

AXMINSTER

WORKSHOP

Code 107710

Original Instructions

# AW1400B

## Bandsaw



Watch  
The Set Up  
Guide  
Here!




AT: 22/03/2023  
BOOK VERSION: 12

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# EU DECLARATION OF CONFORMITY

<p><b>Cert No: MJ3420, MJ3425, MJ343C, MJ343B</b></p> <p>Axminster Tool Centre Ltd Axminster Devon EX13 5PH UK <b>axminstertools.com</b></p> <p>declares that the machinery described:-</p> <table border="1"> <tr> <td>Type</td> <td><b>Bandsaw</b></td> </tr> <tr> <td>Model</td> <td><b>AW1400B</b></td> </tr> </table> <p>Signed </p> <p><b>Andrew Parkhouse</b> Operations Director</p> <p>Date: <b>05/11/2018</b></p>	Type	<b>Bandsaw</b>	Model	<b>AW1400B</b>	<p><b>EU Declaration of Conformity</b></p> <p><b>This machine complies with the following directives:</b></p> <table border="1"> <tr> <td>2006/42/EC</td> <td rowspan="4">06/42/EC - Annex I/05.2006</td> </tr> <tr> <td>2004/108/EC</td> </tr> <tr> <td>EN 1807-1:2013</td> </tr> <tr> <td>EN 60204-1:2006+A1+AC</td> </tr> </table> <p>conforms to the machinery example for which the EC Type-Examination Certificate No BM 50421300 has been issued by <b>Laizhou Fulin Machinery Co., Ltd.</b> at: Wenchang Road Street Nanwuli Industry Yard Laizhou, Shandong261400 China</p> <p>and complies with the relevant essential health and safety requirements.</p>	2006/42/EC	06/42/EC - Annex I/05.2006	2004/108/EC	EN 1807-1:2013	EN 60204-1:2006+A1+AC
Type	<b>Bandsaw</b>									
Model	<b>AW1400B</b>									
2006/42/EC	06/42/EC - Annex I/05.2006									
2004/108/EC										
EN 1807-1:2013										
EN 60204-1:2006+A1+AC										

**The symbols below advise the correct safety procedures when using this machine.**



**Fully read manual and safety instructions before use**



**Ear protection should be worn**



**Eye protection should be worn**



**Dust mask should be worn**



**HAZARD  
Motor gets hot**

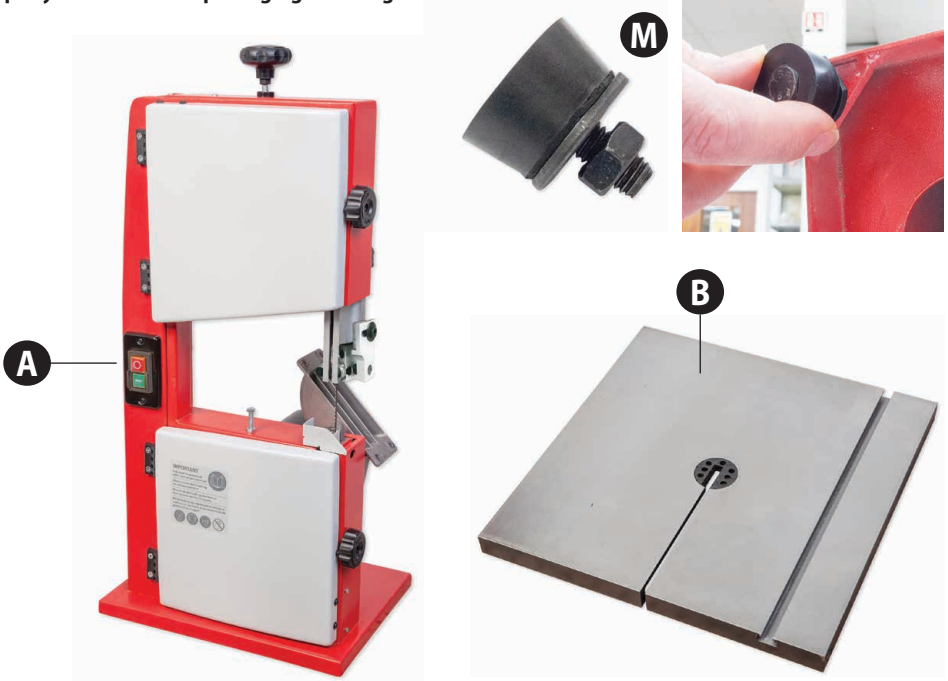
## WHAT'S INCLUDED

Quantity	Item	Part	Model Number
			AW1400B
1	Craft Bandsaw	A	
1	Bandsaw Blade 1,400mm Long 6mm 6TPI (Mounted on the saw but not tensioned)		
1	Table	B	
1	Fence Rail	C	
1	Fence Assembly	D	
1	Mitre Fence (Optional Accessory)	E	Code: 102919
1	Push Stick	F	
1	Fence Rail Scale Strip (see pages 17-19 for mounting instructions)		

### Fixings

4	M6 x 12mm Caphead Screws	G
4	M6 Washers	H
4	M8x12mm Bolts	I
4	M8 Washers	J
1	Angled Bolt and Nut	K
1	3-4mm Hex Key	L
4	Adjustable Rubber Feet	M
1	Instruction Manual	

Having unpacked your saw (see below) and its accessories please dispose of any unwanted packaging properly. The cardboard packaging is biodegradable.

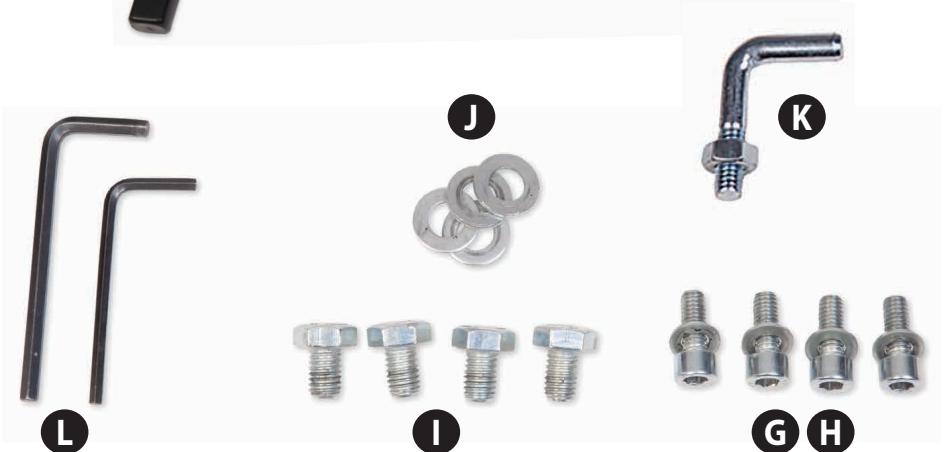


# WHAT'S INCLUDED

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Optional Mitre Fence  
Code: 102919



## GENERAL INSTRUCTIONS FOR 230V MACHINES

The following will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.



**WARNING!! KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN**



**KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN THE WORK AREA.**

### Mains Powered Tools

- Tools are supplied with an attached 13 Amp plug.
- Inspect the cable and plug to ensure that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

### Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.

- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.
- Carry out a final check e.g. check the cutting tool is securely tightened in the machine and the correct speed and function set.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check cutters are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

## SPECIFICATION

Code	107710
Model	AW1400B
Rating	Home Workshop
Power	250W 230V 1ph
Blade Speed	800 m/min
Blade Length	1,400 mm
Blade Width Min/Max	4.8 mm (3/16") to 9.5 mm (3/8")
Max Width of Cut	200 mm
Max Depth of Cut	80 mm
Max Width of Cut with Fence	102 mm
Airflow	200 m3/hr
Table Size	300 x 300 mm
Table Tilt	0-45°
Table Height	290 mm
Wheel Diameter	200 mm
Dust Extraction Outlet	40 mm
Overall L x W x H	450 x 430 x 700 mm
Weight	20 kg

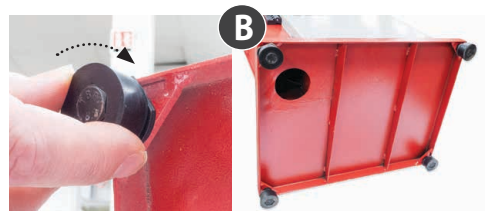
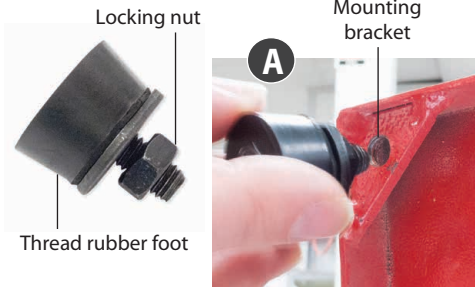
Please read the Instruction Manual prior to using your new machine; as well as the operating procedures for your new machine, there are numerous hints and tips to help you to use the machine safely and to maintain its efficiency and prolong its life.

**Keep this Instruction Manual readily accessible for any others who may also be required to use the machine.**

## ASSEMBLY

### Fitting the Rubber Feet

Locate the four adjustable rubber feet (M), screw each foot in turn into each corner to the underside of the bandsaw base, see fig A & B. Stand the bandsaw upright, adjust each foot until the bandsaw is level. Nip-up the locking nuts against the frame to secure in position.



