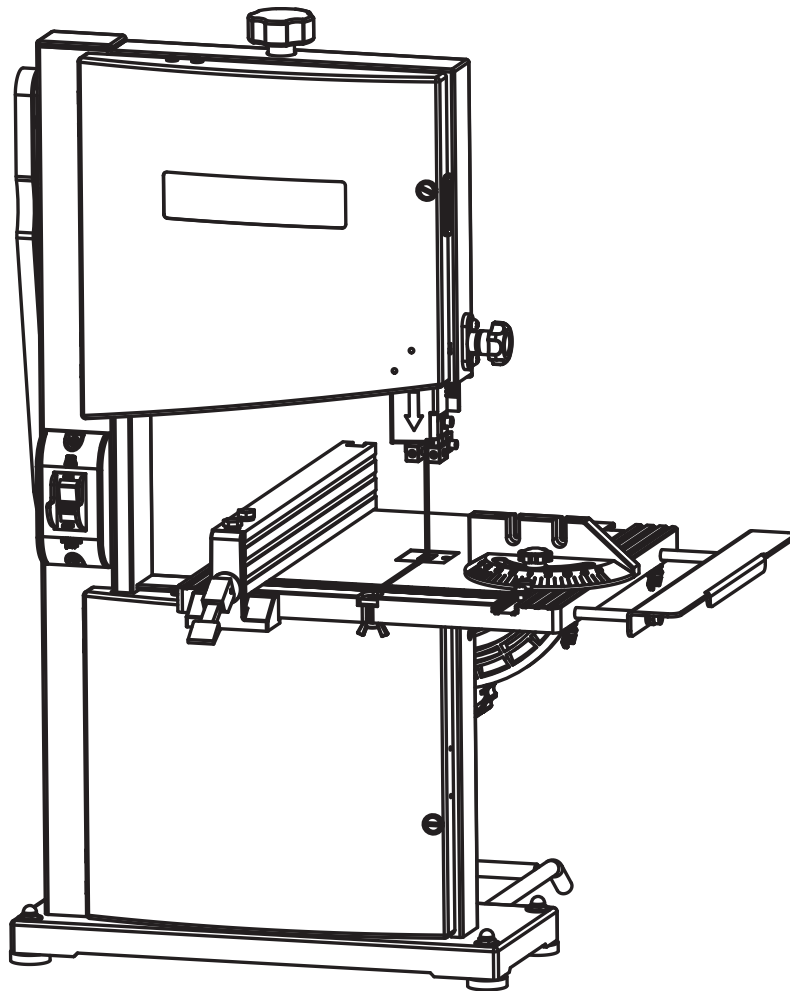


model no. 055-6748-6

Mastercraft[™]

BAND SAW WITH EXTENSION TABLE



IMPORTANT:

Please read this manual carefully before running this band saw and save it for reference.

**INSTRUCTION
MANUAL**

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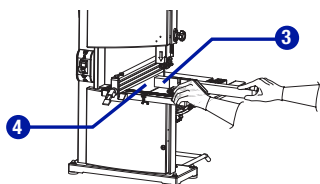
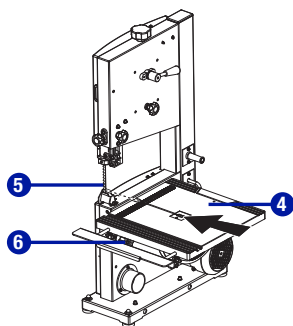
NOTE:

If any parts are missing or damaged, or if you have any questions, please call our toll-free helpline at 1-800-689-9928

**SAVE THESE INSTRUCTIONS**

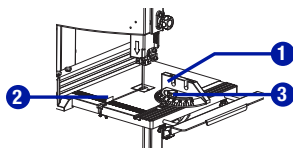
This manual contains important safety and operating instructions. Read all instructions and follow them when using this product.

- 1 • Holding the work table with your left hand while pulling the table, tilt adjustment knob (6) away from the saw frame, align the teeth on the table support assembly (7) with the teeth on the table tilt adjustment knob (6).
→ see page 21



- 2 • Use both hands to hold the workpiece (3) flat against the work table (4) and to guide along desired path.
• Turn the band saw On. Wait until the band saw reaches maximum speed (refer section "Specifications").
→ see page 29

- 3 • Place the mitre gauge (1) on the mitre gauge slot of the work table (2).
• Use the gauge knob (3) to set the desired angle on the gauge scale.
→ see page 29



SPECIFICATIONS

Motor	120 V, 60 Hz, 2.5A
Motor speed	2556 SFM (no load)
Blade length	62" (157.5 cm)
width	1/4" (6.35 mm)
teeth	6 TPI
thickness	1/64" (0.3 mm)
Main table size	11 3/4 x 11 3/4" (30 x 30 cm)
Extension table size	11 3/4 x 1 9/16" (30 x 4 cm)
Table Tilting Range	0°-45°
Max. extension table range	2 5/32" (5.2 cm)
Max. cutting depth	3 1/8" (8 cm)
Max. cutting width	9" (23 cm)
Weight	40 lb 13 oz (18.5 kg)

SAFETY GUIDELINES

This manual contains information that relates to PROTECTING PERSONAL SAFETY and PREVENTING EQUIPMENT PROBLEMS. It is very important to read this manual carefully and understand it thoroughly before using the product. The symbols listed below are used to indicate this information.



DANGER!

Potential hazard that will result in serious injury or loss of life.



WARNING!

Potential hazard that could result in serious injury or loss of life.



CAUTION!

Potential hazard that may result in moderate injury or damage to equipment.

Note: The word "Note" is used to inform the reader of something the operator needs to know about the tool.

SAFETY RECOMMENDATIONS

These precautions are intended for the personal safety of the operator and others working with the operator. Failure to follow these instructions may result in a permanent loss of vision, serious personal or even fatal injury, property damage and/or tool damage. Please take time to read and understand them. Safety is a combination of common sense, staying alert, and knowing how your band saw works.

- READ and become familiar with this entire instruction manual. LEARN the tool's applications, limitations, and possible hazards.
- AVOID DANGEROUS CONDITIONS. DO NOT use power tools in wet or damp areas, and DO NOT expose them to rain. Keep work areas well lit. Attach the dust extraction unit. If there are connections for dust extraction and collection equipment, then make sure that the equipment is correctly attached and used.
- DO NOT use power tools in the presence of flammable liquids or gases.
- ALWAYS keep your work area clean, uncluttered and well lit. DO NOT work on floor surfaces that are slippery with sawdust or wax.
- KEEP BYSTANDERS AT A SAFE DISTANCE FROM the work area, especially when tool is operating. NEVER allow children or pets near the tool.
- DO NOT FORCE THE TOOL to do a job that it was not designed to do.
- DRESS FOR SAFETY. DO NOT wear loose clothing, gloves, neckties, or jewellery (rings, watches, etc.) when operating the tool. Inappropriate clothing and items can get caught in moving parts and pull you in. ALWAYS wear non-slip footwear, and tie back long hair.



WARNING!

To avoid mistakes that could cause serious injury, do not plug in the band saw until you have read and understood the following rules.

