KAKA INDUSTRIAL BS-108G

KAKA INDUSTRIAL BS-108G Horizontal Metal Band Saw Instruction Manual

Model: BS-108G
Brand: KAKA INDUSTRIAL

1. Introduction

This manual provides essential information for the safe operation, maintenance, and setup of your KAKA INDUSTRIAL BS-108G Horizontal Metal Band Saw. Please read this manual thoroughly before operating the machine to ensure proper use and to prevent injury or damage. This horizontal metal band saw is designed for precise cutting of various metal materials, featuring a 10 inch x 7.9 inch cutting capacity, 60° miter angle, and a 1.5HP 115V motor suitable for steel and aluminum fabrication.



Figure 1: Overview of the KAKA INDUSTRIAL BS-108G Horizontal Metal Band Saw.

2. Safety Instructions

Always prioritize safety when operating any power tool. Failure to follow these instructions may result in serious injury or property damage.

- **Read the Entire Manual:** Understand all operating procedures and safety warnings before use.
- **Wear Personal Protective Equipment (PPE):** Always wear safety glasses, hearing protection, and appropriate work

gloves. Avoid loose clothing or jewelry that could get caught in moving parts.

- **Ensure a Safe Work Area:** Keep the work area clean, well-lit, and free from obstructions. Do not operate in damp or wet conditions.
- **Secure Workpiece:** Always ensure the material is securely clamped in the vise before cutting to prevent movement and kickback.
- **Blade Safety:** Never touch the blade while the machine is running. Ensure the blade guard is in place. The machine features an automatic shutoff when the rear guard opens during operation.
- **Electrical Safety:** Ensure the power source matches the machine's requirements (115V). Do not operate with damaged cords or plugs.
- **Maintenance:** Disconnect power before performing any maintenance, adjustments, or blade changes.
- **Supervision:** Never leave the machine unattended while it is running. Keep children and unauthorized personnel away from the operating area.

3. Setup

This section outlines the initial steps for setting up your band saw.

3.1 Unpacking and Placement

Carefully unpack the band saw and inspect for any shipping damage. The unit is heavy; use appropriate lifting equipment or assistance. The detachable stand allows for flexible placement in various workshop environments.

3.2 Power Connection

Connect the machine to a 115V power supply. Ensure the circuit can handle the 1.5HP motor load.

3.3 Blade Installation and Tension

Install the band saw blade according to the markings, ensuring the teeth are oriented correctly for cutting. Adjust the blade tension to the recommended setting for optimal performance and blade life.

3.4 Coolant System Setup

Fill the coolant reservoir with appropriate metalworking coolant. Ensure all hoses and nozzles are securely connected and positioned to deliver coolant to the cutting area.



Figure 2: Band saw ready for operation with material positioned.

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Video 1: Overview of the KAKA INDUSTRIAL 9 Inch Horizontal Metal Cutting Band Saw, demonstrating key features and setup (relevant to BS-108G operation).

4. Operating Instructions

Follow these steps for safe and effective operation of your band saw.

4.1 Miter Cutting

The saw bow can rotate from 0° to 60° for miter cuts. Use the engraved angle scale to set the desired angle. The calibrated vise jaws allow for quick and precise angle adjustments.

