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## ELEKTRA BECKUM ()

### Betriebsanleitung Bandsäge BAS 315 Instruction Manual Band Saw BAS 315

Serien-Nr. 09004 K



#### Contents

- 1.0 **Technical Data**
- 2.0 User Responsibility
- Safety Rules for Band Saws 3.0
- 4.0 Initation

- 5.0 Operation
- 6.0 Additional Safety Rules
- 7.0 **Optional Accessories** 
  - Spare Parts Lists 8.0

#### 1.0 **Technical Data**

wax. neight of cut
Throat capacity
Saw blade length
Saw blade width
Saw blade size
Saw blade tilt

170 mm 305 mm 2250 mm 6-15 mm 400x400 mm stepless 90° to 45°

Height	1265 mm
Width	610 mm
Depth	590 mm
Weight BAS 315/55	45 kg
Weight BAS 315 Unimex	41 kg
Table height from floor	480 mm
Table height from floor with workstand	1100 mm

Blade speeds: BAS 315/55

BAS 315 Unimex

50 Hz 370&800 m/min 60 Hz 444&960 m/.in 50/60 Hz 950/1140 m/min Motors:

OFF LINUO JE ha deolate V	FO/CO LI- 1 shares
0.55 KW/0.75 np 110/115 V	50/60 Hz 1-phase
0.55 kW/0.75 hp 220/240 V	50/60 Hz 1-phase
Unimex 1.76kW/2.40hp 220/240 V	50/60 Hz 1-phase
Unimex 2.20kW/3.00 hp 380/415 V	50/60 Hz 3-phase

#### Standard Accessories

General purpose blade 2240x12x0,5 mm, tooth spacing 6 mm; rip fence; adaptor 100 mm diameter for connection of dust extractor: Allen key SW 3 mm; instruction manual

#### 2.0 User Responsibility

This machine will perform in conformity with the description contained in the manual when installed, operated, maintained and repaired in accordance with the instructions provided.

This machine must be checked periodically. Defective equipment (including service leads) should not be used. Parts that are broken, missing, plainly worn, distorted or contaminated, should be replaced immediately. Should such repair or replacement become neccessary, it is recommended that such repairs are carried out by qualifed persons approved by the equipment manufacturer or its representatives.

This machine or any of its parts should not be altered or changed from standard specifrications. The user of thes machine shall have the sole responsibility for any malfunction which results from improper use, unauthorized modification from standard specifications, faulty maintenance, damage or improper repair be anyone other thand qualified persons approved by the equipment manufacturer or its representatives.

#### Note

The information contained in this manual is intended to help the owner/operator of this band ssaw with the setup of the machine and the setting of cutting speeds, fences and guards. It is not a maintenance manual for servicing and repair nor does it teach the operator how to become an expert woodworker.

#### **Dust Colloction**

We strongly recommend the use of a Dust Collector with this machine. Our Sales Department will be happy to offer you advice on the correct collector.

#### 3.0 Safety Rules for Band Saws

As with all power tools there is a certain amount of hazard involved with the operator and his unse of the machine. Using the machine with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. If, however, normal safety precautions are overlooked or completely ignored, personal injury to the operator can develop.

This machine falls under the Woodworking Machinery Regulations 1974. For your own safety it is recommended to follow the instructions given in the Woodworking Machines Regulations 1974 Guidance and Regulations ref. L4 (ISBN 0118855921). This publication is available from Her Majesty's Stationary Office and other bookshops. 1. FOR YOUR OWN SAFETY READ AND UNDERATAND THIS INSTRUCTION MANUAL BEFORE OPERATING THE SAW: Learn the saw's application and limitations as well as the specific hazards peculiar to it.

