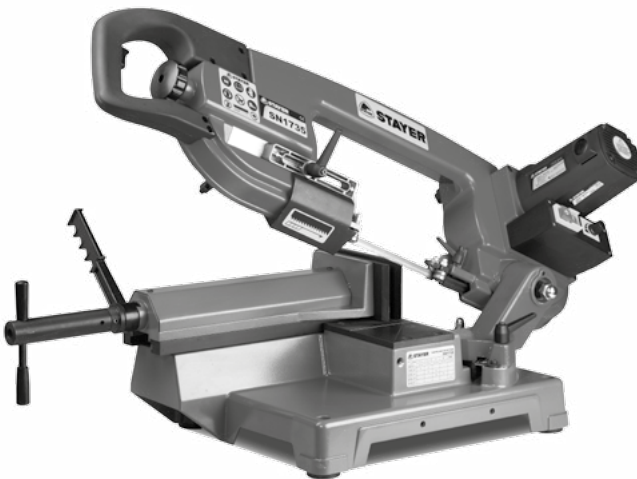




STAYER

- ES** Manual de instrucciones
- IT** Istruzioni d'uso
- GB** Operating instructions
- FR** Instructions d'emploi
- P** Manual de instruções

SN1435B
SN1470
SN1735
SN180







STAYER

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		SN1435B	SN1470	SN1735	SN180	
P_1	W	375	375	2000	550	
V_1	m/min	38-80	45	30-80	20 - 29.5	
H_1	mm	1435x12.7x0.65	1470x13x0.65	1735x13x0.65	1638x12.7x0.64	
Dmax	mm	Ø125	Ø100	Ø160	Ø128	
	Kg	21	22	38	94	
		I	I	I	0	
	K=3db	L_{PA} dB(A)	80.3	65	81.2	78
		L_{WA} dB(A)	64	60	79	71
	K=1.5 m/s ²	a_h m/s ²	< 2.5 m/s ²	< 2.5 m/s ²	< 2.5 m/s ²	< 2.5 m/s ²

Estos datos son válidos para tensiones nominales de [U] 230/240 V ~ 50/60 Hz - 110/120 V ~ 60 Hz. Los valores pueden variar si la tensión fuese inferior, y en las ejecuciones específicas para ciertos países. Preste atención al nº de artículo en la placa de características de su aparato, ya que las denominaciones comerciales de algunos aparatos pueden variar .

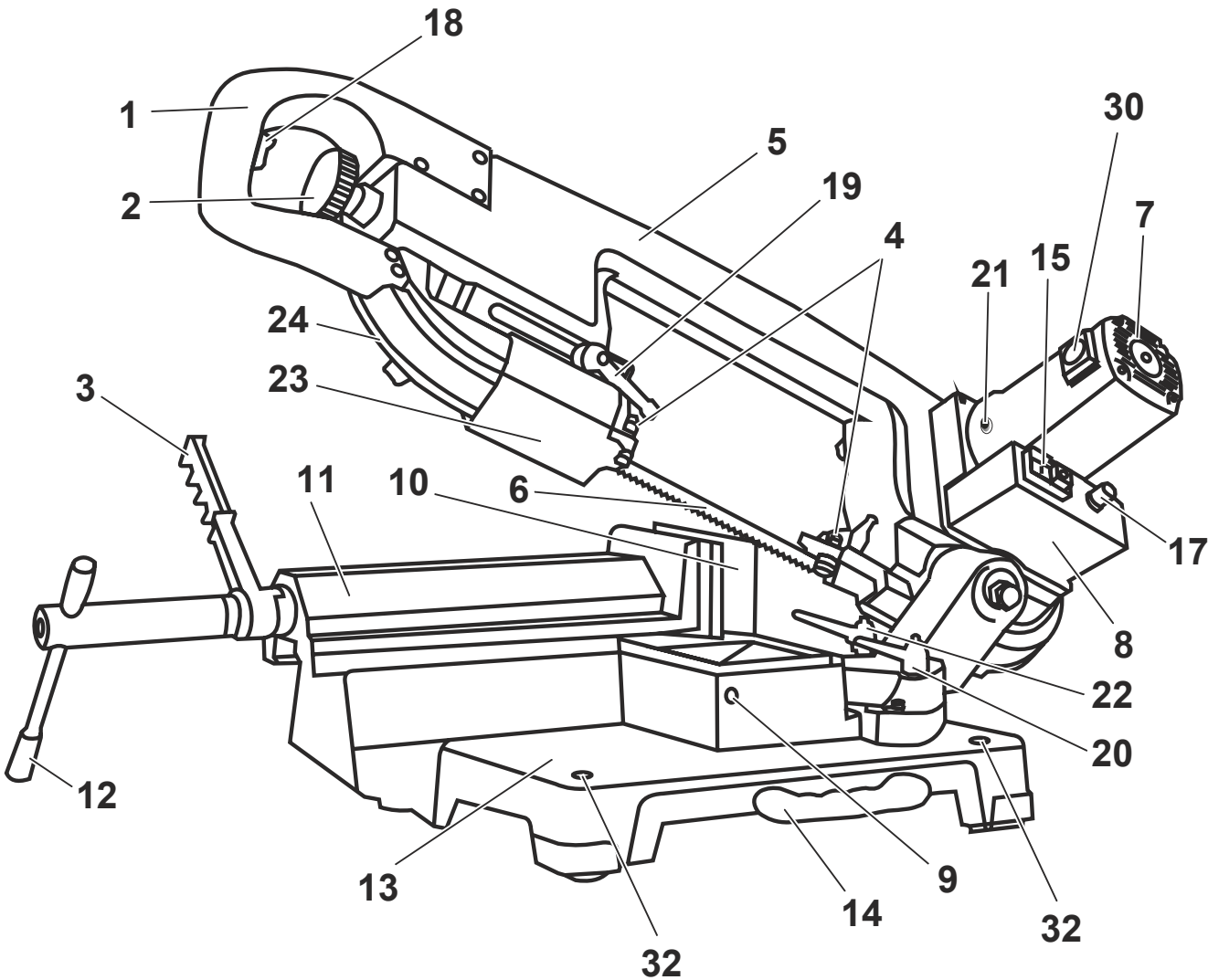
Le caratteristiche si riferiscono a tensioni nominali [U] 230/240 V ~ 50/60 Hz - 110/120 V ~ 60 Hz. In caso di tensioni minori ed in caso di modelli speciali a seconda dei Paesi, le caratteristiche riportate possono essere divergenti. Si prega di tenere presente il codice prodotto applicato sulla targhetta di costruzione del Vostro elettrooutensile. Le descrizioni commerciali di singoli elettrooutensili possono variare.

