

Apply: KENT330F-SL/ KENT440F-SL

Operating Instructions



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This machine original produced by BMT company, China
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Contents

1. User Information	3
1.1 General	3
1.2 Symbols and conventions	3
1.3 Symbols	4
2. Scope of Supply	5
2.1 Package contents	5
2.2 Unpacking the band saw	5
3. Product Liability	Error! Bookmark not defined.
4. Environmental protection	6
5. Safety	7
5.1 Meaning of the warnings	7
5.2 Intended use	7
5.3 General safety instructions	7
5.4 Information signs on the band saw	9
5.5 Covers	9
6. Structure and Function	10
6.1 Technical data	10
6.2 Structure	11
6.3 Function	Error! Bookmark not defined.
6.4 covers	Error! Bookmark not defined.
7. Putting into operation	14
7.1 Installing the band saw	14
7.2 Assembling the band saw	14
7.3 Setting & adjusting the band saw	15
7.4 controls on the band saw	22
7.5 Switch on the band saw	23
7.5 Switch off the band saw	25
8. Cutting food material	28
9. Servicing and maintenance	30
9.1 Changing the scrapers	31
9.2 Changing the saw blade	32
9.3 Cleaning the band saw	36
9.4 Hygiene plan	37
9.5 Electrical diagram	39
9.6 Fault Finding	40
10. Spare Parts	41
10.1 Spare Parts Drawing	41
10.2 Ordering spare parts	42
11. Confirmation on material definition	43
12. CE Declaration of Conformity EU	44

1. User Information

1.1 General

This operating instructions are part of the Band Saw with the serial number given on the machine plate.

The operating instructions must be kept close at hand at all times. It contains important information and instructions for safe, proper and economic use of the band saw. It must have been read and understood by each person before this person can be entrusted with the following work using the band saw:

- putting into operation,
- operating,
- servicing.

The operating instructions must be followed during all work on and with the band saw. Following them helps to prevent hazards, to reduce repair costs and to increase the reliability and life of the band saw.

The technical information and instructions for use in this operating instructions are up-to-date and correct on delivery of the band saw.

1.2 Symbols and conventions

Instructions

Sequences of actions, which must be carried out in the given order are given as a numbered list. Example:

- 1 Instruction step 1.
- 2 Instruction step 2.

Lists

Lists without a particular order that has to be followed are shown as a list with bullet points or indent markings. Example:

- Property A
 - Detail 1
 - Detail 2
- Property B

1.3 Symbols

Important or particularly useful information is highlighted by way of symbols so that it is readily recognised.

WARNING

This symbol denotes a warning, which must always be noted and followed.

For more information on the meaning of the warnings, refer to the Safety chapter



MANDATORY

This symbol indicates instructions, which must be complied with for safety reasons.



NOTE, TIP

This symbol denotes general information, which contains user tips and useful information.



WARNING

Warning of high electrical voltage



2. Scope of Supply

2.1 Package contents

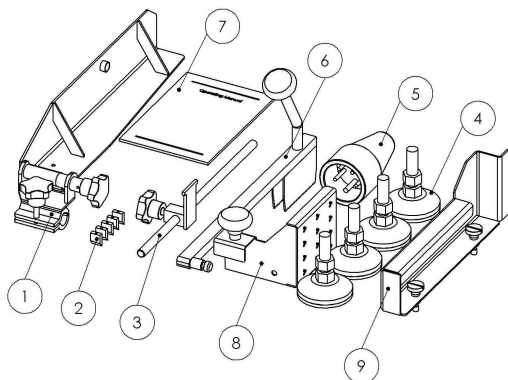


Figure 2.1 Package contents

[1] Portioning panel assembly	1 PCS
[2] Scraper plate (POM)	5 PCS
[3] Support bar assembly	1 SET
[4] Feet	4 PCS
[5] Power plug 16A	1 PCS
[6] Pusher Assembly	1 PCS
[7] Operating manual	1 COPY
[8] Rest material holder	1 PCS
[9] Push panel of sliding table	1 PCS

Note: some parts above has been installed in machine.

2.2 Unpacking the band saw

Unpack the band saw immediately after purchase and check whether it has any defects or transport damage. Also check the package contents for complete scope of supply.

Report any defects immediately. Complaints made at a later date can no longer be recognised.

Keep the invoice for the entire warranty period as proof of purchase. Before returning the product, wait for the manufacturer's reply in order to initiate the necessary steps.

**DAMAGE TO THE BAND SAW DUE TO
INCORRECT CONNECTION DATA NOT IN LINE WITH
THE SPECIFIED DATA**

Before starting up the band saw, compare the band saw's electrical data (see "6.1 Technical data") with the connection data on site.

3.Product Liability

All wearing parts are excluded from the guarantee.

For further details of the product liability and guarantee, please refer to our General Terms and Conditions of Sale, Delivery and Payment.

4.Environmental protection

Used machines, replacement parts and packaging are made of recyclable materials. The owner is obliged to dispose of them properly and in an environmentally friendly way, in accordance with the legal regulations.

5. Safety

5.1 Meaning of the warnings

In this operating instructions, a differentiation is made between warnings depending on the hazard:

DANGER



Imminent risk to life and the health of people.

- Causes serious injuries or death.

WARNING



Possibly imminent risk to the life and health of people.

- Could cause serious injuries or death.

CAUTION



Possibly dangerous situation

- Could cause minor injuries.
-

5.2 Intended use



The band saw is solely designed for commercial use. The Bone Band Saw is used for separating and portioning meat, bones, fish and other foods of any kind fresh or frozen.

The size of the meat to be processed must match with the proportions of the machine. The maximum height is limited through the cutting height passage. Products which hang over the left side of the table with more than 40% are not allowed to be processed.

Any other or additional use is deemed to be not as intended and therefore misuse.



The band saw may not be switched on or operated in potentially explosive atmospheres and is solely designed for use in dry rooms at temperatures between 2°C and 40°C.

Only original spare parts and accessories may be used.

The owner is responsible for any damage caused by misuse.

5.3 General safety instructions

WARNING**Risk of injuries due to incorrect handling**

Incorrect handling of the band saw can cause substantial injuries.

- The band saw may only be used by people who have read and understood the operating instructions, and have been instructed in the use of the safety equipment.
- The band saw may only be operated by people who are familiar with the putting into operation/starting up, operation, and servicing of machines and the relevant accident prevention regulations, who are able to recognise the hazards that occur during the band saw's use and who work reliably.
- The band saw may not be operated outside the given power ranges (see "6.1 Technical data").
- Operate the band saw only for the approved uses (see "5.2 Intended use").
- Safety equipment problems must always be rectified before the machine is used!
- The machine is only allowed to be used by trained personnel. Corrective training has to be done on a regular basis. People below the age of 16 are not allowed to work with the machine.
- Pay attention to the cleaning methods described within the hygiene plan.
- The maintenance work described within the maintenance instructions have to be observed and executed.
- Safety equipment has to be checked once a year by an expert on proper functioning.
- The machine must not be modified.
- The machine must be switched off immediately in the case of any malfunction! All malfunctions must be rectified before the machine can be used again.
- The machine is not allowed to be turned on in explosion-prone atmosphere.
- Only use original spares and accessories!

