



4630 18" Bandsaw

Owner's Manual



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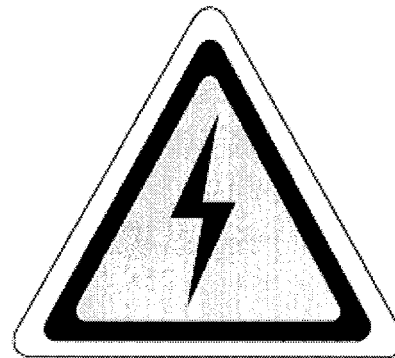
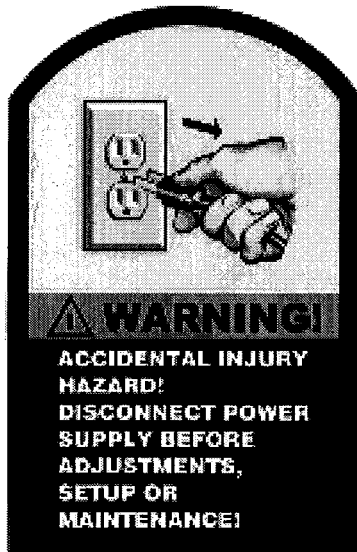
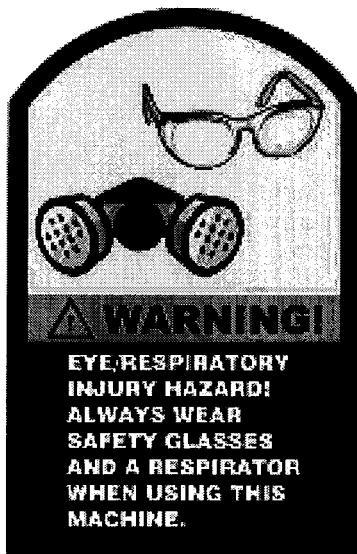
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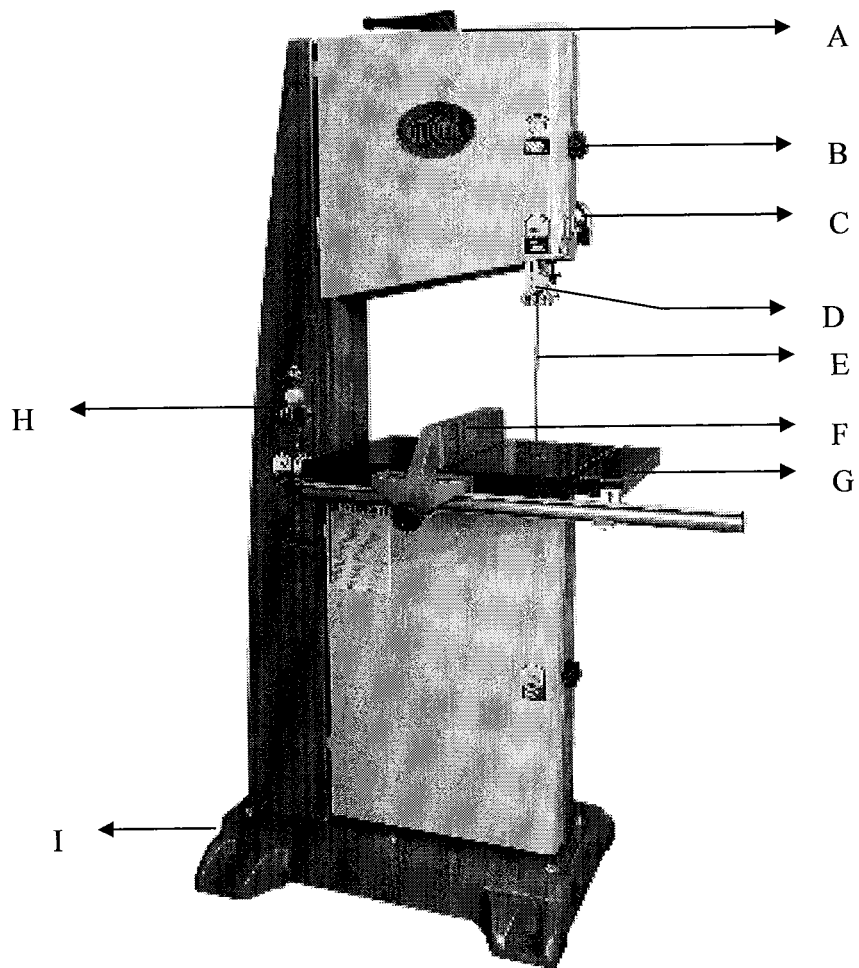
WARNING PLATES

This machine has warning symbols attached on it as shown below to ensure proper and safe operation.

