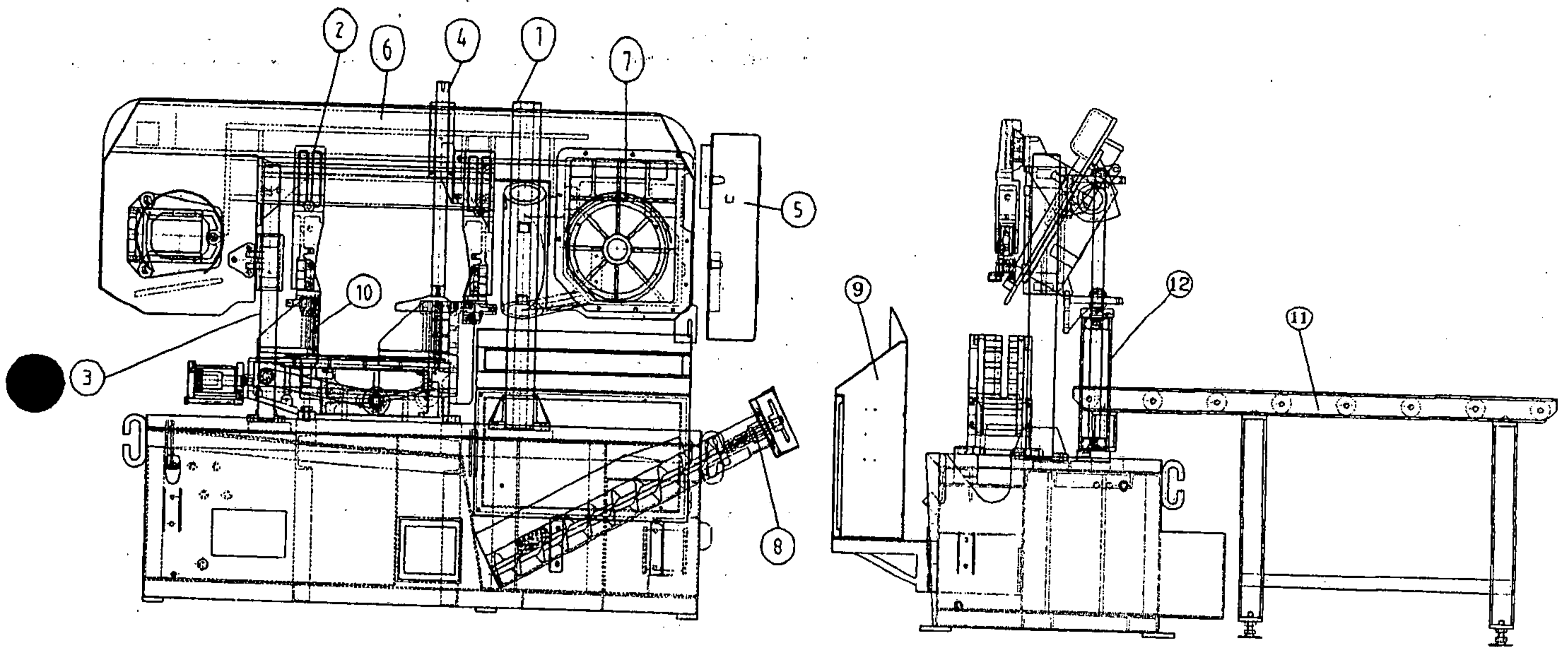


1. INTRODUCTORY ILLUSTRATIONS

1.1 Principal Parts



1	Main Column	7	Gear Box
2	Guide Arm	8	Chip Conveyor Sys.
3	Guide Column	9	Electric Control Box
4	Quick Approach Rod & Feeler	10	Movable Vice Jaw & Bed
5	Pulley Cover	11	Roller Table
6	Saw Frame	12	Lift Cylinder

2 SPECIFICATIONS

2.1 SPECIFICATIONS

MODEL		H330
SPECIFICATIONS		
Cutting Capacity	(Mm)	φ 330 □ 330H*350W
	(In)	φ 13 □ 13*13.7
Bundle Cutting	(Mm)	264W*150H
Blade Size	(Mm)	32*1.06*3920
	(In)	1 1/4*0.042*154.33
Blade Speed	(M)	25, 32, 42, 55, 70, 80 M/Min Variable Speed 20-80 M/Min
	(F)	82, 105, 138, 180, 230, 260 F/Min Variable Speed 65-260F/Min
Motor Output	(KW)	Blade-3.75, HYD-0.75, Coolant-0.1
	(HP)	Blade-5, HYD-1, Coolant- 1/8,

