



CT018 – 18" BAND SAW OWNER'S MANUAL



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CT018, 18" 2 SPEED BANDSAW

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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 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.
- ❑ **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.

CT018 2-SPEED BANDSAW

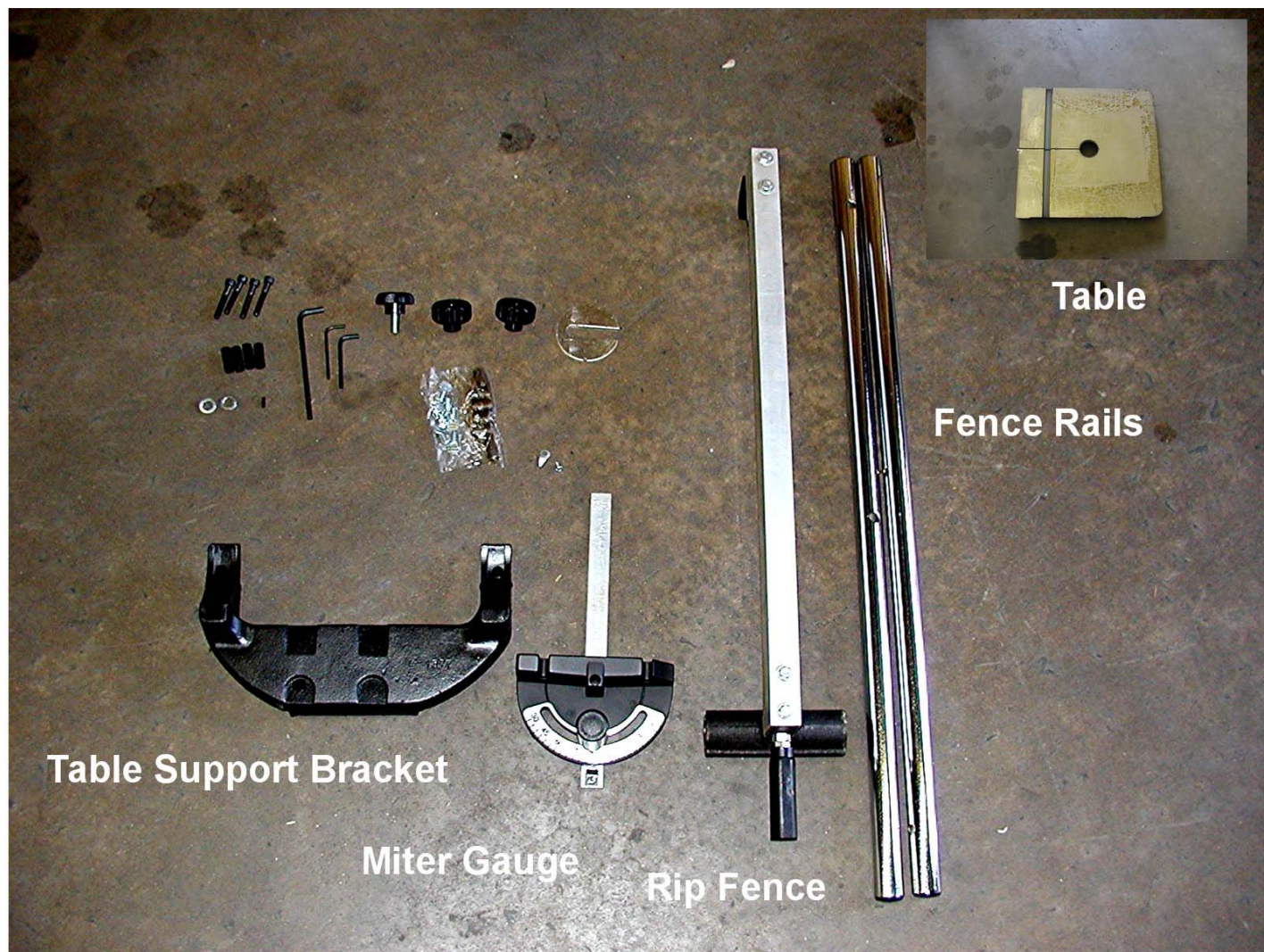
As part of the growing line of **Craftex** woodworking equipment, we are proud to offer the **CT018**. The **Craftex** name guarantees **Craft Excellence**. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The **CT018** is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

