



## OWNER'S MANUAL



### B2544 - SWIVEL METAL CUTTING BANDSAW



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# INDEX

<b>GENERAL SAFETY INSTRUCTIONS</b>	<b>Page 3</b>
Specific Safety Instructions	Page 4
Specifications	Page 5
Assembly	
Pulley Guard Assembly	Page 6
Work Stop Assembly	Page 6
Blade Guide Assembly	Page 7
Blade Guide Bearing Adjustment	Page 7
Adjusting Blade Tension	Page 8
Changing Speeds	Page 8
Blade Selection	Page 9
Changing the Blade	Page 9
Adjusting Blade Tracking	Page 10
Adjusting Blade Angle	Page 11
Horizontal Cutting	Page 11
Vertical Cutting	Page 12
Maintenance	Page 13
Trouble Shooting	Page 14
Wiring Diagram	Page 15
Parts List	Page 16
Schematic Diagram	Page 17
Warranty	Page 18

## **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.
- ❑ **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.

## **B2544 – SWIVEL METAL CUTTING BANDSAW SPECIFIC SAFETY INSTRUCTIONS**

- ❑ Know your bandsaw. Read this manual carefully. Learn the operation, applications and limitations.
- ❑ Do not overreach or stand on the machine
- ❑ Avoid a dangerous environment. Don't use the bandsaw in damp or wet locations.
- ❑ Keep your work area clean. Cluttered and slippery floors invite accidents.
- ❑ Remove adjusting keys and wrenches from the bandsaw before turning the power on.
- ❑ Don't force the bandsaw. It is only safe to operate at the cutting rate at which it was designed for.
- ❑ Be especially careful in when using bandsaws in the vertical position. Keep your fingers and hands out of the path of the blade, both above and beneath the blade.
- ❑ During the horizontal position, never hold the material in your hand. Always use a vise and have your work clamped down.
- ❑ Keep all guards and covers in working order and use them at all times
- ❑ Disconnect the power lead before adjusting, servicing or changing the blade
- ❑ Use a sharp blade and keep the bandsaw clean for best results.
- ❑ Most importantly, always wear eye protection (goggles)

## B2544 – SWIVEL METAL CUTTING BANDSAW

As part of the growing line of **Craftex** Metalworking Equipment, we are proud to offer the B2544 Swivel Metal Cutting Bandsaw. 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 B2544 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

### Specifications

Motor: 1 / 2 HP, 110V, 60 HZ, 1700 RPM

Cutting Capacity @ 90°: Round – 100mm (4")  
Flat – 110 x 100mm (4 ¼" x 4")

Cutting Capacity @ 45°: Round – 75mm (3")  
Flat – 100 x 75mm (4" x 3")

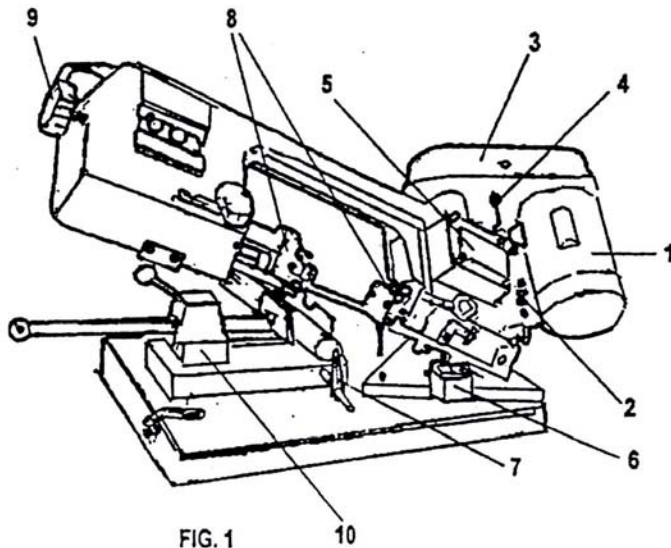
Blade Length: 1 / 2" x 0.03" x 64.5"

Blade Speeds: 20, 29, 50 m/min (65, 95, 164 f/min)

Weight: 80 kg

2 Year Warranty

## B2544 – SWIVEL METAL CUTTING BANDSAW ASSEMBLY



Item	Description
1	Motor assembly
2	Belt Adjusting bolt
3	Pulley Guard
4	Micro-Switch cable and Grommet
5	Gearbox
6	Main On/Off Switch
7	Work Stop Assembly
8	Blade Guide
9	Blade Tension adjusting knob
10	Speed Lock Vice

### PULLEY GUARD ASSEMBLY

The pulley guard (Figure 1, item 3) sits over two shafts, one from the motor (Figure 1, item 1), the other from the gearbox (Figure 1, item 5). The gearbox shaft extends through a circular plate secured by three screws. It is necessary to remove the uppermost of these screws before mounting the pulley cover. Having done so, lower the pulley cover over the shafts, ensuring the elongated hole is over the motor shaft.

