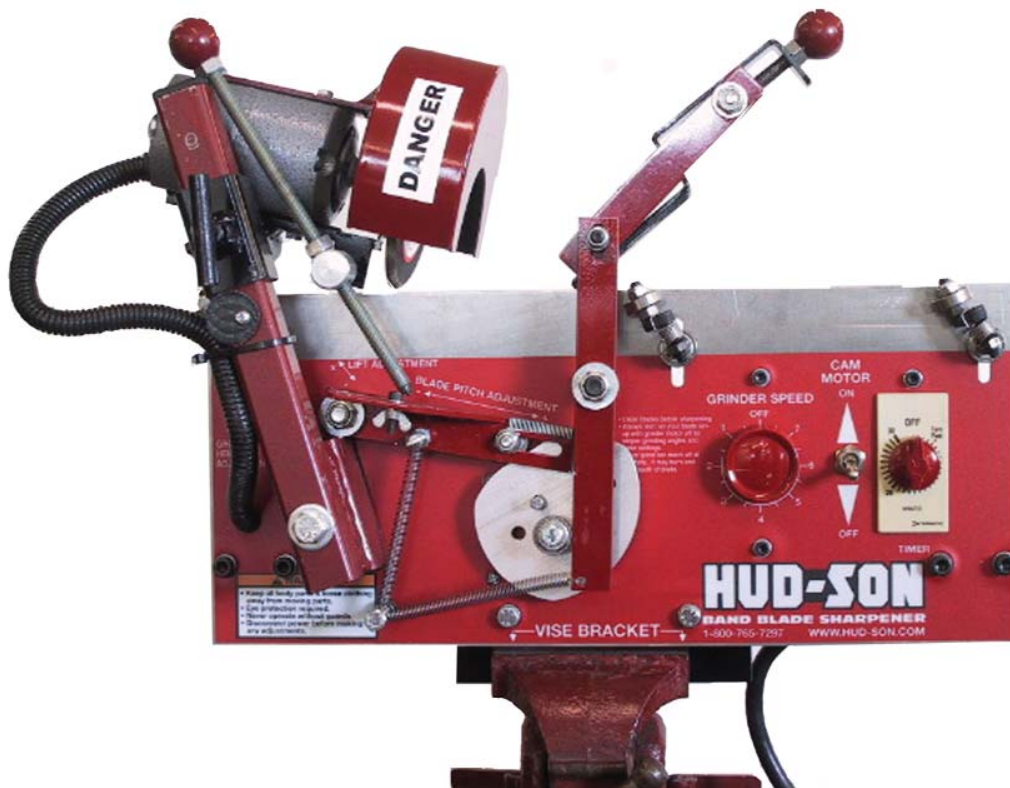


HUD-SON

FOREST EQUIPMENT

800.765.SAWS • WWW.HUD-SON.COM



BANDBLADE SHARPENER

OWNERS MANUAL

8201 STATE ROUTE 12 • BARNEVELD NY • 13304

STATEMENT OF WARRANTY

LIMITED WARRANTY

Hud-Son Forest Equipment warrants that its products be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period of ninety (90) days, Hud-Son Forest Equipment shall, upon notification of and substantiation that the product has been stored, installed, operated, and maintained in accordance with Hud-Son Forest Equipment's specifications and instructions, repair or replace, at Hud-Son Forest Equipment's sole option, any components or parts of the product determined by Hud-Son Forest Equipment to be defective.

This warranty is exclusive and is in lieu of any warranty of merchantability, fitness for a particular purpose, or other warranty of quality, whether express or implied.

LIMITATION OF LIABILITY

Hud-Son Forest Equipment shall not, under any circumstances, be liable for special or consequential damages such as, but not limited to, damage or loss of other property or equipment, loss of profits or revenue, cost of capital, cost of purchased or replaced goods, or claims of Purchaser for service interruption. The remedies of the Purchaser set forth herein are exclusive and the liability of Hud-Son Forest Equipment with respect to any contract, or anything done in connection therewith, such as the performance or breach thereof, or from the manufacturer, sale delivery, resale, or use of any goods covered by or furnished by Hud-Son Forest Equipment whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based.

