holzstar
Holzbearbeitungsmaschinen

Operating Instructions

Wood Band Saw

HBS 603

HBS 803

HBS 703

HBS 603

HBS-SERIES

Imprint

Product identification

Wood Band Saw	Item number
HBS 603	5941163
HBS 703	5941173
HBS 803	5941183

Manufacturer

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Information about the operating instructions

Genuine operating instructions
according to DIN EN ISO 20607:2019

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Copyright information

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Subject to technical modifications and error.

Content

1 Introduction

You have made an excellent choice in purchasing a HOLZSTAR Wood Band Saw.

Carefully read the operating instructions prior to commissioning.

They describe correct commissioning, intended use and safe as well as efficient operation and maintenance of your band saw.

The operating instructions form part of the wood band saw. Keep these operating instructions at the installation location of your band saw. Also observe the local accident prevention regulations and general safety regulations for the use of the band saw.

1.1 Copyright

The contents of these operating instructions are protected by copyright. Their application is permitted within the context of the use of the band saw. Any further use shall not be permitted without written consent by the manufacturer.

For the protection of our products, we shall register trademark, patent and design rights, as this is possible in individual cases. We strongly oppose any infringement of our intellectual property.

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
Germany

Repair service:

Fax: 0049 (0) 951 96555-111
Email: service@stuermer-maschinen.de

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

We are always interested in valuable experience and knowledge gained from using 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 untrained 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 hazardous situation which, if not avoided, will result in death or serious injury.

CAUTION!

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

Operators are defined as the persons who operate the machine for commercial or profit-based purposes or provide the machine to third parties for use or application and bear the legal product responsibility in terms of the protection of users, staff 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 Operating staff qualification

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.

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.

Protective dust-mask

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

2.5 Safety labels on the wood band saw

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

Fig. 1: Safety labels

The safety labels attached to the machine must not be removed. Damaged or missing safety labels can lead to incorrect actions, personal injury and damage to property. They must be replaced immediately.

If the safety labels are not recognisable and comprehensible at first glance, the machine must be taken out of operation until new safety labels have been attached.

2.6 Safety devices

Limit switch

The band saw is equipped with two safety limit switches. The band saw can only be started when the upper and lower doors are closed.

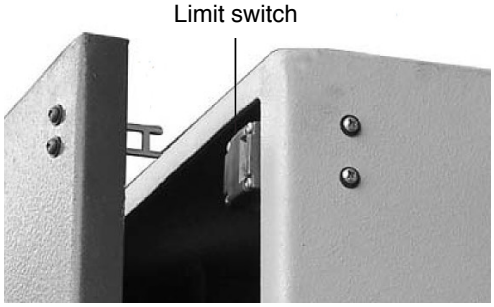


Fig. 2: Limit switch

Emergency stop button

Pressing the emergency stop button (Fig. 2) stops the band saw. After the emergency stop button has been pressed, it must be unlocked by turning it in the direction of the arrow so that it can be switched on again

2.7 General Safety Instructions

- The wood band saw may only be operated and maintained by persons who have read and understood these operating instructions. The operator must be sufficiently trained in the use, setting and operation.
- Keep children and people who are not familiar with the band saw away from its working area.
- Before each use of the band saw, make sure that no parts are damaged. Damaged parts must be replaced immediately to avoid sources of danger.
- Do not overload the band saw! It works better and safer in the specified power range.
- The work area on the band saw must be free of chips and wood debris. Clutter can cause accidents.
- Make sure that the band saw and the working area are sufficiently illuminated.
- Do not switch on the machine until immediately before starting to work. Do not leave the machine unattended when it is ready for operation.
- Do not connect the bandsaw to the mains when the door or protective cover is removed.
- To avoid improper operation, familiarise yourself with the location of the switches before switching on the band saw.
- Memorise the position of the emergency stop button so that you can use it immediately at any time.
- If you are not working on the bandsaw, switch it off and disconnect the mains plug.
- Do not use the cable to pull the plug out of the socket. Protect the cable from heat, oil and sharp edges.
- Make sure that electrical cables are not damaged to avoid injury from leaking electrical current (electric shocks).
- When laying the mains cable, make sure that it is not crushed, bent or wet.
- If the mains cable is damaged, stop the band saw immediately and have it replaced by a qualified electrician.
- Protect the Wood Band Saw from environmental influences and do not expose it to direct sunlight or rain.
- Do not use tools in damp or wet environments.
- Do not neglect to carry out regular inspections according to the instructions for use..
- Check regularly that the safety covers are fitted correctly and are not damaged. Repair damaged covers immediately or have them replaced by a qualified person. Do not operate the bandsaw with the covers removed and do not modify anything on the machine.
- Use only original spare parts and accessories to avoid possible dangers and risks of accidents.

- Store the band saw in a safe place so that no one can be injured or switch on the machine. Make sure that the band saw is not stored unprotected outdoors or in a damp environment.
- Remove items such as rings, watches, bracelets, ties, etc. before starting work, as they can get caught on various parts of the band saw and become entangled.
- Never work under the influence of diseases that impair concentration, overtiredness, drugs, alcohol or medication.
- Protect and secure their hair so as to avoid entanglement by moving parts on the bandsaw.
- Always wear the necessary safety equipment (safety glasses, safety shoes, hearing protection, etc.). Non-slip footwear is recommended when operating the band saw.
- Always wear a protective mask while working on material that generates dust during the operation.
- Avoid abnormal posture.

2.8 Machine-specific safety instructions

- Never touch the rotating saw blade with your hands.
- Check the saw band for perfect condition. Risk of injury from a defective
- saw band.
- Pay attention to the saw band when switching on the band saw. Risk of injury from the starting saw band!
- Make sure that the band saw is set up in a stable position on solid ground. During operation, the band saw should be secured to the floor with screws.
- Do not modify the band saw in a way that poses a risk to safe operation.
- Use the extraction system and respiratory protection while working on the band saw.
- Health hazard due to inhalation of wood dust!
- Only use the bandsaw in accordance with the instructions and the purpose for which it was designed.
- Only a qualified electrician may connect the band saw and carry out repairs on the electrical equipment.
- Before carrying out any maintenance, cleaning or repair work, switch off the bandsaw and disconnect the mains plug.
- Remove all adjustment tools before switching on the bandsaw.
- When handling heavy or bulky workpieces, use suitable supports, e.g. roller stands (optional equipment).
- Do not use compressed air to clean the machine or to remove chips.
- Persons under the age of 16 may only use the band saw as part of vocational training and under the supervision of an instructor.
- Keep the handles dry, clean and free from oil and grease.
- Do not wear gloves when working on the band saw! Use only for cleaning and changing the band saw blade!
- Keep the cutting tools sharp and clean for better and safer work.
- For better and safer working, use only well-sharpened bandsaw blades recommended by the manufacturer.
- Before operation, inspect all workpieces for foreign bodies such as nails and screws.
- Check the workpiece for protruding nails, screw heads or anything that can damage the blade.
- Use a push stick to cut small workpieces on the bandsaw.
- Do not over-tension the drive belt and check it at regular intervals.
- Ensure that the direction arrow, if marked on the band saw, corresponds to the direction of rotation of the motor, the teeth of the blade should always point downwards when viewed from the front of the saw.
- All guards and safety devices must be refitted immediately after repair or maintenance has been completed.

2.9 Safety data sheets

You can obtain safety data sheets on hazardous goods 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.

3 Intended Use

The band saws are designed for sawing wood. It is possible to process solid wood, chipboard, panels and profiles.

The Wood Band Saw is suitable for private use and not for industrial use.

Intended use also includes compliance with all the information in these instructions.

3.1 Reasonably foreseeable misuse

Any use beyond the intended use or any other use is considered misuse.

Possible misapplications may include:

- Use of the wood band saw for materials other than wood (e.g. the processing of metal/plastic).
- Simultaneous sawing of several workpieces.
- Machining workpieces that are too large or too heavy or that are not fixed or not fixed enough.
- Operating the band saw without functioning, intended safety devices.
- Bypassing or changing the safety devices.
- Installation of spare parts and use of accessories
- accessories not approved by the manufacturer.
- Modifications to the band saw or the use of modified tool systems.
- Non-compliance with the maintenance instructions.
- Non-observance of wear and damage marks.
- Service work by untrained or unauthorised personnel.
- Maintenance work on an unsecured Wood Band Saw.
- Placing objects on the work surface.
- Deliberate or careless handling of the band saw during operation.
- Operating the band saw in industrial areas.
- Use of the band saw in areas where there are aggressive or flammable substances in the air (the band saw is not explosion-proof as standard).

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.

3.2 Residual risks

Even if all safety regulations are observed and the machine is used in accordance with the regulations, there are still residual risks, which are listed below.

- Impairment of hearing in the case of prolonged work without hearing protection or if this is inadequate.
- Risk of fire.
- Electrical hazard due to contact with parts and high voltage (direct contact) or with parts under high voltage due to a defect of the appliance (indirect contact).
- Crushing hazard to upper and lower limbs.
- Risk of injury from ejected workpieces if the workpiece is not properly secured or fed, e.g. when working without a fence.
- Danger from inhalation of wood dust (if necessary, use an exhaust system in accordance with the legal requirements).
- Danger of loose clothing or long hair being pulled in.

4 Technical Data

4.1 Table

Model	HBS 603	HBS 703
Length	1100 mm	1200 mm
Width / Depth	800 mm	800 mm
Height	2150 mm	2250 mm
Weight	230 kg	308 kg
Supply voltage, Phase(s)	400V, 3Ph	400V, 3Ph
Current type/mains requency	AC / 50 Hz	AC / 50 Hz
Input power	3,5 kW	4 kW
Delivery power	2,6 kW	3 kW
Main work table length	630 mm	640 mm
Main work table width	480 mm	500 mm
Work table height	920 mm	940 mm
Work table extension length	150 mm	150 mm
Work table extension width	480 mm	500 mm
Work table pivot*	0° - 45°	0° - 45°
Max. cutting height 90°	430 mm	430 mm
Max. cutting height 45°	258 mm	258 mm
Max. cutting width with stop	410 mm	415 mm
Max. cutting width without stop	600 mm	700 mm
Saw band speed(s)	1080 m/min	1080 m/min
Flywheel diameter	610 mm	710 mm
Saw band length	4590 mm	5020 mm
Saw band width	25 mm	38 mm
Saw band thickness	0,6 mm	0,65 mm
Ø Extraction port	2x120 mm	2x120 mm
Saw band guide	fixed	
Ambient temperature max. / min.	+5° ~ +40°C	

Modell	HBS 803
Length	1300 mm
Width / Depth	800 mm
Height	2500 mm
Weight	365 kg
Supply voltage, Phase(s)	400V, 3Ph
Current type/mains frequency	AC / 50 Hz
Input power	4,5kW
Delivery power	3,3 kW
Main work table length	640 mm
Main work table width	500 mm
Work table height	1050 mm
Work table extension length	200 mm
Work table extension width	500 mm
Work table pivot*	0° - 45°
Max. cutting height 90°	470 mm
Max. cutting height 45°	285 mm
Max. cutting width with stop	420 mm
Max. cutting width without stop	800 mm
Saw band speed(s)	1080 m/min
Flywheel diameter	810 mm
Saw band length	5610 mm
Saw band width	38 mm
Saw band thickness	0,65 mm
Ø Extraction port	2x120 mm
Ambient temperature max. / min.	+5° ~ +40°C

*For safety reasons, a holding device / stop must be fitted from 20° to prevent the wood from slipping! a stop must be fitted to prevent the wood from slipping!

4.2 Type plate

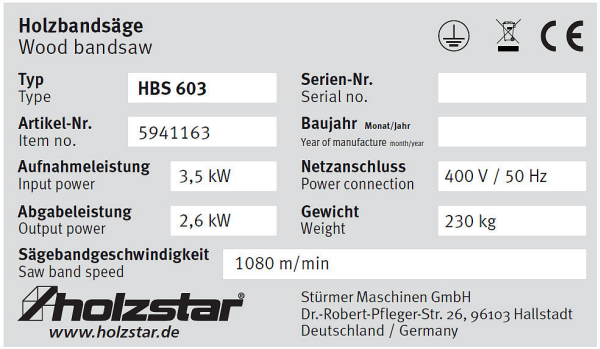


Fig. 3: Type plate HBS 603

5 Transport, packaging, 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.

5.1 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.