WARNING

- Before each transportation, switch off the band saw and remove the mains plug from the socket.
 - Safety equipment must never be removed, modified, manipulated or rendered ineffective by any other means!
-

Residual risks

Risks that are not completely eliminated by the safety equipment in place include:

- Danger with freewheeling saw blade (Adjust the height of the band threading path as tight as possible to the cutting material)
 - Interference with saw blade from the side
 - Getting hand caught between connecting link and sliding plate
 - Saw falling over
 - Potential human health risks and unacceptable changes to the foodstuff resulting from
 - Non-observance of the hygiene regulations and cleaning guidelines
-

5.4 Information signs on the band saw

[1] Logo of brand

[2] Splitting scale

[3] Machine plate

5.5 Covers

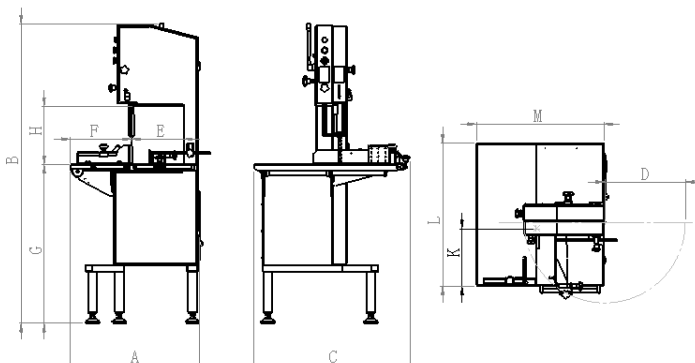
WARNING

Risk of injuries due to missing protection equipments
The band saw may not be started up until all protection equipments [Figure 6.7 Covering danger zones] are fully functional.



6. Structure and Function

6.1 Technical data



Model	KENT330F-SL	KENT440F-SL
A	740mm	940mm
B	1720mm	1930mm
C	890mm	890mm
D	460mm	560mm
E	300mm	400mm
F	350mm	450mm
G	910mm	910mm
H	330mm	440mm
K	320mm	320mm
L	820mm	820mm
M	730mm	930mm
Rated Voltage	3P 380V50Hz	3P 380V50Hz
Rated Power	1.5kw	2.2kw
Rated Current	3.7A	5.2A
Fuse	16A	16A
Rated Speed	1420rpm	1420rpm
Linear Speed	24m/s	21m/s
Saw Blade	2590x16x0.46mm	3340x16x0.5mm
Machine Weight	165kg	210kg

6.2 Structure

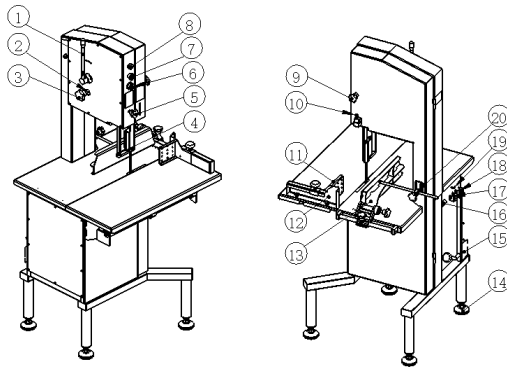


Figure 6.1 Structure of the band saw (overview)

- [1] Handle of tension device
- [2] Butterfly nut
- [3] Adjustment handle for upper wheel
- [4] Blade protection guide
- [5] Locking handle for blade protection guide
- [6] Emergency stop button
- [7] Stop button
- [8] start button
- [9] Locking handle for front door
- [10] Spring pin for pusher
- [11] Rest material holder
- [12] Push panel of sliding table
- [13] Portioning device
- [14] Machine foot
- [15] Pusher
- [16] Hook for portioning device
- [17] Hook for support level assembly
- [18] Hook for Pusher
- [19] Hook for rest material holder
- [20] Support level assembly

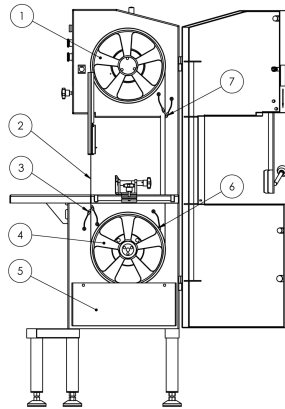


Figure 6.2 Structure of the band saw (opening front door)

- [1] Upper wheel
- [2] Saw blade
- [3] Blade scraper lower
- [4] Down wheel
- [5] Material dust box
- [6] Blade scraper for down wheel
- [7] Blade scraper upper

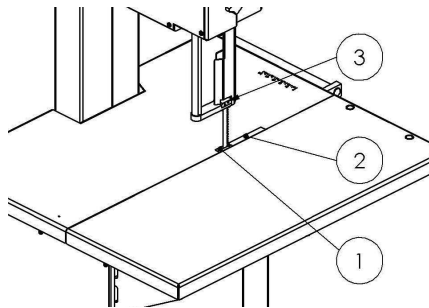
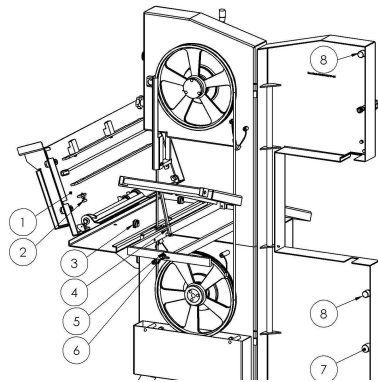


Figure 6.3 Structure of the band saw (section 1)

- [1] Belt guide lower
- [2] Re-movable block
- [3] Sliding bar belt guide

Figure 6.4 Structure of the band saw (section 2)

- [1] Sliding table
- [2] Fixing pin for sliding table
- [3] Rolling wheel assy.
- [4] Support level for rotatory table.
- [5] Column buffer
- [6] Fixing Pin for rotator table
- [7] Manetic lock
- [8] Manetic blokc for sensor.



7. Putting into operation

7.1 Installing the band saw

WARNING



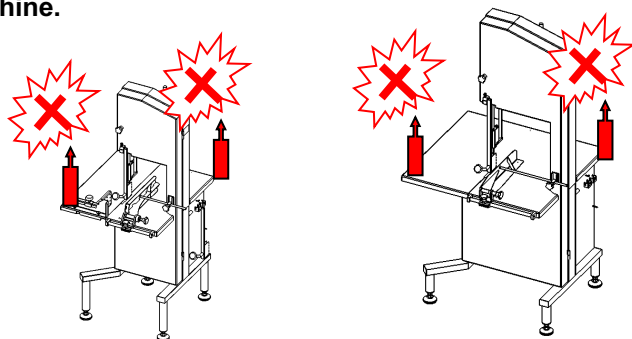
Risk of injuries in the event of slipping, falling or tilting the band saw

- Install the band saw on the ground floor or a stable table or other stand, which has sufficient stability to carry the weight of the band saw.
 - The stand must not be mobile or fitted with wheels or castors.
 - Install the band saw on a flat, slip-proof surface so that the band saw does not slip, tilt or otherwise move when used.
-



CAUTION

In the process of dismantling, handling, moving, installing and setting machine, it is forbidden to lift the machine by lifting the working table, otherwise it will be caused serious damage to the machine.