2. PERMANENTLY MOUNT YOUR BAND SAW before performing cutting operations.

3. KEEP GUARDS IN PLACE and working order.

4. MAKE ALL ADJUSTMENTS AND SET UPS, such as tilting the table or adjusting the saw blade guards and blade guides, WITH THE POWER OFF. add we build add add and a set of a set

5. ADJUST BLADE TENSION, upper and lower blade guides, thrust bearing, and blade tracking correctly.

6. DOOR AND BLADE GUARD must be in place and securely fastened when performing any saw operations.

7. SECURELY LOCK ALL ADJUSTABLE PARTS so they cannot loosen while sawing. This will prevent distraction during sawing operations. Ideal and a solar should be added by the solar should by the solar should by the solar sh

8. PLACE THE BLADE GUARD to approximately 5 mm above the material being cut.

9. USE THE PROPER BLADE TYPE AND SIZE for the material being cut.

10. ALWAYS KEEP HANDS AND FINGERS AWAY from the saw blade, especially at the end of a cut. Use a spike or push stick as neccessary.

11. HOLD MATERIAL FIRMLY and feed into the blade at a moderate speed.

12. USE A PUSH STICK or piece of scrap wood to do the pushing and guiding when sawing small pieces which require the fingers to be close to the blade.

13. DO NOT SAW SSTOCK shat does not have a flat surface unless a suitable support is used.

14. ALWAYS STOP THE MACHINE before removing scrap pieces from the table.

15. STOP THE MACHINE IF THE MATERIAOL IS TO BE BACKED OUT OF AN UNCOMPLETED CUT:

18. WHEN SAWING CURVES, make relief cuts to allow removal of scrap material. This will help to prevent undue twisting or binding of the saw blade. The relief cuts are made before starting the curved cut.

#### 4.0 Initiation

#### 4.1 Final Assembly

To facilitate better handling and prevent damage to projecting parts during transport, this machine is shipped partly disassembled. After unpacking, the saw table, rip fence and crank handle have to be assembled and mounted before the saw can be taken into operation.

Remove wrapping and check for any visible damages which may have occured during transport. If damages are detected, notify your dealer immediately.

#### To assemble table proceed as follows:

Remove rip fence carrier extrusion (93) to table (90). Place the four carriage bolts M8x30 (108) into the t-slot of the table, place table onto upper table trunnion (92) and secure carraige bolts with washer M8.4 (109), spring washer B8 (110) and hex. nuts M8 (111).

Attach rip fence carrier extrusion (93) to table and tighten nuts.

Press table insert (pos. 88 for 90° cuts, pos. 23 for bevel cuts) into table and align slot parallel with saw blade.

DNITABLED BROBB JAUMAN MORTOURING CONTINUES ON THE ACTION OF A CASE YTERAS MWO RUOY Insert bolt guide (97) with carriage bolt M8x50 (112) into the rip fence carrier extrusion's t-slot.

Place rip fence carrier (95) onto carriage bolt (112) and tighten with washer A 8.4 (109) and lock lever M8 (25).

Bolt rip fence extrusion (94) to rip fence carrier (95) with 2 each carriage bolt M6x35 (113), washer A 6.4 (35) and knurled nut M6 (104).

Attach crank handle (75) to crank (51), using cap screw M6.55 (107) and two hex. flat nuts M6 (76). HTTV second

After assembly the table has to be aligned in order to have the blade running through the centre of the table insert's slot.

To move table sideways, loosen bolts on the lower table trunnion (91). Move table trunnion to left or right, until blade runs through center of slot. Tighten bolts, be careful that table stays in position while bolts are being tightened. To set the table square to the blade, the cap nut on the stop on the underside of the table has to be turned in or out, as required.

After the table is correctly aligned affix the scale (96) to the rip fence carrier extrusion (93).

r the table is correctly aligned and the scale (96) to the hp rence carrier extrusion (95)

To ensure sufficiennt upright stability machine should be bolted to be bench or table, or mounted on the ELEKTRA Workstand BAS 315, available as optional accessory.

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#### 4.2 Connection to Power Mains

Check motor type plate to be sure that rated mathces voltage of your outlet.

Model BAS 315/55 is supplied either with a switch with integrated plug (SSK) or a switch with a 3-conductor cord. The yellow-green conductor of the cord is the earth lead.

Fit a SCHUKO-type female receptacle to en extension cord to connect to the SSK-type switch, or a plug of your local standrad to the power cord.

