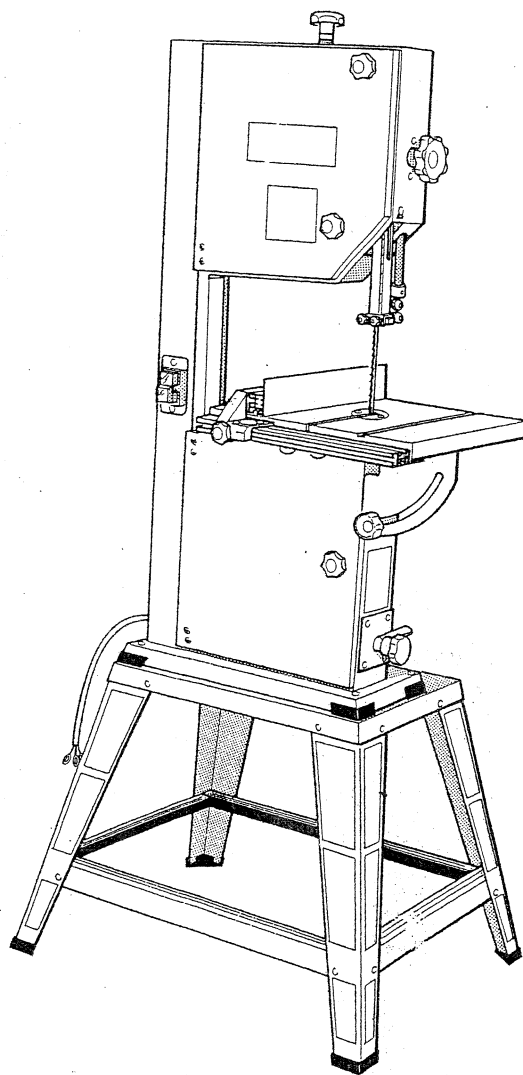


Band Saw

350_{mm}

W422 BP350



BEFORE USING BE SURE TO READ THIS MANUAL
• INSTRUCTION MANUAL •

Head Office:
"The Junction"

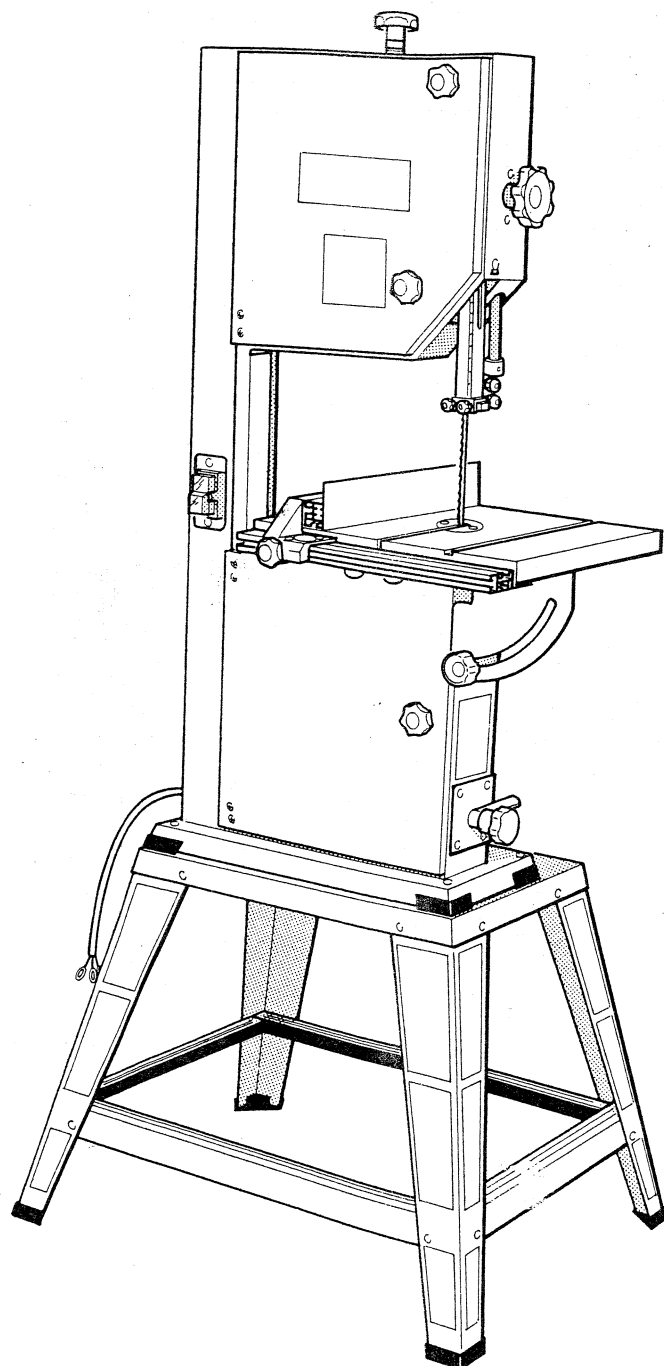
Unit 1/2 Windsor Road, Northmead, NSW 2152
Ph: (02) 9890 9111 Fax: (02) 9890 4888

Brisbane Branch:

550 Kessels Road, MacGregor, QLD 4109
Ph: (07) 3849 1888 Fax: (07) 3849 1414

Band Saw

350_{mm}



CE

BEFORE USING BE SURE TO READ THIS MANUAL

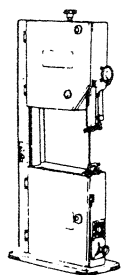
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SAFETY RULES FOR ALL POWER TOOLS

1. Read and become familiar with the entire instruction manual. Learn the tool's applications, limitations and possible hazards.
2. Earth all tools. If the tool is equipped with a three-prong plug, it must be plugged into a three-contact electric outlet. The third prong is a ground to provide protection against accidental electrical shock. If an adapter is used to accommodate a two-contact outlet, the adaptor's grounding lug must be connected to a known ground. Never remove the third prong on a three-prong plug.
3. Check damaged parts. A guard or any other part that is damaged should be checked to ensure that it will operate properly and perform its intended function before the tool is used further. Check for proper alignment of moving parts and for possible broken parts, loose mountings, or any other condition that could affect the tool's operation. A guard or other damaged part should be properly repaired or replaced.
4. Disconnect power before servicing and when changing accessories such as blades, cutters.
5. Keep guards in place and in working order.
6. Protect your eyes from being injured by objects thrown by a power tool. Always wear safety glasses or safety goggles.
7. Wear a face mask or dust mask if the cutting operation produces dust.
8. Don't force the tool. It will give a better and safer performance when used on jobs for which it was designed.
9. Avoid accidental starting. Ensure that the power switch is in the OFF position before plugging in the power cord. Remove the switch when the tool is not being used.
10. Remove adjusting keys and wrenches. Ensure that keys and adjusting wrenches are removed from the tool before turning it on.
11. Drugs, alcohol, and medication. Do not operate tool if you are under the influence of drugs, alcohol, or medication that could effect your ability to use the tool properly.
12. Use recommended accessories. Using improper accessories can be hazardous. If in doubt, check the instruction manual.
13. Never stand on a tool. Falls can result in injury.
14. Never leave a tool running unattended. Turn the power switch OFF. Don't leave the tool until it has come to a complete stop.
15. Always remove the power cord plug from the electric outlet when making adjustments, changing parts, cleaning, or working on the tool.
16. Avoid dangerous conditions. Don't use power tools in wet or damp areas or expose them to rain. Keep your work area clean and well-lit. Do not use power tools in areas where fumes from paint, solvents, or flammable liquids pose a potential hazard.
17. Keep visitors and children away. Other people should keep a safe distance from the work area, especially when the tool is operating.
18. Use the proper tool. Don't force a tool to do a job for which it was not designed.
19. Keep tools in top condition. Keep them clean and sharp for the best and safest performance. Follow the instructions for changing accessories and lubricating.
20. Secure all work. When practical use clamps or a vise to hold work. It is safer than using your hands and prevents round or odd-shaped pieces from turning.
21. Don't overreach. Keep proper footing and balance at all times. Wear oil-resistant rubber-soled footwear. Keep the floor clear of oil, scrap wood, and other debris.
22. Wear proper clothing and, if necessary, protective hair covering. Loose clothing or jewelry can get caught in moving parts.
23. Make the workshop childproof with padlocks, master switches, or by removing starter keys.

UNPACKING AND CHECKING LIST



Saw Q'ty: 1

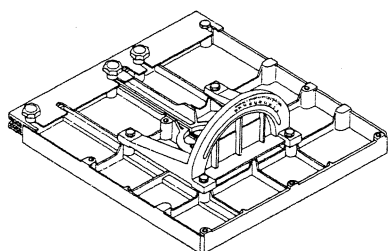
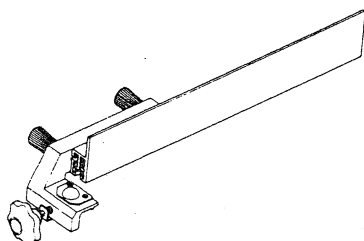
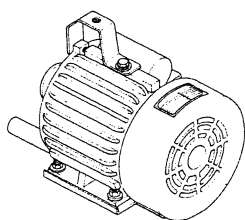


