AXMINSTER Craft

AC1950B Code **105093**
AC2305B Code **105094**
AC2606B Code **105095**

Original Instructions

Bandsaws

10,12,14 inch

AC1950B

AC2305B

AC2606B

AXMINSTER 3 THREE YEAR GUARANTEE

AT&M: 04/02/2019
BOOK REF: 105742

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Cert No: MJ3420, MJ3425, MJ343C, MJ343B

Axminster Tools & Machinery Ltd
Axminster Devon
EX13 5PH UK
axminster.co.uk

declares that the machinery described:-

Type	**Bandsaw**
Model	**AC1950B, AC2305B, AC2606B**

Signed

Andrew Parkhouse
Operations Director Date: **05/11/2018**

EU Declaration of Conformity

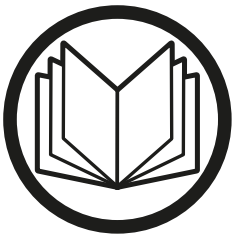
This machine complies with the following directives:

2006/42/EC
EN 1807-1:2013
EN 60204-1:2006+A1+AC
06/42/EC - Annex I/05.2006

and conforms to the machinery example for which the
EC Type-Examination Certificate No BM 50421300
has been issued by **Laizhou Fulin Machinery Co., Ltd.**
at: Wenchang Road Street Nanwuli Industry Yard Laizhou, Shandong261400
China

and complies with the relevant essential health and safety requirements.

The symbols below advise the correct safety procedures when using this machine.



Fully read manual and safety instructions before use

Ear protection should be worn

Eye protection should be worn

Dust mask should be worn

HAZARD

Model Number	AC1950B

Quantity	Item	Part
1	105093 Bandsaw Blade 1,950mm long, mounted on saw but not tensioned	A

Model Number	AC2305B

Quantity	Item	Part
1	105094 Bandsaw Blade 2,305mm long, mounted on saw but not tensioned	B

Model Number	AC2606B

Quantity	Item	Part
1	105095 Bandsaw Blade 2,606mm long, mounted on saw but not tensioned	C

Quantity	Item	Part
1	Craft Bandsaw Unit	1
1	Cast Iron Saw Table with Table Insert	2
1	Fence Guide Rail	3
1	Guide Fence Assembly	4
1	Extraction Port	5
1	Blade Tensioning Knob	6
1	Flexible Extraction Hose with Retaining Clips	7
1	Angled Pin and Nut	8
1	Push Stick	9
4	Long Bolts Washers & Nut	10
3	Hex Keys	11
Floor Stand Comprising		
4	Leg Brackets	12
2	Long Upper Support Struts	13
2	Short Upper Support Struts	14
2	Long Lower Support Struts	15
2	Short Lower Support Struts	16
4	Threaded Rubber Feet	17
1	Floor Stand Bag of fixings	18
Optional Accessories		
1	Mitre Fence (code 104928)	19

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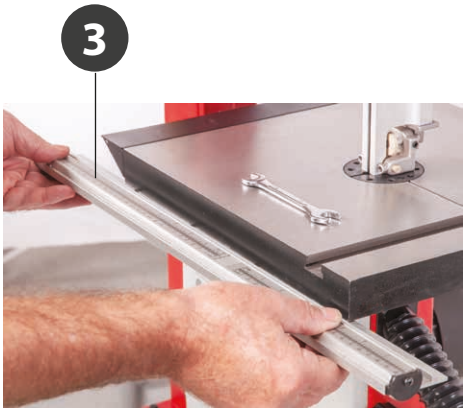
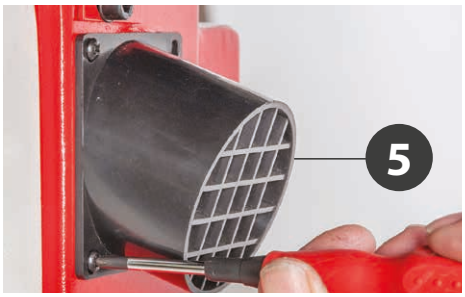
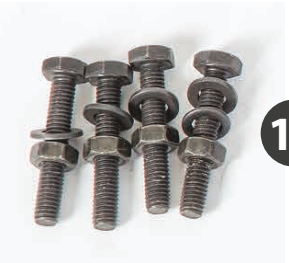
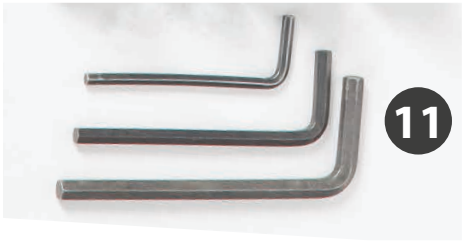
What's Included









Optional Accessory

HAVING UNPACKED YOUR SAW (SEE BELOW) AND ITS ACCESSORIES PLEASE DISPOSE OF ANY UNWANTED PACKAGING PROPERLY. THE CARDBOARD PACKAGING IS BIODEGRADABLE.

General Instructions for 230V Machines

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

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

KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN THE WORK AREA.

Mains Powered Tools

- Tools are supplied with an attached UK 13 Amp plug.
- Inspect the cable and plug to ensure that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.
- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.
- Carry out a final check e.g. check the cutting tool is securely tightened in the machine and the correct speed and function set.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check blades are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

Specification

Code	105093
Model	AC1950B
Rating	Craft
Power (Output)	550 W
Blade Speed	660 & 840 m/min
Blade Length	1,950mm
Blade Width Min/Max	6 mm to 13 mm
Max Width of Cut	260 mm
Max Width of Cut with Fence	185 mm
Table Size	350 x 330 mm
Table Height on Stand	1,035 mm
Table Tilt	0° - 45°
Dust Extraction Outlet	63 mm
Overall L x W x H	790 x 620 x 1,570 mm
Weight	39 kg

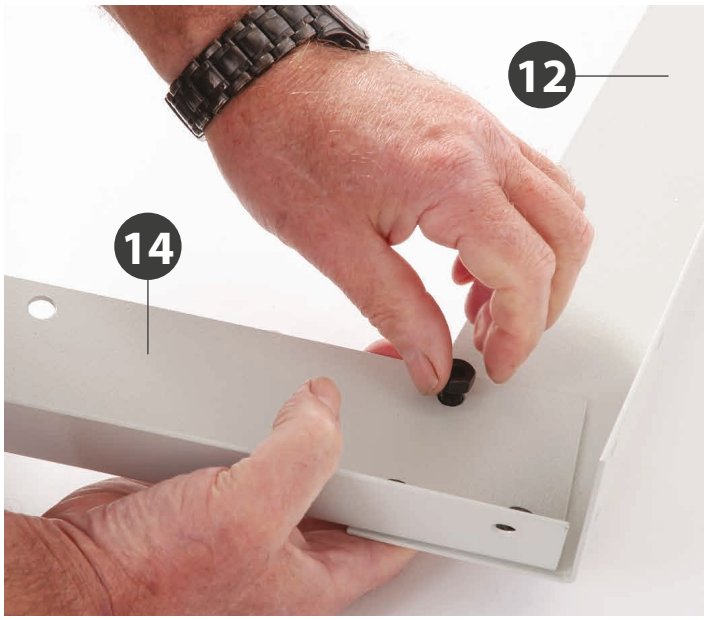
Code	105094
Model	AC2305B
Rating	Craft
Power (Output)	750 W
Blade Speed	360 & 720 m/min
Blade Length	2,305mm
Blade Width Min/Max	6 mm to 16 mm
Max Width of Cut	315 mm
Max Width of Cut with Fence	208.5 mm
Table Size	400 x 500mm
Table Height on Stand	1,035 mm
Table Tilt	0° - 45°
Dust Extraction Outlet	100 mm
Overall L x W x H	700 x 890 x 1,623mm
Weight	66kg

Code	105095
Model	AC2606B
Rating	Craft
Power (Output)	1.1 kW
Blade Speed	600 & 840 m/min
Blade Length	2,606mm
Blade Width Min/Max	6 mm to 25 mm
Max Width of Cut	360 mm
Max Width of Cut with Fence	260 mm
Table Size	480 x 550 mm
Table Height on Stand	1,060 mm
Table Tilt	0° - 45°
Dust Extraction Outlet	100 mm
Overall L x W x H	980 x 630 x 1,740 mm
Weight	85 kg

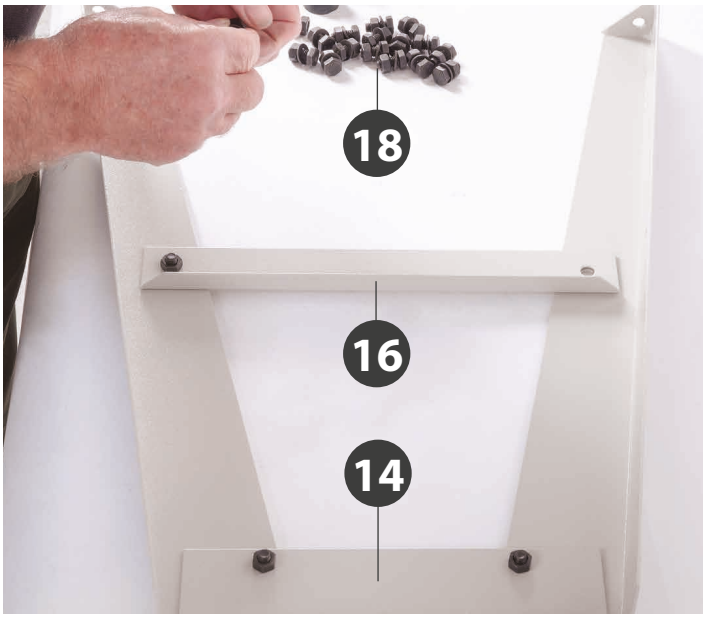
Assembly

Stand Assembly

Step 1



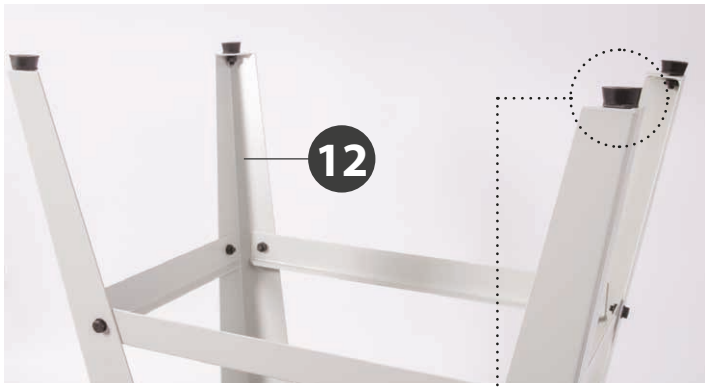
Step 2



Step 3

Step 4

Step 5



Step 6

Mounting the Bandsaw to the Stand

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

Lift the saw on to the stand, secure using four long bolts, nuts and washers (10). Insert the bolts through the pre-drilled holes in each corner of the base and through the floor stand. Fit the washers and nuts on the underside and tighten to secure the assembly.

Mounting the Saw Table

Locate the blade tensioning knob (6) and insert it down over the control shaft ,on top of the bandsaw housing, see fig 01.

1) The saw table can be fitted without removing the blade. However, if you would feel more comfortable not having to manoeuvre the table around the blade, remove the blade by opening the top and bottom covers, release the tension on the blade by backing off the tensioning wheel, see fig 02-03.

Fig 01

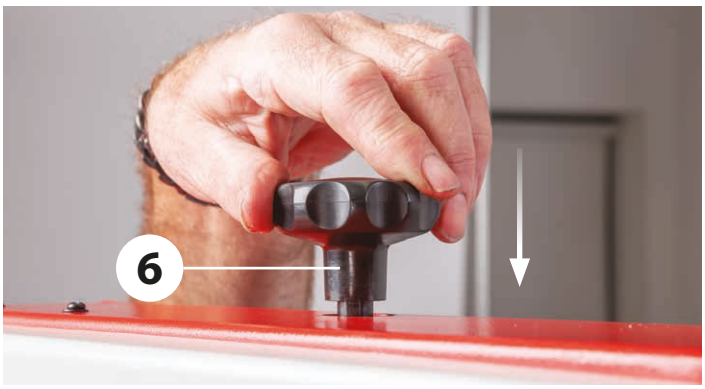
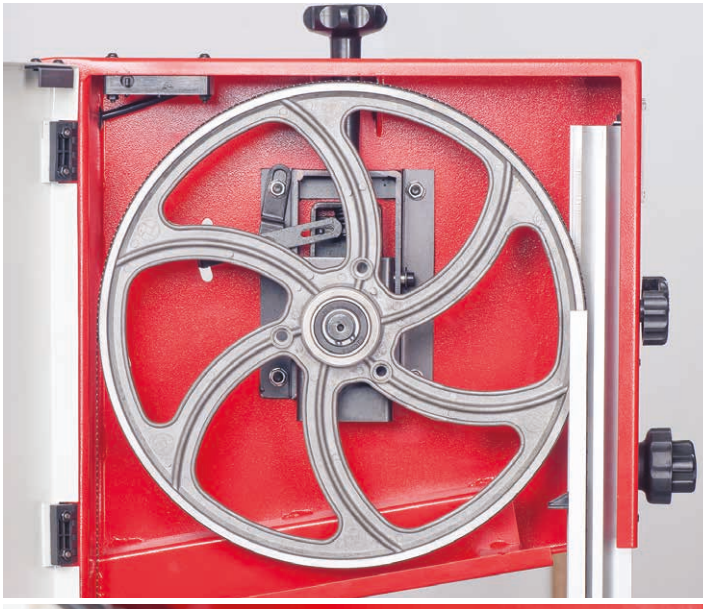


Fig 02-03



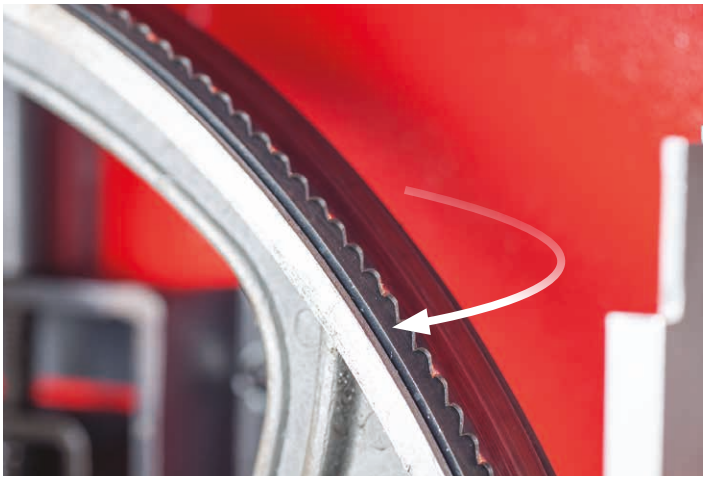
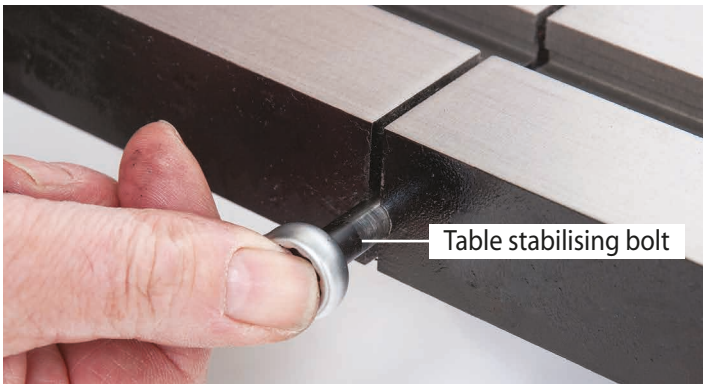
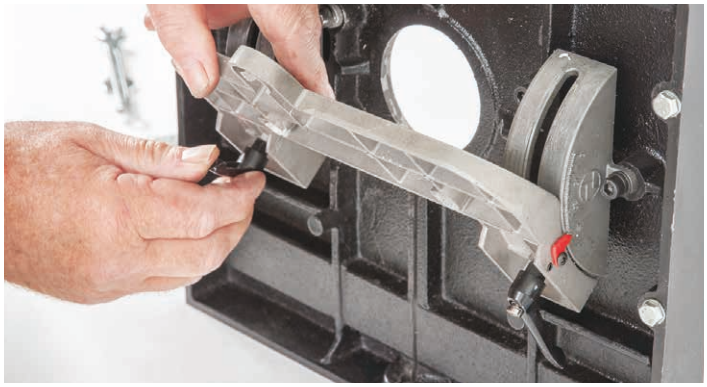


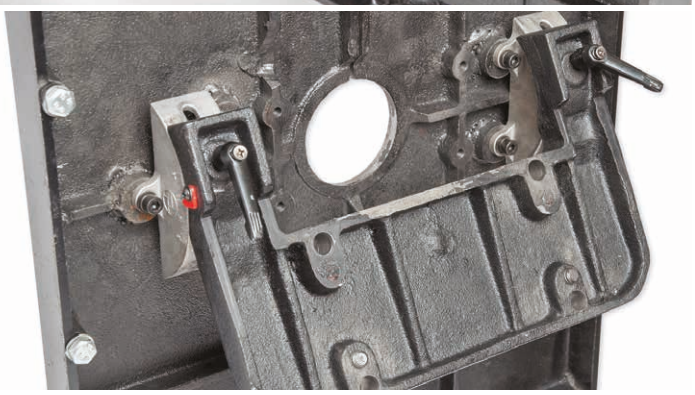
Fig 04-05



2) Locate the cast iron table (2), remove the table stabilising bolt and the table insert, see fig 04-05. Angle the tilt quadrant assemblies base by loosening the two lift and shift handles beneath the table in readiness for mounting, see fig 06-07.

