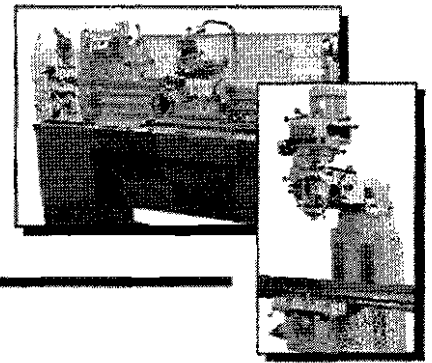


**MACHINERY DIVISION**

6465 18 MILE ROAD  
STERLING HEIGHTS, MI 48314

**PHONE:**  
(586) 731-3600 • 1-800-860-1740

**FAX:**  
(586) 731-7464 • 1-800-862-1740



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## **MODEL BAH-1018M-VS BANDSAW**

**THANK YOU FOR PURCHASING WITH KBC MACHINERY. ALL KBC MACHINES ARE BACKED BY OUR 1 YEAR PARTS REPLACEMENT WARRANTY. WHEN USED AS INTENDED, AND WITH PROPER MAINTENANCE THIS MACHINE WILL PROVIDE YOU WITH YEARS OF TROUBLE-FREE SERVICE. IF YOU NEED PARTS SIMPLY FILL OUT THE PARTS REQUEST FORM, AND FAX OR E-MAIL YOUR REQUEST. ALL OTHER QUESTIONS PLEASE CONTACT US @ :**

**KBC MACHINERY  
6465 18 MILE ROAD  
STERLING HEIGHTS, MI 48314  
PH (800) 860-1740  
FAX (800) 862-1740  
[MACHINERY@KBCTOOLS.COM](mailto:MACHINERY@KBCTOOLS.COM)  
[WWW.KBCTOOLSANDMACHINERY.COM](http://WWW.KBCTOOLSANDMACHINERY.COM)**



# PARTS REQUEST FORM

YOUR COMPANY NAME: \_\_\_\_\_

STATE/PROVINCE \_\_\_\_\_

YOUR NAME \_\_\_\_\_

PHONE # + EXT \_\_\_\_\_

FAX # \_\_\_\_\_

MACHINE INFO: \_\_\_\_\_

MAKE/MANUFACTURER \_\_\_\_\_

MODEL NUMBER \_\_\_\_\_

YEAR MADE \_\_\_\_\_

SERIAL# \_\_\_\_\_

PARTS REQUESTED:

PART#	DESCRIPTION
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_____	_____
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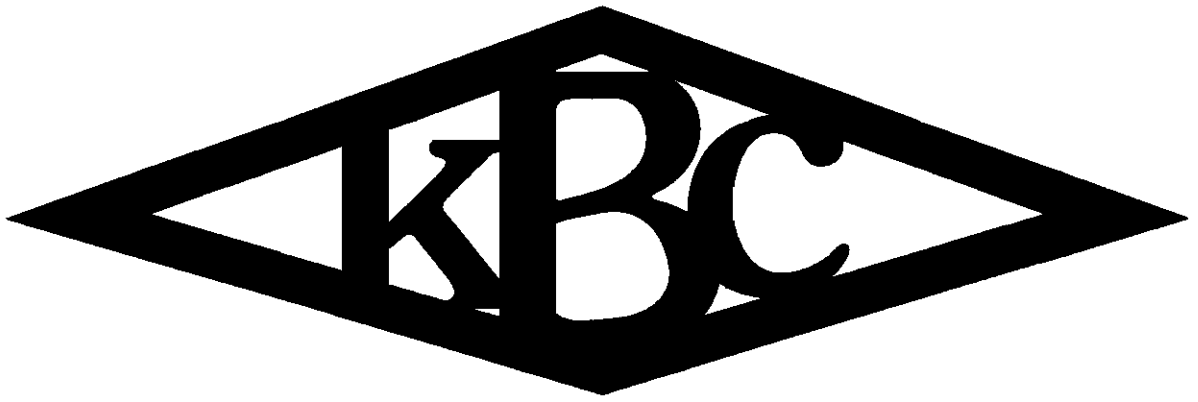
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PLEASE INCLUDE COPY(S) OF THE PARTS DRAWING FROM THE  
MANUAL AND CIRCLE THE PARTS NEEDED

