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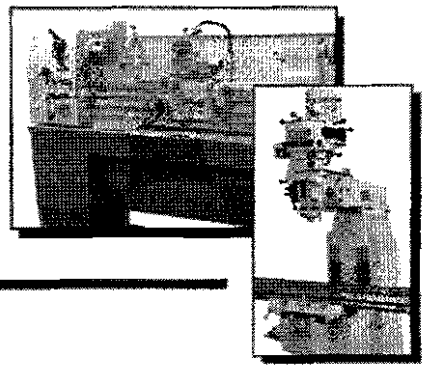

MODEL BAH-916
BANDSAW

THANK YOU FOR PURCHASING WITH KBC MACHINERY. ALL KBC MACHINES ARE BACKED BY OUR 1 YEAR PARTS REPLACEMENT WARRANTY. WHEN USED AS INTENDED, AND WITH PROPER MAINTENANCE THIS MACHINE WILL PROVIDE YOU WITH YEARS OF TROUBLE-FREE SERVICE. IF YOU NEED PARTS SIMPLY FILL OUT THE PARTS REQUEST FORM, AND FAX OR E-MAIL YOUR REQUEST. ALL OTHER QUESTIONS PLEASE CONTACT US @ :

KBC MACHINERY
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STERLING HEIGHTS,MI 48314
PH (800) 860-1740
FAX (800) 862-1740
MACHINERY@KBCTOOLS.COM
WWW.KBCTOOLSANDMACHINERY.COM

PARTS REQUEST FORM

YOUR COMPANY NAME: _____
STATE/PROVINCE _____
YOUR NAME _____

PHONE # + EXT _____
FAX # _____

MACHINE INFO:
MAKE/MANFACTURER _____

MODEL NUMBER _____
YEAR MADE _____

SERIAL# _____

PARTS REQUESTED:

PART#	*DESCRIPTION*
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____

PLEASE INCLUDE COPY(S) OF THE PARTS DRAWING FROM THE MANUAL AND CIRCLE THE PARTS NEEDED

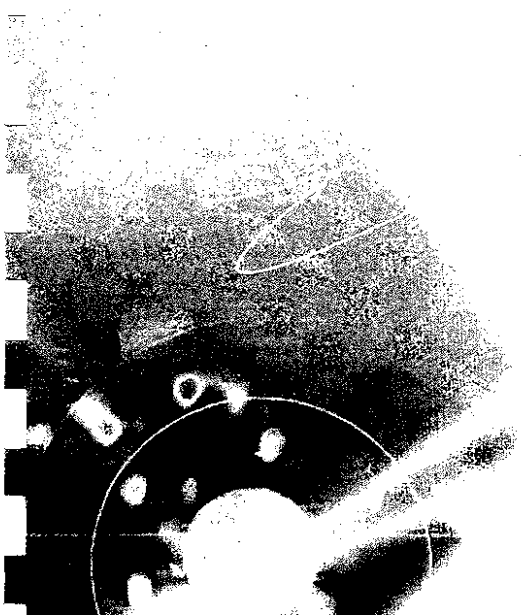
FAX PARTS REQUEST TO (800) 862-1740
E-MAIL PARTS REQUEST TO: machinery@kbctools.com

THANKS; KBC MACHINERY - MICHIGAN

KBC machinery

Manual & Auto. Horizontal Bandsaw

BAH 916



SAFETY SUGGESTIONS

1. READ THE INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.
2. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF HORIZONTAL BAND SAWS, OBTAIN ADVICE FROM YOUR SUPERVISOR, INSTRUCTOR OR OTHER QUALIFIED PERSON.
3. REMOVE TIE, RINGS, WATCH AND OTHER JEWELRY, AND ROLL UP SLEEVES.
4. ALWAYS WEAR SAFETY GLASSES OR A FACE SHIELD.
5. MAKE SURE WIRING CODES AND RECOMMENDED ELECTRICAL CONNECTION INSTRUCTIONS ARE FOLLOWED AND THAT MACHINE IS PROPERLY GROUNDED.
6. MAKE ALL ADJUSTMENTS WITH THE POWER OFF.
7. ADJUST AND POSITION THE BLADE GUIDE BEFORE STARTING CUT.
8. MAKE SURE THAT BLADE TENSION IS PROPERLY ADJUSTED BEFORE STARTING CUT.
9. STOP THE BAND SAW BEFORE PUTTING A WORK PIECE IN THE VISE.
10. ALWAYS KEEP HANDS AND FINGERS AWAY FROM THE BLADE WHEN THE MACHINE IS RUNNING.
11. STOP THE MACHINE BEFORE REMOVING CHIPS.
12. ALWAYS HAVE STOCK FIRMLY CLAMPED IN VISE, BEFORE STARTING CUT.
13. DISCONNECT MACHINE FROM POWER SOURCE WHEN MAKING REPAIRS.
14. BEFORE LEAVING THE MACHINE, MAKE SURE THE WORK AREA IS CLEAN.

DAILY CHECK LIST

1. CHECK COOLANT: Low coolant level can cause foaming and high blade temperatures. Dirty or weak coolant can clog pump, cause crooked cuts, low cutting rate and permanent blade failure. Dirty coolant can cause the growth of bacteria with ensuing skin irritation.
2. KEEP VISE SLIDES CLEAN AND OILED.
3. CLEAN CHIPS FROM BLADE WHEELS AND AREAS AROUND WHEELS.
4. SAW GUIDE: Keep saw guide tight. Loose guide will affect sawing accuracy.
5. SAW BLADE: Is saw blade sharp?
6. BLADE SPEED: Is blade speed set correctly for workpiece material and shape?
7. CHECK BLADE TENSION: Particularly after initial cuts with a new blade.

SAW BLADE SELECTION

A. Never use a blade so coarse that less than 3 consecutive teeth are engaged in the work piece at any one time. (Too few teeth will cause teeth to strip out.)

B. Never use a blade finer than required to obtain a satisfactory surface finish or satisfactory flatness. (Too many teeth engaged in the workpiece will prevent attainment of a satisfactory sawing rate; frequently cause premature blade wear; frequently produce "dished" cuts or cuts which are neither square nor parallel.)