- WEAR A FACE MASK OR DUST MASK. Sawing operations produce dust. Dust generated from certain materials can be hazardous to your health. Always operate the band saw in a well-ventilated area, and provide for proper dust removal. Wear a face mask or dust mask when operating.
- ALWAYS remove the power cord plug from the electric outlet when making adjustments, changing parts, cleaning or working on the tool.
- KEEP GUARDS IN PLACE AND IN WORKING ORDER.
- AVOID ACCIDENTAL START-UPS. Turn the power switch to the Off position before plugging in the power cord.
- REMOVE ADJUSTMENT TOOLS. ALWAYS make sure all adjustment tools are removed from the band saw before turning it on.
- NEVER LEAVE A RUNNING TOOL UNATTENDED. Turn the power switch to the OFF position. DO NOT leave tool until it has come to a complete stop.
- NEVER STAND ON THE TOOL. Serious injury could result if the tool tips or is accidentally jarred. DO NOT store anything above or near the tool.
- DO NOT OVERREACH. Keep proper footing and balance at all times. Wear oil-resistant, rubber-soled footwear. Keep the floor clear of oil, scraps and other debris.
- MAINTAIN TOOLS PROPERLY. ALWAYS keep tools clean and in good working order. Follow instructions for lubricating and changing accessories.
- CHECK FOR DAMAGED PARTS. Check for alignment of moving parts, jamming, binding, breakage, improper mounting or any other conditions that may affect the operation. Any part that is damaged should be properly repaired or replaced before use.
- MAKE THE WORKSHOP CHILDPROOF. Use padlocks and master switches, and ALWAYS remove starter keys.
- DO NOT operate the tool if you are under the influence of any drugs, alcohol or medication that could affect your ability to use the tool properly.

ADDITIONAL SAFETY GUIDELINES FOR BAND SAW

- TO AVOID INJURY FROM UNEXPECTED MOVEMENT, make sure the saw is on a firm, level surface and that it is properly secured to prevent rocking. Make sure there is adequate space for operations. Bolt the saw to a support surface to prevent slipping or sliding during operation.
- TURN OFF AND UNPLUG the saw before moving it.
- USE THE CORRECT SIZE AND STYLE OF BLADE.
- MAKE SURE THE BLADE TEETH POINT DOWN AND TOWARD THE TABLE.
- BLADE GUIDE, SUPPORTS, BEARINGS AND BLADE TENSION must be properly adjusted in order to avoid accidental blade contact, and to minimize blade breakage. To maximize blade support, always adjust the upper blade guide and blade guard so that it barely clears the workpiece.
- TABLE LOCK HANDLE SHOULD BE TIGHT.
- USE EXTRA CAUTION with very large, very small, or awkward workpieces.

- USE EXTRA SUPPORTS to prevent workpieces from sliding off the tabletop. Never use another person in place of a table extension, or to provide additional support for the workpiece.
- WORKPIECES SHOULD BE SECURED so that they do not twist, rock, or slip while being cut.
- PLAN INTRICATE OR SMALL WORK CAREFULLY in order to avoid pinching the blade. Avoid awkward operations and hand positions in order to prevent accidental contact with the blade.
- SMALL PIECES SHOULD BE SECURED with clamps or fixtures. Do not hold small pieces with your hand, because your fingers might go under the blade guard.
- SUPPORT ROUND WORK PROPERLY (use a V block or press it against the mitre gauge) to prevent it from rolling and the blade from biting.
- CUT ONLY ONE WORKPIECE AT A TIME. Make sure the table is clear of everything except the workpiece and its guides before you turn the saw on.
- ALWAYS WATCH THE SAW RUN BEFORE EACH USE. If there is excessive vibration or unusual noise, stop immediately. Turn the saw off and unplug it immediately. Do not start the saw again until the problem has been located and corrected.
- TO FREE JAMMED MATERIAL, turn the switch off. Remove the switch key and unplug the saw. Wait for all moving parts to stop before removing the jammed material.
- DON'T LEAVE THE WORK AREA UNTIL ALL MOVING PARTS HAVE STOPPED. Shut off the power to master switches. Remove the switch key from the band saw and store it in a safe place, away from children. Childproof the workshop!

USE SAFETY GOGGLES AND EAR PROTECTION:

ALWAYS WEAR EYE PROTECTION THAT CONFORMS WITH CUL REQUIREMENTS. FLYING DEBRIS can cause permanent eye damage.

The tool is loud and the sound can cause hearing damage. Always wear ear protection to help prevent hearing damage and loss. Failure to comply may result in moderate injury.

USE DUST MASK:

Some dust created by sawing contains chemicals that are known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals come from lead-based paints, crystalline silica from bricks, cement and other masonry products, arsenic and chromium from chemically treated lumber. To reduce exposure to these chemicals, work in a well-ventilated area with approved safety equipment, such as dust masks that are specially designed to filter out microscopic particles.



WARNING!

For your own safety, read the instruction manual before operating the band saw.

- Wear eye protection.
- Do not wear gloves, a necktie or loose clothing.
- Make sure the saw is on a firm, level surface and that it is properly secured.
- Use only the recommended accessories.
- Use extra caution with very large, very small or awkward workpieces.
- Keep your hands away from the blade at all times in order to prevent accidental injury.

ELECTRICAL SAFETY

GUIDELINES FOR USING EXTENSION CORDS:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with a green outer surface, with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service technician if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only three-wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug, as shown in Fig. 1. Repair or replace a damaged or worn cord immediately.

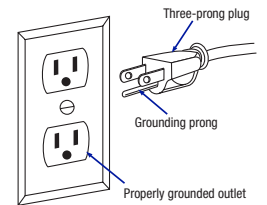


Fig. 1

GROUNDING INSTRUCTIONS:

- Make sure the extension cord is in good condition. When using an extension cord, be sure to use one that is heavy enough to carry the current that your product will draw. An undersized cord will cause a drop in line voltage, which will result in loss of power and overheating. The table on the next page shows the correct size to be used according to cord length and nameplate ampere rating. When in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- Make sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord, or have it repaired by a qualified person before using it. Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.



WARNING!

- Use the proper extension cord. Make sure to use an extension cord that is heavy enough to carry the current required by the tool. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating of the tool.
- Use the extension cord only for intended purpose. Do not pull the extension cord to remove it from the power socket.



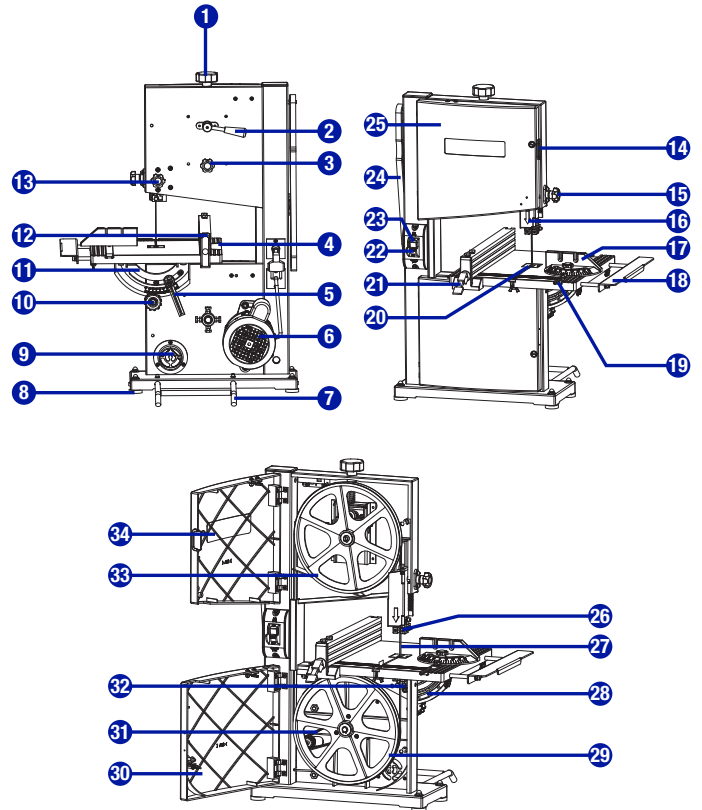
CAUTION!

This band saw is intended for indoor use only. Do not expose it to rain or use in damp locations.

- Use a separate electrical circuit for your tools. This circuit must consist of not less than #12 wire with a 20 A time-delayed fuse or a #14 wire with a 15 A time-delayed fuse. Before connecting the motor to the power line, make sure the switch is in the Off position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.

