

AXMINSTER

PROfessional

AP1854B (BS11) Code 107651

AP1854BV (BS11-INV) Code 107652

Original Instructions

AP1854B & AP1854BV

Bandsaw



Electro-magnetic brake
key switch



INV Variable Speed Control



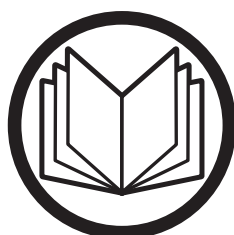
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EU DECLARATION OF CONFORMITY

Cert No: BS11, BS11INV Axminster Tool Centre Ltd Axminster Devon EX13 5PH UK axminstertools.com declares that the machinery described:- <table border="1"> <tr> <td>Type</td> <td>Bandsaw</td> </tr> <tr> <td>Model</td> <td>AP1854B & AP1854BV</td> </tr> </table> Signed  Andrew Parkhouse Operations Director Date: 06/01/2020	Type	Bandsaw	Model	AP1854B & AP1854BV	EU Declaration of Conformity This machine complies with the following directives: 2006/42/EC EN 1870-1:2013 and conforms to the machinery example for which the EC Type-Examination Certificate No MDC 1522 has been issued by KINGCRAFT MACHINERY COMPANY LIMITED at: No.26. GONG YEH 12RD., DAH LI DISTRICT, TAICHUNG CITY, TAIWAN and complies with the relevant essential health and safety requirements.
Type	Bandsaw				
Model	AP1854B & AP1854BV				

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

WHAT'S INCLUDED

Model Number		BS11
Quantity	Item	Part
1 No	AP1854B Bandsaw	A



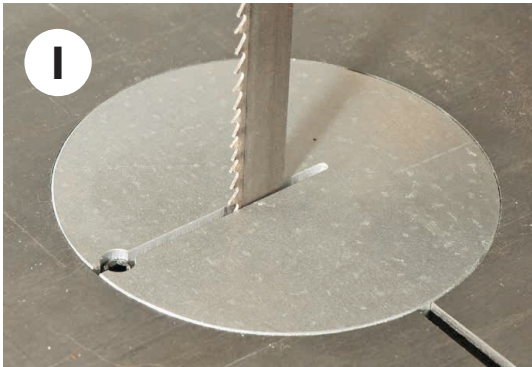
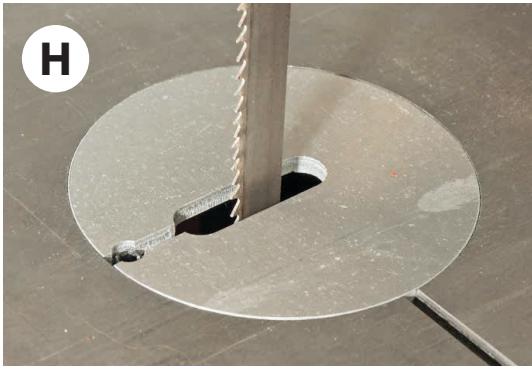
1 No	Dust Extraction Outlet	C
4 No	M5 Domed Phillips Screws and Washers	D
4 No	M8 x 50mm Bolts	E
4 No	M8 Nuts	F
4 No	M8 Washers	G
1 No	Table Insert	H
1 No	Table Insert (AT1854BV ONLY)	I



Model Number		BS11-INV
Quantity	Item	Part
1 No	AP1854BV Bandsaw	B



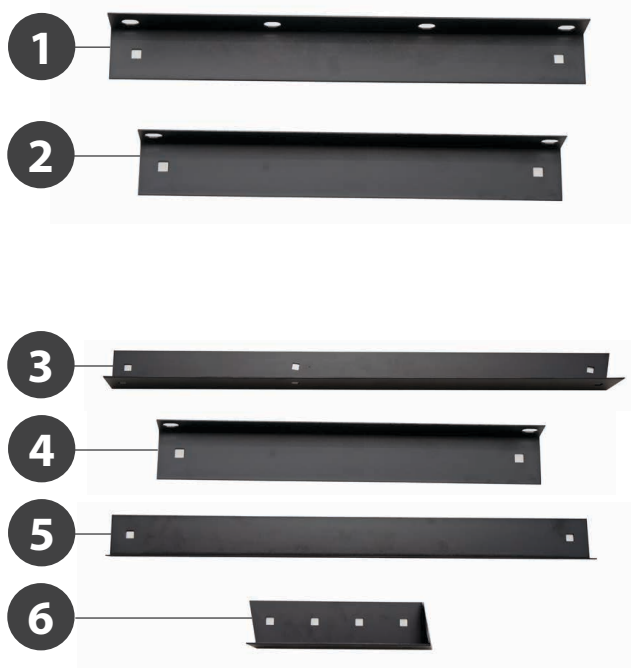
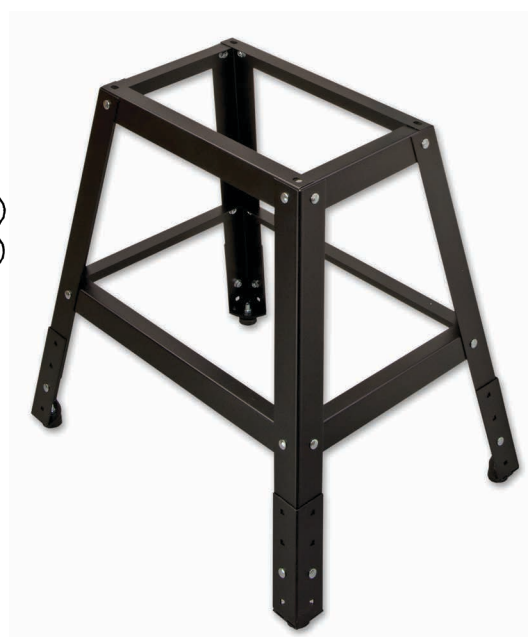
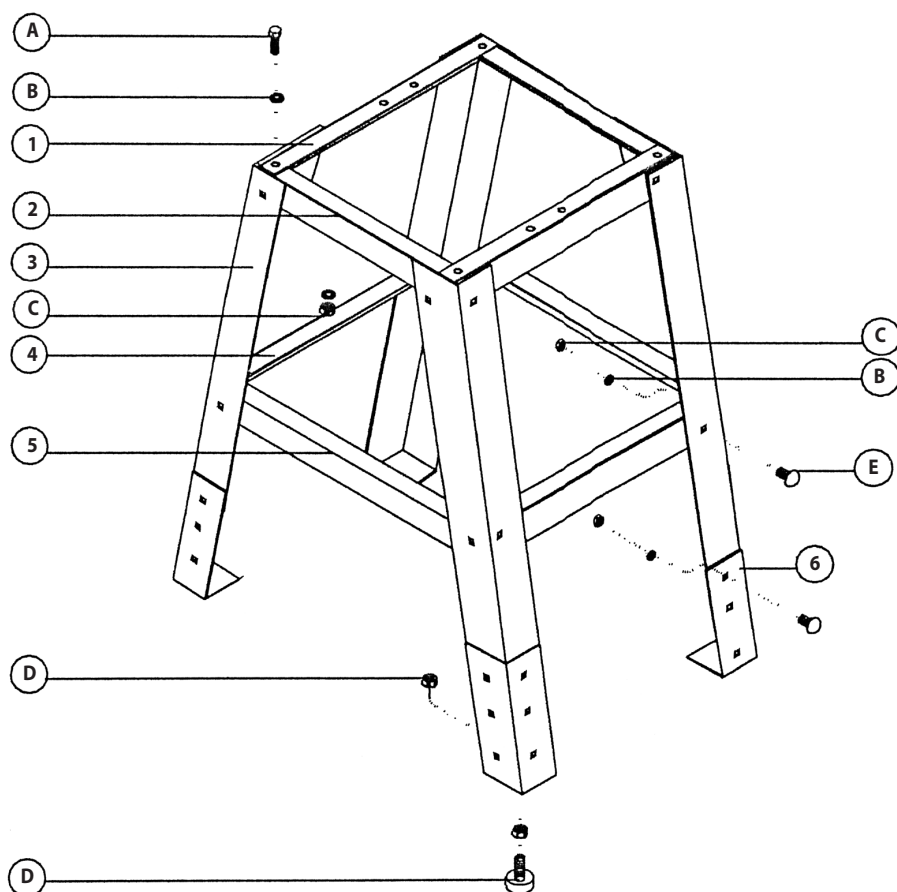
Please read the Instruction Manual prior to using your new machine; as well as the operating procedures for your new machine, there are numerous hints and tips to help you to use the machine safely and to maintain its efficiency and prolong its life. Keep this Instruction Manual readily accessible for any others who may also be required to use the machine.



OPTIONAL ACCESSORIES

Stand Assembly (Code 102028)

04 No	M8 Bolts	A	2 No	Long Struts (Upper)	1
32 No	M8 Washers	B	2 No	Short Struts (Upper)	2
28 No	M8 Nuts	C	4 No	Leg 'A' Frames	3
04 No	Threaded Rubber Feet	D	2 No	Short Struts (Lower)	4
32 No	M8 Coach Bolts	E	2 No	Long Struts (Lower)	5



A

x4 M8
Bolts



E

x24 M8
Coach Bolts



B

x32 M8
Washers



C

x28 M8
Nuts



D

x4 Thread Rubber
Foot

Good Working Practices/Safety

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 WORK AREAS.

Mains Powered Tools

- Tools are supplied with an attached 13 Amp UK 3 pin plug, fitted with 13 amp fuse
- 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.**

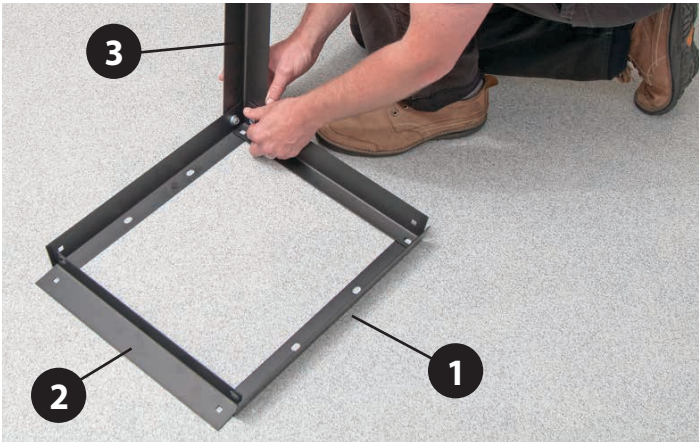
SPECIFICATION



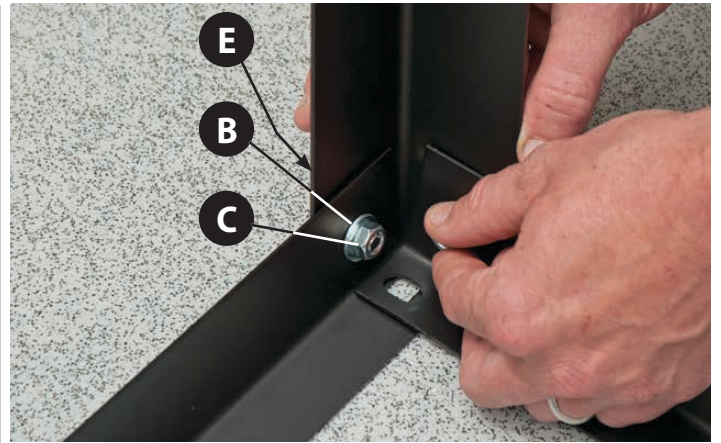
Code	107651
Model	AP1854B
Rating	Trade/Professional
Power	750W 230V 50Hz 1ph
Blade Speed	534 m,819m/min
Blade Length	1,858 mm
Blade Width Min/Max	3 mm /12 mm
Max Width of Cut	250 mm
Max Depth of Cut	160 mm
Max Width of Cut with Fence	220 mm
Table Size	350 x 350 mm
Table Tilt	-5° to +45°
Table Height	340 mm
Dust Extraction Outlet	63 mm
Base Size	455 x 280 mm
Overall L x W x H	590 x 540 x 850 mm
Overall L x W x H with stand	750 x 540 x 1530 mm
Weight	60 kg



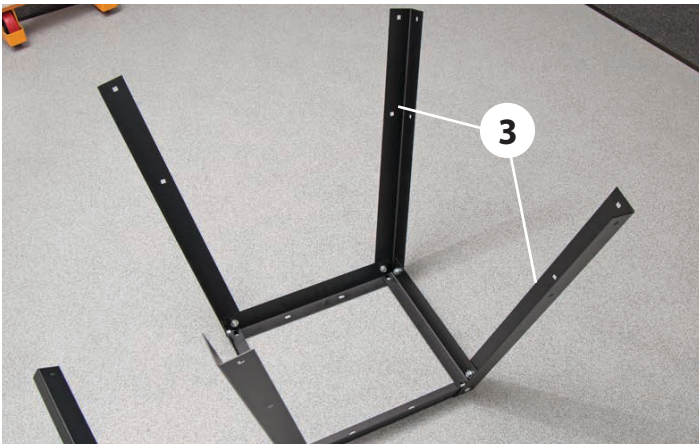
Code	107652
Model	AP1854BV
Rating	Trade/Professional
Power	750W 230V 50Hz 1ph
Blade Speed	(L) 42-660m, (H) 64m-1001m/min
Blade Length	1,858 mm
Blade Width Min/Max	3 mm/12 mm
Max Width of Cut	250 mm
Max Depth of Cut	160 mm
Max Width of Cut with Fence	220 mm
Table Size	350 x 350 mm
Table Tilt	-5° to +45°
Table Height	340 mm
Dust Extraction Outlet	63 mm
Base Size	455 x 280 mm
Overall L x W x H	590 x 540 x 850 mm
Overall L x W x H with stand	750 x 540 x 1530 mm
Weight	63 kg



Step 1



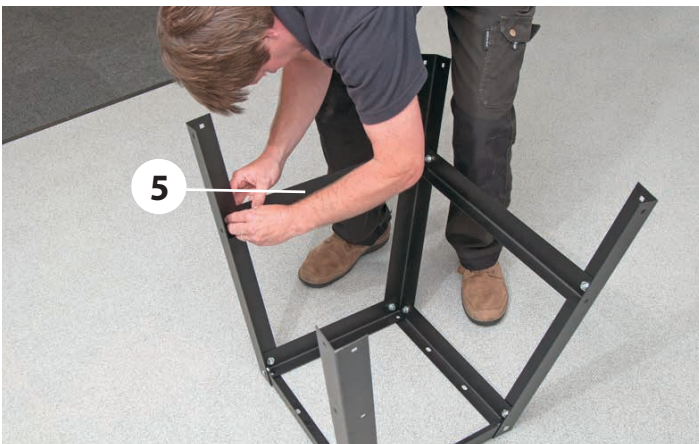
Step 2



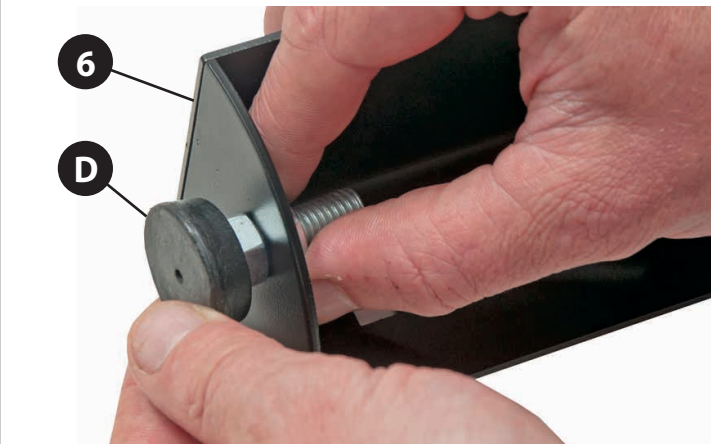
Step 3



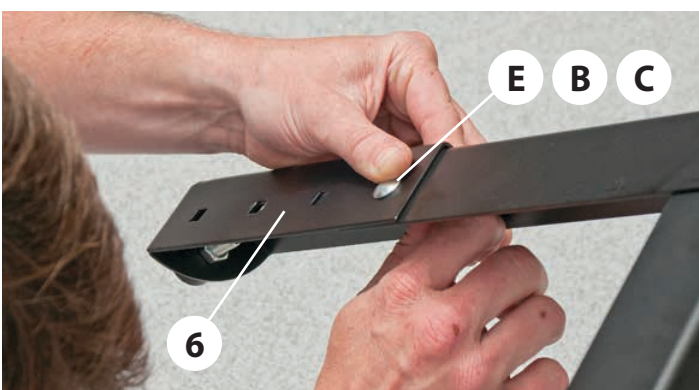
Step 4



Step 5



Step 6



Use the holes in the bracket (6) to adjust the stand height

Step 7



Stand assembled

MOUNTING THE BANDSAWS

When you receive your new bandsaw it will come fully assembled.



HAVING UNPACKED YOUR ACCESSORIES PLEASE DISPOSE OF ANY UNWANTED PACKAGING PROPERLY. THE POLYTHENE AND CARD IS RECYCLABLE.



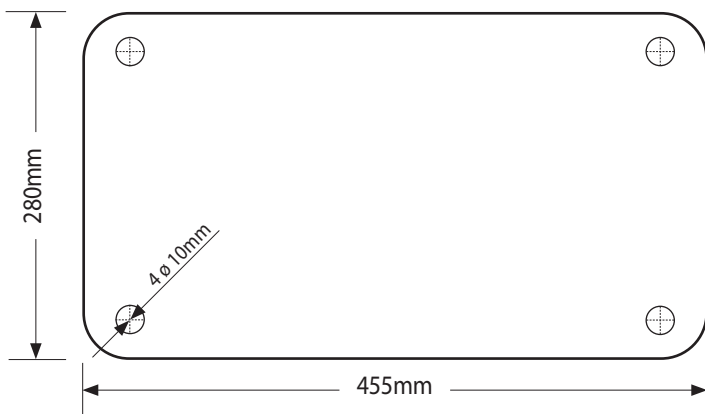
WARNING! THE BANDSAW IS A HEAVY PIECE OF MACHINERY, WE STRONGLY ADVISE YOU GET THE ASSISTANCE OF ANOTHER PERSON OR USE SOME SORT OF LIFTING DEVICE, (HOIST, ENGINE CRANE), BEFORE YOU ATTEMPT TO LIFT OR MOVE THIS MACHINE!

