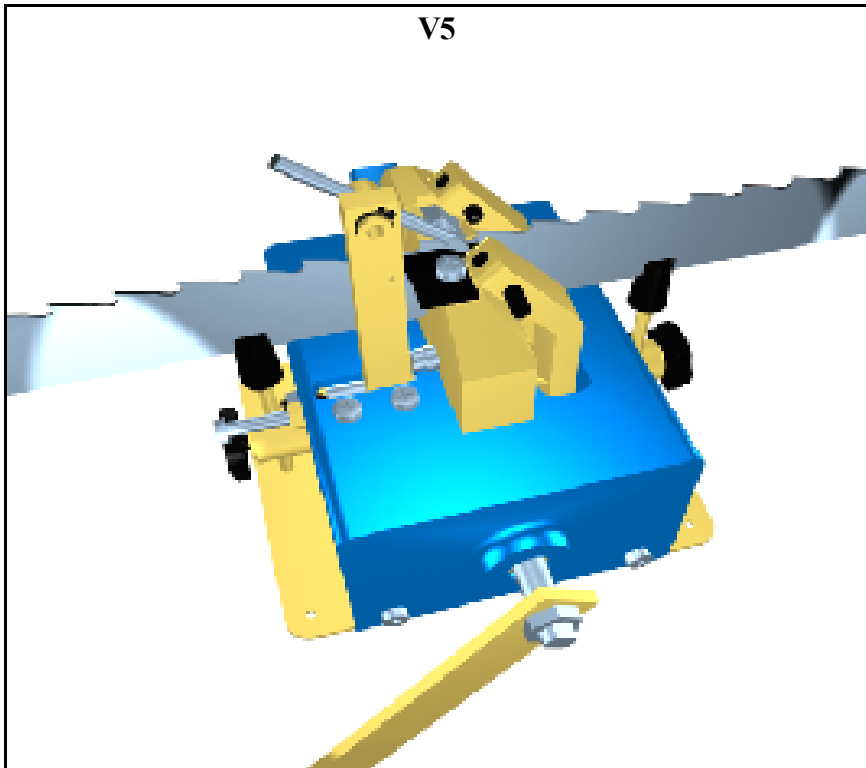


"DINO" BANDSAW SETTER

INSTRUCTION MANUAL

V5



Dinasaw

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STATEMENT OF WARRANTY

LIMITED WARRANTY:

Dinasaw Pty Ltd warrants that its products will be free of defects in workmanship or material for a period of 6 months. Should any failure to conform to this warranty appear within the time period of 6 months, Dinasaw Pty Ltd shall upon notification of and substantiation that the product has been stored, installed, operated and maintained in accordance with Dinasaw's specifications and instructions, repair or replace, at Dinasaw's sole option, any components or parts of the product determined by Dinasaw to be defective.

This warranty is exclusive and is in lieu of any warranty of merchantability, fitness for a particular purpose or other warranty of quality, whether expressed or implied.

LIMITATION OF LIABILITY:

Dinasaw shall not under any circumstances be liable for special or consequential damages, such as, but not limited to, damage or loss or other property or equipment, loss of profits or revenue, cost of capital, cost of purchased or replaced goods, or claims of Purchaser for service interruption. The remedies of the Purchaser set forth herein are exclusive and the liability of Dinasaw with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale delivery, resale, or use of any goods covered by or furnished by Dinasaw whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based.

The warranty period for Dinasaw Pty Ltd products is six months from date of purchase.

No transportation costs of any kind are covered under this warranty. Transportation charges to return products for repair shall be the responsibility of the customer. Returned goods shall be at the customer's risk and expense.

DESCRIPTION:

The “Dino” Bandsaw Setter is a portable bandsaw blade setter capable of setting raker style bandsaw blades up to 54mm (2 1/8”) wide and with tooth pitches up to 28mm (1-1/8”) It can be used in conjunction with the Dino Profiler/Sharpener to maintain your blades for optimum performance.

Four cams are located along a common shaft. The two outside setting cams (3) with the single lobes, actuate the setting yoke while the two inside 3 lobe cams (4&5) control the clamping of the blade (4) and the tooth indexing arm (5). Three teeth are indexed for every single rotation of the handle with the setting action occurring twice (one left-one right) in the same cycle. The blade clamp is released while the next tooth is indexed which is again clamped as the setting screw bends the tooth.