5.2 Storage

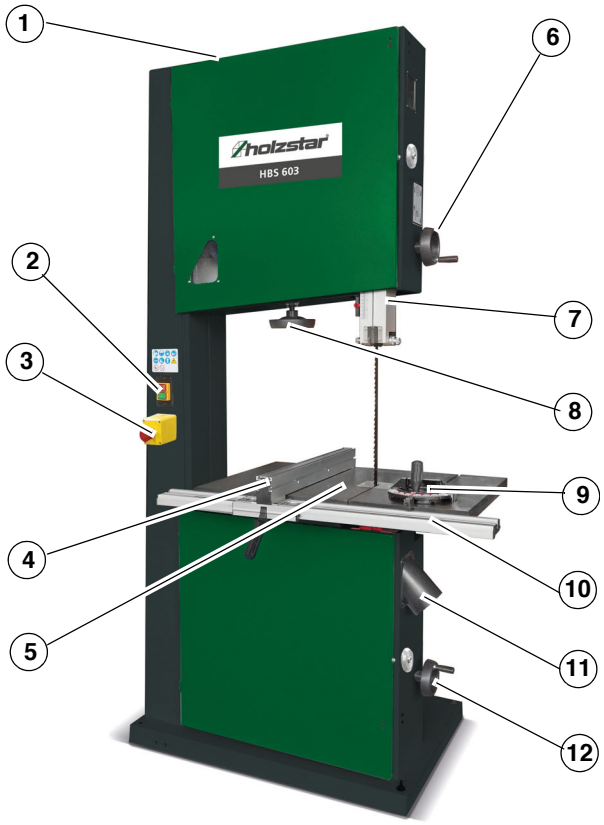
Allow the band saw to cool down completely and store thoroughly cleaned in a dry, clean and frost-free environment.

The temperature range for storage and transport is - 15°C / +55°C.

The relative humidity should not exceed 50% at a maximum temperature of +40°C. A higher relative humidity can be permitted at lower temperatures (e.g. 90% at 20°C).

6 Description of the device

Illustrations in these operating instructions may deviate from the original.



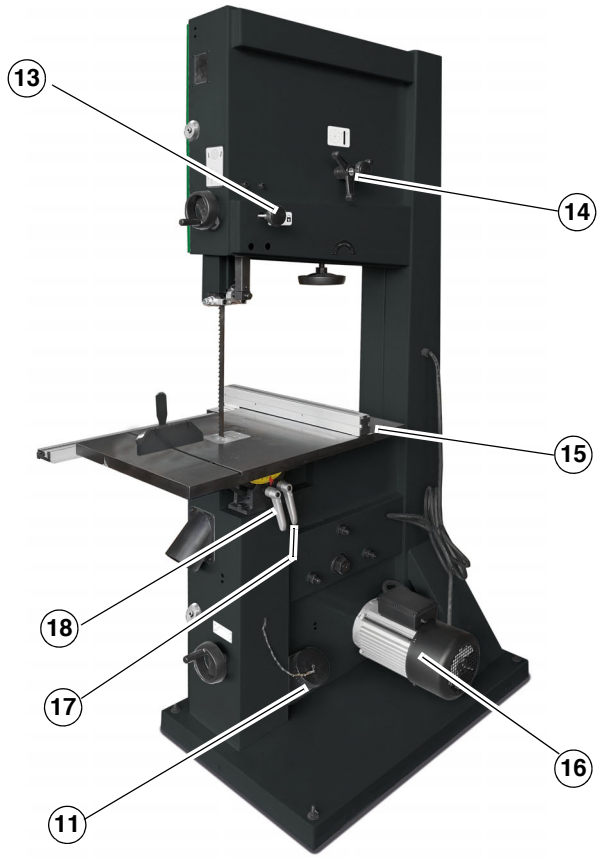


Fig. 4: Machine description

1 Transport eyelet (concealed)
2 On/off switch
3 Emergency stop button
4 Rip fence
5 Work table
6 Handwheel for height adjustment of belt guide
7 Belt guide & guard
8 Handwheel for belt tension
9 Mitre gauge
10 Rip fence guide
11 Suction nozzle
12 Handwheel for belt tension
13 Locking saw band guide (top & bottom)
14 Locking lever saw band guide
15 Work table extension
16 Motor
17 Work table clamping lever
18 Table tilt lever

6.1 Scope of delivery

- Angle stop
- Saw blade
- Push stick

6.2 Accessories

Designation	Item number
Travelling device HBS 603/703/803	5150799
HBS 603	
Saw blade 4590x10x0,5mm 4ZpZ	5169210
Saw blade 4590x16x0,6mm 3ZpZ	5169216
Saw blade 4590x20x0,7mm 3ZpZ	5169220
Saw blade 4590x30x0,7mm 3ZpZ	5169230
HBS 703	
Saw blade 5020x10x0,6mm 4ZpZ	5169310
Saw blade 5020x16x0,6mm 3ZpZ	5169316
Saw blade 5020x20x0,7mm 3ZpZ	5169320
Saw blade 5020x25x0,8mm 2ZpZ	5169325
Saw blade 5020x30x0,8mm 3ZpZ	5169330
HBS 803	
Saw blade 5611x10x0,6mm 4ZpZ	5169410
Saw blade 5611x16x0,7mm 4ZpZ	5169416
Saw blade 5611x20x0,7mm 3ZpZ	5169420
Saw blade 5611x25x0,9mm 3ZpZ	5169425
Saw blade 5611x32x0,9mm 2ZpZ	5169432

7 Assembly

7.1 Requirements for the installation site

The installation site should meet the following criteria:

- The underground must be level, solid and free of vibrations.
- The underground must be able to bear the weight of the band saw and the workpieces to be processed and must not allow any lubricants to pass through.
- The installation or working area must be dry and well ventilated.
- There must be sufficient space for the operating personnel, for material transp.

7.2 Lifting and attachment

ATTENTION!

Pay attention to the weight of the band saw!

The band saw may only be set up by two people together.

Check the transport equipment for sufficient dimensions and load-bearing capacity.

Only lift and transport the band saw according to the description. Never lift the band saw by the working plate..

Transport with a Cran

The bandsaw can be lifted on the transport eye by fitting the eye on the top of the bandsaw using an M10 hexagon nut & M10 washer. See Fig. 5.

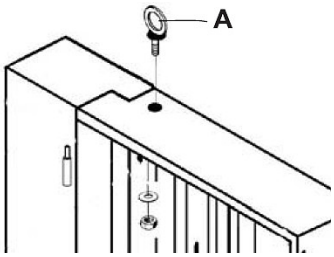


Fig. 5: ansport eyelet

Space requirements

In addition to the maximum dimensions of the workpiece to be processed, at least 1.5 m of free space must be left around the band saw in order to be able to work safely.

Anchoring the wood band saw

In the base plate of the band saw there are four 4x12 mm diameter holes which are used to align the band saw. The corresponding screws are enclosed with the machine. There are also four holes for fixing the bandsaw to the floor (Figure 6).

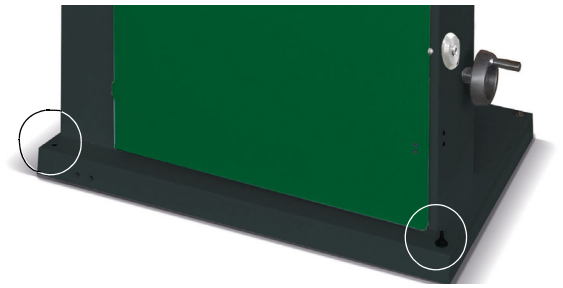


Fig. 6: Fixing the band saw

To prevent vibrations::

- Place insulation material between floor slab and and the subfloor,
- the floor slab must not be deformed.

7.3 Assembly of the wood saw

ATTENTION!

Risk of injury due to an unstable set-up of the wood band saw!
Check the stability of the band saw after setting it up on a stable surface.

The band saw is delivered in a cardboard box and is already mostly assembled. Only a few parts need to be assembled after delivery.

The following steps make the band saw ready for operation:

Step 1: Mount the handwheel (pos. 6, fig. 4) for the height adjustment of the saw band and tighten it with a 10 mm spanner.

Fig. 7: Fitting the handwheel for height adjustment

Step 2: Attach the handwheel (pos. 12, fig. 4) for the belt tension and tighten it with a 10 mm spanner.

Fig. 8: Install the handwheel for the belt tension

Step 3: Mount the suction socket (pos. 11, fig. 4) on the lower side of the machine cover using the 4 screws M5x16.

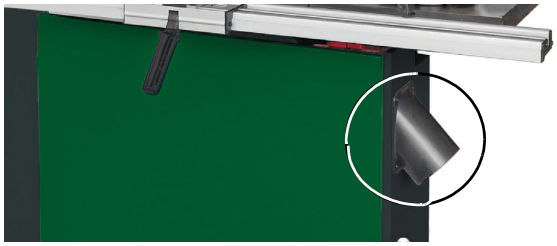


Fig. 9: Install the suction nozzle

Step 4: Position the work table (Pos. E, Fig. 10) on the stand with the help of a second person and guide the saw band (item 2, fig. 10) through the recess on the table.

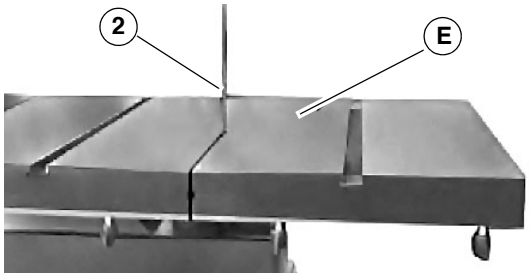


Fig. 10: Assemble the work table

Step 5: Using the 3 M8x30 Allen screws (pos. F, fig. 11), lightly mount the work table.

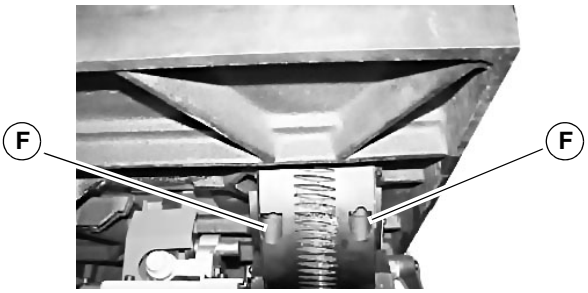


Fig. 11: Mounting the work table

Step 6: Tilt the work table by 30°.

Step 7: Insert Allen screw M8x30 (pos. G, Fig. 12) and tighten slightly.
Please do not tighten the screws too much at first, as readjustment may be necessary to set the table correctly.

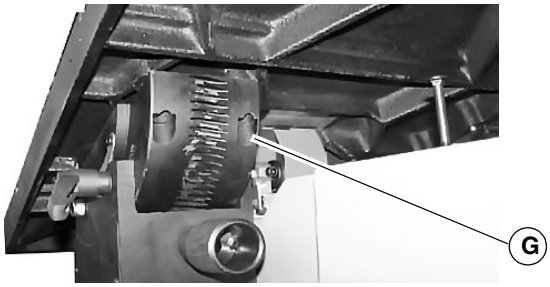


Fig. 12: Insert the allen screw

Step 8: Check if the saw blade is in the centre of the recess on the table. If the saw blade is not centred, bring the worktable into the correct position by tapping lightly on the side of the worktable top.

Step 9: Tighten all the fixing screws (pos. G & F, fig. 11 and fig. 12) of the worktable.

Step 10: To fix the guide of the rip fence, mount 4 wing screws (pos. I, fig. 13) with washers to the underside of the worktable. Mount the wing screws with only a few turns so that there is sufficient clearance for mounting the parallel stop. distance for the assembly of the parallel stop rail (pos. J, fig. 13).

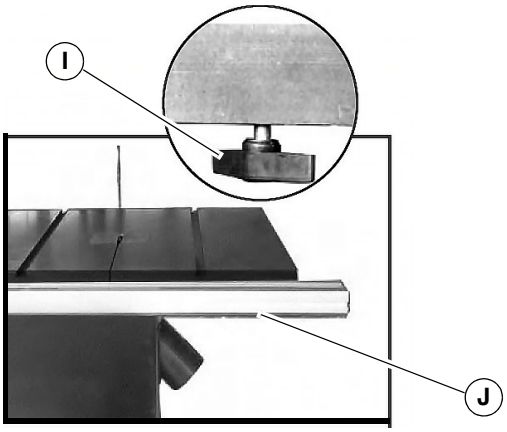


Fig. 13: Install the parallel stop guide

Step 11: Insert the rip fence into the guide of the rail.