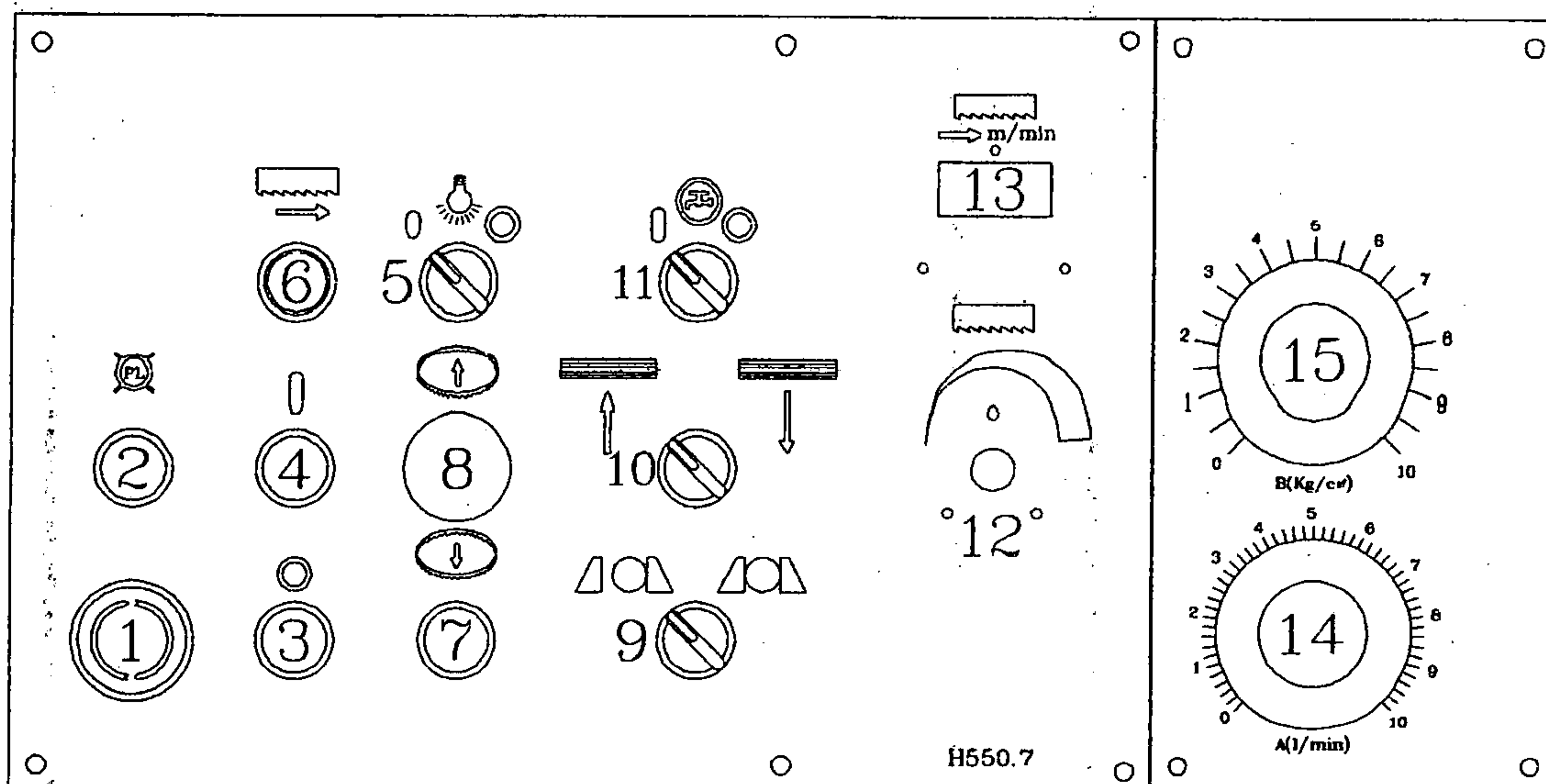
Specifications subject to change without notice for improvement and modification.