FAX PARTS REQUEST TO (800) 862-1740

E-MAIL PARTS REQUEST TO: [machinery@kbctools.com](mailto:machinery@kbctools.com)

THANKS; KBC MACHINERY - MICHIGAN



**machinery**

**10" Mitre Saw**

**BAH-1018MVS**



# SAFETY SUGGESTIONS

1. READ THE INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.
2. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF HORIZONTAL BAND SAWS, OBTAIN ADVICE FROM YOUR SUPERVISOR, INSTRUCTOR OR OTHER QUALIFIED PERSON.
3. REMOVE TIE, RINGS WATCH AND OTHER JEWELRY, AND ROLL UP SLEEVES.
4. ALWAYS WEAR SAFETY GLASSES OR A FACE SHILD.
5. MAKE SURE WIRING CODES AND RECOMMENDED ELECTRICAL CONNECTION INSTRUCTIONS ARE FOLLOWED AND THAT MACHINE IS PROPERLY GROUNDED.
6. MAKE ALL ADJUSTMENTS WITH THE POWER OFF.
7. ADJUST AND POSITION THE BLADE GUIDE BEFORE STARTING CUT.
8. MAKE SURE THAT BLADE TENSION IS PROPERLY ADJUSTIED BEFORE STARTING CUT.
9. STOP THE BAND SAW BEFORE PUTTING A WORK PIECE IN THE VISE.
10. ALWAYS KEEP HANDS AND FINGERS AWAY FROM THE BLADE WHEN THE MACHINE IS RUNNING.
11. STOP THE MACHINE BEFORE REMOVING CHIPS.
12. ALWAYS HAVE STOCK FIRMLY CLAMPED IN VISE, BEFORE STARTING CUT.
13. DISCONNECT MACHINE FROM POWER SOURCE WHEN MAKING REPAIRS.
14. BEFORE LEAVING THE MACHINE, MAKE SURE THE WORK AREA IS CLEAN.

# DAILY CHECKLIST

1. **CHECK COOLANT:** Low coolant level can cause foaming and high blade temperatures. Dirty or weak coolant can clog pump, cause crooked cuts, low cutting rate and permanent blade failure. Dirty coolant can cause the growth of bacteria with ensuing skin irritation.
2. **KEEP VISE SLIDES CLEAN AND OILED.**
3. **CLEAN CHIPS FROM BLADE WHEELS AND AREAS AROUND WHEELS.**
4. **SAW GUIDE:** Keep saw guide tight. Loose guide will affect sawing accuracy.
5. **SAW BLADE:** Is saw blade sharp?
6. **BLADE SPEED:** Is blade speed set correctly for workpiece material and shape?
7. **CHECK BLADE TENSION:** Particularly after initial cuts with a new blade.

## SAW BLADE SELECTION

- A. Never use a blade so coarse that less than 3 consecutive teeth are engaged in the work piece at any one time. (Too few teeth will cause teeth to strip out.)
- B. Never use a blade finer than required to obtain a satisfactory surface finish or satisfactory flatness. (Too many teeth engaged in the workpiece will prevent attainment of a satisfactory sawing rate; frequently cause premature blade wear; frequently produce "dished" cuts or cuts which are neither square nor parallel.)
- C. The Chart which follows is not expected to be exactly correct for all cases. It is intended as a general guide to good sawing practice. Your blade supplier or factory application engineer should be your most reliable source of correct information for operational details of saw blades and their use.

WORK SIZE (Solid Bars)	PROBABLE PITCH-TEETH PER INCH		
	BEST	SECOND BEST	THIRD BEST
Less Than 1" Dia. or Sq.	10		
1" Dia. or 1" Sq.	8	10	6
1½" or 1" Sq.	8	10	6
2" Dia. or 2" Sq.	8	6	4
2½" or 2½" Sq.	6	8	4
3" Dia. or 3" Sq.	6	4	3
3½" or 3½" Sq.	6	4	3
4" Dia. or 4" Sq.	4	3	6
4½" or 4½" Sq.	4	3	6
5" Dia. or 5" Sq.	4	3	6
6" Dia. or 6" Sq.	3	4	6
7" Dia. or 7" Sq.	3	4	6
8" Dia. or 8" Sq.	3	2	4
9" Dia. or 9" Sq.	3	2	4
10" Dia. or 10" Sq.	3	2	4