These symbols are used on the machine to indicate points or instances of specific danger to operating personnel.

Make sure to memorize these symbols and bring them to the attention of others as and when necessary. **Do not remove safety symbols from the machine.**





- A. Quick Release Tension Handle**
- B. Door Knob**
- C. Guide Post Handlewheel**
- D. Ball Bearing Guide Support**
- E. Blade**
- F. Fence**
- G. Working Table**
- H. Switch**
- I. Casting Iron Base**

FEATURES

- Motor – 2HP, Single Phase 220 Volts.
- Motor Speed – 3450 RPM.
- Motor Switch – Magnetic.
- Blade Speed – 1,480, 2,300 & 3,260 FPM.
- Fully Balanced Cast Iron Wheels with Coplanar Shim Adjustments.
- Table Size – 17 3/4" X 17 3/4" with 6" steel wing on the left.
- Table Material – Precision Ground Cast Iron.
- Table Height – 37"
- Table Tilts – 50° left, 10° right.
- Throat – 17 1/2"
- Cutting Height – 12" rack & pinion adjustment.
- Blade Size – 1/4" – 1 1/4" 133" long.
- Fence – precision aluminum fence with optical cursors.
- Miter Gauge – 'T' Slot, Included.
- Overall Height – 74"
- Gross Weight – 175 kg

Fence install

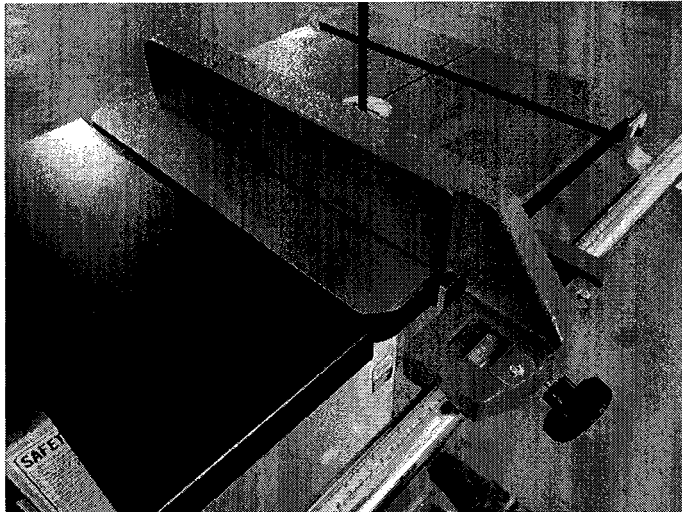
Step1



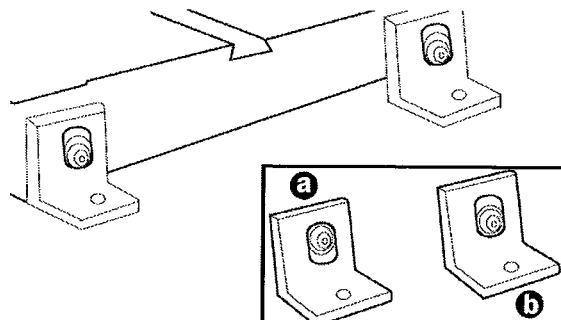
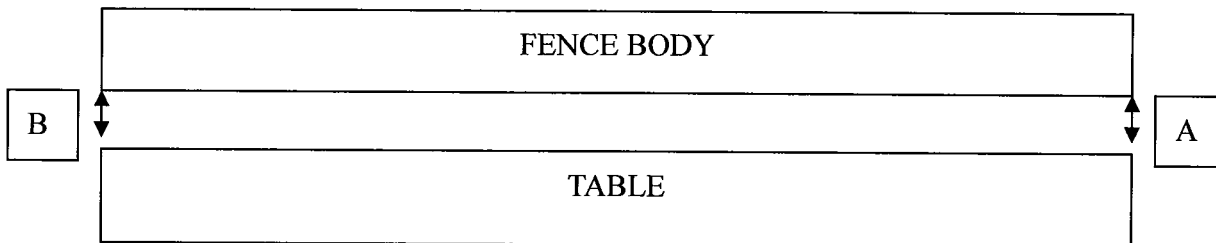
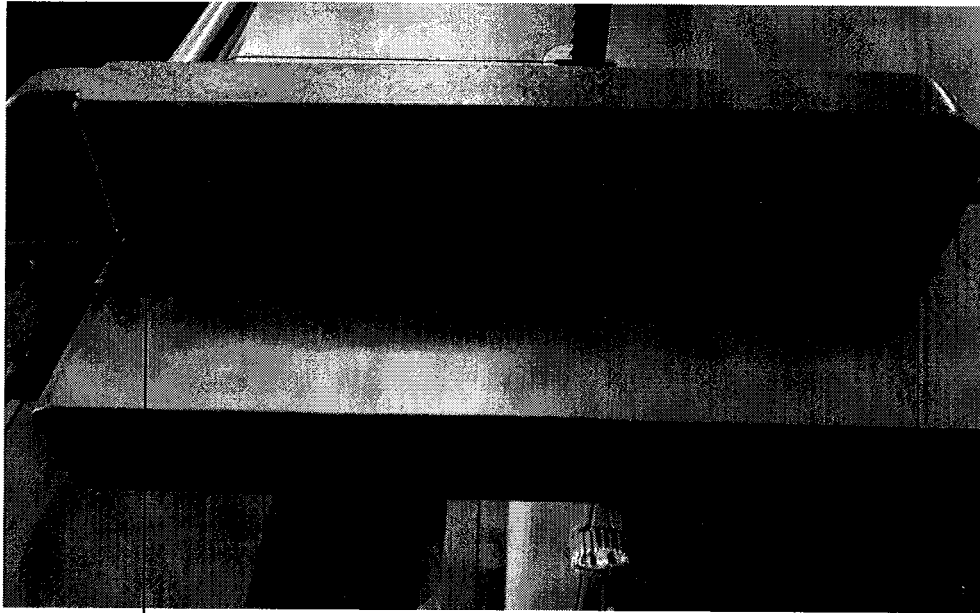
Step2