2.2 STANDARD ACCESSORIES

1. Tools with tool box 1 set
2. 7 ft.(2M) long roller table 1 set
3. Band-cleaning wire brush 2 pieces
4. Band saw blade 1 piece
5. Instruction manual 1 copy

4. OPERATION

4.1 CONTROL PANEL



- (1) **EMERGENCY STOP** -- This switch is used for emergency case to stop the machine only.
Turn this switch clockwise makes power source on. When this switch is pressed, all machine's operation stop immediately.
- (2) **PILOT LAMP** -- This light will come on when the power supply is on.
- (3) **Power Switch Off**
- (4) **Power Switch On**
- (5) **WORK BEAM LIGHT SWITCH** -- When this switch is set at "1" the work light illuminates.
- (6) **BLADE DRIVE BUTTON** -- When this button is pressed, both the saw blade motor and the cutting fluid pump operate and saw head begins to descend. The saw head descends quickly until the feeler of the quick approach device comes into contact with the workpiece and thereafter, it will descend at the designated cutting speed.
- (7) **QUICK APPROACH BUTTON** -- While this button is pressed, the saw head descends quickly.
This button is used to cause the saw blade to approach the work quickly when the saw blade is at a distance from the workpiece. When the feeler of the quick approach device comes into contact with the work, the saw head stops descending at that position even this button is still pressed.
- (8) **SAW FRAME RAISE BUTTON** -- When this button is pressed, the saw blade motor stops and the saw head ascends. The saw head stops ascending at that position when the button is released.
- (9) **LEFT - VISE OPEN**
RIGHT - VISE CLOSE
- (10) **LEFT - ROLLER RAISE**
RIGHT - ROLLER DOWN
- (11) **Coolant Switch** -- When this button is depressed, the coolant pump motor operates during manual mode.
- (12) **Inverter Control Knob** -- Please turn left for being slow speed wanted, turn right for being fast speed wanted.
- (13) **Speed Display** -- Cutting speed display.
- (14) **FEED RATE CONTROL KNOB** -- When this control dial is turned clockwise the feed rate of the cutting increases, when it is turned counter clockwise, the feed rate decreases.
- (15) **CUTTING PRESSURE CONTROL KNOB** -- When this control dial is turned clockwise the cutting pressure increases, when it is turned counter clockwise, the cutting pressure decreases.

4.2 OPERATING PREPARATION

There are several steps will be taken before start the machine.

(1) CHOOSE PROPER SAW BLADE :

Select the saw blade best suited to the workpiece to be cut, Size and shape of the workpiece , and type of material should all be considered when selecting the saw blade to be used . There is a reference chart in chapter 9 which can help you to select the right saw blade and cutting conditions .

(2) UNPACK THE SAW BLADE :

Usually the saw blade is packed in 3 circle ,unpack it one circle first grip the part to release another 2 circles gradually , tear off the saw-cap protective shield , inspect the blade teeth , make sure that the cutting edge of the blade teeth point to the right . If they point to the left the blade should be turned over.

(3) PLACE THE SAW BLADE ONTO BOTH THE DRIVE AND DRIVEN WHEELS ----

- a. Turn the hydraulic blade tension handle clockwise , to fully loosen the driven wheel .
- b. Open both the drive and driven wheel covers , place the saw blade onto both the drive and driven wheels. Check the cutting edge of the saw blade , to ensure that it point to the right.
- c. Insert the saw blade into both the left and right blade guides so that the back edge of the saw blade touches the back-up roller of each guide .
- d. The back edge of the saw blade should make contact with the flange of the drive and driven wheel , turn count -clockwise the hydraulic blade tension handle to tighten the saw blade , Then the blade is properly tensioned .
- e. Don't forget to tighten the insert adjusting screw .

(4) WORKPIECE CLAMPING :

- a. Raise the saw frame , open the vise , place the workpiece on the roller table .
- b. Gently push the workpiece into the roller-feed vise, taking care not hit the feed rollers.
- c. Clamp the workpiece in vise.

(5) ADJUST THE BLADE GUIDE ARM :

Blade guide arm adjustment

a. unlock the guide arm and carbide guides to move the guide arm.

