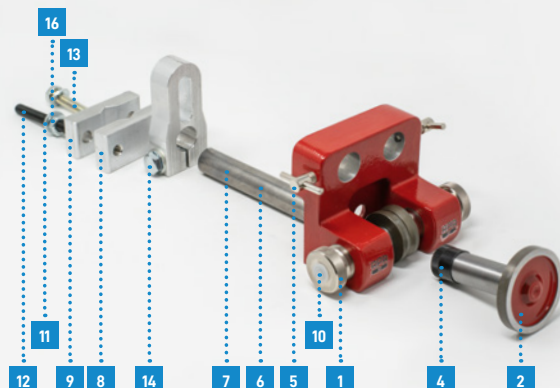


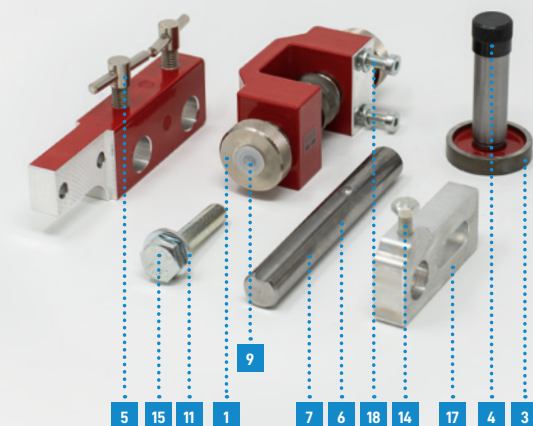
# CONSTRUCTION AND SPARE PARTS

TECHNICAL DATA	APA 2 Size 1	APA 2 Size 2
Back roller	ø 40 mm	ø 58 mm
Bearing sleeve	ø 16 mm	ø 22 mm
Back roller bolt	ø 8 mm	ø 10 mm
Side roller	ø 26 mm	ø 40 mm
Bolt	ø 8 mm	ø 10 mm
Bolt length	11 mm	22 mm

Upper band saw blade guide APA 2



Lower band saw blade guide APA 2



## LIST OF SPARE PARTS

		ORDER NUMBER	
		Size 1	Size 2
1	1x Side roller complete with bearing sleeve and locking plug	1290	1291
2	1x Back roller top complete with bearing sleeve and locking cap	1046	1047
3	1x Back roller bottom complete with bearing sleeve and locking cap	1052	1053
4	1x Locking cap	1097	1099
5	1x Tommy screw	1182	1182
6	1x Support bolt 16 x 120 mm*	1146	
7	1x Support bolt 22 x 120 mm*		1270
8	1x Clamp front	1268	1268
9	1x Clamp rear	1269	1269
10	1x Locking plug	1265	1265
11	Disc (4x top, 2x bottom)	DIN125 1 B10,5	DIN125 1 B10,5
12	1x Threaded pin	DIN553 M10 x 90	DIN553 M10 x 90
13	1x Hexagon screw	DIN933 M10 x 55	DIN933 M10 x 55
14	1x Hexagon screw	DIN933 M6 x 20	DIN933 M10 x 55
15	1x Hexagon screw	DIN933 M10 x 35	DIN933 M10 x 35
16	2x Hexagon nut	DIN934 M10	DIN934 M10
17	1x Holder	1266	1267
18	2x Pan-head screw	DIN912 M6 x 30	DIN912 M6 x 35

\* available in different lengths

## SPECIAL OIL 1059

For APA high-performing band saw blade guides, for the lubrication of the side and back rollers.

A regular lubrication increases considerably the service life of the APA band saw blade guide.

 5 bottles 20ml each

Order number: 3215

HOKUBEMA Maschinenbau GmbH

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✉ E-MAIL: service@hokubema-panhans.de