Step3



Fence adjustment

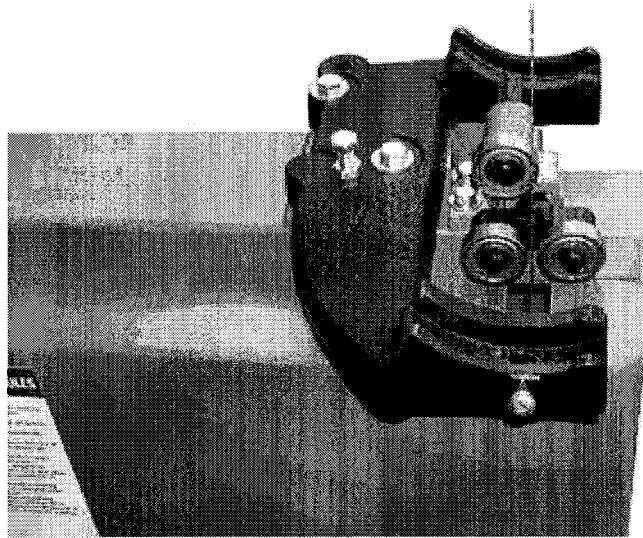


To level and adjust the height of the fence, loosen the bolt that hold the mounting brackets to the table, and raise or lower the front rails along the elongated holes in the mounting brackets. Level the fence, front and back as needed, and set the spacing between the bottom of the fence and the table to 1mm (approx.) as shown in image . Then, tighten the bolt to lock the rails in position

ADJUSTMENT

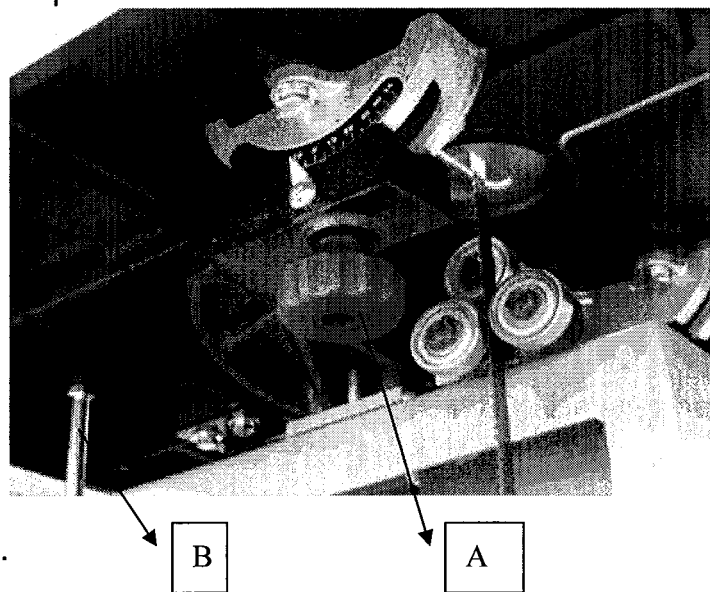
TABLE ASSEMBLY

1. Place table bracket on the bandsaw so that the two bracket pins can go into the holes on the support.
2. Secure table bracket to bandsaw body using the two hex head bolt and flat washers(Fig.1)
3. Set table on bracket, insert screw into bracket and secure with knob (Fig.2)



