

INSTRUCTION MANUAL

BP-250 Wood Band Saw (240V) 245 x 100mm



W417

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1.0 General

1.1 Specifications

Dimensions(lxwxh)	W417 860X420X530 mm
Weight with motor	35 kg
Table height from floor	370 mm
Throat width	245 mm
Max. cutting height	100 mm
Sawblade length	1712 mm
Sawblade width	10 mm
Sawtable tilt	to 45°
Sawtable size	340x335 mm
Sawblade speeds	700 m/min
Motor capacity	230V 50Hz 370W

1.2 User Responsibility/Warranty

This appliance will perform in conformity with the description contained in the instructions provided. This machine must be checked periodically. Defective equipment (including power cables) should not be used. Parts that are broken, missing, obviously worn, distorted or contaminated, should be replaced immediately. Should such repair or replacement become necessary, it is recommended that only genuine D&D replacement parts are used and that such repairs are carried out by qualified persons approved by D&D or its representatives. Failure to comply relieves D&D from product liability. The aforementioned also applies to all accessories offered for this appliance.

This appliance or any of its parts should not be altered or changed from standard specifications. The user of this machine shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specifications, faulty maintenance, damage or improper repair by anyone other than qualified person approved by D&D or its representatives. Please fill in the warranty registration card and send to the address shown on it. Normal wearing parts and consumables are not covered by the warranty.

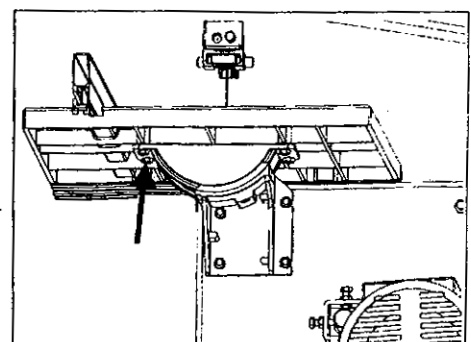
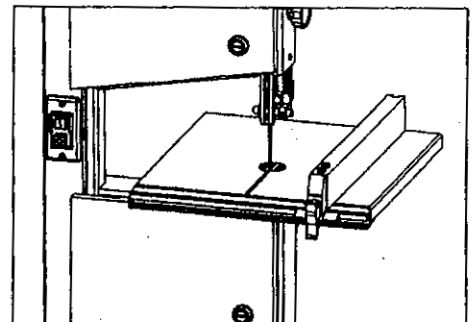
1.3 Final Assembly and Installation

Unpack machine and check for any visible damage which may have occurred during transport. If a damage is detected notify your dealer immediately.

This machine is shipped partly disassembled. Saw table and rip fence guide have to be installed prior to use.

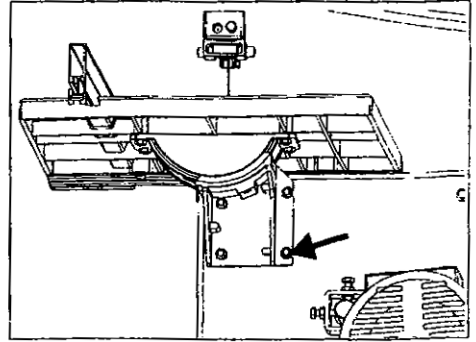
- Remove the rip fence guide extrusion from the table.
- Place the table onto the upper table trunnion.
- Install to trunnion with 4 each serrated lock washer and hexagon head screw M 6x16.
- Attach rip fence guide extrusion to table with the two thumb screws.
- Place table insert into the table centre hole (table insert with wide slot for bevel cuts only).
- Insert cup square neck screw into rip fence guide and secure with washer ϕ 8.4 and wing nut.
- Attach rip fence extrusion with 2 each cup square neck screw M6x30, washer ϕ 6.4 and knurled nut M6 to the rip fence guide.

After installation adjust the table so that the sawblade runs through the centre of the table insert's slot.



