MAKSIWA®

SF.35.MI

Band Saw 14” - 1 3/4 HP - 1 Phase

INSTRUCTION MANUAL

Attention: Read this manual before using the machine.

Greetings,

Congratulations, you jJust purchased the SF.35.MI Maksiwa Band Saw, which was developed with the Maksiwa's highest standards of technology and Quality. Your SF.35.MI Maksiwa Band Saw allows you to have the highest productivity in woodworking. It should be noted that to use this machine with maximum efficiency, you should read and understand the instructions in this manual.
Visit our website to know about our launches and other product lines and Technical Assitance:
www.maksiwa.com/usa
tech@maksiwa.com

Attention!: The machine must be inspected immediately upon arrival. If the machine has been damaged during transport, or if any parts are missing, a written record of the problems must be submitted to the forwarding agent and a damage report compiled. Also be sure to notify your supplier immediately.

For the safety of all personnel, it is necessary to study this manual thoroughly before assembly and operation. This manual must be kept in good condition and should be considered as part of the machine. Furthermore, the manual must be kept to hand and within the vicinity of the machine so that it is accessible to operators when using, maintaining or repairing the machine.

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MAKSIWA®

Contents

1 General

1.1 Symbol legend

Important technical safety instructions in this manual are marked with symbols.
These instructions for work safety must be followed.

In all these particular cases, special attention must be paid in order to avoid accidents, injury to persons or material damage.

The symbols below advise the correct safety procedures when using this machine.

1.2 Information on the operating instructions

This manual describes how to operate the machine properly and safely. Be sure to follow the safety tips and instructions stated here as well as any local accident prevention regulations and general safety regulations. Before beginning any work on the machine, ensure that the manual, in particular the chapter entitled Safety" and the respective safety guidelines, has been read in its entirety and fully understood. This manual is an integral part of the machine and must therefore be kept in the direct vicinity of the machine and be accessible at all times. If the machine is sold, rented, lent or otherwise transferred to another party, the manual must accompany the machine.

1.3 Liability and warranty

The contents and instructions in this manual have been compiled in consideration of current regulations and state-of-the-art technology as well as based on our know-how and experience acquired over many years. This manual must be read carefully before commencing any work on or with this machine. The manufacturer shall not be liable for damage and/or faults resulting from the disregard of instructions in the manual. The text and images do not necessarily represent the delivery contents. The images and graphics are not depicted on a 1:1 scale. The actual delivery contents are dependent on custom-build speci cations, add-on options or recent technical modi cations and may therefore deviate from the descriptions, instructions and images contained in the manual. Should any questions arise, please contact the manufacturer. We reserve the right to make technical modi cations to the product in order to further improve user-friendliness and develop its functionality.

1.4 Copyright

This manual should be handled con dentially. It is designated solely for those persons who work on or with the machine. All descriptions, texts, drawings, photos and other depictions are protected by copyright and other commercial laws. Illegal use of the materials is punishable by law.
This manual, in its entirety or parts thereof, may not be transferred to third parties or copied in any way or form, and its contents may not be used or otherwise communicated without the express written consent of the manufacturer.
Infringement of these rights may lead to a demand for compensation or other applicable claims. We reserve all rights in exercising commercial protection laws.

1.5 Spare parts

! Attention: Non genuine, counterfeit or faulty spare parts may result in damage, cause malfunction or complete breakdown of the machine.

If unauthorized spare parts are fitted into the machine, all warranty, service, compensation and liability claims against the manufacturer and their contractors, dealers and representatives shall be rejected. Use only genuine spare parts supplied by the manufacturer. Unless, specified by manufactor.

1.6 Disposal

Attention!: Used electrical materials, electronic components, lubricants and other auxiliary substances must be treated as hazardous waste and may only be disposed of by specialised, licensed firms.

If the machine is to be disposed of, separate the components into the various materials groups in order to allow them to be reused or selectively disposed of. The whole
structure is made of steel and can therefore be dismantled without problem. This material is also easy to dispose of and does not pollute the environment or jeopardize public health. International environmental regulations and local disposal laws must always be complied with.

2 Safety Regulations

For your own safety, read all of the instructions and precautions before operating tool.

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
- Wear protective hair covering to contain long hair.
- Wear safety shoes with non-slip soles.
- Wear safety glasses complying with the Standard of your country. Everyday glasses have only impact resistant lenses. They are NOT safety glasses.
- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

2.1 Workspace

- Keep work area clean. Cluttered work areas invite accidents.
- Do not use power tools in dangerous environments. Do not use power tools in damp or wet locations. Do not expose power tools to rain.
- Work area should be properly lighted.
- Keep visitors at a safe distance from work area.
- Keep children out of workplace. Make workshop childproof. Use padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.
- Keep power cords from coming in contact with sharp objects, oil, grease and hot surfaces.

2.2 Maintainence

- **Always unplug tool prior to inspection.**
- **Consult manual for specific maintaining and adjusting procedures.**
- **Keep tool lubricated and clean for safest operation.**
- **Remove adjusting tools. Form habit of checking to see that adjusting tools are removed before switching machine on.**
- **Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.**
- **Check for damaged parts. Check for alignment of moving parts, binding, breakage, mounting and any other condition that may affect a tool's operation.**
- **A guard or other part that is damaged should be properly repaired or replaced. Do not perform makeshift repairs. (Use parts list provided to order replacement parts.)**
- **Maintain proper adjustment of rip fence and blade guard.**
- **Never adjust saw while running. Disconnect power to avoid accidental start-up.**
- **Have damaged or worn power cords replaced immediately.**
- **Keep blade sharp for efficient and safest operation.**

2.3 Machine Safety

The following is a list of safety precautions you must consider when using a bandsaw:

ALWAYS REMEMBER TO DISCONNECT THE POWER TO THE BANDSAW WHEN MAKING REPAIRS OR ADJUSTING BLADES AND GUARDS.

ALWAYS REMEMBER TO READ THROUGH THE MACHINE INSTRUCTIONS SUPPLIED.

• Eye and ear protection are required when operating a Bandsaw. Dust extraction and respiratory PPE are highly recommended.

• Do not wear gloves, loose clothing, jewellery, or any dangling objects when operating a bandsaw.

• Do not allow children to operate the machine.

• All guards must be in place and fully operational. If a guard seems to be missing or damaged, adjust, replace or repair immediately.

• Disconnect the power to the bandsaw when making repairs or adjusting blades and guards.

• Remember to check the blade tension after a new blade has been 'working' for 30-60 minutes. The blade may 'stretch' slightly from new and the tension becomes slack.

• Hands and fingers must be kept clear of the blade, always use push blocks and push sticks when feeding small pieces into the blade.

• Use only the recommended blade size and type for the machine- see page 17-18 for recommendations.

• Ensure all blades are sharp and in good condition.

• The blade guard/guide set must be lowered to approximately 3/4"(20mm) above the workpiece.

• Check that the blade is tensioned and tracked correctly before turning the machine on.

• Never cut pieces smaller than the table insert size.

• Do not attempt to cross cut round timber free hand. Clamp to mitre fence or make a jig to keep the work piece stable.

• Long material should be supported at the same height as the saw table.

• To avoid contact with a coasting blade, do not reach into the cutting area until the blade comes to a full stop.

• Make sure the blade is not in contact with the material when you start the saw.

• Never leave the machine unattended when it is running.

• Keep the table top and surrounding work area free from excessive dust and debris to help prevent slipping or tripping.

• Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts.

• Do not overreach or use excessive force to perform any machine operation.

3 What's in the box

Fig A A

Adjustable Feet for Stand and Bolt to Hold Machine to Base

Fig B B

Push Stick, Push Stick Fixing Bolt and Mitre Fence

Fig CC

Tool Kit and Stand Fixing Bolts

Fig DD

Table Dust Outlet, Hose Ring Clips, Table Insert and Blade Guide Rise and Fall Handwheel

Fig E

Dust Outlet Screws

Fig F

Extraction Hose

Fig G

Cast Iron Table with Fence Rail

Fig H

Fence and Fence Lock Assembly

Fig I

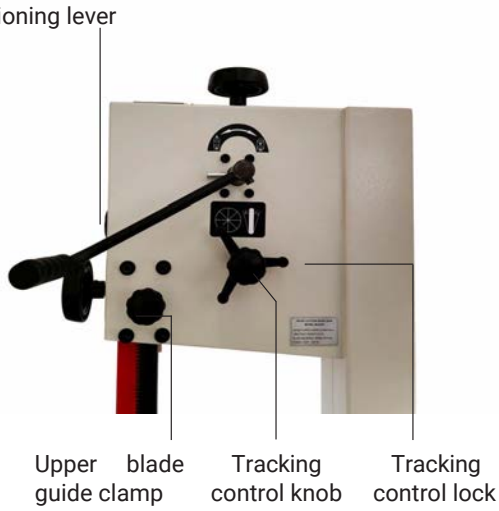
Self Adhesive Scale Strips for Fence Rail