ADJUSTING TO 90° TABLE STOP

1. Disconnect the machine from the power source.
2. Loosen the lock knobs (A) as illustrated in (Fig.2) tilt the table towards the left until it rests against the table stop bolt.(Fig.2,B)
3. Use a square, place on the table against the blade. This will allow you to verify the 90 degree to the table(Fig.5).
4. Turn table stop bolt to get the 90-degree angle; tighten the lock knobs once completed.

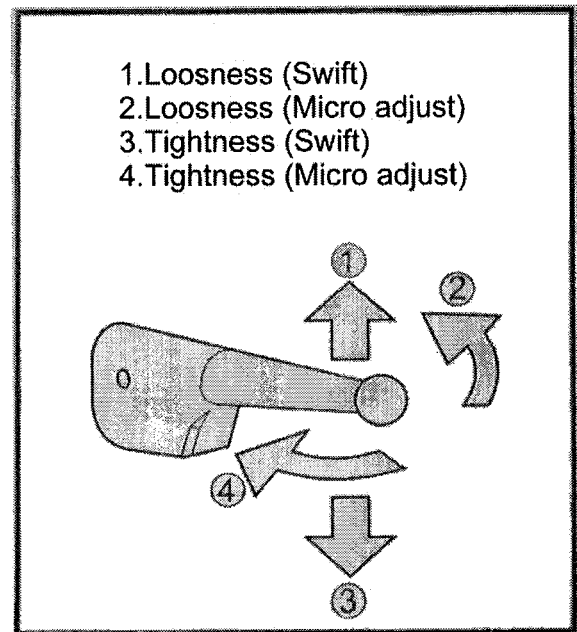


Quick release / blade tensioning

Lifting the quick release handle to release blade tension. Remove blade and replace with new one. Turn down the handle to tighten blade.

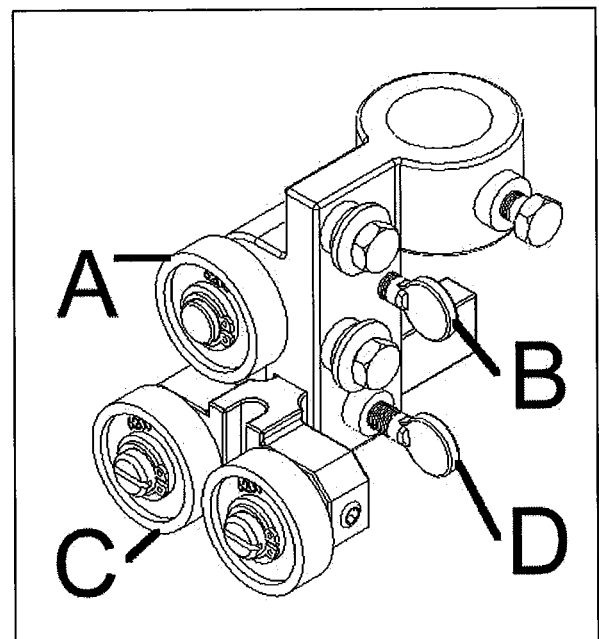
Turn the handle clockwise to minor tighten blade tension and counterclockwise to release blade tension.

A blade under tension may also pull drive wheel out of alignment. Adjust alignment of drive wheel with tracking knob.



