TLZ200V

Portable Metal Cutting Band Saw Manual

SAFETY RULES

1. KEEP GUARDS IN PLACE and in working order.
2. REMOVE ADJUSTING KEYS AND WRENCHES. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
3. KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.
4. DON'T USE IN DANGEROUS ENVIRONMENT. Don't use power tools in Damp or wet locations, or expose them to rain. Keep work area well lighted.
5. KEEP CHILDREN AWAY. All visitors should be kept safe distance from work area.
6. MAKE WORKSHOP KID PROOF with padlocks, master switches, or by removing starter keys.
7. DON'T FORCE TOOL It will do the job better and safer at the rate for which it was designed.
8. USE RIGHT TOOL doesn't force tool or attachment to do a job for which it was not designed.
9. USE PROPER EXTENSION CORD. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table 1 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.
10. WEAR PROPER APPAREL does not wear loose clothing, gloves, neckties, rings, bracelet or other jewelry, which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
11. ALWAYS USE SAFETY GLASSES AND EAR PROTECTION. Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
12. SECURE WORK. Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
13. DON'T OVERREACH. Keep proper footing and balance at all times.
14. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. DISCONNECT TOOLS before servicing; when changing accessories, such as blades, bits, cutters, and the like.
16. REDUCE THE RISK OF UNINTENTIONAL STARTING. Make sure switch is in off position before plugging in.
17. USE RECOMMENDED CCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
18. NEVER STAND ON TOOL Serious injury. Could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
19. CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of

parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

20.DIRECTION OF FEED. Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.

21.NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. Don't leave tool until it comes to a complete stop. To lock the main switch in the OFF position, remove the switch key from the switch. Place the key in a location that is inaccessible to children and others not qualified to use the tool.

(1) WEAR EYE PROTECTION.

(2) DO NOT REMOVE JAMCUT OFF PIECES UNTIL BLADE HAS STOPPED.

(3) MAINTAIN PROPER ADJUSTMENT OF BLADE TENSION, BLADE GUIDES, AND TRUST BEARING.

(4) ADJUST UPPER GUIDE TO JUST CLEAR WORKPIECE.

(5) HOLD WORKPIECE FIRMLY AGAINST TABLE

Material to be cut

The tool is intended to cut matter material like steel. Iron, copper, etc. NEVER USE THIS TOOL TO CUT WOOD AND EXPLOSIVE METAL MATERIAL.

USE A CORRECT PLUG

As different countries may use different plug, so the user shall install the right plug approved in your country.

GROUNDING INSTRUCTIONS

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 Insulation having an outer surface that is green 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 Personal if the grounding instructions are not Completely understood, or if in doubt as to Whether the tool is properly grounded.

FIG B

Running in the blade

To safe guard the life and quality of a New blade, the first two or three cuts must be made Exerting slight pressure on the piece so that the Cutting time is almost twice the one normally Needed (see cutting table)

Correct positioning of the piece in the clamp

: Pieces to be cut must always be held firmly in The clamp, directly between the two jaws and Without inserting other objects. Were profiles, flat? Bars or particular shapes to be cut, refer to the Examples in fig .B

To cut a long work piece, use roll stand to support it.

Choosing the blade Fig c

Warning:

1. NEVER USE BANDS WHICH ARE DAMAGED OR DEFORMED.
2. NEVER CLEAN THE SAW BAND WHILST IT IS IN MOTION

The choice of the right blade and its tooting Depends on the type of material you have to cut And on its section. Your band saw is fitted with a 1325mm x 13mm, 0.65mm thick metal blade, However, blades with 6 or 14 teeth per inch are Also available for special cutting Requirements, indicated in the "cutting table"(fig c).

Maintenance

1. Be careful: before every cleaning or maintenance operation, ensure that the plug is not in the electric supply socket.
2. Keep the cutting machine free from residue by means of a vacuum cleaner or a brush, passing it also over the blade guides. Keep the band saw in good condition: if it is not to be used for a long time, put it away in its original packing in a damp-free place. In these cases it is advisable to slacken the blade so as not to keep it under tension unnecessarily.

