



Woodworking Multi-blade Rip Saw MJF142A-0630

OWNER'S MANUAL



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1. Safety operating rules and precautions

Dear customer, thank you for using our products. Before using this product, please read this manual in detail and pay attention to the following matters:

1. Before using the machine tool, the relevant personnel should first read this manual in detail to understand the installation, operation and adjustment of the machine tool, so as to avoid the damage of the machine tool or the occurrence of accidents.
2. When installing the machine tool, it is required to check whether the electrical circuit is firm and the electrical components are out of order. The machine tool must be well grounded to ensure personal safety;
3. Before using the machine tool, check whether all parts and components are in good condition. If broken, please replace it immediately to ensure the normal using function of the machine tool.
4. The saw blade used and other parts should be suitable. Please do not use the parts that go beyond the original design function of the machine tool;
5. Please keep the workplace clean and orderly. Dirty and disorderly working environment is easy to cause accidents;
6. Dress appropriately and work clothes should be worn at work;
7. Flying objects may affect or do harm to human organs. Before operating the machine tool, please first make sure relevant operators have worn protective glasses and other labour protection appliances
8. Before operating the machine tool, please remove the wrench and other tools first to avoid accidents.



9. Before operating the machine tool, the relevant personnel should clearly understand the feeding direction of the machine tool and the area where the work piece bounces off (See figure 1-1 for details).

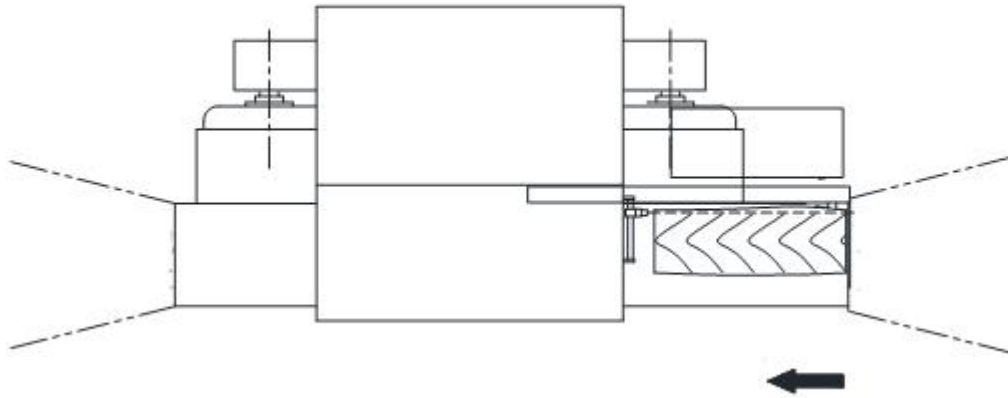


Figure 1-1 (This drawing is only a sketch map, please refer to the actual sample)

10. When using the machine tool, the operator and personnel on site shall not stand directly in front of the inlet and outlet of the workpiece to avoid personal injury caused by the workpiece's discharge or rebound (see figure 1-1 for details).

11. When using the machine tool, it is strictly forbidden to open the front door to prevent injury.

12. When putting, pushing or receiving materials, do not put your hand between the workpiece and the work table (feeding frame) to avoid pinching your finger.

13. It is required to clean and maintain the machine tool before and after using it.

14. Before replacing the saw blade or carrying out maintenance and cleaning of the machine tool, please be sure to cut off the main power supply and do not rotate the main shaft to avoid injury to the operator.

15. Accidents are easy to happen in the workplace. Please turn off the main power



before the machine is stopped or left, so that the machine completely stops.

16. It is strictly forbidden to carry out any experimental operation or the operation that goes beyond the original design function of this machine tool. If you have any question, please contact us.

17. We shall not be responsible for any accidents that occur without strict compliance with the above operating procedures.



2. Machine tool introduction and operation instructions

2.1 Machine tool introduction

This machine tool is mainly designed for dry woods below 60mm. It is equipped with a dust suction inlet and a frequency converter; it can process medium soft wood beam and the saw mouth is only 1.4mm; it can feed materials smoothly; the processing speed is fast speed and with high precision; the lifting and descending of hand wheel is convenient and fast.