Workbench

Locate the four M8x50mm bolts (E), M8 Washers and nuts (F-G).

1. Place the bandsaw on a work bench. Mark the position of the holes in the bandsaw's base, place the bandsaw to one side and drill the holes using a 10mm drill bit.

2. Line up the holes and secure the bandsaw in place with the M8 bolts, washers and nuts.



Optional Bandsaw Stand

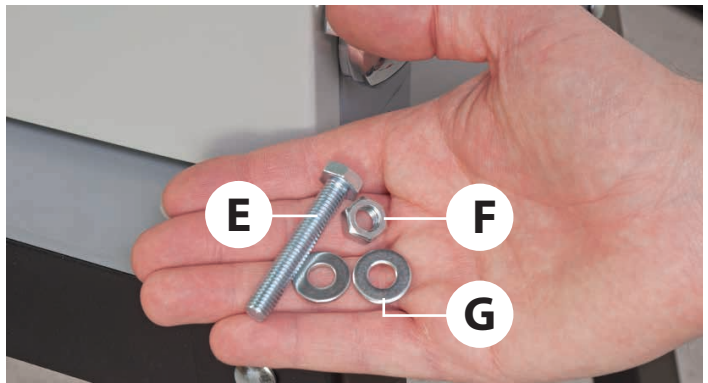
1. Locate the stand, with assistance lift the bandsaw onto the stand and line up the pre-drilled holes with the holes in the stand assembly.

2. Place a washer (F) over the M8 bolt threads (E), slot the bolts through the holes and secure using the remaining washers and nuts (G), see fig 01-02-03.

Fig 01



Fig 02-03-04



3. Locate the dust extraction moulding outlet (C) and the four M5 domed Phillips screws and washers (D).

4. Line up the four holes in the extraction moulding with the threaded holes beneath the bandsaw base and secure in place with the four Phillips screws and washers (D), see fig 05-06.

Note: Make sure the extraction outlet is pointing inward

Fig 05-06



MACHINE FOOTPRINT

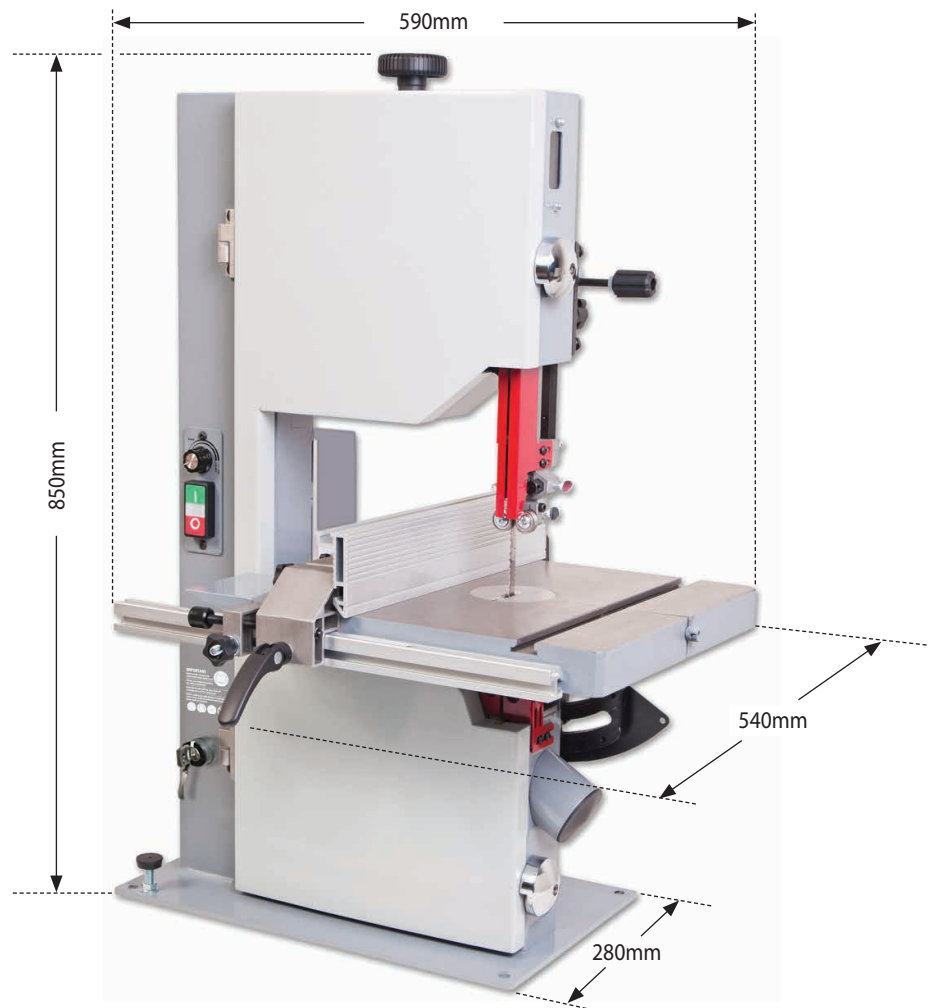
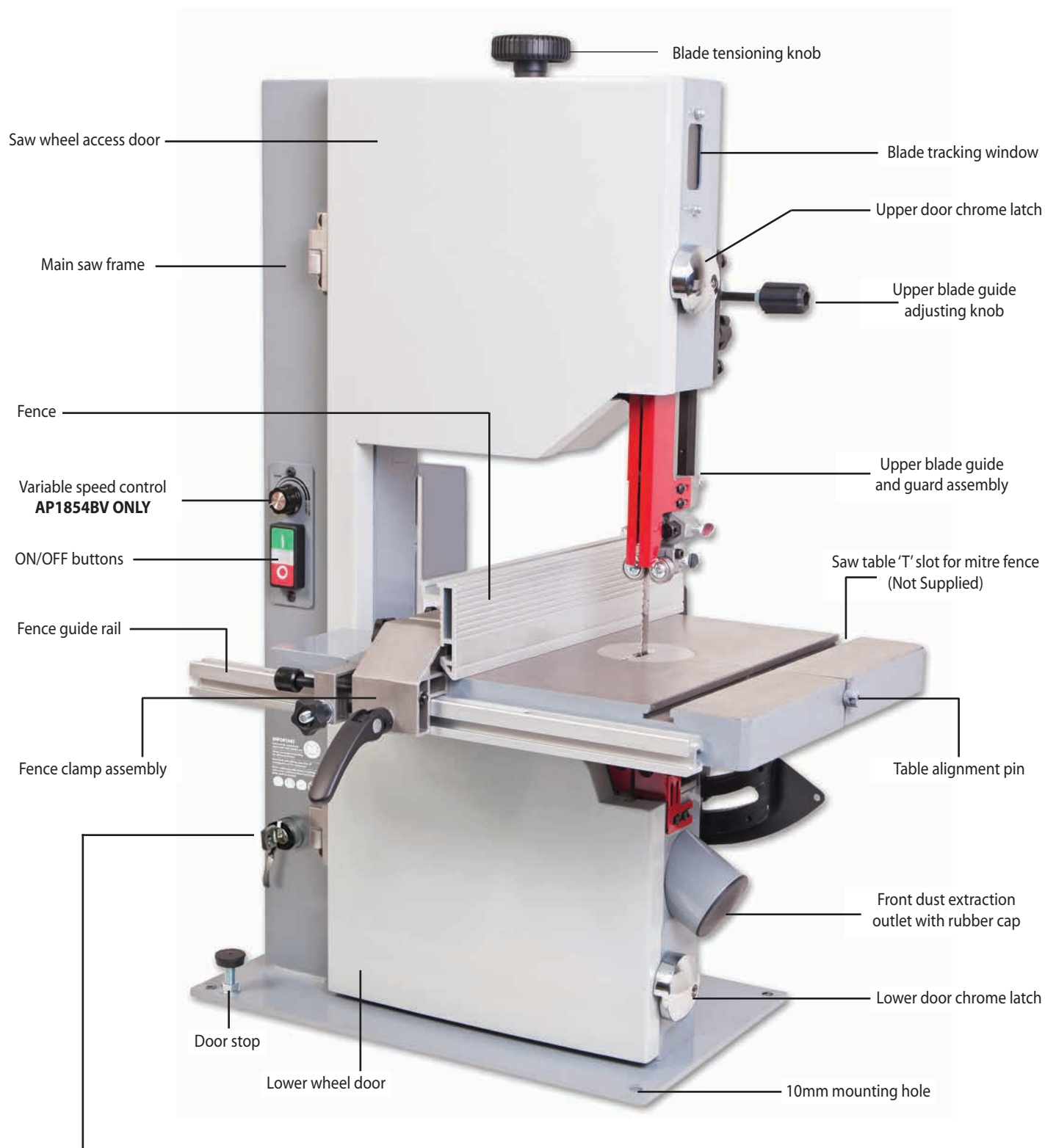


ILLUSTRATION & PARTS DESCRIPTION



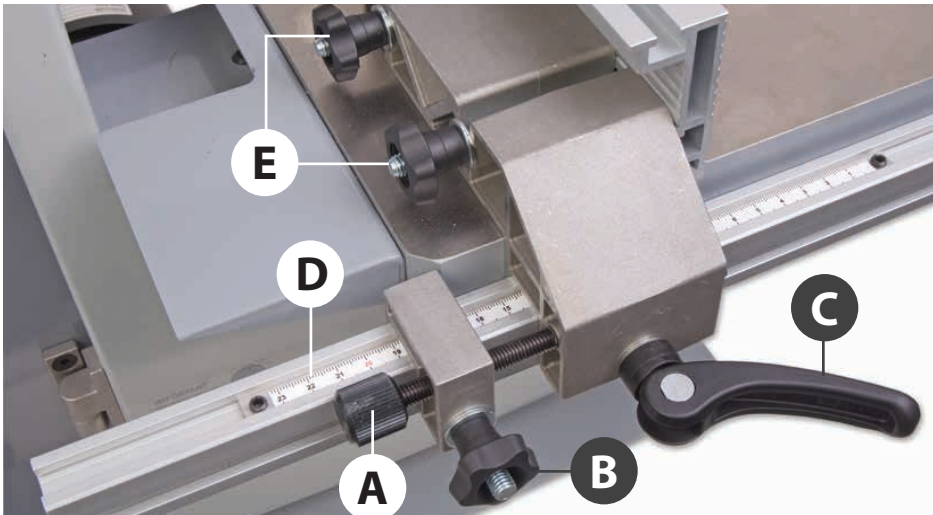
The electro-magnetic brake switch, set to the 'OFF' position isolating the bandsaw



The electro-magnetic brake switch, set to the 'ON' position



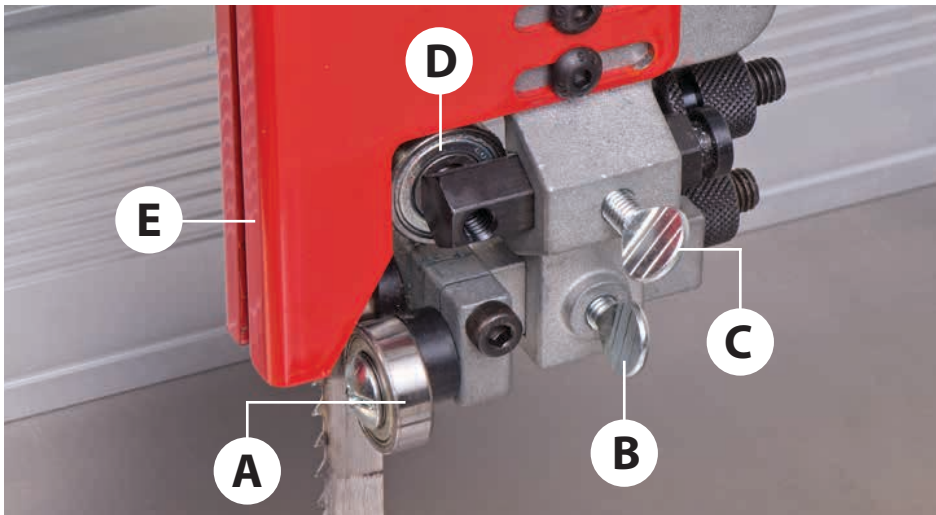
When the switch is set to the 'ON' position the 'GREEN LED' lights up on the control panel. This puts power to the bandsaw



Micro adjuster knob (A), Micro adjuster clamp (B), Fence assembly clamping handle (C), Fence scale (D) and Fence clamping knobs (E)



Model AP1854BV

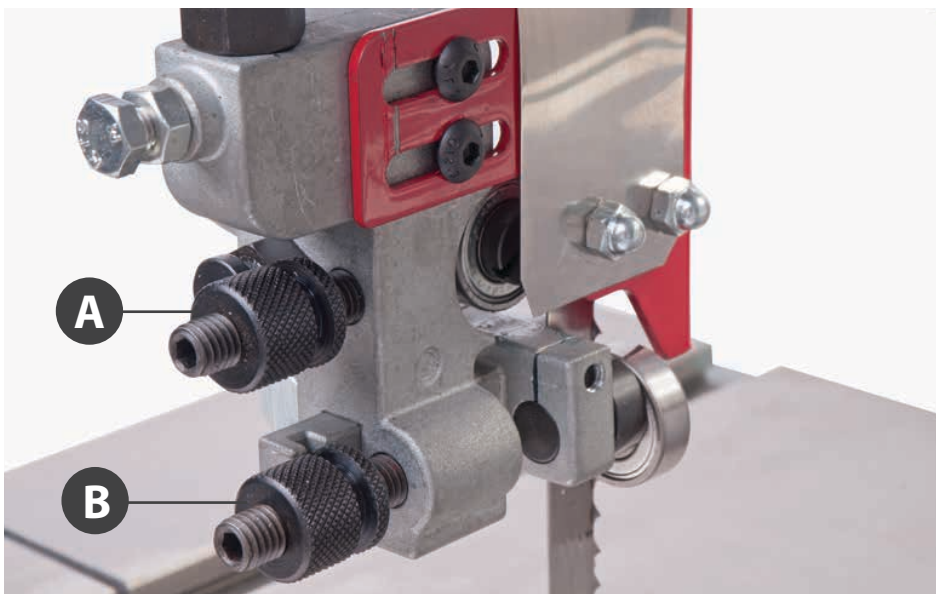


Upper guide bearings (A), Upper guide bearing butterfly clamping screw (B), Rear thrust bearing butterfly clamping screw (C), Rear thrust bearing (D), Upper blade guide guard (E)



Model AP1854B

The Variable speed control for model AP1854BV
ON/OFF control buttons for model AP1854B

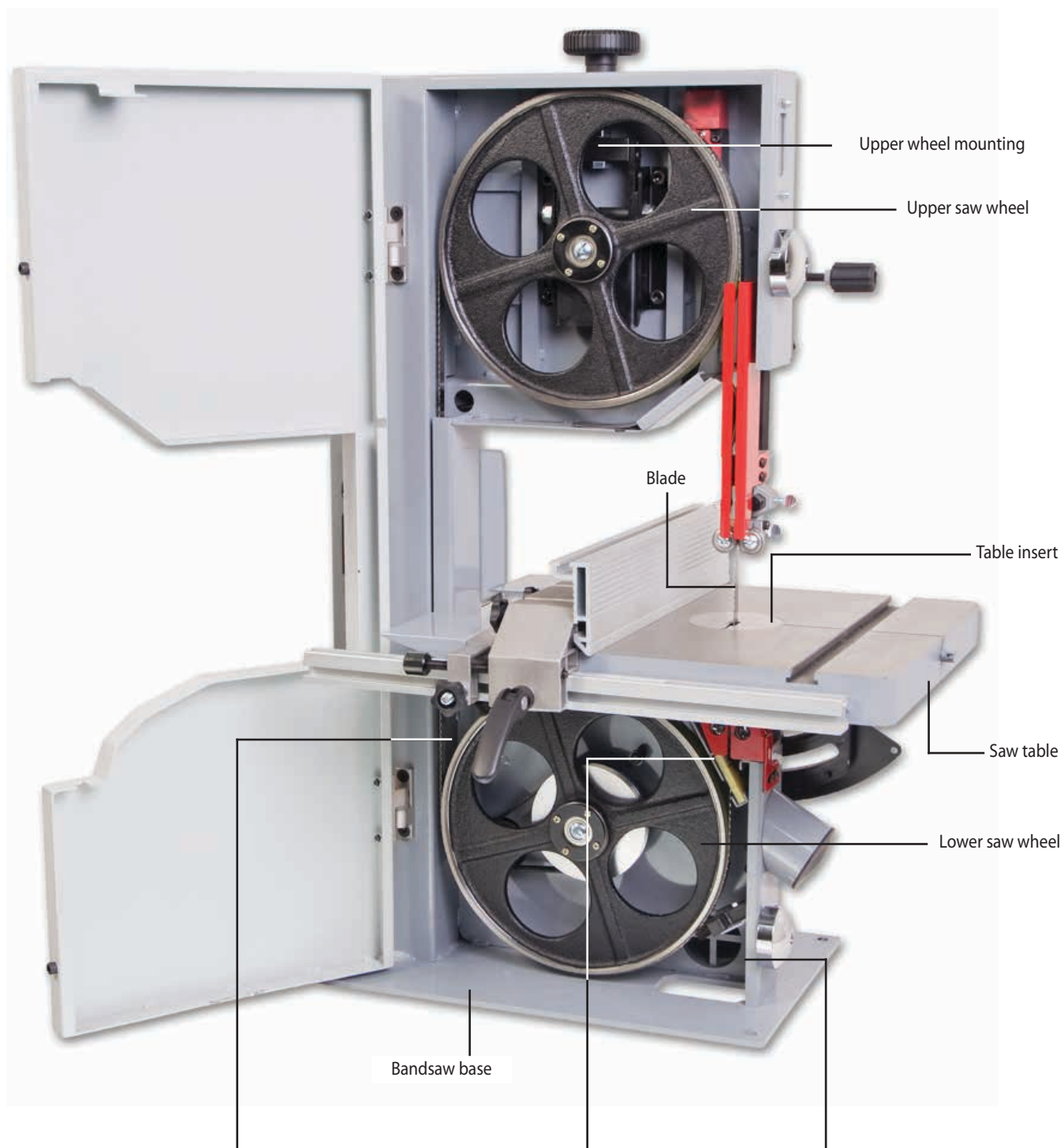


Rear thrust bearing adjusting knob (A) and adjusting knob for the upper guide bearing assembly (B)



