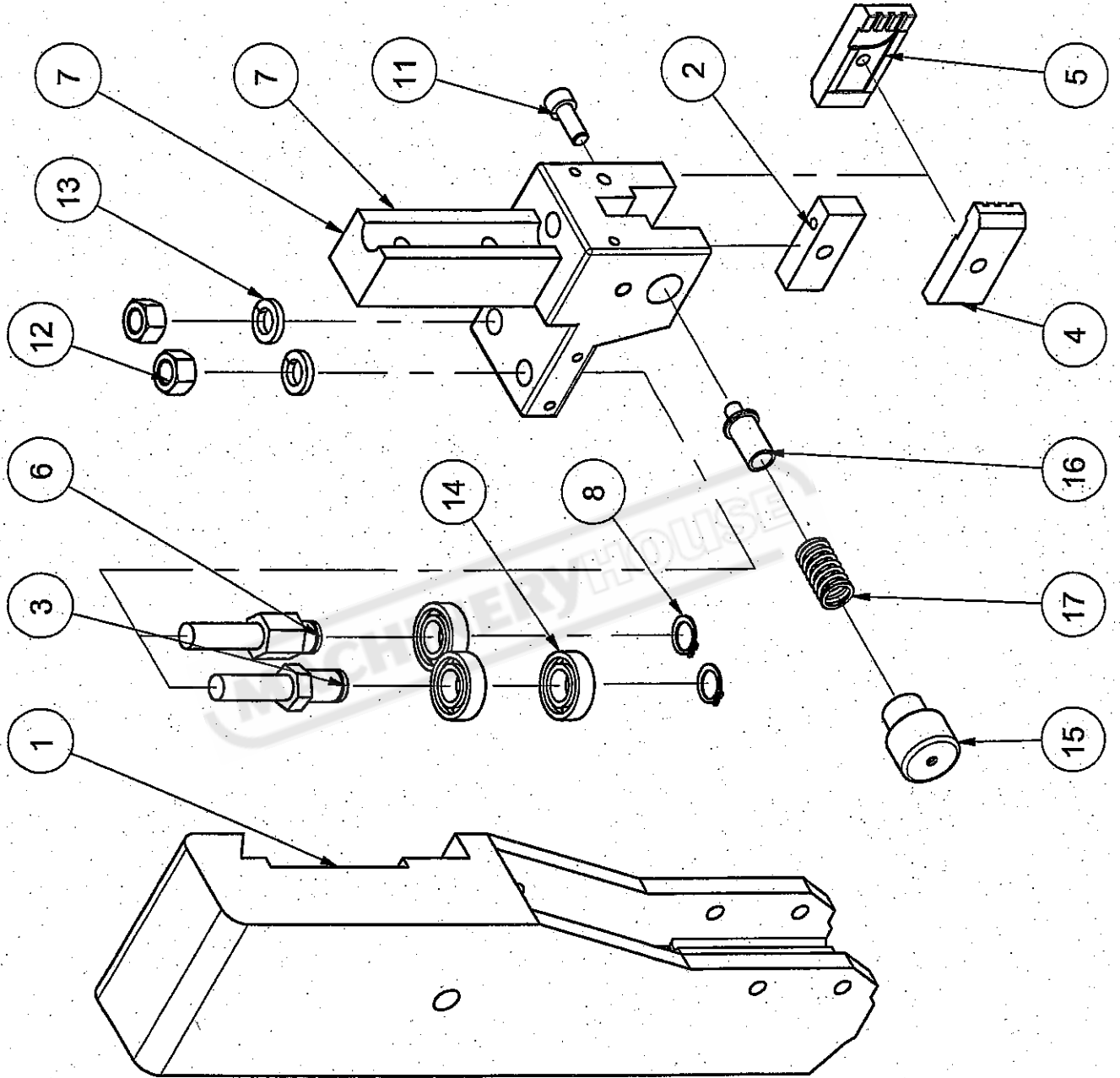
A010004



0.2	1.6	6.3	25	∇

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B02041100	UPPER CARBIDE FIXTURE				
2	1	B01041200	RIGHT GUIDE ARM				
3	1	H02242500	RIGHT GUIDE WHEEL BASE				
4	1	H02241401	RIGHT FRONT CARBIDE FIXTURE				
5	1	H02241501	RIGHT BACK CARBIDE FIXTURE				
6	2	φ 15	C TYPE RETAINING RING				
7	1	H02241900	LONG ECCENTRIC SHAFT				
8	1	B02044100	SHORT ECCENTRIC SHAFT				
9	2	M12	HEXAGON NUT				
10	2	M12	WASHER				
11	1	M8 x 10	HEX SOCKET CAP SCREW				
12	1	M8 x 20	HEX SOCKET CAP SCREW				
13	1	φ 8 x 60L	STRAIGHT PIN				
14	3	6002	BALL BEARING				
15	1	B02042300	NUT				
16	1	B02042400	PIN				
17	1	DIAMETER 13	COMPRESSED SPRING				
18							
19							
20							
21							
22							
23							
24							
25							