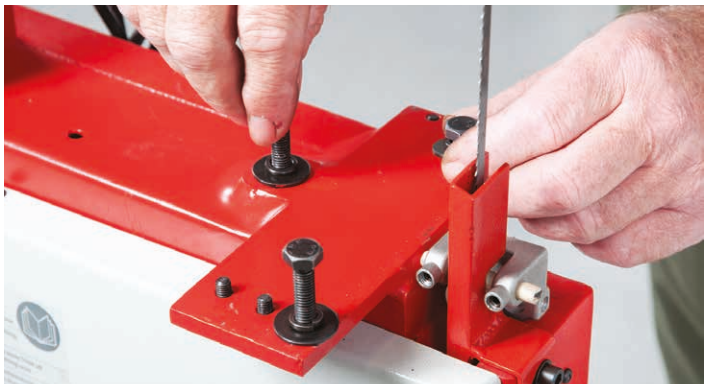
Fig 06-07

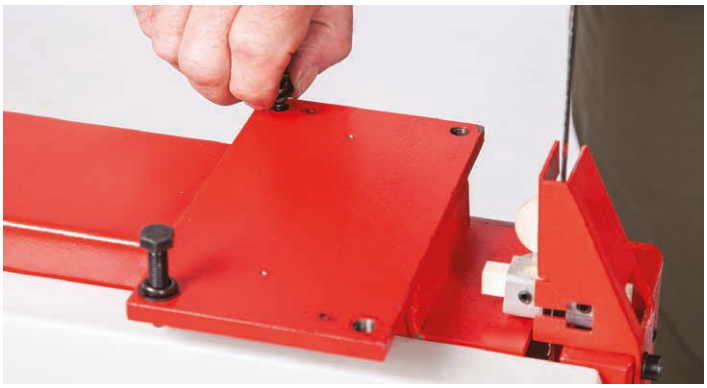




3) Remove the bolts, washers/spring washers from the bandsaws mounting plate and place safely aside, see fig 8-9. Lift the table (2), slide the blade through the table,s slot and

Fig 08-09

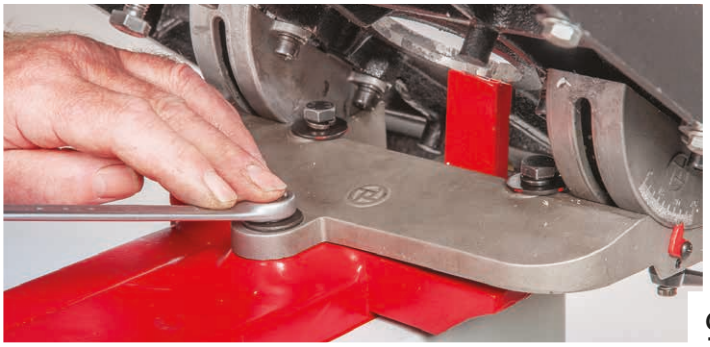


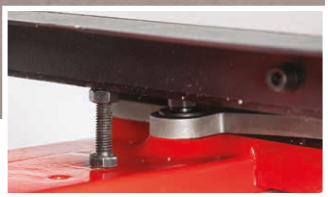


lower it onto the mounting plate, see fig 10. Line up the holes in the tilt quadrant with the ones in the mounting plate, replace the bolts/washers and tighten. Lower the table down on its stop, replace table insert and stabilising bolt, see fig 11-12-13.

DO NOT OVERTIGHTEN!

Fig 10-11-12-13

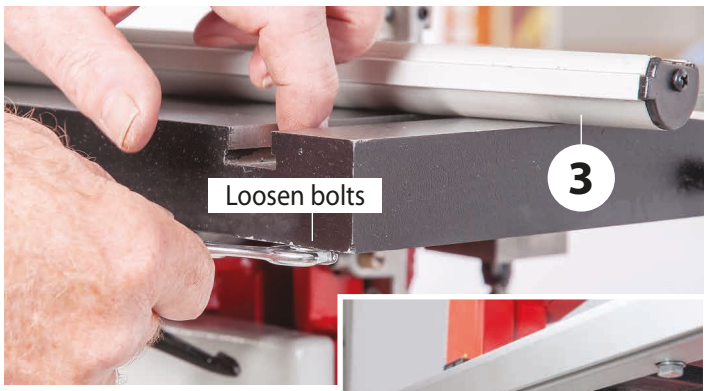




Fence Assembly

1) Locate the guide fence rail (3) and guide fence assembly (4). Loosen the bolts beneath the table (2), giving enough clearance between the table and bolts. Line up machined slots in the fence rail (3) and slide the rail up against the table. Nip up the bolts to secure the rail, see fig 14-15-16.

Fig 14-15-16



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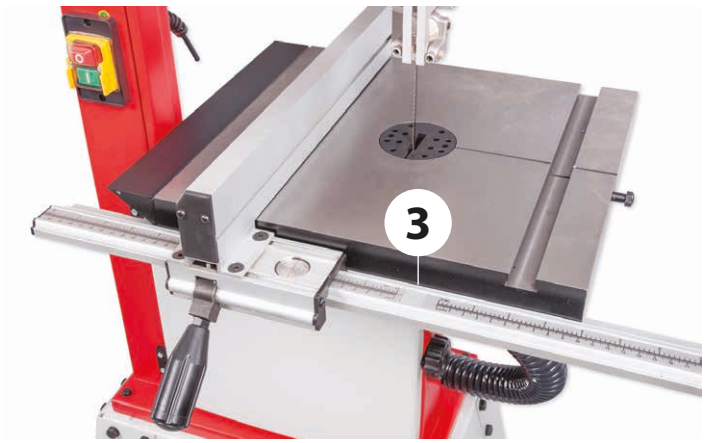
2) Locate the guide fence assembly (4), lowering the fence down over the fence rail (3) and press down the locking lever to secure the fence in position, see fig 17-18.

Fig 17-18



Extraction Port & Hose Assembly

1) Find the extraction port (5), flexible hose and retaining clips (7). Remove the four Phillips screws around the extraction outlet beneath the table. Line up the holes in the extraction port (5) and secure with the Phillips screws, see fig 19-20-21.

Fig 19-21-21

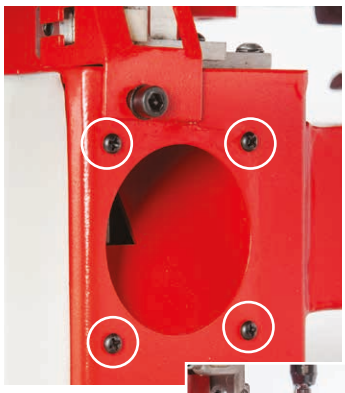
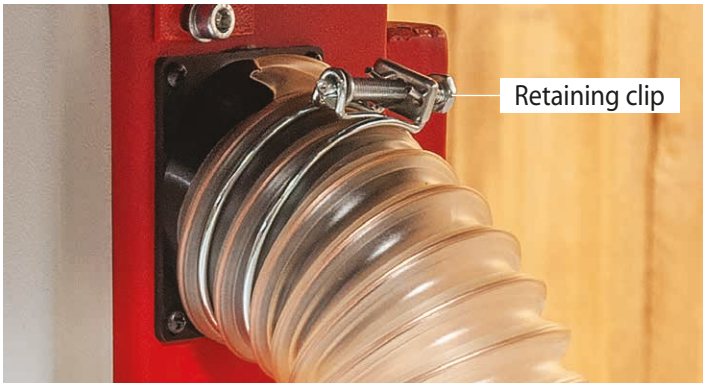
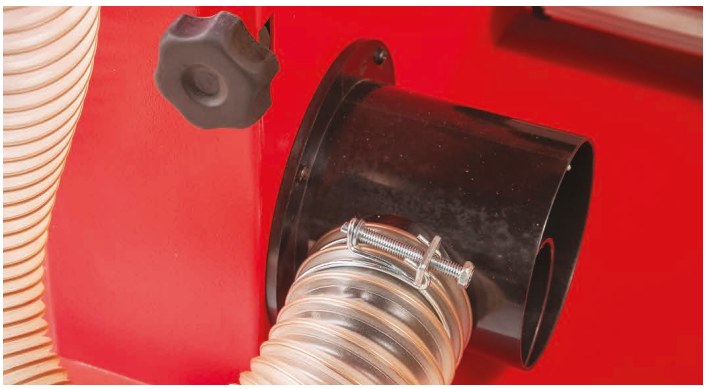


Fig 22-23





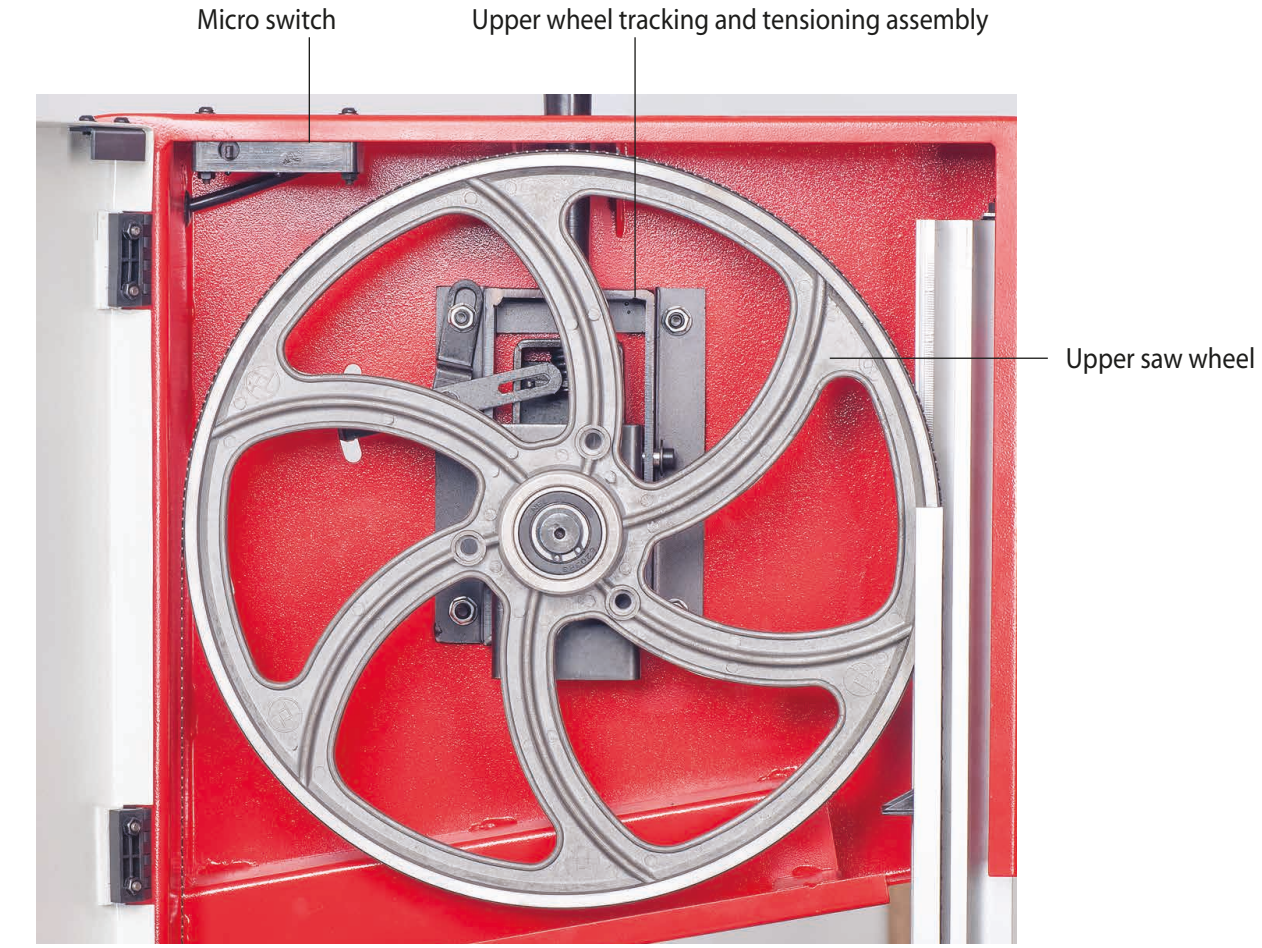
2) Place a retaining clip over the end of the hose (7), slide the hose over the port (5) and tighten the clip. Repeat for the lower extraction port, see fig 22-23.

3) Locate the angled pin and nut (8) and push stick (9). Screw the nut onto the threaded pin then screw the pin into the threaded hole to the rear of bandsaw and tighten with a spanner. Slot the push stick (9) over the pin, see fig 24-25.

Fig 24-25

AC1950B Bandsaw

Illustration and Parts Description


Micro switch
Upper wheel tracking and tensioning assembly
Upper saw wheel

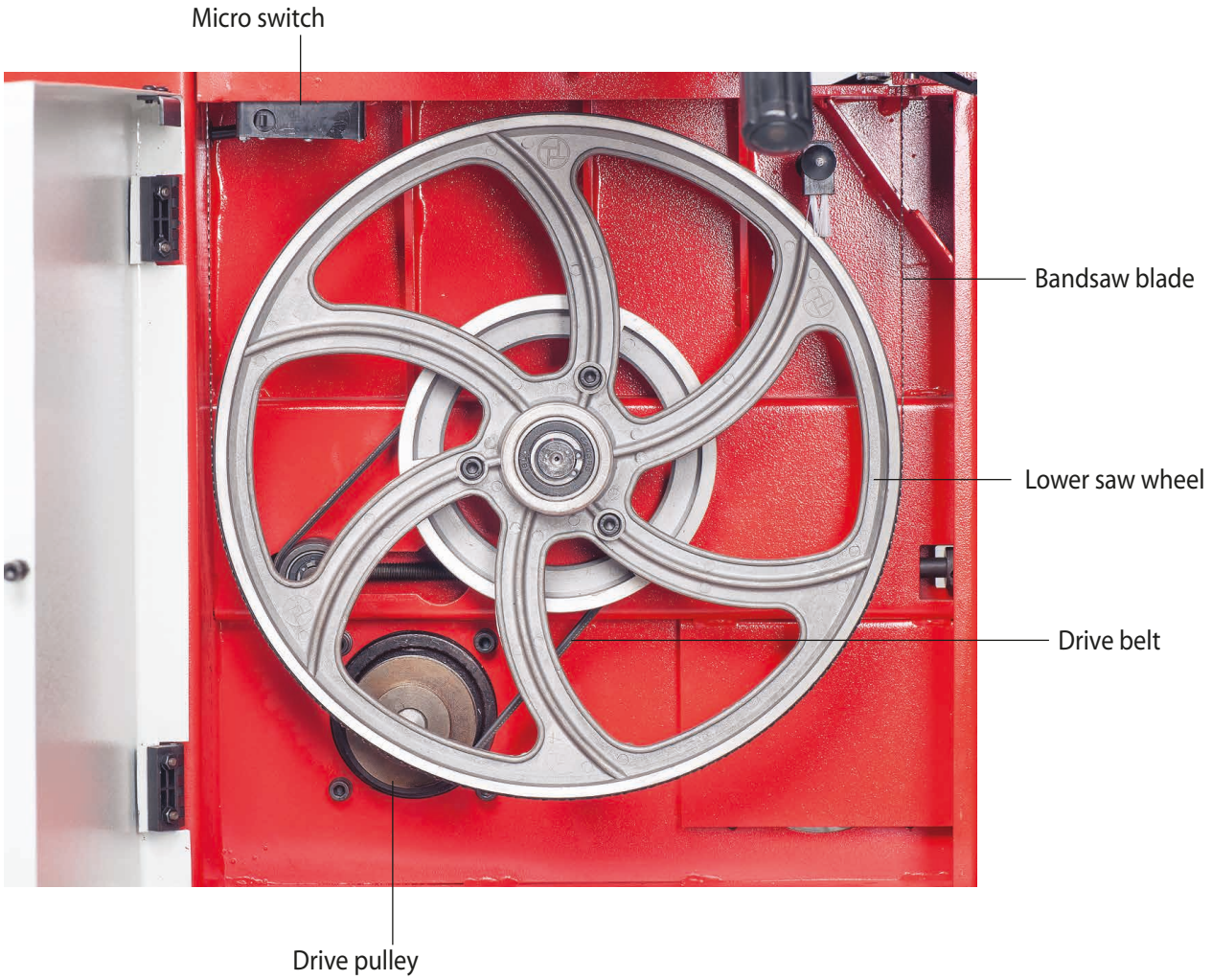
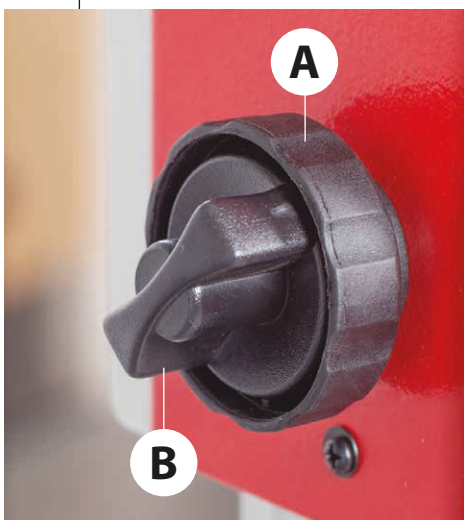