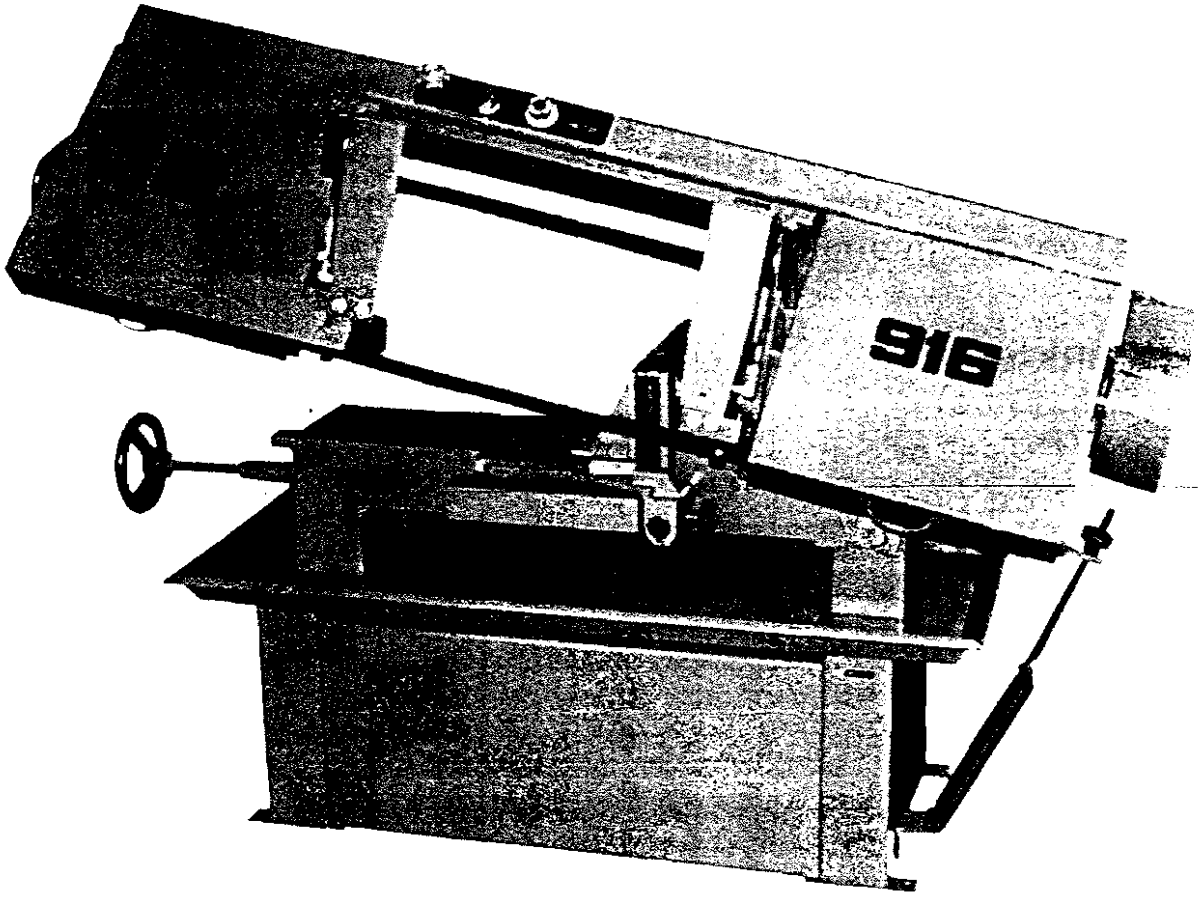
C. The Chart which follows is not expected to be exactly correct for all cases. It is intended as a general guide to good sawing practice. Your blade supplier or factory application engineer should be your most reliable source of correct information for operational details of saw blades and their use.

WORK SIZE (Solid Bars)	PORBABLE PITCH–TEETH PER INCH		
	BEST	SECOND BEST	THIRD BEST
Less Than 1" Dia. or Sq.	10		
1" Dia. or 1" Sq.	8	10	6
1-1/2" Dia. or 1-1/2" Sq.	8	10	6
2" Dia. or 2" Sq.	8	6	4
2-1/2" Dia. or 2-1/2" Sq.	6	8	4
3" Dia. or 3" Sq.	6	4	3
3-1/2" Dia. or 3-1/2" Sq.	6	4	3
4" Dia. or 4" Sq.	4	3	6
4-1/2" Dia. or 4-1/2" Sq.	4	3	6
5" Dia. or 5" Sq.	4	3	6
6" Dia. or 6" Sq.	3	4	6
7" Dia. or 7" Sq.	3	4	6
8" Dia. or 8" Sq.	3	2	4
9" Dia. or 9" Sq.	3	2	4

NOTE:

1. When standard wall pipe or tubing or thin wall tubing, channel iron, angles I Beams are cut, a 10 pitch saw blade of "wave" set type is frequently used to good advantage. Fewer than 10 teeth per inch of saw will almost never be satisfactory.
2. Tubing or structurals with wall thickness or web thickness of 1/2" or more can usually use an 8 or 6 pitch blade satisfactorily,
3. When rectangular, solid bar is to be sawed, the work should, whenever possible, be loaded with thinnest cross section exposed to the blade teeth. The pitch (or number of teeth per inch of blade) selected must provide engagement of at least 3 consecutive teeth in the work piece. Should application of this rule not be possible because the thinnest cross section is too thin, the piece must be loaded with the wider dimension exposed to the saw teeth and a coarser blade selected from the listing of

9" × 16" HORIZONTAL BAND CUT-OFF MACHINE



INTRODUCTION

Your new 9" x 16" HORIZONTAL Band Saw is well suited for many users - job shops, tool rooms, maintenance departments, metal fabricators, building trade contractors, machine shops, vocational schools and teacher training colleges. Your machine is shipped wired for one of the five following electrical systems:

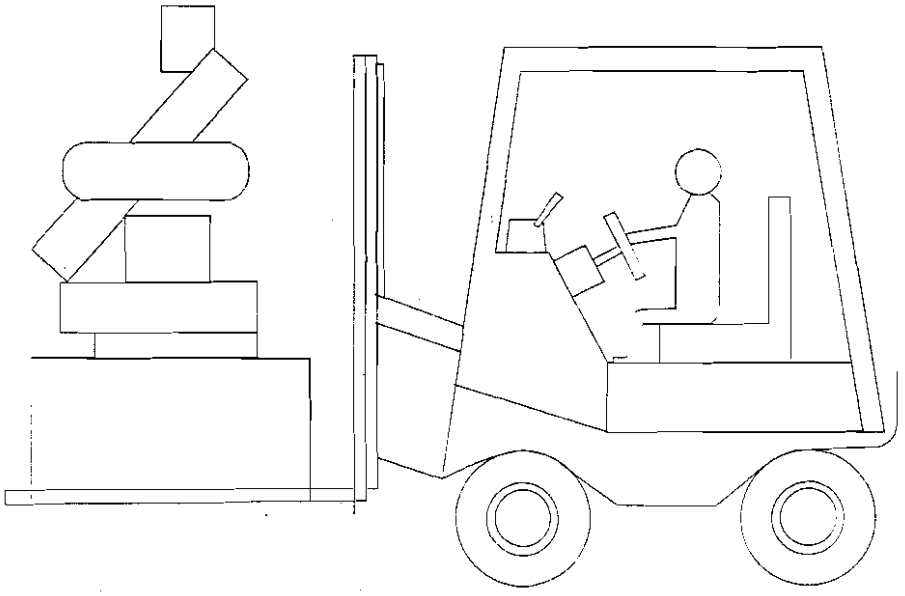
115 Volt, Single Phase Only
115/230 Volt, Single Phase - Motor wired for 115 Volt
230/460 Volt, Three Phase - Motor wired for 230 Volt
200 Volt, Three Phase
575 Volt, Three Phase

We suggest you read and understand this manual before setting up, making wiring connections and operating your machine and also that you save it for future reference.