A010004 RIGHT GUIDE WHEEL BASE



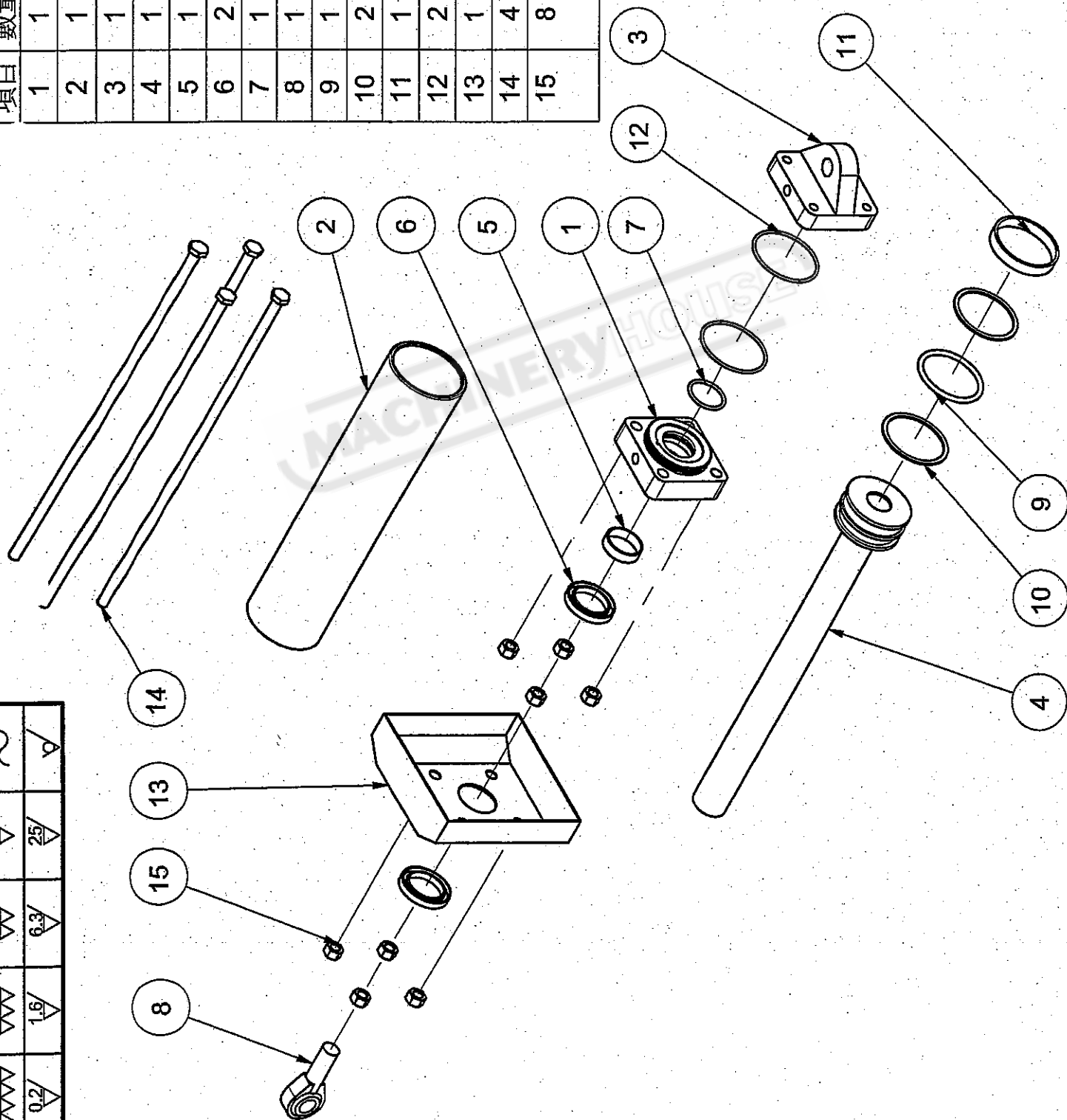
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0.2/▽	1.6/▽	6.3/▽	25/▽

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01041100	LEFT GUIDE ARM				
2	1	B02041100	UPPER CARBIDE FIXTURE				
3	1	B02044100	SHORT ECCENTRIC SHAFT				
4	1	H02241201	LEFT FRONT CARBIDE FIXTURE				
5	1	H02241301	LEFT BACK CARBIDE FIXTURE				
6	1	H02241900	LONG ECCENTRIC SHAFT				
7	1	H02242600	LEFT GUIDE WHEEL BASE				
8	2	φ 15	C TYPE RETAINING RING				
9	1	φ 8 x 60L	STRAIGHT PIN				
10	1	M8 x 10	HEX SOCKET CAP SCREW				
11	1	M8 x 20	HEX SOCKET CAP SCREW				
12	2	M12	HEXAGON NUT				
13	2	M12	WASHER				
14	3	6002	BALL BEARING				
15	1	B02042300	NUT				
16	1	B02042400	PIN				
17	1	DIAMETER 13	COMPRESSED SPRING				
18							
19							
20							
21							
22							
23							
24							
25							

A010005 LEFT GUIDE WHEEL BASE

項目	數量	零件號碼	品名
1	1	B01062000	抬昇上蓋
2	1	B01062100	抬昇油缸
3	1	B01062200	抬昇下蓋
4	1	B01062300	抬昇活塞
5	1	2DU4012	自潤軸承
6	2	4TC58-40-8	油封
7	1	P40	O型環
8	1	POS20	O型環
9	1	P70	O型環
10	2	背托環P70	背托環
11	1	E-MWP80	耐磨環
12	2	G75	O型環
13	1	B01011600	抬昇隔水封板
14	4	H02260200	抬升拉桿螺絲
15	8	JIS B.1181 - A M12	六角螺帽 - 型式 1

