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## KAKA INDUSTRIAL BS-2114T

# KAKA INDUSTRIAL BS-2114T Metal Band Saw User Manual

Model: BS-2114T

## 1. INTRODUCTION

This manual provides essential information for the safe operation, maintenance, and troubleshooting of your KAKA INDUSTRIAL BS-2114T Metal Band Saw. Please read this manual thoroughly before operating the machine to ensure proper use and to prevent injury or damage. This industrial-grade band saw is designed for precise cutting of various metal materials, featuring a swivel head miter for angled cuts and a robust gear-driven system.

### Safety Information

Always prioritize safety. Wear appropriate personal protective equipment (PPE) including safety glasses, hearing protection, and gloves. Ensure the work area is clear and well-lit. Disconnect power before performing any maintenance or adjustments.

## 2. SETUP

### Unpacking and Placement

The KAKA INDUSTRIAL BS-2114T is a heavy machine, weighing approximately 1566 pounds. Use appropriate lifting equipment and methods for unpacking and placement. Ensure the machine is placed on a stable, level surface capable of supporting its weight and operational forces. The stand is included and should be securely assembled.

### Power Connection

This machine requires a 220V-60Hz-3PH power supply. Ensure your electrical system meets these requirements and that the connection is made by a qualified electrician. Improper power connection can lead to machine damage or electrical shock.

### Initial Checks

- Verify all components are present and undamaged.
- Check for proper blade tension. The machine features mechanical blade tensioning.
- Ensure the quick-lock vise operates smoothly.
- Inspect the coolant system reservoir and lines for any leaks or blockages.



Figure 2.1: Overview of the KAKA INDUSTRIAL BS-2114T Metal Band Saw. This image displays the complete machine from a front-side perspective, highlighting its robust construction and key components like the saw frame, control panel, and base.

### 3. OPERATING INSTRUCTIONS

#### Control Panel Overview

Familiarize yourself with the control panel before operation. It includes power indicators, start/stop buttons, an emergency stop, and controls for saw speed and coolant flow.



Figure 3.1: Close-up of the control panel. This image shows the various buttons and dials for operating the band saw, including power, start, emergency stop, and saw speed selection.

## Material Clamping

Use the quick-lock vise to securely clamp the workpiece. Proper clamping is crucial for accurate cuts and operator safety. Ensure the material is stable and cannot shift during cutting.