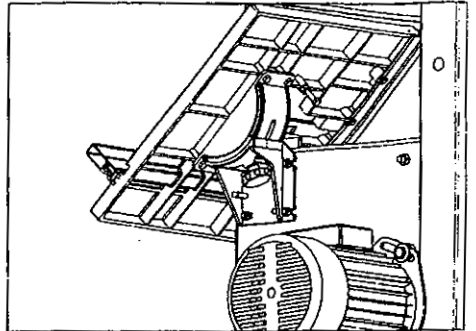
Centering the Table

- Loosen the screws holding the lower table trunnion.
- Move table sideways as required, until sawblade runs through the centre of the table insert.
- Tighten the table trunnion screws, ensure the table stays in its set position

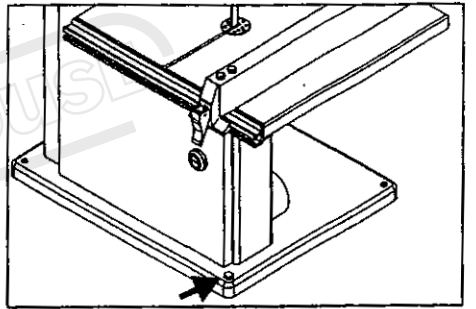


Setting the Table Square with the Sawblade

- The saw table can be tilted up to 45°. To tilt, loosen the knob of the table trunnion.
- A stop on the underside of the table rests on the lower wheel housing when the table is at 90° with the blade.
- By turning the hexagon nut (A) in or out, as required, the angle against the sawblade can be adjusted.
- After setting the table affix the scale to the rip fence carrier extrusion.

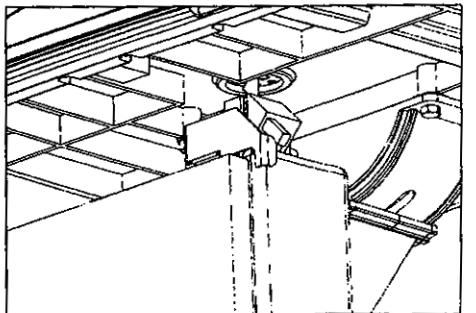


To ensure sufficient upright stability of the machine it should be bolted to floor, bench or table, or mounted on the Workstand BAS, available as optional accessory. For this purpose $\phi 9\text{mm}$ holes are provided in the machine's base plate.



Sawblade Guard

When opening the lower wheel housing door the sawblade guard swings down.
When closing the door, the sawblade guard must be lifted by hand, so the door can close fully.
Important: Operate saw only with the lower wheel housing door closed.



Dust Collection

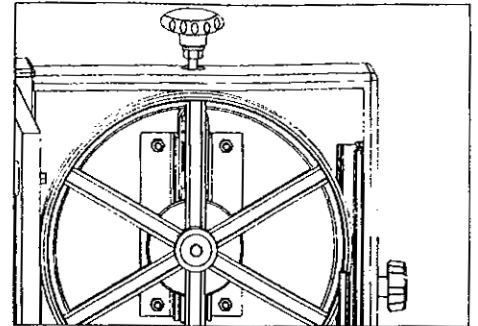
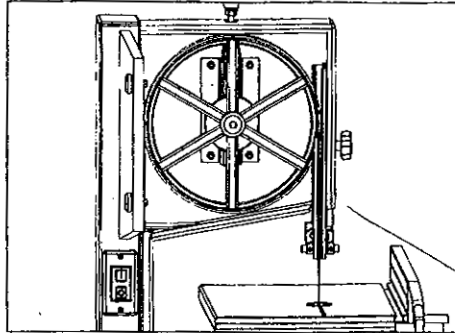
If this band saw is operated indoors it is recommended to have it connected to a dust collector. The suction connector, supplied with the machine, has to be fitted to the dust ejection port of the saw for this purpose. The diameter of the suction connector is 60 mm. The dust collector this saw is connected to must provide for an air flow rate of 20 mtr/sec.
Caution! Wood dust and chips, together with an ignition source and the oxygen in the ambient air, can cause fires and explosions, injuries and allergies.

- Workmen working in operations processing oak or beech timber where found to develop more often cancer of the mucous membrane of the nose (adenocarcinoma of the inner nose) than other workers.
- Experience shows that skin contact with oak or beech dust does not cause cancer.

