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KAKA INDUSTRIAL BS-712N

KAKA INDUSTRIAL BS-712N Horizontal Metal Cutting Bandsaw Instruction Manual

Model: BS-712N | Brand: KAKA INDUSTRIAL

1. Introduction

This manual provides essential instructions for the safe operation, setup, maintenance, and troubleshooting of your KAKA INDUSTRIAL BS-712N Horizontal Metal Cutting Bandsaw. Please read this manual thoroughly before operating the machine to ensure proper use and to prevent injury or damage.

The KAKA INDUSTRIAL BS-712N is a robust metal cutting bandsaw designed for precision cutting of various metal materials, including steel, pipe, structural aluminum, and more. It features a 1.5HP dual voltage motor, four adjustable blade speeds, and a hydraulic feed system for efficient and accurate cuts.



Figure 1: KAKA INDUSTRIAL BS-712N Horizontal Metal Cutting Bandsaw. This image displays the complete bandsaw unit, highlighting its robust construction and primary components.

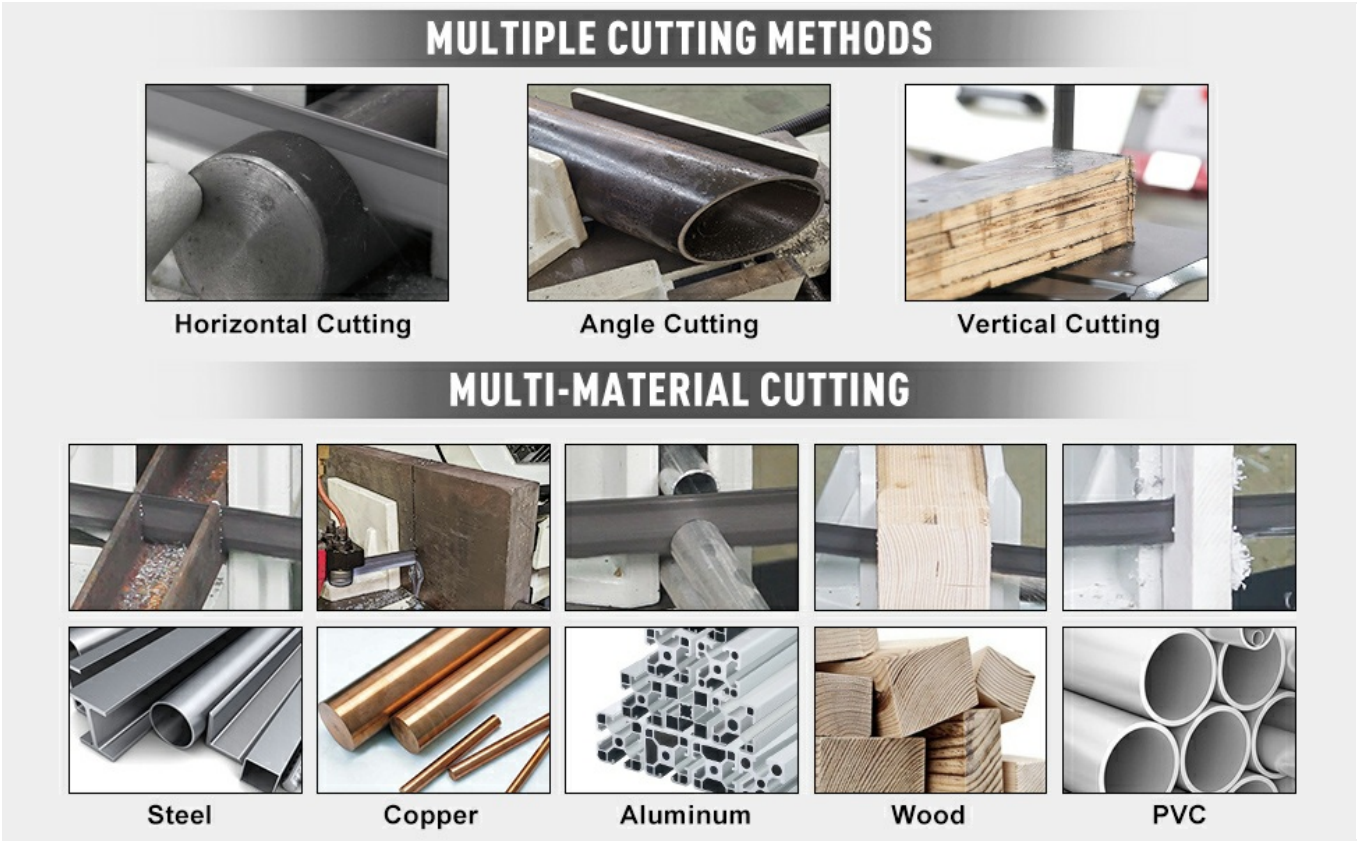

Figure 2: Multiple applications for the KAKA INDUSTRIAL BS-712N bandsaw. This image illustrates various environments where the bandsaw can be utilized, including metalworking shops, automotive repair shops, home garages, and construction sites.

2. Safety Instructions

Always prioritize safety when operating any machinery. Failure to follow these safety guidelines can result in serious injury or death.

2.1 General Safety Warnings

- **Read the Manual:** Understand all instructions and warnings before operation.
- **Personal Protective Equipment (PPE):** Always wear safety glasses, hearing protection, and appropriate work gloves. Avoid loose clothing, jewelry, and long hair that can get caught in moving parts.
- **Work Area:** Keep the work area clean, well-lit, and free from obstructions. Ensure adequate space around the machine.
- **Electrical Safety:** Ensure the machine is properly grounded. Do not operate in damp or wet conditions. Verify voltage matches machine requirements (115V/230V).
- **Unauthorized Use:** Do not allow untrained personnel to operate the bandsaw. Keep children and bystanders at a safe distance.
