holzstar
Holzbearbeitungsmaschinen

Instruction Manual

Wood Band Saw

- HBS 231-1
- HBS 261-2
- HBS 321-2
- HBS 361-2

HBS 231-1

HBS 261-2

HBS SERIES

Imprint

Product identification

Wood Band Saw	Item number
HBS 231-1	5902423
HBS 261-2	5902426
HBS 321-2	5902432
HBS 361-2	5902436

Manufacturer

Stürmer Maschinen GmbH
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Information about the operating instructions

Genuine operating instructions
according DIN EN ISO 20607:2019

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Author: FL/MS

Copyright information

Content

1 Introduction

You have made a good choice by purchasing the Holzstar wood band saw.

Read the operating instructions carefully before using the machine.

These are an important part of the machine and must be kept near the machine and accessible to every user.

The operating instructions inform you about the proper commissioning, the intended use as well as the safe and efficient operation and maintenance of the wood band saw.

In addition, observe the local accident prevention regulations and general safety regulations for the area of application of the wood band saw.

1.1 Copyright

1.2 Customer service

Please contact your specialist retailer if you have any questions regarding your band saw or require any technical information. Your specialist retailer will be happy to support you with specialist advice and information.

Germany:
Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt

Repair service:
Fax: 0049 (0) 951 96555-111
E-Mail: service@stuermer-maschinen.de
Internet: www.holzstar.de

Spare parts orders:
Fax: 0049 (0) 951 96555-119
E-Mail: ersatzteile@stuermer-maschinen.de

We are always interested in valuable experience and knowledge from the application, which then could be shared and be valuable to develop our products even further.

1.3 Limitation of liability

All data in these operating instructions has been compiled on the basis of the state-of-the-art, valid standards and guidelines as well as our many years of expertise and experience.

The manufacturer shall not be liable for damage in the following cases:

- Non-observance of these operating instructions
- Unintended use
- Deployment of inexperienced staff
- Conversions at one's own responsibility
- Technical modifications
- Use of unauthorised spare parts

The actual scope of delivery may deviate from the descriptions and illustrations in this document as a result of special variants, optional extras or recent, technical modifications.

The obligations defined in the supply contract shall apply in addition to the general terms and conditions and the manufacturer's general terms and conditions as well as the statutory regulations valid at the time of the conclusion of the contract.

2 Safety

This section provides an overview of all important safety packages for personal protection as well as safe and reliable operation. The sections on individual service life phases contain additional, specifically applicable safety information.

2.1 Legend of symbols

Safety Instructions

Safety instructions in these operating instructions have been highlighted with symbols. Safety instructions are indicated by signal terms that express the degree of risk involved.

DANGER!

This combination of symbol and signal word indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

WARNING!

This combination of symbol and signal word indicates a potentially dangerous situation that will result in death or serious injury if not avoided.

CAUTION!

This combination of symbol and signal word indicates a potentially hazardous situation which, if not avoided, may result in minor or slight injury.

ATTENTION!

This combination of symbol and signal word indicates a possibly hazardous situation which, if not avoided, may result in damage to property and the environment.

NOTE!

This combination of symbol and signal term indicates a potentially dangerous situation which may cause material damage or harm the environment if it is not averted.

Tips and recommendations

Tips and recommendations

This symbol highlights useful tips and recommendations as well as information for efficient and reliable operation.

Observe the safety information in these operating instructions to minimise the risk of personal injury as well as material damage and prevent hazardous situations.

2.2 Operator responsibility

The operator is the person who operates the machine himself for commercial or economic purposes or who makes it available to a third party for use or application and who bears the legal product responsibility for the protection of the user, the personnel or third parties during operation.

Obligations of the operator:

If the machine is used for commercial purposes, operators are subject to the legal stipulations in terms of occupational safety. For this reason, the safety instructions in these operating instructions as well as the safety, accident prevention and environmental protection regulations valid at the installation location must be complied with. In this process, the following shall apply in particular:

- Operators shall obtain information about valid occupational safety regulations and determine additional hazards as part of a risk assessment which result from the specific operating conditions at the machine's installation location. Said risk assessment shall be reflected in operating instructions for machine operation.
- During the entire machine operating time operators must check whether the operating instructions they created meet current standards and adapt the operating instructions where necessary.
- Operators shall clearly manage and specify the responsibilities for installation, operation, troubleshooting, maintenance and cleaning.
- Operators must make sure that all persons handling the machine have read and understood these operating instructions. Operators must also regularly train staff and notify of the hazards.
- Operators shall provide staff with the required protective equipment and wearing the required protective equipment shall be mandatory.

Operators shall also be responsible for maintaining the machine in a technically perfect condition. For this reason, the following shall apply:

- Operators shall make sure that the maintenance intervals described in these operating instructions are complied with.
- Operators shall regularly check that the safety equipment is fully functional and complete.

2.3 Qualification of the staff

The different tasks described in these operating instructions require different levels of skills in terms of the qualifications of operating staff working with the machine.

WARNING!

Risk from inadequately qualified persons!

Inadequately qualified persons are unable to assess the risks when handling the machine, thus putting themselves and others at risk of severe injuries.

- All work must be carried out by qualified persons only.
- Keep inadequately qualified persons and children away from the work area.

Exclusively persons of whom it can be expected that they reliably complete assigned tasks shall be authorised to carry out any tasks. Persons whose reactions have been impaired shall not be authorized, e.g. drug users, users under the influence of alcohol or medication.

These operating instructions specify the following personal qualifications for the different tasks:

Operating staff:

Operating staff has undergone an induction by the operator about the entrusted tasks and potential hazards resulting from improper behaviour. Tasks which go beyond normal operation may only be carried out by the operator if they are listed in the operation manual and the operator has made him/herself familiar with them.

Qualified electrician:

Due to the electrician's specialised training, know-how, experience and knowledge of pertinent standards and regulations the electrician is in a position to work on the electrical systems, and autonomously identify and avoid potential hazards.

Specialist staff:

As a result of specialist training, expertise, experience and skills in terms of the relevant standards and regulations, specialist staff is able to complete the tasks they are entrusted with and independently identify hazards and avert risks.

Manufacturer:

Certain work must be carried out by manufacturer specialist staff only. Other staff is not permitted to carry out this work. Contact our customer service to have the work carried out.

2.4 Personal protective equipment

Personal protective equipment is intended to protect the health and safety of persons at work. Staff must wear the personal protective equipment indicated in individual sections of these operating instructions when carrying out the different tasks on the machine.

The personal protective equipment is described in the following section:

Hearing protection

The hearing protection protects the ears against damages of hearing due to noise.

Eye protection

Protective glasses protect the eyes against projected parts and splashes of liquid.

Suitable protective gloves

The protective gloves provide protection for the hands against sharp-edged components, as well as against friction, abrasions or deeper injuries.

Protective dust-mask

The dust protection mask protects the respiratory tract from wood chips and wood dust.

Safety boots

The safety boots protect the feet against crushes, falling parts and slipping over on slippery underground.

Protective clothes

Protective work clothing means tight-fitting clothing with low tear resistance.

2.5 General safety instructions

A band saw is a dangerous tool that can cause serious injury if left unattended. It is therefore essential that you follow the safety instructions below:

- The band saw may only be operated and operated by persons who are familiar with the band saw and who are aware of the dangers of using the band saw. Keep visitors and unauthorized personnel away from the band saw.
- Persons under the age of 16 may use the band saw only as part of a vocational training and under the supervision of an instructor.
- Always disconnect the band saw from the electrical power supply when making adjustments, inspection, cleaning or maintenance.
- When installing, operating, maintaining and repairing the band saw, observe the European standards. For the European standards that have not yet been transposed into the relevant national law, the country-specific regulations still applicable must be applied.
- Band saw operators outside the scope of European standards are required to comply with the safety and accident prevention regulations in force in the host country. If necessary, appropriate measures must be taken to ensure compliance with country-specific regulations before operating the band saw.
- Do not wear loose clothing or jewelry, they may get caught in moving parts. When working outdoors, rubber gloves and non-slip shoes are recommended. Wear a protective hair cover to protect long hair. Use safety goggles and ear protection as well as a face mask or dust mask to protect against toxic wood dust.

- In case of tiredness, lack of concentration or under the influence of medication, alcohol or drugs, working on the machine is prohibited!
- Keep the work area clean.
- Do not use the device near flammable liquids or gases.
- Use only saw blades recommended by the manufacturer, which correspond to the state of your country. Always choose the correct saw blade for the material to be cut.
- Do not use saw blades made of high-speed steel.
- Do not cut metals such as nails and screws. Examine all nails, screws, and other foreign objects that make up the workpiece before operation.
- Carefully inspect the blade for cracks or damage before use. Replace cracked or damaged blade immediately.
- Remove wrenches, cut off parts etc. from the table before turning on the band saw.
- Keep your footing and balance at all times as you work on the band saw.
- Pay attention to the saw blade during operation. DO NOT TOUCH THE SAW BLADE!
- Before cutting a workpiece with a band saw, let the machine run for some time. Watch out for any vibration or wobble that may indicate a poor installation or a badly balanced knife.
- Only operate the wooden band saw if a suction device is connected and switched on.
- Do not clean the saw blade during the cutting process.
- Replace the table insert when worn.
- Make sure that the choice of saw blade and the speed of the material to be cut depends.
- Do not operate the machine if the protective cover is open to protect the saw blade.
- Do not expose the wooden band saw to rain. Do not use the wooden band saw in damp or wet places. Keep the work area well lit. Do not use power tools that are likely to cause a fire or explosion.
- Avoid body contact with grounded surfaces to avoid electric shock.
- When not in use, keep the tools and band saw in a dry, closed place out of the reach of children.
- Make it a habit to check that the tool and adjustment wrench have been removed before turning on the band saw.
- Never unplug the unit by the power cord to unplug it from the wall outlet. Keep the cable away from heat, oil and sharp edges.
- Use a push stick to cut the workpieces on the band saw.
- When using the device outdoors, use only extension cords designed for outdoor use.
- Keep cutting tools sharp and clean for better and safer performance. Follow the instructions for lubricating and changing the accessories. Check the cable regularly and if it is damaged, have it repaired by an authorized service representative. Check the extension cords regularly and replace them if they are damaged. Keep the handles dry, clean and free from oil and grease.

- Before using the tool, carefully inspect a damaged guard or other damaged part to make sure it is working properly and performing its intended function. Check the alignment of the moving parts, the free movement of the moving parts, the breakage of parts, the assembly and any other conditions that should be properly repaired or replaced by an authorized service center, unless otherwise stated in this manual. Have defective switches replaced by an authorized service facility. Do not use the band saw if the switch does not work properly.
- Only use original accessories and spare parts from HOLZSTAR.

2.6 Safety labels on the band saw

The following safety labels identifications are attached to the band saw (Fig. 1) and must be observed.

Fig. 1: Safety labels

If safety labels on the machine are damaged or missing, this can cause errors, personal injury and material damage. The safety symbols attached to the machine must not be removed. Damaged safety symbols must be replaced immediately.

As soon as the signs are not clearly visible and comprehensible at first glance, the machine must be stopped until new signs have been attached.

2.7 Safety data sheets

Safety data sheets on hazardous goods can be obtained from your specialist dealer or by calling +49 (0)951/ 96555-0. Specialist dealers can find safety data sheets in the download area of the partner portal.

2.8 Intended Use

The wood band saw is used exclusively for sawing wood or wood-like materials. The processing of other materials is not intended and not permitted. Each workpiece must be inspected for foreign bodies such as screws or nails before machining. Round material may only be cut transversely to the longitudinal axis with a suitable holding device. Rotation of the workpiece must be prevented by this holding device. When sawing flat workpieces on edge, a suitable stop angle must be used for safe guidance.
Intended use also includes compliance with all the information in these instructions.

2.9 Reasonably foreseeable misuse

- Any use beyond the intended use or any other use is considered misuse.
- Possible misuses can be:
- Using the wood band saw for materials other than wood (e.g. machining metal).
- Machining workpieces that are not fixed or not fixed enough.
- Operating the machine without functioning, intended safety devices.
- Bridging or changing the safety devices.
- Failure to observe the maintenance instructions.
- Non-observance of wear and damage marks.
- Service work carried out by untrained or unauthorised personnel.
- Maintenance work on an unsecured machine.
- Deliberate or careless handling of the wood band saw during operation.
- Installation of spare parts and use of accessories and equipment not approved by the manufacturer.
- Machining of oversized or undersized workpieces so that safe working can no longer be guaranteed.
- Modifications to the machine or the use of modified tool systems.

Misuse of the wood band saw can lead to dangerous situations.

Stürmer Maschinen GmbH accepts no liability for constructive and technical modifications to the wood band saw.

Claims of any kind for damage due to improper use are excluded.

2.10 Residual risks

Even if all safety regulations are observed and the machine is used correctly, there are still residual risks, which are listed below:

- There is a risk of injury to the upper limbs (e.g., hands, fingers).
- Danger from falling or spinning-on workpieces.
- Danger due to inhalation of wood dust in chemically treated workpieces.
- Breakage / crack of the tool
- Fire hazard with insufficient ventilation of the engine
- Impairment of hearing during prolonged work without hearing protection
- Risk of injury to the eye from flying parts, even with safety glasses.
- Risk of injury due to kickback of the cuttings, ejection of the cuttings or parts thereof.
- Touching rotating parts or tools
- Touching electrical parts.