The warranty period for The Semi-Automatic Band Blade Sharpener is ninety (90) days from the date of purchase.

No transportation costs of any kind are covered under this warranty. Transportation charges to return products for repair shall be the responsibility of the customer. All returned goods shall be at the customer's risk and expense. A 10% restocking fee is charged if the equipment is returned in 10 days in excellent condition. If the equipment is returned in 10 days and is **NOT** in excellent condition the cost of repairs will be deducted.

Outsourced components will be warranted by the respective manufacturer, for a period equal to the warranty at the time of shipping, as shown below:

- | | |
|-------------------------------|----------|
| • Grinder Speed Control | One Year |
| • Spring Wound Interval Timer | One Year |
| • Gear Box Motor | One Year |
| • Electrical Grinder Motor | One Year |

HUD-SON Forest Equipment

DESCRIPTION

The Hud-Son Semi-Automatic Band Blade 115V grinder is a versatile bandsaw blade sharpener capable of sharpening blades 1" to 2" in width and 3/4" to 1" in pitch. Its action is based on a timed cam principle and it can accommodate a wide variety of tooth shapes and hook angles.

Bandsaw blades suffer large stresses because they are continually flexing as they travel around the bandwheels. This flexing, as well as the teeth being racked back, can cause minute cracks, especially in the gullet bottoms. Keeping them sharpened and clean is critical not just to keep the cutting edge keen, but equally, to remove these cracks before they develop into serious problems.

The object of sharpening the blades, therefore, is to remove the minimum amount of material over the whole tooth profile, while refreshing the cutting faces and maintaining a good tooth shape. Excessive grinding merely shortens blade life, but ineffective grinding is equally destructive.

Tooth shape is important. A bad shape can lead to premature gullet cracking and inefficient cutting. Familiarize yourself with a "good" tooth shape, such as the blade supplied from the factory and keep that shape.

Read these instructions thoroughly before using the grinder. Make all major adjustments with the motor switched **off**.

SETTING UP THE BAND BLADE SHARPENER

The Hud-Son Semi-Automatic Band Blade Sharpener is pre-set at the factory for 7/8" spacing on 1 1/4" band blades. You may select to have your sharpener pre-set for your individual blade. Forward one of your blades to Hud-Son Forest Equipment at the time of order.

FIELD ADJUSTMENTS

Bear in mind that all these adjustments are interrelated and you may need to alter an earlier adjustment at a later stage.

BLADE ADJUSTMENT

Adjust blade height on rollers so that the bottom of blade gullet to the top of the stainless steel main frame should be between 1/8" to 3/16". Measure at all three guide rollers to insure a level blade.

HUD-SON Forest Equipment

FIELD ADJUSTMENTS - *(Continued)*

Guide tension blade holders must remain at a 15° angle to provide adequate drag to eliminate chatter. Ensure "L" brackets and slides are positioned for smooth feed and minimum tension.

MOTOR ARM SLIDE

Raising results in greater grinding angle, lower reduces grinding angle for the tooth under cut.

DEPTH CONTROL ROD

Clockwise reduces gullet depth, counter-clockwise increases gullet depth.

CAM TIMING BEARING ON LIFT BRACKET

Moving it to the right results in the grinding stone lifting higher and faster. Moving to the left results in grinding stone lowering lower and slower.

LIFT BRACKET ADJUSTMENT WING NUT

Fine tunes the cam timing bearing on lift bracket similar to above.

FEED PUSH KNOB

Turning clockwise accelerates blade feed, turning counter-clockwise decelerates blade feed.

TIMER ADJUSTMENT

Always start sharpening just after weld. Time one foot of sharpening, then multiply by length of band to determine cycle time. (Reduce cycle time slightly to stop sharpening just before the weld & return to the feed arm.)

