



OWNERS MANUAL



B1329 – 20” WOOD BAND SAW



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B1329 WOOD CUTTING BAND SAW

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GENERAL SAFETY INSTRUCTIONS

EXTREME CAUTION SHOULD BE USED IN OPERATING ALL POWER TOOLS. KNOW YOUR POWER TOOL, BE FAMILIAR WITH ITS OPERATION. READ THE OWNER'S MANUAL AND PRACTICE SAFE USAGE PROCEDURES AT ALL TIMES.

- ❑ **CONNECT** your machine **ONLY** to the matched and specified power source.
- ❑ **WEAR SAFETY GLASSES, RESPIRATORS, HEARING PROTECTION** and **SAFETY SHOES** when operating heavy machinery. **Always wear safety glasses.**
- ❑ **DO NOT** wear loose clothing or jewellery when operating machinery.
- ❑ **A Safe Environment is important.** Keep the area free of dust, dirt and other debris in the immediate vicinity of the machine.
- ❑ **BE ALERT!** Do Not Use prescription or other drugs that may affect your ability or judgement to safely use this machine.
- ❑ **DISCONNECT** the power source when changing drill bits, hollow chisels or making other adjustments or repairs.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **NEVER** reach over the table when the tool is in operation.
- ❑ **ALWAYS** keep blades, knives or bits sharp and properly aligned.
- ❑ **ALWAYS** keep all safety guards in place and ensure their proper function.
- ❑ **ALWAYS** use push sticks and featherboards to safely feed your work through the machine.
- ❑ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❑ **ALWAYS** secure your work with the appropriate clamps or vises.
- ❑ **ALWAYS** keep bystanders safely away while operating machinery.
- ❑ **THINK SAFETY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

B1329, 20" Wood Band Saw

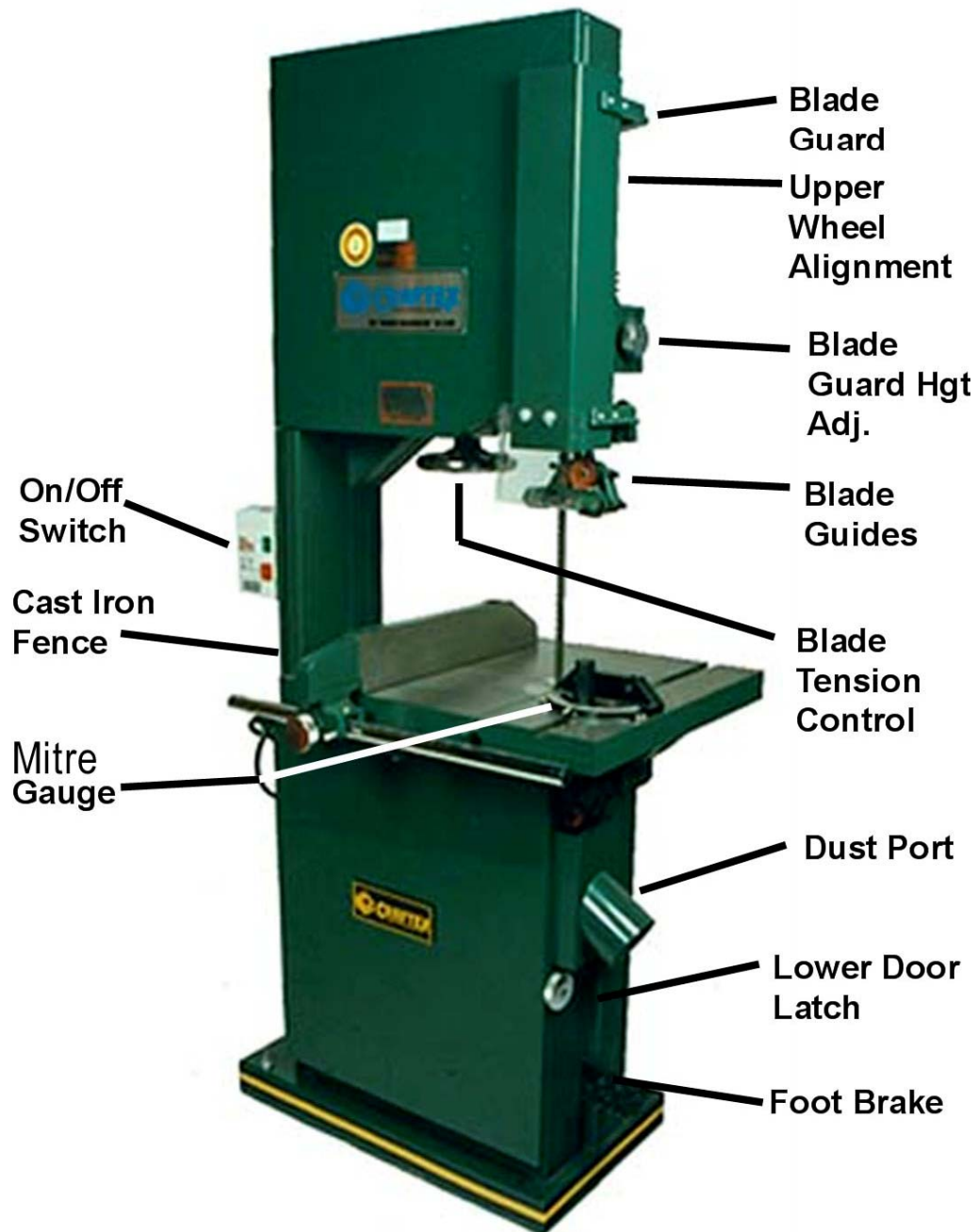
As part of the growing line of Craftex woodworking equipment, we are proud to offer the B1329 20" Wood Band Saw. The Craftex name guarantees Craft Excellence. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The B1329 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