3 Technical Data

Type HBS	231-1	261-2	321-2	361-2
Length	490 mm	680 mm	780 mm	870 mm
Width/ Depth	420 mm	520 mm	600 mm	690 mm
Height	835 mm	1435 mm	1600 mm	1715 mm
Weight	20 kg	34 kg	51 kg	76 kg
Electrical Connections	230 V	230 V	230 V	230 V
Length Work table	300 mm	360 mm	480 mm	545 mm
Width Work table	300 mm	320 mm	390 mm	515 mm
Height Work table	405 mm	935 mm	1000 mm	1020 mm
Cutting height max. 90°	90 mm	152 mm	165 mm	225 mm
Cutting height max. 45°	50 mm	95 mm	105 mm	145 mm
Max. cutting width with stop	125 mm	145 mm	225 mm	255 mm
Max. cutting width without stop	228 mm	245 mm	305 mm	340 mm
Saw blade speeds	635 min^{-1}	400 / 800 min^{-1}	370 / 800 min^{-1}	370 / 800 min^{-1}
Flywheel speed	850	490 / 960	365 / 785	330 / 735
Ø flywheel	238 mm	256 mm	316 mm	356 mm
Saw blade length	1575 mm	1826 mm	2240 mm	2560 mm
Saw blade width	6,35 mm	10 mm	12,7 mm	12,7 mm
Saw blade width max.	10 mm	12,5 mm	20 mm	25 mm
Saw band thickness	0,35 mm	0,35 mm	0,5 mm	0,5 mm
Ø Extraction port	53 mm	100 mm	100 mm	100 mm
Rating	0,3 kW	0,375 kW	0,75 kW	1,1 kW
Output	0,17 kW	0,22 kW	0,5 kW	0,8 kW
Sound pressure level dB(A)	65-70	65-70	68-73	68-73

3.1 Type plate

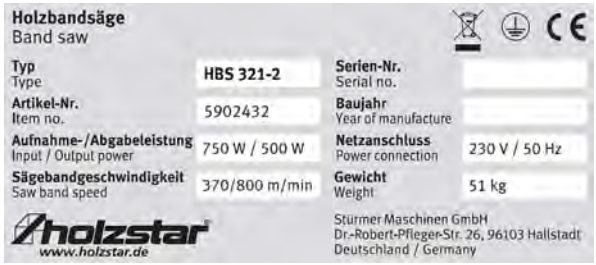

Fig. 2: Type plate HBS 321-2

3.2 Scope of supply

HBS 231-1

- Saw band
- Rip fence
- Angle fence
- LED work light
- Sliding stick

HBS 261-2 / HBS 321-2 / HBS 361-2

- Saw band
- Rip fence with magnifying glass
- Angle fence
- LED work light
- Sliding stick
- Chassis

4 Transport, packaging and storage

Delivery

After delivery, check the band saw for visible transport damage. If you discover any damage to the cross-cut and mitre saw, report it immediately to the transport company or dealer.

Transport

Improper transport is accident-prone and can cause damage or malfunctions for which we do not grant any liability or guarantee.

Transport the scope of delivery secured against shifting or tilting with a sufficiently dimensioned industrial truck to the installation site.

WARNING!

Severe or fatal injuries may occur if parts of the machine tumble or fall down from the forklift truck, pallet truck or from the transport vehicle.
Follow the instructions and information on the transport box.
Note the total weight of the machine. The weight of the machine is indicated in the "Technical data" of the machine. When the machine is unpacked, the weight of the machine can also be read on the rating plate.
Only use transport devices and load suspension gear that can hold the total weight of the machine.

WARNING!

The use of unstable lifting and load suspension equipment that might break under load can cause severe injuries or even death. Check that the lifting and load suspension gear has sufficient load-bearing capacity and that it is in perfect condition.
Observe the accident prevention regulations issued by your Employers Liability Insurance Association or other competent supervisory authority, responsible for your company.
Fasten the loads properly.

General risks during internal transport

WARNING: DANGER OF TIPPING

The device may be lifted unsecured by a maximum of 2cm.
Employees must be outside the danger zone, the reach of loads.
Warn employees and, if necessary, advise employees of the hazard.

Devices may only be transported by authorized and qualified persons. Act responsibly during transport and always consider the consequences. Refrain from daring and risky actions.

Gradients and descents (e.g. driveways, ramps and the like) are particularly dangerous. If such passages are unavoidable, special caution is required.

Before starting the transport check the transport route for possible danger points, unevenness and disturban-ces as well as for sufficient strength and load capacity.

Danger points, unevenness and disturbance points must be inspected before transport. The removal of danger spots, disturbances and unevenness at the time of transport by other employees leads to considerable dangers.Careful planning of internal transport is therefore essential.

4.1 Packaging

All of the machine‘s packaging materials and packing aids are suitable for recycling and must always be disposed of using material-based recycling systems.

Packaging materials made of cardboard must be shredded and disposed of as part of waste paper recycling.

The foils are made of polyethylene (PE), padding is made of polystyrene (PS). Dispose of these substances at a recycling centre or hand them over to the relevant waste disposal company.

4.2 Storage

Store the Wood Band Saw thoroughly cleaned in a dry, clean and frost-free environment. Cover the machine with a protective plane.

5 Description of device

5.1 Machine

Illustrations in these operating instructions may deviate from the original.

HBS 231-1

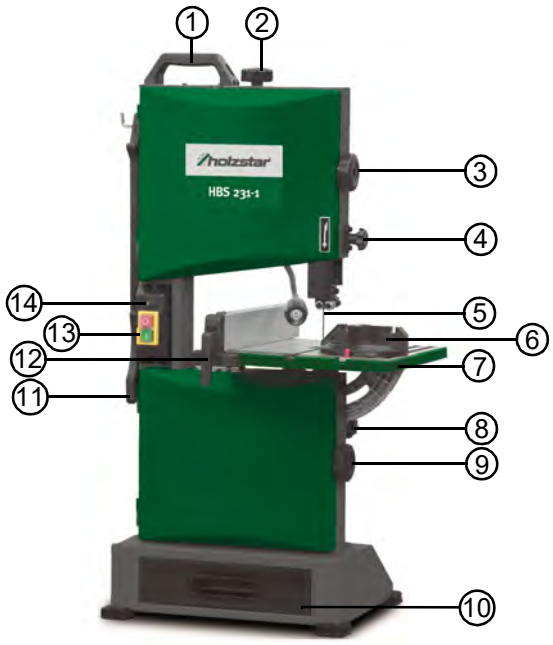

Fig. 3: Wood Band Saw HBS 231-1

1 Handle
2 Handle screw saw blade tension
3 Saw blade guide
4 Star grip for locking the roller cover
5 Saw blade

6 Miter stop
7 Saw table
8 Angle adjustment screw
9 Star grip for locking the roller cover
10 Chip containers
11 Push stick
12 Clamping lever for rip fence
13 ON / OFF switch
14 LED light switches

HBS 261-2 / HBS 321-2 / HBS 361-2

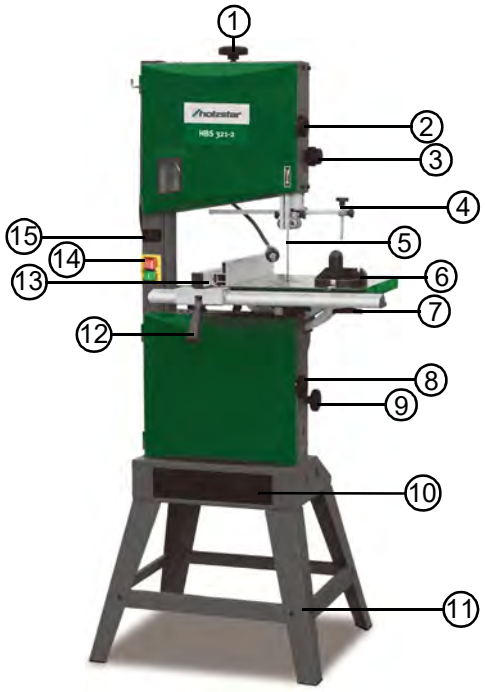

Fig. 4: Wood Band Saw HBS 261-2 / HBS 321-2 / HBS 361-2

1 Handle screw saw blade tension
2 Star grip for locking the roller cover
3 Adjustment handle saw band guide
4 Circle cutter (optional)
5 Saw blade
6 Miter stop
7 Locking handle of the guide rail
8 Star handle for locking the roller cover
9 Handle screw saw blade tension
10 Chip containers
11 Underframe
12 Clamping lever for rip fence
13 Rip fence
14 ON / OFF switch
15 LED light switches

5.2 Optional accessories

Tips and recommendations

We recommend to use only high quality original Holzstar accessories. Only with original accessories, a flawless operation and optimal work results can be guaranteed.

5912426 Circle cutting device to HBS 261-2

5912432 Circle cutting device to HBS 321-2

5912436 Circle cutting device to HBS 361-2

6 Setting up and connection

6.1 Requirements for the place of operation

Remove the band saw from the packaging and all protective films. Do not set up or operate the machine in a damp or wet environment. The air humidity should not exceed 80% and the measured room temperature should be between 5°C and 35°C. The machine should not be operated in a humid or wet environment.

The installation or work area must be dry and well ventilated.

6.2 Set up the Wood Band Saw

NOTE!

To reduce noise, a rubber layer can be placed between the machine and the workbench. This effectively prevents vibrations and noise.

CAUTION!

Risk of injury from an unstable machine!
Check the stability of the machine after setting it up on stable ground.

ATTENTION!

In order to ensure sufficient stability of the machine, it should be bolted to the ground. There are 4 holes at the bottom of the machine housing for this purpose.

ATTENTION!

Do not overtighten the fixing screws of the base plate. The base plate must not be distorted

Use sutiable protective gloves!

Wear protective clothes!

Wear safety boots!

The wood band saw is already delivered largely assembled. Only a few parts like the saw table, the rip fence and the handwheels have to be assembled after delivery.

DANGER!

Before all maintenance and conversion work on the wooden band saw, the mains plug must be unplugged.

6.2.1 Assembly HBS 231-1

Step 1: After unpacking, park the machine in the desired location and carefully tilt it to the side.

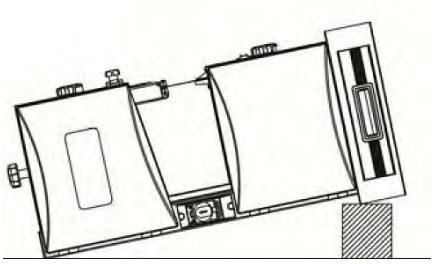

Fig. 5: Assembly of the Band saw

Step 2: Screw on the washers with the washers and screws M5x10 and put the band saw back upright.

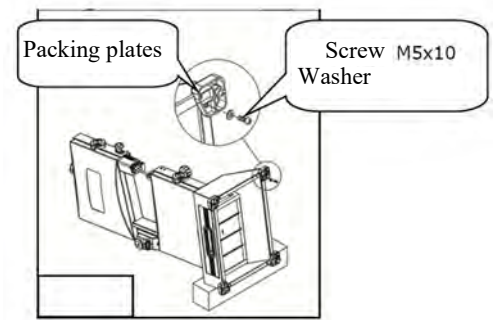

Fig. 6: Screw on washers

Step 3: Screw the lifting handle to the top of the band saw with the screws provided.

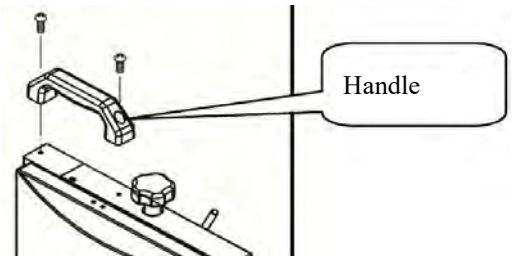

Fig. 7: Screw on lifting handle

Assembly of the saw table HBS 231-1

Step 1: Unscrew the nut, washers and wing screws on the saw table.

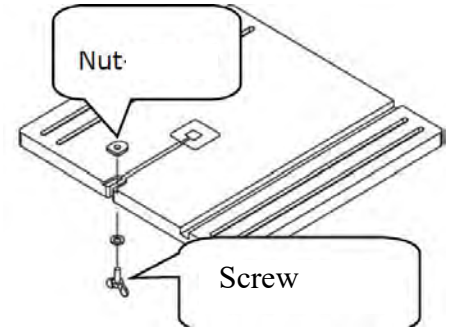

Fig. 8: Assembly of the work table

Step 2: Push the saw table past the saw blade through the groove of the saw table. Align the teeth on the saw table mount with the teeth on the angle adjustment knob.

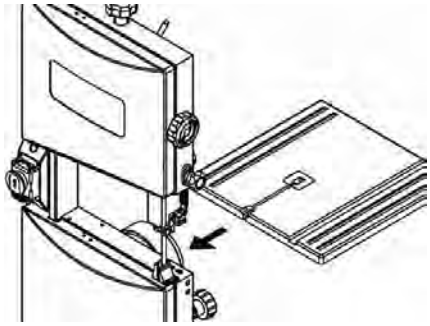

Fig. 9: Assembly of the work table

Step 3: Insert the pins on the frame into the slots of the saw table mount. Tighten the saw table by securing the clamping lever and the angle adjustment handle of the table.

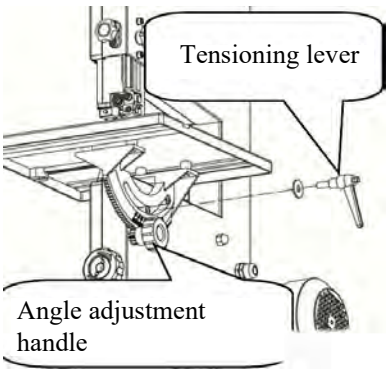

Fig. 10: Assembly of the work table

Step 4: Screw the thumbscrew with nut and washer back to the work table.

Mounting the retaining hook HBS 231-1

Step 1: Screw the retaining hook to the frame with the hex screw and secure the push rod to it.

