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KAKA INDUSTRIAL 188015

KAKA INDUSTRIAL Horizontal Bandsaw User Manual

Model: BS-1018B
Brand: KAKA INDUSTRIAL

1. Introduction

This manual provides essential information for the safe and efficient operation, setup, and maintenance of your KAKA INDUSTRIAL 10x18-Inch Horizontal Bandsaw. Please read this manual thoroughly before operating the machine to ensure proper use and to prevent injury or damage.
The KAKA INDUSTRIAL Horizontal Bandsaw is designed for precise metal cutting, featuring a robust 2HP 220V motor, 4-speed blade control, and a built-in cooling system for extended blade life and improved cutting performance.

2. Important Safety Instructions

WARNING: Failure to follow these safety instructions may result in serious injury or death.

- Always wear appropriate personal protective equipment (PPE), including safety glasses, hearing protection, and sturdy work gloves.
- Ensure the machine is properly grounded and connected to a 220V, 1-phase power supply.
- Keep the work area clean and well-lit. Cluttered or dark areas invite accidents.
- Do not operate the bandsaw in damp or wet locations, or expose it to rain.
- Keep children and bystanders away while operating the machine.
- Securely clamp all workpieces before cutting. Never hold material by hand.
- Disconnect power before performing any maintenance, adjustments, or blade changes.
- Do not overreach. Maintain proper footing and balance at all times.
- Use only blades recommended for this machine and ensure they are properly tensioned.

3. Components and Features

Familiarize yourself with the various parts of your KAKA INDUSTRIAL Bandsaw.