FEATURES

- ❑ The Craftex B1329 is a heavy-duty 20" Wood Cutting Band saw.
- ❑ Motor – 3HP, Single Speed, Single Phase 220 Volts.
- ❑ Motor Speed – 3,450 RPM's.
- ❑ Motor Switch – Magnetic.
- ❑ Blade Speed – 3,700 FPM.
- ❑ Table Size – 20" x 23".
- ❑ Table Material – Surface Ground Cast Iron.
- ❑ Table Height – 35 1/2".
- ❑ Table Tilts, 10° Left, 45° Right.
- ❑ Throat – 19 1/2".
- ❑ Cutting Height – 12".
- ❑ Blade Size – Up To 1 1/4" Wide x 156" Long.
- ❑ Fence – Cast Iron, 18" x 3 1/2".
- ❑ Miter Gauge – 'T' Slot, Included.
- ❑ Overall Height – 73 1/2".
- ❑ Gross Weight – 250kg.

B1329 WOOD CUTTING BAND SAW

OPERATING CONTROLS



B1329 WOOD CUTTING BAND SAW Assembly

Congratulations on your purchase of the Craftex B1329, 20" Wood Cutting Bandsaw. Like all Craftex Products, the B1329 will give you many years of excellent service.

Your B1329 Band saw has been shipped complete and there is very little to do regarding the assembly of the tool.

Carefully, unpack the band saw but leave it on the pallet until you have placed the tool in its final position. The band saw is very heavy and should be moved mechanically. A lifting eye positioned on the upper frame is provided for convenience.

Consideration should be given to the positioning of the saw due to its weight. The floor should be solid and level.



You will find a cardboard carton near the base of the crate and this contains the cast-iron rip fence. The 't' slot Miter Gauge is 'locked' to the band saw tabletop. Loosen the handle to remove it.

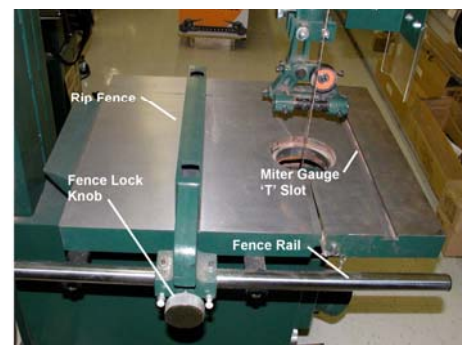


Cleaning

The cast-iron components of the B1329 have been shipped with a protective coating on them to prevent rusting in storage and shipping. This coating should be removed with mineral spirits and dried thoroughly. A coating of paste wax should be applied to these components and then buffed dry.

Fence & Miter Gauge

Assemble the rip fence to the rail on the front edge of the cast-iron band saw table. The 'T'-slot mitre gauge is best installed by setting the bar into the mitre slot at the backside of the saw table. This will allow the 'T' to fit smoothly into the slot as you draw the gauge back toward you.



B1329 WOOD CUTTING BAND SAW

Assembly, Continued

Power Supply

The B1329 has been equipped with a Magnetic Power Switch that must be either hard-wired to a 220V power supply or to an appropriate 220V 3-prong plug.

Be sure that the power switch is in the OFF position.



B1329 WOOD CUTTING BANDSAW Operation

The B1329 Band saw has been shipped with a blade but with the blade tension handle loosened. This may have resulted in the blade moving out of position.