- **Machine Stability:** Ensure the bandsaw is stable and secured before operation. The machine is heavy (approximately 400 lbs); use appropriate lifting equipment or assistance during setup and relocation.
- **Emergency Stop:** Familiarize yourself with the location and operation of the emergency stop button.

2.2 Operational Safety

- **Material Clamping:** Always securely clamp the workpiece in the vise before cutting. Never attempt to hold material by hand.
- **Blade Inspection:** Before each use, inspect the blade for damage, dullness, or cracks. Replace damaged blades immediately.
- **Blade Guards:** Ensure all blade guards are in place and properly adjusted before starting the machine.
- **Coolant System:** Verify the coolant system is functioning correctly to extend blade life and reduce heat.

- **Automatic Shut-off:** The machine is equipped with an automatic shut-off feature. Do not bypass or tamper with this safety mechanism.
- **Adjustments:** Never make adjustments to the machine while it is running. Disconnect power before performing maintenance or adjustments.

3. Setup and Assembly

3.1 Unpacking and Placement

The bandsaw is shipped in a protective crate and weighs approximately 400 lbs. A lift gate service or multiple individuals/equipment will be required for safe unloading and placement. Carefully remove all packaging materials and inspect the machine for any shipping damage. Place the bandsaw on a level, stable surface capable of supporting its weight and the weight of the material being cut.

3.2 Electrical Connection

The BS-712N operates on dual voltage (115V/230V). Ensure the machine is configured for your power supply before connecting. Consult a qualified electrician if you are unsure about the correct wiring or voltage conversion. Always ensure the machine is properly grounded.

3.3 Blade Installation and Tensioning

Refer to the blade tensioning guide on the machine for proper tension settings. Incorrect blade tension can lead to poor cut quality or blade breakage. Ensure the blade teeth are pointing in the correct cutting direction.

3.4 Coolant System Setup

Fill the coolant reservoir with appropriate metalworking coolant. Ensure the pump and lines are clear and functioning. The coolant system helps to lubricate the blade, dissipate heat, and flush chips away from the cutting area.