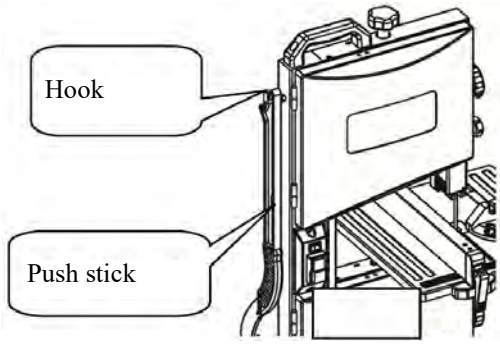

Fig. 11: Mounting the retaining hook

Mounting the HBS 231-1 on a workbench

The bandsaw HBS 231-1 can be mounted on a workbench with 4 screws.

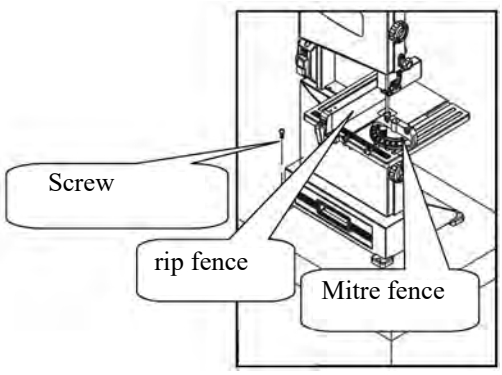

Fig. 12: Assembly on a workbench

6.2.2 Assembly HBS 261-2 / HBS 321-2 / HBS 361-2

Step 1: After unpacking, park the machine in the desired location and carefully tilt it to the side.

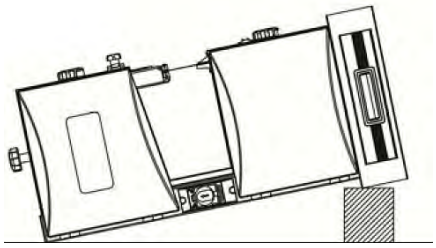

Fig. 13: Tilt the band saw

Step 2: Fix the leveling feet with M8X10 Allen screws and 8mm spacers. Attach the long and short cross struts to the leveling feet with M6X12 carriage bolts, 6mm spacers and M6 hex nut.
Do not fully tighten the nuts.

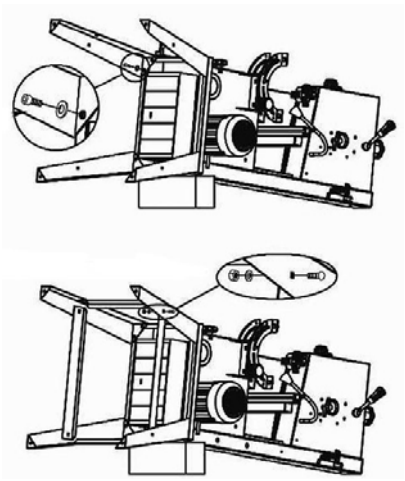

Fig. 14: Fasten the underframe

Step 3: Place the machine in the prepared place and tighten the nuts.

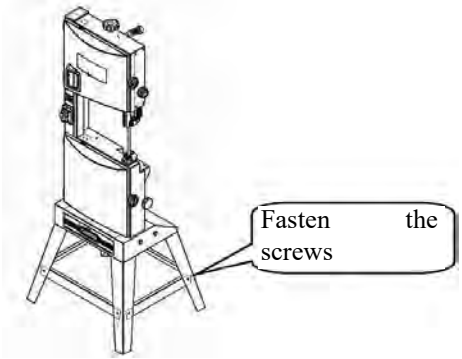

Fig. 15: Fasten the underframe

Assembly of the Work table HBS 261-2 / HBS 321-2 / HBS 361-2

Step 1: Assemble the table (After mounting the lower frame) with M8X10 hex bolts and 8 mm washers on the band saw. Make sure that the saw blade blade is centered in the table insert.

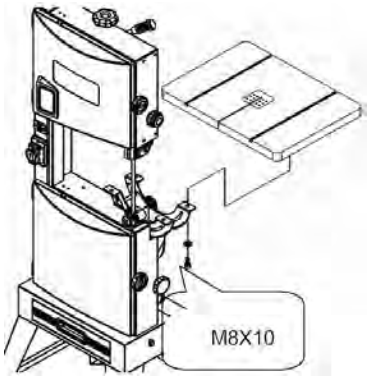

Fig. 16: Assembly the work table

Mounting the guide rail HBS 261-2 / HBS 321-2 / HBS 361-2

Step 1: Fix the guide rail with the 4 knobs on the saw table.

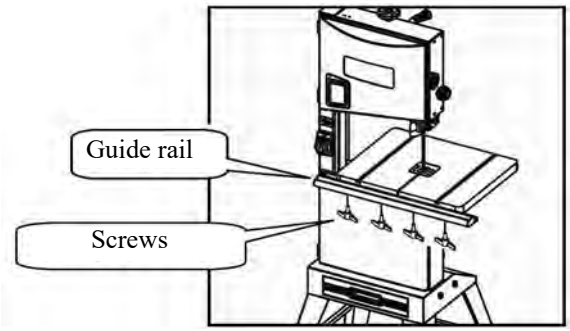

Fig. 17: Mounting the guide rail

Mounting the accessories HBS 261-2 / HBS 321-2 / HBS 361-2

Step 1: Install the accessory tool assembly to the frame using M4X10 screws. Attach the hook to the frame with the hex nut. The accessory and rip fence can be mounted as shown in Figure 18.

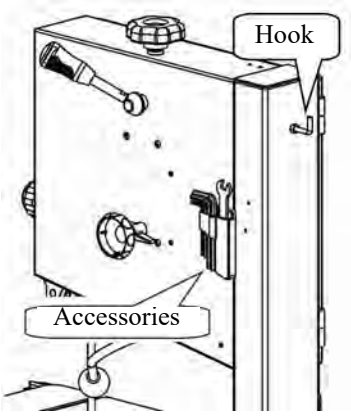

Fig. 18: Mounting the accessories

6.3 Electrical connection

DANGER!

Risk of fatal injury due to electric shock!

Contact with live components may result in fatal injury. Switched-on electrical components can make uncontrolled movements and lead to serious injuries.

Before connecting the mains plug to the mains, check that the wood band saw is switched off.

ATTENTION!

All work on the electrical installation may only be carried out by a qualified electrician.

When connecting the power supply, make sure that the characteristics (voltage, mains frequency) match the information on the type plate.

DANGER!

Use suitable circuit protection to avoid electrical hazards, fire hazards or damage to the tool. Use a separate circuit for your tools. Have the power cord replaced immediately if it is damaged.

Only use the band saw in a dry environment. Operate the band saw only on an electrical supply that meets the following requirements:

- The mains plug must be freely accessible.
- Fuse protection with a residual current circuit breaker (RCD), with a residual current of 30 mA.
- Only use a socket outlet with earthing contact (properly earthed socket outlet).
- Lay the mains cable in such a way that it does not interfere with work and cannot be damaged.
- Protect the power cord from heat, aggressive liquids, and sharp edges.

DANGER!

This equipment must be grounded during operation to protect the operator from electrical shock.

In the event of a malfunction or disconnection, earthing leads to a path with the least resistance to electrical current and reduces the risk of electric shock. This device is equipped with a power cord that has a grounding conductor and a grounding plug. The plug MUST be plugged into a suitable power outlet that is properly installed and grounded in accordance with ALL local codes and regulations.

Do not change the supplied plug.

Guideline for the use of extension cords

Use suitable extension cords. Make sure your extension cord is in good condition. When using an extension cord, be sure to use a cable strong enough to carry the current your machine needs. If the cable is too small, the mains voltage will drop, resulting in power failure and overheating.

Make sure your extension cord is properly connected and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it. Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

DANGER!

This machine is intended for indoor use only. Do not expose the device to rain and do not store it in damp places.

6.4 Connection of the chip extraction

WARNING!

Some types of saw dust can cause cancer when inhaled. Only work indoors with a chip extraction system (air speed at the extraction nozzle of the saw greater than 20 m / s).

If the band saw is operated in closed rooms for more than 30 minutes, it must be connected to a chip evacuation unit. The electrical connection of the chip evacuation must ensure that the extraction starts when the band saw starts. The exhaust must run for 20 seconds when the band saw is switched off.

6.5 Before commissioning

- Attach the band saw to a suitable base.
- Mount the saw table.
- Check all parts for tight fit.
- Adjust the saw band tension (see „Tensioning the saw band“).
- Set the upper saw band guide (see „Setting the upper saw band guide“).
- Check the band guide bearings at the top and bottom of the saw band guide for a correctly set distance from the saw band.
- Align the saw band.

7 Seetings

ATTENTION!

- Before any adjustment, set-up and maintenance work on the machine, the machine must be switched off and the mains plug must be disconnected!

7.1 Settings on the HBS 231-1

Adjusting the tilting table

Step 1: Release the latch with the quick release lever.

Step 2: Swing the table with the angle adjustment wheel until the desired angle is reached.

Step 3: Fix the table and check the angle marks with the scale display.

Step 4: Perform a trial cut to control the angle.

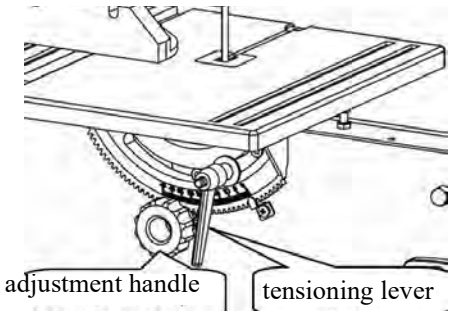

Fig. 19: Setting the swivel table

Adjusting the saw blade run and inclination

If the saw blade does not run in the middle of the rollers, the tracking must be corrected by adjusting the inclination of the band saw blade.

Step 1: Open the top and bottom roller cover.

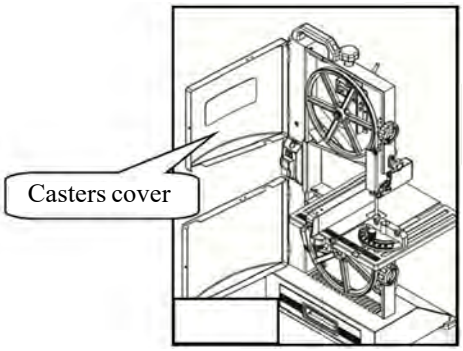

Fig. 20: Casters cover

Step 2: Slowly turn the top roller clockwise by hand. The saw band should run centrally on the rubber pads of the roller. Be careful not to grab the saw blade.

Step 3: If the saw blade does not run in the middle, correct the saw blade by turning the knob to the left or right.

Step 4: Check the run of the saw blade on the roller. It should rest in its full width on the rubber pad.

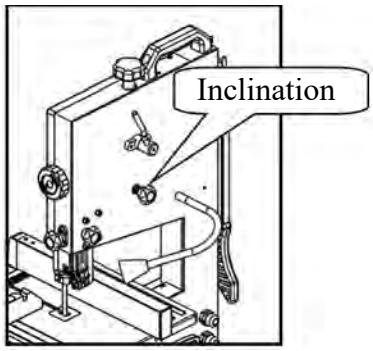

Fig. 21: Rotary knob for Inclination

Step 5: After completing the adjustments, fix everything again and close both covers

Adjustment the saw blade tension

DANGER!

The saw blade tension must be checked before each use!

WARNING!

Excessive saw blade tension can cause saw blade breakage and serious injury.

Too low a saw blade tension can lead to slippage of the tape guide rollers and thus to the standstill of the saw blade.

Therefore always pay attention to a correct setting of the saw blade tension!

Step 1: Turn the handwheel to increase or decrease the saw blade tension via a spring. Turn the adjustment knob clockwise to increase the blade tension. Turning the knob counterclockwise decreases the blade tension.

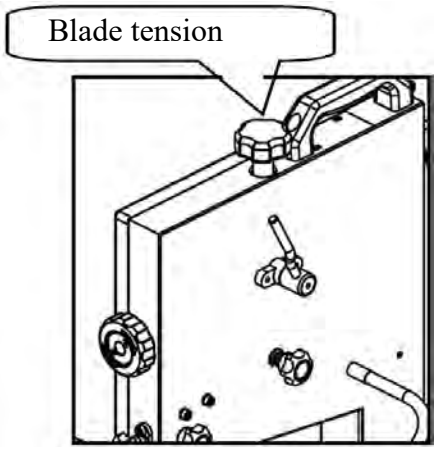

Fig. 22: Blade tension

NOTE!

After completion of the working shift, the saw band is to be released again with the rotary knob.

NOTE!

Check the tension by pressing your finger halfway between the table and the top guide against the side blade.

The ideal tension is about 2mm.

Adjusting the upper saw band guide

Before each sawing process, the upper saw band guide must be adjusted depending on the workpiece height. The upper saw band guide must be approx. 3 mm above the workpiece.

Step 1: Open the clamping screw of the saw band guide and adjust the height with the aid of the adjusting handle. Then fix the adjustment handle again. (Fig.23)

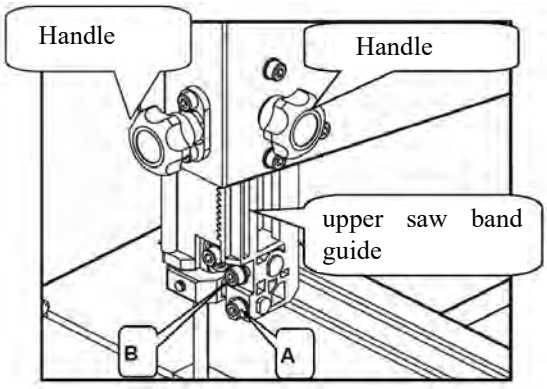

Fig. 23: Adjust the position of the upper strap guide

Step 2: Loosen the screw (A, Fig.23)) and adjust the position of the guide bearing so that the guide bearing is 1 or 2 mm (Fig.24) away from the teeth of the saw blade. Then tighten the screw (A, Fig.23).