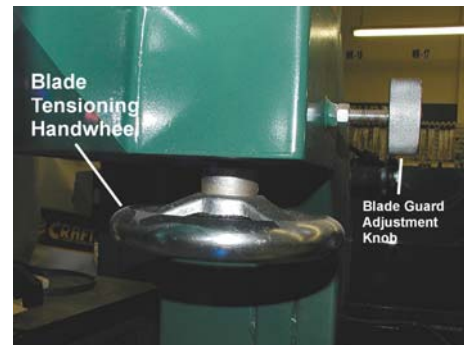
Initial Setup

Open the upper and lower doors by rotating the door latches in a clock-wise motion.

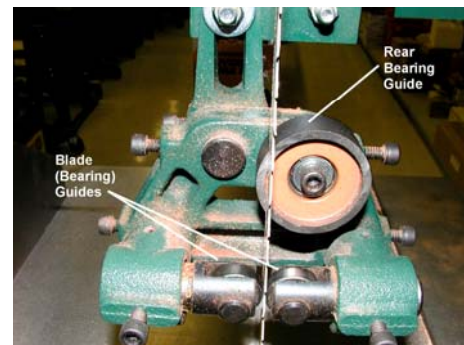
Center the blade on both the upper and lower wheels being sure that the blade runs through the upper and lower blade guides.



Slightly tighten the blade-tensioning wheel by turning it in a clockwise motion to just snug the blade on the upper and lower wheel tires.



The upper and lower band saw blade guides should be positioned snug to and slightly behind the gullets of the blades and the rear blade guides should be positioned so that they are just touching the rear edge of the blade.



B1329 WOOD CUTTING BAND SAW

Operation, Continued

Wheel Alignment

Although the B1329 was aligned at the factory, shipping and handling may have altered the alignment of the upper wheel assembly. Should this have occurred, the band saw blade will not remain on the upper wheel and tire when in use. If the blade comes off the wheels in operation, it could cause damage to the interior components of the saw.

To vertically align the two wheels, the blade should be slightly tensioned by turning the blade tensioning hand wheel as above.

Slowly rotate the upper wheel in a clockwise motion and take note of the tracking of the band saw blade. If the blade wanders from the crest (center) of the wheel, adjust the alignment knobs on the back of the upper saw casing.

Rotate the knob to adjust the wheel in accordance with the instructions printed on the saw casing above the knob.



Blade Tensioning

It is now time to tension the band saw blade. As a rule of thumb, the narrower the blade, the more tension may be applied. The reason for this is that the narrower blades tend to wander off a straight line cut easier than a wider blade.

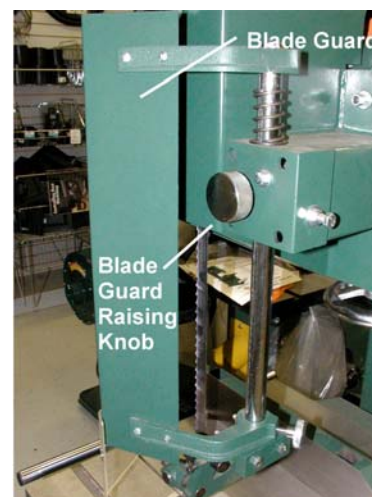
Tighten the blade by turning the blade-tensioning wheel in a clockwise motion.

Hand rotate the upper wheel to be certain that the blade is taut, the blade remains on the crest of the wheels and the blade remains positioned correctly in the upper and lower blade guides.

Blade Guard

Swing the Blade guard into position to cover the saw blade.

For safe band saw operation the blade guard **MUST** be positioned no more than 1/4" above the material being cut.



B1329 WOOD CUTTING BAND SAW

Operation, Continued

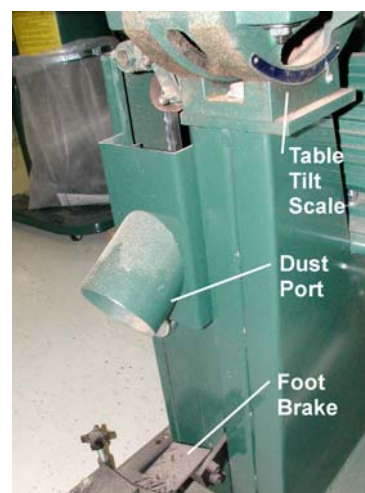
Table Tilting

The B1329 saw table can be tilted 10 degrees to the left and 45 degrees to the right. A scale and a pointer are located under the saw table. Two knobs under the table should be loosened to adjust the table angle.



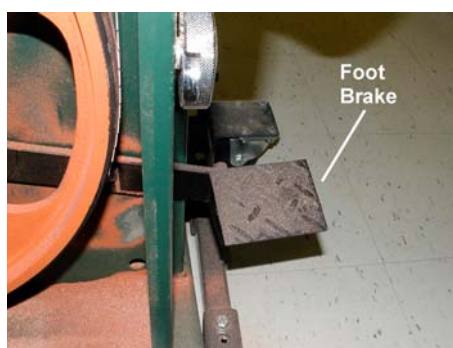
Sawdust

A dust port is located in the lower wheel housing and is of a diameter that is compatible with most dust collection systems.