Replace the screw removed earlier through the pulley cover, into its hole in the circular plate. (This screw now locates and secures the pulley cover at the gearbox shaft)

### WORK STOP ASSEMBLY

A work stop (Figure 1, item 7) is provided. This is used to allow stock pieces of equal length to be cut without having to measure each piece individually. It comprises of two parts, the work stop and the mounting rod.

Push the rod into the hole in the edge of the vise and secure with the grub screw provided.

Mount the work stop into the rod, with the flat face towards the saw table and temporarily secure with the grub screw provided. Ensure it is not pushed too far, as it may interfere with the saw blade when it is lowered.

# **B2544 – SWIVEL METAL CUTTING BANDSAW**

## **BLADE GUIDE ASSEMBLY**

Your B2544 is equipped with two adjustable blade guide assemblies (Figure 1, item 8). This feature will permit you to adjust the position of the blade guides for various widths of work pieces.

It should be adjusted to just clear the piece to be cut. This is done as follows:

1. Place the work piece in the vise and clamp tightly
2. Adjust the blade guide assembly to the desired position by loosening the hand knobs and positioning the guides as required.
3. Tighten the hand knobs

## **BLADE GUIDE BEARING ADJUSTMENT**

This is the most important adjustment on your saw. It is impossible to get satisfactory work from your saw if the blade guides are not properly adjusted. The blade guide bearings for your B2544 are adjusted and power tested with several test cuts before leaving the factory to ensure proper setting. The need for adjustment should rarely occur when the saw is properly used. If the guides do get out of adjustment, it is extremely important to readjust the saw immediately. If proper adjustment is not maintained, the blade will not cut straight and if the situation is not corrected, it will cause blade damage.

Because guide adjustment is a critical factor in the performance of your saw, it is always best to try a new blade to see if this will correct the poor cutting. If the blade becomes dull on one side sooner than the other, it will begin cutting crooked. A simple blade change should correct the problem – the more difficult guide adjustment will not.

If a new blade does not correct the problem, check the blade guides for proper spacing. There should be a 0.001" clearance between the 0.025" thickness blade and the guide bearings. To obtain this clearance, adjust as follows (see Figure 4, step 7 – Page 10)

1. The inner guide bearing is fixed and cant be adjusted
2. The outer guide bearing is mounted to an eccentric and can be adjusted.
3. Loosen the nut while holding the bolt with a wrench.
4. Position the eccentric by turning the bolt to the desired position of clearance.
5. Tighten the nut
6. Adjust the second blade guide bearing in the same manner.
7. The back edge of the blade should just touch the lip of the Blade Guide Bearing

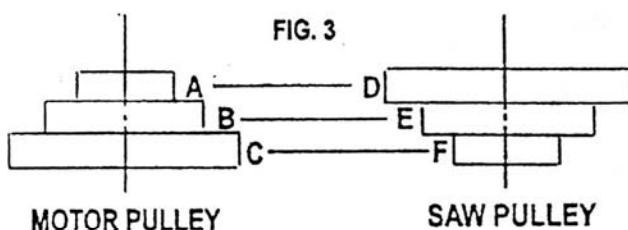
## B2544 – SWIVEL METAL CUTTING BANDSAW

### ADJUSTING BLADE TENSION

1. Make sure the motor is switched off and the machine is completely disconnected from the power source
2. Press the blade lightly with your left hand so the rear of the blade touches the flange of the blade wheel and adjust the blade using the tension-adjusting knob (Figure 1, item 9) with your right hand until no blade slipping occurs.

### CHANGING SPEEDS

When using your bandsaw always change the speed to best suit the material being cut. The material cutting chart is shown in Figure 3.