TRANSPORATION METHODS

1.ALWAYS KEEP BALANCE WHILE THE MACHINE IS IN TRANSPORTATION.

2.DRIVE FOLKLIFT SLOWLY AND CAREFULLY.



OPERATING CONTROLS AND ADJUSTMENTS

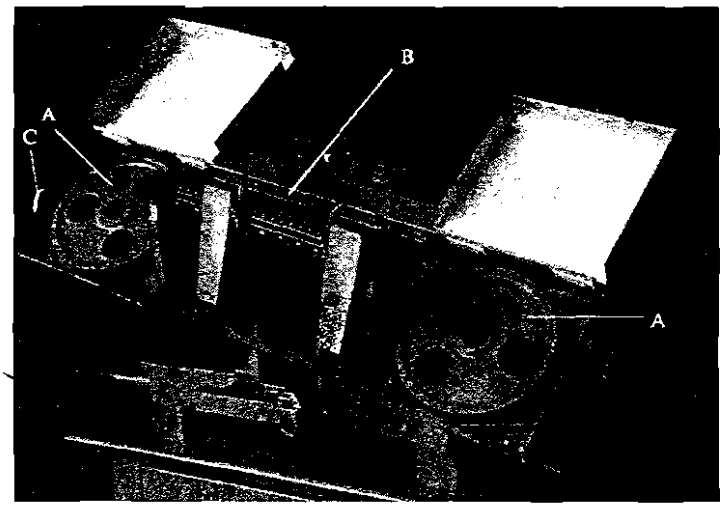


FIG.1

REMOVING AND INSTALLING THE BLADE

When your machine was shipped, a blade was supplied and assembled to the saw.When selecting a new blade refer to page 3 for information on SAW BLASE SELECTION. This machine requires a blade 1" wide x 132 1/2" long.

1. Disconnect the machine from the power source.
2. Raise the saw frame about 6" and close the feed rate lever by turning it clockwise as far as it will go.
3. Open both wheel covers and clean the swarf out of the machine.
4. Release blade tension by turning the blade tension handwheel (C) Fig. 1 counterclockwise.
5. Remove the blade from both wheels and out of each blade guide.
6. Make sure the teeth of the new blade are pointing in the direction of travel.If necessary, turn the blade inside out.
7. Place the blade in place on the wheels (A) and through the upper blade guard (B) Fig. 1. Fig. 1 is shown with the wheel covers removed for clarity.
8. Work the blade (F) all the way up into the blade guide roller bearings (D) with the back of the blade against the back–up bearing (E), as shown in Fig. 2

NOTE: If roller bearings need adjusted refer to the section ADJUSTING BLADE GUIDE ROLLER BEARINGS.

9. Put light tension on the blade and work it on both wheels, as shown in Fig. 3 MAKE SURE THAT THE BACK OF THE BLADE IS AGAINST THE WHEEL FLANGES OF BOTH WHEELS. THIS IS VERY IMPORTANT.
10. When you are sure the back of the blade is against the wheel flanges of both wheels and properly inserted into the guides, finish putting tension on the blade.
11. Jog the power "on" and "off" to be sure the blade is in place and tracking properly. If blade is not tracking properly refer to the section TRACKING THE BLADE.

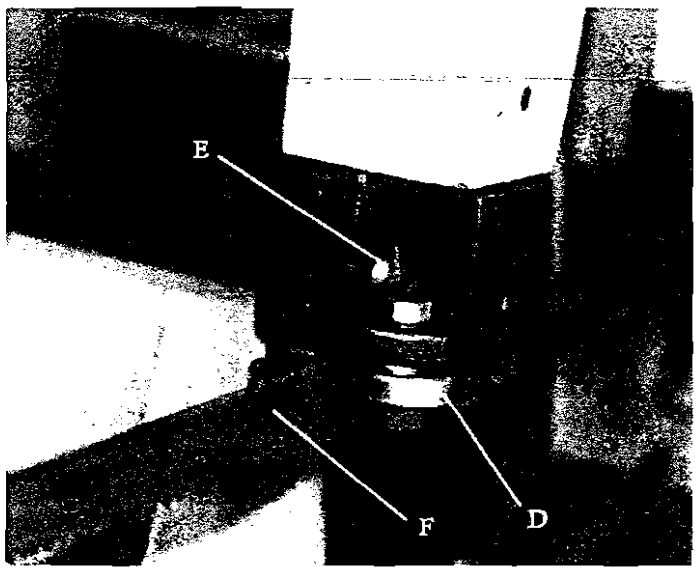


FIG.2

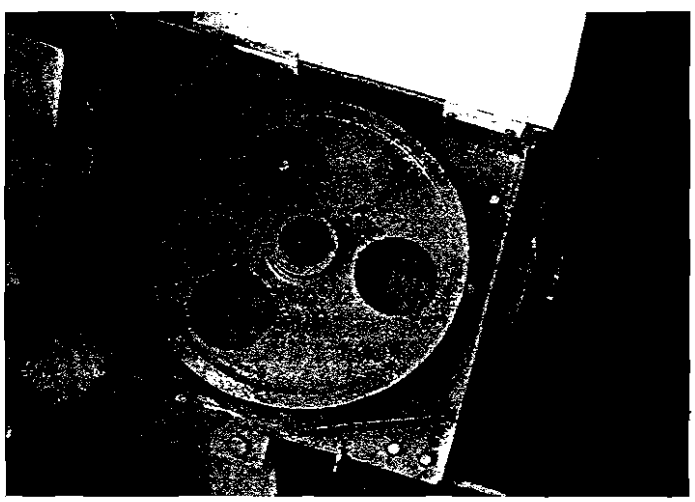


FIG.3

ADJUSTING BLADE GUIDE BRACKETS

The blade guides should be set as close to the vise jawa as possible. The right blade guide bracket (A) Fig.4, is not adjustable and is set at the factory to clear the right hand vise jaw. The left blade guide bracket (B) can be moved to the left or right depending on the position of the left hand vise jaw (C). To move the left blade guide bracket (B), loosen hand knob (D), position blade guide bracket (B) and tighten hand knob (D).
(Note: when operating 1018T, the right blade guide bracket (A) can be moved as well especially when cutting in 90° to make sure the bracket be moved as close to the vise jaw as possible.

