

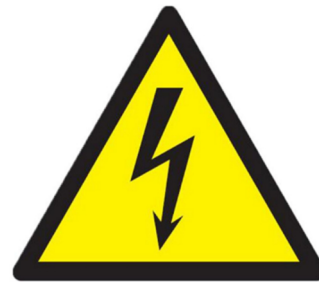


INSTRUCTIONS FOR THE ASSEMBLY OF THE SCROLL GUIDES SRP13 DUAL



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Strictly observe the safety instructions described in the general machine manual



Unplug the machine from the power supply.

Introduction :

Congratulations on the purchase of your Pegas mixed band saw.

Follow the steps of the first assembly step by step.

The next permutations classic cutting / scrolling will then take only a few minutes because the bearings of scrolling will no longer need to be removed.

Important :

- The machine is delivered in classic cutting assembly with the original bearings.
- The assembly of the scrolling kit is explained from the machine configured in classic cutting, with the table mounted (Machine manual pages 4 and following)
- For a first experience of scrolling, **it is strongly advised to use the band saw blade # 12**

List of parts of the scrolling kit :

- 2 scroll band saw blades : #9 and #12 2300 mm
Ref : 91.009 / 2300 and 91.012 / 2300
- 2 scroll bearings for bandsaws sizes #9 and #12
- 4 spacer washers M6
- 4 square nuts M6
- 1 table insert for scrolling
- 1 Instructions for the assembly of the scroll guides



Preparation of the machine:

- Remove the conventional cutting insert from the table. (Fig 1)



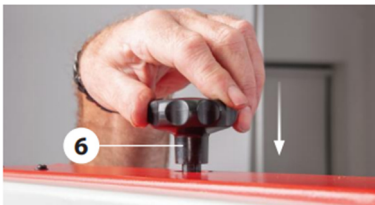
Figure 1

Remove the lower blade guard.

(Machine manual page 10 Fig.16)



Loosen and remove the classic cutting blade. (Machine manual page 25 Fig.71 - 72)



Set the machine to the "high speed" position. (Machine manual page 27 Fig.83 - 87)



Mounting the scroll bearing on the lower guide :

Remove the lower classic cutting bearing. (Machine manual page 11 Fig.21)

- Mount the M6 x 18 screw, the square nut and two M6 x 18 x 0.8 mm washers supplied with the scrolling bearings, on one of the scroll bearings. (Fig 2)

The symbol > engraved on the bearing indicates the groove to use: **band saw 12 > band saw 9**

The **left** groove must match the blade size used. (Fig 3 - 4)

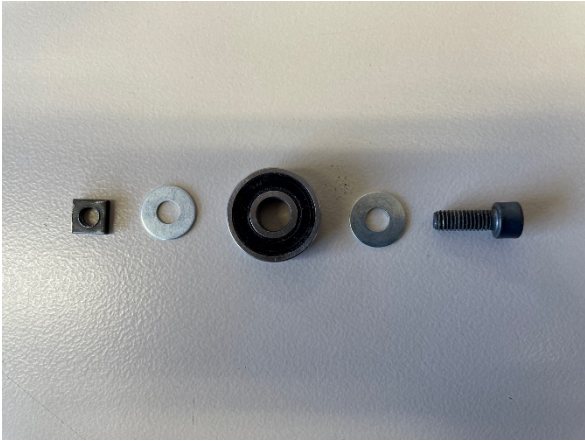


Figure 2

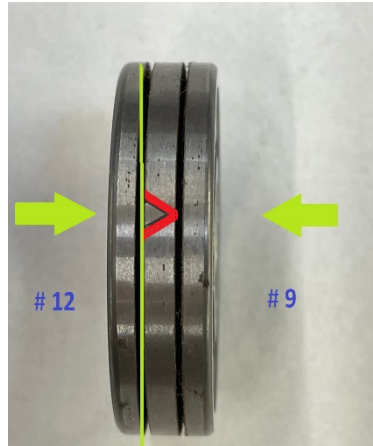


Figure 3

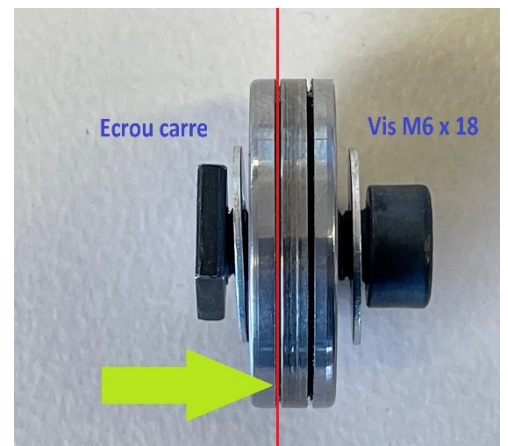


Figure 4

- Mounting the bearing on the guide :