Figure 3: Detailed view of the BS-712N bandsaw components. This image highlights key features such as the roller guide block, rotatable clamp vise, built-in coolant system, powerful motor, hydraulic down feed control, and stable base with foot wheels.

4. Operation

4.1 Material Preparation and Clamping

Measure and mark your workpiece accurately. Place the material securely in the vise. The BS-712N features quick clamps for efficient material securing. Ensure the material is stable and will not shift during the cut.



Figure 4: Measuring material on the bandsaw vise. This image shows a large circular metal piece clamped in the vise, with a measuring tape indicating its diameter, demonstrating the machine's capacity.

4.2 Blade Speed Selection

Select the appropriate blade speed based on the material type and thickness. The BS-712N offers four cutting speeds (e.g., 80-260 FPM) to optimize cutting efficiency and blade life. Consult the speed chart located on the machine for guidance.

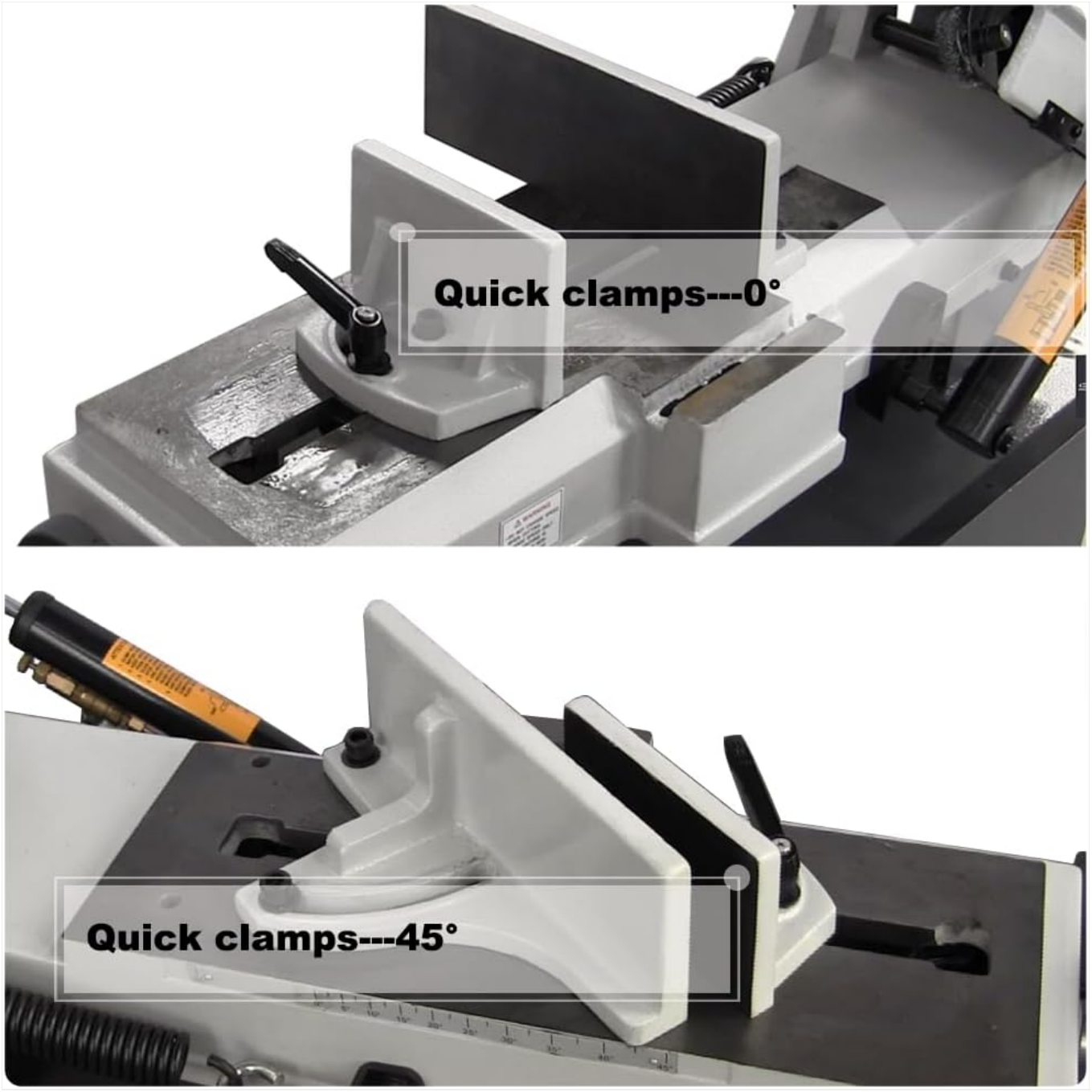

Figure 5: Bandsaw blade speed chart and pulley system. This image displays the internal pulley mechanism and a label indicating four different blade speeds (FPM) for various motor (60Hz) configurations.

4.3 Cutting Procedures

The BS-712N supports horizontal, vertical, and angle cutting operations.

- **Horizontal Cutting:** For standard straight cuts, ensure the saw head is locked in the horizontal position.
- **Angle Cutting:** The swivel base allows for angled cuts from 0° to 45°. Adjust the vise to the desired angle and secure it before cutting.
- **Vertical Cutting:** The saw head can be raised to a vertical position for contour cutting or other vertical applications. A separate workbench attachment is used for this mode.



Figure 6: Close-up of bandsaw cutting round metal stock. This image shows the blade actively cutting through a solid cylindrical metal piece, demonstrating the machine's cutting action.

Adjustable Blade Speed

Pulley wheels with four cutting speeds



Figure 7: Close-up of bandsaw cutting metal pipe. This image illustrates the blade cutting through a hollow metal pipe, showcasing its capability for tubular materials.

