

Horizontal Bandsaw Standard Operating Procedures

LIMITATIONS

- The checklist only meant for material ISO grade N, P1-P4, M1-M2. You can find the ISO grade of your material using the following [link](#). ISO grade K supported with specialized training. ISO grade C, S, H or unknown materials cannot be machined on our equipment.
Reference in machine controls how to adjust the speed on the band saw and use guide below the gear switch for what speed to use

- Shapes – Cuboid and round material. Plate and any other geometry stock supported with further training
- Sizes – Max width 3in. Min width. All other sizes will go through a vetting process

MACHINE SPECIFIC HAZARDS

- Loose clothing and body parts can be caught in and amputated by the rotating blade.
- The stationary blades can cut your hands.
- Hands can be crushed by the hydraulic vice.



- Coolant can irritate your skin.
- Spilled coolant and cutting residue can cause slippage on the floor.
- After cutting objects, both the blade and the stock can be hot even with coolant applied.
- Stock can be heavy.

MACHINE CONTROLS







PRE-FLIGHT

- Ensure the **FEED RATE** nob and **FEED ON/OFF** are turned fully clockwise

- ❑ Rase the cutting head by pushing and holding the **RAPID** button
 - NOTE: The head will slightly lower after the **RAPID** button is released therefore you need to hold the button and not just quickly release it
- ❑ Load stock in-between vice jaws
 - NOTE: If vice is not the correct size for your stock move the arm attached to the vice face
- ❑ Turn the **FEED ON/OFF** knob 90 degrees counterclockwise to on position
- ❑ Slowly lower the head to about .5" from stock by turning the **FEED RATE** knob counterclockwise
- ❑ Turn **FEED ON/OFF** to off position
- ❑ Set the desired length to be cut
- ❑ Close the vise by pushing in the **VISE** toggle

OPERATE

- ❑ Disengage the **OFF** button
- ❑ Start the blade using the **BLADE ON** button
- ❑ Set the blade to desired speed using the **SPEED CONTROLL WHEEL**
 - NOTE: MACHINE MUST BE RUNNING
- ❑ Turn on coolant by turning the **COOLANT NOB** counterclockwise
- ❑ Turn the **FEED ON/OFF** knob 90 degrees counterclockwise to on position
- ❑ Lower the head by turning the **FEED RATE** knob counterclockwise
- ❑ Press **OFF** to disengage the blade, wait for the blade to stop.

POST-FLIGHT

- ❑ Close the **COOLANT VAULVE** by tightening it clockwise.
- ❑ Turn off the **FEED RATE** using the **Feed ON/OFF** knob, so it does not fall when raised.
- ❑ Raise the cutting head by pushing and holding **RAPID**.
 - NOTE: The head will slightly lower after the **RAPID** button is released therefore you need to hold the button and not just quickly release it
- ❑ Pull on the **VIDE** toggle to release and remove the stock.
- ❑ Clean the area by wiping up the coolant and sweeping up the chips on both the machine and the floor.
- ❑ Set the feed rate to a low setting using the **FEED RATE** knob. Clockwise lowers the feed rate.
- ❑ Turn on the **Feed Rate** using the **Feed ON/OFF** knob, let it (slowly) fall all the way down
- ❑ Complete assigned 5-minute shop job at the end of your reservation.