Lower wheel door stop

ILLUSTRATION & PARTS DESCRIPTION



Lower saw wheel brush (upper)

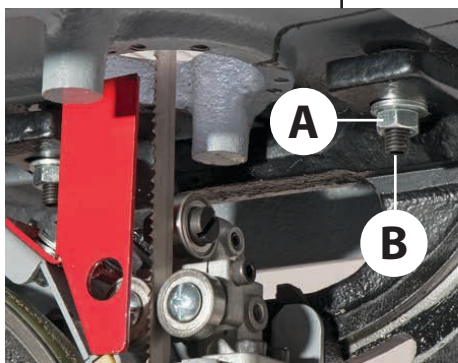


Table securing nut (A)
Height adjusting grub screw (B)



Lower saw wheel brush
and dust extraction outlet



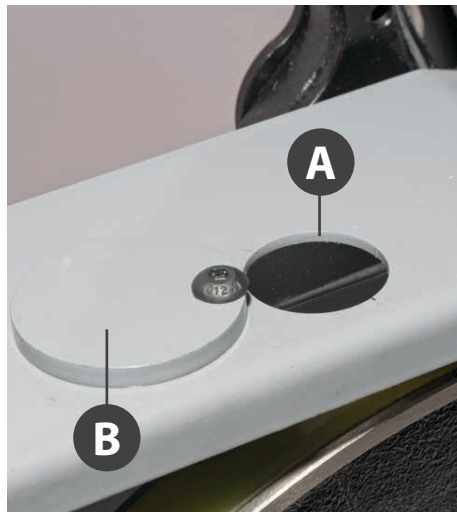
Micro switch (A), Blade (B), Tyre (C)



Blade tracking window



Flexible blade guard



Access hole (A) for setting the table to cut dovetails at -5° degrees
Access hole cover (B) to set the table at 90° degrees

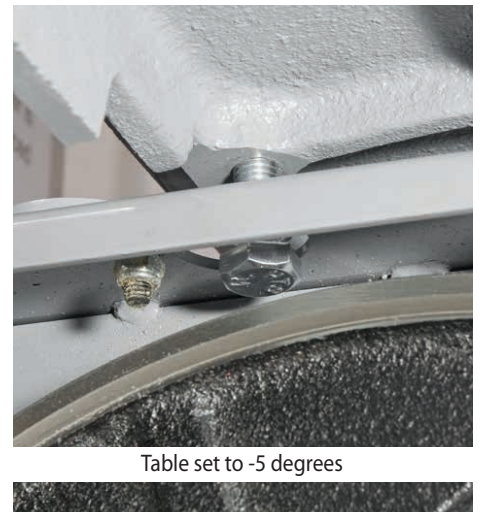
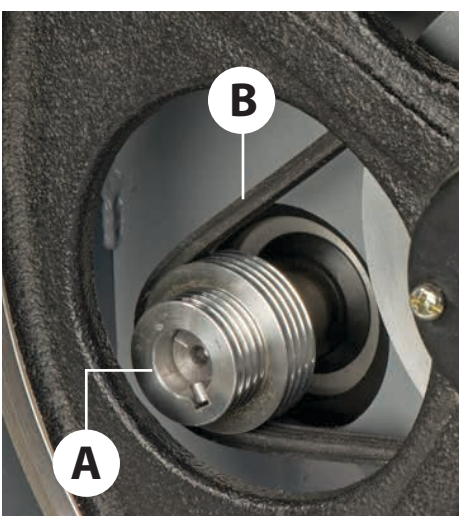
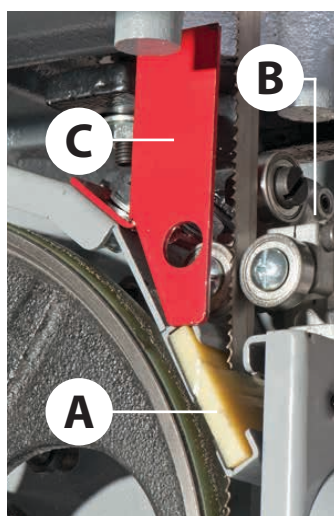


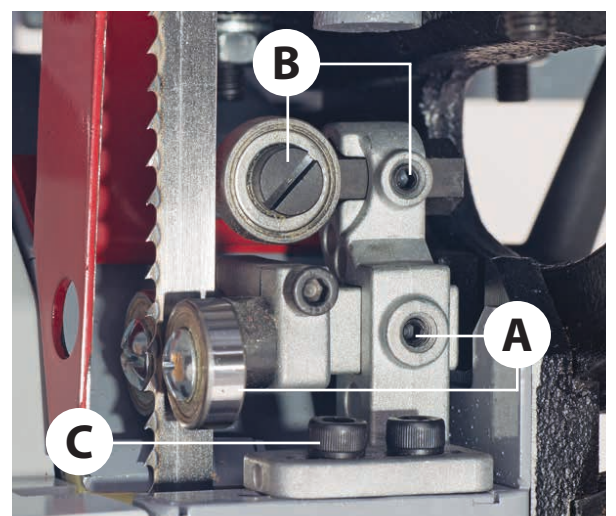
Table set to -5 degrees



Motor drive pulley (A), Drive belt (B)

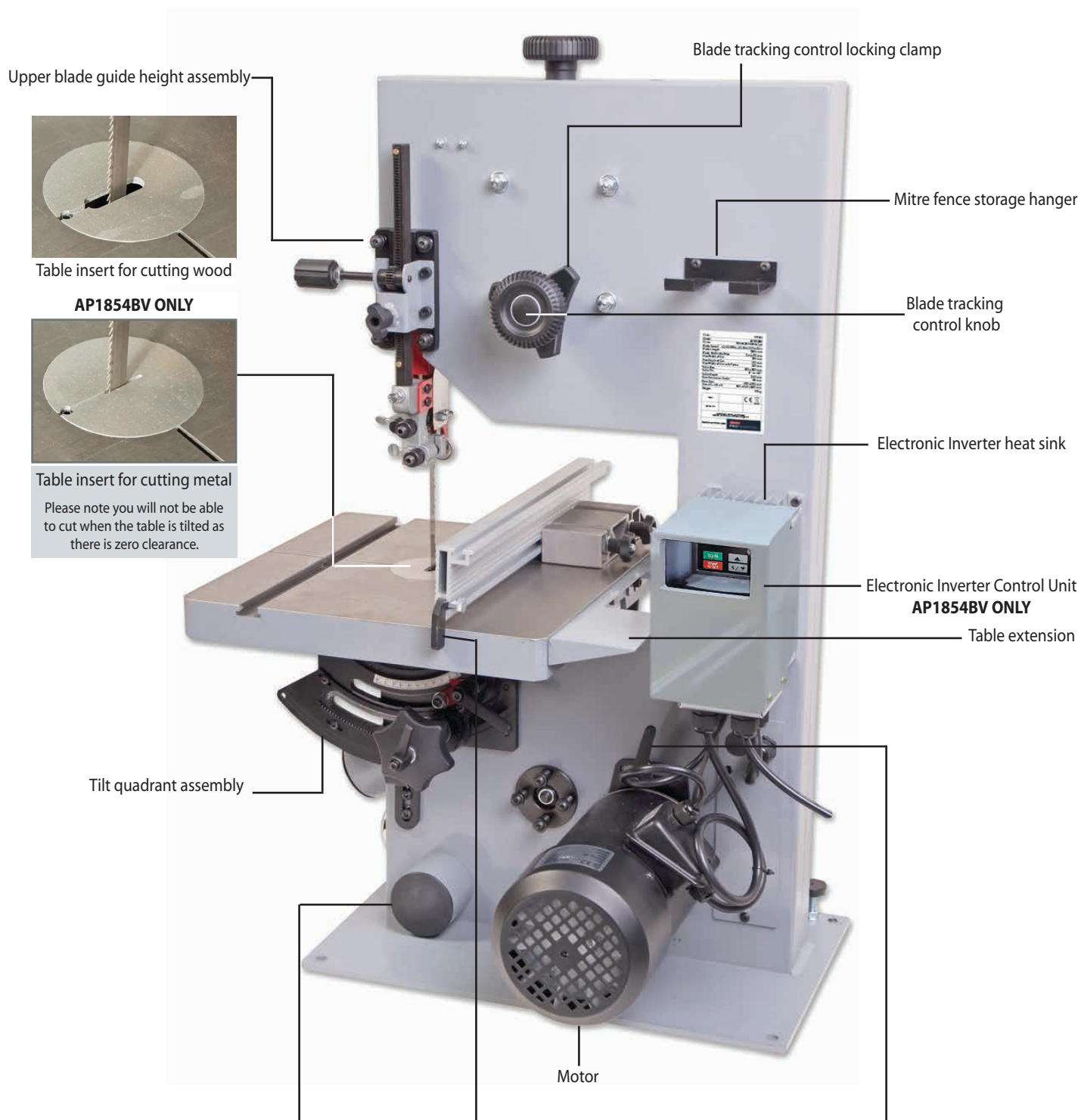


Saw dust deflector (A)
Lower blade guide assembly (B)
Lower blade guard assembly (C)



Lower bearing blade guides and grub screw clamp (A)
Rear thrust bearing and grub screw clamp (B)
Lower bearing assembly adjustment screws (C)

ILLUSTRATION & PARTS DESCRIPTION



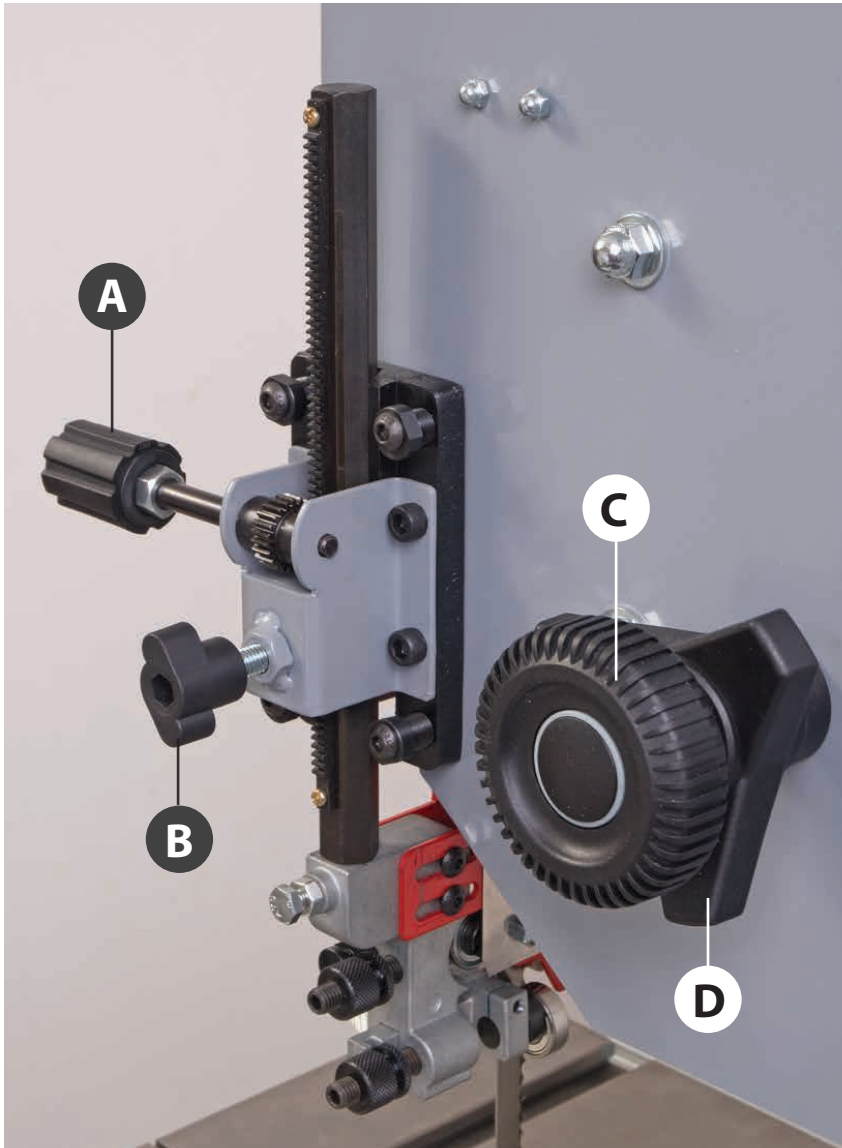
Rear dust extraction outlet with rubber cap



Rear fence guide



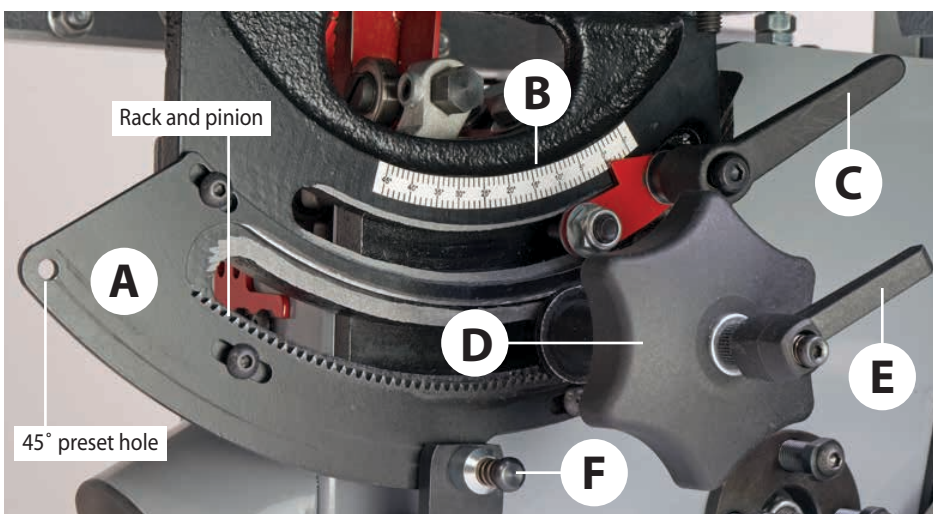
Motor lift and shift clamping handle



Upper blade guide adjusting knob (A), Guide assembly butterfly clamp (B), Blade tracking control knob (C) and Blade tracking control clamp (D)



ME300 Electronic Inverter Control Unit
Note: The inverter comes preset from the factory and you should not need to make any adjustments.



Tilt quadrant (A), Scale (B), Table clamping handle (C), Tilt quadrant adjusting knob (D), Tilt quadrant clamping handle (E), Present locating pin (F) for 45° - 90° degrees



Scale pointer

SETTING UP THE SAW



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Tensioning and tracking the blade

NOTE: Make sure both top and bottom blade guides are well clear of the blade

NOTE: Release the tension on the drive belt by loosening the motor locking handle (A) then rotate the motor assembly, see fig 11-12.

1. Open the saw wheel door fully, giving good access to the top compartment of the saw and good visibility into the bottom compartment, see page 12. 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 07.

Fig 07



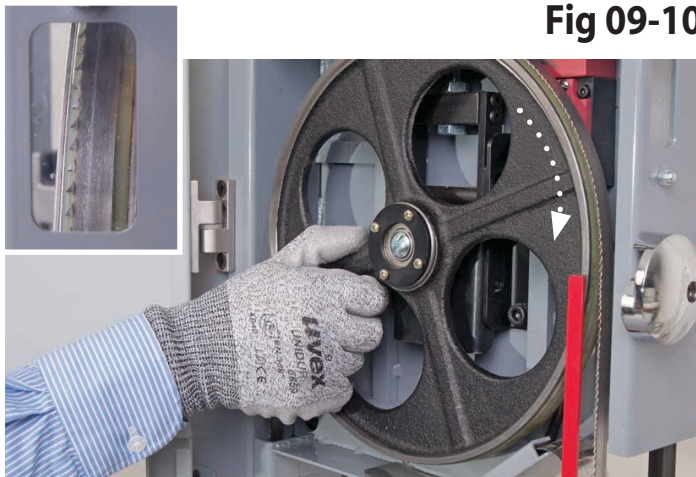
2. Apply some tension to the blade by turning the tensioning knob clockwise, see fig 08 spin the top wheel by hand and check that the blade remains centrally on the tyre, see fig 09. If it does not, adjust the tracking by first loosening the locking clamp and turning the tracking control knob to the rear of the head box, see fig 10. 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).

Fig 08



3. 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. Tighten the tracking control lock up to lock the setting. Tension the blade fully. A sideways push of about

Fig 09-10



Tracking control knob

7-8 lbs(3+kgs) in the middle of the blade should allow a 1/4" (6.5mm) distension. Check the tracking again, adjust if necessary.

Fig 11-12





CLEAR ALL THE TOOL AWAY FROM WORK AREA!

4. Close the saw wheel door. 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.

5. 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 complete stop.



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Checking the table is square

1. Loosen the two clamping handles beneath the table, see fig 13-14. Lower the table by turning the tilt quadrant adjusting knob, until its against the stop. This is a bolt with a lock nut screwed into the underside of the table, see fig 15. The head of the bolt acts as a stop when it strikes the machine frame. Tighten the clamping knobs.

