



J-349V

Portable Bandsaw

Original:

GB
Operating Instructions



JPW Tool Group Hong Kong Limited

98 Granville Road, Tsimshatsui East, Kowloon, Hong Kong, PRC

www.jettools.com

Импортер в РФ: ООО «ИТА Технолоджи»

105082, Москва, Переведеновский пер., д. 17

www.jettools.ru

Made in Taiwan / Сделано на Тайване



Dear Customer,

Many thanks for the confidence you have shown in us with the purchase of your new machine. This manual has been prepared for the owner and operators of a J-349V metal band saw to promote safety during installation, operation and maintenance procedures. Please read and understand the information contained in these operating instructions and the accompanying documents. To obtain maximum life and efficiency from your machine, and to use the machine safely, read this manual thoroughly and follow instructions carefully.

Table of Contents

- 1. Declaration of conformity**
- 2. Warranty**
- 3. Safety**
- 4. Machine specification**
- 5. Transport and installation**
- 6. Machine operation**
- 7. Setup and adjustments**
- 8. Maintenance and inspection**
- 9. Troubleshooting**
- 10. Environmental protection**

Contents

1. Declaration of conformity

On our own responsibility we hereby declare that this product complies with the regulations* listed on page 2. Designed in consideration with the standards**.

2. Warranty

JPW (Tool) AG guarantees that the supplied product is free from material defects and manufacturing faults.

This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, accidental damage, repair, inadequate maintenance or cleaning and normal wear and tear. Any warranty details (i.e. warranty period) can be found in the General Terms and Conditions (GTC) that are integral part of the contract.

These GTC can be viewed at the website of your dealer or sent to you upon request.

JPW (Tool) AG reserves the right to make changes to the product and accessories at any time.

3. Safety

3.1 Authorized use

This machine is designed for sawing machinable metal and plastic materials only.

Machining of other materials is not permitted and may be carried out in specific cases only after consulting with the manufacturer.

Never cut magnesium-high danger to fire!

The workpiece must allow to safely be loaded and clamped for machining.

The proper use also includes compliance with the operating and maintenance instructions given in this manual.

The machine must be operated only by persons familiar with its operation and maintenance and who are familiar with its hazards.

The required minimum age must be observed

The machine must only be used in a technically perfect condition.

When working on the machine, all safety mechanisms and covers must be mounted.

In addition to the safety requirements contained in these operating instructions and your country's applicable regulations, you should observe the generally recognized technical rules concerning the operation of metalworking machines.

Any other use exceeds authorization. In the event of unauthorized use of the machine, the manufacturer renounces all liability and the responsibility is transferred exclusively to the operator.

3.2 General safety notes

Metalworking machines can be dangerous if not used properly. Therefore the appropriate general technical rules as well as the following notes must be observed.

Read and understand the entire instruction manual before attempting assembly or operation.

Keep this operating instruction close by the machine, protected from dirt and humidity, and pass it over to the new owner if you part with the tool.

No changes to the machine may be made.

Daily inspect the function and existence of the safety appliances before you start the machine. Do not attempt operation in this case, protect the machine by unplugging the mains cord.

Remove all loose clothing and confine long hair.

Before operating the machine, remove tie, rings, watches, other jewellery, and roll up sleeves above the elbows.

Wear safety shoes; never wear leisure shoes or sandals.

Always wear the approved working outfit

Do not wear gloves while operating this machine.

For the safe handling of saw blades wear work gloves.



Wear safety goggles when working

Wear ear protection when working

Install the machine so that there is sufficient space for safe operation and work-piece handling.

Keep work area well lighted.

The machine is designed to operate in closed rooms and must be placed stable on firm and levelled ground.

Make sure that the power cord does not impede work and cause people to trip.

Keep the floor around the machine clean and free of scrap material, oil and grease.

Never reach into the machine while it is operating or running down.

Stay alert! Give your work undivided attention. Use common sense.

Keep an ergonomic body position. Maintain a balanced stance at all times.

Do not operate the machine when you are tired. Do not operate the machine under the influence of drugs, alcohol or any medication. Be aware that medication can change your behavior.

Keep children and visitors a safe distance from the work area.

Never leave a running machine unattended. Before you leave the workplace switch off the machine.

Do not operate the electric tool near inflammable liquids or gases. Observe the firefighting and fire alert options, for example the fire extinguisher operation and place.

Do not use the machine in a damp environment and do not expose it to rain. Insure that the workpiece does not roll when cutting round pieces. Use suitable table extensions and supporting aids for difficult to handle workpieces.

Always adjust the blade guide close to the workpiece. Work only with well sharpened tools.

