

Jet Horizontal Bandsaw

BMW-1018w



Machine Purpose: Cut Metal and Plastics

Safety: **Must wear safety glasses while operating machine. Keep.** Beware of objects that dangle and could get caught in cutting tool. Beware of flying metal chips. **This machine has no built-in safety system.** Machine auto turns off at lowest height.

Materials: Metals, Plastics, Synthetic

Machine Specs: 10"x18" cutting capacity, 45 deg cut,

Limitations: NO WOOD, **NO SHEET METAL, NO MATERIAL UNDER .5"**, no pipe

Accessories: Adjustable Depth Stop, Flood Coolant

Blade Dimensions: 1"x130"

Instruction Required: Cold Metals Basic Training

MATERIAL	BANDSAWING SPEED (fpm)	MATERIAL	BANDSAWING SPEED (fpm)
ALUMINUM	200 TO 2,000	RUBBER, HARD	150 TO 250
BAKELITE	200 TO 900	STEEL, ALLOY	50 TO 100
BRASS, SOFT	175 TO 300	STEEL, HIGH CARBON ...	50 TO 100
BRASS, HARD	75 TO 150	STEEL, HIGH-SPEED	50 TO 90
BRASS, SHEETS	200 TO 900	STEEL, MACHINE	75 TO 175
BRONZE	75 TO 150	STEEL, SHEET	150 TO 200
CAST IRON	50 TO 100	STEEL STAINLESS	50 TO 75
COPPER	115 TO 175	STEEL TOOL	50 TO 150
MONEL METAL	50 TO 100		

Figure 5-17. Band sawing speeds.



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Notes

- Never hold a piece smaller than half the vice width in the jaws
- If blade is skipping turn down the cutting pressure
- Always adjust the blade speed relative to the material being cut
- If blade tracking, tension, roller guides or changes are necessary please see shop tech for assistance

Prechecks

- Vice is securely holding work piece
- Blade tracking
- Blade roller guide spacing
- Blade tension

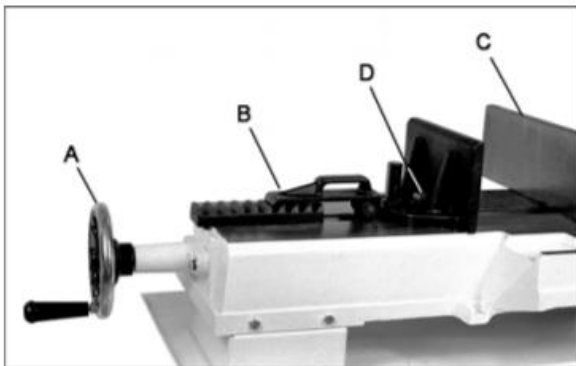
Set up & Operation

Changing Blade Speed:

- While standing in front of controls, on the right side remove motor covers
- Loosen handle on the bottom of the motor to release tension on motor belt
- Adjust belt to desired pulley configuration, reference chart on cover for speeds
- Adjust motor so belt is tensioned
- Tighten handle on underside of motor to hold belt in place
- Replace Cover



Work holding: **If material doesn't reach half the vice width it is too small to cut**



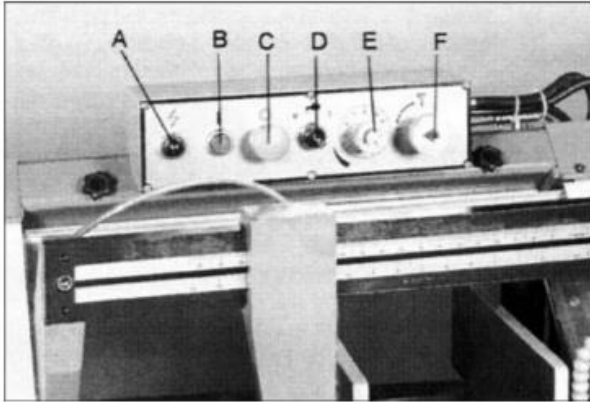
- Turn vise handwheel (A) 1/2 turn counterclockwise.
- Move rack block (B) to desired location by sliding along the bed. Place the rack block onto the rack.
- Turn the handwheel to tighten the vise.



To adjust the vise for angle cutting:

- Loosen bolts and move vise jaw (C) to desired location.
- Set the vise to desired angle, re-install nuts and tighten the nut and bolt assemblies.
- Adjust the movable vise parallel to the fixed vise by loosening bolt (D) adjusting to parallel, and re-tightening bolt.

Controls



- Power Indicator Light (A) – lit whenever machine is running.
- Start Button (B) – press to start band saw.
- Emergency Stop Button (C) – press to immediately stop all machine functions.
- Coolant Switch (D) – Turn arrow to “I” to turn on coolant flow. Turn arrow to “O” to stop coolant flow.
- Cutting Pressure Control (E) – turn clockwise to decrease cutting pressure. Turn counter-clockwise to increase cutting pressure.
- Hydraulic On-Off Valve (F) – turns hydraulic cylinder on and off.