The values given are valid for nominal voltages [U] 230/240 V ~ 50/60 Hz - 110/120 V ~ 60Hz. For lower voltage and models for specific countries, these values can vary. Please observe the article number on the type plate of your machine. The trade names of the individual machines may vary.

Ces indications sont valables pour des tensions nominales de [U] 230/240 V ~ 50/60 Hz - 110/120 V ~ 60 Hz. Ces indications peuvent varier pour des tensions plus basses ainsi que pour des versions spécifiques à certains pays. Respectez impérativement le numéro d'article se trouvant sur la plaque signalétique de l'outil électroportatif. Les désignations commerciales des différents outils électroportatifs peuvent varier .

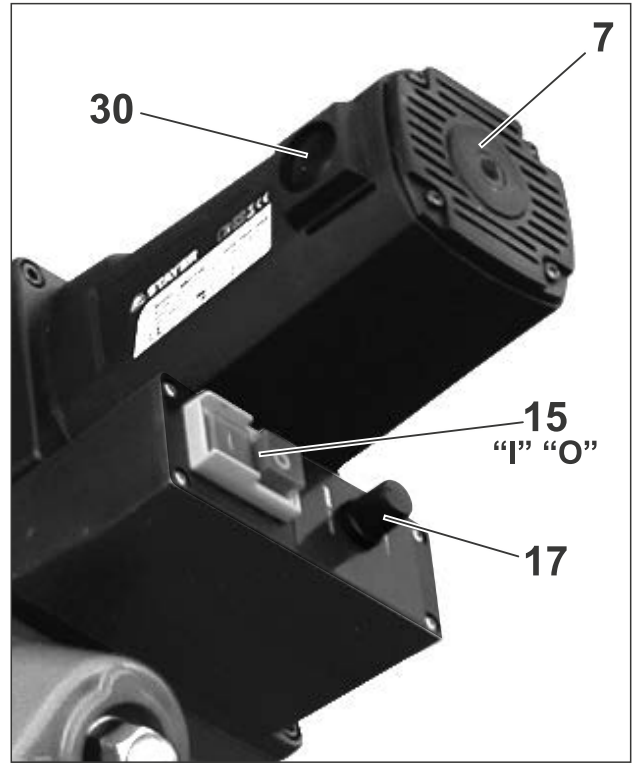
As indicações só valem para tensões nominais [U] 230/240 V ~ 50/60 Hz - 110/120 V ~ 60 Hz. Estas indicações podem variar no caso de tensões inferiores e em modelos específicos dos países. Observar o número de produto na sua ferramenta eléctrica. A designação comercial das ferramentas eléctricas individuais pode variar.