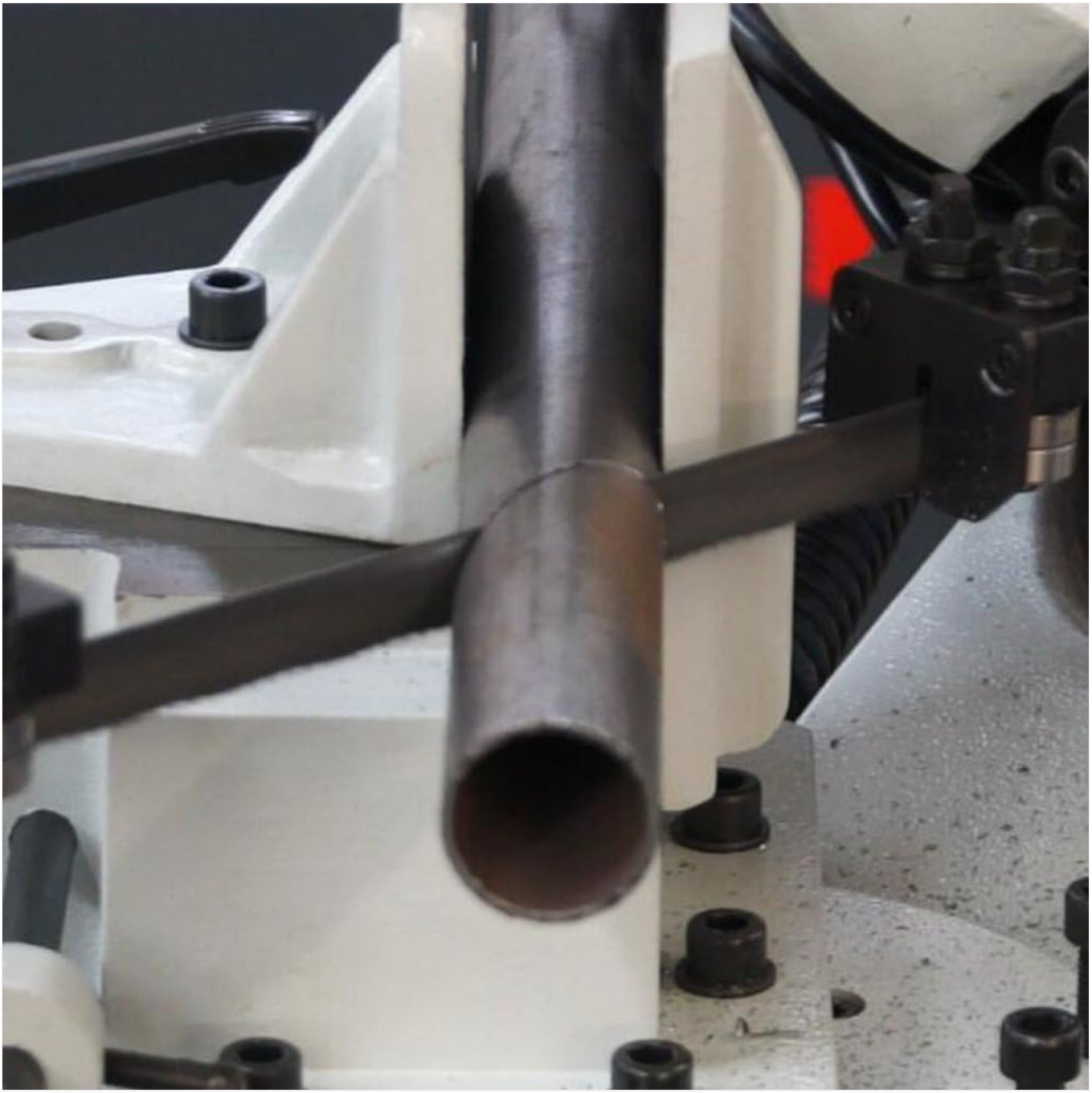

Figure 8: Bandsaw quick clamps at 0 and 45 degrees. This composite image shows the quick clamp mechanism adjusted for a straight (0°) cut and an angled (45°) cut, demonstrating the versatility of the vise.

