



## OWNERS MANUAL



**CT016N 16" 2-SPEED BAND SAW**



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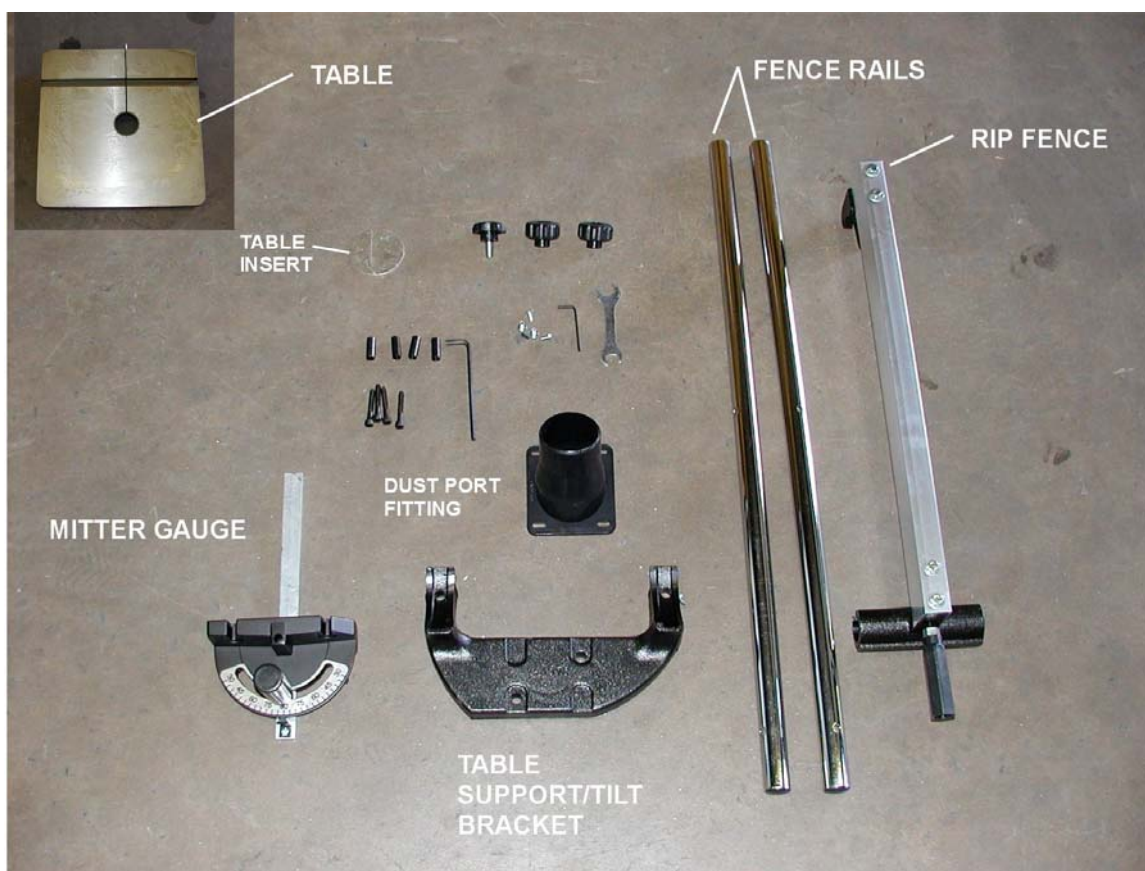
## GENERAL SAFETY INSTRUCTIONS

**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 this machine.
- ❑ **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, router bits, shaper heads, blades, knives or making other adjustments or repairs.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **NEVER** reach over the table when the tool is in operation.
- ❑ **NEVER** make crosscuts with the rip fence in place.
- ❑ **NEVER** attempt cut material that is warped or twisted.
- ❑ **NEVER** stand or lean on the tool.
- ❑ **DO NOT** force the tool – tools work best when allowed to perform @ own speed.
- ❑ **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.

