



S20

393381

THANK YOU,

On behalf of everyone at HYD-MECH Group Limited, we would like to thank and congratulate you on your decision to purchase a HYD-MECH bandsaw.

Your new machine is now ready to play a key role in increasing the efficiency of your operation, helping you to reduce cost while boosting quality and productivity.

To ensure you are maximizing the power and versatility of your new HYD-MECH bandsaw, please take the time to familiarize yourself and your employees with the correct operation and maintenance procedures as outlined in this manual. Please keep this instruction manual for future reference in a known location and easily accessible to all users of the device.

HYD-MECH offers a great variety of options, components, and features for its various models. Therefore, some of the equipment described in this manual (various illustrations and drawings) may not be applicable to your particular machine.

The information and specifications provided in this manual were accurate at the time of printing. HYD-MECH reserves the right to discontinue or change specifications or design at any time without notice and without incurring any obligation.

Thank you.

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SECTION 0 - SAFETY INSTRUCTIONS

SUMMARY

All persons operating this machine must have read and understood all of the following sections of this Manual:

Section 0	SAFETY
Section 2	OPERATING INSTRUCTIONS

However, as a memory aid, the following is a summary of the Safety Section.

Put Safety First

Mandatory Information – What operators and maintenance people must have read and understood.

Signatures – Everyone involved with this machine must sign to confirm they have read and understood mandatory information.

Basic Rules – only use this machine when

- It is in good working order.
- All safety equipment is in place and functional.
- Operations are in compliance with this manual.
- Materials are within designed specifications and are non-hazardous.

Owner is responsible to

- Keep Manual accessible at the machine.
- Ensure only reliable, fully trained personnel work with the machine.
- Clearly define responsibilities of all personnel working with the machine.
- Keep the machine in good working order.

Operator and Maintenance Personnel are responsible to:

- Keep all safety equipment in order, check its function at the beginning of each shift, and report any shortcomings.
- Shut down machine and report any faults or malfunctions that could impair safety.
- Understand and obey safety hazard labels.
- Not to wear un-restrained long hair, loose clothing or jewellery.
- Wear all required personal protective equipment.
- Not to wear gloves within 24 inches of moving blade.
- Maintain a clean working area and machine.
- Always use Lock-out when performing maintenance or repairs.

FOREWORD

Put Safety First!

This Safety Section contains important information to help you work safely with your machine and describes the dangers inherent to bandsaws. Some of these dangers are obvious, while others are less evident.

It really is important to PUT SAFETY FIRST. Make it a habit to consider the hazards associated with any action BEFORE you do it. If you feel any uncertainty, stop and find a safer approach to the action. If you're still uncertain, ask for advice from your supervisor.

The SAFETY FIRST approach is particularly necessary when you do something new, or different, and most people instinctively recognize this, although impatience may still cause them to take unnecessary risks.

Danger also lurks in the routine task that we have done over and over. Here, familiarity, boredom, or tiredness may lull us into unthinking, automatic repetition. Be alert for this, and when you feel it happening, stop and assess your situation. Review the safety hazards associated with what you are doing. That should get your brain working again.

Certainly production is important, but if you think you're too busy to put safety first, think how much production you'll lose if you get hurt.

You owe it to yourself, your family, and your co-workers to PUT SAFETY FIRST.

Mandatory Information

All persons operating this machine must have read and understood all of the following sections of this Manual:

Section 0 SAFETY

Section 2 OPERATING INSTRUCTIONS

Personnel involved in installation and maintenance of the machine must have read and understood all sections of the manual

Persons who have difficulty reading, or for whom English is not their first language, must receive particularly thorough instruction.

Signatures

Everyone involved in operation of this machine must sign below to confirm that:

I have read and understood all parts of Section 0 – Safety, and Section 2 – Operating Instructions.

Name	Date	Signature

Everyone involved in the installation, inspection, maintenance, and repair of this machine must sign below to confirm that:

I have read and understood all parts of this Operation and Maintenance Manual.

Name	Date	Signature

BASIC RULES

Intended Use

Our machines are designed and built in line with the state of the art, and specifically in accordance with American National Standards Institute Standard B11.10 *Safety Requirements for Metal Sawing Machines*. However, all machines may endanger the safety of their users and/or third parties, and be damaged, or damage other property, if they are operated incorrectly, used beyond their specified capacity, or for purposes other than those specified in this Manual.

Exclusion of Misuse

Misuse includes, for example:

Sawing hazardous materials such as magnesium or lead.

Sawing work pieces which exceed the maximum workload appearing in the Specifications.

Operating the machine without all original safety equipment and guards.

Liability

The machine may only be operated:

When it is in good working order, and

When the operator has read and understood the Safety and Operating Instructions Sections of the Manual, and

When all operations and procedures are in compliance with this Manual.

Hyd-Mech Group cannot accept any liability for personal injury or property damage due to operator errors or non-compliance with the Safety and Operating Instructions contained in this Manual.

RESPONSIBILITIES OF THE OWNER

Organization of work

This Operation and Maintenance Manual must always be kept near the machine so that it is accessible to all concerned.

The general, statutory and other legal regulations on accident prevention and environmental protection must also be observed, in addition to the Manual material. The operators and maintenance personnel must be instructed accordingly. This obligation also includes the handling of dangerous substances and the provision and use of personal protective equipment.

Choice and qualification of personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work.

Training

Everyone working on or with the machine must be properly trained with regard to the correct use of the machine, the correct use of safety equipment, the foreseeable dangers that may arise during operation of the machine, and the safety precautions to be taken.

In addition, the personnel must be instructed to check all safety devices at regular intervals.

Define responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine.

Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety.

Persons being trained on the machine may only work on or with the machine under the constant supervision of an experienced operator. Observe the minimum age limits required by law.

Condition of Machine and Workplace

Ensure that the machine and its safety equipment are kept in good working order.

Ensure that the work area is well lit, and protected from the elements, such as rain, snow, abrasive dust, and extremes of temperature.

Ensure that the machine is installed with sufficient clearance around it for the safe loading and unloading of work pieces.

RESPONSIBILITIES OF THE OPERATOR AND MAINTENANCE PERSONNEL

Safety equipment

All machines are delivered with safety equipment that must not be removed or bypassed during operation.

The correct functioning of safety equipment on the machine must be checked:

- At the start of every shift.
- After maintenance and repair work
- When starting for the first time, and after prolonged shutdowns

Emergency Stop Button (E-Stops)

Always be aware of the location of the Emergency Stop Button(s). Do not allow material or objects to block your access to an Emergency Stop.

Damage

If any changes capable of impairing safety are observed in the machine or its operation, such as damage, malfunctions, or irregularities, then appropriate steps must be taken immediately, the machine switched off, locked-out, and the fault reported to the responsible person.

Safe operation

The machine may only be operated when in good working order and when all protective equipment is in place and operational.

Keep a safe distance from all moving parts – especially the blade and vises.

Stock should not be loaded onto the saw if the blade is running.

Long and heavy stock should always be properly supported in front of and behind the saw.

Faults

The machine must be switched off and locked-out before starting to remedy any faults.

Safety hazard labels

Safety hazard labels and other instructional labels on the machine must be observed. They must be clearly visible and legible at all times. If they become damaged they must be replaced.

Clothing, jewellery, protective equipment

Personnel operating or working on the machine must not wear un-restrained long hair, loose-fitting clothes and dangling jewellery.

When operating or working on the machine, always wear suitable, officially tested personal protective equipment such as safety glasses and safety boots and any other equipment required by workplace regulations.

Gloves

Experience has shown that careless use of gloves around machinery is a major factor in serious hand injuries.

Gloves should not be worn when operating or adjusting the machine, except:

Wear protective gloves when handling bandsaw blades at blade changes.

Gloves may be worn when handling work pieces, only if the machine is in Manual Mode and the bandsaw blade is not running.

If the machine is running in Auto Mode, and only if the cut parts are greater than 24 inches long, it may be possible to safely wear gloves for handling the cut parts, but the wearer of the gloves must never put his hands near the blade for any reason. If the cut parts are less than 24 inches long, it is required to arrange their automatic flow into a parts bucket or other suitable arrangement to avoid the necessity to pick them off the machine by hand.

Hearing protection

Ear protection must be worn whenever necessary.

The level and duration of noise emission requiring hearing protection depends upon the national regulations in the country in which the machine is being used.

The actual level of noise emission by band sawing machines depends upon work piece size, shape and material, blade type, blade speed and feed rate.