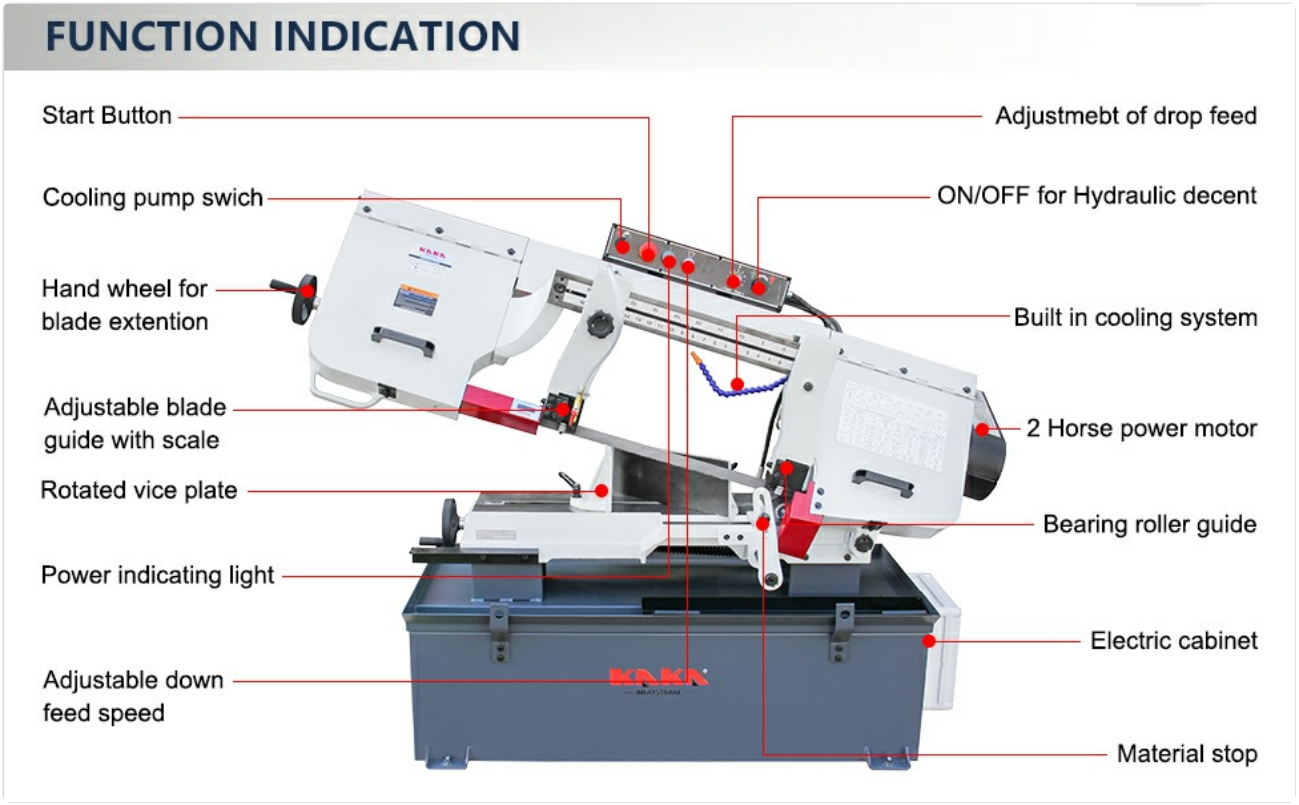


Figure 3.1: Bandsaw Components Overview

This diagram highlights key functional areas including the control panel, blade arm, material vise, and cooling system.



Figure 3.2: Control Panel and Vise Detail

The control panel includes the start button, cooling pump switch, ON/OFF for hydraulic descent, and feed rate adjustment. The quick-release vise ensures secure material clamping.



Figure 3.3: Hydraulic Descent Control

The hydraulic cylinder provides controlled descent of the blade arm for consistent cutting pressure and finish.

4. Setup and Assembly

The KAKA INDUSTRIAL Bandsaw is a heavy machine (approximately 849 lbs). Ensure you have adequate lifting equipment and assistance for unpacking and placement.

1. **Unpacking:** Carefully remove the bandsaw from its packaging. Inspect for any shipping damage. Retain packaging for future transport if needed.
2. **Placement:** Position the bandsaw on a level, stable surface capable of supporting its weight and the weight of the material being cut. Ensure sufficient clearance around the machine for safe operation and material handling.
3. **Power Connection:** Connect the bandsaw to a dedicated 220V, 1-phase power outlet. Verify the voltage matches the machine's requirements.
4. **Blade Installation:** Refer to the detailed instructions provided with your blade for proper installation and tensioning. The quick-release blade system facilitates this process. Ensure the blade teeth are oriented correctly for cutting.

5. **Coolant System Setup:** Fill the coolant reservoir with appropriate metalworking coolant. Ensure the pump and lines are clear and properly connected.

5. Operating Instructions

5.1 Material Compatibility and Speed Selection

The bandsaw is capable of cutting various materials. Selecting the correct blade speed is crucial for efficient cutting and blade longevity.