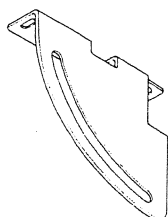
Table Assembly Q'ty: 1



Rip Fence Assembly Q'ty: 1



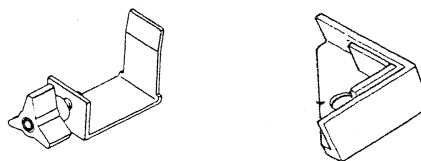
Motor Assembly Q'ty: 1



Trunnion BS14003007 Q'ty: 1

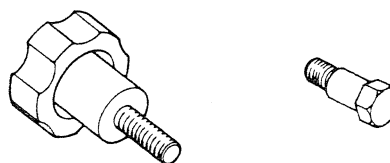
Loose parts in small box

Bag 1



Fence Clamp Q'ty: 1 Pad BS14004017 Q'ty: 4

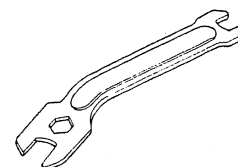
Bag 2



Knob BS 14002016 Q'ty: 2 Bolt BS14003005 Q'ty: 1



Curve Washer
BS14003004 Q'ty: 1



Wrench
BS14003006 Q'ty: 1

Bag 3



Lock Nut M10 P1.5
F204031 Q'ty: 1



Washer $\phi 8.2 \times \phi 18 \times 2$
F702168 Q'ty: 2

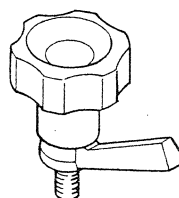


Spring Washer M8
F701008 Q'ty: 2



Hex bolt M8 P1.25 $\times 15$
F101151 Q'ty: 2

Bag 4

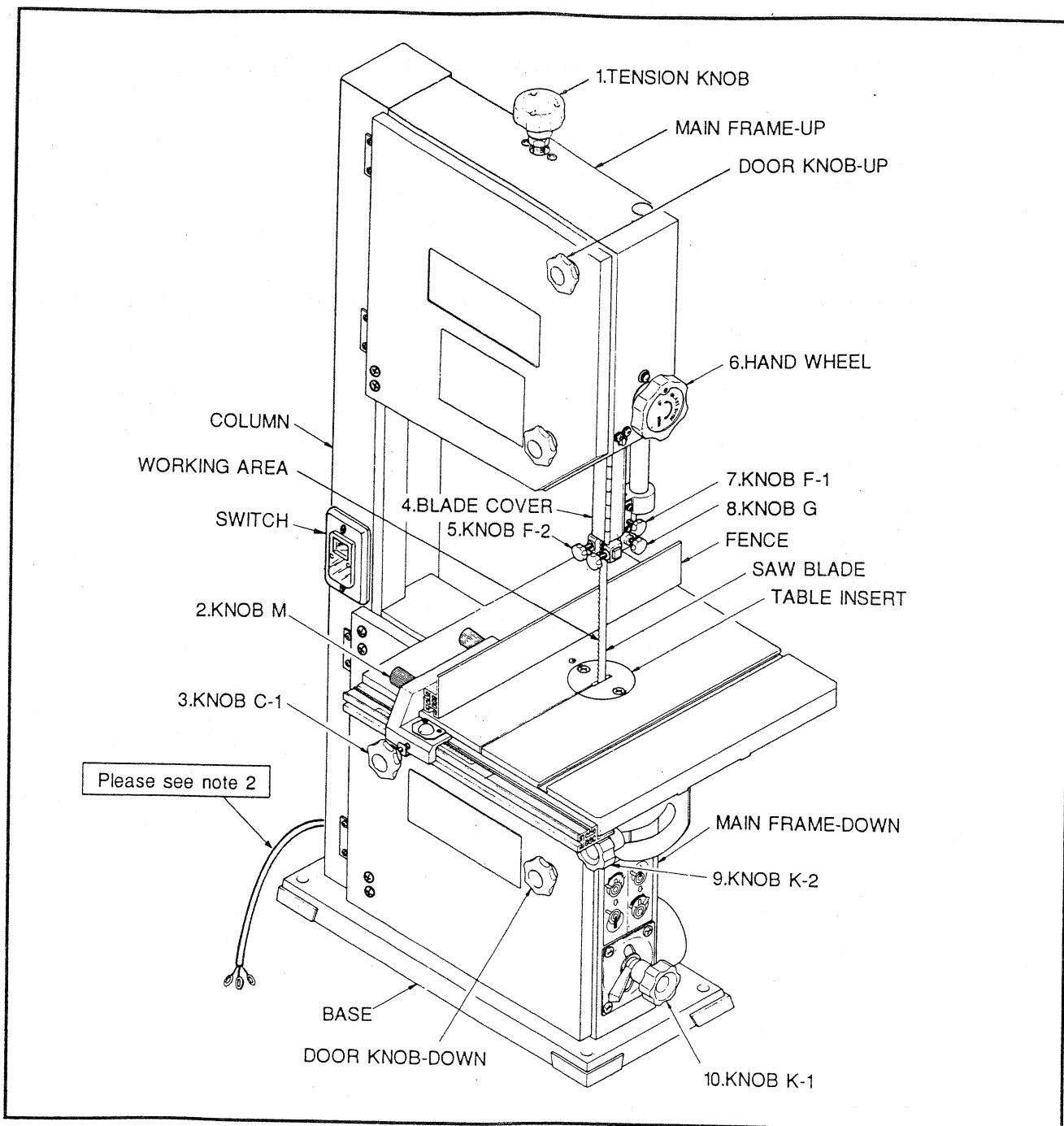


Knob K & Locking Handle
BS14002016, BS14002017 Q'ty: 1



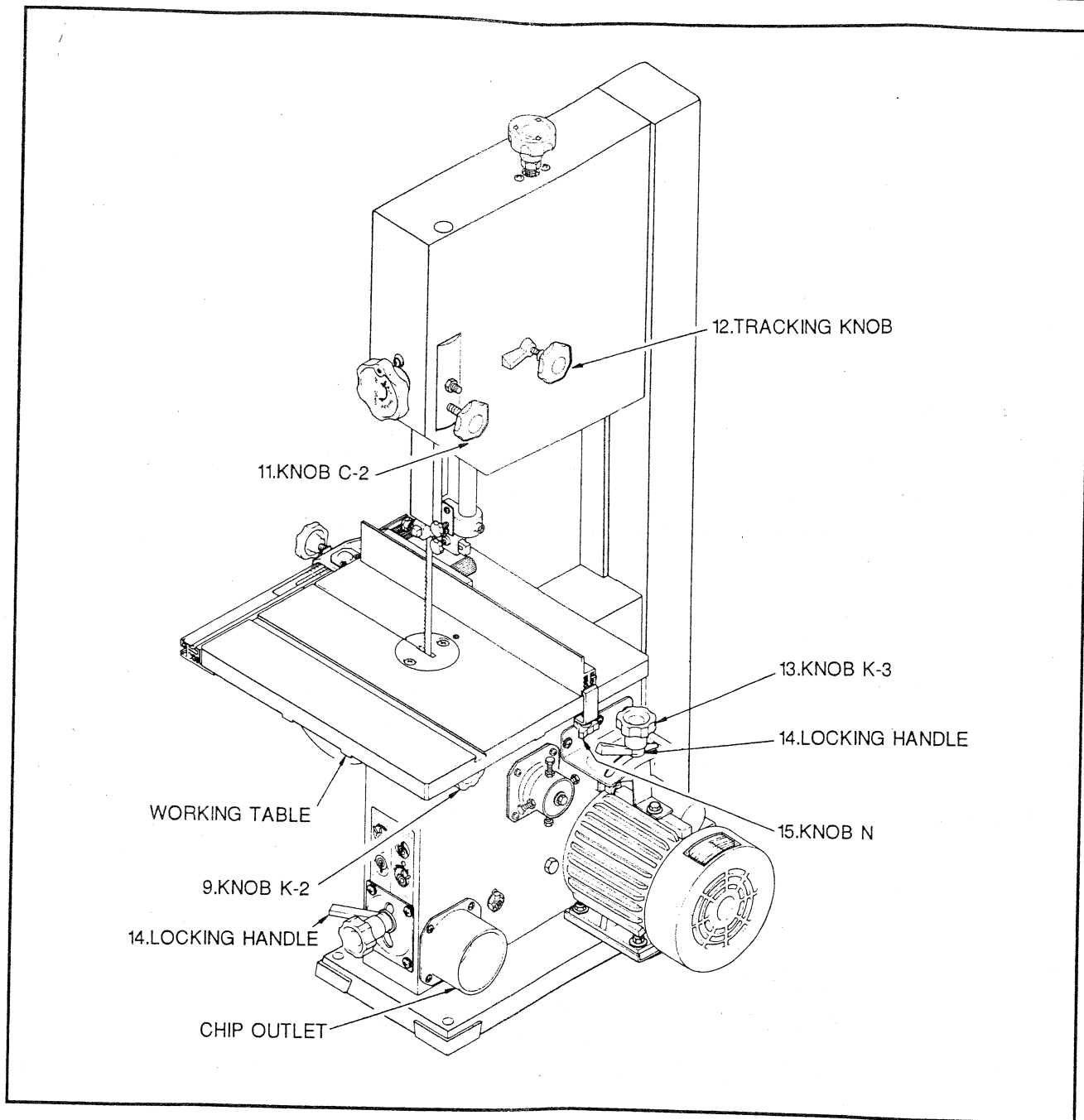
Washer $\phi 10 \times \phi 20 \times 2$
F702211 Q'ty: 1

GETTING TO KNOW YOUR BANDSAW



1. **TENSION KNOB** Turn clockwise to tighten blade tension, counter clockwise to release tension.
2. **KNOB M** Fix fence.
3. **KNOB C-1** Move rip fence to required scale.
4. **BLADE COVER** Openable style, convenient for blade change.
5. **KNOB F-2** Adjust guide block to keep sawblade in line.
6. **HAND WHEEL** Turn clockwise to lower blade guide, counter clockwise to raise guide.
7. **KNOB F-1** Adjust bearing position, keep 0.5mm distance from blade.
8. **KNOB G** Adjust guide holder for various sizes of blade width.
9. **KNOB K-2** Fix table at required position from 0-45°
10. **KNOB K-1** Adjust high-low speed and belt tension.

GETTING TO KNOW YOUR BANDSAW



- 11. KNOB C-2 Fix blade guide.
- 12. TRACKING KNOB Adjust blade tracking on wheels.
- 13. KNOB K-3 Push/pull motor to give tight belt tension.
- 14. LOCKING HANDLE Turn it clockwise to fix a proper belt tension.
- 15. KNOB N Fix fence clamp.

Note 1 : The control circuit installation diagram has been included in this clause.

Note 2 : The table for connection of power.

Model	Electric Supply.	Fuse recom.	Connection through
BS140-04CE(1~)	230 V, 50Hz, single phase	10A	Plug/Socket Connection.
BS140-05CE(3~)	400V, 50Hz three phase	6A	Hand-operated disconnecting device

TECHNICAL DATA

Model	BS140-05CE	BS140-04CE
Cutting Height (Max)	200 MM	200 MM
Cutting Width (Max)	330 MM	330 MM
Cutting Speed (50 Hz) (60 Hz)	300/1000 m/min 300/1000 m/min	300/1000 m/min 300/1000 m/min
Table Size	400x400MM	400x400 MM
Table Tilt	0-45 Degree	0-45 Degree
Flying Wheel	350 MM	350 MM
Blade Length	2440 MM	2440 MM
Motor (Output)	0.52 kW /3~	0.52 kW /1~
Height (without Stand)	1190 MM	1190 MM
Height (with Stand)	1760 MM	1760 MM
Weight, Nw/Gw(w/o Stand)	77/82 Kg	79/84 Kg
Weight, Nw/Gw(with Stand)	87.5/93.5 Kg	89.5/95.5 Kg
Noise Level (dry run) (Operation)	78 dB 83 dB	78 dB 83 dB

FEATURES:

1. Two speeds to allow cutting of various materials.
2. Large cutting capacity.
3. Ground heavy duty cast iron table.
4. Precision aluminium profiled rip fence.
5. Gear-guide, safety blade guard.
6. Rubber-coated, balanced heavy duty wheels.
7. Sawdust chute is equipped.
8. Wide range of accessories and attachments.
9. IP-54 protection against water & dust.
10. EN 60204 standard control device.
11. Equipped with positive mode interlock.
12. Short run down time (not exceed 10 sec)

Handling of Band Saw

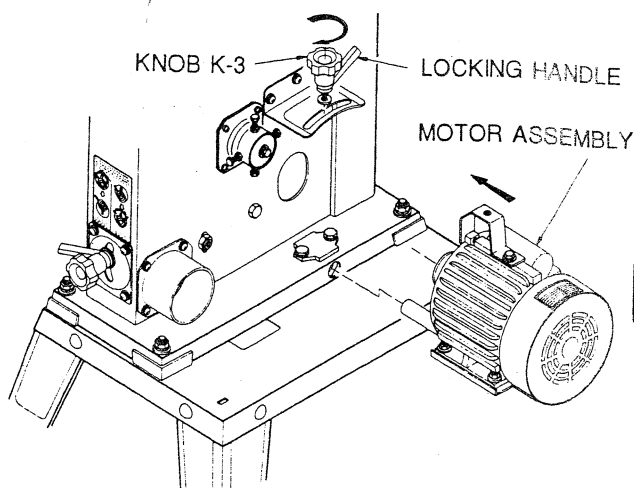
1. The net weight of your power feeder can be at the range of 75 to 100 KGS depend upon the accessories it include. The total weight of this machine must be ensured before handling.
2. It is better to handle and transport this power feeder with the help of lifting tools.
3. Otherwise, make sure you can afford it before handling, and handle it with much care.

Environment Requirements for Installation.

1. The ground for installation of band saw should be flat and big enough for operation.
2. Be sure to provide sufficient light for operation according to the codes or regulations published for local area. if you do not get the information about lighting.
3. A light intensity of 300 Lux is the least value should be supply.