CAUTION

Note the ergonomic requirements

- The machine must be installed in such a way that safe working is possible for a person in an upright position.
 - Ensure good lighting is provided at the workplace.
 - Reasonable space must be available to operate with and clean the machine.
-

7.2 Assembling the band saw

Figure 7.1 Assembling**[1]** Machine foot

The band saw is installed on the machine feet[1] on a slipproof, clean and flat surface. The table of the band saw is horizontal and stable after installed. Lock the nut of machine foot at the finally. It is forbidden to lift the work table in installation.

7.3 Setting & adjusting the band saw

CAUTION

Risk of injuries due to rotating machine parts

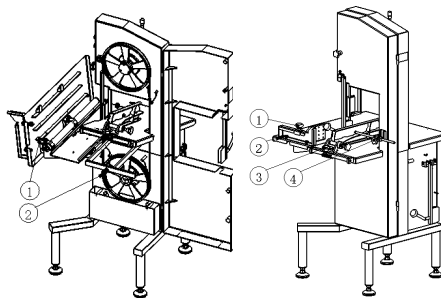
- Remove the plug from the socket before carrying out any setting & adjusting work.
 - Setting and adjusting the band saw accord the bellowing steps.
-

7.3.1 Locking the table

Figure 7.2

 Locking the table

- [1]** Fixing pin for sliding table
[2] Fixing Pin for rotate table
[3] Rest material holder Support level Assy
[4] Screws for push panel of sliding table
[5] Handle of pottioning device
[6] Handle of support assy.



The sliding table is fixed or released by fixing pin for sliding table[1], The rotate table is fixed or released by fixing pin for rotate table[2],

Accord the size of food material to select rest material holder[3] or push panel for sliding table.(the push panel for sliding table can be fixed or remove from sliding0, or select portioning device or support assy.

7.3.2 Adjusting the saw blade

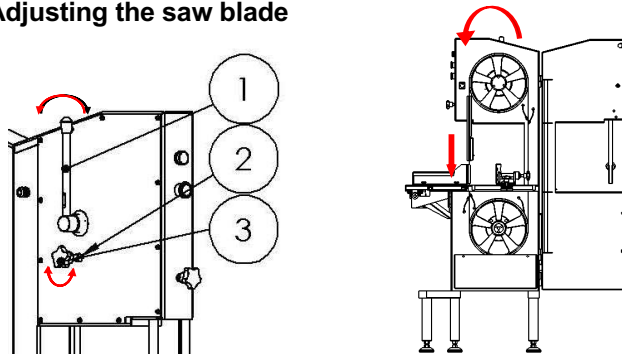


Figure 7.3 Adjusting saw blade

- [1] Handle level
- [2] Butterfly nut
- [3] Up wheel adjust handle

The saw blade need to be check before running, the process is:

Step 1:

un-lock butterfly nut[2], un-lock direction is anti-clockwise

Step 2:

Rotate the upper wheel as the direction of anti-clockwise 3 to 5 cycles by hand.

Step 3:

Check the saw blade gap between saw blade and slot of upper wheel. The normal gap is 1.0mm to 2.0mm[see **Figure 7.4** Checking the gap of saw blade (a)], if not, then turning up wheel adjust handle[3], the direction is clockwise or anti-clockwise to see gap, while rotating the upper wheel in anti-clockwise by hand. Finishing this process only to sure the saw blade gap is between 1.0mm and 2.0mm[As **Figure 7.4** Checking the gap of saw blade (a)].

- anti-clockwise →blade moves to front side,gap increased.
- clockwise →blade moves to back side,gap reduced.

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Make sure, that the teeth of the blade never have contact to the front shoulder of the wheels

Step 4:

Lock butterfly nut[2], the direction is clockwise.

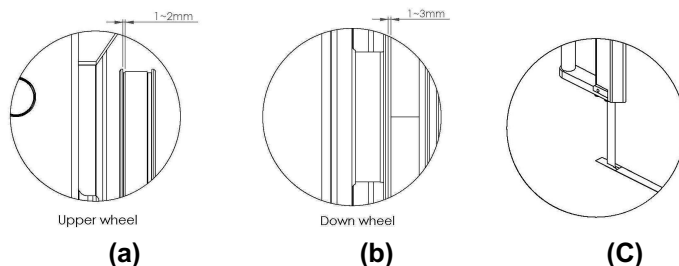


Figure 7.4 Checking the gap of saw blade

Step 5:

Check the saw blade gap on the down wheel, the gap is 1.0mm to 3.0mm[**Figure 7.4** Checking the gap of saw blade (b)], this step is only to check for safety reason, the numerical value is can't be adjusted by user. If the saw blade is scratched to down wheel after adjusting the right numerical value between the saw blade and upper wheel, then need to give this information to your dealer.

Step 6:

Check the saw blade gap on the other 2 places[see **Figure 7.4** Checking the gap of saw blade (c)], the saw blade should has a very little gap in those two copper parts for both sides. Same as step 5, This step is only to check for safety reason, the numerical value is can't be adjusted by user. If the saw blade is scratched too much and make great noise, then need to give this information to your dealer.



Both parts of sliding bar belt guide and belt guide lower are wear-and-tear parts and must be replaced on time to avoid damages on the table or others parts of the machine. It can also extend the use time of saw blades and save the cost of buying saw blades.

7.3.3 Adjusting the scrapers

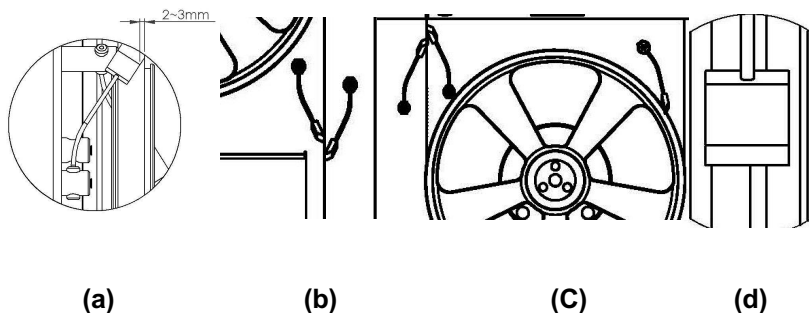


Figure 7.5 Adjusting the scraper

The scrapers can keep the saw blade and wheel clean, so adjust scrapers in right position can increase efficiency.