The only practical course of action is to measure the actual noise emission levels for the type of work that is typically done. With reference to national standards, decide upon the necessary hearing protection required.

In the absence of such measurements, it is advisable for anyone exposed to long periods of moderate to loud noise to wear hearing protection. It is important to understand that hearing loss is gradual and easily goes un-noticed until it is serious and irreversible.

Workplace

A clear working area without any obstructions is essential for safe operation of the machine. The floor must be level and clean, without any build-up of chips, off-cuts, coolant, or hydraulic oil.

The workplace must be well lit, and protected from the elements, such as rain, snow, abrasive dust, and extremes of temperature

Nothing may ever be placed on, or leaned against the machine, with the obvious exception of the work piece on the table and conveyor of the machine.

Master Disconnect

Lock-out the machine before undertaking any maintenance or repair work on it. 'Lock-out' refers switching off the master electrical disconnect switch, and locking it out so that it cannot be switched on again without authorization.

On Hyd-Mech machines the Master Disconnect Switch will be of one of four types:

- Rotary switch mounted in electrical control cabinet door and inter-locked with door.
- Rotary switch mounted on the side of the operator interface console.
- Lever switch mounted in separate box on the machine.
- Supply disconnect switch supplied by user at installation and usually wall-mounted within sight of the machine, depending upon local regulations.

In almost all jurisdictions, it is required that owners of industrial equipment establish and post lock-out procedures. Know and use the lock-out procedures of your company or organization.

Residual Risks

The machine is still not completely de-energized if an electrical cabinet door type switch is locked-out.

The line side of the disconnect switch itself remains energized.

Variable speed blade drives store dangerous voltage in their capacitors, and this requires time to dissipate. After locking out power, wait 3 minutes before beginning to work on machine electrical circuits.

If compressed air is supplied to the machine to power a mist lubrication system or other devices, it should be disconnected, and any stored air pressure released before working on the machine.

The weight of individual machine components represents stored potential energy that can be released if they fall when disconnected. Secure these components with adequate hoisting gear before disassembly.

SAFETY HAZARD LABELS

The safety hazard labels attached to your machine represent important safety information to help you avoid personal injury or death.

All supervisors, operators, and maintenance personnel must locate and understand the safety information associated with each hazard label prior to operating or servicing the machine.

The safety hazard labels shown below are located at various positions on the machine to indicate possible safety hazards. The location and re-order part number of all the safety labels associated with this particular model of bandsaw are indicated at the end of this section of the manual. It is important to replace any safety hazard label that becomes damaged or illegible.

HAZARDOUS VOLTAGE INSIDE

Contact with high voltage may cause death or serious injury. Never perform maintenance on, or near, electrical components until the machine's electrical power source has been disconnected. Lock-out power in accordance with your company's lock-out procedures before any such maintenance. The "Stop" or "Emergency Stop" push button does not disconnect the machine's power supply. Hazardous voltage is still present in the machine's electrical circuits.

The machine's Electrical Disconnect Switch does disconnect voltage from the machine's circuits; however hazardous voltage is still present inside the main electrical cabinet, on the infeed (line) side of the main fuses. Therefore keep hands and tools away from the infeed side of the control panel main fuses. If these fuses need to be replaced, use a fuse puller.

Allow three minutes after locking-out power before opening any electrical enclosures. Your machine may be equipped with a variable frequency drive that stores high voltage within its capacitors. Three minutes will allow sufficient time for this voltage to safely discharge.

Never spray coolant directly at electrical components or cabinets.



MOVING BANDSAW BLADE WILL CUT

Do NOT operate with guard removed.

Do NOT place hands or fingers near moving bandsaw blade.

For blade changing, always follow the proper Blade Changing Procedure, as given in Section 3 of this manual.



PINCH POINT

Machine parts may move without warning, either because the machine is operating automatically, or because another person initiates the motion. Keep hands clear of all labelled pinch points, whenever the machine is running. Machine vises can exert great force and cause severe injury. Keep hands clear of vises and work piece when vises are opened or closed. Be aware that vise closing or opening may result in potentially dangerous work piece movement. Be aware also that the opening motion of a vise may create potential pinch points.



MOVING PARTS CAN CRUSH AND CUT

Keep hands clear of chip auger. Lock-out power in accordance with your company's lock-out procedures before attempting to clear a jam in the chip auger.

Be aware that the chip auger may start unexpectedly, either because the machine is operating automatically, or because another person initiates the motion.

If the chip auger is stalled because of a jam, it may start without warning when the jam is cleared, unless the machine power is locked out.



SECTION 1 INSTALLATION

Upon delivery of your new S20 saw, it is imperative that a thorough inspection be undertaken to check for any damage that could have been sustained during shipping. Special attention should be paid to the electrical and hydraulic systems to check for damaged cords and hoses, or for fluid leaks. In the event of damage caused during shipping, contact your carrier to file for a damage claim.

LIFTING MACHINE

This machine is to be lifted in one, fully assembled piece. In order to lift the machine it needs to be in the following condition:

- Saw head in the down position
- Coolant tank emptied

The S20 may be lifted from the FRONT with a forklift, which has a minimum capacity of 4500 lbs (2040 kg) and a fork length of 72" (1830mm).

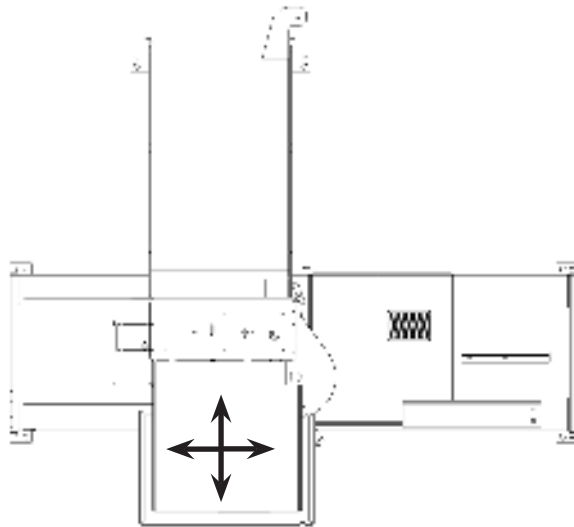
The S20 is shrink-wrapped for shipping from our plant. Remove wrapping from the saw and dispose safely. Complete the inspection for signs of damage. Undo the bolts that hold the saw to the pallet. Retain these bolts to use for machine leveling.



FOUNDATION, LEVELLING AND ANCHORING

Machine location should be carefully selected. A flat concrete floor area should be chosen. It should have enough free space surrounding the machine to enable free access for safe operation and maintenance. The machine should be leveled in both directions (from side to side & from front to back), using a level on the machine out-feed table. Six leveling screws used for securing machine to the pallet during transport, should be installed, one in each corner of the machine base, as shown below. It might be required to place steel plates under leveling bolts to prevent their sinking into the concrete floor. In cases when the machine is to be anchored permanently, anchoring holes are provided. They are located next to the leveling screw holes. The larger diameter hole is used for retaining during shipping and for use with concrete floor anchors. The smaller diameter threaded hole at each corner, are used for leveling the saw. Using a level on the machine out-feed table, level machine front to back and side to side.

NOTE: In some cases leveling the saw infeed with a slight slope towards the blade is recommended. This will prevent coolant from running down the raw stock. (This is especially true when cutting tubing or bundles).

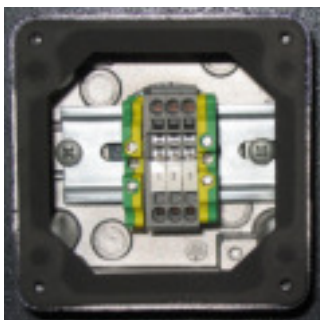


WIRING CONNECTIONS

After the machine is leveled and anchored the necessary power hook-up needs to be performed. Check that there is no sign of shipping damage to the electrical conduits, cords or hydraulic hoses.

As supplied, the S20 is built to run on three phase AC Voltage, as indicated on the machine serial plate and voltage label. Machine voltage is customer specific and should be indicated while ordering the machine. If machine voltage does not match available power source contact factory.

Power connection to the machine is made in the junction box, located at the side of the machine. The power cable can be routed through the supplied hole in the junction box, and connections made to L1, L2, L3, and ground terminals. Proper strain relief should be used on the incoming power cable.