2.0 Band Saw Settings

2.1 Changing and Setting the Saw Blade

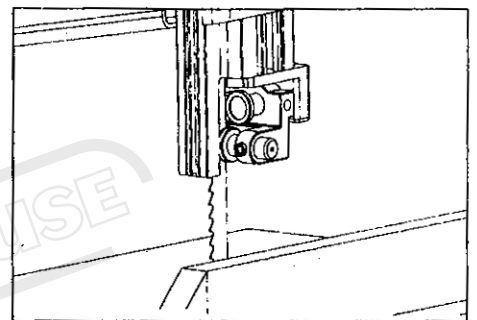
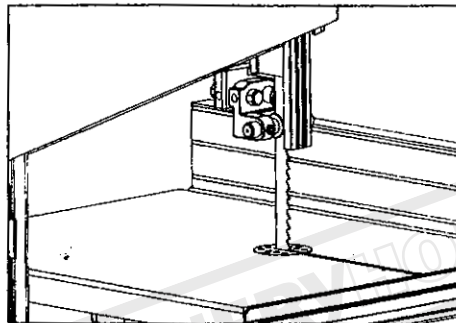
This band saw is factory-equipped with a general purpose woodcutting blade, the blade set. To change the blade, remove the rip fence carrier extrusion from the table. Then slacken the blade tension by turning the handwheel on top of the upper wheel housing. Remove the blade.



Fit new blade and tension lightly. The blade should run in the centre of the rubber lined band saw wheels or else it may jump off. To check tracking, turn upper wheel by hand. If required, adjust tracking with the knurled handle at the rear of the upper wheel housing.

2.2 Blade Guiding

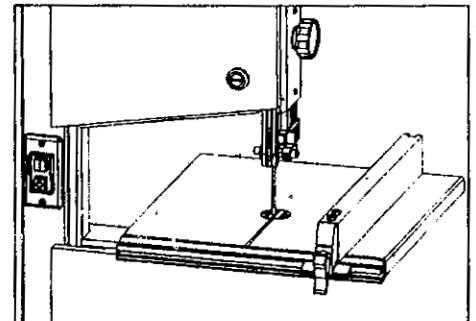
The saw blades guide of this band saw model BAS 250 ensure an exact guiding of the blade for clean cuts. When using narrow blades ensure that the lower blade guide positively supports the blade from both sides and the rear.



Set the bearings of the upper blade guide to within approx. 0.5 mm of the blade, and the rear bearing against the back of the blade, just clear of it. Do not set the bearing too close, as the friction generates heat, which may have an adverse effect on the bearings and the saw blade as well.

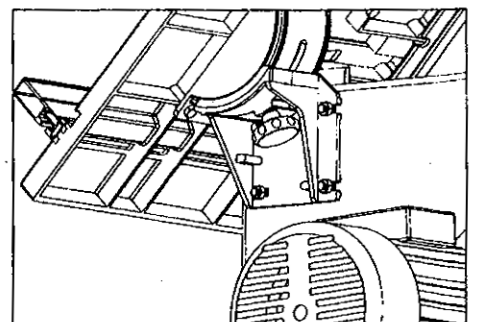
2.3 Setting the Cutting Height

The upper blade guide should always be set as close as practical against the work. To adjust, turn the knob nut at the side of the upper wheel housing, and Tighten wig nut after setting.



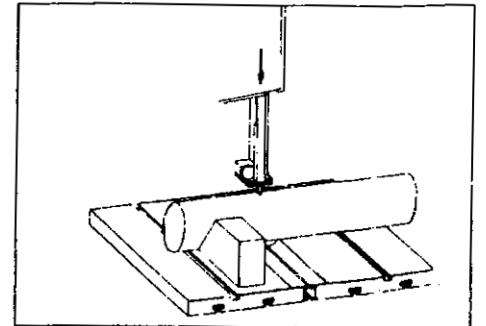
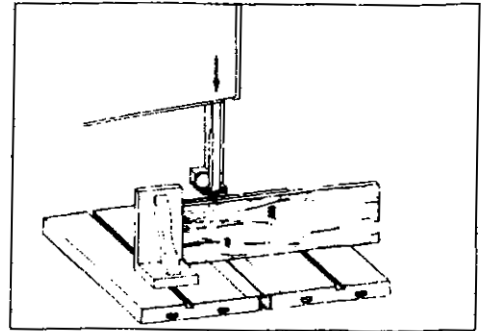
2.4 Saw Table Tilt

For bevel cuts the saw table tilts steplessly through 45°. To tilt, loosen the knob on the table trunnions, set table to the required angle and tighten the knob again. It is recommended to verify the correct angle setting by making trial cuts in scrap wood.