## NOTE:

1. When standard wall pipe or tubing or thin wall tubing, channel iron, angles I Beams are cut, a 10 pitch saw blade of "wave" set type is frequently used to good advantage. Fewer than 10 teeth per inch of saw will almost never be satisfactory.
2. Tubing or structurals with wall thickness or web thickness of 1/2" or more can usually use an 8 or 6 pitch blade satisfactorily.
3. When rectangular, solid bar is to be sawed, the work should, whenever possible, be loaded with the thinnest cross section exposed to the blade teeth. The pitch(or number of teeth per inch of blade) selected must provide engagement of at least 3 consecutive teeth in the work piece. Should application of this rule not be possible because the thinnest cross section is too thin, the piece must be loaded with the wider dimension exposed to the saw teeth and a coarser blade selected from the listing of recommendations for round and square solid bars.

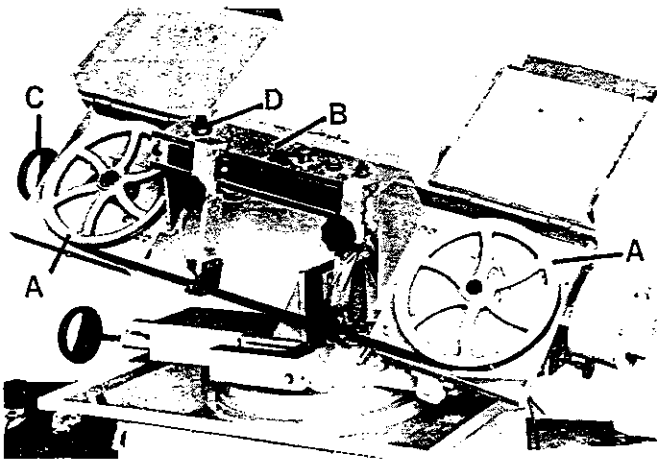


FIG. 1

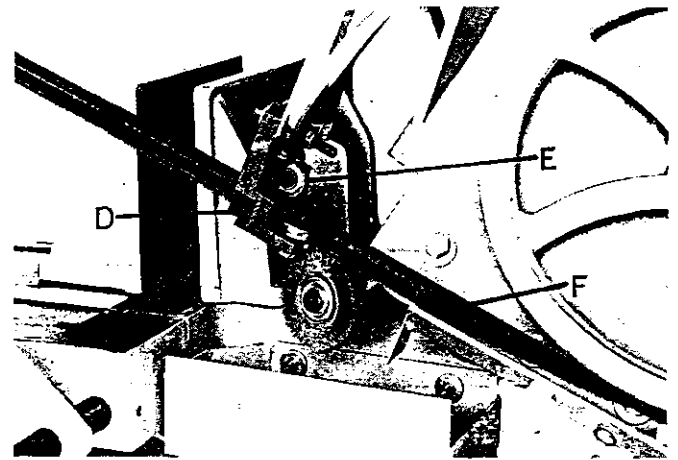


FIG. 2

## REMOVING AND INSTALLING THE BLADE

When your machine was shipped, a blade was supplied and assembled to the saw.

When selecting a new blade refer to page: 3 for information on SAW BALDE SELECTION.

1. Disconnect the machine from the power source.
2. Raise the saw frame about 6" and close the feed rate knob (D) Fig.1 by turning it clockwise as far as it will go.
3. Open both wheel covers and clean the debris out of the machine.
4. Release blade tension by turning the blade tension handwheel (C) Fig.1 counterclockwise.
5. Remove the blade from both wheels and out of each blade guide.
6. Make sure the teeth of the new blade are pointing in the direction of travel. If necessary, turn the blade inside out.
7. Place the blade in place on the wheels (A) and through the upper blade guard(B) Fig.1
8. Work the blade (F) all the way up into the tungsten blade guides (D) with the back of the blade against the back-up bearing (E), as shown in Fig.2
9. Put light tension on the blade and work it on both wheels. **MAKE SURE THAT THE BACK OF THE BLADE IS AGAINST THE WHEEL FLANGES OF BOTH WHEELS. THIS IS VERY IMPORTANT.**
10. When you are sure the back of the blade is against the wheel flanges of both wheels and properly inserted into the guides, finish putting tension on the blade.
11. Jog the power "on" and "off" to be sure the blade is in place and tracking properly.