The handle may be rotated in either a clockwise or anti clockwise direction but this alters the setting sequence of the teeth from left-right-straight to right-left-straight. The feed cam (5) must then be rotated 180 degrees by first loosening it’s grub screw and turning the cam 180 degrees and retightening the screw to ensure the correct sequence otherwise clamping occurs while the tooth is being indexed.

The rapid action and the sequential nature of the “Dino” Bandsaw Setter means that all working parts must operate freely and if the number of blade teeth is not a multiple of 3 then ensure you start and finish at the join.

SETTING UP SETTER:

Slide the middle strut of the 3-pronged blade support frame over the protruding 25mm square at the rear of the setter and secure it by tightening the 6mm screw. The three telescoping support arms are extended to suit blade length and locked in position. Blade support legs are adjusted to a suitable height and locked with the 6mm screws in each end.

Screw the setter onto the edge of a suitable fixture ensuring sufficient clear room for handle rotation. Turn the handle until the blade clamp wedge (20) rises and releases the clamp block (37) and fit the blade between the blocks with teeth facing towards the picker (13). Slacken the clamping bolts (35)

on the vertical posts and move the support posts (24) on the side of the setter up or down so that the teeth tips are approximately 2 mm (1/16") above the centre of the adjustable cone point setting screws. (23)

Ensure the blade is presenting level and adjust the remaining 3 vertical posts on the telescoping arms to comfortably support the remainder of the blade.

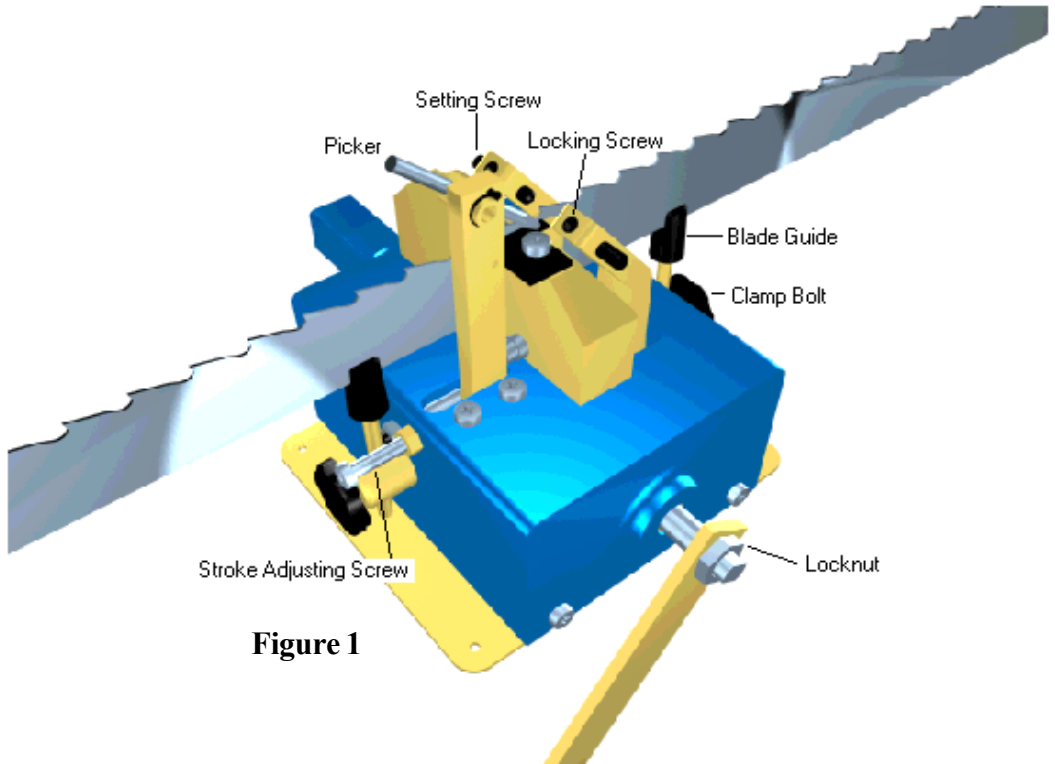


Figure 1

Rusted or gummed blades must be cleaned to ensure a smooth progression. Gummed blades will also cause setting errors by forcing the blade to one side of the clamp. The objective of this set-up procedure is to achieve a smooth, but controlled passage of the blade through the setter. Back off the 6mm cone point setting screws (23) using the 3mm hexagonal key provided. The cone point setting screws are retained from unintentional loosening by 90 degree locking screws (22) positioned on top of the setting yoke. These locking screws have a plastic pad (21) between their points and the setting screws to prevent to the thread damage and should be adjusted to apply only enough pressure to keep the setting screws firm.