2.5 Safety Information

1. Check that all guards are in place and securely locked before switching the machine on.
2. Always disconnect from power when servicing this machine.
3. Do not use bent or cracked band saw blades.
4. Replace table insert if slot has enlarged.
5. For cutting operations with a tilted table the rip fence has to be located to the right hand side of the blade.
6. When cutting round stock use a suitable jig or fixture to keep the work from turning.
7. When cutting boards in an upright position use a suitable push block to prevent kickback.
8. To keep health risk to a minimum it is recommended to always connect this band saw to a dust collector having an air flow rate of at least 20 m/s.



The most common hazards associated with the operation of band saws are the following:

- a hazard by the running saw blade, e.g. contact with the teeth of the blade.
- flinging of cutoffs or knots
- workpiece kickback

The principal hazard areas of a band saw are:

- the work area
- the area around a running machine
- the kickback area

Despite the use of the specific safety devices and compliance with all relevant regulations for the prevention of accidents, when operating a band saw the following residual risks remain:

- hearing damage by excessive noise;
- danger of accidents in the unprotected cutting area of the running saw blade;
- danger of injury when changing blades (danger of cuts by the sharp teeth);
- endangering by flung about workpieces or parts;
- squashing of fingers;
- danger of injury by kickback of workpieces;
- health risk caused by the dust emission, especially from oak and beech saw dust.

2.6 Other Information

This band saw can be fitted and/or upgraded with a range of optional accessories. D&D or its representatives can only assume liability under the current product liability regulations if the machine, and all accessories offered or made available for it, is used for its intended purpose.