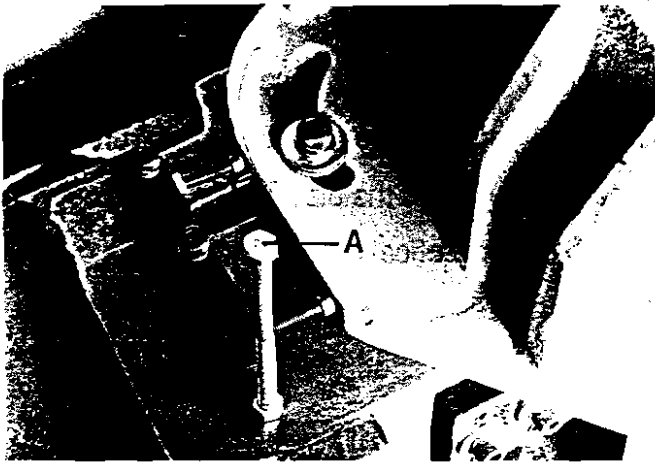


FIG. 3

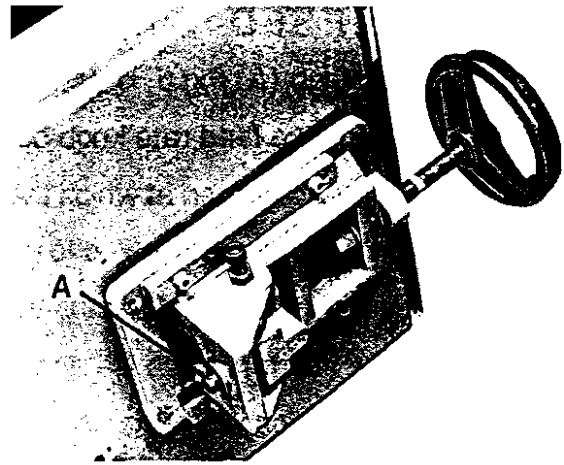


FIG. 4

## AUTOMATIC SHUT-OFF

The machine and any accessories which are wired into electrical system are controlled by the start-stop buttons. The machine will automatically shut off when the cut is completed. The lever for the automatic shut-off contacts the top of the bolt (B) Fig.3 and shuts off the machine. The bolt (B) is adjustable for desired height.

## BLADE TRACKING ADJUSTMENT

The blade is tracking properly when the back of the blade is against wheel flanges of both wheels. If the back of the blade is not against the wheel flanges, tighten or loosen screw (A) Fig.4, until the blade is tracking properly.

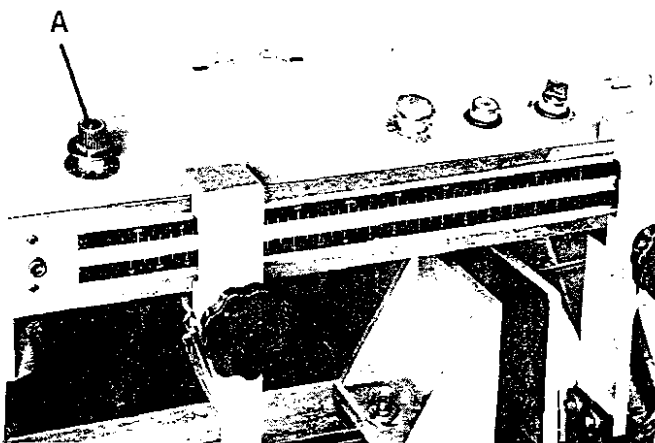


FIG. 5

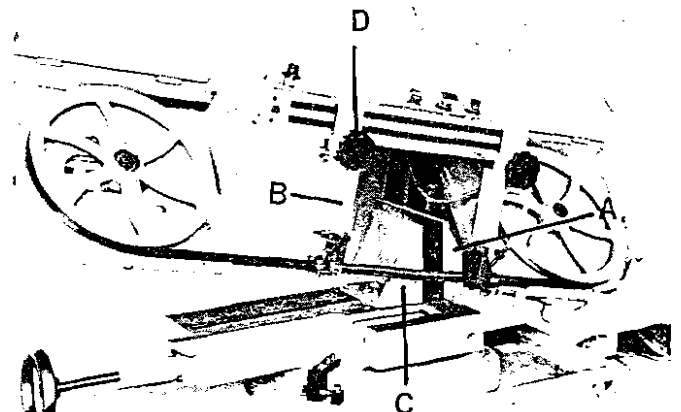


FIG. 6

2. Shift the belt (B) Fig.8, to the desired grooves on the pulleys and adjust belt tension by pulling the motor plate (C) Fig.7 back until correct belt tension is obtained and tighten tension lock knob (A) Fig.7