SN1435B / SN1470 / SN1735 / SN180





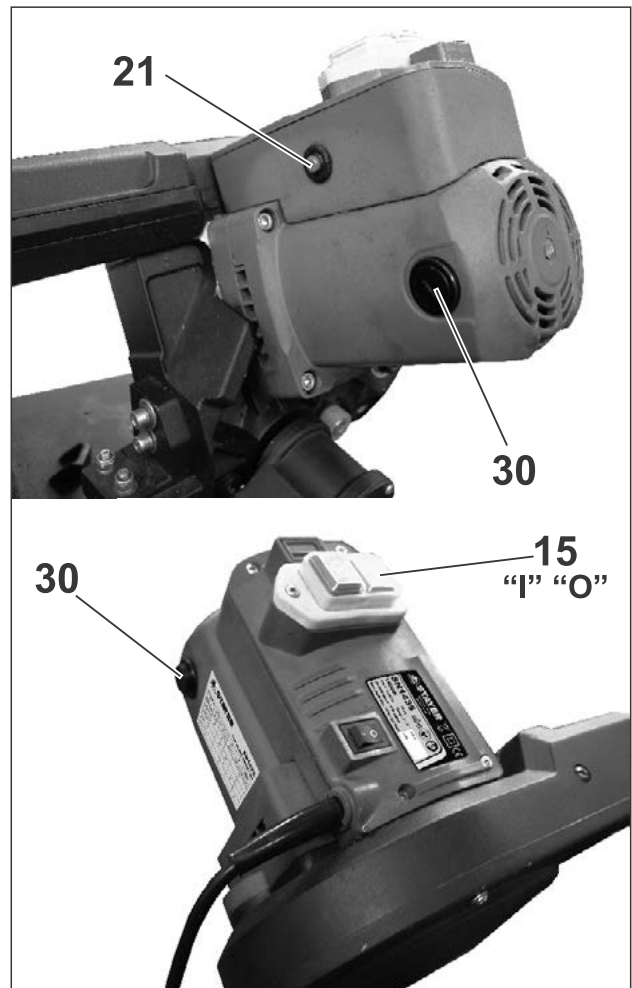
SN1470



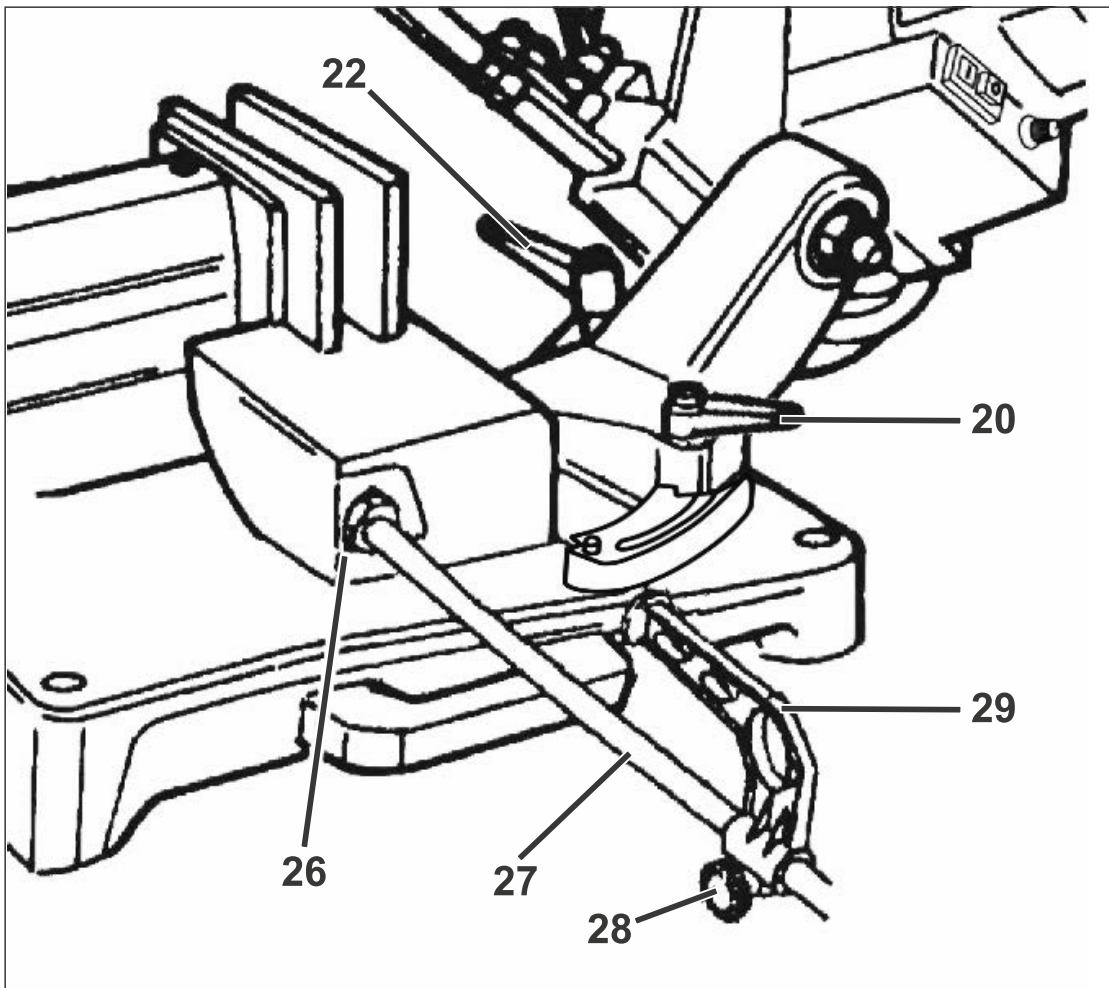