Micro switch
Bandsaw blade
Lower saw wheel
Drive belt
Drive pulley

Illustration and Parts Description

AC2305B Bandsaw
AC2606B Bandsaw

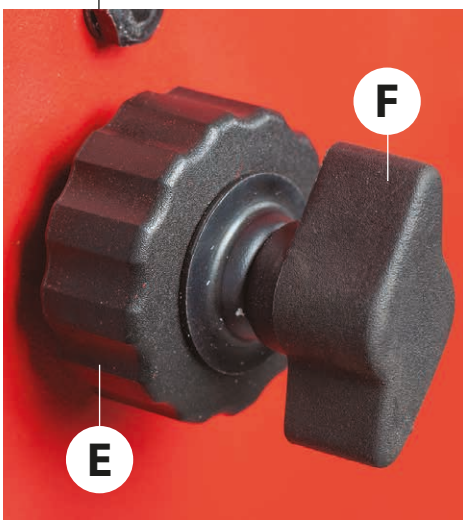
Blade tensioning scale



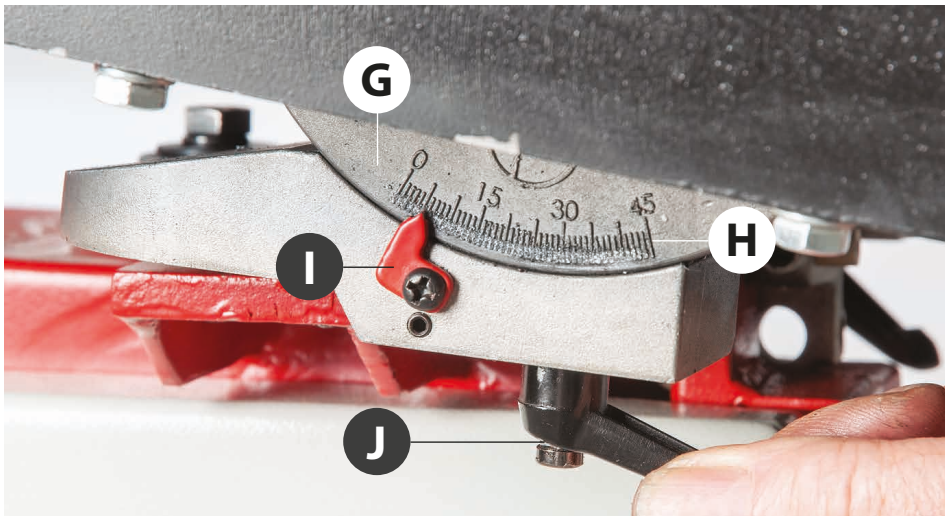
Blade guide adjusting knob (A)
Blade guide clamp (B)

Tracking control knob (C)
Tracking butterfly lock (D)

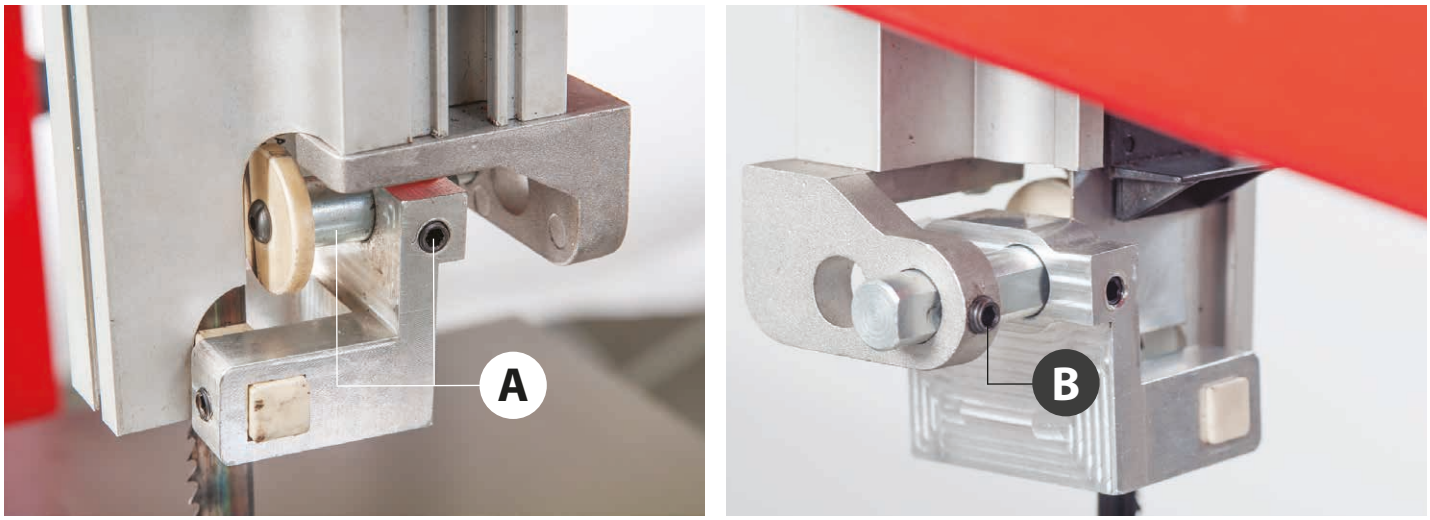
AC1950B Bandsaw



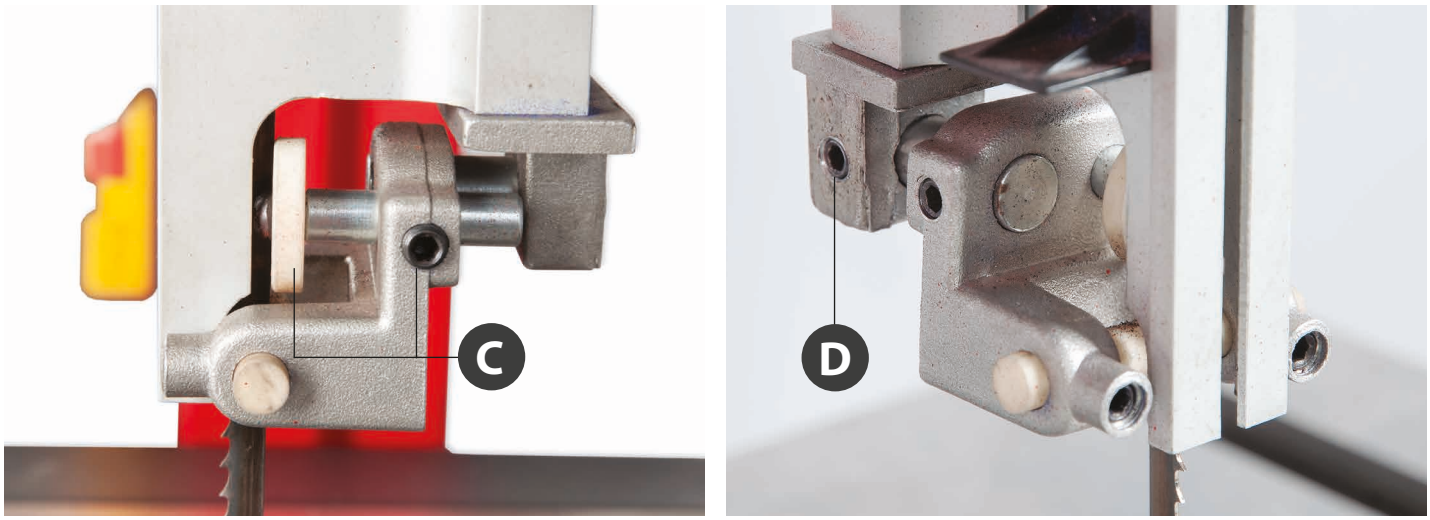
Blade guide adjusting knob (E)
Blade guide clamp F)



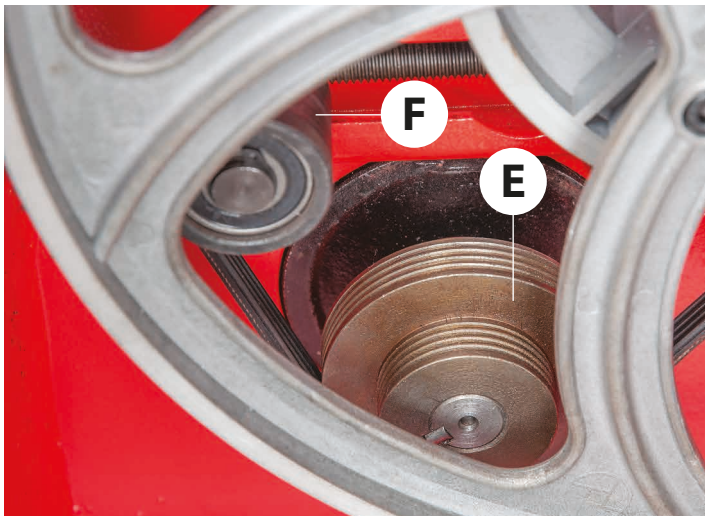
Tilt quadrant (G), Tilt scale (H)
Tilt scale pointer and adjusting screw (I), Lift and shift handle (J)



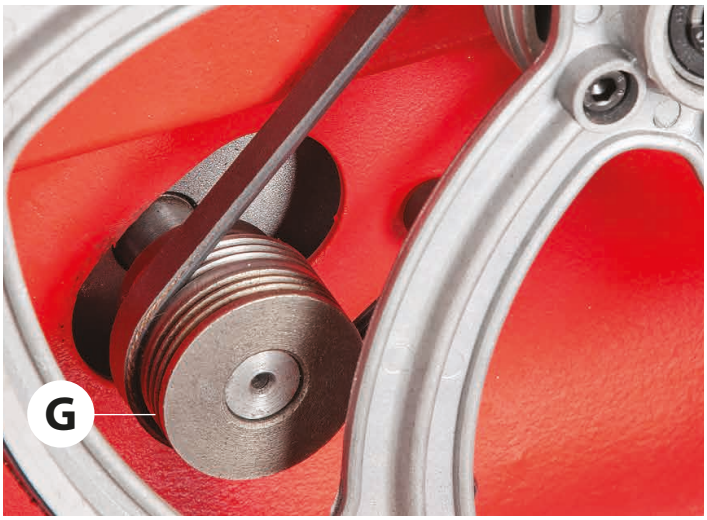
Upper blade guide assembly for AC2305B and AC2606B Bandsaw
Rear thrust bearing and clamping grub screw (A) Fore and aft clamping grub screw (B)



Upper blade guide assembly for AC1950B Bandsaw
Rear thrust bearing and clamping grub screw (C) Fore and aft clamping grub screw (D)



Drive assembly for AC2305B and AC2606B Bandsaw
Drive pulley (E) and tensioning Idler wheel (F)



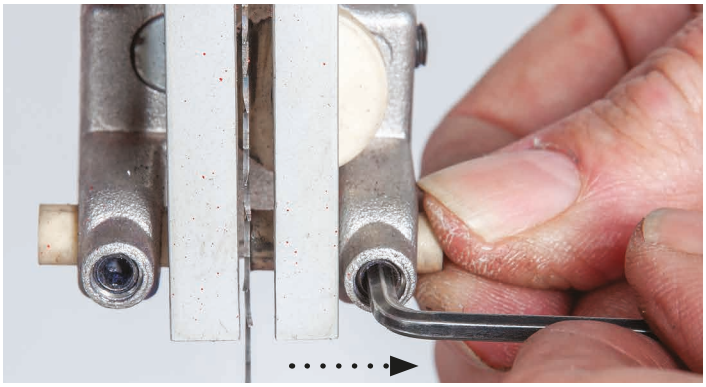
Drive assembly for AC1950B Bandsaw
Two speed drive pulley (G)

DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Tensioning and tracking the blade

Make sure both top and bottom blade guides and thrust bearing are well clear of the blade, see fig 26

Fig 26



1) Open the front covers fully, giving good access to the top compartment of the saw and good visibility into the bottom compartment, see page 13. For tracking the blade first adjust all bearing guides so that they are well clear of the blade. Check that the blade is sitting approximately in the middle of the wheels, see fig 27.

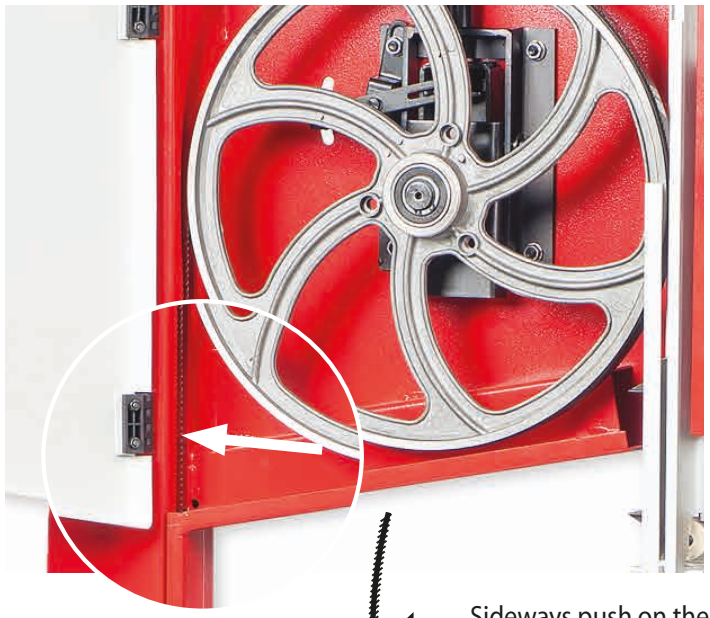
Fig 27

2) Apply some tension to the blade by turning the tensioning wheel clockwise, spin the top wheel by hand and check that the blade remains centrally on the tyre, see fig 28. If it does not, adjust the tracking by turning the tracking control at the rear of the head box, see fig 29. Viewed directly onto the tracking control wheel, turning clockwise should cause the blade to track to the rear of the tyre; anti-clockwise to the front, **Note: DO NOT make large adjustments otherwise you will over correct yourself.**

Fig 28-29

3) Spin the top wheel again, check again. Continue until the blade tracks in the centre of the tyres with no appreciable to and fro movement. Tension the blade fully. A sideways push on the blade should allow a maximum of 1 centimetre of movement with moderate pressure on the blade, see fig 30. Check the tracking again, adjust if necessary.

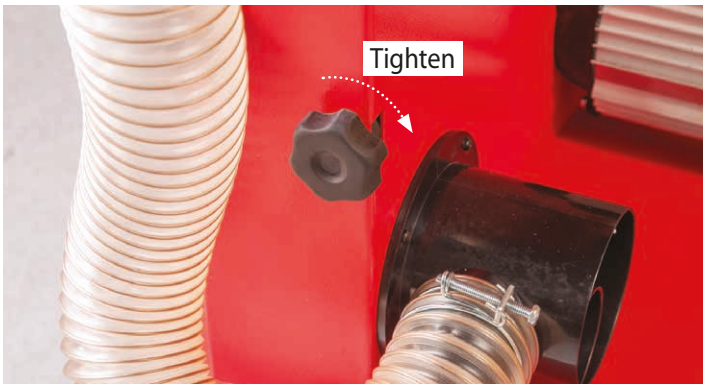
Fig 30

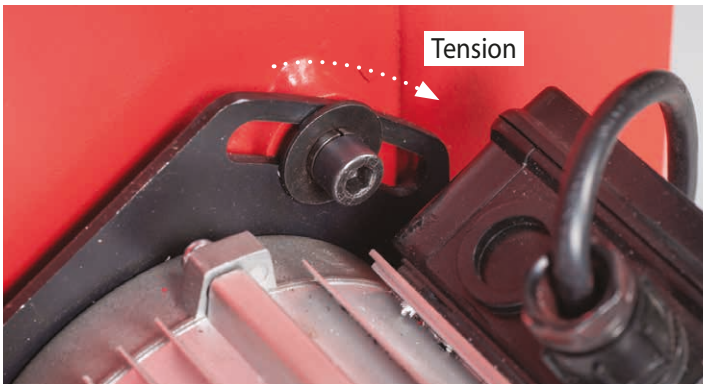


Continues over...

4) Check that the drive belt is tensioned correctly. If it is slack, apply 'take up' pressure to the belt by adjusting the 'Idler' pulley, using the knob at the side of the machine, see fig 31-32. Note this applies only for model numbers AC2305B and AC2606B bandsaws. To tension the drive belt on model AC1950B, loosen the motors clamping Hex bolt and press the assembly down. While holding motor in place retighten the Hex bolt, see fig 33.

Fig 31-32-33



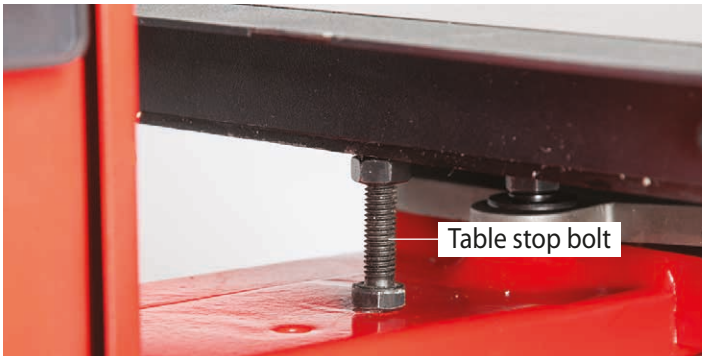


CONNECT THE SAW TO THE MAINS SUPPLY!

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

If it doesn't, adjust the tracking until it does, see fig 29.

Fig 34



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

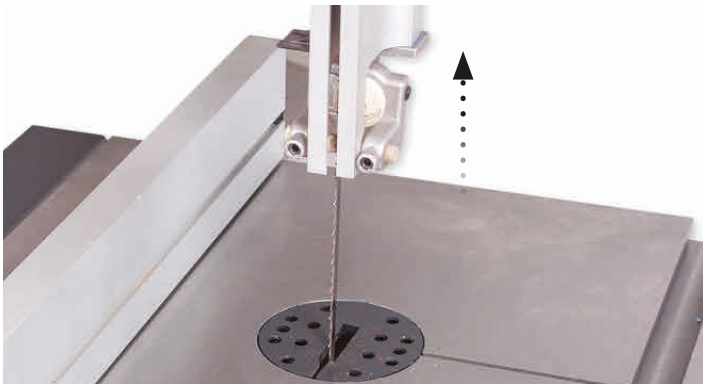
DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Checking the Table is Square

1) Loosen the clamping handle beneath the table, lower the table until it rests against its stop. This is a bolt with a lock nut screwed into the underside of the table, see fig 34. The head of the bolt acts as a stop when it strikes the machine frame. Tighten the clamping handles.

2) Loosen the blade guide clamp and raise the upper blade guide assembly as high as possible, see fig 35. Place a 90˚square on the table and move it up against the blade (behind the teeth), see fig 36.