- Install the lower bearing by placing the two washers **on each side of the bearing**. (Fig 5)
Only the square nut must be inserted in the groove of the lower guide.

- Adjust the position of the guide slightly behind the axis of the blade (Fig 6)

- Move the two lateral bearings of the blade guide apart. (Fig 7)

The scroll saw will be guided by the **left** groove. (Fig 7)

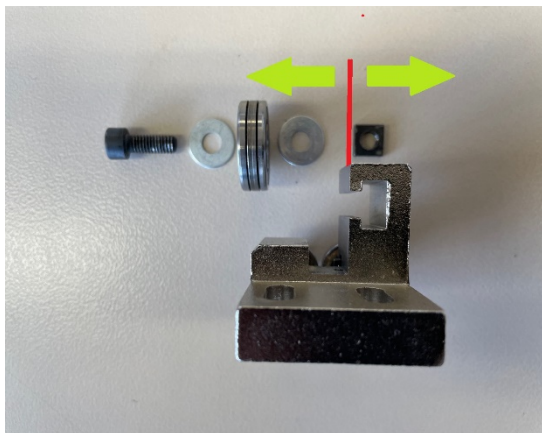


Figure 5

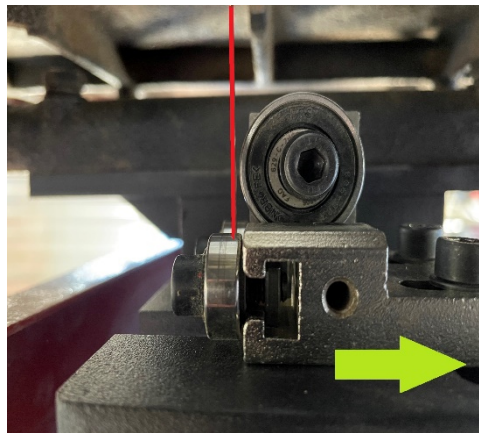


Figure 6

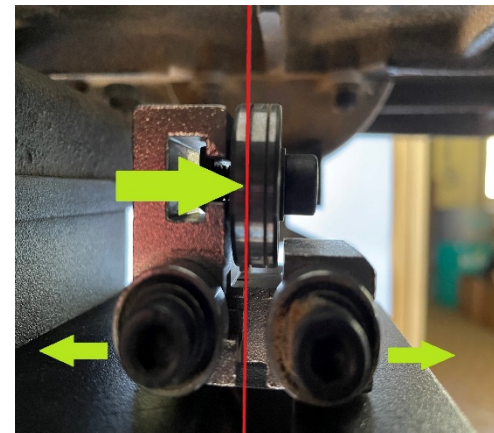


Figure 7

Mounting the scroll bearing on the upper guide:

- Remove the upper classic cutter bearing. (Fig 8)
- Unscrew the two fixing screws and remove the blade guide from the axis. (Fig 9)

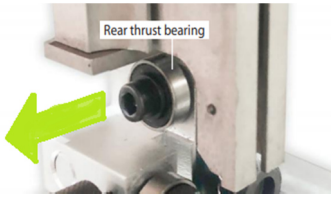


Figure 8

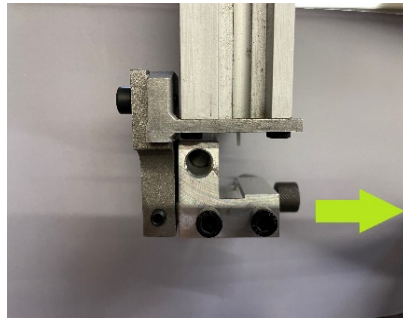


Figure 9

- Mounting the bearing on the guide :

The symbol **>** engraved on the bearing indicates the groove to use: **band saw 12 > band saw 9** (Fig 10)