Step 12: Push down the locking handle to fix the rip fence in the desired position.

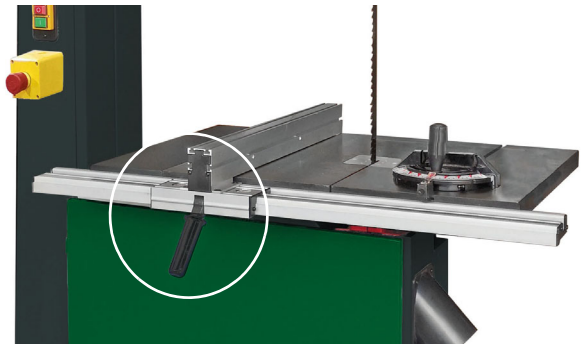


Fig. 14: Install the rip fence

Step 13: Attach the suction hose to the suction connection of the machine housing and to the suction unit with a hose clamp..

Fig. 15: Assembly of the suction hose

Tips and recommendation

The extraction device for chips and dust must have an output of at least 690 m^3/hour. at a flow speed of at least 20 m/s.

7.3.1 Installation of travelling device (optional)

Step 1: Screw the U-shaped bracket (pos.6, fig.16) to the front wheel set assembly (pos. a, fig.16).

Step 2: Fix hexagon bolt M10x70 (pos.14, fig.16) with washer (pos.9, fig.16) and sleeve (pos.10, fig.16) to the band saw base.

Step 3: Fix the rear castor frame (pos. 11, fig. 16) to the lower frame of the bandsaw with two hexagon bolts M10x20 (pos. 12, fig. 16) and washer (pos. 7, fig. 16).

Step 4: When moving the bandsaw, adjust the Allen screw M12x50 (pos. 5, fig. 16) and raise the bandsaw approx. 5 mm above the ground.

Step 5: Insert the driving device (pos. b, fig. 16) into the castor frame (pos. 11, fig. 16), press the lever down to be able to move the bandsaw.

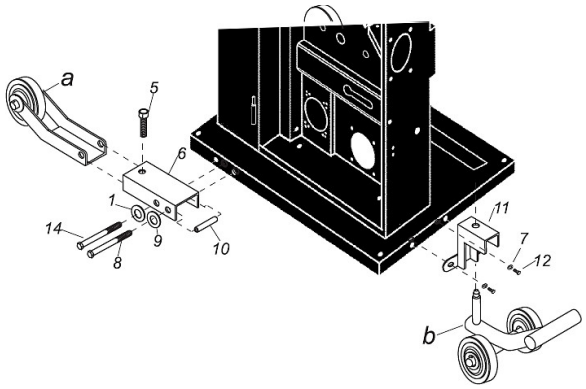


Fig. 16: Installation of travelling device

7.4 Electrical connection

DANGER!

Danger to life from electric shock!

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

- All work on the electrical installation may only be carried out by a qualified electrician.
- Before making any adjustments to the band saw, pull out the power plug..

The band saw must be properly connected to an electrical outlet using a 400V, 16A power cord..
Only operate the wood band saw with an electrical power supply that meets the following requirements:

- The mains voltage and the current frequency of the power supply must correspond to the specifications on the type plate..
- The band saw must be protected with a 16A fuse and a residual current circuit breaker (RCD circuit breaker (triggering at 30 mA)).
- If the plug does not fit or is defective, only a qualified electrical engineer may modify or replace the plug!
- Use of an earthed socket (socket outlet earthed in accordance with regulations).

Grounding instructions

In the event of a malfunction, earthing provides a path with the least resistance for the electric current and reduces the risk of electric shock. The bandsaw is equipped with an electrical cord with a grounding conductor and a grounding plug.

The plug must be plugged into a suitable outlet that is properly installed and grounded in accordance with ALL local codes and ordinances..

DANGER!

There is a risk of electric shock if the machine is improperly connected. The machine must be grounded during operation to protect the operator from electric shock.

Motordrehrichtung prüfen

After the electrical connection, check whether the direction of rotation of the spindle corresponds to the direction indicated on the plate.

If the direction of rotation is incorrect, have an electrician reverse two phases on the mains connection plug.

ATTENTION!

The band saw is dangerous to injury if the saw band rotates in the opposite direction. Switch on the band saw only briefly to check the correct direction of rotation (without tools).

8 Settings

DANGER!

Before making adjustments, the machine must be disconnected from the power supply.

The following personal protective equipment must be worn when working on the band saw:

The explanation of the pictograms can be found in Chapter 2.4 “Personal protective equipment”.

8.1 Perpendicularity of the work table

If it is necessary to adjust the right angle of the working plate to the saw blade, proceed as follows:

Step 1: Release the locking lever (Pos. M, Fig. 17) on the worktable.

Step 2: Loosen the hexagon nut (Pos. K, Fig. 17) on the stop screw (Pos. L, Fig. 17).

Step 3: Lower the worktable.

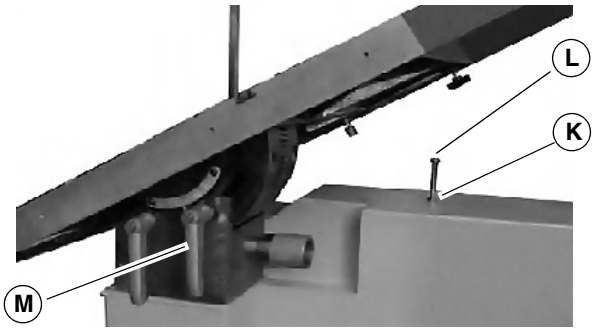


Fig. 17: Perpendicularity of the work table

Step 4: Place a right angle on the work table and put it against the saw band (Fig. 18).

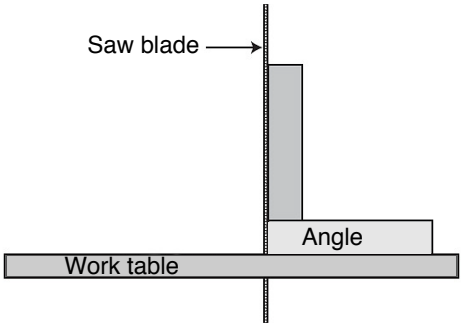


Fig. 18: Measuring the right angle

Step 5: Turn stop screw (Pos. L, Fig 17) to the left or right to adjust the height or depth of the worktable. Adjust the worktable so that the table is at a 90° angle (at right angles) to the saw blade(Fig. 18).

Step 6: Once the right angle is set, tighten the hexagonal nut (Pos. K, Fig 17).

Step 7: Tighten the locking lever (Pos. M, Fig 17) on the worktable.

Step 8: Set the angle pointer on the table inclinometer to zero.

8.2 Tension saw band

DANGER!

Tension or release the saw band only when the machine is switched off.

The saw band can be tensioned or released by turning the handwheel (N). Turning the wheel clockwise increases the band tension and counterclockwise reduces it. The saw band has the correct tension when it can be pressed in about 10 mm with moderate hand pressure.

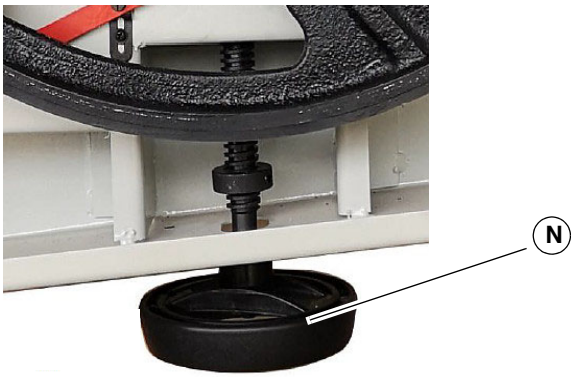


Fig. 19: Tension saw band

8.3 Adjusting the saw band run

NOTE!

First release the electrical brake for the flywheels. To release the electric brake for the flywheels, leave the machine connected to the power supply. Then switch off the machine, open the upper and lower doors to be able to turn the flywheels by hand.

Proceed as follows to adjust the saw band run:

Step 1: Release the electrical brake, switch off the machine and disconnect it from the power supply.

Step 2: Release the locking lever (Pos. O, Fig. 20) on the side of the machine.

Step 3: Open the upper machine cover.

Step 4: Turn the upper drive wheel by hand..

Step 5: Then turn the drive wheel and band run adjustment screw (pos. P, fig. 20) simultaneously until the saw band runs in the middle of the drive wheel.

Fig. 20: Adjusting the saw band run

Step 6: After correct adjustment of the saw blade run, tighten the locking lever (O) again.
If the band saw is operated daily, you can use the band tension check window to check the band run.

Fig. 21: Window saw band run

Step 7: Close the machine cover again and tighten the brake.

8.4 Adjusting the upper saw blade guide

The lateral guide blocks should be adjusted so that they are about 0.5 mm from the saw blade.

Step 1: Switch off the machine and disconnect it from the power supply.

Step 2: Loosen the clamping nut (Pos. Q, Fig. 22).

Step 3: Turn the adjusting screw (Pos. R, Fig. 22) counterclockwise to push the guide back. This allows the saw band to be removed or the band guide play to be adjusted.

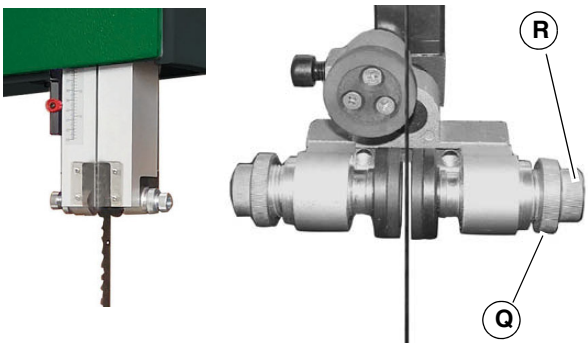


Fig. 22: Adjusting the upper saw blade guide

The rear guide blocks should be adjusted so that they are about 3 mm behind the saw blade. They only come into contact with the saw blade when cutting the workpiece. Due to the many different sizes of band saw blades, the rear guide block must offer more adjustment possibilities than the lateral guide block.
This is achieved by 2 different adjustment points, as opposed to only one adjustment point on the lateral guide blocks.

Hexagon socket screw **S** (Fig. 23)- This allows the lateral adjustment of the lateral band guide block and should be used when a large adjustment is required.

Hexagon socket screw **T** (Fig. 23) - This allows the rear strap guide to be moved for a slight change in the guide.

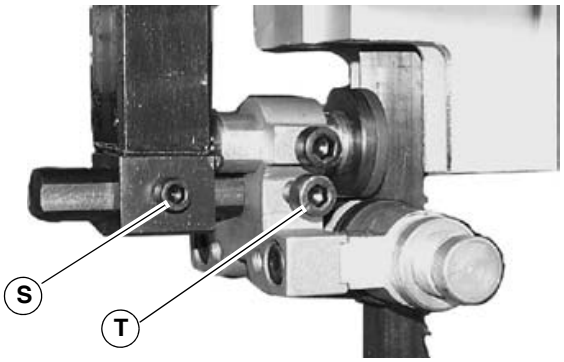


Fig. 23: Rear guide blocks

Step 4: Loosen the required Allen screws to move the belt guides into the correct position.

Step 5: Retighten all screws and nuts.

8.5 Adjust lower saw blade guide

Hexagon socket screw **U**:

For adjusting the guide assembly for large changes in the tape guide position.

Hexagon socket screw **T**:

For adjusting the rear tape guide for small changes in tape guide position.

Step 1: Switch off the machine and disconnect it from the power supply.

Step 2: Loosen the knurled nut (Pos. Q, Fig. 24).

Step 3: Turn the knurled nut (Pos. R, Fig. 24) counter-clockwise to adjust the lateral guide block.

Step 4: Adjust the rear guide block by loosening the Allen screws (Pos. U, Fig. 24).

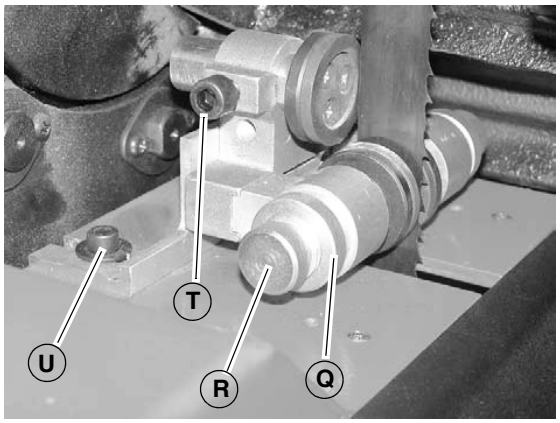


Fig. 24: Adjust lower saw blade guide

8.6 Adjusting the belt tension

Proceed as follows to check or adjust the belt tension:

Step 1: Switch off the machine and disconnect it from the power supply.