2.2 Main parameters of machine tool

Model	MJF 142A-0630	
Maximum thickness	25/32"-2 23/64"	20-60mm
Minimum length material	17-23/32"	450mm
Maximum width	11-13/16"	300mm
Saws	6-11/16" dia	170mm dia
Spindle	1-31/32" dia × 4450rpm	50mm dia × 4450rpm
Main motor	30 HP	22kw
Feed motor	2 HP	1.5kw
Vari-speed feed	0~ 78-47/64"/min	0~20m/min
Top feed rolls	rise & fall 1/2 HP	rise & fall 0.37kw
Dust collection	15/32" dia	12mm dia
Dimension	94-31/64" × 47-1/4" × 57-3/32"	2400mm × 1200mm × 1450mm

Table 2.2-1 Main parameters list of machine tool



(The product is constantly improved. When the machine tool parameters change, please refer to the actual samples.)

2.3 Main structure of machine tool

The machine tool is mainly composed of the body part, the main shaft working part, the feeding part, wood sawing base part and the electrical part. The body part is mainly composed of a base, a frame, a backstop and a cover; the main shaft working part is mainly composed of main shaft box, main shaft assembly, spacer sleeve, saw blade, main shaft nut, pulley and v-belt; the feeding part mainly consists of feeding motor, chain, chain wheel and feed roller. The base part of wood sawing is mainly composed of working table board and infrared device. The electrical part is mainly composed of an electrical box, the electrical operation buttons and electrical components.

2.4 Installation, use and adjustment of machine tool

2.4.1 Machine tool installation

I. Machine tool placement

The machine tool should be placed on a flat horizontal ground. A flat horizontal ground can make the machine tool work more smoothly, reduce the vibration and noise of the machine tool, and ensure the safe use of the machine tool.

II. Power cable access

The following items must be confirmed before the power cable is connected: The power supply voltage must be consistent with the motor voltage; the minimum cross-sectional dimension of the power phase line and the neutral wire should be



determined according to the total load current of the machine tool; the machine tool must be grounded.

Then the power cable should be connected to the main power switch of the machine tool. After the power cable is connected, start up the machine tool to have a test run and check whether the rotation direction of the saw shaft and the rotation direction of the feed roller are correct, and if there is any mistake, it should be adjusted.

III. Dust collection device connection

Connect the suction inlet (diameter: 120mm) to the dust collect plant.

2.4.2 Installation and use of saw blades

When installing (replacing) the saw blade, it is required to wipe clean all the saw blades, spacer sleeves and others first, and pay attention to the rotation direction of the saw blade. When installing the saw blade, the saw blade which is relative to the saw shaft should be flush. If there is any irregularity, it should be adjusted, otherwise the board surface after sawing will be dislocated. When adjusting, it is required to loosen the locking bolts at both ends of the spindle seat first , and then adjust the fine-tuning bolts so that the corresponding saw blade end faces are in the same straight line; it will be ok to tighten the lock bolt after adjustment. After the saw blade is installed, it should be started up and run for 10 minutes. If there is no abnormality, wood saw cutting can be carried out.

Note: Before installing (replacing) the saw blade, the main power must be turned off first for safety.

2.4.3 Machine tool adjustment



I. Sawing cutting benchmark adjustment

When sawing the woods, the straight and short wood with a datum plane or that within one meter shall be sawed on the baseline of the workbench plate. For those woods without datum planes or natural width, infrared can be used as a baseline for sawing. Before using infrared ray, you should adjust accurate infrared ray first. When adjusting, the infrared rays should be moved to align the location used as saw road (The innermost piece of saw blade usually be used as the base point and it should be paralleled to the saw blade), and the infrared rays should be fixed after being adjusted.