Specifications regarding the maximum or minimum size of the work-piece must be observed. Do not stand on the machine. Remove cut and jammed workpieces only when motor is turned off and the machine is at a complete standstill.

Never operate with the guards not in place – serious risk of injury! Connection and repair work on the electrical installation may be carried out by a qualified electrician only. Have a damaged or worn cord replaced immediately. Make all machine adjustments or maintenance with the machine unplugged from the power source. Remove defective saw blades immediately.

3.3 Remaining hazards

When using the machine according to regulations some remaining hazards may still exist

The moving saw blade in the work area can cause injury.

Broken saw blades can cause injuries.

Thrown cutting chips and noise can be health hazards. Be sure to wear personal protection gear such as safety goggles and ear protection.

The use of incorrect mains supply or a damaged power cord can lead to injuries caused by electricity.

4. Machine specification

4.1 specification

Power supply ~230V, PE, 50Hz Main motor 1.0kW, S4-60%




Saw blade dimension 1440 x 13 x 0.65mm

Saw blade speed 30 - 70 m/min

Overall LxWxH 724 x 375 x 456mm

Weight 19kg.

Cutting capacity (mm):

(mm)			
0°	125	125x125	130x125
45°	80	80x80	85x80
60°	50	50x50	52x50

4.2 Noise emission

Acoustic pressure level (EN ISO 11202): Idling LpA 60,0 dB(A)

The specified values are emission levels and are not necessarily to be seen as safe operating levels.

As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

5. Transport and installation

5.1 Minimum requirements for storing the machine

-Environment temperature within $-10\text{ }^{\circ}\text{C}$ to $+50\text{ }^{\circ}\text{C}$.

-Relative humidity cannot be over 90%.

-The machine stand must be placed stable on firm and levelled ground.

5.2 Assembly

If you notice transport damage while unpacking, notify your supplier immediately. Do not operate the machine!

Dispose of the packing in an environmentally friendly manner.

5.3 Mains connection

Mains connection and any extension cords used must comply with applicable regulations. The mains voltage must comply with the information on the machine license plate.

The mains connection must have a 10A surge-proof fuse. Only use power cords marked H07RN-F.

Connections and repairs to the electrical equipment may only be carried out by qualified electricians.

5.4 Start up

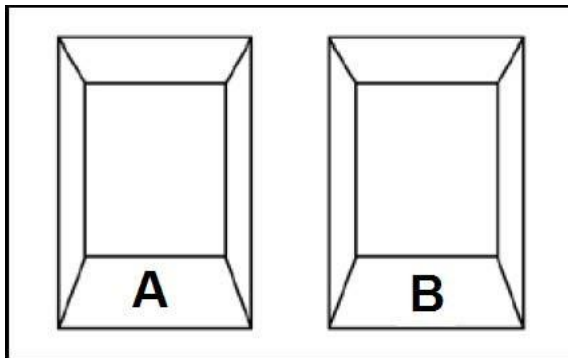


Fig 1



Fig 2

A=RED=OFF

B=GREEN=ON

To switch on the machine use the green button (B, fig 1) on main switch. Adjust the speed rotation with the knob (C, Fig 2) according to the table.

Start the machine in pressing the control switch (D, Fig 2). To release the control switch (D), the machine stops. To take the machine out of operation, press the red button (A, Fig 1) on main switch.

6. Machine operation

NOTE: Before using the saw, pull the transport lock pin (A, Fig 3). For transport lock it again.

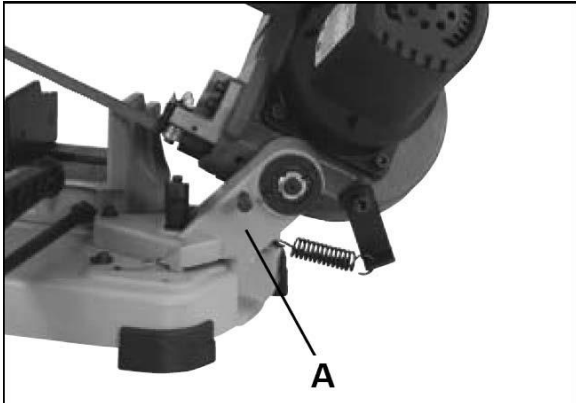


Fig 3

The machine is designed to cut in dry condition only. The use of any coolant or oil will damage the machine. Don't cut magnesium-high danger to fire!

Support long workpieces with helping roller stands. Work only with a sharp and flawless saw blade. Don't take measurements when the machine is running. Don't chuck too short in vice.

