

HBS350N 14"

Bandsaw



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Warning The symbols below advise that you follow the correct safety procedures when using this machine.



Fully read manual
and safety instructions
before use



Ear protection
should be worn



Eye protection
should be worn



Dust mask
should be worn



HAZARD
Motor gets hot

What's Included

Quantity	Item	Model Number
		HBS350N
1 No	HBS350N 14" Bandsaw	(Code: 508206)
1 No	Bandsaw Blade 2,616mm long, mounted on saw but not tensioned	
1 No	Saw Table	1
1 No	Fence Guide Rail	2
1 No	Fence Rear Guide Rail	3
1 No	Guide Fence Assembly	4
1 No	Guide Fence Assembly	5
1 No	Micro Adjuster Assembly with two Phillips screws and washers	6
1 No	Mitre Fence Holder with two Phillips screws	7
1 No	Mitre Fence	8
1 No	Guide Fence Extension with two M6 x 65mm coach bolts and washers	
Floor Stand comprising:		
4 No	Threaded Rubber Feet	A
4 No	Leg Brackets	B
2 No	Short Support Struts	C
2 No	Long Support Struts	D
Bag Containing:		
18 No	M8 x 18mm Coach Bolts	E
3 No	M8 x 25mm Square Head Bolts	F
25 No	M8 Nuts & Washers	G
3 No	M6 x 15mm Hex Bolts and washers	H
2 No	Table Clamping Handles	I
2 No	Butterfly Nuts (for fence extension)	J
1 No	5,4,3mm Hex Keys	
Optional Accessories:		
1 No	Wheel Mobility Kit with M6 bolts nuts and washers	K
1 No	Lifting Handle Bracket	L

Having unpacked your accessories please dispose of any unwanted packaging properly. The cardboard packaging is biodegradable.



Please read the Instruction Manual prior to using your new machine; as well as the operating procedures for your new machine, there are numerous hints and tips to help you to use the machine safely and to maintain its efficiency and prolong its life. Keep this Instruction Manual readily accessible for any others who may also be required to use the machine.

General Instructions for 230V Machines

Good Working Practices/Safety

The following suggestions will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.



WARNING! KEEP TOOLS AND EQUIPMENT OUT OF THE REACH OF YOUNG CHILDREN

Mains Powered Tools

Primary Precautions

These machines are supplied with a moulded 13 Amp. plug and 3 core power cable. Before using the machine inspect the cable and the plug to make sure that neither are damaged. If any damage is visible have the tool inspected/repaired by a suitably qualified person. If it is necessary to replace the plug, it is preferable to use an 'unbreakable' type that will resist damage on site. Only use a 13 Amp plug and make sure the cable clamp is tightened securely. Fuse as required. If extension leads are to be used, carry out the same safety checks on them and ensure that they are correctly rated to safely supply the current that is required for your machine.

Work Place/Environment

Make sure when the machine is placed that it sits firmly on the floor; that it does not rock and is sufficiently clear of adjacent obstacles so that cutting operations will not be impeded. Check you have adequate clearance both in front of and behind the machine when cutting long stuff. If you are liable to be processing unwieldy or awkward work pieces, it is suggested that you consider fastening the machine down to the floor.

The machine is not designed for sub-aqua operation, do not use when or where it is liable to get wet. If the machine is set up in the open, and it starts to rain (unusual though this would be in U.K.), cover it up or move it into the dry. If the machine has got wet dry it off as soon as possible, with a cloth or paper towel.

Do not use 230V a.c. powered machines anywhere within a site area that is flooded or puddled and do not trail extension cables across wet areas.

Keep the machines clean; it will enable you to more easily see any damage that may have occurred.

Clean the machine with a damp soapy cloth if needs be, do not use any solvents or cleaners as these may cause damage to any plastic parts or to the electrical components.

Keep the work area as uncluttered as is practical, this includes personnel as well as material.



(UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS)

It is good practice to leave the machine unplugged until work is about to commence, also make sure to unplug the machine when it is not in use or unattended.

Always disconnect by pulling on the plug body and not the cable. Once you are ready to commence work, remove all tools used in the setting operations (if any) and place safely out of the way. Re-connect the machine.

Carry out a final "tightness" check e.g. guide fence, table tilt, etc., check that the 'cutting path' (in this case the path that the work piece will travel) is unobstructed.

Make sure you are comfortable before you start work; balanced, not reaching etc..

If the work you are carrying out is liable to generate flying grit, dust or chips wear the appropriate safety clothing, goggles, gloves, masks etc., and if the work operation appears to be excessively noisy, wear ear-defenders.

If you wear your hair in a long style, wearing a cap, safety helmet, hair net, even a sweatband, will minimise the possibility of your hair being caught up in the rotating parts of the tool. Likewise, consideration should be given to the removal of rings and wristwatches, if these are liable to be a 'snag' hazard. Consideration should also be given to nonslip footwear, etc..

Do not work with cutting tools of any description if you are tired, your attention is wandering or you

General Instructions for 230V Machines

are being subjected to distraction. A deep cut, a lost fingertip or worse; is not worth it!

Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases. There are very expensive, very specialised machines for working in these areas, **THIS IS NOT ONE OF THEM.**

Check that blades are the correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.

Above all, **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

Specification

Model	HBS350N
Code	508206
Rating	Hobby
Power	850W (230V)
Blade Speed	600 & 720 m/min
Blade Length	2,616mm
Blade Width Min/Max	6mm (1/4") to 16mm (5/8")
Max Width of Cut	325mm
Max Depth of Cut	200mm
Max Width of Cut with Fence	285mm
Table Size	480 x 535mm
Table Height on Stand	995mm
Table Tilt	-5° to +45°
Wheel Diameter	350mm
Dust Extraction Outlet	100mm
Overall L x W x H	760 x 720 x 1,700mm
Weight	95kg

Unpacking

Your saw is packed in the box partially assembled. This is to ensure that the components are inserted in the correct positions. e.g. The blade is fitted, the securing bolt for the tilt mechanism is inserted in the tilt quadrant with the washer and the locking butterfly nut threaded on to the bolt, etc.

Please make careful note of the positions of the various components if you have cause to disassemble, whilst putting the machine together.

Take all the easily removable items out of the box,

tip the box up so that the base of the saw is to the ground, remove all the polystyrene packaging from around the saw (open both sides of the box?) then "corner walk" the saw out of the box.

If this is still awkward, split the top of the box, fold the box material flat on the floor, and "wriggle" the saw off the cardboard. (The best method of moving the saw is with a 'hug' lift through the neck of the saw, holding the saw back against your body and lifting by straightening your legs).

Stand Assembly

Locate and identify the 4 leg brackets (B), the short struts (C) and the long struts (D) for the stand, and M8 x 18mm coach bolts, washers and nuts (E & G).

Using the M8 coach bolts, nuts and washers bolt together two legs (B) and one short strut (C) at the top. 'finger tighten' at this time, see fig 1.

When the two frames have been assembled, select one, turn it upside down on a flat surface and loosely bolt one the long strut (D) in place, see fig 2. Attach the other frame and bolt to the remaining strut (D) for the other side.

When all the components are assembled, turn the stand upright. Using the flat surface as a reference, tighten up all the nuts, turn the stand on its side and insert one of the four thread rubber feet (A) into one of the four pre-drilled holes to the ends of the leg brackets (B). Tighten in place with a M8 washer and nut (G). Repeat for the remaining feet. Upright the frame and stand it on the floor, see fig 3.

Fig 01

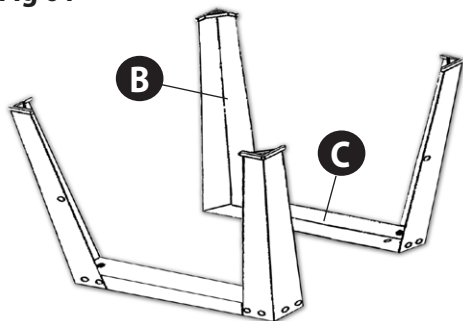


Fig 02

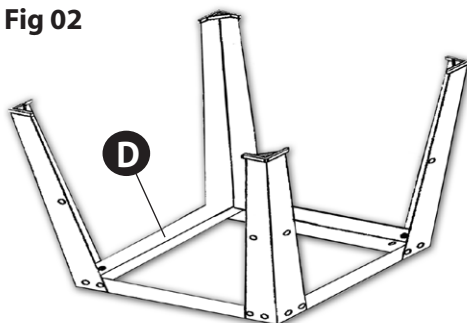
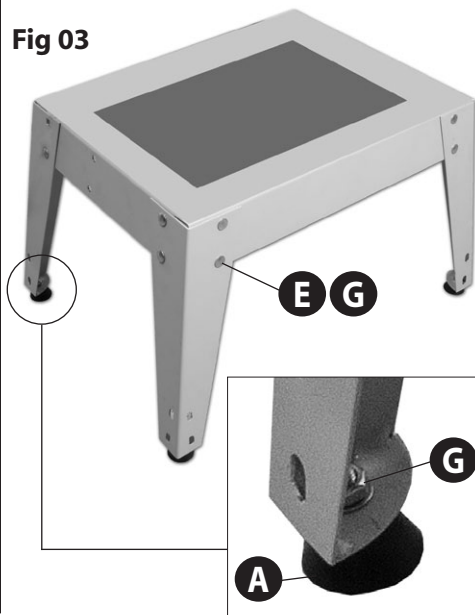


Fig 03



Mounting the Bandsaw to the Stand

Lift the saw on to the stand, secure using four M8x40 bolts nuts and washers. Insert the bolts through the pre-drilled holes in each corner of the base and through the floor stand. Fit the washers and nuts on the underside and tighten to secure the assembly.



WHEN MOUNTING THE UNIT, WE STRONGLY ADVISE YOU GET THE ASSISTANCE OF ANOTHER PERSON BECAUSE THE BANDSAW IS HEAVY.



Two Man lift

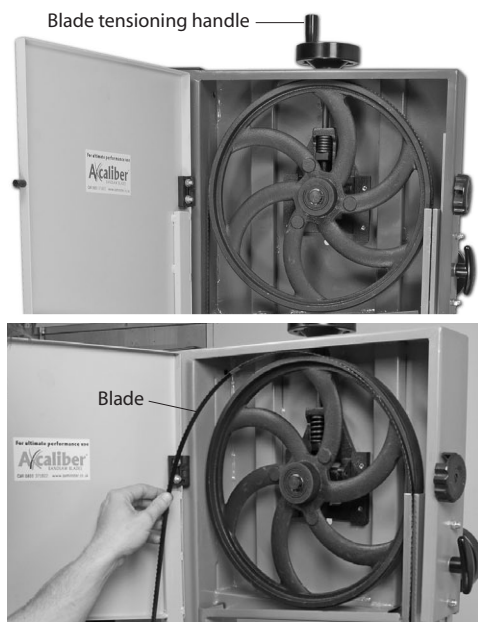


Main Assembly

Mounting the saw table

The saw table can be fitted without removing the blade. However, if you would feel more comfortable not having to manoeuvre the table around the blade (the table is quite heavy), remove the blade by opening the top and bottom covers, release the tension on the blade by backing off the tensioning wheel, see fig 01-02.