Fig J

Bandsaw Stand Panels

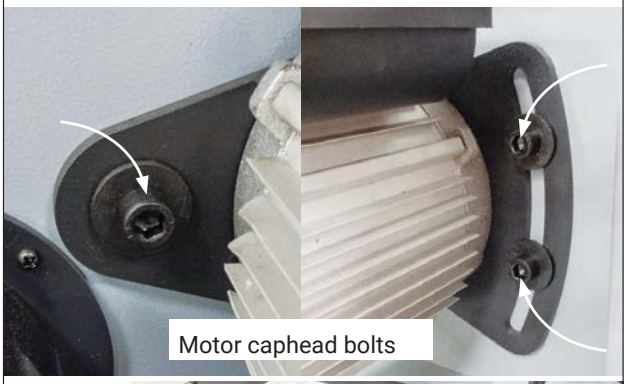
4 Anatomy

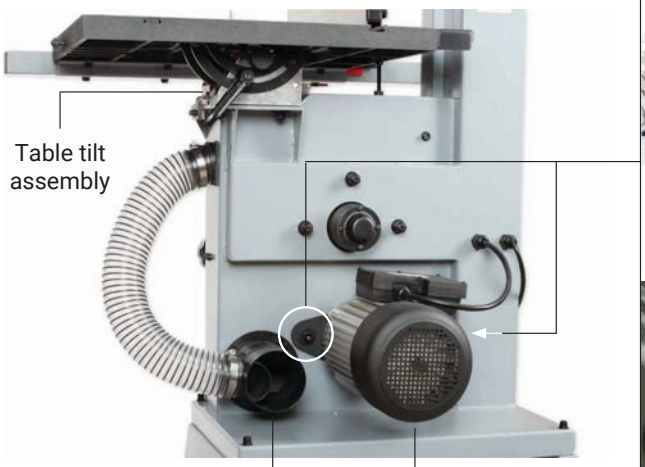

Blade tensioning wheel
Push stick
Wheel tensioning window
Blade tension pointer
ON/OFF buttons
Fence clamp handle
Lower wheel door
Main saw frame
Upper door locking knob
Upper blade guide adjusting wheel
Upper blade guide and guard
Fence
Mitre fence
Cast iron table
Fence guide rail
Dust extraction hose
Lower door locking knob
Stand
MAKSIWA
STOP



Tension the Drive Belt

Loosen the three caphead bolts holding the motor, pivot the motor to increase or to decrease tension on the drive belt.
Note: Check the tension on the belt, there should be a 1/2 inch depression.





5 Assembly

Stand Assembly

1. Fix the adjustable feet to each stand end panel, (fig 01).

Fig 01

2. Fix the stand side panels to the end panels using the eight bolts, washer and nuts, (fig 02-05).

Fig 02-03

Fig 04-05

Attaching Stand to Bandsaww

1. Lay the bandsaw on its back to attached the stand assembly to bandsaw with the four stand Hex bolts and washers, (fig 06-07-08).

FIG 06-07-0808

2. Lift bandsaw vertical, (fig 09).

THE BANDSAW IS A HEAVY PIECE OF EQUIPMENT, IT IS ADVISABLE TO GET ASSISTANCE.

TWO MAN ASSEMBLY REQUIRED.

Fig 09 09

3. Attach the dust outlet below the table with the four screws provided, (fig 10).

Fig 10

4. Attach each end of the hose to the table's dust extraction outlet's using the two ring clips, (fig 11).

Fig 11-12

5. Line-up the holes to the underside of the cast iron table with the ones in the trunnions and secure in place with four button head Hex bolts/washers, (fig 13-14).

Fig 13-14

6. Locate the table insert and place it into the centre of the table, (fig 15).

Fig 15

7. Find the fence locking assembly and slide it into position on the fence rail as shown, (fig 16).

8. Loosen the two lift and shift handles on the fence locking assembly. Line-up the 'T' slot to the base of the fence and slide it over the mounting plate to the desired position. Nip-up the lift and shift handles to secure the fence, (fig 17-18).

Fig 16-17-18

9. Locate the Rise and Full handle wheel, loosen the two grub screws around the mounting boss. Line up the grubs crews with the machined flats on the drive shaft and slide the unit on. Nip-up the screws to secure in place, (fig 19-20).

Fig 19-20

10. Find the threaded hole to the side of the bandsaws column. Locate the push stick holding screw and screw it into the column, hook the push stick over the screw, (fig 21-22).

Fig 21-22-22

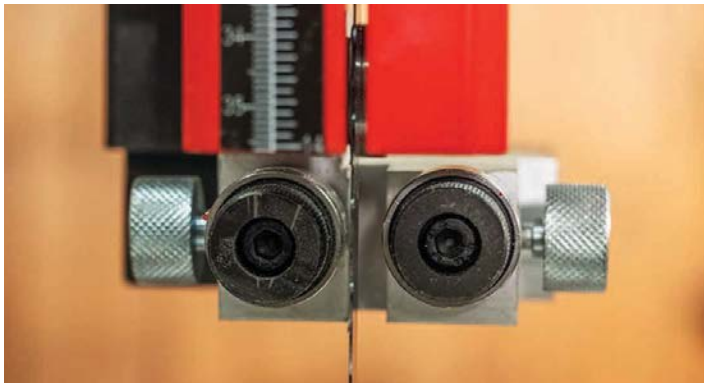
6 SettUp

Blade Tension

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

Ensure that all guide bearings are well clear of the blade!, (fig 23).

Fig 23-24



Position the tension lever down in full tension position, (see fig 24).

• Before altering blade tension ensure that the blade is roughly positioned in the middle of the wheel, you will need to lower the top wheel slightly by using the tension lever to do this, (fig 25).

• Turn the blade tension knob clockwise to tension the blade whilst rotating the top wheel slowly at first by hand. A gauge at the front of the upper wheel shows either tension on or tension off, (fig 26).

• The best place to check blade tension is on the left hand side of the bandsaw. Around 1cm of blade movement is recommended, (fig 27).

• Changes in blade width will have an effect on blade tension. Keep in mind that too little blade tension can cause blade breakage.

• After a period of use it is recommended to recheck the blade tension and possibly readjust as bandsaw blades can stretch slightly in use.

TIP:I If the bandsaw is to sit idle for a period of time, place the tension lever in partial tension position; this will help prevent blade fatigue and tyre deformation, and save wear on bearings and band wheels.

Fig 25

Fig 266

Fig 27

Blade Tracking

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

• Do not adjust blade tracking with the machine running. “Tracking” refers to how the blade is positioned on the wheels whilst running.

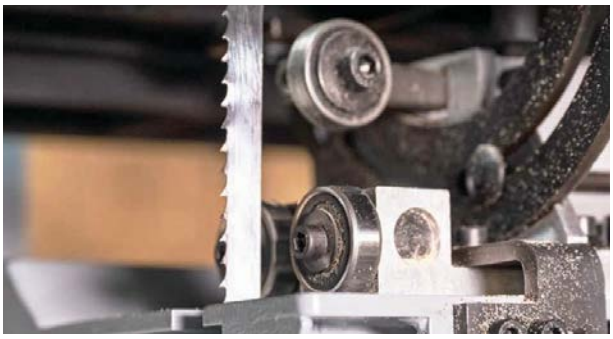
• The blade should track approximately in the centre of both wheels, as shown in (fig 28) Tracking on the Bandsaw should be checked periodically, included as part of every blade change.

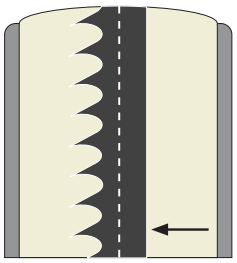
• The blade must be properly tensioned before adjusting blade tracking. Make sure blade guides bearings are opened up, backed off and are well clear of the blade, (fig 29)

• Open the upper door and rotate the upper wheel slowly at first clockwise by hand. Observe the position of the blade on the wheel - it should be in the centre, (fig 30-31).

Fig 28

Fig 29-30-31





Blade approximately centred

• If the blade tends to shift to one side or the other of the wheel, slight adjustment will need to be made, start by loosening the locking knob, (fig 32).

• If the blade is tracking toward the front edge of the wheel, rotate the tracking knob clockwise – the upper wheel will tilt toward the back and the blade will move to the centre of the wheel. If the blade is tracking toward the back edge of the wheel, rotate the tracking knob counterclockwise: the upper wheel will tilt toward the front and the blade will move toward the centre of the wheel, (fig 33).

Fig 32

Fig 33

• **IMPORTANT:** This adjustment is sensitive; perform it in small increments and give the blade time to react to the changes, as you continue to rotate the wheel.

• When the blade is tracking properly at the centre of the wheel, re-tighten the locking knob, (fig 34).

• Turn on the saw and verify proper tracking while the machine is running.

• If further tracking adjustments are needed, disconnect from power, and repeat instructions above.

Fig 34

Setting Upper and Lower Blade Guides

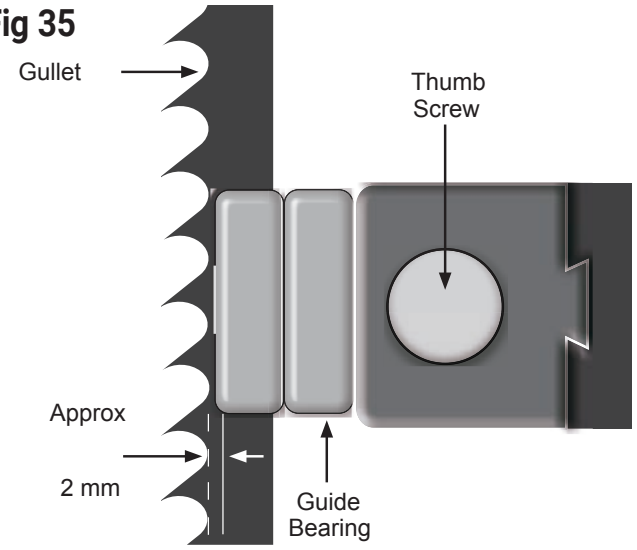
Both top and bottom bearing blade guides will be set in exactly the same position.

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

• Blade must be tensioned and tracked properly.