240V & 480V Junction Box

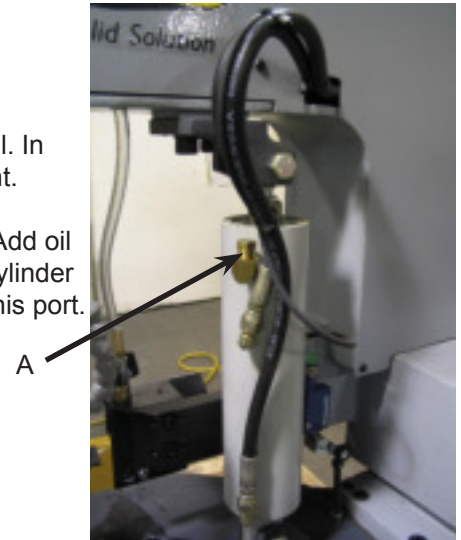


208V & 600V Junction Box

HYDRAULIC OIL

As shipped the saw hydraulic circuit is filled with Texaco Rando HDZ 22 hydraulic oil. In general any mineral hydraulic oil ISO viscosity grade 22 is suitable as a replacement.

The head cylinder contains oil that should be topped up to the level of filler plug **A**. Add oil to the cylinder only with head in the down position. The head is a self air-bleeding cylinder with a small port in the top plate. It is normal for excess of oil to be displaced from this port.



CUTTING FLUID

The S20 uses a pump and reservoir to circulate necessary cutting fluid to the blade for maximum blade life. Your blade supplier will be able to provide information about cutting fluid products that are available for your needs.

No cutting fluid is supplied with the machine. There are two types of coolant available:

- Oil based; dilute in 1:10 ratio (one part of concentrated coolant and 10 parts of water).
- Synthetic; dilute as recommended by manufacturer

SECTION 2 – OPERATING INSTRUCTIONS

OPERATOR CONTROL PANEL

The operator control panel provides the operator with all the controls necessary to operate the saw after the cutting angle has been set and the stock has been loaded and secured. All of the electrical functions and Feed Rate setting are operated from the control panel. **For all the functions to work machine has to be powered up.** The Main Disconnect switch, which is located on the side of control box, has to be in ON position. Emergency Switch has to be released (turn Emergency Knob clockwise to release). For the blade to operate the blade door has to be completely shut and blade tensioned to minimum tension of 1000 kg.



Main Disconnect switch is located on the side on the machine control box.



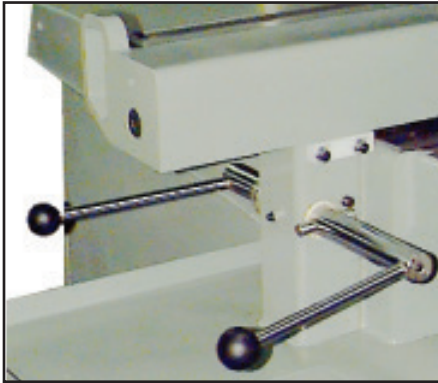
Operator Panel Controls

SWITCH	FUNCTION
EMERGENCY STOP BUTTON	Pressing the red EMERGENCY STOP button will turn OFF all machine functions. To operate machine after emergency stop the EMERGENCY STOP knob has to be released. To release EMERGENCY STOP turn knob clockwise.
COOLANT SWITCH	This switch has three positions: AUTO, OFF, and ON. In the ON position, the coolant system will operate when there is power to the machine. This allows use of the wash gun to clean the machine. In the OFF position, the coolant system is inactive. In the AUTO position the coolant system will only run when the blade is on.
BLADE START	The BLADE START button will start the blade with BLADE SWITCH in ON position. The blade will not start if there is not sufficient blade tension or head door is not closed properly.
BLADE SWITCH	This switch has two positions: ON and OFF. The ON position enables the operator to start the blade by depressing the BLADE START button. The OFF position shuts off the blade if it is running. The blade will not start if the BLADE SWITCH is in this position.
BLADE SPEED DIAL	Sets the blade speed infinitely from 46 ft/min - 330 ft/min.
FEED RATE DIAL	The speed at which the head will descend can be set on the scale from 0 to 10. As the number increases so does the feed rate.
HEAD FEED	Works only when the blade is running. Depressing the HEAD FEED button results in head continuous descent proportionally to the FEED RATE DIAL setting. To stop head movement move the BLADE SWITCH to the OFF position.
FAST APPROACH	Works only when the blade is not running. The BLADE SWITCH can be at an arbitrary position. Depressing and holding the FAST APPROACH button advances the head with fast down speed. Releasing the FAST APPROACH button will stop the head from descending.
BLADE TENSION DISPLAY	Shows the blade tension force in kg. Recommended blade tension is between 1000 - 1200 kg. If blade tension is below 550 kg the blade will not start.

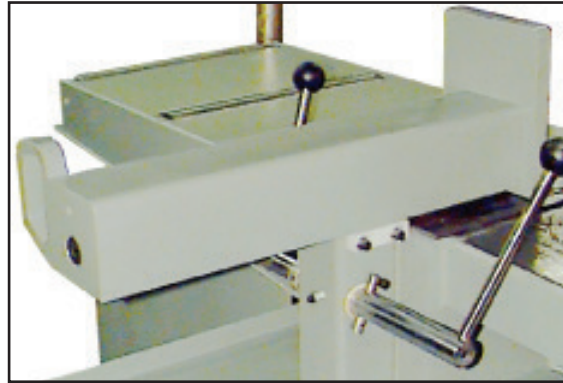
MECHANICAL CONTROLS

WISE CONTROL

The material clamping vise is a cam operated, double handle locking vise. The saw operator can push the vise handle to close the jaw on the material and then lock it from either side of the saw. The handles have two positions, forward toward the stock to unlock the vise and away from the stock to lock. The following photo's show vise handles in locked and unlocked position.



Locked Position



Unlocked Position

HEAD UP

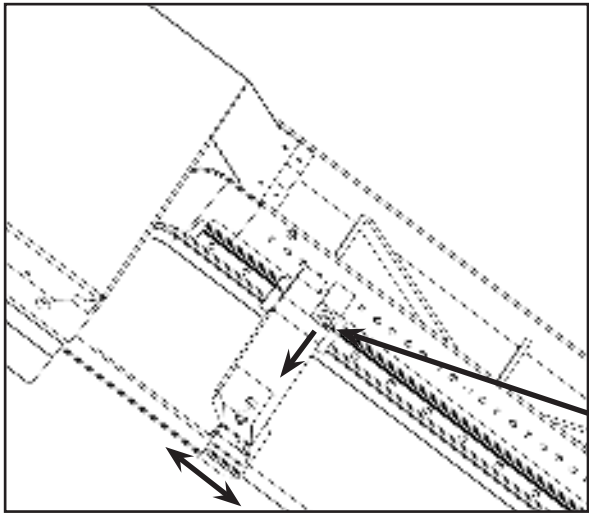
After finishing a cut the operator needs to manually lift the head to the required height by pushing on the provided handle below the blade tension wheel. Required lifting force is factory set using counterbalance springs to approximately 35 lbs at point of effort.

Lift here



GUIDE ARM POSITIONING

The S20 idler side guide arm is adjustable to accommodate varying material widths. The guide arm should be adjusted as close to the material as possible while still allowing it to pass. This process of matching the guide arm spacing to the material size is important to optimize blade life and ensure straightness of the cut.



To adjust the guide arm location pull down the locking handle and slide the guide arm to the required position, and then release the locking handle. The locking handle is spring energized and will self return to the locking position.

Locking handle

COOLANT FLOW

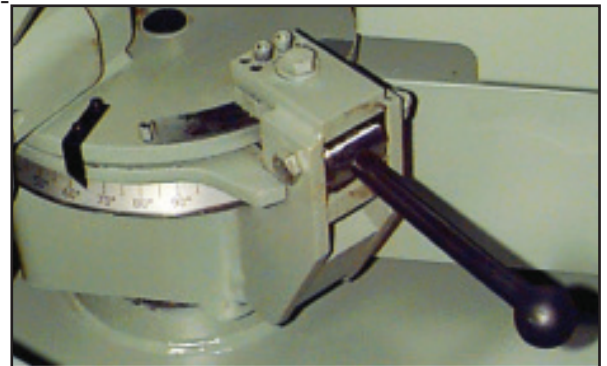
The S20 bandsaw is equipped with a coolant pump supplying coolant flow to four coolant outlets.