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0.2	1.6	6.3	25
▽	▽	▽	▽

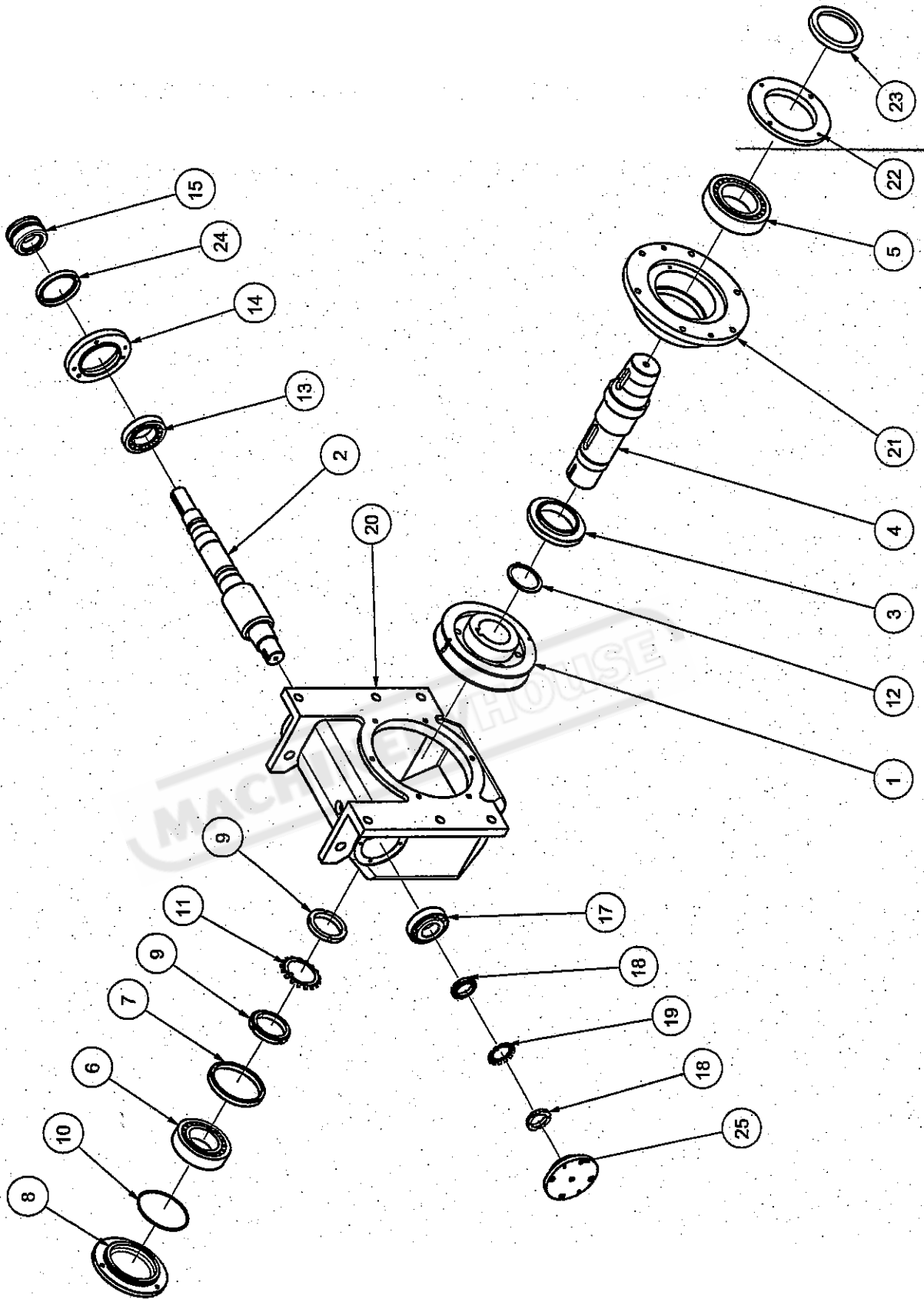


A010006 抬昇缸組爆炸圖

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2	1	B01062100	CYLINDER				
3	1	B01062200	UNDER COVER				
4	1	B01062300	PISTON				
5	1	2DU4012	LUBRICATING BEARING				
6	2	4TC58-40-8	OIL SEAL				
7	1	P40	O RING				
8	1	POS20	ROD BEARING				
9	1	P70	O RING				
10	2	P70	BACKING UP RING				
11	1	E-MWP80	WEARABLE RING				
12	2	G75	O RING				
13	1	B01011600	PLATE				
14	4	H02260200	SCREW				
15	8	JIS B 1181-AM12	HEXAGON NUT				
16							
17							
18							
19							
20							
21							
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A010006 LIFTING CYLINDER UNIT

A010007



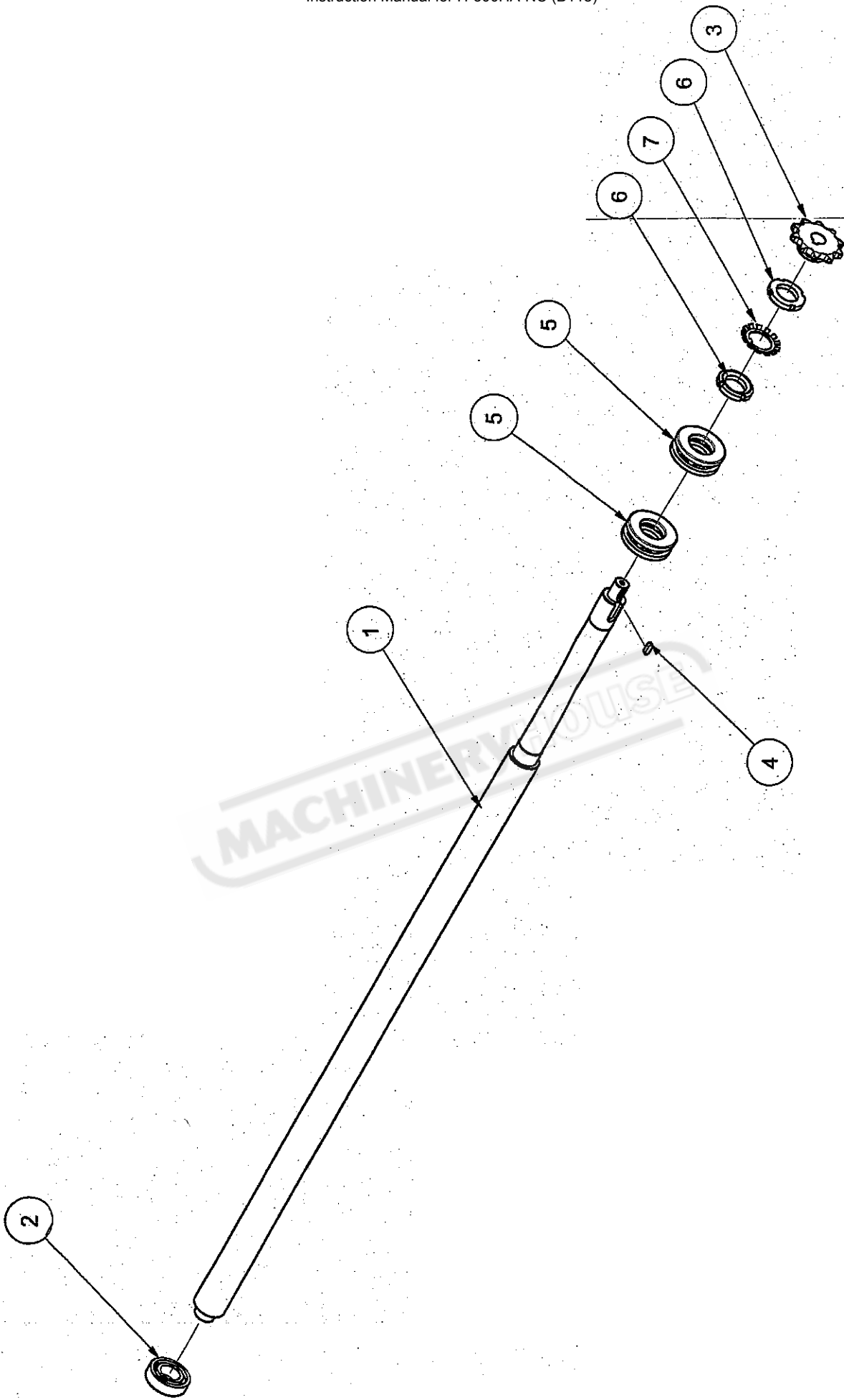
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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01020500	WORM GEAR				
2	1	B01020400	OUTPUT SHAFT				
3	1	B02020900	BEARING SLEEVE				
4	1	B02020100	SHAFT				
5	1	22215	BEARING				
6	1	22212	BEARING				
7	1	B02021000	BEARING SLEEVE				
8	1	B02020700	UNDER COVER				
9	2	AN12	NUT				
10	1	G100	O RING				
11	1	AW12	GASKET				
12	1	ϕ 65 x 2.5t	C TYPE RETAINING RING				
13	1	3020913	BEARING				
14	1	B02021200	BEARING COVER				
15	1	B02021300	NUT				
16	1	6909	BEARING				
17	1	3030713	BEARING				
18	2	AN07	NUT				
19	1	AW07	GASKET				
20	1	B01020600	GEAR BOX				
21	1	B01020700	UPPER COVER				
22	1	B02020800	OIL SEAL COVER				
23	1	4TC85-110-13	OIL SEAL				
24	1	4TC65-85-10	OIL SEAL				
25	1	B01020800	BACK COVER				