- ❑ The Craftex CT018 is an 18" Heavy Duty Bandsaw
- ❑ Motor – 2 HP 220V, Single Phase.
- ❑ Speeds – 2, 2,600 FPM & 3,150 FPM.
- ❑ On/Off Switch, Magnetic.
- ❑ Table – 18" x 18", Cast-Iron with Precision Ground Surface.
- ❑ Table Height – 34 1/2"
- ❑ Table Tilt – 0 – 45 degrees, right.
- ❑ Throat Depth – 17 1/2".
- ❑ Cutting Height – 9 1/2".
- ❑ Blade Widths – 1/4" – 1 1/4"
- ❑ Blade Length – 130 1/2".
- ❑ Overall Height – 69"
- ❑ Frame – Formed & Welded for maximum rigidity.
- ❑ Full Cabinet Style Stand.
- ❑ Drive Wheels – Cast Iron, Precision Balanced with Sealed Bearings and Inset Rubber Tires.
- ❑ Upper Blade Guide – Rack & Pinion.
- ❑ Dust Port – 4".
- ❑ Miter Gauge.
- ❑ Double Locking Rip-Fence.
- ❑ Gross Weight – 155kg.



CT018 BANDSAW

CARTON CONTENTS

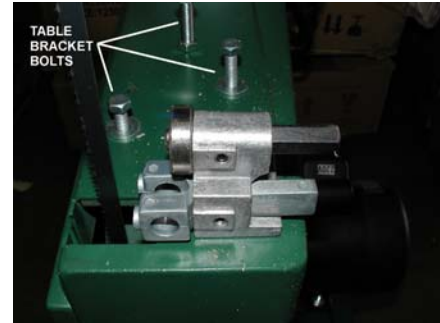


CT018 ASSEMBLY

The Craftex CT018 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 tabletop and then buffed dry.

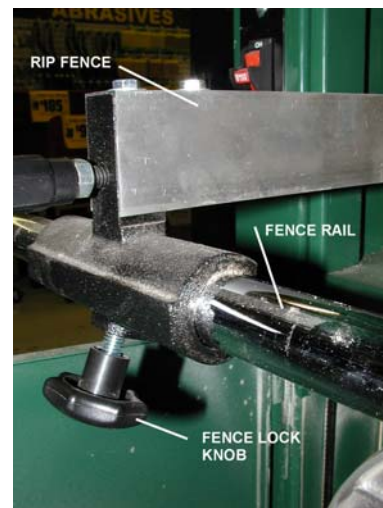
Install the table bracket to the saw frame with the bolts and washers provided.



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.



CT018 OPERATION

Your Crafttex CT018 Bandsaw 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 CT018 must be connected to the correct electrical power source, 210-volt, single phase. This may be hard wired into a separate, dedicated power supply 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 as an index.

Select the correct speed (2,600 or 3,150 RPM) by adjusting the V-belt to the appropriate pulleys.



Wheel Alignment

Using the pre-installed bandsaw blade as an example, proceed to fine-tune the saw for precision cutting being certain that the tool is **NOT** connected to a power source.

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



CT018 OPERATION Continued

Wheel Alignment Cont'd.

If there is any deviation of the bandsaw blade on the upper wheel rubber tire surface, loosen the tracking adjustment-locking knob and adjust the 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 CT018 must have enough tension on it to ensure straight tracking. The correct tension is more of an operators 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 CT018. This is a wheel and turning it in a clockwise rotation will increase the tension on the blade. When the CT018 is not in use, the tension on the blade should be released to ease the pressure on the rubber tire and the bandsaw blade. By making this a habit you will extend the life of the rubber tires and the wheel bearings.

The tension on the blade must also be released when changing blades.

BLADE/TABLE ALIGNMENT

For best results the CT018 Band Saw blade must be properly aligned with the table. This is accomplished through the use of a square as illustrated.



CT018 OPERATION Continued

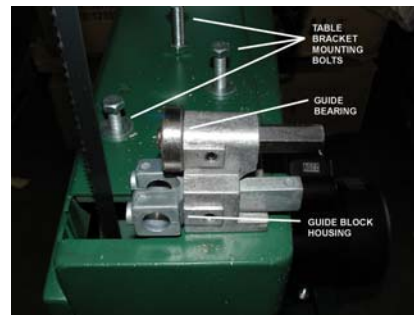
Blade/Table Alignment Cont'd.

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 CT018 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.