3. Close belt and pulley guard.

For variable speed drive:

4. The variation of speed is controlled by the control knob (A) Fig.9, speed goes faster when turn it counterclockwise.

5. Always select correct speed to prevent premature blade wear.

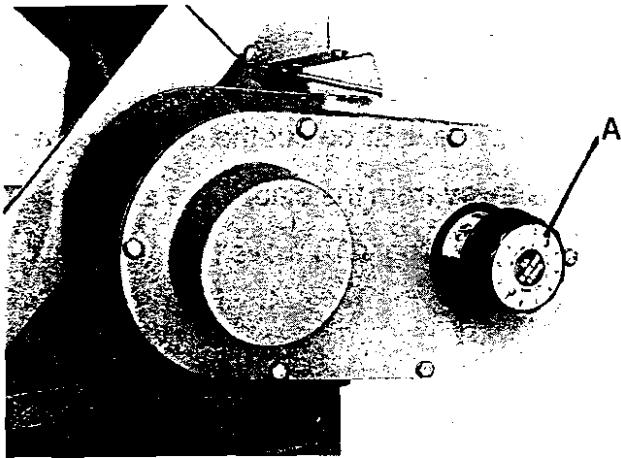


FIG.9

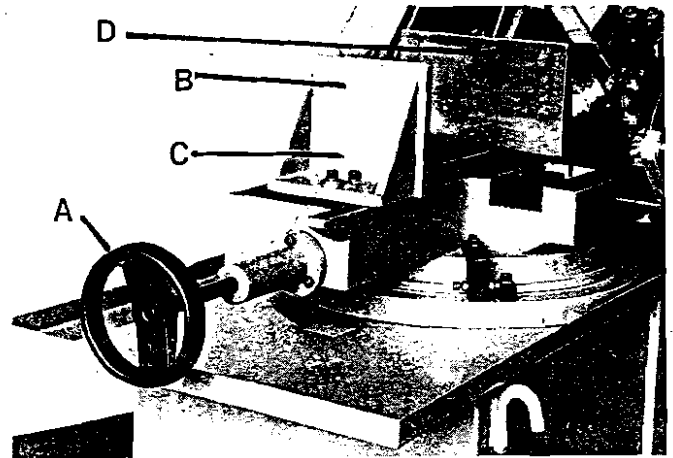


FIG.10

## OPERATING VISE

The workpiece is placed between the vise jaws with the required amount to be cut- off extending out past the blade. To position the moveable vise jaw (B) instant. Simply turn vise handknob (A) Fig.10, counterclockwise  $\frac{1}{2}$  turn and move the vise jaw (B) to the desired position. Then tighten vise by turning the knob (A) clockwise.

The vise can be adjusted to cut any angle from 0 degrees to 45 degrees by loosening the two bolts (C) Fig.10 on left vise jaw. Position the vise jaws to the desired angle and tighten the bolts.

## ADJUSTING FEED RATE

When the feed rate knob (A) Fig.5, is turned clockwise as far as it will go the saw frame will not move down. By turning the feed rate knob counter clockwise, you regulate the flow of oil from the cylinder and determine the speed at which the saw frame will lower and the blade will feed through the work. Too many factors are involved to make tabulated data practical on feed rates. As a general rule, an even pressure without forcing the blade gives best results. Avoid forcing the blade at the start as this may shorten blade life and produce a bad cut. By inspecting the chips while the cut is being made will indicate whether the feed rate is correct. Fine powdery chips indicate a feed rate which is too light. The teeth are rubbing over the surface instead of cutting. Burned chips indicate excessive feed which causes the teeth to break off as the blade overheats. The ideal feed rate is indicated by chips that have a free curl and this will give the fastest cutting time and longest blade life.

## ADJUSTING BLADE GUIDE BRACKETS

The blade guides should be set as close to the vise jaws as possible. The right blade guide bracket (A) Fig.6 is set at the factory to clear the right hand vise jaw. The left blade guide bracket (B) can be moved to the left or right depending on the position of the left hand vise jaw (C). To move the left blade guide bracket (B), loosen hand knob (D) position blade guide bracket (B) and tighten hand knob(D).