30 · 50 115 max	8/12 6 6	30x s.1 40x s2 50x s.5 max	14 14 8/12
30 40 115 max	8/12 6 6	30x s.1 50x s.2	14 14
25x35 40x50 115x153 max	8/12 6 6		

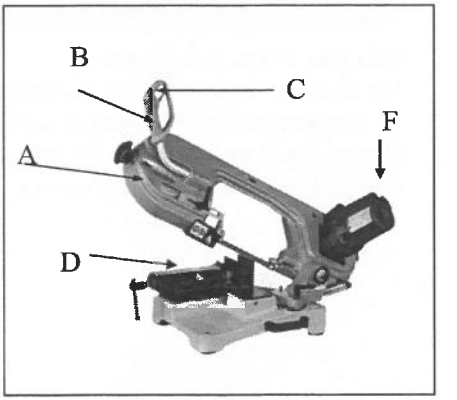
Fig C

AND ASSEMBLY INSTRUCTIONS

FIG 1

This view shows the:

Machine body	(A)	Handle	(B)
Button switch	(C)	VISE	(D)
Spring	(E)	Motor	(F)



Your cutting machine is provided with Manual cutting
(As clearly shown in Fig 3)

FIG 2

TO start the machine move switch (H of FIG2) to ON (I)
Position Press the button (B of FIG1) while manual Cutting.

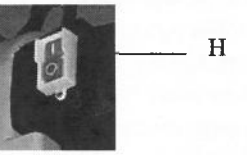


Fig2.

! WARING: WHEN THE TOOL IS NOT IN USE. THE SWITCH SHOULD BE LOCKED IN THE OFF (O) POSTION.

ADJUSTMENTS

FIG8 Adjusting the distance Set Bracket

If you have to cut several pieces, all the same length,
Use the Set Bracket (D of FIG1) provided with the band saw.
In order to avoid repeating the measurements.

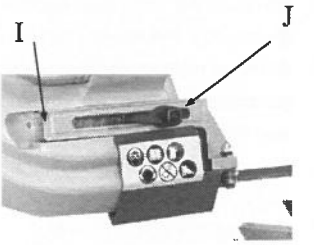


FIG3

FIG7 Adjusting the blade guide

Your cutting machine is provided with a sliding guide (I of FIG3)
With built-in protection, which guides the part of the blade
Necessary to make the cut, and at the same time, protects the
Part of the blade not in use .To do this, simply slacken the
Locking Handle (J of FIG3) and Slide the blade guide (I of FIG3)
So as to bring it closer to or farther from the piece that is to be cut.

FIG4 Adjusting the cutting angle

The band saw can cut an angle varying from 0° to 60°. Slacken the Locking Handle (K of FIG9) and Turn the Bow-Saw (L of FIG9) until the scale to the Desired angle. Then Tighten the Locking Handle.

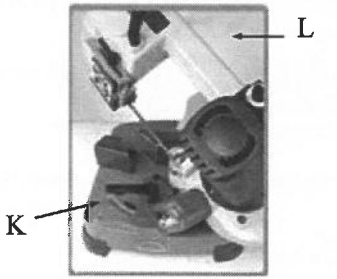
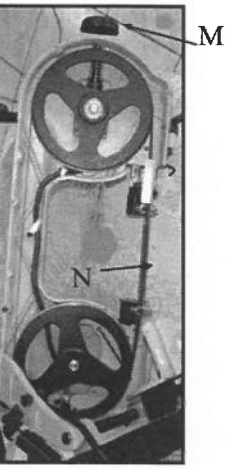