7. Setup and adjustments

General note: Setup and adjustment work may only be carried out after the machine is protected against accidental starting by pulling the mains plug.

7.1 Miter angle adjustment

Miter cuts can be made from 0° to 60°. The 90° stop has been adjusted ex works.

To make miter adjustments:

Loosen the clamping lever (A, fig 4). Set the saw arm to the desired cutting position (scale). Retighten the clamping lever (A).

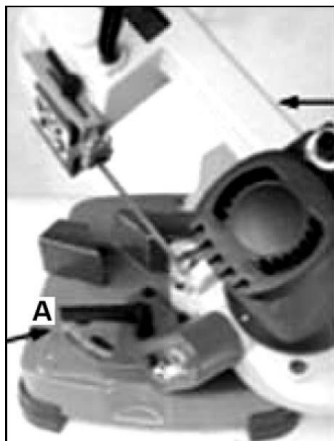


Fig 4

7.2 Blade guides adjustment

Loosen the indexable knob (B, Fig 5) and slide blade guide assembly (C) as close as possible without interfering the material being cut. Tighten knob.

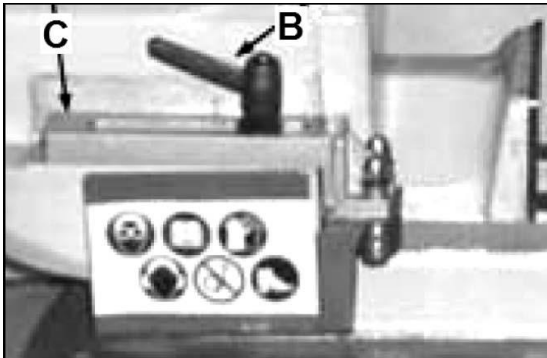


Fig 5

7.3 Machine vice adjustment

The machine is equipped with a vise.



Fig 6

To clamp the workpiece, rotate the lever in clockwise direction.

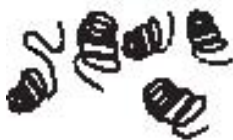
To unlock, rotate in counter-clockwise direction.

Note: The workpiece must properly be clamped during machining, otherwise machining errors and blade damage can occur.

7.4 Feed pressure selection

A good indication of proper feed pressure is the shape of the cutting chips.

Perfect: Loose curled chips



If the chips are thin or powdered increase the feed pressure.

If the chips are burned reduce the cutting speed and decrease the feed pressure.

7.5. Choosing the saw blade

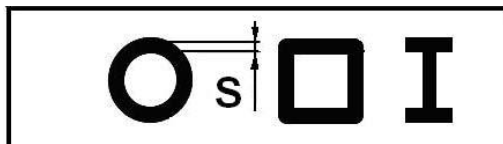
Choose a tothing that is appropriate to the workpiece being processed. Ideally, at least 3 teeth should be in action at the same time.

The tothing should not be smaller than necessary, as the cutting speed is reduced if there are too many small teeth working on the workpiece simultaneously, which causes the saw blade to wear more quickly, and makes the cuts crooked and distorts them.

The following table shows the approximate tothing of the saw blades for a specific material thickness. For further information please contact your saw blade dealer.

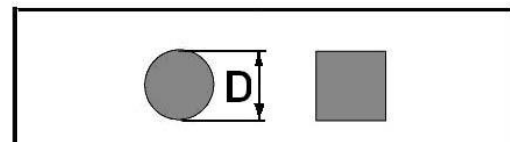
Table for saw blade selection:

Material thickness	No. of teeth per inch	Art. No.
< 3 mm	14	2201
2 - 5 mm	10 / 14	2202
4 - 8 mm	8 / 12	2203



S mm	T / "
< 3	14
2 - 5	10/14
4 - 8	8/12

Fig 7



D mm	T / "
< 30	10/14
20 - 50	8/12

Fig 8

Comments:

10/14 tothing provides good cutting results for thin-walled pipes and profiles.

The choice of tothing (i.e. the number of teeth per inch) should be such that at least 3 teeth are always in action at the same time.

When cutting thick material, a coarse Tooth Pitch "T" is needed to accommodate the big chips (fig 9).

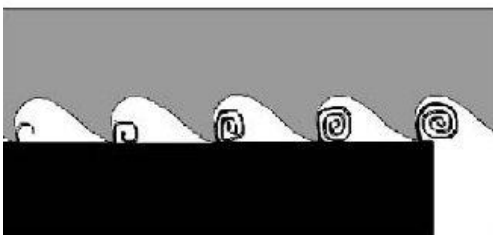


Fig 9

7.6 Cutting speed selection

The general rule is the harder the material being cut, the slower the blade speed.