Recommended size for extension cords

AMPERAGE RATING OF THE TOOL (120 V CIRCUIT ONLY)		TOTAL LENGTH OF THE EXTENSION CORD			
MORE THAN	NOT MORE THAN	25' (7.6 m)	50' (15.2 m)	100' (30.5 m)	150' (45.7 m)
		MINIMUM GAUGE FOR THE EXTENSION CORD (AWG)			
0	6	18	16	16	14
6	10	18	16	14	12
10	12	16	16	14	12
12	16	14	12	Not recommended	



WARNING!

This tool must be grounded while in use in order to protect the operator from electric shock.

NOTE:

Recycle unwanted materials rather than disposing of them as waste. Sort the tool and its components in specific categories and take to the local recycling centre or dispose of them in an environmentally safe way.

No.	Description	No.	Description
1	Blade tension knob	18	Extension table
2	Blade tension lever	19	Mitre gauge groove
3	Tracking knob	20	Table insert
4	Work table	21	Fence locking lever
5	Table tilt locking knob	22	Safety key
6	Motor assembly	23	On/Off switch assembly
7	Additional support	24	Push stick
8	Rubber feet	25	Cabinet
9	Dust extraction port	26	Upper blade guide
10	Table tilt adjustment knob	27	Blade
11	Table tilt gauge	28	Table support assembly
12	Rip fence	29	Lower drive wheel
13	Blade tracking knob	30	Lower door
14	Tracking window	31	Drive belt
15	Upper guide knob	32	Lower blade guide
16	Blade guard	33	Upper idler wheel
17	Mitre gauge	34	Upper door

Blade:

The blade furnished with the band saw is a carbide-tipped combination blade, 62" (157.5 cm) long and 1/4" (6.35 mm) wide, used for producing a good quality cut for many applications.

Blade pitch:

The blade pitch is the number of teeth per inch or tooth size. A blade with more teeth per inch produces a smoother cut. The type of material to be cut determines the number of teeth that should be in contact with the workpiece. When cutting soft materials, use a proper blade having six to eight teeth per inch. When cutting hard materials, where vibration is more detrimental, use a blade with eight to twelve teeth per inch. The blade vibration occurs when the pitch is too large. This vibration can strip the teeth from blade.

Blade thickness:

The blade thickness is the distance between sides of blade. A thicker blade has more rigidity and stronger teeth. A narrow thick blade is used to make curves and a wide thin blade is used to make long, straight cuts.

Table insert:

The table insert is located on the table slot to support the workpiece with respect to the blade. It prevents the movement of the workpiece from the work table.

Table tilt locking knob:

Loosening the table tilt locking knob allows the work table to be tilted at different angles. Tightening the table tilt locking knob locks the work table in place.

Tracking knob:

Adjusts tracking knob to keep blade centred on the wheels.

Tracking window:

The tracking window makes tracking adjustments easier to see.

Blade tension knob:

Controls blade tension when changing blades and making adjustments for various sawing applications.

Mitre gauge:

This mitre gauge aligns the wood for a crosscut. The easy-to-read indicator shows the exact angle for a mitre cut at 90° and 45°.

Dust collection system:

The system is connected with a dust extraction port at the motor side of the band saw. If the band saw is operated without this system, some of the dust will be blown out.

Blade guides:

Upper and lower blade guides help keep the blade from twisting during operation.

Blade guard:

The guard is attached to the upper blade guide. It protects the operator from coming in contact with the blade.

Table tilt adjustment knob:

The adjustment knob is located under the work table, to adjust the work table to a desired angle.

Table tilt locking knob:

The locking wheel is located under the work table, to lock the work table at a desired angle.

Push stick:

Always use the push stick to feed the workpiece until it is clear of the table.

Fence locking lever:

The lever is located on the front of the rip fence to release or lock the rip fence with respect to the work table.

Blade tension lever:

This lever is located at the back of the tool to apply tension on the blade.

Blade cleaning brush:

The brush is used to remove foreign particles from the drive wheel by contacting the blade.

Drive belt:

The drive belt is fitted onto the lower drive wheel. The belt must be properly tensioned to enable smooth operation of the drive wheel.

Lower drive wheel:

The lower drive wheel drives the blade in an endless loop.

Rubber feet:

The rubber feet are provided on four corners of the table base.

Table tilt gauge:

The tilt gauge is provided below the work table. The gauge has a scale that enables the operator to set the work table at required angle between 0 to 45°.

Upper idler wheel:

The upper idler wheel can be adjusted to apply tension on the blade.

Upper and lower doors:

The upper and lower doors cover the upper idler wheel and lower drive wheel, respectively.

On/Off switch assembly:

The switch assembly located on the front of the cabinet allows the operator to easily turn On/Off the band saw. To lock the switch in the Off position, remove the switch key from the switch. Place the key in a location that is not accessible to children and others who are not qualified to use the tool.

Work table:

The surface where the workpiece rests while performing the cutting operation.

Table support assembly:

The support assembly attaches the work table with respect to the band saw.

Causes of kickback:

Kickback can be caused by any action that pinches the blade in the wood, such as the following:

- Incorrect blade depth
- Sawing into knots or nails in the workpiece
- Twisting the wood while making a cut
- Failing to support the workpiece
- Forcing the blade to cut the workpiece
- Cutting warped or wet lumber
- Not using the appropriate type of blade
- Not following correct operating procedures
- Misusing the band saw

- Cutting with a dull, gummed-up or improperly set blade

Avoiding kickback:

- Inspect the workpiece for knots or nails. Knock out any loose knots or remove any nails in the workpiece with a hammer before cutting the workpiece. Never perform cutting operation into a loose knot or nail of the workpiece.
- Always use the rip fence when rip cutting and the mitre gauge when crosscutting to prevent twisting of the wood during cutting operation.
- Always use clean, sharp, and properly set blades. Never make cuts with dull blades.
- Support the workpiece properly before starting the cutting operation to avoid blade pinching.
- When cutting the workpiece, apply constant and uniform pressure to the workpiece. Never force the workpiece while cutting.
- Do not cut wet or warped lumber.
- Use the correct type of blade according to the cut being made.
- Always hold the workpiece firmly with both hands or with push sticks. Keep your body in a balanced position in order to resist kickback. Never stand directly in line with the blade.


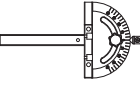

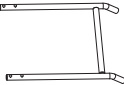
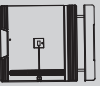



**WARNING!**





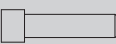
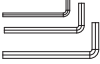


- Use only blades at maximum safe operating speeds of 2556 SFM. Failure to heed this warning could result in personal injury.
- The blades should always be kept sharp. Use a reputable sharpening service to sharpen the blades when needed.
- Never store the blades stacked on top of one another. Place material such as cardboard between them to keep the blades from coming into contact with one another.

**WARNING!**

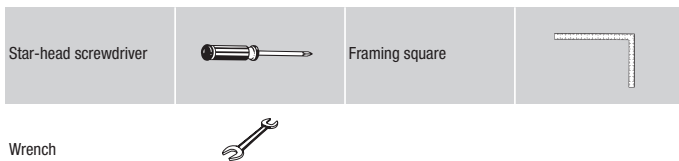
Do not keep your hands near the saw blade. There is a chance of your hands suddenly slipping from the workpiece and coming into contact with the blade.

PACKAGE CONTENTS

No.	Description	Qty	Illustration
1	Band saw assembly	1	
2	Mitre gauge	1	
3	Rip fence	1	
4	Additional support	1	
5	Work table assembly	1	
6	Push stick	1	
7	Rubber feet	4	
8	M8 Flat washer	1	

NO.	Description	Qty.	Illustration
9	M6 Flat washers	4	
10	M5 Flat washers	2	
11	M5 Hex nuts	2	
12	M6x30 Hex bolts	4	
13	M5x20 Hex bolts	2	
14	3, 4, 5 mm hex keys	3	
15	M6 Cap nuts	4	
16	Table tilt locking knob	1	

TOOLS NEEDED FOR ASSEMBLY



UNPACKING

Do not use this product if any parts of the package contents are already assembled to your product when you unpack it. Package contents are not assembled to the product by the manufacturer and require customer installation. Use of a product that may have been improperly assembled could result in serious personal injury.