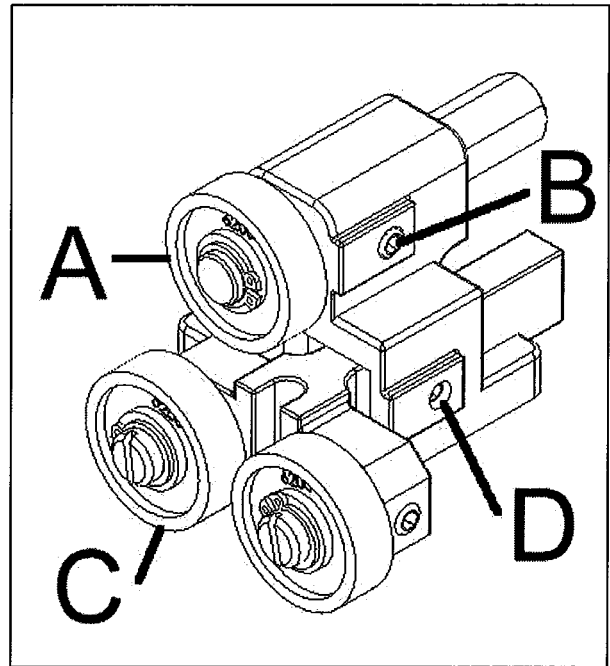
Adjusting upper blade support

The blade support bearing (A) should be adjusted so it almost touches the back of the saw blade when the blade is tracking properly. To adjust, loosen indexable locking lever (B) and slide bracket in or out until the adjustment is correct. Tighten lever. The blade guide bearing (C) should be adjusted so they almost touch the side of the blade. The front edge of the guide bearings must be positioned just behind the "gullets" of the saw teeth. To adjust, loosen indexable locking lever (D) and slide bearing assembly in or out until the adjustment is correct. Tighten lever. Replace blade guard.



Adjusting lower blade support bearing

The lower bearing adjustments are similar to the upper bearing adjustments. The blade support bearing (A) should be adjusted so it almost touches the back of the saw blade. To adjust, loosen hex screw (B) and slide bracket in or out until the adjustment is correct. Tighten screw. The blade guide bearings (C) should be adjusted so they almost touch the sides of the blade. To adjust, loosen hex screw (D) and slide bearing assembly in or out until the adjustment is correct. Tighten hex screw.