Fig 13-14-15

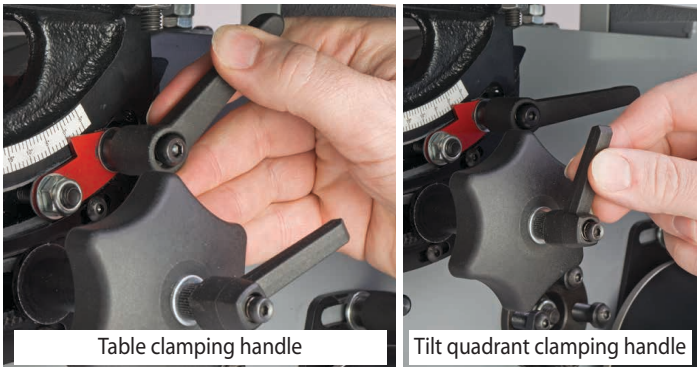
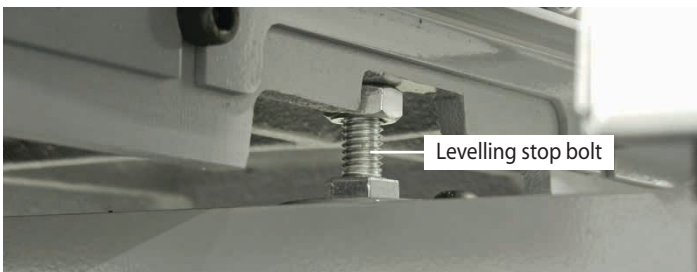


Table clamping handle

Tilt quadrant clamping handle

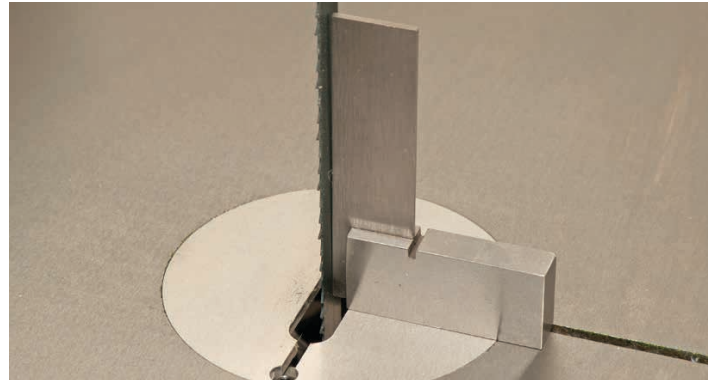


Levelling stop bolt

2. 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 16.

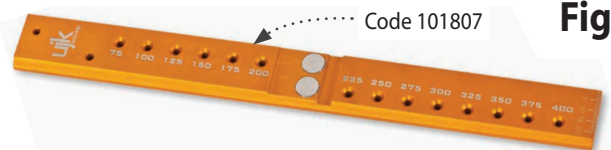
3. Check that the blade is perpendicular to the table. If adjustment is required reset the levelling stop bolt beneath the table then tighten the lock nut. Check again. Once you are satisfied, tighten both tilt and table clamping handles.

Fig 16



Setting the Fence

1. To make sure the fence is perfectly square to the blade we recommend using our unique bandsaw blade aligning tool, called the Bandsaw Buddy, see our website for details. The 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. The Bandsaw Buddy has two rare earth magnets which hold it firmly on the blade, see fig 17.



Code 101807

Fig 17

2. Place the Bandsaw Buddy on the blade as shown in fig 19. Move the fence up close to the alignment tool, lock in place check the fence face is aligned with the alignment tool, see fig 18. If adjustment is required loosen the four securing nuts beneath the table and adjust until correct, see fig 20. Secure the table place.

Fig 18-19-20

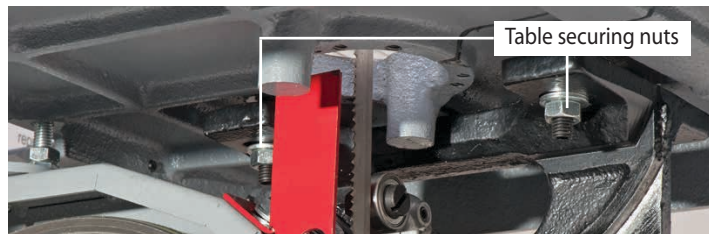
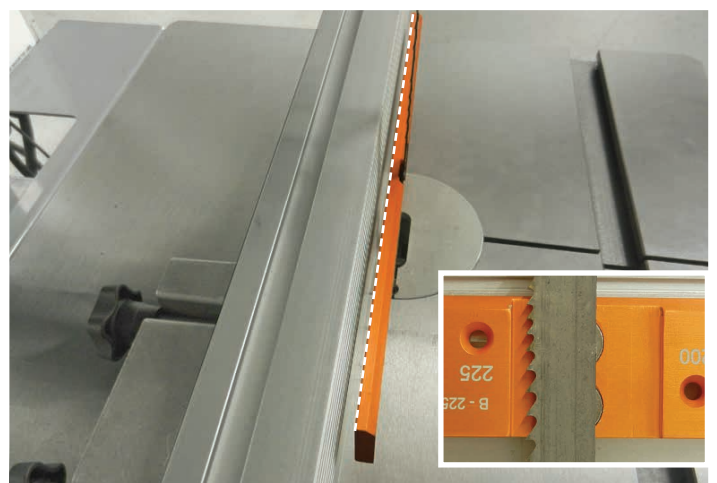


Table securing nuts

SETTING UP THE SAW

3. Remove the bandsaw buddy if not done so already. Position the fence so it's just touching the blade, press down the clamping handle to lock in place, see fig 21-22.

4. Using a 3mm Hex key, loosen the two grub screws holding the fence rail scale and reposition so the face of the fence is set 'zero' on the scale. Retighten the grub screws to lock the setting, see fig 22-23.

Fig 21-22-23-24

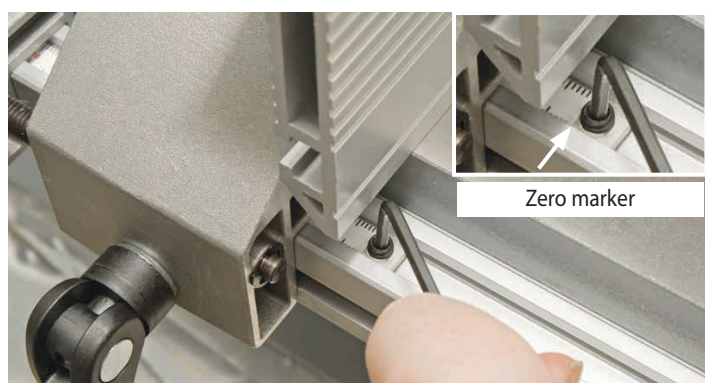
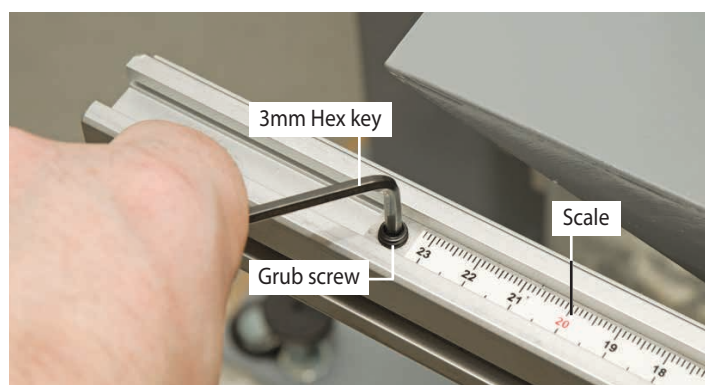
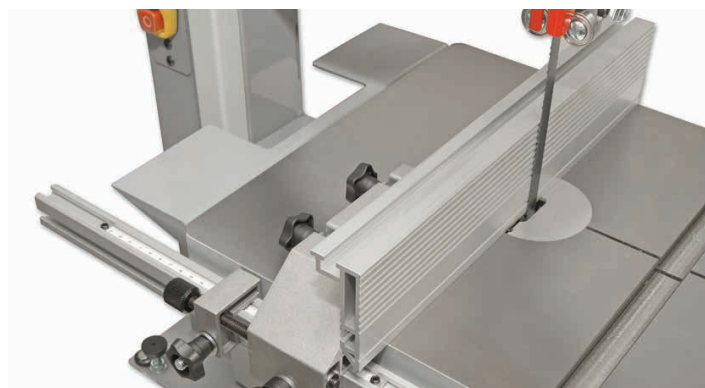
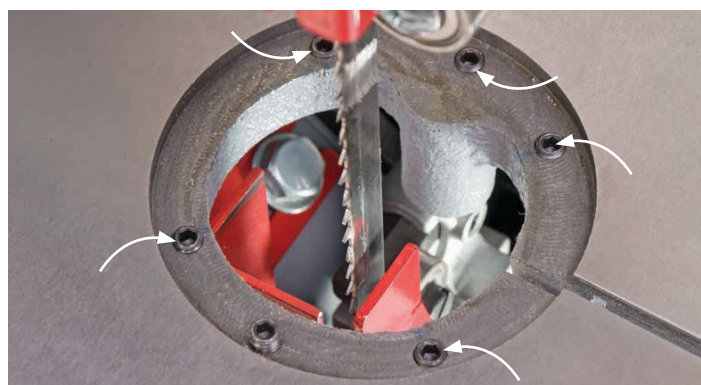
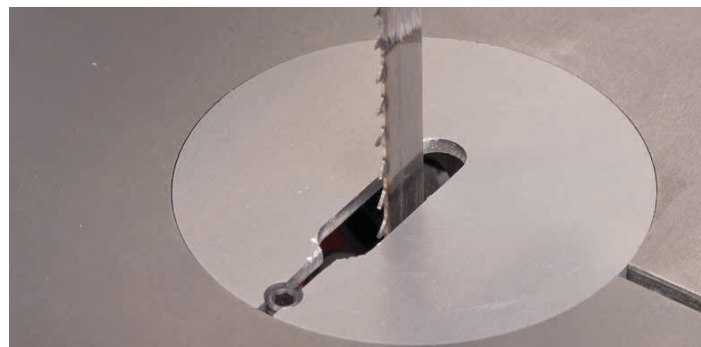


Table Insert

Place a straight edge across the table insert and check its level with cast iron table. If adjustment is required, remove the insert and place aside. Around the inside edge of the machined recess there are five height adjustable grub screws, adjust each screw in turn until the table insert is level with the main table, see fig 25.

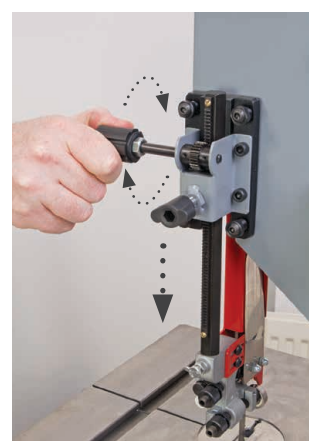
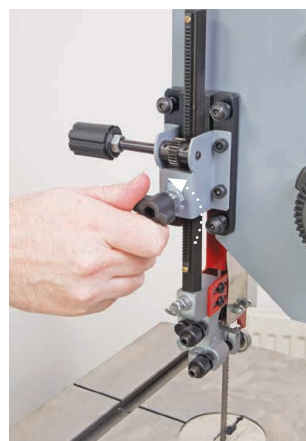
Fig 25-26



Setting the Blade Guides (above table)

1. Loosen the guide assembly butterfly clamp and lower the upper blade guide to approximately 1 1/2" (38mm) above the table using height adjusting knob, see fig 27-28. Clamp in place. Loosen the butterfly screw (A), holding the guide assembly in place and adjust the fore and aft position by turning the adjustment knob (B) so that the leading edges of the side guide bearings are approximately 2mm behind the gullets of the saw blade. Re-tighten the butterfly screw, see fig 29-30.

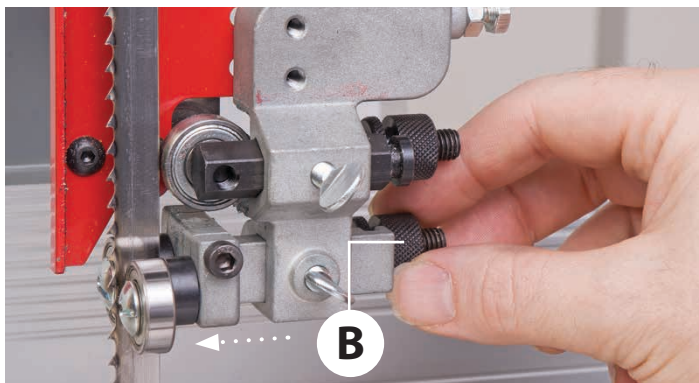
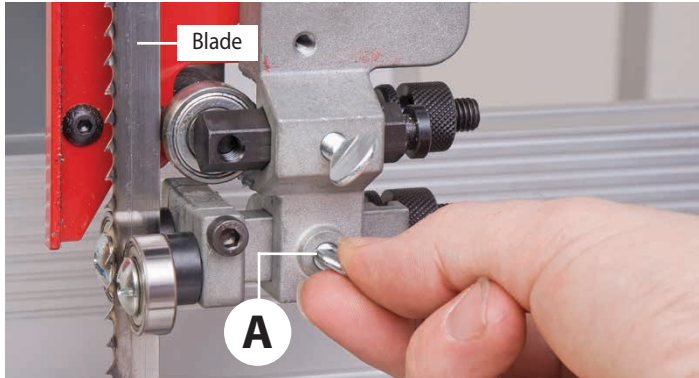
Fig 27-28





TO SET THE UPPER GUIDE BEARINGS FIRST REMOVE ONE SIDE OF THE GUARD ASSEMBLY BY REMOVING THE TWO SMALL HEX SCREWS, THIS WILL GIVE YOU GOOD ACCESS TO BEARINGS!

Fig 29-30



2. Loosen the butterfly screw (C) that clamps the rear thrust bearing in position and turning the adjustment knob (D) until the thrust bearing is approximately 1mm behind the blade, re-tighten the butterfly screw, see fig 31-32-33.

Fig 31-32-33

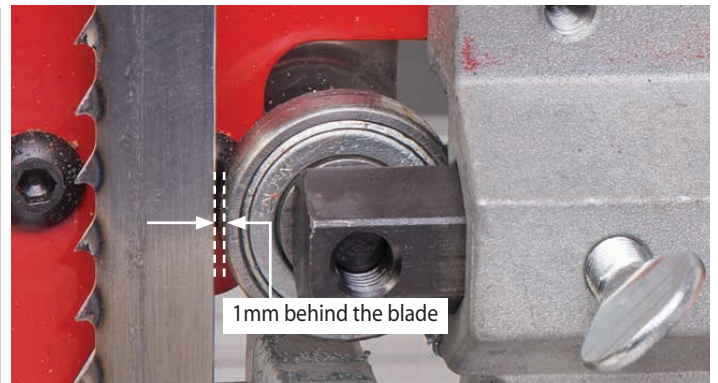
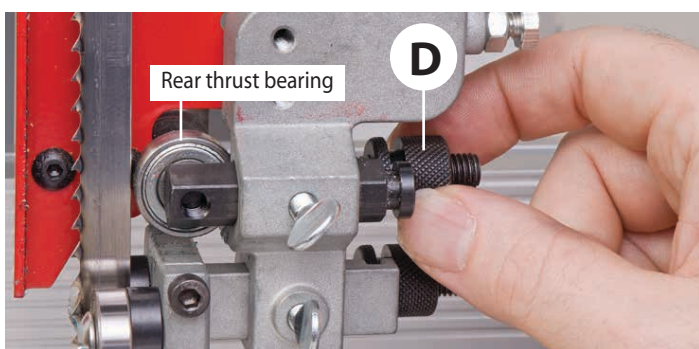
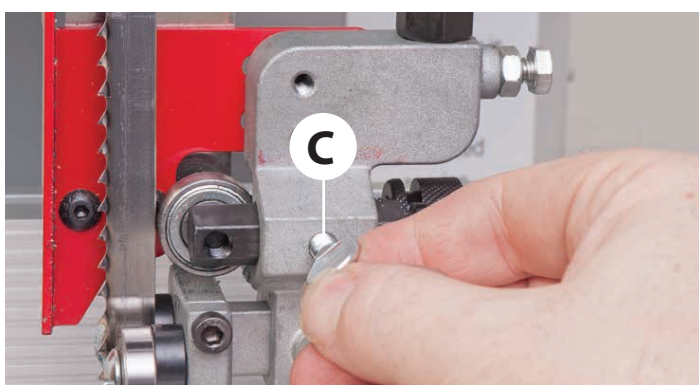
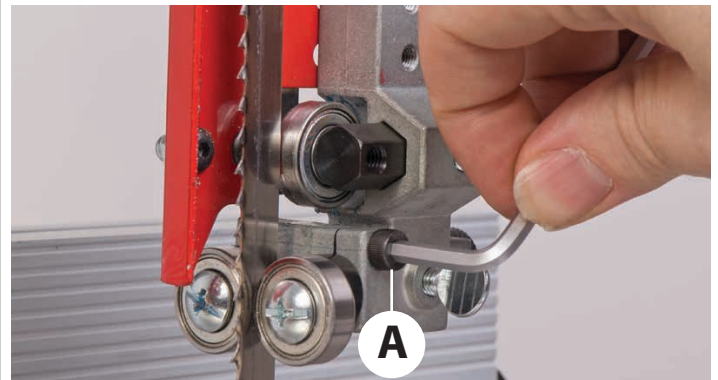
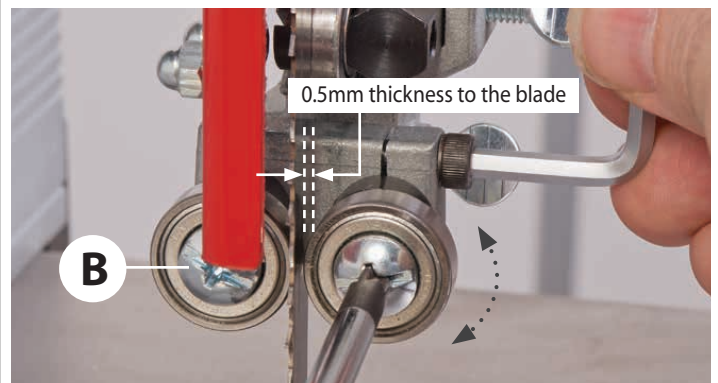


Fig 34-35



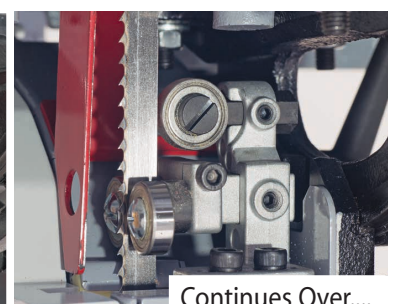
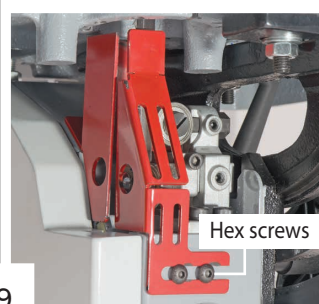
3. Loosen the Hex screw (A) holding the guide bearings and move to approximately 0.5mm from each side of the blade.
NOTE: A sheet of A4 of photocopy paper is approximately 0.5mm thick. Adjust the guide bearings by turning the adjusting Phillips screw (B), until the bearings are set to the correct thickness. Re-tighten the Hex screw (A), see fig 34-35.