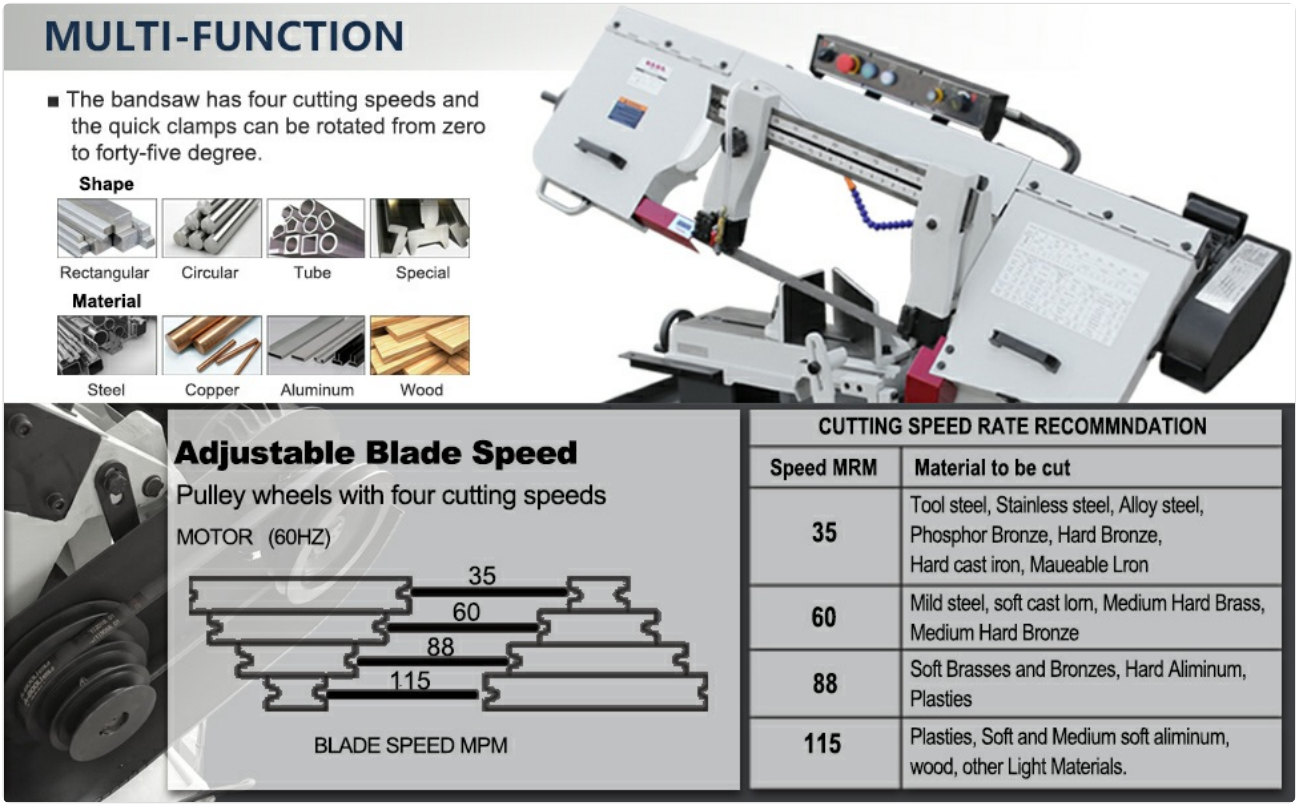


Figure 5.1: Material Types and Cutting Speed Recommendations

This chart provides recommended blade speeds (MPM - Meters Per Minute) for different materials. Adjust the speed using the pulley system.

5.2 Adjusting Blade Speed

The bandsaw features a 4-speed pulley system to adjust blade speed. To change the speed:

1. Disconnect power to the machine.
2. Open the pulley cover.
3. Loosen the motor mount to allow belt adjustment.
4. Move the drive belt to the desired pulley combination as indicated by the speed chart (Figure 5.2).
5. Tighten the motor mount and close the pulley cover.