• Loosen thumb screw and move guide block by turning the knob so that the front face of the guide bearings are approximately 2mm behind the gullet (curved area at base of tooth) of the blade, tighten thumb screw, (fig 35).

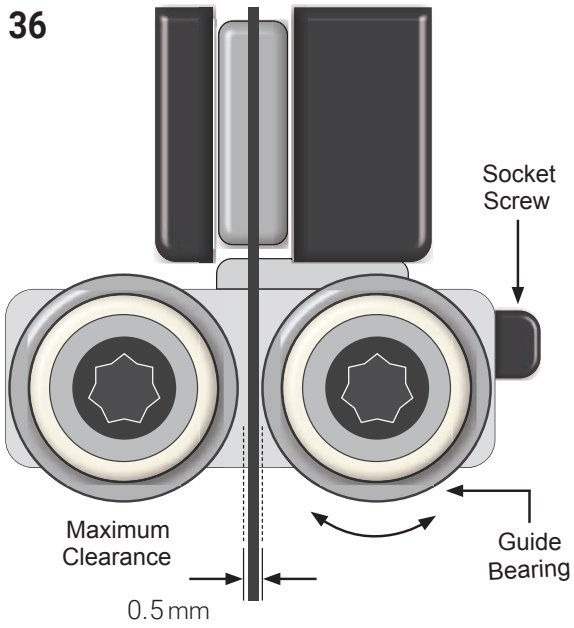
Fig 35



• Loosen the socket screw and position each guide bearing so that it is no more than 0.5mm away from the blade, very close but not quite touching the blade. A quick way to set this distance is to use a piece of breakfast cereal packet cardboard between the blade and bearing, which is approximately 0.3mm thick, (fig 36).

• Tighten socket screw when adjustment is satisfactory.

Fig 36

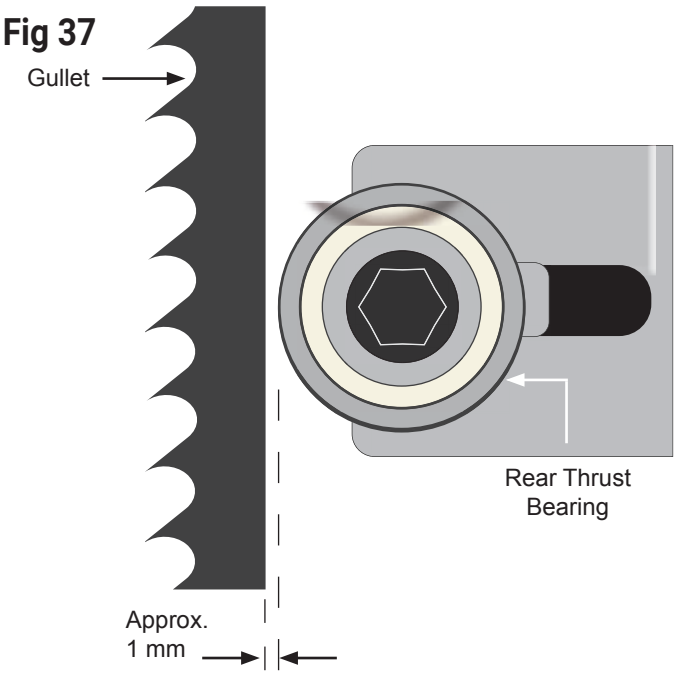


Thrust Bearing, Upper and Lower

The thrust bearing supports the back edge of the blade during operation, and is set so that the blade will contact it only when the blade is under pressure during a cut

• Loosen thumb screw and turn knob to move the thrust bearing in or out until the bearing is approximately 1mm behind the blade, tighten thumb screw, (fig 37).

Fig 37

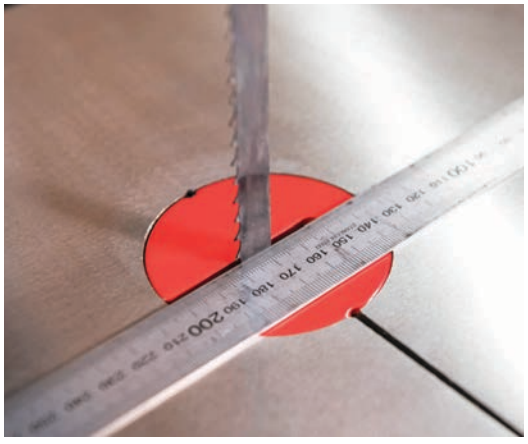


Aligning the Table to the Bladele to the Blade

• Place a straight edge along the side of the blade (width blade or wider), with very light pressure (do not deflect the blade). The straightedge should contact both the front and back of the blade but sit between the teeth, (fig 38).

• Measure carefully with a fine rule from the straightedge to the edge of the mitre slot, do this at the front and back of the table; the distance should be the same, (fig 3).

Fig 38-3



• If the mitre slot is not aligned with the blade, slightly loosen the four screws holding the trunnions to the table, (fig 4).

• Nudge the table as needed, until the mitre slot is aligned with blade (distances are the same front to back), (fig 41).

• Tighten trunnion screws. **(NOTE: After this adjustment, the alignment of fence to blade may need to be re-checked. See "Aligning Fence to Blade section"**

Fig 40-41

Squaring the Table to the Blade

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

• Loosen table locking knobs and tilt table to the left (down flat) until it rests against the table stop screw (fig 42).

• Use a square placed on the table and against the left hand side of the blade (fig 43) verify that the table is 90 degrees to the blade. Make sure the table insert is level with the table surface or removed to ensure an accurate reading.

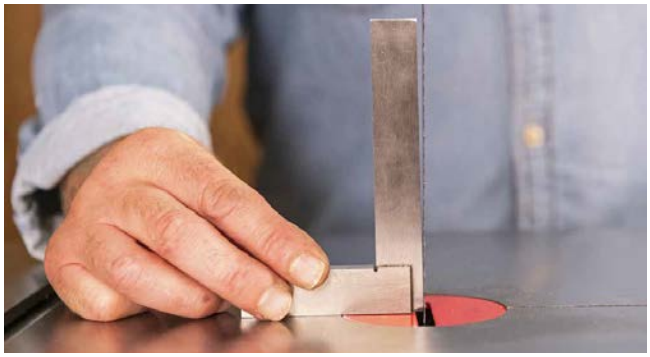
• If an adjustment is necessary, tilt the table and tighten the table locking knobs.

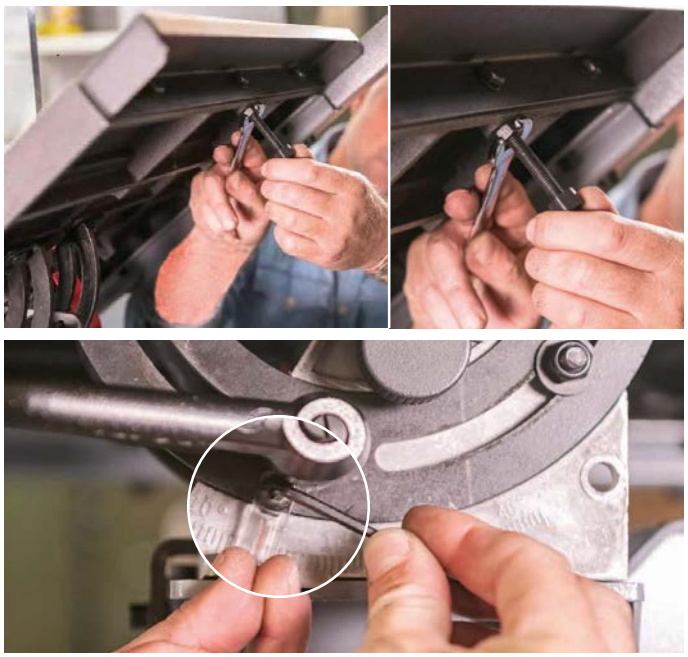
• Loosen the lock nut and turn the table stop screw left or right to raise or lower the stop, rasing or lowering the table height when in the down position, tighten lock nut down against the trunnion/table to hold table stop screw in place, (fig 44).

• Unlock the table and tilt it back on to the table stop screw to confirm the table is 90 degrees to the blade. Repeat this process as necessary until the table is at 90 degrees to the blade.

• Adjust the pointer indicates zero, (fig 45).

Fig 42-43-44-455





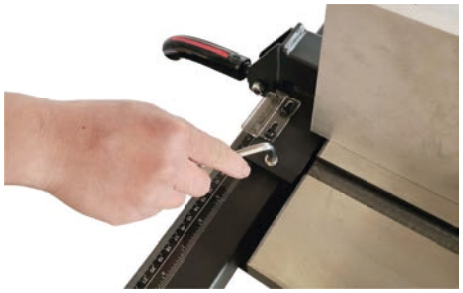
Aligning the Fence to the Blade

• Line up the fence with the edge of the tables mitre fence slot and press down the locking handle, (fig 46).

• If the fence is out of alignment, loosen the four Hex screws either side of the fence clamping assembly, (fig 47).

• Adjust the fence until its in alignment with the mitre fence slot, retighten the Hex screws, (fig 48).

Fig 46-47-48-48



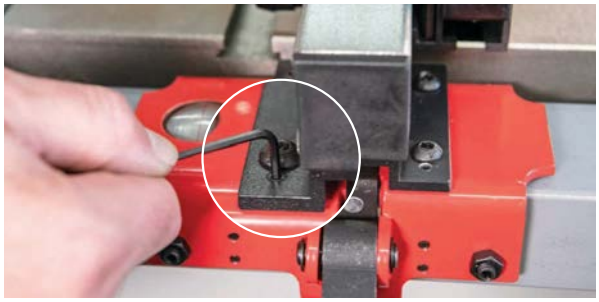
Squaring the Fence to the Table

• Check to see if the fence is square to the table,(fig 49).