Blade Brake

Your B1329 20" band saw is equipped with precision balanced upper and lower wheels on ball bearing axles. The wheels will continue running freely even with the motor turned off. A safety foot brake to stop the blade and wheels is located just below the dust port and should be pressed **after** turning the tool off or in emergency situations.



B1329 WOOD CUTTING BAND SAW Operation, Continued

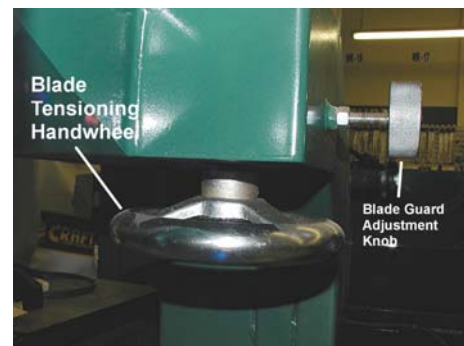
Tire Brush

The B1329 band saw is equipped with a tire brush in the lower wheel housing that is designed to remove most of the sawdust from the tires of the tool. Sawdust that adheres to the tires will build up and eventually adversely affect blade tracking. The tire brush should be adjusted from time to time as a routine maintenance program.



Releasing Blade Tension

It is important to release the blade tension on the B1329 band saw if the machine will not be in use for several hours. Keeping tension on the blade could weaken the weld in the blade and may cause flat spots on the tires.



B1329 WOOD CUTTING BANDSAW Maintenance

Although woodworking machinery generally creates sawdust, ironically that same sawdust may be the cause of premature damage to the internal parts of the machine.

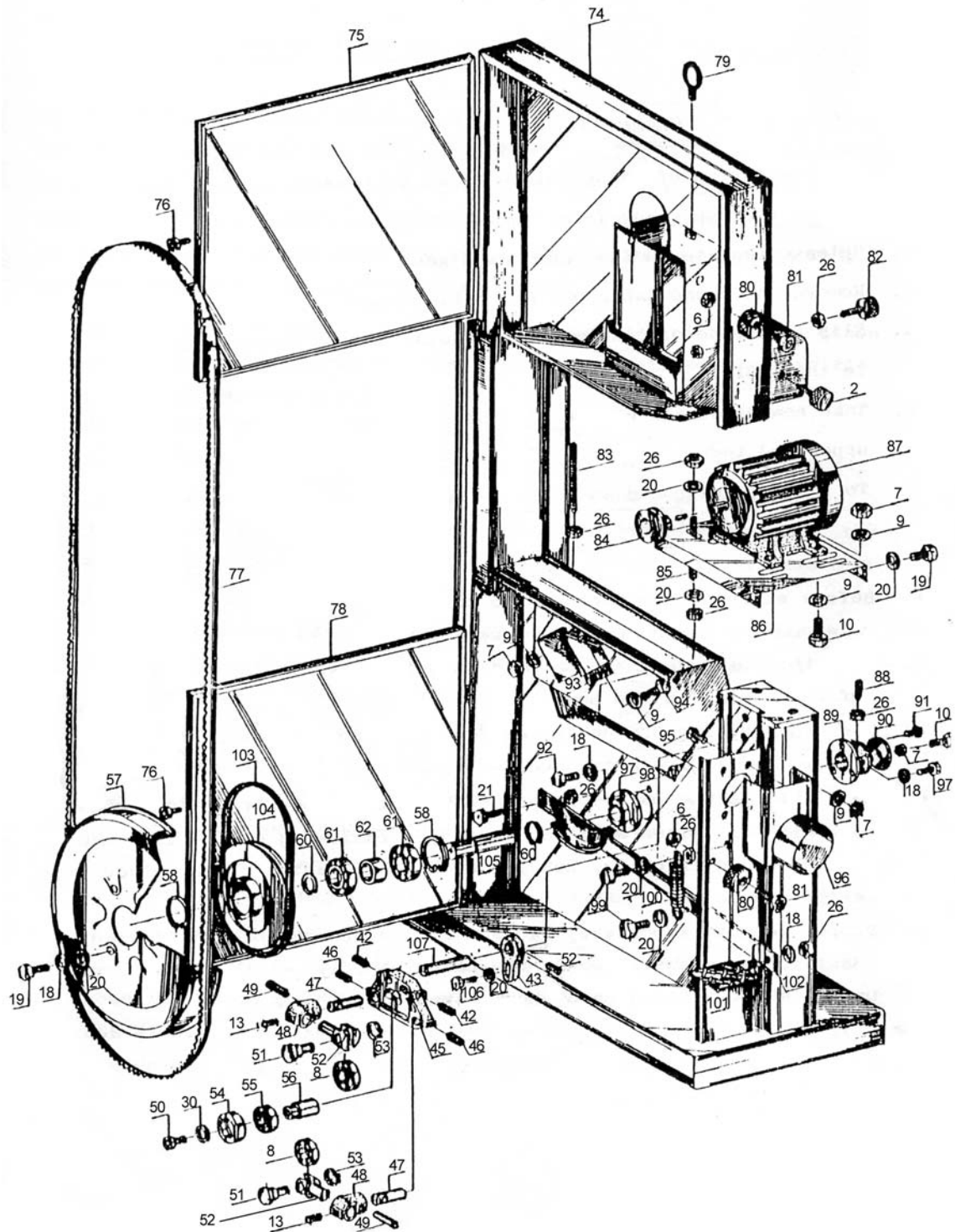
The best way of preventing this is to set up a routine maintenance program of your machinery.