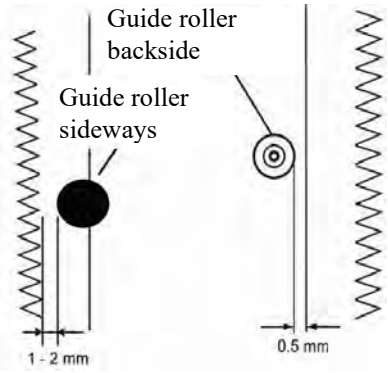

Fig. 24: Setting the guide bearings

Step 3: Loosen the screw (B. Fig.23) and set the back of the guide roller to 0.5 mm (Fig.25) behind the back of the blade. Tighten the knob (B, Fig.23) again.

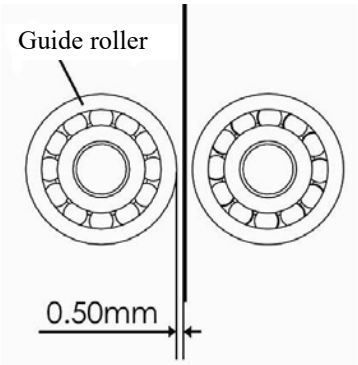

Fig. 25: Adjusts the guide bearing

Step 4: Loosen the hexagon socket screw (C, Fig.26) and set the guide bearing to a position 0.5 mm from the blade. Tighten the Allen screw (C, Fig.26) again.

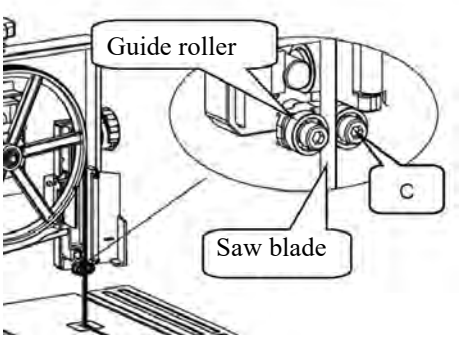

Fig. 26: Setting the tape guide

Adjusting the lower saw band guide

The lower saw band guide must be readjusted after each band saw blade change or tracking adjustment.

Step 1: Loosen the socket head cap screws through the holes (B) and (E) using an Allen key, and adjust the guide block (D) and thrust bearing (C).

Step 2: Loosen the screw (A) and set the guide bearing to a position 0.5 mm from the saw blade. Tighten the screw (A) again.

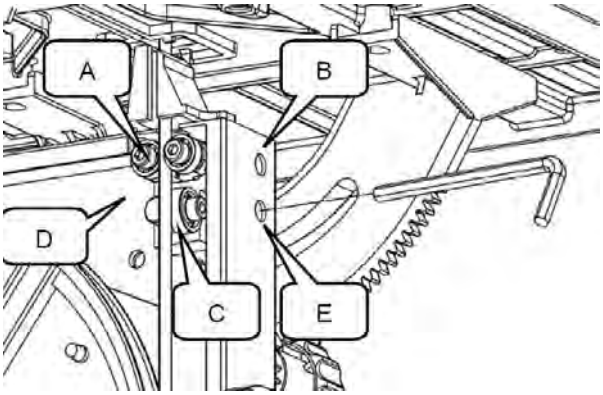

Fig. 27: Set the position of the lower tape guide

Changing the saw blade

DANGER!

Before changing the saw blade, switch off the machine, pull out the mains plug and wait until the band saw band stops.

Use suitable protective gloves!

DANGER

Use only suitable saw bands!

DANGER!

Make sure to insert the new saw blade correctly!
Make a note of which direction the teeth of the old saw band are pointing!

A saw blade change is required when using different materials and material thicknesses, as well as worn saw band.

Step 1: Lower the upper saw blade guide to the lowest position and unscrew the lock nut, washers and wing screws on the saw table.

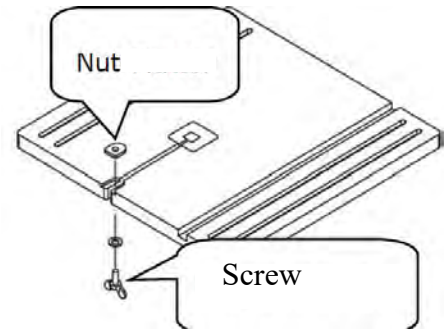

Fig. 28: Change saw blade

Step 2: Open the upper and lower roller cover.

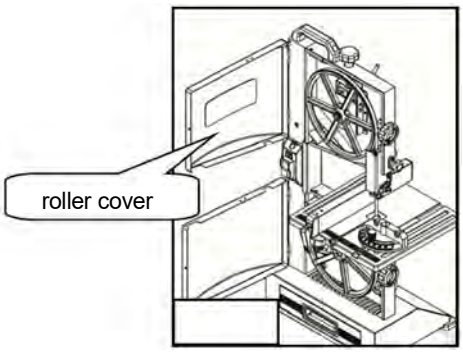

Fig. 29: Open the roller cover

Step 3: Open the saw blade cover.

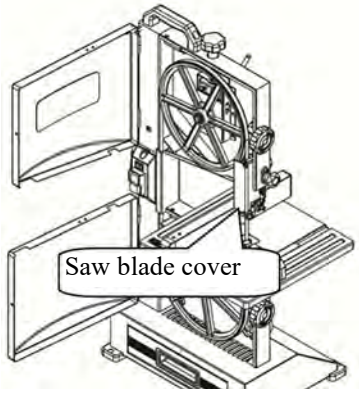

Fig. 30: Open the saw blade cover

Step 4: Loosen the saw blade with the quick release lever.

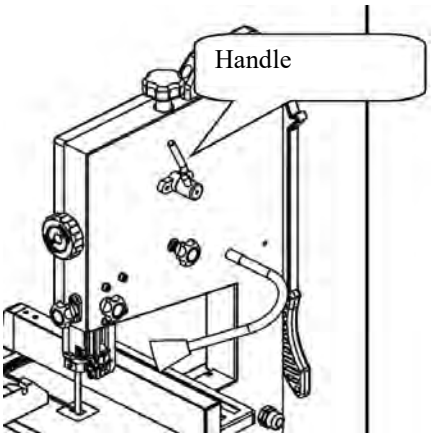

Fig. 31: Loosen the saw blade

Step 5: Remove the old saw blade.

Step 6: Insert a new saw blade in the correct direction.

Step 7: Tighten the tension lever again and tighten the saw blade as described in chapter 8.1.

Step 8: Screw the nut, washers and wing screws to the saw table.

Step 9: Close the upper and lower roller cover and the saw blade cover.

Step 10: Align the saw blade. Switch on the bandsaw and make sure that the saw blade is moving correctly.

7.2 Seetings on the HBS 261-2

DANGER!

- Before any adjustment, set-up and maintenance work on the machine, the machine must be switched off and the mains plug must be disconnected!

Adjusting the tilting table

Step 1: Release the latch with the quick release lever.

Step 2: Swing the table with the angle adjustment knob until the desired angle is reached.

Step 3: Fix the table and check the angle marks with the scale display.

Step 4: Perform a trial cut to control the angle.

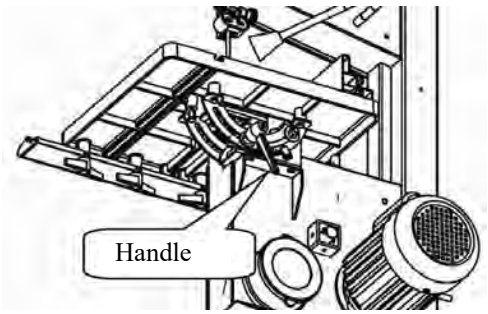

Fig. 32: Setting the swivel table

Aligning the saw blade

If the saw blade does not run in the middle of the rollers, the tracking must be corrected by adjusting the inclination of the band saw blade.

Step 1: Open the top and bottom roller cover.

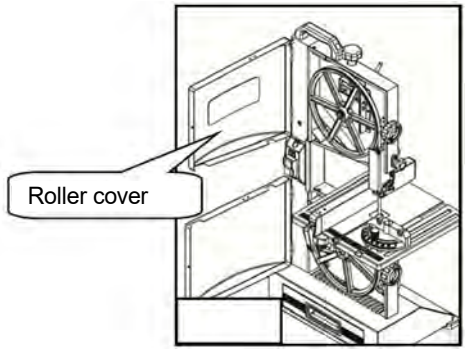

Fig. 33: Roller cover

Step 2: Slowly turn the top roller clockwise by hand. The saw band should run centrally on the rubber pads of the roller. Be careful not to grab the saw blade.

Step 3: If the saw blade does not run in the middle, correct the saw blade by turning the dial to the left or right.

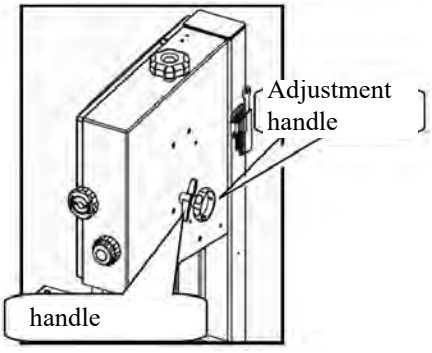

Fig. 34: Rotary knob for tilt adjustment

Step 4: Check the run of the saw blade on the roller. It should rest in its full width on the rubber pad.

Step 5: After completing the adjustments, fix everything again and close both covers.

Adjusting the saw blade tension

DANGER!

The saw blade tension must be checked before each use!

WARNING!

Excessive saw blade tension can cause saw blade breakage and serious injury.

Too low a saw blade tension can lead to slippage of the tape guide rollers and thus to the standstill of the saw blade.

Therefore always pay attention to a correct setting of the saw blade tension!

Step 1: Turn the handwheel to increase or decrease the saw blade tension via a spring. Turn the adjustment knob clockwise to increase the blade tension. Turning the knob counterclockwise decreases the blade tension.

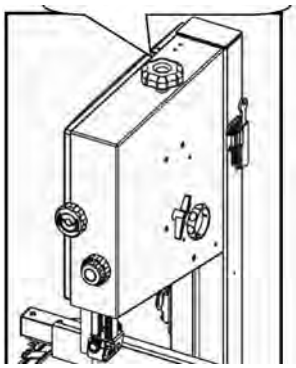

Fig. 35: Saw blade tension

NOTE!

After completion of the working shift, the saw band is to be released again with the rotary knob.

NOTE!

Check the tension by pressing your finger halfway between the table and the top guide against the side blade.
The ideal tension is about 2mm.

Adjusting the upper saw band guide

Before each sawing process, the upper saw band guide must be adjusted depending on the workpiece height. The upper saw band guide must be approx. 3 mm above the workpiece.

Step 1: Loosen the saw blade guide wheel and use the dial to adjust the height. Then retighten the locking wheel (Fig.36).

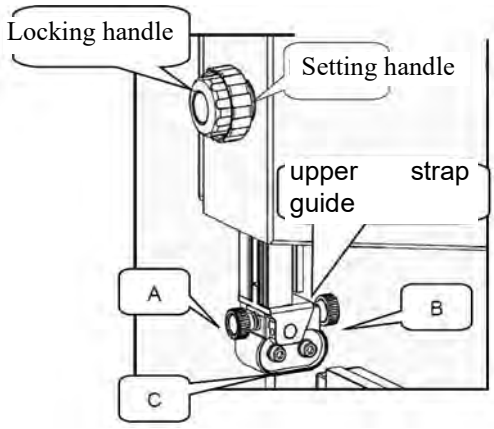

Fig. 36: Adjust the position of the upper strap guide

Step 2: Loosen the screw (A, Fig.36) and adjust the position of the guide bearing so that the guide bearing is 1 or 2 mm (Fig.37) away from the teeth of the saw blade. Then tighten the screw (A, Fig.36).

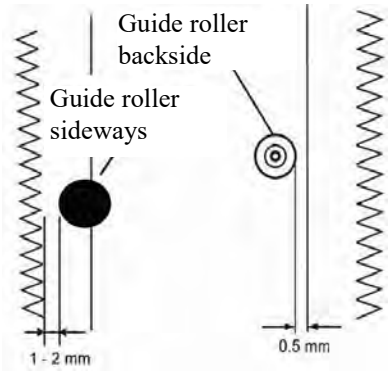

Fig. 37: Setting the guide bearings

Step 3: Loosen the screw (B. Fig.36) and set the back of the guide roller to 0.5 mm (Fig.37) behind the back of the blade. Tighten the knob (B, Fig.36) again.

Step 4: Loosen the screw (C, Fig.36) and set the guide bearing to a position 0.5 mm from the blade. Tighten the screw (C, Fig.36) again.

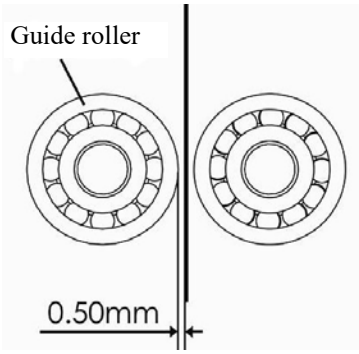

Fig. 38: Setting the guide bearings

Adjusting the bottom saw band guide

The lower saw band guide must be readjusted after each band saw blade change or tracking adjustment.

Step 1: Loosen the Allen screw (D), move the entire lower tape guide, and set the guide bearing to a position of 1 or 2 mm below the edge of the sheet. Tighten the Allen screw (D) again.

Step 2: Loosen the screw (E) and set the support bearing to 0.5 mm behind the back of the blade. Tighten the screw (E) again.