• IIf not square, adjustments are made by firstly slackening the four fence bolts, (fig 50).

• Adjust the four alignment grubs crews until the fence is square. Nip-up the fence bolts, (fig 51).

Fig 49-50-51



Setting Fence Scale -

Once the table and fence are squared and aligned you can attach the self adhesive scale to the fence rail.

• Attach the fence to the fence rail and slide it over to lightly touch the blade, ensure that the blade to fence contact is very light - do not deflect the blade.

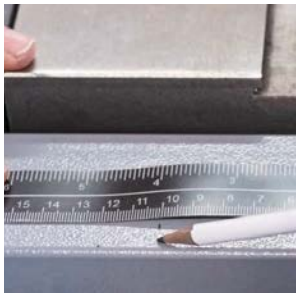
• Slide the scale under the fence to bring the zero mark to the red line in the lens, (fig 52).

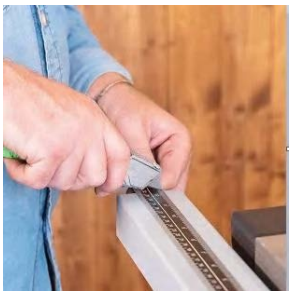
• Make a pencil mark at any given point, (fig 53).

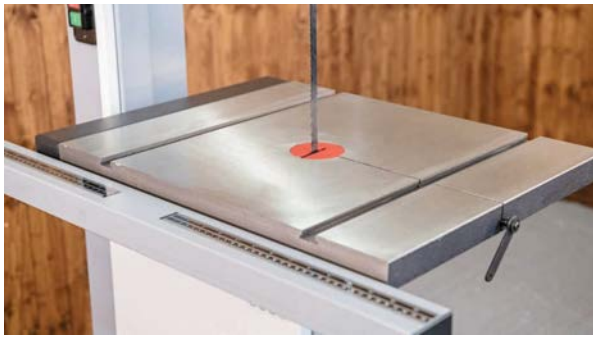
• Remove the fence then stick the scale to the fence rail bringing it back to the pencil mark and using a sharp knife trim off excess scale, (fig 54).

• Repeat for both right hand and left hand fence use,(fig 55).

Fig 52-53-54-5554-55

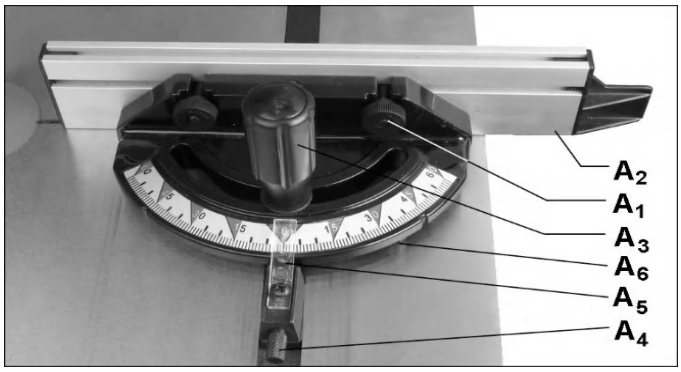






Mitre Fence

Fig 56



1. Slide miter gauge into table slot from front edge of table.
2. Loosen knobs (A1) and install miter fence (A2) onto gauge body. Position fence as needed and tighten knobs.
3. Loosen handle (A3), pull out pin (A4), and rotate body to desired angle. Tighten handle.

The miter gauge has positive stops at 0 (90º), and 45º left and right, located beneath the gauge body.

4. Use a square to verify that miter fence is square to blade when set at 90 on scale
5. If miter gauge is not square to blade, loosen handle (A3) and adjust until square. Tighten handle.
6. Verify that pointer (A5) shows 90 . If it does not, loosen screw and shift pointer to 90 . Tighten screw.
7. Adjust a stop if needed by loosening hex nut and rotating screw (A6). Retighten nut. The top channel on miter fence will accommodate accessory items, such as hold-downs. Remove end cap and install t-bolts into the channel.

General use / operationtion

The following section contains basic information, and is not intended to cover all possible applications or techniques using the Bandsaw. Consult published sources of information, acquire formal training, and/or talk to experienced Bandsaw users

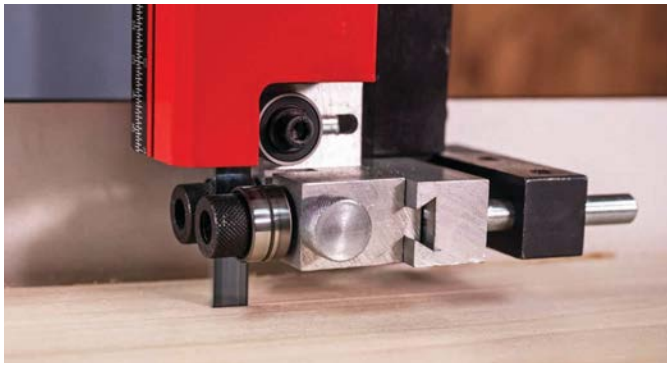
to gain understanding and knowledge of bandsaw operations.

Firstly ensure that you have the right blade fitted for the intended cut - see the blade selection guide on pages 17-18.

• Make sure the blade is adjusted correctly tensioned and tracking, and that upper and lower guide bearings and thrust bearings are set in proper relation to the blade. Adjust guide post so that the guide bearings are just above the workpiece, about ” (20mm) allowing minimum exposure to the blade but maximum support during the cut,(fig 59).

• If using the fence, move it into position and lock it to the fence rail. If you are using the mitre gauge for a crosscut, the rip fence would usually be moved safely out of the way, (fig 60-61).

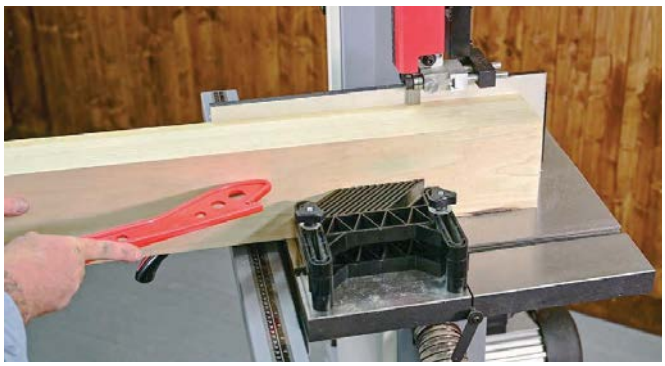
Fig 59-60-61



• Turn on the bandsaw and allow a few seconds for the machine to reach full speed.

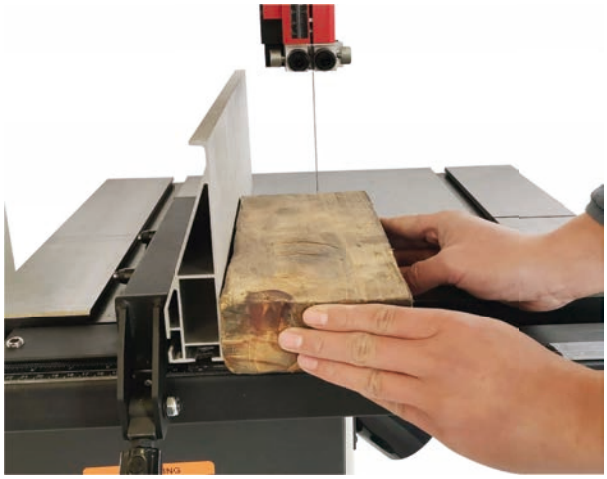
• Whenever possible, use a push stick, hold-down, jig, or similar device while feeding timber, to prevent your hands getting too close to the blade, (fig 62-63).

Fig 62-63



• Place the straightest edge of the workpiece against the fence for a rip cut; or against the mitre gauge for a crosscut. Push the workpiece slowly into the blade, while also keeping it pressed against the fence or held against the mitre gauge. Do not force the workpiece into the blade, always feed through at a slow and steady pace, (fig 64-65).

Fig 64-65



Tips:

• Make relief cuts whenever possible. A relief cut is an extra cut made through the waste portion of a workpiece up to the layout line. When that intersection is reached by the blade while following the layout line, the waste portion comes free. This helps prevent pinching of the back edge of the blade in the cut, (fig 66).

• When cutting, do not overfeed the blade; overfeeding will reduce blade life, and may cause the blade to break.

• Stand at the corner of the machine when making rip or re-saw cuts using the rip fence, this will help ensure that the timber stays in contact with the fence for the full cut, (fig 67).

• When cutting long timber, the operator should use roller stands, support tables, or an assistant to help stabilise the workpiece, (fig 68).

Fig 66

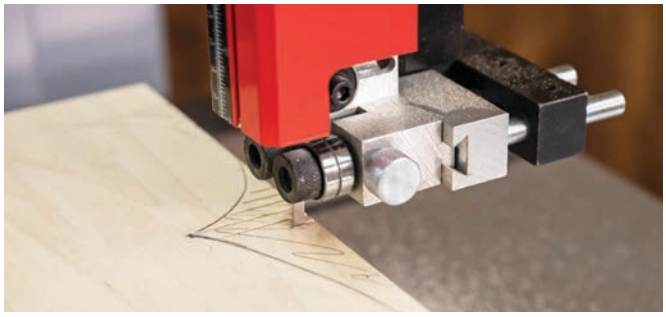


Fig 67

Fig 68

Ripping cuts

Ripping is cutting lengthwise down the workpiece, and with the grain. Always use a push stick or similar safety device when ripping narrow pieces. Rip cuts can also be made freehand" following a pencil line but you will find far more accurate results if a fence is used, (fig 69).