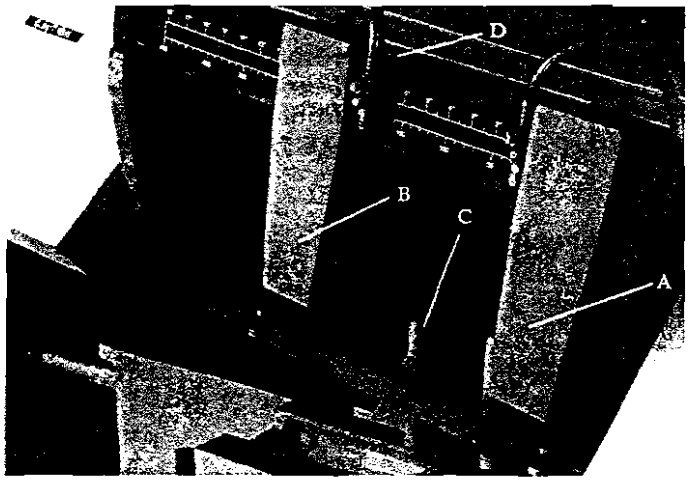


FIG.4

ADJUSTING BLADE GUIDE ROLLER BEARINGS

The back of the blade (A) Fig.5, should ride against the back–up support bearing (B) which is positioned at an angle so as to provide greater bearing support, eliminating bearing wear and extending blade life. The saw blade (A) should also ride between the two roller bearings (C) and (D) Fig. 5,The rear bearing (C) on the left hand blade guide can be easily adjusted to suit blade thickness by loosening nut (E). The bearing (C) is on an eccentric which enables it to be adjusted for te thickness of the blade. The roller bearings on the right blade guide bracket are adjusted for blade thickness in the same manner with the exception that the adjustable roller bearing is in the forward position.

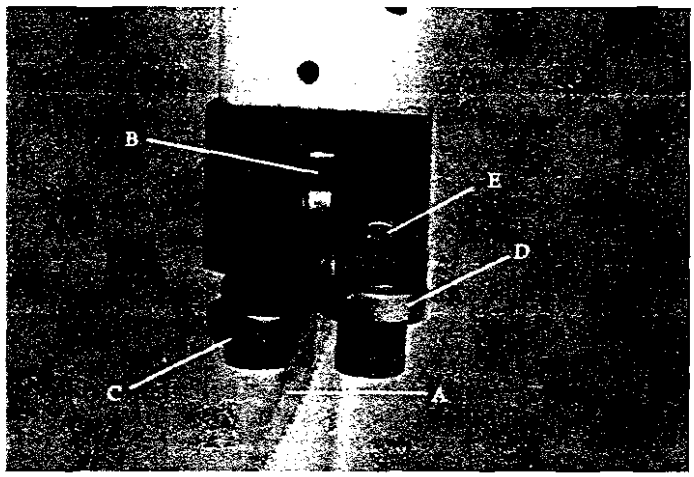


FIG.5

Part (F) shown Fig. 6 is a tungsten carbide block, after complete the adjustments shown in Fig. 5, tighten the Part (F) onto the surface of the saw blade.

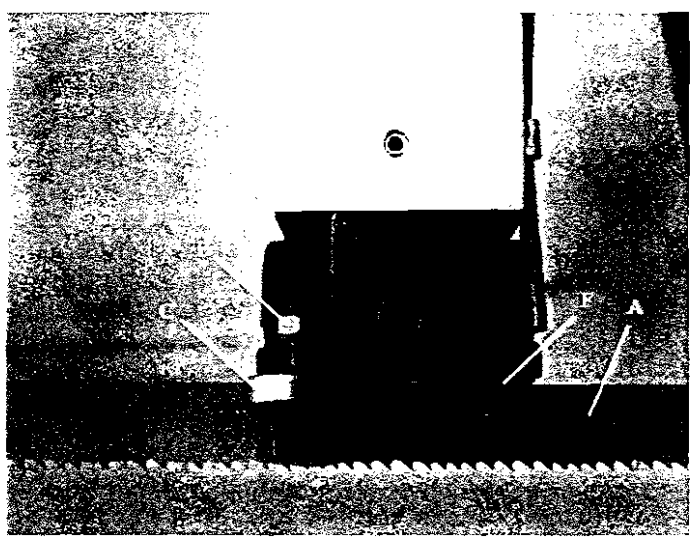


FIG.6

CHANGING SPEEDS

Your machine is provided with a range of four speeds; 50, 125, 200 and 275 feet per minute. To change speeds, proceed as follows:

1. Disconnect the machine from the power source.
2. Loosen wing nut and lift up the swing belt and the pulley guard to the front of the machine.
3. Release tension on the belt by turning the tension lock knob (A) Fig. 7 counterclockwise and lifting the motor swing forward.
4. Shift the belt (B) Fig. 7, to the desired grooves on the pulleys and adjust belt tension by pulling the motor plate (C) back until correct belt tension is obtained and tighten tension lock knob (A).
5. Close the belt and pulley guard.

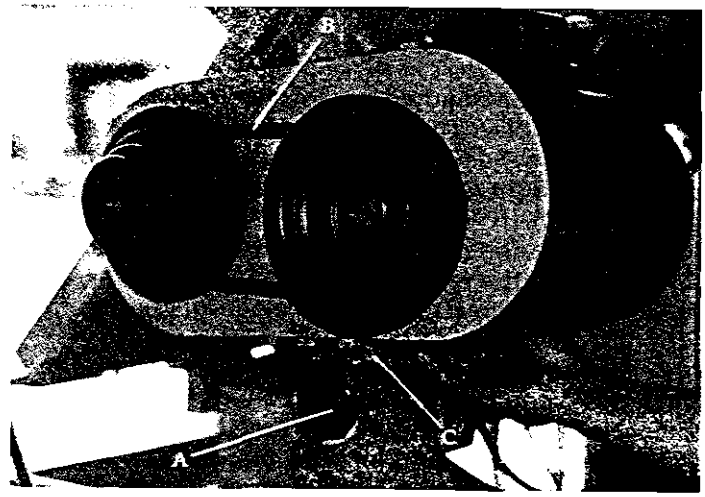


FIG. 7

OPERATING VISE (1018M)

The workpiece is placed between the vise jaws with the required amount to be cut_off extending out past the blade. To position the moveable vise jaw (B) instantly, Simply turn vise handknob (A) Fig 8, counterclockwise 1/2 turn and move the vise jaw (B) to the desired position. Then tighten vise by turning the knob (A) clockwise.

The vise can be adjusted to cut any angle from 0 degrees to 45 degrees by loosening the two bolts c Fig, 8, on each vise jaw. Position the vise jaws to the desired angle and tighten the bolts. It is also necessary, when angle cutting, to move the right hand vise jaw (D) to the left until the workpiece and right hand vise jaw clears the right hand guide arm.