A010007 GEAR BOX UNIT

A010008

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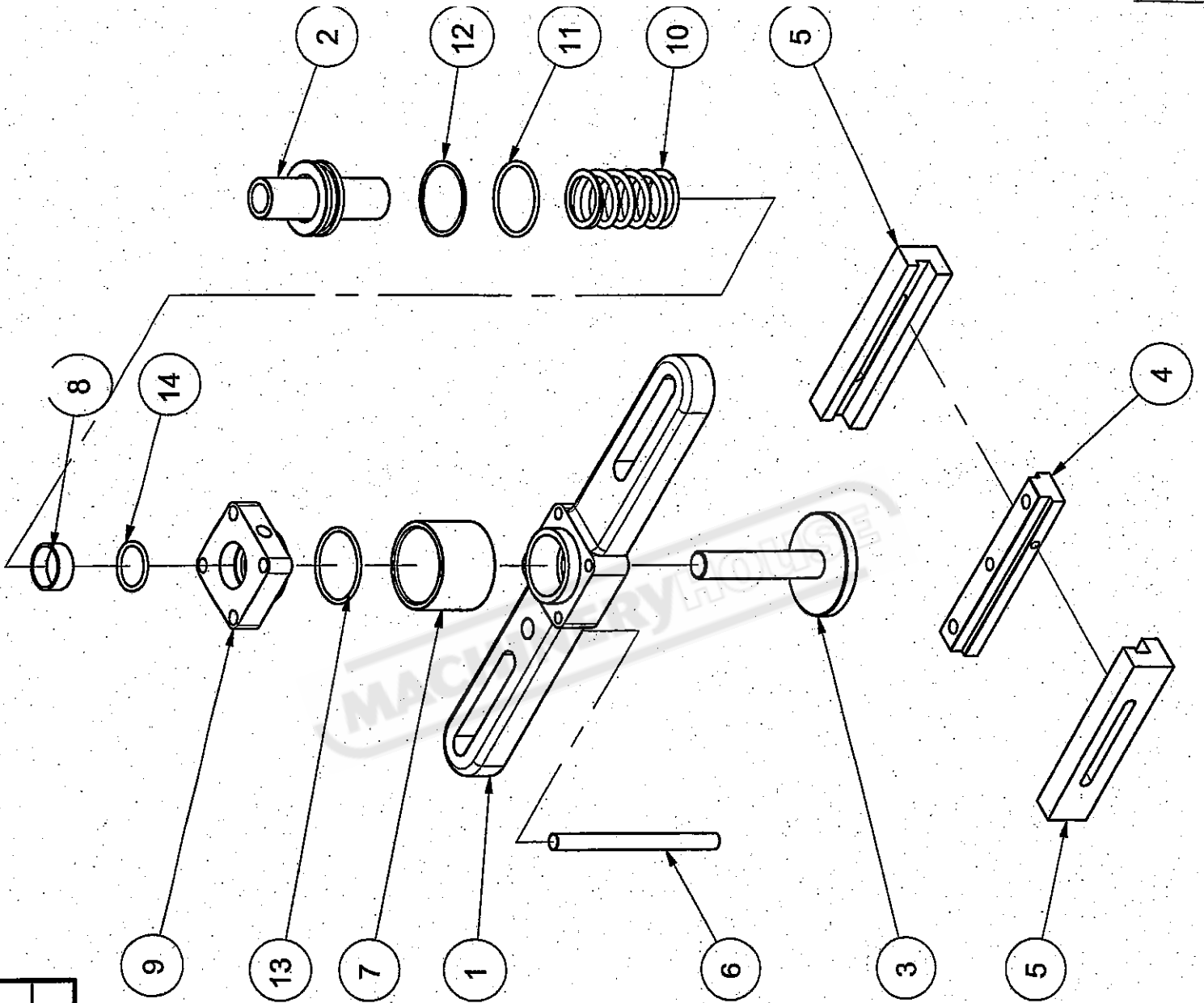


MACHINERYHOUSE

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01032300	SCREW				
2	1	6004	BALL BEARING				
3	1	B02132100	CHAIN WHEEL				
4	1	5 x 5 x 15	ROUND KEY				
5	2	51305	BEARING				
6	2	AN05-JIS B 1554	NUT				
7	1	AW05	GASKET				
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A010008 SCREW

