

HAFCO-METALMASTER BS-13DS



Semi - Automatic, Swivel Head-Dual Mitre Metal Cutting Band Saw

Variable Cutting Speeds, Dual Mitre Cuts Up To 60°, Laser Line Guide, Hydraulic Vice Clamping & Includes Hydraulic Downfeed Control



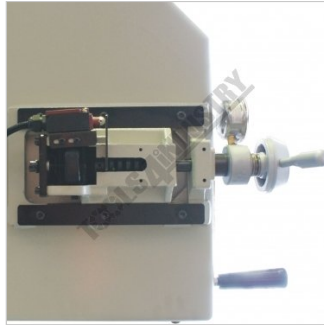
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Control Panel



Blade Tension Gauge



Blade Breakage Sensor



Laser Light Guide



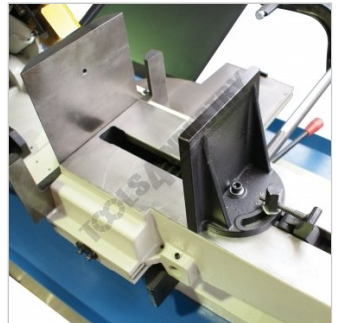
Vice Pressure Regulator



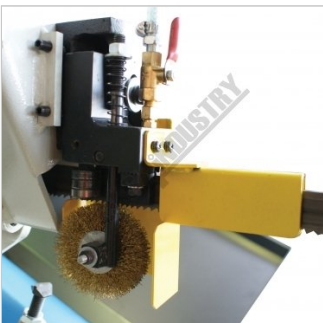
Hydraulic Vice



Sliding Vice For Dual Mitre



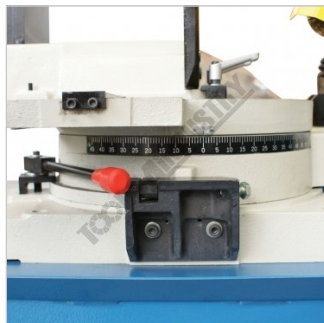
Quick Action Vice



Blade Cleaning Brush



Carbide Blade Guides with Bearings



Swivel Head Locking Handle



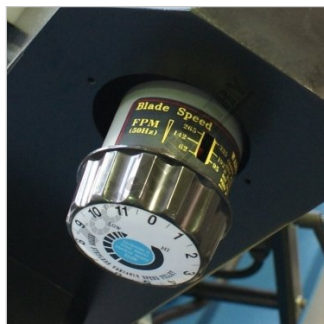
Swivel Head



Beam Height Setting Stop



Coolant Cleaning Gun

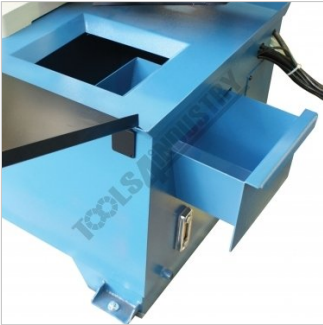


Variable Blade Speed Dial



Safety Blade Guard Micro Switch

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Slide Out Swarf Tray



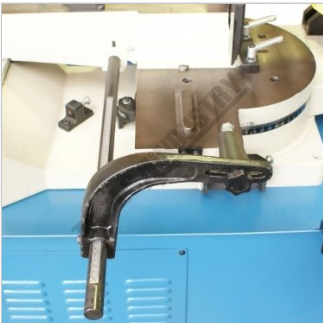
Hydraulic Feed Ram with Spring Dampener



Coolant to Blade Guides



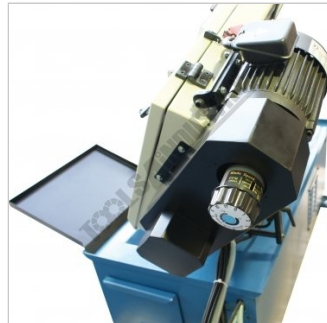
Double Mitre Vice



Length Stop



Motor



Rear View



Swarf Tray

MAKE PROPER TOOTH SELECTION										
mm	30	75	100	150	200	250	300	350	400	450
mm	4.5	5.5	6.5	7.5	8.5	9.5	10.5	11.5	12.5	13.5
mm	2	3	3.5	4	4.5	5	5.5	6	6.5	7