Fig 01-02



Step 1 Remove the table stabilising bolt and the table insert, see figs 03-04. Lift the table (1), slide the blade through the table slot and lower the table, guiding the threaded bolts through the holes in the tilt quadrant housing, see fig 05. Screw on the table clamping handles (I) and tighten, see fig 06. Replace the stabilising bolt.



DO NOT OVERTIGHTEN!

Step 2 Locate the fence rear guide rail (3) and the three M6 hex bolts and washer (H). Line up the pre-drilled holes in the guide rail with the holes in the saw table (1) and secure in place using the M6

Fig 03-04

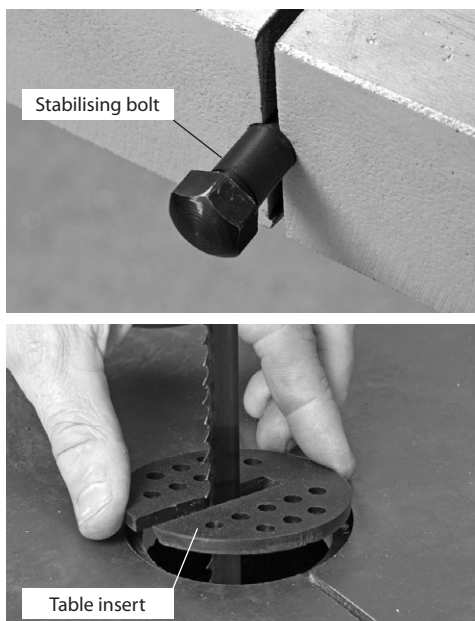
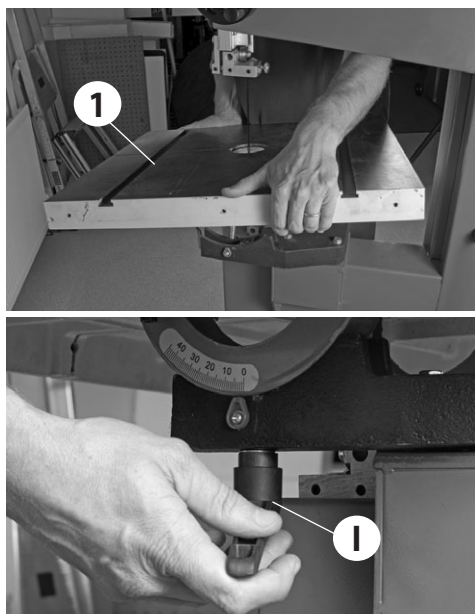


Fig 05-06



Hex bolts and washer (H), see fig 07. Locate the three M8 square head bolts (F), three M8 nuts/washer (G) and the fence guide rail (2). Introduce the square head bolts into the pre-drilled holes to the front of the table (1) and lightly screw on a washer and nut, see fig 08. **(NOTE: DO NOT TIGHTEN AT THIS POINT)**

Fig 07

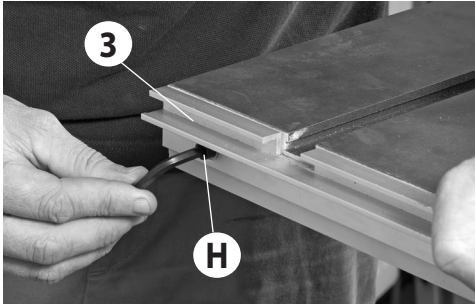
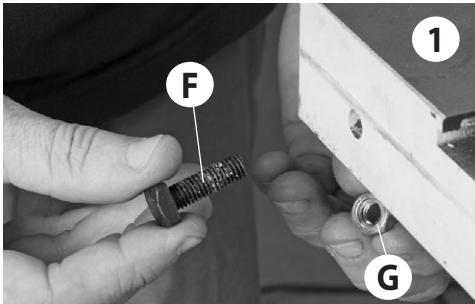


Fig 08



Step 3 Locate the fence guide rail (2), remove the capping plate from the right side of the fence guide rail by undoing the two Phillips screws and place safely aside. Slot the square headed bolts (F) into the guide rails "T" slot and slide on, see fig 09. Secure the

Fig 09



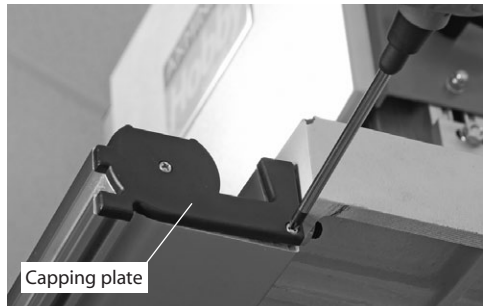
Guide rail "T" slot 9

Fig 10



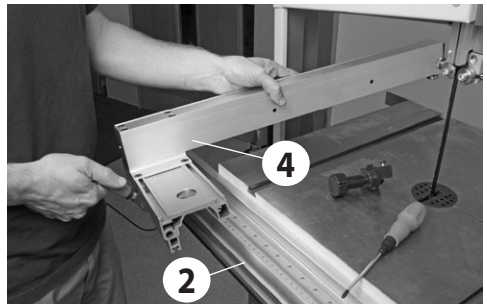
rail in place by tightening the three nuts beneath the table, see fig 10. Replace the capping plate you removed earlier, see fig 11.

Fig 11



Step 4 Locate the guide fence assembly (4), fit the fence over the back rail first then lowering the front clamp over the fence rail (2), see fig 12. Push down the locking lever and check the fence clamps up correctly, see fig 13.

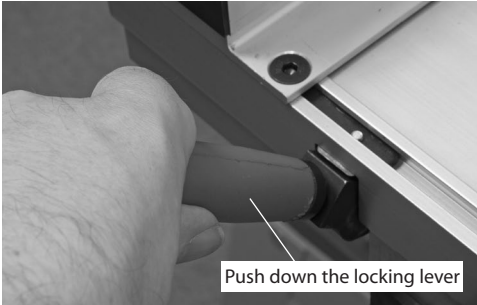
Fig 12



Continues Over...

Main Assembly

Fig 13



Step 5 Locate the micro adjuster assembly (6), remove the two Phillips screws and remove the mounting bracket from the assembly. Insert the mounting bracket into the 'T' slot to the right side of the fence casting assembly (4), see fig 14. Line up the holes in the micro adjuster (6) with the holes in the mounting bracket, making sure the pinion engages into the rack beneath the fence guide rail (2). Using the Phillips screws and washers you removed earlier secure the micro adjuster in position, see fig 15.

Fig 14

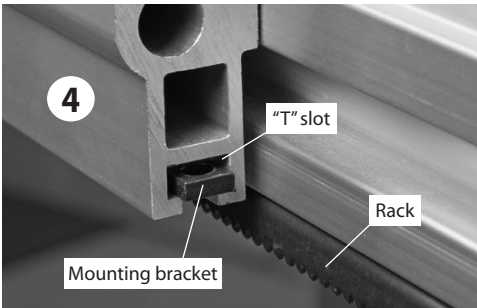
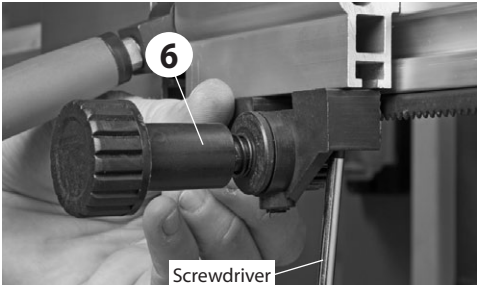


Fig 15



Check the guide fence is set parallel to the blade. Any slight discrepancy can be taken out by loosening the four Hex bolts that secure the blade of the guide fence to the clamping body, adjust and re-tighten, see fig 16. Larger discrepancies may require that the fence rail is angled slightly.

The dimensioning scale has an adjustable index plate set in the fence guide front clamp body to enable the scales to be zero read, see figs 17-18.

Fig 16

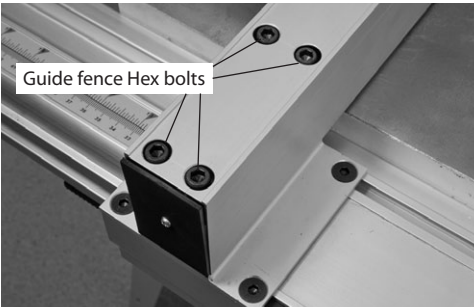
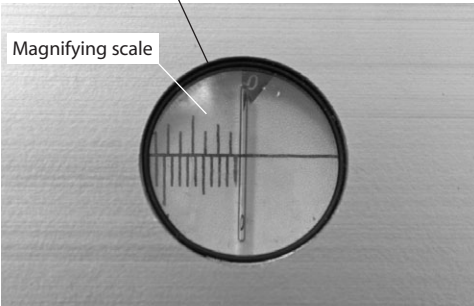
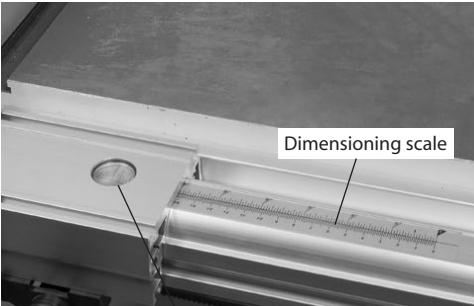
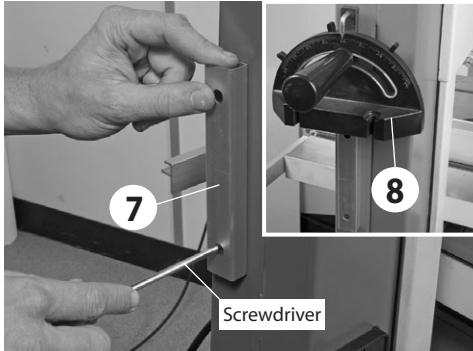


Fig 17-18



Step 6 Locate the mitre fence holder (7) and two Phillips screws. Line up the holes in the holder bracket with the pre-drilled holes in the bandsaw pillar and secure in place with the Phillips screws, see fig 19. Locate the mitre fence (8) and slide it into the holder (7), see fig 20.

Fig 19-20

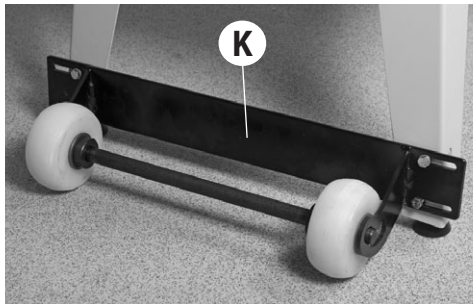


Optional Wheel Mobility Kit (508207)

The optional wheel kit provides mobility for the Hobby bandsaw. To assemble follow the instructions below:

Step 1 Locate the wheel mobility assembly (K), four M6 bolts, nuts, washers and lifting handle bracket (L). Line up the slotted holes in the wheel bracket (K) with the four slotted holes in the two front leg supports and secure using the M6 bolts, nuts and washers, see figs 21-22.