- Carefully lift the tool from the carton and place it on a level work surface.
- Inspect the tool carefully to make sure no breakage or damage occurred during shipping.
- Do not discard the packing material until you have carefully inspected and satisfactorily operated the tool.
- If any parts are damaged or missing, please call 1-800-689-9928 for assistance.

MOUNTING RUBBER FEET ON THE BASE (Fig. 2)

- Insert the four rubber feet (1) into holes provided in the four corners of saw base.
- Insert M6 hex bolts (2) into the holes and tighten them with M6 flat washers (3) and M6 cap nuts (4).

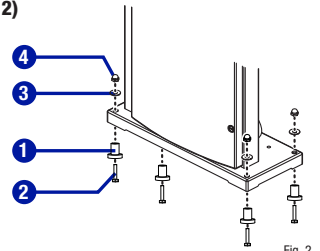


Fig. 2

MOUNTING BAND SAW TO WORKBENCH

If the band saw is to be used in a permanent location, the band saw must be mounted to a firm supporting surface such as a workbench. Four bolt holes have been provided in the saw's base for this purpose. Bolts (not included) should be of sufficient length to accommodate the saw base, lock washers (not included), hex nuts (not included), and the thickness of the workbench. Tighten all four bolts securely.

Carefully check the workbench after mounting to make sure that no movement can occur during use. If any tipping, sliding, or walking is noted, secure the workbench to the floor before operating.

- Place band saw on the workbench. Using the saw base as a pattern, locate and mark the holes where the band saw is to be mounted.
- Drill holes through the workbench.
- Place band saw on the workbench, aligning holes in the saw base with the holes drilled in the workbench.
- Insert bolts (not included) and tighten securely with lock washers and hex nuts (not included).

CLAMPING BAND SAW TO WORKBENCH (Fig. 3)

If the band saw is to be used as a portable tool, it is recommended that you fasten it permanently to a mounting board that can easily be clamped to a workbench or other supporting surface. The mounting board should be of sufficient size to avoid tipping of the saw while in use. Any good grade plywood or chipboard with a thickness of 3/4" (19 mm) is recommended.

NOTE:

All bolts should be inserted from the top. Install the lock washers and hex nuts from the underside of the bench.



WARNING!

- If any parts are damaged or missing, do not operate this tool until the parts are replaced. Use of this product with damaged or missing parts could result in serious personal injury.
- Do not attempt to modify this tool or create accessories not recommended for use with this tool. Any such alteration or modification is misuse and could result in a hazardous condition leading to possible serious personal injury.
 - Do not connect to power supply until assembly is complete. Failure to comply could result in accidental starting and possible serious personal injury.
 - Risk of injury! Always pull out the mains plug (disconnect the product from its power supply) before commencing work on the product.
 - Never stand directly in line with the blade or allow hands to come within 3" (7.6 cm) of the blade. Failure to heed this warning could result in serious injury.
 - To avoid serious injury, always make sure the tool is securely mounted on the work table. Never operate the tool on the floor.

If lag bolts are used, make sure they are long enough to go through holes in the saw base and material the saw is being mounted to. If machine bolts are being used, make sure bolts are long enough to go through holes in the saw base, the material being mounted to, and the lock washers and hex nuts.

- Mount saw to board using holes in saw base as a template for hole pattern. Locate and mark the holes where the band saw is to be mounted.
- Follow the last three steps in the section MOUNTING BAND SAW TO WORKBENCH.

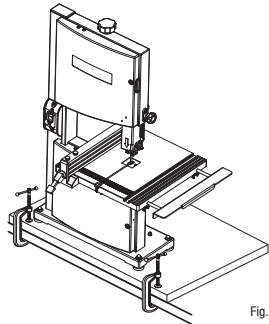


Fig. 3

MOUNTING ADDITIONAL SUPPORT ON THE BASE (Fig. 4)

- Place the additional support (1) on the rear side of the base.
- Align the two holes in the additional support with the corresponding holes on the rear side of the saw base.
- Secure the additional support with two hexagon bolts (2), two flat washers (3) and two nuts (4).

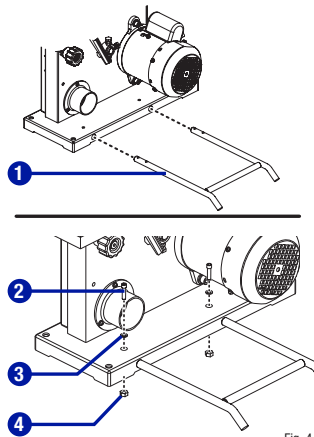


Fig. 4

NOTE:
It may be necessary to countersink hex nuts and washers on bottom side of mounting board.

ASSEMBLING THE WORK TABLE (Fig. 5-7)

- Remove the D-nut (1), flat washer (2) and wing screw (3) from the hole located in the front edge of the work table (4). (Fig. 4)
- Standing at the front of the band saw, slide the work table (4) past the blade (5) and through the slot moving from the right side of the work table to the left.
- Holding the work table with your left hand while pulling the table tilt adjustment knob (6) away from the saw frame, align the teeth on the table support assembly (7) with the teeth on the table tilt adjustment knob (6). Release the knob.
- Fit the pins on the frame into the slots of the table support assembly (7)
- Insert the washer (8) on the threaded end of the table tilt locking lever (9). Tighten the work table to the saw frame by turning the table tilt locking lever (9) clockwise.
- Attach the D-nut, flat washer and wing screw to the work table.

Make sure that the wing screw goes below the saw blade.

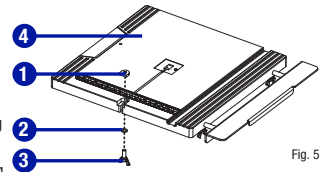


Fig. 5

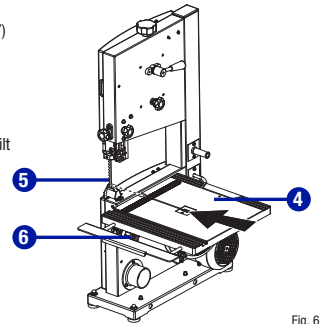


Fig. 6

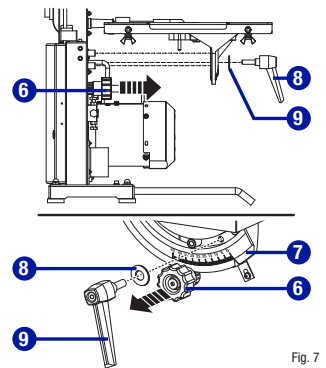


Fig. 7

SQUARING THE SAW TABLE TO THE BLADE (Fig. 8-9)

- Turn the blade tracking knob (1) counter-clockwise to unlock the blade guide assembly (2). Turning the upper guide knob (3) clockwise, raise the blade guide assembly (2) as far as it will go. Turn the blade tracking knob clockwise to retighten.
- Place a small combination square (4) on the saw table beside the blade (5).
- Loosen the table tilt locking knob (6) and rotate the table tilt adjustment knob (7) to tilt the work table up or down to align table 90° to blade (0° position). Retighten the table tilt locking knob (6).
- Using an adjustable wrench, loosen the locking nut (8).
- Turn the adjusting bolt (9) until the bolt just touches the saw housing.
- Check squareness of the work table to the blade. Make readjustments if necessary.
- Once squareness is confirmed, retighten the locking nut.
- Set scale indicator (10) to zero and tighten screw with a star-head screwdriver.