To keep your B1329 20" Wood Cutting Bandsaw in top operating condition, routinely check or clean the following:

Disconnect the tool from the power source before performing the following maintenance.

- ❑ Check blade(s) for sharpness.
- ❑ Check guide blocks, bearings and rear bearing wheels for alignment.
- ❑ Lubricate guide bearings and rear bearing wheels with light oil.
- ❑ Check upper and lower tires for flat spots.
- ❑ Check blade for vertical alignment to table.
- ❑ Check wheels for alignment.
- ❑ Check lower tire brush and adjust.
- ❑ Vacuum upper and lower wheel housings and clean tires.
- ❑ Vacuum motor openings.
- ❑ Check 'V' belt for excessive wear.

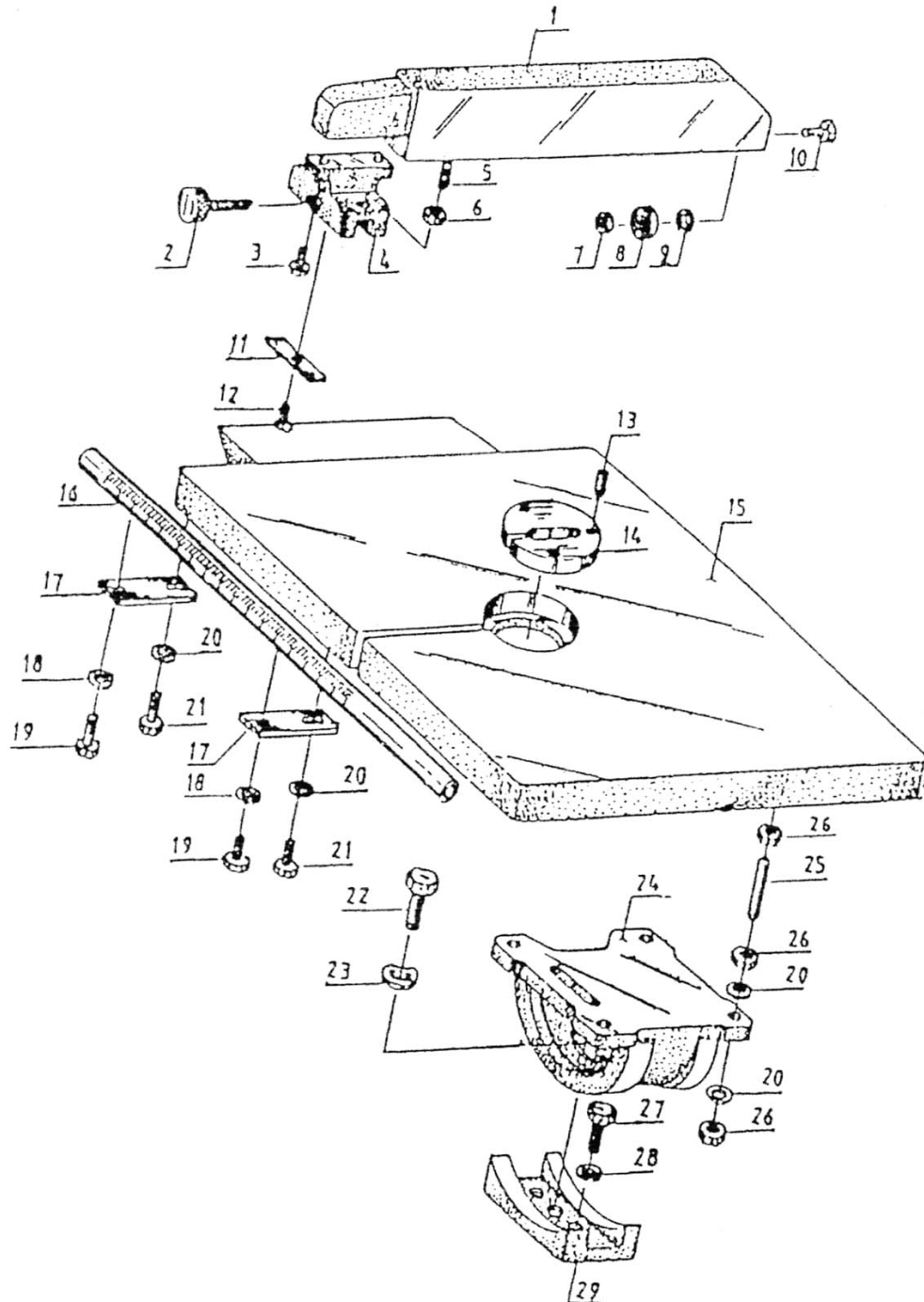
B1329 WOOD CUTTING BANDSAW Cabinet Assembly Schematic Drawing