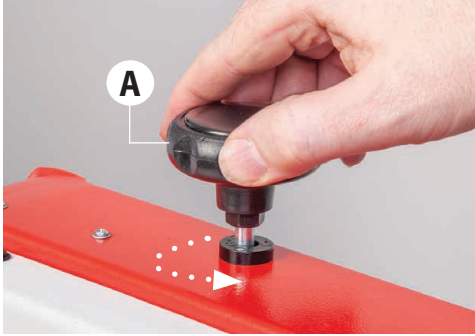
### Fitting the Table

NOTE: The table can be fitted without removing the bandsaw blade. However, if you feel safer with the blade removed, loosen the blade tensioning knob (A), see fig 01 and very carefully remove the blade. To refit the blade refer to pages 18-19 for "Changing the Saw Blade".



**WARNING! WE ADVISE YOU WEAR GLOVES AS THE BLADE HAS SHARP TEETH!**

**Fig 01**



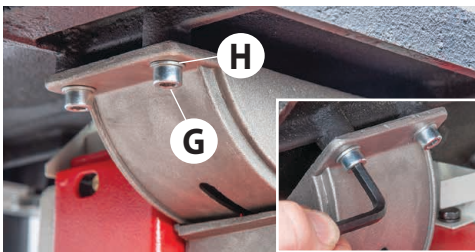
**Step 1** Locate the bandsaw table (B), the four M6 caphead screws (G) and washers (H). Slot the blade into the table's slot and line up the threaded holes in the table with the pre-drilled holes on the tilt quadrant, see fig 02.

**Fig 02**



**Step 2** Place a washer (H) over each M6 caphead screw (G), screw the caphead screws through the tilt quadrant into the table and tighten using the supplied spanner, see fig 03.

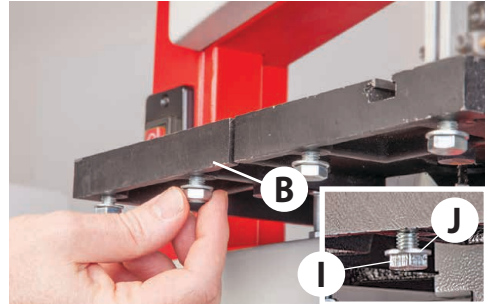
**Fig 03**



**Fitting the Fence**

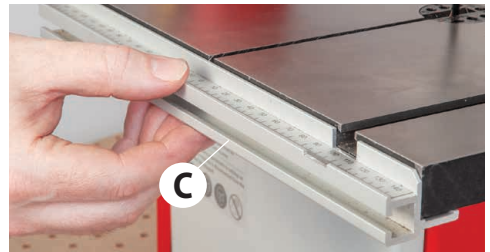
**Step 1** Locate the fence rail (C), fence assembly (D), four M8 bolts (I) and washers (J). Place a washer over the end of each bolt and lightly screw the bolts into the threaded holes beneath the front of the table (B), see fig 04. **NOTE: Leave sufficient distance between the bolt head and table for mounting the fence rail.**

**Fig 04**



**Step 2** Find the fence rail (C), line up the half moon cutouts with the four bolts in the table and insert the fence rail up against the table (B), see fig 05.

**Fig 05**



Secure the fence rail (C) in position by tightening the four bolts with the supplied spanner, see fig 06.

**Fig 06**

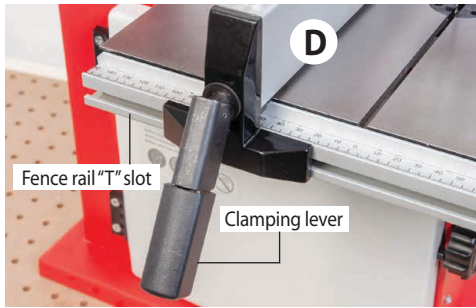




## ASSEMBLY

**Step 3** Locate the fence assembly (D). Lower the fence over the table until the clamping lever assembly slots into the fence rail's "T" slot. **NOTE: Make sure the clamping hook to the rear of the fence (D) has engaged over the rear of the table.** Twist the locking lever clockwise to adjust the clamping tension.(two rotations should be adequate) then press down the lever to lock the fence in position, see figs 07-08.

**Fig 07**



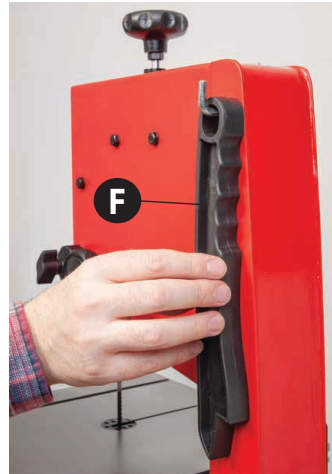
**Fig 08**



**Fig 09-10**



**Step 4** Locate the angled bolt (K), screw the threaded end of the bolt into the threaded hole to the top of the bandsaw frame and, using the supplied 10mm spanner, tighten with the nut to lock the bolt in position, see fig 09. Find the push stick (F) and hook it onto the angled bolt (K), see fig 10.



**Fig 11**



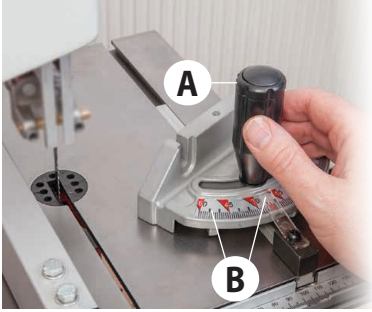
**Step 5** Locate the optional mitre fence assembly (E) and slide it into the table's "T" slot, see fig 11.



## ILLUSTRATION AND PARTS DESCRIPTION



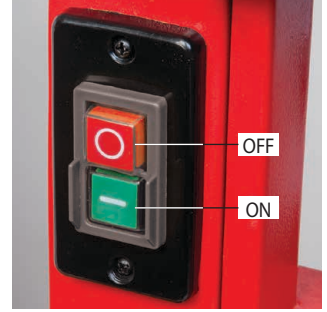
## ILLUSTRATION AND PARTS DESCRIPTION



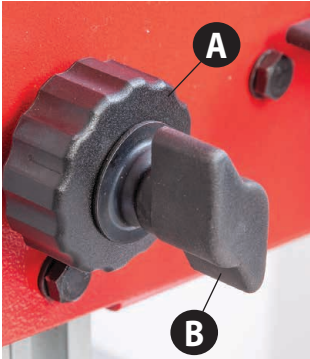
Optional mitre fence assembly (A)  
Index and pointer (B)



Table levelling stop bolt



ON/OFF NVR switch assembly



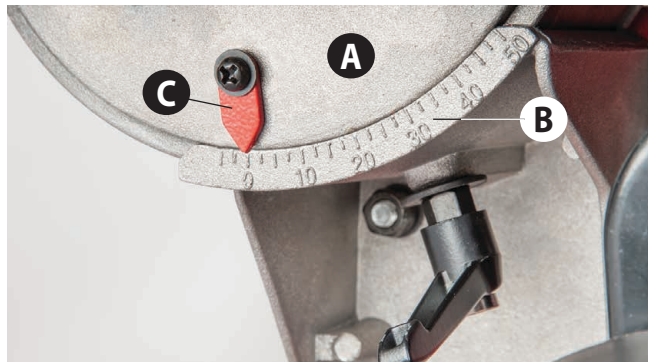
Blade guide adjusting knob (A)  
Blade guide clamp (B)



Tracking control knob (A)  
Tracking control butterfly lock (B)