Setting the Blade Guides (below table)



TO SET THE LOWER GUIDE BEARINGS FIRST REMOVE ONE SIDE OF THE GUARD AS BEFORE BY LOOSENING THE TWO SMALL HEX SCREWS, GIVING GOOD ACCESS TO BEARING ASSEMBLY!

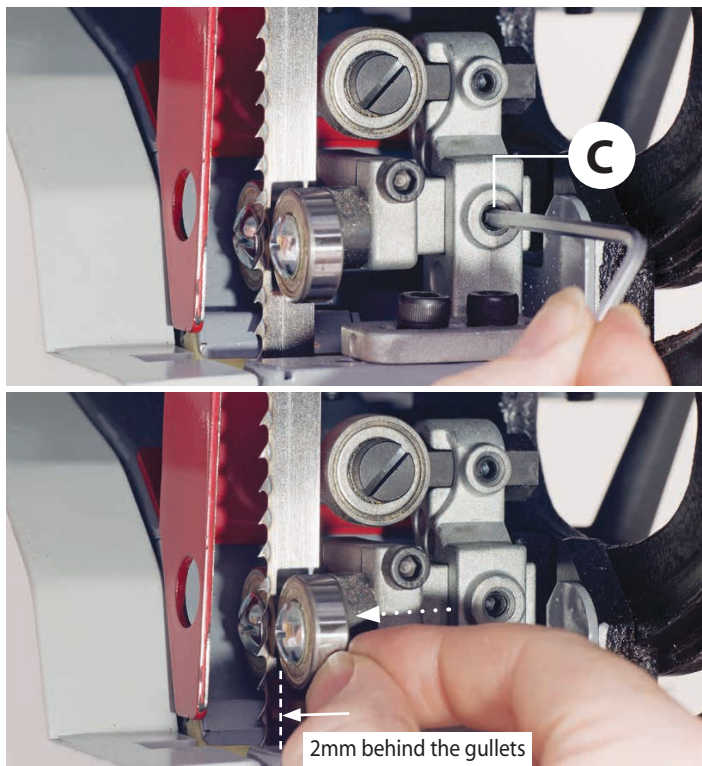


Continues Over....

SETTING UP THE SAW

1. Beneath the table loosen the Hex screw (C) holding the lower blade guide assembly in place and position so that the leading edges of the side guide bearings are approximately 2mm behind the gullets of the saw blade. Re-tighten the Hex screw (C), see fig 36-37.

Fig 36-37



Note: The guide bearing should always be set behind the teeth of the saw.

2. Rotate the top wheel by hand, at this point. None of the bearings should come into contact with the blade—only when in use. Adjust the lower blade guides, and set them similarly to the upper guides, using a Hex key (A) to release the bearings and the Phillips screw (B) to adjust, see fig 38.

3. To adjust the lower thrust bearing, loosen the Hex screw (D), see fig 39, move forward the thrust assembly (E) to move the bearing approximately 1mm behind the blade, see fig 40.

Fig 38

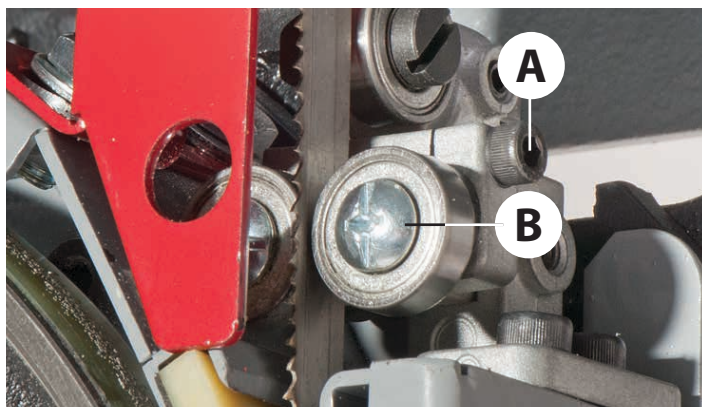
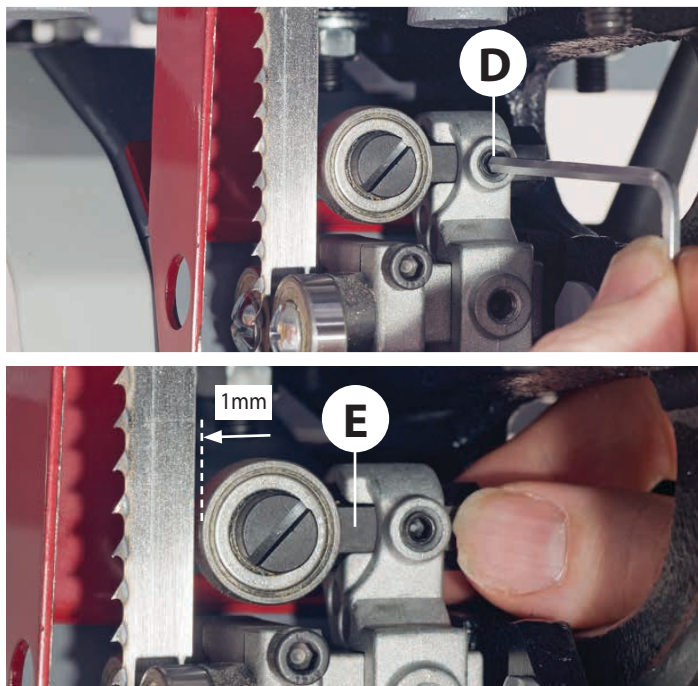


Fig 39-40



4. When all adjustments have been made, recheck that when the blade is pressed back against the thrust bearing, both the upper and lower side guides are still behind the teeth of the saw. When all adjustments are complete tighten all the Hex screws and replace the half section of guard, see fig 41.

Fig 41



Re-tension the belt by rotating the motor assembly until the belt is under tension then re-tighten the lift and shift handle (A) to lock the motor in position, see fig 11-12.



RECONNECT THE SAW TO THE MAINS SUPPLY!

5. Re-connect the power, turn the electro-magnetic brake switch to the 'ON' position and switch the saw on, allow it to run for several minutes, check that the blade is still tracking correctly, there is no excessive vibration, etc. Switch off power and let the saw come to a complete stop. **The saw is ready to be used.**



WAIT UNTIL THE BLADE HAS COME TO A COMPLETE STOP.

GENERAL 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 machine 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 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's capacity, and the cut you are about to make is within the blades' 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. 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 constant changes in stress and tension. Only release the tension to change the blade or once work has finished for the day. The blade in tension over a long period of non-use will cause the tyres to develop 'flat' spot. 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).



HSE Health and Safety Executive

To operate the machine correctly, it is recommended to read the HSE (Health and Safety Executive) website at **www.hse.gov.uk** on the safe operation procedures.

SPECIFIC OPERATING INSTRUCTIONS

Cast Iron Table Features



DISCONNECT THE SAW FROM THE MAINS SUPPLY BEFORE CONTINUING!

Setting the Table Angle

The cast iron table can be tilted from 0-45° degrees. On the tilt quadrant there are two pre-drilled holes to check the table is set at 45° or 90° degrees using the preset locating pin. The table can also be tilted back -5° degrees for cutting dovetails, by opening the access port beneath the table.

1. To tilt the table loosen both clamping handles beneath the cast iron table and turn the tilt quadrant adjusting knob until you reached the required angle then tighten both clamping handles to lock the table in position, see fig 42-43-44-45.

Fig 42-43-44-45



Table clamping handle



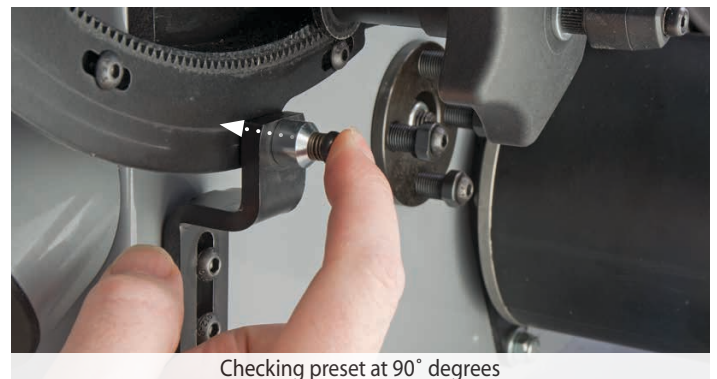
Tilt quadrant clamping handle



2. When setting the table at 45° or 90° degrees, you can check the table is set correctly by pressing the 'preset' locating pin in, see fig 46-47.

Note: the preset pin should slot through one of the preset holes in the tilt quadrant. If however you cannot, adjust the table until the pin slots smoothly through. This will tell you the table is set correctly at the specific angle.

Fig 46-47



Checking preset at 90° degrees



Checking preset at 45° degrees

Cutting Dovetails

When you open the access port beneath the table, the cast iron table then can be tilted back by -5° degrees thus enabling you to cut dovetails, see fig 48-49-50.

Fig 48-49-50



Fence Assembly

The fence has two positions, vertical for guiding large timber through and the horizontal position for cutting narrow pieces. To swap between the two, first remove the rear fence guide, see fig 51 loosen the two clamping knobs (A) behind the fence casting, see fig 52 sufficiently to remove the fence. Turn the fence to the horizontal position, insert the two bolt heads into the fences 'T' slot and slide on. Replace the rear guide, making sure guide is touching the back of the table then tighten the two clamping knobs, see figs 53-54-55.

Fig 51

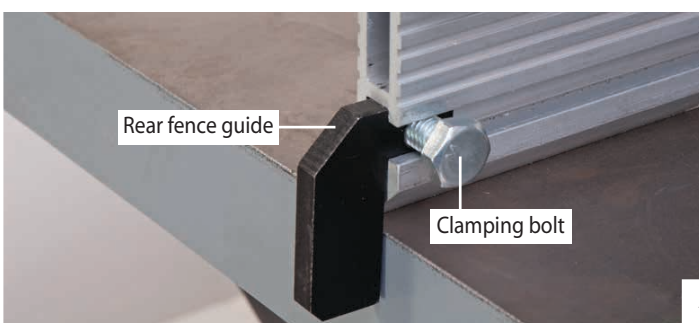


Fig 52-53-54-55

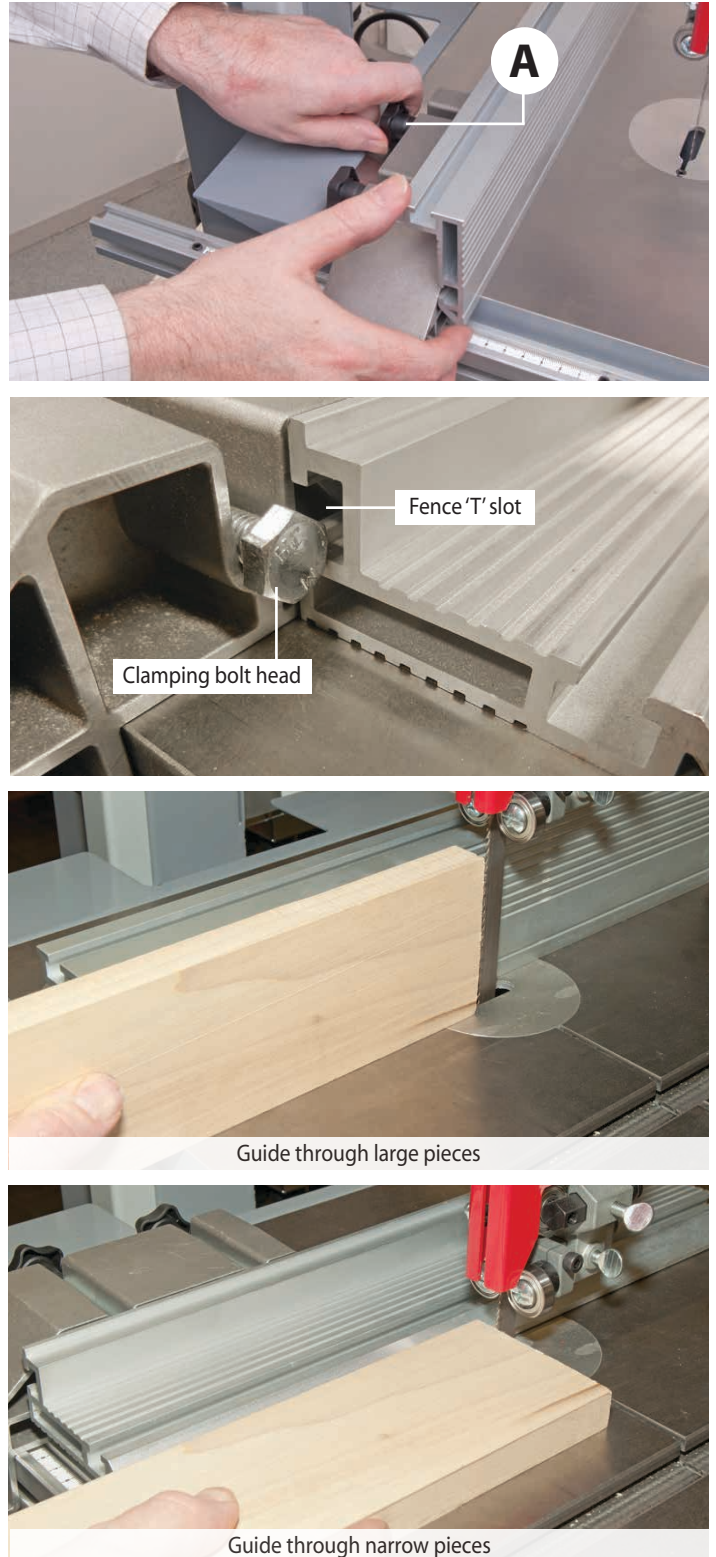


Table Inserts

The bandsaw comes with two table inserts, one for wood and one for cutting plastic/metal. The difference between the two is one has a narrow cutout slot for cutting plastic/metal, see fig 56-57 on page 24.

PLEASE NOTE: The inset for cutting plastic/metal only comes with the AP1854BV which has the variable speed funtion.

SPECIFIC OPERATING INSTRUCTIONS

Fig 56-57



Standard table insert for cutting wood



Table insert for cutting plastic/metal (AP1854BV ONLY)



PLEASE NOTE AS THERE IS ZERO CLEARANCE ON THE TABLE INSERT (I), YOU WILL BE UNABLE TO MAKE ANY CUTS WHEN THE TABLE IS TILTED!



Fence Micro Adjuster

The fence assembly can be adjusted in small increments. To do this first tighten the micro adjuster clamp (A), release the fence clamping handle (B) then turn the micro adjuster knob (C) to make positive or negative changes to the fence, see 58-59-60.

Fig 58

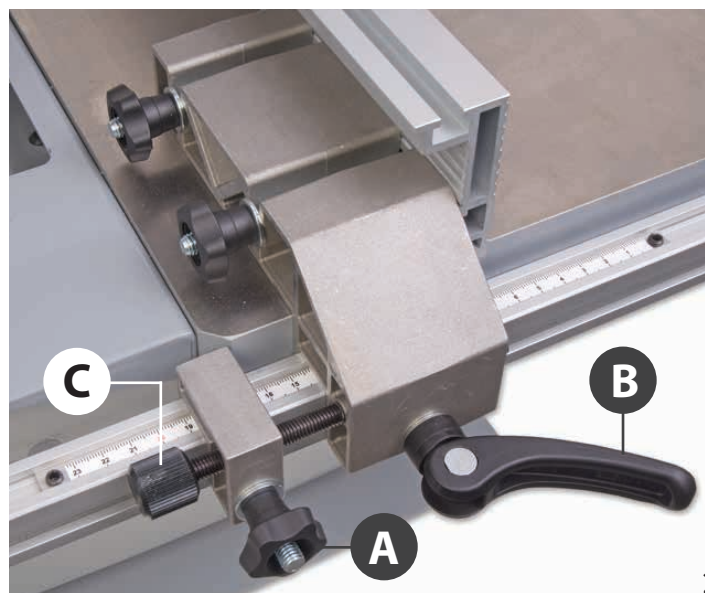
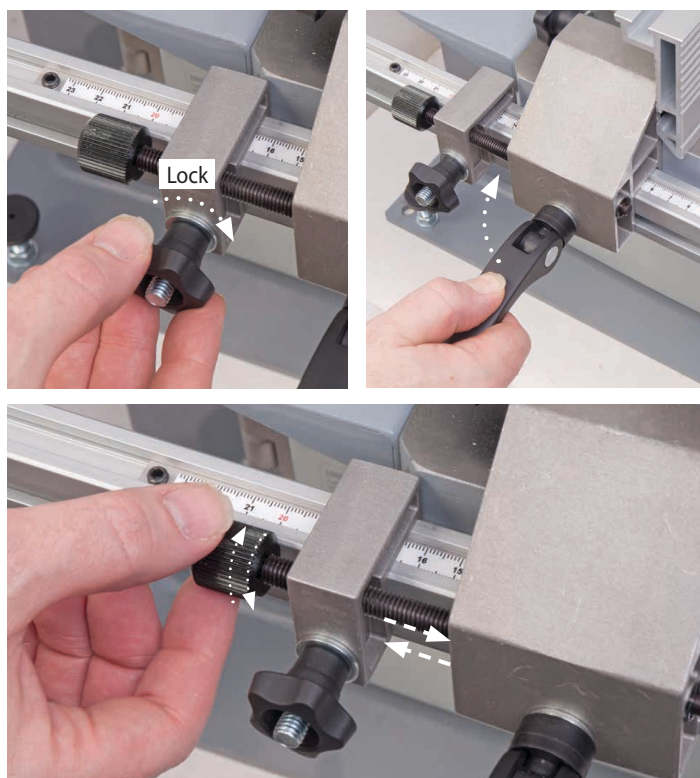


Fig 59-60



ELECTRO-MAGNETIC MOTOR BRAKE SWITCH/EXTRACTION OUTLETS

The electro-magnetic brake switch is located below the NVR switch assembly and has two positions.

- Position (1) engages the motor brake to prevent the bandsaw blade from moving and to isolate the bandsaw to prevent it from being started accidentally, see fig A.
- Position (2) is for running the machine. Move the selector switch to this position, the 'Green LED' light should glow on the NVR switch control panel, (AP1854BV Only). Press the 'Green' button on the NVR switch to start the bandsaw, see fig B-C.