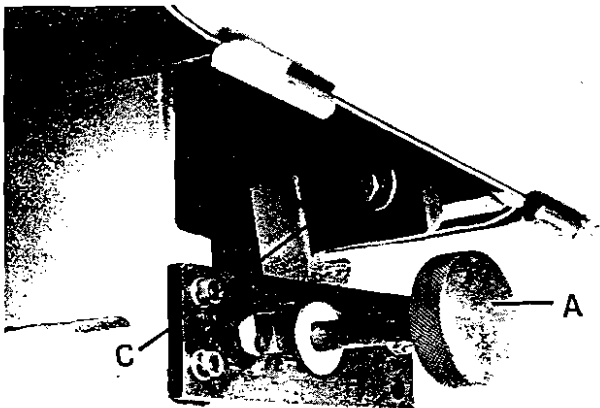


FIG.7

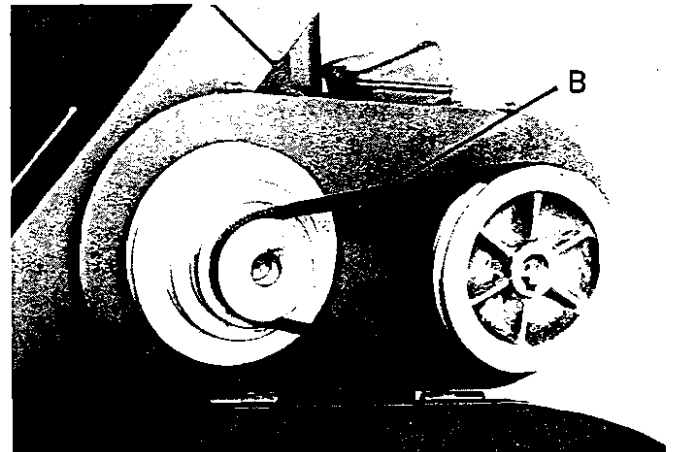


FIG.8

## CHANGING SPEEDS

For 4 step speed drive:

1. Release tension on the belt by turning the tension lock knob (A) Fig.7, counterclockwise and letting the motor swing forward.

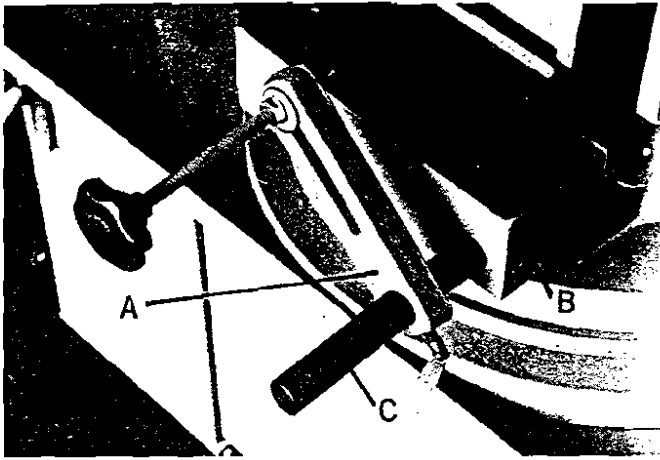


FIG. 11

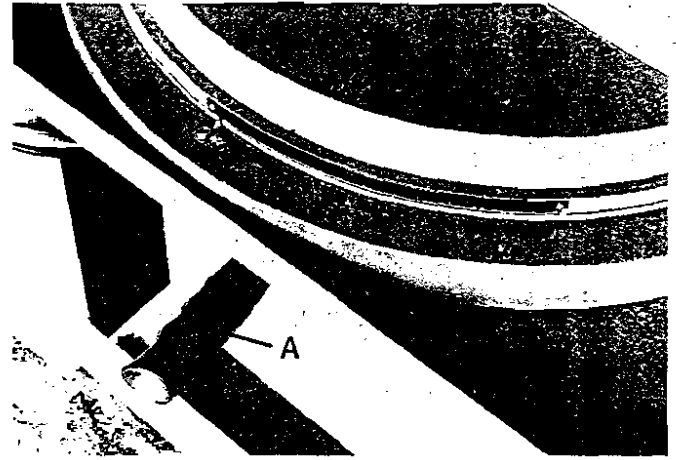


FIG. 12

## ADJUSTING STOCK ADVANCE STOP

The Stock Advance Stop is used mainly when more than one piece is to be cut the same length. Simply position the stop block (A) Fig.11, the desired distance away from the blade. The stop may be repositioned by loosening screw (B) and moving the rod (C) accordingly. To move the stop block (A) out of the way simply push it to the down position.