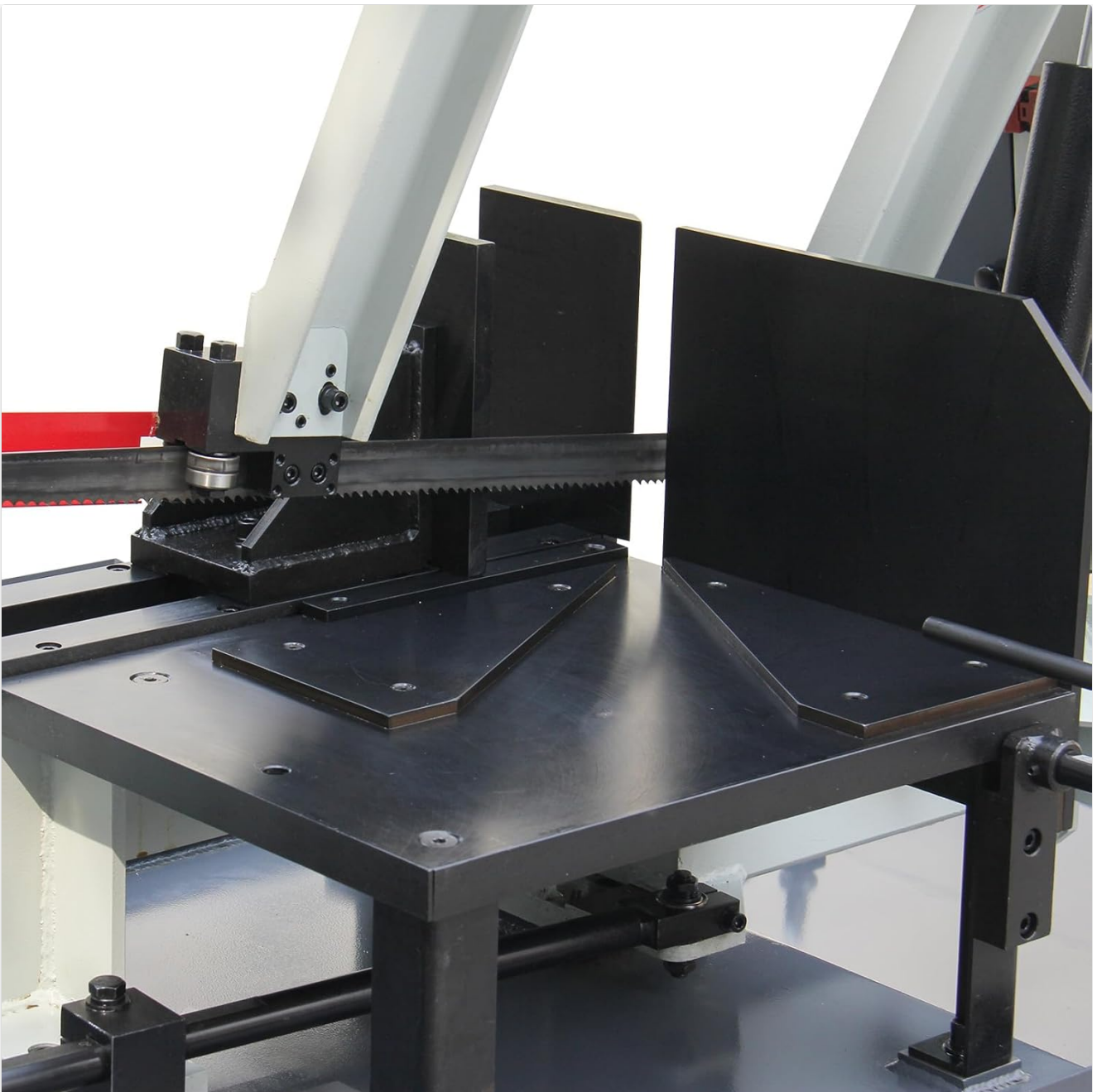


Figure 3.2: Detail of the cutting area and quick-lock vise. This image illustrates how material is secured for cutting, showing the blade path and the robust clamping mechanism.

### **Setting Cutting Angle (Miter)**

The swivel head allows for miter cuts up to 60 degrees. Use the degree indicator to set the desired angle precisely. Loosen the locking mechanism, adjust the head to the required angle, and then re-secure the lock.

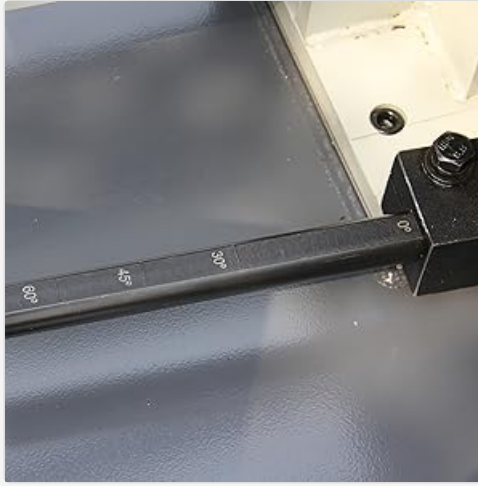


Figure 3.3: Miter angle indicator. This image highlights the scale used to set precise cutting angles for the swivel head, ranging up to 60 degrees.

### **Blade Speed Selection**

The machine offers two blade speeds: 57 MPM (Meters Per Minute) and 84 MPM. Select the appropriate speed based on the material type and thickness being cut. Refer to a material cutting chart for optimal speed recommendations.

### **Cutting Procedure**

1. Secure the workpiece in the vise.
2. Set the desired cutting angle.
3. Select the appropriate blade speed.
4. Engage the coolant system.
5. Start the saw.
6. Lower the saw frame using the hydraulic down feed control. The hydraulic system ensures adjustable cutting speed and a smooth descent.
7. The machine features an automatic shutoff once the cut is complete.





Figure 4.1: Detail of the blade wheel and blade path. This image shows the mechanism that drives the band saw blade, emphasizing the importance of proper blade alignment and tension.

## Coolant System

The built-in coolant system helps prolong blade life and improve cut quality. Regularly check the coolant level and replenish as needed. Clean the coolant reservoir and filter to prevent blockages and maintain system efficiency.