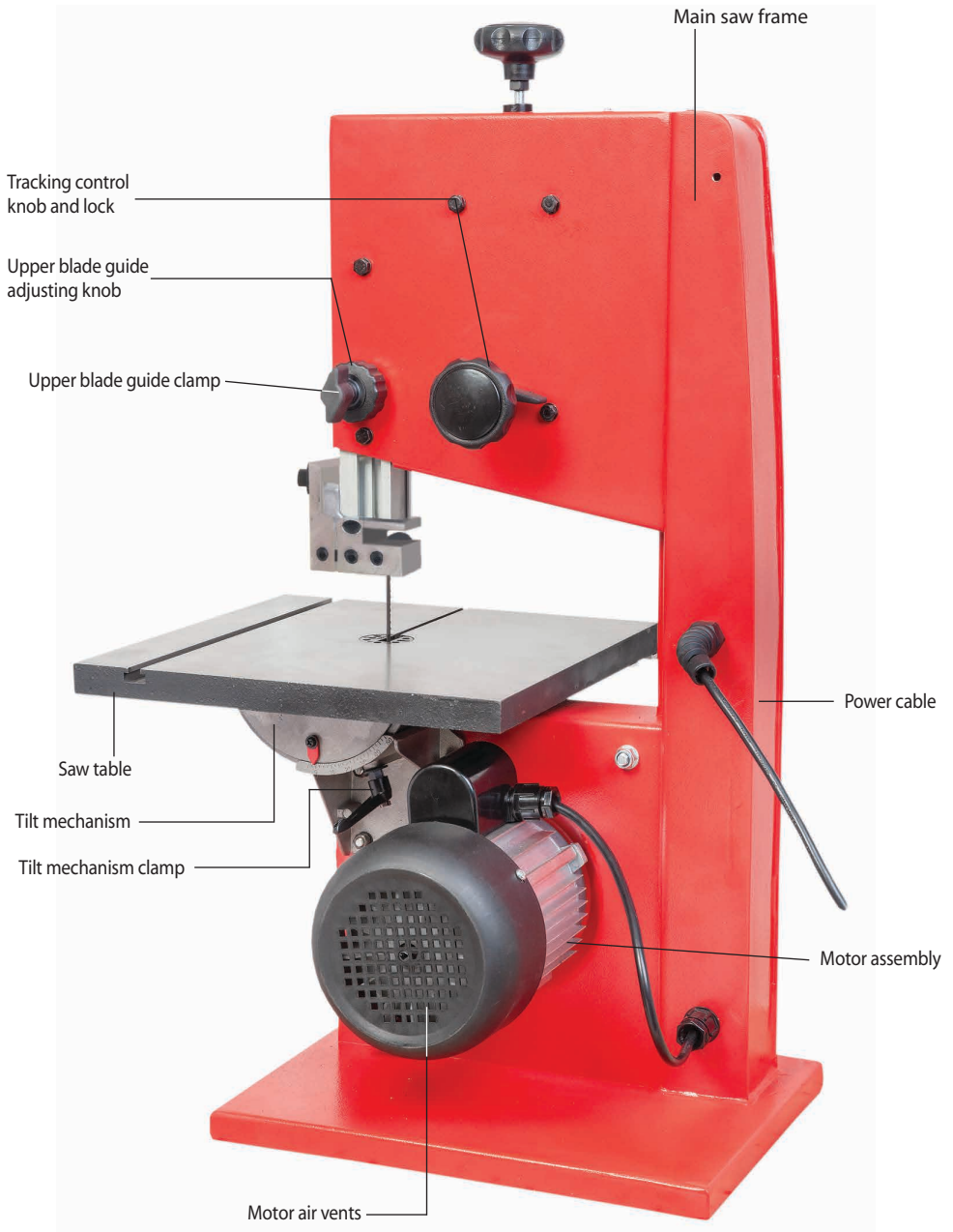


Blade tensioning knob

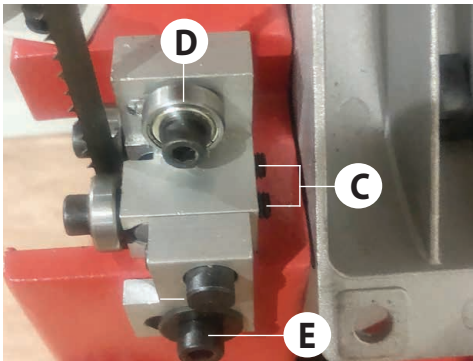
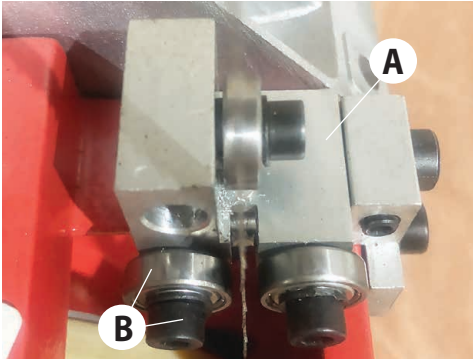


Tilt quadrant (A), Tilt scale (B)  
Tilt scale pointer and adjusting screw (C)

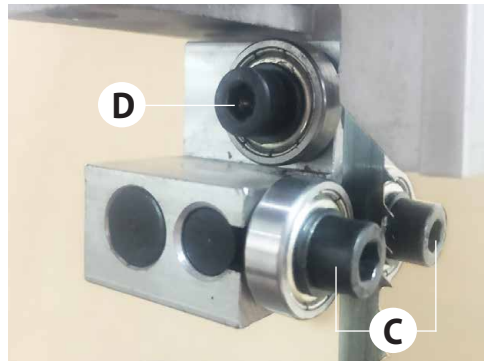
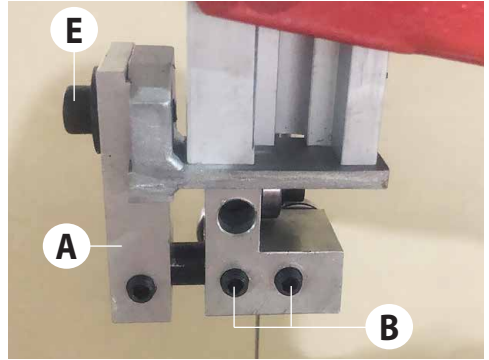
## ILLUSTRATION AND PARTS DESCRIPTION



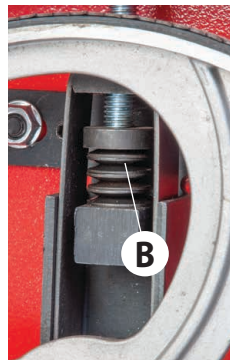
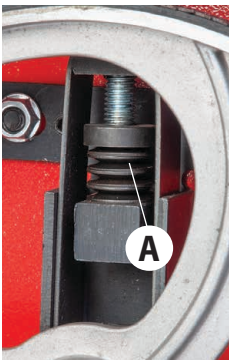
## ILLUSTRATION AND PARTS DESCRIPTION



Lower blade guide assembly (A)  
 Guide bearing & adjustment caphead bolt (B)  
 Guide bearing locking grub screws (C)  
 Rear thrust bearing & clamping bolt (D)  
 Guide assembly fore and aft clamping bolt (E)

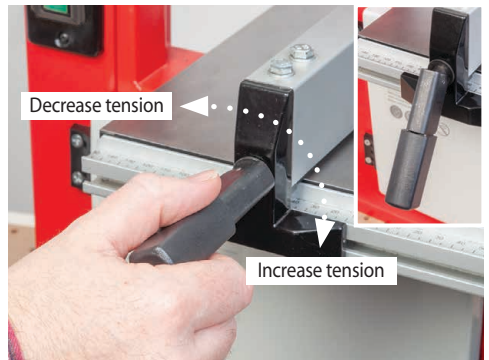


Upper blade guide assembly (A)  
 Guide bearing locking grub screws (B)  
 Guide bearing adjustment caphead bolts (C)  
 Rear thrust bearing and clamping bolt (D)  
 Guide assembly fore and aft clamping bolt (E)



Blade tensioning spring (A),  
 under tension

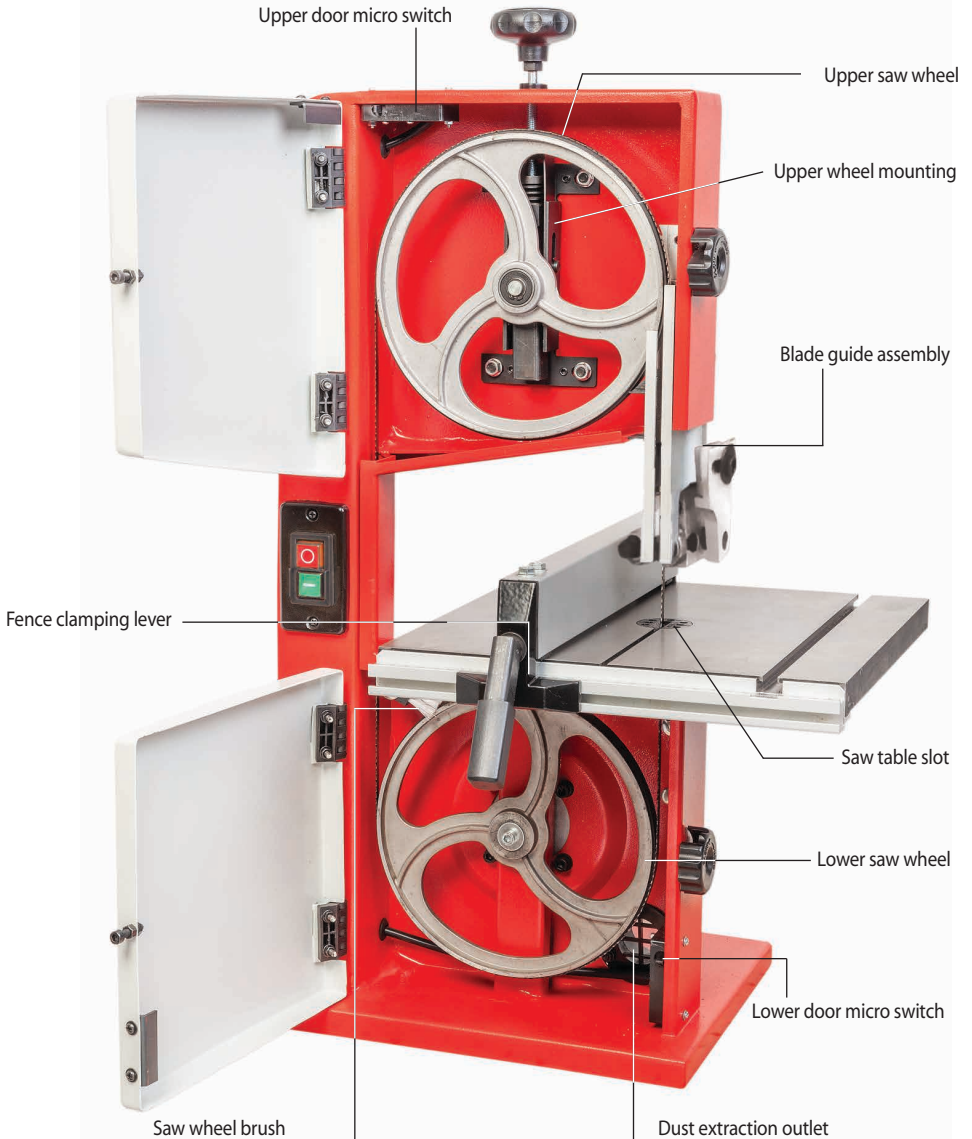
Blade tensioning spring (B)  
 with no tension applied



Twist the locking lever clockwise to adjust the clamping tension, (Two rotations should be adequate) then press down the lever to lock the fence in position.