Material	Speed ( m/min)		Belt Groove Used	
	50Hz	60Hz	Motor pulley	Saw Pulley
Stainless or Alloy Steel, Bearing Bronzes	20	24	Small A	Large D
Mild Steel, Hard brass or Bronze	29	36	Medium B	Medium E
Soft Brass, Aluminum and other materials	50	61	Large C	Small F

1. **Disconnect the power.** Open the pulley guard cover. Loosen the belt adjusting bolt (Figure 1, item #2) You are now able to change the position of the belt to gain the desired speed. Re-set the belt tension to allow ½" depression of the belt when pressed in the middle of its longest run.
2. When the tension of the belt is correctly adjusted, lock the motor firmly.
3. Close the pulley guard cover



# B2544 – SWIVEL METAL CUTTING BANDSAW

## BLADE SELECTION

1. **Special note:** A 1 / 2" x 0.03" x 64.5" 14 TPI general use blade is supplied with the metal cutting bandsaw.
2. The choice of blade pitch is governed by the thickness of the work to be cut; *The thinner the workpiece, the more teeth is advised.* A minimum of 3 teeth should be in the work piece at all times for proper cutting
3. If the teeth of the blade are so far apart that they straddle the work, severe damage to the work piece and to the blade can result.

## CHANGING THE BLADE

**(WARNING:** *Always disconnect the power from your bandsaw before changing the blade*)

Raise the saw head to the vertical position. Loosen the blade tension adjusting knob (Figure 1, item 9) sufficiently to allow the saw blade to slip off the wheels. Install the new blade as follows

1. Place the blade between each of the guide bearings.
2. Slip the blade around the motor pulley (bottom) with the left hand and hold it in position.
3. Hold the blade against the motor pulley by pulling the blade upward with your right hand, which is placed at the top of the blade.
4. Remove your left hand from the bottom pulley and place it at the topside of the blade to continue the application on the upward pull of the blade.
5. Remove your right hand from the blade and adjust the position of the top pulley to permit your left hand to slip the blade around the pulley using the thumb, index and little finger as guides.
6. Adjust the blade tension clockwise until it is just right. So no blade slippage occurs. Don't tighten excessively
7. Place 2-3 drops of oil on the blade
8. Replace the blade guard.

## B2544 – SWIVEL METAL CUTTING BANDSAW

### ADJUSTING BLADE TRACKING

This adjustment has been completed and power-tested at the factory. In the case when you would adjust your blade tracking, follow the procedure listed below (Figure 4, steps 1-5)

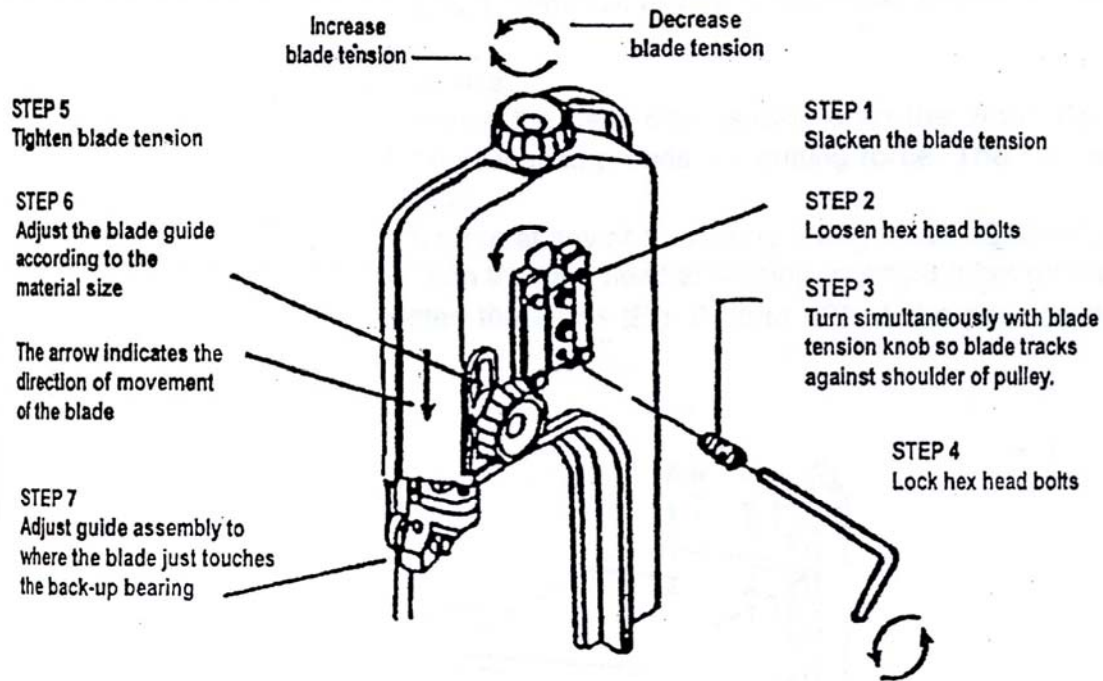


FIG.4 Adjusting The Blade Tracking

### AUTO SWITCH OFF

At the end of the cutting cycle (horizontal use), the machine automatically switches off. This can be adjusted by moving the bracket (item 76) up or down as required.