The handle may be rotated in either direction but the clamping mechanism must be timed in relation to the feed cam.

The handle must be turned in the direction which enables the tooth to be indexed when the clamp is released. The machine is factory set to produce a left - right - straight sequence with a clockwise handle rotation. To produce the opposite sequence of right - left - straight, loosen the 6mm socket set screw (grub screw) securing the feed cam (4) to the camshaft (38), rotate the cam 180 degrees and retighten the socket set screw into the opposing dimple in the camshaft.

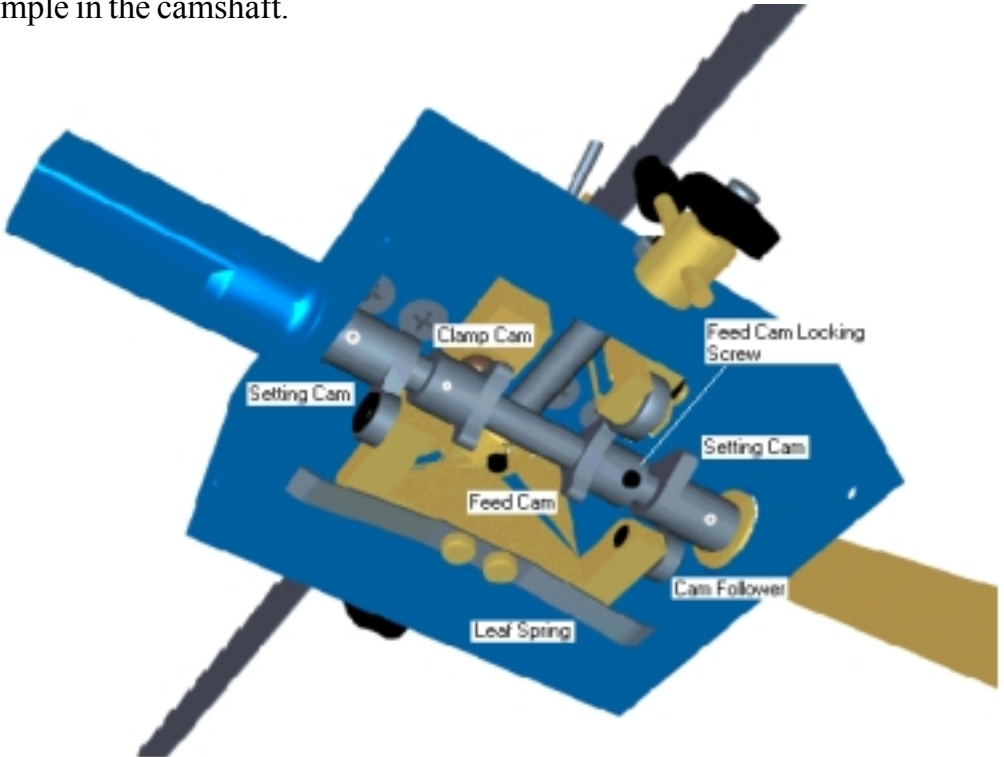


Figure 2

Adjust the tooth pushing picker (13) (by loosening the 6mm socket set screw (33) inside it's pivot bush (8) and move it so as to present the tooth immediately along side the cone point setting screws (23) when at it's maximum push. Ensure the picker is pushing central to the tooth and will not slip to either side of the tooth.

OPERATION OF THE SETTER:

- Rotate the handle and check -
- (1) The sequence of the blade set matches that of the setting action. (this usually remains constant for any one brand of blade)
 - (2) The blade does not "cock" and ensure sits down in it's supports.
 - (3) The rotation of the handle is correct (picker must be returning while yoke is setting.)