The scraper keep a distance to saw blade teeth, normal value is 2.0mm to 3.0mm[**Figure 7.5** Adjusting the scraper (a)], the scraper is just contact saw blade[**Figure 7.5** Adjusting the scraper (b) and (c)] or wheel surface[**Figure 7.5** Adjusting the scraper (d)], the scraper is easy to be worn out if the scraper has big pressuer to saw blade or to wheel surface.

7.3.4 Checking the dust box in order

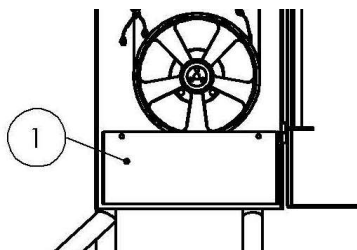
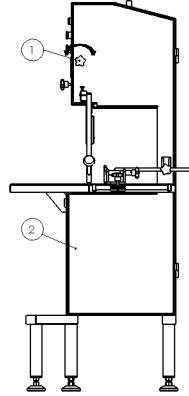


Figure 7.6 Dust box in order

[1] Dust box

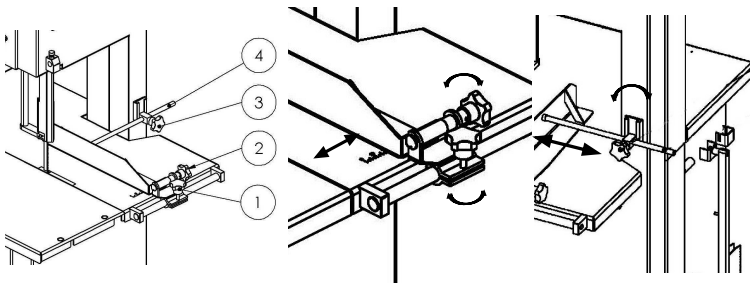
Check dust box in order, otherwise will damaged parts when running.

7.3.5 Locking the front door**Figure 7.7** Locking front door

- [1] Magnetic lock (in side of the body)
- [2] Lock handle of front door

Lock the front door by two locks, one is magnetic lock installed in body [1], another one is on the upper of front door [2], rotate the handle as anti-clockwise is open door, and clockwise direction is lock door.

Machine can not be starting unless the front door locked.

7.3.6 Adjusting the portioning device**Figure 7.8** Adjusting the portioning device

- [1] Portioning fixing handle
- [2] Thin adjust handle
- [1] Handle of support level assy.
- [2] sliding bar.

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Loose the portioning fixing handle [1], you can move the portioning device quickly; After fixed the portioning fixing handle, you can use the Thin adjust handle [2] to adjust the thickness of food material. For each turn, the plate moves towards left or right 1.5mm.

Install a support level assembly is necessary to make portioning device much stable, put support level into the slot, turning portioning support handle[3] to lock or un-lock sliding bar[4].

7.3.7 Assembly the support level and rest material holder

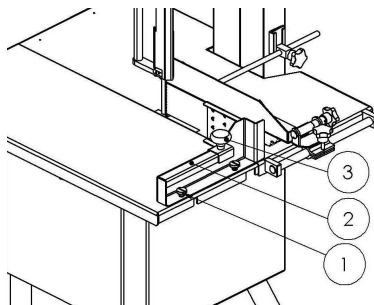


Figure 7.9 Assembly the support level

- [1] Screw of push panel
- [2] Push panel of sliding table.
- [3] Rest material holder.

When the food material is bigger, it's not need rest material holder[3], only install push panel for sliding table[2]. When the food material is smaller, use rest material holder[3] or use pusher (see 7.3.90, it's necessary to take off push panel of sliding table during use pusher.

7.3.8 Adjusting the height of the blade protection guide

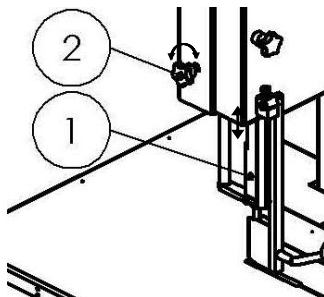


Figure 7.10 Blade protection guide

- [1] Blade protection guide
- [2] Sliding bar handle

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Blade protection guide[1] can be moved until un-locking the sliding bar handle[2], use right hand hold the blade protection guide[1] and use left hand turn the sliding bar handle[2], then move to the height needed.

WARNING**Risk of injuries in the event of moving blade protection guide.**

- Not hold the blade protection guide, then the blade protection guide will drop too fast to injuries.
 - Too fast drop down may be damage the damper.
-

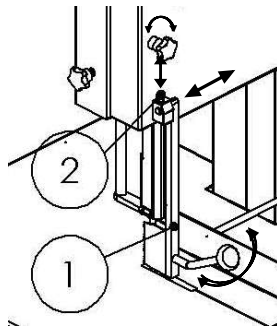
7.3.9 Installing pusher

Figure 7.11 Installing pussher

- [1] Spring pin lockable
[2] Pusher

Pull out the spring pin lockable[1] and turn 90 degree, Put pusher's [2]cylinder into the hole,then turn spring pin locable 90 degree, then the pusher[2] is fixed and only can be turning.

WARNING**Risk of injuries in the event of installing or take off or using pusher**

- Will cause injuries if spring pin lockable is not put in the slot of

pusher.

- Not as the direction of pusher rotation will cause pusher damaged or cause injuries.
 - Only pull out spring pin lockable then can pull out pusher, otherwise will cause pusher etc. parts damaged.
-

CAUTION



Only finished above process [7.3 Setting & adjusting the band saw], then can connect the main plug into the socket.

7.4 controls on the band saw

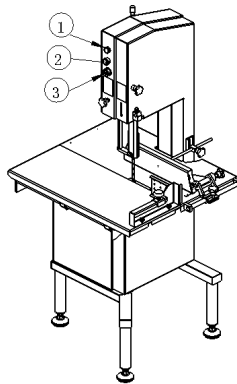


Figure 7.12 Switches

- [1] Switch for switch on[1](green color,waterproof cover)
- [2] Switch for switch off[2](red color,mashroom head)
- [3] Emergency stop button[3](red color,mashroom head)

There has two magnetic switches installed into the body, and active with two magnetic switches installed on the front door cover. The machine can't be starting when the front door not locking (the gap over 6.0mm between body and front door), the machine is stopping while the front

door is opening more than 6.0mm.

In addition, one temperature sensor installed in the machine motor, when the motor overheating, the machine will automatically stop running, only the temperature down to the temperature can be activated, the start button will work

7.5 Switch on the band saw

WARNING



Risk of injury due to damaged or incorrectly mounted machine parts

Using the band saw with damaged electric parts or power cables can cause injuries due to electric shocks or malfunctions.

- Missing or damaged covers expose rotating parts and can cause injuries. Check the band saw for damage before each use, in particular:
 - the saw blade,
 - the power cable,
 - correct assembly and covering function of all covers and the housing,
 - the function of the switches.
- Replace damaged parts before using the band saw again.

CAUTION

Risk of injuries due to poor health of the operator



Lack of concentration, over-tiredness, illness, drunkenness or leg or arm disabilities as well as mental disabilities cause a high risk of injuries.