# ILLUSTRATION AND PARTS DESCRIPTION



## SETTING UP THE SAW



**DISCONNECT THE SAW FROM THE MAINS SUPPLY!**

### Tensioning and tracking the blade

**Make sure both top and bottom blade guide are well clear of the blade.**

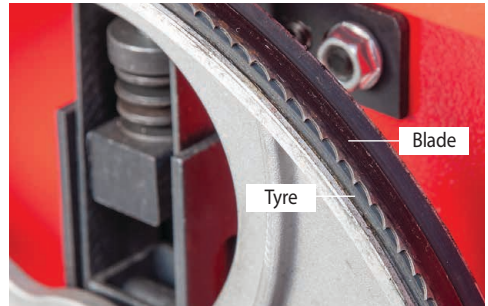
Open the front covers fully, giving good access to the top compartment of the saw and good visibility into the bottom compartment, see page 13. For tracking the blade first adjust all bearing guides so that they're well clear of the blade. Check that the blade is sitting approximately in the middle of the wheels, see fig 12.

Apply some tension to the blade by turning the tensioning wheel clockwise. Spin the top wheel by hand, and check that the blade remains centrally on the tyre, see fig 13. If it does not, loosen the tracking control lock and adjust the tracking by turning the tracking control at the rear of the upper saw wheel compartment, see fig 14. Viewed directly onto the tracking control wheel, turning clockwise should cause the blade to track to the rear of the tyre, anti-clockwise to the front (**DO NOT make large adjustments**).

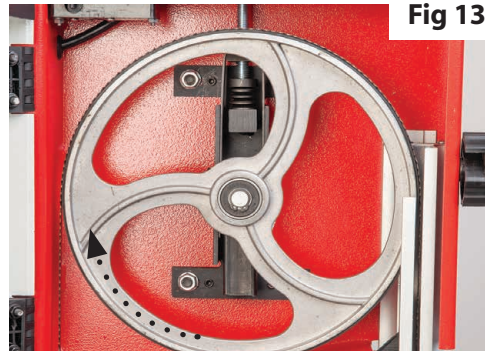
Spin the top wheel again, check again. Continue until the blade tracks in the centre of the tyres with no appreciable to and fro movement. Tension the blade fully. A sideways push on the blade should allow a maximum of 1 centimetre of movement with moderate pressure on the blade. Check the tracking again, adjust if necessary.

Connect the power to the machine. Stand clear and start the saw, check that the saw is running smoothly, (no thumps, bumps, knocking or excessive vibration) and the blade appears to be tracking correctly (in one place). You can check this by holding a marker e.g. a pencil, close to the back of the blade (approach from the back of the blade only) and check that the gap remains constant. If it doesn't, adjust the tracking until it does. If you adjust the tracking with the saw running, make very small adjustments and wait for the saw to react before you adjust again, sometimes the reaction is not instantaneous. Once you are satisfied that the tracking is correct switch the machine off and allow it to run to a stop. Retighten the tracking control lock.

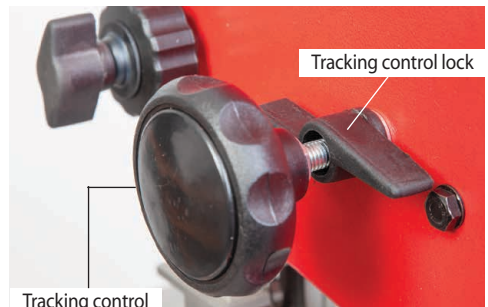
**Fig 12**



**Fig 13**



**Fig 14**



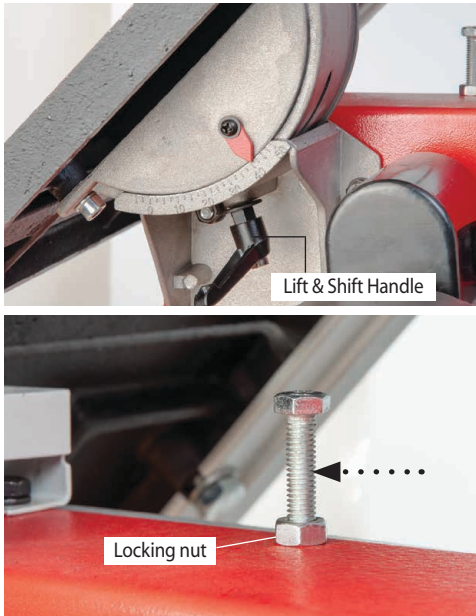
**DISCONNECT THE SAW FROM THE MAINS SUPPLY!**

## Checking the table is square

If the preset table stop has been fitted, proceed as follows:-

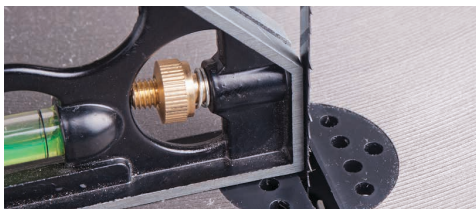
Loosen the lift and shift handle clamping the tilt mechanism, see fig 15, and turn the table hard against its stop. This is a bolt with a lock nut screwed into the underside of the table, see fig 16, that acts as a stop when it strikes the machine frame. Tighten the butterfly nut.

**Fig 15-16**



Make sure the upper blade guide is raised as high as possible. Place a square on the table and move it up against the blade (behind the teeth), see fig 17.

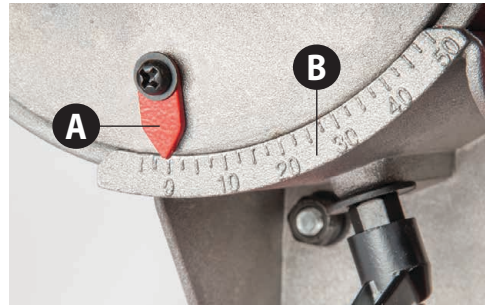
**Fig 17**



Check that the blade is perpendicular to the table. If it is not, try resetting the table.

If it is still not correct, loosen the locking nut and adjust the bolt until perpendicularity is achieved, see fig 16. Tighten the lock nut and then re-check. When you are satisfied that the table is set correctly, check that the pointer of the tilt gauge reads zero, if not, adjust it, see fig 18.

**Fig 18**

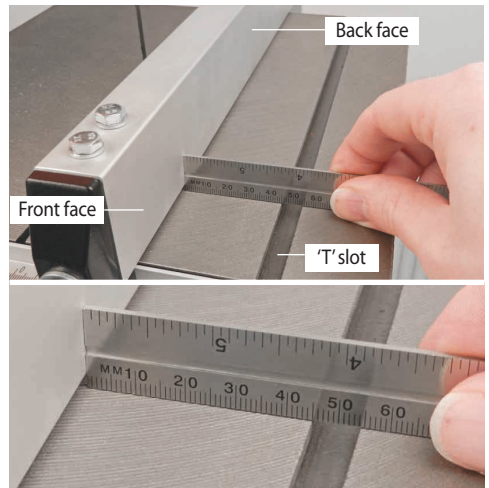


Tilt pointer (A) and tilt gauge (B)

## Setting the Fence

Always make sure the fence is parallel to the table by placing an engineer's rule against the fence and setting equal distances to the front and back face of the fence, see figs 19-20.

**Fig 19-20**





# SETTING UP THE SAW

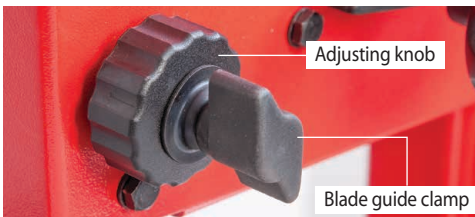
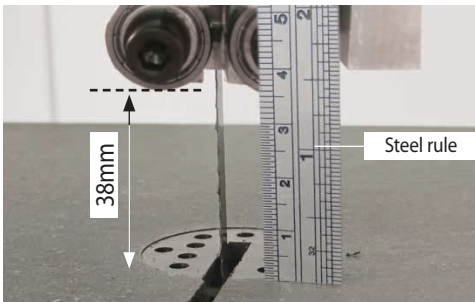


**DISCONNECT THE SAW FROM THE MAINS SUPPLY!**

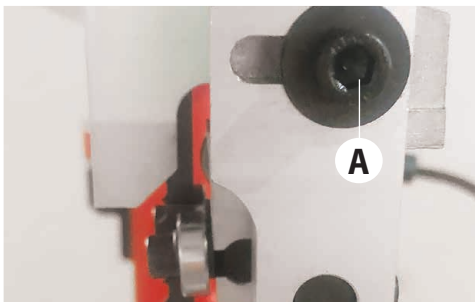
## Setting the Blade Guides

Lower the upper blade guide to approximately 1 1/2" (38mm) above the table by loosening the blade guide height clamp and turning the adjusting knob. Clamp in place, see figs 21-22. Loosen the bolt (A) holding the guide assembly in place, see fig 23. Adjust the fore or aft position so that the leading edges of the side guide bearings are approximately 2mm behind the gullets of the saw blade. Re-tighten the clamping bolt, see figs 24-25.