## TURNTABLE ADJUSTMENT (MITER SAW ONLY)

It is easily to accomplish locking and unlocking of turntable, move hand bar (A) Fig.12 to the left for unlocking, turn the turntable to desired angle and move it back to the right to lock the turntable. Remember to oil the turntable periodically, especially wet cut is frequently used.

# OPERATION

## SETTING UP THE MACHINE FOR OPERATION

1. Select the proper speed and blade for the type of material you are cutting.
2. Make sure blade tension is adjusted properly.
3. Lift the saw frame up and close the feed rate lever.
4. Place the stock between the vise jaws, set the stock for the desired width of cut and tighten the vise.
5. Make sure the left blade guide bracket is adjusted as close as possible to the left vise jaw.
6. Turn the machine on and if your machine is equipped with a coolant system, adjust coolant flow by turning valve.
7. Turn the feed rate lever counterclockwise until the saw blade begins to lower the desired rate of speed.
8. Proceed to cut through the workpiece, the machine will shut off upon completion of cut.

# REPLACEMENT PARTS

## PART NO. DESCRIPTION

9001	Body Frame	9043	Soc Set Scr.
9002	Bracket	9044	Collar, Including:
9003	Base Stand	9045	Handle
9004	Rear Cover	9046	Hex Hd. Scr.
9005	Upper Plate	9050	Acme Nut Assembly, Including:
9006	Split Lockwasher	9051	Button
9007	Washer	9052	Retainer
9008	Hex Hd. Scr	9053	Rd. Hd. Scr.
9009	Split Lockwasher	9054	Bracket
9010	Hex Jam Nut	9055	Special Washer
9011	Wire	9056	Hex Hd. Scr.
9013	Table	9057	Block
9016	Split Lockwasher	9058	Special Washer
9017	Hex Hd. Scr	9059	Hex. Hd. Scr.
9020	Table Bracket	9060	Vise Jaw Bracket,Right
9021	Steel Ball	9060AB	Vise Jaw Bracket,Left
9022	Soc. Set Scr.	9061	Handwheel
9023	Collar, Including:	9062	Hex Jam Nut
9024	Soc, Set Scr.	9063	Special Screw
9025	Pivot Shaft	9064	Washer
9026	Work Support	9065	Thumb Nut
9027	Split Lockwasher	9066	Thumb Screw
9028	Hex Hd. Scr.	9070	Pivot Shaft For Dash Pot
9029	Shaft	9071	Soc Set Scr.
9030A	Mount Plate	9072	Split Lockwasher
9034	Hex Hd. Scr.	9073	Tube Fitting
9035	Split Lockwasher	9074	Oil Tube
9036	Hex Hd. Scr.	9075	Oil Tube
9037	Soc Set Scr.	9076	Tube Fitting
9040	Bracket	9077	Tube Assembly
9041	Collar, Including:	9091	Hex Jam Nut
9042	Acme Screw Assembly, Including:	9092	Cap Screw

9100	Rear Pivot Bracket	9152	Clip
9101	Soc. Set Scr.	9153	Clip
9102	Strap	9154	Flat Hd. Soc. Screw
9103	Split Lockwasher	9155	Washer
9104	Hex Hd. Scr.	9156	Special Washer
9105	Special Washer	9170	Cover Assembly L.H., Including:
9106	Knob Assembly, Including	9182	Rd. Hd. Scr.
9107	Special Nut	9183	Cover Assembly R.H., Including:
9108	Roll Pin	9184	Hand Pull
9109	Strap	9189A	Hand Wheel
9110	Split Lockwasher- Jam Nut	9189B	Special Screw
9111	Hex Hd. Scr.	9190R	Blade Guide
9120	Hex Jam Nut	9201A	Bracket
9121	Special Soc. Set Scr.	9202	Soc. Set Scr.
9122	Motor Plate	9203A	Column
9123	Motor	9204A	Bracket R.H.
9124	Split Lockwasher	9206	Soc. Set Scr.
9125	Hex Hd. Scr.	9207	Guide
9126	Split Lockwasher	9217	Bearing
9127	Hex Hd. Scr.	9218	Special Screw
9128	Key	9219	Washer
9136	Split Lockwasher	9221	Hex Jam Nut
9137	Split Lockwasher	9226	Cap Screw
9138	Special Screw	9227	Set Screw
9139	Special Nut	9233	Cap Screw
9140	Tank	9234	Cap Screw
9141	Water Pump	9235	Washer
9142	Split Lockwasher	9236	Washer
9143	Hex Hd. Scr.	9250	Wiper
9144	Special Soc. Set Scr.	9251	Cap Screw
9145	Relief Valve	9252	Washer
9146	Special Soc. Set Scr.	9253	Collar
9148	Water Tubing	9254	Washer
9149	Valve	9255	Hex Jam Nut
9150	Water Tubing	9256	Hex Jam Nut