- People who work at the band saw must be healthy and capable of concentrating.
- Before starting work at the band saw, ensure you are in a stable

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position in which you can maintain your balance without any effort.

- When cutting, do not look away from the saw blade and food material.
-

CAUTION

Risk of injuries on touching the band saw



Touching the saw blade while the band saw is switched on causes injuries.

- Do not touch the saw blade while the band saw is switched on.
- Do not use any objects to brake rotating saw blade.
- The switched on band saw must be inaccessible to persons not working at the band saw, especially to children.

Before leaving the work area, switch off the band saw and remove the mains plug from the socket.

WEAR SUITABLE CLOTHING

Rotating machine parts can catch unsuitable clothing or long hair. Splash powder of food material spun off the machine or loud machine noises can damage eyes and ears.



- Ensure good lighting is available,
 - wear tight-fitting clothing,
 - do not wear jewellery,
 - wear a hair net on long hair,
 - wear safety glasses or goggles,
 - wear hearing protection,
 - wear suitable protective gloves.
-

Switch on the band saw as follows:

Step 1:

Check the saw blade as "7.3 Setting & adjusting the saw blade "

Step 2:

Insert the plug into the socket.

Step 3:

Press the green button (starting switch).

Step 4:

Check the direction of rotation when starting up the band saw.

-The direction of rotation toward down.

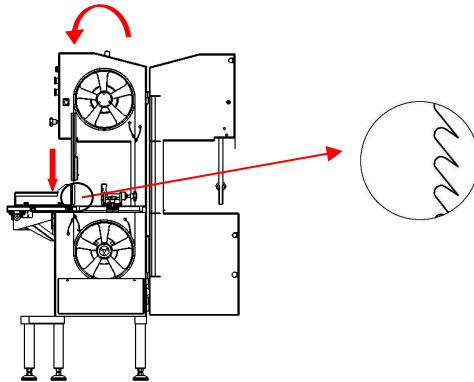


Figure 7.13 Saw blade teeth to down

7.6 Switch off the band saw

Switching off the band saw just press the red switch (mushroom switch).

Wait until the blade and wheel stop.

Risk of electric shock**WARNING**

If the plug is removed from the socket by pulling the power cable, the connection between the plug and cable can be damaged and is therefore a substantial source of danger.



- When disconnecting the power connection, hold onto the plug and pull it out of the socket.

1 Pull the mains plug out of the socket.

2 Cleaning the band saw.

WARNING**Risk of injuries after thoughtless switching on of the band saw**

If the band saw is left unattended after cutting work, there is a risk of the band saw being switched on by unauthorised or thoughtless persons.



- After carrying out cutting work, never leave the band saw unsupervised unless the mains plug has been disconnected.
 - Store the band saw in a safe place, to which unauthorised persons do not have access.
-

Food material dust box:

Can only be removed after opening the machine door. Lift it lightly and pull it out.

Sliding table :

For an effort saving moving of the cutting material. The device is guided via ball bearing and can be flapped up for cleaning.

WARNING

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Only switch the band saw on after it is ready for operation!

8. Cutting food material

After knowing well about “7. Putting into operation”, then can cutting food material.

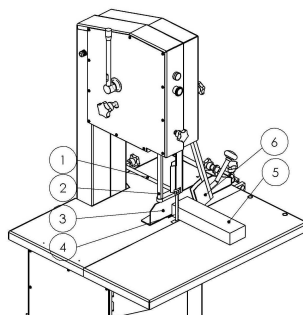
Using pusher as showing:

For models with a fixed table use the material pusher.

Press the material which must be cut, after lifting the material pusher lightly, against the portioning device. Then use the pusher to feed the material with the necessary pressure to the saw blade and cut through.

Figure 8.1 Fixing table

- [1] Support level assy.
- [2] Blade protection guide
- [3] Portioning device
- [4] Saw blade
- [5] Food material
- [6] Pusher



Note:

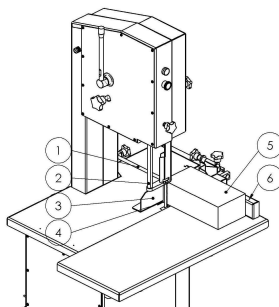
(use fixing pin to fix sliding table, then table is fixed table)

Using sliding table as showing:

For models with a sliding table, press lightly against the table pushing bar to feed the material to the saw blade. Then cut through with the necessary pressure

Figure 8.2 Sliding table

- [1] Support level assy.
- [2] Blade protection guide
- [3] Portioning device
- [4] Saw blade
- [5] Food material
- [6] Push panel of sliding table



General safety advises

- work with concentration
- do not bring your hands close to the saw blade
- except for the materials which are to be cut, do not place any part or tool on the table while running the machine
- use the safety devices
- ensure a clean and slippery free stand platform
- in case the saw blade cracks, stop the machine immediately

Specific safety advices



The door of the band saw is controlled with two safety magnetic code switches. By opening the door the machine is switched off automatically and the motor brake stops it in the stipulated time.



Leads of operation:

- Cutting of big beef bones:
First cut crosswise into the joint from the front side. Then square to the bone and cut the joint of. The bone must lay flat on the table surface. Then cut your portions.
- Cutting of cutlets and T-bone steaks: After adjusting the portion thickness move the material quickly through the saw blade. The faster you cut, the better the cutting surface on the product will be.
- Generally pay attention to:
The cutting material must have solid contact to the surface of the table. This avoids a jumping of the material during operation.
- Saw blade bending:
Do not bend the saw blade while moving the cutting material.
- Saw blade:
Demand less force for the operation
It is only permitted to use saw blades which have the relevant dimensions for the model of band saw.
For a proper performance it is recommended only to use original saw blades.



Paying attention to the following advices will prolong the usage time of the saw blade:



- Saw blade must move center between the blade guides.
- Avoid bending of the blade during operation.
- The blade should not have contact to the hard metal pin which supports the back of the blade.
- Keep the wheels, scrapers and blade guides clean

9. Servicing and maintenance

WARNING



Risk of injuries due to unauthorised or thoughtless switching on or wrong spare parts

- Always disconnect the mains plug before carrying out any maintenance or repair work on the band saw.
 - Only use original spare parts.
-



WARNING

Risk of injuries due to improper repair work

- Any repair work on electric components may only be carried out by qualified electricians.
-

9.1 Changing the scrapers

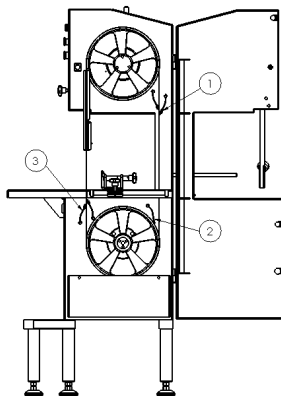


Figure 9.1 Five scrapers

- [1] Upper scrapers (2 PCS)
- [2] Down wheel scraper (1 PCS)
- [3] Down scrapers (2 PCS)

The five scrapers can be changed, when scraper plate[1] is worn out or near to worn out, then need to change scraper plate, otherwise, the scraper level[2] will damage the saw blade. Scraper plate[1] is screwed to the scraper level[2].