Step 3: Loosen the screw (F) and set the guide bearing to a position 0.5 mm from the blade. Tighten the screw (F) again.

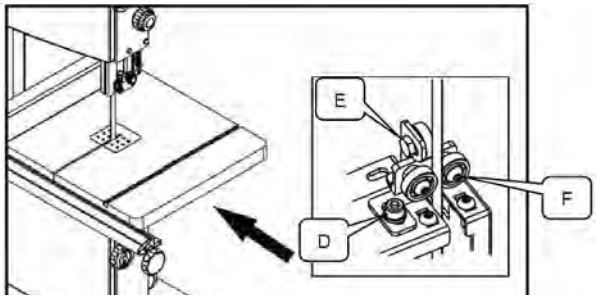

Fig. 39: Set the position of the lower tape guide

Adjusting the cutting speed

Step 1: Open the lower roller cover.

Step 2: Loosen the drive belt by turning the knob clockwise.

Step 3: Place the drive belt on the desired pulley of the drive wheel (lower band saw blade) and the corresponding motor pulley.

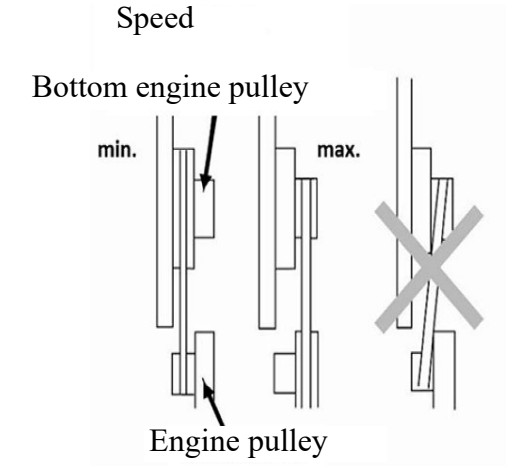

Fig. 40: Set cutting speed

Step 4: Close the lower roller cover.

Adjusting the belt tension

NOTE!

If necessary, adjust the motor position to adjust the belt tension.

Step 1: Release the lock of the motor and turn the motor counterclockwise to reduce the tension of the drive belt. Turn the motor clockwise to increase the tension of the drive belt.

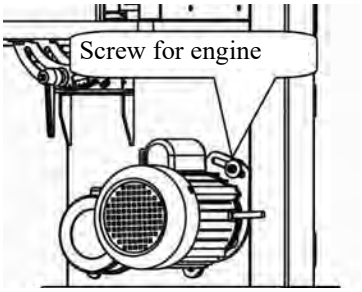

Fig. 41: Adjust belt tension

Step 2: Position the motor so that the drive belt in the middle can be pressed through approx. 10mm. Then fix the engine again and close the lower roller cover.

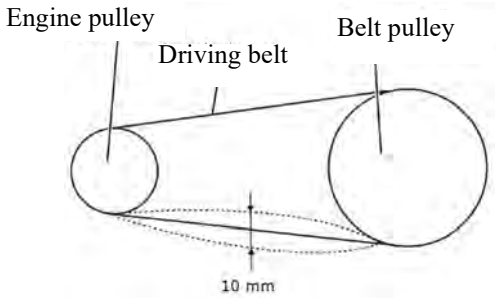

Fig. 42: Belt tension

Changing the saw band

DANGER!

Before changing the saw blade, switch off the machine, pull out the mains plug and wait until the band saw band stops.

Wear sutiable safety gloves!

DANGER!

Use only suitable saw bands!

DANGER!

Make sure to insert the new saw blade correctly!
Make a note of which direction the teeth of the old saw band are pointing!

A saw blade change is required when using different materials and material thicknesses, as well as worn saw band.

Step 1: Detach the guide rail and remove it from the band saw.

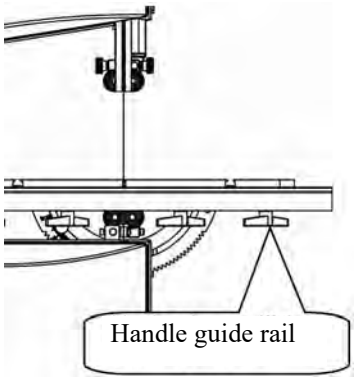

Fig. 43: Remove guide rail

Step 2: Open the upper and lower roller cover.

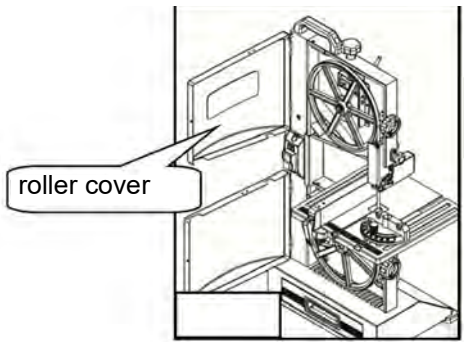

Fig. 44: Open the roller cover

Step 3: Use the turning handle to set the upper saw band roller in the lowest position and then relax saw band.

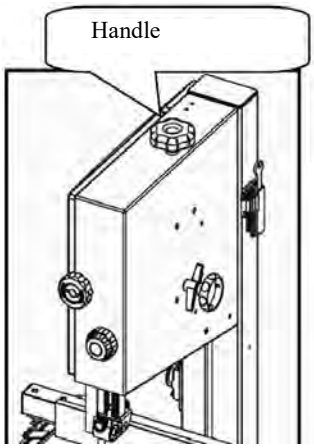

Fig. 45: Set the lowest position

Step 4: Remove the old saw blade.

Step 5: Insert a new saw band with the correct direction.

Step 6: Retighten the twist grip and tighten the saw blade as described in chapter 8.2.

Step 7: Close the upper and lower roller cover.

Step 8: Re-attach the guide rail to the band saw.

Step 9: Align the saw blade. Switch on the bandsaw and make sure that the saw blade is moving correctly.

7.3 Settings on the HBS 321-2 and 361-2

DANGER!

- Before any adjustment, set-up and maintenance work on the machine, the machine must be switched off and the mains plug must be disconnected!

Adjusting the tilting table

Step 1: Release the latch with the quick release lever.

Step 2: Pivot the table until the desired angle is reached.

Step 3: Fix the table and check the angle markings with the aid of the scale display.

Step 4: Perform a trial cut to control the angle.

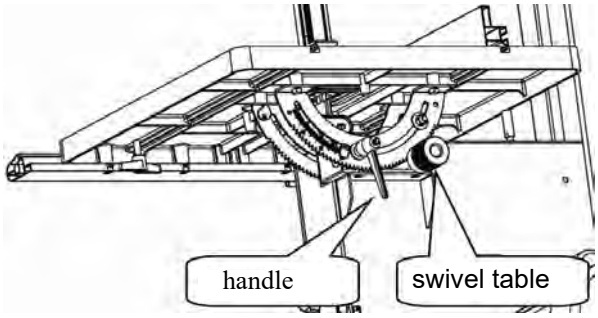

Fig. 46: Setting the swivel table

Aligning the saw blade

If the saw blade does not run in the middle of the rollers, the tracking must be corrected by adjusting the inclination of the band saw blade.

Step 1: Open the top and bottom roller cover.

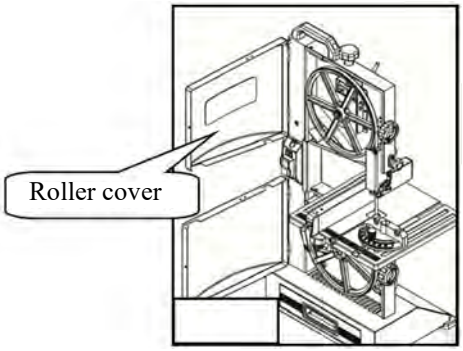

Fig. 47: Roller cover

Step 2: Slowly turn the top roller clockwise by hand. The saw band should run centrally on the rubber pads of the roller. Be careful not to grab the saw blade.

Step 3: If the saw blade does not run in the middle, correct the saw blade by turning the dial to the left or right.

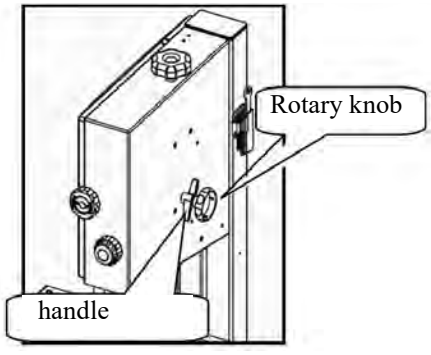

Fig. 48: Rotary knob for tilt adjustment

Step 4: Check the run of the saw blade on the roller. It should rest in its full width on the rubber pad.

Step 5: After completing the adjustments, fix everything again and close both covers.

Adjusting the saw blade tension

DANGER!

The saw blade tension must be checked before each use!

WARNING!

Excessive saw blade tension can cause saw blade breakage and serious injury.

Too low a saw blade tension can lead to slippage of the tape guide rollers and thus to the standstill of the saw blade.

Therefore always pay attention to a correct setting of the saw blade tension!

Step 1: Turn the handwheel to increase or decrease the saw blade tension via a spring. Turn the adjustment knob clockwise to increase the blade tension. Turning the knob counterclockwise decreases the blade tension. Check the setting on the blade voltage gauge. The scale indicates the correct setting depending on the band saw blade width.

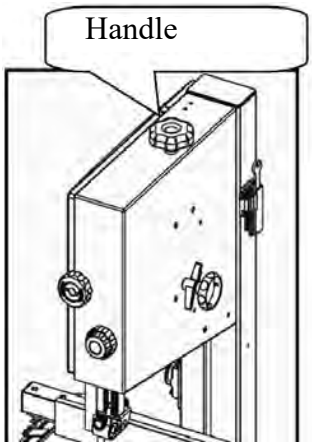

Fig. 49: Saw band tension

NOTE!

After completion of the working shift, the saw band is to be released again with the rotary knob.

NOTE!

Check the tension by pressing your finger halfway between the table and the top guide against the side blade.

The ideal tension is about 2mm.

Adjusting the saw band tension indicator

The blade tension indicator can be adjusted for blades that are known to be cut over / under length by different manufacturers. If the blade is moderately tensioned, loosen the locking screw and raise or lower the blade indicator as needed. Tighten the set screw again.

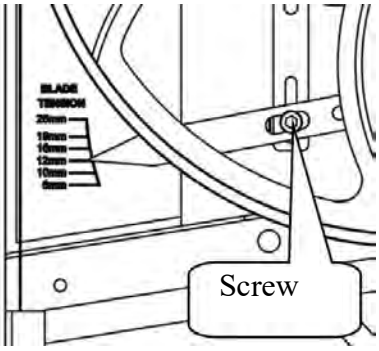

Fig. 50: Saw band tension indicator

Adjusting the upper saw band guide

Before each sawing process, the upper saw band guide must be adjusted depending on the workpiece height. The upper saw band guide must be approx. 3 mm above the workpiece.

Step 1: Loosen the saw blade guide wheel and use the dial to adjust the height. Then retighten the locking wheel (Fig.51).

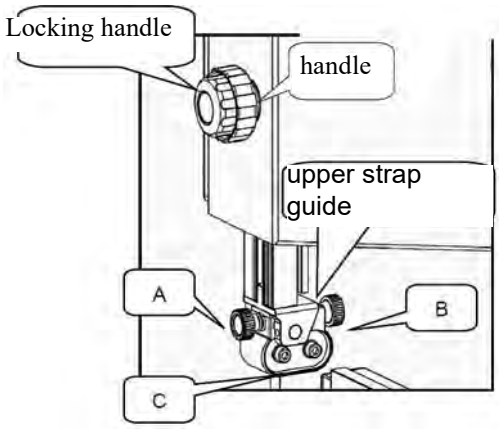

Fig. 51: Adjust the position of the upper strap guide

Step 2: Loosen the screw (A, Fig.51) and adjust the position of the guide bearing so that the guide bearing is 1 or 2 mm (Fig.52) away from the teeth of the saw blade. Then tighten the screw (A, Fig.51) again.

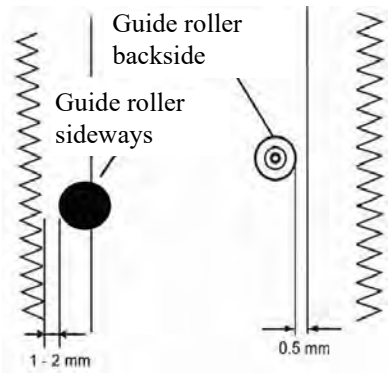

Fig. 52: Adjustment the guide bearings

Step 3: Loosen the screw (B. Fig.51) and set the back of the guide roller to 0.5 mm (Fig.53) behind the back of the blade. Tighten the knob (B, Fig.51) again.

Step 4: Loosen the screw (C, Fig.51) and set the guide bearing to a position 0.5 mm from the blade. Tighten the screw (C, Fig.51) again.

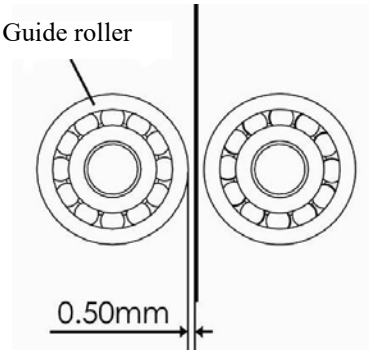

Fig. 53: Adjustment the guide roller

Adjusting the lower saw band guide

The lower saw band guide must be readjusted after each band saw blade change or tracking adjustment.

Step 1: Loosen the Allen screw (D), move the entire lower tape guide, and set the guide bearing to a position of 1 or 2 mm below the edge of the sheet. Tighten the Allen screw (D) again.