Fig 21-22

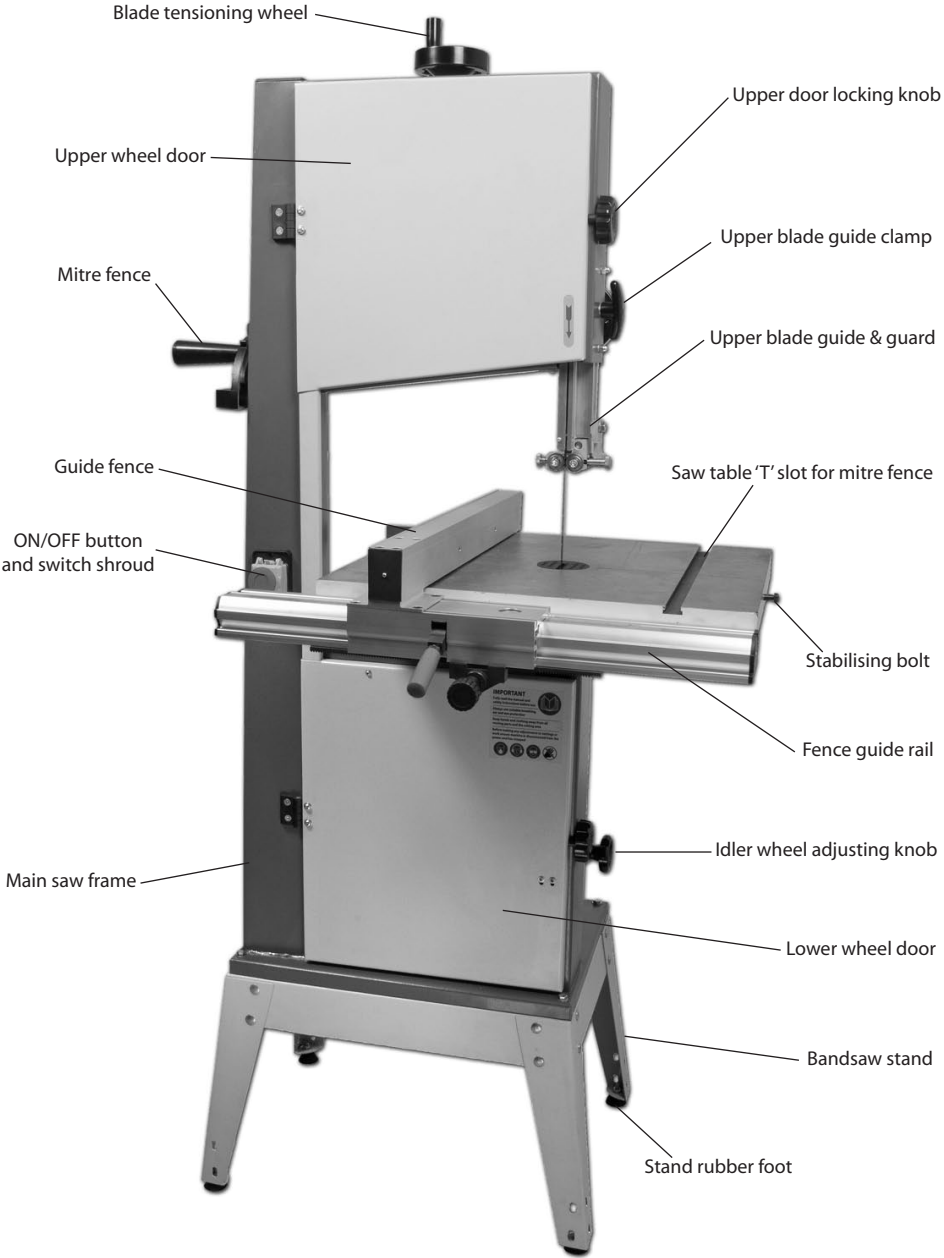


Step 2 Locate the lifting handle bracket (L) and two M8 coach bolts, nuts and washers (E-G). Remove the two coach bolts from the right support leg to the rear of the stand assembly, place safely aside, see fig 23. Line up the four holes in the handle bracket (L) with the four holes in the stand assembly and secure in place using the four coach bolts, nuts and washers (E-G), this includes the coach bolts you removed earlier, see figs 23-24.

Fig 23-24



Illustration and Parts Description



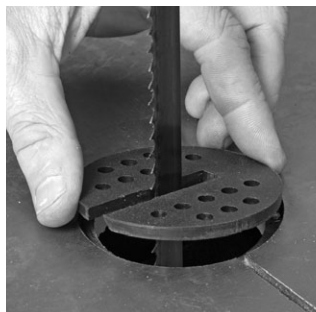
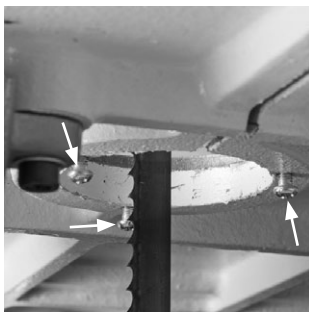
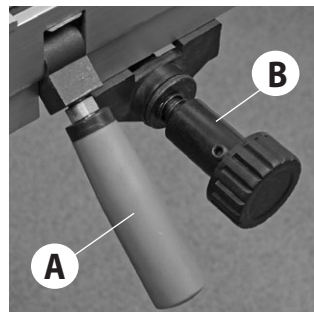


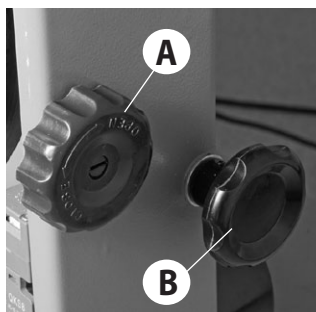
Table insert plate



Insert plate height
adjustment screws



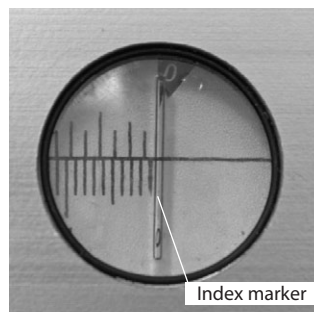
Fence locking lever (A)
Micro adjuster (B)



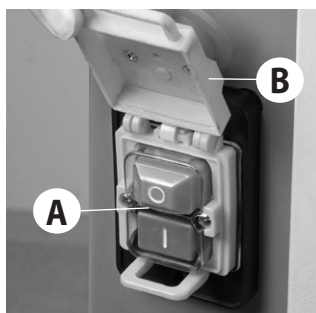
Lower door lock (A)
Idler wheel adjusting knob (B)



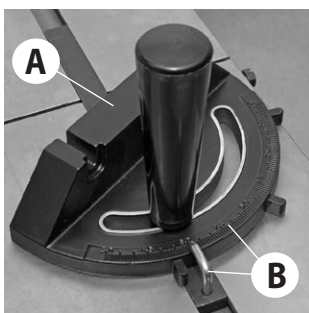
Mitre fence holder



Magnifying glass with index marker



ON/OFF NVR switch assembly (A)
Emergency stop shroud (B)

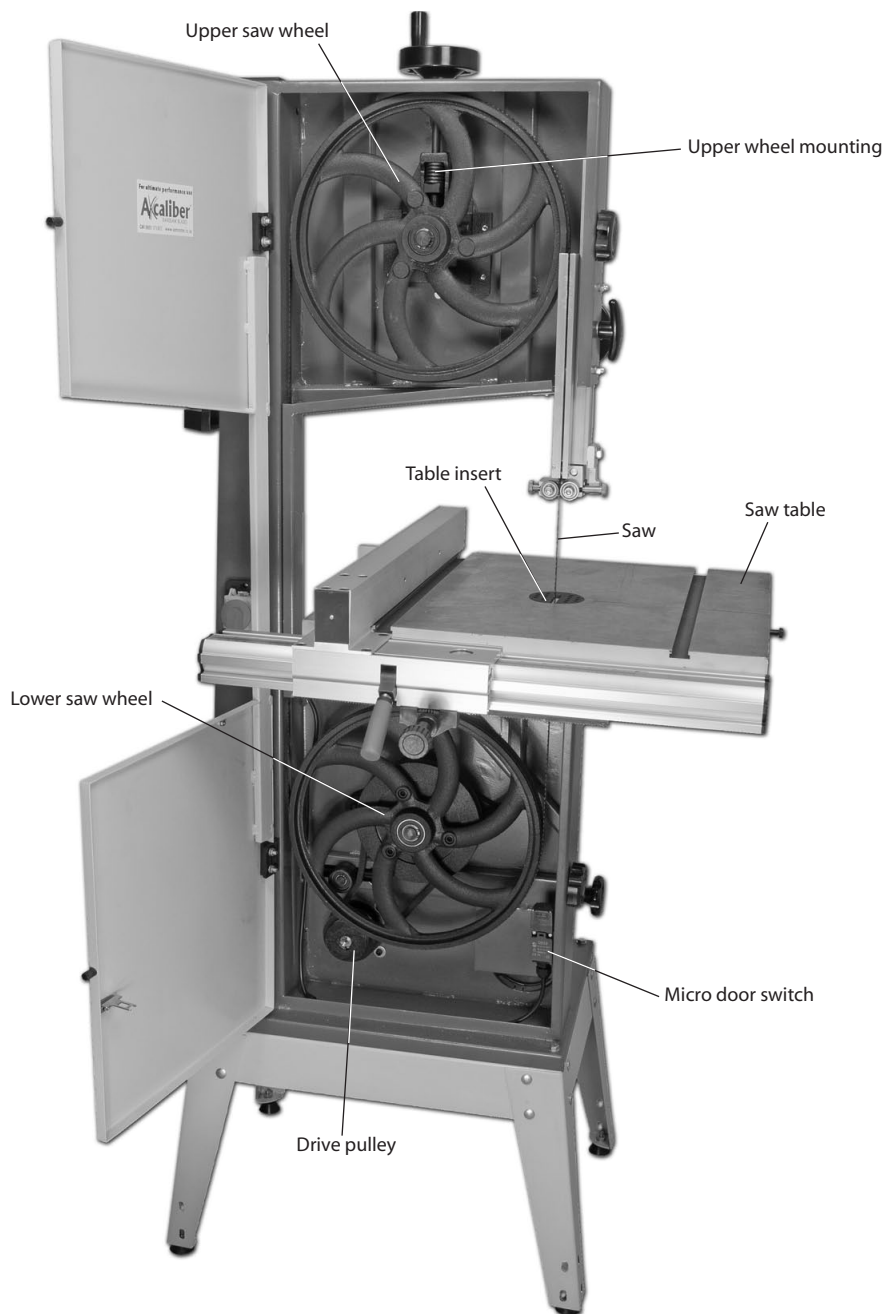


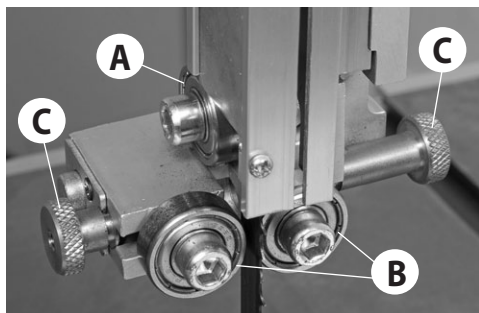
Mitre fence assembly (A)
Index and pointer (B)



