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Shepshed
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SIP 10" Variable Speed Swivel Head Metal-Cutting Bandsaw

SIP Code: 01526

Instruction Manual

For help or advice please contact
your distributor, or sip directly
on:

Tel.: 01509 500400

Email:

sales@sip-group.com

or

customerservice@sip-group.com

www.sip-group.com

Please read and fully understand the instructions in this manual before operation. Keep
this manual safe for future reference.

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SAFETY SYMBOLS USED THROUGHOUT THIS MANUAL



Danger / Caution: Indicates risk of personal injury and/or the possibility of damage.



Warning: Risk of electrical injury or damage!



Note: Supplementary Information.

SAFETY INSTRUCTIONS



Important: Please read the following instructions carefully, failure to do so could lead to serious personal injury and / or damage to the saw.

When using your bandsaw, basic safety precautions should always be followed to reduce the risk of personal injury and/or damage to the bandsaw.

Read all of these instructions before operating the bandsaw and save this user manual for future reference.

The bandsaw should not be modified or used for any application other than that for which it was designed.

Do not use this bandsaw for anything other than its intended purpose; this bandsaw is designed for metal cutting work in engineering workshops, garages, metal fabricators, etc.

If you are unsure of its relative applications do not hesitate to contact us and we will be more than happy to advise you.

Before operating the bandsaw always check no parts are broken, and that no parts are missing.

Always operate the bandsaw safely and correctly.

KNOW YOUR BANDSAW: Read and understand the owner's manual and labels affixed to the bandsaw. Learn its applications and limitations, as well as the potential hazards specific to it.

KEEP CHILDREN AND UNTRAINED PERSONNEL AWAY FROM THE WORK AREA: All visitors

should be kept at a safe distance from the work area; never allow untrained persons to operate the bandsaw.

STAY ALERT: Always watch what you are doing and use common sense.

NEVER LEAVE THE BANDSAW UNATTENDED: When in use, or connected to the mains supply.

SAFETY INSTRUCTIONS Cont...

KEEP WORK AREA CLEAN AND WELL LIT: Cluttered work areas and dark areas invite accidents. Floors must not be slippery due to oil, water or sawdust etc.

HAVE YOUR BANDSAW REPAIRED BY A QUALIFIED PERSON: The bandsaw is in accordance with the relevant safety requirements. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user and void the warranty.

DANGER! Check that the bandsaw is in sound condition and good working order before each use; Take immediate action to repair or replace faulty / damaged parts.

WARNING! Only operate on a level and stable surface.

WARNING! RISK OF ELECTRIC SHOCK. Do not expose the bandsaw to water spray, rain, dripping water or moisture of any kind.

PROTECT YOURSELF FROM ELECTRIC SHOCK: When working with power tools, avoid contact with any earthed items (e.g. pipes, radiators, hobs and refrigerators, etc.). It is advisable wherever possible to use an RCD (residual current device) at the supply socket.

DO NOT ABUSE THE MAINS LEAD: Never pull the mains lead to remove the plug from the mains socket, or to move the bandsaw from place to place. Keep the mains lead away from heat, oil and sharp edges. If the mains lead is damaged, it must be replaced by the manufacturer or its service agent or a similarly qualified person in order to avoid unwanted hazards.

ALWAYS check that the blade guards / guides are in place, adjusted correctly, un-damaged and firmly attached.

NEVER STAND ON THE BANDSAW: The bandsaw is not designed for this purpose.

DO NOT dismantle, tamper with or modify the bandsaw, as this may be dangerous and will invalidate the warranty.

SECURE THE WORKPIECE: Use the vice to hold the workpiece; this frees up both hands to operate the saw.

REMOVE ADJUSTING KEYS AND WRENCHES: Form a habit of checking to see that keys and adjusting tools are removed from the bandsaw before every use.

- If a problem with the bandsaw is experienced or suspected stop using the bandsaw immediately and contact your distributor for repair.
- Regularly inspect the bandsaw, ensuring that it is in good working order and condition.
- Always ensure that the work area is clean, tidy and free from unrelated materials.
- Operate away from flammable objects, materials & surfaces.
- Use in a location where accidental contact (particularly by children) is unlikely.
- Ensure on/off switches are switched to off position (0) before connecting the mains lead to the power supply.
- Keep the work area clean and clear of possible tripping hazards.
- Keep children and unauthorised persons away from the bandsaw, as it has a sharp blade!
- Disconnect from the mains before moving or attempting any cleaning or maintenance.

SAFETY INSTRUCTIONS Cont...

- Keep hands and all other body parts away from the blade.
- Turn the bandsaw off and disconnect it from the mains supply when moving from one location to another.
- Never operate the bandsaw without all guards in place.
- **DO NOT** get the bandsaw wet or use in damp or wet locations or areas where there is condensation.
- **DO NOT** move the bandsaw whilst in operation.
- **DO NOT** remove or adjust the blade guard / guides whilst the bandsaw is switched on.
- **DO NOT** allow unqualified persons to disassemble the bandsaw for any reason, the bandsaw must be checked and adjusted etc. by qualified personnel only.
- **DO NOT** use the bandsaw without the blade guard / guides correctly set, as this could lead to personal injury to you or others!
- **ALWAYS** ensure a blown fuse is replaced with the correct fuse type and rating.
- **DO NOT** place any objects on the safety guard or on the covers at any time.
- When not in use, store the bandsaw carefully in a safe, dry, childproof location.
- **NEVER** cover the bandsaw during operation or whilst it cools after operation.
- Be aware of moving parts that occur during normal operation of this bandsaw.
- **NEVER** operate the bandsaw with damaged, broken or missing parts, or with any guards or covers removed.
- **DO NOT** operate the bandsaw or any electrical items with wet hands.
- Keep the floor around the machine clean and free of scrap material, oil and grease etc.
- **ALWAYS** keep the machine guards in place at all times when the machine is in operation, if removed for maintenance, use extreme caution, always refit the guards immediately after any maintenance.
- **DO NOT** over reach, always maintain a balanced stance so that you do not fall or lean into any moving parts.
- Keep all visitors at a safe distance.
- **ALWAYS** keep hands and fingers away from the blade when in operation.
- **ALWAYS** use the vice to secure your workpiece, never cut any workpiece without using the vice; this is extremely dangerous!
- **ALWAYS** have the blade cover correctly fitted and secure at all times when the machine is in operation, failure to do this can lead to personal injury.
- **ALWAYS** use adequate roller stands for supporting longer and heavier workpieces.
- **ALWAYS** use the correct blade, using the correct tpi blade for cutting the workpiece will make your job easier, and the blade last longer, using the wrong tpi blade will make a rough cut and will decrease the life of the blade.
- **NEVER** force the blade through the workpiece, this will decrease the life of the blade.
- **ALWAYS** keep the bandsaw as clean as possible and keep blades sharp for best and safest performance.
- **WARNING!** round bar and tubing have a tendency to roll whilst being cut and can cause the blade to slip, **DO NOT** cut such items without clamping or blocking the workpiece.

SAFETY INSTRUCTIONS Cont...

- **DO NOT** start the bandsaw until the workpiece is secure and the blade has been lowered to just above the workpiece.
- **NEVER** use damaged or deformed bandsaw blades.
- **ALWAYS** secure the workpiece that is too be cut in the vice.
- **NEVER** use the bandsaw with the blade guard or wheel cover removed.
- **DO NOT** use whilst under the influence of drugs, alcohol or other intoxicating medication.
- **NEVER** start the bandsaw with the blade in contact with the workpiece.
- **ALWAYS** allow the bandsaw to reach full speed before commencing the cutting operation.
- **NEVER** use this bandsaw for any application other than that specified by the manufacturer.
- **NEVER** operate this bandsaw under conditions not approved by the manufacturer.
- Before using or servicing your bandsaw, read and understand all instructions. Failure to follow safety precautions or instructions can cause equipment damage and/or serious personal injury.
- **WEAR THE CORRECT CLOTHING.** Do not wear loose clothing, neckties, rings, brace-lets, or other jewellery, which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Roll long sleeves up above the elbow.
- If the bandsaw is used in a place of work all rules and laws etc. relating to the use of portable electrical appliances should be followed.
- Failure to follow the warnings in this manual, may result in personal injury and/or property damage.
- Understand the operating environment; Before each use the operator should assess, understand and where possible reduce the specific risks and dangers associated with the operating environment. Bystanders should also be made aware of any risks.



When using the saw, particularly during extended periods; ensure the operator as well as those in the area wear ear protection.