## CT016N CARTON CONTENTS

Carefully remove all components from the shipping case and set to one side. The components in the carton and the case should be as those pictured below.

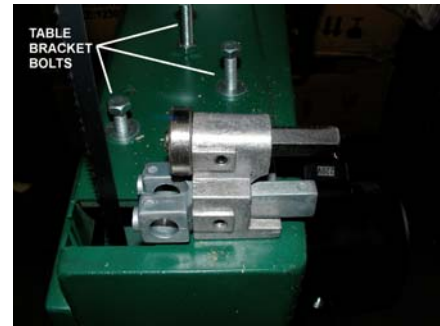


## CT016N ASSEMBLY

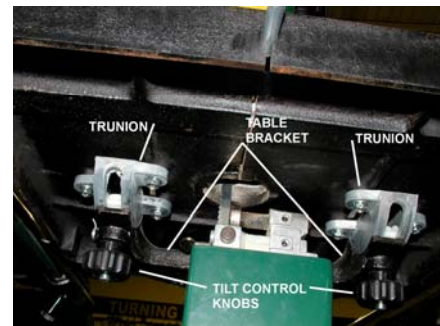
The CT016N is shipped pre-assembled except for a few minor components such as the cast-iron table and the rip-fence rails.

Remove all of the components and set aside for assembly. There are a number of components that have a protective lubricant on them and these should be cleaned before assembly. These may be cleaned with mineral spirits. After cleaning, a coat of paste wax should be applied to the band saw table top and then buffed dry.

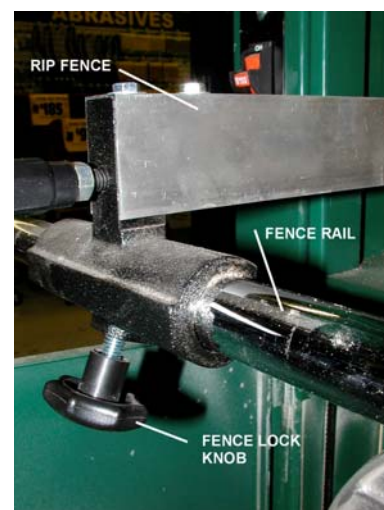
Install the table bracket to the saw frame with the bolts and washers provided.



Fit the table trunions (already installed under the saw table) into the table bracket and tighten with the locking knobs.



Install the rip-fence rails to the sides of the cast-iron saw table with the bolts provided and attach the fence to the rails.



## **CT016N OPERATION**

Your CT016N Band Saw is almost ready for use. There are only a few more steps to assure you of safe and accurate operation of the saw.

**Power** – Your CT016N must be connected to the correct electrical power source, 220-volt, single phase. This may be hard-wired into a separate, dedicated power box or by receptacle.

DO NOT CONNECT THE TOOL TO A POWER SOURCE AT THIS TIME, WAIT UNTIL ALL ADJUSTMENTS ARE COMPLETE.

Install the table insert using one of the small pins for an index.

Select the correct speed (2300 or 3200 feet per minute) by adjusting the V-belt to the appropriate pulleys.



### **Wheel Alignment**

Using the pre-installed band saw blade as an example, proceed to fine-tune the saw for precision cutting being certain that the tool is disconnected from the power source.

Rotate the upper wheel slowly by hand in a clockwise direction to determine if the blade is mounted precisely on the center of the tire. If this seems correct and the blade maintains this position after several rotations, proceed to **Blade Tensioning**.



## **CT016N OPERATION Continued**

### **Wheel Alignment Cont'd.**

If there is any deviation of the bandsaw blade on the upper wheel tire surface, adjust the wheel alignment (tracking) knob by rotating it slowly. You will note the change in the blade position as you simultaneously rotate the wheel and the alignment knob. Turn the alignment knob until the blade remains on the crest (center) of the rubber tire.