B1329 WOOD CUTTING BANDSAW Cabinet Assembly Parts List

No.	Description	Qty	Remarks
74	Base	1	
75	Upper Wheel Cover	1	
76	Socket Screw	2	1/4 x 20 x 3/8
77	Blade	1	
78	Lower Wheel Guard	1	
79	Saw Ring	1	
80	Wheel Cover Lock Nut	2	
81	Socket Screw	2	1/4 x 20 x 1
82	Lock Screw	1	3/8 x 16 x 2 1/2
83	Support Rod	1	
84	Motor Drive Pulley	1	
85	Motor Adjusting Screw	1	
86	Motor Plate	1	
87	Motor	1	
88	Screw	4	3/8 x 16 x 1
89	Adjust. End Cap	1	
90	End Cap	1	
91	Round-Head Screw	3	3/16 x 24 x 1/2
92	Hex Screw	6	3/8 x 24 x 1
93	Dust Clearing Brush	1	
94	Hex Screw	1	5/16 x 18 x 1 1/4
95	Hex Screw	4	5/16 x 18 x 3/4
96	Dust Collector	1	
97	Support End Cap	1	
98	Motor Base Shaft	1	
99	Hex Screw	1	3/8 x 16 x 1/2
100	Brake Spring	1	
101	Foot Brake	1	
102	Brake Rod	1	
103	Belt	1	A-42
104	Belt Wheel Driver	1	
105	Driver Shaft	1	
106	Hex Screw	1	3/8 x 16 x 1 1/4
107	Thrust Stop Base Shaft	1	