When using the saw always ensure the operator as well as those in the area wear eye protection.



Some materials have the potential to be highly toxic; always wear a face mask when operating the saw.



CAUTION: The warnings and cautions mentioned in this user manual can not cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be applied.

ELECTRICAL CONNECTION

WARNING! It is the responsibility of the owner and the operator to read, understand and comply with the following:

You must check all electrical products, before use, to ensure that they are safe.

You must inspect power cables, plugs, sockets and any other connectors for wear or damage.

You must ensure that the risk of electric shock is minimised by the installation of appropriate safety devices; A residual current circuit Breaker (RCCB) should be incorporated in the main distribution board. We also recommend that a residual current device (RCD) is used. It is particularly important to use an RCD with portable products that are plugged into a supply which is not protected by an RCCB. If in any doubt consult a qualified electrician.

Connecting to the power supply:

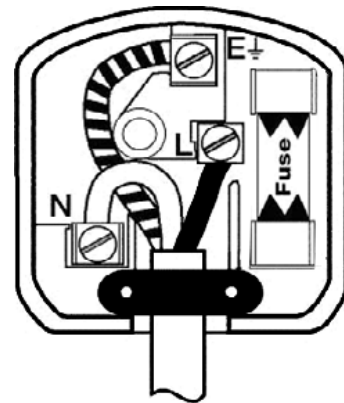
This SIP bandsaw is fitted with a standard 230v ~ 13 amp type plug. Before using the bandsaw, inspect the mains lead and plug to ensure that neither are damaged. If any damage is visible have the bandsaw inspected / repaired by a suitably qualified person. If it is necessary to replace the plug a heavy duty impact resistant plug would be preferable.

The wires for the plug are coloured in the following way:

Yellow / green Earth

Blue Neutral

Brown Live



When using the saw, particularly during extended periods; ensure the operator as well as those in the area wear ear protection.



ELECTRICAL CONNECTION Cont...



Warning: Never connect live or neutral wires to the earth terminal of the plug. Only fit an approved plug with the correct rated fuse. If in doubt consult a qualified electrician.



Note: Always make sure the mains supply is of the correct voltage and the correct fuse protection is used. In the event of replacing the fuse always replace the fuse with the same value as the original.



Note: If an extension lead is necessary in order to reach the mains supply; The cross section should be checked so that it is of sufficient size so as to reduce the chances of voltage drops. Always fully unwind the lead during use.

GUARANTEE

This SIP bandsaw is covered by a 24 month parts and labour warranty covering failure due to manufacturers defects. This does not cover failure due to misuse or operating the bandsaw outside the scope of this manual - any claims deemed to be outside the scope of the warranty may be subject to charges Including, but not limited to parts, labour and carriage costs.

This guarantee does not cover consumables such as bearings, oil, blades etc.

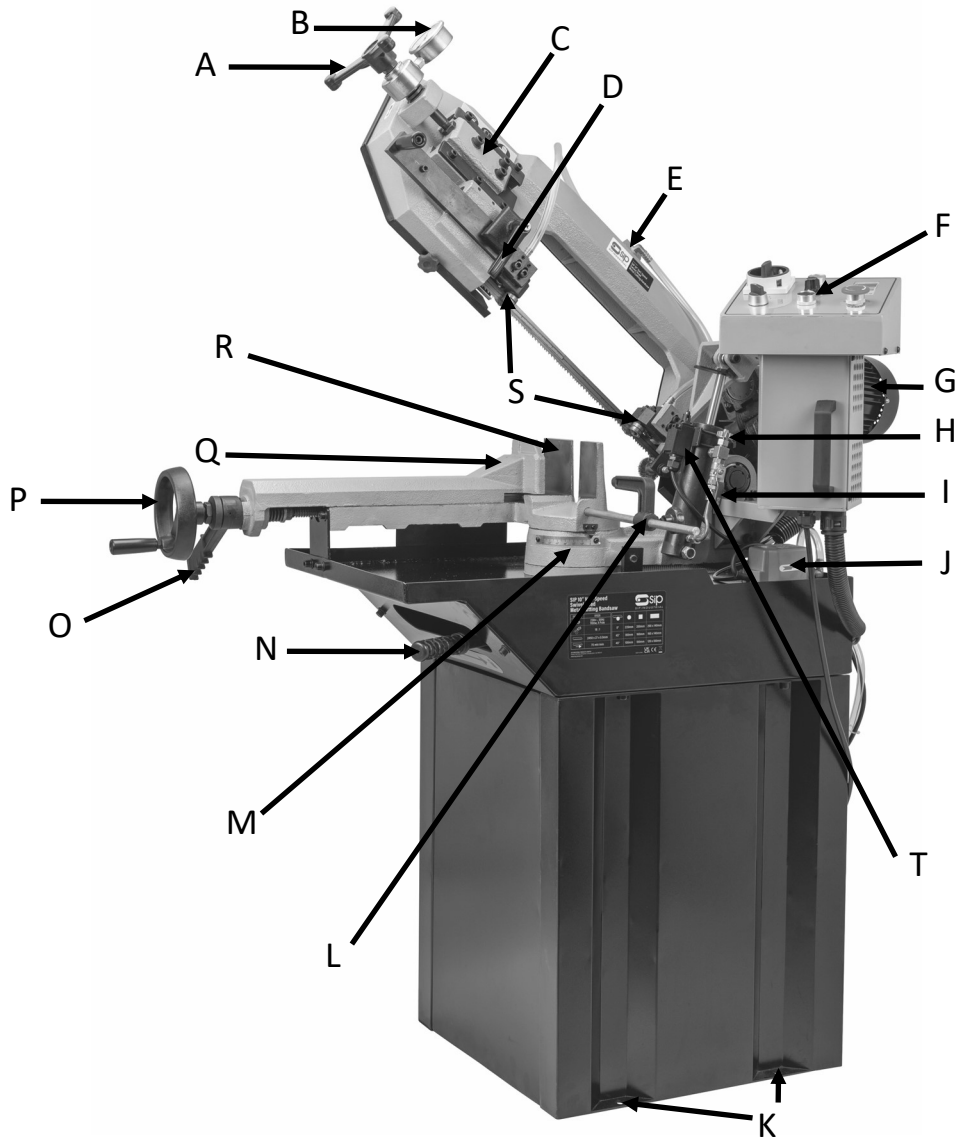
In the unlikely event of warranty claims, contact your distributor as soon as possible.



Note: Proof of purchase will be required before any warranty can be honoured.