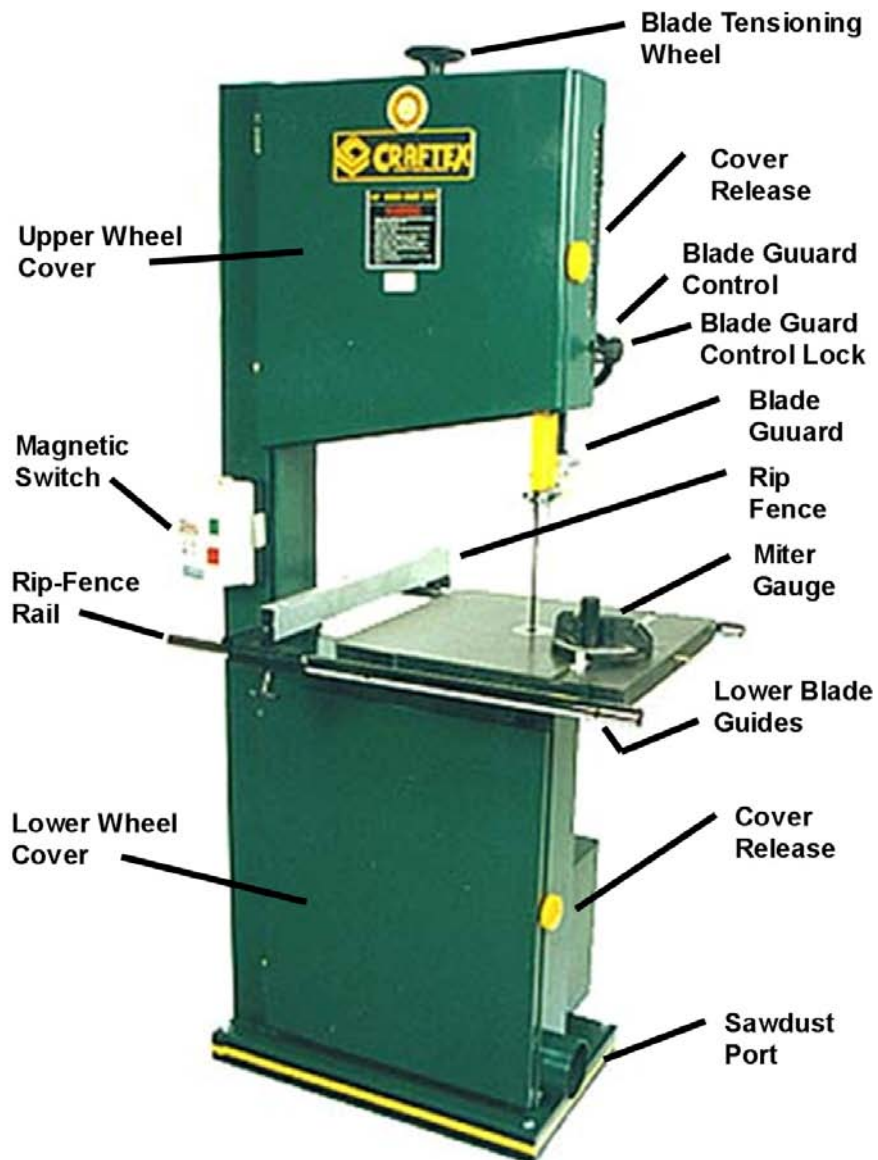
The rear bearing wheels should just touch the rear of the bandsaw blade. The blade guides should be set so that they are 'snug' on the blade but not so tight as to restrict vertical movement. The lateral position of the blade guides should be that the leading edge is just behind the gullet of the blade.