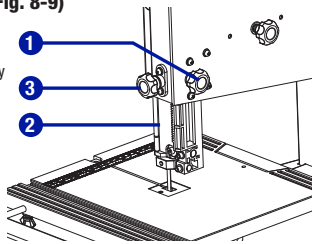


Fig. 8

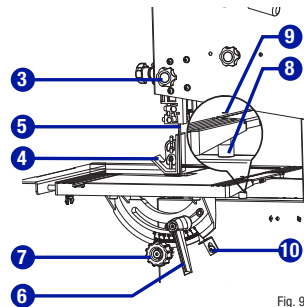


Fig. 9

NOTE:

Always make a test cut to insure the squareness of the blade prior to beginning any new project. If not square, it may be necessary to loosen the screws under the work table to make the adjustment (mitre slot must be parallel to the saw blade). Once square, retighten screws.

WORK TABLE TILT ADJUSTMENT (Fig. 10)

Before adjusting the band saw, turn Off the band saw, remove the safety key, and unplug the power cord from the electrical outlet.

The work table can be tilted from 0° - 45° to the right side.

- Turn the table tilt locking knob (1) counter-clockwise.
- Rotate the table tilt adjustment knob (2) until the pointer is at the desired angle on the table tilt gauge (3). Now the work table is tilted to the desired angle.
- Tighten the table tilt locking knob in order to secure the work table in position.

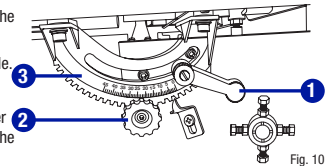


Fig. 10

SETTING THE RIP FENCE ON THE WORK TABLE (Fig. 11)

- Raise the fence locking lever (1) on the rip fence (2).
- Place the rip fence on the work table (3) so that the fence locking lever is at the front of the work table.
- Lower the fence locking lever in order to lock the rip fence in position on the work table.
- To move the rip fence, raise the fence locking lever and slide the fence to the desired location. Lower the fence locking lever to lock the fence in position.

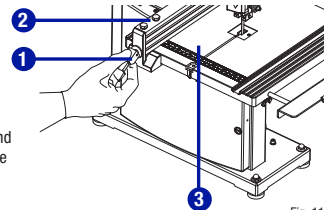


Fig. 11

CONNECTING DUST EXTRACTION PORT TO DUST COLLECTION SYSTEM (Fig. 12)

Connect the dust extraction port (1) located on the motor side of the band saw to the dust collection system by connecting the inlet of the dust collection hose to the dust extraction port.

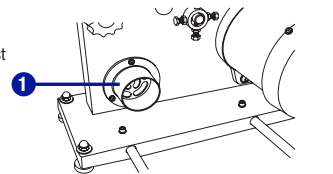


Fig. 12

**WARNING!**

Never use miter gauge and rip fence at the same time. If you do, the blade may bind into the workpiece, thereby resulting in the serious injury of the operator and/or damage to the workpiece.

REMOVING AND INSTALLING THE BLADE (Fig. 13-15)

- Loosen and remove the D-nut, flat washer and wing screw from the work table (1).
- Open the upper and lower door (2) by unscrewing the cover locking screw (3).
- Turn the blade tracking knob (4) counter-clockwise to unlock the blade guide assembly (5). Turning the upper guide knob (6) (clockwise raises the blade guide assembly (5); counter-clockwise lowers it), position the blade guide assembly (5) about halfway between the work table and saw housing. Retighten the blade tracking knob (4).
- Open the blade guard by pulling the left side of the guard out and away from the idler wheel.
- Release all blade tension from the blade.
- Carefully remove the old blade (7).
- Wearing gloves, carefully uncoil the new blade at arms length. If the new blade was oiled to prevent rusting, it may need to be wiped to keep the oil from your workpiece. Carefully wipe in the same direction the teeth are pointing so the rag does not catch on the teeth of the saw blade.

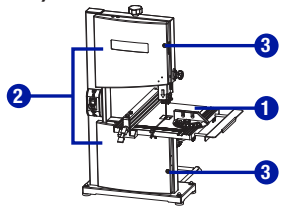


Fig. 13

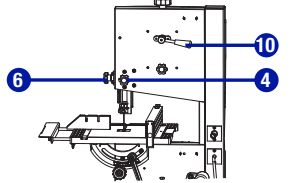


Fig. 14

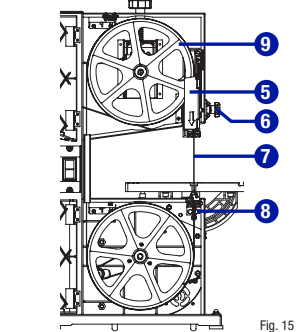


Fig. 15

The blade may need to be turned inside out if the teeth are pointing in the wrong direction. Hold the blade with both hands and rotate it inward.

- With the teeth of the blade toward the left of the saw and facing downward, place the blade through the lower blade guides (8) and around both idler wheels.
- Slowly turn the upper idler wheel (9) to the right or clockwise by hand to centre the blade on the rubber tires.
- Re-engage the blade tension lever (10) then adjust the blade tension; check or adjust the blade tracking.
- Adjust both upper and lower blade guides as explained later in this manual.
- Re-attach the D-nut, flat washer and wing screw. Tighten securely.
- Close the blade guard and upper and lower door. Tighten the cover locking screw.

TRACKING THE BLADE (Fig. 16-17)

- Disconnect the band saw from power source.
- To check the position of the blade, rotate the lower drive wheel (1) by hand in clockwise direction. View the blade through tracking window.
- Loosen the blade tracking knob (2). If the blade rides away from the cabinet, turn the tracking knob clockwise. If the blade rides toward the cabinet, turn the tracking knob counter-clockwise.
- Tighten the blade tracking knob to secure the blade in the proper position.

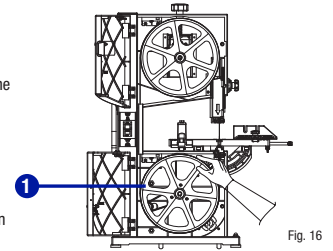


Fig. 16

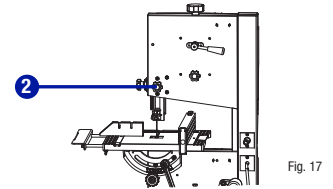


Fig. 17

NOTE:

Proper tracking is achieved only when upper idler wheel and lower drive wheel are aligned.

**WARNING!**

Always ensure correct tracking of the blade, as an improperly tracked blade may spring out from the blade wheels, thereby causing serious injury. Do not perform the tracking adjustment while band saw is operating.

TRACKING THE BLADE (Fig. 18-19)

- Loosen the screws (1) to adjust guide pins (2) provided on the blade sides.
- Use a feeler gauge to check that the guide pins are 0.002" away from the blade. Now tighten the screws to lock the guide pins in the proper position.
- Adjust the ball bearing (3) at rear of blade by loosening socket head bolt and repositioning the blade shaft.
- Use a feeler gauge to check that the ball bearing is 0.002" away from the back of blade. Secure the ball bearing in position by tightening the socket head bolt.
- Loosen upper guide knob (4) to adjust the height of upper blade guide (5) so that the blade guide is set at a distance of 1/4" (6.35 mm) from the workpiece (6). Tighten the upper guide knob after adjustment.