- Mount the M6 x 18 screw, the square nut and two M6 x 18 x 0.8 mm washers supplied with the scrolling bearings, on one of the scroll bearings. (Fig 11)

The scroll saw will be guided by the right groove. (Fig 12)

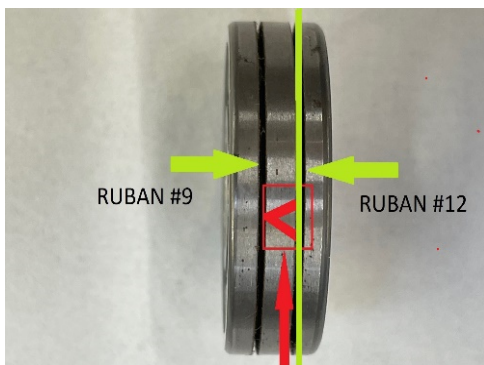


Figure 10

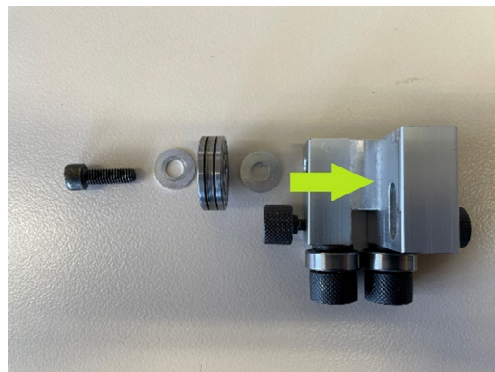


Figure 11

- Mount the blade guide in the scrolling position by pivoting it from its classic cutting position and move the two side bearings apart. (Fig 12-13)

Classic cutting position

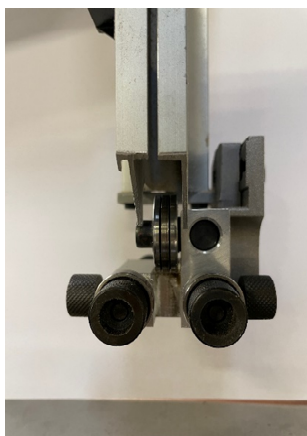


Figure 12

Scrolling position

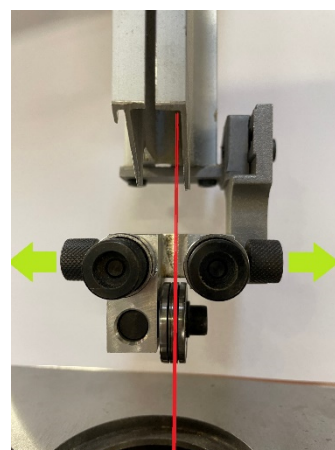


Figure 13

Mounting of the scrolling band saw :

- # Mount the scroll band saw on the upper wheel. (Machine manual pages 8 Fig.02-03-04-05)
- Hold the tape **to the center** of the upper wheel with two pieces of tape or two clips. (Fig 14-15)

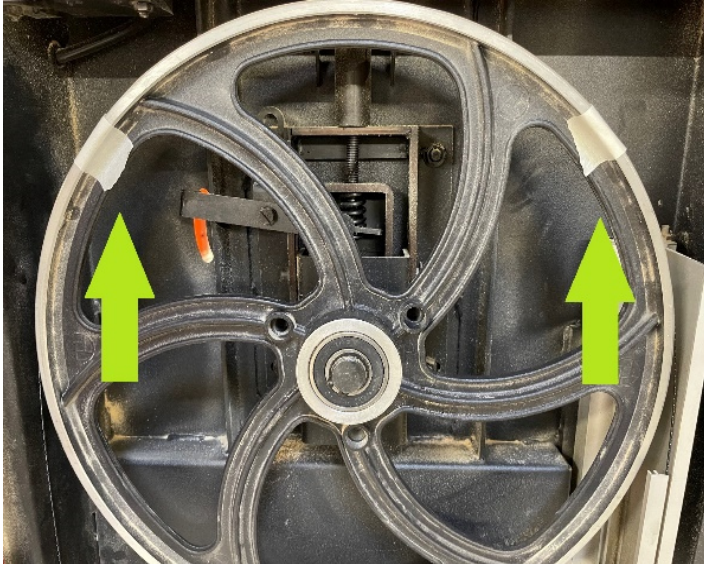


Figure 14



Figure 15

- Tension the band saw sufficiently with the tension knob to have good rigidity, holding the band saw manually **in the center** of the lower wheel. (Fig 16)