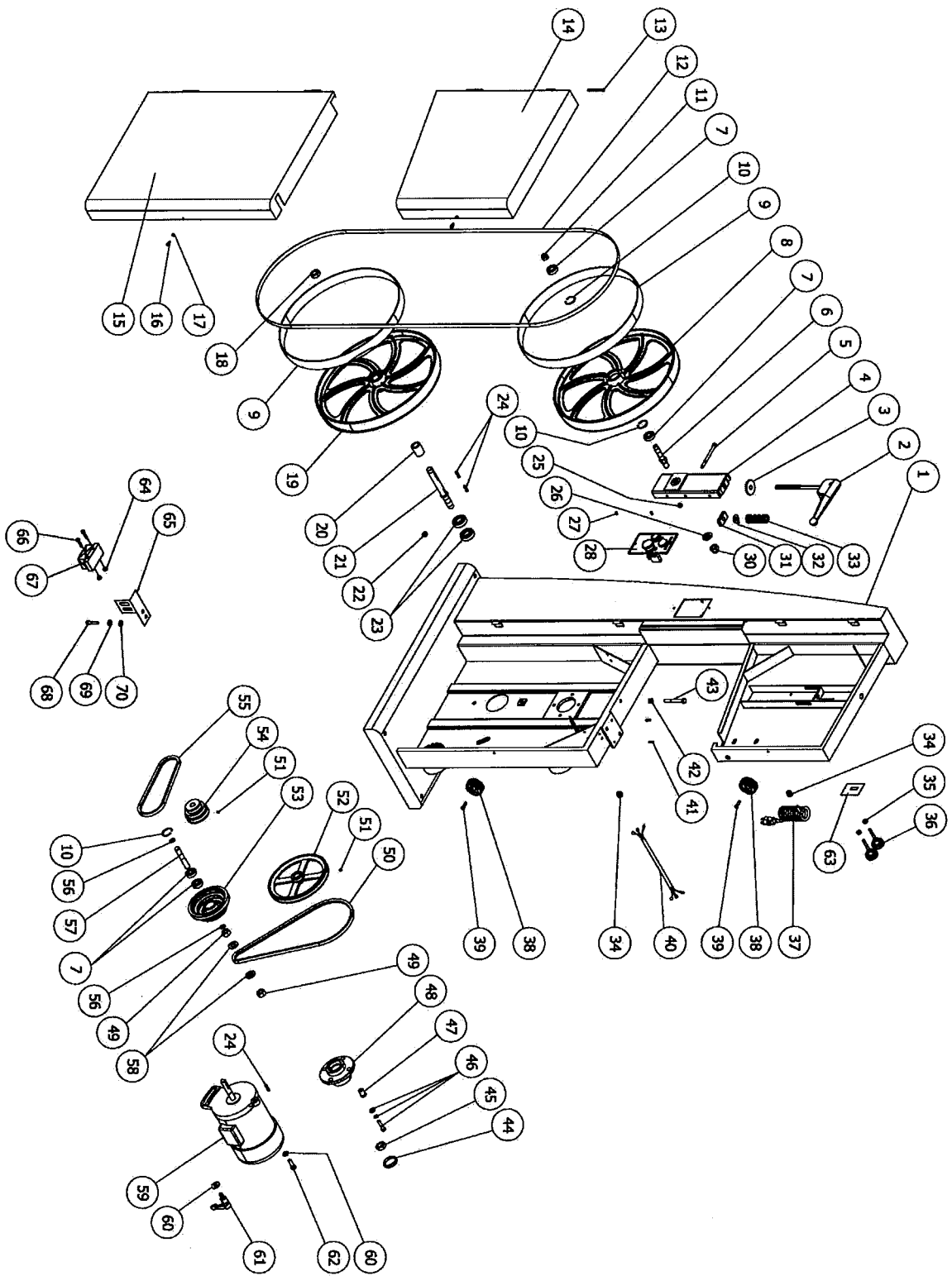


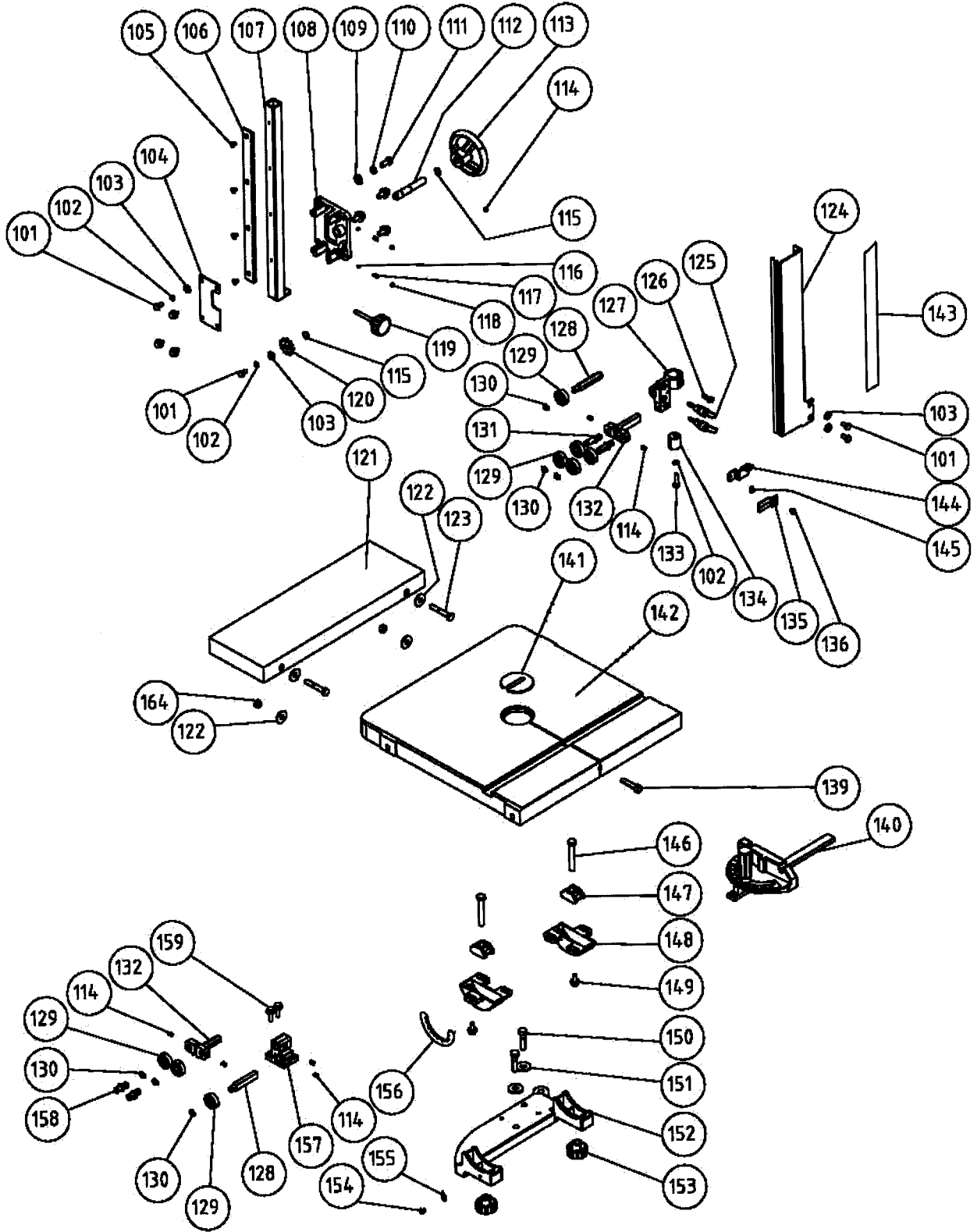
Troubleshooting

! WARNING

Disconnect the machine from power source before proceeding with any troubleshooting! Failure to comply may cause serious injury!