SAFETY NOTE! IF THE MAINS SUPPLY IS CUT THE MAGNETIC BRAKE IS ENGAGED STOPPING THE BANDSAW INSTANTLY.



SAFETY NOTE! TURNING THE SWITCH TO POSITION '1' WILL ENGAGE THE MAGNETIC BRAKE STOPPING THE BANDSAW INSTANTLY.

Fig A-B



Position 1 isolates the bandsaw and engages the motor brake



Position 2 puts power to the bandsaw and releases the motor brake

Fig C



Control Switch (AP1854BV)

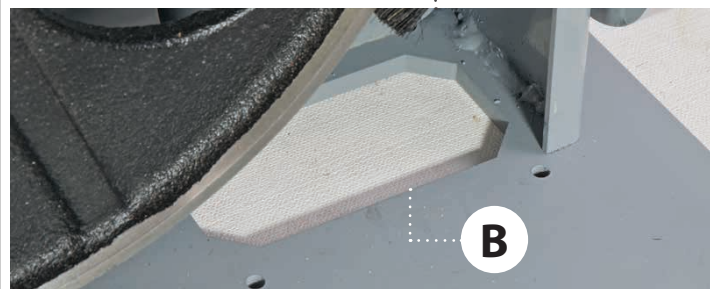
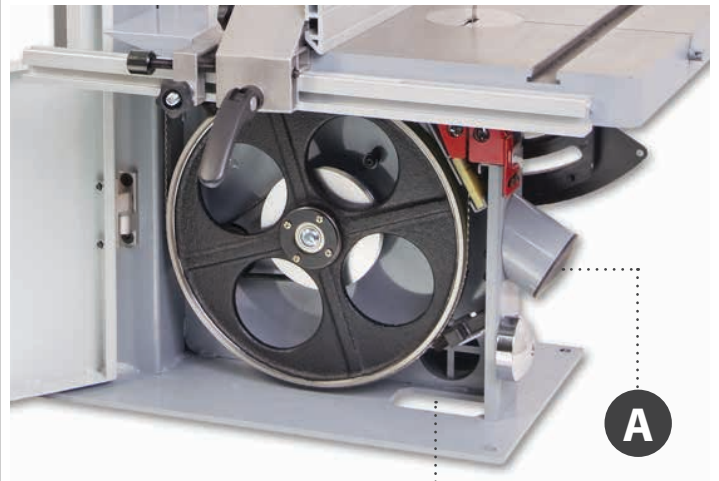


Control Switch (AP1854B)

Dust Extraction Outlets

The bandsaw comes with three extraction outlets for extracting the various materials to be cut. See the table below for the correct connections for the various materials. To avoid cross contamination clean thoroughly when changing material type.

Extraction Outlets					
Port	Wood Only	Metal		Plastic	
A	✓				
B		✓	If mounted to the stand	✓	If mounted to the stand
C		✓	If bench mounted	✓	If bench mounted
AP1854BV ONLY					



CHANGING THE BLADE SPEED

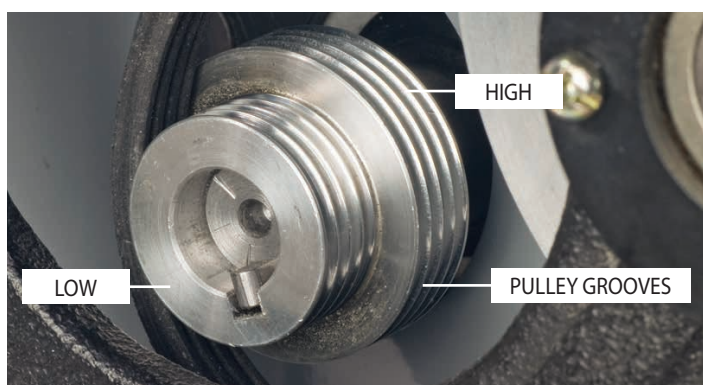


DISCONNECT THE SAW FROM THE MAINS SUPPLY!

The bandsaw drive pulley has two speed positions, see fig 61. To change the bandsaw speed, follow the instructions below.

Bandsaw Speed Chart		
MODEL	LOW	HIGH
AP1854B	534m/min	819m/min
AP1854BV	660m/min	1001m/min

Fig 61



The picture above shows the HIGH and LOW drive pulley positions

1. Open the upper and lower doors, see fig 62. Release the tension on the drive belt by loosening the motor locking handle (A) then rotate the motor assembly until the belt is loose, see fig 63-64.

2. With the drive belt tension removed, very carefully re-position the drive belt, see fig 65-66.

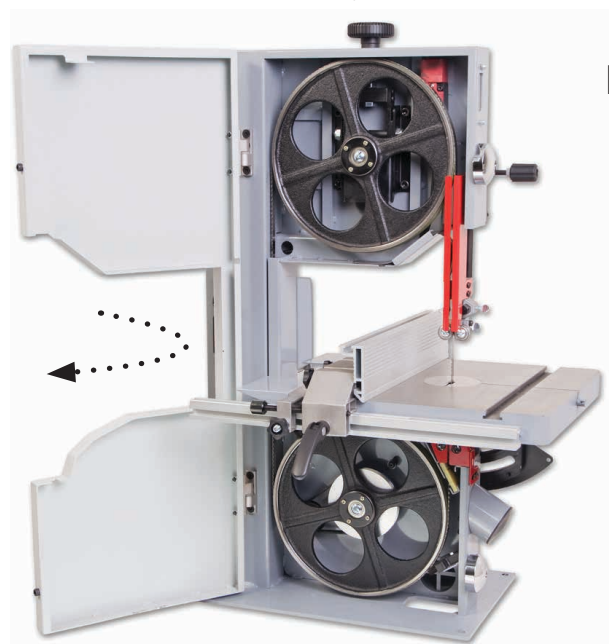


Fig 62

Fig 63-64



NOTE: Make sure the belt is seated correctly into the drive pulley grooves, see fig 61.

3. Rotate the motor back to re-tension the belt enough to prevent the belt from slipping when in operation, but not tight to cause the belt to get hot.

4. Re-tighten the locking handle to lock the motor in position.

Fig 65-66



5. Close the upper and lower doors, connect the bandsaw to the mains supply and start the saw. Check the saw is running correctly, no erratic noises coming from within for example. Once you are satisfied, switch off the bandsaw and wait until it comes to a complete stop.



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Variable Speed Control (BS11-INV ONLY)

To the left side of the bandsaw, just above the on/off switch there is variable speed control dial, see fig 67-68. Turning the dial you will increase or decrease the bandsaw blade speed from 42-660m/min in low gear or 64-1001m/min in high gear.

NOTE: This will depend on where the drive belt has been positioned on the drive pulley, see previous page for repositioning the drive belt.

This gives you better control of the blade speed and allows you to adjust the speed for cutting different materials.

Fig 67-68



The blade speed is subjective to a variety of factors, the type and thickness of the material being cut, the type of blade to be used, the feed rate and the quality of finish. Personal experience is another factor.

NOTE: Experiment on some scrap material before commencing on your actual workpiece.

Wood and Plastics

Below is some general guidelines when selecting/adjusting the blade speed:

- For best results when cutting, always select the speed you are comfortable with based on experience and skill level.
- Generally, harder or denser material requires slower blade speed.
- Some woods and plastics could start to burn at higher speeds. To avoid this, reduce the blade speed and the feed rate, thus reducing the risk of your workpiece being damaged.

Steel and Aluminium

When cutting mild steel or aluminium which is a harder/denser material, will require a very slow blade speed. Adjust the speed control dial until the speed is sufficiently set so the blade is cutting and not generating heat.



WARNING! DO NOT SET THE BLADE SPEED TO HIGH OTHERWISE THE BLADE WILL START TO GENERATE HEAT WHICH WILL REDUCE THE BLADES LIFE SPAN AND COULD DAMAGE THE INTERNAL COMPONENTS.



WARNING! FOR YOUR OWN SAFETY DO NOT ADJUST THE SPEED CONTROL WHILE CUTTING, ALSO KEEP A FIRM GRIP ON THE WORKPIECE AT ALL TIMES.

CHANGING THE SAW BLADE



DISCONNECT THE SAW FROM THE MAINS SUPPLY!



IT IS ADVISABLE TO WEAR GLOVES WHEN REMOVING THE BLADE!

1. 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 doors and remove the table insert.

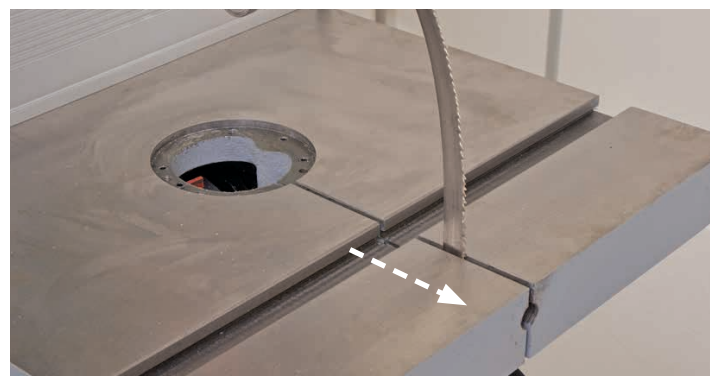
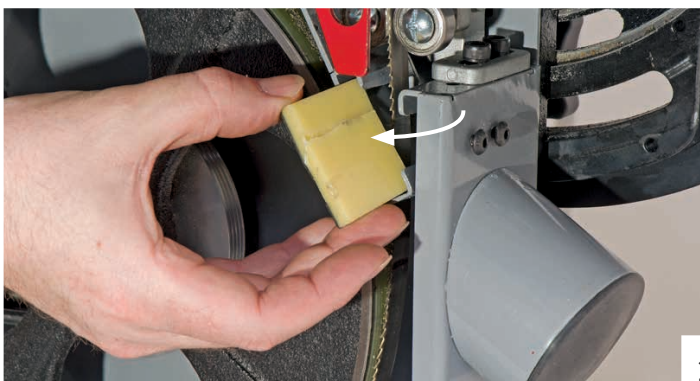
2. Release the blade tension by turning the tensioning knob counter-clockwise and remove the table stabilising bolt, see fig 69-70.

Fig 69-70



3. Remove the saw dust deflector, and place safely aside see fig 71. The blade can be easily slipped off the wheels. Remove the blade carefully, 'wiggling' it clear of the upper blade guard and through the lower blade guard and out the slot in the table, see fig 72-73-74-75.

Fig 71-72-73-74-75



4. This would be 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 threads of the blade and drive belt tensioners and the tracking control. The pivots and the slides of the top wheel mounting assembly and the captive stub axle of the drive belt tensioner in its slot could likewise be lightly oiled.



5. 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.



WARNING! BE VERY CAUTIOUS WHEN YOU 'UNFOLD' THE BLADE; IT TENDS TO 'SPRING' OPEN, BLADE AND TEETH GOING EVERYWHERE.

6. Also check that 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.



MAKE SURE THE BLADE TEETH ARE POINTING DOWN!

7. Open up all blade guides so that they are clear of the blade. Hold the blade approximately midway on either side of the loop and feed it 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 between the lower guard assembly and then through the guard on the upper blade guide assembly, see fig 76.

Fig 76



Fig 77



8. Ease the blade over the wheels and locate the blade in the blade guides, replace the saw dust deflector. Check that the blade is sitting approximately in the middle of the wheels and re-tension the blade by turning the tensioning knob clockwise, see fig 69 and 78.

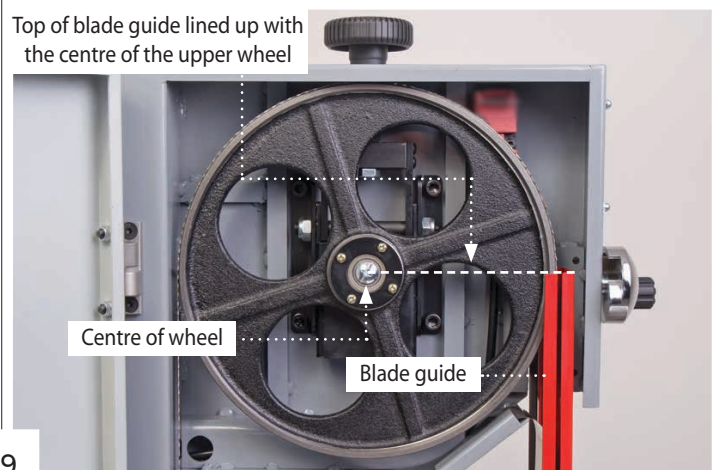
9. Turn the top wheel by hand to ensure the blade will not skip off the wheels and the blade is travelling in the blade guides, see fig 78. When you are sure that the blade is "ON" and stable, re-fit the table stabilising bolt and re-fit the table insert.

Fig 78



10. 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 79. Re-tighten the clamp. Now carry out the procedures as detailed in 'Setting Up the Saw' on page 18.

Fig 79



ROUTING MAINTENANCE



DISCONNECT THE SAW FROM THE MAINS SUPPLY!

Daily

- Keep the machine clean.
- Check the saw blade for missing teeth and cracks, see fig 82
- Spray oil the bare metal surfaces.
- If you are constantly using the bandsaw during the day, open up the wheel doors and clean out all the compacted saw dust.

IMPORTANT NOTE: If you are cutting metal, clean the lower blade guides and lower wheel daily!

Weekly

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

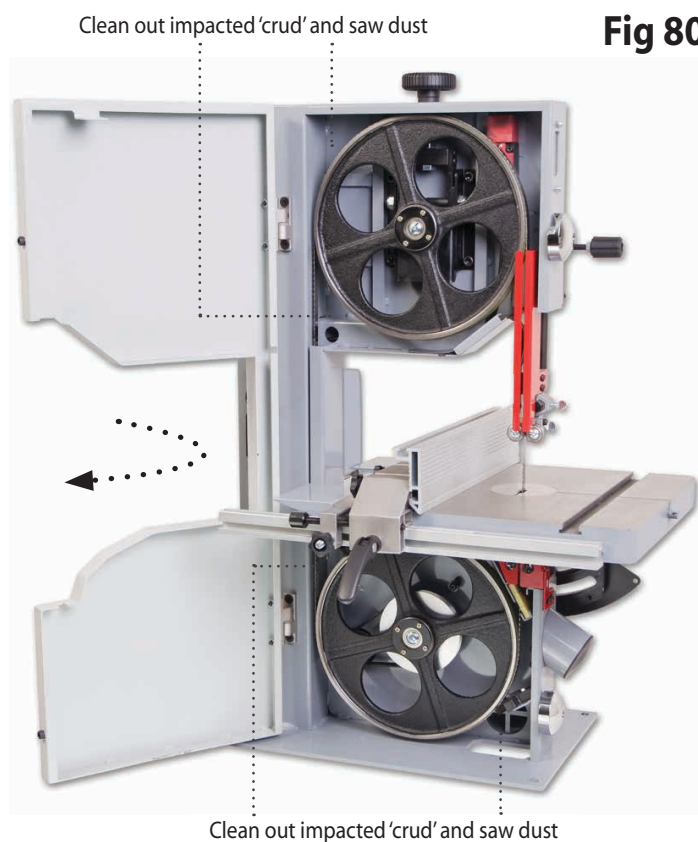
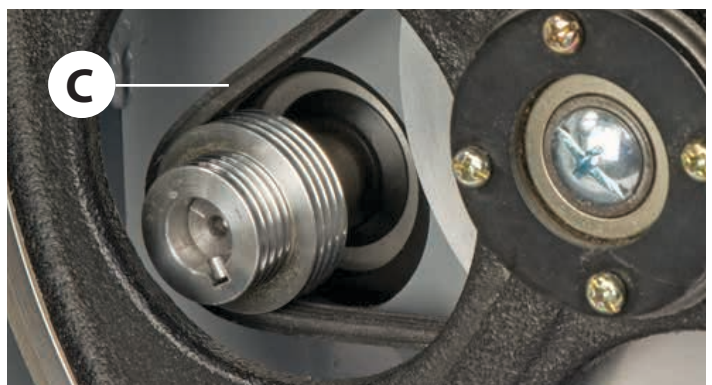
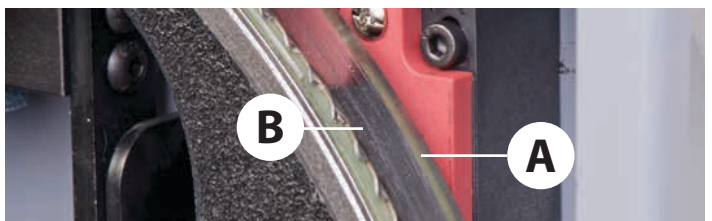


Fig 80

Fig 81-82-83



- Check the condition of the tyres (A)
- Check for missing teeth (B)
- Check the condition of the drive belt (C)

Monthly

- Open the lower and upper door and check the condition of the tyres and the drive belt, see figs 81-82-83.
- 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 motor casing.

About Axc caliber Bandsaw Blades

Axc caliber 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)

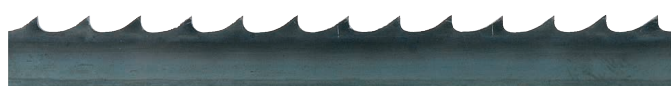
3 tpi (skip form)

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, a 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
13mm (1/2")	63mm (2 1/2")
10mm (3/8")	27mm (1 1/16")
6mm (1/4")	19mm (3/4")
5mm (3/16")	13mm (1/2")
3mm (1/8")	10mm (3/8")

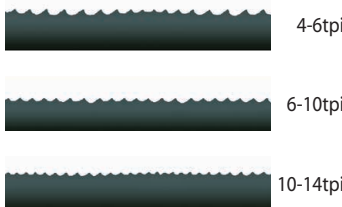
Blade Length

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:

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.

BANDSAW BLADE INFORMATION

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.