- The wash gun is provided for clearing chip accumulations.
- Guide arm coolant nozzles, one at each guide arm, are equipped with a flow control shut-off valve. The guide arm nozzles should be adjusted to apply an even covering of coolant to the blade.
- The flexible nozzle can be pointed directly where necessary. It should be used when cutting wide work pieces, bundles, or structurals. Set extra coolant into the saw kerf at about mid span of the cut. The flexible nozzle has a flow control shut-off valve.

NOTE: When cutting materials that do not need constant coolant, such as cast iron, some coolant flow is still required for blade lubrication to prevent blade scoring by carbide pads as the blade moves through them.

HEAD SWING and BREAK

An integral function of the S20 is the ability to make mitered cuts at angles between 90 and 30 degrees. The Head swing of the S20 is easily changed to set a different cutting angle by first releasing the Angle Brake lever, and then manually moving the Head to the cutting angle desired. An angle scale with a pointer in clear view of the saw operator allows for accurate setting of the cutting angle. The Angle Brake lever is then locked in position by forcing it into the down position. It should be noted that the angle brake should be locked into position whenever cutting with the saw. The photo illustrates the Angle Brake in the locked position at 65 degrees. To set the saw to the 90 degree position, the Head (in the fully down position) is moved until the frame meets the 90 degree stop bolt, which is located in the coolant tray at the drive end of the head.



Head swing scale and angle brake locked

BLADE BASICS

Technology is rapidly changing all aspects of production machining. Metal cutoff is no exception. The advances made in the bandsaw industry have definitely brought down the cost per cut, despite the three-fold increase in the price of newer technology blades. Variable pitch (following pages), bi-metal blades (like the $\frac{3}{4}$ or $\frac{4}{6}$ bi-metal blade supplied with the Hyd-Mech machine) last much longer, cut faster and more accurately than the conventional carbon steel blades. In order to take advantage of the superiority of bi-metal blades, it is critical to properly “break in” a new blade. This is accomplished by taking two or three cuts through solid four or five-inch diameter mild steel at an extremely slow feed rate. These two or three slow cuts sufficiently lap (polish) the new blade so that it does not snag the material being cut. Proper break-in will alleviate blade vibration, improve surface finish and accuracy, and improve expected blade life.

1. **A new blade must be properly “broken-in”.** Proper break-in will alleviate blade vibration, improve surface finish and accuracy, and improve expected blade life. The most convenient way to do this is to cut the intended work-piece, at the standard recommended blade speed for that material, but with the feed rate reduced to about 25% of normal. Near the end of the first cut, increase the feed rate again, and once again when the blade approaches the end of the second cut. Keep increasing feed rate in this fashion, so that normal feed rate is reached after 300 to 400 square centimeters of cutting.
2. **Generous coolant application is essential with almost all materials.** A high quality and well-mixed coolant will dramatically extend blade life, and will increase cutting rate and surface finish. On those few materials where coolant is undesirable, a slight coolant flow or periodic oiling of the blade is necessary to prevent the blade from being scored by the carbide guides.
3. **The Stock being cut must be securely clamped in the vises.** Stock movement during cutting will strip blade teeth. Noticeable stock vibration reduces cutting performance and blade life – consideration should be given to reorientation of the stock, or additional clamping measures (e.g. wood between vise jaws and work-piece).
4. **The proper blade speed for the work-piece material must be selected.** Use the following chart as a starting point:
Blade speeds higher than recommended will quickly dull the blade. Blue chips are evidence of excessive blade speed.
Lower than recommended speeds will not prolong blade life, and will require reduced feed rate. However, reduced speeds may be helpful in reducing vibration, and therefore may increase blade life.

BLADE BASICS - CUTTING SPEEDS FOR VARIOUS MATERIALS			
	Blade Speed (in SFM)	Coolant Required	
Free Cutting Steels AISI # 1045 Series	310	YES	✓
Low/Medium Carbon 1045 - 1045	220	YES	✓
High Carbon Steels 1045 - 1045	140, 220	YES	✓
Alloy Steels	140, 220	YES	✓
Tool Steels	90, 140	YES	✓
Pipe & Structures	140, 220	YES	✓
Nickel Base Alloys	90, 140	YES	✓
Copper Base Alloys	140, 220	YES	✓
Stainless Steels	140, 220	YES	✓
Super Alloy, 400, 300	140, 220	YES	✓
Cast Iron	140, 220	NO	✓
		OR Grease	

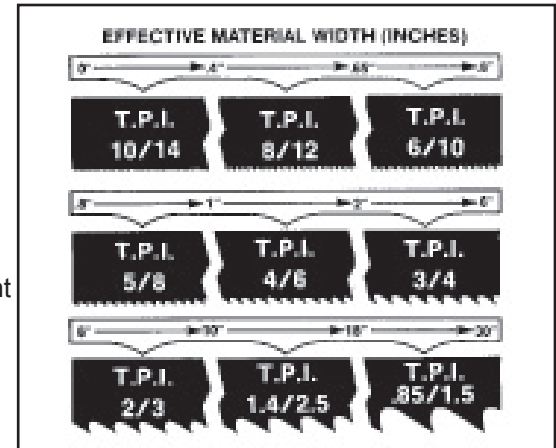
Blade Speed Selection Chart

5. **The proper feed rate must be applied.** Feed rate is the speed which the head “free-falls” and is set with the feed rate control knob. The head will descend more slowly when the blade encounters the work-piece. Verification of proper feed rate is provided by the appearance of the cut chips, which ideally form nicely curled “clock springs”. Note that cast irons and interrupted cuts result in short, broken chips even at ideal feed rates. Excessive feed rate will result in short blade life and/or crooked cuts.

DETERMINE OPTIMUM BLADE PITCH – TEETH PER INCH (T.P.I.)

Selecting a blade with proper tooth pitch is important in order to achieve optimal cutting rates and good blade life. For cutting narrow or thin wall structural materials, a fine blade with many teeth per inch (T.P.I.) is recommended. For wide materials a blade with a coarse pitch should be used. See the sketch below for the blade pitch changes for differing effective material widths.

It is impractical to change the blade to the proper pitch every time a different width of material is cut and it is not necessary, but remember that the optimum blade will cut most efficiently. Too fine a blade must be fed slower on wide material because the small gullets between the teeth will get packed with chips before they get across and out of the cut. Too coarse a blade must be fed slower because it has fewer teeth cutting and there is a limit to the depth of a cut taken by each tooth.



OPTIONAL EQUIPMENT/CONTROLS

MIST COOLANT

Mist Coolant - the air powered pump delivers a regulated number of pulses of lubricant to a single applicator nozzle. The unit has two control screws:

- Pulse / Minute - adjusts the rate of lubricant use. About 8 to 12 pulses per minute is optimum - more is not better.
- Air Screw - regulates the jet of air that projects the lubricant from the nozzle onto the blade. Adjustment should be such that lubricant covers the blade without blowing the mist beyond the back edge of the blade.

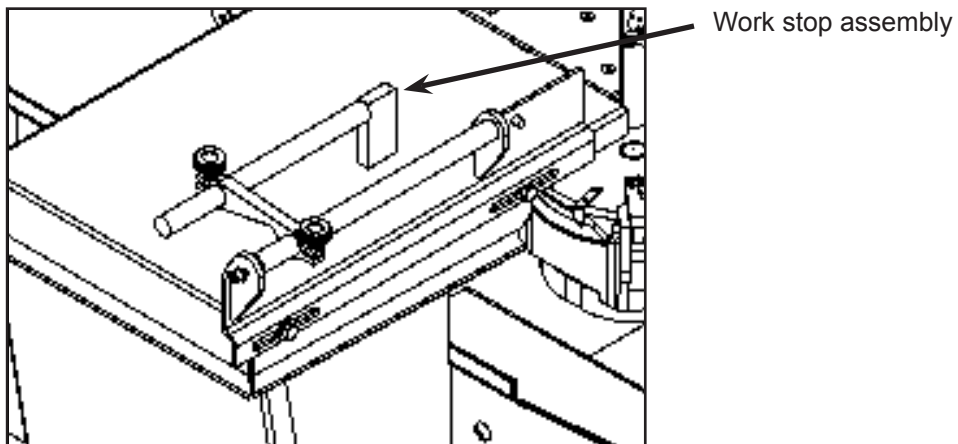
Pulse/Minute Adjustment



Air screw

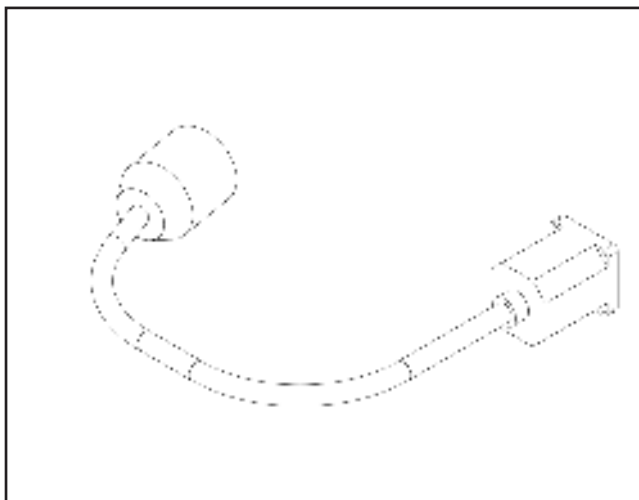
WORK STOP

The work stop is used to set a consistent cut length from 0 to 34 inches. The photo shows the stop at a short length, which is adjusted with one or both of the locking handles. The bar with the actual stop attached to it can be removed, turned 180 degrees end for end, and inserted for longer lengths. The work stop may also be swung out of the work area when it is not required.