II. Adjustment of upper press roller height and pressure

Before saw cutting the wood, the height and pressure of the upper press roll should be properly adjusted. When adjusting the height of the upper press roller, the operator only needs to shake the lifting hand wheel to make the upper press roller reach the appropriate position (Generally speaking, the height of the upper press roller should be less than the thickness of the processed wood by 10mm or so, that is to say, compared with the situation in which the wood is not pressed by the upper press roller, the upper press roller should increase by 10mm when the wood is pressed).The pressure adjustment of the upper press roller can be realized by adjusting the adjusting nut (Generally, the thicker the wood, the greater the pressure of the upper press roller will be).

2.4.4 Machine tool operation

Before operating the machine tool, please first understand the function of each operating button (knob) on the machine tool, and try to operate to understand the specific action of the machine tool. When operating the machine tool, the machine tool should be left to have a free-load running for 10 minutes. If there is no



abnormality, it can be started to saw-cut the wood.

When saw cutting the wood, taking the working table panel or infrared ray as the baseline, the operator should put the wood on the working-table first, and then push the wood to the internal feed roller of the machine tool, and after that the material will be fed by the feed roller automatically.

When an emergency occurs or woods get stuck, please press the emergency stop button to eliminate the situation. When unloading the materials, please first turn the backstop up before discharging.

Note: When using the machine tool, the operator and the personnel on site must not stand directly opposite the feed inlet and outlet of the work piece. And it is forbidden to open the front door; when putting, pushing or receiving materials, it is strictly prohibited put your hand between the work piece and the work table; please turn off the main power before you stop using the machine tool or leave it.

2.5 Lubrication and maintenance of machine tool

Regular lubrication and maintenance of machine tool can improve the performance of the machine tool and extend the service life of it. Therefore, the user should regularly lubricate and maintain the machine tool according to the following requirements.

I. Cleaning of the machine tool

After each shift, the entire machine tool should be cleaned. The sawdust and scrap left at the front of the machine must be cleaned up.

II. Lubrication and maintenance of major components

1). Maintenance of motor and reducer

The motor bearings should be maintained and refueled once a year. If the bearing



clearance is too large, a new bearing should be used for replacement. The maintenance of the reducer can be detailed in the operating instructions of the reducer.

2). Maintenance and protection of the main shaft

Main shaft is the most important part of the machine tool, so the maintenance and protection of it is of paramount importance. The main shaft bearing has been added with lithium grease before leaving the factory and it should be refueled every six months when it is used. In the early stage of use, the main shaft bearing is in the running-in phase, so its temperature will be a little high. (Usually the temperature rise will not exceed 40 degrees, and the maximum temperature will not exceed 70 degrees) After that, the temperature will gradually decrease and the main shaft will enter the normal use stage. With the increase of service time, the wear of main shaft bearing will exceed a certain degree, which can make the clearance of main shaft bearing become too large, causing vibration of main shaft and abnormal temperature rise. At this moment, the main shaft bearing should be replaced in time to ensure the machine tool performance. Main shaft bearing should be replaced by experience professionals.

3). Maintenance of transmission part

The chain drive at the rear of the spindle box must ensure that the chain will not be lack of grease to ensure sufficient lubrication, reduce the wear of the chain wheel and the chain, and extend the service life of them. Feeding bearings must be regularly lubricated.

4). Maintenance of the electrical parts

Soot blowing should be regularly conducted for the electrical box of the machine tool. When blowing soot, electric blower should be used. Do not use compressed air with moisture so as to avoid short circuit of electrical components.



Note: Before conducting the maintenance or upkeep of the machine tool, the main power must be turned off to prevent injury.

2.6 Causes of some common malfunctions and their elimination methods

No.	Malfunctions	Reasons		Processing method	
1	Burning saw blade	Dust collection device is out of order		Dispose in time	
		Saw blade is blunt		Grind or change a new saw blade in time	
		Power is insufficient	Belt is worn.	Replace it in time	
			Belt is too loose.	Tighten the belt	
		The feeding speed is too fast.		Decrease the feeding speed	
		The saw blade cannot be installed properly	Saw blades and spacers have not been cleaned up.		Clean up in time
			The processing of spacer sleeve is not balanced.		Dispose in time
		The leftover materials are jammed into the saw blade.		Clean up in time	
2	The surface of wood is not smooth and flat, and there is dislocation.	The saw blade is blunt.		Grind or change a new saw blade in time	
		The saw blade is not even.		Adjust to make the blade even and flat	