Fig 35-36



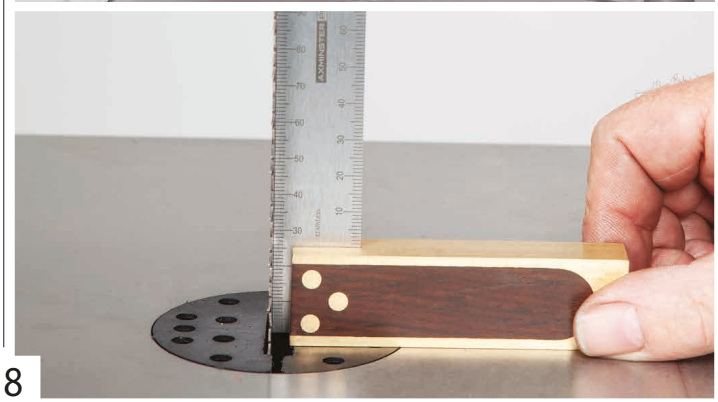
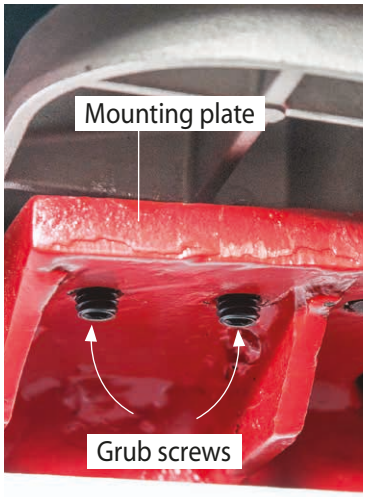


Fig 37

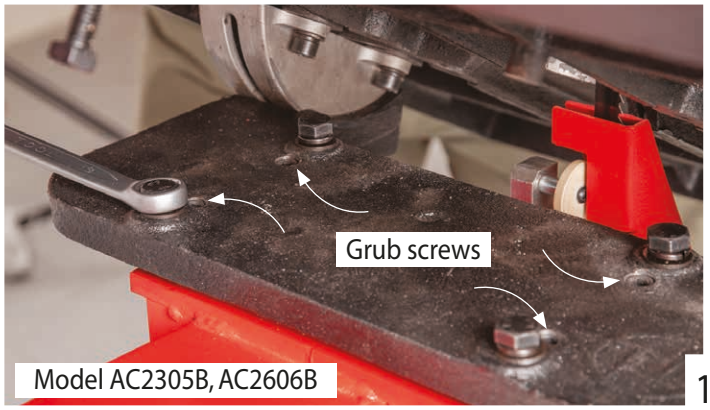
3) Check that the blade is perpendicular to the table. If it is not, try resetting the table by loosening the lift & shift handles and adjusting the table stop nut until perpendicularity is achieved, see fig 37.

4) Move the square up against the back of the blade and check it's square against the table, see fig 38. If adjustment is required loosen the locking handles, pivot the table and lock in place. Loosen the bolts holding the tilt quadrant, using a Hex key adjust the four grub screws in the quadrant. For model AC1950B, adjust the grub screws beneath the mounting plate, see fig 39-40. Make small adjustments, lower the table and postion the square as before. Continue until the blade is square to the table. Tighten the tables bolts to secure in place. Note: check the blade is still square against the table as shown in fig 36 and make adjustments to the table stop if required.

Fig 38-39-40



Model AC1950B



Model AC2305B, AC2606B

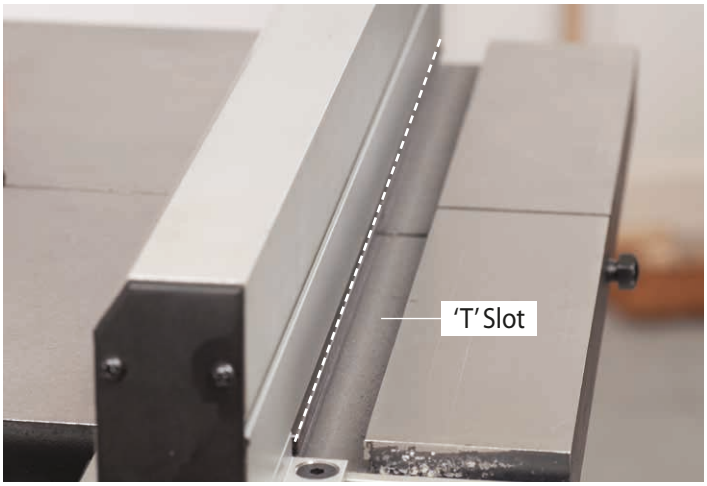
5) Lower the table down and check that the pointer of the tilt scale reads zero, if not, loosen the Phillips screw and reposition the pointer, see fig 41.

Fig 41

Setting the Fence

1) Line up the fence (4) with the edge of the tables 'T' slot and press down the locking handle., see fig 42. If the fence is out of alignment, loosen the two Hex screws either side of the fence clamping assembly. Adjust the fence until its in alignment with the 'T' slot, retighten the Hex screws, see fig 43.

Fig 42

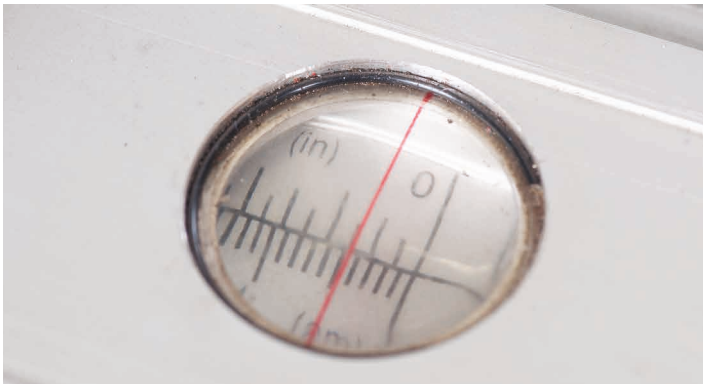


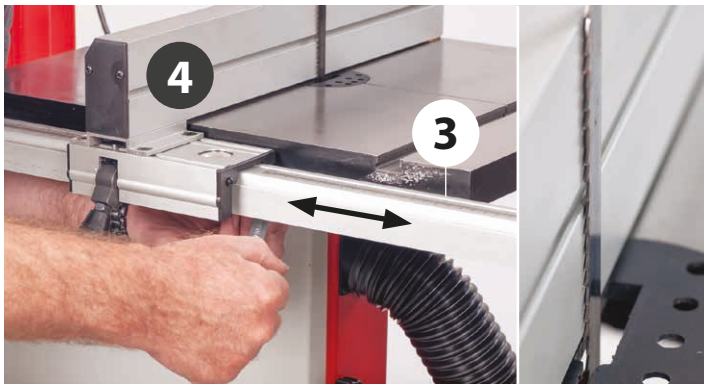
Continues over...

Fig 43

2) Reposition the fence up against the blade, check the magnifying lens indicator lines up with '0' on the fence rail scale. If the scale is out of alignment, see fig 44 loosen the fixing bolts beneath the fence rail (3) and tap the fence rail until the indicator is in line, tighten the rail, see fig 45-46.

Fig 44-45-46

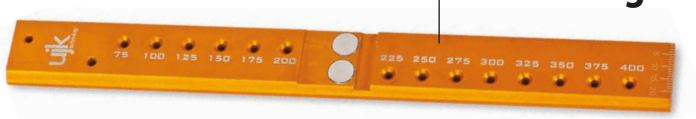




3) To make sure the fence is perfectly square to the blade we recommend using our unique bandsaw blade aligning tool, called the Bandsaw Buddy, see our website for details. The Bandsaw Buddy allows you to check the alignment of the bandsaw blade to the face of the fence. Most other checks only require the use of a combination or engineer's square. Truing the fence to the blade is tricky. The Bandsaw Buddy has two rare earth magnets which hold it firmly on the blade, see fig 47.

Code 101807

Fig 47



4) Place the Bandsaw Buddy on the blade as shown in fig 48. Move the fence up close to the alignment tool, lock in place check the fence face is aligned with the alignment tool, see fig 49. If adjustment is required loosen the four securing nuts beneath the table, adjust the table until correct, see fig 50. Secure the table place.

Fig 48-49-50

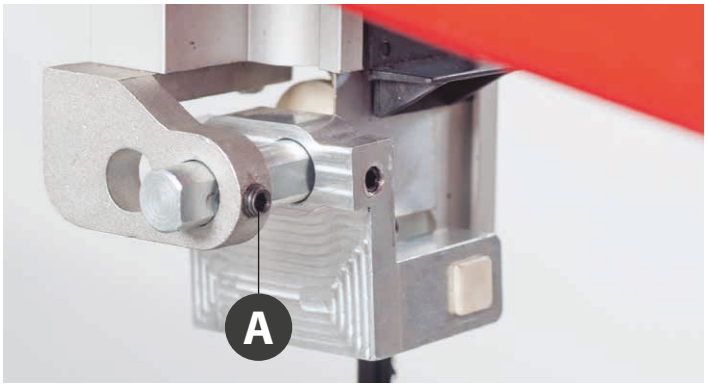
DISCONNECT THE SAW FROM THE MAINS SUPPLY!

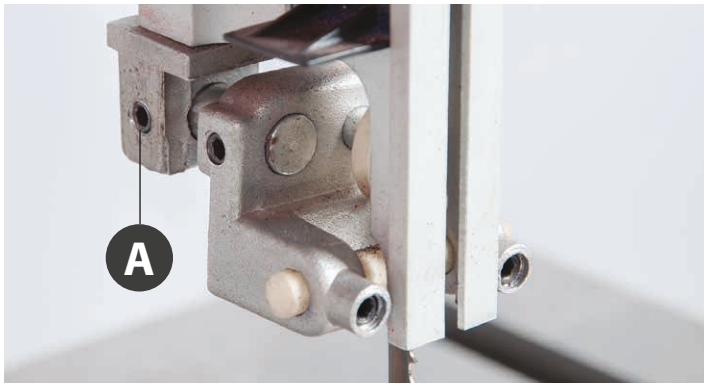
Setting the Blade Guides

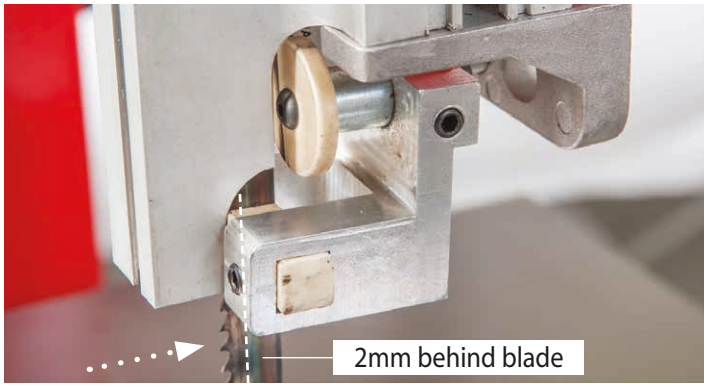
1) Loosen the blade guide clamp and lower the upper blade guide to approximately 1 1/2"(38mm) above the table, secure in place.

2) Loosen the grub screw (A) holding the guide assembly in place, adjust the fore and aft position so that the leading edge of the ceramic guides are approximately 2mm behind the gullets of the saw blade. Re-tighten the grub screw, see fig 51-52-53.

Fig 51-52-53

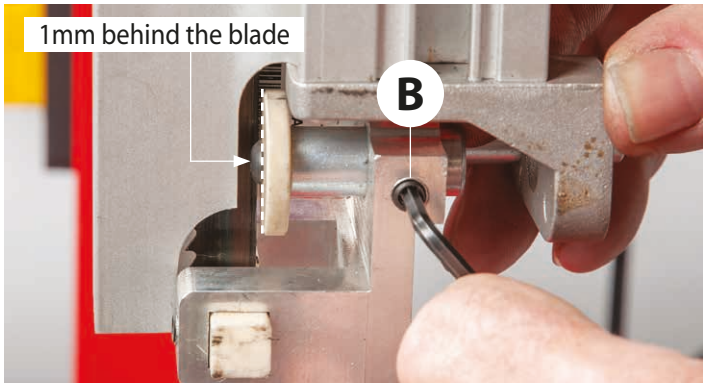


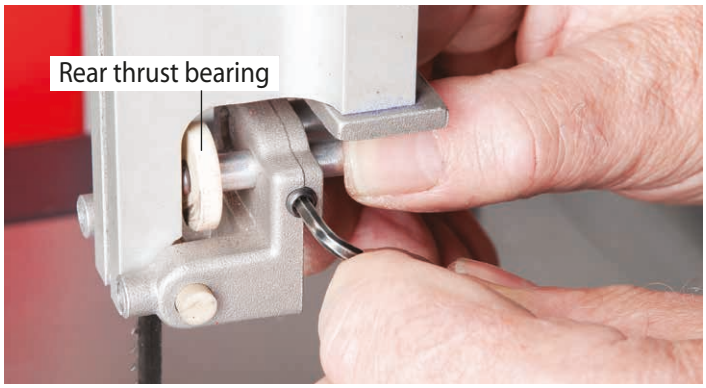




3) Loosen the grub screw (B) that clamps the rear thrust bearing, position the bearing so it's 1mm behind the blade, retighten the grub screw, see fig 54-55.

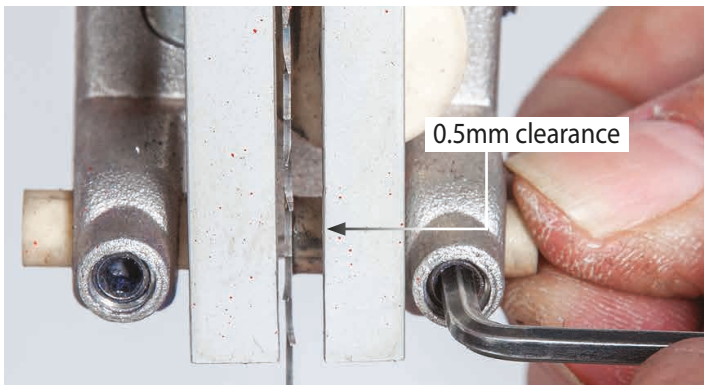
Fig 54-55

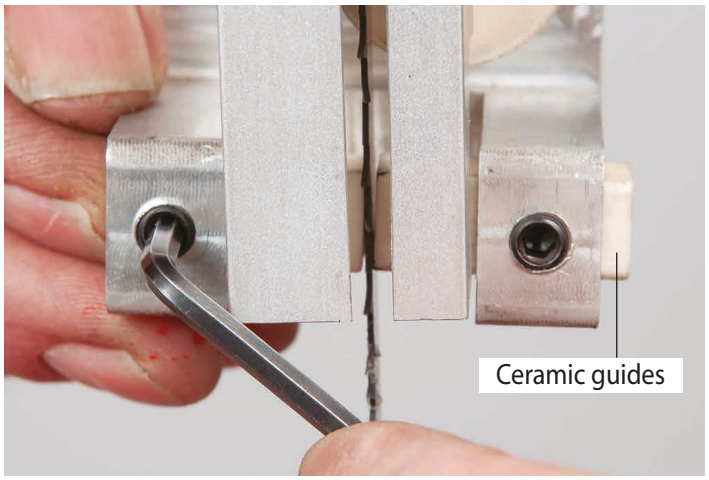




4) Loosen the two grub screws holding the ceramic blade guides. Adjust the guides to approximately 0.5mm clearance on either side of the blade. Re-tighten the grub screws, see fig 56-57.

Fig 56-57





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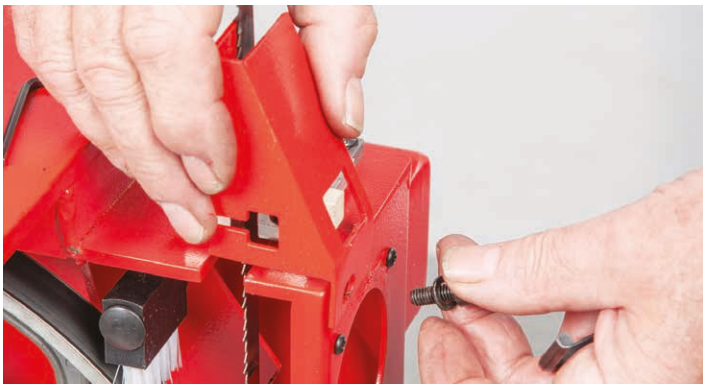
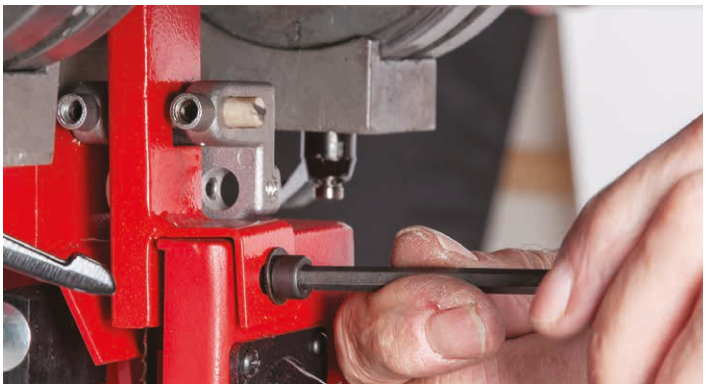
Note: When setting the lower blade guides you may find it easier to remove the table to gain better access.

5) Remove the lower blade guide guard and place safely aside, see fig 58-59.

