



IFL Training Shift 03-1: Bandsaws

Written By: David Paul Farace



Step 1 — IFL Daily Responsibilities



- Make sure to complete the LM Daily Responsibilities upon entering/using/leaving the space.
- [IFL LM Daily Responsibilities](#)

Step 2 — General Info



- This is a vertical bandsaw. It has a continuously cutting blade in the vertical direction.
 - This is the on-off button for the machine.
- Aluminum, steel, and plastics are allowed. No other materials are, however.

Step 3 — Safety Guardrail Adjustment



- This is the safety guardrail. It should always be 1/4" above the stock on the machine.
- Adjust the height of the red safety guard with this black knob.

Step 4 — Speed Adjustment



- This is the blade adjustment wheel. For harder materials (steel), use a slower speed, and vice-versa for softer materials (aluminum).
- General practice dictates using 30 for slower and 60 for faster speeds. Also, do not change speed unless machine is running.

Step 5 — Use a Push Stick



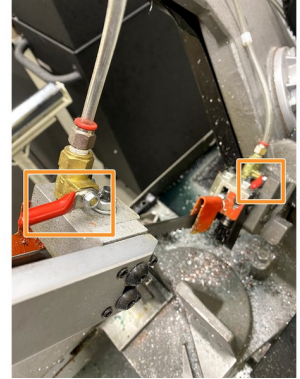
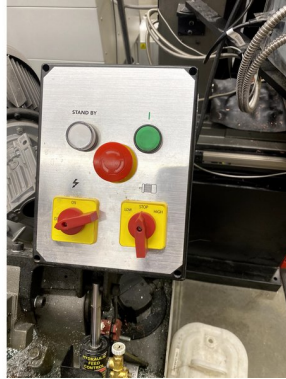
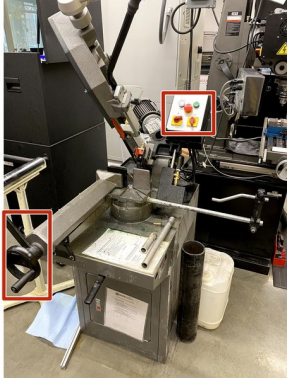
- Whenever using the horizontal bandsaw and pushing material through the blade, use a push stick to keep your fingies safe.

Step 6 — Replace the Blade



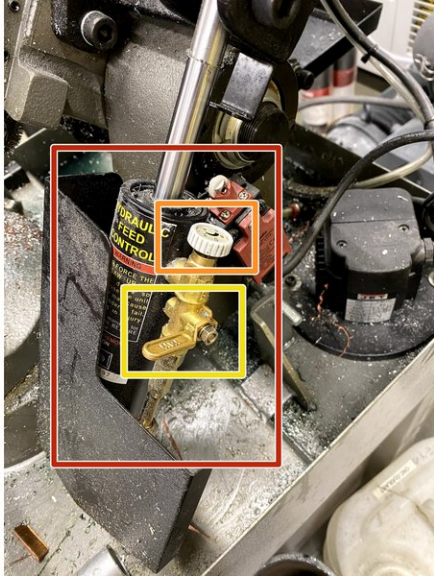
- Use this black knob to loosen the blade in the bandsaw.
- Next, open both doors, as show, and slowly and safely pull the blade out of the bandsaw.
- Do this process in reverse to install the new blade.

Step 7 — Horizontal Bandsaw General Information



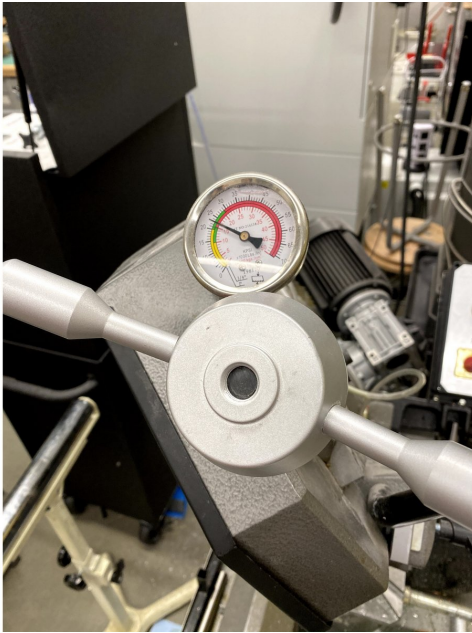
- The horizontal bandsaw differs from the vertical because instead of the piece moving through a "stationary" blade, this blade moves down and through the piece of material.
 - First, you turn the power knob on. Also, use this black knob and lever to hold your piece of stock firmly.
 - Next, you select the blade speed. (based again on hard or soft material)
 - Then, you turn the blade on with the green button on the panel.
 - Next, turn the coolant on for the blade.
- After you have done these steps, you are about ready for cutting.

Step 8 — Letting the Bandsaw Fall




- This is the piston that lets the blade fall.
- This lever will let you control if the blade falls or stops.
- This dial lets you control the speed at which the blade falls.
 - Lets the blade fall slowly through the stock as to not mess up the blade or stock.
- When the blade falls, it will automatically stop when it falls to the bottom of the range of motion it has

Step 9 — Blade Tension



- On the horizontal bandsaw, you want to make sure the blade is within the green on the blade tension gauge.

Step 10 — Dozuki File for the Bandsaws



Horizontal Bandsaw

This manual will show you how to properly replace the saw of the Jet J-9180 horizontal band-saw.

Author: David Kriesberg (and 2 other contributors)

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Vertical Bandsaw

Author: David Kriesberg (and 3 other contributors)

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- All maintenance Dozukis for the bandsaws can be found in the link below.
- [Horizontal Bandsaw](#)
- [Vertical Bandsaw](#)