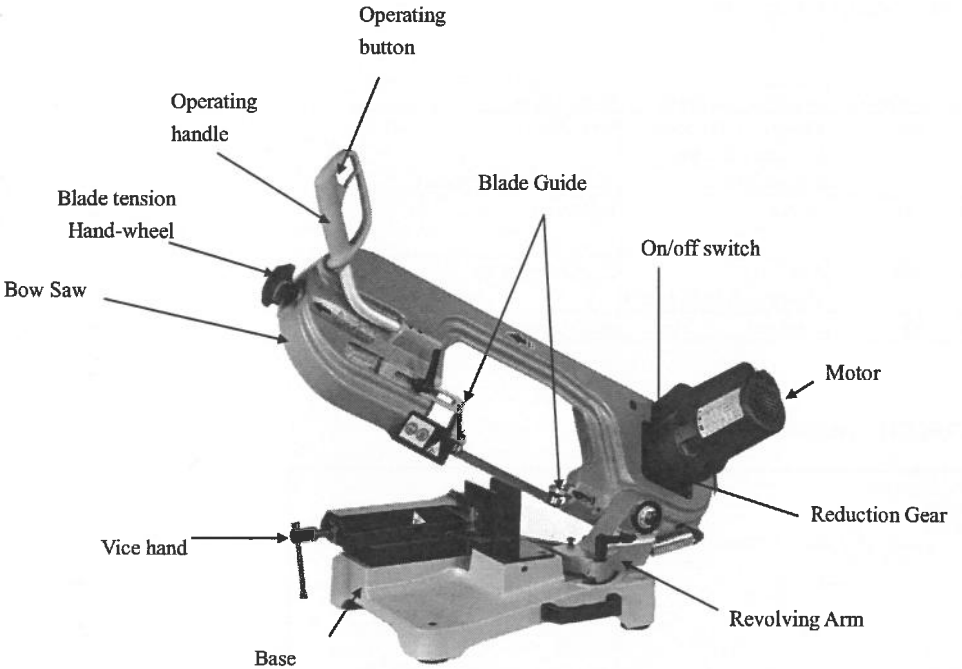
FIG5 Blade replacement

Raise saw head to vertical position and open the blade Guards. Loosen tension screw knob (A of FIG5) sufficiently to allow The saw blade to slip off the wheels. Install the new blade With teeth slanting toward the motor as follows:



1. Place the blade in between each of the guide bearings (N of FIG5).
2. Slip the blade around the motor pulley (bottom) with the left hand and hold in position.
3. Hold the blade taut against the motor pulley by pulling the blade upward with the right hand, which is placed, at the top of the blade.
4. Remove left hand from bottom pulley and place is at the top aide of the blade to continue the application on the upward pull on the blade.
5. Remove right hand from blade and adjust the position of the top pulley to permit left hand to slip the blade around the pulley using the thumb. Index and little finger as guides.
6. Adjust the blade tension knob (M of FIG5) clockwise until it is just right enough so no blade slippage occurs. Do not tighten excessively.
7. Replace the blade guards.
8. Place 1-2 drops of oil on the blade.

PROFILE

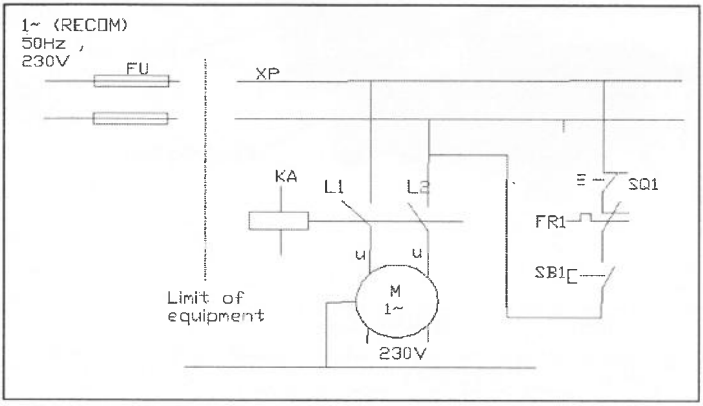


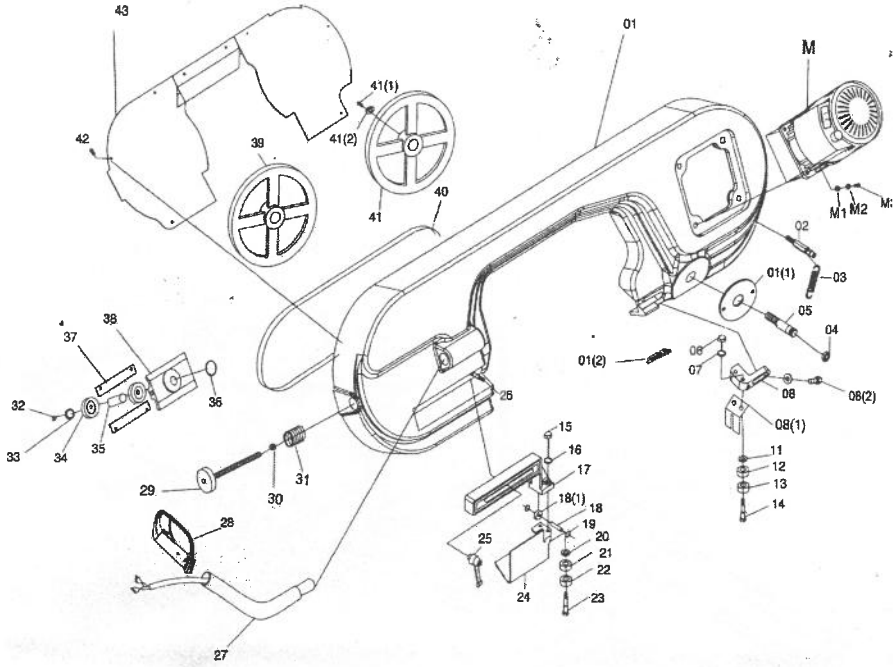
Item	Specifications	Item	Specifications
Voltage	230 V	Blade size	20 x 0.9 x 2035mm
Motor	1650W	Bow-Saw	Aluminum
Cutting capacity 90°	Circular bar: 170mm, rectangular bar: 170 x170mm	Base	Aluminum
Cutting capacity 45°	Circular bar: 125mm, rectangular bar: 125 x 125mm	Dimension	1100 mm x 550 mm x 600 mm
Cutting capacity 60°	Circular bar: 75mm, rectangular bar: 75 x 70mm	Packing	1040 mm x 490 mm x 565 mm
Function	Manual Cutting: YCM-170	Optional Accessories:	**Machine Stand**
Blade speed	30~80 MPM	NOISE LEVEL	The noise level for the tool is about 62 dB (A)