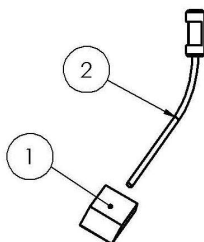


Figure 9.2 Scraper assembly

- [1] Scraper plate
- [2] Scraper level welding

9.2 Changing the saw blade

To remove the saw blade, work the opposite way around.

WARNING



Risk of injuries due to unauthorised or thoughtless switching on or wrong spare parts

- Always disconnect the mains plug before carrying out any maintenance or repair work on the band saw.
 - Only use original spare parts.
-



WARNING

Risk of injuries due to improper repair work

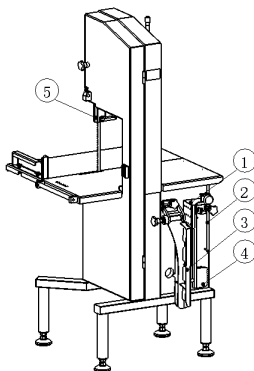
- Any repair work on electric components may only be carried out by qualified electricians.
-

Step 1: Collecting tools

Move rest material holder[1] to side hook; move support level assy[2] to side hook; move portioning devic[3] to side hook; move pusher to side hook; move blade protection guide to top position.

Figure 9.3 Collecting tools.

- [1] Rest material holder
- [2] Support level assembly
- [3] Portioning device
- [4] Pusher
- [5] Blade protection guide

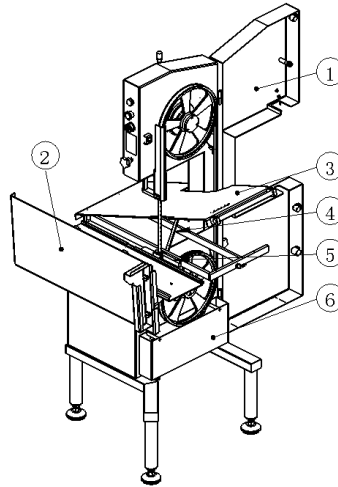


Step 2: Lifting table

Open front door assembly[1]; Move sliding table to the end, and then rotate the sliding table[2]; Lift rotatory table[3], and keep opening by support level assembly[4]; Take off Re-moveable block[5]; Take off dust box[6]

Figure 9.4 Lifting table

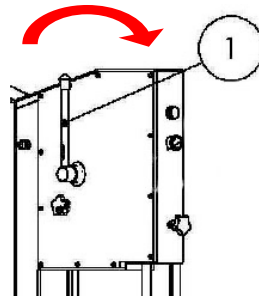
- [1] Front door assembly
- [2] Sliding Table
- [3] Rotate table
- [4] Support level Assy
- [5] Re-moveable block
- [6] Dust box

**Step 3:** Lost the saw blade

Hold the end of the handle level[1], perpendicular to the handle level, and move the handle bar clockwise to the horizontal position

Figure 9.5 Lost the saw blade

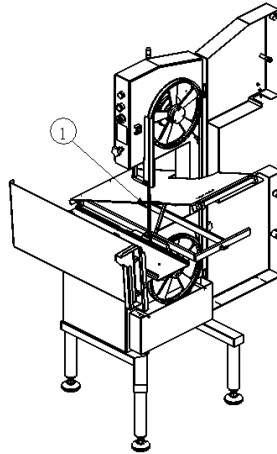
- [1] Handle level



Step 4: Take off the saw blade

Take off the saw blade[1] from upper wheel first, then take off the saw blade from the band saw.

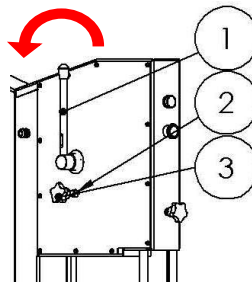
Figure 9.6 Take off the saw blade
[1] Saw blade

**Step 5:** Install the NEW saw blade

After installing a new saw blade and ensuring that the saw blade is in the proper position, the handle lever [1] is moved from the horizontal position counterclockwise back to the vertical position, and check the saw blade position in the upper wheel meets the standard or not. Rotate upper wheel by manual(right hand) as the direction of anti-clockwise, to see the gap of back side of the saw blade to the shoulder of wheel, to sure the gap is 1.0 to 2.0mm, same as 7.3.1 **Adjusting the saw blade,Then lock butterfly nut[2].**

Figure 9.7 Install the NEW saw blade

- [1] Handle level
- [2] Butterfly nut
- [3] Up wheel adjust handle



After installing a new saw blade the adjustment must be checked and if necessary corrected.

Pay attention that

- the teeth of the blade show towards the open side of the machine,
- the teeth of the blade show downwards,
- the blade tension is released over night,
- only a buckling and distortion free saw blade is used.

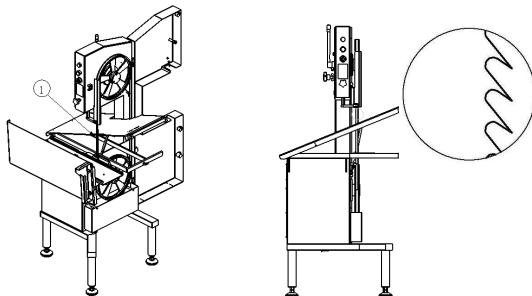


Figure 9.8 Check the saw blade teeth

[1] Saw blade

Step 6: Check scrapers

Same as 7.3.3 **Adjusting the scrapers**

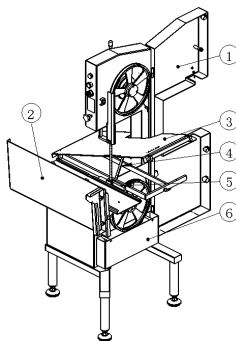
Step 7: Lock front door

The process as following:

Insert re-moveable block[4],put back dust box[5],flat down table[2] and lock it , close front door assembly[1] and lock it.

Figure 9.9 Lock front door

- [1] Front door assembly
- [2] Sliding table
- [3] Rotate table
- [4] Support level Assy
- [5] Re-moveable block
- [5] Dust box



9.3 Cleaning the band saw

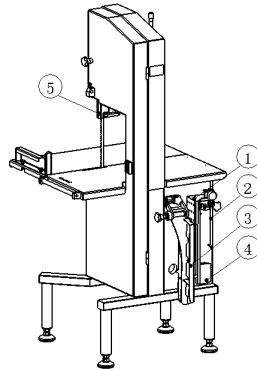
The band saw must be cleaned after each work session.

Step 1: Cleaning tools

Clean all tools and put those on the side of machine.

Figure 9.10 Cleaning tools.