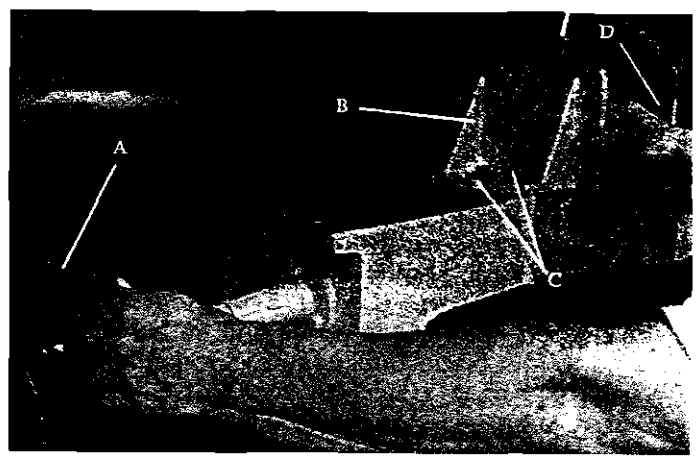
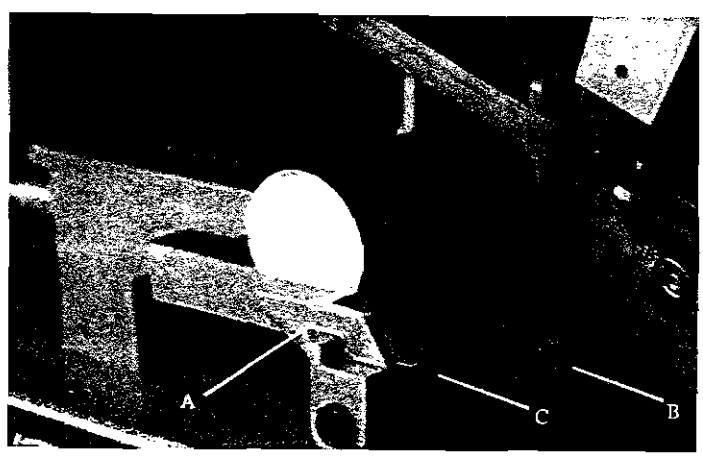


FIG. 8

ADJUSTING STOCK ADVANCE STOP

The Stock Advance Stop is used mainly when more than one piece is to be cut to the same length. Simply position the stop block (A) Fig.9, the desired distance away from the blade. The stop may be repositioned by loosening screw (B) and moving the rod (C) accordingly. To move the stop block (A) out of the way simply push it to the down position.



SETTING UP THE MACHINE FOR OPERATION

1. Select the roper speed and blade for the type of material you are cutting.
2. Make sure blade tension is adjusted properly.
3. Lift the saw frame up and close the feed rate lever.
4. Place the stock between the vise jaws, set the stock for the desired width of cut and tighten the vise.
5. Make sure the left blade guide bracket (A) is adjusted as close as possible to the left vise jaw (B) Fig. 10
6. Turn the machine on and if your machine is equipped with a coolant system, adjust coolant flow by turning lever (C) Fig.10.
7. Turn the feed rate lever (D) Fig 10, counterclockwise until the saw blade begins to lower the desired rate of speed.
8. Proceed to cut throughout the workpiece, as shown in Fig. 10. The machine shut off upon completion of cut.

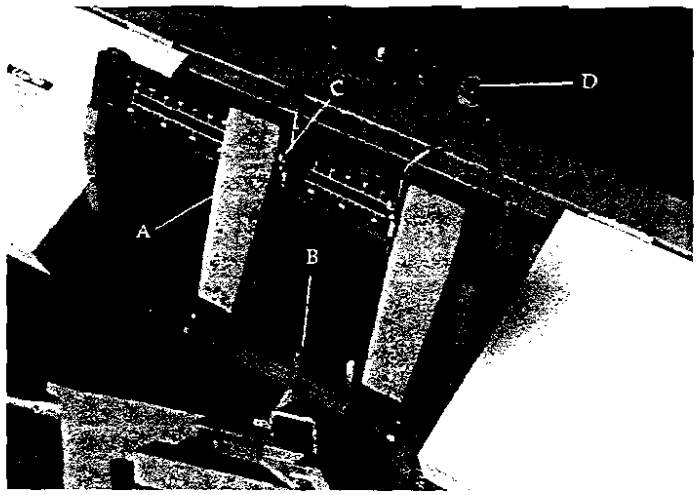


FIG.10

AUTOMATIC SHUT–OFF

On machine equipped with 115/230 Volt, single Phase; 230/460 Volt, Three Phase:200 Volt Three Phase: or 52-402. 575 Volt Three Phase Electrical, Kits, the machine and any accessories which are wired into the electrical system are controlled by the start–stop buttons. The machine will automatically shut off when the cut is completed. The lever (A) Fig. 11, for the automatic shut–off contacts the top of the hydraulic cylinder (B) and shuts off the machine.

Lubrication of hydraulic system If it is necessary to fill the hydraulic cylinder with oil, proceed as follow:

1. Lift the saw frame a little bit (about 15), pave a block underneath the saw frame to hold it.
2. Turn cover (B) shown in Fig. 11 counterclockwise, then fill hydraulic oil or equivalent in till it is full.

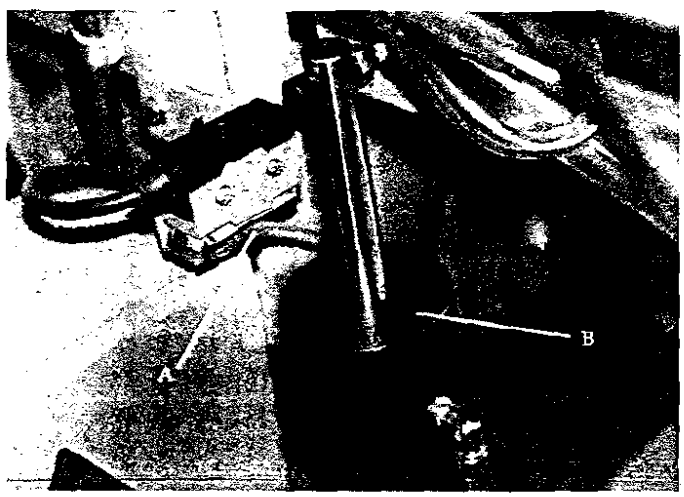


FIG.11

GEAR CASE

After the first 50 hours of use the gear case should be drained and refilled. Remove drain plug (A) Fig. 12 drain all of the oil out of the gearbox. Remove oil filler plug located underneath the right wheel and fill the gear case with 850ml of multi–function gearbox oil or equivalent.