Indicative minimum tension: **3.5** on the indicator on the back of the machine. (Fig 17)



Figure 16



Figure 17

Adjustment of the scrolling upper guide :

- The two side bearings must be spaced. (Fig 19)
- Adjust the guide laterally on the fixing axis with the M6 x 12 screws so that :
the right groove of the bearing is precisely in the axis of the blade. (Fig 18-19)

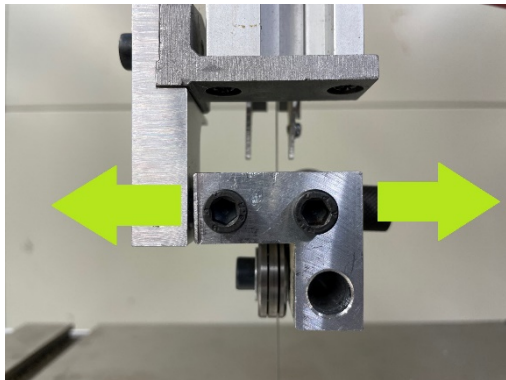


Figure 18

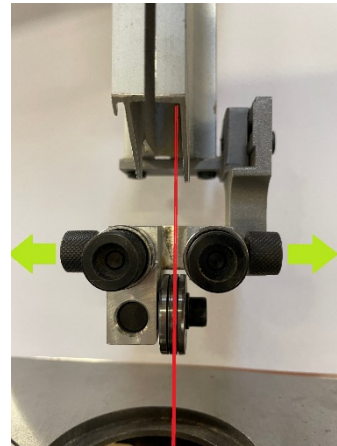


Figure 19

- Tighten the two M6 x 12 screws gradually, checking the position of the bearing.
- after loosening the top screw, advance the guide to the bearing groove by sliding the guide. Before tightening the screw, make sure the guide is in the correct position in the slide. (Fig 20)
- Then precisely adjust the depth of the guide with the bearing screw so that the heel of the band saw enters in the groove of the scroll bearing. (Fig 21)
- Tighten the bearing screw

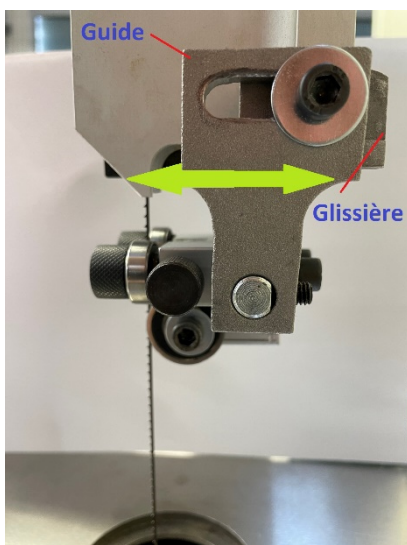


Figure 20

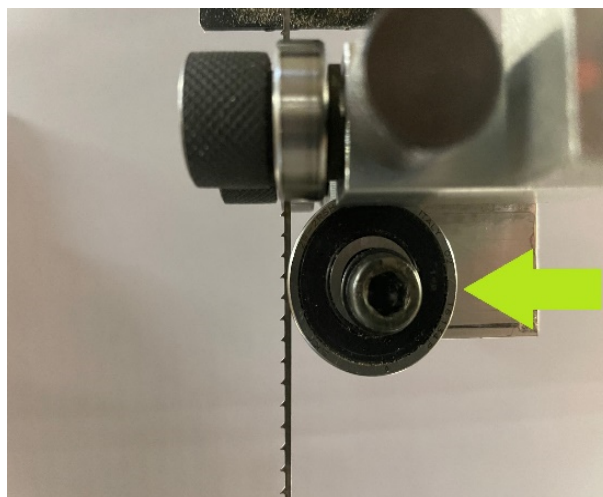


Figure 21

Adjustment of the lower scrolling guide :

- This adjustment can be made by observing the position of the blade guide through the opening of the table insert. (Fig 22)
- Loosenig the two fixing screws of the lower guide