Step 2: Open lower machine cover.

Step 3: Check the belt tension. Press down the belt in the middle between the rollers and observe the size of the deflection. The deflection should be about 3/4".

Step 4: If the deflection is more than 3/4", turn the hand wheel (Pos. V, Fig. 25) to increase the tension.

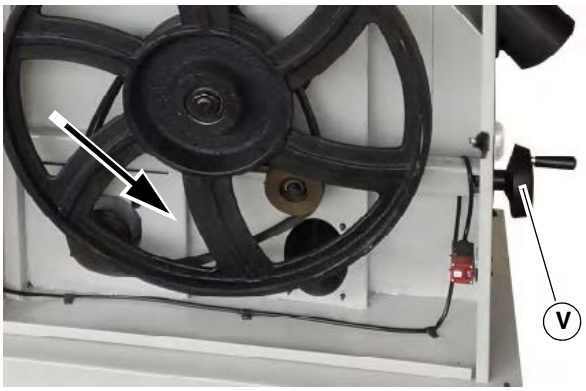


Fig. 25: Adjusting the belt tension

8.7 Adjusting the position of the saw blade guide

The upper belt guide must be lowered so far that it is positioned as close as possible to the workpiece.

Proceed as follows to adjust the position of the tape guide:

Step 1: Switch off the machine and disconnect it from the power supply.

Step 2: Loosen clamping screw (Pos. X, Fig. 26).

Step 3: Turn handwheel (Pos. W, Fig. 26) to lower or raise the guide assembly.

Step 4: Retighten clamping screw (Pos. X, Fig. 26).

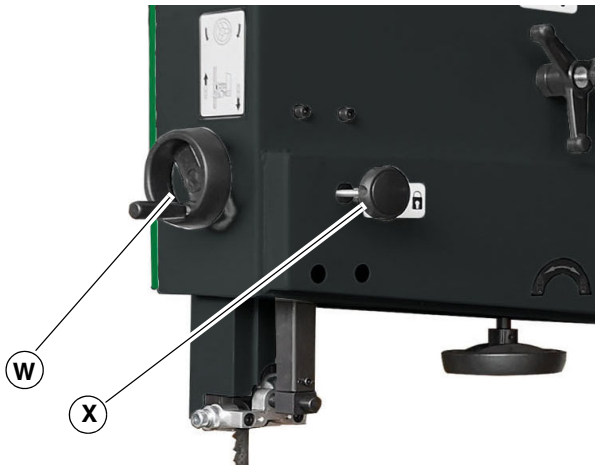


Fig. 26: Adjusting the position of the saw blade guide

8.8 Adjusting the rip fence

Set the rip fence to the desired width (make sure that the large part of the workpiece rests against the fence).

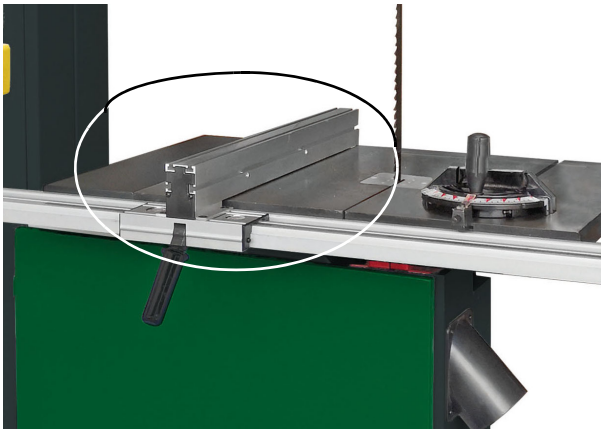


Fig. 27: Adjusting the rip fence

8.9 Adjusting the crosscut fence

Make a practice cut with the angular stop in the 0° position and check the cut with a suitable angle.

If adjustment is required, proceed as follows:

Step 1: Switch off the machine and disconnect it from the power supply.

Step 2: Loosen the pointer of the angular stop by opening the screw.

Step 3: Set the desired angle on the stop.

Step 4: Retighten the screw of the pointer.

Step 5: Make a test cut.

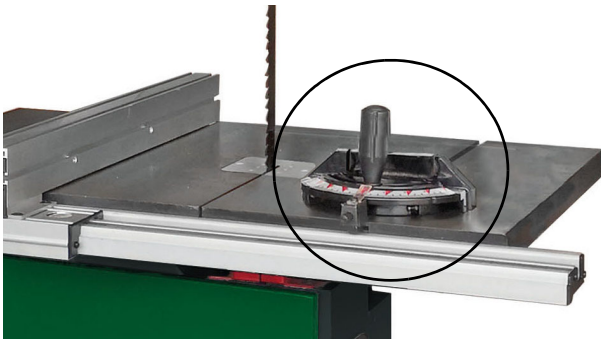


Fig. 28: Adjusting the crosscut fence

8.10 Tilt the work table

Proceed as follows to tilt the worktable:

Step 1: Turn off the machine and disconnect the power supply.

Step 2: Release the locking lever (Pos. M, Fig. 29).

Step 3: Turn tilt lever (Pos. Z, Fig. 29) until the desired angle is reached.

Step 4: Retighten the locking lever (Pos. M, Fig. 29).

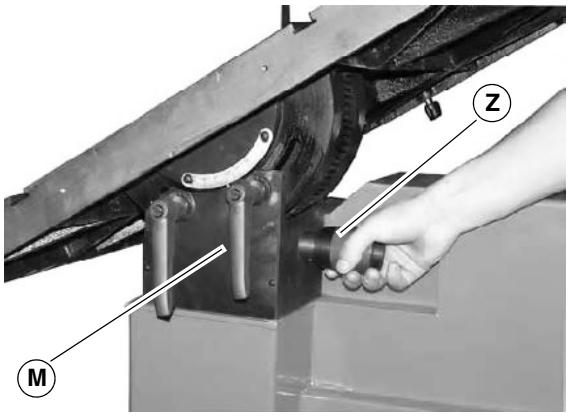


Fig. 29: Tilt the work table

9 Operation

ATTENTION!

The wood band saw may only be operated by a trained and experienced person. Other persons must keep away from the working area during operation.

ATTENTION!

Before commissioning,

- check the electrical connection, lines and contacts,
- Tension the saw blade by operating the corresponding handwheel and check the tension at the window provided for this purpose..

9.1 Switch the band saw on and off

The bandsaw is switched on and off by the on-off switch and is equipped with two safety limit switches (Fig.2). The band saw can only be switched on when the upper and lower doors are closed.

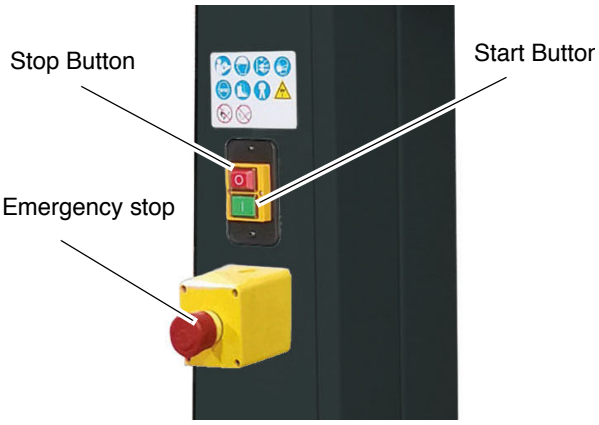


Fig. 30: Control panel

Start button: By pressing the start button, the bandsaw is switched on.

Stop button: By pressing the stop button, the bandsaw is switched off.

Emergency stop button:
By pressing the emergency stop, the machine stops immediately.

9.2 Workflow

Step 1: Check that the band saw is switched off and the power plug is disconnected.

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

Step 3: Check the workpiece for foreign objects such as nails or screws and remove them if necessary.

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

Step 5: If necessary, adjust the inclination angle of the table.

Step 6: Connect the extraction unit to the extraction socket and switch it on.

Step 7: Switch on the saw by turning the main switch and pressing the START button.

Step 8: Guide the workpiece against the saw blade.

Step 9: When the sawing process is finished, switch off the band saw with the red STOP button, switch off the suction after approx. 20 seconds and pull out the mains plug.

9.3 Longitudinal sections

Longitudinal cutting is the sawing along the wood fibre. You can cut freehand along a torn line or along the rip fence, which gives a better result. For right-angled cuts (table is at right angles to the saw blade) the rip fence is placed to the left of the saw blade so that the workpiece can be guided safely along the fence with the right hand. For longitudinal mitre cuts with an inclined table, the rip fence must be placed to the right of the blade, on the side facing downwards (if the width of the workpiece allows this), to prevent the workpiece from slipping.

9.4 Cross sections

Cross-section is defined as sawing at right angles to the grain of the wood. This type of cutting can also be done freehand, but it is recommended to use a stop for safety and accuracy reasons.

The fence can be set at up to 45° for mitre cuts. In combination with an inclined table, double mitre cuts can also be made. Hold the workpiece firmly against the stop of the cross-cutting jig and flat on the table. Pay attention to your fingers, especially towards the end of the cut, and keep your distance from the saw blade. Small workpieces should be held with a screw clamp.

The cross-cutting jig can be equipped with an end stop so that several workpieces can be cut to exactly the same length. The end stop can also be used as a support when the table is inclined.

9.5 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 of a width that can cut the smallest radii found in your workpiece.

For freehand cutting, you should work at a low feed rate so that the band saw blade can follow the desired line. Be careful not to push the workpiece sideways out of the cutting line. This causes the saw blade to run and can jam in the kerf.

It can often be useful to first remove excess material about 10 mm from the cutting line. In the case of very tight radii, which the saw blade cannot cut properly, cuts at right angles to the curve line and at a small distance from each other will help. When sawing the radius, the material falls off so that the saw blade cannot jam.

10 Care, maintenance and repair

DANGER!

Danger to life from 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 power plug.
- Connections and repairs may only be carried out by qualified personnel.

10.1 Care after work

NOTE!

Never use harsh cleaning agents for any cleaning work. This can lead to damage or destruction of the band saw

Step 1: Pull the mains plug out of the socket.

Step 2: Empty and clean the extraction device.

Step 3: Vacuum the chips and wood dust from the band saw (Attention: Wear protective goggles and dust mask!) and/or clean with a dry cloth.

Step 4: Spray or oil all unpainted metal surfaces with some anti-rust spray.

Step 5: Check the band saw for damage to the safety devices and the saw band. If necessary, carry out or arrange for repairs, observing the safety instructions.

Step 6: Check the band saw regularly for:

- Appropriate tension of the drive belt
- Clean ventilation opening of the motor
- Loose bolts and nuts
- Worn or damaged switches
- Worn or damaged saw band

Step 7: Check drive belt every 3 months, monthly if used daily, replace if worn or damaged..

Regularly clean and lubricate the internal moving parts of the band saw, such as the upper band guide adjuster (rack), the belt tensioning screw, the table tilter and the belt tensioner, to ensure easy and accurate adjustment.

10.2 Maintenance and repair

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

If the band saw does not function properly, contact a dealer or our customer service department. The contact details can be found in chapter 1.2 Customer service.

All protective and safety devices must be reinstalled immediately after repair and maintenance work has been completed.

10.2.1 Functional test

The band saw is delivered ready for operation.

A functional test should be carried out before each use.

Step 1: The drive belt must be under tension.

Step 2: The saw band must rotate freely and must not jam.

Step 3: Check the connection cable for damage.

10.2.2 Suction

Check the suction system daily to ensure that it is functioning properly. If the suction does not function or functions only to a limited extent, it must be repaired. Only then may the band saw be operated.

10.2.3 Change the saw band

Step 1: Unplug the power cord from the wall outlet.

Step 2: Remove the rip fence and rip fence rail.

Step 3: Open the upper and lower machine cover.

Step 4: Release the tape tension by turning the hand-wheel (Pos. N, Fig. 31).

Step 5: Remove the saw blade.

Step 6: Pull the new saw blade through the groove in the worktable through the groove in the worktable onto the upper and lower drive wheels. Make sure the saw blade is correctly aligned.