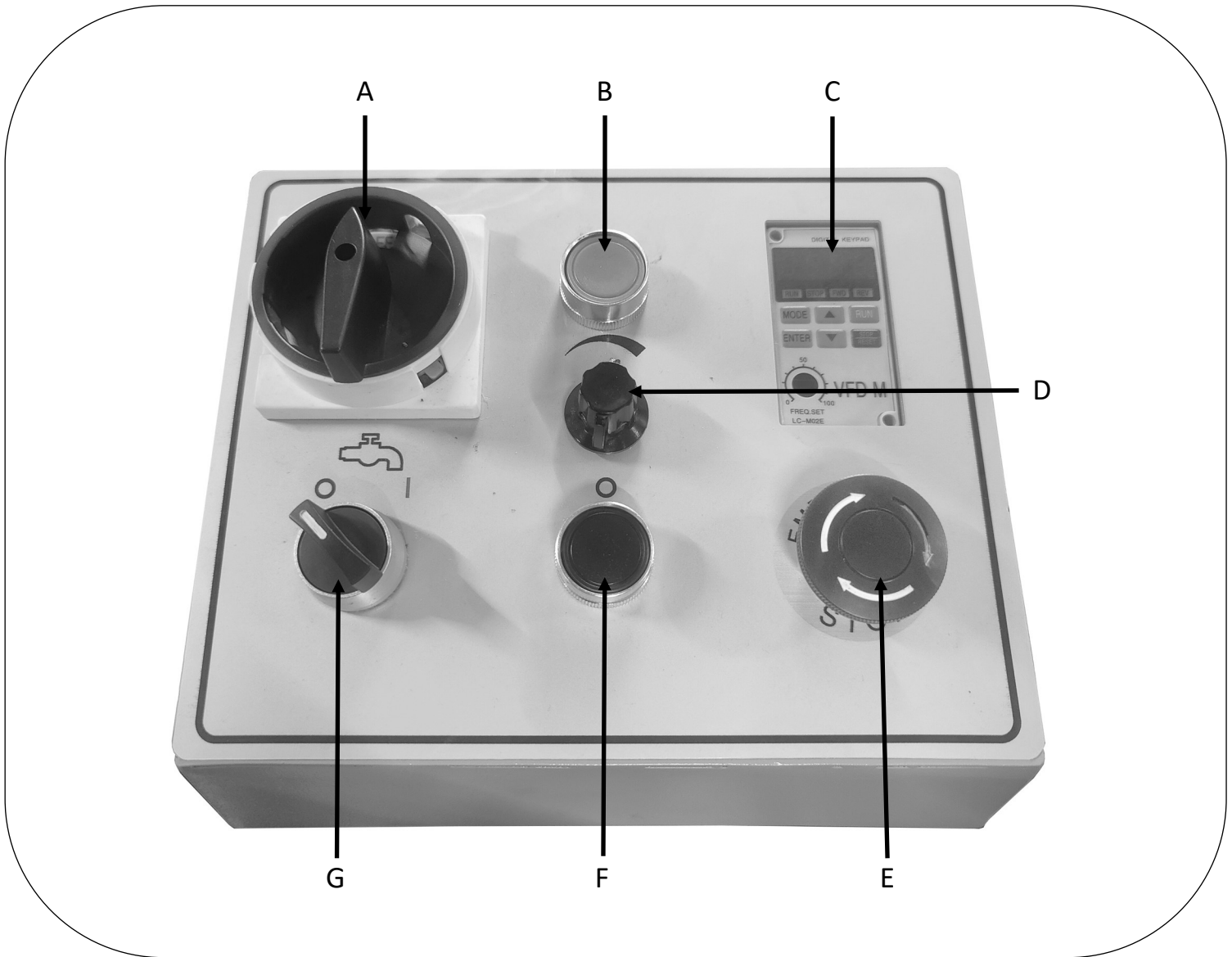
GETTING TO KNOW YOUR BANDSAW

01526



<i>Item</i>	<i>Description</i>	<i>Item</i>	<i>Description</i>
A	Blade-Tension Hand Wheel	K	Anchor Points
B	Blade Tension Gauge	L	Workpiece Stop
C	Blade Tracking Adjustment	M	Swivel Angle Scale
D	Blade Guide Lock	N	Swivel Release/Lock
E	Coolant Tap	O	Vice Release / Lock
F	Control Panel	P	Vice Adjust Hand Wheel
G	Motor	Q	Moveable Vice
H	Bow Control (Speed)	R	Fixed Vice Jaw
I	Bow Lock (On/Off)	S	Blade Guides
J	Coolant Pump	T	Cut-Off Micro-Switch

CONTROL PANEL



<i>Item</i>	<i>Description</i>	<i>Item</i>	<i>Description</i>
A	Mains Isolator Switch	E	Emergency Stop
B	Motor Start	F	Motor Stop Button
C	Motor Inverter Control	G	Coolant Pump Switch
D	Motor Variable Speed Adjusting Knob	-	

TECHNICAL SPECIFICATION

<i>Model</i>	SIP 10" Variable Speed Swivel Head
<i>Part Number</i>	01526
<i>Input Voltage</i>	230V 50Hz
<i>Motor Power</i>	1.1kW / 1.5HP
<i>Circular 0°</i>	220 mm
<i>Circular 30°</i>	190 mm
<i>Circular 45°</i>	160 mm
<i>Circular 60°</i>	100 mm
<i>Square 0°</i>	200 mm
<i>Square 30°</i>	180 mm
<i>Square 45°</i>	160 mm
<i>Square 60°</i>	100 mm
<i>Rectangle 0°</i>	260 x 140 mm
<i>Rectangle 30°</i>	200 x 140 mm
<i>Rectangle 45°</i>	160 x 140 mm
<i>Rectangle 60°</i>	120 x 100 mm
<i>Blade Speed</i>	0 - 90 m/min
<i>Blade Size</i>	2450 x 27 x 0.9 mm
<i>Drive</i>	Gearbox
<i>Packed Dimensions</i>	1350 x 580 x 970 mm
<i>Net Weight</i>	195 kg
<i>Gross Weight</i>	235 kg

CONTENTS & ACCESSORIES

- Bandsaw
- Bandsaw Base
- User Manual



Note: If any of the above are missing or damaged, contact your distributor immediately.

ASSEMBLY INSTRUCTIONS

UNPACKING



Caution: All die-cut metal parts have a sharp edge (called “flashing”) on them after they are formed. This is generally removed at the factory. Sometimes a bit of flashing might escape inspection, and the sharp edge may cause cuts or lacerations when handled, please examine the edges of all die-cut metal parts and file or sand the edge to remove the flashing before handling.

- The metal bandsaw is shipped from the factory in a carefully packed crate. If the machine is damaged on arrival, save the packaging and call the distributor.
- The metal bandsaw is a very heavy machine (235kg shipping weight) DO NOT over exert yourself while unpacking or moving your machine, get assistance. In the event that your machine must be moved up or down a flight of stairs, ensure that the stairs are capable of supporting the weight of the people and machine, as serious personal injury may occur.

CLEANING



WARNING: Do not use gasoline or other petroleum-based solvents to remove this protective coating. These products generally have low flash points which makes them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.



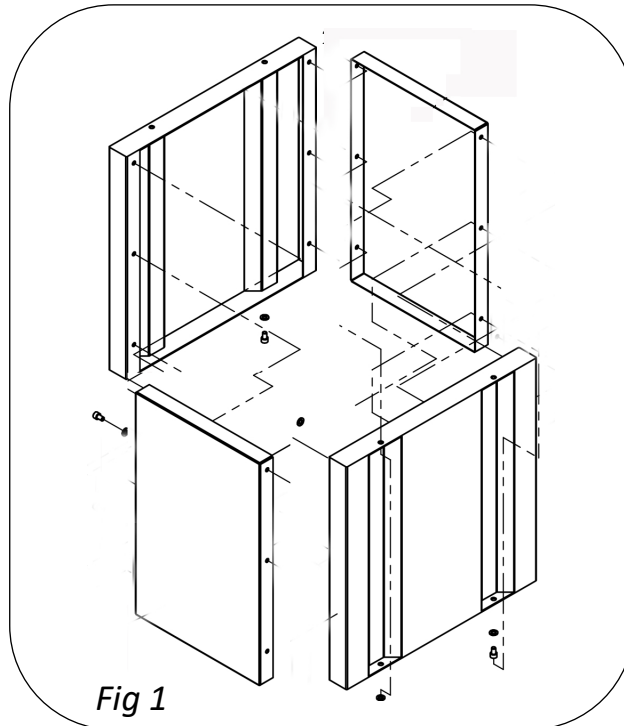
CAUTION: Many of the solvents commonly used to clean machinery can be highly flammable, and toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards. Keep children and animals safely away when cleaning and assembling this machine.

- The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the usage instructions on the product you choose for clean up.

ASSEMBLY INSTRUCTIONS Cont...

ASSEMBLING THE BASE

- This metal cutting bandsaw is completely assembled, just needs to assemble the machine stand.
- Assembling the machine stand as shown in Fig.1



ASSEMBLING THE BANDSAW

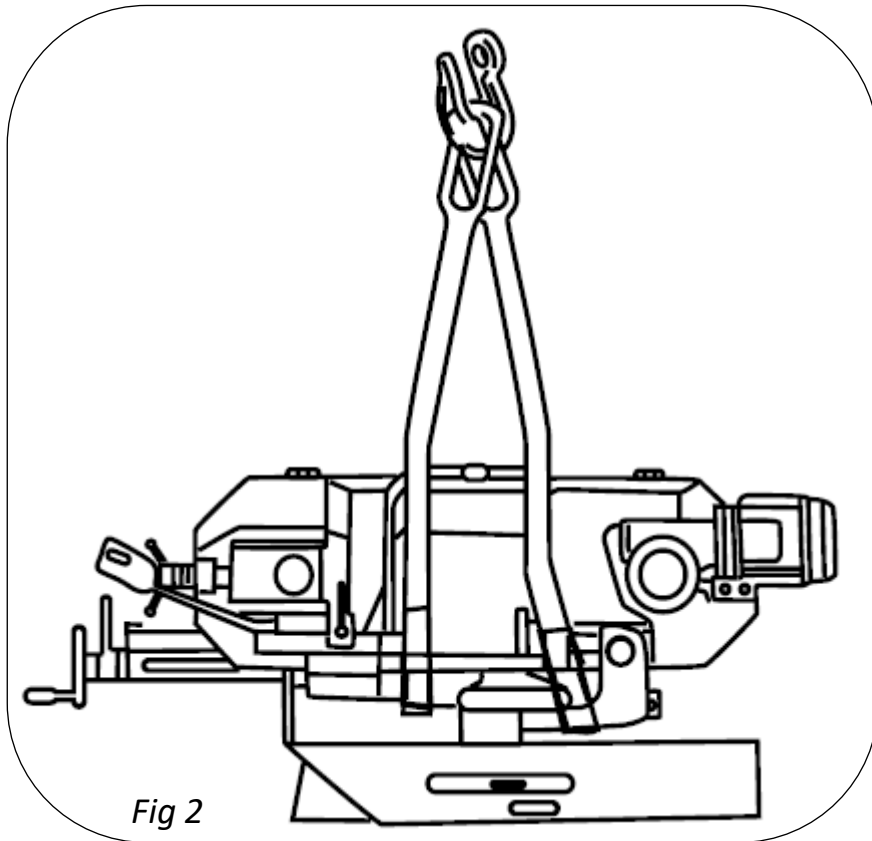


WARNING: Before starting to lift the machine make sure that all movable parts have been securely fastened. Ensure that the crane's lifting capacity is suitable for the machine. Lift the machine carefully and move it slowly, avoiding bumps or sudden movements.