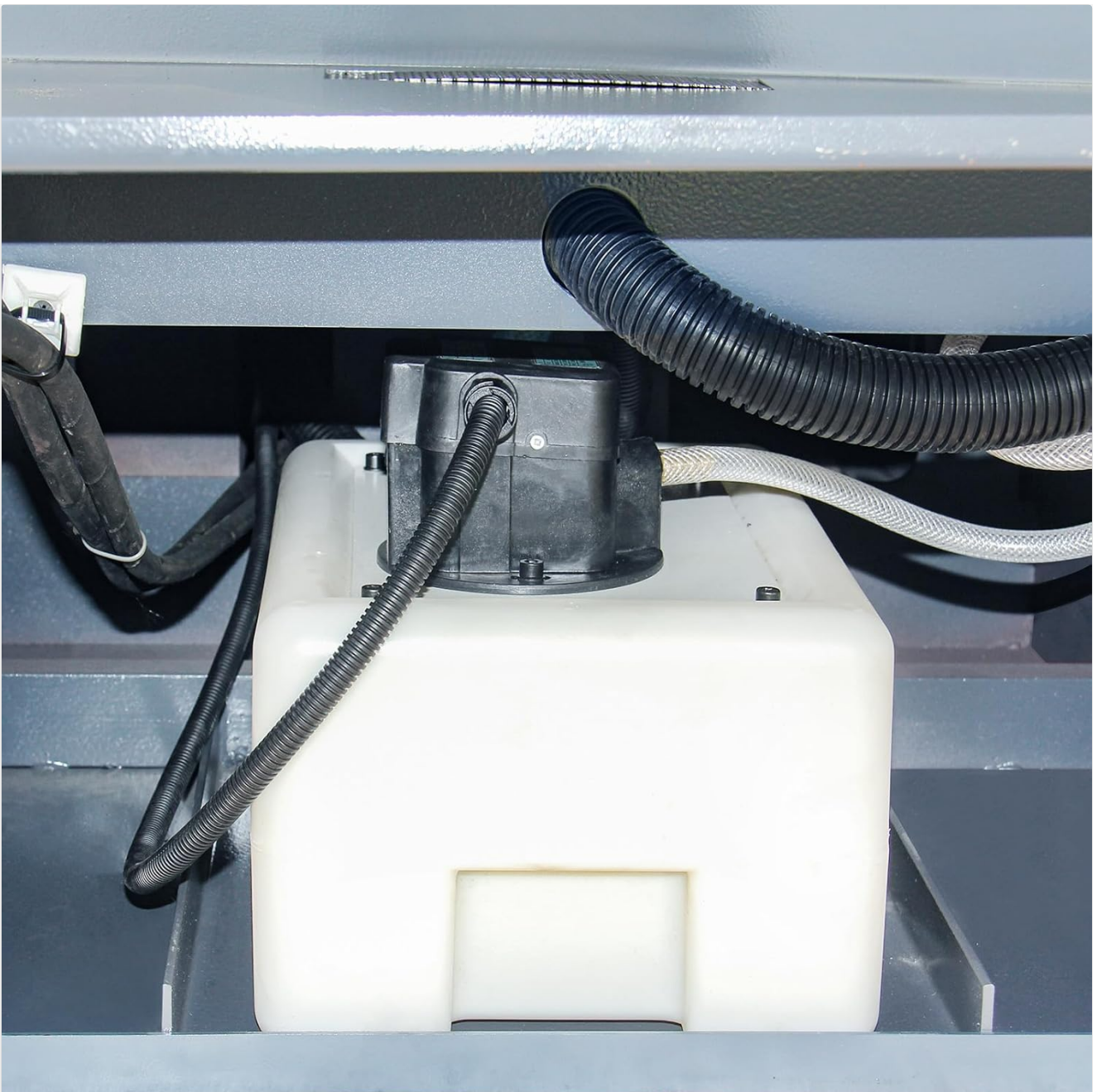


Figure 4.2: View of the coolant reservoir. This component stores the cutting fluid used to cool the blade and workpiece during operation, contributing to extended blade life.

## General Cleaning

Keep the machine clean from metal chips and debris. Regularly wipe down surfaces and ensure all moving parts are free from obstructions. Lubricate moving parts as recommended by the manufacturer.

## 5. TROUBLESHOOTING

This section addresses common issues you might encounter during operation.

Problem	Possible Cause	Solution
Saw does not start	No power supply; Emergency stop engaged; Motor overload	Check power connection; Release emergency stop; Reset motor overload protector
Poor cut quality / Excessive vibration	Dull blade; Incorrect blade tension; Improper material clamping; Incorrect blade speed	Replace blade; Adjust blade tension; Re-clamp material securely; Select correct blade speed
Blade breakage	Incorrect blade tension; Worn blade guides; Material not clamped properly; Excessive feed pressure	Adjust blade tension; Inspect/replace blade guides; Secure material; Reduce feed pressure via hydraulic control
Coolant not flowing	Low coolant level; Clogged filter/nozzle; Pump malfunction	Refill coolant; Clean filter/nozzle; Inspect coolant pump

## 6. SPECIFICATIONS

Detailed technical specifications for the KAKA INDUSTRIAL BS-2114T Metal Band Saw.

Feature	Specification
Model	BS-2114T
Brand	KAKA INDUSTRIAL
Cutting Capacity (Round at 90°)	15.7 inches
Cutting Capacity (Rectangular at 90°)	21.6" x 14"
Miter Capability	Up to 60 degrees
Power Source	Corded Electric
Voltage	220 Volts
Frequency	60 Hz
Phase	3 Phase
Wattage	2200 watts
Blade Speeds	57 / 84 MPM (Meters Per Minute)
Blade Length	173 Inches
Item Weight	1566 Pounds
Product Dimensions (L x W x H)	91" x 32" x 62"
Included Components	Stand
Material	Metal
Color	Grey

## OVERALL DIMENSIONS



Figure 6.1: Overall dimensions of the band saw. This diagram provides key measurements (length, width, height) of the machine for planning installation space.

## 7. WARRANTY AND SUPPORT

### Warranty Information

The KAKA INDUSTRIAL BS-2114T Metal Band Saw comes with a Limited Warranty. For specific terms and conditions, please refer to the warranty documentation included with your purchase or contact KAKA INDUSTRIAL LLC directly.

### Customer Support

For technical assistance, parts, or service inquiries, please contact KAKA INDUSTRIAL LLC. You can visit their official store on Amazon for more information: KAKA INDUSTRIAL Store.