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.
- Note the BS11-INV will cut mild steel.
- **DO NOT SET THE BLADE SPEED TOO HIGH OTHERWISE THE BLADE WILL START TO GENERATE HEAT WHICH WILL REDUCE THE BLADE’S LIFE SPAN AND COULD DAMAGE THE INTERNAL COMPONENTS.**

Accessories

Below is the list of top recommended accessories and up-sell items for the bandsaw. Please visit our website at axminstertools.com



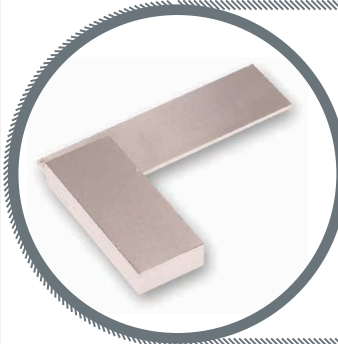
Mitre Fences



Bandsaw Blades



Lubricants and maintenance tools



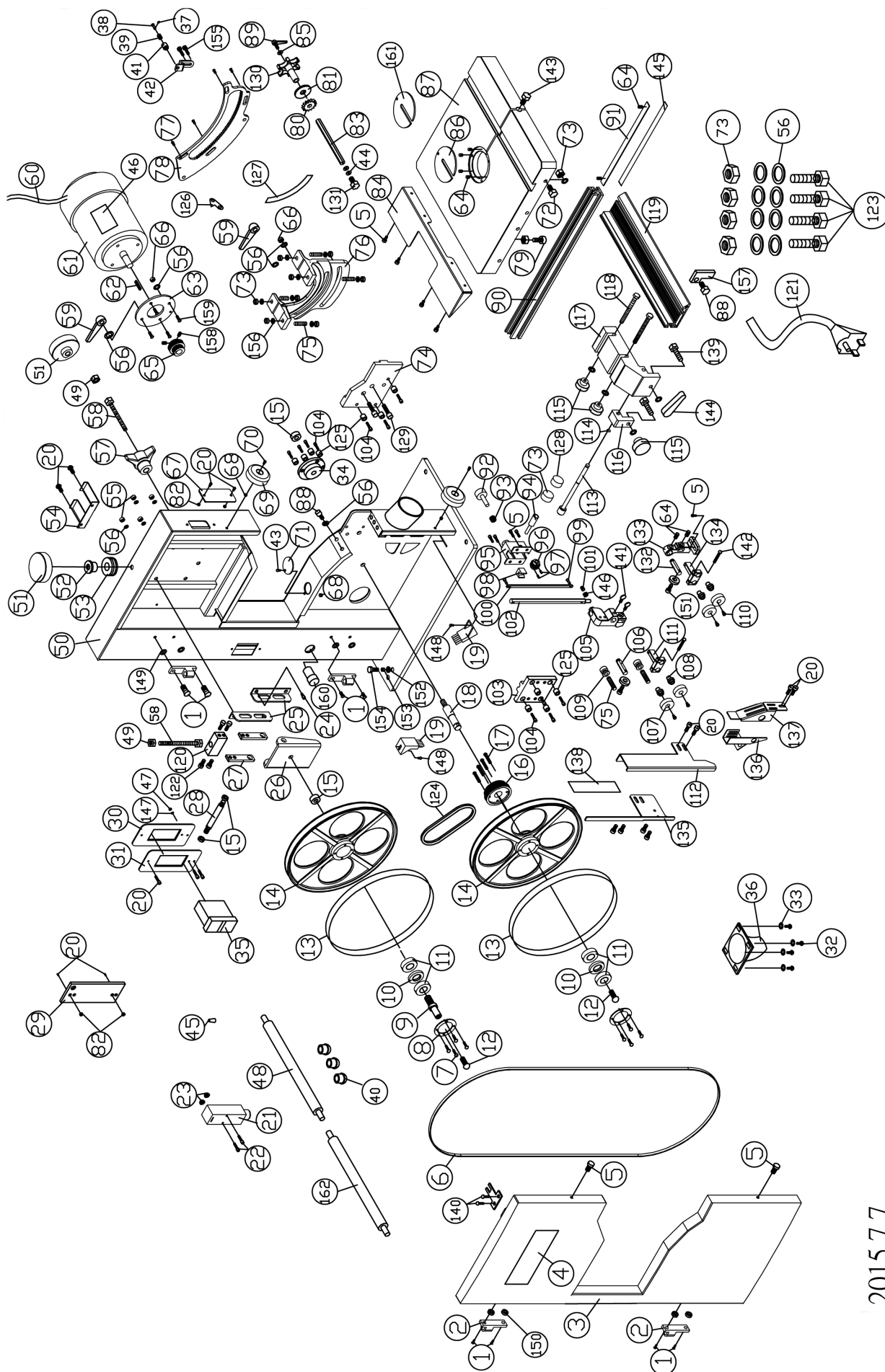
Squares



Extractors

EXPLODED DIAGRAM/LIST

Model: AT1854B (BS11)



2015.7.7

Model: AP1854B (BS11)

PART NO	DESCRIPTION	SPECIFICATION	QTY
1	Flat head screw	M6 x 15	8
2	Hinge		2
3	Door		1
4	Name plate		1
5	Cap screw	M6 x 10	12
6	Blade	0.5 x 6 x 6T x 1858	1
7	Round head screw	M4 x 10	8
8	Block plate		2
9	Top wheel shaft		1
10	Bush		2
11	Bearing	6202-ZZ	4
12	Big round head screw	M8 x 10	2
13	Rubber ring		2
14	Saw wheel		2
15	Nylon nut	M10	4
16	Wheel pully		1
17	Round head cap screw	M4 x 27	4
18	Down shaft		1
19	Brush		2
20	Round head cap screw	M5 x 10	14
21	Limited switch		1
22	Cap screw	M4 x 30	2
23	Round head nut	M4	2
24	Cap screw	M8 x 15	6
25	Bracket		2
26	Adj. bracket		1
27	Pull plate		2
28	Pull rod		1
29	Cover plate		1
30	Control plate		1
31	Label		1
32	Big round head screw	M5 x 10	4
33	Washer	M5	4
34	Adj. shaft		1
35	ON/OFF switch		1
36	Dust collect		1
37	E ring		1
38	Rod		1
39	Spring		1
40	Wire clamp	PG-11	3
41	Bush		1
42	Base		1

43	Button head screw	M5 x 15	1
44	Spring washer	M6	1
45	Connector		3
46	Motor label		1
47	Handle		1
48	Signal wire		1
49	Nut	M10	2
50	Body		1
51	Knob		2
52	Bush		1
53	Flat bearing	51101	1
54	Bracket		1
55	Round head nut	M8	4
56	Washer	M8	27
57	Knob		1
58	Hex screw	M10 x 90	2
59	Handle	M8	2
60	Motor wire		1
61	Motor		1
62	Key	4 x 4 x 25	1
63	Motor plate		1
64	Set screw	M6 x 6	8
65	Motor pulley		1
66	Nylon nut	M8	3
67	Acrylic plate		1
68	Nylon nut	M5	2
69	Handle		2
70	Cap screw	M5 x 25	2
71	Angle plate		1
72	Hex screw	M8 x 20	3
73	Nut	M8	17
74	Slide plate		1
75	Set screw	M8 x 40	5
76	Table Bracket		1
77	Round head cap screw	M5 x 10	4
78	Tooth plate		1
79	Hex screw	M8 x 25	1
80	Tooth washer		1
81	Washer		1
82	Round head nut	M5	4
83	Hexagonal rod		1
84	Leader plate		1
85	Washer	1/4"-T=2mm	2
86	Plate		1
87	Table		1
88	Hex screw	M8 x 15	3

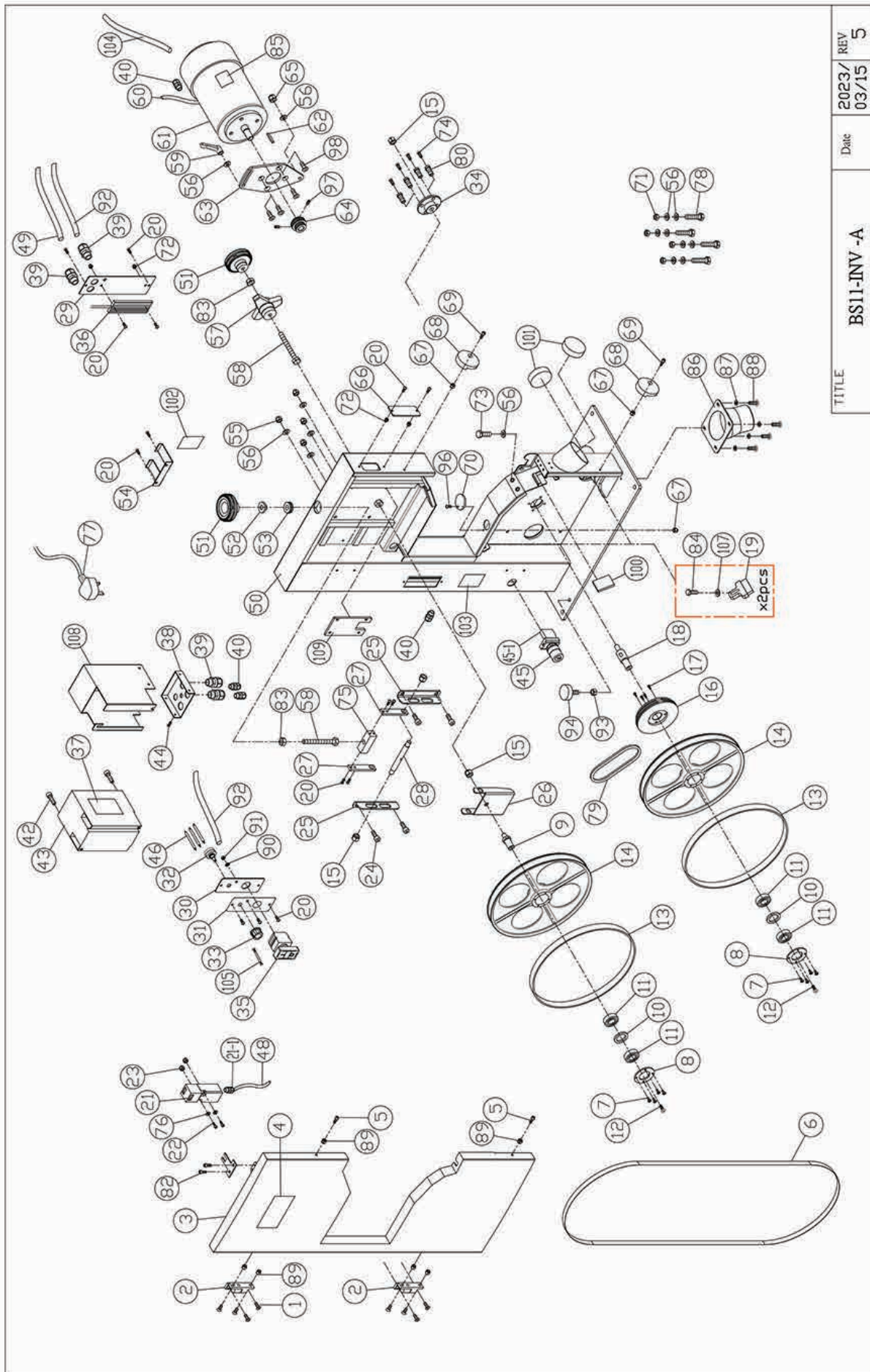
EXPLODED DIAGRAM/LIST

89	Handle	1/4"	1
90	Aluminum bar		1
91	Scale plate		1
92	Knob		1
93	Spring		1
94	Knob rod		1
95	Bracket		1
96	Tooth wheel		1
97	Set screw	M3 x 5	2
98	Push block		1
99	Round head screw	M3 x 10	2
100	Rack		1
101	Hex screw	M6 x 15	1
102	Hexagonal rod		1
103	Hexagonal base		1
104	Round head cap screw	M6 x 30	12
105	Blade base up		1
106	Hexagonal rod		1
107	Bearing	608-ZZ	6
108	Off center rod		4
109	Adj. nut		2
110	Big round head screw	M6 x 10	6
111	Bracket		1
112	Cover plate		1
113	Adj. rod		1
114	E-ring	S-5	1
115	Handle		3
116	Adj. block		1
117	FENCE block		1
118	Hex screw	M8 x 90	3
119	Fence		1
120	Pull block		1
121	Power wire		1
122	Round head cap screw	M5 x 10	4
123	Hex screw	M8 x 50	4
124	Belt	140-J4	1
125	Adj. Screw		12

126	Pointer		1
127	Angle label		1
128	Handle		1
129	Cap screw	M8 x 45	2
130	Handle		1
131	Hex screw	1/4"-20 x 3/8"	1
132	Hexagonal rod-short		1
133	Blade base down		1
134	Bracket-short		1
135	Cover-2		1
136	Cover-3		1
137	Cover-4		1
138	Soft plate		1
139	Hex screw	M8 x 50	2
140	Cap screw	M4 x 10	2
141	Adj. screw	M6 x 12	2
142	Cap screw	M5 x 35	2
143	Table pin		1
144	Pull handle	M8	1
145	Scale label		1
146	NUT	M6	1
147	Tooth washer	M5	1
148	Hex screw	M5 x 16	2
149	Washer	t=0.6	6
150	Nylon nut	M6	4
151	Screw		2
152	Washer	3/8"	1
153	Nut	3/8"	1
154	Stop rod	3/8"	1
155	Button head screw	M6 x 20	2
156	Washer	M8 x 22 x 1.2	4
157	Stop plate		1
158	Set screw	1/4" x 1/4"	2
159	Flat head screw	1/4" x 5/8"	4
160	Switch		1
161	Plate 2		1
162	POWER CORD 2		1

EXPLODED DIAGRAM/LIST

Model: AP1854BV (BS11-INV- A)



EXPLODED DIAGRAM/LIST

Model: AP1854BV (BS11-INV- A)

PART NO.	DESCRIPTION	SPECIFICATION	Qty
A01	Flat Head Screw	M6x16	8
A02	Hange		2
A03	Door		1
A04	Name Plate		1
A05	Cap Screw	M6x10	2
A06	Blade	0.5x12.5Wx6Tx1858	1
A07	Round Head Screw	M4x10	8
A08	Block Plate		2
A09	Top Wheel Shaft		1
A10	Bush		2
A11	Bearing	6202ZZ	4
A12	Big Round Head Screw	M8x10	2
A13	Rubber Ring		2
A14	Saw Wheel		2
A15	Nylon Nut	M10	4
A16	Wheel Pulley		1
A17	Round Head Cap Screw	M4x27	4
A18	Down Shaft		1
A19	Brush		2
A20	Round Head Cap Screw	M5x10	15
A21	Limited Switch		1
A21-1	Wire Clamp		1
A22	Cap Screw	M4x30	2
A23	Round Head Nut	M4	2
A24	Cap Screw	M8x16	4
A25	Breaket		2
A26	Adj. Breaket		1

A27	Pull Plate		2
A28	Pull Rod		1
A29	Cover Plate		1
A30	Control Plate		1
A31	Label		1
A32	VR		1
A33	VR Nut		1
A34	Adj. Shaft Breaket		1
A35	ON/OFF Switch		1
A36	Break		1
A37	Label		2
A38	Inverter Breaket		1
A39	Wire Clamp	PG-11	3
A40	Wire Clamp	PG-9	4
A42	Cap Screw	M5x16	2
A43	Inverter		1
A44	Round Head Screw	M5x10	4
A45	Key Switch		1
A45-1	Switch connector		1
A46	VR Wire		3
A48	Signal Wire		1
A49	Control Wire		1
A50	Body		1
A51	Knob		2
A52	Bush		1
A53	Thrust Bearing		1
A54	Breaket		1
A55	Round Head Nut	M8	4
A56	Washer	M8	16
A57	Knob		1
A58	Hex Screw	M10x90	2

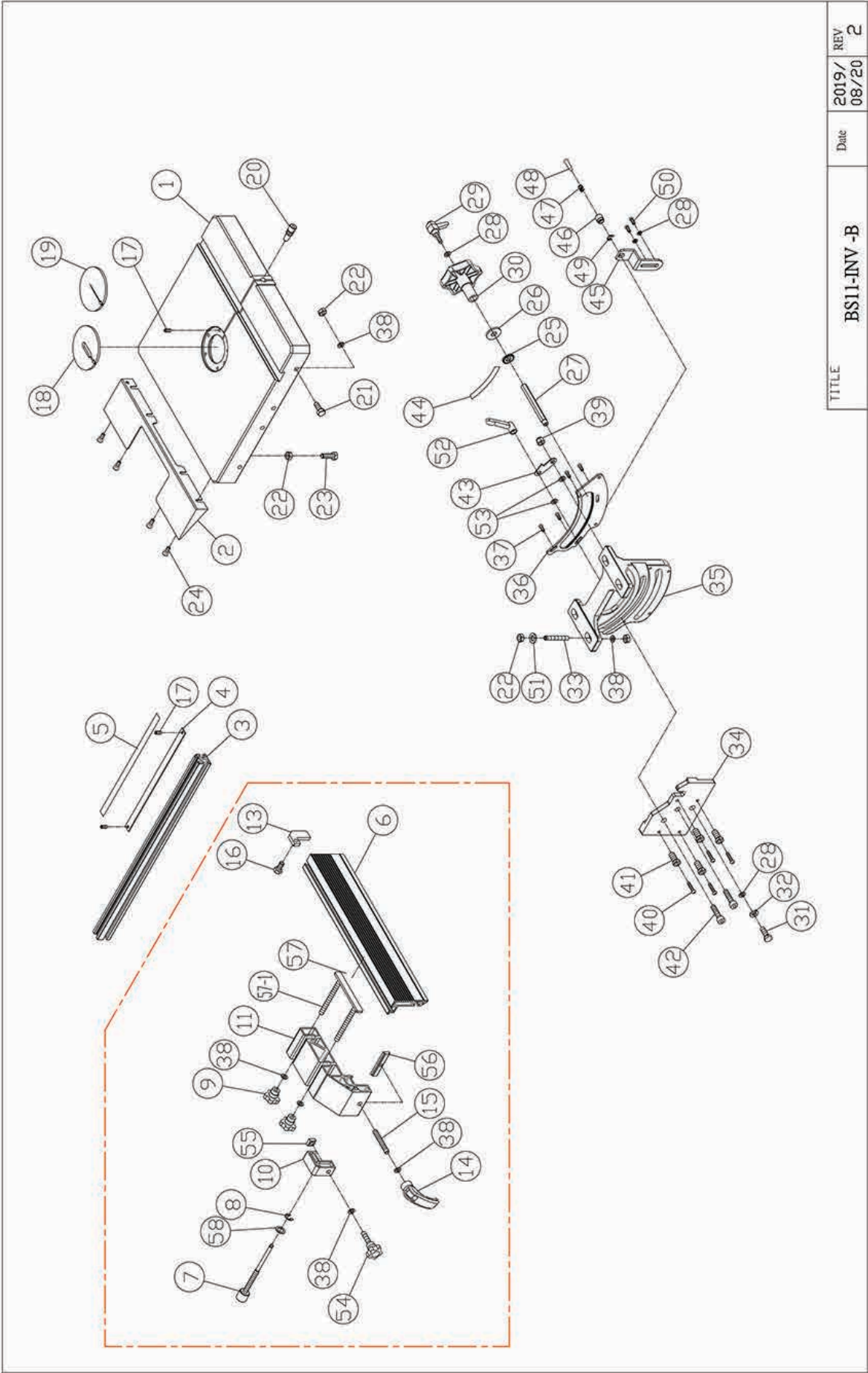
EXPLODED DIAGRAM/LIST

A59	Handle	M8	1
A60	Motor Wire		1
A61	Motor	3/4HP*50HZ*230V	1
A62	Key	4x4x25	1
A63	Motor Plate		1
A64	Motor Pulley		1
A65	Nylon Nut	M8	1
A66	Acrylic Plate		1
A67	Nylon Nut	M5	3
A68	Handle		2
A69	Cap Screw	M5x25	2
A70	Angle Plate		1
A71	Nut	M8	4
A72	Round Head Nut	M5	4
A73	Hex Screw	M8x16	2
A74	Round Head Cap Screw	M6x35	4
A75	Pull Block		1
A76	Washer	M4	2
A77	Power Wire		1
A78	Hex Screw	M8x50	4
A79	belt	170-J4	1
A80	Adj. Screw		4
A82	Cap Screw	M4x10	2
A83	Nut	M10	2
A84	Hex Screw	M5x16	2
A85	Motor Label		1
A86	Dust Collect		1
A87	Washer	M5	4
A88	Big Round Head Screw	M5x8	4
A89	Nylon Nut	M6	6