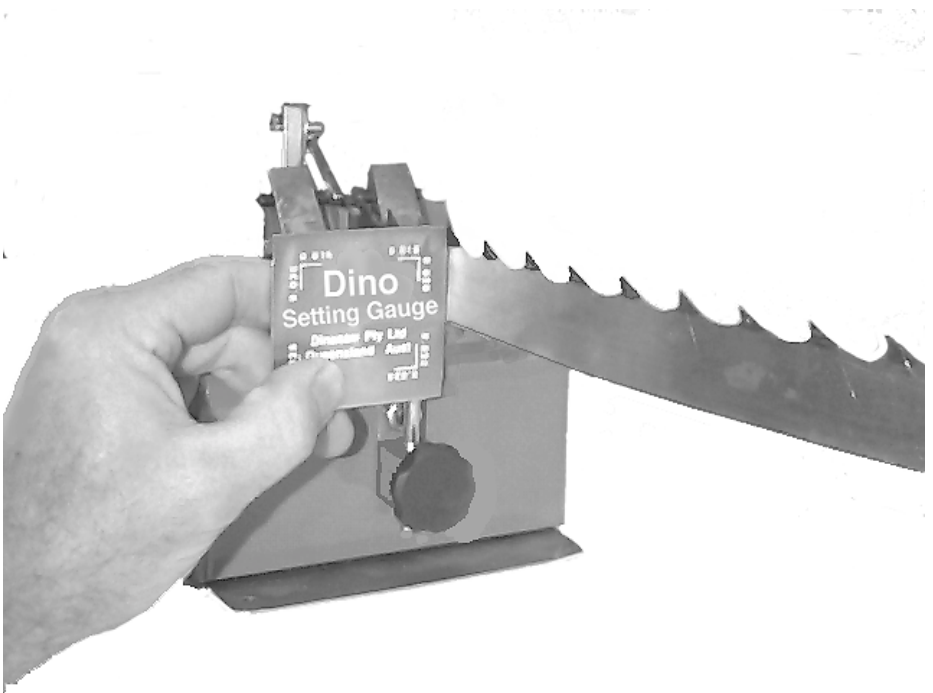
When satisfied with the index operation, locate the blade join and place it next to the setting yoke. The blade can be freely moved between the clamp by rotating the handle to release the clamp. Rotate the handle to index the next tooth and adjust in it's cone point setting screw (using the 3mm hexagonal key supplied) to just contact the tooth. Rotate the handle for the next tooth and repeat the adjustment for the other side.

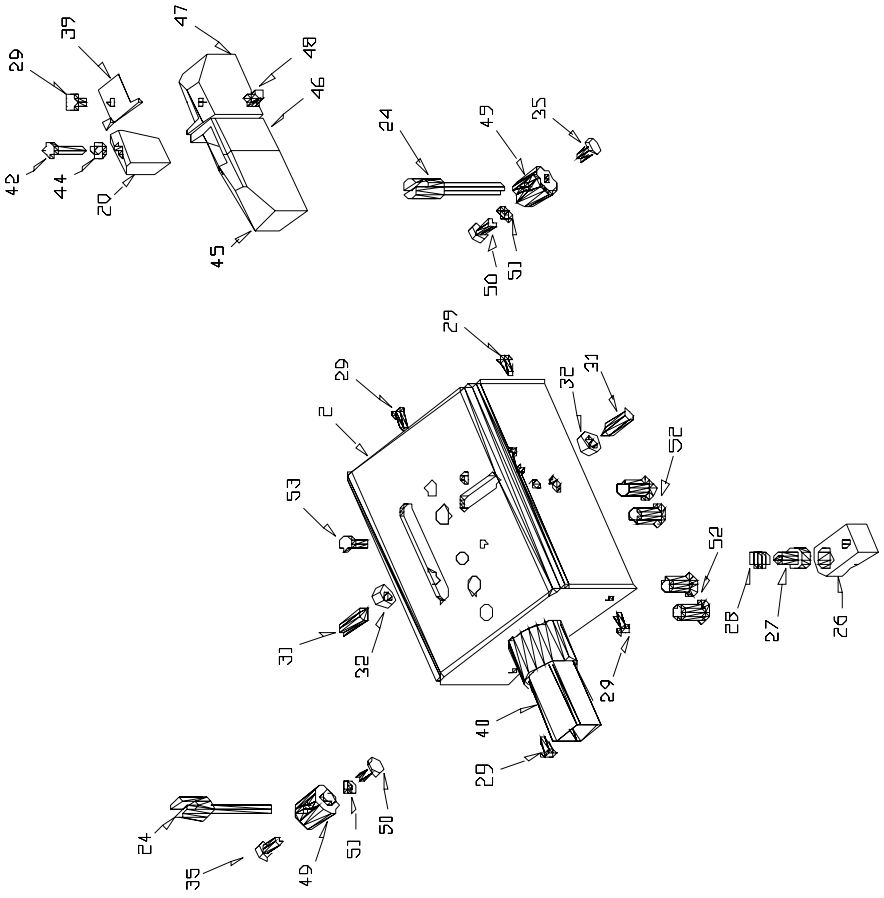
Fine adjustment of the setting screws can now be performed while checking the amount of set being applied with the setting gauge supplied (fig3). The gauge consists of a square metal sheet with two "steps" machined into each corner. Select the required set on the gauge and while holding the flat edge across the width of the blade, try to touch the set tooth with the appropriate step. Should the step not touch, more set will need to be applied.