### **BLADE TENSIONING**

The blade on the CT016N must have enough tension on it to ensure straight tracking. The correct tension is more of an operator's feeling than an accurate measurement. The operator will soon learn the correct tension of the various sizes of blades being used. If the blade is too loose, it will tend to wander and will not track in a straight line. If the blade tension is too tight, the blade will 'squeeze' the rubber tires and force them out of round. Too much tension will stress the blades and cause frequent breakage.

The blade tensioning control is found on the extreme top of the CT016N. This is a quick release control and the lever should be lifted up when the saw is not in use. By making this a habit you will extend the life of the rubber tires and the wheel bearings.

By rotating the lever in the 'down' position you may increase or decrease the blade tension.



**When changing blades the quick release lever must be in the 'up' position.**

### **BLADE/TABLE ALIGNMENT**

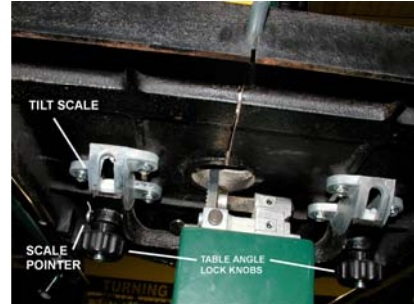
For best results the CT016N Band Saw blade must be properly aligned with the table. This is accomplished through the use of a square as illustrated.



## **CT016N OPERATION Continued**

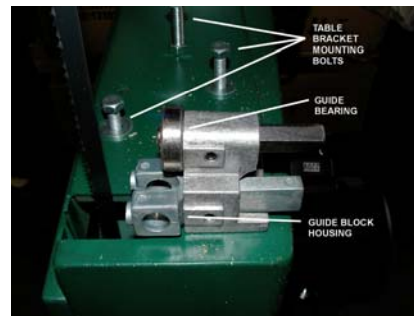
### **Blade/Table Alignment Cont'd.**

Loosen the table angle locking knobs and place the table in the horizontal position (the table has a positive stop at 0° and 45°) and set the pointer to the 0° mark. This will insure that all other scale markings are accurate.



### **BLADE GUIDES**

The blades on the CT016N like any professional tool, require guidance and this is accomplished through the upper and lower blade guides and rear guide bearing wheels. Without these, the blade would wander with the grain of the wood being the guide. Correctly adjusted the guide blocks and bearing wheels will keep the blade running straight.