A90	Tooth Washer	M5	1
A91	Nut	M5	1
A92	Power Cord 2		2
A93	Nut	3/8"	1
A94	Stop Rod	3/8"	1
A96	Button Head Screw	M5x16	1
A97	Set Screw	1/4"x1/4"	2
A98	Flat Head Screw	1/4"x5/8"	4
A100	ABS plate		1
A101	Pipe Cover		2
A102	ID Lable		1
A103	Warning Label		1
A104	Wire		1
A105	Switch Wire		1
A107	Washer	M5	2
A108	Inverter cover		1
A109	Fixed block		1

EXPLODED DIAGRAM/LIST

Model: AP1854BV (BS11-INV- B)



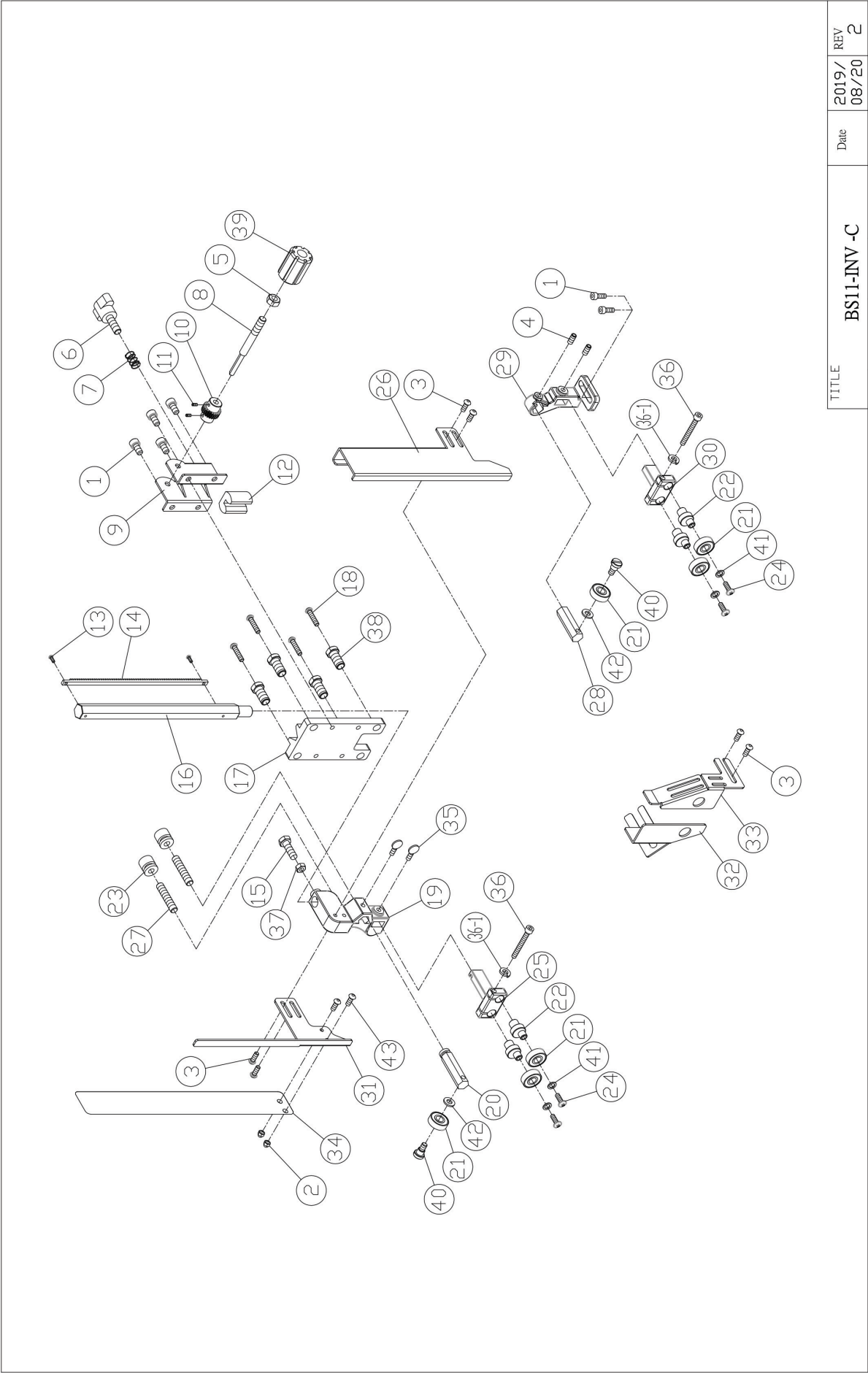
Model: AP1854BV (BS11-INV- B)

PART NO.	DESCRIPTION	SPECIFICATION	QTY
B01	Table		1
B02	Leader Plate		1
B03	Aluminum bar		1
B04	Scale Plate		1
B05	Scale Lable		1
B06	Fence		1
B07	Adj.Rod		1
B08	E-Ring	ETW-5	1
B09	Handle		2
B10	Adj. Block		1
B11	Fence block		1
B13	Stop Plate		1
B14	Pull Handle	M8	1
B15	SET Screw	M8x55	1
B16	Hex Screw	M8x16	1
B17	Set Screw	M6x6	8
B18	Plate		1
B19	Plate 2		1
B20	Table pin		1
B21	Hex Screw	M8x20	4
B22	Nut	M8	13
B23	Hex Screw	M8x25	1
B24	Cap Screw	M6x10	4
B25	Tooth Washer		1
B26	Washer		1
B27	Hexagonal Rod		1
B28	Washer	1/4"	4
B29	Handle	1/4"x20	1
B30	Handle		1

B31	Hex Screw	1/4"-20UNCx3/8"	1
B32	Spring Washer	M6	1
B33	Set Screw	M8x40	4
B34	Slide Plate		1
B35	Table Bracket		1
B36	Tooth plate		1
B37	Round Head Cap Screw	M5x10	4
B38	Washer	M8	12
B39	Nylon Nut	M8	1
B40	Round Head Cap Screw	M6x30	4
B41	Adj. Screw		4
B42	Cap Screw	M8x45	2
B43	Pointer		1
B44	Angle Label		1
B45	Base		1
B46	Bush		1
B47	Spring		1
B48	Rod		1
B49	E-Ring	ETW-3	1
B50	Button Head Screw	M6x20	2
B51	Washer	M8xD25	4
B52	Handle	M8	1
B53	Washer	M8	2
B54	Handle		1
B55	Nut		1
B56	T type Nut		1
B57	Clamp plate		1
B57-1	Set Screw	M8x90	2
B58	Washer	M6	1

EXPLODED DIAGRAM/LIST

Model: AP1854BV (BS11-INV- C)



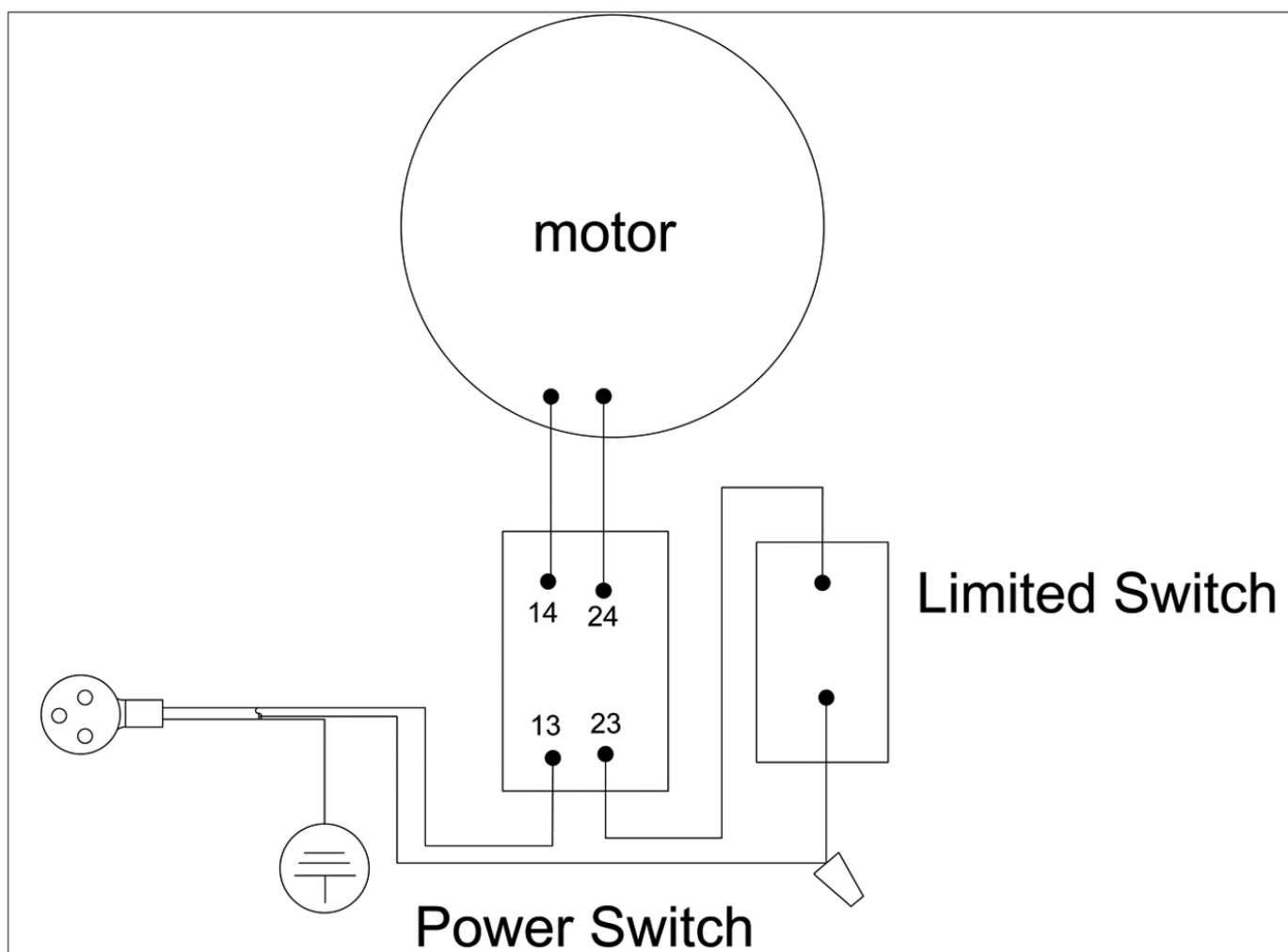
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BS11-INV- C				

Model: AP1854BV (BS11-INV- C)

PART NO.	DESCRIPTION	SPECIFICATION	QTY
C01	Cap Screw	M6x10	6
C02	Round Head Nut	M5	2
C03	Round Head Cap Screw	M5x10	6
C04	Set Screw	M6x6	2
C05	Nut	M8	1
C06	Knob		1
C07	Spring		1
C08	Knob Rod		1
C09	Breaket		1
C10	Tooth Wheel		1
C11	Set Screw	M4x5	2
C12	Push Block		1
C13	Round Head Screw	M3x10	2
C14	Rack		1
C15	Hex Screw	M6x16	1
C16	Hexabonal rod		1
C17	Hexabonal Base		1
C18	Round Head Cap Screw	M6X35	4
C19	Blade base up		1
C20	Hexabonal rod		1
C21	Bearing	608zz	6

C22	Off Center rod		4
C23	Adj. Nut		2
C24	Big Round Head Screw	M6x8	4
C25	Blacket		1
C26	Cover Plate		1
C27	Set Screw	M8x40	2
C28	Hexagonal Rod-Short		1
C29	Blade Base Down		1
C30	Breaket-Short		1
C31	Cover-2		1
C32	Cover-3		1
C33	Cover-4		1
C34	Soft Plate		1
C35	Screw	M6x12	2
C36	Cap Screw	M5x40	2
C36-1	Spring Washer	M5	2
C37	Nut	M6	1
C38	Adj. Screw		4
C39	Handle		1
C40	Screw		2
C41	Washer	M6	4
C42	Washer	M6xD13x1.5t	2
C43	Round Head Cap Screw	M5x6	2

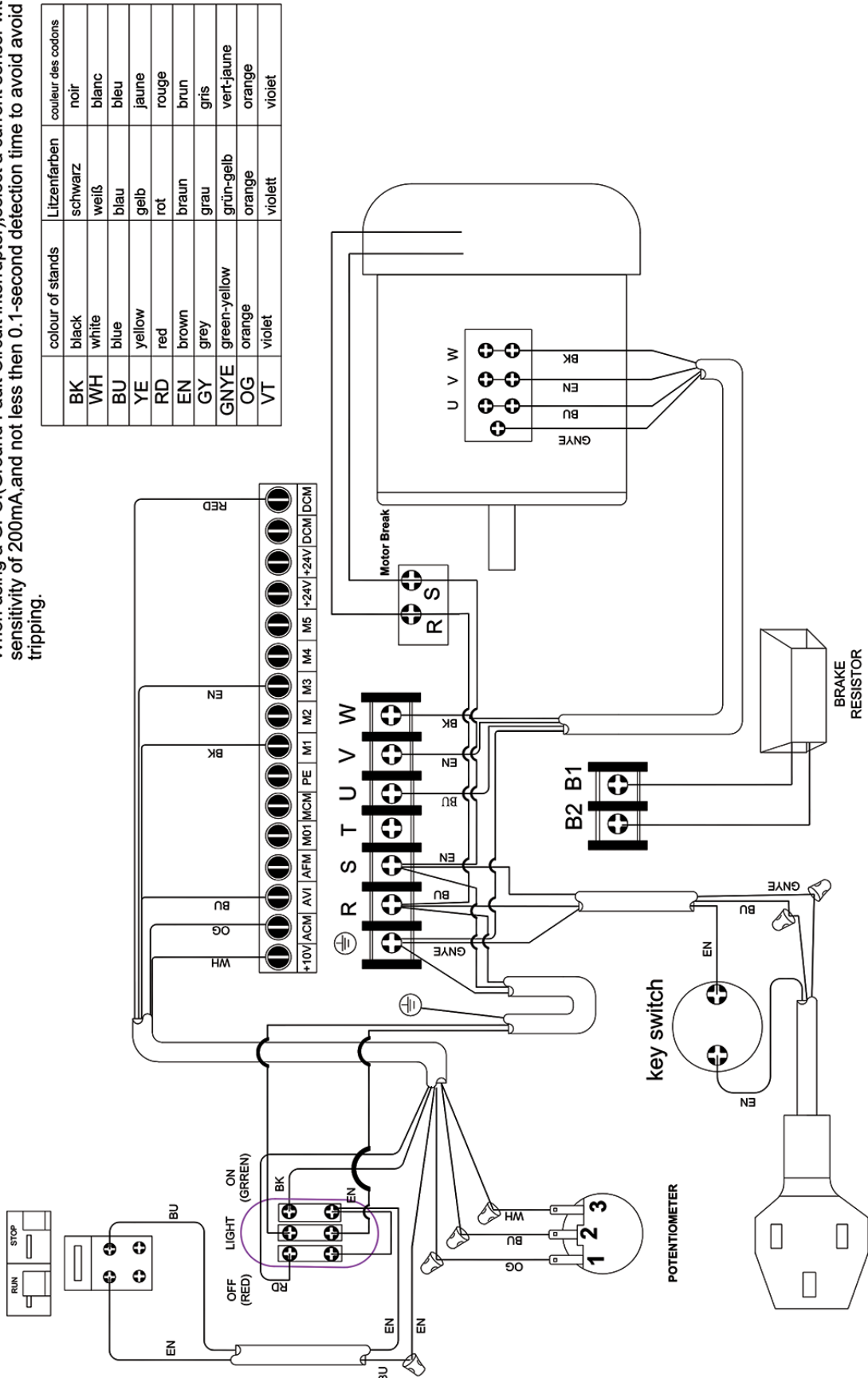
WIRING DIAGRAM FOR AP1854B



ELECTRIC WIRING DIAGRAM
CIRCUIT DE CBLAGE ELECTRIQUE



NOTE
If a filter is required for reducing EMI(Electro Magnetic Interference), install it as close as possible to AC drive.EMI can also be reduced by lowering the Carrier Frequency.
When using a GFCI(Ground Fault Circuit interrupter),select a current sensor with sensitivity of 200mA,and not less then 0.1-second detection time to avoid avoid nuisance tripping.



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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

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