HOOK ANGLE

Different timbers require different hook angles if the most efficient cutting action is to be accomplished. Generally, softwoods are cut with greater hook angles than hardwoods. 16° may cut pine well, but cause the blade to jam in such timbers as oak or maple. As they come from the factory, blades will usually have 12° to 15° hook angle.

Your grinder has the capability of grinding hook angles between 9° - 15° and you may find it desirable to alter your blade.

Changing the hook angle will alter the profile of the grinding wheel. More hook may require dressing inside face of the wheel back to a more acute angle. The trailing edge of the grinding wheel should approximately conform to the angle of the tooth back as it passes up towards the cutting edge.

HUD-SON Forest Equipment

MAINTENANCE

1. Keep all moving parts clean and free of grinding dust.
2. Lubricate rusty blades with WD40 prior to sharpening.
3. Kinked or bent blades may require operator assistance to insure smooth feed through sharpener.
4. Frequent visual preventative maintenance inspections should be performed to identify lubrication needs, as well as worn parts or loose fittings.
5. Keep Band Blade Sharpener in a dry environment, not exposed to weather or excessive moisture.

LUBRICATION

Use a light grease or equal. Grease feed arm pivot point, lift bracket pivot point and motor pivot point.

BAND BLADE SET

Although, under normal use, the band blade set does not need to be addressed with every sharpening eventually continued use will reduce the tooth set, reducing cutting efficiency. The sharpening angle for blades is 40 degrees.

Hud-Son Forest Equipment does offer a hand setter tool.
Call for current pricing.

A Adj. Setter *TS-101A

Prices subject to change without notice

TIPS

Problem

Erratic Grinding

Cause

Loose or worn pivot points
Kinked, bent, or rusty blades
Blade sides rough
Blade supports

Solution

Tighten or replace pivots
Lubricate band
Clean blade thoroughly
Ensure blade is resting on supports

Grinder missing Tooth Back

Cam timing

Adjust cam timing, or, let blade go around another time rather than taking a lot off at one time. As you resharpen blade, the more of the tooth profile you will grind.