ELECTRICAL PART LIST

Item	Description	Description and function	Technical data
1	SB1	TR26-21C-13D/L SM-8 4P Switch with lighe	IP54:250Vac CE
2		Supply Cable	Ac 600V, 10A,3G/0.75mm
3	M	motor	1650W/230V,
4	SQ1	ZIPPY Micro Switch,VMN-15,15A	20.5A 125 / 250 Vac CE
5	FR1	Over Load	5A / 250 Vac CE

CIRCUIT DIAGRAM




43
01
M
41(1)
41(2)
42
39
41
40
M1
M2
02
01(1)
03
05
04
01(2)
06
07
08
08(2)
08(1)
38
37
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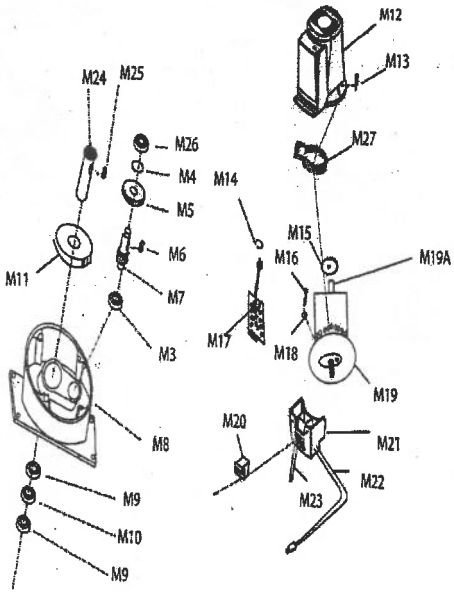
M12
M13
M24
M25
M26
M27
M4
M14
M5
M15
M6
M16
M19A
M11
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M3
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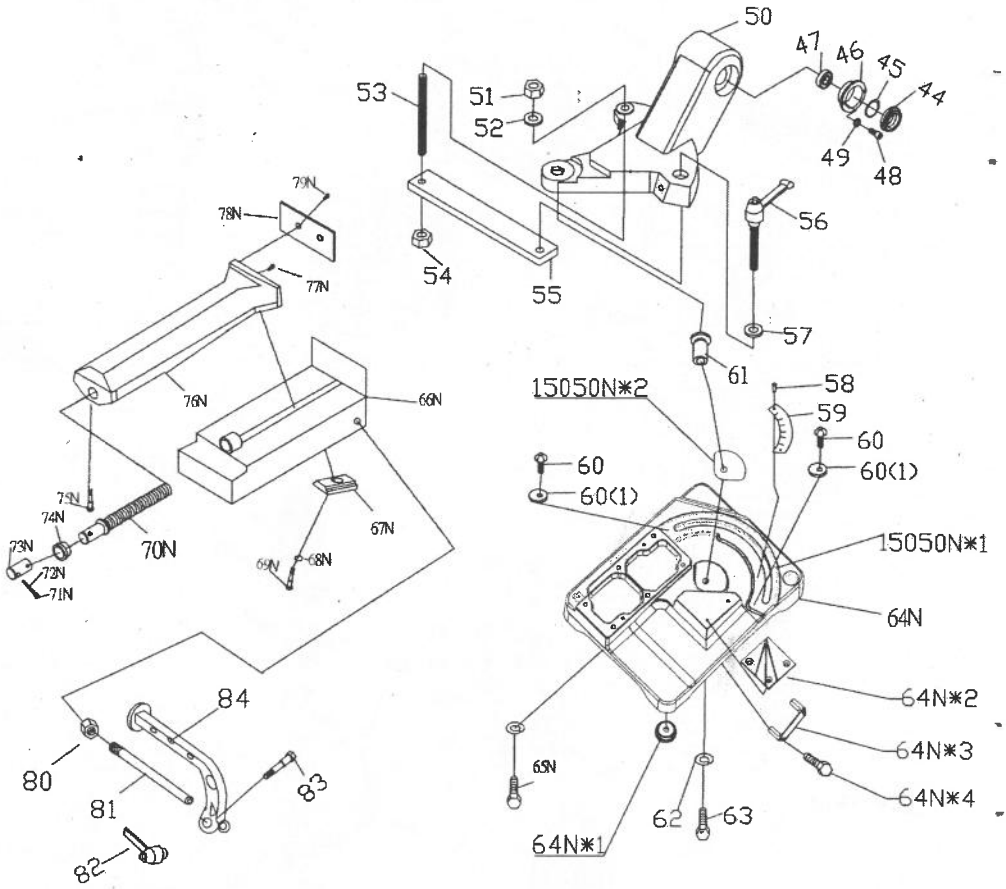
M20
M8
M21
M22
M9
M23
M10
M9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48
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54
55
57
61
58
15050N*2
59
60
60(1)
60
60(1)
15050N*1
64N
64N*2
64N*3
64N*4
65N
62
63
64N*1
79N
78N
77N
76N
66N
75N
74N
73N
72N
71N
70N
67N
69N
68N
84
80
81
83
82