Fig 69

Resawing

• Resawing is the process of slicing timber to reduce its thickness, or to produce boards that are thinner than the original timber, such as veneers and book matching. The ideal blade for resawing is the widest one the machine can handle, as the wider the blade the better it can hold a straight line, a fairly course tooth (3-4 TPI) is recommended for this cut, (fig 70).

• Resawing is always performed using the rip fence, use a push stick and often a feather board to ensure straight safe cuts. Keeping your hands away from the blade, (fig 71).

Fig 70-71

Crosscutting

• Crosscutting is cutting across the grain of the timber, usually whilst using the mitre gauge to feed the timber into the blade. The right hand should hold the workpiece steady against the mitre gauge, while the left hand pushes the mitre gauge past the blade. Cross cuts can also be made freehand" following a pencil line but you will find far more accurate results if a mitre fence is used (fig 72).

Fig 72

Freehand Curve Cutting

• Curve cutting is something all bandsaws do very well in both shallow and deep timber with the correct blade installed. An ideal curve cutting blade is a 1/4" x 6 TPI - the narrower the blade the tighter curve it can cut.

• No fences are used making these cuts and usually no push sticks either so it is very important to ensure that your hands remain as far away from the blade as possible. If the timber is too small or the curve too tight then the cut is better made on a Scroll saw, (fig 73).

Fig 73

6.1 Blade Types

Choosing the Right Tooth Pitch (tpi)

3 tpi (skip form)

Used for deep cutting especially rip cuts, this blade will leave a rough sawn finish although slow feed rate and high tension will improve the finish of the cut.

4 tpi (skip form)form)

Good for general-purpose use with a degree of cutting across the grain and with the grain, a reasonable finish can be achieved with slower feed rates and good tension.

6 tpi (skip form) form)

The ideal general purpose blade suitable for cross cutting up to 150mm and ripping in sections up to 50mm thick although thicker sections can be cut using slow feed rates. This tooth form will give a clean finish and is very well suited to natural timbers.

10 tpi (regular)r)

Good for cutting plywood and MDF as well as non-ferrous metals and plastics. The finish is good when cutting natural timbers but the feed rate should be slow and maximum depth of cut should not exceed 50mm. When cutting metals reduce the speed as much as possible especially when cutting ferrous metals or cast iron.

14 tpi (regular))

A very clean cutting blade for plywood, plastics and MDF although too fine for natural timbers unless they are very thin sections (sub 25mm thick). The 14tpi blade is very good to use on slow speeds when cutting non-ferrous metals. A slow feed speed should be used at all times with a blade tooth pitch this fine.

Blade Width

Always use the widest saw blade possible; it is stronger and will withstand greater feed pressures without flexing. Consult your machine manual for the maximum and minimum blade widths that it will accept. The minimum radius of curve for each blade width is as follows:

Blade width	Minimum radius
13mm (1/2”)	63mm (2 1/2”)
10mm (3/8”)	27mm (1 1/16”)
6mm (1/4”)	19mm (3/4”)
5mm (3/16”)	13mm (1/2”)
3mm (1/8”)	10mm (3/8”)

Blade Lengthh

This is determined by your machine specification, please refer to the specification label shown

6.2 Blade Change

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY.

Removing Blade

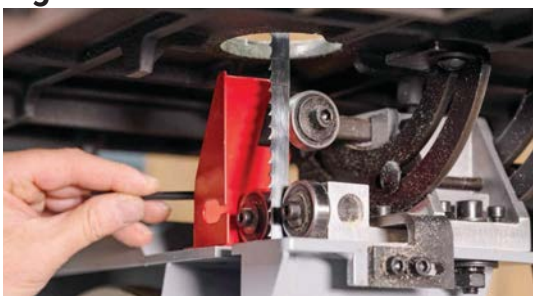
• Open the doors

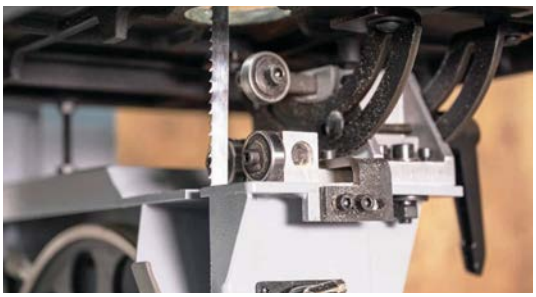
• Adjust the upper blade guide set so that it is around half way down, (fig 74).

• Remove the lower blade guards and open up/back off all blade guides so that they are clear of the blade, (fig 75-76).

Fig 74

Fig 75-76

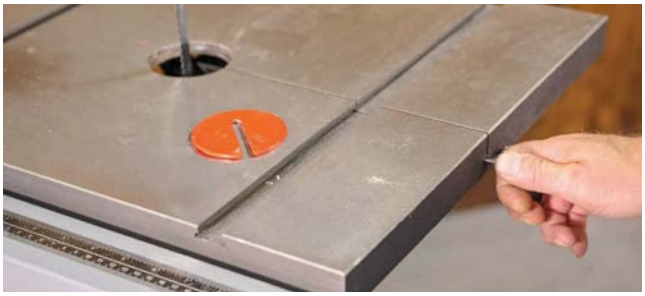




• Remove the table insert, table alignment pin and wooden plate, (fig 77-78).

• Use the tension lever to de-tension the blade, (fig 79).

Fig 77-78



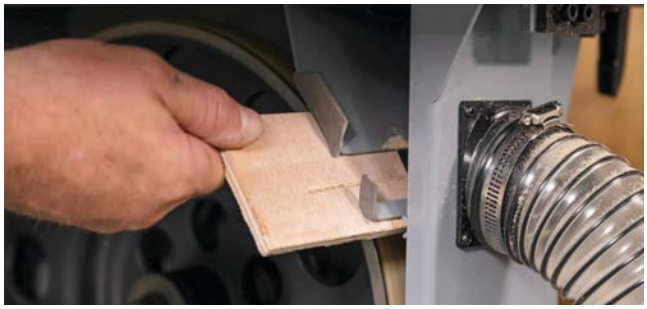
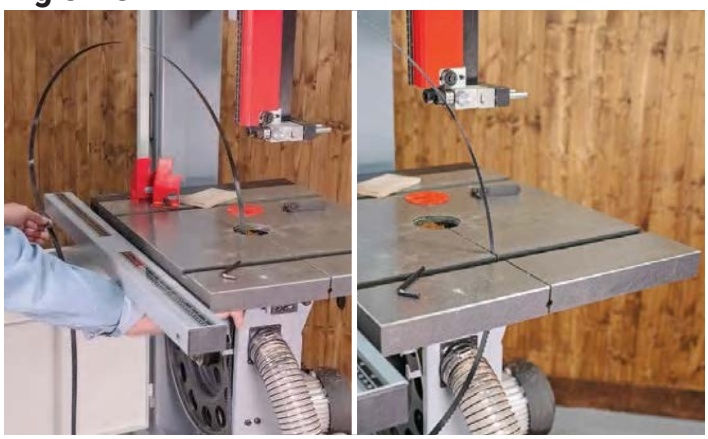


Fig 79

• Slide the blade forward clear of both wheels and through the right hand guard slot (fig 80). Bring the left hand side of the blade through the slot and around towards the right hand side of the machine then guide the blade through the table slot, (fig 81-82).

Fig 80

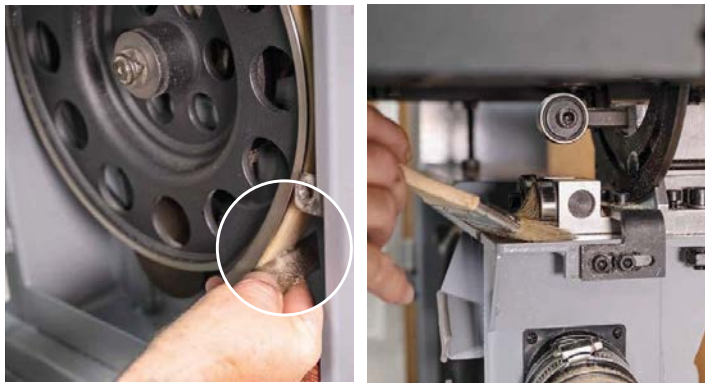
Fig 81-82



• Clean crud from the tyres and remove any small off cuts that may be around the bottom blade guide set, (fig 83-84).

• Use the blade selection guide on pages 17-18 to ensure that you have the right blade for the job!

Fig 83-84



Fitting the new Blade

• Slide the new blade through the table slot taking care not to twist or distort the blade, then guide the left hand side of the blade around toward the machine and through the slot at the spine of the machine, (fig 85-86-87).