1. Turn clockwise throat flow control valve V1 to close the in-flow to the guide arm lock and carbide tightening.
2. Turn counter-clockwise throat flow control valve V2 to let the oil out back to tank, to release the guide arm lock and carbide tightening.
3. Move the guide arm to the proper position that just wide enough to clear the workpiece for cutting.

b. lock the guide arm and carbide guides before cutting.

1. Turn counter-clockwise throat flow control valve V1 to let the in-flow to the guide arm lock and carbide tightening.
2. Turn clockwise throat flow control valve V2 to close the oil out back to tank, to have the guide arm locked and carbide tightened to the saw blade. Properly position the blade guide arms according to the diameter (or the width) of the workpiece to be cut.

(6) ADJUST THE POSITION OF THE WIRE BRUSH :

- a. loosen the lock lever of the wire brush case.
- b. Manually move the wire brush case so that wire brush just contacts the cutting edge of the saw blade.
- c. Tighten the lock lever.

(7) ADJUST THE FEED RATE :

Select suitable feed rate for the workpiece to be cut. This varies according to the size and shape of the workpiece, type of material, and what type of saw blade is being used. As a guide hard materials, wide workpiece or structural sections and tubing have to be cut at a slower rate than mild steel bar. As concerns the saw blade, high speed steel is better than carbon steel, and bi-metal alloy is better than high speed steel. Roughly the ratio of feed speeds could be 1:2:3

(8) SELECT THE SAW BLADE SPEED :

There are 6 speeds provided : 25, 32, 42, 55, 70, 80 M/min

If a optional variable speed drive is equipped the speed to be 20 to 80 M/Min steplessly.

4.3 MANUAL OPERATION :

Place the workpiece to be cut on the work table, decide how long you want the off-cut, and carry out all the procedures as described above in [2] Operating Preparation.

- (1) Depress the RAISE button to lift the saw frame until the cutting edge of the saw blade clears the workpiece by 1/2 to 3/4 inch.
- (2) Turn the AUTO-MANUAL selector to manual.
- (3) Clamp the workpiece.
- (4) Adjust the spacing of the blade guide arms.
- (5) Preset the required cutting length of the workpiece.
- (6) Depress BAR FEED FORWARD button until the workpiece touch the bar stop feeler.
- (7) Adjust the FEED RATE.
- (8) Depress BLADE DRIVE button to start both the saw blade motor and the cutting fluid pump and the saw frame begins to descend.
- (9) After completion of the cut saw blade stops at the lower limit position.
- (10) Depress the RAISE button to cut next piece again.

*. Before you start to cut the workpiece, you must inspect that....

*. The workpiece is well clamped.

*. The saw blade is suitable for the material being cut.

*. The feed rate is suitable for the material being cut.

*. The speed of the saw blade is suitable for the material being cut.

*. The insert adjusting screw and the lock lovers of the blade guide arms are all tightened.

*. Sufficient tension is placed on the saw blade.

*. The wire brush is properly positioned.

*. There is sufficient cutting fluid in good condition.

*. The off-cut length is as required.

4.4 SPECIAL OPERATION :

- (1) While you are cutting a workpiece, if the saw blade suddenly jams in the workpiece, depress the FRAME RAISE button to lift the saw frame immediately.
- (2) The saw blade jamming in the workpiece is most likely because of :
 - a. Slippage occurring between saw blade and drive wheel. Tension placed on the saw blade is not sufficient.
 - b. Slippage occurring between drive belt and motor pulley. Tension on drive belt is not sufficient or belt is worn.
 - c. Broken teeth on saw blade.
 - d. Too blunt saw blade.
 - e. Too fine tooth spacing on saw blade for material being cut.
 - f. Too fast feed rate for material being cut and blade used.

4.5 BREAK-IN OPERATION:

When a new blade is used , be sure to first break in the blade before using it for extended operation. Failure to break in the blade will shorten the service life of the blade ,and result in less than optimum efficiency. To break in the blade ,proceed as follow :

- (1) Reduce the blade speed setting to one half of its normal setting .
- (2) Lengthen the time required for cutting to 2-3 times that of normal.
- (3) The break-inoperation can be considered sufficient if all unusual noises or metallic sounds have been eliminated. (For instance, to completely break in the blade, a minimum of five complete cuts of a 200mm (8 ins) diameter work- piece will be required.)
- (4) After the break-in operation has been completed, return the blade speed and feed rate to their normal setting.