CAUTION: The lifting and transporting operations can be extremely dangerous if not carried out with maximum caution. Move all unqualified personnel away from the area. Clean, clear and close off the installation area. Check the condition and suitability of the equipment available. Do not touch the suspended loads and remain at a safe distance from them.

- Carefully lift the saw head onto the base, and fasten the machine head by 4 x Hex head screw, M10x25, spring washer M10 and washer 10mm.
- Fig 2 shows how the lifting harness should be connected to the bandsaw.



ASSEMBLE THE ACCESSORIES

- Fit the mount bar stop rod.

DEACTIVATION OF THE BANDSAW

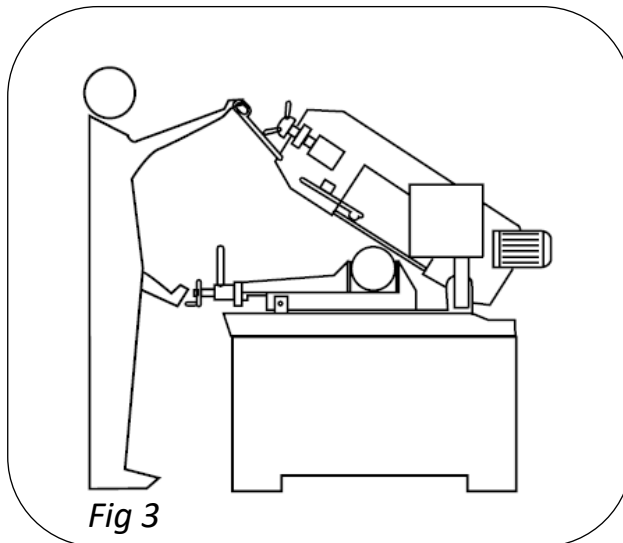
If the machine is to be out of use for a long period, it is advisable to proceed as follows:

- Detach the plug from the electric supply panel
- Loosen blade
- Release the arch return spring
- Lowering the saw arm as possible
- Empty the coolant tank
- Carefully clean and grease the machine
- If necessary, cover the machine

OPERATING INSTRUCTIONS

OPERATOR POSITION

- Only one operator is needed to use the machine, that must stand at the front of machine as shown Fig.3.

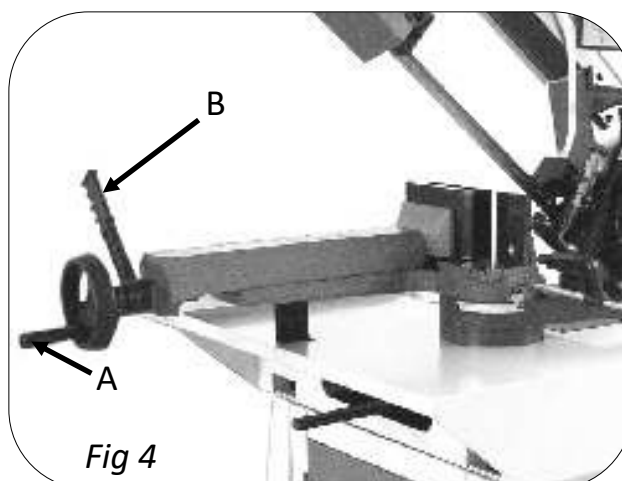


CLAMPING THE WORK PIECE



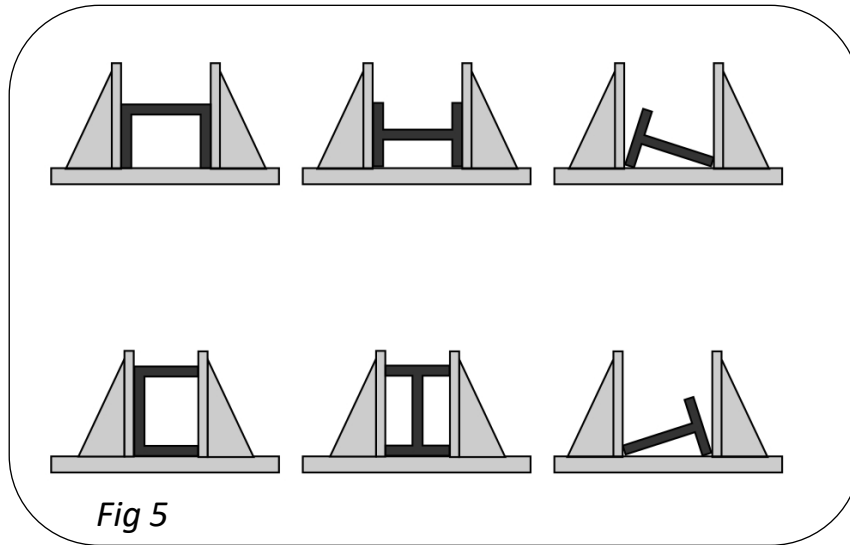
Caution: Always ensure the workpiece is fully locked in the vice before operating the saw.

- Place work piece between the jaws.
- As shown in Fig. 4 use the hand wheel (A) to approach the vice jaw to the work piece, leaving 3-4mm of space. Lock down work piece and lower the quick lock lever (B).
- When the cutting cycle is finished, release vice by raising the quick lock lever (B). Upon releasing the quick lock lever (B), the vice jaw will open to the same distance that was set initially. This allows for rapid loading of same size material.



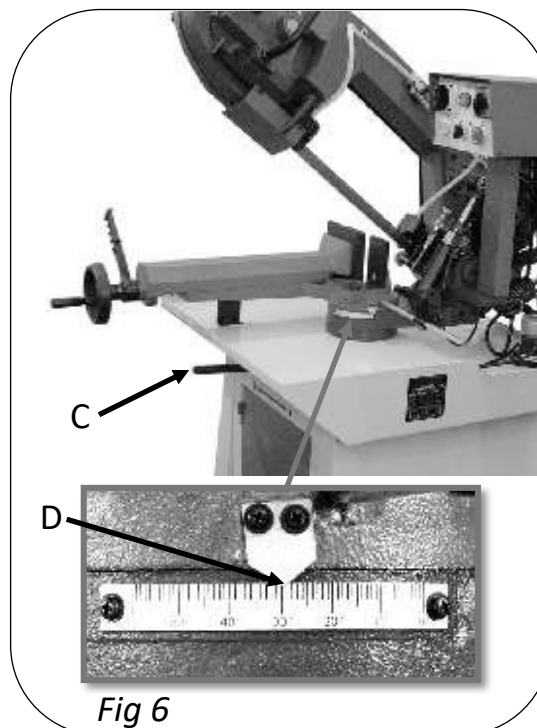
OPERATING INSTRUCTIONS Cont...

- Fig. 5 shows examples of suitable clamping of different section bars, take note of the cutting capacities of the machine in order to achieve a good efficiency and blade durability.



ADJUSTING THE CUTTING ANGLE

- The angle can be set up between 0°(90°) to 60°.
- Turn the saw arm lock lever (C) to left to loosen the saw arm.
- Turn the saw arm to desired angle, see the scale (D).
- Then turn the saw arm lock lever to right to lock the saw arm.



OPERATING INSTRUCTIONS Cont...

FILLING UP THE COOLANT



Note: We recommend the use of water soluble coolant, this will prolong the blade life and make the cut more efficient.

- Fill the bandsaw with coolant by pouring the coolant into the coolant tank via the coolant inlet mesh (E) shown in Fig. 7.