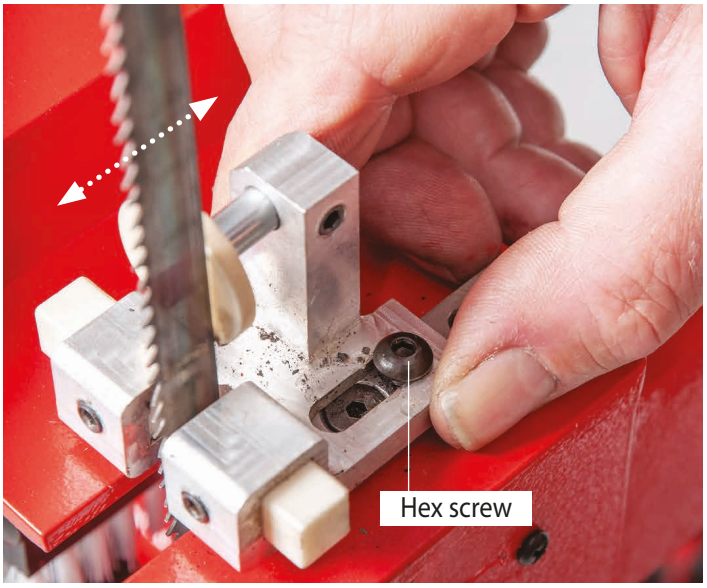
Fig 58-59

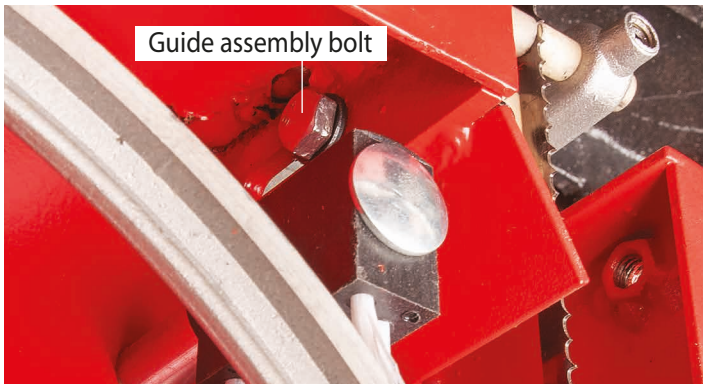




6) Set the fore and aft position on the guide assembly, as described in step 2 on page 21. Loosen the Hex screw on the lower guide assembly for models AC2305B, AC2606B, see fig 60. Loosen the bolt to the under side of the bottom wheel housing for model AC1950B, see fig 61. Note you may need to remove the lower wheel brush to gain access to the bolt, see fig 62. Once complete secure the assembly.

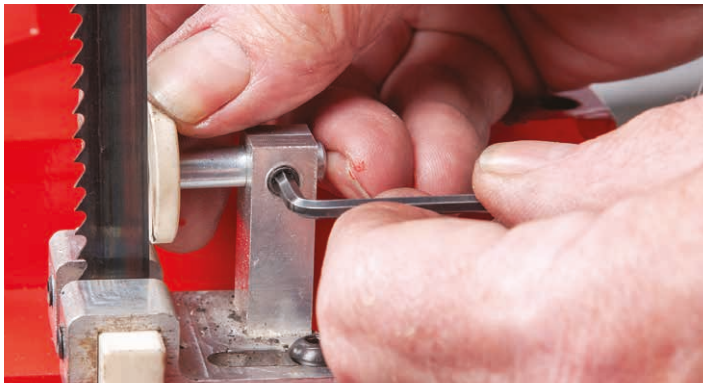
Fig 60-61-62

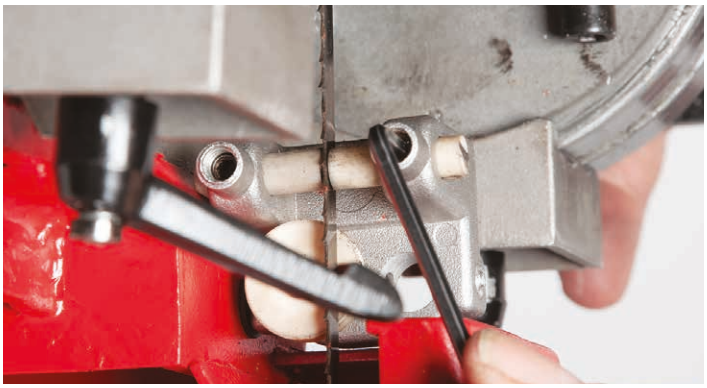


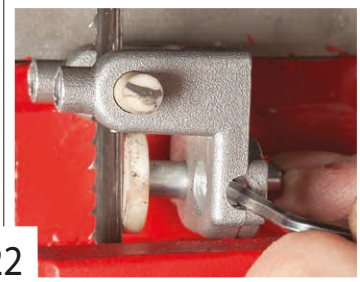


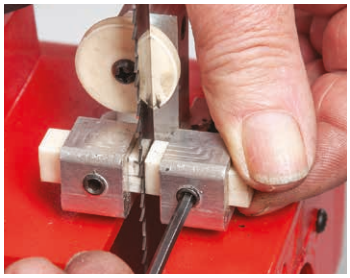
7) Repeat steps 3 and 4 on page 21 for setting the thrust bearing and ceramic blade guides, see figs 63-64.

Fig 63-64-65-66









1) Make sure you have read and fully understood the general instructions and safety precautions that are printed in the preceding pages of this manual.

2) Before connecting the machine to the supply; check the tool for obvious signs of damage, paying particular attention to the plug and the power cable. Rectify or have rectified any damage you discover. Check that the blade you are using is the correct one for the job in hand. Change the blade if necessary. Check the blade is not damaged; is clean, sharp, tracks properly and is correctly tensioned.

3) Set the upper blade guide to approximately 12mm (1/2") above the height of the work piece.

4) Check especially on site, that there are no foreign objects e.g. old nails, screws, small stones etc embedded in the material you are about to cut.

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

UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN THE WORK AREA AND KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN!

CONNECT A DUST EXTRACTION MACHINE TO THE SAW.

Note: For the AC1950B we recommend a vacuum style extractor, such as the AC50E, code 105251. For the AC2305B and AC2606B we recommend a 1-1 ½ hp high volume extractor, such as the AC 82E, code 105184.

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

7) Make sure that the material you are about to cut is within the machine is capacity, and the cut you are about to make is within the blades' capabilities, e.g. do not try to cut a 1" radius curve using a 5/8" blade.

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

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

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

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

USE THE SUPPLIED PUSH STICK WHEN CUTTING SMALL PIECES.

11) If you have to cut very small pieces of material, arrange or manufacture some form of 'shoe' to carry the timber. If the work piece is exceptionally small, find something to use as a sacrificial carrier and mount the work piece on it with double sided tape, or similar.

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

13) Do not release the tension on the saw blade when work is complete. The blades and the main saw frame do not respond kindly to constant changes in stress and tension. Only release the tension to change the blade or if the blade is to be removed because the machine is to be 'mothballed' for a lengthy time period. The blade in tension over a long period of non-use will cause the tyres to develop 'flat' spot.

WARNING! IF THE SAW JAMS! SWITCH OFF IMMEDIATELY.

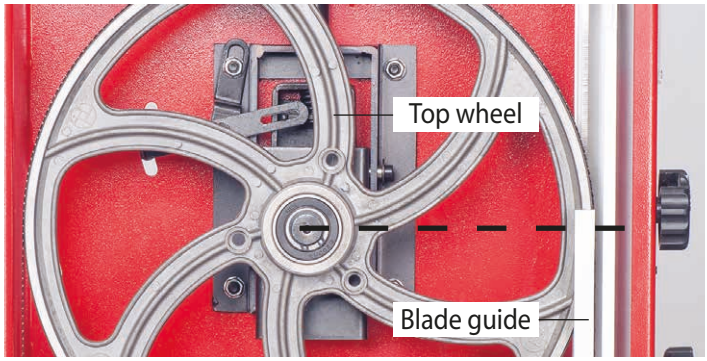
14) Open the saw cut, either by pulling apart or driving a wedge in close to the back of the blade. Try to wriggle the blade free of the saw. If this is not possible; check that the saw is free in the cut, start the saw, allow it to run up to speed and 'cut out' as quickly as possible. The removal of the 'off cut' may well prevent the saw jamming again if you resume the original cut).

DISCONNECT THE SAW FROM THE MAINS SUPPLY!

1) Put the table back to the level position if it has been tilted. Open up all blade guides so that they are clear of the blade and open the wheel doors. Set the upper blade guide assembly approximately midway in the throat so the top of the blade guide is level with the centre of the top drive wheel, see fig 67. Remove the table insert.

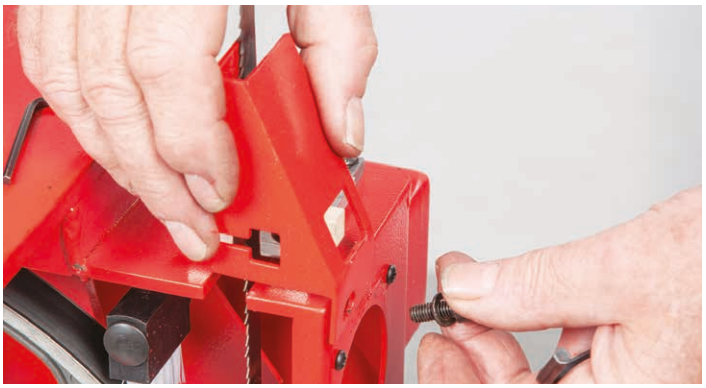
2) Remove the table stabilising bolt, slacken the blade tension by turning the blade tensioning wheel anti-clockwise, until the blade can be easily slipped off the wheels, see fig 68-69.

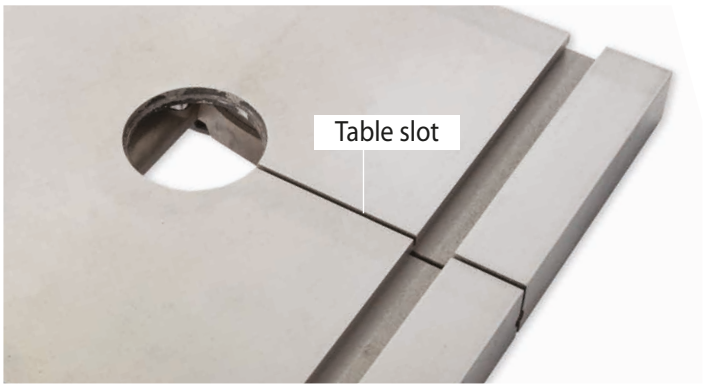
Fig 67-68-69



3) Remove the upper and lower blade guide guards and place safely aside, see fig 70-71. Remove the blade carefully, "wiggling" it clear of the upper blade guard and out through the slot in the table, 72.

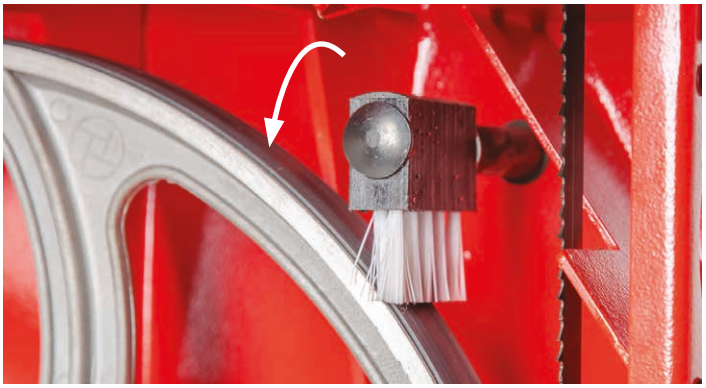
Fig 70-71-72

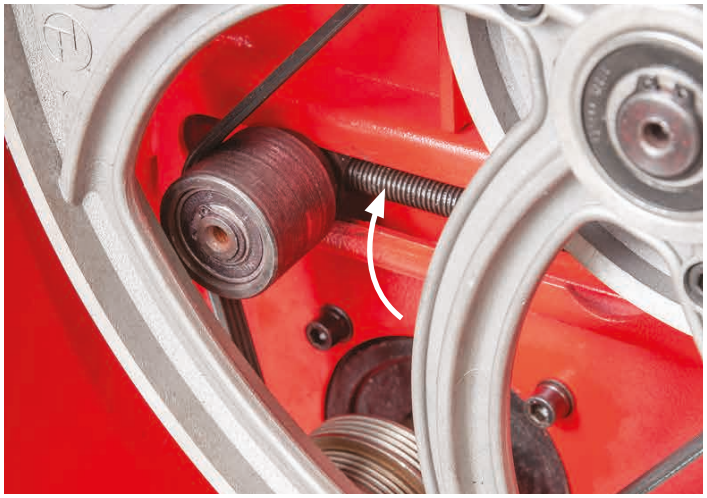


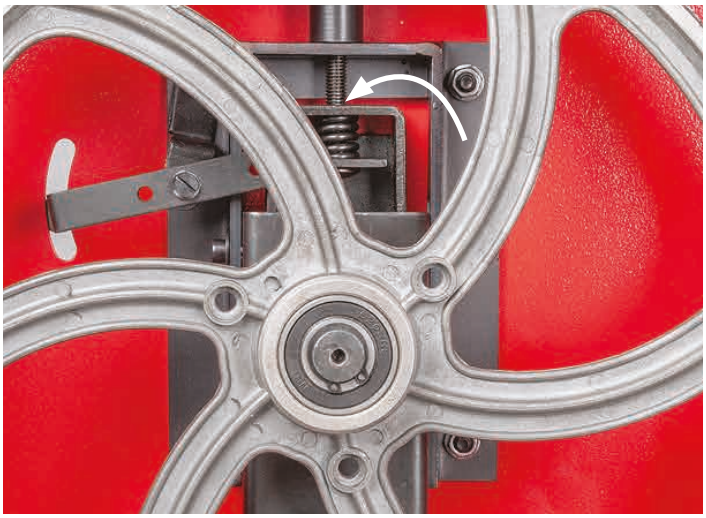


4) This is a good time to clean out the interior of the machine; remove the impacted 'crud' from the tyres, apply a little light oil to the screw threads of the blade and drive belt tensioners and the tracking control. The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the drive belt tensioner in its slot could likewise be lightly oiled, see fig 73-74-75.

Fig 73-74-75







Drive belt tensioner & tracking control assembly

5) If you are fitting a new blade, it will have been supplied to you "folded", bound together in this configuration with tape or tie wrap.

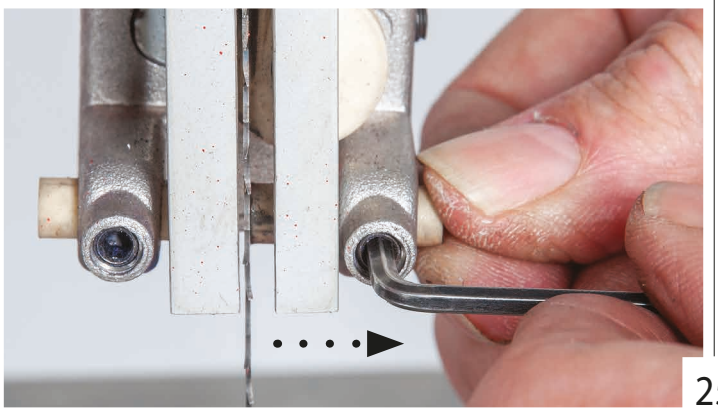
WARNING! BE VERY CAUTIOUS WHEN YOU "UNFOLD" THE BLADE; IT TENDS TO 'SPRING' OPEN, BLADE AND TEETH GOING EVERYWHERE.

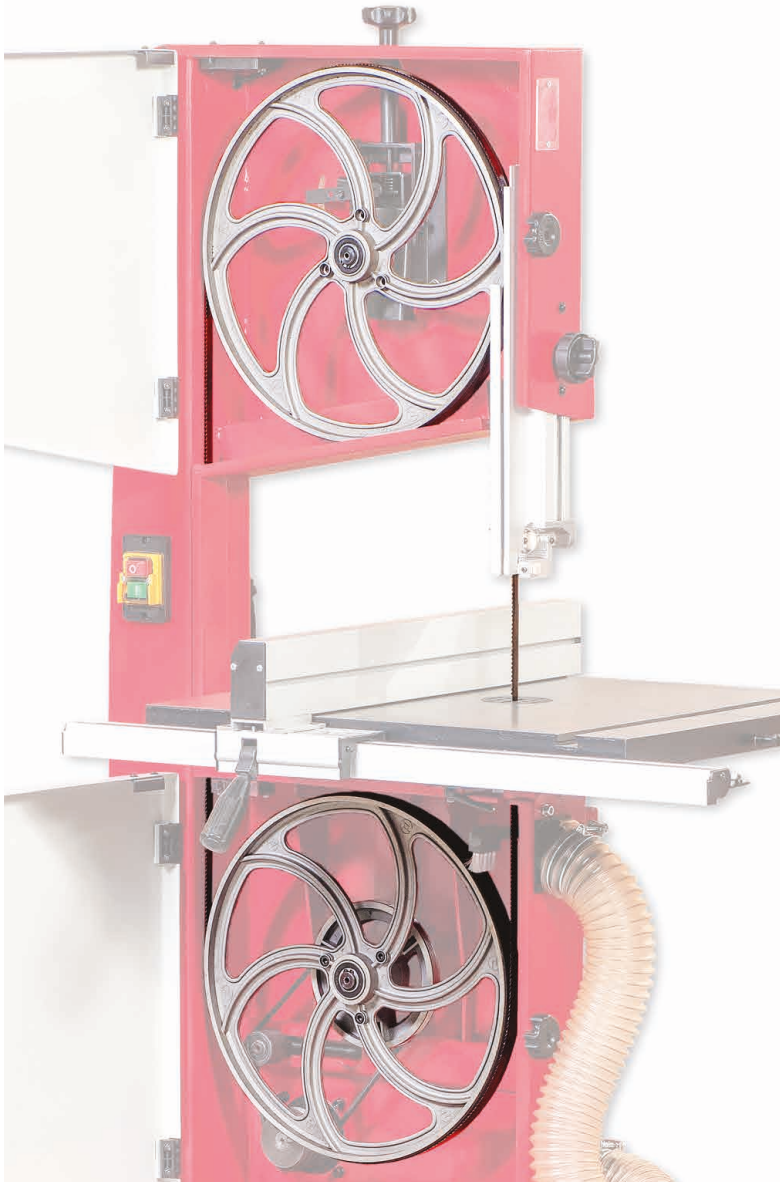
MAKE SURE THE BLADE TEETH ARE POINTING DOWN!