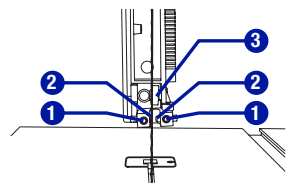


Fig. 18

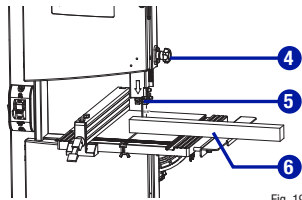


Fig. 19

ADJUSTING THE LOWER BLADE GUIDE (Fig. 20)

- Loosen the screws (1) to move guide pins (2) away from the blade sides.
- Loosen socket head bolts (3) and adjust the bearing (4) so that the rear part of blade is positioned 0.002" away from the bearing.
- Tighten the socket head bolts.
- Adjust the guide pins to the blade sides. Inserting a playing card between guide and blade to check that guide pins are 0.002" away from blade.
- Tighten the screws to lock the guide pins in proper position.

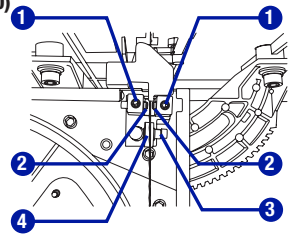


Fig. 20

ON/OFF SWITCH ASSEMBLY (Fig. 21)

- Insert switch key (1) into switch (2), and move the switch to the On position to turn On the band saw.
- Move the switch (2) to the Off position to turn Off the band saw.
- To lock the band saw, move the switch to the Off position. Then remove the switch key (1) from the switch and store the switch key in a safe and secure location.

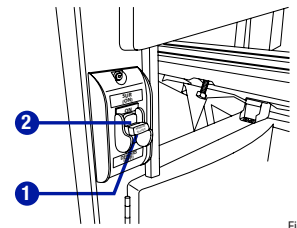


Fig. 21

**WARNING!**

- Always handle the band saw with care. Failure to comply could cause serious injury.
- Always wear safety goggles or safety glasses with side shields when operating the tool, as doing so may prevent flying particles from getting into eyes.
- Do not use any attachments or accessories that are not recommended by the manufacturer of this tool. Failure to comply could result in serious injury.
- Do not operate the band saw without having the blade guard attached.
- Mount the band saw on a firm, supporting and waist-high surface. Failure to comply could result in serious injury.
- Before using the band saw, check whether the power outlet is properly installed and grounded in compliance with all local codes and ordinances. Improper connection could result in electric shock.
- Do not alter three-pronged plug of the table saw. If the plug does not fit into the power outlet, allow a qualified electrician to install the power outlet.

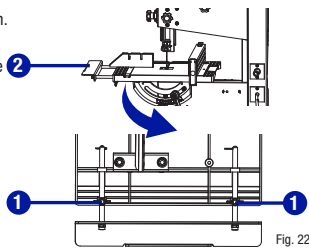
**WARNING!**

- Always remove the switch key when the tool is not in use, and keep it in a safe place. In the event of a power failure, turn Off the switch and remove the key, as doing so may prevent the tool from accidentally starting when the power returns.
- Make sure the workpiece does not come into contact with the blade before operating the switch. Failure to heed this warning may cause the workpiece to be kicked back toward the operator, and could result in serious injury.

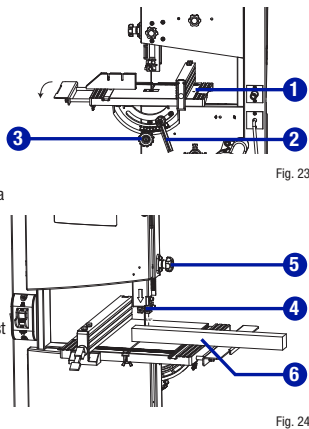
USING THE EXTENSION TABLE (Fig. 22)

When cutting a wider workpiece, you can use the extension. The maximum extension table range is 2 5/32" (55 mm).

- Loosen the two wing screws (1) located underneath the extension table (2).
- Pull the extension table to desired length.
- Tighten two wing screws (1).

**CUTTING OPERATIONS****BEVEL CUTTING (Fig. 23-24)**

- Unlock the work table (1) by loosening the table tilt locking knob (2).
- Tilt the work table to desired position by rotating the table tilt adjustment knob (3).
- Lock the work table in position by tightening the table tilt locking knob.
- Adjust the upper blade guide (4) using the upper guide knob (5) so that the upper blade guide is positioned at a distance of 1/4" (6.35 mm) from the workpiece (6).
- Insert the switch key and turn On the band saw by moving the switch to the On position. Wait until the band saw reaches maximum speed. (Refer the "Specifications" section.)
- Hold the workpiece firmly on the work table and against the rip fence.
- Slowly feed the workpiece through the blade to make beveled cuts on the workpiece.

**NOTE:**

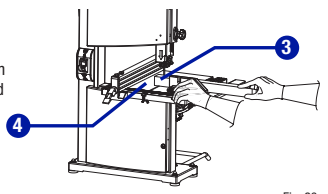
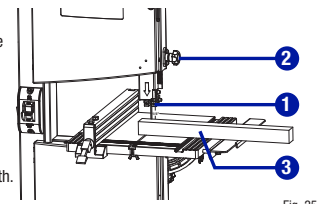
The beveled cuts can be made freehand, or use the rip fence to guide and support the workpiece.

**WARNING!**

Use care when making this bevel cut freehand. The workpiece may slip from the work table, thereby causing pressure on the blade, making it hard to follow the pattern line on the workpiece and resulting in damage to the tool.

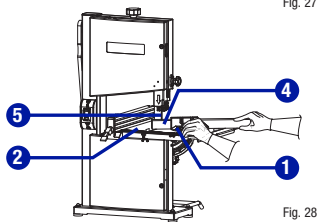
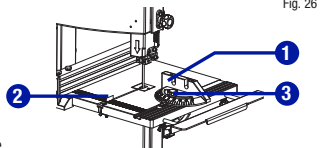
CONTOUR CUTTING (Fig. 25-26)

- Adjust the upper blade guide (1) using the upper guide knob (2) so that the upper blade guide is positioned at a distance of 1/4" (6.35 mm) from the workpiece (3).
- Stand in front of the band saw and keep hands over the work table exactly to the right of blade.
- Use both hands to hold the workpiece (3) flat against the work table (4) and to guide it along the desired path.
- Turn the band saw on. Wait until the band saw reaches maximum speed. (refer to the section "Specifications" section.)
- Slowly feed the workpiece through the blade to cut small corners of the workpiece. Continue the operation until scrap is removed from the workpiece and desired shape is obtained.

**MITRING (Fig. 27-28)**

This operation is performed by setting the mitre gauge to an angle other than 0°.

- Place the mitre gauge (1) on the mitre gauge slot of the work table (2).
- Use the gauge knob (3) to set the desired angle on the gauge scale.
- Hold the workpiece (4) firmly against the mitre gauge (1), and slowly feed the workpiece into the blade (5).

**CAUTION!**

- Never use mitre gauge and rip fence simultaneously, as the blade may bind into the workpiece and could result in damage of the workpiece.
- Hold the workpiece firmly against the mitre gauge and feed the workpiece slowly into the blade to restrict the movement of workpiece.

GENERAL MAINTENANCE

Avoid using solvents when cleaning plastic parts. Most plastics are susceptible to damage from various types of commercial solvents. Use a clean cloth to remove dirt, dust, oil, grease, etc.

- Periodically check all clamps, nuts, bolts, and screws for tightness and condition.
- Check and clean the blade guard periodically. Replace the blade guard if required.
- Clean the blades using a gum and pitch remover.
- To prevent the workpiece from slipping during cutting operations, do not wax the working face of the mitre gauge.
- Protect the saw blade by cleaning sawdust accumulated under the work table and between the blade teeth, and applying a resin solvent on the blade teeth.
- Clean plastic parts only with a soft damp cloth. Do not use any aerosol or petroleum solvents.
- Keep the upper and lower blade wheels clean. Debris on the wheels will cause poor tracking and blade slippage.

LUBRICATION

- Apply small amount of machine oil to belt tension mechanisms and threaded or sliding surfaces.
- Lubricate all screw threads, nuts, and bearing points of the band saw (including the blade guard and the mitre gauge).
- Apply a coat of paste wax to the tabletop to keep the work table slick and corrosion free.