Never connect earth lead to a live terminal!

Caution! Disconnect machine from power when servicing or changing blades.

On machines equipped with electronic motor brake a light humming sound, emitted from the switch while machine is connected to power mains, is normal and does not represent a fault.

#### 5.0 Operation

#### 5.1 Changing/Setting of Saw Blade

This band saw is factory-equipped with a general purpose woodcutting blade, size 2240x12x0.5 mm, tooth spacing 6 mm.

To change blade, remove rip fence carrier extrusion (93) from saw table. Then slacken blade tension by turning vlade tensioner handwheel (9) counter-cloxkwise, open both doors and swing saw blade guard out of the way. Remove blade from machine.

Fit new blade and tension lightly. Blade must run in centre of band saw wheels or else it may jump off. To check alignment turn upper wheel by hand. If necessary, adjust tilt of upper band saw wheel with starknob setting screw (26) at rear of upper wheel housing. If a blade of different width is fitted, the thrust bearings of the upper and lower blade guide must be adjustes. Set thrust bearings against blade so that its teeth are just running clear of the guide bearings/pilot pins. Fully tension blade.

#### 5.2 Guiding of Saw Blade

For a clean and straight cut sufficient lateral support of the blade is necessary. This support is provided by the 3-roller guide at the blade guard assembly. Keep the guide bearings set closely against the blade, woth only minimal play of the blade, for best performance.

The pilot pins (14) of zthe lower blade guide are subject to wear. Regularly check blade for play and adjust pins to take the play out.

To adjust, loosen threaded pins at rear of pilot pin guide with Allen key 3 mmn, provided with machine, and set pilot pins against blade, touching it lightly. Tighten threaded pins to secure in position.

#### 5.3 Change of Saw Blade Speed

On band saw model BAS 315/55 two cutting speeds can be selected by changing the v-belt on the drive pulleys. Slacken v-belt tension with crank (51), located at right lower wheel housing. Both lower band saw wheel and motor pulley are two-stepped. Place v-belt (78) on either front or rear groove on both pulleys, slide v-belt tension pulley (53) into corresponding position on sliding shaft (59). Tighten v-belt with crank (51).



#### 5.4 Setting of Cutting Height

The upper blade guide should always be set as close as possible against the work. The adjust, loosen lock lever (24), to required position. Tighten lock lever after setting.

Pull, then lever swings freely

#### 5.5 Setting of Saw Table

For bevel cuts the saw table can be steplessly tilted up to 45°. To tilt, loosen the lock lever (25) holding the upper trunnion (92) to the lower trunnion (91), swing table to desired position and retighten nuts. Use wide slot table insert (23), so blade can travel freely.

#### 6.0 Additional Safety Rules

- 1. Disconnect from power changing blades or servicing machine.
- 2. Before switching machine on be sure that all guards are in place and securely locked.
- 3. Do not use cracked or bent saw blades.
- 4. Replace table insert (23/88) if slot has enlarged.
- 5. For cutting operations with tilted table the rip fence must be placed to the right of the blade.
- 6. When cutting round stock use a suitable jig to prevent work from turning.
- 7. When cutting boards in an upright position use a suitable pushblock to prevent kickback.

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Jig for cutting round stock

#### 7.0 Optional Accessories

#### 7.1 Crosscut/Mitre Fence PK/BAS

Stock-no. 091 000 8048 (for 3-pc. Table ass'y only)

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Push block

#### 7.2 Band Saw Blades

All blades Swedish steel with induction-hardened teeth.



General purpose blade tooth spancing 6 mm 2240x12x0,5 mm A4 stock-no. 090 900 0467 Blade for wood circular cutting tooth spacing 4 mm 2240x6x0,5 mm A6 stock-no. 090 900 0475



Blade for wood ripping tooth spacing 6 mm 2240x15x0.5 A6 stock-no. 090 900 0483 Blade for NF-metals tooth spacing 2 mm 2240x15x0,5 A2 stock-no. 090 900 0491