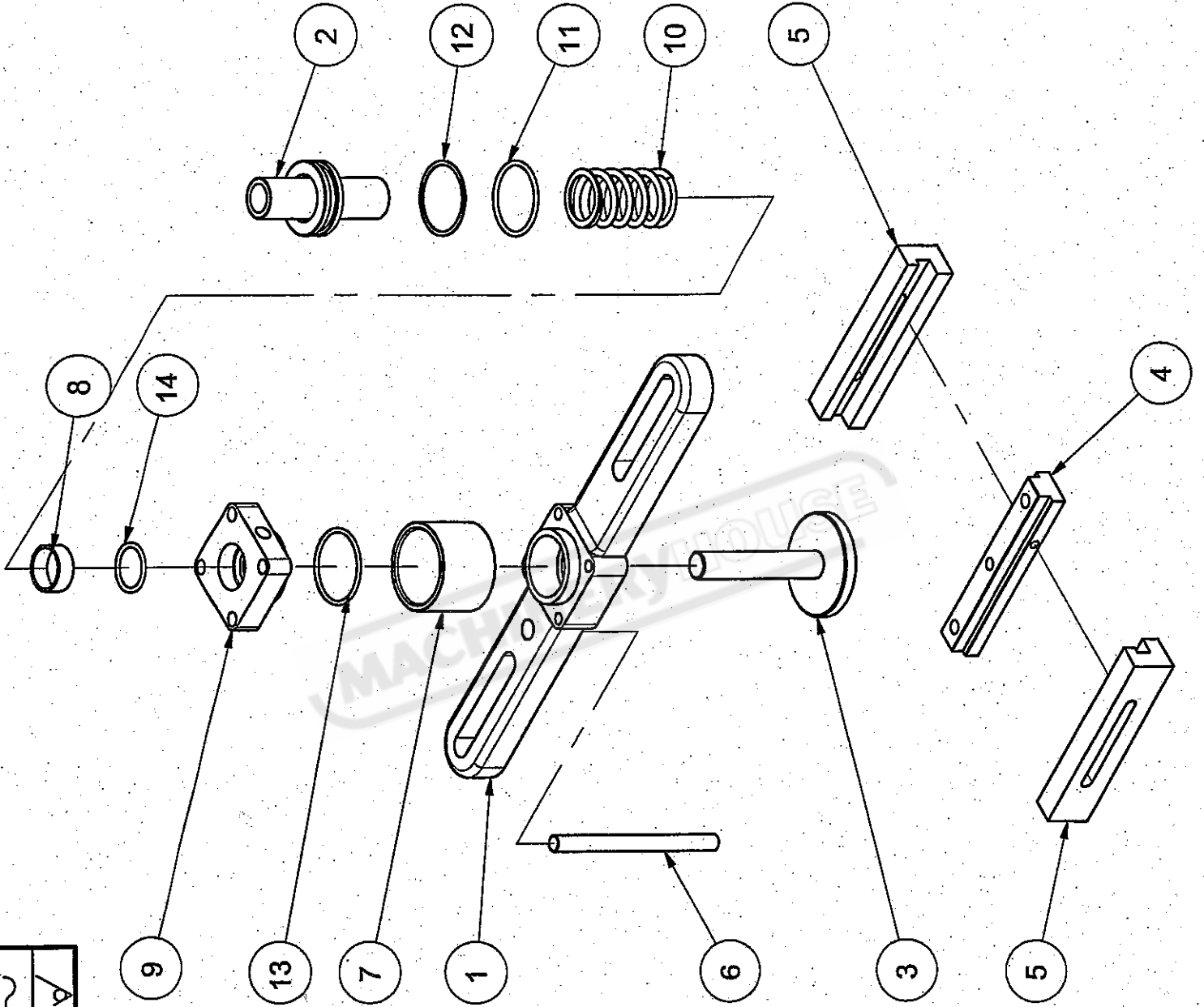
A010009



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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01060600	BASE (LONG)				
2	1	B01060900	PISTON ROD				
3	1	B01061000	ADJUSTING DISK				
4	1	B02140200	BLOCK				
5	2	B02140700	FLEXIBLE BLOCK				
6	1	B01032700	GUIDE ROD				
7	1	B01060700	CYLINDER				
8	2	2DU3012	LUBRICATING BEARING				
9	1	B01060800	BACK COVER				
10	1	DIAMETER 33	COMPRESSED SPRING				
11	1	P49	O RING				
12	1	P49	BACKING UP RING				
13	1	G50	O RING				
14	1	P30	O RING				

A010009 VERTICAL PRESS DEVICE (LONG)