🌐 WEBSITE: www.panhans.de | 🛒 SHOP: www.hokubema.com



**SIITEC**  
SAFETY TECHNOLOGY



MONTAGE

OPERATION

MAINTENANCE

SPARE PARTS

**MANUAL**  
BANDSAW GUIDE TYP APA 2

MADE IN GERMANY

BA-APA-10-03-UK.doc

HOKUBEMA

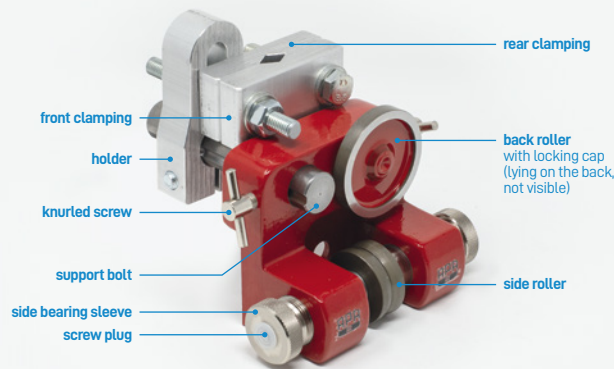
PANHANS  
QUALITÄT SEIT 1918

SIITEC  
SICHERHEITSTECHNIK



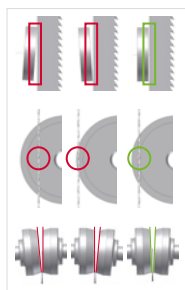
R. Beck  
Maschinenbau

## MONTAGE



- Fasten the fixation parts on the upper bar of the saw.
- Tighten the screws only slightly so that the guide can still be moved.
- Put the guide onto the support bolt and make a rough alignment. Position the back roller completely to the rear and the side rollers towards the outside.
- Fasten the fixation of the lower guide with a screw M10 at the machine base. If necessary, provide a boring.
- The lower guide should be mounted as close as possible underneath the table plate. If the machine is equipped with tilting table plate, the guide has to be mounted in deeper and suitable position.

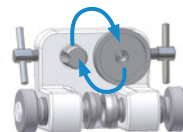
## BASIC ADJUSTMENTS DURING MONTAGE



- Put on the saw blade like for operation of the bandsaw machine. The guide must be aligned towards the saw blade as follows:  
Back roller in parallel to the back side of the saw blade (perpendicular).
- The saw blade must run exactly in front of the inside edge of the back rollers.
- The side rollers are only allowed to touch the saw blade in the front area.
- The opening angles between the side rollers and the saw blade must be the same on both sides of the saw blade.
- Both guides must be exactly perpendicular.
- After having done these basic settings of the guides, tighten well all fixation screws.

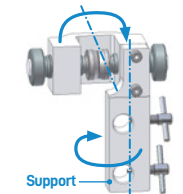
## MODIFICATION OF THE GUIDES TO LEFT-HAND PERFORMANCE

### UPPER GUIDE



- Exchange the support bolt and the back roller.

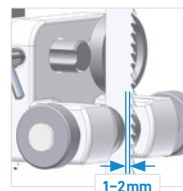
### LOWER GUIDE



- Take off the back roller and the support bolt from the fixation.
- Take off the two fixation screws from the support.
- Turn the support by 180° in its vertical axis.
- Turn the guide with the side rollers by 180° in its horizontal axis.
- Screw the support again at the guide.
- Fix the back roller and the support bolt again.

## ADJUSTING THE GUIDES

Adjustment of the guides for machine operation or after change of blade (both guides have to be adjusted the same way):



- Adjust the back rollers completely to the rear.
- Adjust the side rollers to the outside so that a new saw blade can freely run between them.
- Mount the saw blade, tension and align it.
- By moving the complete guide on the support bolt it may be adjusted so that the front sides of the side rollers are about 1–2 mm behind the tooth bottom of the saw blade.
- Adjust the back roller towards the back side of the saw blade in a way that it just does not touch the blade in idle run of the machine.
- The saw blade is allowed to touch the back roller only through the pressure during the cutting procedure.
- Adjust the side rollers in a way that they only touch slightly the saw blade.  
**Attention: Make sure that the saw blade is not pressed laterally.**

## MAINTENANCE

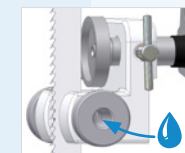
Clean the guides regularly from saw dust, resin or other dirt.

## INSTRUCTIONS FOR LUBRICATION

- ▲ In no case use any grease for lubrication of the bearings. We recommend exclusively the use of our special oil (TYP 1059) for lubrication (s. overleaf)

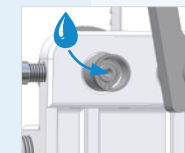
Treat the blank steel parts of the guides from time to time slightly with oil in order to ensure their smooth run and to keep them free from rust.

### SIDE ROLLERS



- Take off the screw plug and put some drops of oil into the bearings.
- Put in the screw plug again.
- The round sealings in the side bearing sleeves need to be greased from time to time with an acid-free grease, e.g. vaseline.

### BACK ROLLERS



- Screw off the locking cap from the back roller bearing.
- Put some oil into the lubrication point at the front side of the bearing bolt.
- Fix the locking cap again.

## DISTURBANCES AND TROUBLESHOOTING

DISTURBANCE	REASON	SOLUTION
Side rollers or back rollers don't turn.	Inadequate or wrong lubrication. Wrong basic setting of the guide. Insufficient cleaning.	Clean the bearings and lubricate (oil). Check the basic setting, if necessary adjust again.
Back roller is damaged (cut) through the back of saw blade.	Back roller does not turn. Saw blade runs too much inside of the back roller.	see above Check the basic setting, if necessary adjust again.
Contact surface of the back roller is wearing outside more than inside.	Saw blade runs too much outside of the back roller. Back roller is not positioned exactly perpendicular to the saw blade.	Check the basic setting, if necessary adjust again.
Saw blade is pressed through the side rollers towards the front.	Side rollers adjusted too tight to the saw blade. Contact surfaces of the side rollers or saw blade dirty.	Adjust the side rollers correctly. Clean.

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