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

7) Open up all blade guides so that they are clear of the blade. Hold the blade approximately midway on either side of the loop and feed it into the table slot. When you get to the table insert cut out void, work the left side of the loop into the slot in the guard in the neck of the main saw frame. "Wriggle" the right hand side of the blade through the slot in the upper blade guide assembly. Ease the blade over the wheels and locate the blade in the lower/upper blade guides, see fig 76-77.

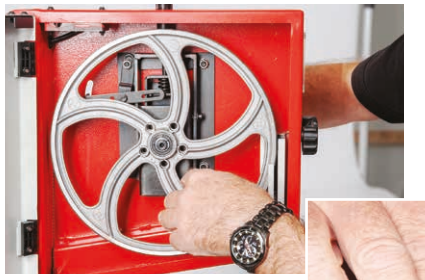
Fig 76-77

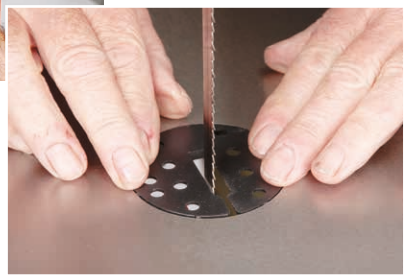




8) Apply some tension to the blade. Turn the top wheel by hand, to ensure the blade will not skip off the wheels and the blade is travelling in the blade guides. Apply a little more tension and check by once again spinning the upper saw wheel by hand, see fig 78. When you are sure that the blade is "ON" and stable, re-fit the table stabilising bolt and re-fit the table insert, see fig 79. Now adjust the blade guides as described in 'Setting up the saw' on page 21.

Fig 78-79





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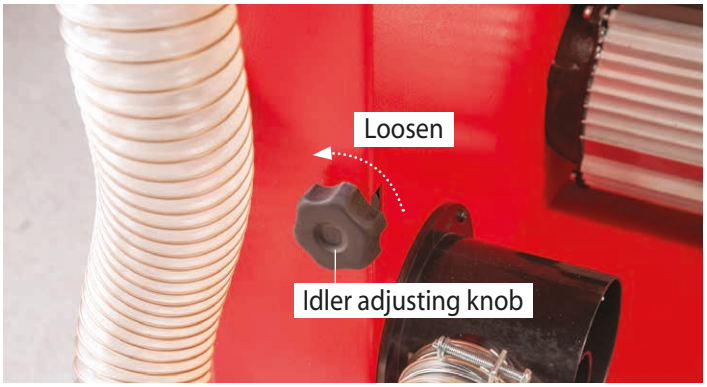
Changing the Blade Speed

DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Bandsaw Speed Table		
Model	**Min** (Small Pulley)	**Max** (Large Pulley)
AC1950B	660m/min	840m/min
AC2305B	360m/min	720m/min
AC2606B	600m/min	840m/min

1) The bandsaw drive pulley has two speed positions. To change the speed, follow the instructions below. Open the bandsaw wheel doors and release the tension on the drive belt by turning the idler wheel adjusting knob anti-clockwise, see fig 80-81. Note: to release the belt tension on the AC1950B bandsaw, loosen the motor Hex bolt, see fig 82 and pull the motor up.

Fig 80-81-82



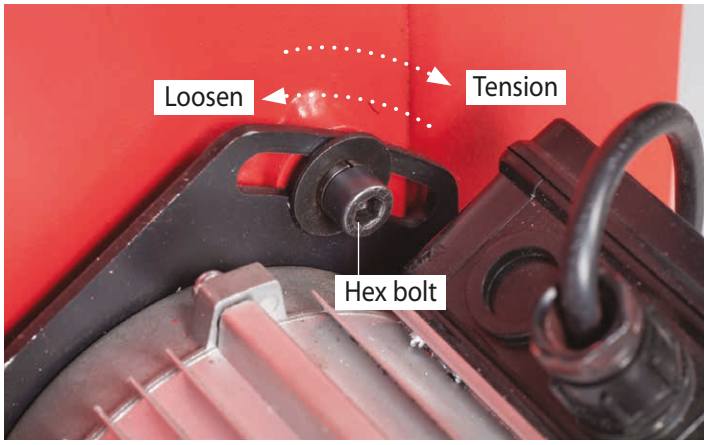
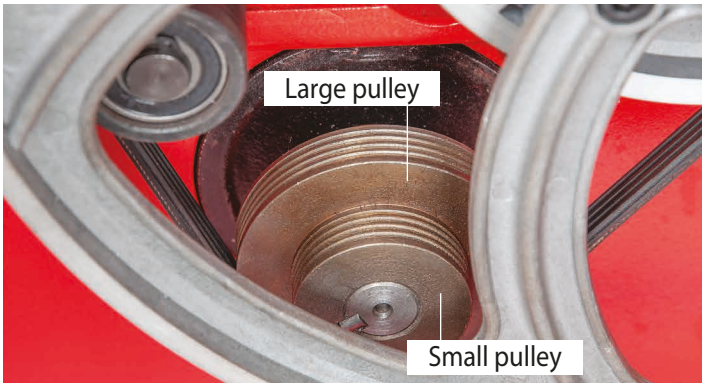


Fig 83-84



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

NOTE: MAKE SURE THE BELT IS NOT TENSIONED TO TIGHTLY TO CAUSE IT TO GET HOT.

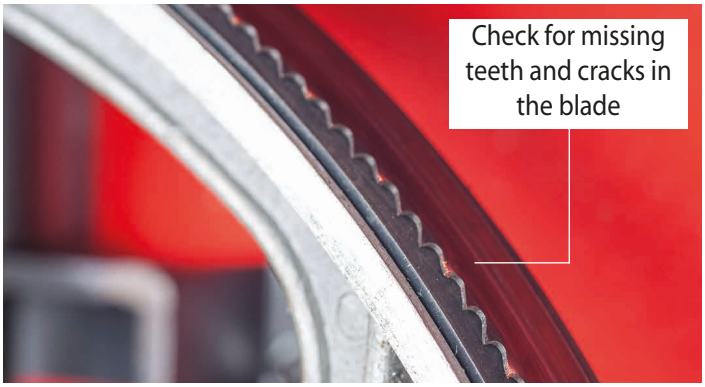
2) With the drive belt loose, carefully reposition the drive belt, see fig 83-84. NOTE: Make sure the belt is seated correctly in one of the drive pulley grooves. With the belt repositioned, turn the Idler wheel adjusting knob clockwise to re-tension. Push the motor down on the 'AC1950B' and tighten the bolt to retention. Close the wheel doors.

DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Daily

- Keep the machine clean.
- Check the saw blade for missing teeth and cracks, see fig 85.
- Spray Axcaliber Dry Lubricant on the bare metal surfaces.

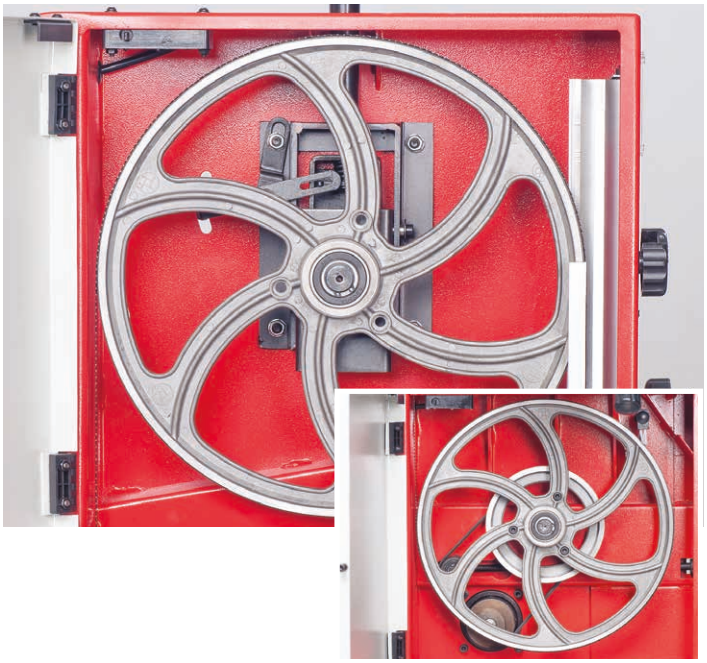
Fig 85

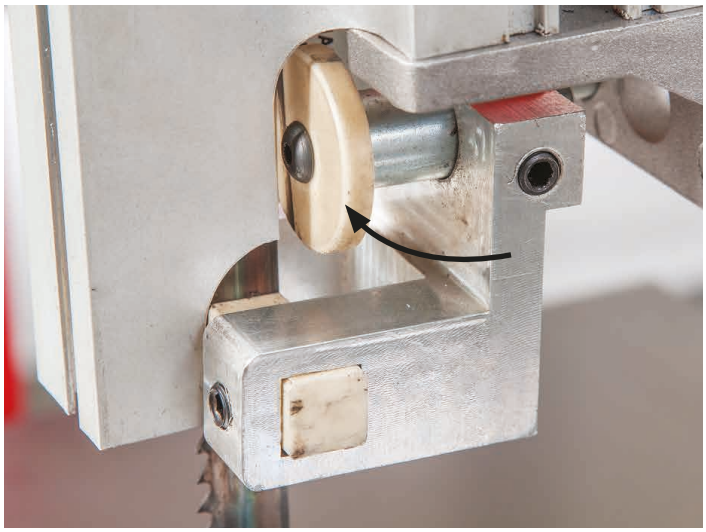


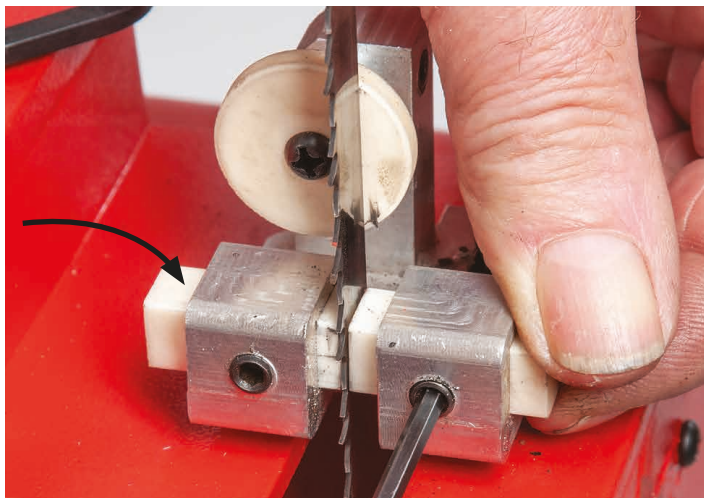
Weekly

- Open the wheel doors and clean out all saw dust and impacted 'crud' from the wheels and compartment area, see fig 86-87. Note: using a vaccum cleaner, clean the motor vents and casing.
- Check the condition of the upper/lower ceramic blade guides and thrust guide. Clean any impacted 'crud' from the ceramic guides, see fig 88-89.

Fig 86-87-88-89







Monthly

- Open the lower and upper door and check the condition of the tyres and the drive belt. Clean out all saw dust and impacted 'crud' from the wheels and compartment area.
- Apply a little oil to the screw threads of the blade and drive belt tensioners. **DO NOT TO GET ANY OIL ON THE TYRES AND DRIVE BELT.**
- Check the condition of the tyres
- Check the blade for missing teeth and cracks
- Over time the drive belt can slacken, refer to the previous page for tensioning the drive belt.

Bandsaw Blade Information

About Axcaliber Bandsaw Blades

Axcaliber bandsaw blades are manufactured at Axminster using advanced CNC machining, high precision digital measuring equipment and specialised heat treatment facilities. Detailed quality checks are performed at each stage of manufacture using the most modern inspection equipment. The result is a blade which consistently cuts straighter, has harder, longer-life teeth and which gives a superior finish to the work. The final step in the manufacturing process is one of the most important; the weld. We have invested heavily in this area through the purchase of precision welding and grinding equipment and are, as a result, one of the few companies worldwide able to offer a fully guaranteed weld. Blades are cut accurately to length then, using an IDEAL bandsaw blade welder, a high voltage current is passed through the blade to achieve a precision butt weld. The weld is annealed to remove any brittleness and danger of fatigue and then hand dressed to produce a perfectly smooth joint.

Choosing the Right Tooth Pitch (tpi)

3 tpi (skip form)

Used for deep cutting especially rip cuts, this blade will leave a rough sawn finish although slow feed rate and high tension will improve the finish of the cut.

4 tpi (skip form)

Good for general-purpose use with a degree of cutting across the grain and with the grain, a reasonable finish can be achieved with slower feed rates and good tension.

6 tpi (skip form)

The ideal general purpose blade suitable for cross cutting up to 150mm and ripping in sections up to 50mm thick although thicker sections can be cut using slow feed rates. This tooth form will give a clean finish and is very well suited to natural timbers.

10 tpi (regular)

Good for cutting plywood and MDF as well as non-ferrous metals and plastics. The finish is good when cutting natural timbers but the feed rate should be slow and maximum depth of cut should not exceed 50mm. When cutting metals reduce the speed as much as possible especially when cutting ferrous metals or cast iron.

14 tpi (regular)

A very clean cutting blade for plywood, plastics and MDF although too fine for natural timbers unless they are very thin sections (sub 25mm thick). The 14tpi blade is very good to use on slow speeds when cutting non-ferrous metals. A slow feed speed should be used at all times with a blade tooth pitch this fine.

Blade Width

Always use the widest saw blade possible; it is stronger and will withstand greater feed pressures without flexing. Consult your machine manual for the maximum and minimum blade widths that it will accept. The minimum radius of curve for each blade width is as follows:

Blade width	Minimum radius
13mm (1/2")	63mm (2 1/2")
10mm (3/8")	27mm (1 1/16")
6mm (1/4")	19mm (3/4")
5mm (3/16")	13mm (1/2")
3mm (1/8")	10mm (3/8")

Blade Length

This is determined by your machine model. A list of the most popular machines and their blade lengths is found in the catalogue.

Blade Tooth Form

Standard Blade Tooth Forms: We supply bandsaw blades with one of two tooth forms, skip or regular:

The skip tooth is provided on coarse tooth blades, those with 3, 4 and 6 teeth per inch; it has a wide shallow gullet with plenty of space for waste to collect. Please note that the quality of the cut can be adversely affected by sawdust packing between the teeth. The regular, or triangular, tooth form is provided on blades with 10 or more teeth per inch where, because of the reduced material removal, there is less need for waste storage.

Premium Bandsaw Blades

•Premium blades made from M42 with 8% cobalt.

• Long life with high resistance to heat, abrasion and vibration.

• Variable pitch teeth for wider ranging applications.

• Also used for cutting metal on horizontal bandsaws. Blades are available in three variable pitch forms 4-6tpi, 6-10tpi and 10-14tpi.

High Carbon Bandsaw Blades

• General purpose range of blades for wood and metal cutting.

• Comprehensive range of lengths widths and tooth configuration.

• Hardened and long lasting teeth.

Ground Tooth Bandsaw Blades

• Diamond ground teeth staying sharper for at least 30% longer.

• Smoother cut over general purpose milled tooth blades.

• Comprehensive range of lengths, widths and tooth configuration.

Back Tooth Bandsaw Blades

• Specifically designed for curve cutting so ideal for wood turners.

• Back tooth design allows better clearance and tighter curves.

• Available in one width of 5/16" (8mm) x 4 tpi.

Bandsaw Trouble Shooting

Trouble Shooting

Bandsaws are relatively simple machines and with all machinery regular servicing (preventative maintenance) is essential to get the best from your saw.

'My bandsaw won't cut Straight"

- This is the most common question that you will get from bandsaw users. Usually the answer lies within the blade; poor quality blades with uneven set, the blade is blunt or damaged often only on one side, the tooth count is far too high for the material being cut -remember 2 teeth minimum and 10 teeth maximum in the work piece.
- The fence is out of line with the blade.

"My bandasw slows down when cutting"

- Check drive belt is tensioned correctly.
- If cutting hard or wet material slow your feed rate down.
- Check blade is sharp and not too fine.
- Make sure that when curve cutting a narrow blade is used- see unit 5 blade and cutter types.

"My bandsaw vibrates"

- Clean machine wheels.
- Check blade is running correctly on wheels.
- Check blade weld – is it in line?
- Check machine is not on an uneven floor.

"Can I cut steel on my bandsaw?"

- No , most woodcutting bandsaws run far too fast to cut steel even if a metal cutting blade is fitted.

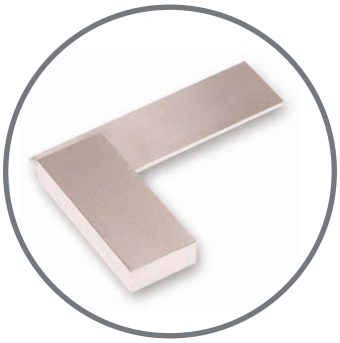
Accessories

Below is the list of top recommended accessories and up-sell items for the bandsaw. Please visit our website at **axminster.co.uk**

Axminster Machine Maintenance Kit

Lubricants and Maintenance Tools

Bandsaw Blades



Squares

Cyclone Extractors

Code: 101807

INTRODUCTION

• Bandsaw Buddy is a unique bandsaw blade aligning tool. Bandsaw Buddy allows you to check the alignment of the bandsaw blade to the face of the fence. Most other checks only require the use of a combination or engineer's square. Truing the fence to the blade is tricky. Bandsaw Buddy has two rare earth magnets which hold it firmly on the blade. At 250mm long it is easy to spot any discrepancy and then make necessary adjustments. The magnets will keep it safely stored on the bandsaw's frame when not in use.