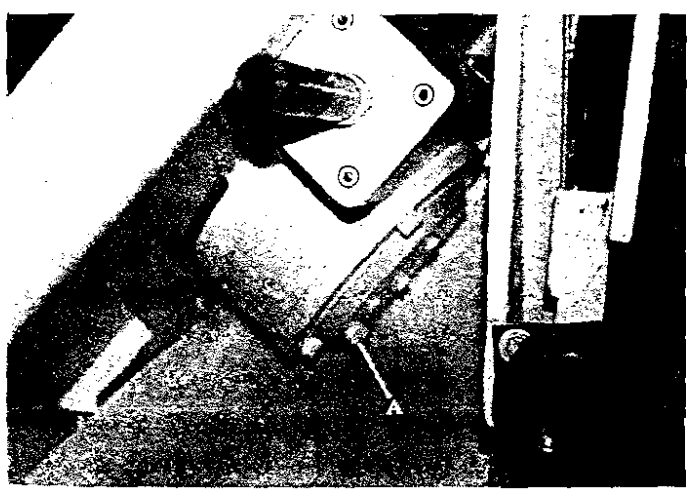
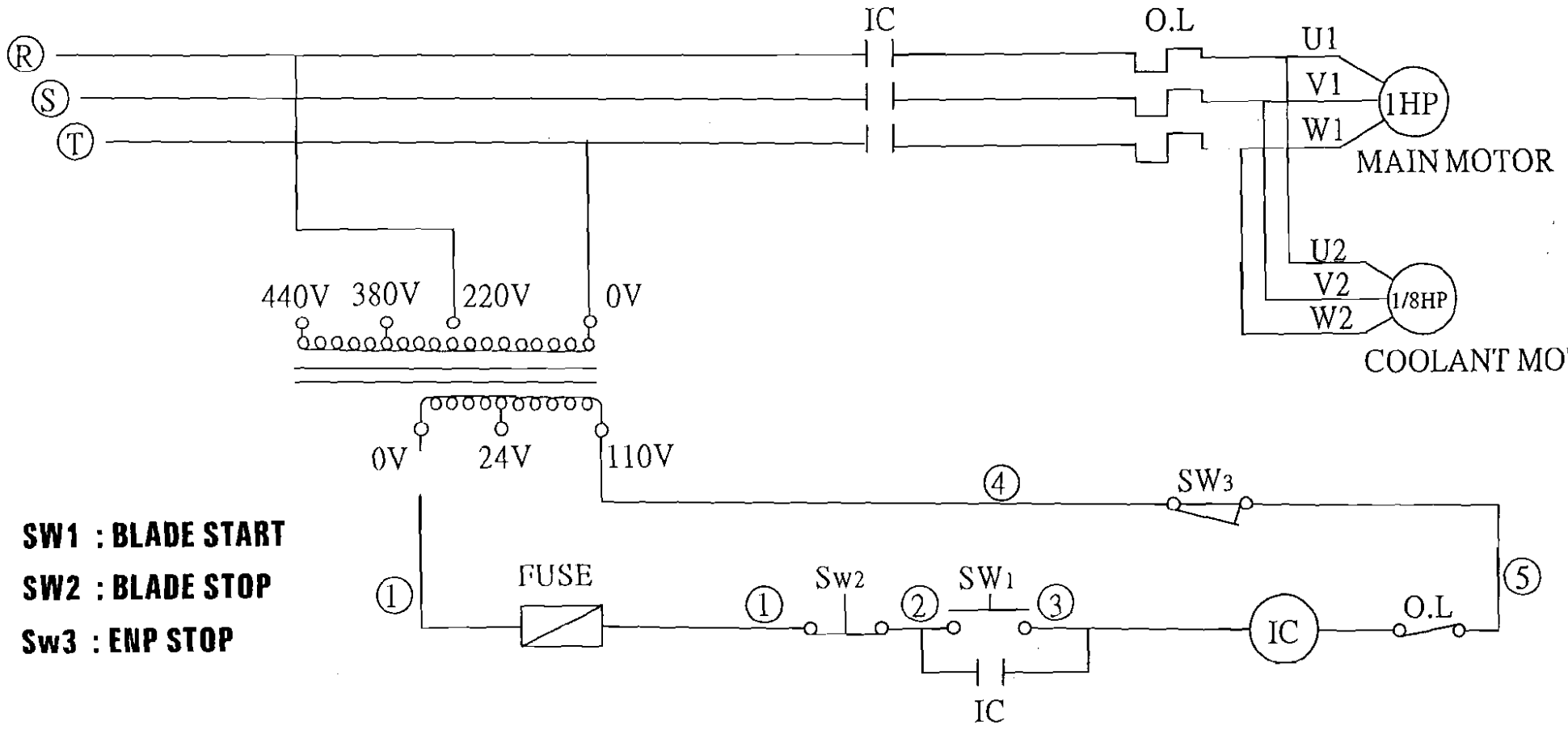