25 - 30 m/min (Position 1)

for stainless steel, alloy steel and bearing bronzes.

40 - 50 m/min (Position 2-3)

for mild steel, hard brass or bronze.

60 - 80 m/min (Position 4-6)

for soft brass, aluminum or other light materials.

Saw blade lubricant

The lifetime of the saw blade can be extended significantly by lubricating it with stick wax item no. 2168.

7.7 Changing the saw blade

ATTENTION: Before opening the saw blade cover disconnect the machine from the power source.

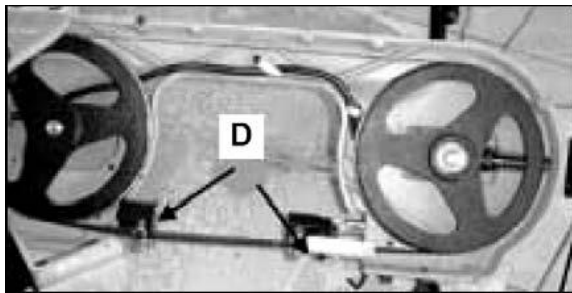


Fig 10

Raise saw head in vertical position and open the guards.

Loosen blade-tension knob sufficiently to allow the saw blade to slip off the wheels.

Install the new blade with teeth slanting toward the motor. Place the blade in between the guide bearings (D, fig 10). Tighten the blade tension knob.

Make sure the blade locates against the wheel shoulder. Reattach all covers and check the run of the saw blade by starting the machine with caution.

7.8 Rounding of teeth

A carefully broken in blade lasts much longer and gives better performance.

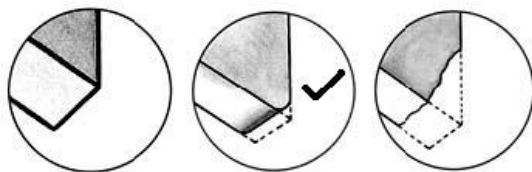


Fig 11

To break in your new blade, run it at only 30% of normal pressure for ten minutes. Then gradually increase to normal pressure.

8. Maintenance and inspection

General notes: Maintenance, cleaning and repair work may only be carried out after the machine is protected against accidental starting by pulling the mains plug.

The maintenance schedule has been divided into daily, weekly, monthly and six-monthly intervals. Neglecting the machine maintenance will result in premature wear and poor performance.

Daily maintenance

- General cleaning of the machine to remove accumulated shavings.
- Check blade for wear.
- Rise of saw frame to top position and partial slackening of the blade to avoid useless yield stress.
- Check functionality of the shields and emergency stops.

Weekly maintenance

- Lubrication of blade tension screw
- Lubrication of vise screw and vise guides
- Cleaning of saw blade guides

Monthly maintenance

- Check the tightness of all screws.
- Lubricate the bolts of the arm hinge.

Semi-annual maintenance

- Lubricate the gearbox.
- The gears are manufactured of special steel to assure a long life.
- To achieve maximum machine life, we recommend to lubricate the gears every 100 operating hours.
- Disconnect the machine from the power source.
- Remove the blade cover and the saw blade.
- Remove the wheel bolt.
- Remove the hinge and lubricate the gear wheel with high quality oil (BLASOLUBE 304 or similar).
- Remount the hinge and retighten the wheel bolt.
- Remount all covers and guides.

Special maintenance

Special maintenance operations must be carried out by skilled personnel. However, we advise contacting dealer and/or importer the term special maintenance also covers the resetting of protection and safety equipment and devices.

Deactivating the machine

- If the machine is to be inactive for a long period, prepare the machine as follows:
- Detach the plug from the electric supply panel.
- Carefully clean and grease the machine.
- If necessary, cover the machine

9. Troubleshooting

Motor doesn't start

- *No electricity-check mains and fuse.
- *Defective switch, motor or cord- consult an electrician.
- *Overload has reacted-Wait for automatic reset.

Machine vibrates excessively

- *Stand on uneven surface-adjust for even support.
- *saw blade has cracks-replace saw blade immediately
- *Tool heavy a cut-reduce feed pressure and feed speed.

Cut is not square

- *Saw arm setting is bad
- *Blade guide setting is bad.
- *Saw blade is dull.

Cutting surface is bad

- *Wrong saw blade chosen
- *Saw blade is dull
- *Blade guide setting is bad
- *Blade tension too low
- *Feed pressure too high
- *Feed speed too high

10.Environmental protection

Protect the environment.

Your appliance contains valuable materials which can be recovered or recycled. Please leave it at a specialized institution.