- [1] Rest material holder
- [2] Support level assembly
- [3] Portioning device
- [4] Pusher



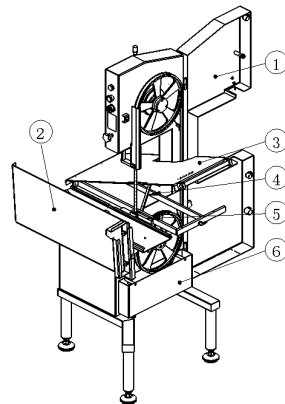
Step 2: Clean every visible place

Opening table and cleaning any place out of machine

Open front door assembly[1], open table[2], table[2] supported by support level assy[3], take off dust box[5], take off re-moveable block[4], use water gun to clean any place out of machine.

Figure 9.11 Clean every visible place

- [1] Front door assembly
- [2] Sliding table
- [3] Rotate table
- [4] Support level Assy
- [5] Re-moveable block
- [6] Dust box



Step 3: Restitution

Put all parts back after cleaning.

Residual risks

Risks that are not completely eliminated by the safety equipment in place include:



- Danger with freewheeling saw blade (Adjust the height of the band threading path as tight as possible to the cutting material)
 - Interference with saw blade from the side
 - Getting hand caught between connecting link and sliding plate
 - Saw falling over
 - Potential human health risks and unacceptable changes to the foodstuff resulting from
 - non-observance of the hygiene regulations and cleaning guidelines
-

9.4 Hygiene plan

The machine must not be cleaned using the high-pressure cleaner or aggressive agents.

Handle all parts which have been removed with care during the cleaning process! Wear suitable protective clothing.

- Cleaning area:
outside the machine and tools, see [9.3 clean cutting machine]
- Cleaning frequency:
clean at least once a day
- Cleaning steps:

Step 1: remove all residues

To remove the residue in each part of the machine with plastic shovel, plastic scraper, brushes, water and so on.

Step 2: Rinse with warm water

The use of lower pressure water gun and drinking water (water temperature up to 50°C as fat softening point) washing machine.

Step 3: Detergent cleaning

Thoroughly clean the machine surface with neutral food grade detergent.

Step 4: Rinse with warm water

The use of lower pressure water gun and drinking water (water temperature up to 50°C as fat softening point) washing machine.

**Step 4:** Dry

Dry with a clean cloth or dry naturally in air.

**Step 4:** Care

With a clean cloth dipped in some Shell Ondina oil 68# to wipe the surface of the machine, especially when the machine is stopped to use for a long time, need more care, otherwise it will cause the machine surface mildew or rust.

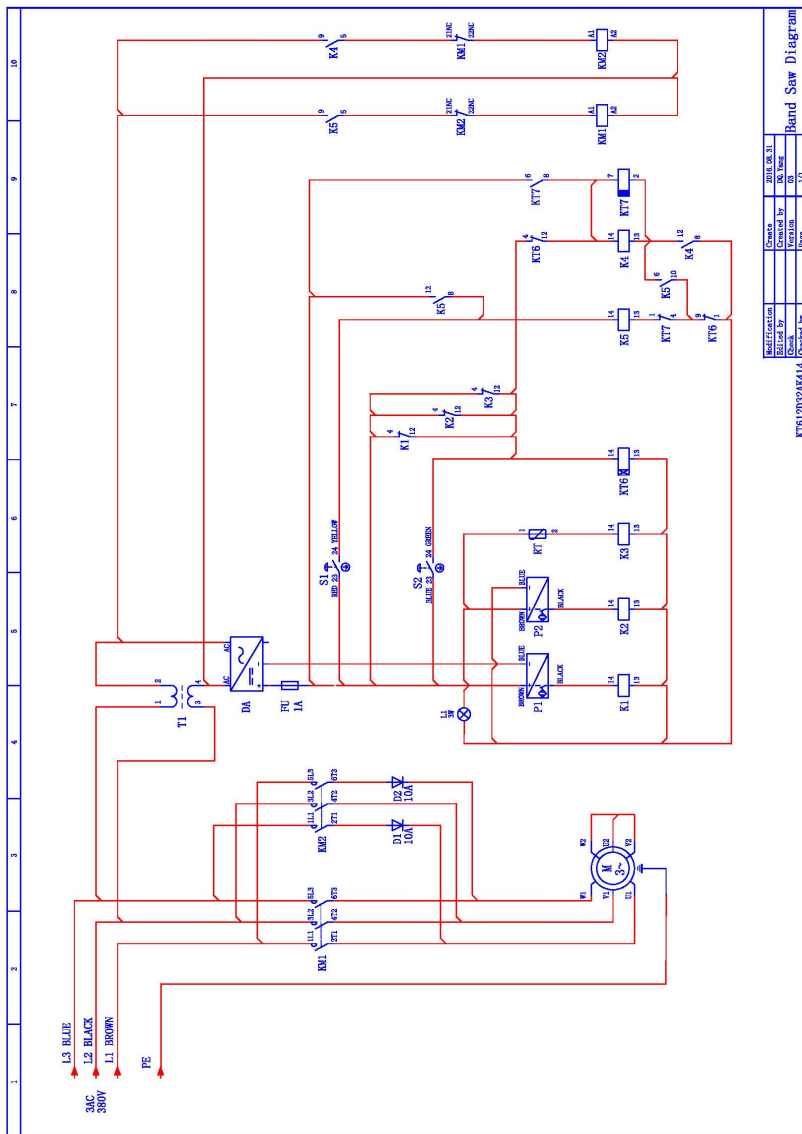
Comments 1:

Acid sensitive materials such as POM and castings are allowed to be cleaned by acid material only when necessary, with a frequency of about 1 times around 2 months, and no acid residue can be retained after finish cleaning.

Comments 2:

Like saw blade or other non stainless material, each must be in dry after cleaning, and must care for the surface, to prevent oxidation or rus.

9.5 Electrical diagram



Modifications		Drawn		Date	
Modified by	KT612032M411	Created by		Revision	01
Checked by		Checked by		Page	01

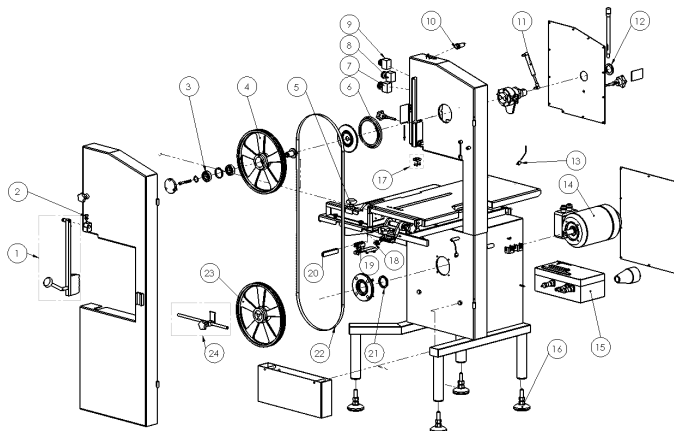
Band Saw Diagram

9.6 Fault Finding

Fault	Cause	Remedy
Cut is not straight	Teeth of saw blade are damaged on one side	Replace saw blade
	Blade guide damaged	Replace blade guide
Saw blade getting hot	Blade guides and scrapers are polluted with hard waste	Clean the parts
	Blade is getting friction on one side of the blade guides	Check blade guides and wheels and replace them if necessary
	Bumpy blade run	Check upper wheel adjustment and change blade in case of distortion
Material becoming black on cutting surface	Blade guides are polluted with hard waste, fat is melting due to the friction and becomes black.	Clean the parts
	Blade is getting friction on the wheel shoulder	Adjust position of upper wheel
Rumbling noise	Running surface of wheels is polluted with hard waste	Clean up the wheel and replace the wheel scraper
Cutting requires too much force	Saw blade is worn off	Replace saw blade
Saw is blocked during cutting	Saw blade is clamped from cutting material	Switch off immediately and replace the saw blade
Machine does not run after replacement of saw blade / loosening plugging	Overloaded motor	Check the electrical parts