NOTE!

When the saw blade is mounted correctly, the teeth of the saw blade point downwards.

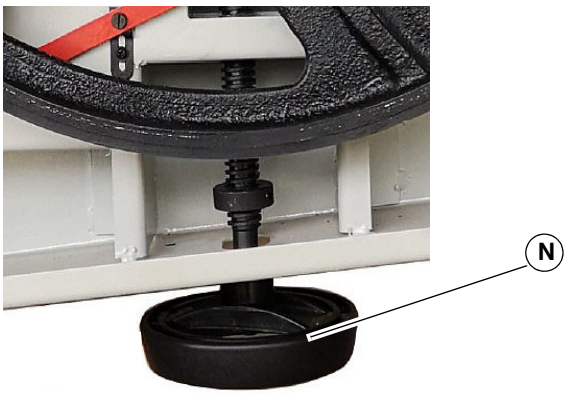


Fig. 31: Change the saw band

Step 7: Tension the saw band by turning the hand wheel (pos. N, fig. 32).

Step 8: Close the upper and lower machine covers.

Step 9: Refit the rip fence and rip fence rail..

10.2.4 Change drive belt

Step 1: Switch off the machine and pull the mains plug.

Step 2: Open upper and lower machine cover.

Step 3: Release and remove the saw band.

Step 4: Turn handwheel (Pos. V, Fig. 32) for belt tension to release the tension of the drive belt.

Step 5: Loosen and remove the drive wheel lock nut and washer (Pos. A2, Fig. 32). (Located on the back of the saw)

Step 6: Remove the drive wheel.

Fig. 32: Replacfe drive belt

Step 7: Place new drive belt over the pulley of the main drive wheel.

Step 8: Refit the drive wheel and tighten the drive wheel lock nut and washer (Pos. A2, Fig. 32)).

Step 9: Tension and check the drive belt by turning the handwheel (Pos. V, Fig. 32). (See section 8.6)

Step 10: Reinsert the saw blade.

Step 11: Tension the saw band.

Step 12: Close upper and lower machine cover.

11 Troubleshooting

DANGER!

If one of the following errors occurs, stop working with the machine immediately. Serious injury could result.

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

Fault	Possible causes	Remedy
The band saw does not start when the switch is pressed.	1. No power supply 2. Defective switch	1. Insert the plug or have the power connection checked by qualified personnel. 2. Let the switch replaced by qualified personnel.
The motor runs, but the saw blade does not.	1. The quick release lever is open 2. The saw blade runs off the wheels. 3. The saw blade is broken. 4. The V-belt is broken.	1. Switch off the engine and clamp the quick release lever. 2. Switch off the motor and adjust the saw blade correctly. 3. Insert a new saw blade. 4. Insert a new V-belt
The saw blade does not cut a straight line.	1. The rip fence is not used 2. feed rate too fast. 3. The saw blade teeth are blunt or damaged. 4. The saw blade guides are not correctly adjusted.	1. Use the rip fence 2. Press with the workpiece on the saw blade. 3. Insert a new saw blade. 4. Readjust the saw blade guide.
The saw blade does not cut or cuts very slowly.	1. Saw blade teeth are blunt due to sawing the wrong material 2. The saw blade was installed the wrong way round.	1. Use the correct saw blade for the material to be cut 2. Insert the saw blade correctly.
Sawdust and sawdust accumulate in the machine.	1. That's normal.	1. Clean the machine regularly. Use a vacuum cleaner if necessary.
Sawdust in motor housing.	1. Excessive amounts of sawdust.	1. Clean the motor housing with a vacuum cleaner 2. Use a vacuum cleaner
Band saw vibrates during the sawing process	1. The floor surface is uneven 2. V-belt is damaged 3. Saw blade is damaged	1. Place the saw on a flat surface and fasten it. 2. Replace the V-belt 3. Replace the saw blade
Fuses or circuit breakers are triggered frequently	1. Fuses or circuit breakers are wrongly dimensioned 2. Blunt saw blade 3. Mains switch or motor is defective	1. Replace fuses or circuit breakers 2. Replace the saw blade 3. Check, repair or replace power switch or motor

12 Disposal, recycling of old equipment

In the interest of the environment, care must be taken to ensure that all components of the machine are disposed of only via the designated and approved methods.

12.1 Decommission

Discarded machines must be taken out of service immediately and professionally in order to avoid later misuse and danger to the environment or persons.

- Dispose of all environmentally hazardous operating materials from the old device.
- If necessary, dismantle the machine into manageable and recyclable assemblies and components.
- Dispose of the machine components and operating materials in the appropriate disposal route.

12.2 Disposal of electrical equipment

Electrical devices contain a large number of recyclable materials and environmentally harmful components.

These components must be disposed of separately and properly. In case of doubt, contact the municipal waste disposal service.

If necessary, use the services of a specialized waste disposal company for processing.

DANGER!

It is forbidden to dispose of the machine as normal household waste.

12.3 Disposal of lubricants

The lubricant manufacturer provides the disposal instructions for the lubricants used. If necessary, ask for the product-specific data sheets.

12.4 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.

13 Spare parts

DANGER!

Risk of injury through the use of incorrect spare parts!

The use of incorrect or faulty spare parts can be dangerous for the operator and cause damage and malfunctions.

- Only original spare parts from the manufacturer or spare parts approved by the manufacturer must be used.
- In case of any uncertainties, always contact the manufacturer.

Tips and tricks

The manufacturer's warranty is void if non-approved spare parts are used.

13.1 Ordering spare parts

The spare parts can be obtained from the authorised dealer .

Specify the following key data when making inquiries or ordering spare parts:

- Device type
- Order number
- Position number
- Year of manufacture
- Quantity
- desired mode of dispatch (mail, freight, sea, air, express)
- Shipping address

Spare parts orders without the above information cannot be considered. In the absence of information on the mode of dispatch, dispatch will be at the discretion of the supplier.

Information on the device type, article number and year of manufacture can be found on the type plate attached to the machine.

Example

The motor for the wood band saw HBS 603 must be ordered. The motor is in the spare parts drawing 1 with the number 15 identified.

When ordering spare parts, send a copy of the spare parts drawing (1) with the marked component (motor) and marked item number (15) to the authorised dealer and provide the following information::

- Type of device: **Wood Band Saw HBS 603**
- Item number: **5941163**
- Drawing number: **1**
- Position number: **15**

Item number of your wood band saw:

Bandsäge HBS 603	5941163
Bandsäge HBS 703	5941173
Bandsäge HBS 803	5941183

13.2 Spare parts drawings

The following drawings should help to identify necessary spare parts in case of service. To order, send a copy of the parts drawing with the marked components to your authorized dealer.

Spare parts drawing 1

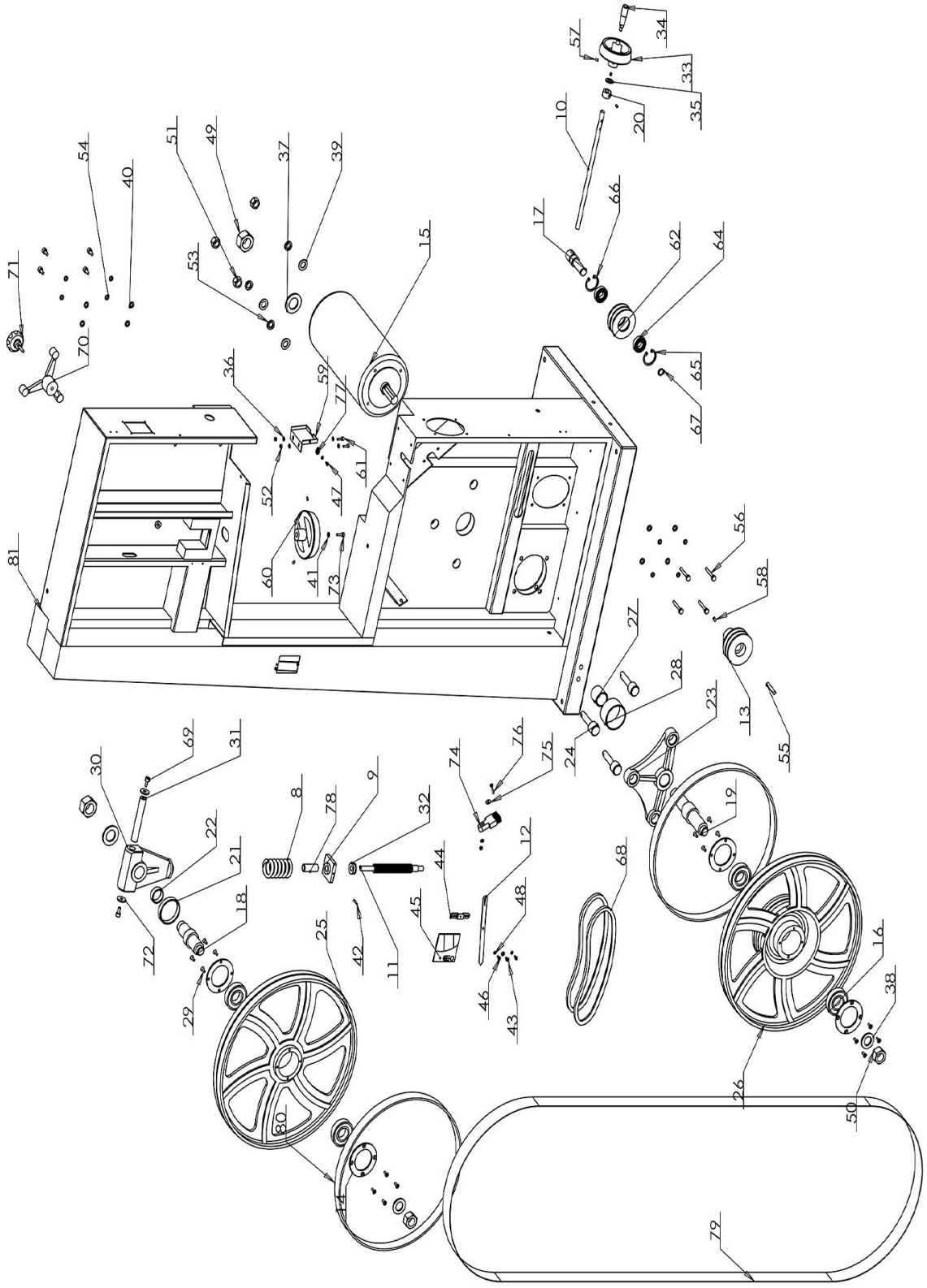


Fig. 33: Spare parts drawing 1

Spare parts list 1

Pos.	Descfription	Size		Pos.	Descfription	Size
8	spring			44	adjustable pointer seat	
9	indicator base			45	indicator	
10	thread tension rod			46	cross recessed pan head screw	M4x10
11	thread rod for upper wheel			47	cross recessed pan head screw	M4x8
12	pointer			48	washer	Ø4
13	motor pulley			49	hexagon nut	M30
14	block bearing			50	hexagon nut	M24
15	motor			51	hexagon nut	M16
16	bearing 80207	80207		52	hexagon nut	M5
17	shaft,tension pulley			53	spring washer	Ø16
18	shaft,upper wheel			54	black spring washer	Ø8
19	shaft,lower wheel			55	key	8x7x50
20	collar,tension rod			56	hexagon head bolt	M8x50
21	space,upper wheel			57	nail	M6x8
22	inner space,upper wheel			58	nail M8X10	M8x10
23	bracket lower wheel			59	protective board	
24	adjustable bolt ,lower wheel			60	hand wheel,upper wheel	
25	upper wheel			61	hexagon socket cap head screw	M5x16
26	lower wheel			62	tension pulley	
27	inner space,lower wheel			64	bearing	6004
28	spacer,lower wheel			65	ring circle	Ø42
29	crossed recessed countersunk	M6x12		66	ring circle	Ø42
30	head screw M6*12			67	ring shaft d	Ø12
31	sliding mount,upper wheel			68	motor belt "A-type"	
32	shaft of sliding mount			69	hexagon socket cap head screw	M8x16
33	hand wheel,belt tension			70	triangle star lock knob	
34	lever			71	Adjustable knob	M10x70
35	washer	Ø12		72	large washer	Ø8
36	washer	Ø5		73	Hexagon socket cap head screw	M6x20
37	washer	Ø30		74	brush	
38	washer	Ø24		75	large washer	Ø5
39	washer	Ø16		76	cross recessed pan head screw	M5x25
40	black washer	Ø8		77	rotating pointer	
41	washer	Ø6		78	bush	
42	spring pin			79	rotating pointer	
43	pointer nail			80	tyre ,wheel	
				81	Body	