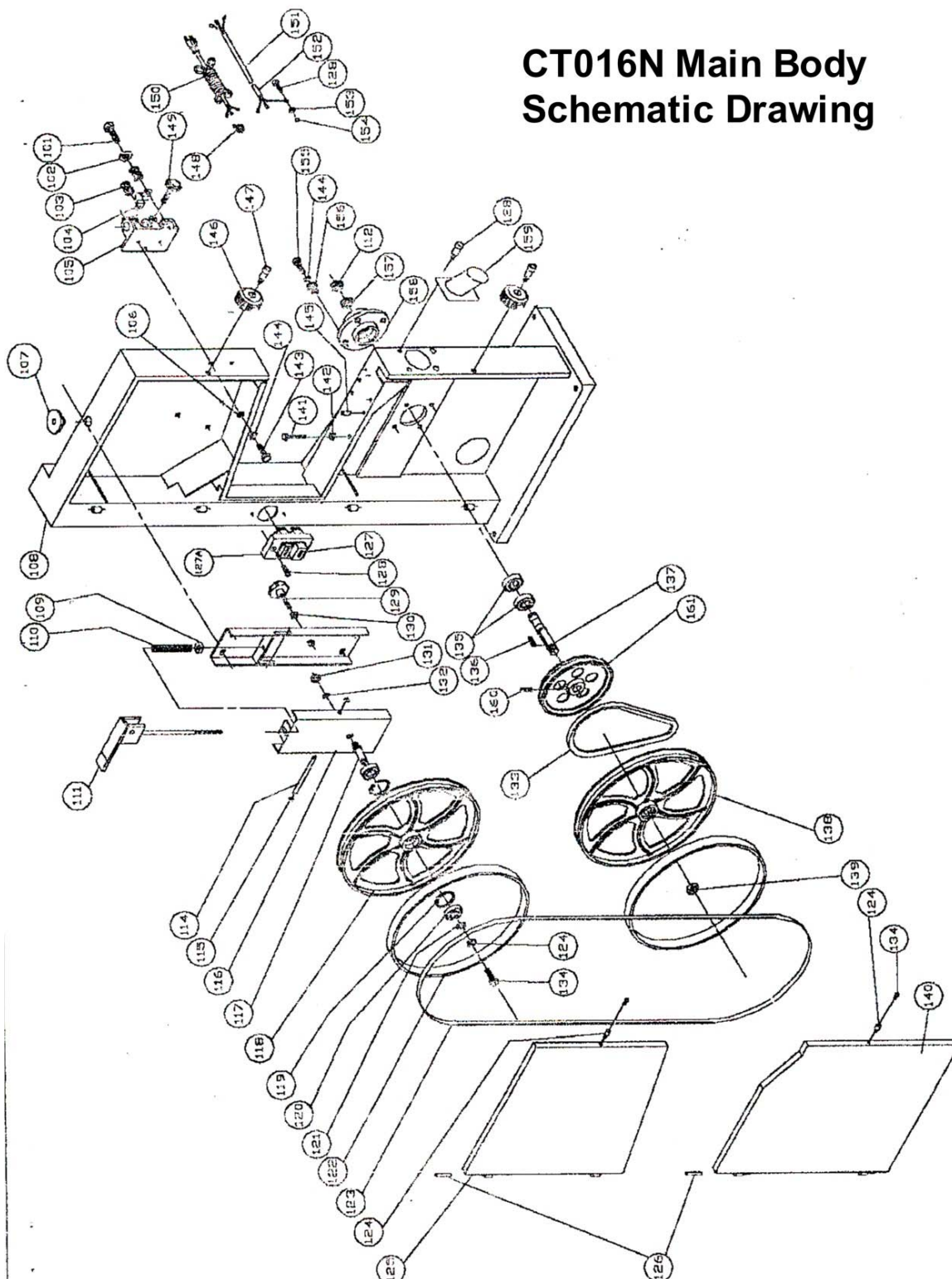
The rear bearing wheels should just touch the rear of the band saw blade. The blade guides should be set so that they are 'snug' on the blade but not so tight as to restrict vertical movement. The lateral position of the blade guides should be that the leading edge is just behind the gullet of the blade.

### **BLADE ADJUSTING**

The band saw blades that you install may require additional adjusting to provide you with a smoother operating band saw. The weld on the blade should be checked for rough spots. If any are found, they should be ground smooth.

With a blade installed and the saw running, carefully "round-off" the rear of the band saw blade with a grinding stone. This will allow smoother radius cuts with your saw.