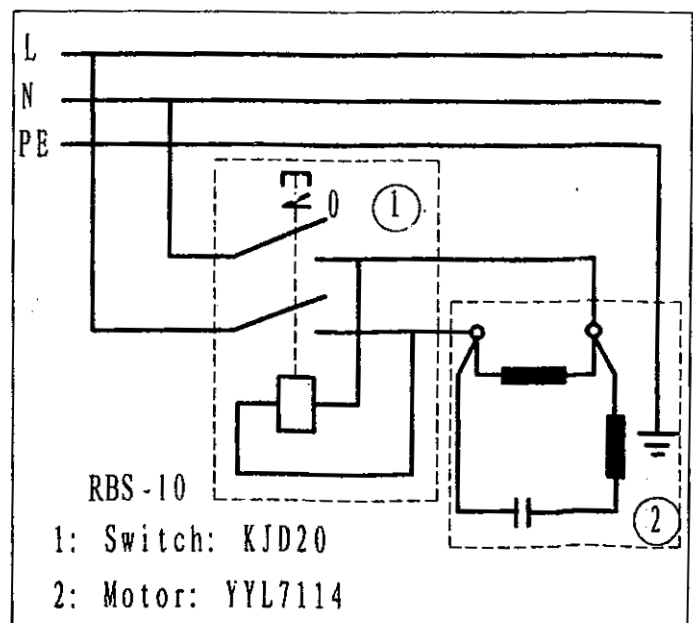
2.7 Electrical Installation

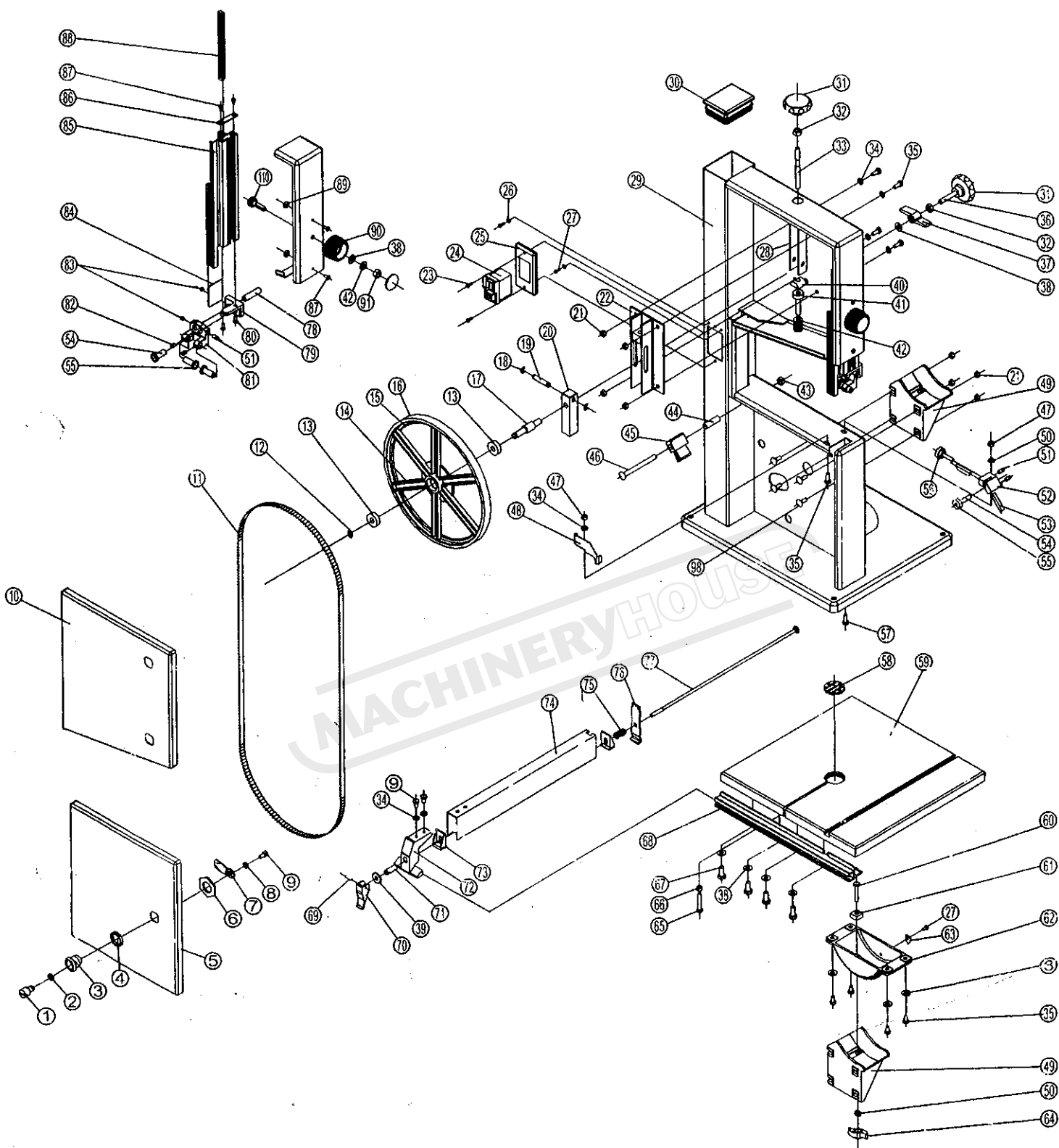
This band saw is equipped with either a 0.37 kW 230V single-phase motor. Connection to a supply circuit is made by an extension cable, plugged directly into the switch.