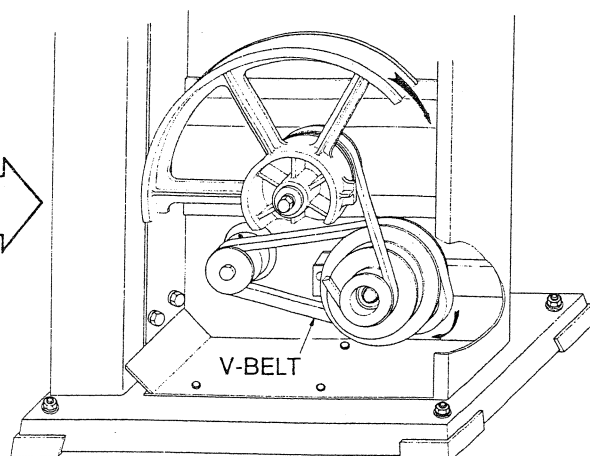
MOTOR ASSEMBLY AND ADJUSTMENT

1



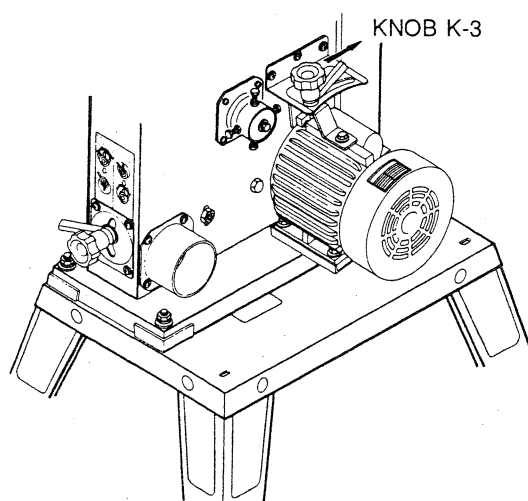
- Assemble your stand.
- Put bandsaw on stand, put 4 pieces of rubber pads on corners of base.
- Fix bandsaw to stand by 4 pieces of bolt (square neck) and provided washers, spring washers, nuts. Please read drawing of stand (base) assembly for details.
- Insert motor pulley into the hole of lower frame.
- Connect knobs K-3 with motor, by turning knob K-3 into the thread whole upon the motor.

2



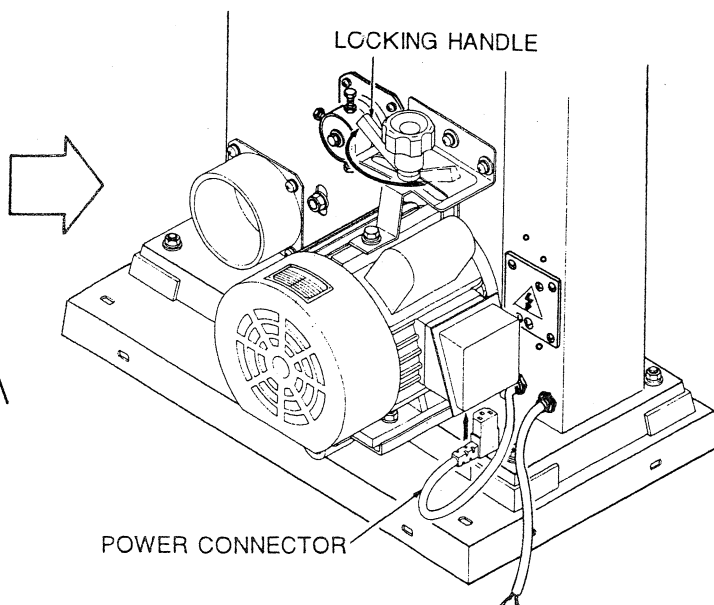
- Slip V-belt into groove of motor pulley.
- Slip the other end of belt, from topside, into the inmost groove of driven pulley.
- Slightly transmit lower-wheel clockwise to help belt-setting.

3



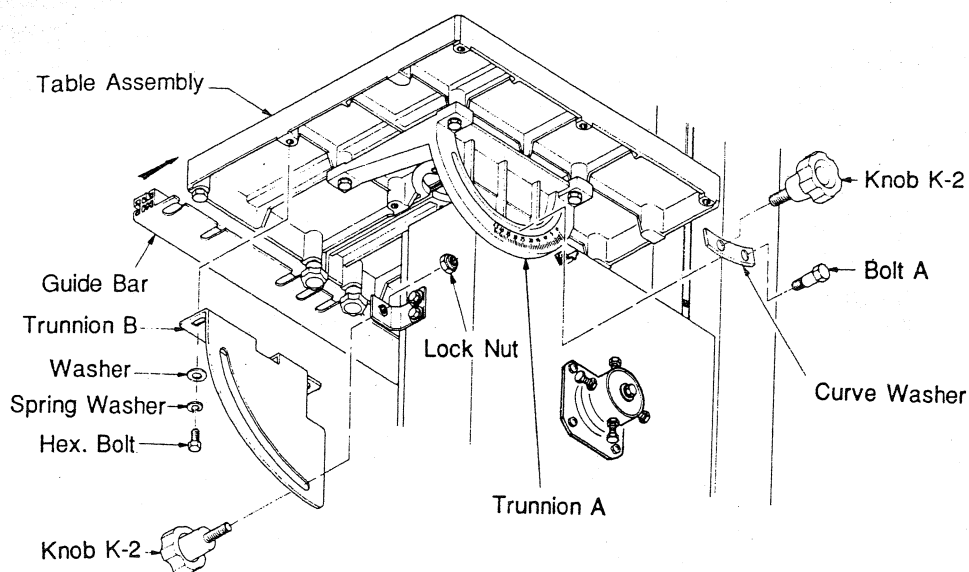
- Push knob K-3 to tighten the belt.

4

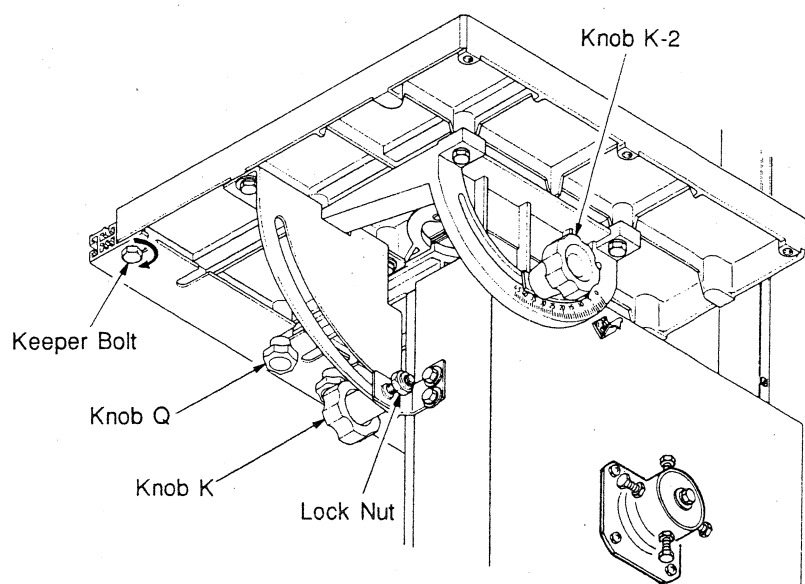
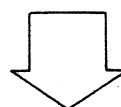


- Hold knob K-3 then turn locking handle clockwise.
- Make sure to get proper belt tension.
- Plug in power connector as diagram shows.

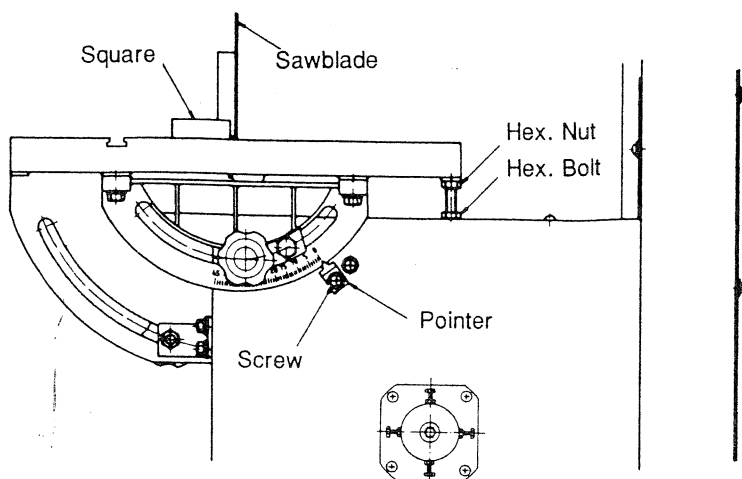
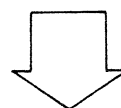
TABLE ASSEMBLY AND ADJUSTMENT



- Remove the guide bar.
- Install table and make trunnion-A closely connect with flange.
- Insert knob K-2 and bolt-A into curve washer to fix table.
- Fix trunnion-B as diagram shows.



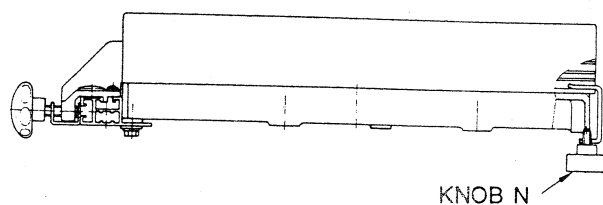
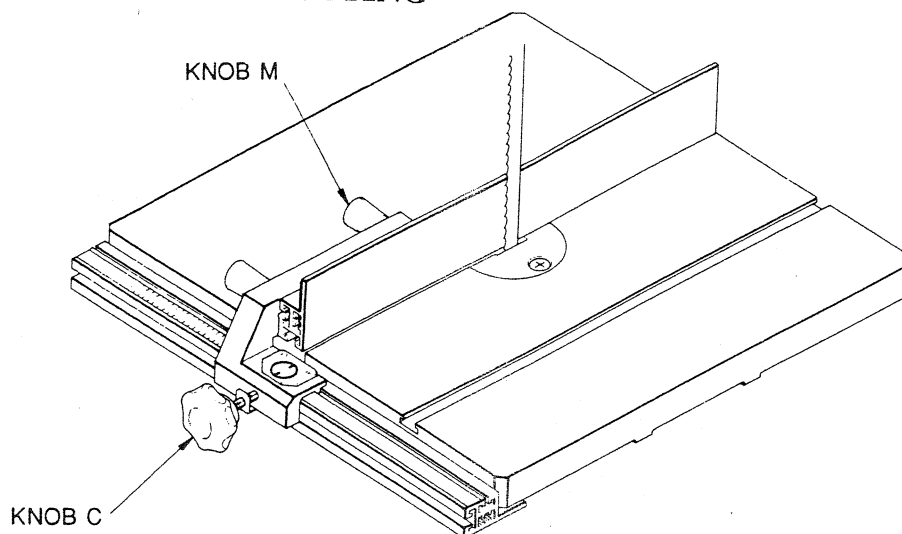
- This figure shows complete assembly of working table.
- Loosen knob K-2 (2 Pcs) and bolt A to be able to tilt table.
- Fit lock nut in the position shown in figure.
- The fastened keeper bolt is the pivot of guide bar.
- Fasten knob Q to fix guide bar.



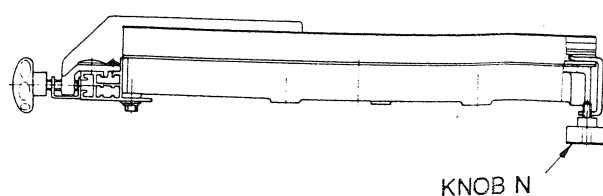
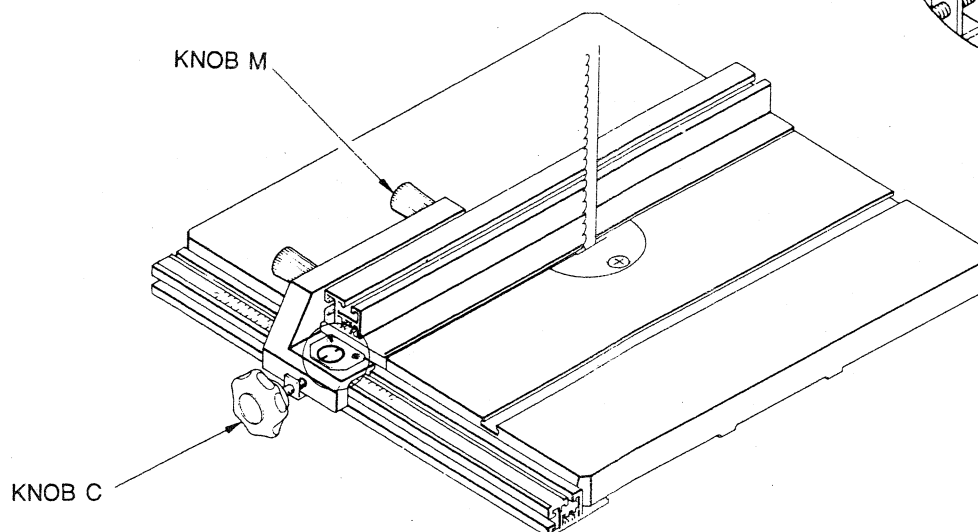
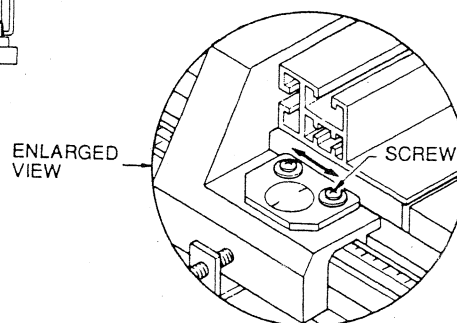
- Position a square against table and blade.
- Adjust hex. bolt with wrench until the blade is flat against the square (at 0°)
- Unfasten screw and move pointer to the zero point of trunnion.