## CT016N Main Body Schematic Drawing

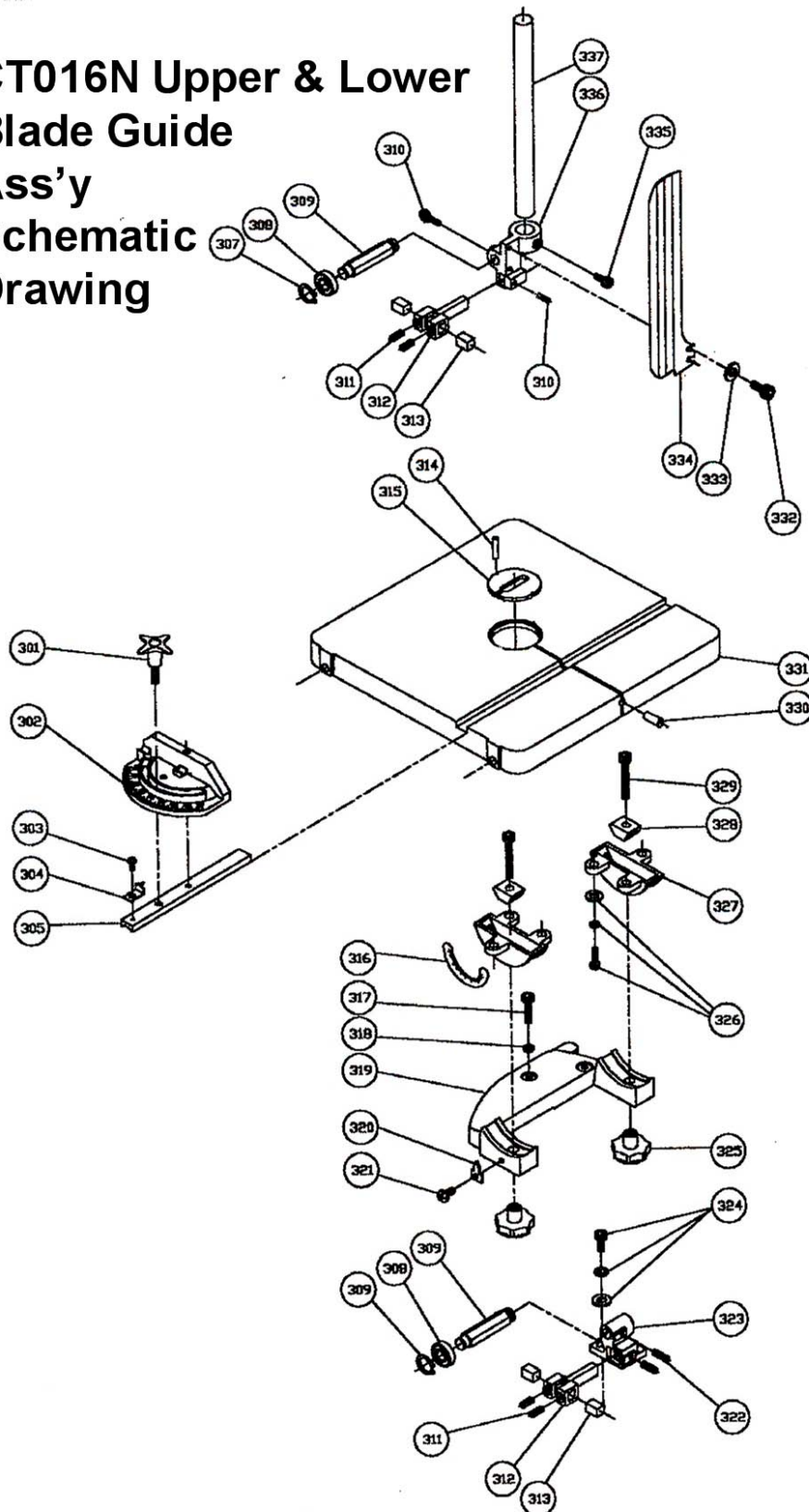


### CT016N MAIN BANDSAW PARTS LIST

Item	Description
101	Screw – 5/16"
102	Washer – 5/16"
103	Spring
104	Bracket
105	Bar Setting Plate
106	Washer – 5/16"
107	Special Washer
108	Body
109	Special Nut
110	Spring
111	Quick-Release Handle
112	Dust Cover
113	
114	Guide Rod
115	C-Ring
116	Upper Wheel Mount
117	Upper Wheel Shaft
118	Upper Wheel
119	C-Ring
120	Bearing (6202ZZ)
121	Washer 1/4"
122	Rubber Tire
123	Blade
124	Lock Washer 1/4"
125	Upper Wheel Guard
126	Pin
127	Switch
127a	Switch Plate
128	Screw 3/16" x 1/2"
129	Tracking Knob
130	Nut 5/16"
131	Nut 1/2"
132	Lock Washer 1/2"
133	V-Belt
134	Cap Screw 1/4" x 3/8"
135	Bearing 6204ZZ
136	Key 5 x 5 x 40mm
137	Shaft
138	Drive Wheel
139	Nut 3/8", LH Thread
140	Lower Wheel Guard
141	Screw 3/8" x 3"
142	Nut 3/8"
143	Screw 5/16" x 5/8"
144	Lock Washer 5/16"
145	Pin
146	Guard locking Knob
147	Special Screw