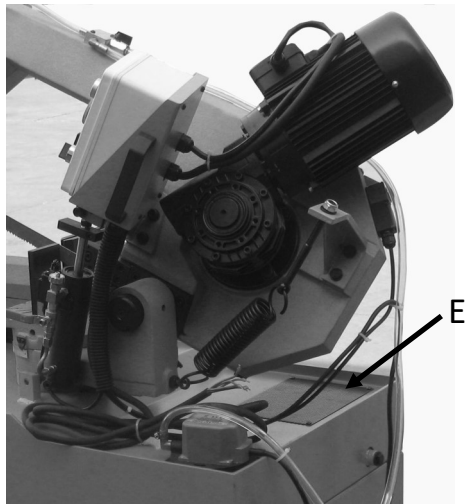


Fig 7

USING THE COOLANT PUMP

The coolant is pumped from the coolant tank by the coolant pump (J) and fed through a clear plastic tube to a valve/tap (F) situated on the top edge of the bow casting (see Fig. 8). When the valve is opened the coolant is fed through two separate pipes which deliver the coolant directly to each blade guide. The coolant then drops onto the machine bed where it flows to the lower level and returns to the coolant tank through the coolant inlet mesh situated above the coolant tank ready for recirculation.

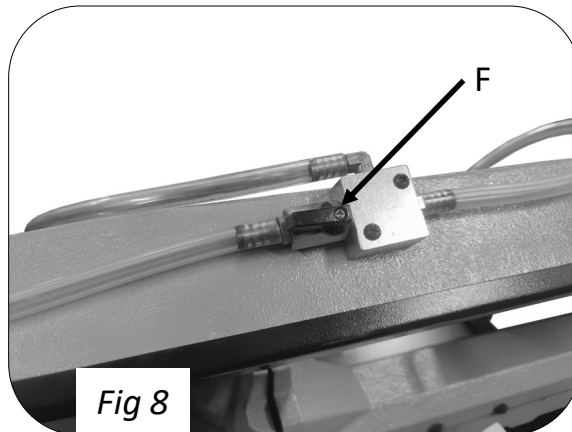


Fig 8

OPERATING INSTRUCTIONS Cont...

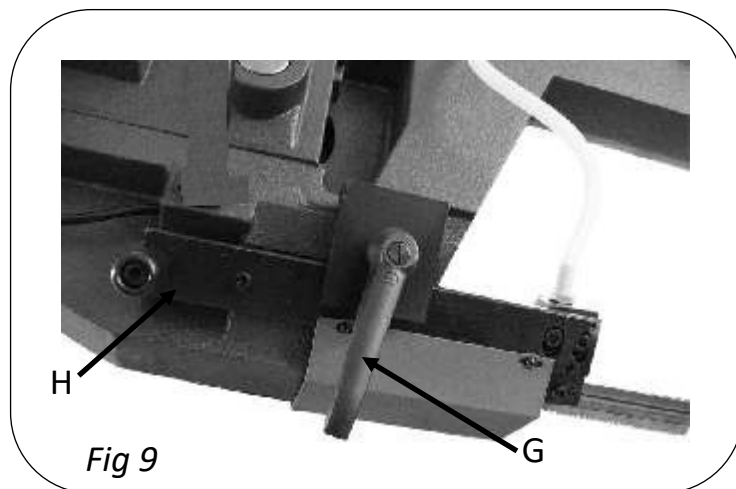
ADJUSTING THE BLADE GUIDES



WARNING: Disconnect the machine from the power source before adjusting the blade guides.

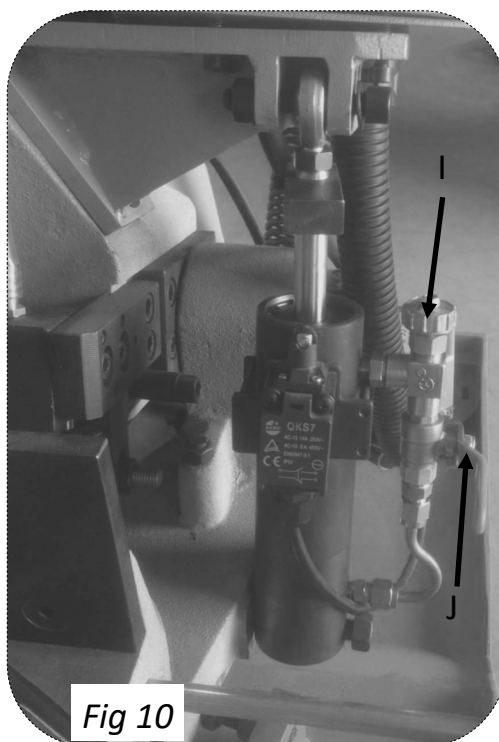
As per Fig. 9:

- Loosen the ratchet lever (G)
- Hold the handle (H) and slide blade guide block as close as possible to the material without interfering with cut.
- Tighten the ratchet lever (G).
- Re-connect the machine to power source.



ADJUSTING THE HYDRAULIC STOP

The hydraulic cylinder shown in Fig. 10 has an adjustable rate of descent; it can be adjusted by turning the knob (I) clockwise to slow down the rate, or anti-clockwise to speed up the rate of descent. The bow can be stopped in any position by turning the tap (J). When the tap is at 90° to the cylinder, the flow will stop and the bow will stop descending.



CUTTING WITH THE BANDSAW



Danger: Before attempting to cut always make sure all covers are on and secure.

1. Disconnect the bandsaw from the mains supply.
2. Fully close the hydraulic flow valve (J) & hydraulic control valve (I).
3. Check that the blade tension is correct. Refer to the blade tension gauge.
4. Raise the saw bow to its highest position.
5. Adjust the workpiece stop to your desired position (if required).
6. Set the vice angle to your desired position.
7. Open the vice and insert the workpiece to be cut then close the vice to secure.
8. Move the two adjustable blade guides closer to the workpiece, but make sure they don't foul against it or the saw.



Danger: Do not turn the machine on until the workpiece is secured and the blade has been lowered just above the workpiece.



Caution: Never remove the workpiece when the bandsaw is still running, always switch the machine off before attempting to remove the workpiece, failure to do this could lead to serious personal injury.



Caution: Never start the bandsaw with the blade in contact with the workpiece. Allow the saw to reach full speed before commencing cut.

AUTO-CUTTING OPERATION



Caution: All the parameters of the Inverter Control have been set by the manufacturer. There is no need to re-set before normal use. Fig. 11

- Adjust the rate of descent of the bow as described on page 20 so that it is creeping slowly down towards the workpiece, shut off the hydraulic cylinder when the blade gets close to the workpiece.
- If the blade guides need adjusting at this point follow the instructions detailed on page 20.
- Ensure the main power switch (S1) is in the off position and connect the bandsaw to the power supply. Fig. 11.
- Turn the main power switch (S1) on.



Caution: Never start the bandsaw with the blade in contact with the workpiece. Allow the saw to reach full speed before commencing cut.



Caution: If for some reason the saw is required to stop immediately, the emergency stop button (ES) shown in Fig.11 should be pressed. The emergency stop will stop all functions of the bandsaw.

1. Turn the coolant pump on via the switch S2. Fig 11.
2. Turn the saw blade on by pressing button Motor Start B1 and check the blade is running in the correct direction.
3. Adjust the blade to the required speed (0-90m/min) using the variable switch VS.
4. To bring the blade in to contact with the workpiece to be cut, open the hydraulic valve (J) Fig 10. If the blade jams then immediately turn the bandsaw off via the emergency stop and refer to the troubleshooting guide on page 26.

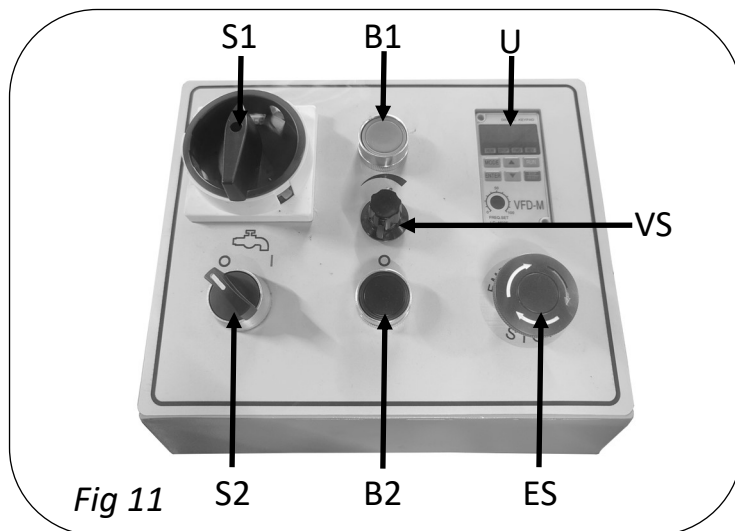


Fig 11

5. If the speed of the descent needs changing during the cut refer to the instructions detail on page 20.
6. Once the cut is complete, the saw should automatically stop. If the saw does not stop automatically stop adjust Cut-Off Micro-Switch (T).