B1329 WOOD CUTTING BANDSAW Fence & Table Schematic Drawing



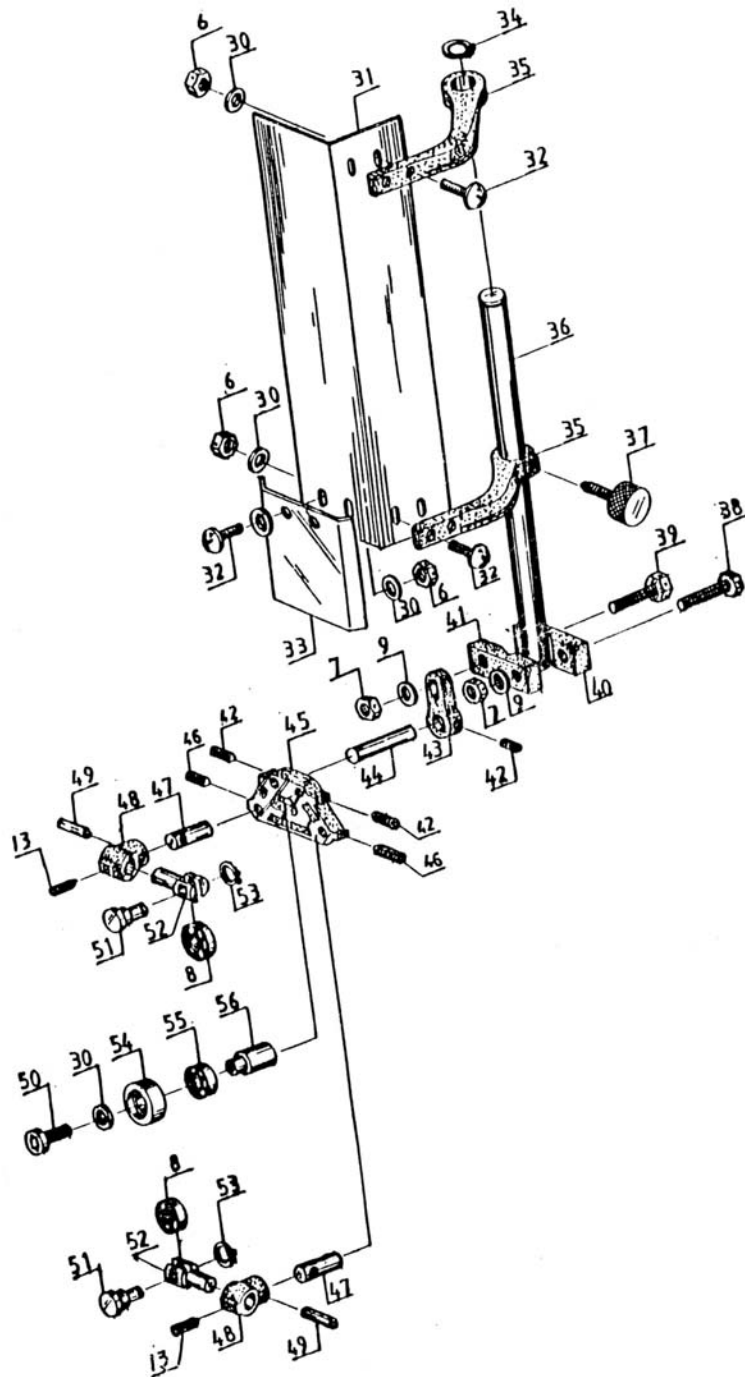
B1329 WOOD CUTTING BANDSAW

Fence & Table Parts List

Part No	Description	Qty	Remarks
1	Rip Fence	1	
2	Screw	2	3/8" – 16x1 1/4
3	Socket Screw	2	3/8" – 16 x 1"
4	Fence guide Bar base	1	
5	Screw	2	1/4 –20x5/8"
6	Hex Nut	10	1/4 x20
7	Hex Nut	13	5/16 x20
8	Bearing	5	608ZZ
9	Washer	17	5/16"
10	Hex Screw	6	5/16 x 18 x 1"
11	Fence Block Bracket	1	
12	Square Screw	1	1/4"x 20x1/2"
13	Screw	7	1/4x20x1/2"
14	Blade Guide	1	
15	Saw Table	1	
16	Front Guide Rail	1	
17	Rear Guide Rail & Support Plate	2	
18	Spring Washer	15	3/8"
19	Hex Screw	9	3/8x16x3/4"
20	Washer	24	3/8"
21	Hex Screw	3	3/8x16x1"
22	Hex Screw	1	5/8x11x1 1/2"
23	Washer	1	
24	Table Support Bracket	1	
25	Table Adjustment Screw	4	
26	Hex Nut	27	3/8"x16
27	Hex Screw	2	1/2x12x1 1/2"
28	Washer	2	1/2:"
29	Table Base	1	