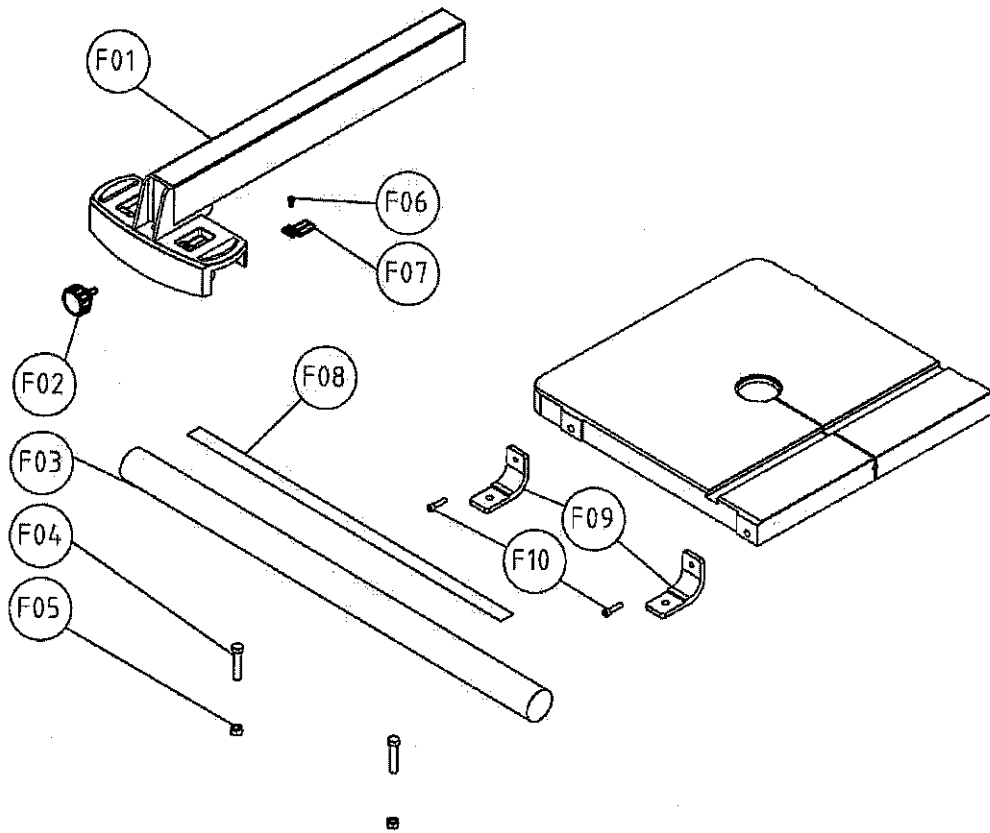
Description of Symptoms	Possible Cause	Corrective Action
Machine will not start	<ol style="list-style-type: none"> 1. Fuse blown or circuit breaker tripped 2. Cord Damaged 3. Faulty switch 4. Not connected to power source 5. Connected to wrong voltage 6. Emergency stop button pressed 	<ol style="list-style-type: none"> 1. Replace fuse or reset circuit breaker 2. Have cord replaced 3. Replace switch 4. Check connection 5. Check voltage 6. Rotate emergency stop button clockwise until it pops out
Blade does not come up to speed	<ol style="list-style-type: none"> 1. Cable too light or too long 2. Low current 3. Circuit shared with other equipment 4. Motor not wired for correct voltage 	<ol style="list-style-type: none"> 1. Replace with adequate size cable 2. Contact local electric company 3. Provide a dedicated circuit 4. Refer to motor nameplate for correct voltage
Motor overheats	<ol style="list-style-type: none"> 1. Motor overloaded 2. Air circulation through the motor restricted 	<ol style="list-style-type: none"> 1. Reduce load on motor 2. Clean out fan and fan cover
Machine slows when operating	<ol style="list-style-type: none"> 1. Feeding workpiece too fast 	<ol style="list-style-type: none"> 1. Slow the feed speed
Does not make accurate 45° or 90° cuts	<ol style="list-style-type: none"> 1. Stops not adjusted correctly 2. Angle pointer not set accurately 3. Miter gauge out of adjustment 	<ol style="list-style-type: none"> 1. Check blade with combination square and adjust stops 2. Check blade with combination square and adjust pointer 3. Adjust miter gauge
Saw makes unsatisfactory cuts	<ol style="list-style-type: none"> 1. Dull blade 2. Blade mounted backwards 3. Gum or pitch on blade 4. Incorrect blade for cut 	<ol style="list-style-type: none"> 1. Sharpen or replace blade 2. Turn blade around 3. Remove blade and clean 4. Change blade to correct type
Saw vibrates excessively	<ol style="list-style-type: none"> 1. Stand on uneven floor 2. Damaged saw blade 3. Bad V-belt 4. V-belt tension incorrect 5. Loose hardware 	<ol style="list-style-type: none"> 1. Reposition on flat, level surface 2. Replace saw blade 3. Replace V-belt 4. Check and adjust v-belt tension 5. Tighten hardware