MAINTENANCE

CHANGING THE BLADE



Caution: Before carrying out any maintenance always disconnect the bandsaw from the mains supply.



Caution: We strongly advise wearing gloves for protection when changing blades, blades are sharp and dangerous and can cause personal injury.



Note: The bandsaw was designed to use a 2450 x 27 x 0.9 mm size blade. Always use the specific blade sizes for each of the respective machines

1. Disconnect from the mains supply.
2. Raise the saw bow into its highest position.
3. Open the blade cover by removing the 4 knobs.
4. Take the tension off the blade by turning the blade tensioning knob anti-clockwise.
5. Remove the wire brush and the upper blade guard.
6. Ease the blade from the lower wheel first and then from the top wheel, carefully remove it from the blade guide bearings.
7. Fit the new blade through the blade guide bearings first, then ease it onto the lower wheel then onto the top wheel.
8. Use both hands to work the blade onto both wheels.
9. Both flywheels have a rear lip. Ensure the blade is as practically close to this lip without touching.
10. Put a small amount of tension on the blade (see tensioning the blade).
11. Once done reattach the blade guards etc.
12. The blade will need to be fully tensioned see page 24.

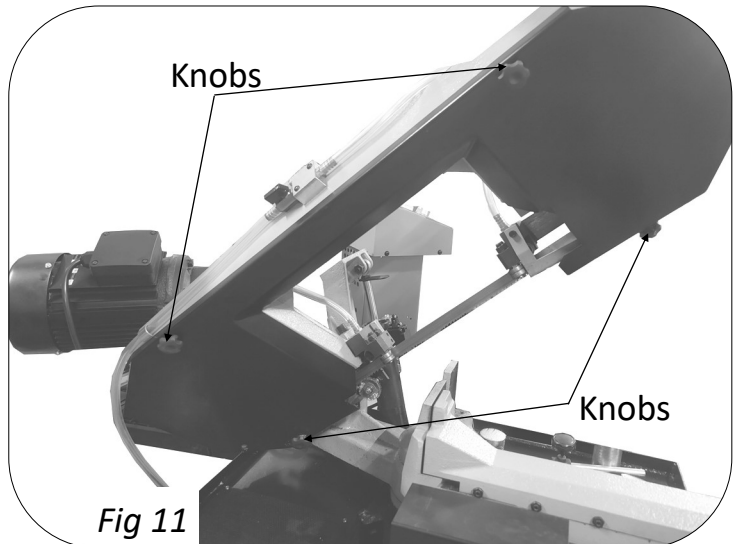


Fig 11

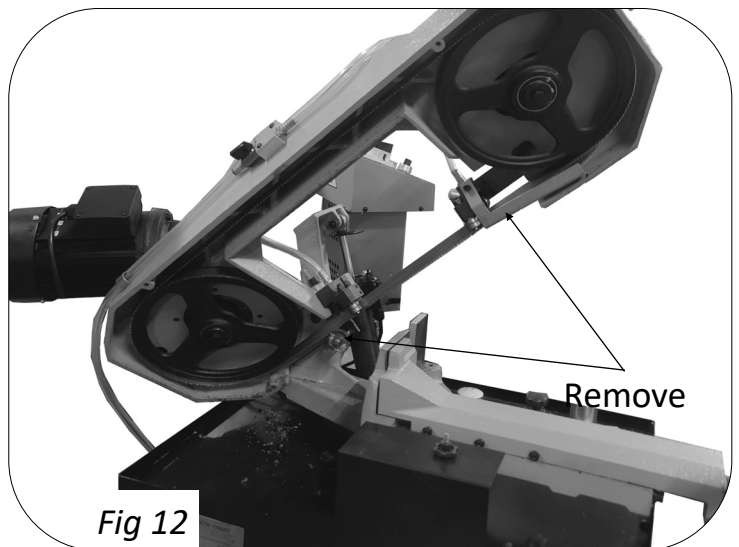


Fig 12

ADJUSTING BLADE TENSION



Caution: DO NOT over tension the blade as this will warp and stretch the blade.



Danger: Blades are sharp use extra care when removing, installing or handling.

Blade tension is important for the correct operation of the bandsaw; the blade tension should be set between 12 - 14MPa.

To set the blade correctly, take the following steps.

1. Disconnect the bandsaw from the mains supply.
2. Open the blade cover by removing the 4 knobs (Fig 11).
3. Ensure the blade is seated correctly on the pulley wheels.
4. Tension the blade slightly to take any slack off the blade.
5. Turn the Blade tensioning knob in a clockwise direction, one and a half turns or two full turns.
Fig.13
6. Close the blade guard etc. and connect to the
7. Run the bandsaw between 2-3 minutes so the blade can seat correctly.
8. Stop the bandsaw and disconnect from the mains supply.
9. Open the blade guard and loosen the blade until it just begins to slacken.
10. Tighten the blade so it becomes straight between the blade wheels, and all the slackness has gone.
11. Turn the Blade tensioning knob so the blade is tensioned in the Green Area between 12 & 14MPa..



Fig 13

BLADE GUIDE BEARING ADJUSTMENT



Danger: Never attempt to adjust the blade guide bearings whilst the machine is running, ALWAYS disconnect from the mains supply before proceeding.



Note: The correct guide bearing adjustment is very important, this will make the blade run smoother and evenly without any snagging or twisting whilst the blade is running. It will also prolong the blade life.

1. Loosen hex screw (L)
2. Adjusting the set screw (M), will move the blade (Q) further or closer depending on whether the screw is turned clockwise or counter-clockwise.
3. Make sure that between the blade and the two sides there is at least 0.1mm of free play.
4. Then re-tighten a hex screw (L).
5. Make sure that between the blade and the upper teeth of the pad there is at least 0.2~0.3 mm of free play; if necessary, loosen the hex screws (P) that fasten the block and adjust accordingly.