9304A	Bracket L.H.	9503	Bracket (Left Side)
9307	Guide	9505	Front Pivot Bracket
9317	Bearing	9506	Split Lockwasher
9318	Special Screw	9507	Hex Hd. Scr.
9319	Washer	9508	Soc. Set Scr.
9328	Retainer	9509	Split Lockwasher
9329	Blade Guard	9560	Hex Hd. Scr.
9330	Cap Screw	9561	Split Lockwasher
9331	Hex Jam Nut	9562	Hex Hd. Scr.
9332	Washer	9563	Tube Retainer
9333	Cap Screw	9564	Rd. Hd. Scr.
9334	Cap Serew	9570	Split Lockwasher
9335	Washer	9571	Hex Hd. Scr.
9336	Washer	9572	Catch
9337	Hex Jam Nut	9573	Split Lockwasher
9401	Bracket	9574	Rd. Hd. Scr.
9402	Box	9575	Special Jam Nut
9403	Hex Hd. Scr.	9576	Special Screw
9404	Cap Screw	9577	Hex Hd. Scr.
9405	Box Cover	9601	Gear Box
9406	Limit Switch	9602	Soc Hd. Pipe Plug
9407	Hex Hd. Scr.	9603	Split Lockwasher
9408	Limit Switch	9604	Hex Hd. Scr.
9409	Hex Hd. Scr.	9605	Key
9410	Hex Hd. Scr.	9701	Wheel Assembly R.H., Including:
9421	Name Plate	9703	Washer
9422	Water Pump Switch	9704	Cap Screw
9423	Stop Switch	9705	Key
9425	Start Switch	9801	Wheel Assembly L.H., Including:
9426	Relief Valve	9802	Bearing
9427	Hex Jam Nut	9803	Collar, Including:
9428	Seal	9804	Retainer Ring
9429	Special Hex Hd. Scr.	9805	Washer
9501	Upper Frame Lockwasher	9806	Hex Hd. Scr.
9502	Bracket	9820	Bracket

9821	Slide	9971	Saddle, Spring, Bottom
9822	Special Screw	9972	Nut
9823	Hex Jam Nut	9973	Washer
9824	Bracket Assembl	9974	Soc. Set Scr.
9824A	Wheel Shaft sher	9975	Soc. Set Scr.
9825	Spring	9976	Headless Set Scr.
9826	Split Lockwasher	9978	Washer
9827	Hex Hd. Scr.	9979	Soc. Set Scr.
9829	Gib	9980	Soc. Set Scr.
9831	Split Lockwasher	9981	Soc. Set Scr.
9832	Hex Hd. Scr.	9983	Spring Adjuster Block
9833	Shaft	9984	Saddle, Spring, Upside
9834	Hex Jam Nut	9985	Nut
9835	Hand Wheel	9986	Soc. Set Scr.
9836	Soc. Set Scr.	9987	Spring Washer
9902	Split Lockwasher	9990	Outer Tube, Spring
9903	Hex Hd. Scr.	9991	Spring
9908	Hanger	9992	Supporting Rod, Spring
9940	Pulley Cover	9993	Soc. Set Scr.
9941	Motor Pulley	9994	Soc. Set Scr.
9942	Idle Pulley	9995	Nut
9943	Motor Pulley	9997	Handle Bar
9944	Pulley Cover	9998	Handgrip
9945	Pulley Guard	9999	Gripping Block
9946	Spring Washer		
9947	Flat Hd. Soc. Screw		
9948	Spring Washer		
9949	Cap Screw		
9951	Turntable, Upside		
9951A	Stop Block, Bottom		
9952	Turntable, Bottom		
9952A	Stop Block, Upside		
9953	Soc. Set Scr.		
9960	Nameplate		
9961	Indicator		