3. List of vulnerable parts

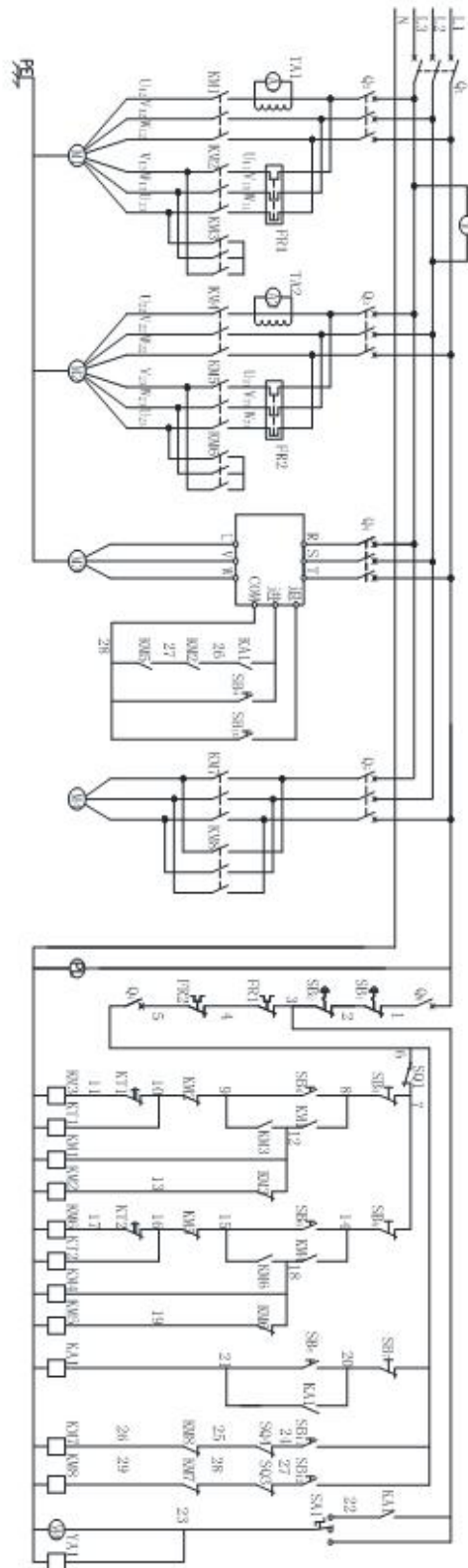
No.	Name		Specification	Quantity	Remarks
1	V-belt	MJF142A-0630	B2159/B2591	Each five	Random
					Random
2	Main shaft bearing	MJF142A-0630	6011	Each eight	Random
					Random
3	Saw blade	MJF142A-0630	$\phi 170 \times \phi 50$		

(The product is constantly improved. When the accessories change, please refer to the actual samples.)

4. Electrical schematic diagram

- Upper saw-shaft motor
- Bottom saw-shaft motor
- Feeding motor and inching forward and withdraw
- Lifting motor
- Power indicating emergency stop and motor protection
- Upper saw-shaft motor start and stop
- Bottom saw-shaft motor start and stop
- Feeding operation
- Compression roller lifting
- Cooling system automatic manual control

This picture is for reference only. If there is any change, please refer to the actual sample.





5. Packing List

No.	Name	Specification	Quantity	Remarks	
1	Main machine		One set		
2	V-belt	MJF142A-0630	B2591/B2159	Each five	Random
3	Infrared ray		One set	Random	
4	Solid wrench	17-19/22-24	Each one		
5	Ring spanner	27/30	One piece		
6					
7					
8	Internal hexagonal wrench		One set		
9	Tool cabinet		One		
10	Booster pump	370W	One set	Random	
11	Solid ring spanner	21-21	One piece		
12	Bolt	φ10	One piece		
13	Decelerator Manual		One		
14	Operating manual		One		
15	Packing list		One		
16	Product qualification certificate		One		

(The product is constantly improved. When parts are changed, please refer to the actual samples.)

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