Step 2: Loosen the screw (E) and set the support bearing to 0.5 mm behind the back of the blade. Tighten the screw (E) again.

Step 3: Loosen the screw (F) and set the guide bearing to a position 0.5 mm from the blade. Tighten the screw (F) again.

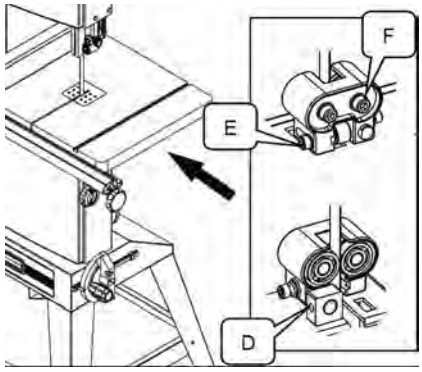

Fig. 54: Set the position of the lower tape guide

Adjusting the cutting speed

Step 1: Open the lower roller cover.

Step 2: Loosen the drive belt by turning the knob clockwise.

Step 3: Place the drive belt on the desired pulley of the drive wheel (lower band saw blade) and the corresponding motor pulley.

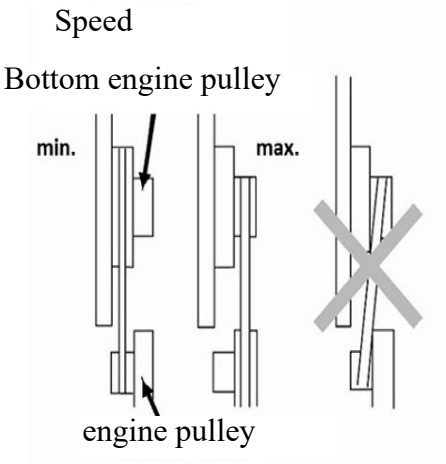

Fig. 55: Adjustment the cutting speed

Step 4: Close the lower roller cover.

Adjusting the belt tension

NOTE!

If necessary, adjust the motor position to adjust the belt tension.

Step 1: If necessary, turn the adjustment knob to adjust the belt tension. Turning the adjustment knob clockwise reduces the tension of the drive belt. Turning the adjustment knob counterclockwise increases the tension of the drive belt.

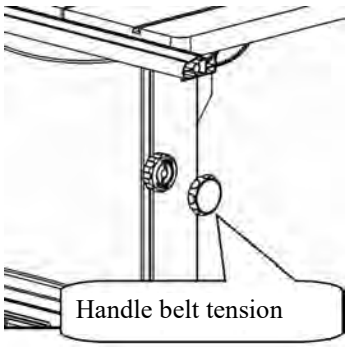

Fig. 56: Adjust the belt tension

Step 2: Position the motor so that the drive belt in the middle can be pressed through approx. 10mm. Then fix the engine again and close the lower roller cover.

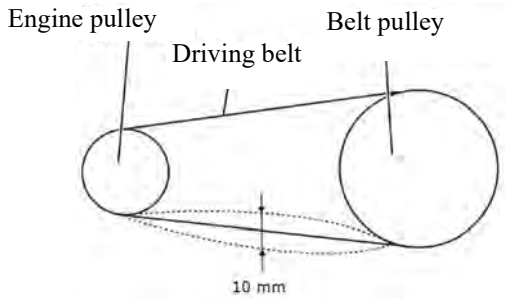

Fig. 57: Belt tension

Changing the saw blade

DANGER!

Before changing the saw blade, switch off the machine, pull out the mains plug and wait until the band saw band stops.

Wear suitable safety gloves!

DANGER!

Use only suitable saw bands!

DANGER!

Make sure to insert the new saw blade correctly! Make a note of which direction the teeth of the old saw band are pointing!

A saw blade change is required when using different materials and material thicknesses, as well as worn saw band.

Step 1: Loosen the guide rail fasteners and remove them from the band saw.

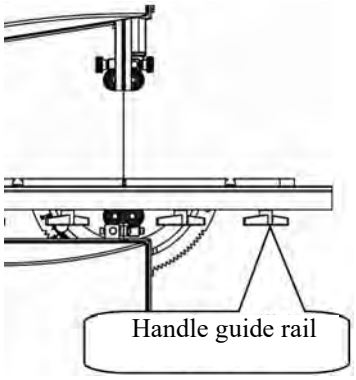

Fig. 58: Remove guide rail

Step 2: Open the upper and lower roller cover.

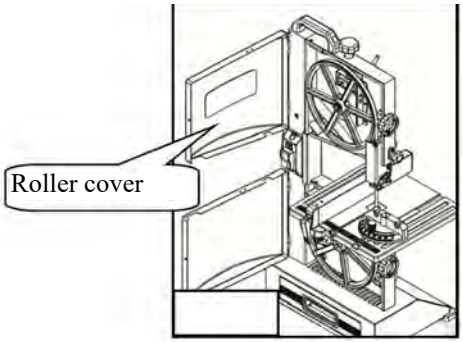

Fig. 59: Open the roller cover

Step 3: Use the turning handle to set the upper saw band roller in the lowest position and then relax saw band.

Step 4: Remove the old saw blade.

Step 5: Insert a new saw band with the correct direction.

Step 6: Retighten the twist grip and tighten the saw blade as described in chapter 8.3.

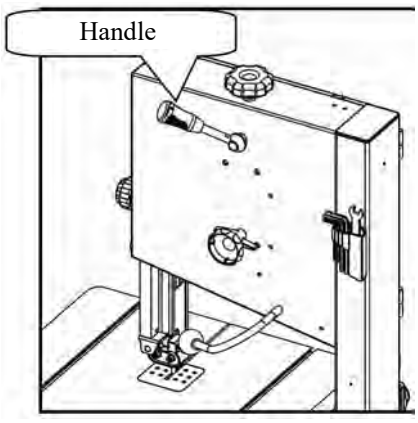

Fig. 60: Handle

Step 7: Close the upper and lower roller cover.

Step 8: Re-attach the guide rail to the band saw.

Step 9: Align the saw blade. Switch on the bandsaw and make sure that the saw blade is moving correctly.

7.4 Adjustment the rip fence scale

Step 1: Slide the rip fence in the direction of the saw blade and loosen the screw.

Step 2: Move the scale along the mark in the viewing window. If necessary, you can also insert the screw in another position to fix the scale.

Fig. 61: Rip fence scale

Step 3: To check the settings, saw a test piece first if necessary and reset the scale.

8 Operation of the Wood Band Saw

DANGER!

Risk of fatal injury due to electric shock!

Contact with live components may result in fatal injury. Switched-on electrical components can make uncontrolled movements and lead to serious injuries.

- Disconnect the mains plug before making any adjustments to the machine.

WARNING!

Risk of injury!

There is a risk of injury to the operator and other persons if they do not comply with the following rules.

- The Wood Band Saw may only be operated by a trained person.
- The operator may not work while under the influence of alcohol, drugs or medication.
- Always cut only one workpiece.
- Secure round stock when you cut it.
- Do not try to slow or stop the band saw blade by pushing the workpiece against the saw blade from the side.
- The operator must not work when he is tired or suffering from concentration-impairing illnesses.
- The Wood Band Saw may only be operated by one person.

DANGER!

- Health-damaging emissions of wood dust when used indoors.
- Risk of kickback of the workpiece.
- Risk of ejection of branch parts and workpiece parts.

DANGER!

- Protect the machine from humidity (danger of short circuit!).
- Do not overload the machine! You will work better and safer in the specified performance range.
- Never use blunt or damaged saw blades. Check that the correct saw blade is used.

ATTENTION!

Risk of crushing!

In case of unintended work on the device, there is a risk of injury to the upper limbs.

Use hearing protection!

Use protective goggles!

Wear protective dust-mask!

Wear safety boots!

Wear protective clothes

8.1 Workflow

Step 1: Check that the Wood Band Saw is turned off and the power plug is unplugged.

Step 2: Check that all covers and safety devices are properly installed. Adjust the upper saw band guide 3mm above the workpiece.

Step 3: The workpiece on foreign objects such as e.g. Check nails or screws and remove if necessary.

Step 4: Select and clamp the saw blade and check the moving parts for ease of movement.

Step 5: Adjust the tilt angle if necessary.

Step 6: Connect suction to the exhaust and switch on.

Step 7: Switch on the saw by pressing the green START button.

Step 8: Guide the workpiece against the saw blade.

Step 9: After completing the sawing work, switch off the wooden band saw with the red STOP button, switch off the exhaust after approx. 20 seconds and disconnect the mains plug.

NOTES FOR SAWING!

- The band saw does not cut the workpiece automatically. The user allows cutting by guiding the work-piece into the moving saw blade.
- The teeth cut the workpiece in the direction of the worktable (down).
- The workpiece must be moved slowly into the saw blade.
- Every person who works with the band saw needs instruction.
- When cutting thicker workpieces, make sure that the band saw blade is not bent or twisted. This increa-ses the service life of the saw blade.
- For all cutting operations, the upper band guide must be positioned as close as possible to the work-piece. This ensures the best possible operator safety.
- Always guide the workpiece with both hands and hold it flat on the band saw table to avoid jamming the band saw blade.
- Always use the rip fence or the mitre fence for all cutting operations for which they can be used. This prevents the saw blade from running out of the cut-ting line, especially when working with an inclined table.
- Plan the necessary steps in advance. An old crafts-man's rule is "measure twice, saw once". It is better to make a cut in one operation rather than in several secti-ons that may require retraction after the band saw blade has come to a standstill.
- Remember that the band saw blade causes a kerf and adjust the kerf width so that the kerf is in the section part of the workpiece. Add a little extra if the workpiece edge is to be machined later.

8.2 Turning the band saw off and on

To start the band saw, switch on the switch. To stop the band saw, turn off the switch. To use the LED light, turn on the LED light switch.

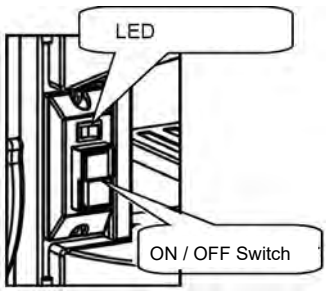

Fig. 62: ON / OFF Switch

8.3 Rip fence

For straight longitudinal cuts, the workpiece is guided along the rip fence. The rip fence can be adjusted to the desired cutting width.

8.4 Mitre fence

To use the miter fence, push it into the provided guide groove.

To set the angle of the miter cut, loosen the lock, bring the miter fence to the desired position and then fix it again.

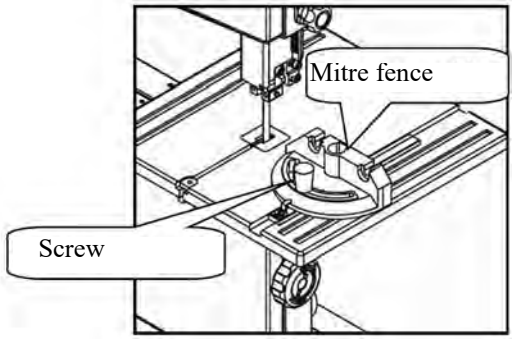

Fig. 63: Mitre fence

DANGER!

When cutting with miter box, the fixed clamping screw must be tightened.

8.5 Use of the push stick

The push stick serves as an extension of the hand and protects against accidental contact with the saw blade. If the push stick is not used, it can be stored on the hook provided on the band saw.

Replace the push stick if it is damaged.

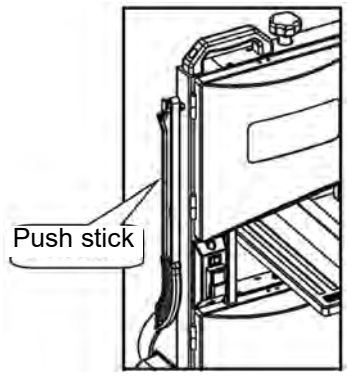

Fig. 64: Push stick

8.6 Using the rip fence

The rip fence can be used on both sides of the blade. If the rip fence moves from one side of the saw blade to the other, the fence must be reversed.

To change the stop side, loosen the two screws (G), fix the stop on the other side and fix the stop with the two screws (G).

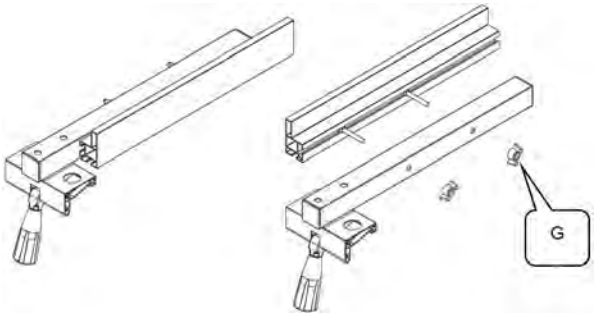

Fig. 65: Adjust rip fence

To move the stop, loosen the quick release (Fig.66), position the stop to the desired position and fix it again.

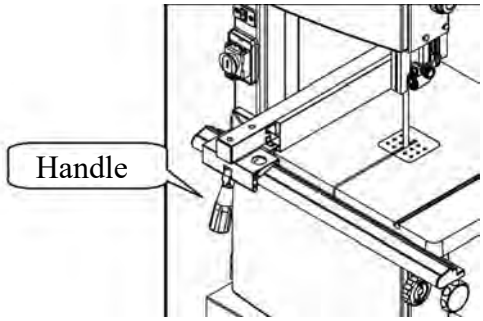

Fig. 66: Clamping the rip fence

When cutting thin workpieces it is possible to change the height of the stop.

- Loosen the 2 screws (G, Fig. 65).
- Push the stop out and turn it 90 °.
- Insert the locking screw into the other groove of the stopper.
- Tighten the two screws (G, Fig. 65) again.

To set the stop parallelism, loosen the screws (H, Fig.67), set the stop and then fix it again.