CUTTING SPEED RATE RECOMMENDATION									
Material	Speed (m/min)	Material	Speed (m/min)	Material	Speed (m/min)				
Carbon Steel	196 - 254 (1000)	Tool Steel	200 (100)	Alloy Steel	111 - 321 (100)				
Alloy Steel	180 - 220 (540 - 671)	High-Speed Steel	210 - 119 (130 - 140)	Weld Steel	246 (75)				
Aluminum	180 - 220 (540 - 671)	Cold Chisel (Tool Steel)	160 - 113 (129 - 85)	Welder Head Tool Steel	240 (74)				
Aluminum Alloy	220 - 524 (1000 - 1000)	Stainless Steel	85 (100)	Marine Cast Iron	80 (100)				
Copper Alloy	220 - 480 (1000 - 1000)	Cr Stainless Steel	85 - 203 (100 - 100)	Plastic	220 (100)				

Tooth Selection-Recommended Cutting Speed Rate Chart

Description

Manufactured in Taiwan

The BS-13DS Industrial duty metal cutting band saw has many features on offer with a double mitre swivel head to cut mitres up to 45 degrees left and 60 degrees right with a variable blade speed system, hydraulic feed control a cutting capacity of up to 330mm diameter or 458 x 235mm in steel at 90° and three ball bearings per side with carbide blade guides for optimal control and accuracy. There is a choice of blade speeds via an adjustable dial system so that the cutting speed can be changed to suit a wide range of materials, whilst the built-in coolant system ensures maximum cutting efficiency and longer blade life. Both blade control arms are adjustable, allowing them to be positioned as close to the cut as possible. This means reliability and accurate cuts!

The cutting operation works automatically with the weight of the head providing the cutting force and a limit switch shutting the machine down when the cut is complete and automatically returning to set height position. The weight of the head is counter balanced by an adjustable hydraulic damper to control the feed rate, an excellent machine choice for maintenance shops, steel fabrications, and industrial engineering workshops. If you're looking for this size range of machine, you'll have a tough time finding a better metal-cutting band saw with these features and at this price. It

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represents excellent value.

Features

- 458 x 235mm (W x H) rectangular capacity
- Double mitre swivel head for easy angle cutting without moving material
- Semi-automatic operation, machine returns to open height position after finishing the cutting process
- Automatic hydraulic vice incorporated with a manual hand wheel
- Adjustable hydraulic vice pressure regulator
- Hydraulic operated system raising and lowering the cutting beam
- Adjustable hydraulic feed cutting rate for multiple applications
- Blade breakage sensor fitted that automatically shuts machine off
- Mitre cuts to 45° right & 60° left using swivel head
- Built-in coolant system for maximum cutting efficiency with wash down trigger
- Laser line guide assist in lining up material positioning
- Adjustable variable blade speed system enabling 19-102mpm cutting speeds
- Limit switch stops machine and raises cutting beam when cut is complete
- Swivelling electric control panel mounted on base for quick operation
- Combination roller bearing & carbide blade guides
- Heavy duty cast iron blade wheels
- Large mitre scale - easy to read
- Cast Iron frame with heavy duty fabricated base
- Adjustable blade roller guides provides accurate cutting
- Adjustable length stop for repetition cutting
- Wire wheel brush to clean swarf from blade
- Industrial-duty gearbox driven by a 1.5kW / 2hp 415V motor

Specifications

ORDER CODE	B030
MODEL	BS-13DS
Operation Type	Swivel Head - Dual Mitre Semi - Automatic
Round @ 90° (mm)	330
Round @ 45° (mm)	330
Round @ 60° (mm)	204
Square @ 90° (mm)	330
Square @ 45° (mm)	280
Square @ 60° (mm)	160
Rectangle (W x H) @ 90° (mm)	458 x 235
Rectangle (W x H) @ 45° (mm)	310 x 170
Rectangle (W x H) @ 60° (mm)	204 x 80
Coolant System	Yes
Table Working Height (mm)	840
Cutting Head Beam Type	Semi-Automatic
Cutting Head Beam Return	Auto-Hydraulic Return
Cutting Head Down Feed Control	Adjustable Hydraulic
Vice Clamping Fixture	Automatic-Hydraulic
Bundle Cutting Fixture	~
Blade Steps / Speeds (M/Min)	Variable 19-102

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Blade Size (L x W x T) (mm)	3810 x 27 x 0.9
Motor Power (kW / hp)	1.5 / 2
Voltage / Amperage (V / amp)	415
Nett Weight (kg)	600