## B2544 – SWIVEL METAL CUTTING BANDSAW

### ADJUSTING BLADE ANGLE

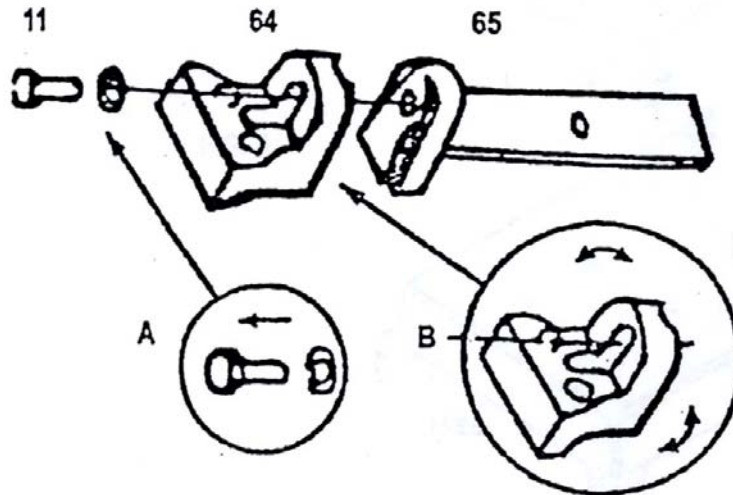


FIG. 5 ADJUSTING BLADE ANGLE

When cutting the horizontal position, the blade must be at right angle (or vertical) to the bed. To achieve this, (Refer to Figure 5)

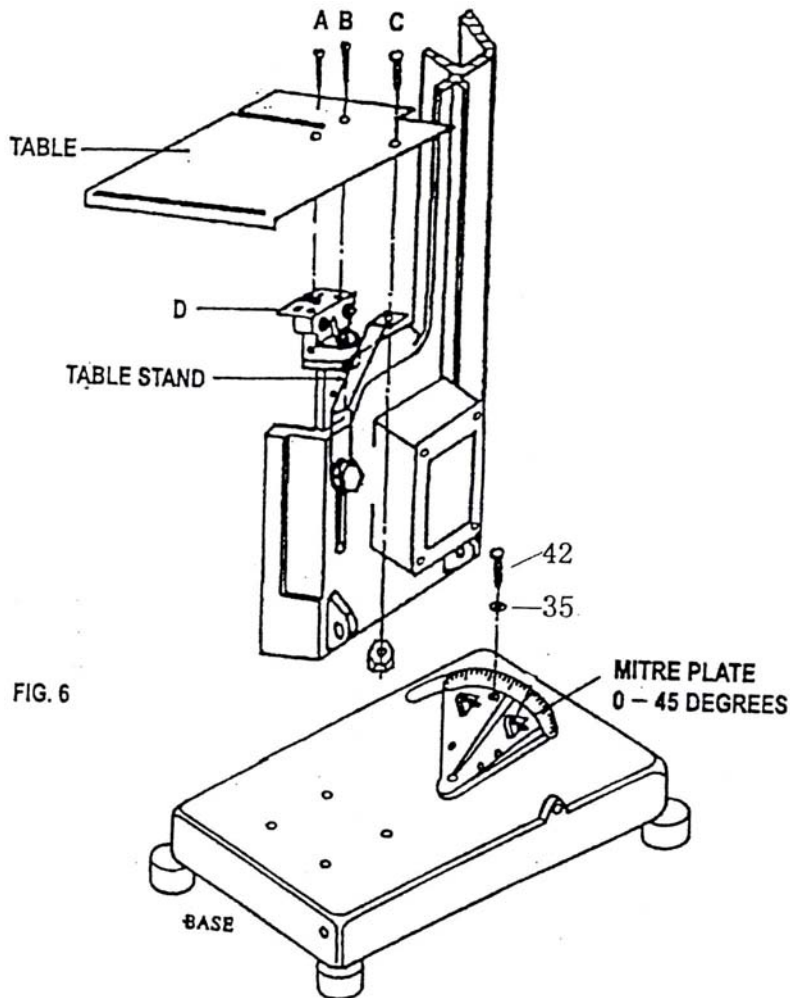
- A. Loosen the screw (11)
- B. Adjust the blade guide (64) to make the blade vertical to the bed
- C. Place a square on the bed to check if the blade is vertical, if not, repeat the process A to C
- D. Tighten the screw (11)