RIP FENCE ASSEMBLY AND ADJUSTMENT

USED FOR GENERAL CUTTING

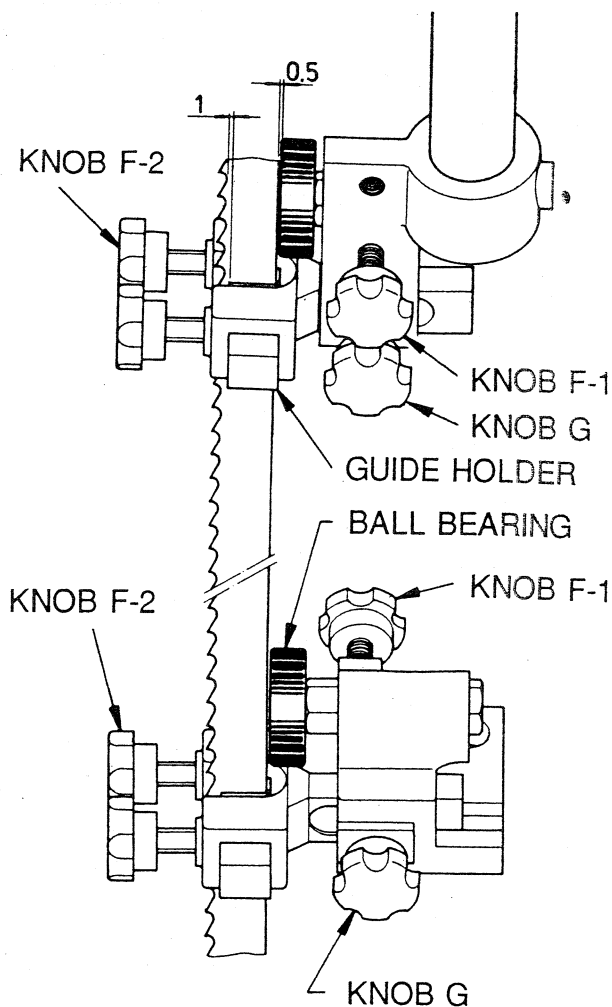


- This rip fence is designed for both general purpose cutting and special purpose of thin cutting.
- Loosen knob C.M.N Turn down the fence, and re-adjust Zero Point, of scale by moving magnifier.



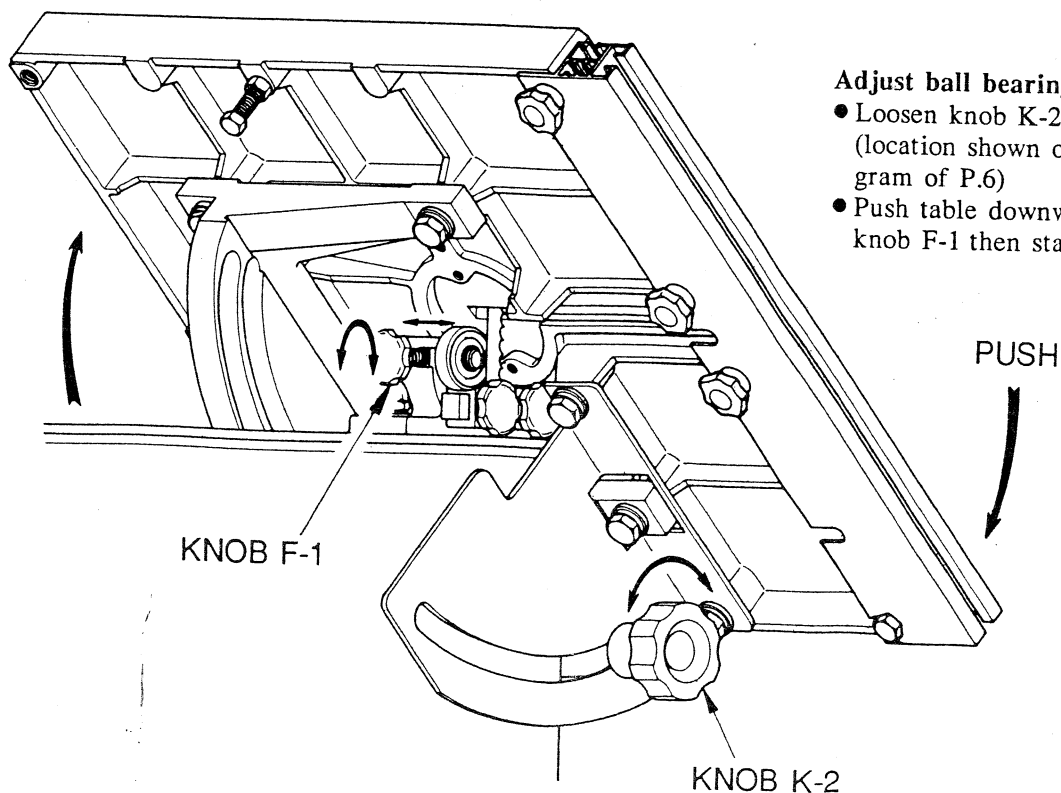
USED FOR CUTTING OF SPECIAL THIN WORKPIECE

GUIDE HOLDER ADJUSTMENTS



After blade tracks on proper way, do some adjustments as follows:

- Adjust the distance between ball bearing and blade about 0.5mm. Use knob F-1 to keep it.
- Adjust the distance between the bottom of blade teeth and guide holder about 1mm. Use knob G to keep it.
- On normal cutting keep guide holder as close as possible with blade. But on circular cutting, adjust the distance between guide holder and blade at 2mm, Use knob F-2 to keep it.

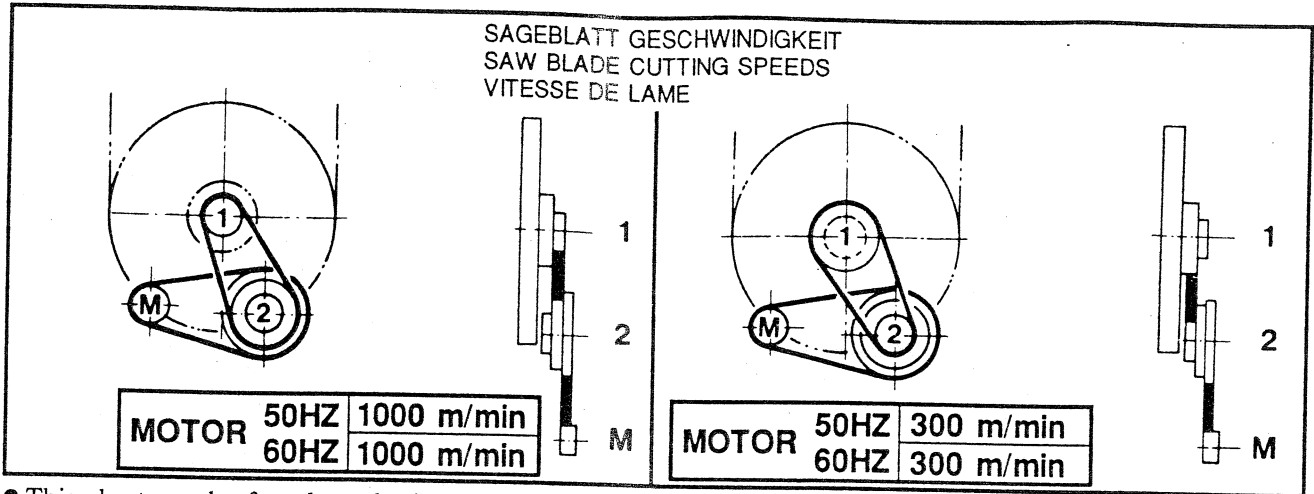


Adjust ball bearing under table:

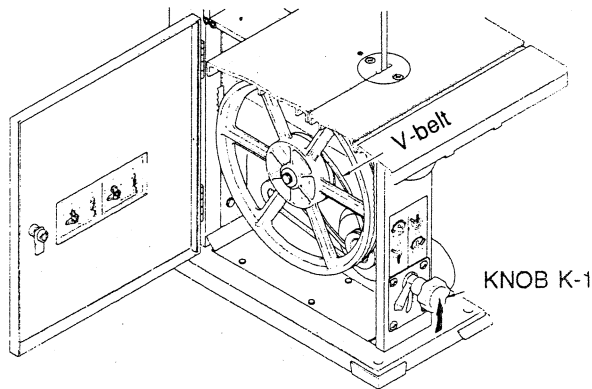
- Loosen knob K-2 and bolt A (location shown on the first diagram of P.6)
- Push table downward, loosen knob F-1 then start adjustment.

SPEED ADJUSTMENT AND BELT TENSION ADJUSTMENT

• SPEED ADJUSTMENT

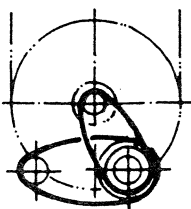


- This chart can be found on the inside of the door on your machine.

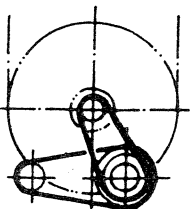


- Open door.
- Loosen locking handle and move knob K-1 up to release belt tension.
- Put V-belts into the right groove position of pulley for required speed.

BELT TENSION ADJUSTMENT

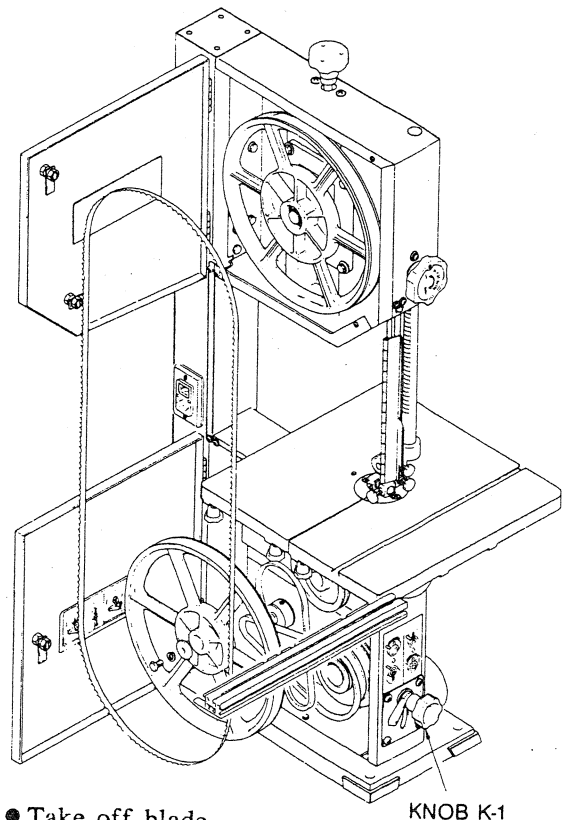


- This diagram shows belts in loose condition which cause inefficient cutting.