Item	Description
148	Strain Relief
149	Knob
150	Power Cord
151	Motor Side
152	Switch Side
153	Lock Washer 3/16"
154	Nut 3/16"
155	Screw 5/16 x 1 1/2"
156	Adjusting Screw
157	Nut 5/8"
158	Bearing Housing
159	Adapter
160	Set Screw 1/4" x1/4
161	Idler Pulley

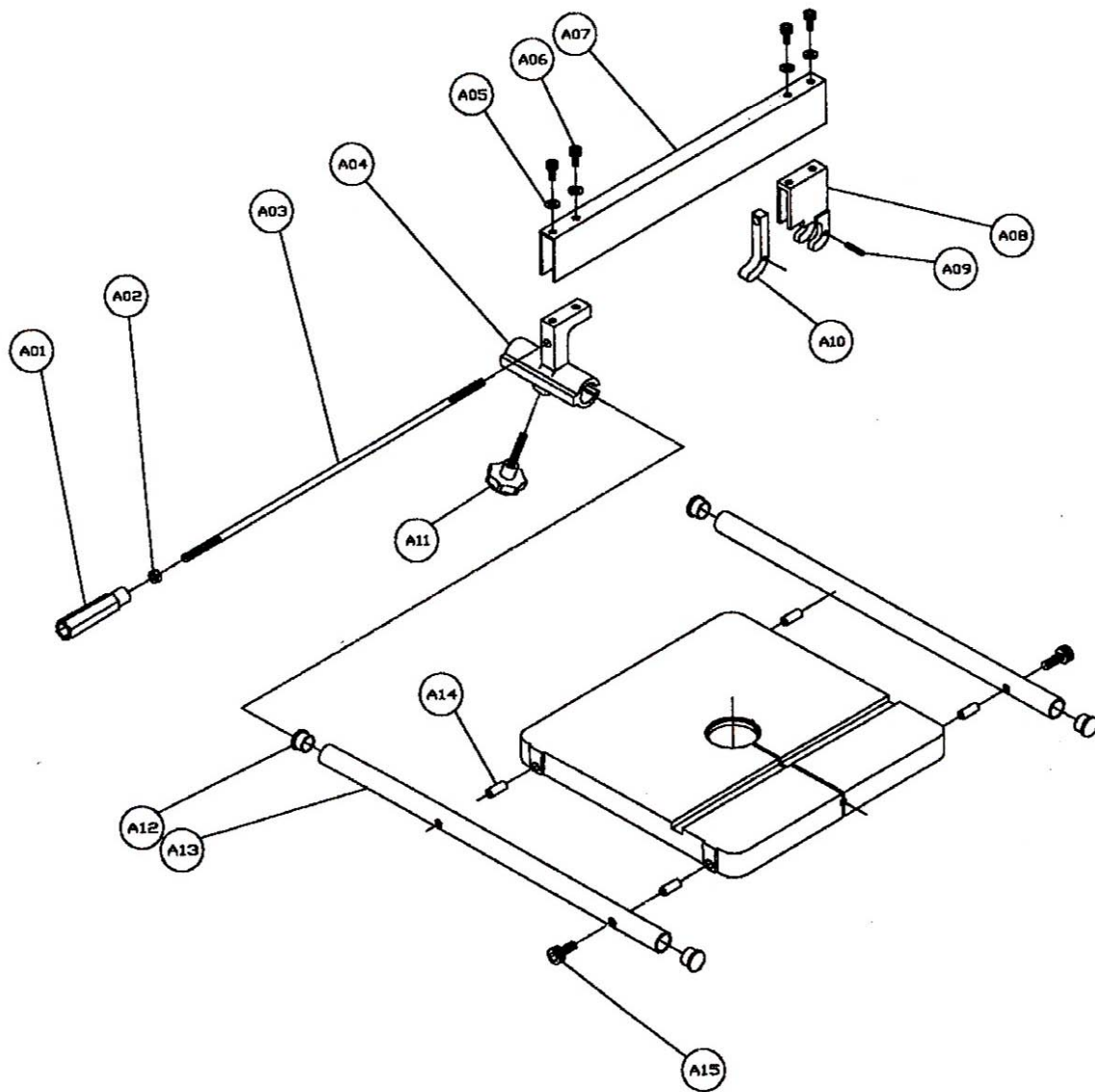
# CT016N Upper & Lower Blade Guide Ass'y Schematic Drawing