PART	DESCRIPTION	PART	DESCRIPTION
1	BODY	37	CORD
2	HANDLE	38	KNOB
3	WASHER	39	1/4"-3/4" SOC HD SCREW
4	UPPER WHEEL BRACKET	40	CORD
5	SCREW	41	6mm PIN
6	UPPER WHEEL SHAFT	42	3/8" HEX NUT
7	BEARING	43	3/8"-5" SCREW
8	UPPER WHEEL	44	COVER
9	TIRE	45	3/4" HEX NUT
10	C-RING	46	SCREW
11	1/2" HEX NUT	47	ADJUSTING SCREW
12	BLADE	48	BEARING HOUSING
13	PIN	49	5/8" HEX NUT
14	UPPER WHEEL GUARD	50	BELT
15	LOWER GUARD	51	1/4"-3/8" SET SCREW
16	1/4"-3/8" SCREW	52	PULLEY
17	1/4" LOCK WASHER	53	PULLEY
18	3/4" HEX NUT-L	54	MOTOR PULLEY
19	LOWER WHEEL	55	BELT
20	SPACER	56	C-RING
21	SHAFT	57	SHAFT
22	3/8" HEX NUT	58	5/8" WASHER
23	BEARING	59	MOTOR
24	KEY 5x5	60	3/8" WASHER
25	NUT	61	KNOB
26	1/2" WASHER	62	3/8"-2 1/2" SCREW
27	3/16"-1/2" PAN HD SCREW	63	LABEL
28	SWITCH	64	3/16 HEX NUT
30	1/2" NUT	65	BRUSH PLANE
31	SQUARE NUT	66	3/16*1 1/2 SCREW
32	POINTER	67	BRUSH
33	SPRING	68	1/4*3/4 HEX BOLT
34	RETAINER	69	1/4 LOCK WASHER
35	5/16" HEX NUT	70	1/4 FLAT WASHER
36	KNOB		

PART	DESCRIPTION	PART	DESCRIPTION
101	1/4"-3/8" SCREW	134	GUIDE POST
102	1/4" LOCK WASHER	135	POINTER
103	1/4" WASHER	136	3/16" SCREW
104	GUIDE BAR COVER	137	
105	M5 SCREW	138	
106	GEAR	139	PIN
107	GUIDE BAR	140	GAUGE
108	BRACKET	141	TABLE INSERT
109	5/16" WASHER	142	TABLE
110	5/16" LOCK WASHER	143	SCALE
111	5/16"-5/8" SCREW	144	POINTER PLATE
112	SHAFT	145	1/4"-3/8" SCREW
113	HAND WHEEL	146	3/8"-2/1/2" SCREW
114	1/4" SET SCREW	147	CLAMP SHOE
115	C-RING	148	TRUNNION
116		149	SCREW
117	SPRING	150	3/8"-2" SCREW
118	M6 SET SCREW	151	3/8" WSHER
119	KNOB	152	TABLE BRACKET
120	GEAR	153	KNOB
121		154	3/16" SCREW
122		155	POINTER
123		156	SCALE
124	BLADE COVER	157	BRACKET
125	KNOB	158	GUIDE SHAFT(S)
126	1/4"-3/4" SCREW	159	SCREW
127	BRACKET		
128	BEARING SUPPORT BRACKET		
129	BEARING		
130	C-RING		
131	GUIDE SHAFT(L)		
132	SUPPORT		
133	1/4"-3/4" CAP ACREW		



REF	DESCRIPTION
F01	FENCE BODY
F02	KNOB
F03	Fence Rail
F04	HEX BOLT
F05	HEX NUT
F06	SCREW
F07	Fence Pointer
F08	Scale
F09	L TYPE HOLDER
F10	HEX BOLT