### HORIZONTAL CUTTING

1. Raise the saw head to the vertical position
2. Open the speed lock vise (Figure 1, item 10) and place the work piece in it. If the piece is long, support the end.
3. Clamp the work piece in the vise.
4. Switch the machine on, letting the head down slowly onto the work. Do not drop or force. Let the weight of the saw head provide the cutting force. The saw automatically shuts off at the end of the cut.
5. To cut the workpiece at any angle between 0 and 45 degrees, loosen the screws (Figure 6, item 42), turn the saw head according to the angle label on the miter plate. (Parts list, item W7), tighten the screws (Figure 6, item 42) at the desired position then repeat steps 1 to 4

# B2544 – SWIVEL METAL CUTTING BANDSAW

## VERTICAL CUTTING



To use the saw in the vertical position, the table must be fitted and the main saw body locked in the vertical position.

Fitting the table (see Figure 6)

1. Loosen the screws (A & B) from the blade guide. Then take away the plate D, and assemble the table stand according to the above pictures in Figure 6.
2. Place the table on the lower blade guide, then lock the table and connect it with the table stand by fully tightening the screws A, B and C.

Now, locking the saw in the vertical position, rotate the bracket (Parts list, item 18) to an upright position, locate in the notch on the saw arm and tighten.

## B2544 – SWIVEL METAL CUTTING BANDSAW

If you have difficulty in locating this bracket in the notch, adjust a nearby screw at the bottom of the saw until the bracket locates, then tighten the bracket.

**CAUTION:** always use push stick, especially when cutting small piece.

### LUBRICATION:

Lubricate the following components using EP80 oil

1. Ball bearings
2. Blade guide bearings
3. Drive wheel bearings
4. The drive gears that run in the oil bath will not require a lubricant change more often than once a year. When a change is required, place the head of the bandsaw in the horizontal position, then loosen the 4 screws of the gear box, open the cove (Figure 1, item 6). Placing a pan under the right lower corner of the gearbox, slowly raise the head until the oil flows out, then lower the head. Wipe the excess oil and foreign matter with a shop rag. Add the lubricant until the box is full. Close the cover and tighten the 4 screws.