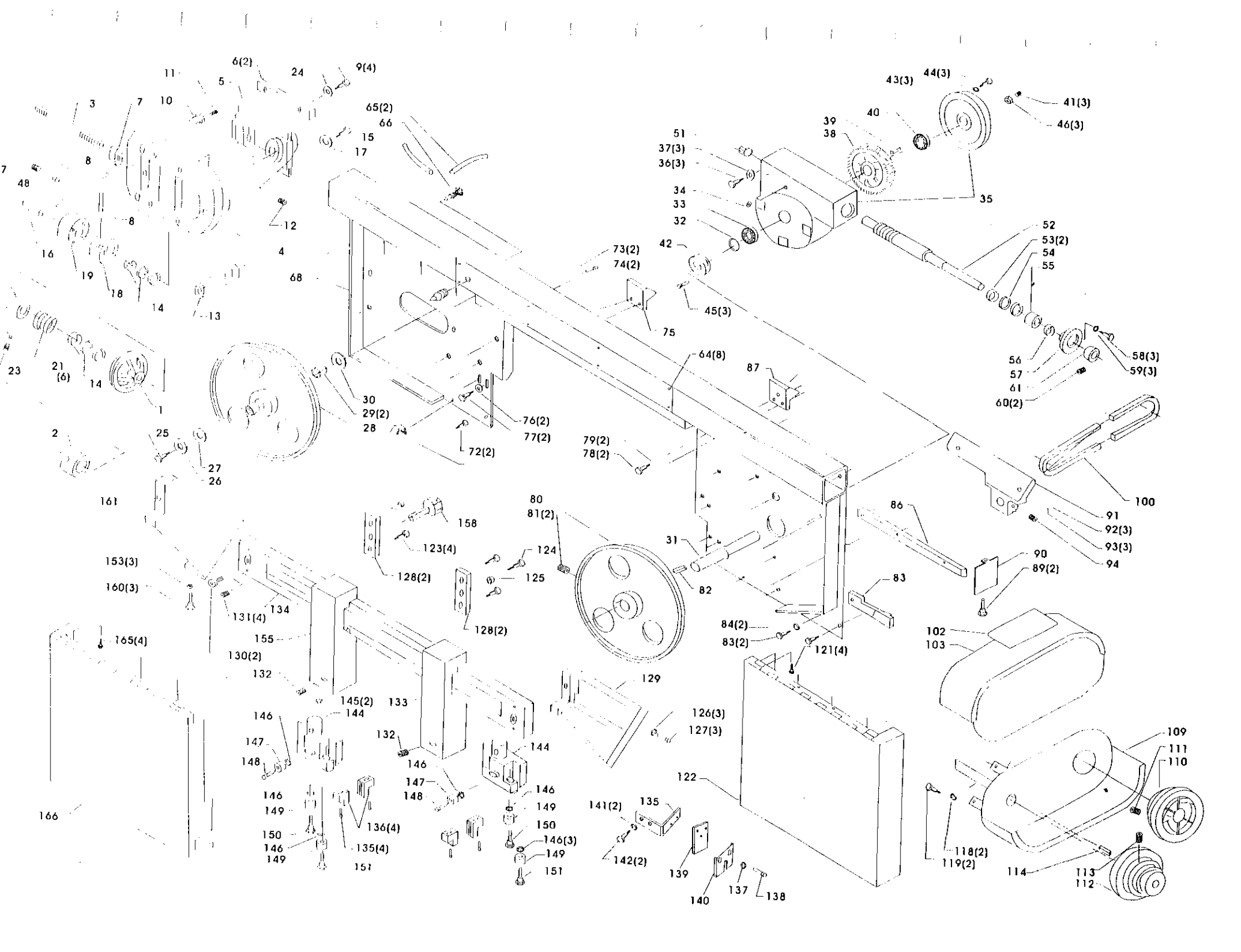
FIG.12



SW1 : BLADE START

SW2 : BLADE STOP

Sw3 : ENP STOP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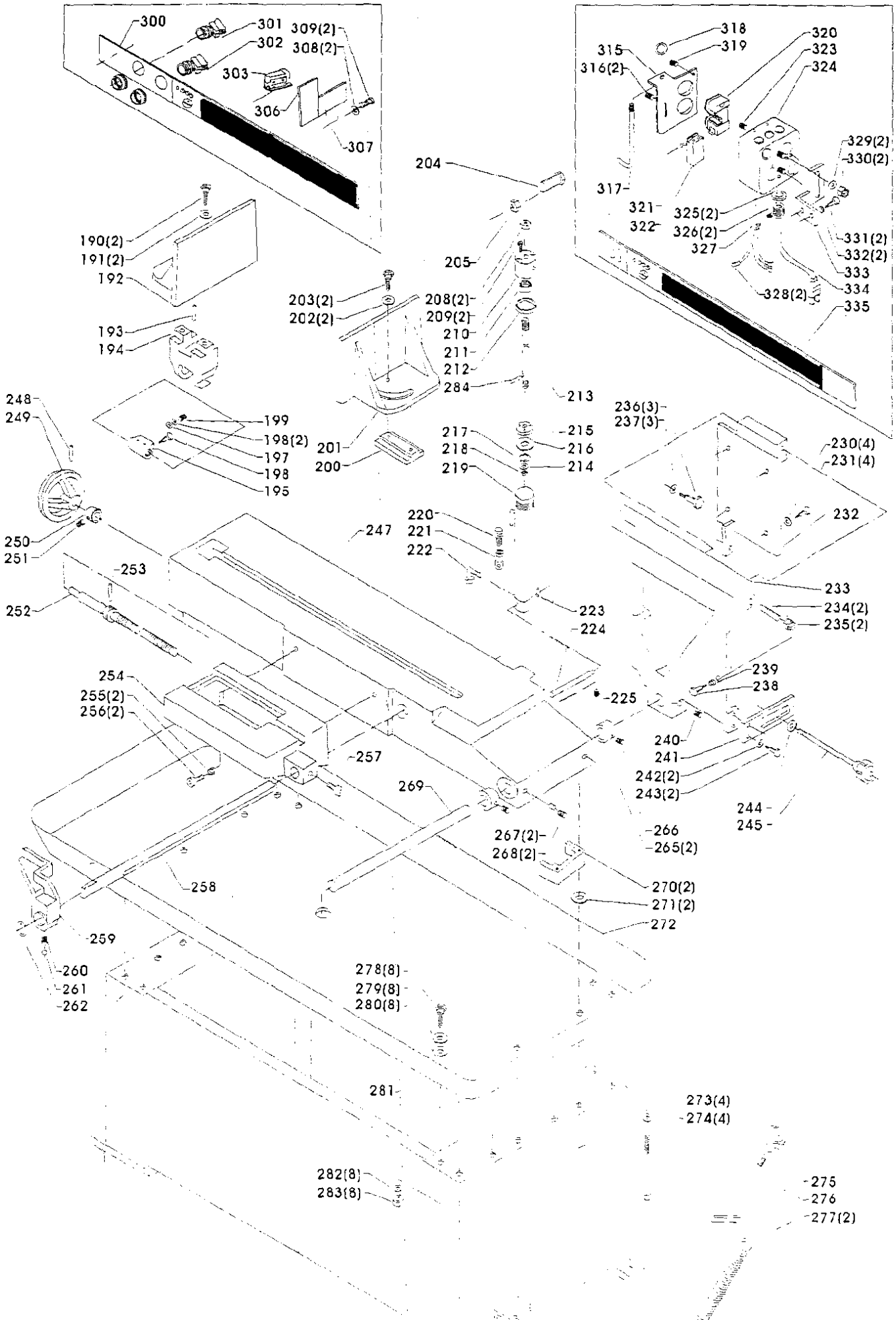
Replacement Parts