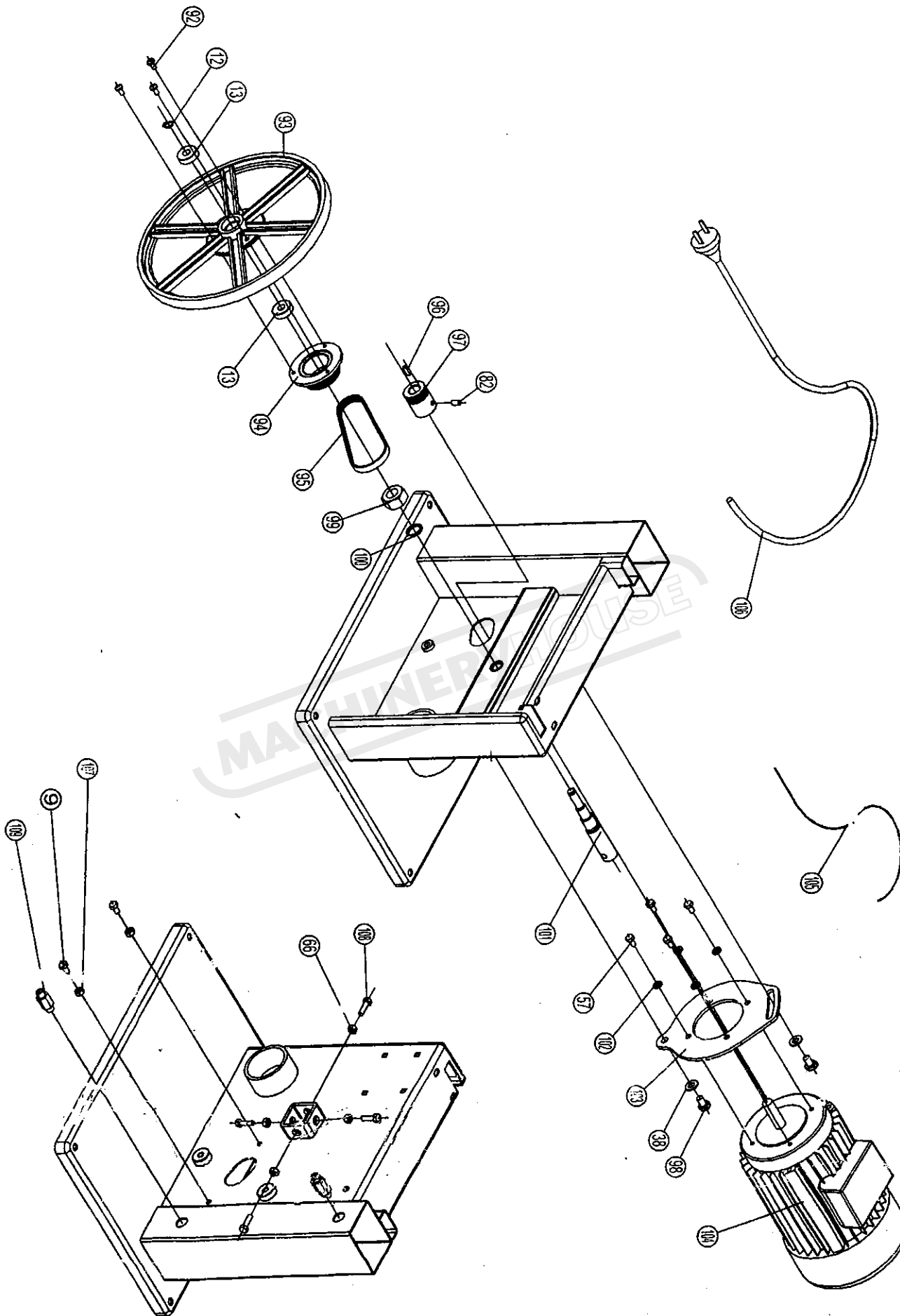
This machine must be connected to an earthed outlet and should be operated on a residual current device (RCD) of 30mA capacity. Extension cables must should have a minimum lead cross section of 3x0.75mm² (230V).

Have damaged power cables replaced at once by a qualified electrician. Risk of electric shock if operated with adamaged power cable.

Children should not operate this band saw.







PARTS LIST

Item	Part No.	Description	Q'ty
1	31503031	Slotted Insert	3
2	31503022	Washer	3
3	31503032	Housing	3
4	31503020	Washer	3
5	DJ250B04001	Door Lower	1
6	31503033	Housing with Nut	3
7	31503030	Tongue	3
8	GB862.2-87 6	Ext.Lock Washer 6	3
9	GB5783-86 M6x10	Hex.Hd.Bolt M6x10	5
10	DJ250B03001	Door Upper	1
11	DJ250A05001	Saw Blade	1
12	GB894.1-86 10	Ring Retaining	2
13	GB/T276-94 6000-2Z	Ball Bearing	4
14	DJ250A03005	Upper Wheel	1
15	DJ250A03005-1	Balance Collar	fit
16	DJ250A04009	Band Saw Tyre	2
17	DJ250A03004A	Bearing Bolt Upper	1
18	GB896-86	"E"Rings	2
19	DJ250A03007	Pin Guide	1
20	DJ250A03003A	Seat Bearing Bolt Upper	1
21	GB6177-86 M6	Hex.Hd.Flange Nut	8
22	DJ250A03002A	Guide Plate Assembly	1
23	GB819-85 M4x12	Cross Countersunk HD.Screw	2
24	KJD20	Magnetic Switch	1
25	DJ25005004B	Switch Plate	1
26	GB862.2-87 4	Ext.Lock Washer	2
27	GB823-88 M4x6	Cross Pan.Hd.Screw	2
28	DJ250A03010	Blade Tensioner	1
29	DJ250B01000	Band Saw Frame	1
30	DJ250A05002	Lamello Plug Black	1
31	DJ250A03008	Adjust Handle	2
32	GB6172-86 M8	Hex.Hd.Thin Nut	4
33	DJ250A03006	Thread Bolt	1
34	GB97.1-85 6	Washer	8
35	GB5783-86 M6x12	Hex.Hd.Bolt	9
36	GB5783-86 M8x45	Hex.Hd.Bolt	1
37	31503007	Wing knob	1
38	GB97.1-85 8	Washer	10
39	GB97.1-85 10	Washer	1
40	DJ250A03009	Nut	1
41	DJ250A03011	Shaft	1
42	GB/T1792 A16	Butterfly Spring	18