• A scale on the tip helps set the bandsaw fence for cutting veneers or thin boards. Holes along the Buddy's length at 12.5mm intervals allow you to draw arcs or circles in 25mm steps from 75mm to 400mm, a useful feature for marking curves or when cutting bowl blanks. Accurately machined from anodised aluminium, it also makes a handy straight edge.

KEY FEATURES

• Designed and made in Axminster

• Unique bandsaw blade aligning tool

• Checks the alignment of blade to the face of the fence

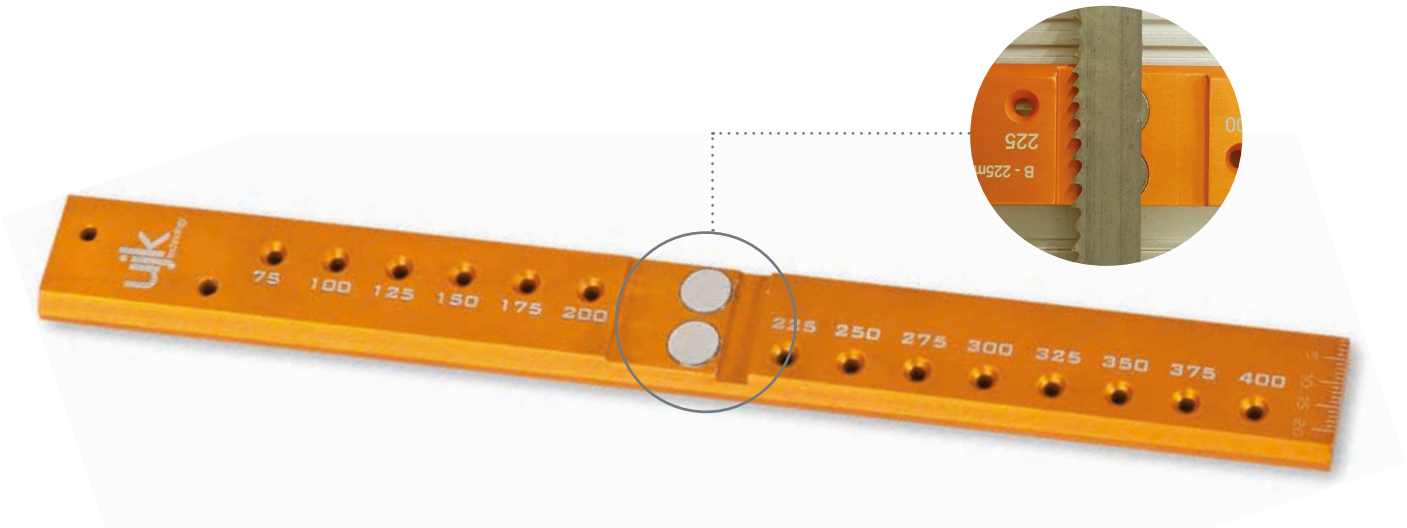
• Rare earth magnets hold it firmly on the blade

• 250mm long makes it easy to spot any discrepancy

• Scale on the tip helps set fence for cutting veneers or thin boards

• Holes for drawing circles in 25mm steps from 75 to 400mm

• Accurately machined from anodised aluminium



Marking Gauge

An easy to use circle marking gauge for bowl blanks from 75mm to 400mm radius in increments of 25mm.

Accurate Marking

The bandsaw buddy can be used as a straight edge for accurate marking.

Thickness Gauge

A convenient and accurate metric thickness gauge, great for veneering.

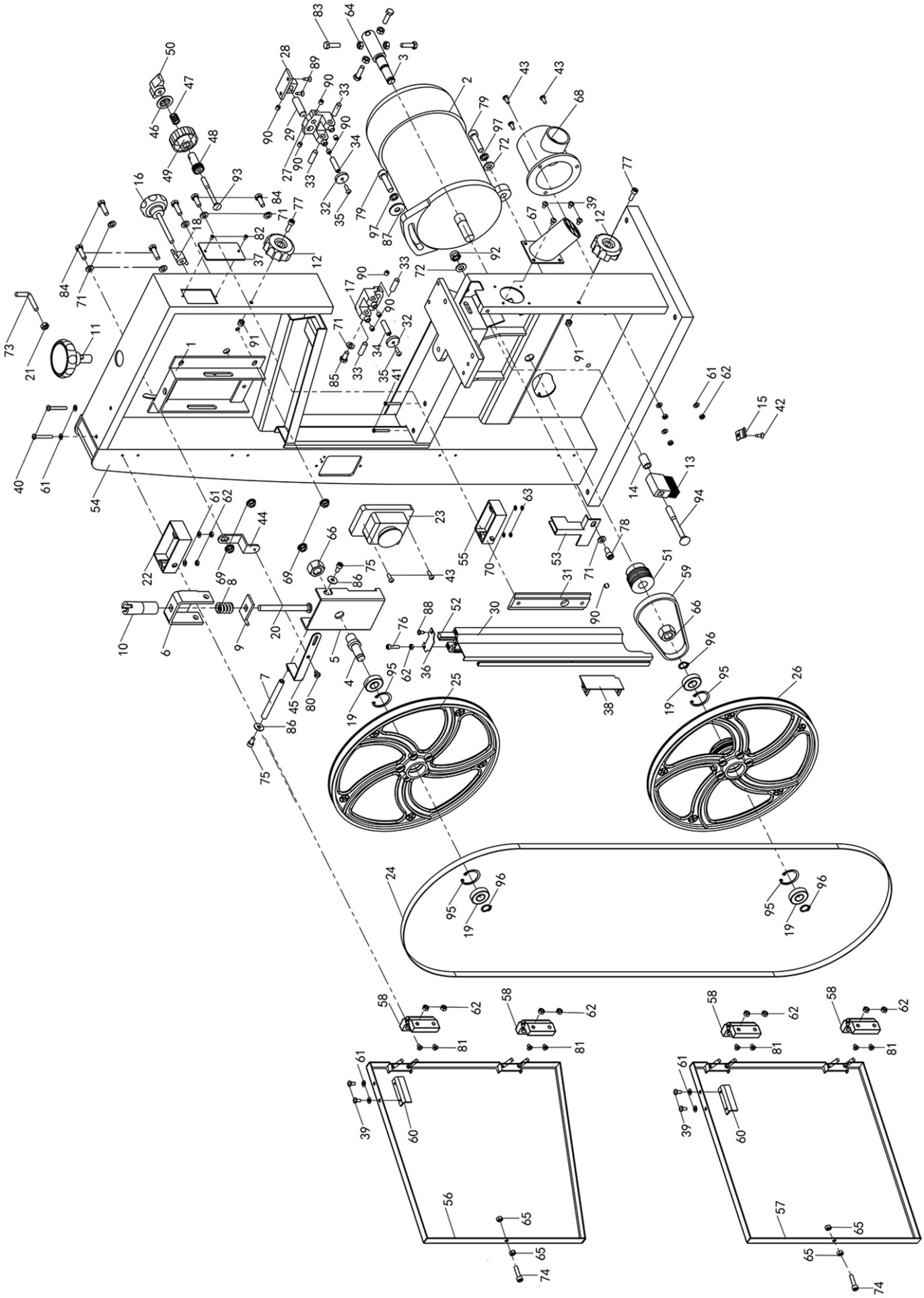
Perfect Alignment

Rare earth magnets securely hold the rule to the blade. This enables you to align your rip fence and table perfectly parallel with the blade.

Keep your buddy on hand

Once you've used your Bandsaw Buddy the integrated magnets allow simple storage on your bandsaw

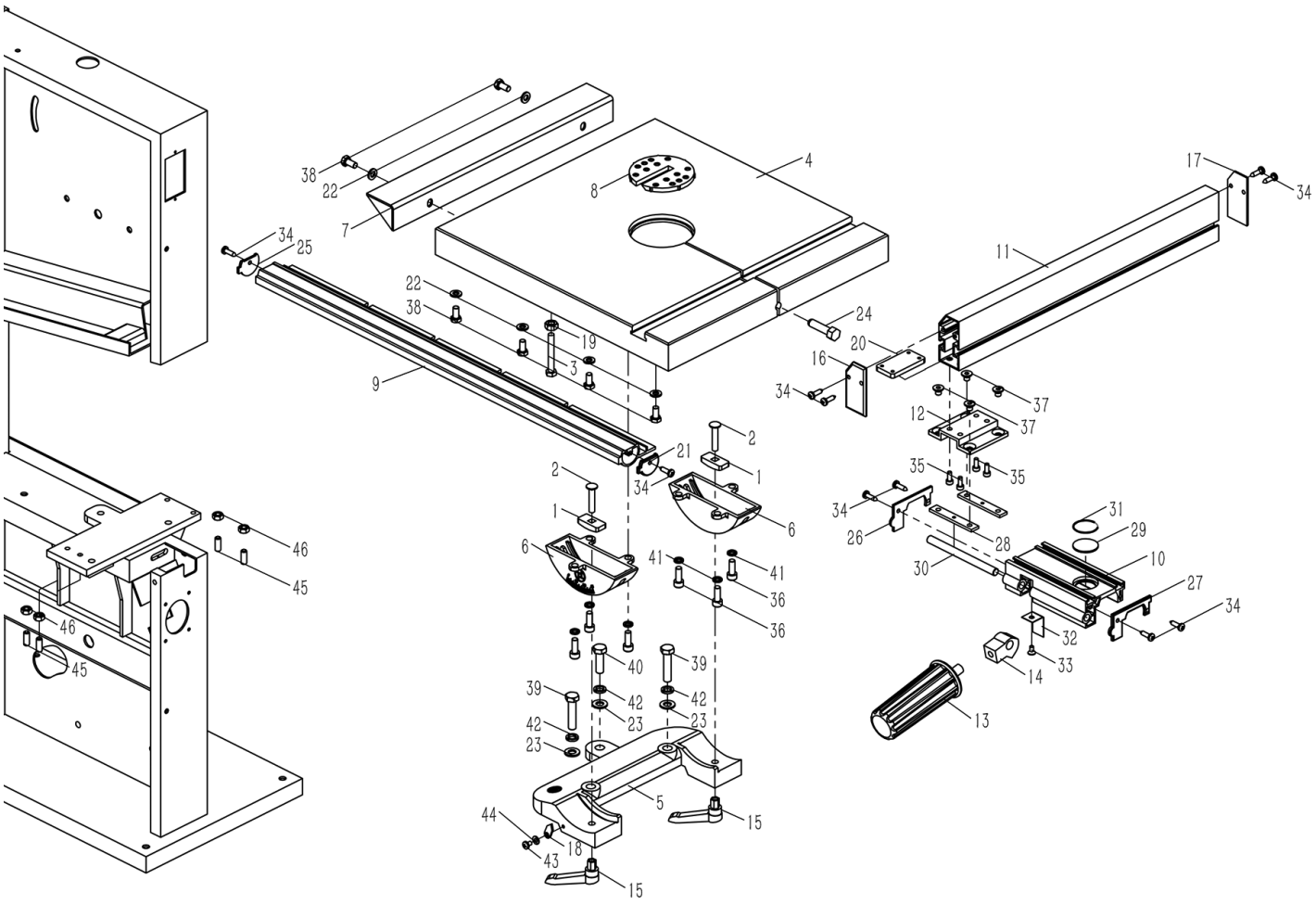
Model AC1950B



No	Description
1	Guide bracket
2	Motor
3	Lower wheel shaft
4	Upper wheel shaft
5	Upper wheel shaft seat
6	Sliding axle bracket
7	Upper wheel sliding axle
8	Spring
9	Strip washer
10	Adjusting nut
11	Adjusting knob
12	Door lock knob
13	Brush
14	Spacer bushing for brush
15	Cover clip
16	Setting knob
17	Lower guide seat
18	Wing nut
19	Bearing 80101
20	Step bolt M8X105
21	Hex.nut M6
22	Micro switch ass'y
23	Power switch
24	Saw blade
25	Upper wheel
26	Lower wheel
27	Upper guide housing
28	Connection seat,upper guide
29	Connection shaft,upper guide
30	Upper guide guard
31	Upper guide guard base
32	Rear thrust ceramic wheel
33	Side guide shaft
34	Guide shaft
35	Hex. socket pan head screw M4X12
36	Cover plate,upper guide guard
37	Sight glass
38	Protection board
39	Cross recessed pan head screw M4X6
40	Cross recessed pan head screw M4X30
41	Cross recessed pan head screw M3X25
42	Cross recessed pan head screw M5X8
43	Cross recessed pan head screw M4X10
44	Pointer bending plate
45	Pointer
46	Dishing cover
47	Spring
48	Adjusting gear wheel,upper guide
49	Adjusting knob,upper guide
50	Wing nut
51	Motor pulley
52	Adjusting rack,upper guide
53	Protection cover,lower guide
54	Saw frame
55	Micro switch ass'y
56	Upper door
57	Lower door
58	Hinge
59	Drive belt
60	Touching plate,micro switch
61	Washer 4
62	Hex.nut M4
63	Hex.nut M3
64	Hex.nut M6
65	Hex.nut M5
66	Hex.nut M14
67	Side extraction adaptor
68	Bottom extraction adaptor
69	Anti-loosening nut M6
70	Washer 3
71	Washer 6
72	Washer 8
73	Push stick hook
74	Hex. socket cap head bolt M5X20
75	Hex. socket cap head bolt M5X10
76	Hex. socket cap head bolt M4X16
77	Hex. socket cap head bolt M5X16
78	Hex. socket cap head bolt M6X12
79	Hex. socket cap head bolt M8X30
80	Pointer screw
81	Cross recessed socket screw M4X14
82	Cross recessed socket screw M3X6
83	Hex.bolt M6X20
84	Hex.bolt M6X16
85	Hex.bolt M6X12
86	Washer 5
87	Washer 8
88	Taping screw ST3.5X10
89	Taping screw ST3.5X13
90	Hex.socket set screw M6X6
91	Self-locking nut M5
92	Self-locking nut M8
93	Step bolt M6X65
94	Step bolt M8X70
95	Circlips for holes 28
96	Circlips for shafts 12
97	Spring washer 8

Parts Breakdown/List

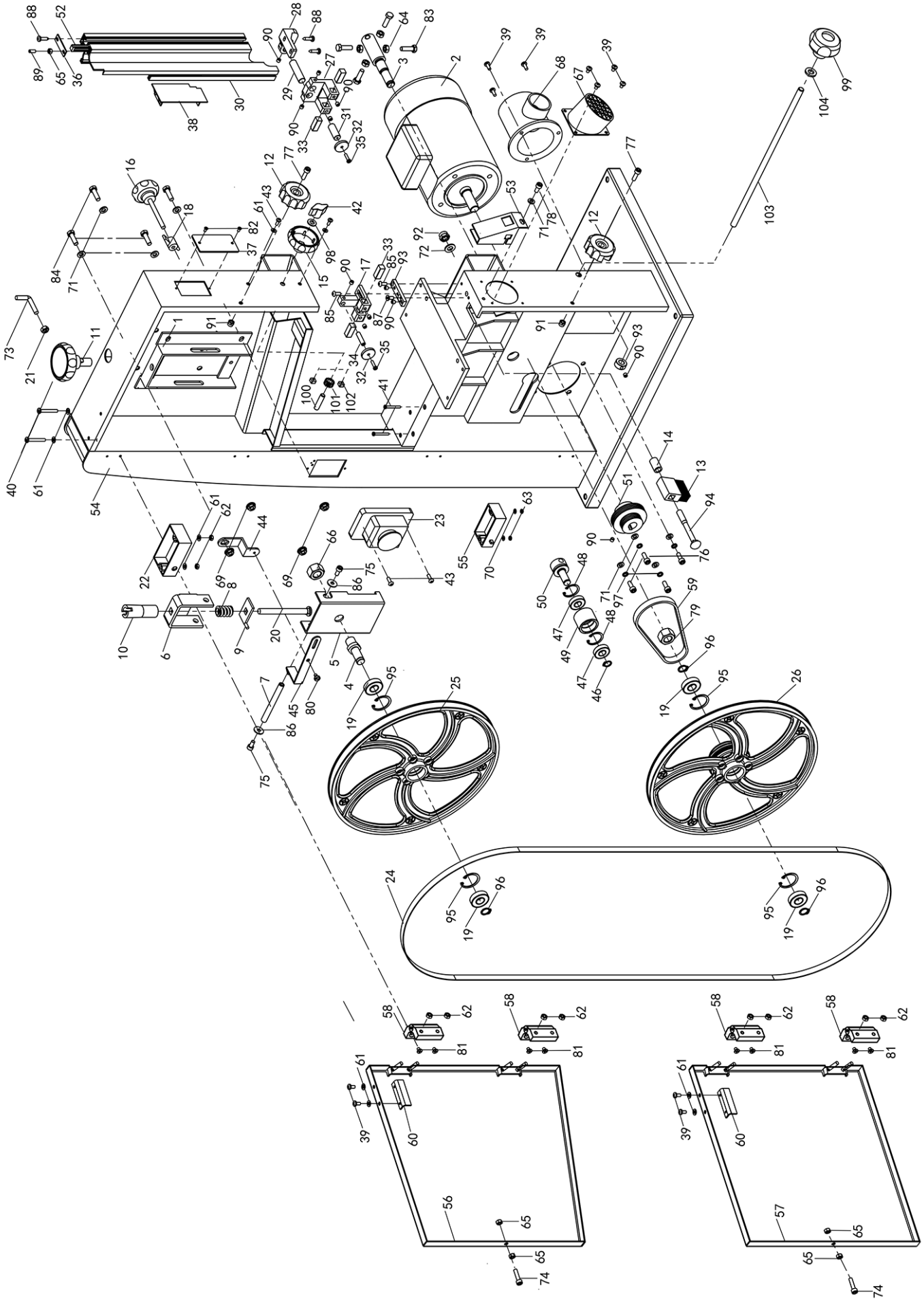
Model AC1950B



No	Description
1	Guide piece
2	Square neck bolt M6X25
3	Hex.bolt M8X45
4	Worktable
5	Mounting base,worktable
6	Rotating base,worktable
7	Extension table
8	Table insert
9	Front rail
10	Fence carrier
11	Rip fence
12	Fence plate
13	Lock handle,fence
14	Eccentric shaft
15	Ratchet lever M6
16	Front cap,fence
17	End cap,fence
18	Pointer
19	Hex.nut M8
20	Screw guide
21	Left cap,front rail
22	Washer 6
23	Washer 8