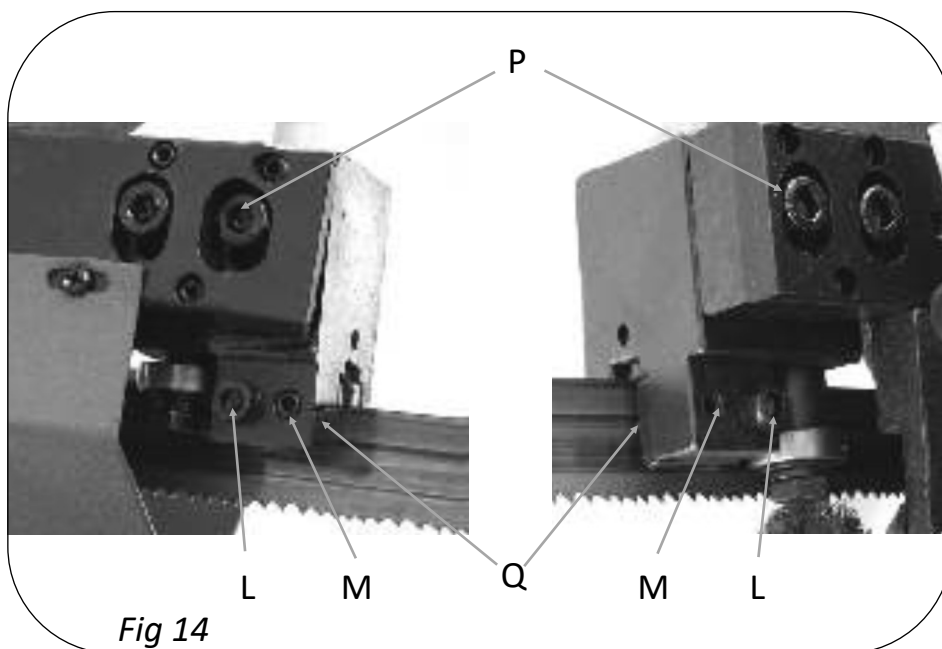


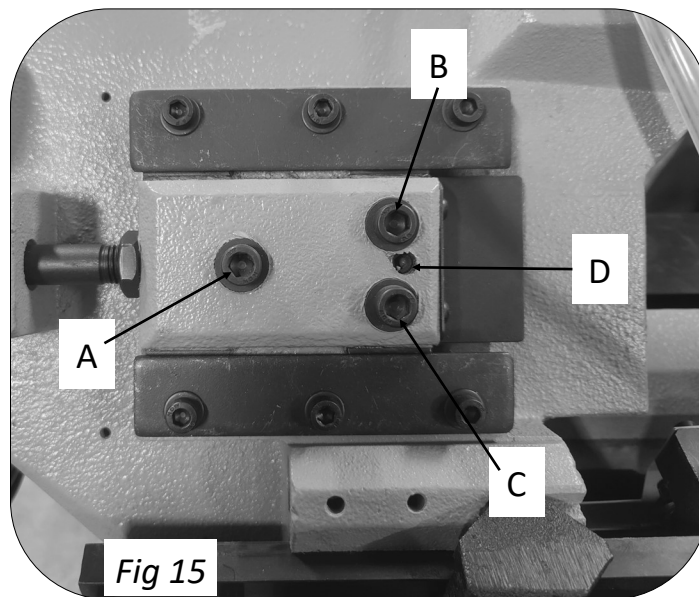
Fig 14

TRACKING THE BLADE

1. Loosen the cap head bolts A, B & C.
2. Use a wrench on set screw D to adjust the tilt of the flywheel.
 - Turning the setscrew. D clockwise will tilt flywheel so that the blade will ride closer to the Flange.
 - Turning the setscrew. D counter-clockwise will tilt the flywheel so that the blade will ride away from the flange.

If the blade rides too far then it will come off.

After the adjustment is finish, fasten the Hex nut screws in this order: A, B & C.



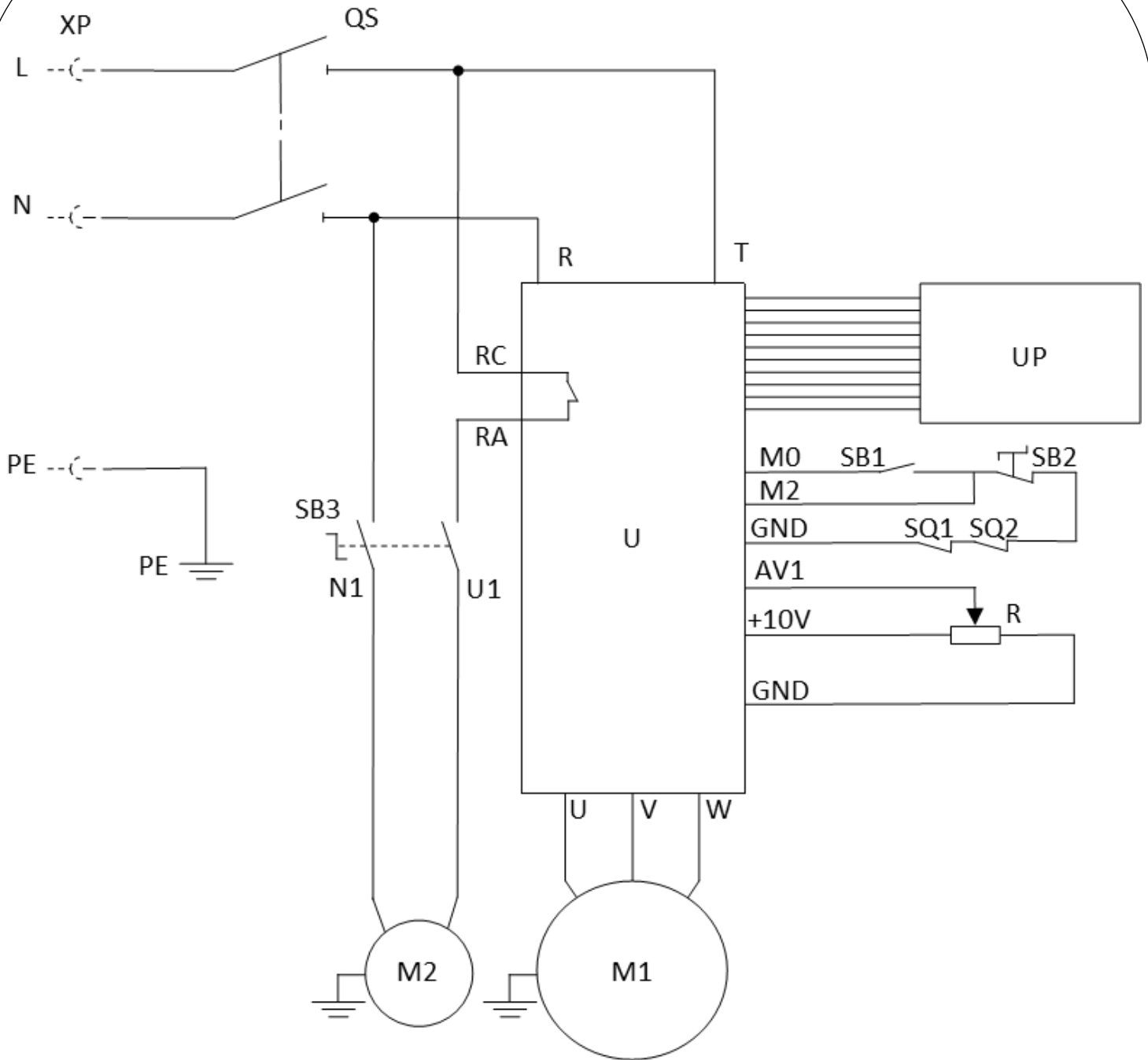
TROUBLESHOOTING

Fault	Possible Cause	Solution
<i>Unusual wear on side or back of blade.</i>	<ol style="list-style-type: none"> 1. Blade guides are worn. 2. Blade guides not properly adjusted. 3. Blade guide brackets are loose. 	<ol style="list-style-type: none"> 1. Replace blade guides. 2. Adjust blade guides. 3. Tighten blade guide brackets.
<i>Excessive blade breakage and teeth ripping from the blade.</i>	<ol style="list-style-type: none"> 1. Workpiece is loose in the vice. 2. Incorrect speed or feed. 3. Blade is too coarse. 4. Incorrect blade tension. 5. Blade is in contact with workpiece before band-saw is started. 6. Blade is rubbing on the wheel flange. 7. Blade guides are misaligned. 8. Blade is too thick. 9. Bad weld on blade. 	<ol style="list-style-type: none"> 1. Clamp the workpiece securely. 2. Adjust speed or feed. 3. Use correct blade for workpiece. 4. Adjust blade tension so that it does not slip on the wheel. 5. Place the blade in contact with the work-piece only after the saw has started. 6. Adjust the blade tracking. 7. Adjust blade guide alignment. 8. Use correct thickness blade. 9. Re-weld or replace blade.
<i>Motor overheating.</i>	<ol style="list-style-type: none"> 1. Blade tension too high. 2. Blade too coarse or too fine. 3. Gears need lubrication. 4. Blade is binding in the cut. 	<ol style="list-style-type: none"> 1. Reduce blade tension. 2. Use a blade designed for the work-piece. 3. Lubricate the gears. 4. Decrease feed and speed.
<i>Blade is twisting.</i>	<ol style="list-style-type: none"> 1. Blade tension is too high. 2. Blade is binding in the cut. 	<ol style="list-style-type: none"> 1. Decrease blade tension. 2. Decrease feed pressure.
<i>Bad, rough or crooked cuts.</i>	<ol style="list-style-type: none"> 1. Blade is too coarse. 2. Blade guide assembly is loose. 3. Blade guides are spaced out too far. 4. Incorrect speed. 5. Blade is blunt. 6. Inadequate blade tension. 7. Blade guide bearings not properly adjust-ed. 8. Feed pressure too much. 	<ol style="list-style-type: none"> 1. Use a finer blade. 2. Tighten the guide assembly. 3. Move guides closer to the workpiece. 4. Adjust speed. 5. Replace the blade. 6. Increase blade tension a little at a time. 7. Adjust blade guide bearings. 8. Reduce feed pressure by increasing

TROUBLESHOOTING Cont...

Fault	Possible Cause	Solution
<i>Premature blade dulling.</i>	<ol style="list-style-type: none">1. Blade tpi is too high.2. Incorrect speed - too fast.3. Inadequate feed pressure.4. Hard spots or scale on the workpiece.5. Blade installed backwards.6. Insufficient blade tension.7. Work hardened material especially stain-less.	<ol style="list-style-type: none">1. Replace with a lower tpi blade.2. Reduce speed.3. Increase feed pressure by unscrewing tension bar. This will decrease the spring tension on the arm.4. Reduce speed, increase feed pressure.5. Remove blade, twist inside out and rein-stall.6. Increase blade tension.7. Increase feed pressure by reducing spring pressure.