### CT016N TABLE, UPPER & LOWER GUIDE PARTS A'SSY

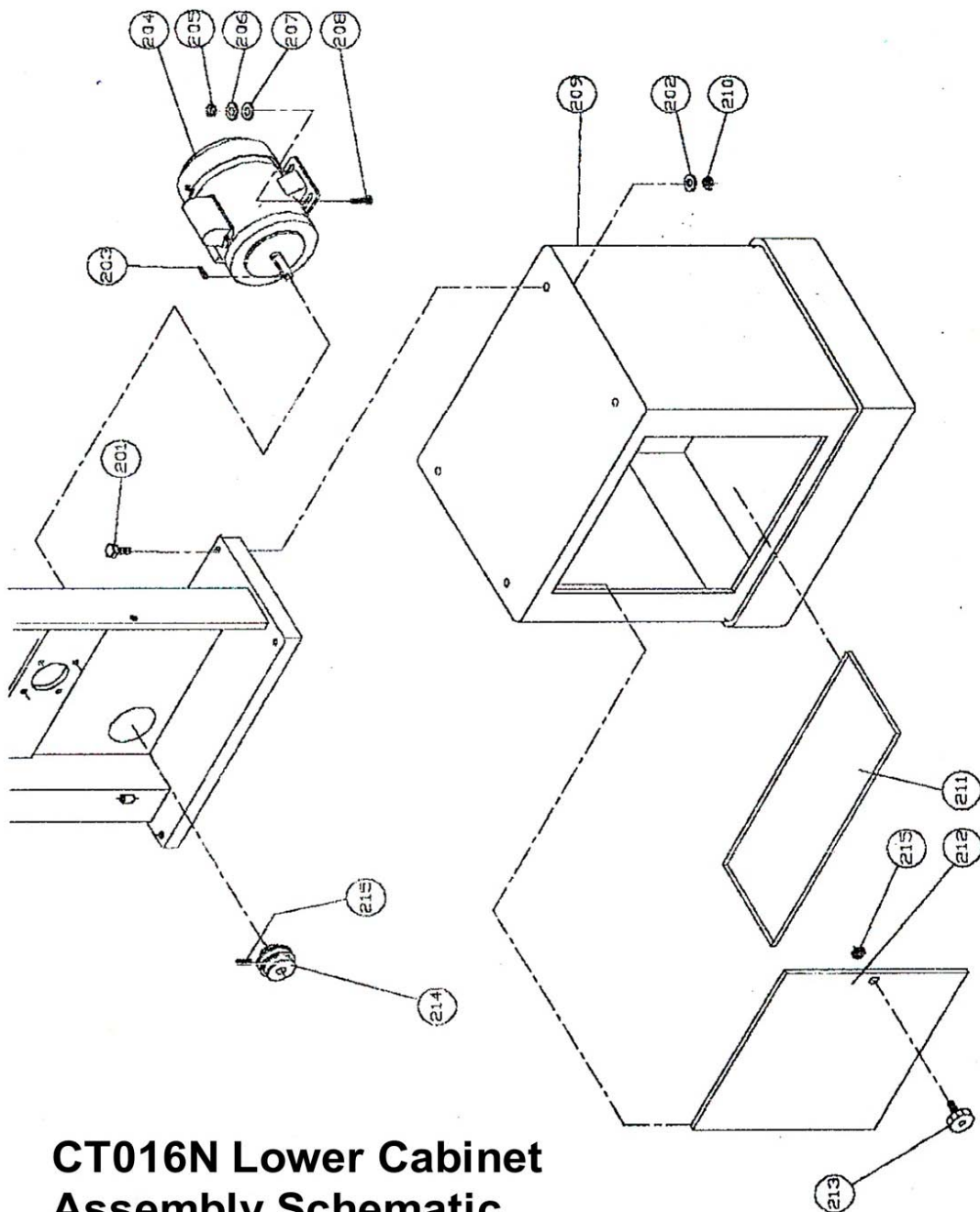
ITEM	DESCRIPTION
301	Locking Bolt
302	Gauge
303	Pan Screw, 3/16" x 3/8"
304	Pointer
305	Gauge Bar
306	
307	C-Ring – C10
308	Bearing – 6200ZZ
309	Upper Spacing Sleeve
310	Screw 1/4" x 3/4"
311	Screw 1/4" x 1/2"
312	Support Bracket
313	Guide Block
314	Pin, 3 x 10mm
315	Table Insert
316	Scale
317	Bolt, 5/16" x 20mm
318	Washer, 5/16" x 20mm
319	Table Bracket
320	Pointer
321	Pan Screw, 3/16" x 3/8"
322	Set Screw 1/4" x 5/8" #20
323	Lower Support Bracket Post
324	Bolt, 1/4" x 3/4" #20
325	Locking Knob
326	Bolt, 1/4" x 3/4" #20
327	Trunion
328	Trunion Clamp Shoe
329	Bolt, 3/8" x 2 1/2" #16
330	Table Pin, 6mm x 30mm
331	Table
332	Bolt, 1/4" x 3/8", #20
333	Washer, 1/4" x 16mm
334	Upper Blade Guide
335	Screw, 1/4" x 16mm
336	Upper Support Bracket
337	Guide Post