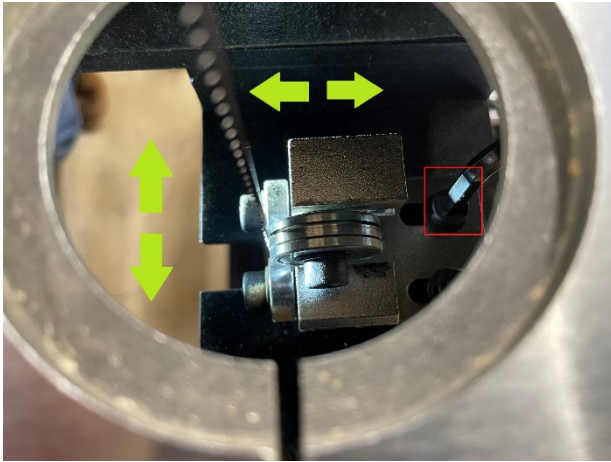


Figure 22

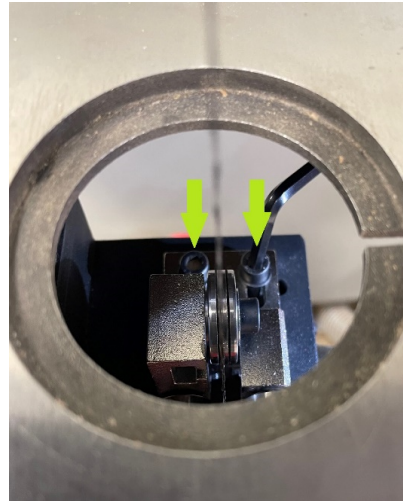


Figure 22b

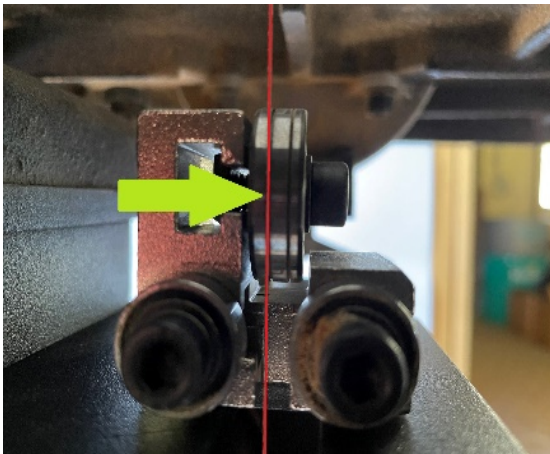


Figure 23

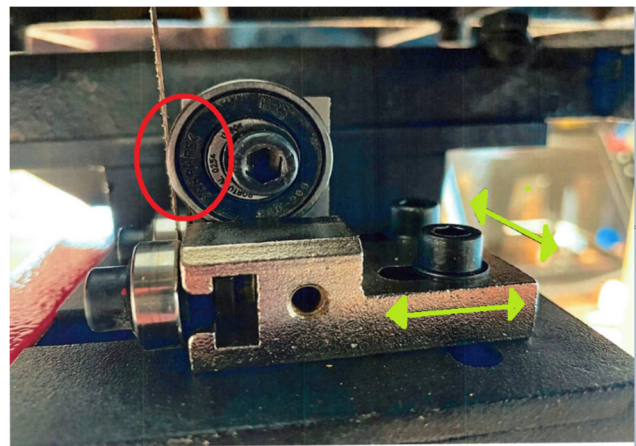


Figure 24

- Then adjust the depth of the left guide so that the heel of the band saw enters in the groove of the scroll bearing (Fig 23), and simultaneously adjust the guide laterally so that The left groove of the bearing is precisely in the axis of the blade. (Fig 24)

- Tighten the fixing screws, being careful not to change the setting.

Centering the band saw blade on the upper wheel :

- Turn the wheel manually in the direction of sawing while gently adjusting the tracking control screw.

Clockwise: the blade moves backwards on the belt towards the inside.

Counterclockwise: the blade moves outward on the belt.

(Fig 25 et 26)

- When centering, if the tape deviates quickly, turn the handwheel in the opposite direction to bring it back to the center of the belt and continue adjusting with the tracking control screw.