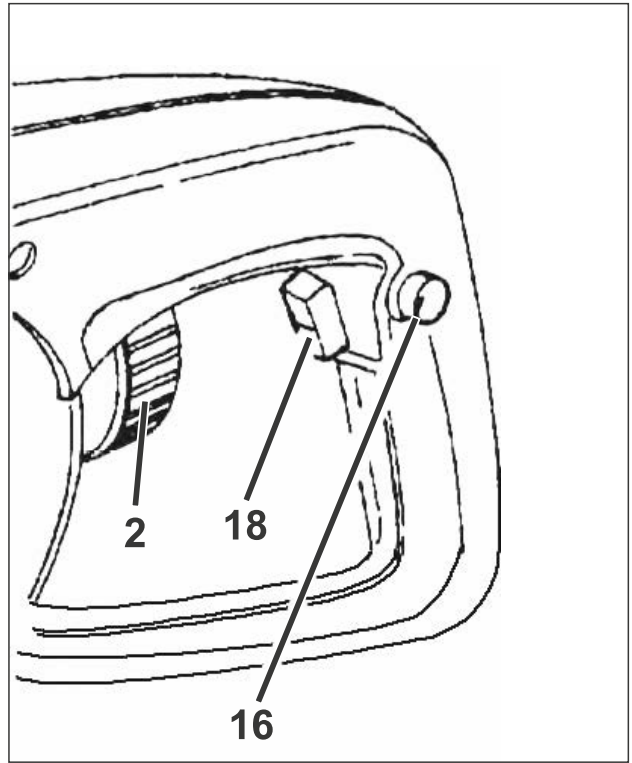
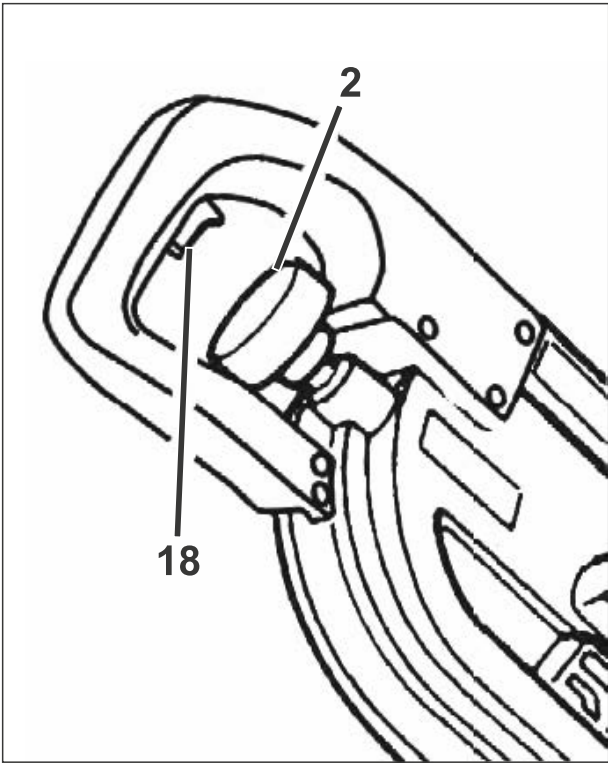
SN1735