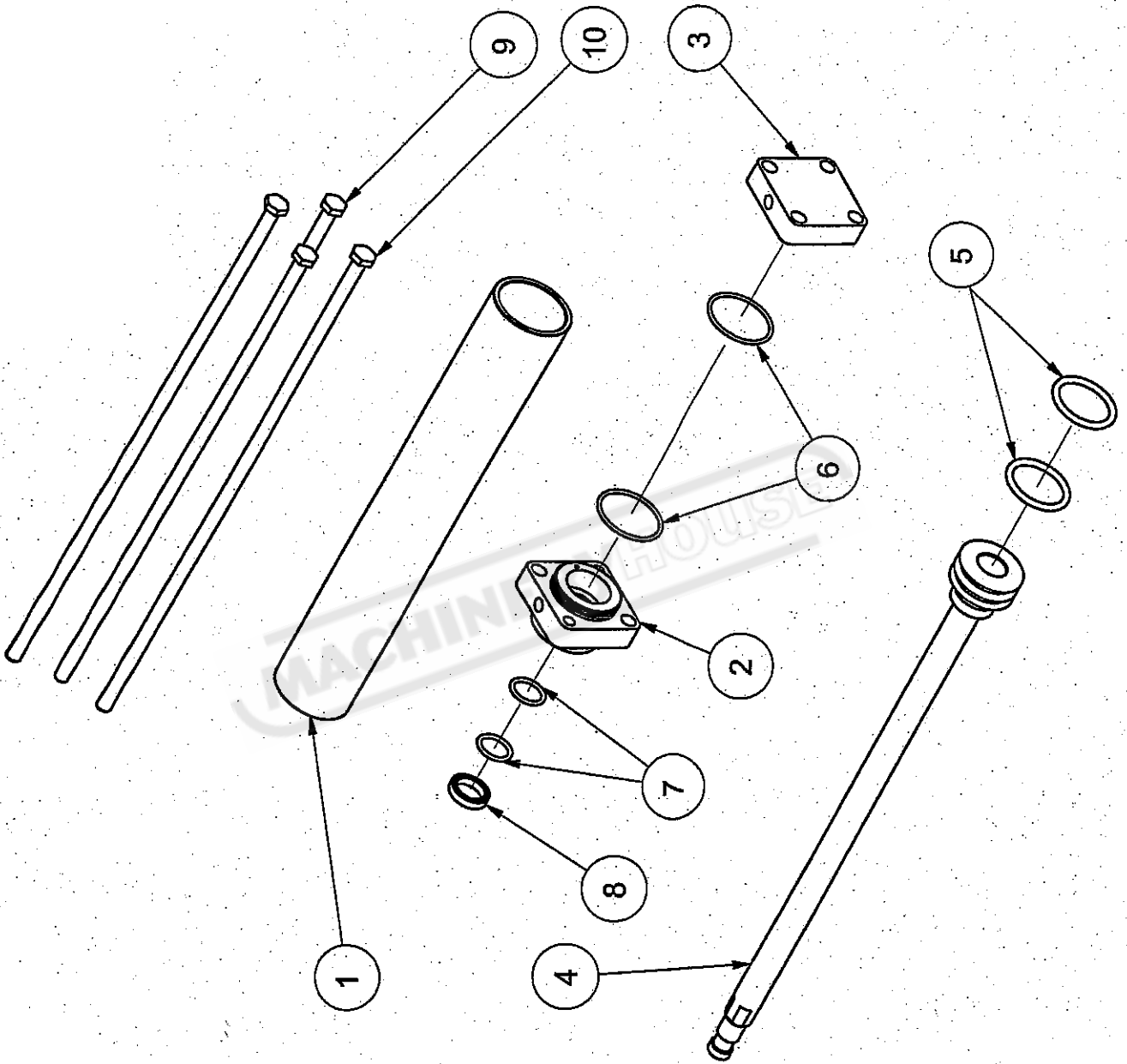


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01061200	BASE (SHORT)				
2	1	B01060900	PISTON ROD				
3	1	B01061000	ADJUSTING DISK				
4	1	B02140200	BLOCK				
5	2	B02140700	FLEXIBLE BLOCK				
6	1	B01032700	GUIDE ROD				
7	1	B01060700	CYLINDER				
8	2	2DU3012	LUBRICATING BEARING				
9	1	B01060800	BACK COVER				
10	1	DIAMETER 33	COMPRESSED SPRING				
11	1	P49	O RING				
12	1	P49	BACKING UP RING				
13	1	G50	O RING				
14	1	P30	O RING				

A010010 VERTICAL PRESS DEVICE (SHORT)

A010011

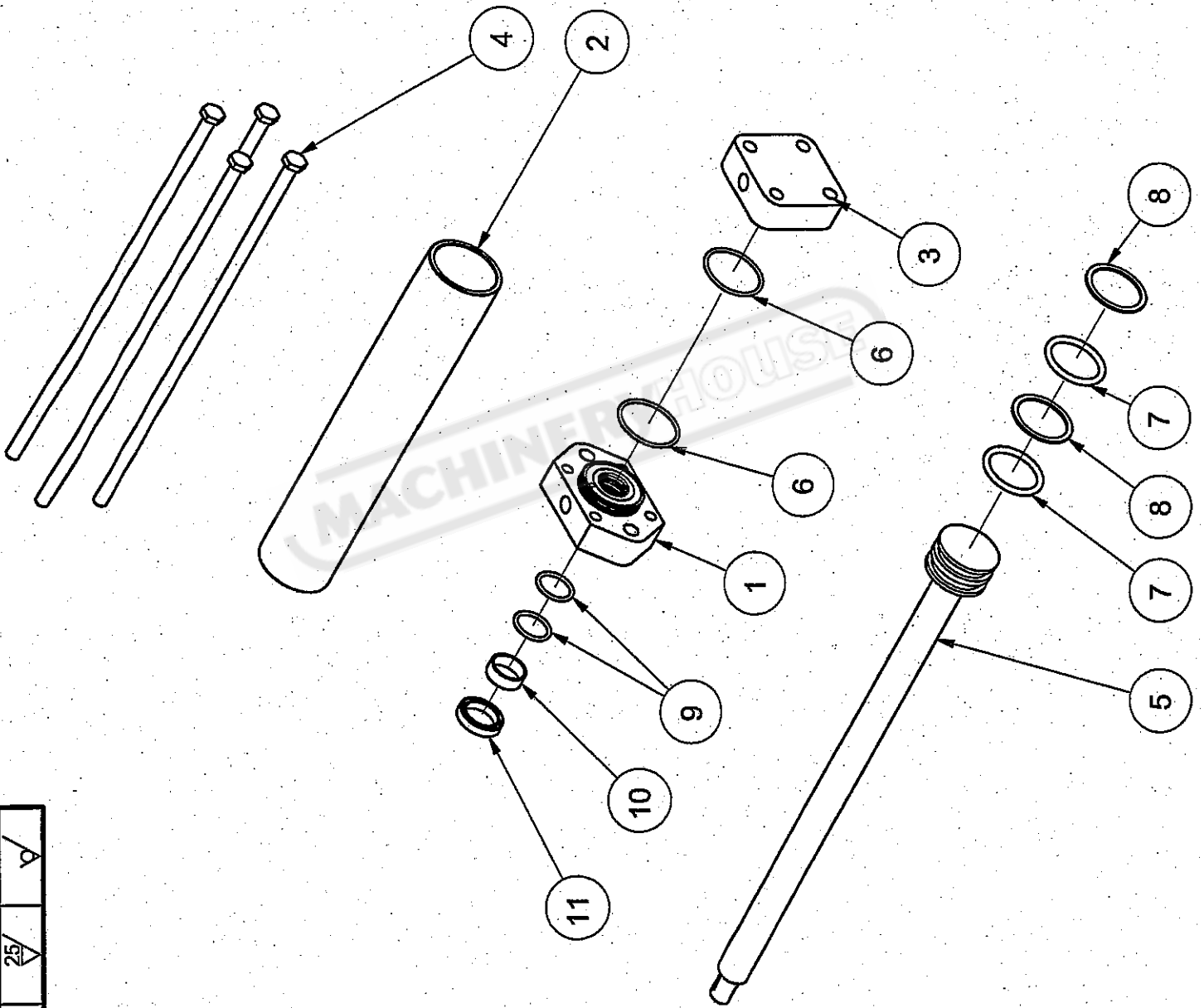


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01062400	CYLINDER				
2	1	H03262200	FRONT COVER				
3	1	H03262100	BACK COVER				
4	1	B01060300	PISTON				
5	2	P50A	O RING				
6	2	G55	O RING				
7	2	P25	O RING				
8	1	D35-d25-B7	OIL SEAL				
9	2	B02063000	SCREW				
10	2	B02162300	SCREW				
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A010011 FEED CYLINDER UNIT