Fig 85

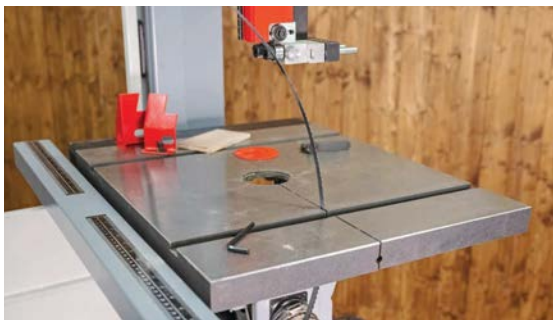
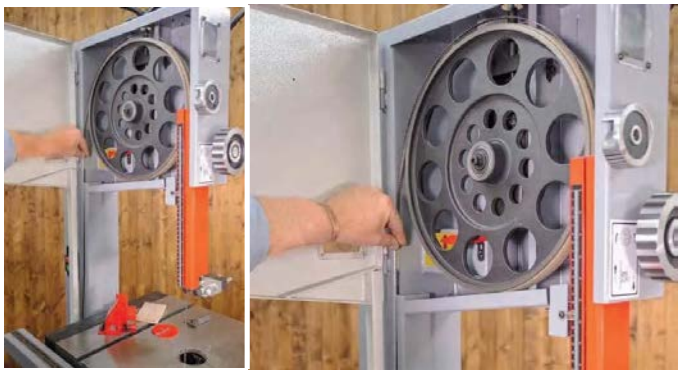


Fig 86

Fig 87



• Guide the blade through the upper blade guard and both the top and bottom blade guides positioning the blade approximately in the middle of firstly the top and then the bottom of the wheel,(fig 88).

Fig 88

• Apply blade tension using the tension lever then fine tune using the tension / tracking guide on pages 08-09-10.

• Reattached the table insert, the table alignment pin and wooden plate then close the doors.

8 Troubleshooting

Bandsaws are relatively simple machines and with all machinery regular servicing (preventative maintenance) is essential to get the best from your saw.

	'My bandsaw won't cut straight"
•	This is the most common question that you will get from bandsaw users. Usually the answer lies within the blade; poor quality blades with uneven set, the blade is blunt or damaged often only on one side, the tooth count is far too high for the material being cut -remember 2 teeth minimum and 10 teeth maximum in the work piece.
•	The fence is out of line with the blade.
•	Increase blade tension

	"My bandsaw vibrates"
•	Clean machine wheels.
•	Check blade is running correctly on wheels.
•	Check blade weld – is it in line?
•	Check machine is not on an uneven floor.

	"My bandsaw slows down when cutting"
•	Check drive belt is tensioned correctly, see page 5.
•	If cutting hard or wet material, slow your feed rate down.
•	Check blade is sharp and not too fine.
•	Make sure that when curve cutting a narrow blade is used- pages 17-18 blade and cutter types.

	"Can I cut steel on my bandsaw?"
•	No , most woodcutting bandsaws run far too fast to cut steel, even if a metal cutting blade is fitted.

	"Getting blade breakage?"
•	Blade tension too slack.
•	Blade guides misaligned.
•	Feeding timber too quickly.

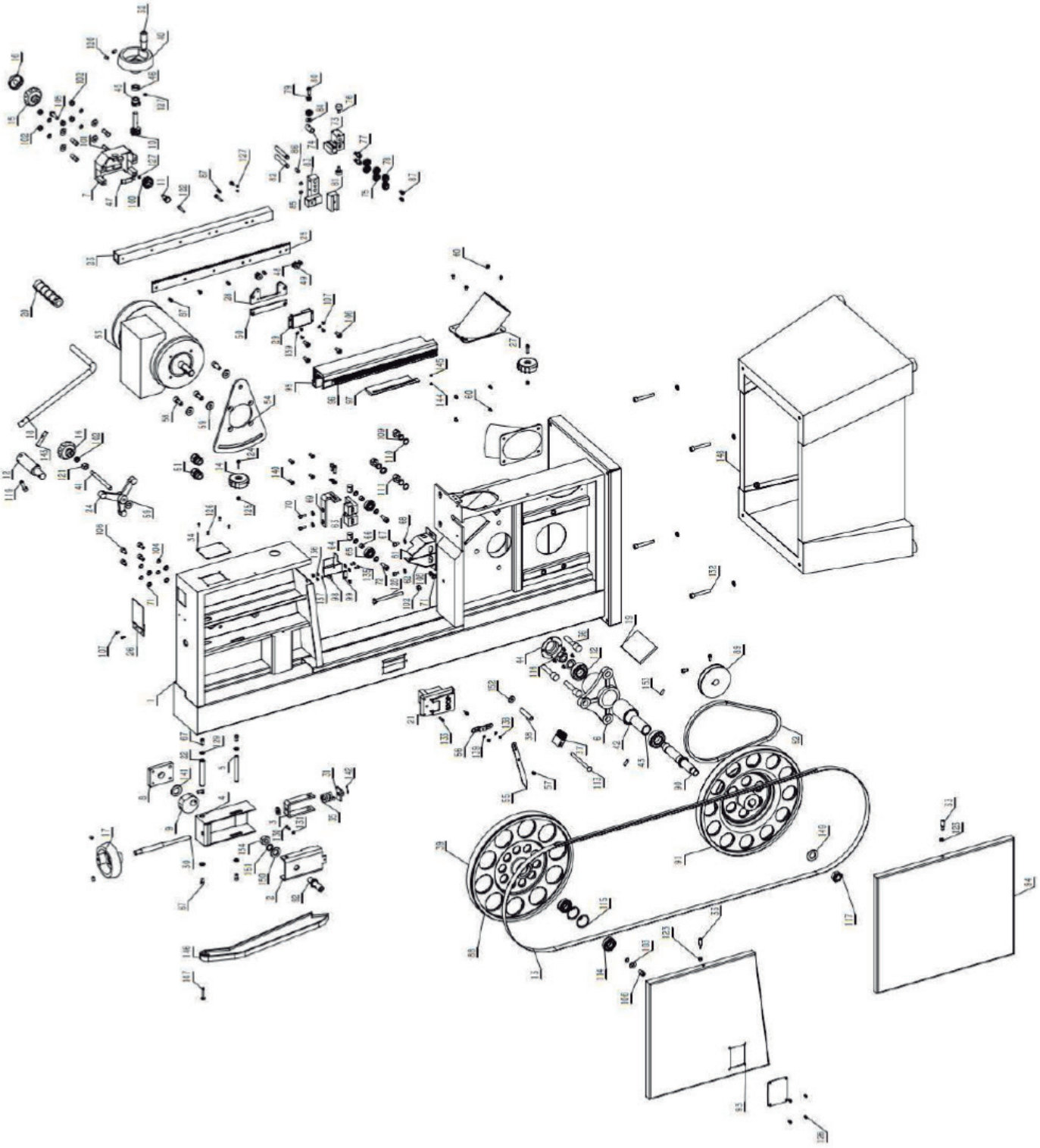
9 Maintenance

Daily -	
•	Keep the machine clean. Use extraction.
•	Check blade condition keeping a close eye out for missing teeth and small fatigue cracks.

Weekly -	**Carry out the above checks, plus**
•	Open the top and bottom wheel covers and clean out all saw dust.
•	Add in wax cast iron tables.
•	Clean impacted 'crud' from the tyres, NOTE: Do not use solvents around tires. If signs of wear or deformation occur, replace the tires.

Monthly -	**Carry out the above checks, plus**
•	Check drive belt condition and tension.
•	Ensure that all guide bearings are moving freely.
•	Check fence for alignment and squareness to blade.

8 Exploded View
Part A



Part A

ITEM	PARTS NAME	QTY
1	SAW BODY	1
2	UPPER WHEEL AXIS SEAT	1
3	U BRACKET	1
4	GUIDE PLATE	1
5	TENSION SHAFT	1
6	LOWER WHEEL BRACKET	1
7	UPPER GUIDE MOUNT	1
8	ECCENTRIC BASE	1
9	LIFTING ECCENTRIC	1
10	WORM	1
11	LIFTING GEAR SCREW	1
12	ECCENTRIC SHAFT	1
13	SAW BLADE	1
14	DOOR LOCK KNOB	2
15	ADJUSTING KNOB	2
16	ADJUSTING KNOB	2
17	ADJUSTING HANDLE	1
18	TENSION HANDLE	1
19	WOOD INSERT	1
20	TENSION HANDLE GRIP	1
21	POWER SWITCH	1
22	QUICK TENSION SHAFT	1
23	UPPER GUIDE SQUARE TUBE	1
24	ADJUSTING HANDLE	1
25	UPPER GUIDE RACK	1
26	HINGE PLATE	1
27	SIDE OUTLET	2
28	STEEL PLATE	1
29	GEAR BOX COVER	1
30	BLADE TENSION SHAFT	1
31	NUT BOARD	1
32	HANDWHEEL KNOB	1
33	ALLEN BOLT	2
34	SIGHT GLASS	2
35	SPRING	1
36	DUAL THREAD BOLT	3
37	BRUSH	1
38	SPACER BUSHING	1
39	WHEEL TYRE	2
40	HANDWHEEL	1
41	ADJUSTING HANDLE SCREW	1