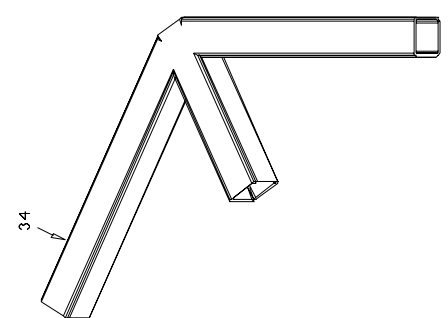
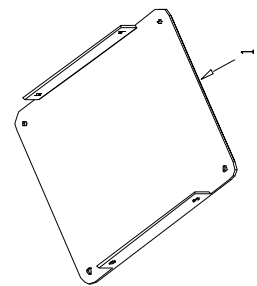
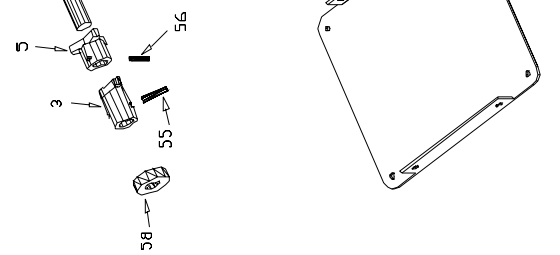
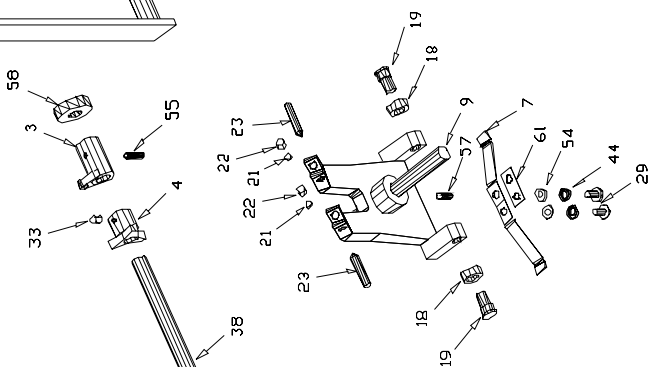
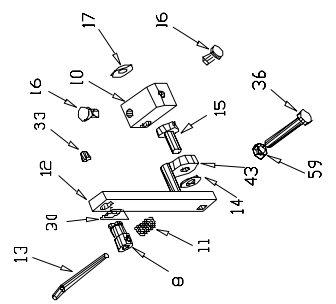
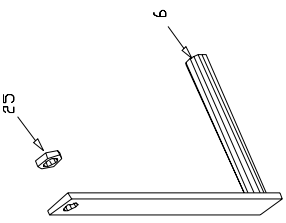
The settings will remain constant for any similar blade gauge and tooth form. It is preferable to apply a minimum of set and go around the blade more than once than to apply maximum set in the one pass.