BLADE ADJUSTING

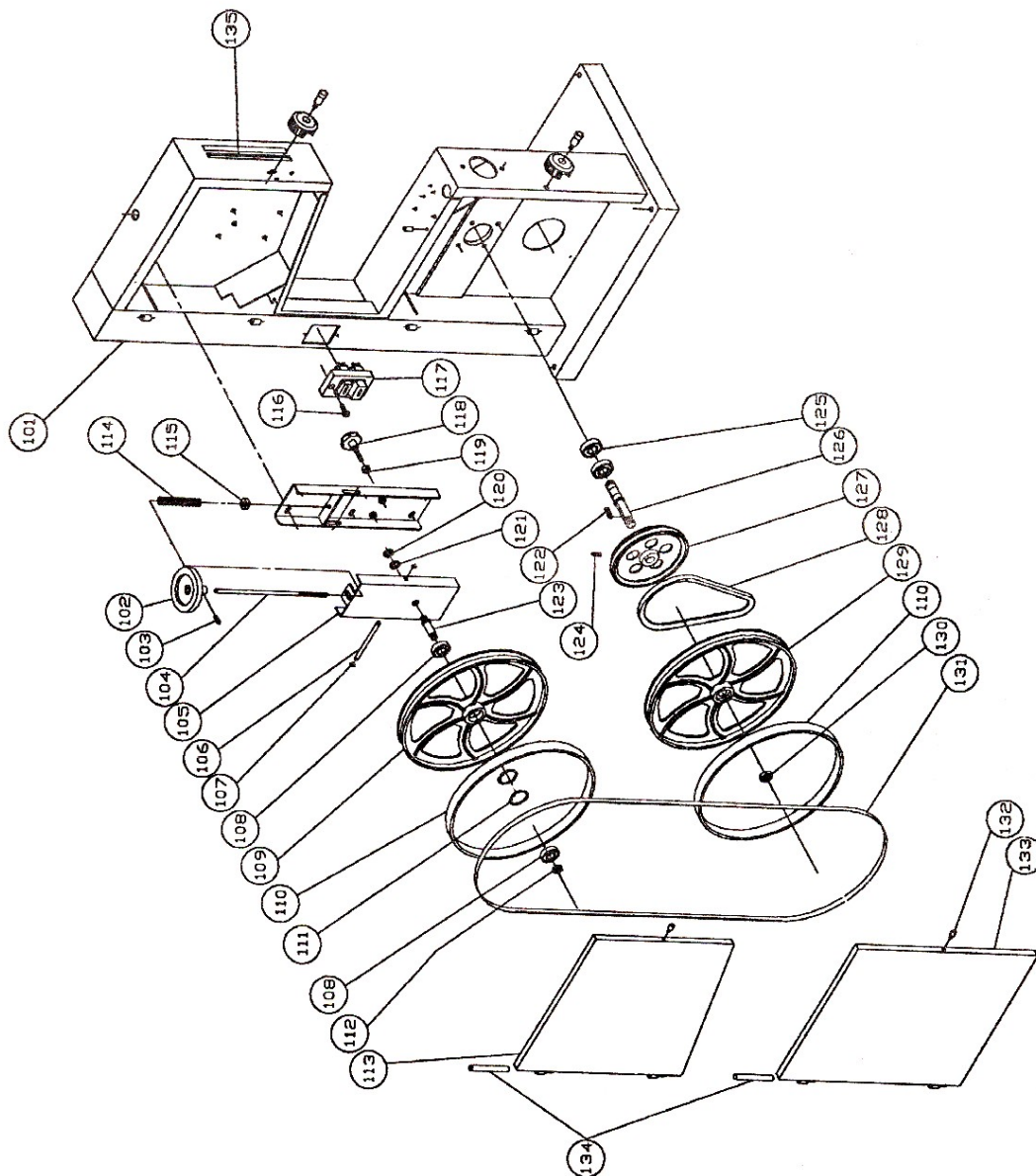
The bandsaw blades that you install may require additional adjusting to provide you with a smoother operating bandsaw. The weld on the blade should be checked for rough spots. If any are found, they should be ground smooth.