24	Table pin
25	Right cap,front rail
26	Left cap,fence carrier
27	Right cap,fence carrier
28	Screw guide
29	Pointer
30	Locking shaft,fence carrier
31	Circle ring
32	Lock plate
33	Cross recessed countersunk screw M4X8
34	Cross recessed pan head tapping screw ST4X16
35	Hex.socket cap head screw M4X10
36	Hex.socket cap head screw M6X16
37	Hex.socket countersunk screw M6X8
38	Hex.bolt M6X12
39	Hex.bolt M8X35
40	Hex.bolt M8X25
41	Spring washer 6
42	Spring washer 8
43	Cross recessed countersunk screw M4X6
44	Washer 4
45	Hex.socket set screw M6X20
46	Hex.nut M6

Model AC2305B, AC2606B



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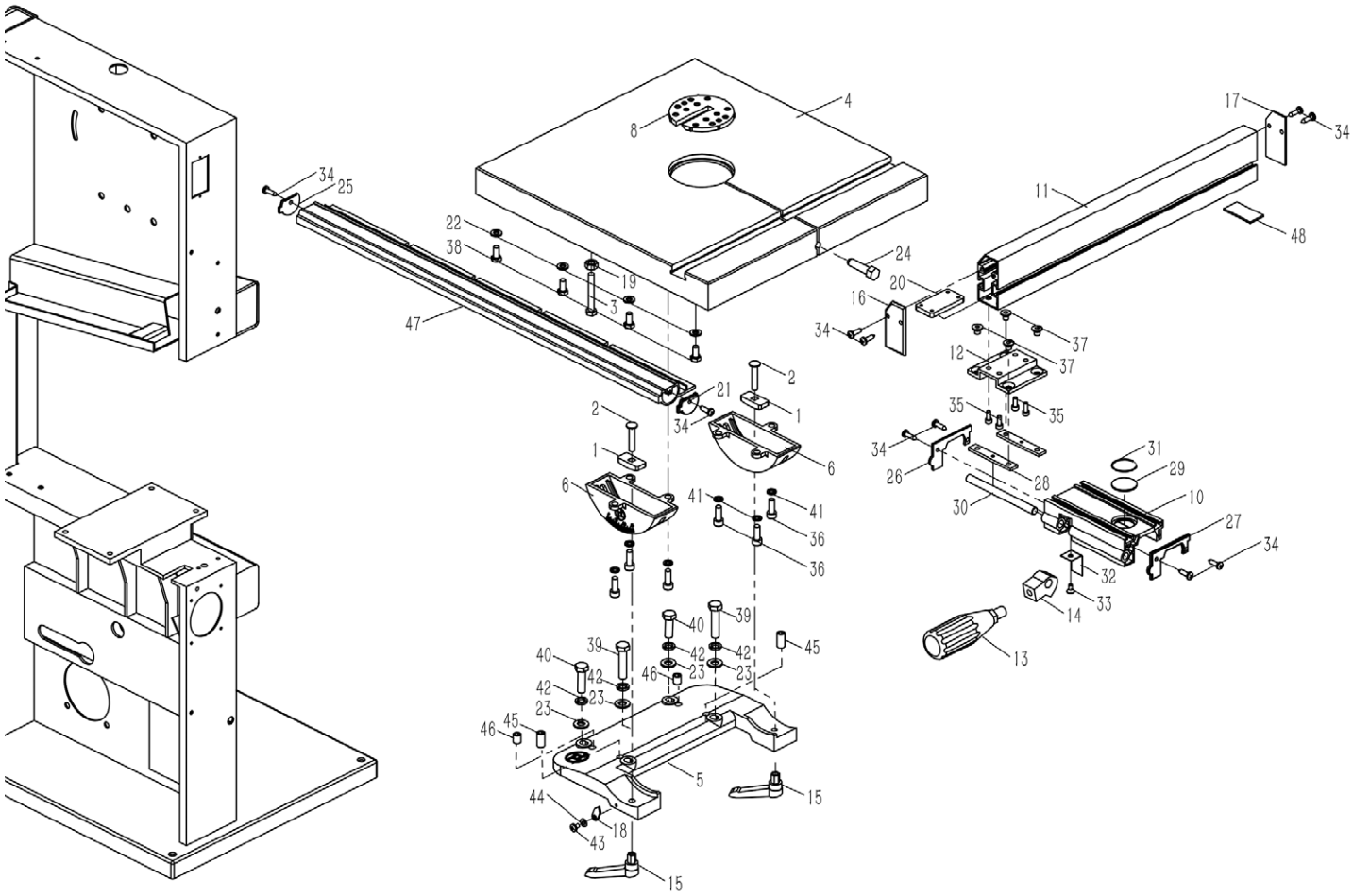
Parts Breakdown/List

No	Description
1	Guide bracket
2	Motor
3	Lower wheel shaft
4	Upper wheel shaft
5	Upper wheel shaft seat
6	Sliding axle bracket
7	Upper wheel sliding axle
8	Spring
9	Strip washer
10	Adjusting nut
11	Adjusting knob
12	Door lock knob
13	Brush
14	Spacer bushing for brush
15	Cover clip
16	Setting knob
17	Lower guide seat
18	Wing nut
19	Bearing 80203
20	Step bolt M8X105
21	Hex.nut M6
22	Micro switch ass'y
23	Power Switch
24	Saw blade
25	upper wheel
26	Lower wheel
27	Upper guide seat
28	Connection seat,upper guide
29	Connection shaft,upper guide
30	Upper guide guard
31	Fixed axis,Upper guide wheel
32	Rear thrust ceramic wheel
33	Side guide shaft
34	Guide shaft
35	Hex. socket pan head screw M4X12
36	Cover plate,upper guide guard
37	Sight glass
38	Protection board
39	Cross recessed pan head screw M4X6
40	Cross recessed pan head screw M4X30
41	Cross recessed pan head screw M3X25
42	Adjusting wing nut
43	Cross recessed pan head screw M4X10
44	Pointer bending plate
45	Pointer
46	Circlips for shafts 12
47	Bearing 80101
48	Circlips for holes 28
49	Tension pulley
50	Shaft for tension pulley
51	Motor pulley
52	Adjusting rack,upper guide
53	Lower guide guard
54	Saw frame
55	Micro switch ass'y
56	Upper door
57	Lower door
58	Hinge
59	Drive belt
60	Touching plate,micro switch
61	Washer 4
62	Hex.nut M4
63	Hex.nut M3
64	Hex.nut M6
65	Hex.nut M5
66	Hex.nut M14
67	Side dust port
68	Bottom dust port
69	Anti-loosening nut M6
70	Washer 3
71	Washer 6
72	Washer 8
73	Push stick hook
74	Hex. socket cap head bolt M5X20
75	Hex. socket cap head bolt M5X10
76	Hex. socket cap head bolt M6X16
77	Hex. socket cap head bolt M5X16
78	Hex. socket cap head bolt M6X12
79	Thin hex.nut M20X1.5
80	Pointer screw
81	Cross recessed socket screw M4X14
82	Cross recessed socket screw M3X6
83	Hex.bolt M6X20
84	Hex.bolt M6X16
85	Hex.bolt M5X12
86	Washer 5
87	Hex.socket countersunk screw M5X12
88	Taping screw ST4.8X19
89	Hex.socket set screw M5X12
90	Hex.socket set screw M6X6
91	Self-locking nut M5
92	Self-locking nut M8
93	Guide board,lower guide seat
94	Step bolt M8X90
95	Circlips for holes 40
96	Circlips for shafts 17
97	Spring washer 6
98	Wing washer 8
99	Adjusting knob
100	Gear shaft
101	Gear wheel,upper guide
102	Position block,cover
103	Belt tension shaft
104	Washer 10
105	Stop collar,belt tension shaft

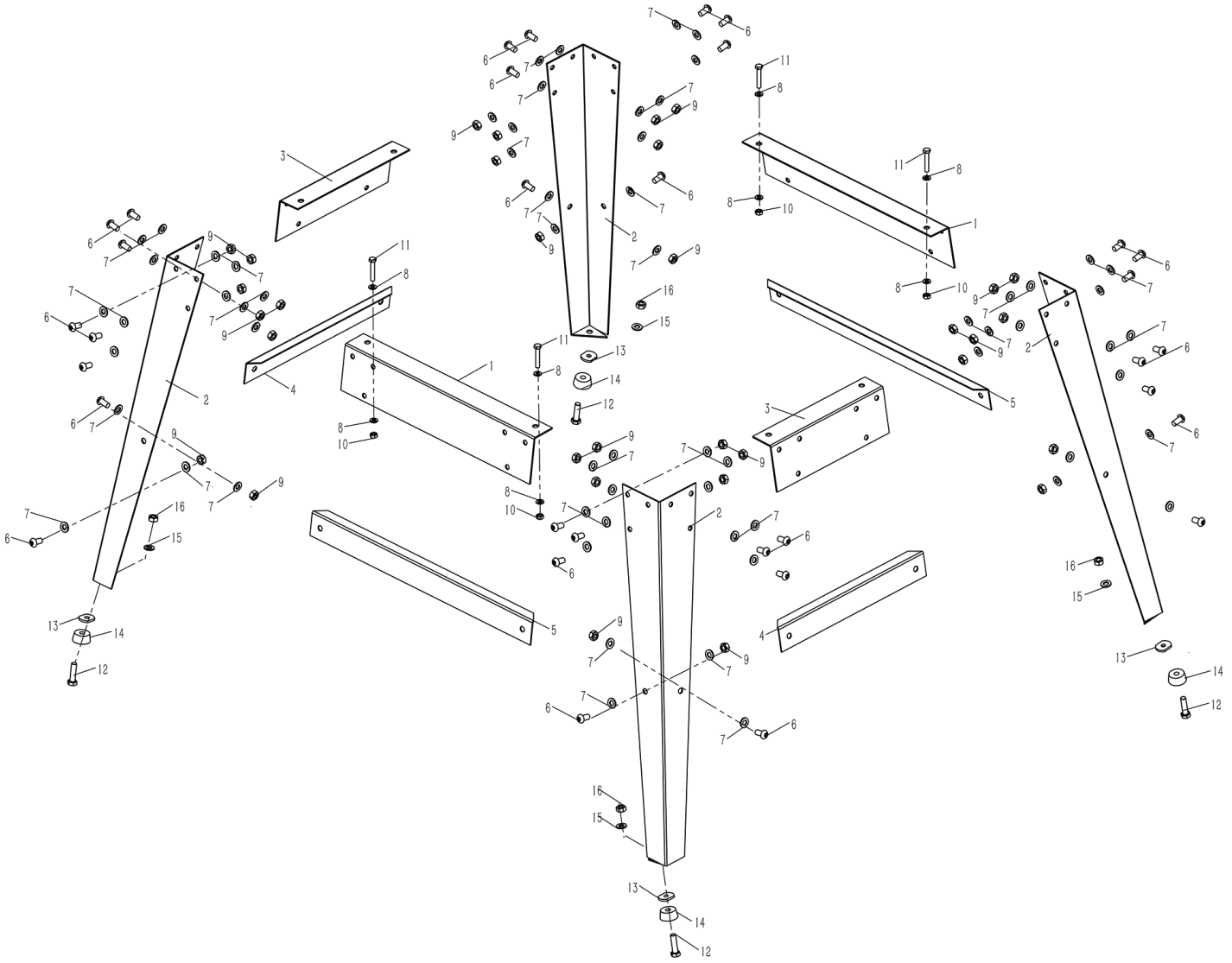
Model AC2305B, AC2606B



No.	Description
1	Guide piece
2	Square neck bolt M6X25
3	Hex.bolt M8X45
4	Worktable
5	Mounting base,worktable
6	Rotating base,worktable
8	Table insert
10	Fence carrier
11	Rip fence
12	Fence plate
13	Lock handle,fence
14	Eccentric shaft
15	Ratchet lever M6
16	Front cap,fence
17	End cap,fence
18	Pointer
19	Hex.nut M8
20	Screw guide
21	Right cap,front rail
22	Washer 8
23	Washer 8
24	Table pin
25	Left cap,front rail
26	Left cap,fence carrier
27	Right cap,fence carrier
28	Screw guide
29	Pointer
30	Locking shaft,fence carrier
31	Circle ring
32	Lock plate
33	Cross recessed countersunk screw M4X8
34	Cross recessed pan head tapping screw ST4X16
35	Hex.socket cap head screw M6X10
36	Hex.socket cap head screw M6X16
37	Hex.socket countersunk screw M6X8
38	Hex.bolt M8X12
39	Hex.bolt M8X35
40	Hex.bolt M8X30
41	Spring washer 6
42	Spring washer 8
43	Cross recessed pan head screw M4X6
44	Washer 4
45	Hex.socket set screw M10X20
46	Hex.socket set screw M10X12
47	Front rail
48	Backing board,rip fence

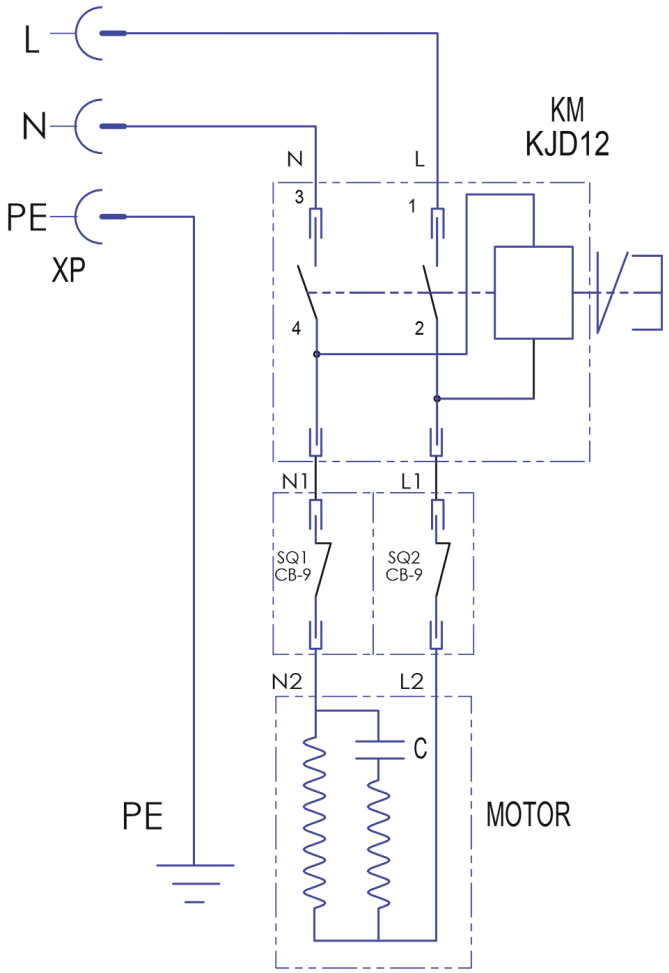
Parts Breakdown/List

Model AC1950B, AC2305B, AC2606B

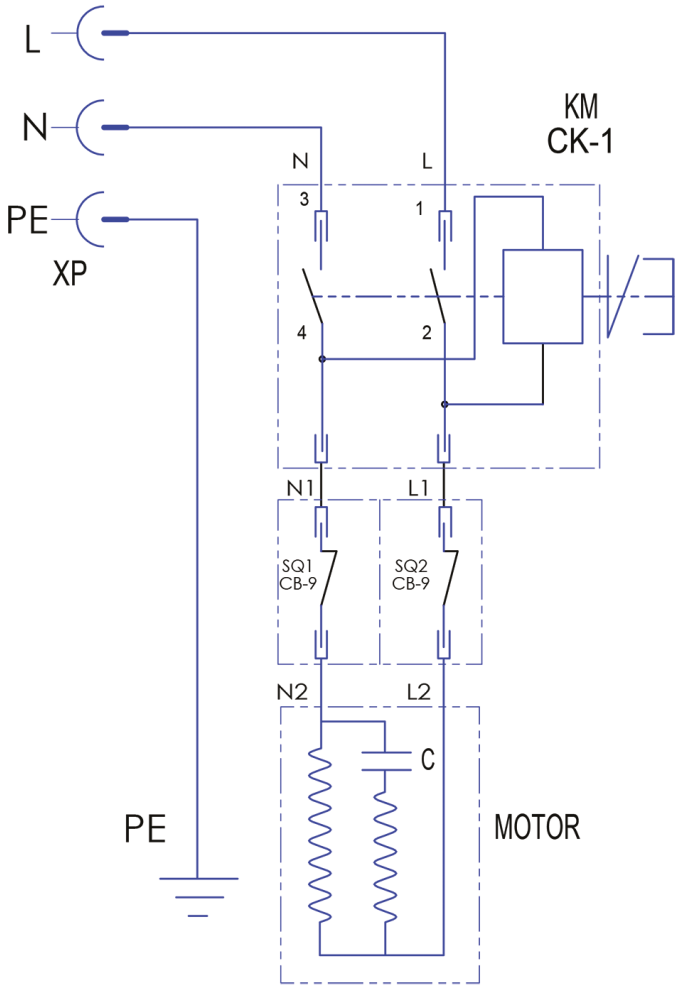


No	Description
1	Upper long bracket
2	Stand leg
3	Upper short bracket
4	Lower short bracket
5	Lower long bracket
6	Hex.socket pan head screw M6X16
7	Washer 8
8	Washer 6
9	Hex.nut M8
10	Hex.nut M6
11	Hex.bolt M6X35
12	Hex.bolt M8X30
13	Gasket nut
14	Rubber mat
15	Washer 8
16	Hex.nut M8

Model AC1950B



Model AC2305B, AC2606B



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