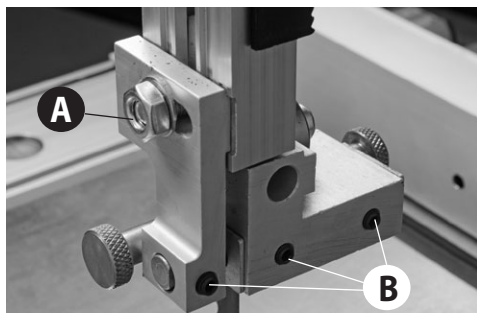
Stabilising bolt

Illustration and Parts Description

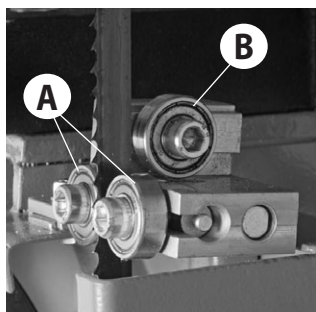




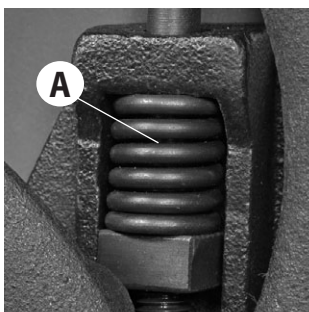
Rear thrust bearing (A), Upper bearing blade guides (B)
Blade guide bearing adjusting knobs (C)



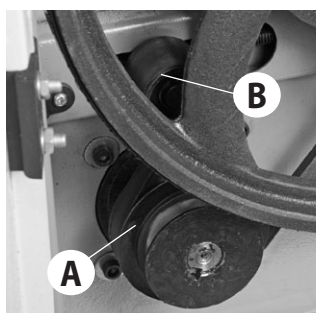
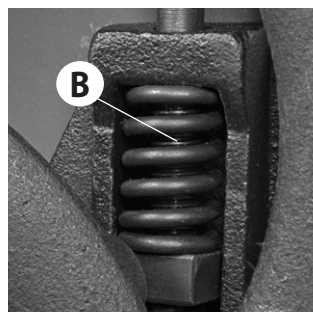
Fore and aft clamping bolt (A)
Lateral adjustment clamping grub screws (B)



Lower bearing blade guides (A)
Lower rear thrust bearing (B)
(Guard removed for clarity)



Blade tensioning spring (A), under tension
Blade tensioning spring (B) with no tension applied



Drive pulley (A)
Drive belt tensioning Idler wheel (B)

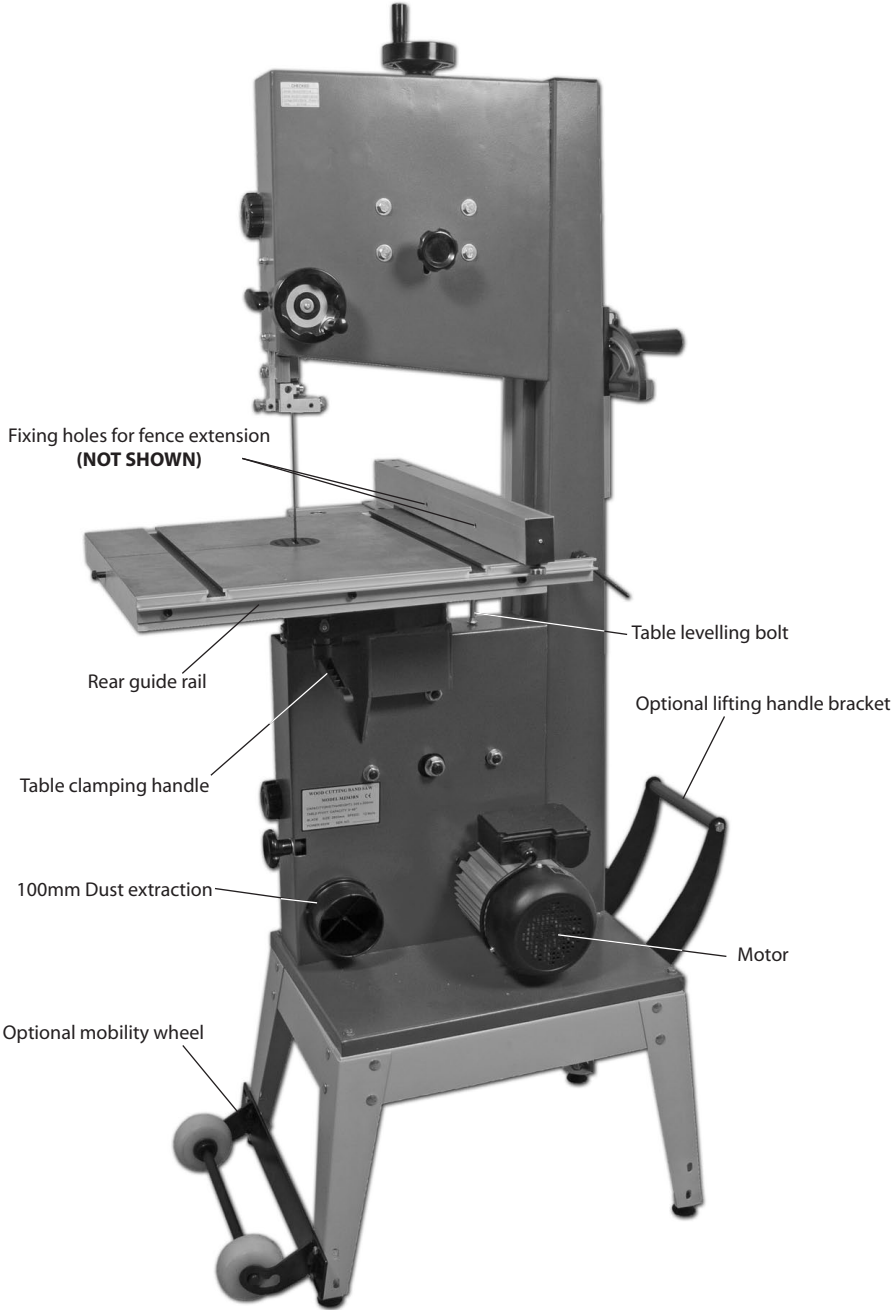


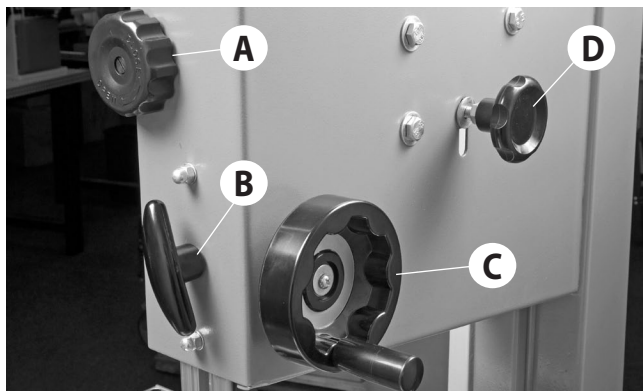
Idler wheel adjusting knob



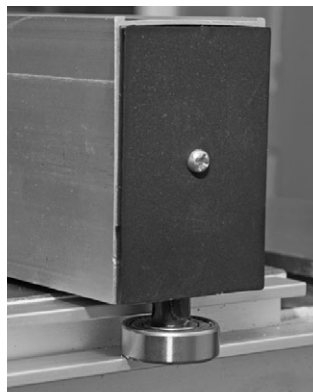
Micro door switch

Illustration and Parts Description

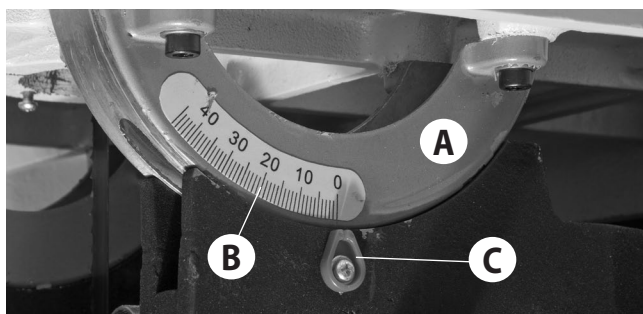




Upper door lock (A), Upper blade guide height clamp (B)
Upper blade guide height adjusting wheel (C), Tracking control knob (D)



Fence guide bearing



Tilt quadrant (A), Tilt scale (B), Tilt scale pointer and adjusting screw (C)

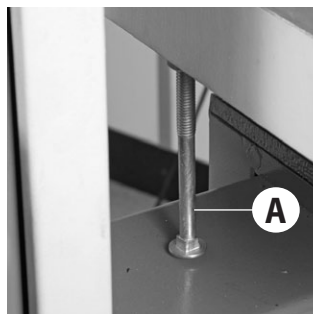
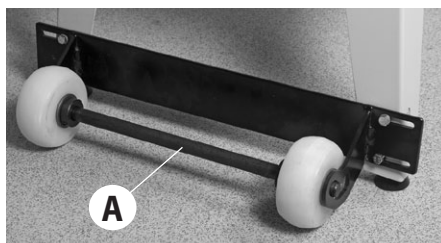
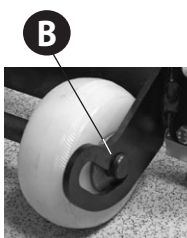


Table levelling stop bolt (A)



- (508207) Optional mobility wheel assembly (A)
- Wheel assembly engaged in the up position (B)
 - Bandsaw stand raised off the ground (C)
 - Bandsaw being moved to a new location (D)



Setting Up the Saw



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Tensioning and tracking the blade

Make sure both top and bottom blade guides are well clear of the blade.

Open the front covers fully, giving good access to the top compartment of the saw and good visibility into the bottom compartment (see page 14). For tracking the blade first adjust all bearing guides so that there well clear of the blade. Check that the blade is sitting approximately in the middle of the wheels, see fig 25. Apply some tension to the blade by turning the tensioning wheel clockwise, spin the top wheel by hand and check that the blade remains centrally on the tyre, see fig 26. If it does not, adjust the tracking by turning the tracking control at the rear of the head box, see fig 27. Viewed directly onto the tracking control wheel, turning clockwise should cause the blade to track to the rear of the tyre; anti-clockwise to the front, **DO NOT make large adjustments**).