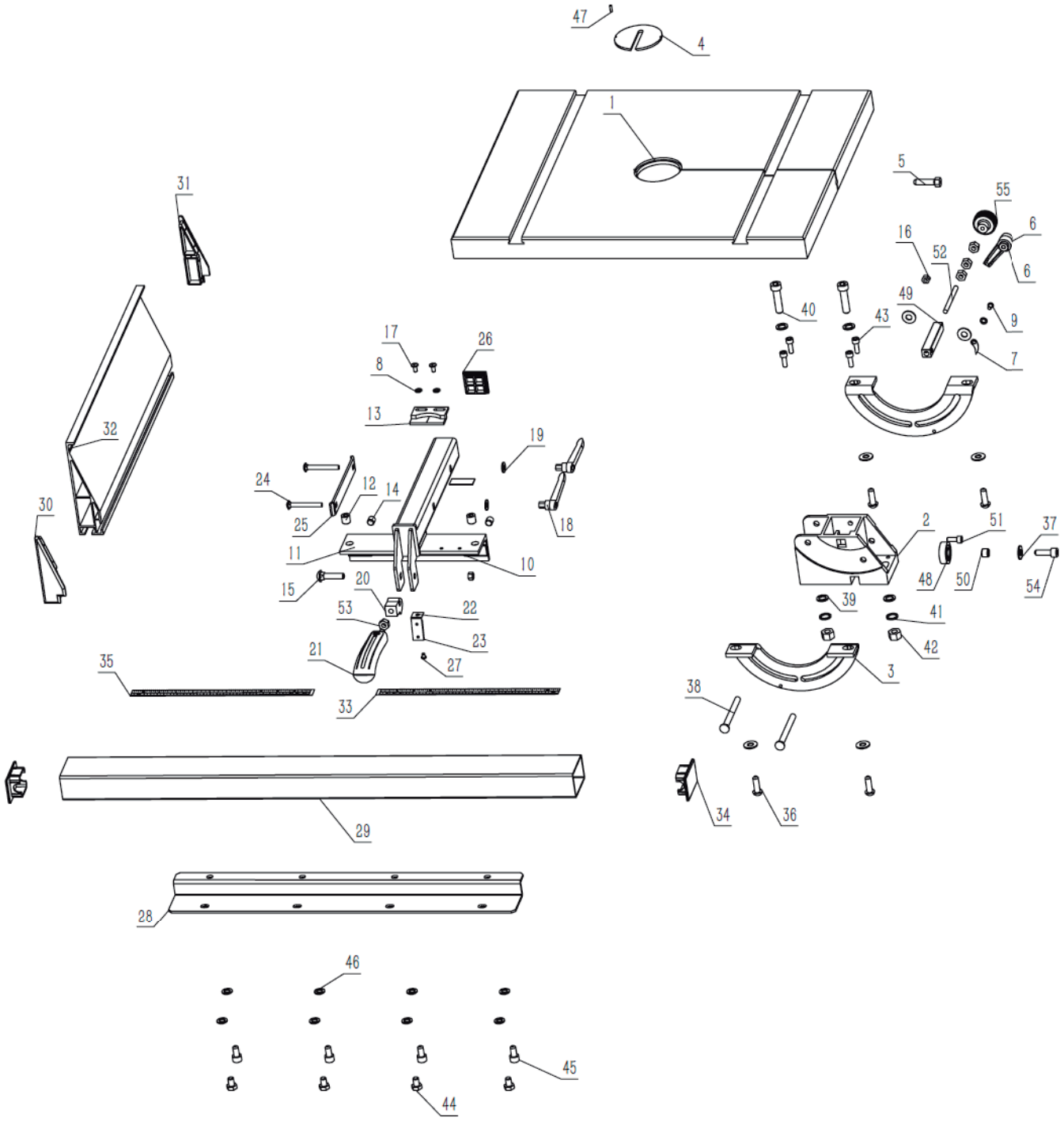
ITEM	PARTS NAME	QTY
42	SLEEVE A	1
43	SLEEVE B	1
44	COVER	1
45	BUSHING	1
46	WORM CIRCLIP	1
47	PRESS PLATE	1
48	ADJUSTABLE SPACER A	2
49	ADJUSTABLE SPACER B	2
50	STEEL PLATE	1
51	STRAIN RELIEF M20	1
52	DRIVE BELT	1
53	MOTOR	1
54	MOTOR PLATE	1
55	POINTER	1
56	ADJUSTABLE POINTER MOUNT	1
57	POINTER SCREW	1
58	HEX SOCKET CAP HEAD BOLT M10X30	3
59	BIG WASHER 10	4
60	HEX SOCKET PAN HEAD SCREW M5X8	12
61	RIGHT GUARD	1
62	LEFT GUARD	1
63	LOWER GUIDE MOUNT	1
64	BEARING NUT	2
65	BEARING 6201	2
66	SHORT BUSHING, BEARING	2
67	HEX SOCKET CAP HEAD BOLT M6X12	8
68	WASHER 6	6
69	SLIDE PLATE, LOWER GUIDE	1
70	HEX SOCKET CAP HEAD BOLT M6X16	4
71	WASHER 8	13
72	HEX SOCKET CAP HEAD SCREW M8X30	2
73	MOUNTING BASE, UPPER GUIDE	1
74	BEARING NUT	1
75	BEARING 61900	5
76	LOCKING NUT	2
77	ECCENTRIC SHAFT, UPPER GUIDE	2
78	BEARING BUSH	2
79	BEARING SPACER BUSHING	1
80	HEX SOCKET CAP HEAD SCREW M6X12	2

Part A

ITEM	PARTS NAME	QTY
81	MOUNTING BASE, UPPER GUIDE	1
82	GUIDE SHAFT	2
83	UPPER GUIDE MOUNT	1
84	BIG WASHER 6 18-1.5	1
85	HEX SOCKET SET SCREW M6X8	2
86	HEX SOCKET SET SCREW M8X16	1
87	HEX SOCKET CAP HEAD BOLT M5X10	9
88	UPPER WHEEL	1
89	MOTOR PULLEY	1
90	LOWER WHEEL SHAFT	1
91	LOWER WHEEL	1
92	UPPER WHEEL SHAFT	1
93	UPPER DOOR	1
94	LOWER DOOR	1
95	BLADE GUARD	1
96	SCALE, UPPER GUIDE	1
97	PROTECTION BOARD A	1
98	PROTECTION BOARD B	1
99	POINTER	1
100	LIFTING GEAR, UPPER GUIDE	1
101	DUAL THREAD BOLT, UPPER GUIDE	4
102	HEX NUT M8	7
103	BIG WASHER 8	5
104	SPRING WASHER 8	9
105	HEX BOLT M8X30	1
106	HEX SOCKET CAP HEAD BOLT M8X16	9
107	CROSS RECESSED PAN HEAD SCREW M4X8	6
108	HEX SELF LOCKING NUT M8	1
109	SPRING WASHER 12	3
110	WASHER 12	3
111	HEX NUT M12	3
112	BEARING 6205	2
113	STEP BOLT M8X105	1
114	DEEP GROOVE BALL BEARING 6304-2RZ	2
115	RING CIRCLE	2
116	HEX NUT M18	1
117	PLASTIC SELF-LOCKING M8X1.5(LEFT)	1
118	WASHER 18	2
119	HEX SOCKET CAP HEAD BOLT M8X30	1
120	HEX SOCKET SET SCREW M6X12	4
121	HEX NUT M10	1
122	HEX SOCKET CAP HEAD BOLT M5X30	2
123	HEX NUT M6	2

ITEM	PARTS NAME	QTY
124	HEX SOCKET CAP HEAD BOLT M5X18	2
125	PLASTIC SELF-LOCKING NUT M5	2
126	RIVET 4X8	8
127	HEX SOCKET SET SCREW M5X6	4
128	HEX BOLT M8X95	1
129	BIG WASHER 6	4
130	CROSS RECESSED PAN HEAD SCREW M4X16	1
131	HEX NUT M4	1
132	HEX SOCKET CAP HEAD BOLT M8X60	4
133	HEX SOCKET CAP HEAD SCREW M4X16	2
134	HEX NUT M16	1
135	HEX SOCKET PAN HEAD SCREW M5X10	2
136	HEX NUT M5	2
137	WASHER 5	4
138	CROSS RECESSED PAN HEAD SCREW M4X6	3
139	WASHER 4	4
140	CROSS RECESSED COUNTERSUNK SCREW M6X16	4
141	BIG WASHER 20	1
142	BIG COTTER PIN 2.5X18	1
143	STOPPING SHAFT, BLADE TENSION	1
144	WHITE CROSS RECESSED PAN HEAD SCREW M3X4	1
145	WHITE SPRING WASHER 3	1
146	PUSH STICK	1
147	SCREW, PUSH STICK	1
148	CABINET STAND	1
149	BIG WASHER 18	1
150	WASHER 16	1
151	SPRING WASHER 16	1
152	FLAT WASHER	1
153	SPRING PIN 6X16	2

Part B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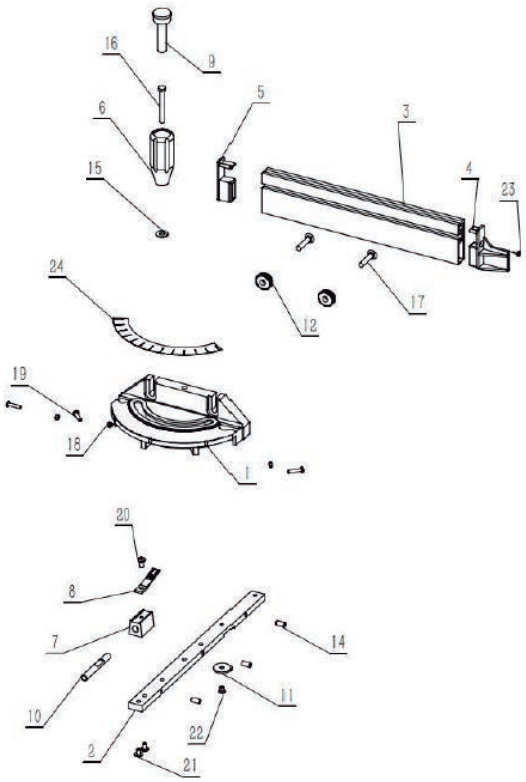
Part B