- Manually rotate the handwheel in the direction of sawing, making sure that the position of the band in the middle of the handwheel does not vary, then lock the tracking control screw. (Fig 25)

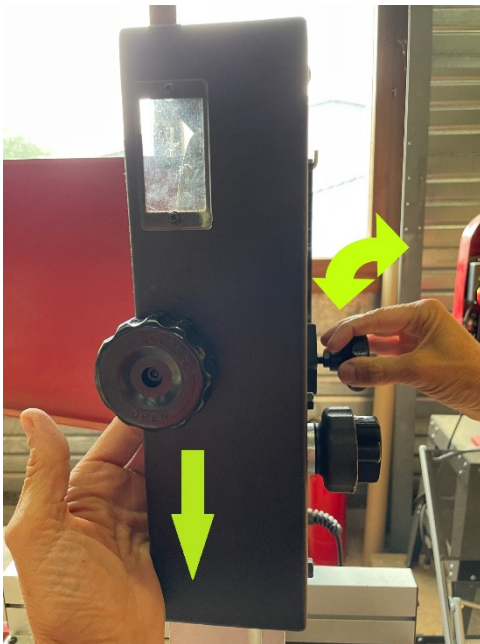


Figure 25



Figure 26

- Manually turn each wheel in the direction of sawing, checking that the position of the blade on the bearings has not changed, and adjust the setting if necessary. (Fig 27)



Figure 27

NB : As the band saw blade is retensioned, the centering may vary.

Start-up and controls :

- # Replace the lower guide guard. (Machine manual page 10 Fig. 16)
- # Control squareness between the table and band saw blade. (Machine manual page 21 Fig.53-54-55-56)
- Mount the insert table for scrolling. (Fig 28)

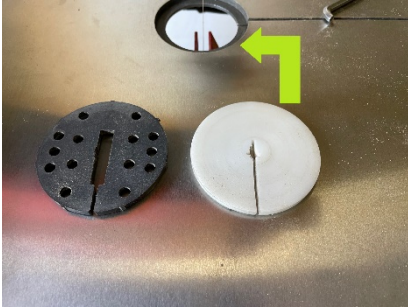


Figure 28

- Reconnect the machine's power supply to the mains and close the doors.
- Start the machine and check that the blade does not move on the belt of the wheels.
- Stop the machine and adjust the setting if necessary.

Your Pégas machine is ready for scrolling !

Advices for the firsts tests :

- Turn while moving forward to avoid pulling the blade out of guiding groove.
- Avoid moving backwards.
- During scrolling, always observe the proper positioning of the blade in the top fence groove, especially before starting a tight curve.
- Move forward at the appropriate speed in regard of wood thickness to cut, to allow time for band saw blade to clear the sawdust.

Switching from the scrolling mode configuration to classic cutting:

Returning to the classic cut mode configuration does not require changing the bearings.

- Loosen and remove the scrolling blade and the table insert.
- Move the upper blade guide to the rear position (Fig 29) then rotate it to the classic cut position. (Fig 30,31)

Scrolling position

Classic cut position

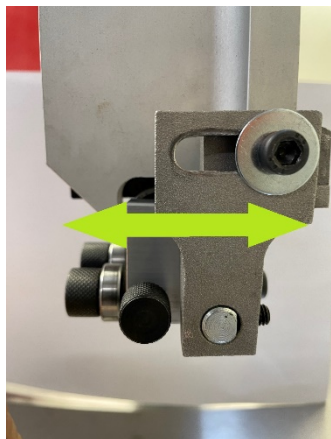


Figure 29

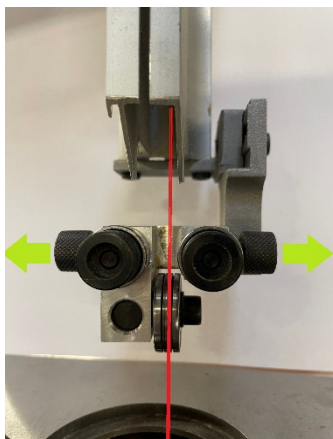


Figure 30

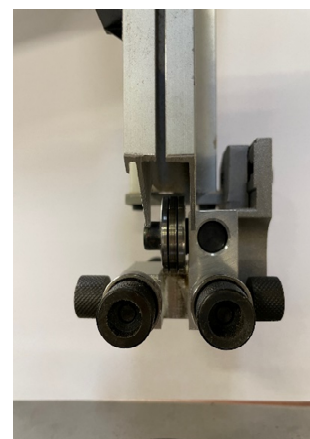


Figure 31

Mount the classic cut band saw blade and center it as explained in the chapter: "Centering the band saw blade".