Spin the top wheel again, check again. Continue until the blade tracks in the centre of the tyres with no appreciable to and fro movement. Tension the blade fully. A sideways push of about 7-8 lbs(3+kgs) in the middle of the blade should allow a 1/4" (6.5mm) distension. Check the tracking again, adjust if necessary. Check that the drive belt is tensioned correctly. If it is slack, apply 'take up' pressure to the belt by adjusting the 'Idler' pulley, using the knob at the side of the machine, see fig 28.

Connect the power to the machine. Stand clear and start the saw. Check that the saw is running smoothly, (no thumps, bumps, knocking or excessive vibration) and the blade appears to be tracking correctly (in one place). You can check this by holding a marker, e.g. a pencil, close to the back of the blade (approach from the back of the blade only) and check that the gap remains constant.

If it doesn't, adjust the tracking until it does. Make very small adjustments and wait for the saw to react before you adjust again, sometimes the reaction is not instantaneous. Once you are satisfied that the tracking is correct switch the machine off and allow it to run to a stop.

Fig 25

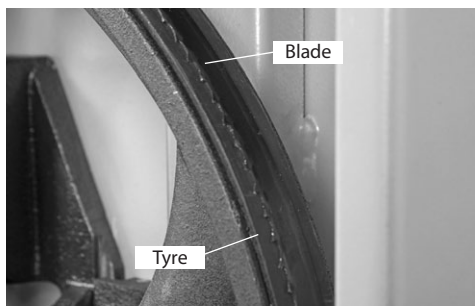


Fig 26



Fig 27



Fig 28



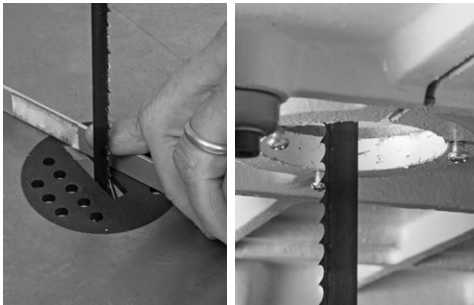


DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Checking the table insert plate

Place a straight edge over the insert plate and check it is level with the surface of the table, see fig 29. If not, adjust the insert plate levelling screws beneath the table, see fig 30, until correct.

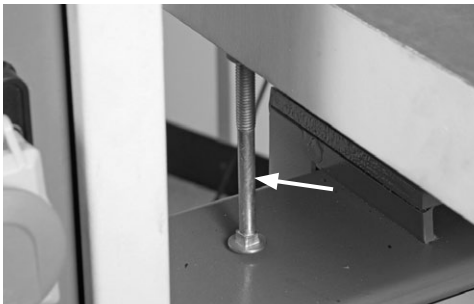
Fig 29-30



Checking the table is square

Loosen the two clamping handles beneath the table clamping the tilt mechanism, turn the table hard against its stop. This is a bolt with a lock nut screwed into the underside of the table, see fig 31. The head of the bolt acts as a stop when it strikes the machine frame. Tighten the clamping handles.

Fig 31



Make sure the upper blade guide is raised as high as possible. Place a square on the table and move it up against the blade (behind the teeth), see fig 32. Check that the blade is perpendicular to the table. If it is not, try resetting the table. If it is still not correct, loosen the table locking handles and adjust the table stop nut until perpendicularity is achieved, see fig 33. Tighten the lock nut and then re-check. When you are satisfied that the table is set correctly, check that the pointer of the tilt gauge reads zero, if not, adjust it, see fig 34. Retighten the table clamping handles.

Fig 32

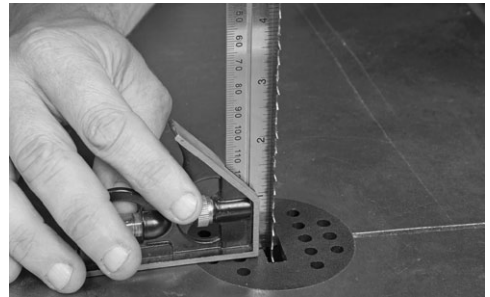


Fig 33



Fig 34



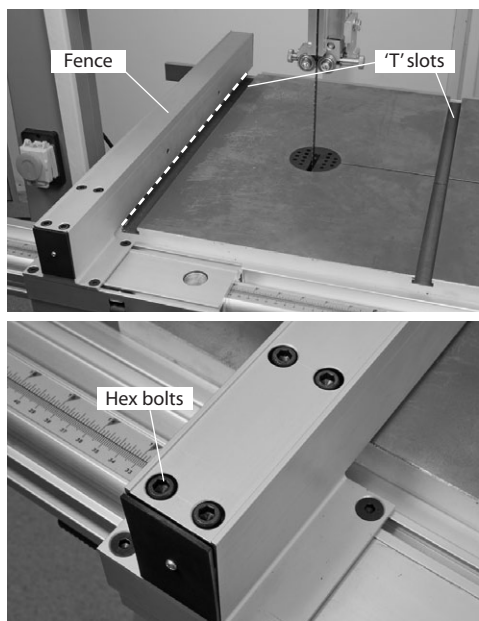
Setting Up the Saw

Setting the Fence

To make sure the guide fence is at 90° line up the guide fence with the edge of the table's 'T' slot, see fig 35. If you find that the fence is out of alignment follow the steps below:

- Clamp down the fence by pushing the locking lever down.
- Loosen the 4 Hex bolts that secure the fence rail and adjust until the fence is in alignment with the 'T' slot, then re-tighten the bolts, see fig 36.
- Replace the extension fence.

Fig 35-36



Setting the Blade Guides



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

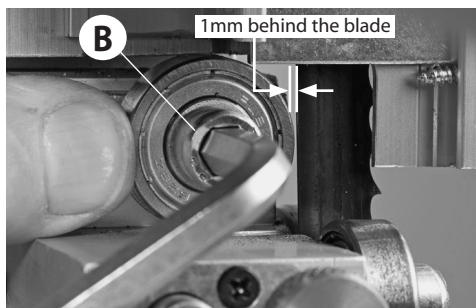
Lower the upper blade guide to approximately 1 1/2" (38mm) above the table. Clamp in place.

Loosen the nut (A) holding the guide assembly in place and adjust the fore and aft position so that the leading edges of the side guide bearings are approximately 2 mm behind the gullets of the saw blade. Re-tighten the nut, see fig 37. Loosen the cap head bolt (B) that clamps the rear thrust bearing in position and adjust the thrust bearing to approximately 1mm behind the blade, re-tighten the bolt, see fig 38. The blade should lineup with

Fig 37



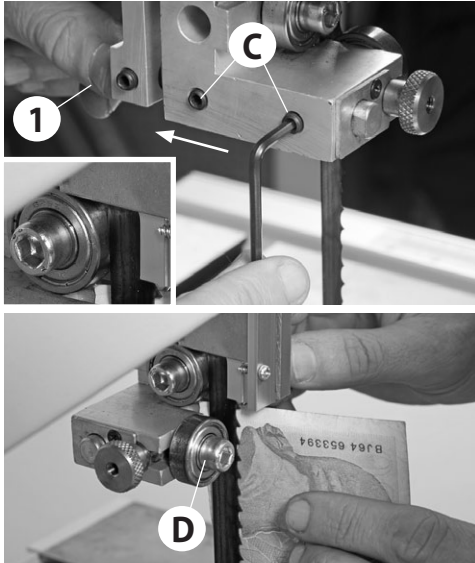
Fig 38



the centre of the thrust bearing, if not loosen the two grub screws (C) and move the upper blade guide assembly in until correct, see fig 39. Retighten the grub screws. Loosen the two cap head bolts (D) holding the guide bearings and move to approximately 0.5 mm from each side of the blade.

NOTE: A five pound note is approximately 0.5mm thick, slide a note between the blade and guide bearing, turn the adjusting knob (1), until the guide bearing is set to the correct thickness. Re-tighten the bolts (D), see fig 40. Repeat for the other guide bearing. Gently push the blade back against the thrust bearing (use a scrap of wood,) and check that the side bearings are still behind the teeth

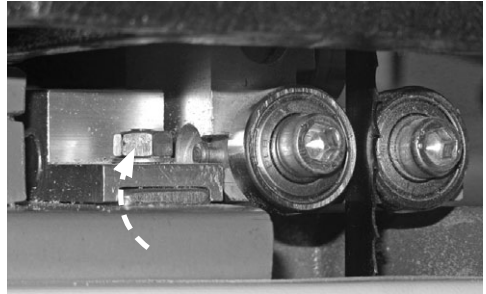
Fig 39-40



of the blade. Beneath the table, remove the safety guard and place aside; loosen the nut holding the lower blade guide assembly in place and position similarly to the upper guide assembly, see fig 41.

Note: The guide bearing should always be set behind the teeth of the saw.

Fig 41



Rotate the top wheel by hand, at this point. None of the bearings should come into contact with the blade—only when in use. Re-tighten the nut. Adjust the lower blade guides, and set them similarly to the upper guides, (D) using an Hex key to release and tighten the clamping bolts. Adjust the lower thrust bearing similarly to the upper thrust bearing. When all adjustments have been made, recheck that when the blade is pressed back against the thrust bearing, both the upper and lower side guides are still behind the teeth of the saw. Replace the safety cover. When all adjustments are complete re-connect the power, switch the saw on, allow to run for several minutes, check that the blade is still tracking correctly, there is no excessive vibration, etc. Switch off. **The saw is ready to be used.**

Operating Instructions

1. Make sure you have read and fully understood the general instructions and safety precautions that are printed in the preceding pages of this manual.
2. Before connecting the machine to the supply; check the tool for obvious signs of damage, paying particular attention to the plug and the power cable. Rectify or have rectified any damage you discover. Check that the blade you are using is the correct one for the job in hand. Change the blade if necessary. Check the blade is not damaged; is clean, sharp, tracks properly and is correctly tensioned.
3. Set the upper blade guide to approximately 12mm (1/2") above the height of the work piece.
4. Check especially on site, that there are no foreign

objects e.g. old nails, screws, small stones etc embedded in the material you are about to cut.

5. Check that all accessories, tools etc., that have been used to set the machine up, are removed and set carefully aside or stowed away correctly.

6. Ensure the machine is switched off. Plug the power cable into a correctly rated switched socket outlet. If extension leads are being used, check these for damage, do not use if damaged; if you are working outside, check that any extension cables in use are rated for outside work. Switch on. Allow the saw to run up to speed.

7. Make sure that the material you are about to cut is within the machine's capacity, and the cut you are about to make is within the blades' capabilities, e.g.

Operating Instructions

do not try to cut a 1" radius curve using a 5/8" blade.

8. Make sure the blade is not in contact with the material when you start the saw. Start the cutting operation. Do not try to cut too quickly; the correct cutting speed, if one could be so precise, would never see the blade pushed back against the thrust bearing, the saw would cut and clear the saw line at the rate the work piece was fed into it. If you notice that you require more and more pressure to effect the cut, and the blade is in continual contact with the thrust bearing, the chances are the blade is becoming blunt. Check and change if necessary.