SN1435B



SN1435B



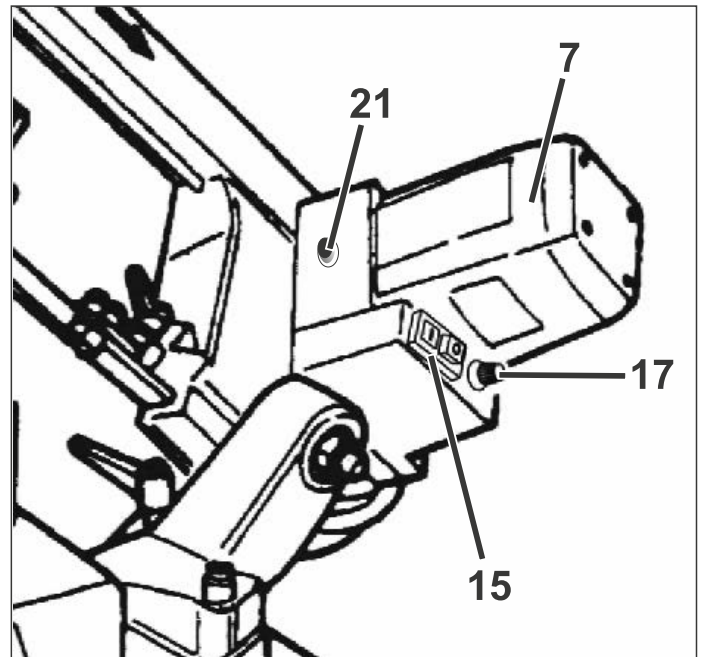
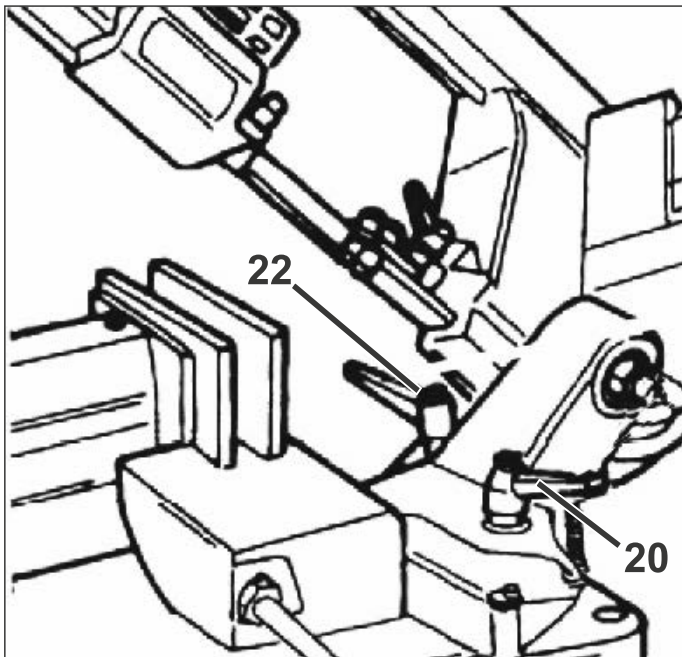
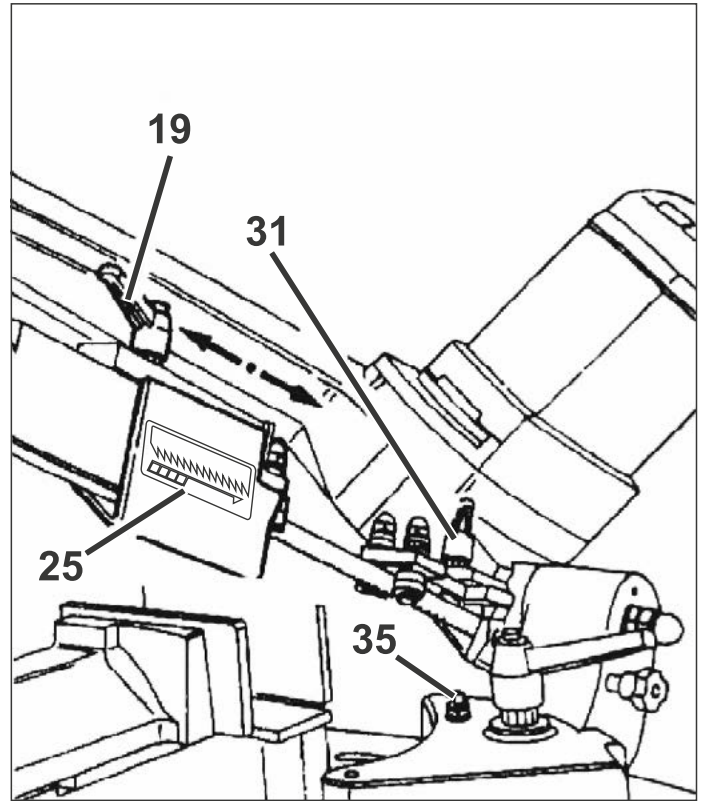
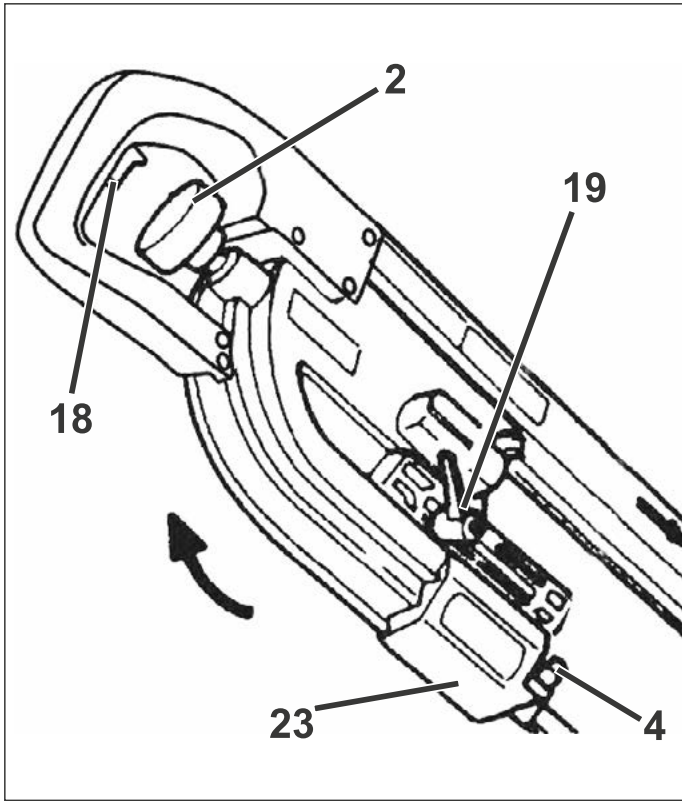