SERVICE

- Replace the power cord if it is worn or damaged.
- Replace any damaged or missing part.

**WARNING!**

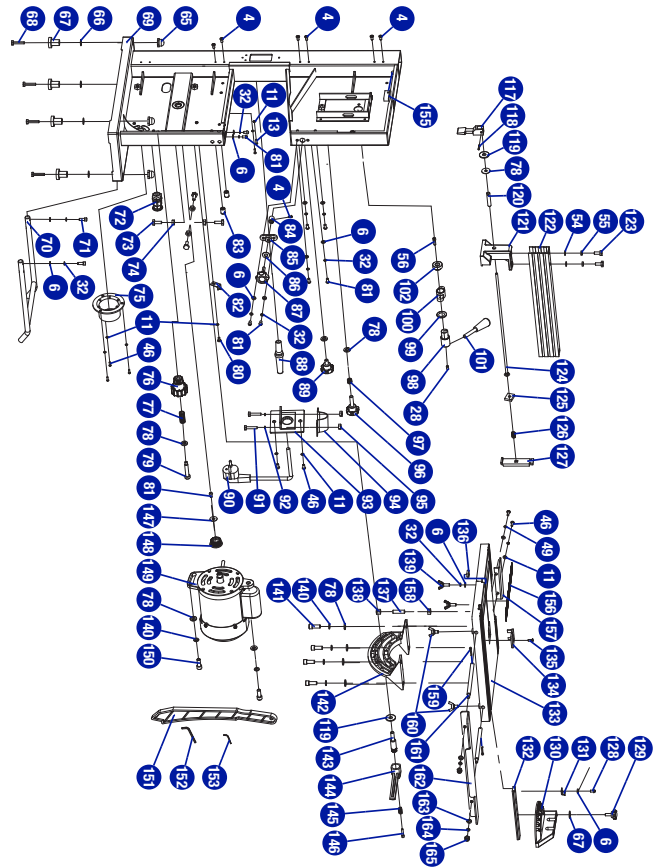
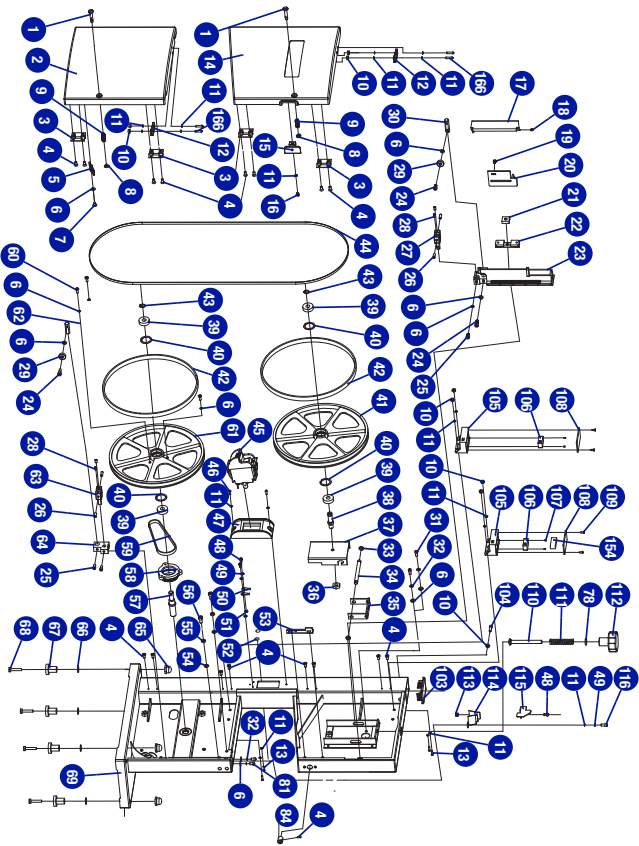
- Do not allow brake fluid, gasoline, petroleum-based products, penetrating oils, etc., to come into contact with plastic parts. Failure to comply leads to tool damage, which in turn creates a spark or fire resulting in serious personal injury.
- Make sure the tool is disconnected from power source before attempting to service or remove any component.

TROUBLESHOOTING

PROBLEM	Possible Causes	Solution
Excessive vibration.	<ul style="list-style-type: none"> • Blade is out of balance. • Blade is damaged. • Saw accessories are not securely mounted. • The workpiece is not placed or used on a flat surface. • Blade is warped. 	<ul style="list-style-type: none"> • Replace the blade. • Replace the blade. • Securely tighten all saw accessories. • Reposition the workpiece on a flat surface. • Replace the blade.
Rip fence does not move smoothly.	<ul style="list-style-type: none"> • Rip fence is not mounted correctly. 	<ul style="list-style-type: none"> • Remount the rip fence in a correct and stable position.
Excessive damage of blade.	<ul style="list-style-type: none"> • Material is not secured on the work table. • Blade is too coarse. • Teeth are in contact with the workpiece before sawing. • Blade guides are misaligned. • Blade is thicker than the wheel diameter. • Crack occurs at weld. 	<ul style="list-style-type: none"> • Place the workpiece firmly on the work table. • Use finer pitch blade. • Allow the blade to contact the workpiece only after the band saw is started. • Adjust the blade guides properly. • Use thinner blade. • Replace the blade.
Blade is dull.	<ul style="list-style-type: none"> • Blade is too coarse. • Inadequate workpiece feed pressure. • Hard spots or irregular layers found on the workpiece. • Blade is installed backwards. 	<ul style="list-style-type: none"> • Use finer tooth blade. • Gently increase the feed pressure. • Increase rate of feed to remove the layers and change the blades to remove hard spots. • Remove the blade, twist the blade teeth inside and reinstall the blade.
Rough cuts.	<ul style="list-style-type: none"> • Workpiece feeding rate is high. • Blade is too coarse. 	<ul style="list-style-type: none"> • Reduce the workpiece feeding rate. • Use finer-tooth blade.

PROBLEM	Possible Causes	Solution
Crooked cuts.	<ul style="list-style-type: none"> • Workpiece is not placed properly on the work table. • Rate of feed of workpiece is too high. • Blade guides are not adjusted properly. • Upper blade guide is too far from the workpiece. • Blade is not sharp. • Blade guide assembly or blade thrust bearing is loosened. 	<ul style="list-style-type: none"> • Use miter gauge to adjust tilt of the work table to 90°. • Reduce the rate of feed. • Use feeler gauge to move the blade guides within 0.002" from the blade. • Set the upper blade guide at a distance of 1/4" (6.35 mm) from the workpiece. • Replace the blade. • Tighten the blade thrust bearing within 0.002" behind the back of blade.
Twisting of the blade or unusual wear on the side/back of the blade.	<ul style="list-style-type: none"> • Blade binds into the workpiece. • Blade guides or bearings are damaged. • Blade guides or bearings are not adjusted properly. • Blade guide brackets are loosened. 	<ul style="list-style-type: none"> • Decrease the workpiece feed pressure. • Replace the blade guides or bearings. • Adjust the blade guides. (Refer to the "Assembly Instructions".) • Tighten the blade guide brackets properly.
Motor runs too hot.	<ul style="list-style-type: none"> • Blade tooth is too coarse. • Workpiece feed rate is high. • Workpiece vibrates. • Blade guide brackets are loosened. 	<ul style="list-style-type: none"> • Use blade with finer teeth. • Decrease the workpiece feed rate. • Hold the workpiece firmly. • Tighten the blade guide brackets properly.
Ripping of the teeth from the blade.	<ul style="list-style-type: none"> • Blade teeth are too coarse especially when cutting pipe. • Blade tooth is too fine especially when cutting slick or soft material. • Excessive dirt and chips on the motor. 	<ul style="list-style-type: none"> • Use blade with finer teeth. • Use blade with coarser teeth. • Clean the motor thoroughly.