## CT016N Rip Fence Schematic Drawing



**CT016N RIP FENCE PARTS LIST**

<b>ITEM</b>	<b>DESCRIPTION</b>
A01	Fence Knob
A02	Nut, 3/8"
A03	Rod
A04	Fence Casting
A05	Washer, 1/4"
A06	Screw, 1/4" x 1/2"
A07	Fence Body
A08	Rear Fence Bracket
A09	Pin
A10	Rear Clamp
A11	Knob
A12	Plug
A13	Fence Tube
A14	Fence Rail Spacer
A15	Cap Screw, 1/4" x 1 1/2"



# CT016N Lower Cabinet Assembly Schematic Drawing

### CT016N LOWER CABINET PARTS LIST

ITEM	DESCRIPTION
201	Screw 3/8" x 2"
202	Washer 3/8"
203	Key
204	Motor
205	Nut 5/16"
206	Lock Washer 5/16"
207	Washer 5/16"
208	Screw 5/16" x 5/8"
209	Stand
210	Nut, 3/8"
211	Stand Guard
212	Knob
213	Motor Pulley
214	Set Screw, 1/4" x 1/4"
215	Nut, 5/16"

### CT016N Specifications

Table -16" x 16"

Table Height – 43"

Table Tilts – 0 – 45° right

Throat – 15 ¾"

Max. Cutting Height – 8 ½"

Blades – ¼" to 1 ¼" @ 115" long

Blade Speed – 2300-3200FPM

Machine Height – 74"

Motor – 1 ½" HP, 220V, 1 Phase

Gross Weight – 130 kg



## WARRANTY

### **CRAFTEX 2 YEAR 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 etcetera.

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, 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.