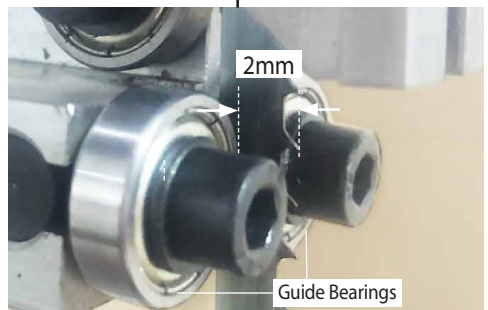
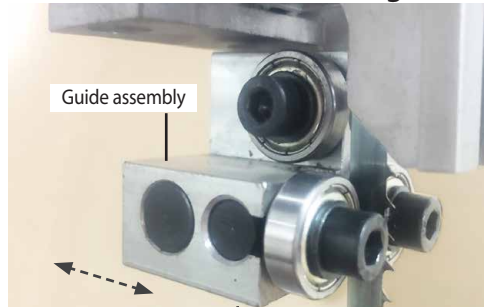
**Fig 21-22**



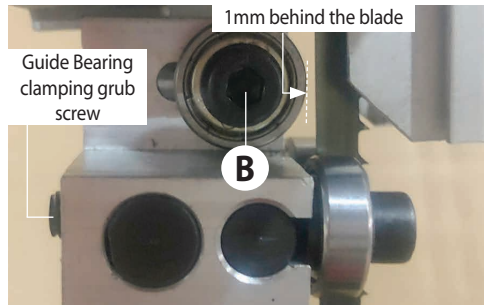
**Fig 23**



**Fig 24-25**

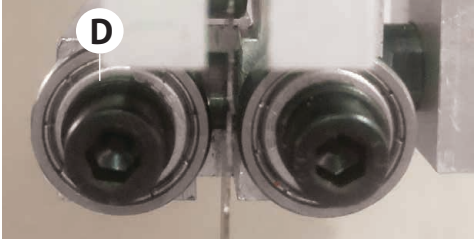


**Fig 26**



Loosen the bolt (B) that clamps the rear thrust bearing and move the thrust bearing so it's 1mm behind the blade; re-tighten the clamping bolt, see fig 26. Turn the blade by hand to check the thrust bearing turns. Loosen the two grub screws to the rear of the guide assembly, see fig 26. Using a Hex key move the bearings (D), approximately 0.5mm from each side of the blade, see fig 27. Re-tighten the grub screws to lock the bearing in place.

**Fig 27**

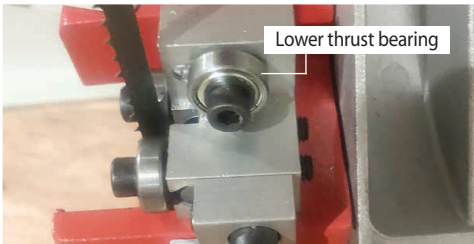


**Setting the Lower Blade Guides**

**NOTE: For easier access to the lower blade guides it is recommended you remove the table.**

Open the lower wheel access door and the lower blade guard door, see fig 28. Repeat the procedures as described for the upper blade guides and thrust bearing, see fig 29. Once all adjustments are completed rotate the blade, replace the table and close the blade guard door.

**Fig 28-29**



Close the upper and lower doors, re-connect the power, switch the saw on, allow to run for several minutes, check that the blade is still tracking correctly, there is no excessive vibration, etc. Switch off and wait until the saw comes to a complete stop. The saw is ready to be used.

**Setting the Fence Scale**



**NOTE: MAKE SURE THE TABLE AND FENCE IS SQUARE TO THE BLADE!**

The fence scale strip does not come pre-mounted to the fence rail and need to be stuck in place. **NOTE: Before sticking the scale down make sure the table and fence assembly is square to the blade.** Follow the instruction below.

**Fig 30**



1) Place a square against the blade & adjust the table until it's square to the blade.

**Fig 31**



2) Position the fence against the bandsaw blade and lock in place.

## SETTING UP THE SAW

**Fig 32**



3) Check the fence is square to the table.

**Fig 33-34**



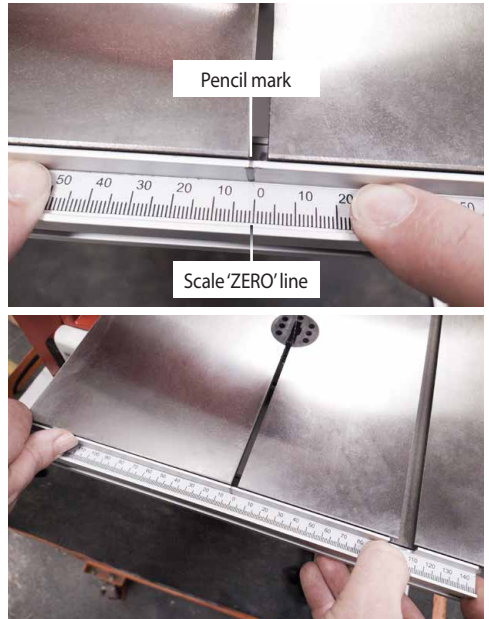
4) Using a steel rule check the fence is still in-line with the cast iron table.

**Fig 35**



5) Using a pencil, 'MARK' the position on the guide fence rail. Remove the fence assembly.

**Fig 36-37**



6) Peel off the backing from the scale strip, line-up the 'ZERO' line with the pencil 'MARK' and carefully stick down the strip onto the fence rail.

**Fig 38**



7) Place the fence back on the table and up against the blade, lock in place. The fence should be aligned with the 'ZERO' line on the scale.

**Fig 39**



## OPERATING INSTRUCTIONS

**1.** Make sure you have read and fully understood the general instructions and safety precautions that are printed in the preceding pages of this manual.

**2.** Before connecting the machine to the supply; check the tool for obvious signs of damage, paying particular attention to the plug and the power cable. Rectify or have rectified any damage you discover. Check that the blade you are using is the correct one for the job in hand. Change the blade if necessary. Check the blade is not damaged; is clean, sharp, tracks properly and is correctly tensioned.

**3.** Set the upper blade guide to approximately 12mm (1/2") above the height of the work piece.

**4.** Check, especially on site, that there are no foreign objects e.g. old nails, screws, small stones etc. embedded in the material you are about to cut.

**5.** Check that all accessories, tools etc., that have been used to set the machine up, are removed and set carefully aside or stowed away correctly.

**6.** Ensure the machine is switched off. Plug the power cable into a correctly rated switched socket



**UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN THE WORK AREA AND KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN!**



**CONNECT A DUST EXTRACTION MACHINE TO THE SAW.**

outlet. If extension leads are being used, check these for damage, do not use if damaged; if you are working outside, check that any extension cables in use are rated for outside work. Switch on. Allow the saw to run up to speed.

**7.** Make sure that the material you are about to cut is within the machine capacity, and the cut you are about to make is within the blade's capabilities. e.g.

**Do not** try to cut a 1" radius curve using a 5/8" blade.

**8.** Make sure the blade is not in contact with the material when you start the saw. Start the cutting operation.

## OPERATING INSTRUCTIONS

**Do not** try to cut too quickly; the correct cutting speed, if one could be so precise, would never see the blade pushed back against the thrust bearing. The saw would cut and clear the saw line at the rate the work piece was fed into it. If you notice that you require more and more pressure to effect the cut, and the blade is in continual contact with the thrust bearing, the chances are the blade is becoming blunt. Check and change if necessary.

**Do not** let go of the work piece; if you have to change your grip, make sure one hand is holding the material at all times.

**9.** If you are cutting long pieces of material think about sawing cutouts (i.e. a saw cut from the edge of the material to the saw line) along the saw line so that you can discard the off cuts as you progress down the saw line.

**10.** Observe the old woodworkers' adage of never allowing your hand/fingers within one handbreadth of the blade.

**11.** If you have to cut very small pieces of material, arrange or manufacture some form of 'shoe' to carry the timber. If the work piece is exceptionally small, find something to use as a sacrificial carrier and mount the work piece on it with double sided tape, or similar.

**12.** Remember to check the blade tension after a new blade has been 'working' for 30-60 mins. The blade will 'stretch' slightly when new.

**13. Do not** release the tension on the saw blade when work is complete. The blades and the main saw frame do not respond kindly to frequent large changes in stress and tension. Only release the tension to change the blade or if the blade is to be removed because the machine is to be 'mothballed' for a lengthy time period. The blade in tension over a long period of non-use will cause the tyres to develop 'flat' spots.

**14.** Open the saw cut, either by pulling apart or driving a wedge in close to the back of the blade. Try to "wriggle" the blade free of the saw. If this is not possible; check that the saw is free in the cut, start the saw, allow it to run up to speed and 'cut out' as quickly as possible. The removal of the 'off cut' may well prevent the saw jamming again if you resume the original cut.