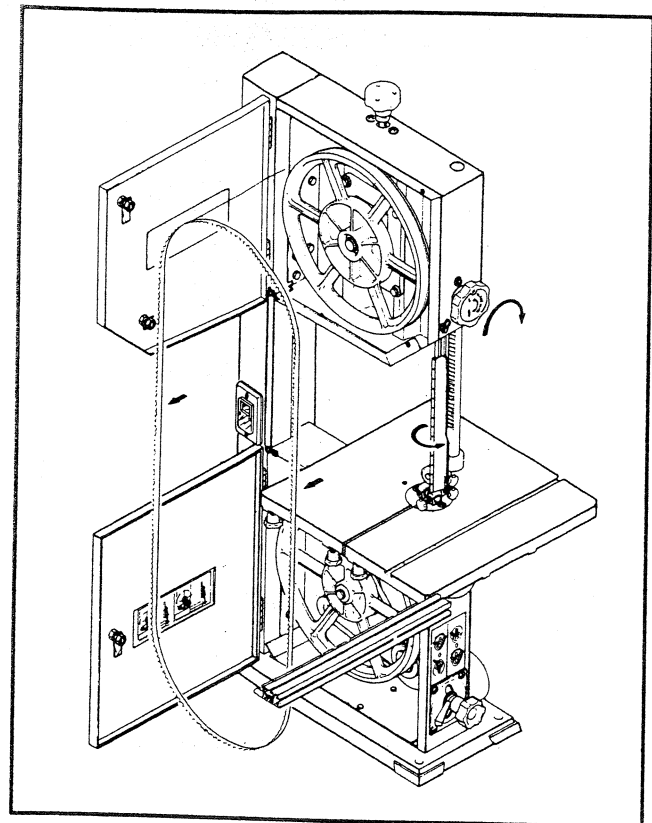
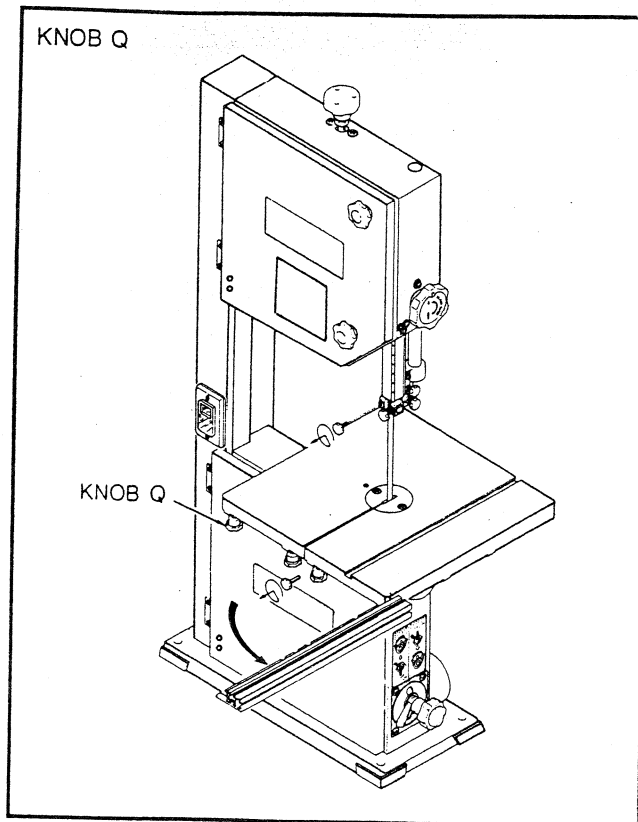
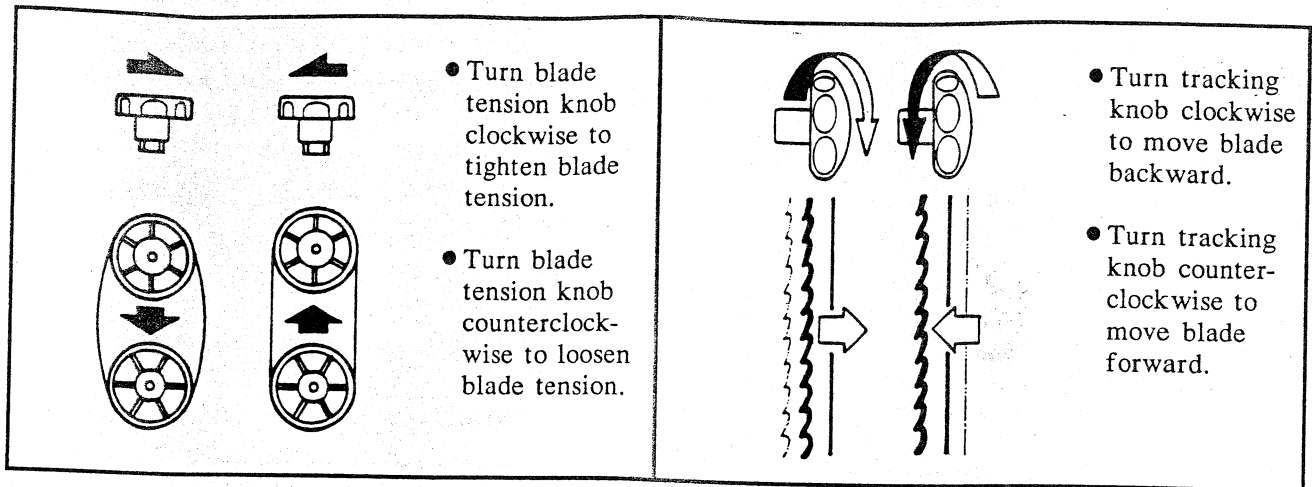
- This diagram shows belts in tighten condition which is good for cutting.

BELT REPLACEMENT



- Take off blade.
See instructions on page 10.
- Remove driving wheel.
- Move knob K-1 up.
- Take off V-belts.
- Put on new belts.
- Install disassembled parts in reverse order.

BLADE TENSION AND REPLACEMENT



- Loosen knob Q, pull out guide bar.
- Take off knobs (2 Pcs) of the guide holders as shown in figure.

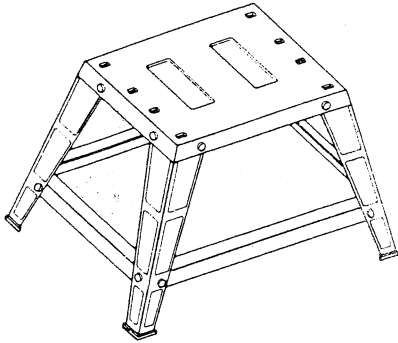
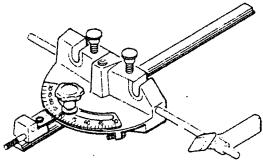
- Adjust the blade guard to its lowest position.
- Open the upper & lower doors.
- Loosen blade tension to its maximum.
- Take off the blade.
- Install new blade in reverse order.

Checking Procedure for Appropriate Blade Tension.

1. Move the guide holder to its upper position and fix it.
2. Press the saw blade in the middle position of exposed part with finger by an suitable force.
3. Check the deflection value of saw blade. The value of 1~2 mm deflection is an appropriate value for a good operation condition.

TOOLS AND ACCESSORIES

OPTIONAL

No.	Article
BS14005-10	 <p>Stand</p>
BS14006-10	 <p>Crosscut/Miter Gauge With Stop</p>

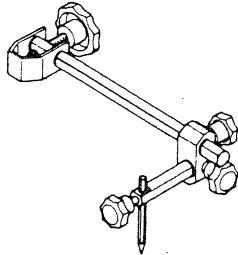
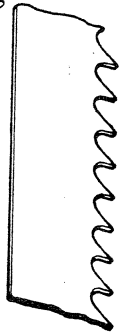
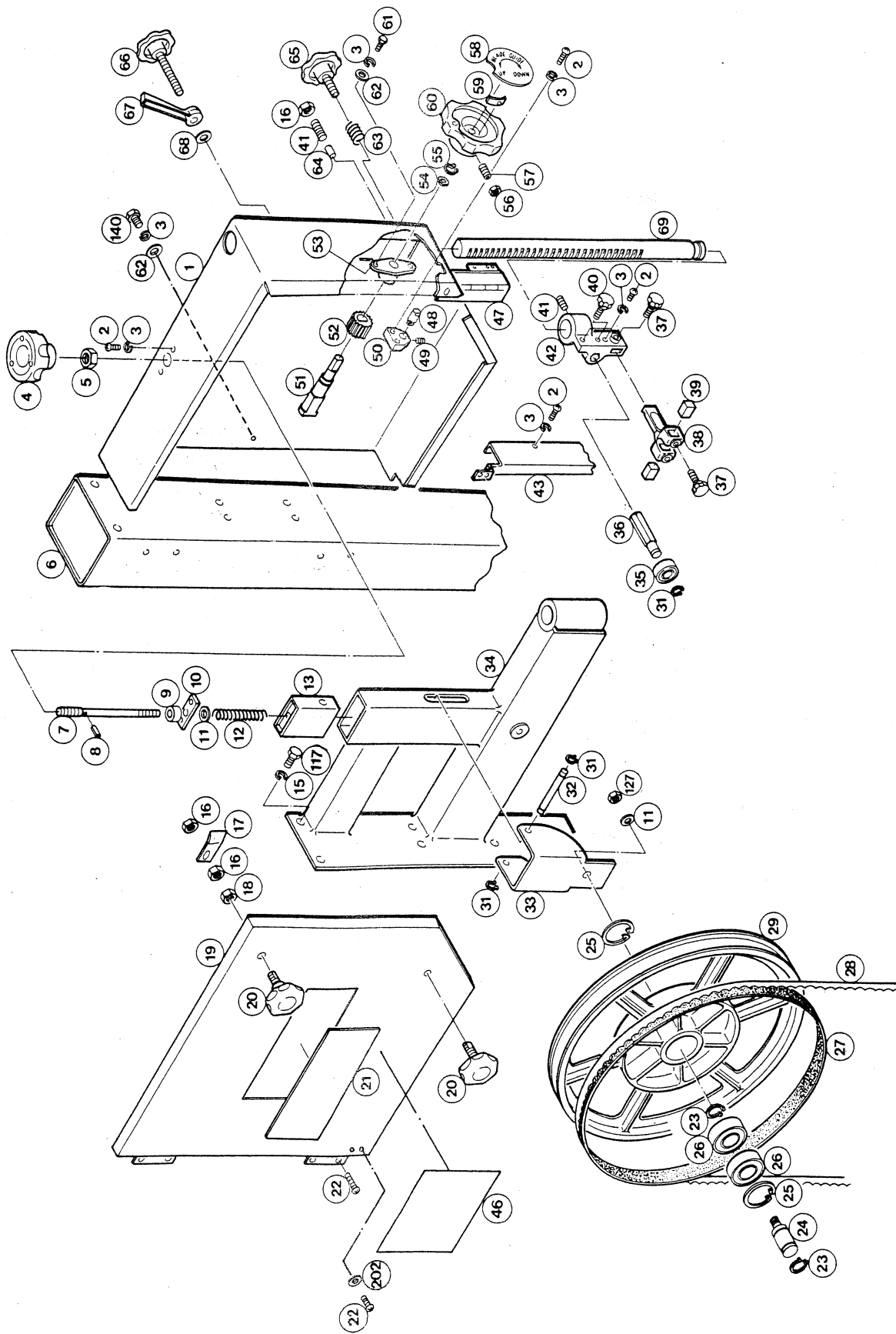
No.	Article
BS14007-10	 <p>Circular Cutting Att. Raidii 30-195mm</p>
F005000 F005001 F005002 F005003 F005004	<p>Saw Blades, 2440mm Long</p> <ol style="list-style-type: none"> 1) For General Purpose 12.7x0.65mm 4TH/in. 2) For Wood Ripping 16x0.5mm 4TH/in. 20x0.8mm 4TH/in. 3) For Wood Cir. Cutting. 6x0.65mm 6TH/in. 4) For Soft Metals 12.7x0.65mm 14TH/in. 