WORK LAMP

Part # 371789

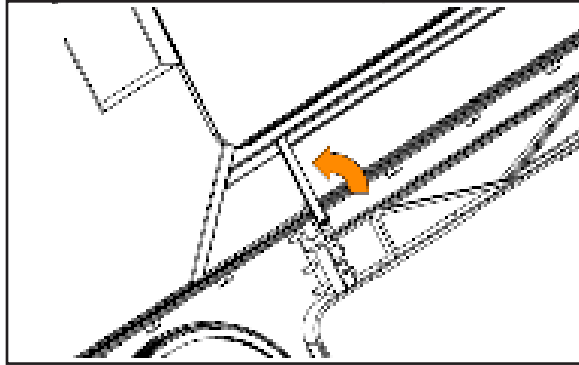


SECTION 3 - MAINTENANCE and TROUBLESHOOTING

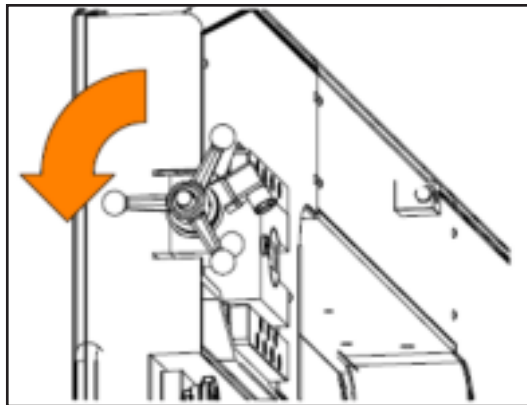
BLADE CHANGING PROCEDURE

NOTE: Wear gloves for protection from the sharp blade.

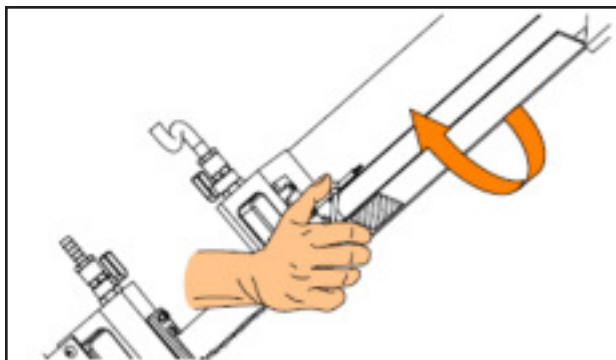
1. Open the Wheels door by unscrewing the two knobs.



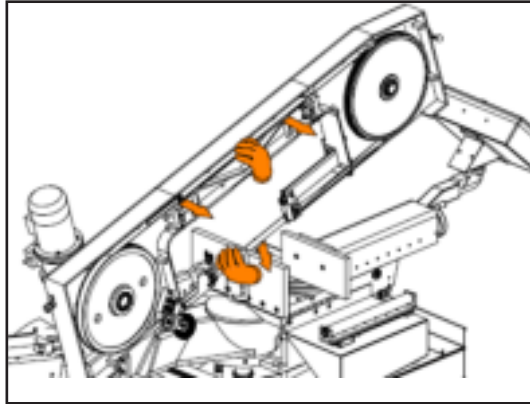
2. Loosen the Blade Tensioner by turning counter clockwise.



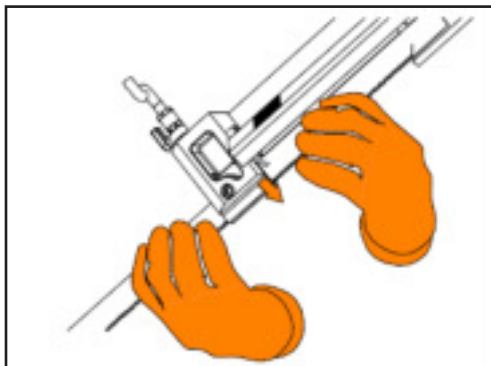
3. Open the blade guard at idler guide arm by undoing the mounting screws and removing it as illustrated below



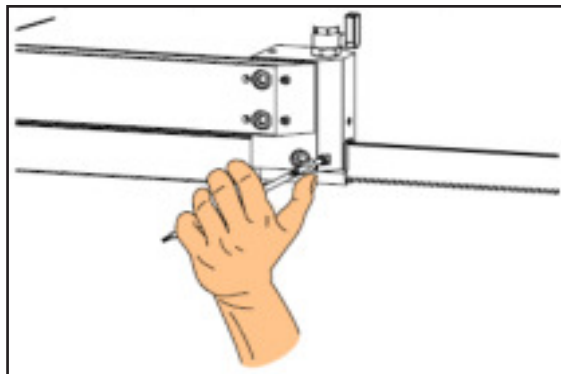
-
4. Remove the worn blade by sliding it off the wheels and out off both guide blocks



5. Your new blade will be in a coil. While wearing gloves, hold the blade away from yourself; twist the blade to uncoil it. Do not let the blade teeth bounce on the concrete floor as some damage may be caused.
6. Place the new blade in the carbide guides and then slide the blade over the wheels. The teeth should be pointing towards the drive side as they pass through the carbide guides.
7. Make sure there is a small amount of play between the blade and guide carbides. The blade band should be snug but able to move freely up and down.



8. If the amount of play is not sufficient for the blade to run smoothly, adjust the locking torque of the screws with an Allen key.



-
9. With the blade in place, turn the tensioner handle clockwise until Blade Tension Display shows required value. Recommended blade tension is 1250 - 1350 kg. If blade is under tensioned the blade motor will not start
 10. Replace the blade cover and close wheels door.
 11. Jog the blade a few rotations to check that the blade is not moving in or out on the blade wheels. As the blade tracking will stay fairly constant, it should be checked occasionally by measuring the gap between the back of the blade and wheel flange. The gap should measure .040-.080". If the tracking requires adjustment, follow the instructions below.

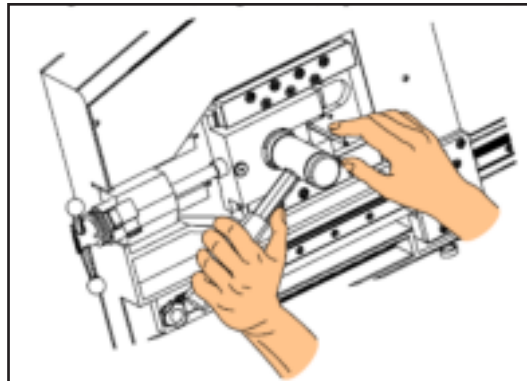
BLADE TRACKING ADJUSTMENT

First, inspect the blade wheels for wear or damage and repair as required, Blade tracking adjustment should always begin at the wheel where the tracking is farthest out of specification. Using the instructions below, adjust the worst wheel, jog the blade and recheck both wheels. Repeat this process until both wheels are within specification.

Idler Wheel Adjustment

The Idler Wheel must be adjusted so that it is aligned with the drive wheel. The purpose of the adjustment is to ensure that the back of the blade remains about .040-.080" away from the wheel flange during rotation.