**USE THE SUPPLIED PUSH STICK WHEN CUTTING SMALL PIECES.**



**WARNING! IF THE SAW JAMS! SWITCH OFF IMMEDIATELY.**

## CHANGING THE SAW BLADE



**DISCONNECT THE SAW FROM THE MAINS SUPPLY!**

Put the table back to the level position if it has been tilted. Set the upper blade guide assembly approximately midway in the throat. Open the top and bottom covering doors. Remove the fence and guide rail and place safely aside. Slacken the blade tension by turning the blade tensioning wheel anti-clockwise, until the blade can be easily slipped off the wheels, see fig 30.

Remove the blade carefully, "wriggling" it clear of the upper blade guard, and out through the slot in the table. NOW is an excellent time to clean out the interior of the machine, remove the impacted 'crud' from the tyres, apply a little light oil to the screw

**Fig 30**



Slacken the blade by turning the tensioning wheel anti-clockwise threads of the blade tensioner, and the tracking control. The pivots and the slides of the top wheel



## CHANGING THE SAW BLADE

mounting assembly could likewise be lightly oiled. If you are fitting a new blade it will have been supplied to you “folded”; bound together in this configuration with tape or tie wrap. Also check the blade did not “unfold” inside out. i.e. looking at the right side front of the loop, the teeth should be on the front of the blade, and pointing down. If you can’t arrive at this view, turn the blade inside out from its current position and look again.



**NOTE: BE VERY CAUTIOUS WHEN YOU “UNFOLD” THE BLADE; IT TENDS TO ‘SPRING’ OPEN, BLADE AND TEETH GOING EVERYWHERE.**



**MAKE SURE THE BLADE TEETH ARE POINTING DOWN!**

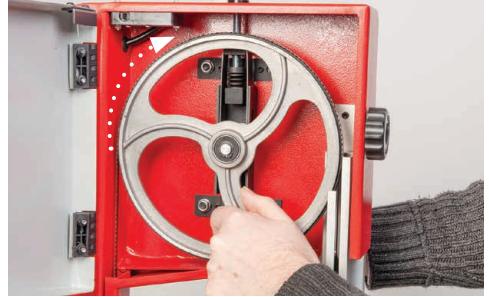
Open up all blade guide pins so that they are clear of the blade. Hold the blade approximately midway on either side of the loop and feed into the table slot. When you get to the table insert cutout void, work the left side of the loop into the slot in the guard in the neck of the main saw frame. “Wriggle” the right hand side of the blade through the guard on the upper blade guide assembly. Ease the blade over the wheels and locate the blade in both the upper and

**Fig 31**



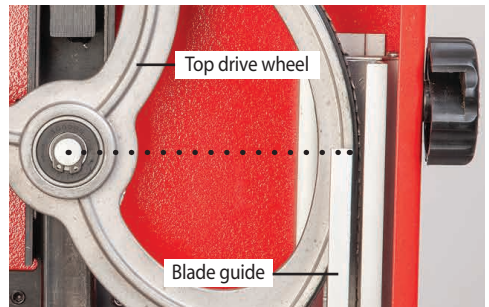
lower blade guides, see fig 31. Apply some tension to the blade. Turn the top wheel by hand to ensure the blade will not skip off the wheels and the blade is travelling in the blade guides, see fig 32. Apply a little more tension and check by once again spinning the

**Fig 32**



upper saw wheel by hand. Loosen the upper blade guide clamp and set the upper blade guide assembly so that the top of the blade guide is level with the centre of the top drive wheel, see fig 33. Re-tighten the clamp.

**Fig 33**



When you are sure that the blade is “ON” and stable, re-fit the fence rail and fence. Now carry out the procedures as detailed in “Setting up the Saw”.

# ROUTINE MAINTENANCE

## Daily

- Keep the machine clean.
- Check the saw blade for missing teeth and cracks, see fig 34.
- Spray oil the bare metal surfaces.

## Weekly

- Open the top & bottom wheel covers and clean out all saw dust.

Clean out impacted 'crud' & saw dust



## Monthly

- Open the lower and upper doors and check the condition of the tyres & the drive belt, see fig 34.
- Clean impacted 'crud' from the tyres, apply a little oil to the screw threads of the blade and drive belt tensioners. **DO NOT USE OIL** near the belt.
- The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the belt tensioner in its slot could likewise be lightly oiled.
- Using an air line (**wearing goggles**) blow out the vents in the motor casing, see fig 35.

Fig 34

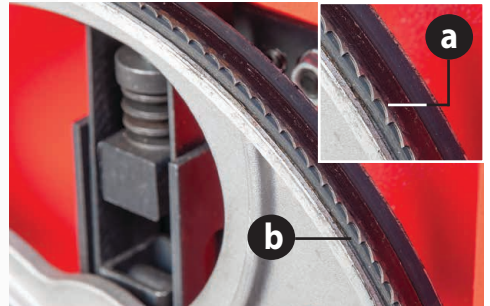


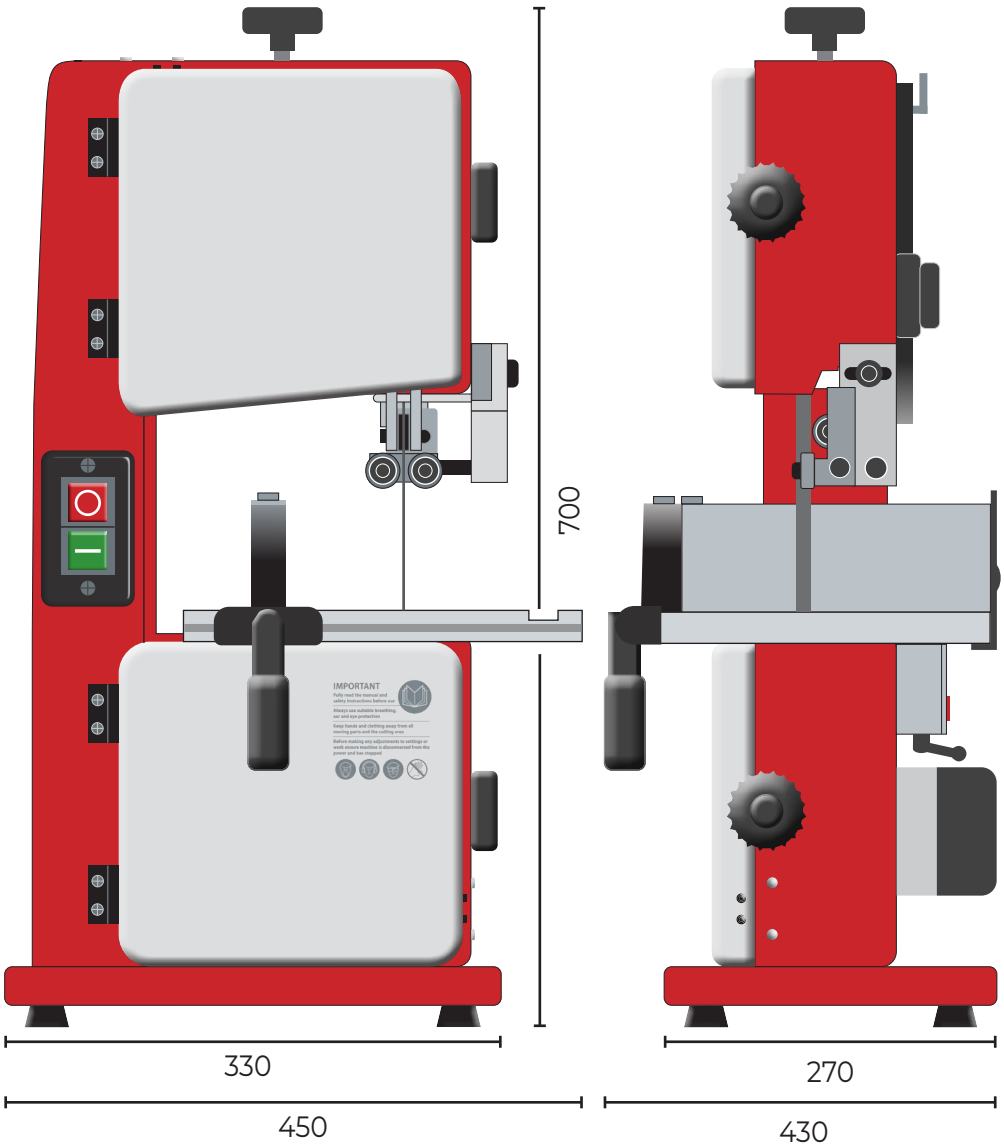
Fig 35



- Check for missing teeth (a)
- Check the condition of the tyres (b)
- Blow out motor vents (c)



# MACHINE FOOTPRINT



# BANDSAW BLADE INFORMATION

## About Axcaliber Bandsaw Blades

Axcaliber bandsaw blades are manufactured at Axminster using advanced CNC machining, high precision digital measuring equipment and specialised heat treatment facilities. Detailed quality checks are performed at each stage of manufacture using the most modern inspection equipment. The result is a blade which consistently cuts straighter, has harder, longer-life teeth and which gives a superior finish to the work. The final step in the manufacturing process is one of the most important; the weld. We have invested heavily in this area through the purchase of precision welding and grinding equipment and are, as a result, one of the few companies worldwide able to offer a fully guaranteed weld. Blades are cut accurately to length then, using an IDEAL bandsaw blade welder, a high voltage current is passed through the blade to achieve a precision butt weld. The weld is annealed to remove any brittleness and danger of fatigue and then hand dressed to produce a perfectly smooth joint.