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

CT018, 18", 2-SPEED BANDSAW CONTROL LOCATIONS



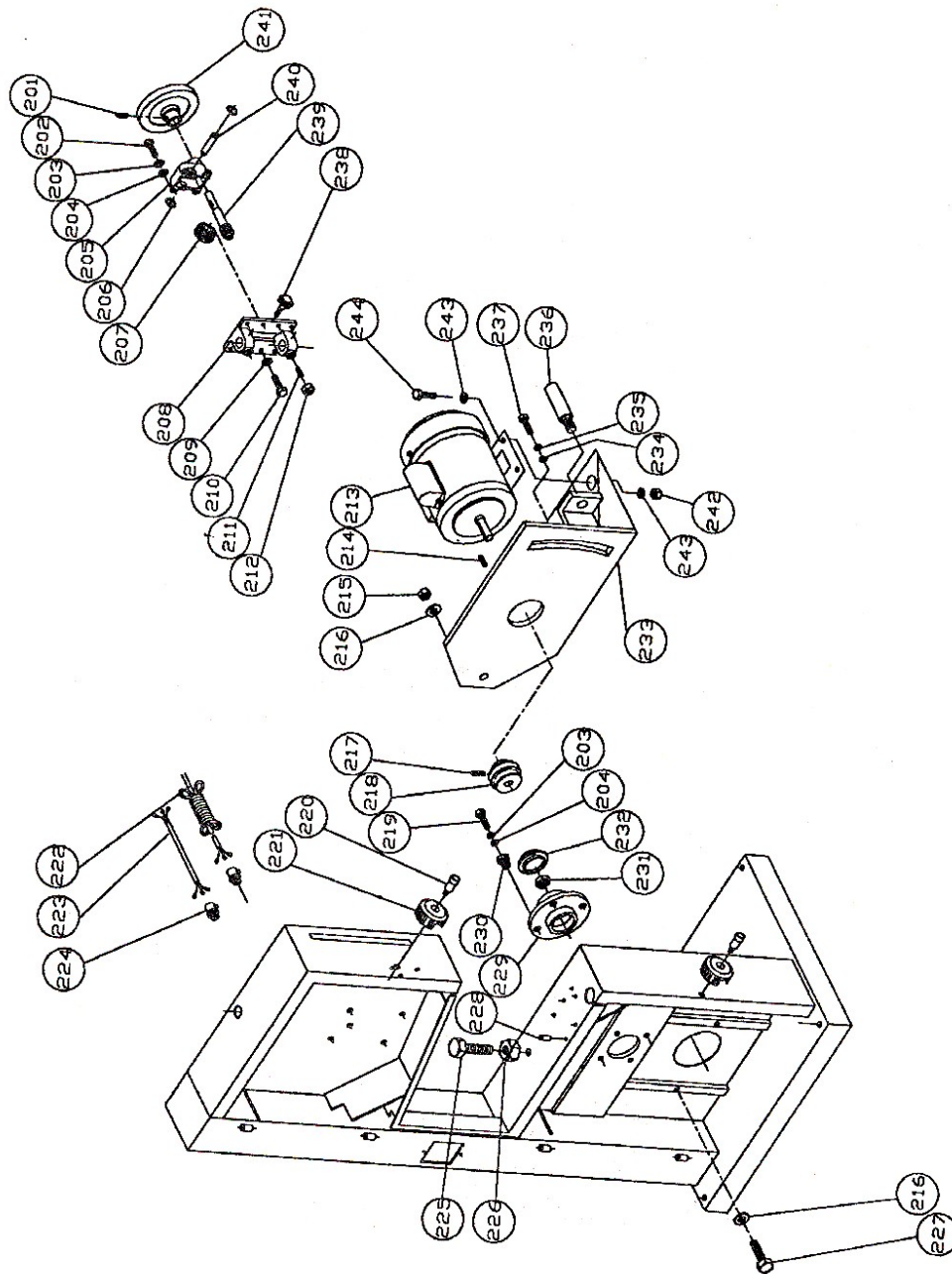
CT018 CABINET SCHEMATIC DRAWING



CT018 CABINET PARTS LIST

PART NO.	DESCRIPTION
101	Cabinet Case
102	Hand Wheel
103	Set Screw 5/16" x 1/2"
104	Blade Tensioning Screw
105	Upper Wheel Bracket
106	Guide Spindle
107	'C' Clip – C-8
108	Bearing
109	Upper Wheel
110	Rubber Tire
111	'C' Ring – R35
112	Nut 1/2"
113	Upper Wheel Cabinet Door
114	Spring
115	Nut 3/8"
116	Screw 3/16" x 3/4"
117	Magnetic Motor Switch
118	Wheel Alignment Knob
119	Nut 5/16"
120	Nut 5/8"
121	Spring Washer 1/2"
122	Key 5x5x35
123	Upper Wheel Shaft
124	Set Screw 1/4" x 3/8"
125	Bearing
126	Shaft
127	Pulley
128	V Belt
129	Lower Wheel
130	Nut 3/4"
131	Blade
132	Screw 1/4" x 3/8"
133	Lower Wheel cabinet Door
134	Pin
135	Scale