1. Release blade tension.
2. Open wheel cover.

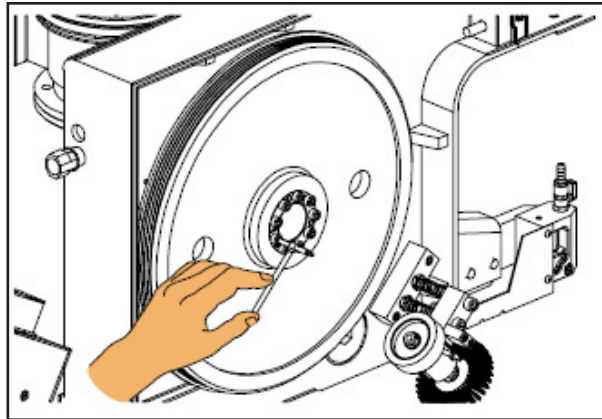


3. Loosen the screw and using a mallet tap the shaft in or out.
4. Restore the machine and run blade for few wheel rotations.
5. Check the distance between the blade and wheels flange.
6. If necessary repeat above steps until proper gap is achieved

Drive Wheel Adjustment

The Drive Wheel adjustment is closely linked to adjustment of the Idler Wheel. The purpose of the adjustment is to ensure that the back of the blade remains about .040-.080" away from the wheel flange during rotation.

1. Open wheel cover.
2. Loosen all the screws on the wheel and manually move it in or out until the blade is correctly distanced from the wheel flange.

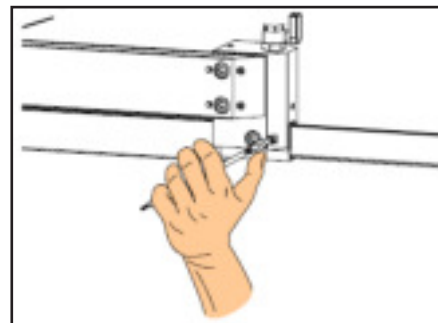
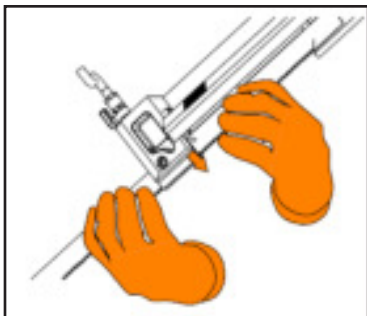


3. Restore the machine and run blade for few wheel rotations.
4. Check the distance between the blade and wheels flange.
5. If necessary repeat steps until proper gap is achieved

BLADE GUIDE ADJUSTMENT

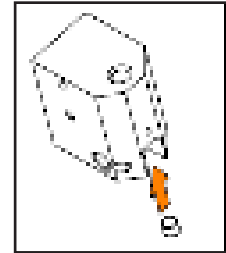
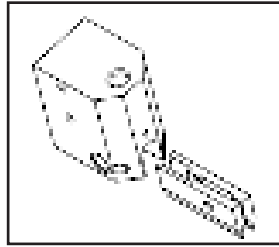
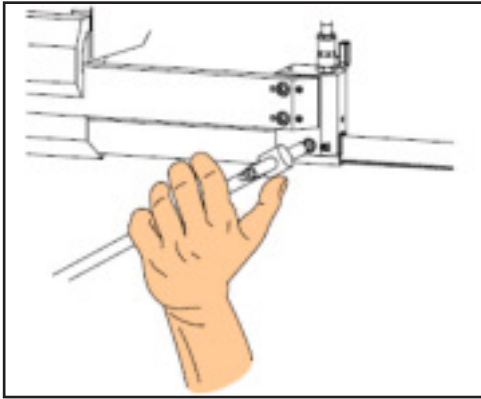
At the bottom of the guide arms are the blade guide block assemblies with carbide pads. These assemblies will need to be adjusted occasionally as the carbide pads become worn, or if a blade with different thickness is used. To adjust properly, follow this simple procedure.

1. Make sure there is a small amount of play between the blade and guide carbides. The blade band should be snug but able to move freely up and down.
2. If the amount of play is not sufficient for the blade to run smoothly, adjust the locking torque of the screws with an Allen key



CARBIDE REPLACEMENT

The blade guide blocks are equipped with one top carbide and two side carbide inserts each. The working life of carbide guides is practically the same as that of the machine itself. However, if required they can be replaced by removing the plate fixing screw as shown.

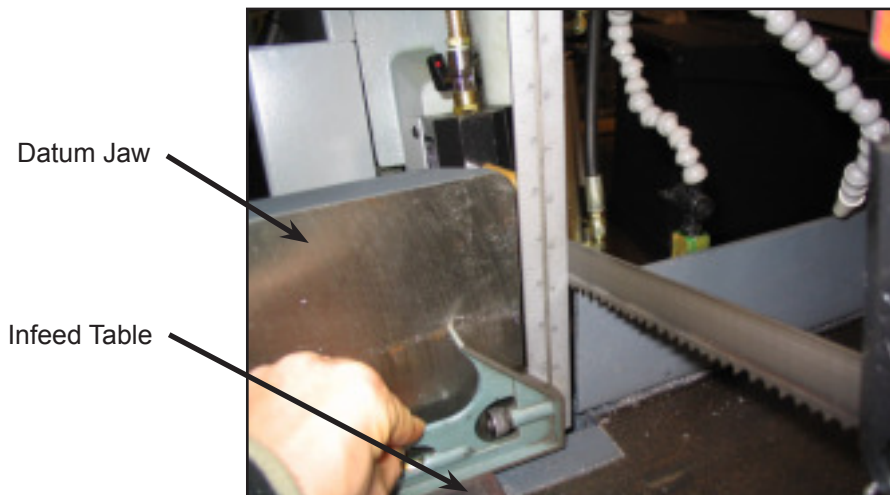


The top carbide is press fit into the guide block. If the top carbide needs replacement the whole guide block has to be changed.

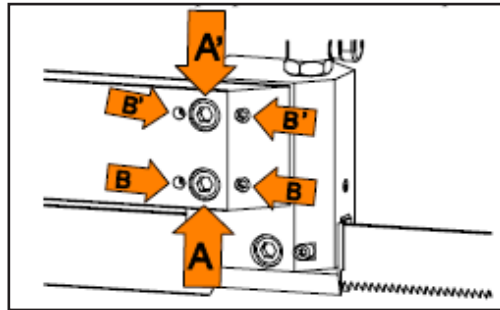
BLADE PERPENDICULARITY

The perpendicularity of the blade to the work table and proper blade tension are vital for achieving straight cut. This adjustment is carried out using a workshop square, which should be placed against the side of the blade while resting on the work table in the middle of the guide arm span. The square edge should contact the blade uniformly along the whole blade width. Follow the procedure below if the guides need to be adjusted to achieve the proper blade perpendicularity.

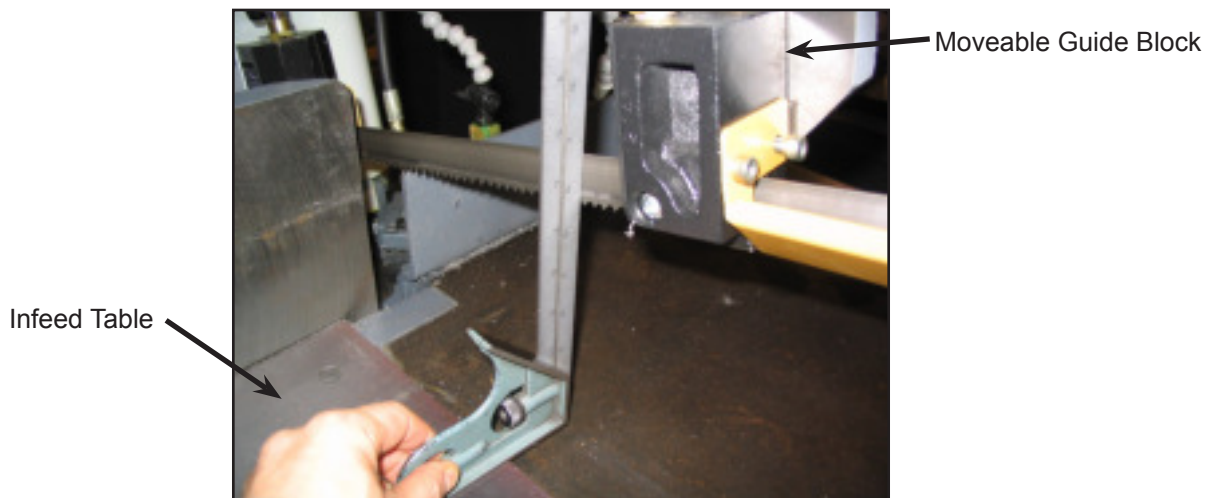
1. Disconnect machine from power.
2. Open the vise.
3. Position the square on the clean work surface of the infeed table against the blade close to the datum jaw at a point where the blade teeth do not prevent contact.