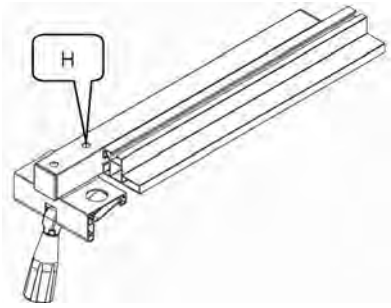

Fig. 67: Set parallelism

8.7 Connection to an exhaust system

The band saw offers a dust connection. When sawing wood, it should be connected to a suitable extraction system.

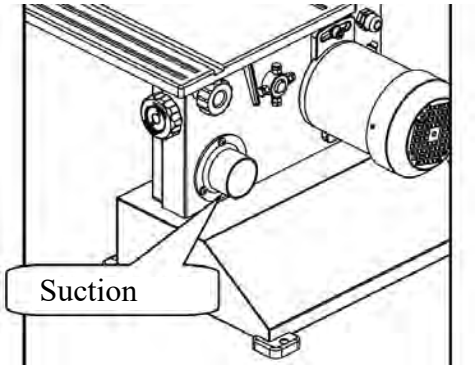

Fig. 68: Suction

If no suction system is connected to the band saw, the wood chips accumulate in the drawer below the lower belt roll.

This drawer must be emptied after use and cleaned regularly.

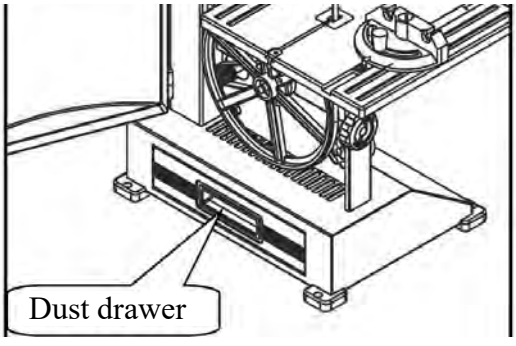

Fig. 69: Dust drawer

8.8 Types of cuts

Longitudinal cuts

The longitudinal cuts are sawing along the workpiece grain. It is possible to saw along a torn line without a rip fence or along the rip fence for a better result.

For right-angled cuts (the table is at right angles to the band saw blade), the rip fence is placed to the left of the band saw blade so that the workpiece can be guided safely along the fence with the right hand.

In the case of longitudinal mitre cuts with an inclined table, the rip fence must be fitted to the right of the blade on the downward side (if the width of the workpiece permits this) in order to secure the workpiece against slipping.

Cross sections

Cross-section is the sawing at right angles to the grain of the wood. This type of cut can also be carried out without a rip fence.

Freehand cuts

The ease with which curved cuts can be made is one of the outstanding features of a band saw. For curved cuts, choose a band saw blade with a width that can cut the smallest radii in your workpiece. For freehand cutting, you should work at a low feed rate so that the saw band can follow the desired line. Make sure that you do not push the workpiece sideways out of the cutting line. This will cause the saw band to run and jam in the cutting groove.

Tips and recommendation

It can often be useful to remove excess material about 10 mm from the cutting line. In the case of very tight radii, which the saw blade can no longer cut properly, cuts at right angles to the curve line and at a small distance from each other can help. When sawing the radius, the material falls off so that the saw band cannot jam.

9 Care, maintenance and repair

In this chapter you will find important information on the inspection, maintenance and repair of the band saw..

WARNING!

Read and observe the safety instructions in this operating manual before starting inspection, maintenance or repair work.

ATTENTION!

Only carry out maintenance or servicing work when the band saw is disconnected from the power supply. Disconnect the mains plug.

Use suitable protective gloves!

Wear protective gloves. There is a danger of cuts even when the saw blade is stationary.

DANGER!

Risk of fatal injury due to electric shock!

Contact with live components may result in fatal injury. Switched-on electrical components can make uncontrolled movements and lead to serious injuries.

- Before starting cleaning and maintenance work, switch off the machine and disconnect the mains plug.
- Connections and repairs to the electrical equipment may only be carried out by a qualified electrician.

9.1 Care after work

Use suitable protective gloves!

NOTE!

Never use strong cleaning agents or solvents for any cleaning work. This can damage or destroy the de-vice.

Step 1: Disconnect the power plug from the power outlet.

Step 2: Empty and clean the suction device.

Step 3: Clean the machine from chips and sawdust with compressed air (Attention: wear safety goggles and dust mask!) And / or with a brush or a dry cloth.

DANGER!

Do not remove the chips with bare hands. There is a risk of cuts due to chips and tools!

Step 4: Clean the wooden band saw regularly with a damp cloth and a mild detergent.

Step 5: Spray or oil all unpainted metal surfaces with a little anti-rust spray.

Step 6: Lubricate the bearings and guide points regularly with a high quality engine grease.

9.2 Maintenance and repair

Maintenance and repair work may only be carried out by qualified personnel.

If the Wood Band Saw does not work properly, contact a dealer or our customer service. The contact details can be found in chapter 1.2 Customer Service.Before use, the machine must be checked for external damage.

Before using for the first time, and every 100 working hours thereafter, lubricate all movable connecting parts (if necessary with a brush of chips and dust beforehand) with a thin layer of lubricating oil or grease.The V-belt should be checked for correct voltage after the first 20 hours of operation. After every 250 operating hours (every six months), check the V-belt for wear, porosity and tension.All protective and safety equipment must be reinstalled immediately after repair and maintenance work has been completed.

After every working

- Relax the saw band.
- Disconnect the machine from the mains.
- Clean the machine completely.
- Lubricate the saw blade guide with light machine oil.
- Clean the machine from chips.
- Check the saw blade for damage and sharpness.

NOTE!

Only a regularly maintained and well maintained machine can be a satisfactory tool. Maintenance and care deficiencies can lead to unpredictable accidents and injuries.Repairs requiring special expertise should only be carried out by authorized professionals.

Storage

The band saw should be stored in a dry, clean and non-corrosive environment.

Suction

Check the suction daily for its adequate function. If the extraction system does not work or only to a limited extent, it must be repaired again. Only then may the wooden band saw be put into operation.

10 Troubleshooting

DANGER!

If one of the following errors occurs, stop working with the machine immediately. It could lead to serious injuries.

All repairs or replacement work may only be carried out by qualified and trained specialist personnel.

Fault	Possible causes	Solution
The wood band saw does not start when the switch is actuated.	1. No power supply. 2. Defective switch.	1.Plug in the plug or have the power connection checked by qualified personnel. 2.Have the switch replaced by qualified personnel.
The motor is running, but the saw band is not.	1.The quick release lever is open. 2.The band saw blade runs off the wheels. 3.The saw band is broken. 4.The V-belt is damaged.	1.Switch off the motor and clamp the quick release lever. 2.Switch off the motor and adjust the saw band correctly. 3.Insert a new saw band. 4.Insert a new V-belt.
The saw band does not cut a straight line.	1.The rip fence is not used. 2.The feed too fast. 3.The saw band teeth are blunt or damaged. 4.The saw band guides are not adjusted correctly.	1.Use the rip fence. 2.Press the saw band with the workpiece. 3.Insert a new saw band. 4.Readjust the saw band guide.
The saw band does not cut or cuts only very slowly.	1.The saw band teeth are blunt due to the sawing of wrong material. 2.The saw band was installed the wrong way round.	1.Insert the correct saw band for the material to be processed. 2.Insert the saw band correctly.
Chips and sawdust accumulate in the machine.	1. It is a normal situation.	1. Clean the machine regularly. If necessary, use a vacuum cleaner.
Sawdust in the motor housing.	1. Abnormal amounts of sawdust.	1.Clean the motor housing with a vacuum cleaner. 2.Use a suction unit
The machine is not sawing at the correct angle.	1.The saw table is not correctly adjusted. 2.The saw band is blunt or too much cutting pressure has been applied	1 Adjust the saw table correctly. 2. Change the saw blade and exert less pressure.
The saw blade run cannot be adjusted correctly.	1.The wheels are not adjusted. Defective bearings. 2.The saw blade run has not been adjusted correctly. 3.Low-quality saw band.	1.Contact your dealer. 2.Adjust the saw blade run. 3.Use a different saw blade

11 Disposal, reusing used machines

In your own interest and to protect the environment make sure that all machine components are exclusively dis-posed of in as intended and permitted.

11.1 Decommissioning

Disused machines must be decommissioned immediately to prevent misuse at a later point and putting the environment or persons at risk.

Step 1: Remove all environmentally hazardous fluids from the old machine.

Step 2: If necessary, dismantle the machine into manageable and usable assemblies and components.

Step 3: Guide the machine components and operating materials to the appropriate disposal routes.

11.2 Disposal of electrical equipment

Note that electrical equipment contains a variety of recycling-capable materials and also environmentally haz-ardous components.

Please help to separate these components and dispose of them responsibly. In case of doubt, contact your local waste disposal authority. Consult a specialist disposal agent for recycling if needed.

11.3 Disposing of lubricants

Lubricant manufacturers provide disposal information for the lubricants used. If necessary, request product-specific data sheets.

11.4 Disposal via municipal collection points

Disposal of used electrical and electronic equipment (Applicable in the countries of the European Union and other European countries with a separate collection system for these appliances).

The symbol on the product or its packaging indicates that this product should not be treated as normal household waste, but must be returned to a collection point for the recycling of electrical and electronic equipment. By helping to properly dispose of this product, you are protecting the environment and the health of others. Environment and health are endangered by improper disposal. Material recycling helps to reduce the consumption of raw materials. For more information about recycling this product, contact your local community, municipal waste management, or the shop where you purchased the product.

12 Spare parts

DANGER!

Risk of injury caused by the use of incorrect spare parts!

The use of incorrect or faulty spare parts may cause risks for operating staff and damage as well as malfunctions.

- Exclusively genuine spare parts made by the manufacturer or spare parts authorised by the manufacturer shall be used.
- Always contact the manufacturer if you are unsure.

12.1 Ordering spare parts

The spare parts can be obtained from the specialist dealer.

Specify the following key data when ordering spare parts:

- Device type
- Item number
- Position number
- Year of construction
- Quantity
- Desired shipping type (post, freight, sea, air, express)
- Shipping address

Spare parts orders without the aforementioned data cannot be taken into account. The supplier shall determine the shipping type if no relevant data was provided. Data on the machine type, item number and year of manufacture is listed on the type plate attached to the device.

Example

The drive belt for the Wood Band Saw HBS 231-1 must be ordered. The drive belt has the number 65 in the spare parts drawing 1.

By ordering spare parts, send a copy of the spare parts drawing (1) with the marked part (drive belt) and marked positon number (65) to the dealer or spare parts department and provide the following information:

- Type of device: **Wood Band Saw HBS 231-1**
- Item number: **5902423**
- Position number: **65**
- Drawing number: **1**

The item number of your device:

Holzbandsäge HBS 231-1	5902423
Holzbandsäge HBS 261-2	5902426
Holzbandsäge HBS 321-2	5902432
Holzbandsäge HBS 361-2	5902436

12.2Spare parts drawings

Spare parts drawing 1 - HBS 231-1

The following spare parts drawings are intended to help identify the necessary spare parts. To order, please send a copy of the list of spare parts with the marked components to your dealer.