PARTS LIST

Item	Part No.	Description	Q'ty
43	GB6177-86 M8	Hex.Hd.Flange Nut	1
44	DJ250A04014	Spacer Bushing	1
45	31504015	Brush Strip	1
46	GB14-88 M8x70	Cup Square Neck Bolt	1
47	GB889-86 M6	Hx.Hd.Lock Nut	2
48	DJ25004011	Blade Guard	1
49	DJ250A02002	Blade Trunnion Lower	1
50	GB96-85 6	Washer	1
51	GB80-85 M6x12	Int.Hd.Screw	3
52	DJ250A04002A	Roller Guide	1
53	31504003	Pilot Pin	2
54	DJ250A03021	Thurst Bearing Shaft	4
55	GB/T276-94 625-2Z	Bearing	4
56	31504018	Idler Wheel Shaft	1
57	GB5783-86 M6x16	Hex.Hd.Bolt	8
58	DJ25002005	Blade Fork	1
59	DJ250A02001	Table	1
60	GB14-88 M6x30	Cup Square Neck Bolt	1
61	DJ25002006A	Guide Piece	1
62	DJ250A02003	Table Trunnion Upper	1
63	DJ250A02004	Indicator	1
64	DJ250A02005	Tension knob	1
65	GB5783-86 M6x30	Hex.Hd. Bolt	1
66	GB6170-86 M6	Hex. Nut	5
67	GB5783-86 M8x12	Hex.Hd. Bolt	4
68	DJ250A02014	Rip Fence Canier Extrvsion	1
69	GB879-86 3x16	Roll Pin	1
70	DJ250A02008A-8	Partiality Piece	1
71	DJ250A02008A-6	Connet Set	1
72	DJ250B02008-1	Baffle Bracket	1
73	DJ250A02008A-2	Stuck Piece	2
74	DJ250A02008A-1	Baffle	1
75	DJ250A02008A-3	Spring	1
76	DJ250A02008A-4	Clamp Board	1
77	DJ250A02008A-5	Clamp Screw	1
78	DJ315B03024	Fastening Shaft	1
79	DJ250A03014A	Seat Guide Upper	1
80	GB846-85 ST4.2x13	Cross CS.HD Tapping Screw	2
81	DJ250A03022A	Housing Upper Guide	1
82	GB80-85 M6x8	Int.Hd.Screw	3
83	GB80-85 M6x6	Int.Hd.Screw	2
84	DJ250A03024	Slide Board	1

PARTS LIST

Item	Part No.	Description	Q'ty
85	DJ250A03012	Guide Lever	1
86	DJ315B03031-1	Cover Board	1
87	GB845-85 ST4.2x9.5	Cross Pan.Hd.Screw	4
88	DJ250A03018	Rack	1
89	DJ250A03013	Guide Piece	2
90	DJ315B03016	Adjust Knob	1
91	GB889-86 M8	Hx.Hd.Lock Nut	1
92	GB818-85 M5x10	Cross Pan. Hd.Screw	3
93	DJ250A04005	Wheel Lower	1
94	DJ25004008	Pulley lower	1
95	DJ25004010	V-Ribbed Belts	1
96	GB1096-79 5x30	Key	1
97	DJ25004004	Motor Pulley	1
98	GB14-88 M6x16	Cup Square Neck Bolt	4
99	GB6171-86 M14x1.5	Hex.Nut	1
100	GB93-87 14	Spring Washer	1
101	DJ250A04006	Bearing Bolt Upper	1
102	GB93-87 6	Spring Washer	4
103	DJ25005003-1	Plate Mounting Motor	1
104	YYL7114	Motor	1
105	DJ250A05006	Motor Cord	1
106	DJ250A5005	Power Cord	1
107	GB6172-86 M6	Hex.Hd.Thin Nut	2
108	GB5783-86 M6x20	Hex.Hd.Bolt	4
109	31505010A	relief strain	2
110	DJ250A03019	Shaft	1