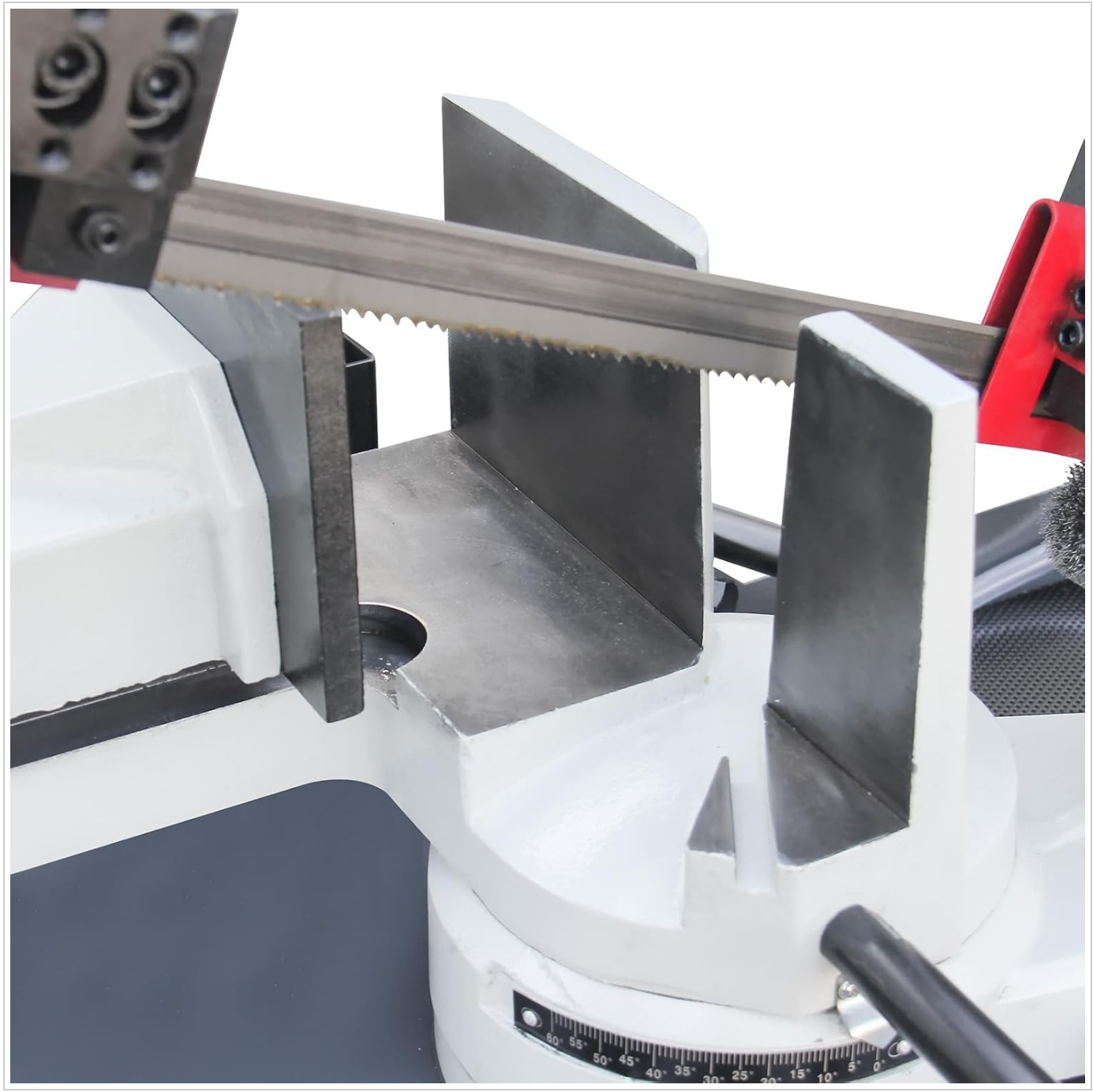


Figure 3: Miter angle scale for precise angle adjustments.