4. If the blade touches the square at the bottom loosen the top fixing screw “A” and tighten screws “B” the same amount until the square edge contacts the blade uniformly along the whole blade width. If contact is at the top of the square, loosen the bottom fixing screw “A” and tighten screws “B” the same amount until the square edge contacts the blade uniformly along the whole blade width.



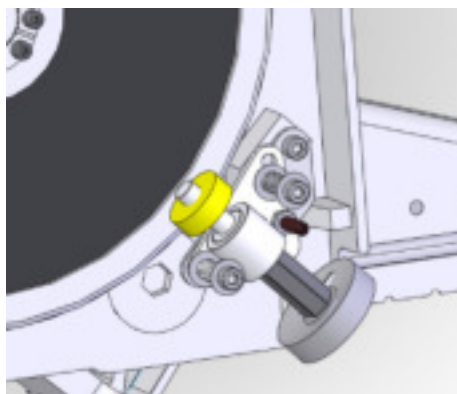
5. Position the square on the clean work surface of the infeed table against the blade close to the movable guide block at a point where the blade teeth do not prevent contact.



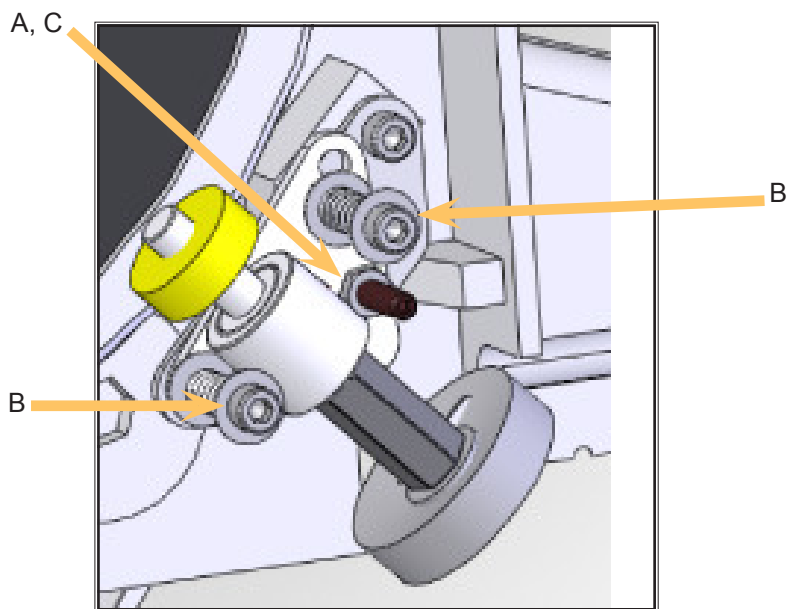
6. Repeat step 4 to adjust the movable guide block.

BLADE BRUSH ADJUSTMENT

The machine leaves the factory with the blade brush adjusted for maximum life of the brush. This setting places the ends of the blade brush wires so as to contact the blade at the bottom of the blade gullets. The plastic drive wheel that is driven by the drive wheel face should be held against the wheel face with the minimum force that is necessary to ensure brush rotation. As the blade brush wears it is necessary to periodically adjust it closer to the blade or if a new brush is installed, further away from the blade.



As shown, there are two springs on socket head screws holding the brush assembly against the blade. There is also an adjusting stop socket set screw **A** with a hex nut **C** on it. This adjusting set screw works as a stop determining the brush position in respect to the blade. To move the brush closer to the blade loosen the hex nut and turn the setscrew **A** counter clockwise with an Allen key. Then rotate the brush stem towards the blade and turn the spring loaded socket head bolts **B** in to maintain proper spring preload. To move the brush away from the blade loosen the spring loaded socket bolts **B** respectively. Then rotate the brush stem away from the blade and turn setscrew **A** clockwise to lock the brush in position. Lock the hex nut to prevent the set screw from loosening.



ANGLE BRAKE ADJUSTMENT

The clamping force on the swivel brake can be adjusted to ensure that the Head is held securely and does not move during cutting. The brake handle should be adjusted so that it does not “bottom out” or hit its movement limit, yet holds the head securely.

ANGLE BRAKE ADJUSTMENT PROCEDURE

STEP 1 Loosen locking cap screws “B” with a 6mm Allen key.

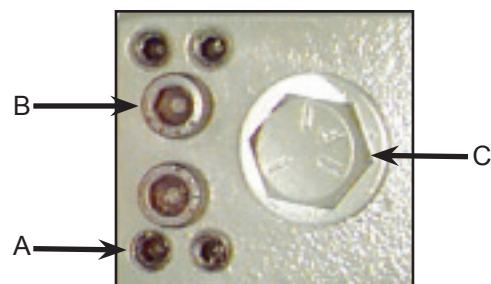
STEP 2 Tighten all 4 set screws “A” until snug with a 4mm Allen key

STEP 3 Back out the “A” screws ¼ of a turn

STEP 4 Tighten the locking cap screws “B”

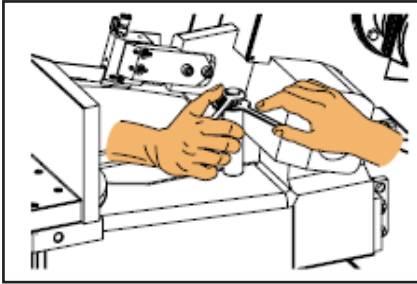
STEP 5 Swing the head to 45° and back to ensure that the head moves freely and does not bind on the pivot surfaces. Continue to step 6 if necessary.

STEP 6 Adjust the clamping force bolt “C” with a 19mm wrench. If not tightened enough, the locking handle will “bottom out” and not hold the head firmly



HEAD DOWN LIMIT SWITCH

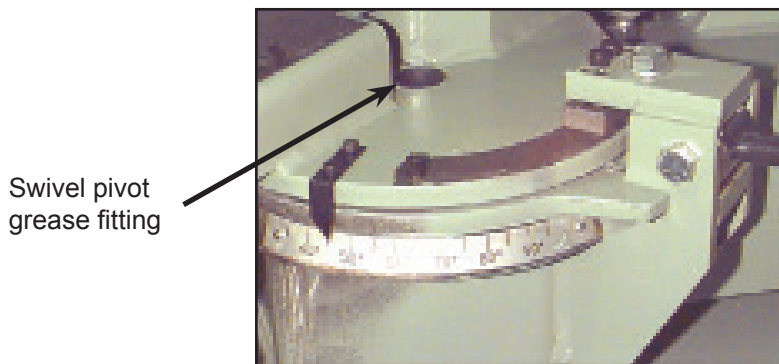
The Head down limit switch operates to cut power to the blade motor and the coolant pump motor when the Head has descended to the bottom of its travel. The Head is adjusted so that the blade will descend slightly past the level of the table wear strip. This setting is critical to ensure that the blade has cut fully through the stock.



Adjustment of the limit switch is made by changing the position of the set bolt. Lengthening the set bolt will cause the limit switch to activate sooner. Shortening the setting bolt by turning it into the swivel will allow the head to come down lower.

LUBRICATION

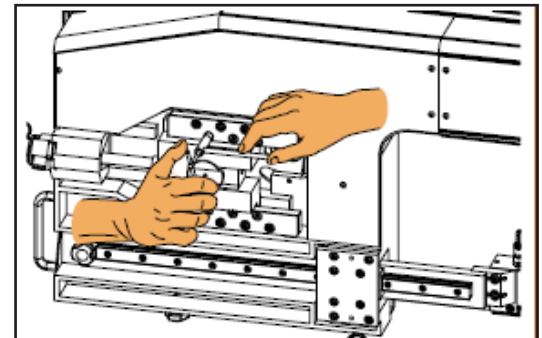
The S20 was designed to minimize the maintenance requirements. Moving assemblies and contact faces need lubrication on a regular schedule whether they are in heavy use or not. The lubrication requirements of the S20 Series III are primarily the saw pivot point which is equipped with a grease fitting, and metal to metal surfaces that require lubrication to prevent wear and seizure. General purpose industrial grease is suitable for application.