FIG. A

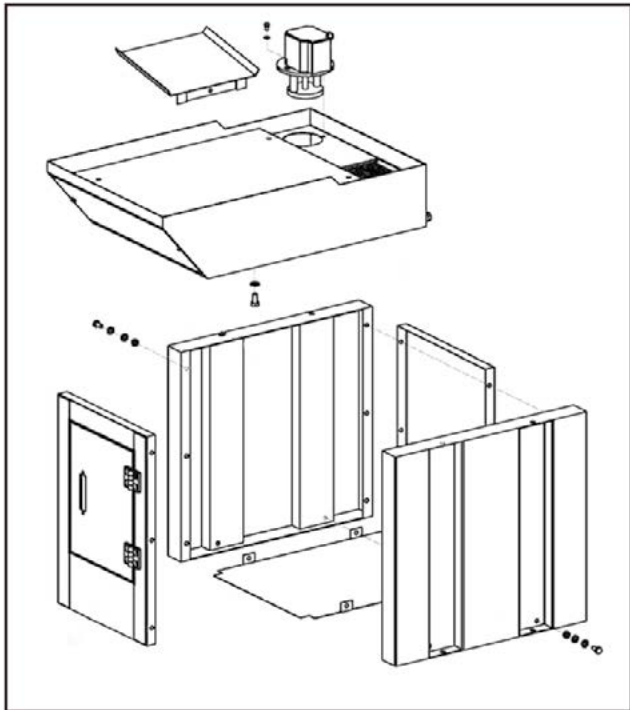


FIG. B

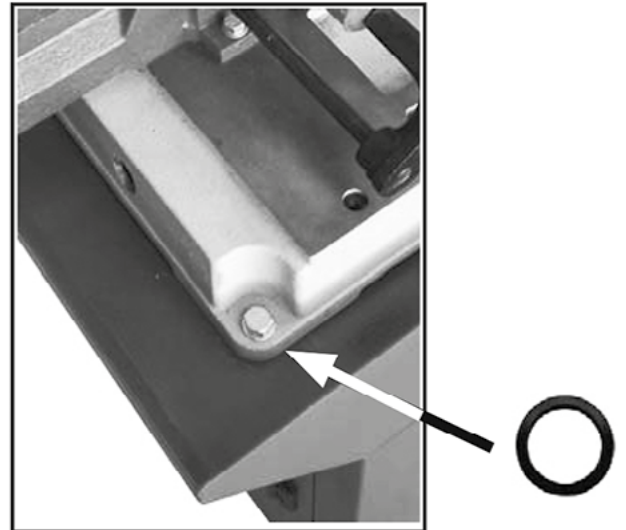


FIG. C

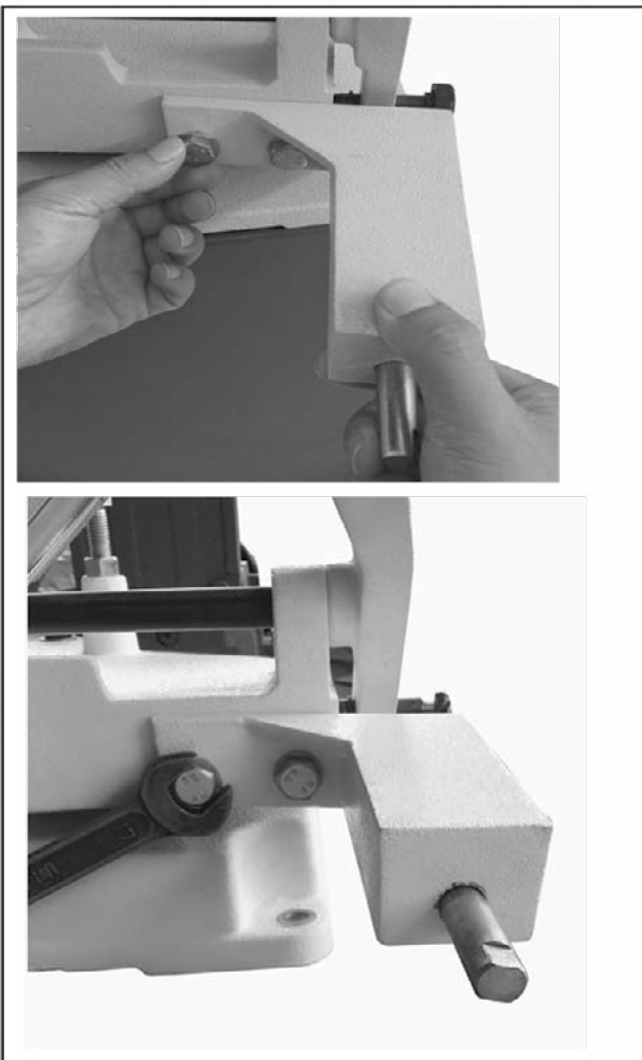


FIG. D

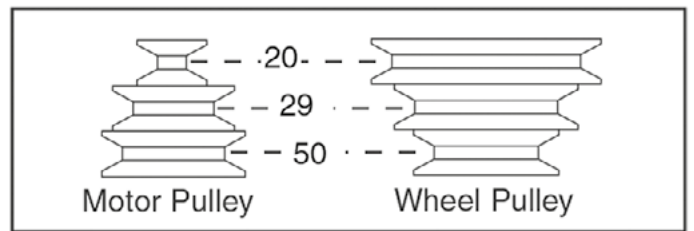
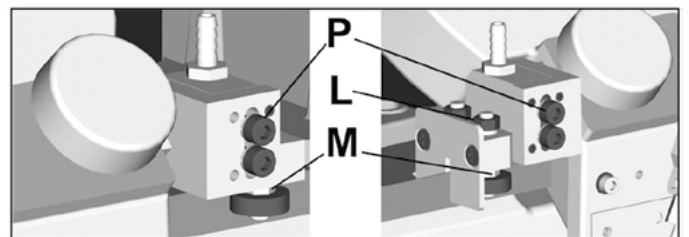


FIG. E



This manual is consistent with the date of manufacture of your machine, you will find information on the technical data of the machine acquired manual check for updates of our machines on the website: www.grupostayer.com

Thank you for purchasing a STAYER product! Congratulations for choosing the STAYER Band Saw! We are sure this modern tool will fulfil your expectations completely.

The tool is capable of fulfilling all the cutting demands regarding the metals most used in the industry, designed to cut common steel, aluminium (and its alloys), brass, bronze, steel tubes, plate and aluminium profiles.

This saw is manufactured to carry out dry machining, with the use of lubricants or coolants in the machine meaning it could be damaged beyond repair.



It is imperative you read this instruction manual carefully before using the tool in order to ensure an appropriate operating and performance of your new Band Saw and to protect your own safety.



Take particular care when observing all the safety precautions! Not observing these precautions could lead to serious injuries or even death!

Packaging



Your STAYER Band Saw will be handed over in a protective cardboard box avoiding any damages during its transport.



Cardboard is a basic raw material and, therefore, reusable and appropriate for recycling (recycled used paper).

1. Particular safety instructions

Read all the safety and indications and the instructions.

- Ensure no blades are used with a damaged or deformed band saw.
- Ensure saw blade and speed selected are appropriate for the material to be cut.
- Keep the cutting area clean from production waste.
- Always use the grip, the parts to be sawed must always be tightly held.
- Always keep hands at a distance from the work area while the machine is operating, always releasing the holder on/off pushbutton before performing any loading or unloading task.
- Do not unnecessarily force the machine, excessive cutting pressure may cause the blade to wear down quickly and worsen the performance of the machine with regard to cutting finishing and precision
- Always wear appropriate personal protection equipment (ear protection, mask, gloves, etc.)