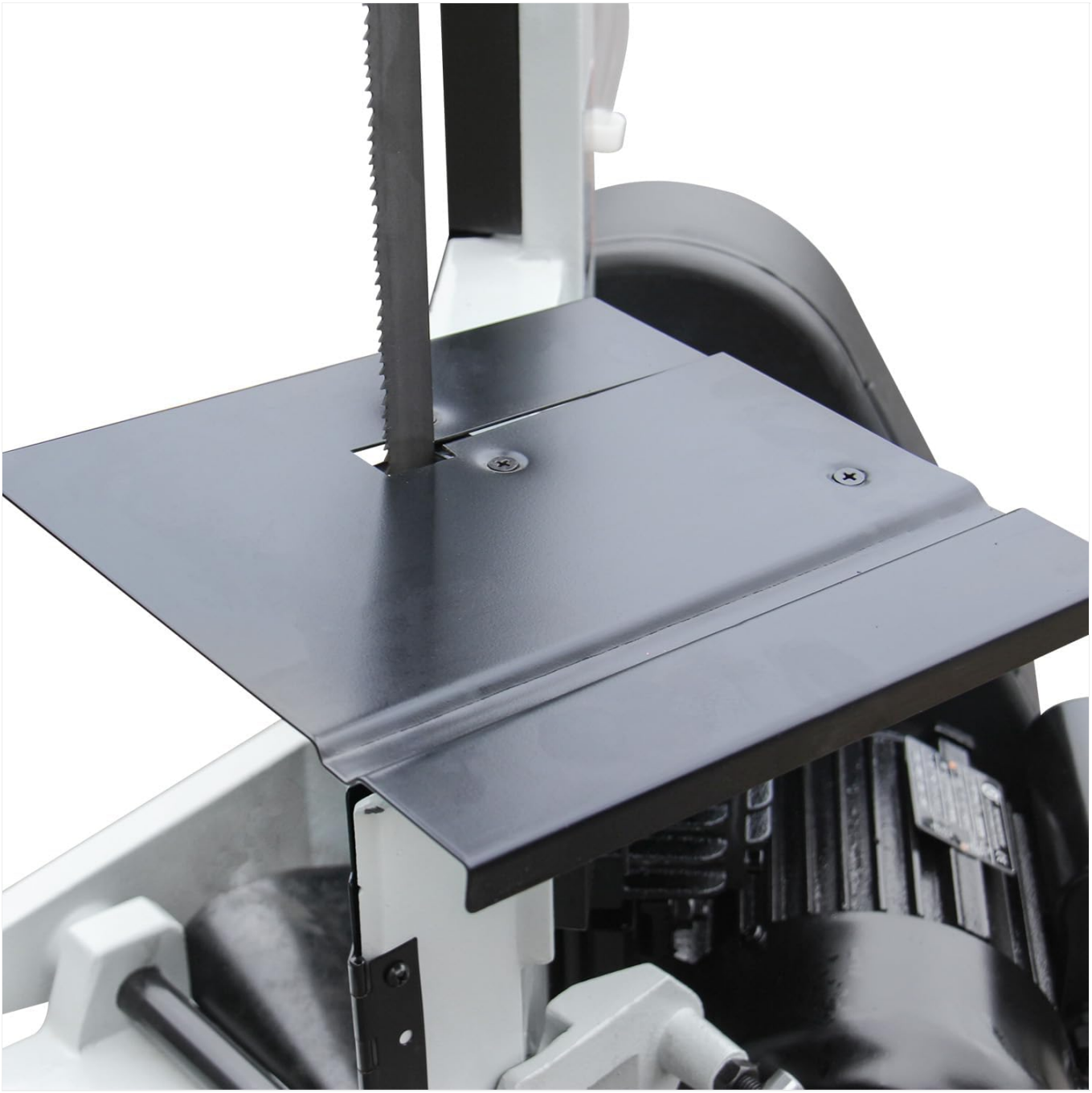

Figure 9: KAKA INDUSTRIAL BS-712N bandsaw in vertical cutting position. This image shows the bandsaw head raised to allow for vertical cutting operations, with a small workbench attached.

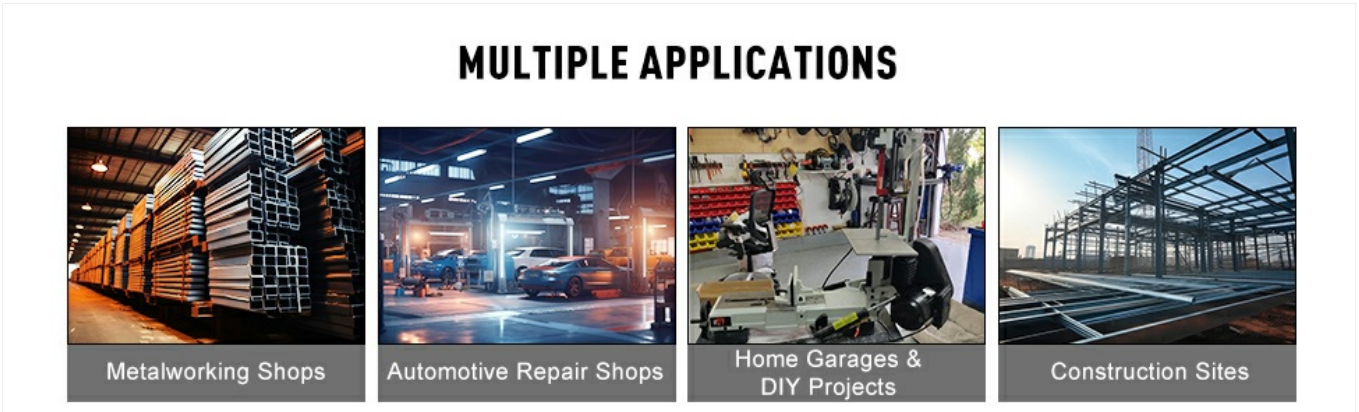

Figure 10: Multiple cutting methods for the KAKA INDUSTRIAL BS-712N bandsaw. This image displays examples of horizontal cutting, angle cutting, and vertical cutting, along with various materials that can be cut, including steel, copper, aluminum, wood, and PVC.