Adjustment of the upper guide on the classic cut band saw blade :

- Move the bearing back. (Fig 32)
- Move the fence forward so that the side bearings are level with the heel of the saw blade. (Fig 33)
- Adjust depth of the guide with the bearing until it is in contact with the blade. (Fig 34)

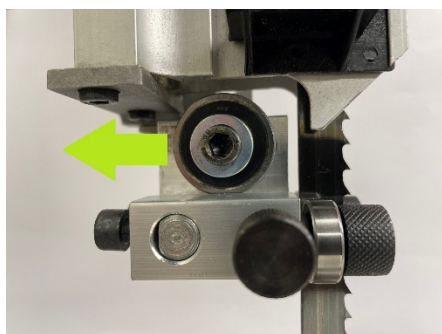


Figure 32

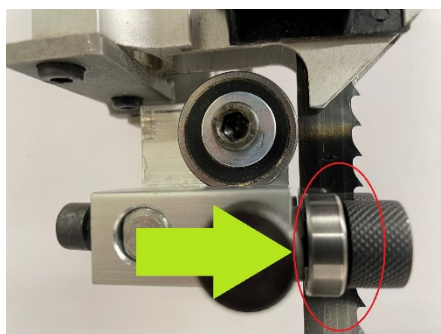


Figure 33

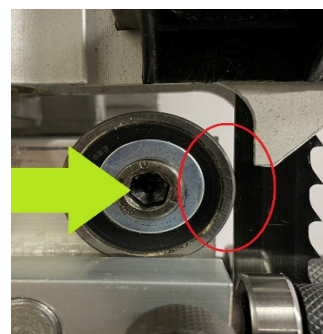


Figure 34

- Center the bearing so that the blade rests against the space between the two scrolling grooves (Fig 35)
- Adjust the side bearings at approximately 0.5 mm of the blade. (Fig 36)

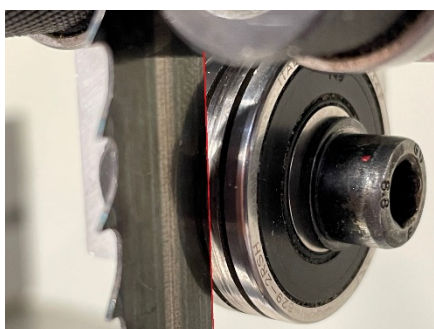


Figure 35

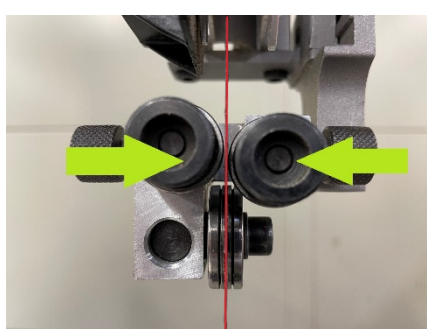


Figure 36

Adjustment of the lower guide on classic cut band saw blade :

- Move forward the scroll bearing so that it is in contact with the classic cut blade and the lateral bearings in front of the heel of the blade. (Fig 37)
- Center the bearing with the 2 fixation screws of the guide, so that the blade is in contact with the space between the two scrolling grooves, (Fig 38)
- Adjust lateral bearings. (Fig 37-39)