A010012

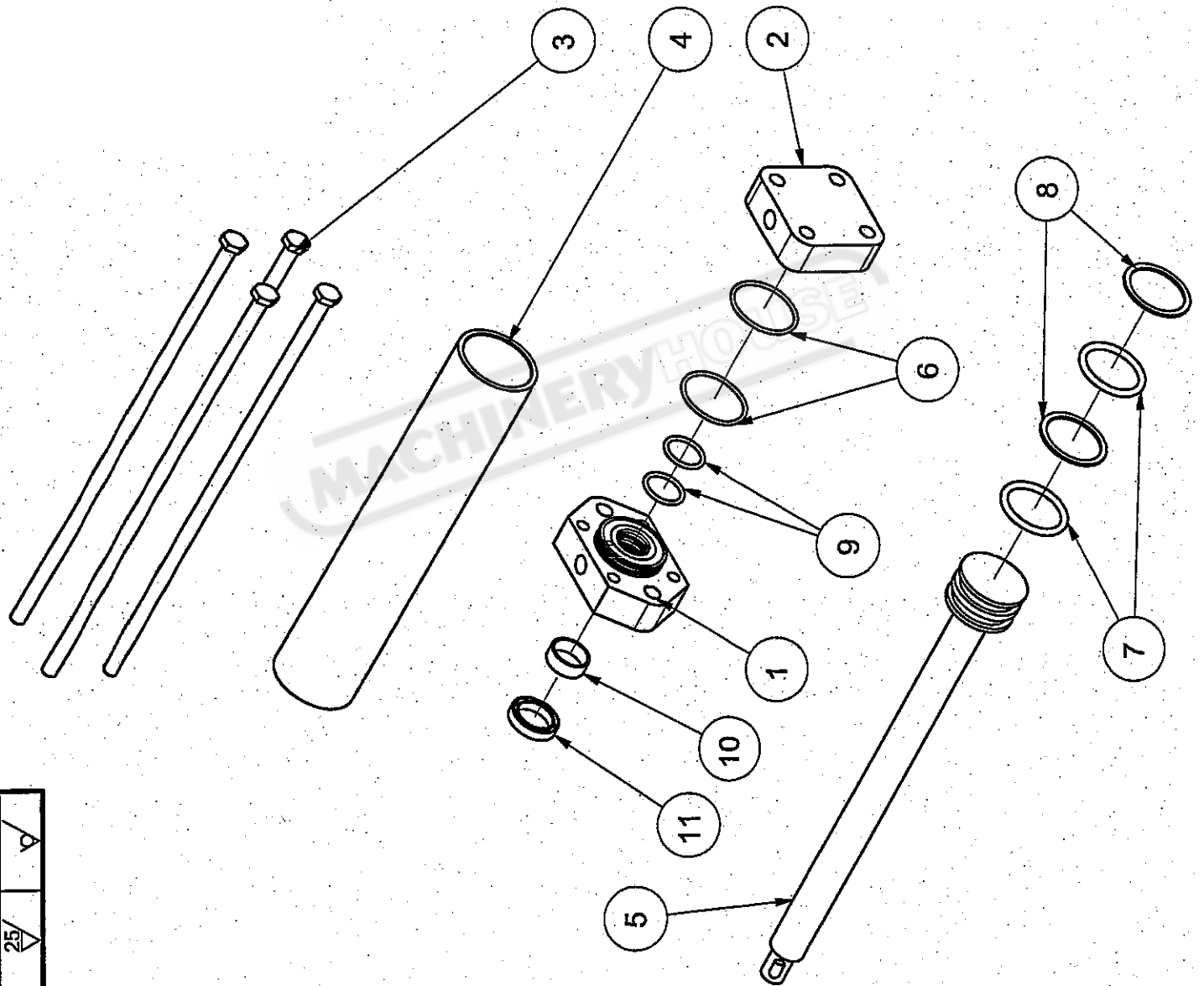


0.2	1.6	6.3	25	

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01061100	FRONT COVER				
2	1	B01060400	CYLINDER				
3	1	B02062000	BACK COVER				
4	4	B01061300	SCREW				
5	1	B01060100	PISTON				
6	2	G55	O RING				
7	2	P50A	O RING				
8	2	TP50A	BACKING UP RING				
9	2	P30	O RING				
10	1	2DU3012	LUBRICATING BEARING				
11	1	D42-d30-B8	OIL SEAL				
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A010012 CYLINDER UNIT OF FEED VISE