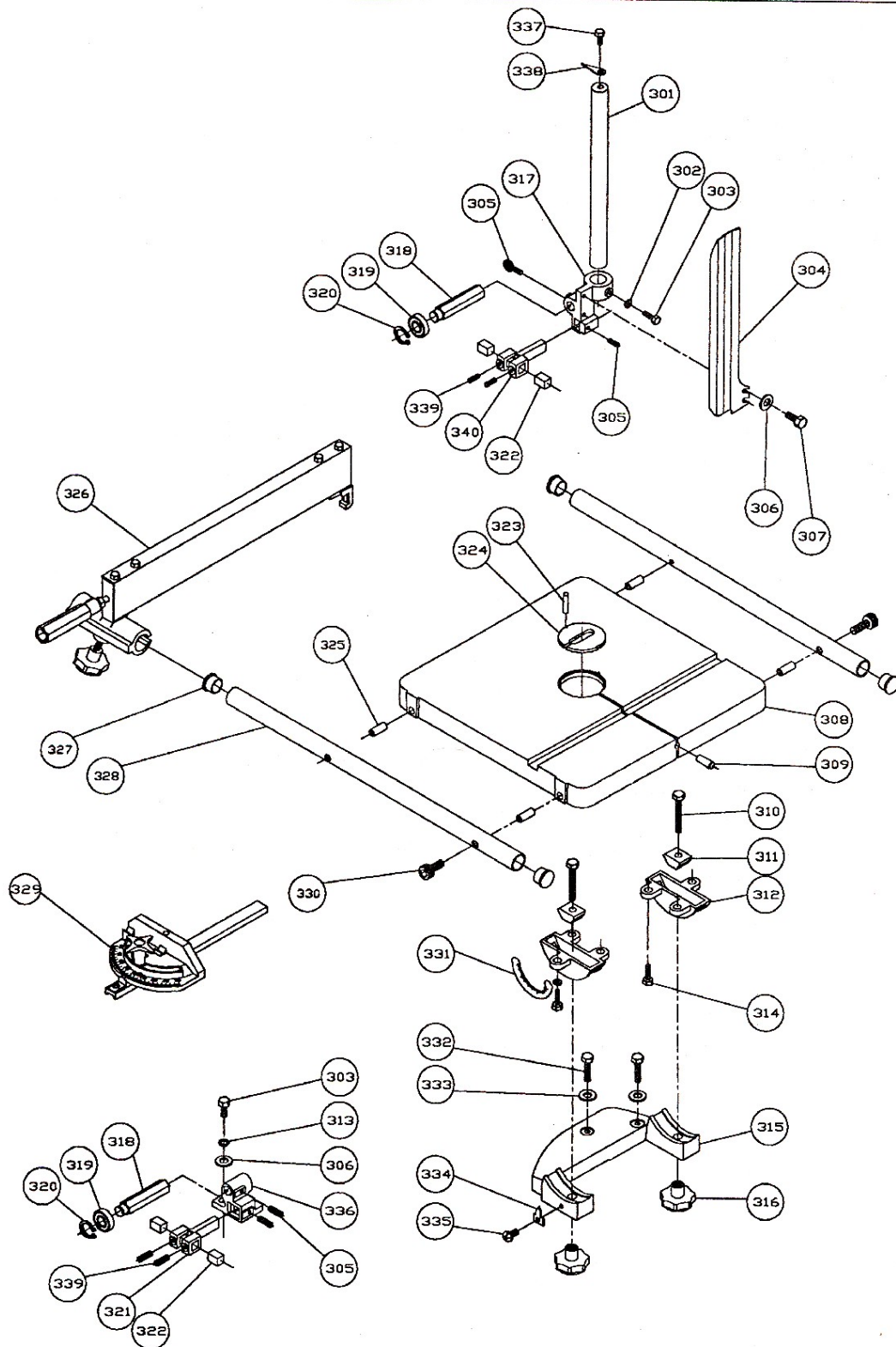
CT018 CABINET INTERIOR SCHEMATIC DRAWING



CT018 CABINET INTERIOR PARTS LIST

PART NO.	DESCRIPTION
201	Set Screw 5/16" x 1/2"
202	Screw 5/16" x 3/4"
203	Spring Washer 5/16"
204	Washer 5/16"
205	Gear
206	'C' Ring – C-12
207	Gear
208	Guide Bar Bracket
209	Spring Washer 1/4"
210	Screw 1/4" x 3/4"
211	Screw 1/4" x 3/8"
212	Nut
213	Motor
214	Key 5x5x25
215	Nut 3/8"
216	Washer 3/8"
217	Set Screw 1/4" x 3/4"
218	Motor Pulley
219	Screw 5/16" x 1 1/2"
220	Screw 1/4" x 3/4"
221	Door Lock Knob
222	Power Cord
223	Motor Cord
224	Cord Holder
225	Screw 3/8" x 4"
226	Nut 3/8"
227	Screw 3/8" x 1 1/2"
228	Pin
229	Bearing Base
230	Adjusting Screw
231	Nut 3/4"
232	Bearing Cover
233	Motor Base
234	Washer 3/8"
235	Spring Washer 3/8"
236	Knob
237	Screw 3/8" x 1 1/4"
238	Knob Screw
239	Worm Gear
240	Gear Spindle
241	Hand Wheel
242	Nut 5/16"
243	Washer 5/16"
244	Screw 5/16" x 1"