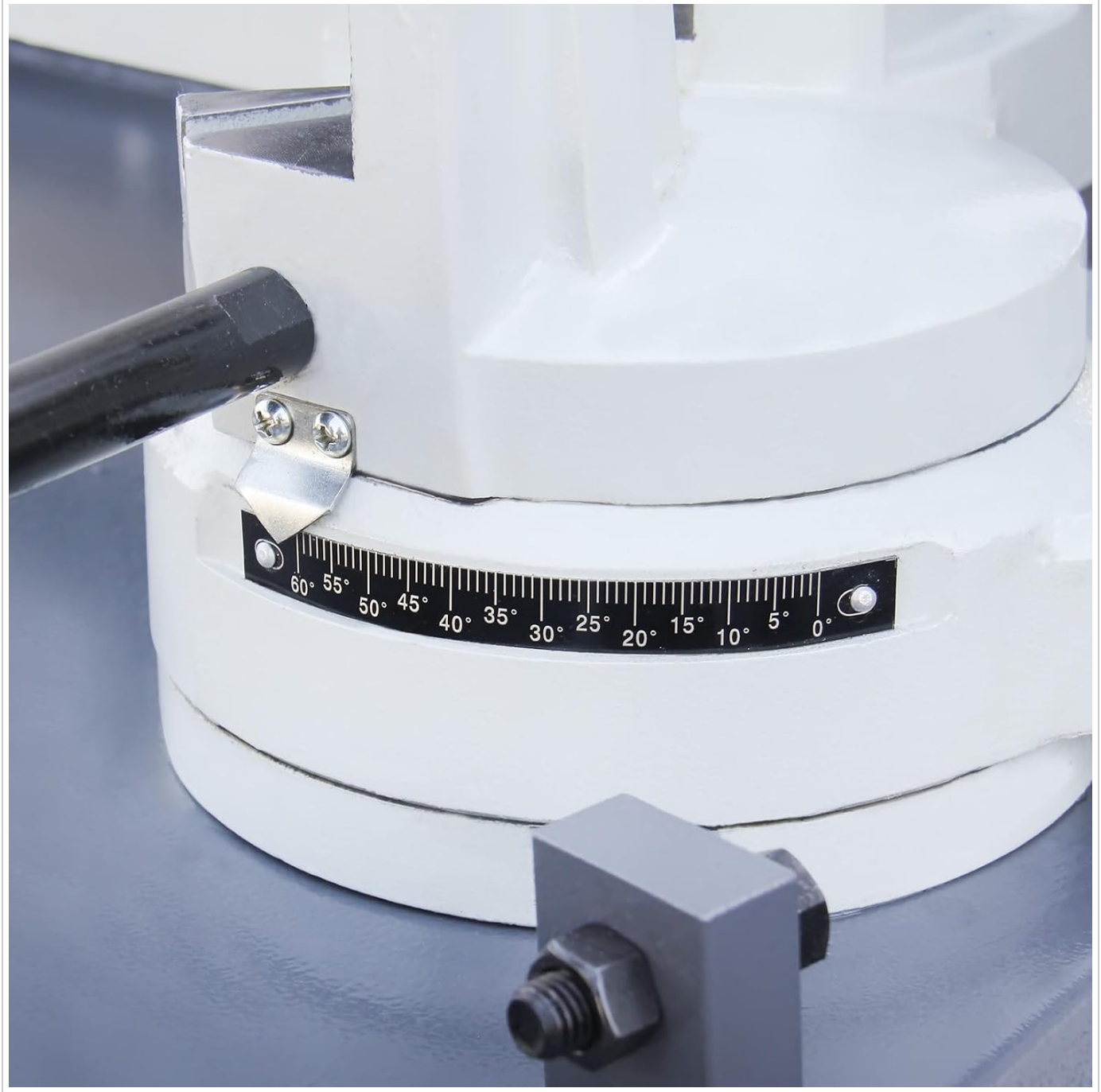


Figure 4: Detailed view of the miter angle settings.

4.2 Vise Operation and Material Clamping

The rapid-adjust vise allows for quick positioning and secure clamping of various material shapes, including I-beams. Use the dual clamping bolts to ensure no slippage during cutting.