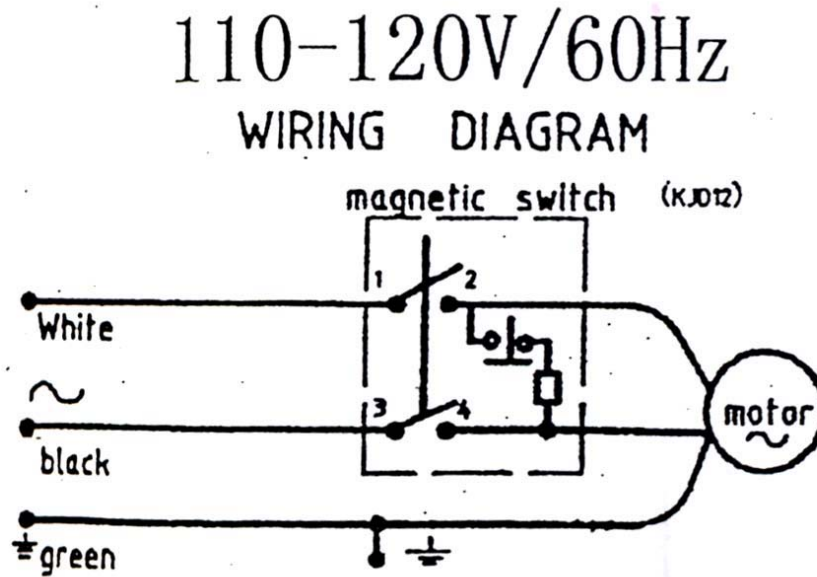
## B2544 – SWIVEL METAL CUTTING BANDSAW

### TROUBLE SHOOTING

Symptom	Possible Cause(s)	Corrective Action
Excessive Blade Breakage	<ol style="list-style-type: none"> <li>1. Material loose in vice</li> <li>2. Incorrect speed or feed.</li> <li>3. Blade teeth spacing too large.</li> <li>4. Material too hard.</li> <li>5. Incorrect blade tension.</li> <li>6. Teeth in contact with material before saw is started.</li> <li>7. Blade rubs on wheel flange.</li> <li>8. Misaligned guide bearings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clamp work securely.</li> <li>2. Adjust speed or feed.</li> <li>3. Replace with a finer tooth blade.</li> <li>4. Use a slower speed and finer tooth blade.</li> <li>5. Adjust to where blade just does not slip on wheel.</li> <li>6. Place blade in contact with work after motor is started.</li> <li>7. Adjust wheel alignment.</li> <li>8. Adjust guide bearings.</li> </ol>
Premature Blade Dulling.	<ol style="list-style-type: none"> <li>1. Teeth too coarse.</li> <li>2. Too much speed.</li> <li>3. Incorrect speed or feed.</li> <li>4. Hard spots or scale on material.</li> <li>5. Work hardening of material.</li> <li>6. Blade twist.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use finer teeth.</li> <li>2. Decrease speed.</li> <li>3. Decrease spring tension on side of saw.</li> <li>4. Reduce speed, increase feed pressure.</li> <li>5. Increase feed pressure by reducing spring tension.</li> <li>6. Replace with a new blade, and adjust blade tension.</li> </ol>
Unusual Wear on Side/Back of blade	<ol style="list-style-type: none"> <li>1. Blade guides worn.</li> <li>2. Blade guide bearings not adjusted properly.</li> <li>3. Blade guide bearing bracket is loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace.</li> <li>2. Adjust as per operator's manual.</li> <li>3. Tighten.</li> </ol>
Teeth Ripping from blade.	<ol style="list-style-type: none"> <li>1. Teeth too coarse for work.</li> <li>2. Too heavy too slow speed.</li> <li>3. Vibrating work piece.</li> <li>4. Teeth clogging.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use finer tooth blade.</li> <li>2. Decrease pressure. Increase speed.</li> <li>3. Clamp work piece securely.</li> <li>4. Use coarser tooth blade or brush to remove chips.</li> </ol>
Motor running too hot.	<ol style="list-style-type: none"> <li>1. Blade tension too high</li> <li>2. Drive belt tension too high.</li> <li>3. Gears need lubrication.</li> <li>4. Cut is binding blade.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce tension on blade.</li> <li>2. Decrease pressure, increase speed.</li> <li>3. Clamp work piece securely.</li> <li>4. Use coarser tooth blade or brush to remove chips.</li> </ol>
Bad Cuts (cutting not square)	<ol style="list-style-type: none"> <li>1. Feed pressure too great.</li> <li>2. Guide bearings not adjusted properly.</li> <li>3. Inadequate blade tension.</li> <li>4. Dull blade.</li> <li>5. Speed incorrect.</li> <li>6. Blade guides spaced out too much.</li> <li>7. Blade guide assembly loose.</li> <li>8. Blade track too far away from wheel flanges.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce pressure by increasing spring tension on side of saw.</li> <li>2. Adjust guide bearing. The clearance cannot be greater than .001 inch.</li> <li>3. Increase blade tension by adjust blade tension.</li> <li>4. Replace blade.</li> <li>5. Adjust guides space.</li> <li>6. Adjust guides space.</li> <li>7. Tighten.</li> <li>8. Retrace blade according to operating instructions.</li> </ol>
Bad Cuts (Rough).	<ol style="list-style-type: none"> <li>1. Too much speed or feed.</li> <li>2. Blade is too coarse.</li> <li>3. Blade tension loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease speed or feed.</li> <li>2. Replace with finer blade.</li> <li>3. Adjust blade tension.</li> </ol>
Blade is twisting.	<ol style="list-style-type: none"> <li>1. Cut is binding blade.</li> <li>2. Too much blade tension.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease feed pressure.</li> <li>2. Decrease blade tension.</li> </ol>

