

Vertical 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 material. Round, plate, and any other geometry stock supported with further training
- ❑ Sizes - .4 in tall to 1 in tall. Max 12 in deep. Min ½ in between fence and blade, max 10.25in. Min ½ in away from the blade, max 12 in. All other sizes will go through a vetting process
- ❑ Base of saw will be perpendicular to the blade. Angle cuts can be made with special training

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.
- ❑ Coolant can irritate your skin.



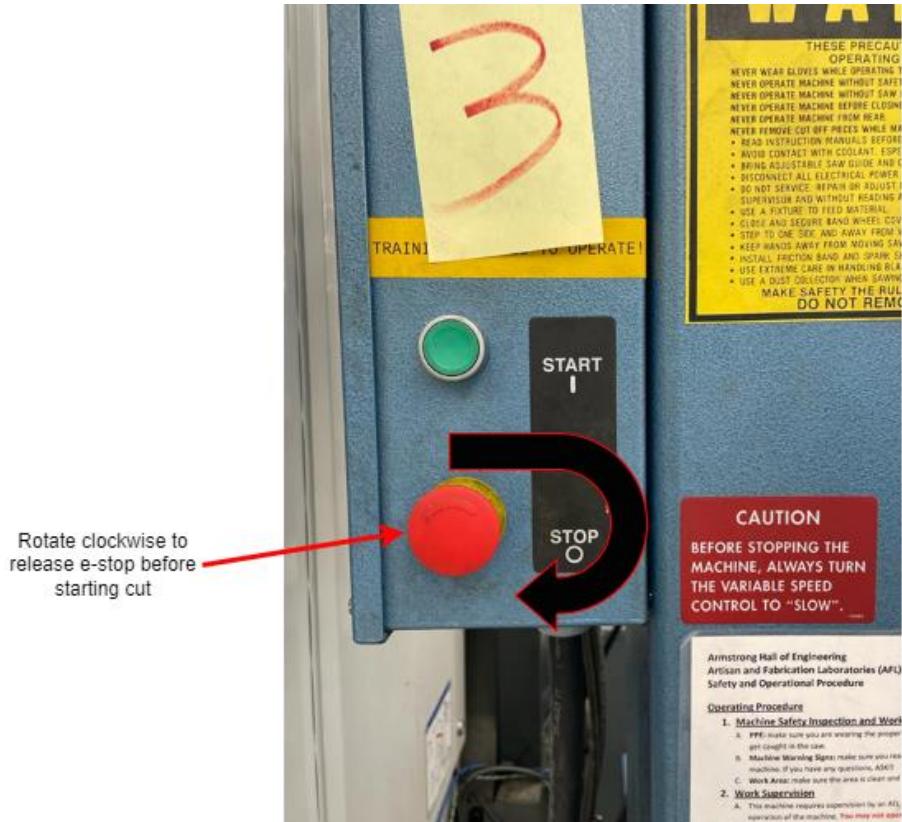
- ❑ Spilled coolant and cutting residue can cause slippage on the floor.
- ❑ After cutting objects, both the blade and the stock can be hot even with coolant applied.
- ❑ Stock and guiding vice can be heavy.

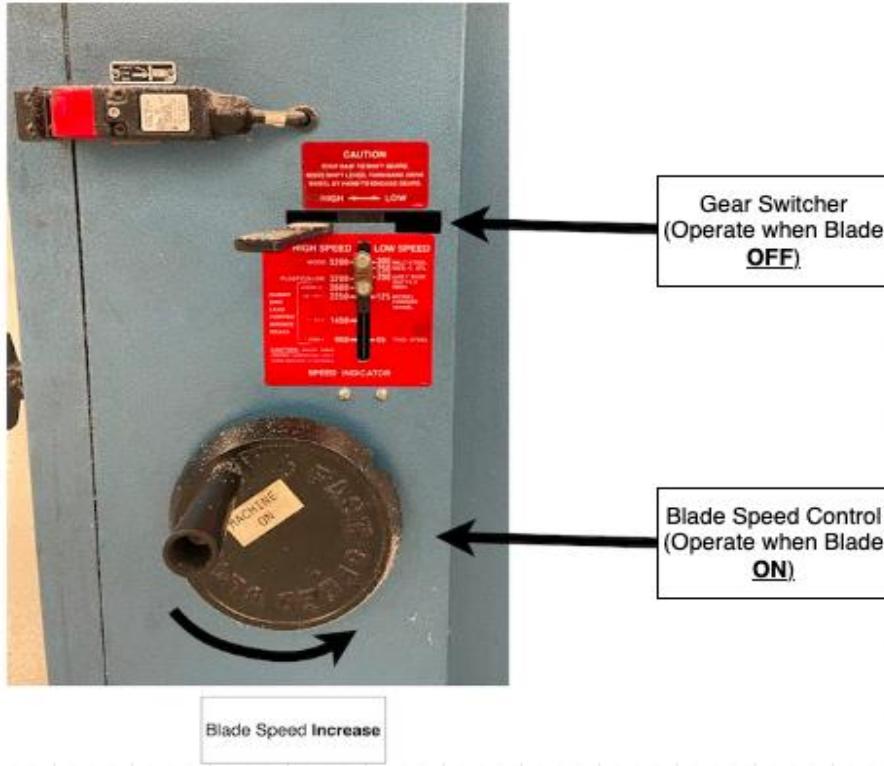


MACHINE CONTROLS

- ❑ Rotate e-stop clockwise to disengage e-stop
- ❑ Press start to engage blade
- ❑ Press e-stop to disengage blade

- While the machine is **ON**, increase and decrease blade speed with blade speed control (indicated in images below)
- While the machine is **OFF** and the speed indicator is at the lowest possible setting, change gears between low speed and high speed. To change gears, lift and bring the gear switcher (indicated in images below) to the other side





PRE-FLIGHT

- Ensure blade is not moving before placing part
- Ensure stock and surface is clean
- Ensure stock is flush with the **Guiding Vice** and table
- Set blade speed and gear according to material type (speed found on side of machine)
- Now move saw guard up to accommodate stock height
 - Open the vertical saw cover



- Remove the black knob



- Place the black knob as can be seen in the above picture and loosen the guard, then physically push it up
- Use the knob to tighten the guard
- Remove knob and place where it was initially

OPERATE

- Start the blade by pressing the green start button
- Begin moving the part towards the blade and stop before making contact
- Use push sticks or hands (whichever is appropriate) to move stock forward slowly through the blade



- Use manual pumped coolant when stock is in contact with blade

POST-FLIGHT

- Push the E-Stop
- WAIT** until blade has reached a complete stop
- Carefully remove your part

Cleanup

- Remove all parts from the machine surface
- Wipe surface and return as found
- Return guard to lowest possible position
- Complete assigned 5-minute shop job at the end of your reservation.