CT018 TABLE COMPONENTS SCHEMATIC DRAWING



CT018 TABLE COMPONENTS PARTS LIST

PART NO.	DESCRIPTION
301	Guide Bar
302	Nut 1/4"
303	Screw 1/4" x 3/4"
304	Blade Cover
305	Screw 1/4" x 5/8"
306	Washer 1/4"
307	Screw 1/4" x 3/8"
308	Table
309	Pin
310	Screw 3/8" x 2 1/2"
311	Clamp Shoe
312	Trunion
313	Spring Washer 1/4"
314	Screw 1/4" x 5/8"
315	Table Bracket
316	Table lock Knob
317	Upper Support Bracket
318	Bearing Support Bracket
319	Bearing
320	'C' Ring R-10
321	Lower Guide Blocks
322	Square Guide Blocks
323	Pin 3 x 10
324	Table Insert
325	Spacer
326	Fence
327	Rail Cap
328	Fence Rails
329	Miter gauge
330	Cap Screw 1/4" x 1/2"
331	Gauge
332	Screw 3/8" x 2"
333	Washer 3/8"
334	Pointer
335	Screw 3/16" x 3/8"
336	Lower Blade Support Bracket
337	Screw 1/4" x 1/2"
338	Pointer
339	Set Screw 1/4" x 1/4"
340	Lower guide Block (L)

OPERATION - A Helping Hand

In this section, **Craftex** provides you with some helpful tips/suggestions that may make life with your new Bandsaw easier and more enjoyable.

Band Saw Blade Tune Up

1. Disconnect the power from your saw
2. Release the blade tension just enough to slip the blade off.
3. Set the guides so they do not interfere with the blade. (At the sides or at the back)
4. Install your new blade starting with the upper band saw wheel, then the lower.
5. Apply just enough tension to the blade so that you take the limp out of the blade.
6. Rotate the upper or lower wheel a few times to move the blade towards the center of the wheel.
7. Track the blade.
8. Adjust the upper and lower thrust bearings so that they *almost* touch the blade.
9. Set the distance from the upper and lower guides to the blades. This can be done with a scarp piece of paper.
10. Square the table-top to the blade for accuracy.
11. For the smoothest of blade operation, check the weld of the blade for rough spots. If any are found, they should be ground smooth.
12. Now, with everything secure and ready to run, turn the band saw on. Carefully "round off" the rear of the band saw blade with a grinding stone. This will allow for smoother radius cuts with your saw.