## B2544 – SWIVEL METAL CUTTING BANDSAW

### WIRING DIAGRAM



# PARTS LIST

Item	Description	Qty
V1	Screw	1
2	Hex. Nut	3
V2	Spring	1
3	Washer	9
V4	Floor Stand	4
5	Wheel Assy	2
7f	Square Neck Bolt	32
V7	Miter Plate	1
V8	Net	1
11	Hex. Head Screw	17
11a	Spring Washer	6
12	Hex. Nut	18
16	Electric Cord	1
17	Pivoting Rod	1
17a	Washer	1
17b	Pin	1
18	Support Plate	1
19	Stock Stop	1
20	Hex. Skt Head Screw	6
21	Stock Stop Rod	1
23	Switch	1
23a	Switch Box	1
25	Hex. Nut	32
26	Switch Panel	1
31	Knob	1
V32	Rod	1
V32-1	Block Base	1
V32-2	Block Plate	1
V32-3	Spring	1
V33	Arometer Axle	1
V34	Movable Vise Plate	1
V34-1	Screw	1
V34-2	Screw	1
35	Washer	4
V36	Knob	1
V36-1	Axle	1
V37	Base	1
V38	Angle Pointer	1
V39	Scale	1
V40	Vise Base	1
V42	Screw	1
44	Electric Cord	1
48	Screw	16
48a	Washer	10
V49	Mitering Vise Plate	1
50	Hex. Head Screw	3
51	Washer	21
V51	Locking Chain	1
52	Hex. Head Screw	2
V54	Pivot	1
55	Vertical Cutting Plate	1
56	Vertical Cutting Plate Stand	
57	Adj. Bracket (Left)	1
58	Plum Screw	2
59	Blade Safety Cover	1
60	Thrust Washer	4
61	Bearing	6
62	Guide Pivot	4
63	Bearing Shaft Pin	2
64	Blade Adj. Seat	1
64a	Blade Adj. Seat (Left)	1
65	Adj. Bracket (Right)	1
66	Brg. Guide Lock Knob	2
67	Screw	4
68	Screw	3
69	Blade Guard	1
70	Hex. Nut	4
71	Blade Wheel (Front)	1
71a	Bear Spacer	1

Item	Description	Qty
72	Brg. Cover	1
72a	Brg. Cover (Front)	1
75	Hex. Head Screw	11
V76	Switch Cut Off Tip	1
77	Blade Wheel (Rear)	1
79	Bld Tension Adj. Knob	1
80	Spring	1
81	Body Frame	1
81a	Cover	1
83	Hex. Head Screw	4
84	Motor Mount Plate	1
84a	Eye Bolt	1
84b	Washer	1
84c	Hex. Head Screw	1
85	Motor	1
85a	Key	1
85b	Capacitor Box	1
85c	Capacitor	1
85d	Screw	2
85e	Washer	2
86	Motor Pulley	1
87	Ball Bearing	4
88	Bearing Bushing	1
89	Oil Seal	2
90	Trans. Wheel Shaft	1
90a	Key	2
91	Transmission Gear	1
91a	Spring Pin	2
92	Gear Box Gasket	1
93	Gear Box Cover	1
94	Worm Gear	1
96	Bearing Bushing	1
98	Thumb Screw	1
100	Screw	2
101	Worm Gear Pulley	1
103	Bld Tension Sliding Plate	1
104	Hex. Skt Head Screw	1
106	Sliding Plate Draw Blk	1
107	Blade Wheel Shaft	1
108	Shaft Block	1
109	Blade Tension Guides	2
110	Motor Pulley Cover	1
110a	Knob	1
110b	Screw	1
112	Belt	1
113	Blade	1
114	Washer	4
118	Thrust Washer	1
120	Spacer	1
122	Hex. Nut	1
126	Bushing	1
132	Blade Safe Guard	1
156	Ld Hd Cross Skt Screw	1
156a	Spring Washer	1
156b	Nut	1
157	Washer	1
V158	Bracket I	2
V159	Bracket II	2
V160	Bracket III	2
V169	Bracket IV	2
V170	Rubber Pad	4
171f	Cotter Pin	2
V176	Axle	1
178	Cover For Micro Sw. (Usedby Mir Sw.)	2
179	Cable Clamp (Usedby Mir Sw.)	1
180	Micro Switch (Usedby Mir Sw.)	2
180c	Nut (Usedby Mir Sw.)	4
180a	Screw (Usedby Mir Sw.)	4
180b	Washer (Usedby Mir Sw.)	4







## 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 or call 1-800-461-BUSY. 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
- 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.