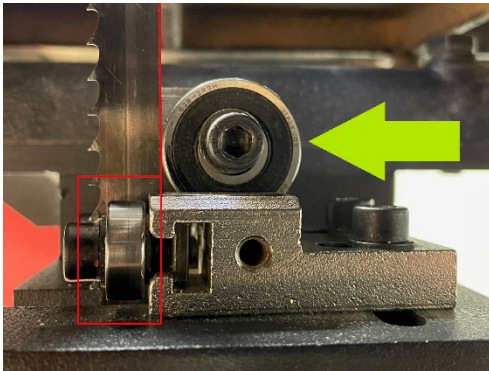


Figure 37

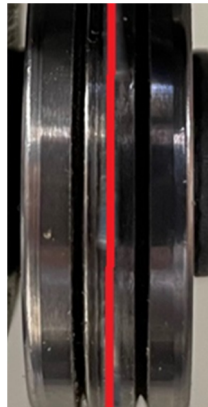


Figure 38

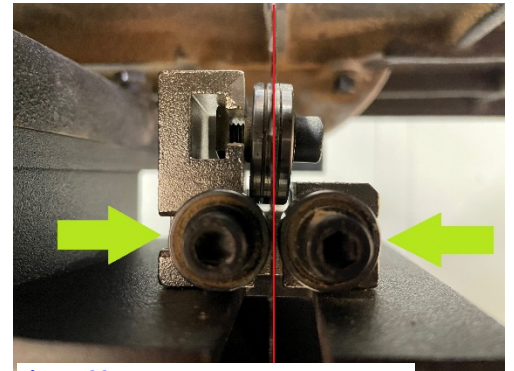


Figure 39

- Manually turn each wheel in the direction of sawing, checking that the position of the blade on the bearings has not changed, and adjust the setting if necessary (Fig 40)
- Replace the classic cut table insert. (Fig 41)

NB : It is important that the scroll bearings are rotating when cutting to avoid wear.



Figure 40



Figure 41






Your Pégas band saw is ready for classic cutting !

LAMES DE SCIE A RUBAN PÉGAS®

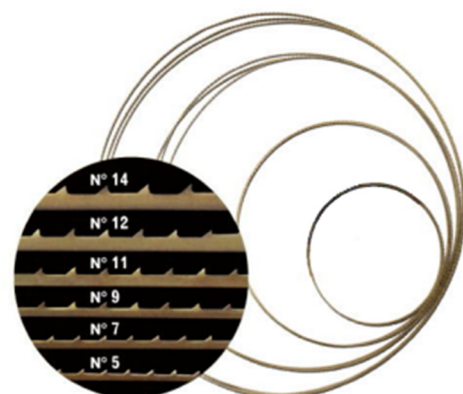
Les rubans sont fabriqués à partir des meilleurs aciers du marché mondial. Ces lames uniques bénéficient de processus de fabrication à la pointe de la technologie actuelle. Les 50 ans d'expérience acquis dans la fabrication de lames de scies de précision permettent de proposer un nouveau produit abouti dont les performances dépassent les attentes des utilisateurs les plus avertis.

La géométrie des dents des lames Pégas® a été soigneusement étudiée pour éliminer complètement les vibrations lors de la coupe. Les résultats qui en découlent sont stupéfiants ; La coupe performante et précise laisse un excellent niveau de finition, tant dans des bois durs que tendres, et dans des épaisseurs allant jusqu'à 150mm. Ces lames de précisions permettent de réaliser des courbes très serrées avec des rayons inférieurs à 2mm sans brûler le bois. Les différentes dimensions de lames permettent de répondre aux exigences des différentes essences de bois, de l'épaisseur et de la complexité des objets à scier.

N°	Art.	 [mm]	 [mm]	 [mm]	Z/cm	TPI	Roulement Führungsrolle Bearing Rondamiento
5	91.005/23 00	0,36	0,40	1,02	5,3	13,4	92.000-5
7	91.007/23 00	0,40	0,46	1,24	4,6	11,8	92.000-7
9	91.009/23 00	0,44	0,52	1,34	4,1	10,5	92.000- 9
11	91.011/23 00	0,50	0,62	1,80	3,6	9,2	92.000-11/12
12	91.012/23 00	0,50	0,63	2,00	3,5	8,9	92.000-11/12
14	91.014/23 00	0,50	0,65	3,00	3,2	8,2	92.000-14

LAMES BLÄTTER BLADES HOJAS

N° 5 > N° 14






D'autres roulements sont proposés en option pour le guidage optimal des autres lames Pégas®:



- 92.000-U Roulement Universel (livré avec la machine)
- 92.000-5 Roulement pour lames n°5.
- 92.000-7 Roulement pour lames n°7
- 92.000-11/12 Roulement pour lames n°11 et 12.
- 92.000-14 Roulement pour lames n°14.
- 92.000-9 Roulement pour lames n°9

Lames de scie et roulements livrés avec le kit de chantournage :

N°	Art.	 [mm]	 [mm]	 [mm]	Z/cm	TPI
9	91.009/23 00	0,44	0,52	1,34	4,1	10,5
12	91.012/23 00	0,50	0,63	2,00	3,5	8,9