Do not let go of the work piece, if you have to change your grip, make sure one hand is holding the material at all times.

9. If you are cutting long pieces of material think about sawing cutouts (i.e. a saw cut from the edge of the material to the saw line) along the saw line so that you can discard the off cuts as you progress down the saw line.

10. Observe the old woodworkers' adage of never allowing your hand/fingers within one handbreadth of the blade.

11. If you have to cut very small pieces of material, arrange or manufacture some form of 'shoe' to carry the timber. If the work piece is exceptionally small,

find something to use as a sacrificial carrier and mount the work piece on it with double sided tape, or similar.

12. Remember to check the blade tension after a new blade has been 'working' for 30-60 mins. The blade will 'stretch' slightly when new.

13. Do not release the tension on the saw blade when work is complete. The blades and the main saw frame do not respond kindly to constant changes in stress and tension. Only release the tension to change the blade or if the blade is to be removed because the machine is to be 'mothballed' for a lengthy time period. The blade in tension over a long period of non-use will cause the tyres to develop 'flat' spot. Open the saw cut, either by pulling apart or driving a wedge in close to the back of the blade. Try to wriggle the blade free of the saw. If this is not possible; check that the saw is free in the cut, start the saw, allow it to run up to speed and 'cut out' as quickly as possible. The removal of the 'off cut' may well prevent the saw jamming again if you resume the original cut).



**WARNING! IF THE SAW JAMS!
SWITCH OFF IMMEDIATELY.**

Changing the Saw Blade



**DISCONNECT THE SAW FROM
THE MAINS SUPPLY!**

Put the table back to the level position if it has been tilted. Set the upper blade guide assembly approximately midway in the throat. Open the top and bottom covering doors. Remove the table insert.

Remove the table stabilising bolt, slacken the blade tension by turning the blade tensioning wheel anti-clockwise, until the blade can be easily slipped off the wheels. Remove the blade carefully, "wiggling" it clear of the upper blade guard and through the plastic lower blade guard and out through the slot in the table.

NOW is an excellent time to clean out the interior of the machine; remove the impacted 'crud' from the tyres, apply a little light oil to the screw threads of the blade and drive belt tensioners and the tracking control. The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the drive belt tensioner in its slot could likewise be lightly oiled. If you are fitting a new blade, it will have been supplied to you "folded", bound together in this configuration with tape or tie wrap.



**WARNING! BE VERY CAUTIOUS
WHEN YOU "UNFOLD" THE BLADE;
IT TENDS TO 'SPRING' OPEN, BLADE
AND TEETH GOING EVERYWHERE.**

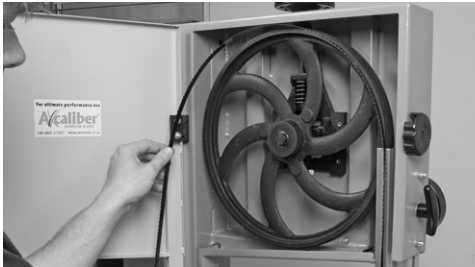
Also check that the blade did not “unfold” inside out. i.e. looking at the right side front of the loop, the teeth should be on the front of the blade and pointing down. If you can’t arrive at this view, turn the blade inside out from its current position and look again.



MAKE SURE THE BLADE TEETH ARE POINTING DOWN!

Open up all blade guides so that they are clear of the blade. Hold the blade approximately midway on either side of the loop and feed it into the table slot. When you get to the table insert cutout void, work the left side of the loop into the slot in the guard in the neck of the main saw frame. “Wriggle” the right hand side of the blade through the slot in the plastic lower guard and through the guard on the upper blade guide assembly, see figs 42-43. Ease the blade over the wheels and locate the blade in the blade

Fig 42-43



guides.

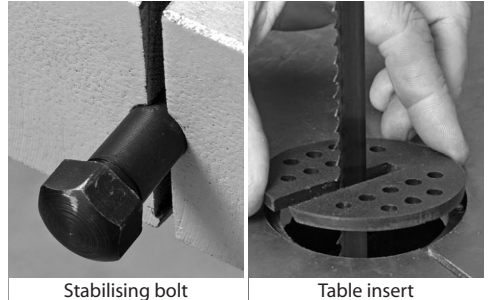
Apply some tension to the blade. Turn the top wheel by hand, see fig 44, to ensure the blade will not skip off the wheels and the blade is travelling in the blade guides. Apply a little more tension and check by once again spinning the upper saw wheel by hand. When

Fig 44



you are sure that the blade is “ON” and stable, re-fit the table stabilising bolt and re-fit the table insert, see fig 45-46. Loosen the upper blade guide clamp and set the upper blade guide assembly so that the top of the blade guide is level with the centre of the top drive wheel, see fig 47. Re-tighten the clamp. Now carry out the procedures as detailed in Setting up the saw.

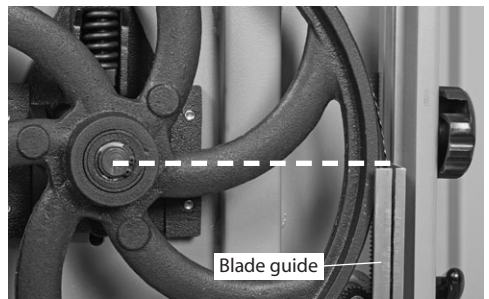
Fig 45-46



Stabilising bolt

Table insert

Fig 47



Blade guide

Set the top of the blade guide until it is level with the centre of the top drive wheel.

Changing the Blade Speed



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

The bandsaw drive pulley has two speed positions, see fig 52. To change the speed from 600 to 720m/minute, follow the instructions below.

Open the upper and lower doors, see fig 48. Release the tension on the drive belt by turning the Idler

Fig 48

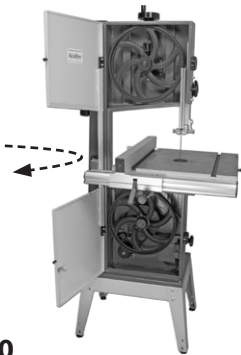
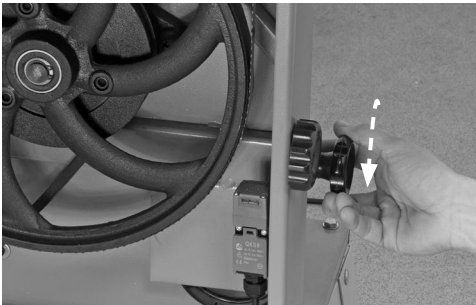


Fig 49-50



wheel adjusting knob anti-clockwise, thus moving the idler wheel back, see figs 49-50. With the drive belt tension removed, very carefully reposition the drive belt, see fig 51. **NOTE: Make sure the belt is seated correctly in one of the drive pulley grooves.** With the belt repositioned, turn the Idler wheel adjusting knob clockwise to re-tension the belt, enough to prevent the belt from slipping when in operation, but not tight to cause the belt to get hot.



WARNING! BE VERY CAREFUL WHEN MOVING THE BELT NOT TO TRAP YOUR FINGERS!



NOTE: MAKE SURE THE DRIVE BELT IS NOT TENSIONED TOO TIGHTLY WHICH WILL CAUSE THE BELT TO GET HOT.

Fig 51

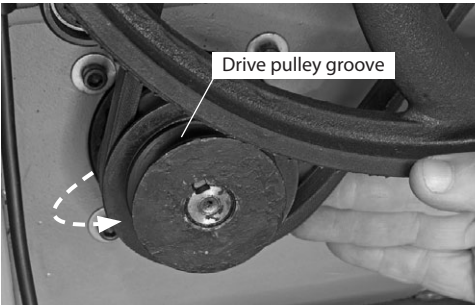
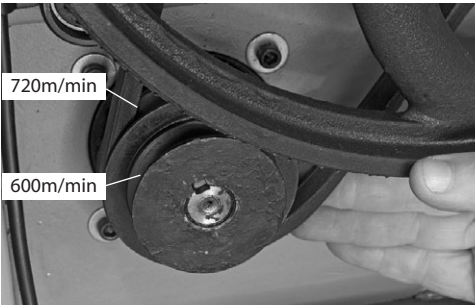


Fig 52



The picture above shows the two drive pulley positions with the speeds available.

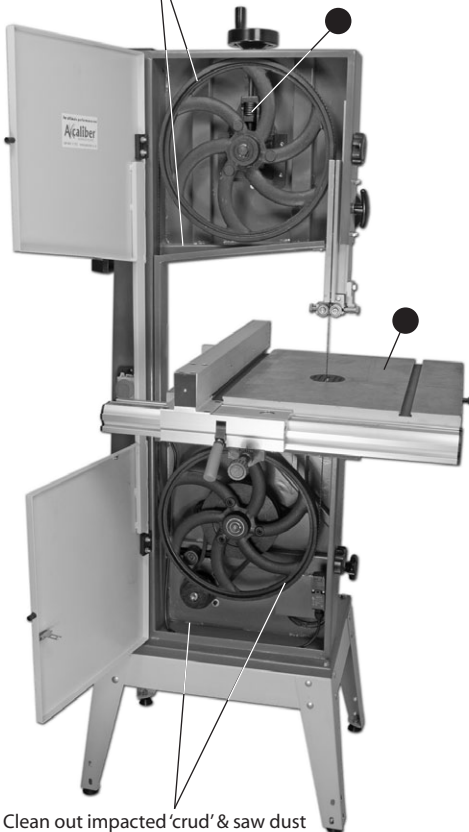
Daily

- Keep the machine clean.
- Check the saw blade for missing teeth and cracks, see fig 53.
- Spray oil the bare metal surfaces.

Weekly

- Open the top and bottom wheel covers and clean out all saw dust.

Clean out impacted 'crud' & saw dust

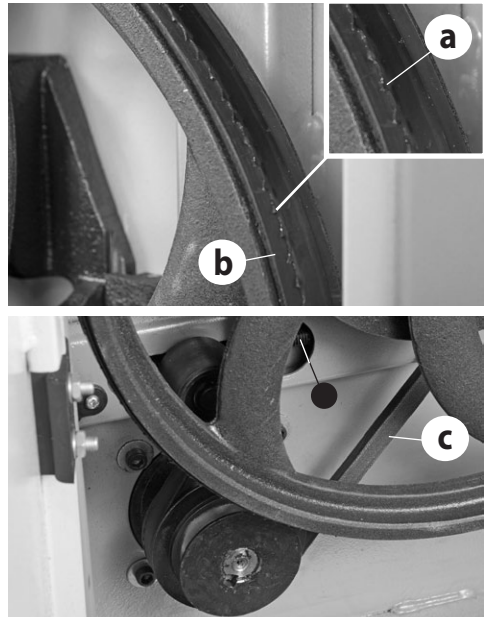


Clean out impacted 'crud' & saw dust

Monthly

- Open the lower and upper door and check the condition of the tyres and the drive belt, see figs 53-54.
- Clean impacted 'crud' from the tyres, apply a little oil to the screw threads of the blade and drive belt tensioners. **DO NOT USE OIL** near the belt.
- The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the belt tensioner in its slot could likewise be lightly oiled.
- Using an air line (**wearing goggles**) blow out the motor casing.