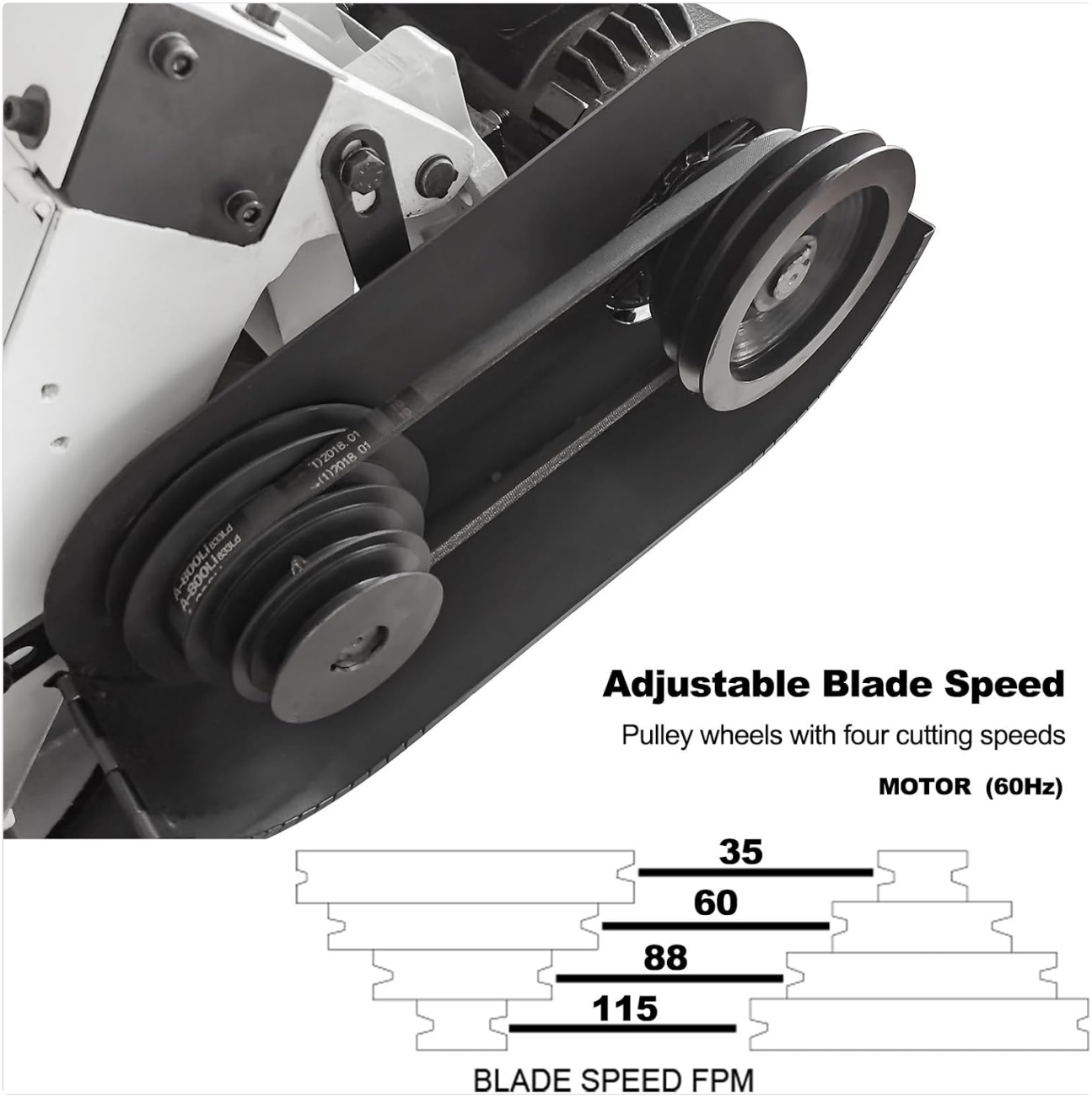


Figure 5.2: 60Hz Motor Blade Speed Diagram

This diagram shows the belt configurations for achieving 35, 60, 88, and 115 FPM (Feet Per Minute) blade speeds.

5.3 Cutting Operation

1. **Prepare Material:** Mark the cutting line on your workpiece.
2. **Secure Workpiece:** Place the material in the vise and tighten the quick-release clamp securely. Ensure the material is stable and will not shift during cutting. The vise can be rotated for angle cuts up to 45 degrees.
3. **Set Blade Speed:** Adjust the blade speed according to the material being cut (refer to Section 5.1).
4. **Start Machine:** Press the green start button on the control panel. Turn on the cooling pump switch.
5. **Engage Cut:** Slowly lower the blade arm using the hydraulic descent control. Adjust the feed rate knob to control the cutting speed. Do not force the cut; allow the blade to cut at its own rate.
6. **Complete Cut:** Once the cut is complete, the machine may have an automatic shut-off feature. Raise the blade arm to its upright position.
7. **Remove Material:** Release the vise and carefully remove the cut material.

6. Maintenance

Regular maintenance ensures the longevity and optimal performance of your bandsaw.

- **Cleaning:** After each use, clean metal chips and debris from the machine, especially around the blade guides, vise, and coolant tray.
- **Coolant System:** Regularly check the coolant level and replenish as needed. Clean the coolant filter and reservoir periodically to prevent clogging and maintain coolant effectiveness.
- **Blade Inspection:** Inspect the blade for wear, damage, or dullness before each use. Replace dull or damaged blades promptly.
- **Blade Guides:** Check the blade guides for wear and proper adjustment. Misaligned or worn guides can lead to inaccurate cuts and premature blade wear.
- **Lubrication:** Lubricate moving parts as indicated in the machine's lubrication points. Refer to the machine's specific lubrication schedule.
- **Belt Tension:** Periodically check the tension of the drive belts and adjust if necessary to prevent slippage.

7. Troubleshooting

This section addresses common issues you might encounter with your bandsaw.

Problem	Possible Cause	Solution
Blade not cutting straight	Dull blade, incorrect blade tension, worn blade guides, improper feed rate.	Replace blade, adjust blade tension, inspect/adjust/replace blade guides, reduce feed rate.
Motor not starting	No power, emergency stop engaged, motor overload.	Check power connection/breaker, disengage emergency stop, allow motor to cool.
Excessive vibration/noise	Loose components, worn bearings, incorrect blade tension, damaged blade.	Tighten all fasteners, inspect/replace bearings, adjust blade tension, replace blade.
Coolant not flowing	Low coolant level, clogged filter/pump, pump malfunction.	Refill coolant, clean filter/lines, check pump operation.
Hydraulic descent inconsistent	Low hydraulic fluid, air in system, worn cylinder seals.	Check fluid level, bleed air from system, contact service for seal replacement.