B1329 WOOD CUTTING BANDSAW

Blade Guard Schematic Drawing

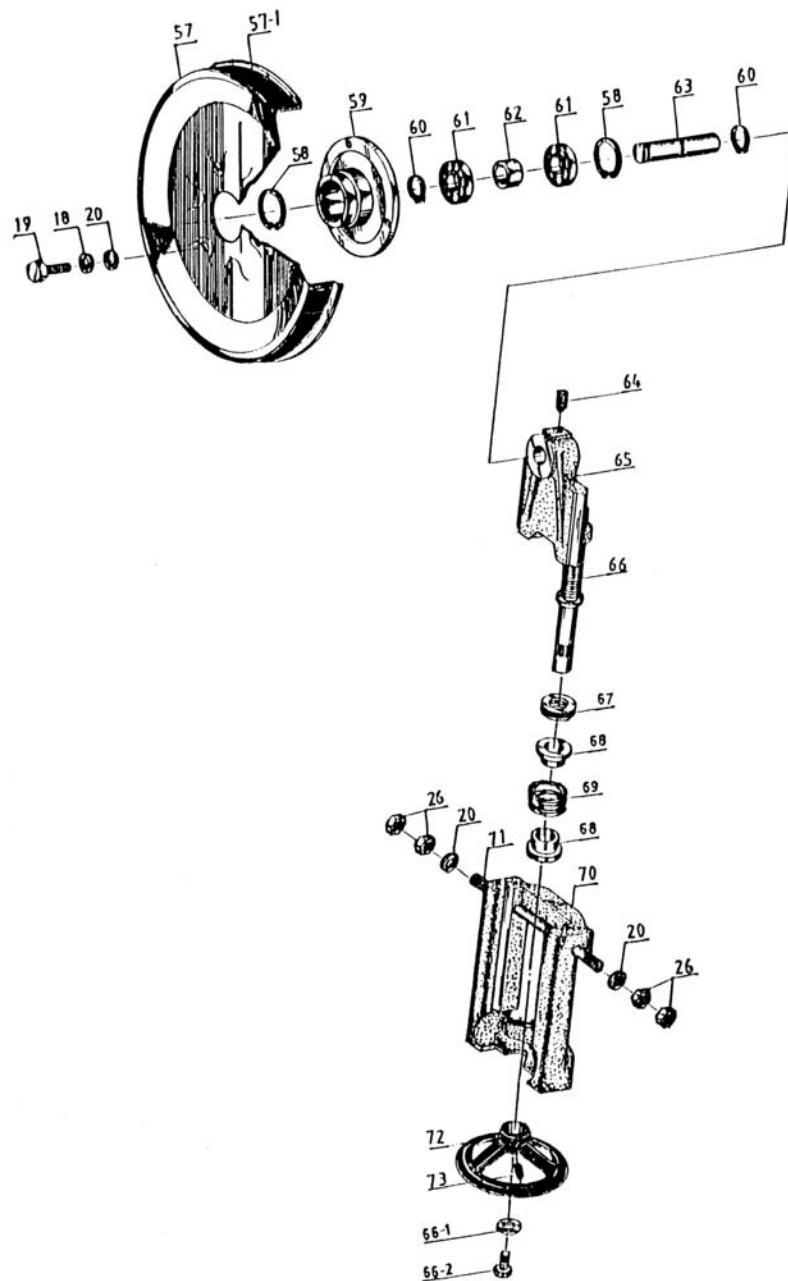


B1329 WOOD CUTTING BANDSAW

Blade Guard and Upper Blade Guide Parts List

Part No.	Description	Qty.	Remarks
30	Washer	10	1/4"
31	Cover (Blade Guard)	1	
32	Round Head Screw	6	1/4x20x3/4"
33	Acrylic Guard Plate	1	
34	'C' Ring	1	S-25
35	Blade Guard Rocker Arm	2	
36	Blade Guard Adjustable Rod	1	
37	Lock Screw	1	5/16x18x13/16"
38	Hex Screw	1	5/16x18x3"
39	Hex Screw	1	5/16x18x3"
40	Support Rod Clamping Block	1	
41	Support Rod Clamping Block	1	
42	Screw	6	1/4x20x5/8"
43	Adjusting Crank	2	
44	Thrust Stop Base	1	
45	Thrust Stop Adjust. Base	2	
46	Screw	4	1/4x20x3/8"
47	Adjustable Crank Shaft	4	
48	Thrust Adjust. Crank	4	
49	Roll Pin	4	4"
50	Socket Screw	2	1/4x20x3/8"
51	Guide Wheel	4	
52	Thrust Adjust Shaft	4	
53	Retainer Ring	4	
54	Blade Thrust Wheel	2	
55	Thrust Block or Bearing Block	2	6201ZZ
56	Wheel Thrust	2	

B1329 WOOD CUTTING BANDSAW Upper Wheel Assembly Schematic Drawing



B1329 WOOD CUTTING BANDSAW

Upper Wheel Assembly Parts List

Part No.	Description	Qty	Remarks
57	Blade Wheel	2	
57-1	Tire	2	
58	Retainer Ring	4	R-62
59	Wheel Follower Round Plate	1	
60	Retainer Ring	4	S-30
61	Wheel Shaft	4	6206-Z
62	Spacer	2	
63	Follower Wheel Shaft	1	
64	Screw	1	1/2 x 12 x 3/4
65	Up/Down Slide Crank	1	
66	Up/Down Crank Gear Shaft	1	
66-1	Washer	1	5/16
66-2	Hex Screw	1	5/16 x 18 x 1/2
67	Bearing	1	2904
68	Spring Bushing	2	
69	Spring	1	
70	Slide Base	1	
71	Slide Base Support Rod	1	
72	Hand Wheel	1	
73	Screw	1	5/16 x 18 x 1/2



WARRANTY

CRAFTEX 2 YEAR LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **two years** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.

Proof of purchase is necessary.

All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.

This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etceteras. Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom. Craftex is a brand of equipment that is exclusive to Busy Bee Tools. For replacement parts directly from Busy Bee Tools, for this machine, please call 1-800-461-BUSY(2879), and have your credit card and part number handy.

- All returned merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.
- Returns must be pre-authorized by us in writing.
- **We do not accept collect shipments.**
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse (see locations on inside back cover of this manual).
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labour.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.
- For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repairs.



BUSY BEE TOOLS - - - SHOWROOMS -Coast to Coast

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We have been serving the Canadian woodworking and metalworking industry for over 26 proud years. We stand behind our machines. If you have any questions, comments, or concerns, please call or write to our head office or call toll free at 1-800-461-BUSY.

Email us at busybee@busybeetools.com or contact us through our web site at

busybeetools.com