Spare parts drawing 2

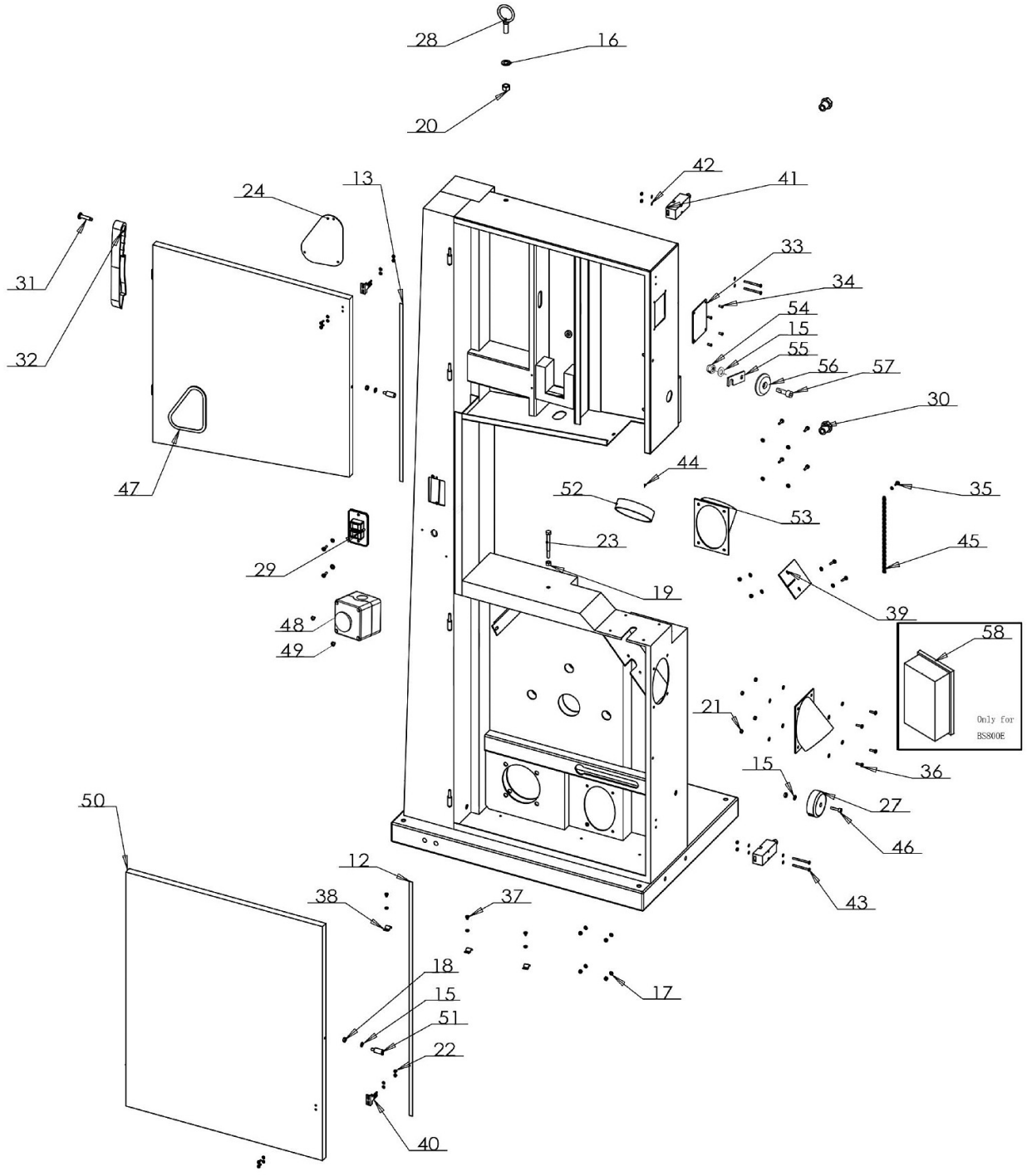


Fig. 34: Spare parts drawing 2 2

Spare parts list 2

Pos.	Descfription	Size		Pos.	Descfription	Size
12	Rubber strip lower door			38	Wire board	
13	Rubber strip upper door			39	Rubber board	
15	Washer	Ø6		40	Micro switch taster	
16	Washer	Ø12		41	Micro switch	
17	Washer	Ø5		42	Washer	Ø4
18	Hex nut	M6		43	Crosshead screw	M4x50
19	Hex nut	M8		44	Sheet metal crosshead screw	ST4.2X12
20	Hex nut	M12		45	Chain	
21	Hex nut	M5		46	Hex bolt	M6x25
22	Hex nut	M4		47	Upper door	
23	Hex bolt	M8x75		48	Emergency stop switch	
24	View window			49	Crosshead screw	M4x10
28	Lift ring			50	Lower dorr	
29	Switch			51	Hex bolt	M6x8
30	Cable relief			52	Cap, dust outlet	
31	pothook for push stick			53	Dust outlet	
32	push stick			54	Selflocking nut	M6
33	View window right			55	Holding plate	
34	Rivet			56	Holding disc	
35	Crosshead screw	M4x12		57	Hex bolt	M8x30
36	Crosshead screw	M5x16		58	Wiring box (only HBS 803)	
37	Crosshead screw	M5x6				

Spare parts drawing 3

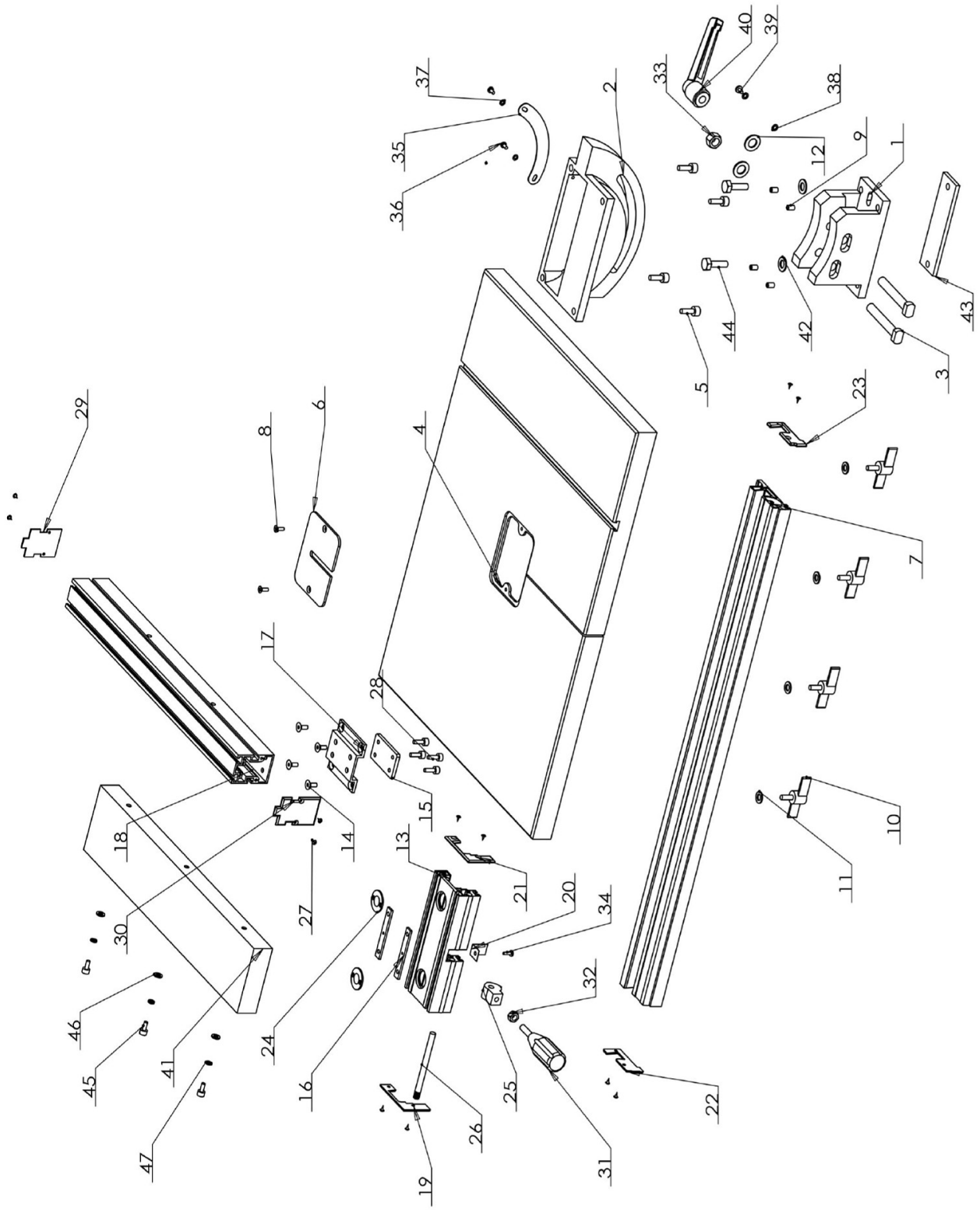


Fig. 35: Spare parts drawing 3

Spare parts list 3

Pos.	Descfription	Size		Pos.	Descfription	Size
1	table tilt swivel part			24	Len	
2	Table rotation			25	Lock eccentric	
3	Lock bolt			26	Loch schaft	
4	Table			27	Sheet metal crosshead screw	ST4.2x12
5	Socket-headed screw	M8x20		28	Socket-headed screw	M8x16
6	Insert			29	End cap of the fence rear	
7	Fence rail			30	End cap of the fence front	
9	Cross recessed countersunk head nail	M8X10		31	Locking handle	
10	Wing screw			32	Hex nut	M8
11	Black washer	Ø8		33	Hex nut	M12
12	Black washer	Ø12		34	Cross-head screw	M4x12
13	Fence guard			35	Scale, table tilt	
14	Socket-headed screw	M6x10		37	Cross-head screw	M4x8
15	4-hole mounting plate			38	Washer	Ø4
16	3-hole mounting plate			39	Washer	Ø5
17	Connected board			40	Washer	Ø8
18	Rip fence			41	Table (accessory)	
19	Left end cap of rip fence			42	Washer	Ø10
20	Latch lock			43	Nut board	
21	Right end cap of rip fence			44	Hex bolt	M10x30
22	Left end cap of fence rail			45	Socket-headed screw	M10x12
23	Right cap of fence rail			46	Washer	Ø6
				47	Spring washer	Ø6