2. Start-up Instructions

2.1 Tool Placement

Place the machine on a sufficiently firm workbench to achieve maximum possible stability. Keep the machine in an appropriate work area in well-lit and appropriate environmental conditions.



Always remember general work environment conditions are essential to prevent accidents from occurring.

2.2 Power Connection

Connect the machine to an electricity installation that is appropriate and in accordance with the local regulations. Use a certified electrician to make the installation. Model SN1470 requires correct earthing including its differential switch.



An incorrect conductor/earth connection of the equipment may result in electricity shock risks.

2.3 Illustrated Description of the Functions

1. Handle.
2. Blade tension tightening knob.
3. Fast grip tightening handle (SN1735).
4. Blade guide.
5. Machine/saw frame body.
6. Saw blade.
7. Motor.
8. Control box.
9. Cutting buffer housing.
10. Support plate.
11. Grips.
12. Grip operating handle.
13. Base.
14. Handles (SN1470-SN1735).
15. Switch (SN1435B-SN1735).
16. Safety button (SN1735).
17. Electronic speed regulator (SN1735).
18. On/off pushbutton.
19. Guide fastening handle (SN1735).
20. Degree blocking handle.
21. Thermal protector (SN1435B).
22. Machine body fastening knob.
23. Protective casing (SN1470-SN1735).
24. Pulley cover.
25. Band saw guide/orientation arrow.
26. Cutting buffer adjustment washer.
27. Cutting buffer.
28. Cutting buffer rod adjustment wheel.
29. Cutting buffer retainer.
30. Brush cover.
31. Back handle (SN1735).
32. Machine fastening holes.
33. Electronic switch.
34. Eccentric washers/grub screws (SN1735).
35. Cutting depth buffer.
36. Eccentric control.

3. Operating Instructions

3.1 Placement and Tests

Install the machine on a flat surface. Fasten the machine by means of 3 or 4 bolts fitted in holes 32 of the machine base.

Ensure blade 6 is tightened sufficiently for it to penetrate without swaying on the piece to be cut. Tighten tensor 2 if this is not so. Perform a trial on a piece to be discarded.

Press general switch 15 into position "I" (Note: only in models SN1435B-SN1735), in such a way the machine is ready to operate.

Mounting the SN 180

Assemble the bench using the diagram (see **FIG. A**) as a guide, joining the parts together with the supplied M8x16 screws.

(See **FIG. B**): Use the 4 M10X30 screws provided by inserting the supplied packing grommets.

Cutting Arm Recovery Spring Bracket Mount: Refer to (**FIG. C**) using two supplied M10x20 screws.

Cutting Operation



Ensure all the protections are complete and in the right position before commencing each cutting operation.

Always keep hands at a distance from the cutting area and refrain from exposing them to the area of exposure during cutting operations. Always release pushbutton 18 and do not attempt to block it between each cut (in the part placement stage).

To cut press on/off pushbutton **18** and gradually lower saw frame **5** pressing holder **1** until placing saw blade **6** in contact with the part to be cut. Do not force the advance of the cut. Simply push enough to perform a clean and efficient cut.

Only for model SN1735. To turn on press safety block button **16** before pressing pushbutton **18**.

Only for mod. SN1435B:

If the machine after a long period of use or in overload, this means the thermal protector of the motor has intervened to avoid any damage.

In this case, wait for a few minutes and press **15** into position "I" and manually activate button **21**.

Models SN1735 and SN1435B are provided with electronic speed regulator **17** to adapt the work to the cutting characteristics.

Use more moderate speeds for harder and more solid materials. Model SN1435B has electric switch **33** to select between 2 speeds (35m/min- 70m/min).

3.2 Tool Change



Always wear protective gloves when performing this operation to avoid any contacts with the teeth of the saw blade. Ensure the machine is disconnected from the mains and that switch 15 is in position "0".

Cutting Blade Extraction



WARNING! In model SN1735 it is necessary to previously disassemble protective casing block 23 in order to change the blade.

- Loosen handle **19**.
- Remove the front guide.
- Assemble the blade on the back guide and then the pulleys.
- Tighten 1/2 a turn to then place the front guide and tighten.

Cutting Blade Placement

- Choose an appropriate saw blade for the work to be performed. HSS blades are recommended with the number of teeth according to the thickness and type of material. Use the table included on the machine body to select the correct blade.
- Place saw blade **6**. Place the saw blade with the teeth in the position according to label **25**. First place blade **6** between the guides and then on the pulleys.
- Tighten saw blade **6** with knob **2**.
- Assemble and tighten protection cover **24** with its screws.

Motor Brush Change (Models SN1435B-SN1735)

- Unscrew and remove brush covers **30**, found on both sides of the machine.
- Remove the brushes.
- Change the brushes for new ones (always change the two).
- Replace covers **30** and ensure they are tightened.

3.3 Adjustment Operation

Speed.

As general orientation to hardness slower speed and vice versa. A hard, stainless steel or tool will cut better at about 20m / min. A medium steel at about 29 m / min.

And soft material like aluminum, soft broek or plastic can be cut at high speed.

Change of speed in the SN 180. It is made by changing the position of the pulley. See (**FIG D**) to see the three speeds available.