## Choosing the Right Tooth Pitch (tpi)

### 3 tpi (skip form)

Used for deep cutting especially rip cuts, this blade will leave a rough sawn finish although slow feed rate and high tension will improve the finish of the cut.



### 4 tpi (skip form)

Good for general-purpose use with a degree of cutting across the grain and with the grain, reasonable finish can be achieved with slower feed rates and good tension.



### 6 tpi (skip form)

The ideal general purpose blade suitable for cross cutting up to 150mm and ripping in sections up to 50mm thick although thicker sections can be cut using slow feed rates. This tooth form will give a clean finish and is very well suited to natural timbers.



### 10 tpi (regular)

Good for cutting plywood and MDF as well as non-ferrous metals and plastics. The finish is good when cutting natural timbers but the feed rate should be slow and maximum depth of cut should not exceed 50mm. When cutting metals reduce the speed as much as possible especially when cutting ferrous metals or cast iron.



### 14 tpi (regular)

A very clean cutting blade for plywood, plastics and MDF although too fine for natural timbers unless they are very thin sections (sub 25mm thick). The 14tpi blade is very good to use on slow speeds when cutting non-ferrous metals. A slow feed speed should be used at all times with a blade tooth pitch this fine.



## Blade Width

Always use the widest saw blade possible; it is stronger and will withstand greater feed pressures without flexing. Consult your machine manual for the maximum and minimum blade widths that it will accept. The minimum radius of curve for each blade width is as follows:

Blade width	Minimum radius
9.5mm (3/8")	27mm (1 1/16")
6mm (1/4")	19mm (3/4")
4.8mm (3/16")	13mm (1/2")
3mm (1/8")	10mm (3/8")

## Blade Length

This is determined by your machine model. A list of the most popular machines and their blade lengths is found in the catalogue.

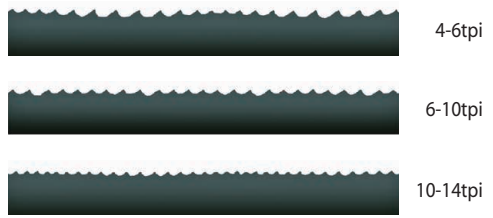
## Blade Tooth Form

Standard Blade Tooth Forms: We supply bandsaw blades with one of two tooth forms, skip or regular:

## BANDSAW BLADE INFORMATION

The skip tooth is provided on coarse tooth blades, those with 3, 4 and 6 teeth per inch; it has a wide shallow gullet with plenty of space for waste to collect. Please note that the quality of the cut can be adversely affected by sawdust packing between the teeth.

The regular, or triangular, tooth form is provided on blades with 10 or more teeth per inch where, because of the reduced material removal, there is less need for waste storage.



### Premium Bandsaw Blades

- Premium blades made from M42 with 8% cobalt.
- Long life with high resistance to heat, abrasion and vibration.
- Variable pitch teeth for wider ranging applications.
- Also used for cutting metal on horizontal bandsaws  
Blades are available in three variable pitch forms 4-6tpi, 6-10tpi and 10-14tpi.



### High Carbon Bandsaw Blades

- General purpose range of blades for wood and metal cutting.
- Comprehensive range of lengths widths and tooth configuration.
- Hardened and long lasting teeth.



### Ground Tooth Bandsaw Blades

- Diamond ground teeth staying sharper for at least 30% longer.
- Smoother cut over general purpose milled tooth blades.
- Comprehensive range of lengths, widths and tooth configuration.



### Back Tooth Bandsaw Blades

- Specifically designed for curve cutting so ideal for wood turners.
- Back tooth design allows better clearance and tighter curves.

- Available in one width of 5/16" (8mm) x 4 tpi.

# AW1400B BANDSAW BLADES

## Standard Axcaliber Bandsaw Blades

TPI	Width	Code
6	1/4"	508253
10	1/4"	508254
14	1/4"	508255
24	1/4"	508256
32	1/4"	508257

## 1,400mm(55") x 0.014"

Axminster AW1400B Craft Bandsaw

TPI	Width	Code
4	3/8"	508258
6	3/8"	508259
10	3/8"	508260
14	3/8"	508261

## BANDSAW TROUBLE SHOOTING/ACCESSORIES

### Trouble Shooting

Bandsaws are relatively simple machines and with all machinery regular servicing (preventative maintenance) is essential to get the best from your saw.

**"My bandsaw won't cut straight"**

- This is the most common question that you will get from bandsaw users. Usually the answer lies within the blade; poor quality blades with uneven set, the blade is blunt or damaged often only on one side, the tooth count is far too high for the material being cut - remember 2 teeth minimum and 10 teeth maximum in the workpiece.
- The fence is out of line with the blade.

**"My bandsaw vibrates"**

- Clean machine wheels.
- Check blade is running correctly on wheels.
- Check blade weld – is it in line?
- Check machine is not on an uneven floor.

**"My bandsaw slows down when cutting"**

- Check drive belt is tensioned correctly.
- If cutting hard or wet material slow your feed rate down.
- Check blade is sharp and not too fine.
- Make sure that when curve cutting a narrow blade is used- see unit 5 blade and cutter types.

**"Can I cut steel on my bandsaw?"**

- No, most woodcutting bandsaws run far too fast to cut steel even if a metal cutting blade is fitted.

### Accessories

Please visit our website at [axminstertools.com](http://axminstertools.com)



Mitre Fences



Bandsaw Blades



Lubricants and Maintenance Tools



Squares



Extractors



**Code: 101807**

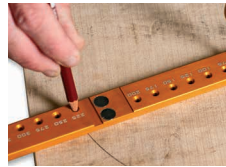
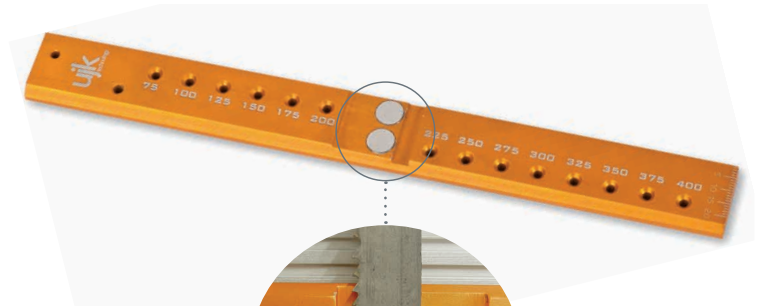
## INTRODUCTION

• Bandsaw Buddy is a unique bandsaw blade aligning tool. Bandsaw Buddy allows you to check the alignment of the bandsaw blade to the face of the fence. Most other checks only require the use of a combination or engineer's square. Truing the fence to the blade is tricky. Bandsaw Buddy has two rare earth magnets which hold it firmly on the blade. At 250mm long it is easy to spot any discrepancy and then make necessary adjustments. The magnets will keep it safely stored on the bandsaw's frame when not in use.

• A scale on the tip helps set the bandsaw fence for cutting veneers or thin boards. Holes along the Buddy's length at 12.5mm intervals allow you to draw arcs or circles in 25mm steps from 75mm to 400mm, a useful feature for marking curves or when cutting bowl blanks. Accurately machined from anodised aluminium, it also makes a handy straight edge.

## KEY FEATURES

- Designed and made in Axminster
- Unique bandsaw blade aligning tool
- Checks the alignment of blade to the face of the fence
- Rare earth magnets hold it firmly on the blade
- 250mm long makes it easy to spot any discrepancy
- Scale on the tip helps set fence for cutting veneers or thin boards
- Holes for drawing circles in 25mm steps from 75 to 400mm
- Accurately machined from anodised aluminium



### Marking Gauge

An easy to use circle marking gauge for bowl blanks from 75mm to 400mm radius in increments of 25mm.



### Accurate Marking

The bandsaw buddy can be used as a straight edge for accurate marking.



### Thickness Gauge

A convenient and accurate metric thickness gauge, great for veneering.