Fig 53-54

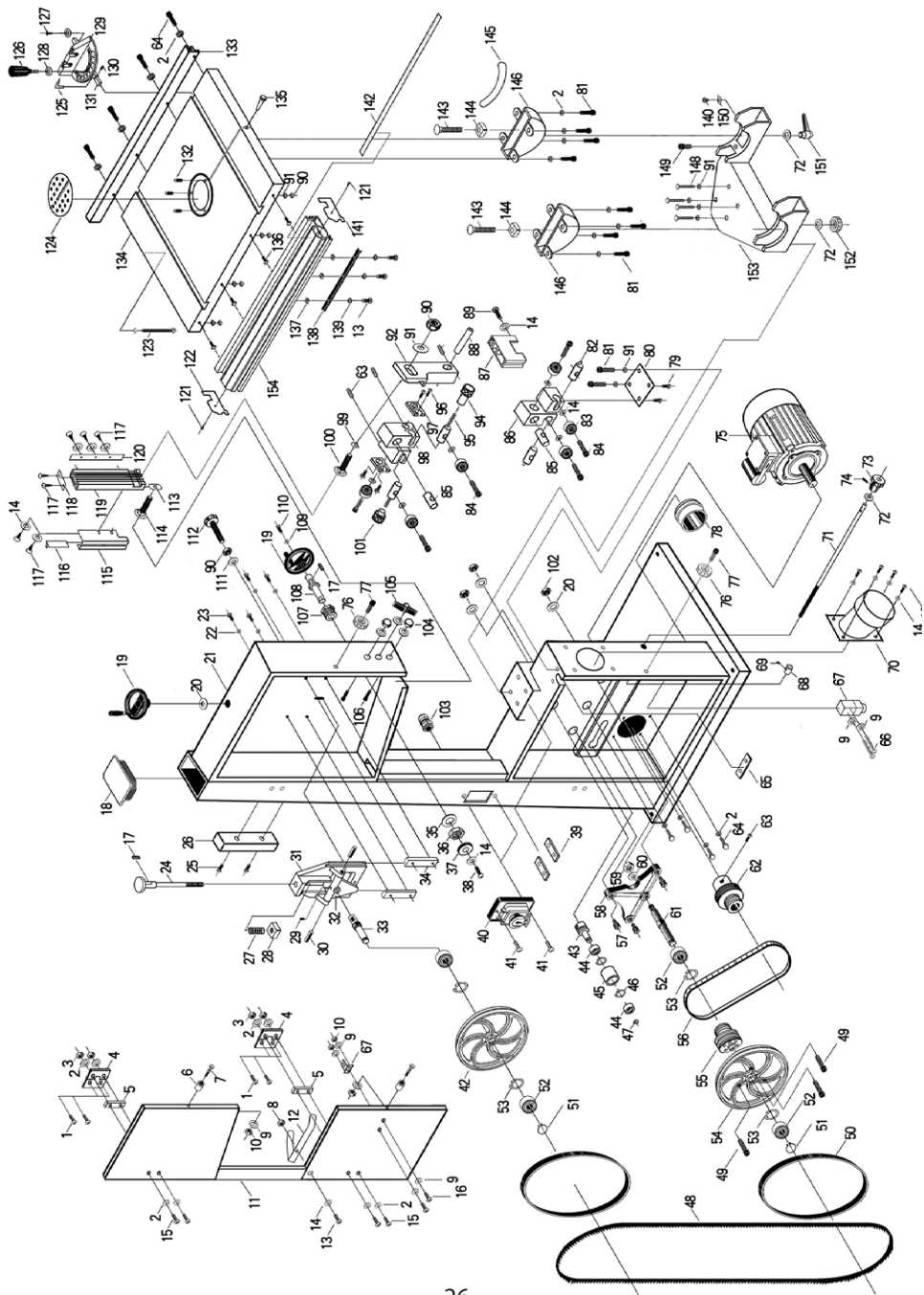


- Check for missing teeth (a)
- Check the condition of the tyres (b)
- Check the condition of the drive belt (c)



Oil

Parts Breakdown/List



Parts Breakdown/List

NO.	Description	Q'TY
1	Countersunk head screws M6X16	4
2	Washer ø6	23
3	Nut M6	4
4	Hinge	2
5	Hinge plate	2
6	Knob sleeve	1
7	Knob screw	1
8	Nut M5	1
9	Washer ø4	4
10	Nut M4	4
11	Door	1
12	Leaf spring	1
13	Semicircle head screw M5x10	5
14	Washer ø5	17
15	Semicircle head screw M6x20	4
16	Semicircle head screw M4x12	2
17	Flat key(A) 4x16	2
18	Column	1
19	Hand wheel	2
20	Washer ø12	4
21	Saw body	1
22	Big Washer ø6	5
23	Bolt M6X20	4
24	Adjusting screw rod	1
25	Countersunk head screws M4X8	2
26	Aluminium sheet	1
27	Spring	1
28	Square nut	1
29	Elastic cylindrical pin M5X25	1
30	Steel dowel	2
31	Upper wheel saddle	1
32	Small triangular frame	1
33	Upper wheel axle	1
34	Guide board saddle	2
35	Washer ø22	1

36	Thin nut M22X1.5	1
37	Lifter wheel	1
38	Semicircle head screw M5x8	1
39	The connecting nut plate	1
40	Switch KJD12	1
41	Semicircle head screw M4x10	2
42	Upper wheel	1
43	Axle pressure	1
44	Bearing	2
45	Press wheel	1
46	Circlips for holes ø28	2
47	Circlips for shaft ø12	1
48	Blade	1
49	Socket head cap screw M6X30	3
50	Rubber belt for saw wheel	2
51	Circlips for shaft ø17	2
52	Bearing 80203	4
53	Circlips for holes ø40	4
54	Lower saw wheel	1
55	A passive belt wheel	1
56	Belt	1
57	Adjusting screw	3
58	Big triangle frame	1
59	Nut M16	1
60	Washer ø16	1
61	Lower wheel axle	1
62	Motor wheel	1
63	Screw M6X8	4
64	Hexagon head screw M6x16	7
65	The lower guide plate	1
66	Semicircle head screw M4x30	2
67	The micro switch QKS8	1
68	Fix bush	1
69	Screw M5X10	1
70	Dust cover	1
71	Press wheel pole	1

Parts Breakdown/List

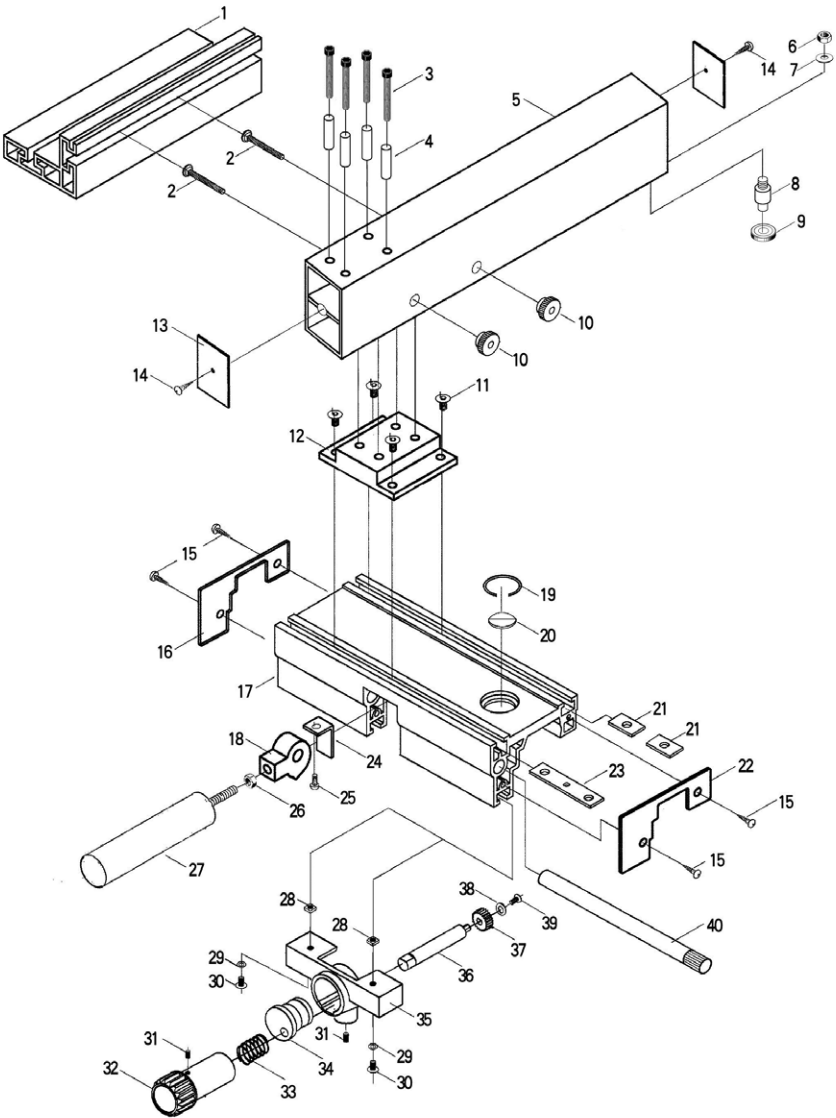
72	Washer ø10	3	109	Washer	1
73	Wave wheel	1	110	Six angle locking nail M5X10	1
74	Elastic cylindrical pin M3X20	1	111	Big Washer ø8	1
75	Motor	1	112	Wave hand	1
76	Knob	2	113	Locking plate	1
77	The knob shaft	2	114	Carriage bolt M8x20	1
78	The dust cover	1	115	Upper blade guard	1
79	Six countersunk head screws M6	2	116	Sliding plate	1
80	Dead plate	1	117	Tapping screw M5X10	7
81	Six countersunk head screws M6	10	118	Spacing board	1
82	Adjusting shaft 2	2	119	Connecting board	1
83	Bearing 80028	6	120	Rack	1
84	Cap screw	6	121	Tapping screw M4X16	4
85	Mount shaft 1	2	122	Side insert	1
86	The lower guiding seat	1	123	Coach screw M12X90	1
87	The lower guide shield	1	124	Table insert	1
88	Upper guide shaft	1	125	Pointer	1
89	Socket head cap screw M5X16	1	126	Big handle	1
90	Nut M8	4	127	Semicircle head screw M6x8	1
91	Washer ø8	9	128	Washer	1
92	The guide rod wrench	1	129	Mitre gauge	1
			130	A locking M5X6	1
94	Length adjusting nut	1	131	Guide plate	1
95	The locking shaft	2	132	A locking M4X8	3
96	Chamfer head screw M3X8	4	133	Rear fence rail	1
97	Guard	2	134	Work table	1
98	The guide rod seat	1	135	A pin	1
99	Locking plate	1	136	Coach bolt M8X20	3
100	Carriage Bolts M8X16	1	137	Nut M5	3
101	Short adjusting nut	1	138	Rack	1
102	Nut M12	3	139	Tooth washers 5	3
103	Pull off M20X1.5	1			
104	Nut M6	2	141	Side insert	1
105	T shaped handle	1	142	Dividing rule	1
106	dog screw M6	2	143	Coach screw M10X60	2
107	Eccentric bush	1	144	Slider	2
108	Eccentric shaft	1	145	Rotation scale	1