Saw Blade Tension Adjustment

The machine is provided with a saw blade tightening device which adjusts the tension of cutting blade **6**.

Ensure blade **6** is tightened sufficiently for it to penetrate without swaying on the piece to be cut. Tighten tensor **2** if this is not so. Perform a trial on a piece to be discarded.

Turn knob **2** clockwise to tighten the saw blade.

Model SN1470 only has two positions in control 2, up to loosen and change the blade and down to tighten the blade.

Cutting Angle Adjustment

To cut from 0° to 45°, loosen knob **22** (model SN1735 has additional knob **20**) and turn saw frame body **5** to the left until selecting the angle desired from the scale indicated. Once selected set the frame by tightening knob **22**.

Cutting Angle Calibration

You can verify and, if necessary, adjust 0° to 45° for cutting by using a set square between 90° and 45°. The adjustment points are eccentric washers grub screws **34** (model SN1435B).

Cutting Depth Calibration

Turn cutting depth buffer screw **35** to obtain a full cut of the part worked on without the blade advancing too far or damaging the part support strip (models SN1735 and SN1470).

Blade Right Angle Calibration

Models SN1735 and SN1470 act on eccentric control **36** of the guide rollers to obtain a totally straight cut at right angles to the cutting surface. It is recommended an official technical service performs this adjustment.




In model SN 180 (See **FIG. E**) to adjust the straight cut. Loosen the screw **L** to adjust the perpendicularity by acting on the eccentric **M**. Apply the Allen screws **P** to ensure a distance of at least 0.3mm with the band saw.

Fixed Cut Distance Buffer Adjustment

Only applicable to model SN1735. If parts are to be cut with the same measurements, use the cut buffer formed by parts **26**, **27**, **28** and **29**.

Screw rod **27** in hole **9** securing it with nut **26**; loosen wheel **28** and place retainer **29** at the distance necessary from saw blade **6**; tighten wheel **28** once again (only mod. SN1735).

Part Size Limit

Cutting capacity (mm)				
SN1435B	90°	∅125	125	125x127
	45°	∅80	80	80x100
	60°	∅45	45	45x60
SN1470	90°	∅100	100	100x150
	45°	∅75	63	63x100
SN1735	90°	∅160	155	170x150
	45°	∅120	120	120x100
SN180	0°	∅128	100	125x150
	45°	∅95	90	75x95
	60°	∅44	40	44x56

3.4 General Use Instructions



Failing to carry out the correct running in procedure implies unavoidably compromising saw blade cutting precision.

Running In

In order to achieve a better performance, the saw blade, forming part of the machine, should undergo a short running in procedure. Therefore, it is necessary to perform the first 2 or 3 cuts on a full piece with ∅ 40-50mm, pressing softly on the part, slowly increasing this in successive cuts.

4. Maintenance and Service Instructions

4.1 Cleaning

Disconnect the plug from the main socket before commencing any maintenance operation on your machine.

Always wear personal protection means (glasses and gloves) during maintenance operations.

Eliminate the residual shavings from production whenever necessary, acting on the cutting area and on the guide/blade. The use of a vacuum cleaner or a fine brush is recommended.

Do not use compressed air due to the risk of harm caused by shavings being projected.

If the band saw is not to be used for a long period, clean and store it in a dry place. It is also recommended to loosen the saw blade in order not to keep it tight for no purpose.

4.2 Repair service

Our after-sales service responds to your questions concerning maintenance and repair of your product as well as spare parts.

Exploded views and information on spare parts can also be found under: info@grupostayer.com

Our customer consultants answer your questions concerning best buy, application and adjustment of products and accessories.

4.3 Warranty

Warranty card

Included in the documentation that accompanies this equipment, you should find the warranty card. You should fill out the card completely and return to vendor with a copy of purchasing receipt or invoice and you should receive a receipt.

Note: If you cannot find the warranty card within the documentation, you must ask for it through your supplier.

The warranty is limited only to manufacturing defects and expire if pieces have been removed or manipulated or repaired other than the manufacturer.

4.4 Disposal and recycling

The machine, accessories and packaging should be sorted for environmental-friendly recycling.

Only for EC countries:

Do not dispose of power tools into household waste!






According to the European Guideline 2002/96/ EC for Waste Electrical and Electronic Equipment and its implementation into national right, power tools that are no longer usable must be collected separately and disposed of in an environmentally correct manner.

Subject to change without notice.

5. Regulations

5.1 Technical Data

P_1	= Power input.
V_1	= Speeds.
H_1	= Saw blade.
D_{max}	= Diameter cutting capacity.
	= Weight.
	= Protection class.
L_{WA}	= Sound power level.
L_{PA}	= Sound pressure level.
	= Vibration.

5.2 EU declaration of conformity

The undersigned: STAYER IBERICA, S.A.

With address at:

Calle Sierra de Cazorra, 7
Área Empresarial Andalucía - Sector 1
28320 PINTO (MADRID)
Tel.: +34 91 691 86 30 / Fax: +34 91 691 86 31

CERTIFIES

That the machine:

Type: **BAND SAW**
Models: **SN1435B / SN1470 / SN1735 / SN180**

I declare under our responsibility that the product described under "Technical Data" is in accordance with the following standards or standardized documents: UNE EN 60745-2-20:2010, UNE EN 61029-2-5:2012 according to regulations 2004/108/CE, 2006/42/CE.

CE  RÖHS

Ramiro de la fuente
Managing Director

January, 2017



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