### Perfect Alignment

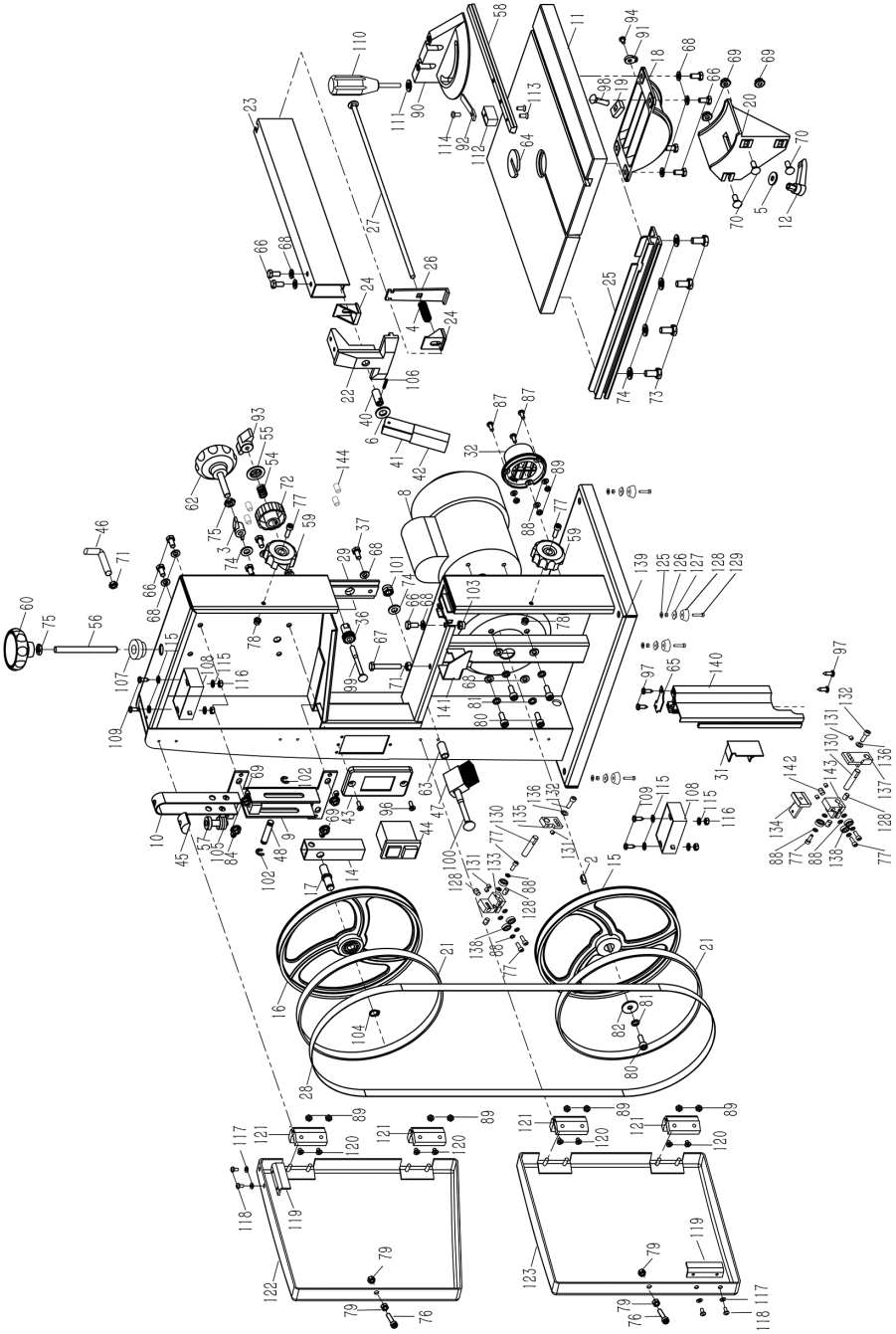
Rare earth magnets securely hold the rule to the blade. This enables you to align your rip fence and table perfectly parallel with the blade.



### Keep your buddy on hand

Once you've used your Bandsaw Buddy the integrated magnets allow simple storage on your bandsaw

# EXPLODED DIAGRAMS/LISTS



## EXPLODED DIAGRAMS/LISTS

No.	Description
2	Key 5x14
3	Wing nut M8
4	Spring,lock plate
5	Washer 6
6	Washer 10
8	Motor
9	Guide bracket
10	Blade tensioner
11	worktable
12	Ratchet lever M6
14	Bearing bolt support upper
15	Lower wheel
16	Upper wheel
17	Bearing bolt upper
18	Table trunnion upper
19	Guide piece
20	Worktable support
21	Bandsaw tyre
22	Locking frame for rip fence
23	Rip fence
24	Washer block
25	Front rail
26	Lock plate for rip fence
27	Lock rod for rip fence
28	Saw blade
29	Upper guide guard base
31	Slide board
32	Dust port
36	Adjusting gear
37	Hex.bolt

40	Locking nut
41	Locking handle
42	Locking handle housing
43	Switch plate
44	Switch
45	Adjusting nut
46	Push stick hook
47	Brush
48	Pin guide
54	Spring
55	Dishing cover
56	Thread rod
57	Tension pin
58	Guide board
59	Knob for door
60	Setting knob
61	Hinge of the door
62	Setting knob
63	Spacer bushing
64	Table insert
65	Cover board
66	Hex.bolt M6X12
67	Hex.bolt M6X40
68	Washer 6
69	Flange nut M6
70	Square neck bolt M6X16
71	Hex.nut M6
72	Adjusting knob
73	Hex.bolt M8X16
74	Washer 8
75	Thin hex.nut M8



## EXPLODED DIAGRAMS/LISTS

76	Hex.socket cap head screw M5X25
77	Hex.socket cap head screw M5X16
78	Self-lock nut M5
79	Hex.nut M5
80	Hex.socket cap head screw M6X16
81	Spring washer 6
82	Thicken washer 6
84	Hex.socket set screw M6X6
87	Cross recessed pan head screw M4X10
88	Washer 5
89	Hex.nut M4
90	Mitre gauge
91	Pointer,worktable support
92	Pointer,mitre gauge
93	Cross recessed pan head screw M4X6
94	Cross recessed countersunk screw M4X6
96	Cross recessed countersunk screw M4X12
97	Cross recessed pan head tapping screw ST4.2X12
98	Square neck bolt M6X25
99	Square neck bolt M6X60
100	Square neck bolt M8X70
101	Self-lock nut M8
102	Split washer 6
103	Self-lock nut M6
104	Circlips for shaft d=26
105	Saddle washer
106	Spring-type pin 3x16
107	Step bushing

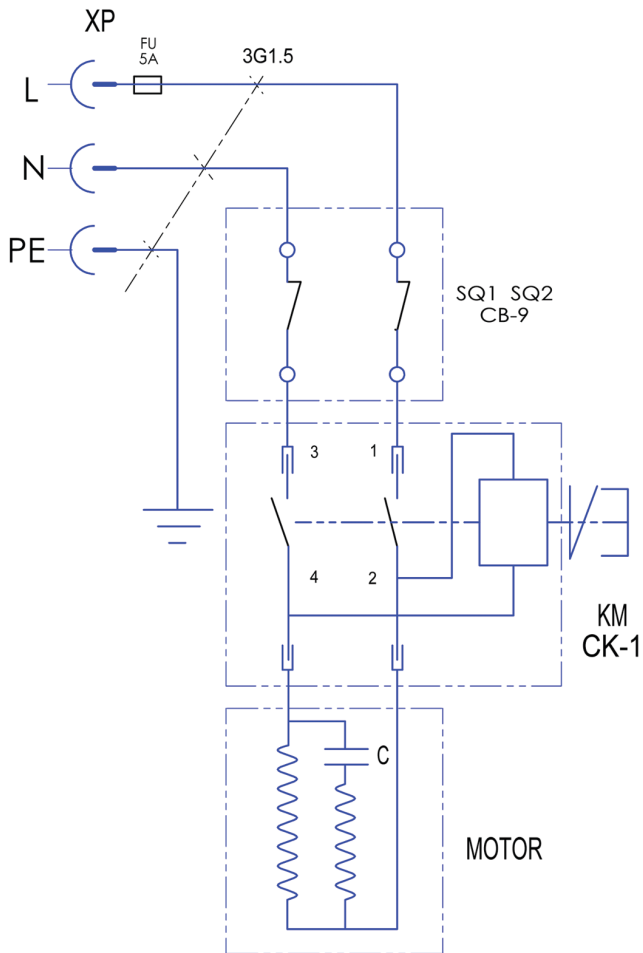
108	safety switch ass'y
109	Cross recessed pan head screw M3X25
110	Mitre gauge knob
	Hex.bolt M6X45
111	Washer 6
112	Mitre gauge block
113	Cross recessed countersunk screw M5X12
114	Cross recessed pan head screw M5X10
115	Washer 3
116	Hex.nut M3
117	Washer 4
118	Cross recessed pan head screw M4X6
119	Touching plate,safety switch
120	Cross recessed countersunk screw M4X14
121	Hinge of the door
122	Upper door
123	Lower door
124	Cross recessed pan head screw M4X16
125	Washer 8mm
126	Hex.nut M8
127	Gasket nut
128	Rubber foot
129	Hex.boltM8X20
130	Connection shaft for upper guide
131	Hex.socket set screw M6X10
132	Hex.socket cap head bolt M6X16
133	Lower guide housing
134	Connection seat,upper guide

## EXPLODED DIAGRAMS/LISTS

135	Connection board,lower guide
136	Washer 6
137	Connection board,upper guide
138	Bearing 625
139	Saw frame

140	Upper guide guard
141	Lower guide guard
142	Bearing nut
143	Bearing seat,upper guide
144	Hex.socket set screw M6X10

## WIRING DIAGRAM



## The Axminster guarantee

Buy with confidence from Axminster!

So sure are we of the quality, we cover all parts and labour free of charge for three years!



For more information visit [axminstertools.com/3years](https://axminstertools.com/3years)

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The packaging is suitable for recycling.  
Please dispose of it in a responsible manner.



### EU Countries Only

Do not dispose of electric tools together with household waste material.  
By law they must be collected and recycled separately.



Axminster Tools, Axminster Devon EX13 5PH

[axminstertools.com](https://axminstertools.com)