PROBLEM	Possible Causes	Solution
Saw does not start.	<ul style="list-style-type: none"> • Motor cord or wall cord is not plugged in. • In-house circuit fuse is blown. • In-house circuit breaker is tripped. • In-house circuit switch is damaged. • Improper electrical connections. 	<ul style="list-style-type: none"> • Plug in the motor cord or wall cord. • Replace the circuit breaker. • Reset the circuit breaker. • Repair or replace the in-house circuit switch. Have the cord or switch replaced by a qualified service technician. • Have a qualified technician check the electrical connections.



PARTS LIST

No.	Description	Qty	No.	Description	Qty
1	Bolt	2	32	Spring washer	12
2	Lower bezel panel	1	33	Split washer	2
3	Hinge	4	34	Fixed pin	1
4	Cross-shaped sunk bolt	17	35	Fixed block	1
5	Brush	1	36	Nut	1
6	Flat washer	21	37	Moving block	1
7	Cross-shaped self-tapping bolt	1	38	Shaft for driven wheel	1
8	Door holder	2	39	Bearing	4
9	Door lock spring	2	40	Retainer ring for hole	4
10	Nut	8	41	Driven wheel	1
11	Flat washer	26	42	Rubber band	2
12	Pressing paw	2	43	Retainer ring for shaft	2
13	Cross-shaped bolt	8	44	Blade	1
14	Upper bezel panel	1	45	Lock switch	1
15	Bezel panel lens	1	46	Cross-shaped bolt	7
16	Cross-shaped self-tapping bolt	1	47	Switch box	1
17	Shield	1	48	Cross-shaped bolt	3
18	Spring	1	49	Spring washer	3
19	Cross-shaped self-tapping bolt	1	50	Grounding terminal	2
20	Sliding block (B)	1	51	Gear pad	2
21	Sliding block (C)	1	52	Grounding signal	2
22	Sliding block (A)	1	53	Locking plate	1
23	Up-down part	1	54	Flat washer	4
24	Bolt	2	55	Spring washer	4
25	Bolt	3	56	Bolt	3
26	Round pin	4	57	Shaft for driving wheel	1
27	bracket (A)	1	58	Synchronize wheel (B)	1
28	Set screw	5	59	Synchronize belt	1
29	Bearing	2	60	Cross-shaped self-tapping bolt	3
30	Pin stop (B)	1	61	Driving wheel	1
31	Bolt	2	62	Fixed pin (A)	1

No.	Description	Qty	No.	Description	Qty
63	Bracket (B)	1	94	Cord clip	1
64	Lower fixed block	1	95	Nut	2
65	Cap nut	4	96	Fine adjusting knob	1
66	Big flat washer	4	97	Spring	1
67	Footing	4	98	Eccentricity shaft	1
68	Hexagon bolt	4	99	Wave-shaped washer	1
69	Body	1	100	Locating sleeve (B)	1
70	Supporting	1	101	Compression handle	1
71	Hexagon bolt	2	102	Roller	1
72	Clip	1	103	Block	1
73	Hexagon bolt	4	104	Bolt	1
74	Nut	4	105	Box	2
75	Dust outlet	1	107	Bolt	4
76	Angle adjusting gear	1	108	Cover	2
77	Spring	1	109	Bolt	4
78	Flat washer	11	110	Square-neck bolt	1
79	Bolt	1	111	Compression spring	1
80	Bolt	1	112	Swelling knob	1
81	Bolt	9	113	Locknut	1
82	Indicator	1	114	Lower shield (A)	1
83	Locating sleeve	2	115	Lower shield (B)	1
84	Adjusting gear	1	116	Bolt	1
85	Locating sleeve (A)	1	117	Clamp handle	1
86	Wave-shaped washer	2	118	Spring round pin	1
87	Up-down knob	1	119	Big flat washer	2
88	Protecting bush	1	120	Connecting screw rod	1
89	Locking knob	1	121	Fixed pressing paw	1
90	Power cord	1	122	Guide tube	1
91	Bolt	2	123	Hexagon bolt	2
92	Flat washer	2	124	Connecting rod	1
93	Fixed plate assembly	1	125	Square washer (A)	1

No.	Description	Qty	No.	Description	Qty
126	Spring	1	146	Bolt	2
127	Movable clamp paw	1	147	Big flat washer	1
128	Bolt	1	148	Synchronize wheel (A)	1
129	Knob for mitre angle	1	149	Motor	1
130	Mitre angle	1	150	Bolt	2
131	Pointer	1	151	Push stick	1
132	Fence	1	152	Spanner	1
133	Worktable	1	153	Spanner	1
134	Table insert	1	156	Scale label	1
135	Bolt	1	157	Worktable steel board	2
136	Snap gauge	1	158	Nut	1
137	Bolt	1	159	Uncork pin	2
138	Cushion cap	1	160	Butterfly bolt	2
139	Wing bolt	1	161	Expand pole	2
140	Spring washer	6	162	Extension table	1
141	Bolt	4	163	Washer	2
142	Mitre seat	1	164	Spring washer	2
143	Lock bolt	1	165	Lock nut	2
144	Securing handle	1	166	Star-head pan head screws	4
145	Compression spring	1			

3-Year Limited Warranty

This Mastercraft product is guaranteed for a period of **3 years** from the date of original retail purchase against defects in workmanship and materials, except for the following component:

Component A: Accessories, which are guaranteed for a period of 1-year from the date of original retail purchase against defects in workmanship and materials.

Subject to the conditions and limitations described below, this product, if returned to us with proof of purchase within the stated warranty period and if covered under this warranty, will be repaired or replaced (with the same model, or one of equal value or specification), at our option. We will bear the cost of any repair or replacement and any costs of labour relating thereto.

These warranties are subject to the following conditions and limitations:

- a bill of sale verifying the purchase and purchase date must be provided;
- this warranty will not apply to any product or part thereof which is worn or broken or which has become inoperative due to abuse, misuse, accidental damage, neglect or lack of proper installation, operation or maintenance (as outlined in the applicable owner's manual or operating instructions) or which is being used for industrial, professional, commercial or rental purposes;
- this warranty will not apply to normal wear and tear or to expendable parts or accessories that may be supplied with the product that are expected to become inoperative or unusable after a seasonable period of use;
- this warranty will not apply to routine maintenance and consumable items such as, but not limited to, fuel, lubricants, vacuum bags, blades, belts, sandpaper, bits, fluids, tune-ups or adjustments;
- this warranty will not apply where damage is caused by repairs made or attempted by others (i.e. persons not authorized by the manufacturer);
- this warranty will not apply to any product that was sold to the original purchaser as a reconditioned or refurbished product (unless otherwise specified in writing);
- this warranty will not apply to any product or part thereof if any part from another manufacturer is installed therein or any repairs or alterations have been made or attempted by unauthorized persons;
- this warranty will not apply to normal deterioration of the exterior finish, such as, but not limited to, scratches, dents, paint chips, or to any corrosion or discolouring by heat, abrasive and chemical cleaners; and
- this warranty will not apply to component parts sold by and identified as the product of another company, which shall be covered under the product manufacturer's warranty, if any.

Additional Limitations

This warranty applies only to the original purchaser and may not be transferred. Neither the retailer nor the manufacturer shall be liable for any other expense, loss or damage, including, without limitation, any indirect, incidental, consequential or exemplary damages arising in connection with the sale, use or inability to use this product.

Notice to Consumer

This warranty gives you specific legal rights, and you may have other rights, which may vary from province to province. The provisions contained in this warranty are not intended to limit, modify, take away from, disclaim or exclude any statutory warranties set forth in any applicable provincial or federal legislation.

This product is not meant for industrial or commercial purposes. This product is for household projects, read manual carefully

Made in China

Imported by Mastercraft Canada Toronto, Canada M4S 2B8