Ref. #	Description
1	Handwheel
2	Collar
3	Shaft
4	Bracket
5	Slide
6	Gib
7	Collar
8	Roll pin
9	5/16" x3/4" screw
10	Adjusting screw
11	3/8" x1–1/2" screw
12	3/8" x3/8" set screw
13	Spindle
14	Thrust bearing 51103#
15	3/8" x1–1/4" screw
16	Roll pin, 6 x401
17	Washer
18	Driven Dog
19	Thrust Bearing Housing
20	Lock nut
21	Disc Spring
22	Copper
23	1–1/4" x1/4" x24" Hex. Hd. Scr.
24	5/16" Split Lockwasher
25	3/8–16 x3/4" L.H.Hex. Hd. Scr.
26	Spacial Washer
27	Fiber Washer
28	Wheel Assembly, L.H., Including:
29	Bearing
30	Nylon Washer
31	Output Shaft
32	32, 42, 7, oilseal
33	Bearing 30207#
34	1/8" Soc. Hd. Pipe Plug
35	Gear Box and Cover Assembly
36	3/8–16 x3/4" Hex. Hd. Scr.
37	Spacial Washer
38	Worm Gear
39	7mm x35mm Key
40	Bearing 30206#
41	1/4" x3/4" set screw
42	Cap
43	3/8" Split Lockwasher
44	3/8"–16 x1–1/2" Hex. Hd. Scr.
45	1/4"–20 x5/8" Hex. Hd. Scr.
46	Washar
47	5/16" x18 x5/8" Soc. Set Scr.
48	Brass Plug
51	Needle Bearing
52	Input Shaft
53	Thrust Race
54	Rhrust Bearing
55	Needle Bearing
56	1" Cll Seal
57	Cap
58	1/4"–20 x3/4" Hex. Hd. Scr.
59	1/4" Split Lockwasher
60	5/16–18 x3/4" Soc. Set Scr.
61	Collar
64	#6–32 x1/4" Rd. Hd. Scr.
65	3/8 O.D. x65"lg. Tubing
66	Valve
68	Upper Frame
71	Catch
76	21/64 x7/8 x1/16" Washer
77	5/16–18 x3/4" Hex. Hd. Scr.
78	5/16–18 x3/4" Hex. Hd. Scr.
79	5/16" Split Lockwashser
80	Wheel–R.H.
81	3/8–24 x3/8" Soc. Set Scr.
82	7 x7 x40 Key
83	1/4–20 x3/4" Hex. Hd. Scr.
84	1/4" Split Lockwasher
85	Bracket
86	Bar
87	Bracket
89	3/16"–24 x1/2" Rd. Hd. Scr.
90	Coulumn Cap
91	Front Pivot Bracket
92	3/8" Split Lockwasher
93	3/8–16 x7/8" Hex. Hd. Scr.
94	3/8–16 x3/8" Soc. Set. Scr.
100	Belt
101	#4 x3/16" Drive Screw
102	Speed Dial
103	Upper Guard
108	1/4"–20 Wing Nut
109	Lower Guard
110	Motor Pulley, Including:
111	5/16–18 x5/16" Soc. Set Scr.
112	Gear Box Pulley, Including:
113	5/16–18 x5/16" Soc. Set Scr.
114	5 x5 x40 Key
118	1/4–20 x3/4" Hex. Hd. Scr.
119	1/4" Split Lockwasher
121	#10–32 x7/16" Rd. Hd. Scr.
122	Cover Assembly R.H., Including:
126	3/8–16 x7/8" Hex. Hd. Scr.
127	3/8" Split Lockwasher
128	Statjonary plate
129	Bracket
130	3/8"–16 x1–3/4" Screw
131	1/4"–20 x3/4" Set.
132	5/16"–18 x5/8" Set.
133	Bracket–R.H.
134	Slide Way
135	Bracket
137	3/16" Washer
138	3/16" x24 x3/4" Rd. Hd. Scr
139	Wiper
140	Retainer
141	1/4" Washer
142	1/4" x20 x5/8" Hex. Hd. Scr
144	Guide
145	5/16"–18 x5/8" Set
145	5/16"–18 Hex. Jam Nut
146	Washer
147	Bearing
148	Special Screw
149	Bearing
150	Special Screw
151	Special Screw
155	Bracket–L.H.
158	3/8"–16 x2–1/2" Screw
159	3/8 x16 x7/8" Hex. Hd. Scr.
160	3/8" Split Lockwasher
161	Bracket
165	3/16"–24 x1/2" Screw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REPLACEMENT PARTS

Ref. #	Description
161	Bracket
162	3/8–16 x3/8" Soc. Set Scr.
165	#10–32 x7/16" Rd. Hd. Scr.
166	Cover Assembly L.H. including:
*	Not shown Assembled
190	3/8–16 x1–1/4" Hex Hd. Scr.
191	Special Washer
192	Vise Jaw Bracket
193	3/16 x1–1/8" Roll Pin
194	Bracket
195	Acme Nut Assembly, including:
196	Button
197	Retainer
198	13/64 x3/8 x1/32" Washer
199	#10–32 x1/4" Rd. Hd. Scr.
200	Block
201	Vise Jaw Bracket
202	Special Washer
203	3/8–16 x1–1/2" Hex Hd. Scr.
204	1/2–13 x1–1/2" Hex Hd. Scr.
*	Dash Pot Assembly, consisting of:
210	Cap
211	Oil Seal
212	Gasket
213	Rod
214	Special Washer
215	Pistom
216	Seal
217	"O" ring
218	5/16–18 Hex Jam Nut
219	Tube Assembly
220	Tube fitting
221	Tube fitting
222	Tube fitting
223	Retaining ring
224	Pivot shaft for Dash Pot
225	3/8" Split Lockwasher
230	5/16" Split Lockwasher
231	5/16–18 x3/4" Hex. Hd. Scr.
232	Motor Plate
233	Rear Pivot Bracket
234	Special Soc. Set Screw
235	1/2"–13 Hex Nut
236	3/8"–16 x1–3/4" Hex Hd. Scr.
237	3/8" Split Lockwasher
238	1/4–20 x3/4" Hex Hd. Scr.
239	1/4" Split Lockwasher
240	3/8–16 x3/8" Soc. Set Scr.
241	Strap
242	1/4" Split Lockwasher
243	1/4–20 x3/4" Hex Hd. Scr.
244	Special Washer
245	Knob Assembly, including:
246	1/8 x3/4" Roll Pin
247	Table
248	1/4 x1–1/2" Roll Pin
249	Handle
250	Collar, including:
251	5/16–18 x5/16" Soc. Set Scr.
252	Acme Screw Assembly including
253	3/16 x1–1/4" Roll Pin
254	Work Support
255	3/8" Split Lockwasher
256	3/8–16 x1" Hex Hd. Scr.
257	5/16–18 x1" Sq. Hd. Set Scr.
*	Adj. Stock Stop. Consisting of:
258	Shaft
259	Stop Bracket
260	Spring
261	7/16" dia. Steel Ball
262	Retaining Ring
265	Collar, including:
266	5/16–18 x3/8" Soc. Set Scr.
267	Brass Plug
268	3/8–16 x3/8" Soc. Set Scr.
269	Pivot Shaft
270	Spacer
271	Cork Gasket
272	Coolant Pan w/Coupling
273	3/8" Split Lockwasher
274	3/8"–16 x5" Hex Hd. Scr.
275	Knob
276	Plate Weld Assembly
277	Spring
278	3/8–16 x1" Hex. Hd. Scr.
279	Special Washer
280	Cork Gasket
281	Base Assembly
282	3/8" Split Lockwasher
283	3/8"–16 Hex Nut
284	3/16 x1–1/2" Roll Pin
For	all 24v. Low voltage contral mach.
300	Nameplate
301	Start Switch
302	Stop Switch
303	Limit Swith
**	Cover for Limit Switch
**	#10–32 x1" Rd. Hd. Scr. for cover
306	Insulator
307	Limit Switch Bracket
308	1/4" Split Lockwasher
309	1/4–20 x3/4" Hex Hd. Scr.
For 115 Volt Manual Toggle Switch mach.	
315	Box Cover
316	#4–36 x3/8" Rd. Hd. Scr.
317	Rod
318	Knob
319	#6–32 x1/4" Rd. Hd. Scr.
320	Duplex Outlet
321	3/32 x1" Cotter Pin
322	Switch w/Wire Clamp
323	#10–32 x3/8" Rd. Hd. Scr.
324	Box
325	Luck Nut
326	Clamp
327	Cable
328	Terminal
329	1/4" External Tooth Lockwasher
330	1/4"–20 Hex Nut
331	1/4–20 x3/4" Dex Hd. Scr.
332	1/4" Split Lockwasher
333	Bracket
334	Power Cord
335	Nameplate
*	Not Shown assembled
**	Not shown