ITEM	PARTS NAME	QTY
1	WORK TABLE	1
2	LOWER TABLE TRUNNION	1
3	UPPER TABLE TRUNNION	2
4	INSERT	1
5	PIN	1
6	ADJUSTABLE KNOB M8	1
7	POINTER	1
8	WASHER 5	3
9	HEX SOCKET PAN HEAD SCREW M5X8	1
10	GASKET BOARD	3
11	RIP FENCE FRAME	1
12	WHITE HEX SOCKET SET SCREW M12X12	2
13	POINTER	1
14	HEX SOCKET SET SCREW M10X10	2
15	SEMI-ROUND STEP BOLT M8X35	1
16	HEX SELF-LOCKING NUT M8	2
17	CROSS RECESSED PAN HEAD SCREW M5X8	2
18	ALUMINUM AJUSTABLE KNOB M6	2
19	BIG WASHER 6	2
20	LOCKING ECCENTRIC CAM	1
21	LOCKING HANDLE	1
22	LOCKING SPRING	1
23	PAD	1
24	STEP BOLT M6X50	2
25	LOCK BAR	1
26	CAP FOR FENCE BODY	1
27	CROSS RECESSED PAN HEAD SCREW M4X6	1
28	MOUTING PLATE, FENCE RAIL	1
29	FENCE RAIL	1
30	END CAP FOR RIP FENCE	1
31	FRONT CAP FOR RIP FENCE	1
32	RIP FENCE	1
33	RIGHT SCALE, FENCE RAIL	1
34	CAP FOR FENCE RAIL	2
35	LEFT SCALE, FENCE RAIL	1
36	HEX SOCKET PAN HEAD BOLT M8X20	4
37	BIG WASHER 8	7
38	STEP BOLT M8X85	2
39	WASHER 10	4
40	HEX SOCKET CAP HEAD BOLT M10X40	2
41	SPRING WASHER 10	2

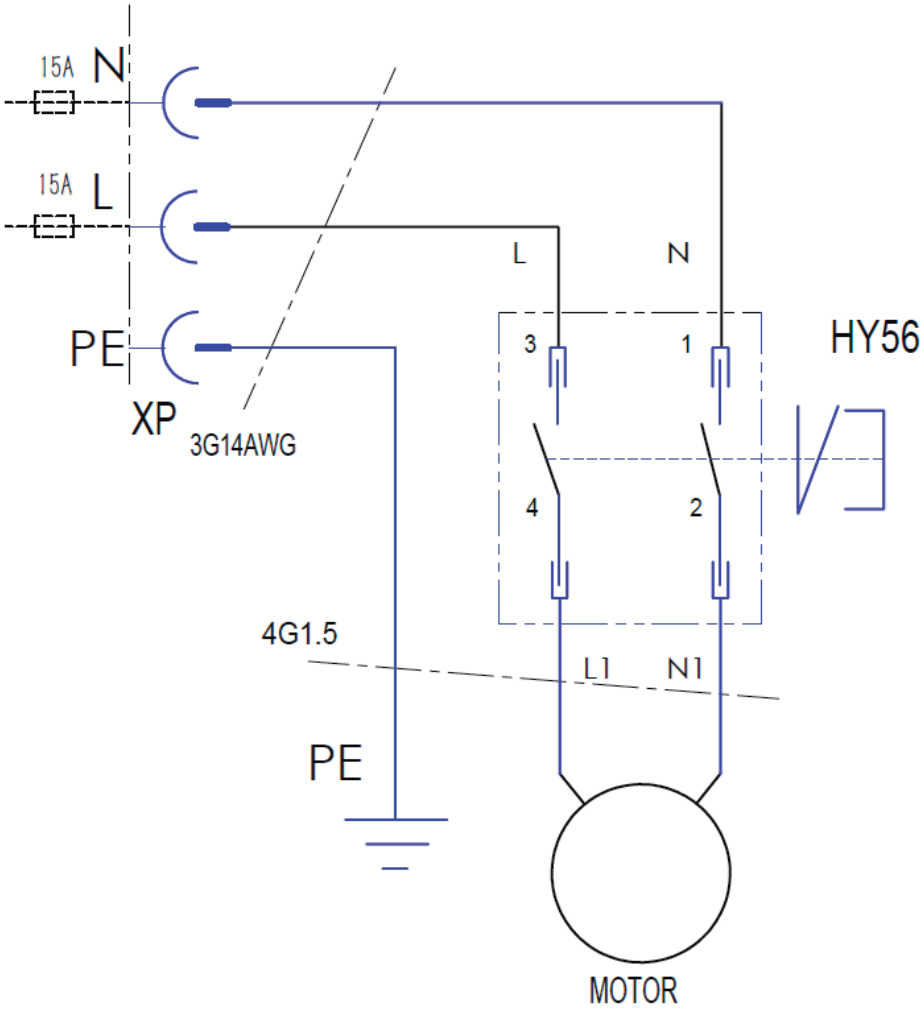
ITEM	PARTS NAME	QTY
42	HEX NUT M10	2
43	HEX SOCKET CAP HEAD BOLT M6X20	4
44	HEX BOLT M8X12	4
45	HEX SOCKET CAP HEAD BOLT M8X16	4
46	WASHER 8	8
47	PIN 3X10	1
48	BEARING 6201	1
49	LOWER BEARING SQUARE POLE	1
50	BEARING BUSHING	1
51	HEX SOCKET CAP HEAD BOLT M6X18	1
52	HEX SOCKET SET SCREW M6X70	1
53	HEX NUT M8	4
54	HEX SOCKET CAP HEAD BOLT M8X25	1
55	GEAR HANDLE	1

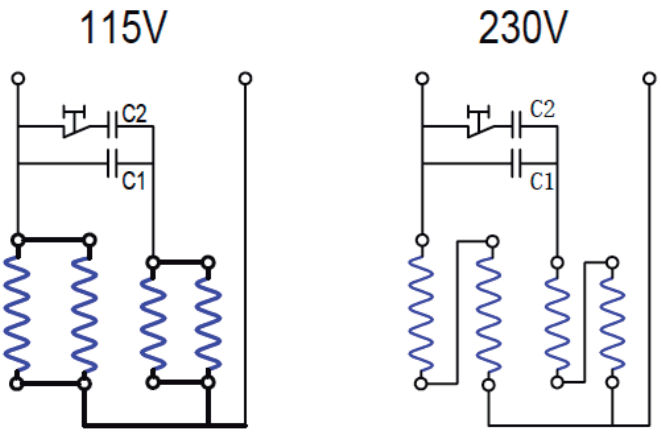
Part C

ITEM	PARTS NAME	QTY
1	MITRE GAUGE	1
2	SLIDING GUIDE	1
3	MITRE GAUGE FENCE	1
4	END CAP A	3
5	END CAP B	1
6	MITRE GAUGE HANDLE	2
7	POINTER BASE	1
8	POINTER	1
9	HANDLE COVER	1
10	STOP SHAFT	1
11	RAIL WASHER	2
12	THUMBNUT	1
14	WAVE SET SCREW M6X12	2
15	WASHER 6	1
16	HEX BOLT M6X50	1
17	CARRIAGE BOLT M6X30	2
18	HEX NUT M4	3
19	CROSS PAN HEAD SCREW M4X18	3
20	CROSS PAN HEAD SCREW M5X10	1
21	CROSS PAN HEAD SCREW M5X8	2
22	CROSS COUNTERSUNK SCREW M5X8	1
23	SELF-TAPING SCREW ST5X13	1
24	ANGLE SCALE	1



9 Wiring Diagram





10 Terms of Warranty

MAKSIWA assures the owner that their equipment, identified by the Serial number issued on the Warranty Terms.

The equipment under warranty, for two (2) years, is as followed:

1. The warranty period begins on the date of the Warranty Terms below.
2. Within the warranty period, the manual labor and the components replaced by manufacturing defect will be provided for free if duly proved by Maksiwa Service.
3. Third-party manufacturing equipment that makes up the MAKSIWA equipment (such as motors, electrical equipment, belts etc.) are subject to the terms and conditions of warranty of their respective manufacturers.
4. In case an exchange of machine is needed, please return the defective part or machine to MAKSIWA.
5. All workplace adaptations for the equipment are under the responsibility of the machine owner.
6. If you notice any defect or malfunction when receiving the equipment, get in touch immediately with the manufacturer or Dealer. Do not turn it on.
7. Not included in this warranty is any technical visits aimed at cleaning or adjustments caused by wear, resulting from normal use of the equipment.
8. The warranty does not cover problems caused by mistreatment, carelessness, misuse or inappropriate use of the functions designed for this equipment in this manual, as well as poorly executed operations by untrained operators to operate it.
9. MAKSIWA is not responsible for lost productivity, direct or indirect damages caused to the owner of the equipment or to third parties, or any other expense, including lost profits.
10. Even under warranty, you may lose its validity as follows:
    a) Application of non-original components;
    b) Alteration of its original features;
    c) Lack of proper maintenance;
    d) Improper use of the equipment;
    e) Change in equipment or electronic connections;
    f) Damage caused by mechanical shock or exposure to unsuitable conditions (humidity, salt spray, corrosive agents, etc.);
    g) Damage caused by bad weather (floods, flooding, lightning, power outages etc.);
    h) Maksiwa is not responsible for damages to electrical components cause by power variation in your area.

For your safety, trust the repairs, maintenance and adjustments (including inspection and replacement) for technical assistance recommended by MAKSIWA, always use genuine spare parts and accessories, reassembling to its original machine the same way.

MODEL: SERIAL NUMBER: DATE: LOT NUMBER:

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