Spare parts drawing 4

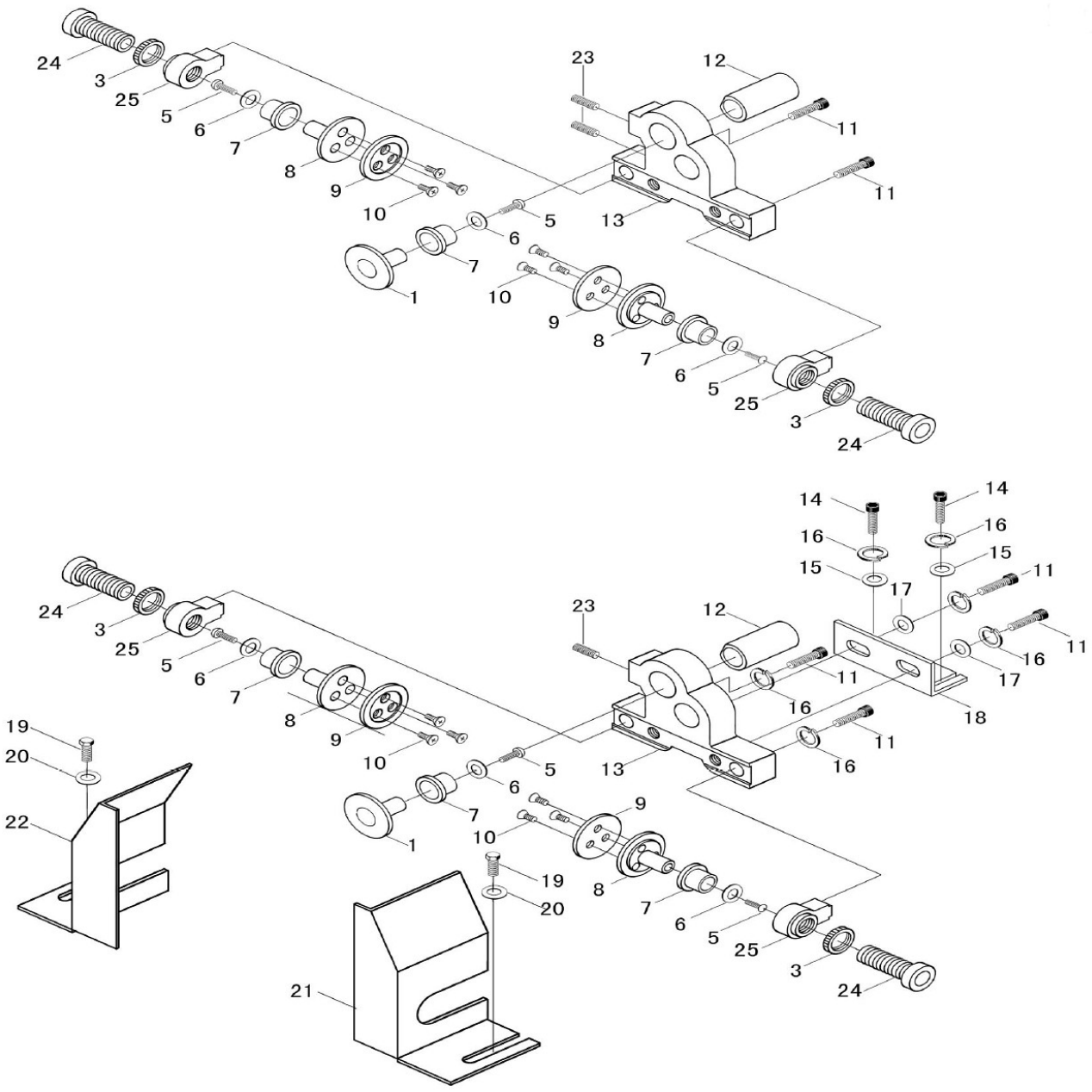


Fig. 36: Spare parts drawing 4

Spare parts list 4

Pos.	Descfription	Size		Pos.	Descfription	Size
1	Guide wheel			15	Washer	Ø6
3	Adjustable nut			16	Spring washer	Ø8
5	Cross-head screw	M4x8		17	Washer	Ø8
6	Washer large	Ø4		18	Angle bracket	
7	Cooper sleeve			19	Hex bolt	M5x12
8	Seat, hard alloy block			20	Washer large	Ø5
9	Hard alloy block			21	Right guard, lower guide	
10	Cross-head screw	M4x8		22	Left guard, lower guide	
11	Hexagon socket cap head screw	M8x16		23	Hexagon socket cap head screw	M8x10
12	Adjustable rod			24	Adjustable thread	
13	Guide base			25	Seat, Adjustable thread	
14	Hexagon socket cap head screw	M6x12				

Spare parts drawing 5

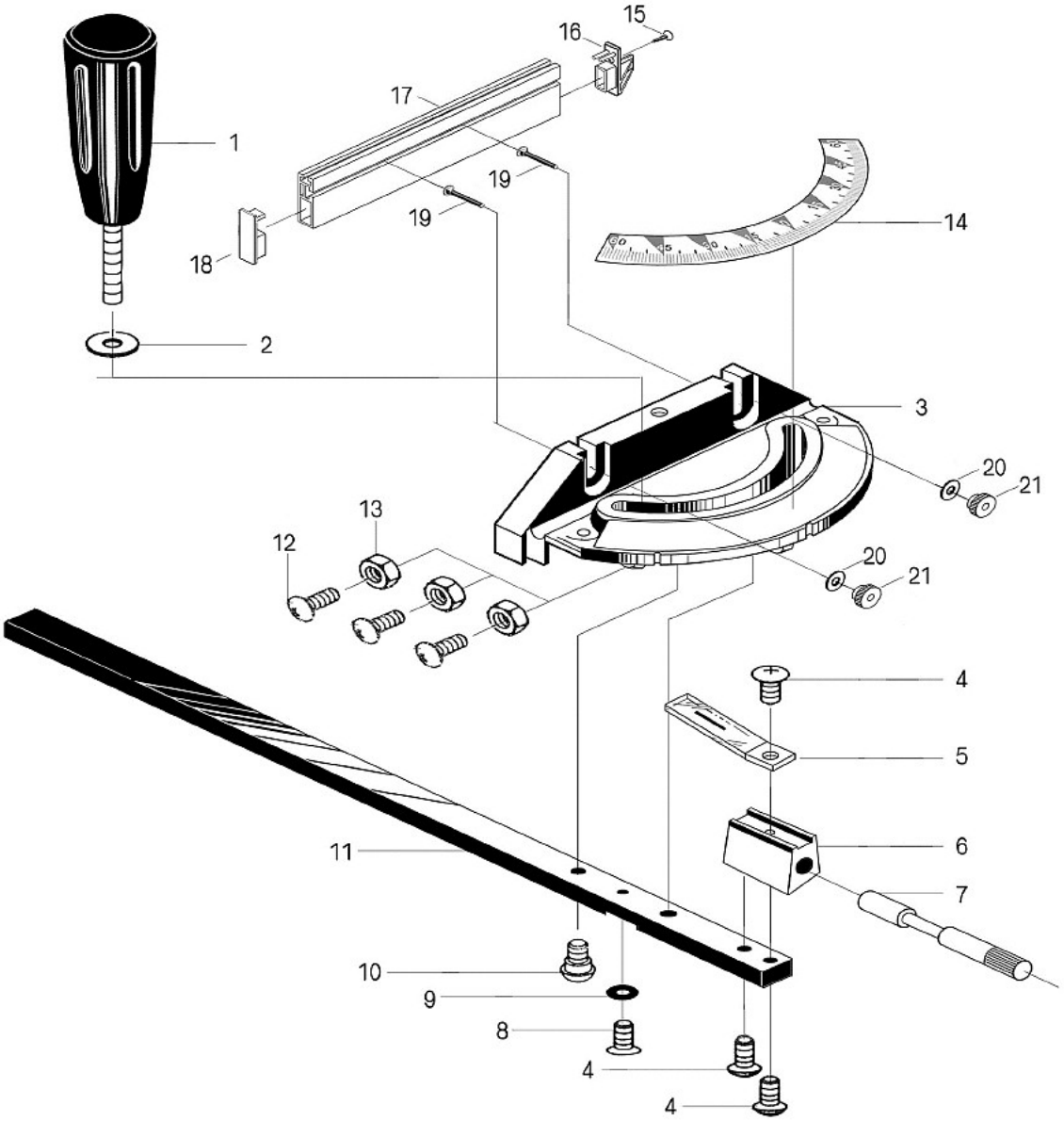


Fig. 37: Spare parts drawing 5

Spare parts list 5

Pos.	Descfription	Size	Pos.	Descfription	Size	Pos.	Descfription	Size
1	Mitre gauge knob		8	Cross-head screw	M5x8	15	Cross-head screw	ST 4.8x10
2	Washer	Ø6	9	Washer		16	End cap A	
3	Mitre gauge		10	Guide pin		17	Rip fence	
4	Cross-head screw	M5x10	11	Guide strip		18	End cap B	
5	Gauge indicator		12	Cross-head screw	M4x18	19	Adjusting screw	M6x32
6	Fence display		13	Hex nut	M4	20	Washer	Ø6
7	Fence pin		14	Scale, gauge		21	Knurled nut	

Spare parts drawing 6

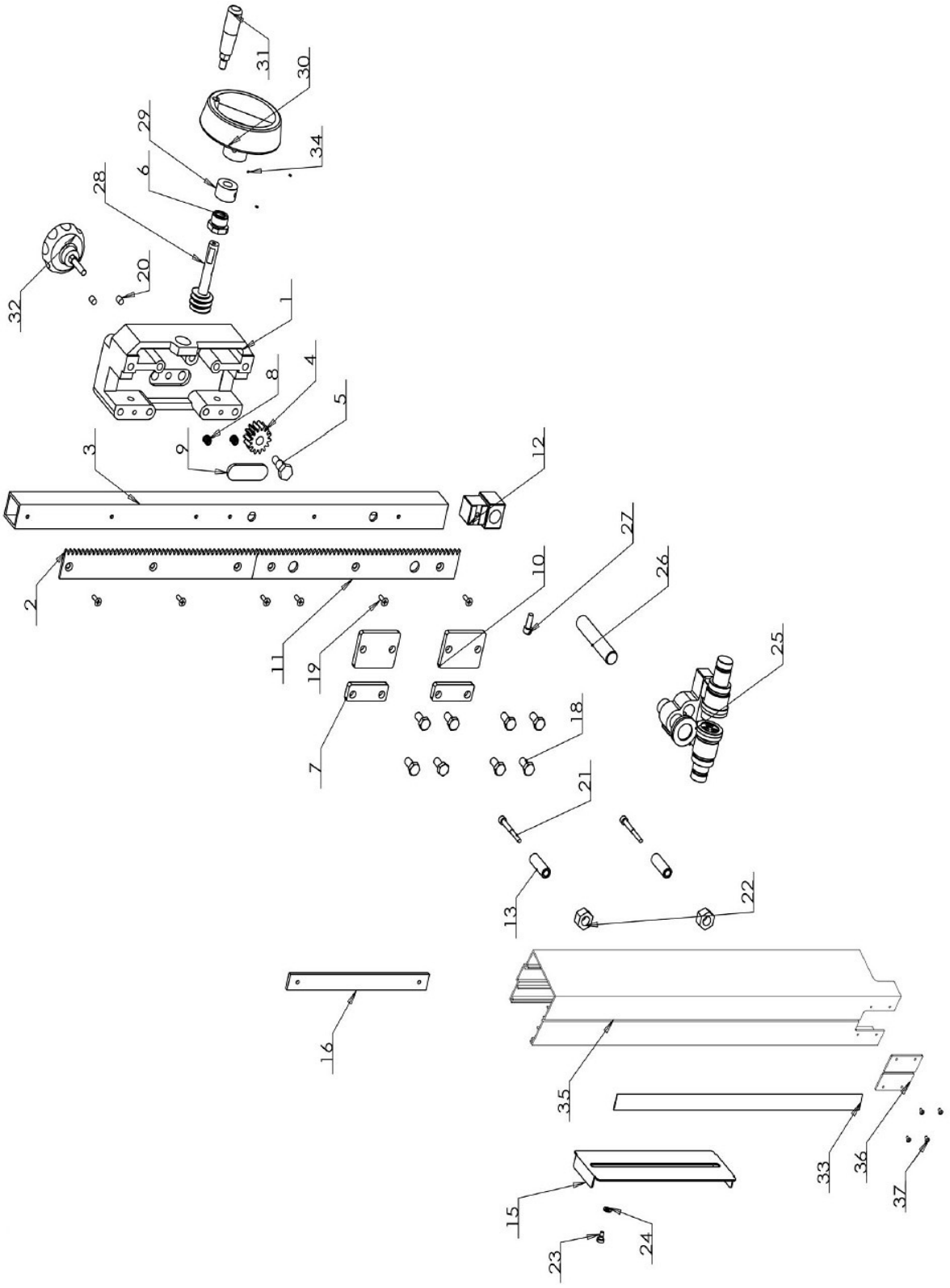


Fig. 38: Spare parts drawing 6

Spare parts drawing 6

Pos.	Descfription	Size		Pos.	Descfription	Pos.
1	mount,upper guide			20	hexagon socket set screw M8x8	M8x8
2	upper rack			21	hexagon socket cap head screw	M5x45
3	square tube,upper guide			22	hexagon nut	M12
4	gear,upper guide			23	pointer nail	
5	thread,gear			24	washer	Ø5
6	thread tube			25	assembley upper guide	
7	left cover,upper guard			26	shaft of bearing base	
8	spring			27	hexagon socket cap head screw	M6x16
9	block,upper guide			28	worm	
10	right cover,upper guard			29	stop ring	
11	lower rack			30	hand wheel	100x12
12	square tube connector			31	lever	
13	sleeve			32	flower screw	
14	upper guide guard			33	upper guide ruler	
15	sliding guard			34	hexagon socket set screw	M6x8
16	nut board			35	upper blade guide cover	
18	hexagon cap head screw M8X16	M8x16		36	view window, guide cover	
19	cross recessed countersunk head	M5x10		37	cross pan head screw	M3x5