BLADE TENSION SLIDE ADJUSTMENT

To reduce the play, which may develop over time between the blade tensioner slide and slide gibs, adjust the screws between the gibs and slide as follows:

1. Remove the head front cover.
2. Undo blade tension.
3. Remove blade from wheels.
4. Remove the pin connecting tensioner actuator with slider.
5. Move the slider by hand back and forth to locate any friction or excessive play.
6. Loosen the nuts, using tubular nut driver while holding the set screws firm with Allen key.
7. Tighten the set screws to take up any play or loosen them up in case of excessive friction.
8. Retighten the nuts with tubular nut drive



GEARBOX LUBRICATION

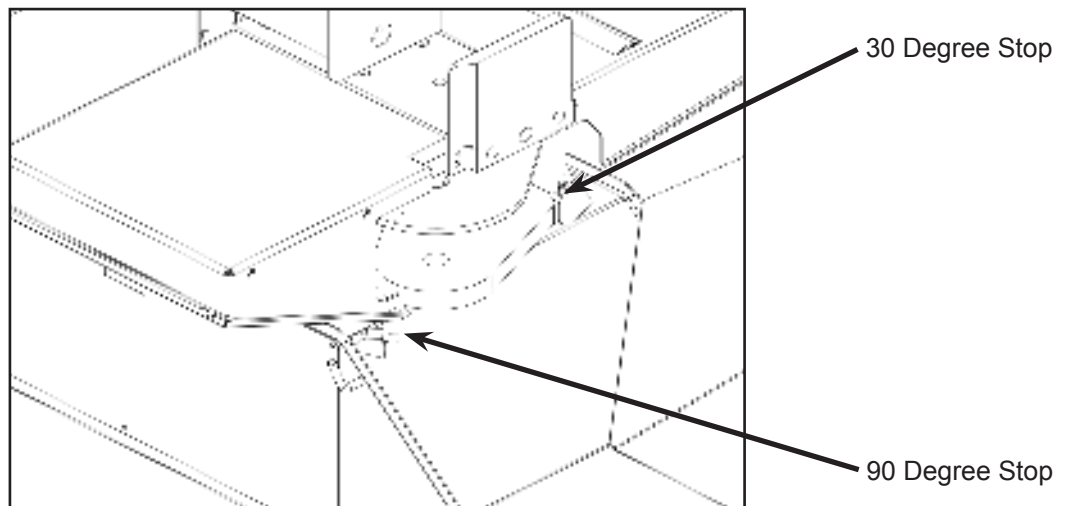
The machine is equipped with a worm gear which is permanently lubricated and therefore maintenance free. The box has no filler cap, level checker and drain, as it already contains the correct quantity of synthetic oil, guaranteeing perpetual lubrication of the crown and worm gear. Below is a short list of synthetic oils for permanent lubrication:

BP Energol SG XP220
KLUBER Syntheso D220EP
ESSO Glycolube Range 220
IP CT614
SHELL Tivela Oil SC 320

Gearbox Capacity - 0.084 Gallons (0.320 Litres)

90 AND 30 DEGREE STOP ADJUSTMENT

There are two adjustable mechanical stops for 90 degree and 30 degree head swing position that can be recalibrated if required.



TROUBLE SHOOTING GUIDE

	PROBLEM	CAUSE AND SOLUTION
1	Cutting out of square (vertically)	Carbide guide adjustment incorrect (adjust)
		Feed rate excessive (reduce)
		Blade worn (replace)
		Guide arms too far apart
		Blade pitch incorrect
2	Cutting out of square (horizontally)	90 Degree stop not set correctly (adjust)
		Stock not square in vise (reset material)
		Angle pointer out of adjustment
		Stock is not secure in the vise (reset vise)
3	Head cylinder creeps in hold	Cylinder cup seals defective (replace)
		Hydraulic hose leaking
		Head hold valve defective
4	Blade tracking incorrect	Improper tension (adjust)
		Tracking needs adjustment
		Wheel is worn or in poor condition
5	Blade stalls in cut	More tension needed
		Excessive feed rate (reduce)
		Blade pitch incorrect
		Carbide guides over tightened
6	Blade vibrating excessively	Blade speed too fast
		More blade tension needed
		Guide arms too far apart
		Feed rate too slow (increase)
		Carbide guides worn or loose (adjust or replace)
Note: new blades tend to vibrate until they are “broken in”		
7	Excessive blade breakage	Excessive blade tension (reduce)
		Excessive feed rate (reduce)
		Top guide(s) damaged (replace)
		Blade back rubbing against wheel flange
		Check tracking
8	No coolant flow	No coolant (add)
		Check coolant ports for blockage
		Line blockage (blow out lines with compressed air)
		Coolant pump inoperable (replace)
		Coolant pump has lost its prime (sink pump in coolant)

9	Blade will not start	Lift head off limit switch
		Control fuse blown
		Turn Emergency button
		Check if proper blade tension
		Check safety door interlock switches
10	Machine stops before cut is completed or runs on after cut is completed	Adjust head down limit switch bolt

SECTION 4 - ELECTRICAL

**FOR ELECTRICAL SCHEMATICS AND COMPONENTS PARTS LISTS
SEE PDF ON ATTACHED CD**

240VAC

THE FUSE RATING FOR THIS BANDSAW ARE:

F1 & F2 = 1 AMP FAST.

F3, F4 & F5 = 0.5 AMP TIME DELAY

F6 = 5 AMP TIME DELAY

480VAC

THE FUSE RATING FOR THIS BANDSAW ARE:

F1 & F2 = 0.75 AMP FAST.

F3, F4 & F5 = 0.75 AMP TIME DELAY

F6 = 5 AMP TIME DELAY

SECTION 5 - HYDRAULIC

**HYDRAULIC SCHEMATICS & PLUMBING DIAGRAMS: SEE PDF
ON ATTACHED CD**

SECTION 6 - MECHANICAL ASSEMBLIES

**MECHANICAL ASSEMBLY DRAWINGS & PARTS LIST: SEE PDF
ON ATTACHED CD**

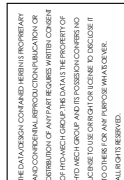
SECTION 7 - OPTIONS

OPTIONAL ASSEMBLY DRAWINGS: SEE PDF ON ATTACHED CD

SECTION 8 - SPECIFICATIONS

S20 Bandsaw Specification List

Capacity - 90°	rectangular	13" (330mm) high x 18" (457mm) wide
	round	13" (330mm) dia
Capacity - 45°	rectangular	13" (330mm) high x 10.9" (277mm) wide
	round	12" (305mm) dia
Capacity - 60°	rectangular	13" (330mm) high x 7.3" (185mm) wide
	round	8" (203mm) dia
Blade	length	14'10" (4521mm)
	width	1" (25mm)
Blade Speed	46-328 surface feet/min (40-100 m/min)	
Blade Guides	Pre Set carbide inserts	
Blade Wheel Diameter	17 3/4" (451mm)	
Motors	standard	3HP (2.2 kW)
Coolant Pump	2.4 US Gal/min (9.1 Litre/minute)	
Coolant Reservoir	6 US Gallons (22.7 Litres)	
Table Height	31" (787mm)	
Machine Weight	1800 lbs (816 kg)	
Machine Work Load	5,000 lbs (2268 kg)	
Overall Dimensions	92" (2337mm) wide x 75" (1905mm) long x 52" (1321mm) high	



SECTION 9 - WARRANTY

Warranty

Hyd-Mech Group Limited warrants parts/components on each new S20 bandsaw to be free from failure resulting from defective material and workmanship under proper use and service for a period of one year following the date of shipment from the factory. Hyd-Mech's sole obligation under this warranty is limited to the repair or replacement without charge, at Hyd-Mech's factory, warehouse, or approved repair shop any part or parts which Hyd-Mech's inspection shall disclose to be defective. Return freight must be prepaid by the user.

This warranty, in its entirety, does not cover maintenance items, including but not limited to lubricating grease and oils, filters, V-belts, saw blades, etc., nor any items therein which show signs of neglect, overloading, abuse, accident, inadequate maintenance, or unauthorized altering.

MOTOR, GEARBOX, PUMP, ELECTRIC COMPONENTS, VALVES, HOSES, FITTINGS, and any other items used in the manufacture of the S20, but not originally manufactured by Hyd-Mech are subject to the original manufacturer's warranty. Hyd-Mech will provide such assistance and information as is necessary and available to facilitate the user's claim to such other manufacturer.

Liability or obligation on the part of Hyd-Mech for damages, whether general, special or for negligence and expressly including any incidental and consequential damages is hereby disclaimed. Hyd-Mech's obligation to repair or replace shall be the limit of its liability under this warranty and the sole and exclusive right and remedy of the user.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, WRITTEN OR ORAL, INCLUDING WITHOUT LIMITATION ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

This warranty may not be changed, altered, or modified in any way except in writing by Hyd-Mech Group Limited

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