DIAGRAM OF DRIVEN WHEEL ASSEMBLY



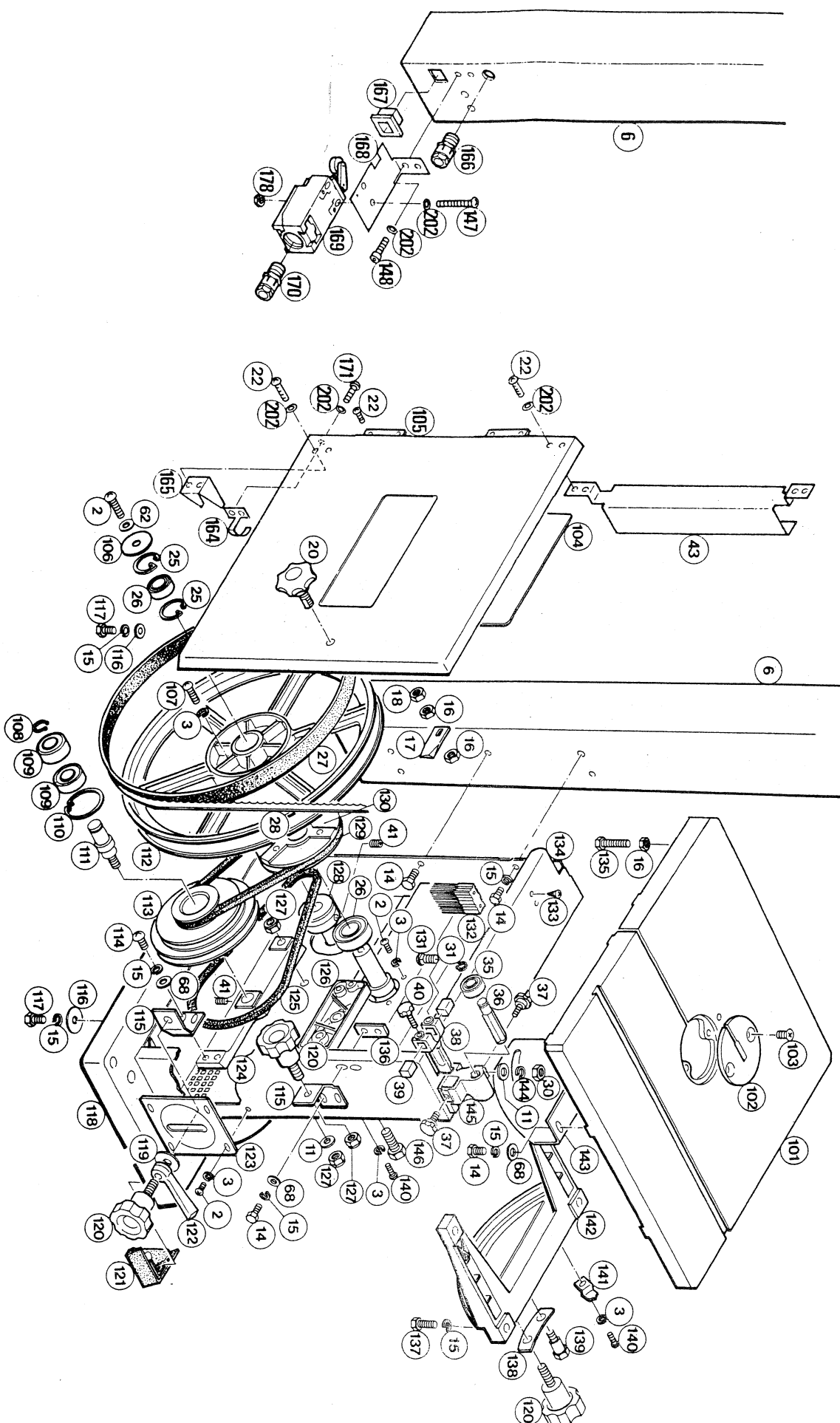
PARTS LIST OF DRIVEN WHEEL ASSEMBLY

REF. NO.	PARTS NO.	PARTS NAME
1	BS14201101	FRAME-UP
2	F103334	SCREW
3	F701006	SPRING WASHER
4	BS14001011	TENSION KNOB
5	F201033	HEX. NUT
6	BS14204101	COLUMN F
7	BS14201004	BOLT SHAFT
8	F501316	SPRING PIN
9	BS14201005	BUSH
10	BS14201006	SUPPORTING PLATE
11	F702211	WASHER
12	BS14201014	SPRING E
13	BS14201003	ELEVATING SEAT
14	F101151	HEX. BOLT
15	F701008	SPRING WASHER
16	F201020	HEX. NUT
17	BS14001038	LOCK PLATE
18	F204020	LOCK NUT
19	BS14201110	FRAME COVER-UP
20	BS14001037	KNOB E
21	—	BRAND LABEL
22	—	SCREW
23	F403020	SNAP RING
24	BS14201009	DRIVEN SHAFT
25	F402042	SNAP RING

REF. NO.	PARTS NO.	PARTS NAME
26	F302004	BALL BEARING
27	BS14001005	WHEEL RUBBER
28	F005000	SAW BLADE
29	BS14001004	DRIVEN WHEEL
30	F201026	HEX. NUT
31	F403010	SNAP RING
32	BS14201008	SUPPORTING SHAFT
33	BS14201007	SHAFT BRACKET
34	BS14201002	FRAME MEMBER
35	F302200	BALL BEARING
36	BS14001028	HEX. SHAFT
37	BS14001025	KNOB G
38	BS14001024	GUIDE HOLDER
39	BS14001026	GUIDE BLOCK
40	BS14001029	KNOB F
41	F107314	SET SCREW
42	BS14001027	SUPPORT-UP
43	BS14004107	BLADE COVER
45	F701005	SPRING WASHER
46	NP9078	COVER LABEL
47	BS14001032	BLADE PROTECTOR
48	BS14001031	KEEPER SHAFT
49	F107210	SET SCREW
50	BS14001030	FIXING BLOCK

REF. NO.	PARTS NO.	PARTS NAME
51	BS14001019	HANDWHEEL SHAFT
52	BS14001020	GEAR
53	BS14001021	GEAR SEAT
54	F704012	WAVE WASHER
55	F403012	SNAP RING
56	F201010	HEX. NUT
57	F107245	SET SCREW
58	—	PLATE
59	BS14001023	CURVE PLATE
60	BS14001022	HAND WHEEL
61	F101090	HEX. BOLT
62	F702149	WASHER
63	CS10003008	SPRING
64	BS14201015	SPACER
65	BS14201013	KNOB B
66	BS14201012	KNOB A
67	BS14001034	LOCKING HANDLE A
68	F702168	WASHER
69	BS14201011	RACK

DIAGRAM OF DRIVING WHEEL ASSEMBLY



PARTS LIST OF DRIVING WHEEL ASSEMBLY

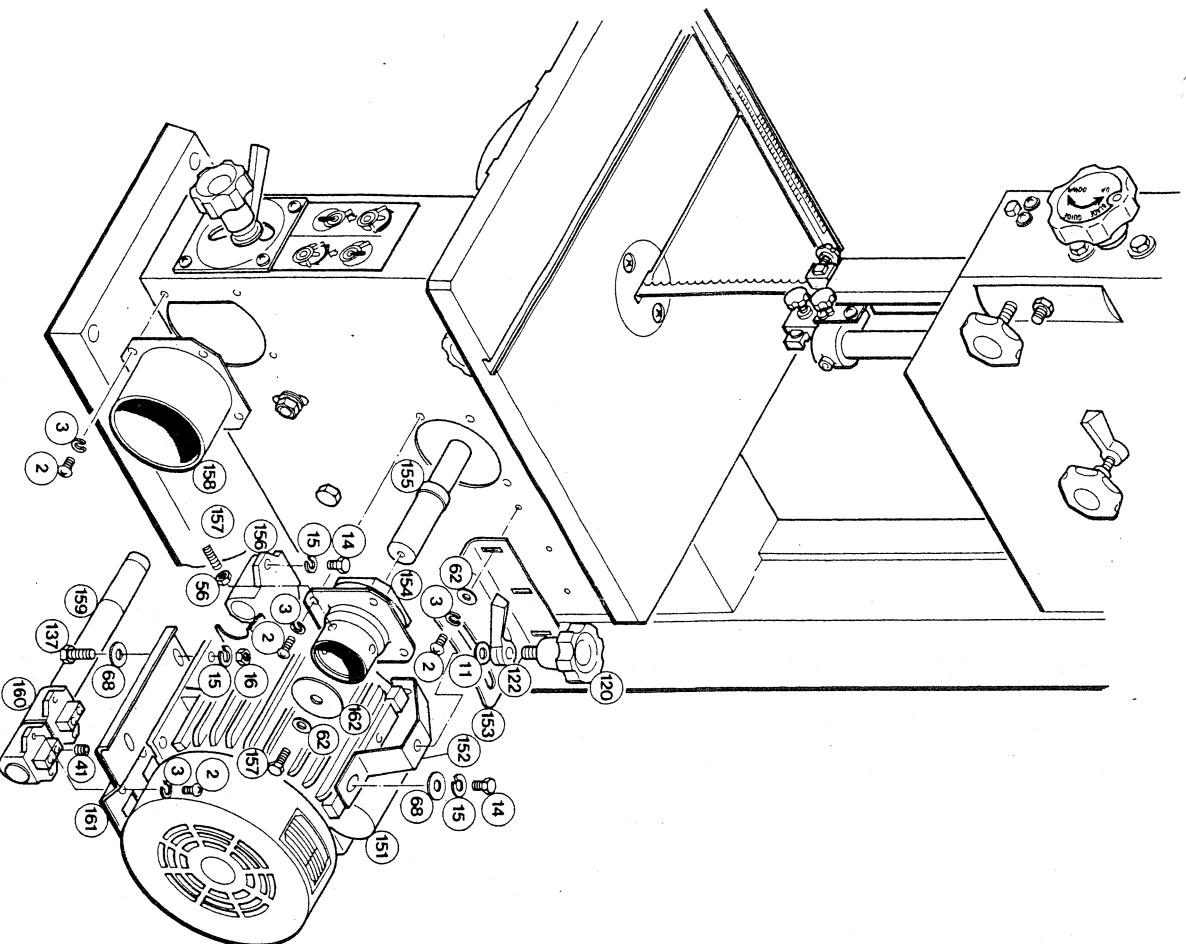
REF. NO.	PARTS NO.	PARTS NAME
2	F103334	SCREW
3	F701006	SPRING WASHER
6	BS14204101	COLUMN F
11	F702211	WASHER
14	F101151	HEX. BOLT
15	F701008	SPRING WASHER
16	F201020	HEX. NUT
17	BS14001038	LOCK PLATE
18	F204020	LOCK NUT
20	BS14001037	KNOB E
22	—	SCREW
25	F402042	SNAP RING
26	F302004	BALL BEARING
27	BS14001005	WHEEL RUBBER
28	F005000	SAW BLADE
30	F201026	HEX. NUT
31	F403010	SNAP RING
35	F302200	BALL BEARING
36	BS14001028	HEX. SHAFT
37	BS14001025	KNOB G
38	BS14001024	GUIDE HOLDER
39	BS14001026	GUIDE BLOCK
40	BS14001029	KNOB F
41	F107314	SET SCREW
43	BS14004107	BLADE COVER
45	F701005	SPRING WASHER
62	F702149	WASHER
68	F702168	WASHER