10. Spare Parts

10.1 Spare Parts Drawing



Item	Parts No.	Quantity	Name	Specification
1	106(8)--652	1 set	Pusher assembly	
2	106(8)--947	2 PCS	spring pin lockable	M8
3	GB/T 276	2 PCS	Rolling bearing	6205
4	106-323	1 PCS	UP wheel	For KENT330F-SL For KENT440F-SL
5	106(8)-760	1 PCS	Rest Material holder	For KENT330(440)F-SL
6	106(8)-920	1 PCS	VD sealing ring 130A	VD130A Black
7	106(8)-956	1 set	E-Stop button	Red CE
8	106(8)-952	1 set	Stop button	Red CE
9	106(8)-951	1 set	Start button	Green CE
10	106(8)-972	2 PCS	Magnetic sensor	
11	106(8)-924	1 set	Gas pressure spring	YQ8
12	106(8)-930	1 PCS	Up wheel shaft sealing ring	D 38, D50
13	106(8)-387	5 PCS	Scraper plate	POM White
14	106-955	1 PCS	Motor 1.5KW 380V	For KENT330F-SL
	108-955	1 PCS	Motor 2.2KW 380V	For KENT440F-SL
15	106(8)-856	1 Ass	Electrical Box	
16	106(8)-925	4 PCS	Foot D=80 M16X60	L100mm 304
17	106(8)-372	1 Ass	Sliding bar belt guide	With pin & screws
18	106(8)-944	2 PCS	Spring location pin	
19	106(8)-374	1 Ass	Lower guide assembly	With Pin & screws
20	106(8)-376	1 PCS	Re-moveable block	POM White
21	106(8)-934	1 PCS	Skeleton oil seal FKM	45X60X8
22	106(8)-922	1 PCS	Saw blade	For KENT330(440)F-SL
23	106(8)--392	1 set	Down wheel assembly	For KENT330(440)F-SL
24	106(8)--702	1 set	Support bar assembly	For KENT330(440)F-SL

10.2 Ordering spare parts



CAUTION

Risk of accidents due to wrong spare parts

Using parts which are not matched to the band saw constitutes an Unknown risk.

Use original spare parts only.



Please order spare parts as follows:

Choose the parts to be replaced from the spare parts drawing, with parts No. and name.

Your spare part order must include the following details:

- 1 Required quantities
- 2 Parts No.
- 3 Name
- 4 Machine type, serial number, year of manufacture (see machine plate).


Please send your order for spare parts to your specialist .

11. Confirmation on material definition

Designation of the machine/equipment:

Materials and objects which come into contact with food	Material designation	Group of materials and objects
Machine body	1.4301	Stainless steel
Machine door	1.4301	Stainless steel
Table	1.4301	Stainless steel
Material pusher	1.4301	Stainless steel
Portioning device	1.4301	Stainless steel
Wheels	1.4462	Stainless steel
Blade scraper	POM	Plastic
Seals	TPU natural	Plastic

Label of KENT440F-SL

Product name: bone saw		
Model: KENT440F—SL		
Power: 2.2kw.	Voltage: 415V/3ph	
Current: 4.9A.	Frequency: 50hz	
Speed: 980rpm	SN: CXXXX	
Year: 2022	Protection: IP65	
OM S6 60%	CE certificated	
Distributed: Kentmaster Meat equipment (Beijing) Co.,Ltd		
This machine original produced by BMT company, China		

12. CE Declaration of Conformity EU



ISET S.r.l. Unipersonale


Sede Legale e Uffici	Cap. soc. i.v.	€ 10.200,00
Via Donatori di sangue, 9 - 46024 Moglia (MN)	Cod. Fisc. e P.IVA Reg. Imprese	02 332 750 369
Tel. e fax +39 (0)376 598963	REA	02 332 750 369
www.iset-italia.com commerciale1@iset-italia.com	Cap. soc. i.v.	MN 0221098

CERTIFICATE

Certificat - Certificado - Сертификат - Zertifikat - 證書

- 1) **APPLICANT:** (who finally puts the product on the market)
Kentmaster Meat Equipment (Beijing) Co., Ltd.
Room 117, Building 6, No. 28, Linhe Avenue, Linhe Industrial Zone, Shunyi, Beijing, China
- 2) **CERTIFICATE NO.:** ISETC.000620200812
TECHNICAL REFERENCE: EBO2007161-E289
- 3) **ISET MARK:**



- 4) **CAUTION ABOUT CE MARKING** (Instruction for the Applicant who puts the product on the EU market):
 The label of the CE Marking on the left side should be not less than 5mm height. CE Marking and EC Declaration of Conformity are duties for the manufacturer or its applicant who puts the product on the market. This one is responsible to start the CE marking and certification procedure as required by the legislation in force. Only for the products which are compulsorily included into specific Directives or Regulations will be necessary to appoint a Notified Body.
- 5) **TYPE OF PRODUCT:** Bone Saw
TRADE MARK: KENTMASTER
MODEL(S): KENT440F, KENT440F-SL, KENT330F, KENT330F-SL, KENT220F-SPH, KENT220F, KENT220T-SPH, KENT220T, KENT550F-RO
- 6) **LIST OF DIRECTIVES / REGULATIONS / STANDARDS** (as declared by the manufacturer itself)
Machinery Directive 2006/42/EC
EN 60204-1:2018, EN ISO 12100:2010, EN 12268:2014, EN 1672-1:2014, EN 1672-2: 2005+A1:2009
- 7) **NOTE:** This document is not referred to any evaluation that could be considered as included in the scope of the activities covered by the standard BS EN ISO/IEC 17065:2012 or European Regulation 765/2008.
- 8) **REMARK:** Certificate is issued on voluntary application from the Client and it gives to the applicant the right to use and affix the ISET Mark on their products, even if it doesn't imply any assessment on the safety and compliance of the product. ISET declares that the only scope of the assessment is to verify the existence of the declaration issued by the manufacturer or an applicant under its own responsibilities.
- 9) **DATE OF ISSUE:** 12/08/2020
- 10) **SIGNATURE:** Xiao Ming
(On behalf of the Legal representative)

EXPIRY DATE: 11/08/2025

Xiao Ming
(On behalf of the Legal representative)