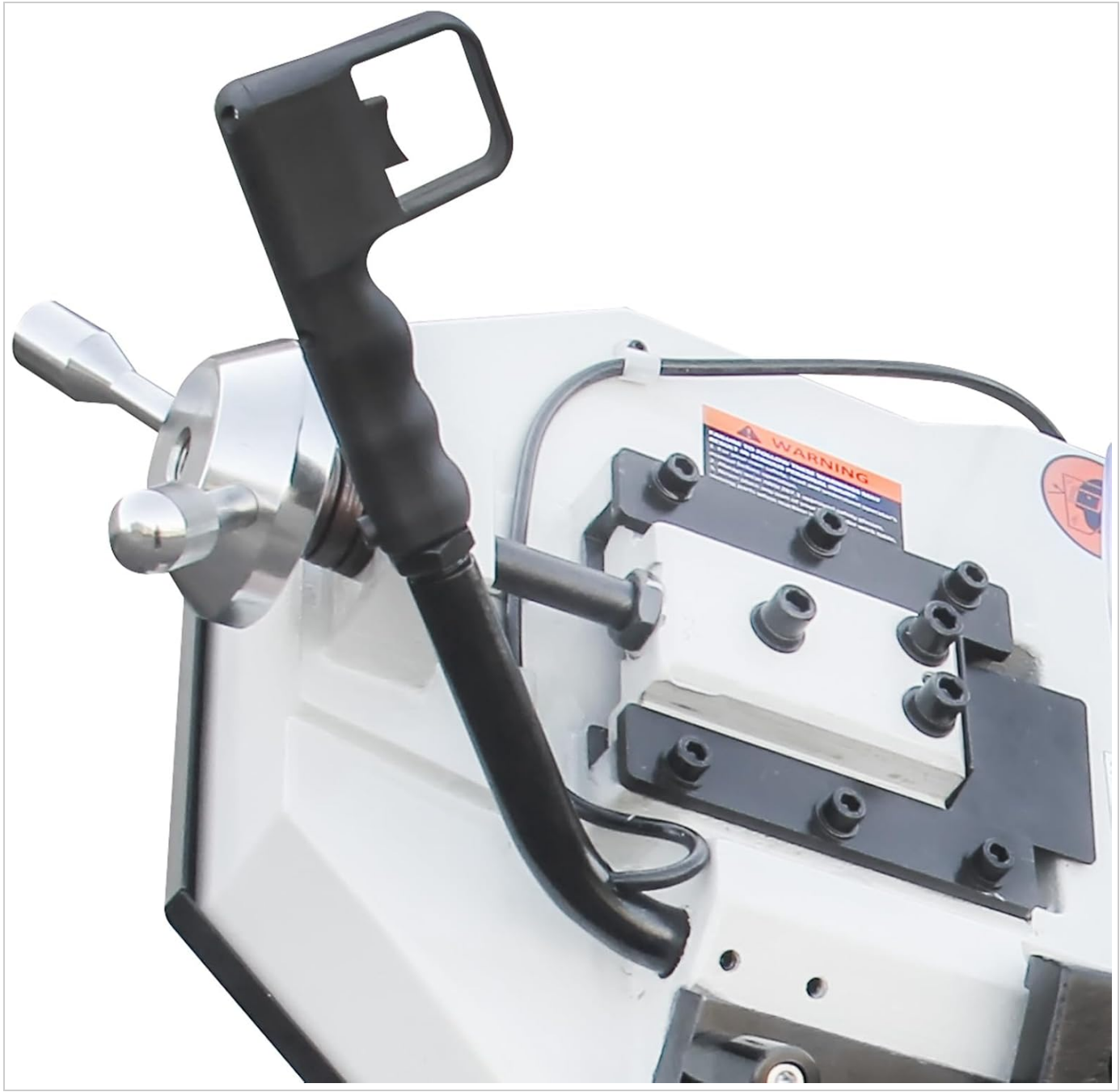


Figure 5: Vise handle for clamping material.



Figure 6: Stop rod for setting cut length.

4.3 Controlled Downfeed and Coolant System

The hydraulic downfeed system allows for controlled descent of the saw blade, ensuring consistent cutting pressure. The dual-coolant system (flood coolant + mist lubrication) reduces blade temperature, extending blade life. Adjust the coolant flow as needed for the material being cut.