NO	Q'ty	Description	NO	Q'ty	Description	NO	Q'ty	Description
1	1	Body frame	43	1	Body cover	83	1	Screw
1(2)	1		44	1	Nut	84	1	Stop Braket
1A	1	PLATE	45	1	Cover	M1	1	Screw
2	1	Spring axis	46	1	Bushing	M2	1	Spring Washer
3	1	Spring	47	1	32004 bearing	M3	1	Bearing
4	1	32004 bearing	48	1	Screw	M4	1	C-ring
5	1	Axis	49	1	Washer	M5	1	Gear
6	2	Nut	50	1	Miter plate	M6	1	Key
7	2	Washer	51	1	Nut	M7	1	Gear shaft
8	1	Fixed blade gvide plate	52	1	Washer	M8	1	Gear box
8(1)	1	Chip Fence	53	1	Screw	M9	2	Bearing
8(2)	1	Screw	54	1	Nut	M10	1	Oil seal
11	2	Bushing	55	1	Plate	M11	1	Gear
12	2	Bearing	56	1	Bolt	M12	1	UP cover
13	2	Bearing	57	1	Washer	M13	1	Screw 4X45mm
14	2	Bias axis	58	1	Screw	M14	1	Nut
15	2	Nut	59	1	Scale	M15	1	Fan
16	2	Washer	60	1	Screw	M16	1	Screw
17	1	Arm	60(1)	1	Washer	M17	1	Electrical board
18	2	Pin	61	1	Bushing	M18	1	Oil seal
18(1)	2	Bearing	62	1	Washer	M19	1	Motor
19	2	Washer	63	1	Screw	M19A	1	Motor shaft
20	2	Washer	64N	1	Base	M20	1	Switch
21	2	Bearing	64N*1	4	Rubber Pad	M21	1	Down cover
22	2	Bearing	64N*2	1	Base plate	M22	1	Plug
23	2	Bias axis	64N*3	2	Handle Rod	M23	1	Handel wire
24	1	L. blade guard	64N*4	8	Screw	M24	1	Main shaft
25	1	Bolt	65N	1	Screw	M25	1	KEY
26	1	Screw	66N	1	Fence Base	M26	1	bearing
27	1	Handle Shelf	67N	1	Locking seat	M27	1	plastic cover
28	1	Handle	68N	1	Washer			
29	1	Handle Wheel	69N	1	Screw			
30	8	Washer	70N	1	Acme Screw			
31	2	Screw	71N	1	Knob			
32	1	Screw	72N	1	Handle Rod			
33	1	Washer	73N	1	Shaft Boshing			
34	2	Bearing	74N	1	Bushing			
35	1	Blade sheet shaft	75N	1	Screw			
36	1	Washer	76N	1	Vise			
37	2	Block	77N	1	Screw			
38	1	Block blade tension	78N	1	Vise plate			
39	1	Return flywheel	79N	1	Screw			
40	1	Saw blade	80	1	Nut			
41	1	MOTOR flywheel	81	1	Rod stock stop			
42	6	Screw	82	1	Bolt			