TYPICAL GRINDING WHEEL DRESSED PROPERLY

GRINDING WHEEL



RELIEF ANGLE TO CONFORM WITH
TOOTH BACK AT THIS POSITION

www.hud-son.com • e-mail info@hud-son.com

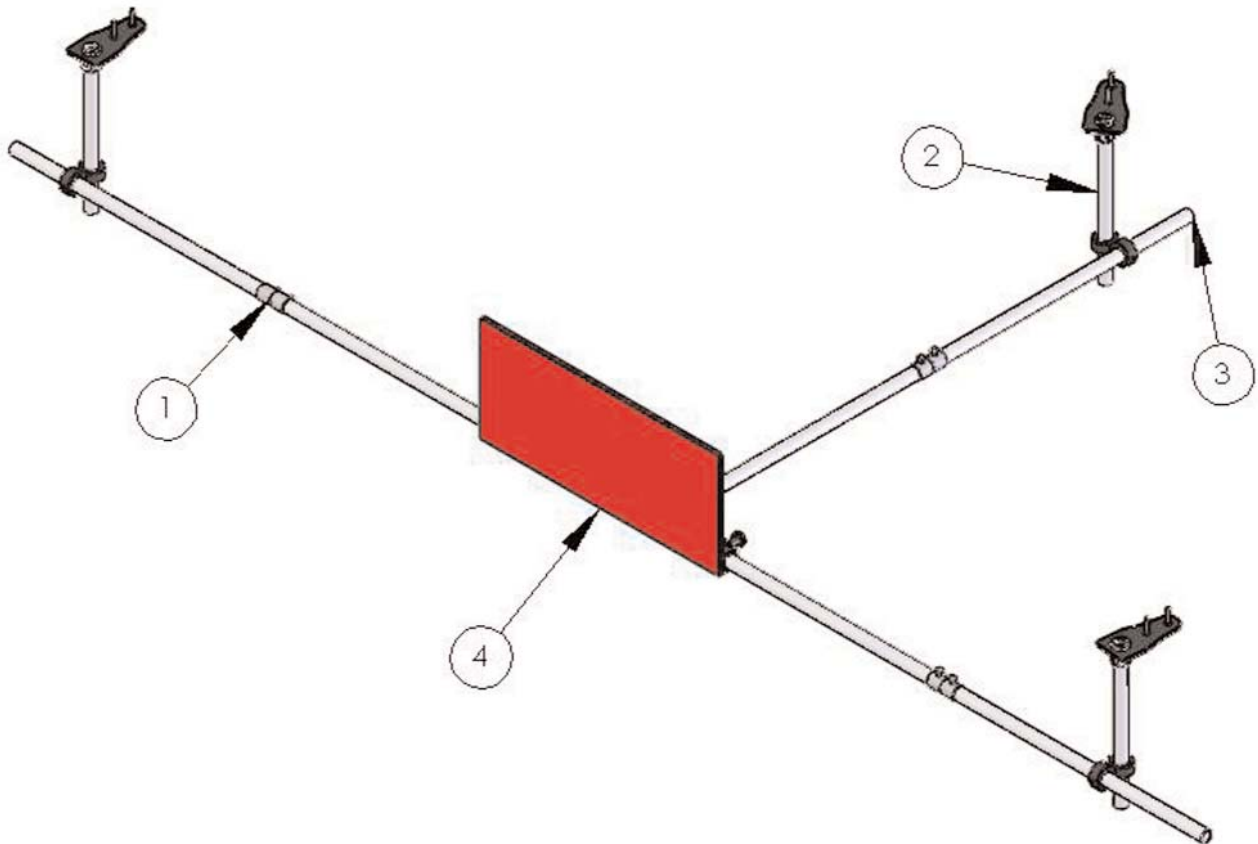
HUD-SON Forest Equipment

Changing the hook angle will alter the profile of the grinding wheel. More hook may require dressing inside face of the wheel back to a more acute angle. The trailing edge of the grinding wheel should approximately conform to the angle of the tooth back as it passes up towards the cutting edge.
(see below)