REF. NO.	PARTS NO.	PARTS NAME
101	BS14003001	WORKING TABLE
102	BS14003002	TABLE INSERT
103	F105319	FLAT SCREW
104	—	SPEED LABEL
105	BS14202106	FRAME COVER-DOWN
106	BS14202007	WASHER
107	F103341	SCREW
108	F403015	SNAP RING
109	F302202	BALL BEARING
110	F402035	SNAP RING
111	BS14002013	PULLEY SHAFT
112	BS14202004	DRIVING WHEEL
113	BS14002012	MIDDLE PULLEY
114	F103391	SCREW
115	BS14002015	LINKING SET
116	F702183	WASHER
117	F101161	HEX. BOLT
118	BS14004001	BASE
119	F702231	WASHER
120	BS14002016	KNOB K
121	BS14004017	PAD
122	BS14002017	LOCKING HANDLE B
123	BS14002011	SQUARE PLATE
124	BS14002014	PULLEY BRACKET
125	F801225	V BELT
126	BS14002009	TRUNNION GUIDE
127	F204031	LOCK NUT
128	BS14004015	MOTOR PULLEY, 1~
129	BS14004115	MOTOR PULLEY, 3~
	F801123	V BELT

REF. NO.	PARTS NO.	PARTS NAME
130	BS14202003	DRIVING PULLEY
131	F110441	SQUARE NECK BOLT
132	BS14002007	BRUSH
133	F113119	TAPPING SCREW
134	BS14002101	FRAME-DOWN
135	F101210	HEX. BOLT
136	BS14002018	CONNECTION PLATE
137	F101191	HEX. BOLT
138	BS14003004	CURVE WASHER
139	BS14003005	BOLT A
140	F103340	SCREW
141	BS14002010	POINTER
142	BS14003003	TRUNNION A
143	BS14003007	TRUNNION B
144	F701010	SPRING WASHER
145	BS14002019	SUPPORT-DOWN
146	F101291	HEX. BOLT
147	F103048	SCREW
148	F101008	CAP SCREW
164	BS14202009	CONTROL SHEET
165	BS14202008	PROTECTION SHEET
166	F912007	STRAIN RELIEF
167	BS14204004	ANTI-DIRT SLEEVE
168	BS14204003	SWITCH SEAT
169	F916400	LIMIT SWITCH
170	F912011	STRAIN RELIEF

DIAGRAM OF MOTOR ASSEMBLY

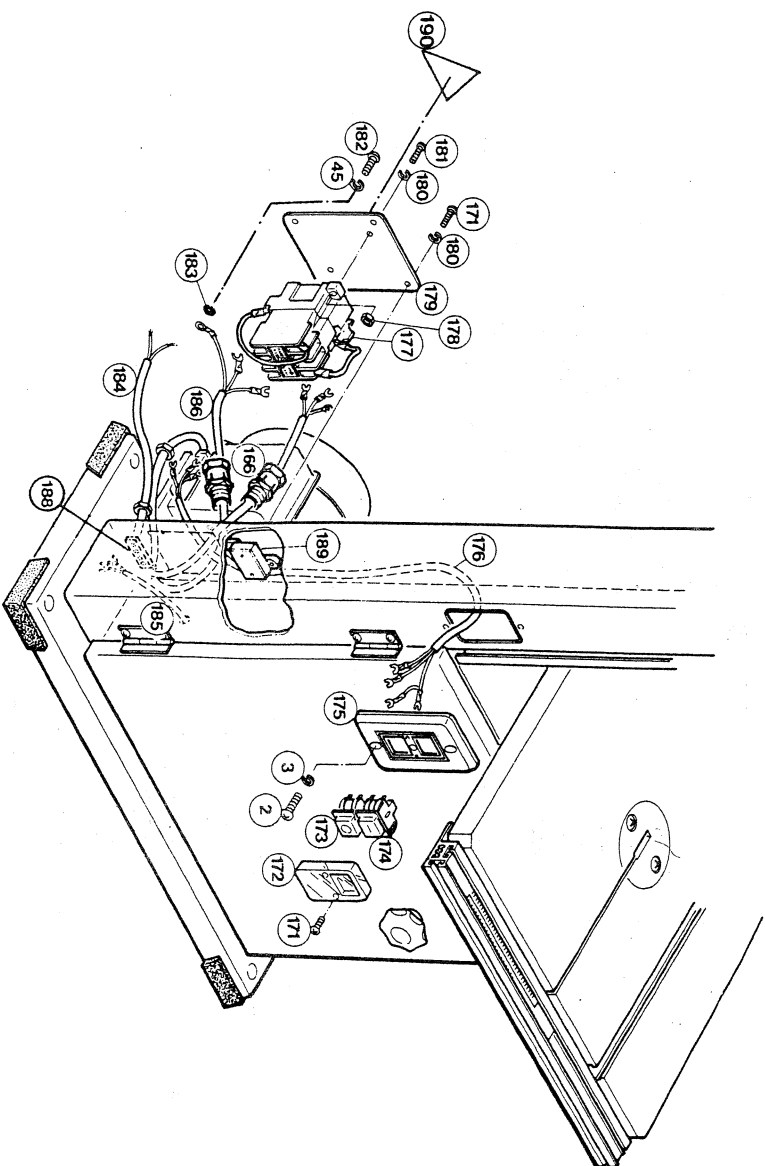
PARTS LIST



REF. NO.	PARTS NO.	PARTS NAME
2	F103334	SCREW
3	F701006	SPRING WASHER
11	F702211	WASHER
14	F101151	HEX. BOLT
15	F701008	SPRING WASHER
16	F201020	HEX. NUT
41	F107314	SET SCREW
56	F201010	HEX. NUT
62	F702149	WASHER
68	F702168	WASHER
120	BS14002016	KNOB K
122	BS14002017	LOCKING HANDLE B
137	F101191	HEX. BOLT
151	—	MOTOR
152	BS14004014	LINKAGE SET, 1~
153	BS14004114	LINKAGE SET, 3~
154	BS14002021	TENSION FIXER
155	BS14202002	ADJUSTING HOUSING
156	BS14202001	DRIVING SHAFT
157	BS14004011	MOTOR BRACKET
158	F107235	SET SCREW
159	BS14002008	CHIP OUTLET
160	BS14004012	PIVOT SHAFT
161	BS14001014	SHAFT HOLDER
162	BS14004013	MOTOR BASE
163	BS14202005	WASHER
	F102202	CAP SCREW

DIAGRAM OF SWITCH ASSEMBLY

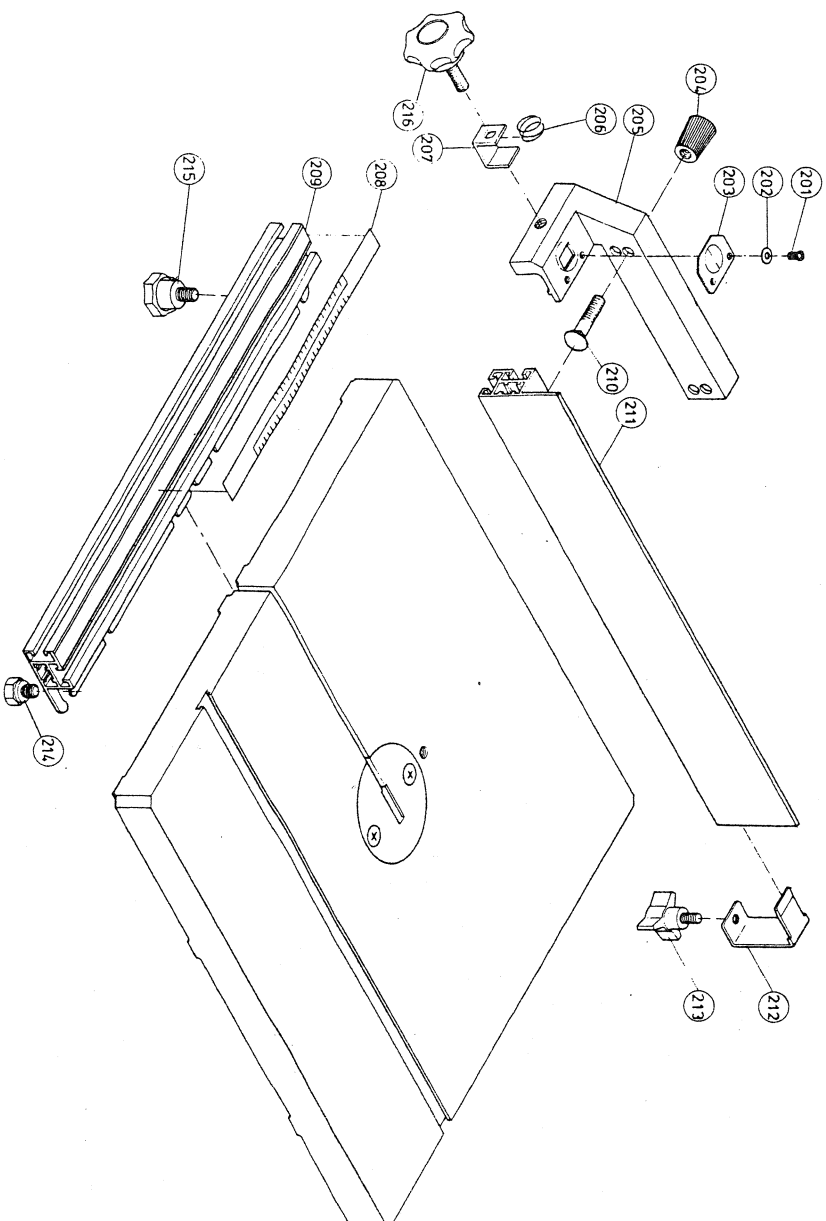
PARTS LIST



REF. NO.	PARTS NO.	PARTS NAME
2	F103334	SCREW
3	F701006	SPRING WASHER
45	F701005	SPRING WASHER
166	F912007	STRAIN RELIEF
171	F103016	SCREW
172	—	WATERPROOF COVER
173	—	PUSH BUTTON-RED
174	—	PUSH BUTTON-GREEN
175	—	SWITCH PLATE
176	—	CONNECTION WIRE
177	—	CONTACTOR
178	F201001	HEX.NUT
179	BS14204002	COLUMN COVER
180	F701004	SPRING WASHER
181	F103025	SCREW
182	F103169	SCREW
183	F703005	EXT. WASHER
184	—	POWER CORD,1 ϕ
185	—	POWER CORD,3 ϕ
186	—	CONNECTION WIRE
188	BS14204005	MOTOR CORD,1 ϕ
189	F906003	MOTOR CORD,3 ϕ
190	NP3206	EARTH PLATE
		WIRING BOARD
		ELECTRICAL LABEL