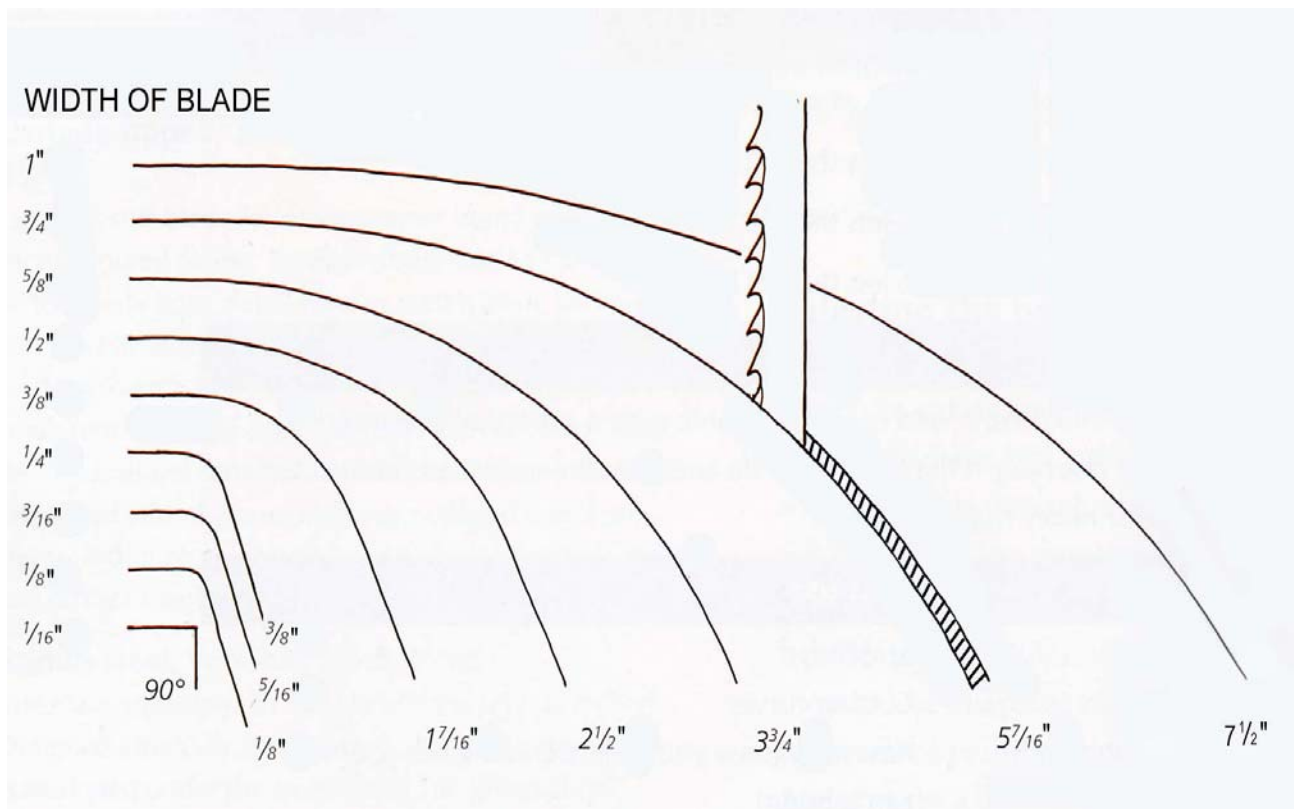
Band Saw Safety Tips

1. Keep the upper guide about ¼" above your work piece.
2. Decrease the feed pressure as you near the end of a cut.
3. Use safety push sticks when ripping or resawing.
4. Keep your fingers out of the path of the blade.
5. Keep the wheel covers closed while running the saw.
6. Always keep the blade guard in place.
7. Disconnect the band saw from its power source after use, and always while changing the blade.
8. Wear eye and ear protection while running the saw.

Finally, it is extremely important to look after your health while in the workshop. Dust collection is no longer a luxury and should be taken seriously. For the sake of your health, and others around you, a dust collection system is highly recommended.

OPERATION – A Helping Hand, Continued

How your Band Saw Blade Affects Cutting Radius



This diagram can come in handy when cutting radii. It is recommended that you try and use the widest blade possible for any job. The reason for this is because wider blades tend to wander less and produce smoother curves. (Never use a wider blade than specified for your machine)

Especially when resawing, it is beneficial to use a wider blade and properly apply tension. CT018 has many blades available for use. From 3/8" to 1" (3 Hook), the CT018 gives the ability to tackle virtually any job.

OPERATION – A Helping Hand Continued

Band Saw & Band Saw Blade Terms

Beam Strength

Beam strength is the result of a combination of blade hardness, thickness and width. A wider blade usually provides greater beam strength, which tends to produce straighter and smoother cuts.

Gullet

Gullet is the valley from the tip of one tooth to the tip of the next tooth. It is designed to carry the chip from the kerf. The size and efficiency of the gullets decrease as the pitch is increased.

Pitch

Pitch is the measurement of the number of teeth per inch (TPI), from the tip of one tooth to the tip of the next. The pitch determines the feed rate at which the blade can cut and the smoothness at which it does so.

Kerf

Kerf is the cut in the material being sawed. The kerfs width is determined by the thickness of the blade as well as the set of teeth.

Rake Angle

The angle of the face of the tooth measured in respect to a line perpendicular to the cutting direction. Hook blades have a positive rake angle, which causes them to cut more aggressively. Regular and skip blades have a zero rake angle, which gives them a slower more scraping action.

Blade Back

Blade back is the body of the blade not including the tooth. The back of the blade must be very strong and tough in order to withstand continuous flexing as the blade moves around the wheel.



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.