Parts Breakdown/List

146	The table is rotating frame	2
148	Semicircle head screw M8x60	4
149	Six angle locking nail M6X10	1
150	Table pointer	1

151	T shaped handle M10	1
152	Take	1
153	The work table fixed seat	1
154	Side guards	1

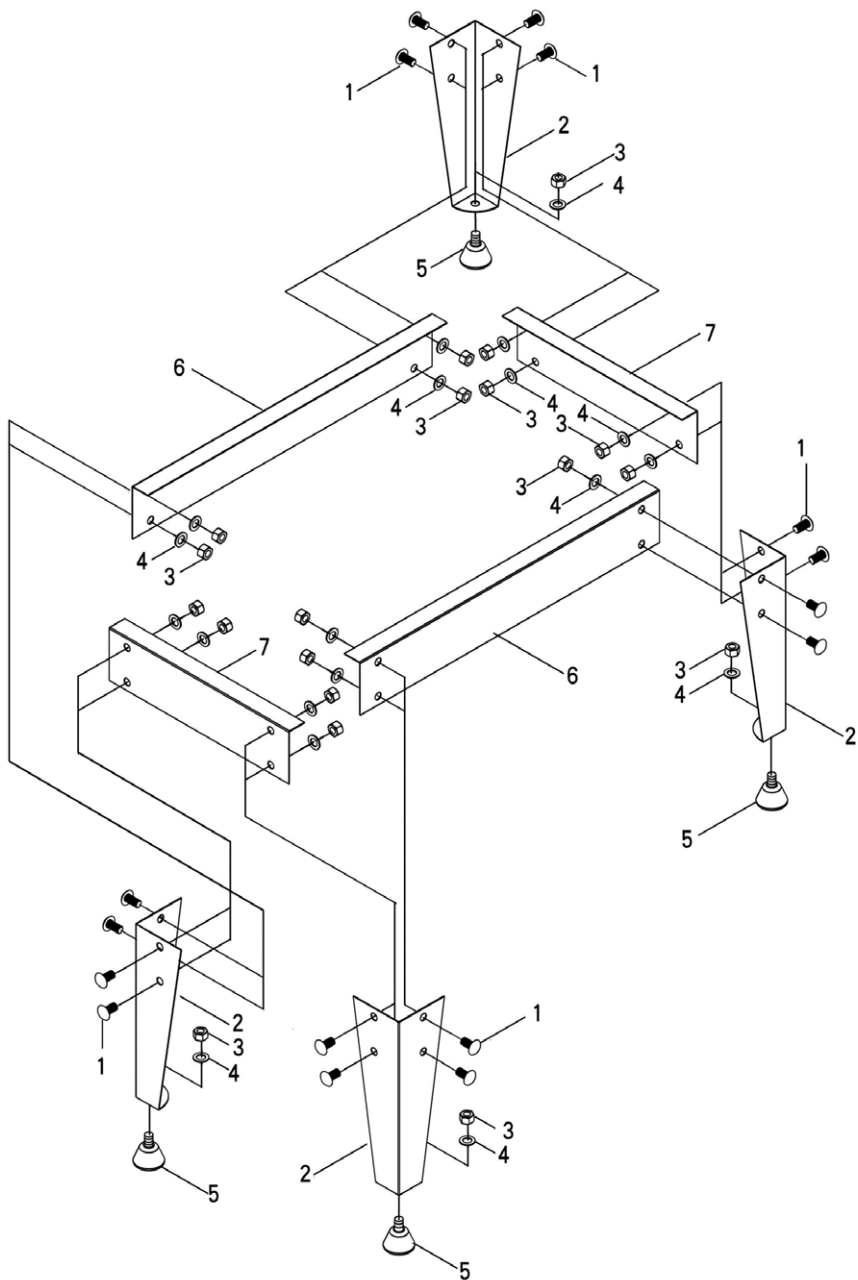
Parts Breakdown/List



Parts Breakdown/List

NO.	Description	Q'TY
1	Fence "L" shape	1
2	Carriage screw M6x70	2
3	Six countersunk head screws M6	4
4	Bushing bearing	4
5	Fence	1
6	Hexagon nut M5	1
7	Washer ø5	1
8	Bearing bar	1
9	Bearing 80027	1
10	Wing nut	2
11	Sunk head screw M6x12	4
12	Fence plate	1
13	End cap, lock handle	2
14	Tapping screw	2
15	Taping screw ST4.2x12	4
16	End cap, fence carrier	1
17	Fence carrier	1
18	Eccentric shaft	1
19	Circle ring	1
20	Len	1

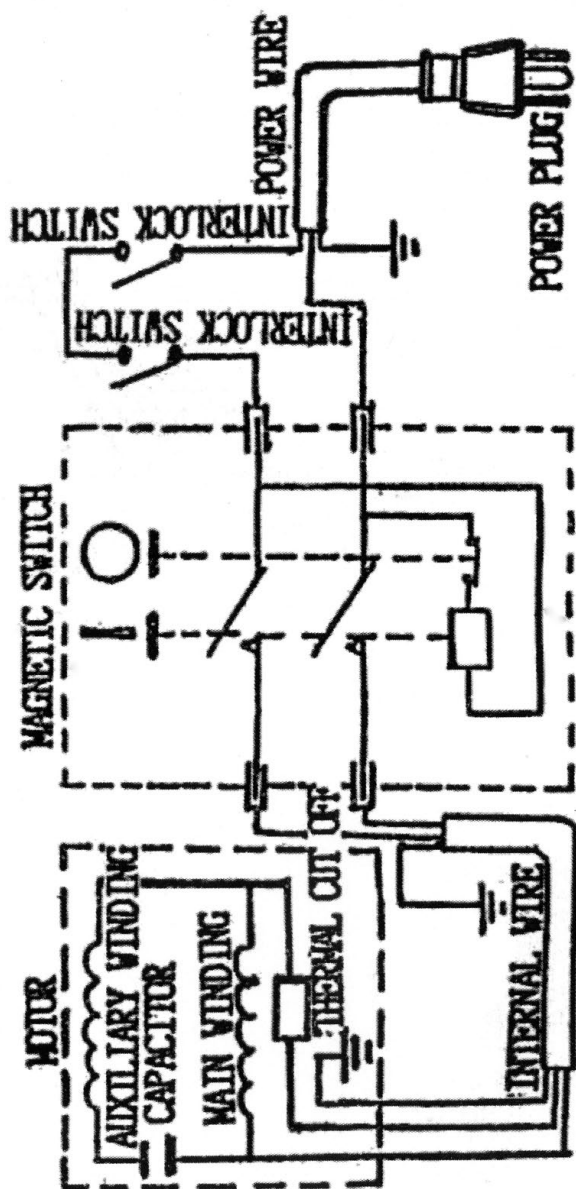
21	Screw guide	1
22	End cap, fence carrier	1
23	Screw guide	1
24	Lock plate	1
25	Pan head screw M4x10	1
26	Hex nut M8	1
27	Lock handle, fence	1
28	T-nut M5	2
29	Washer 5mm	2
30	Pan head screw M5x10	2
31	Set screw M6x6	1
32	Fine adjusting handle	1
33	Coil spring, fine adjust	1
34	Eccentric arbor	1
35	Frame, fine adjust gear	1
36	Gear rod, fine adjust	1
37	Core gear	1
38	Washer 4mm	1
39	Sunk head screw M6x12	1
40	Lock shaft, fine adjust	1



Parts Breakdown/List

NO.	Description	Q'TY
1	Hex bolt M8X16	16
2	Support parts	4
3	Nut M8	20
4	Washer ø8	20
5	Rubber legs M8X15	4
6	Connected plate (1)	2
7	Connected plate (2)	2

Wiring Diagram



Standard Axcaliber Bandsaw Blades

2,616mm (103") x 0.025"

• Suitable for Axminster Hobby HBS350N

TPI	Width	Code
6 skip	1/4"	508241
6 skip	3/8"	508242
10 reg	3/8"	508243
6 skip	1/2"	508244

Axcaliber Ground Tooth Bandsaw Blades

Axcaliber GT bandsaw blades are made from a high carbon content steel band with diamond ground teeth. This gives a much higher level of accuracy in the tooth formation, plus they stay sharp for at least 30% longer than normal, milled tooth blades. The result is a smoother cut for much longer, a really useful step forward for bandsaw blades.

2,616mm(103")

TPI	Width	Code
10	3/8"	508245
4	1/2"	508246
6	1/2"	508247
10	1/2"	508248
4	3/4"	508249

Axminster Hobby Series HBS310 & 350N Wheel Kit

An optional wheel kit to provide mobility for the Axminster Hobby Series HBS310N and HBS350N bandsaws. Includes a bolt-on handle for the bandsaw frame.



	Code
HBS310 & 350N Mobility Kit	508207

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engineer



Compressors and tools for home or
workshop use; durable and great value



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We will repair or replace at our discretion and will collect only from a UK mainland address, irrespective of the original delivery address.

The Guarantee assumes that you have bought the correct machine for the required operation, in accordance with our guidelines; have operated and maintained it in accordance with the instruction manual; and that all cutting machines will be used with a blade which is sharp and serviceable at all times. It does not cover consumable items purchased with the original product, including original blades or abrasives.

Normal wear and tear; misuse, abuse and neglect are excluded and the machine should not have been modified in any way. Please do not attempt to service the product without first contacting us; we are happy to guide you but failure to do so may invalidate the guarantee.

The Guarantee is transferable from owner to owner in the first three years but you must have original proof of purchase. Should we need to replace a machine in the first three years the guarantee will still continue to be effective from the original purchase date.

Full Terms and Conditions can be found at axminster.co.uk/terms

This guarantee does not affect your statutory rights.

For more information visit axminster.co.uk/3years



Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local recycling centre and place into the appropriate recycling bin.

Only for EU countries



Do not dispose of electric tools together with household waste material. In observance of European Directive 2002/96/EC on waste electrical and electronic equipment and its implementation in accordance with national law, electric tools that have reached the end of their life must be collected separately and returned to an environmentally compatible recycling facility.

Axminster Tools & Machinery Ltd
Weycroft Avenue, Axminster, Devon EX13 5PH

axminster.co.uk