8. Technical Specifications

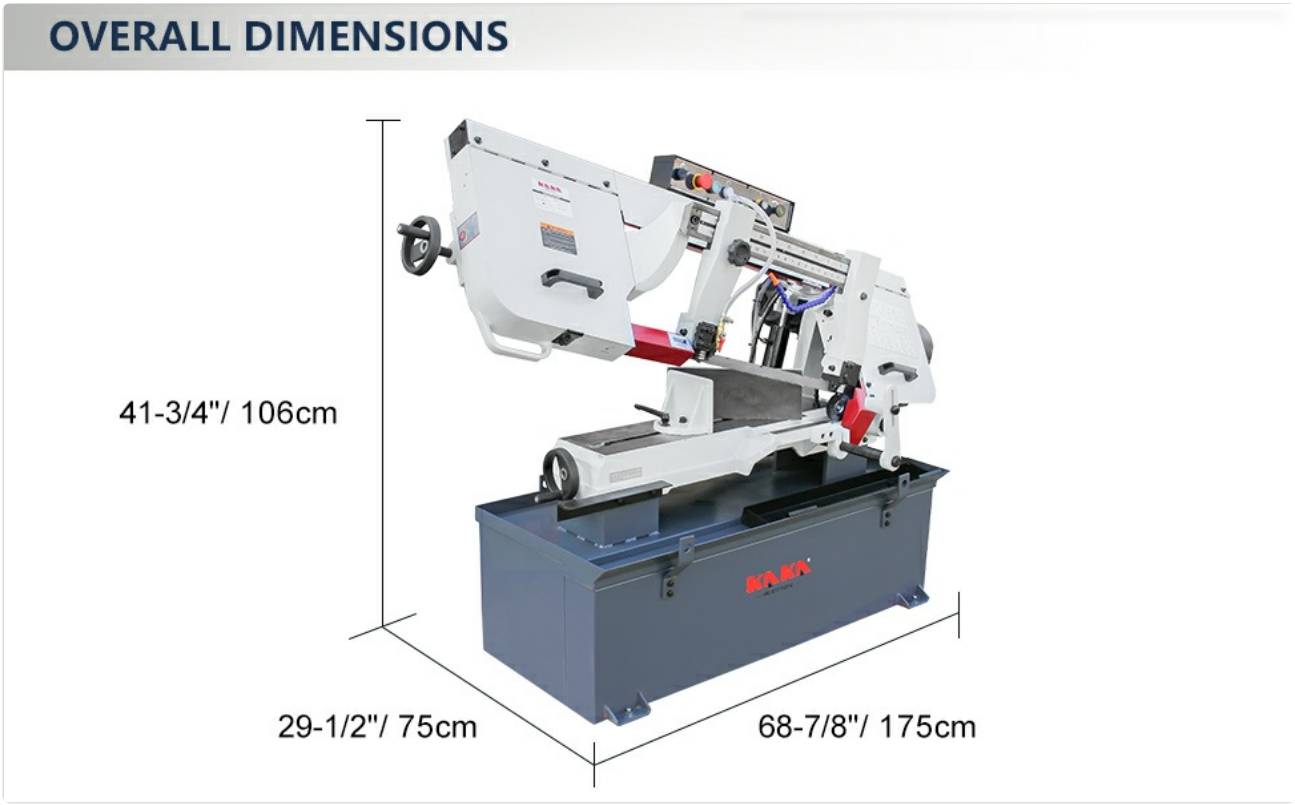


Figure 8.1: Overall Dimensions

Dimensions are approximately 69"L x 30"W x 41"H.

Specification	Value
Model Number	188015 (BS-1018B)
Motor	2 HP, 220V, 1-Phase, 60Hz
Cutting Capacity (Rectangular)	10" x 18"
Cutting Capacity (Round)	10"
Blade Speeds	35, 60, 88, 115 FPM (Feet Per Minute)
Blade Length	129 Inches
Blade Material	Bi-metal
Vise Angle	0-45 Degrees
Item Weight	849 Pounds
Product Dimensions	69"L x 30"W x 41"H
Special Features	Built-in cooling system, Hydraulic descent control, Pulley wheel driven

9. Warranty and Customer Support

This KAKA INDUSTRIAL Bandsaw comes with a manufacturer's warranty. For specific details regarding warranty coverage, duration, and terms, please refer to the warranty card included with your purchase or contact KAKA INDUSTRIAL LLC directly.

For technical assistance, parts, or service inquiries, please contact KAKA INDUSTRIAL LLC customer support. Provide your model number (BS-1018B or 188015) and purchase date when contacting support to expedite

assistance.

KAKA INDUSTRIAL LLC Contact Information:

Please refer to the official KAKA INDUSTRIAL website or your purchase documentation for the most current contact details.

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