Spare parts drawing 7: Travelling device - Optional as an accessory

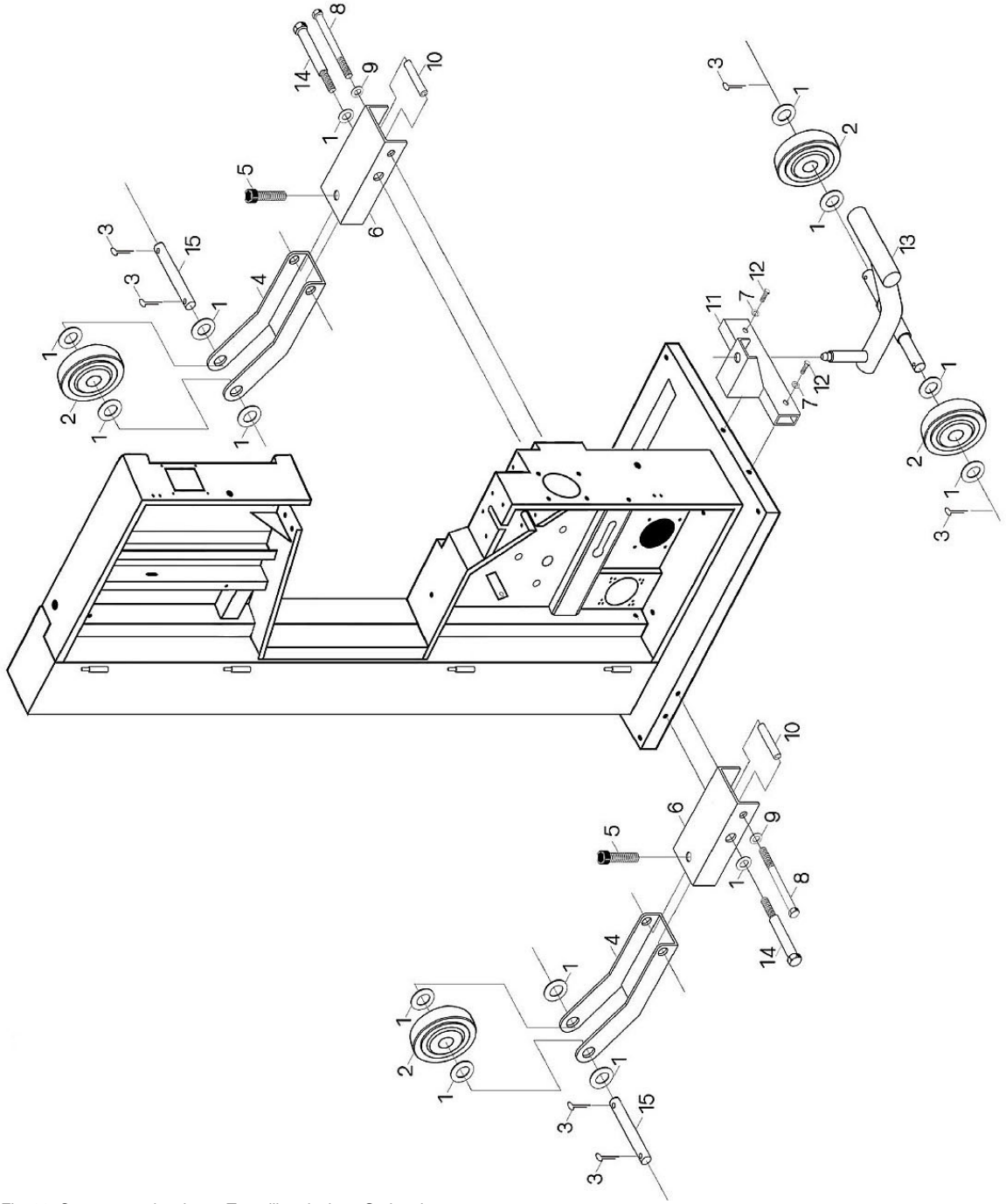


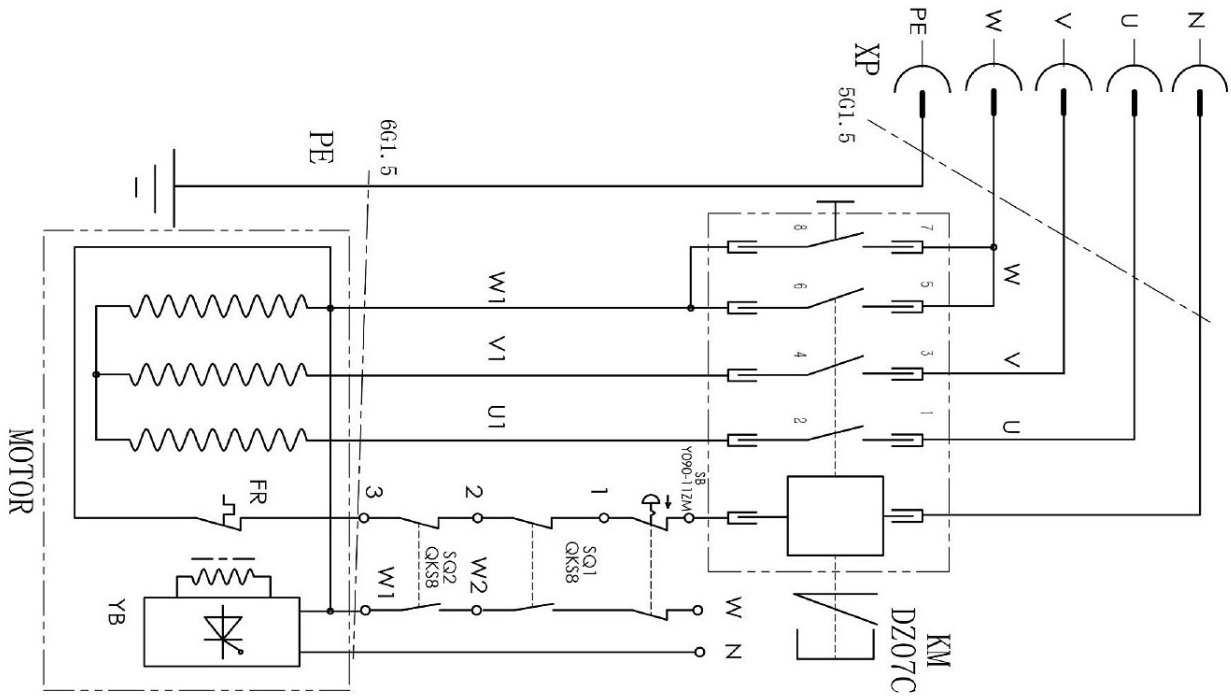
Fig. 39: Spare parts drawing 7: Travelling device - Optional as an accessory

Spare parts list 7

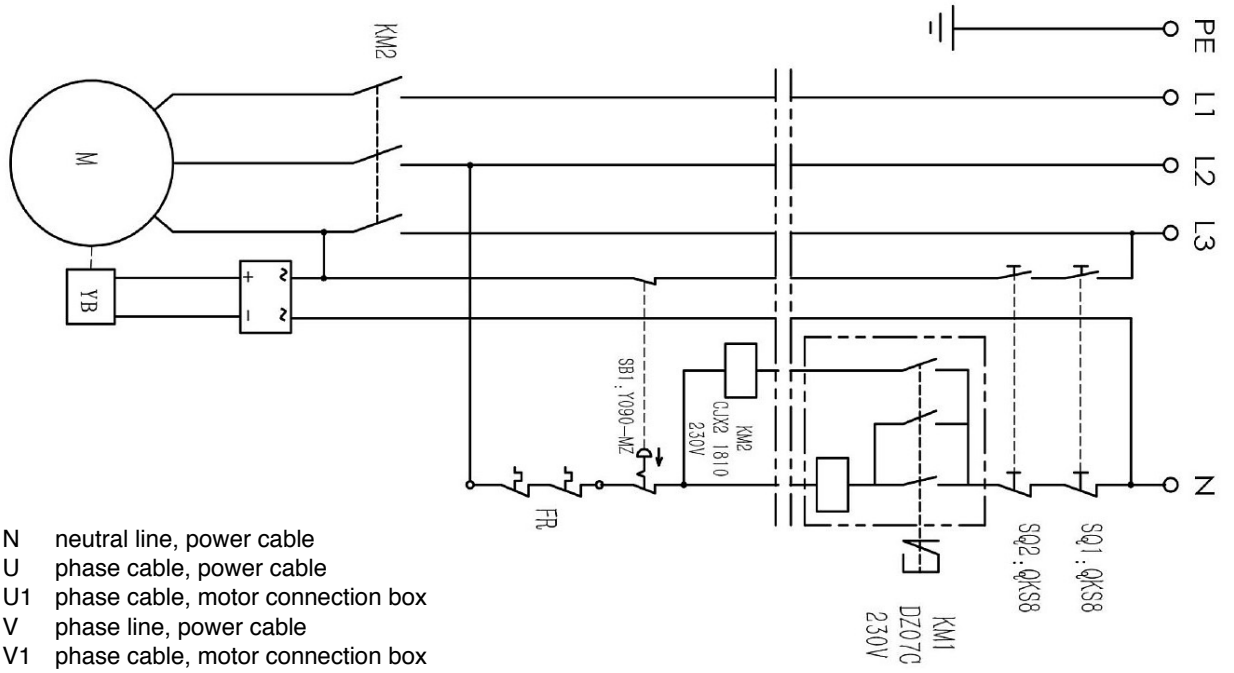
Pos.	Descfription	Size		Pos.	Descfription	Size
1	Washer			9	Washer	Ø12
2	Castor			10	Bushing bracket	
3	Spring pin	4x30		11	Support, pull rod	
4	Bracket castor			12	Hex bolt	M10x55
5	Cross-head screw	M12x50		13	Pull rod	
6	Adjustable bracket			14	Bolt, bracket	
7	Washer	Ø10		15	Shaft, castor	
8	Hex bolt	M12x80				

14 Electrical circuit diagrams

Electrical circuit diagram HBS 603 and HBS 703



Electrical circuit diagram HBS 803



N	neutral line, power cable
U	phase cable, power cable
U1	phase cable, motor connection box
V	phase line, power cable
V1	phase cable, motor connection box
W	phase cable, power cable
W1	phase cable, motor connection box
W2	cable, safe switch
FR	thermal relay
PE	grounding
YB	engine brake
L1	power line
L2	power line
L3	power line

KM1	main switch (on/off switch)
KM2	AC contactor
KM DZ07C	main switch (on/off switch)
XP	power cable
SB Y090-111ZM	emergency stop switch
SQ1/SQ2	limit switch (safety switch

Fig. 40: Electrical circuit diagrams

15 EC-Declaration of Conformity

According to machinery directive 2006/42/EC Annex II 1.A

Producers/Distributor: Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt

hereby declares that the following product

Product group: Holzkraft® Woodworking machines

Designation of the machine *:	**Item number *:**
☐ HBS 603	5941163
☐ HBS 703	5941173
☐ HBS 803	5941183

Type of machine: Wood Band Saw

Serial number*: _____

Year of manufacture*: 20____

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

complies with all relevant provisions of the abovementioned Directive and of the other Directives applied (hereafter referred to), including their amendments in force at the date of this declaration.

Relevant EU Directives:	2014/30/EU	EMC-Directive
	2012/19/EU	WEEE-Directive
	2011/65/EU	RoHS-Directive
Applicable EU regulations:	1907/2006/EU	REACH-Regulation

The following harmonised standards have been applied:

DIN EN 60204-1:2019-06	Safety of machinery - Electrical equipment of machines - Part 1: General requirements
DIN EN 55014-1:2018-08	Electromagnetic compatibility - Requirements for household appliances, electric tools and similar apparatus - Part 1: Emission
DIN EN 55014-2:2016-01	Electromagnetic compatibility - Requirements for household appliances , electric tools and similar apparatus - Part 2: Immunity - Product family standard
DIN EN 61000-3-2:2019-12	Electromagnetic compatibility (EMC). Limits. Limits for harmonic current emissions (equipment input current =16 A per phase)
DIN EN 61000-3-3:2020-07	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
DIN EN 1807-1:2013-06	Safety of woodworking machines - Circular sawing machines - Part 1: Circular saw benches (with and without sliding table), dimension saws and building site saws

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

Hallstadt, 15.10.2021

_____
Kilian Stürmer
Manager

CE

Notes

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