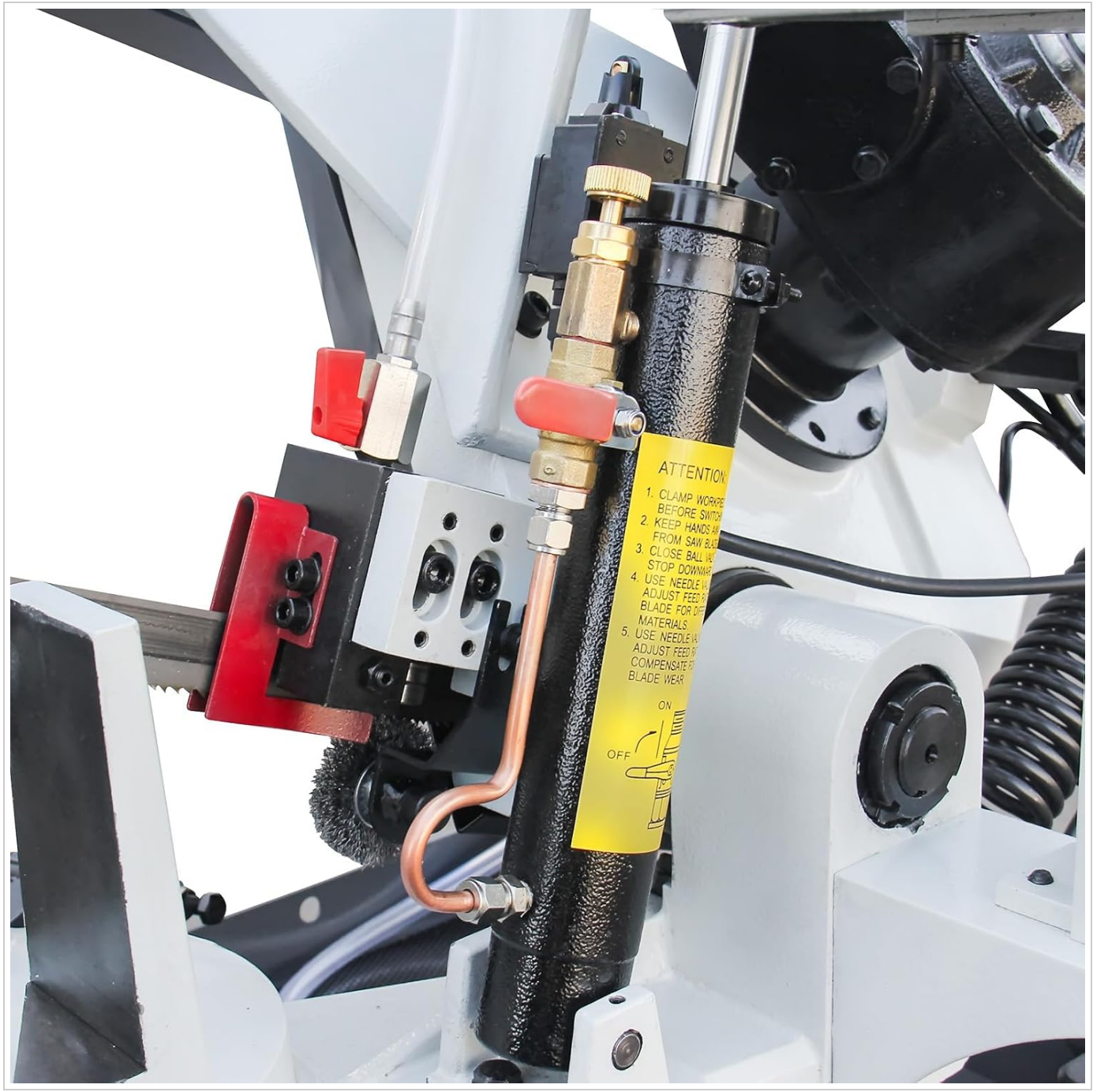


Figure 7: Hydraulic downfeed and coolant system components.

4.4 Initiating a Cut

With the material securely clamped and the desired angle set, turn on the machine. Engage the controlled downfeed to begin cutting. Monitor the cutting process and adjust the downfeed rate if necessary. The machine will automatically shut off upon completion of the cut or if the rear guard is opened.

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Video 2: Demonstration of the KAKA Industrial BS-108G Metal Cutting Band Saw in operation, showing the cutting process.

5. Maintenance

Regular maintenance ensures the longevity and optimal performance of your band saw. Always disconnect power before performing maintenance.

- **Blade Inspection and Replacement:** Regularly inspect the blade for wear, damage, or dullness. Replace worn blades

promptly to maintain cut quality and prevent strain on the motor.

- **Blade Cleaning:** Ensure the blade brush is functioning correctly to remove chips from the blade during operation.
- **Coolant System:** Periodically check coolant levels and replenish as needed. Clean the coolant tank and filter to prevent clogs and maintain coolant effectiveness.
- **Lubrication:** Lubricate moving parts as indicated in the machine's specific lubrication points. Refer to the machine's labels for recommended lubricants.
- **General Cleaning:** Keep the machine clean from metal chips and debris. This prevents buildup that can affect precision and operation.

6. Troubleshooting

This section addresses common issues you might encounter.

Problem	Possible Cause	Solution
Poor cut quality (rough, uneven)	Dull or incorrect blade, improper blade tension, incorrect feed rate	Replace blade, adjust tension, adjust feed rate for material
Saw not cutting	No power, blade not engaged, safety switch activated	Check power connection, ensure blade is engaged, check safety guards
Excessive blade wear	Insufficient coolant, incorrect blade speed, improper feed rate	Check coolant flow, adjust blade speed, optimize feed rate
Coolant not flowing	Low coolant level, clogged pump/nozzle, pump malfunction	Refill coolant, clean system, inspect pump

7. Specifications

Feature	Detail
Brand	KAKA INDUSTRIAL
Model Number	18800X (BS-108G)
Cutting Capacity	10 inch x 7.9 inch
Miter Angle	Up to 60°
Motor Power	1.5 HP
Voltage	115 Volts
Power Source	Corded Electric
Blade Material	High Speed Steel

Feature	Detail
Blade Length	10 Inches
Number of Teeth	24
Product Dimensions	50"L x 25"W x 45"H
Item Weight	Approximately 0.72 Pounds (Note: This weight seems incorrect for the full machine, likely for a component. Refer to shipping documentation for total weight.)
Special Features	European model with a raised base, Swivel Head Miters up to 60°, Dual-Coolant System, Industrial Worm Gear Drive, Rapid-Adjust Vise, Auto Safety Shutoff
UPC	749346838600

8. Warranty and Support

For warranty information, technical support, or to order replacement parts, please contact KAKA INDUSTRIAL LLC directly. Refer to your purchase documentation for specific warranty terms and contact details.
Manufacturer: KAKA INDUSTRIAL LLC

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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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Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

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