DIAGRAM OF RIP FENCE ASSEMBLY

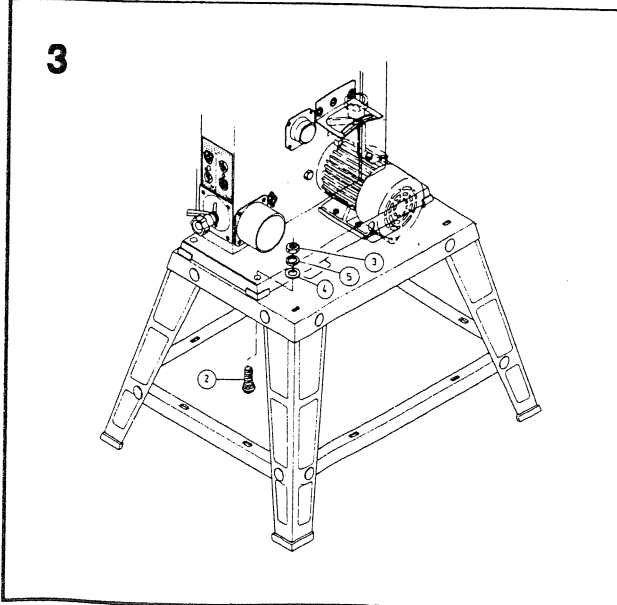
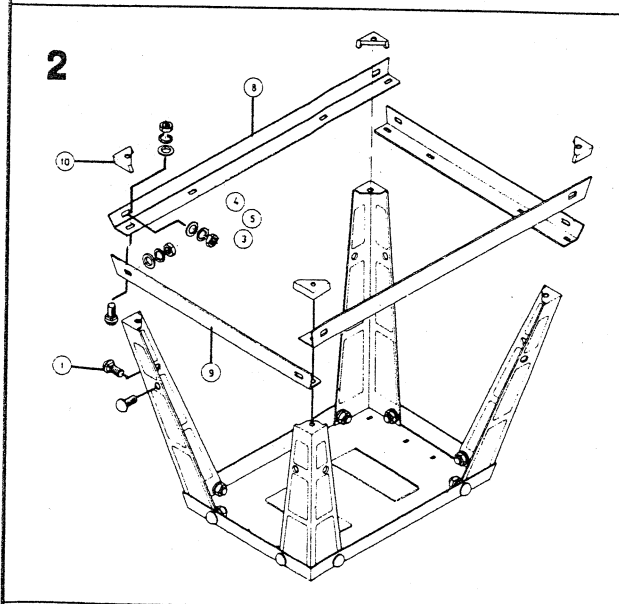
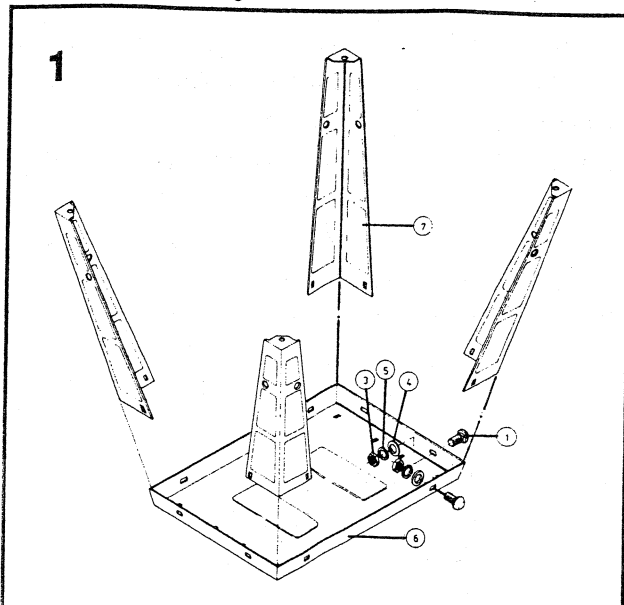
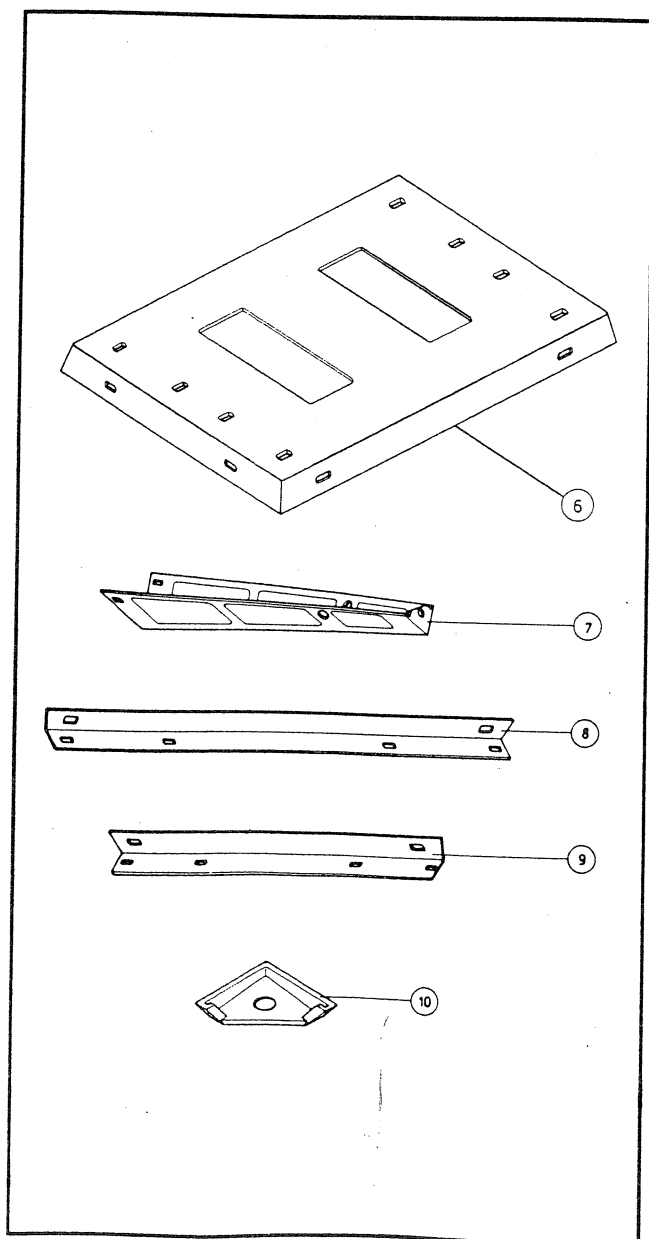
PARTS LIST



REF. NO.	PARTS NO.	PARTS NAME
201	F103009	SCREW
202	F702008	WASHER
203	BS14003012	MAGNIFIER
204	BS14003016	KNOB M
205	BS14003011	FENCE HOLDER
206	BS14003013	SPRING A
207	BS14003014	U CLAMP
208	NP9085	SCALE
209	BS14003008	GUIDE BAR
210	F110356	SQUARE NECK BOLT
211	BS14003015	RIP FENCE
212	BS14003017	REAR CLAMP
213	BS14003018	KNOB N
214	BS14003009	KEEPER BOLT
215	BS14003010	KNOB Q
216	BS14001018	KNOB C

1. Unpacking And Checking List II.Assembly Procedure

Key No.	Part No.	Parts Name	Q'ty
1	F110331	Square Neck Bolt M8P1.25x20	20
2	F110366	Square Neck Bolt M8P1.25x50	4
3	F201020	Hex. Nut M8P1.25	24
4	F702211	Washer $\phi 10.2 \times \phi 20.2 \times 2$	24
5	F701008	Spring Washer M8	24
6	BS14005001	Top	1
7	BS14005002	Leg	4
8	BS14005003	Long Bracket	2
9	BS14005004	Short Bracket	2
10	BS14005005	Pad	4



ELECTRICAL CONNECTION/DISCONNECTION & OPERATION.

FOR THREE PHASE.

1. **Electrical connection:**

- a. A cable with four wires is equipped to connect your machine into the 3 phase power supply. **Please connect your machine into the power supply with hand-operated disconnecting device**, which is in compliance with subclause 5.3 of EN60204-1, such as no fuse breaker or plug/socket combination.
- b. For the protection of control device, we recommend the operator to supply **a fuse with 6 amp. current rating of fuse**, and the total length between fuse and connection terminal shall not exceed 1.5 m.
- c. **The exact power source voltage, frequency, and number of phase** shall be checked according to the installation diagram and circuit diagram.
- d. **The correct direction of saw blade should be checked after connecting.**

2. **Electrical disconnection:**

- a. The disconnection is carried out by hand-operated disconnecting device.
- b. Be sure to disconnect this machine from power source, when you want to stop the job, maintenance, and adjustment.

3. **Grounding.**

The grounding of the band saw is carried out **by connecting the Yellow/green terminal of supply cable** to the grounding terminal of power source. Be sure to ground your machine before connecting machine to power source in any situation.

WARNING!

Do not disconnect grounding terminal before disconnecting power source.

FOR SINGLE PHASE.

1. The connection, disconnection, and grounding is carried out **through the plug**, equipped on the band saw. For the safety reason, **Do not change this plug into any the other type in any situation.**
2. For the protection of control device, we recommend the operator to supply **a fuse with 10 A current rating of fuse**, and the total length between fuse and connection terminal shall not exceed 1.5 m.
3. The **exact power source voltage, frequency, and number of phase** shall be checked according to the installation diagram and circuit diagram.

OPERATION.

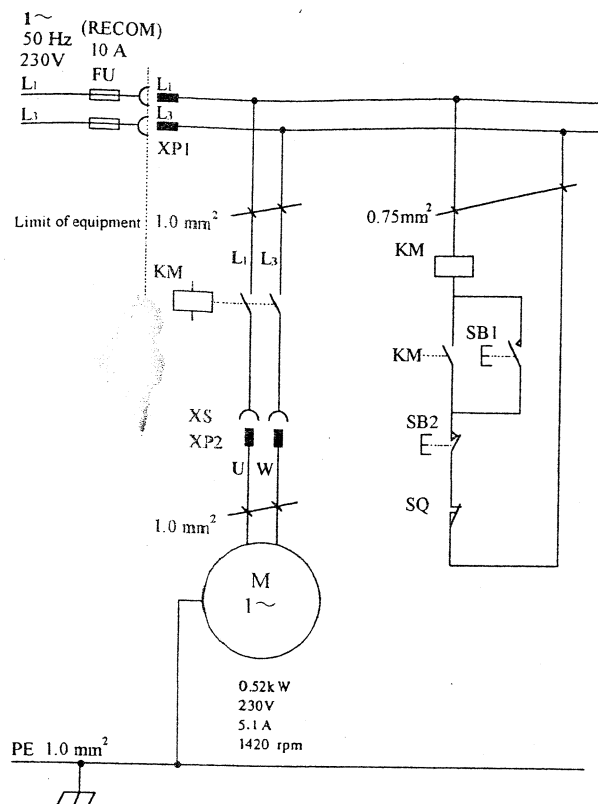
1. **"START"** : Push the button marked with " I ".
2. **"STOP"** : Push the button marked with " O ".

WARNING!

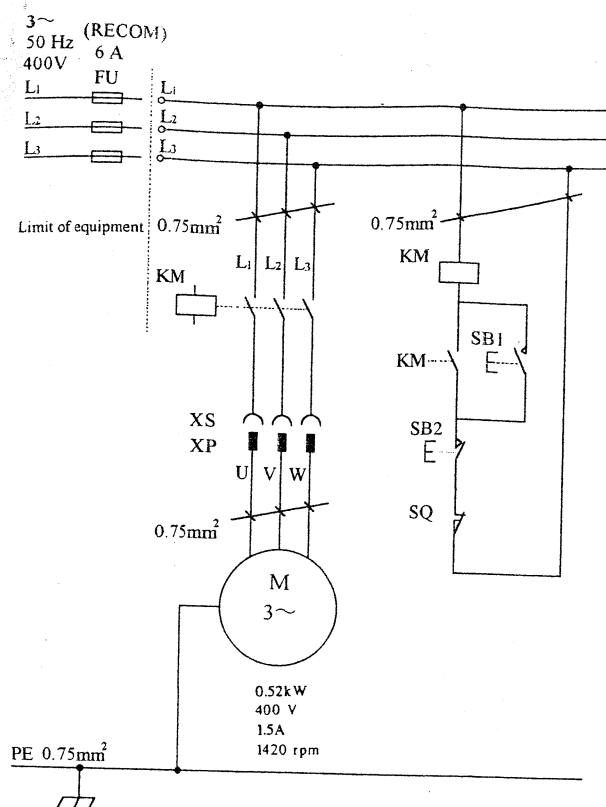
Do not use the interlock device to stop machine in normal operation.

Electrical circuit diagram.

BS 140-04 CE



BS 140-05 CE



Electrical components Parts List.

Item Designation	Description & Function	Technical Data	Remark
KM	Magnetic Contactor	20A, 600 Vac	IEC 158-1, BS 775.
SB1	Push button-On	1<<a>>, green; IP 54 380 Vac; 10A	VDE, UTE, FI, N, S, D, KEMA, SEV
SB2	Push button-Off	1<>, red; IP 54 380 Vac; 10A	VDE, UTE, FI, N, S, D, KEMA, SEV
XP1	Plug (supply cable)	10A, 250 V (1~)	VDE,
XP2	Plug	10A, 250 V (1~) 8A, 500 V (3~)	VDE,
XS	Socket	15A, 250 V (1~) 10A, 500 V (3~)	VDE, CSA, UL
SQ	Limit Switch	4A, 400 V, IP 65	EN-60947 IEC 947
	Cable for 1~	H05-VVF, 3 × 1.0mm ²	VDE
	Cable for 3~	VCTF, 4 × 0.75mm ²	