4.4 Hydraulic Feed Adjustment

The hydraulic feed control allows for steady and consistent blade pressure during the cut. Adjust the feed rate according to the material hardness and desired cutting speed. A slower feed rate is generally recommended for harder materials to prevent blade damage and ensure a clean cut.

5. Maintenance

Regular maintenance is crucial for the longevity and optimal performance of your bandsaw. Always disconnect power before performing any maintenance.

5.1 Blade Replacement

- Replace blades when they become dull, damaged, or show signs of wear.
- Follow the blade installation instructions carefully, ensuring correct tension and tooth direction.
- Use only blades of the specified length (92 inches) and type (High Speed Steel).

5.2 Coolant System Maintenance

- Regularly check and replenish the coolant level.
- Clean the coolant reservoir and filter periodically to prevent clogging and maintain coolant effectiveness.
- Use hydraulic oil for the pump if SAE30 oil proves too thick, as noted by some users.

5.3 General Cleaning and Lubrication

- Keep the machine clean from metal chips and debris.
- Lubricate moving parts as recommended in the full product manual to ensure smooth operation.

6. Troubleshooting

This section addresses common issues you might encounter. For problems not listed here, contact KAKA INDUSTRIAL customer support.

Problem	Possible Cause	Solution
Machine does not start	No power, emergency stop engaged, faulty wiring.	Check power connection, release emergency stop, inspect wiring (consult electrician if needed).
Poor cut quality (uneven, rough)	Dull blade, incorrect blade tension, wrong blade speed, improper material clamping.	Replace blade, adjust blade tension, select correct speed, re-clamp material securely.
Blade breakage	Incorrect blade tension, excessive feed pressure, wrong blade type for material.	Adjust blade tension, reduce hydraulic feed rate, ensure correct blade for material.
Coolant not flowing	Low coolant level, clogged pump/lines, incorrect coolant type.	Refill coolant, clean pump/lines, use recommended coolant.
Hydraulic feed issues (too fast/slow)	Incorrect adjustment, air in system, wrong hydraulic fluid.	Adjust hydraulic control, bleed air from system, use recommended hydraulic fluid.

7. Specifications

Feature	Detail

Feature	Detail
Model	BS-712N
Motor	1.5 HP (1100 watts)
Voltage	115V/230V Dual Voltage
Blade Speeds	4 Speeds (e.g., 80, 132, 178, 260 FPM)
Blade Length	92 Inches
Blade Material	High Speed Steel
Cutting Capacity (Circular @ 90°)	7 inches (178 mm)
Cutting Capacity (Rectangular @ 90°)	7" x 12" (178 x 305 mm)
Cutting Capacity (Circular @ 45°)	5 inches (127 mm)
Cutting Capacity (Rectangular @ 45°)	4.75" x 4.88" (120 x 125 mm)
Cutting Angle	0 to 45 Degrees (Swivel Base)
Feed Type	Hydraulic
Product Dimensions (L x W x H)	47.24" x 17.72" x 41.34"
Item Weight	400 Pounds
Included Components	Bag (likely for accessories/manual)



Figure 11: Bandsaw cutting capacity diagram. This image visually represents the maximum circular and rectangular cutting capacities at both 90° and 45° angles, along with examples of cut materials.

8. Warranty and Support

The KAKA INDUSTRIAL BS-712N Bandsaw comes with a limited warranty. For specific warranty terms and conditions, please refer to the documentation included with your purchase or contact KAKA INDUSTRIAL customer service directly. For technical assistance, parts, or service inquiries, please reach out to the manufacturer's support channels.

Manufacturer: KAKA INDUSTRIAL LLC

Contact: Refer to the official KAKA INDUSTRIAL website or your purchase documentation for current contact information.

Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question and use this page's manual context to help answer it.

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