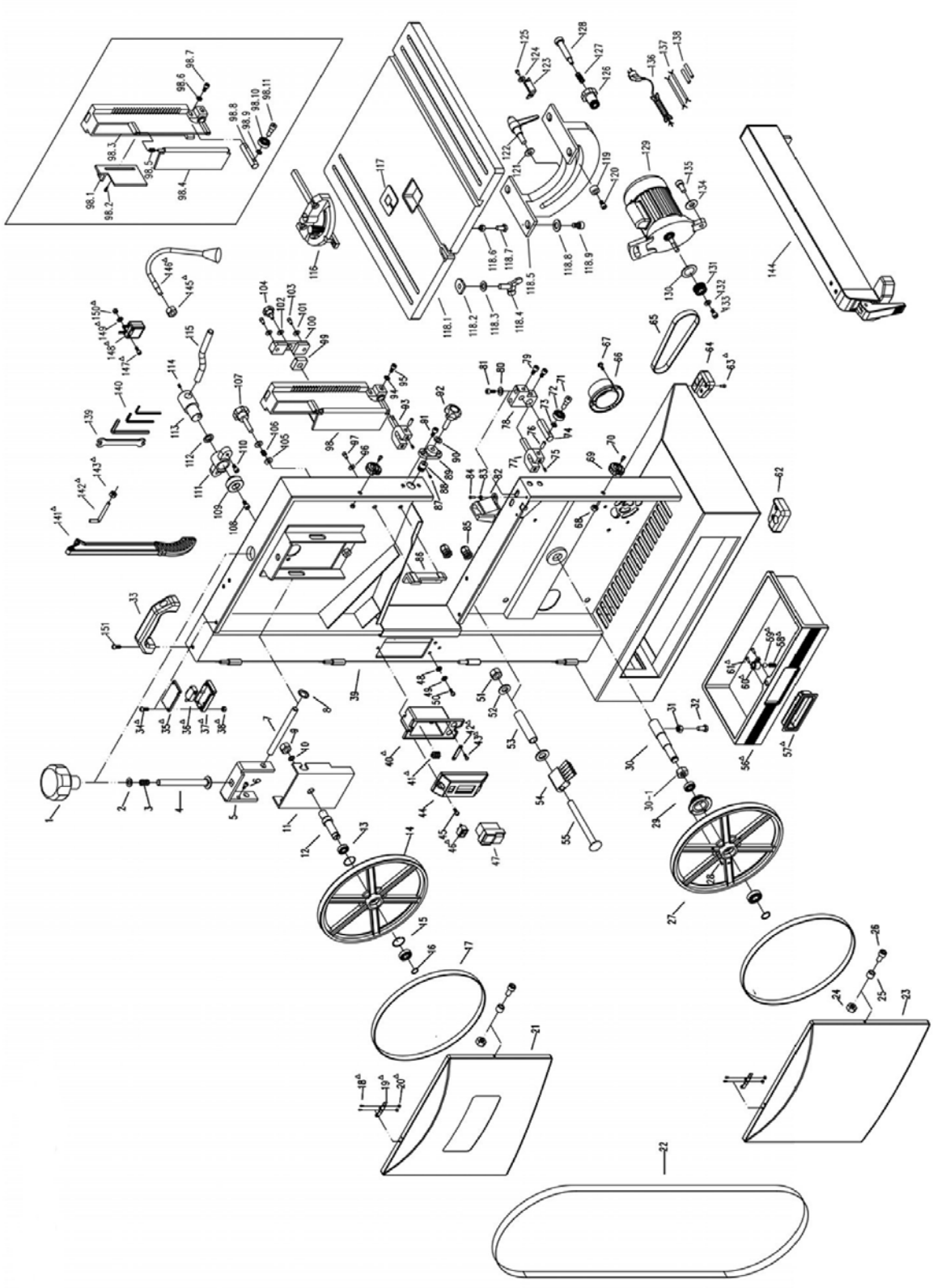

Fig. 70: Spare parts drawing 1 - Wood Band Saw HBS 231-1

Spare parts drawing HBS 261-2

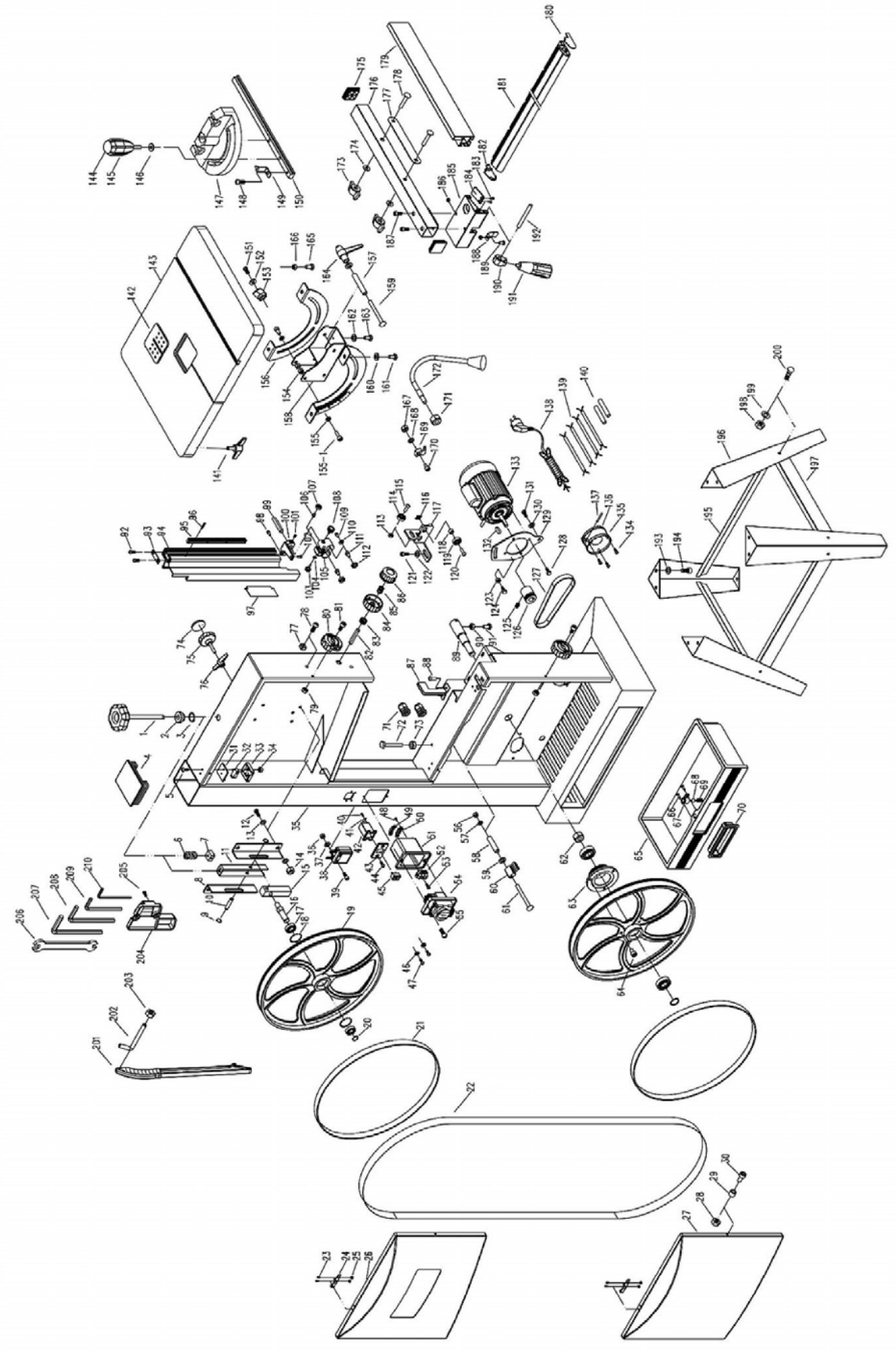

Fig. 71: Spare parts drawing 2 - Wood Band Saw HBS 261-2

Spare parts drawing HBS 321-2 and 361-2

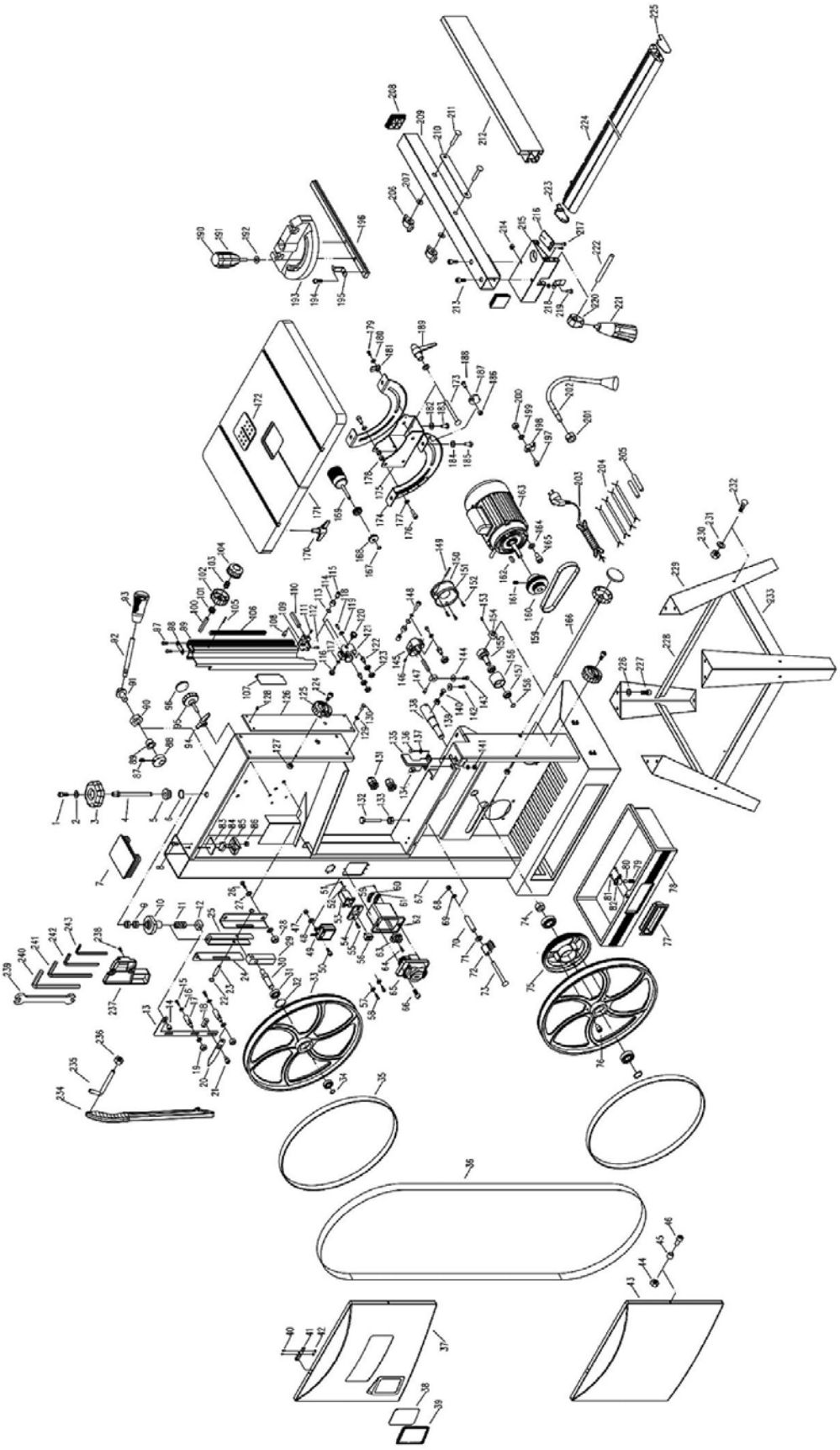

Fig. 72: Spare parts drawing 3 - Wood Band Saw HBS 321-2 and 361-2

13 Electrical circuit diagram

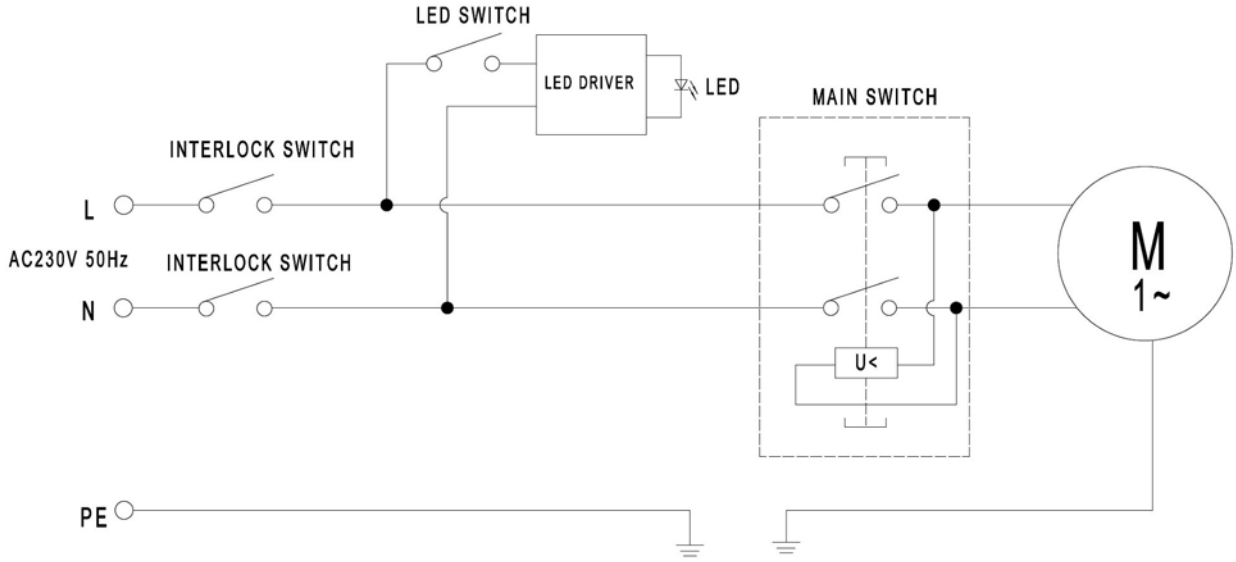

Fig. 73: Electrical circuit diagram

14 EC Declaration of Conformity

As per machine directive 2006/42/EC, Appendix II 1.A

Manufacturer/seller: Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt

hereby declares that the following product

Product group: Holzstar® Woodworking machines

Machine type: Wood Band Saw

Designation of the machine *:		**Item number *:**	
	☐ HBS 231-1		☐ 5902423
	☐ HBS 261-2		☐ 5902426
	☐ HBS 321-2		☐ 5902432
	☐ HBS 361-2		☐ 5902436

Serial number*: _____

Year of manufacture*: 20____

* please fill in according to the information on the type plate

complies with all relevant regulations of the aforementioned directive as well as any other, applicable directives (subsequently added) – including the changes applicable at the time the declaration was made.

Relevant EU directives:

2014/30/EU	EMC Directive
2011/65/EU	RoHS-Directive
2012/19/EU	WEEE-Directive

The following harmonized standards have been applied:

DIN EN 61029-2009/A11:2010	Safety of transportable motor-operated electric tools - Part 1: General requirements
DIN EN 61029-2-5:2011	Safety of transportable motor-operated electric tools - Part 2-5: Particular requirements for band saws
DIN EN 55014-1:2017	Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 1: Emission
DIN EN 55014-2:2015	Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 2: Immunity - Product family standard
DIN EN 61000-3-2:2014	Electromagnetic compatibility (EMC) - Part 3-2: Limits - Limits for harmonic current emissions (equipment input current <= 16 A per phase)
DIN EN 61000-3-3:2013	Electromagnetic compatibility (EMC) - Part 3-3: Limits - Limitation of voltage changes, voltage fluctuations and flicker in public low-voltage supply systems, for equipment with rated current <= 16 A per phase and not subject to conditional connection

Responsible for the documentation:: Kilian Stürmer, Dr.-Robert-Pfleger-Str. 26, D-96103 Hallstadt

Hallstadt, 25.01.2019

Kilian Stürmer
Manager

CE

15 Notes


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