Should excess set need to be removed from an entire blade, adjust the feed cam timing for the opposite sequence by moving the feed cam timing 180 degrees and rotate the handle in the other direction. The setting screws will have to be readjusted to prevent over setting in the other direction. If only several teeth have had excess set applied, it is often quicker to take it off just these teeth with the careful use of a pair of pliers.

The feed picker always presents the teeth to the same position regardless of tooth pitch. The maximum movement for the return of the picker is adjusted with screw stop (36). This should be set to allow the picker to return about half way into the next tooth. Ensure that it cannot span two teeth. Blades may be joined with a tooth pitch (number) not divisible by 3. In such cases blades need to be readjusted to the correct sequence when the setter again reaches the join.







| No. | Description | Part No. | No. | Description | Part No. |
|------------|---------------------|-----------------|------------|---------------------|-----------------|
| 1 | Base | JS16 | 31 | M8 x 16 Cone Pt. | FM816GRUBCP |
| 2 | Body | JS2 | 32 | M8 Nut | FM8NUTZP |
| 3 | Setter Cam | JS3 | 33 | M6 x 6 Grub | FM66GRUB |
| 4 | Feed Cam | JS5 | 34 | Blade Frame | JS36 |
| 5 | Clamp Cam | JS4 | 35 | M6 x 12 Hex Head | FM612HEX |
| 6 | Handle | JS1 | 36 | M6 x 40 Pan Head | FM640PANP |
| 7 | Leaf Spring | JS7 | 37 | Clamp Block | JS23 |
| 8 | Picker Pivot | JS12 | 38 | Camshaft | JS6 |
| 9 | Yolk Shaft | JS9 | 39 | Wear Pad | JS33 |
| 10 | Feed Arm Pivot | JS10 | 40 | Frame Support | JS46 |
| 11 | Feed Spring | JS31 | 42 | M5 x 40 Cheese Hdl. | FM540CH |
| 12 | Feed Arm | JS11 | 43 | 608 Bearing | B-608ZZ |
| 13 | Picker | JS13 | 44 | 5mm Spring Washer | FM5SWZP |
| 14 | M8 Washer | FM8WZP | 45 | Clamp Block Slide | JS22 |
| 15 | M8 x 16 Pan Head | FM816PANP | 46 | Clamp Block | JS23 |
| 16 | M6 x 12 Pan Head | FM612PANP | 47 | Fixed Clamp Block | JS35 |
| 17 | 8 Dia. Push on Fix | FM8FIX | 48 | Feed Spring Stud | JS44 |
| 18 | Roller | JS18 | 49 | Blade Post Block | JS41 |
| 19 | Roller Bolt | JS42 | 50 | M6 x 12 Hex Bolt | FM612HEX |
| 20 | Wedge | JS20 | 51 | 6mm Spring Washer | FM6SWZP |
| 21 | Lock Screw Pad | JS60 | 52 | M10 x 20 C/S | FM1020CS |
| 22 | Lock Screws | FM66GRUB | 53 | M6 x 16 Pan Head | FM616PAN |
| 23 | Setting Screws | FM625GRUBCP | 54 | 5mm Flat Washer | FM5WZP |
| 24 | Support Post | JS24 | 55 | 4 x 20 Roll Pin | FM420SELPIN |
| 25 | M12 Hex Nut | FM12NUT | 56 | 3 x 20 Roll Pin | FM320SELPIN |
| 26 | Cam Follower Guide | JS29 | 57 | M6 x 12 Cone Pt. | FM612GRUBCP |
| 27 | Cam Follower | JS14 | 58 | 6001 Bearing | B-60012NSE |
| 28 | Cam Follower Spring | JS34 | 59 | M6 Nut | FM6NUT |
| 29 | M5 x 10 Pan Head | FM510PANP | 60 | Rocker Arm | JS8 |
| 30 | Picker Spring | JS30 | 61 | Leaf Spring Washer | JS7A |
| | | | | | |
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Warranty Registration

Please fill out and return to:

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|--------------------|-----|
| First Name: | |
| Last Name: | |
| Address: | |
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| Phone Number: | |
| Fax Number: | |
| E-Mail Address: | |
| Place of purchase: | |
| Date of purchase: | |
| Serial Number: | JSD |
| | |
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