A010013

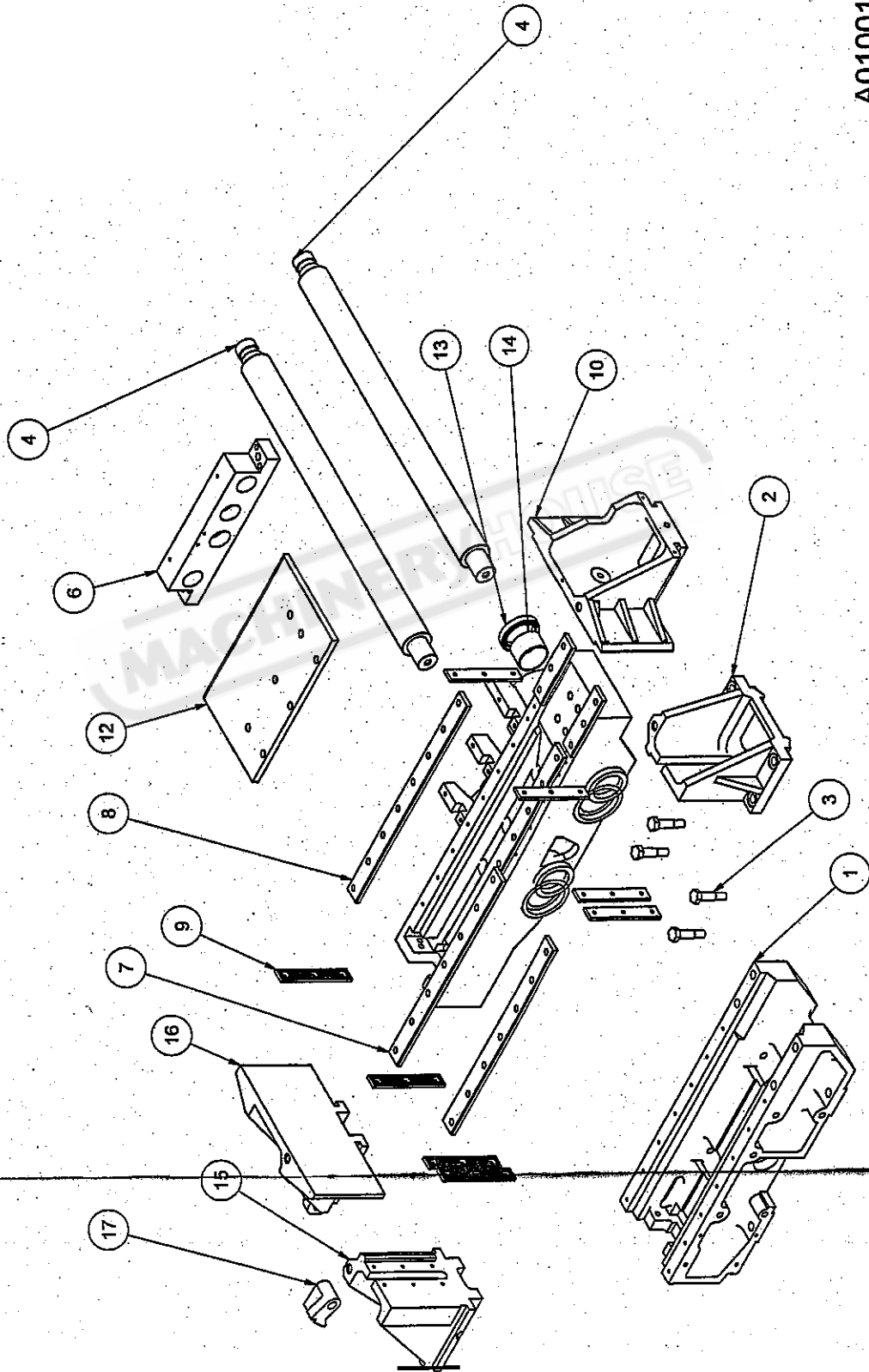


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01061100	FRONT COVER				
2	1	B02062000	BACK COVER				
3	4	B01061300	SCREW				
4	1	B01060500	CYLINDER				
5	1	B01060200	PISTON				
6	2	G55	O RING				
7	2	P50A	O RING				
8	2	TP50A	BACKING UP RING				
9	2	P30	O RING				
10	1	2DU3012	LUBRICATING BEARING				
11	1	D42-d30-B8	OIL SEAL				
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A010013 CYLINDER UNIT OF TABLE VISE

A010015



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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B01030100	FIXING TABLE				
2	1	B01031900	FIXING VISE				
3	4	B02130700	SCREW				
4	2	B01030700	SLIDE RAIL				
5	1	B01030800	MOVABLE TABLE				
6	1	B01031000	BASE				
7	2	B01030500	WEARABLE PLATE				
8	2	B01032600	WEARABLE PLATE				
9	8	B01031200	PLATE				
10	1	B01031400	FLOATING VISE				
11	2	B01032500	PLATE				
12	1	B01030300	PLATE				
13	4	D82-d60-B12	OIL SEAL				
14	4	2DU6040	LUBRICATING BEARING				
15	1	B01032900	VISE				
16	1	B01032800	VISE				
17	2	B01033000	HANDLE				
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A010015 TABLE UNIT (CRACK MODEL)



WARNING

General Machinery Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.



Metal Cutting Bandsaw Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure the bandsaw is turned off and disconnect from the main power supply and make sure all moving parts have come to a complete stop before any inspection, adjustment or maintenance is carried out.
- 2. Bandsaw Condition.** Bandsaw must be maintained for a proper working condition. Never operate a bandsaw that has damaged or worn parts. Scheduled routine maintenance should performed on a scheduled basis.
- 3. Blade Condition.** Never operate a bandsaw with a dull, cracked or badly worn blade. Before using a bandsaw inspect blades for missing teeth and cracks.
- 4. Replacing Blade.** Make sure teeth are facing the correct direction. Wear gloves to protect hands and wear safety glasses to protect your eyes.
- 5. Hand Hazard.** Keep hands and fingers clear from the line of cut of the blade and offcuts workpieces. Hands can be crushed in vice or from falling machine components and cut by the blade.
- 6. Leaving a bandsaw Unattended.** Always turn the bandsaw off and make sure all moving parts have come to a complete stop before leaving the bandsaw. Do not leave bandsaw running unattended for any reason.
- 7. Avoiding Entanglement.** Blade guard must be used at all times. Remove loose clothing, belts, or jewelry items. Never wear gloves while machine is in operation. Tie up long hair and use the correct hair nets to avoid any entanglement with the bandsaw moving parts.
- 8. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 9. Power outage.** In the event of a power failure during use of the bandsaw, turn off all switches to avoid possible sudden start up once power is restored.
- 10. Work area hazards.** Keep the area around the bandsaw clean from oil, tools, chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 11. Workpiece Handling.** Workpieces must be supported with table, vice, roller conveyor/stands, or other support fixtures. Unsupported workpieces may cause the machine to tip over and fall. Flag long pieces of material to avoid tripping hazards. Never hold a workpiece with your hands during the cut process.
- 12. Hearing protection and hazards.** Always wear hearing protection as noise generated from bandsaw blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time.
- 13. Hot surfaces.** Workpieces, machine surfaces and chips become hot due to friction and can burn you.
- 14. Starting position.** Never turn the bandsaw on when the blade is resting on the workpiece.
- 15. Guards.** Do not operate bandsaw without the blade guard in place or with the doors open.
- 16. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Metal Cutting Bandsaw

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Australian Worksafe Standard for Plant(NOHSC.:1010-1994)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
A	ENTANGLEMENT	HIGH	Eliminate, avoid loose clothing / Long hair etc.
B	CRUSHING	LOW	Secure & support Long / heavy material
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Blade guards should always be in the closed position before starting machine. Blade guide system should be adjusted to suit material width. Wear gloves when changing blades. Isolate main power switch before changing blade, cleaning or adjusting. If blade breaks do not open door until both wheels have stopped. Check blade tracking before starting.
D	SHEARING	MEDIUM	Make sure all guards are secured shut when machine is on. Isolate power to machine prior to changing belts or maintenance.
F	STRIKING	LOW	Support long heavy jobs and stand clear of offcuts. Stand clear of machine when in operation. Remove all loose objects around moving parts. Wear safety glasses
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine. Machine should be installed & checked by a Licensed Electrician.
O	OTHER HAZARDS, NOISE.	LOW	Wear hearing protection as required.
Plant Safety Program to be read in conjunction with manufactures instructions			



www.machineryhouse.com.au



www.machineryhouse.co.nz

Authorised and signed by:
Safety officer:



Manager:



Revised Date: Aug-08