HUD-SON Forest Equipment

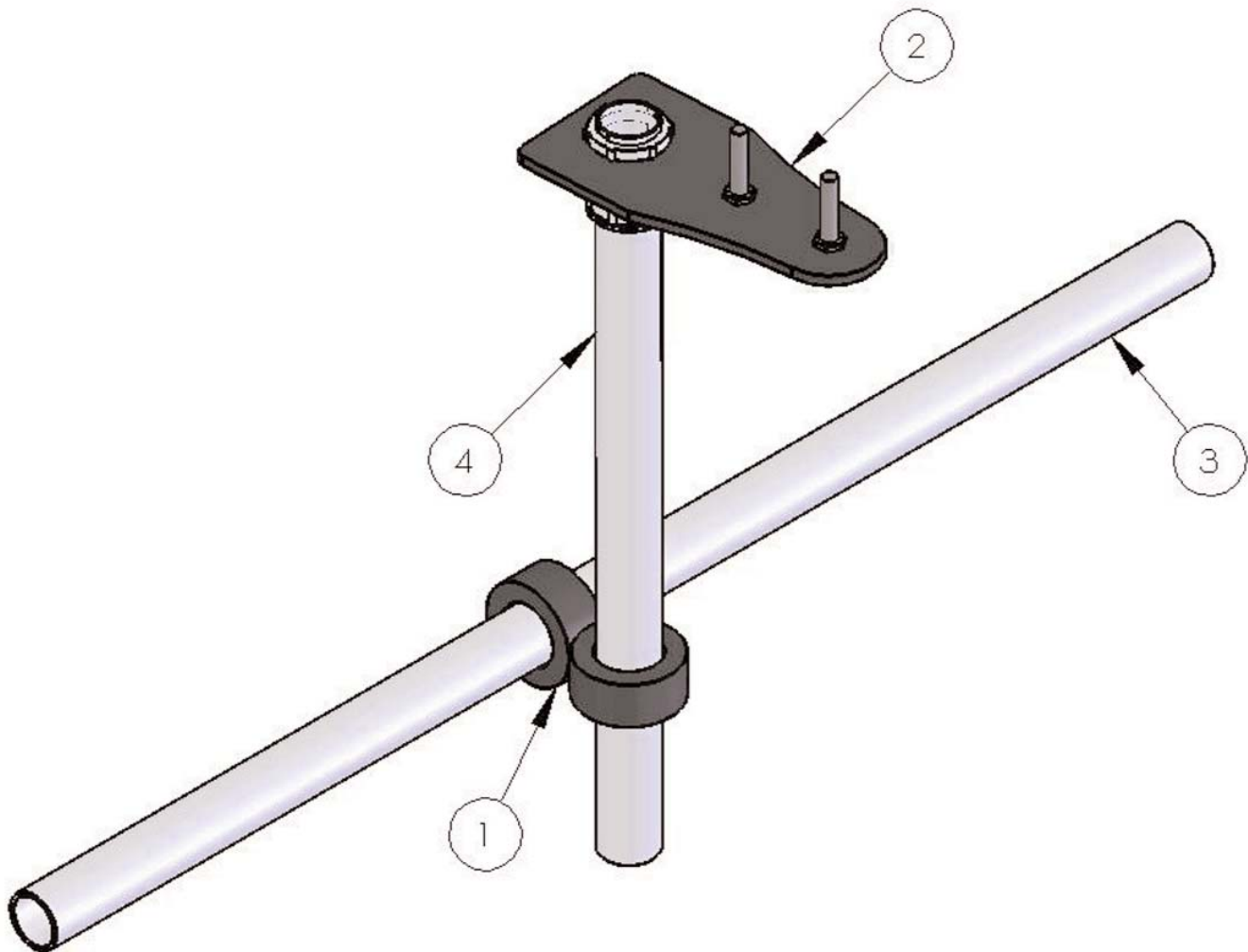
SHARPENER



ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	COLLAR	PIPE COLLAR	3
2	SHARP -001	EXTENSION ARM	3
3	SHARP-001-00-3	EXTENSION ARM	3
4	SHARP-PLATE	SHARPENER PLATE	1

HUD-SON Forest Equipment

EXTENSION ARM



ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	SHARP-001-00-1	COLLAR ASSEMBLY	1
2	SHARP-001-00-2	BLADE PLATE	1
3	SHARP-001-00-3	EXTENSION ARM	1
4	SHARP-001-00-4	VERTICAL ARM ASSEMBLY	1

HUD-SON Forest Equipment

CAUTION

BEFORE, DURING AND AFTER OPERATION

Check the engine compartment for sawdust and wood trash build up in and around the engine compartment and the exhaust area to prevent any possible fires from starting due to excessive build up. Always clean the sawdust out from under the machine after shut down and be sure there is no sawdust build up near or around the muffler area.



DISPUTES

All disputes, claims and causes of action arising out of the delivery, use, or warranty claims for personal injury and or property damage must:

1. Claimant must provide a written notice of the claim or dispute to the company (at the address below) at least 30 days after the claim arose prior to commencement of any action;
2. Company has 60 days to make a decision on the claim and will provide a written response to claimant;
3. No action may be commenced until after the company has provided its decision on the claim;
4. All claims against the company for any cause related to delivery, design defects, repairs,

use of the equipment or warranty shall be filed in Supreme Court, Oneida County, State of New York. The parties may file for Arbitration in Oneida County New York after consent by both parties.

5. Construction and interpretation of this agreement and any and all claims shall be subject to the Laws of the State of New York.

6: The address for submission of claims is:
Hud-Son Forest Equipment
PO Box 345
8201 State Route 12
Barneveld, NY 13304

7. Notices under this agreement must be in writing and sent by certified or registered mail;

HUD-SON Forest Equipment



*Hud-Son Forest Equipment, Inc. 8201 State Rt. 12., PO Box 345 Barneveld, NY 13304
Phone 800.765.SAWS • 315.896.7297
www.hud-son.com • e-mail info@hud-son.com*