WIRING DIAGRAM



QS: Power Switch
 U: VFD
 UP: Frequency Controller
 SB1: ON Button
 SB2: STOP Bottom
 SB3: Water Pump Switch
 SQ1: Limit Switch, Saw Bow Cover

SQ2: Limit Switch, Cutting
 R: Speed Control Potentiometer
 M1: Motor, Cutting
 M2: Motor, Water Pump

DIAGRAM A

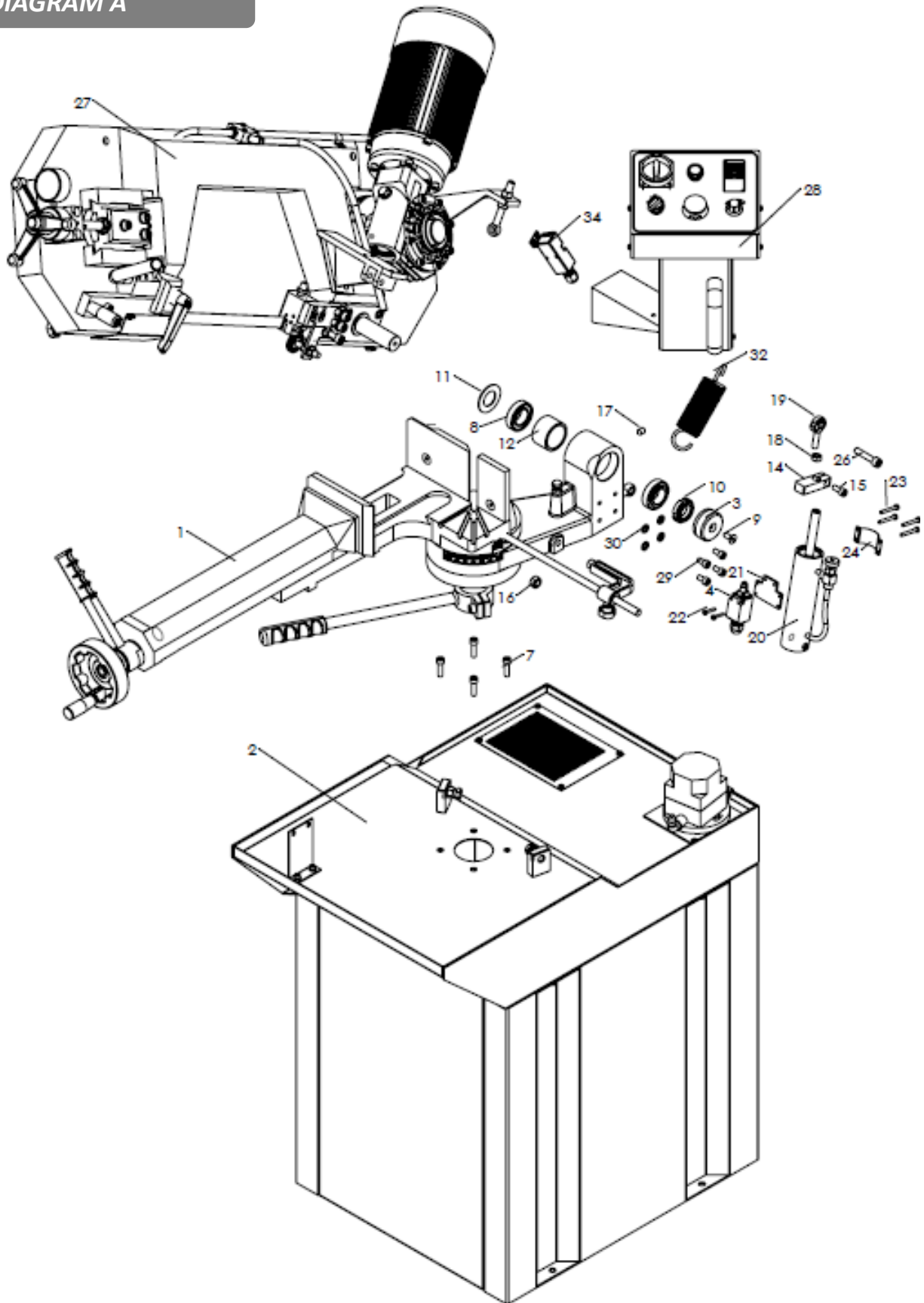


DIAGRAM B

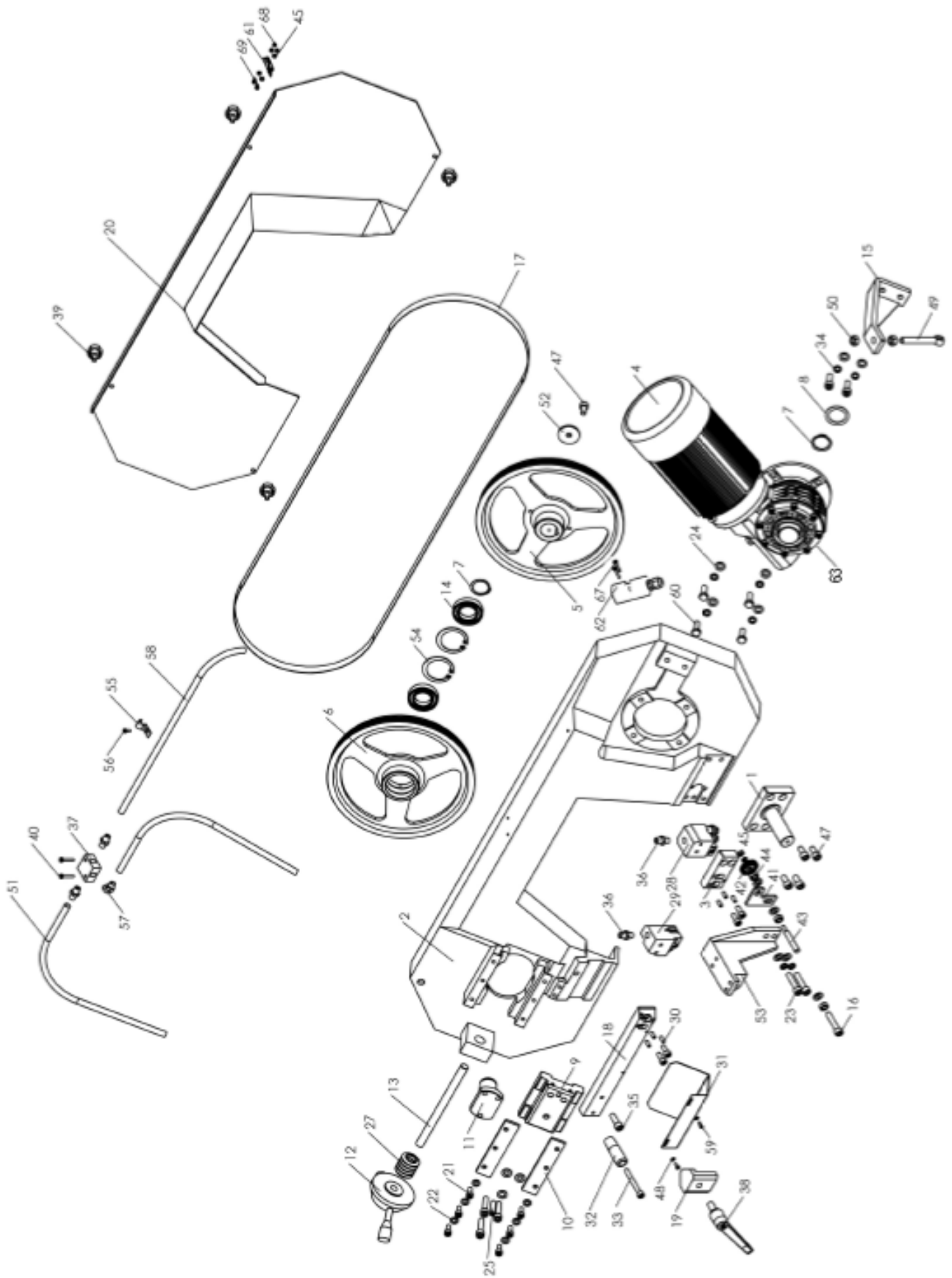


DIAGRAM C

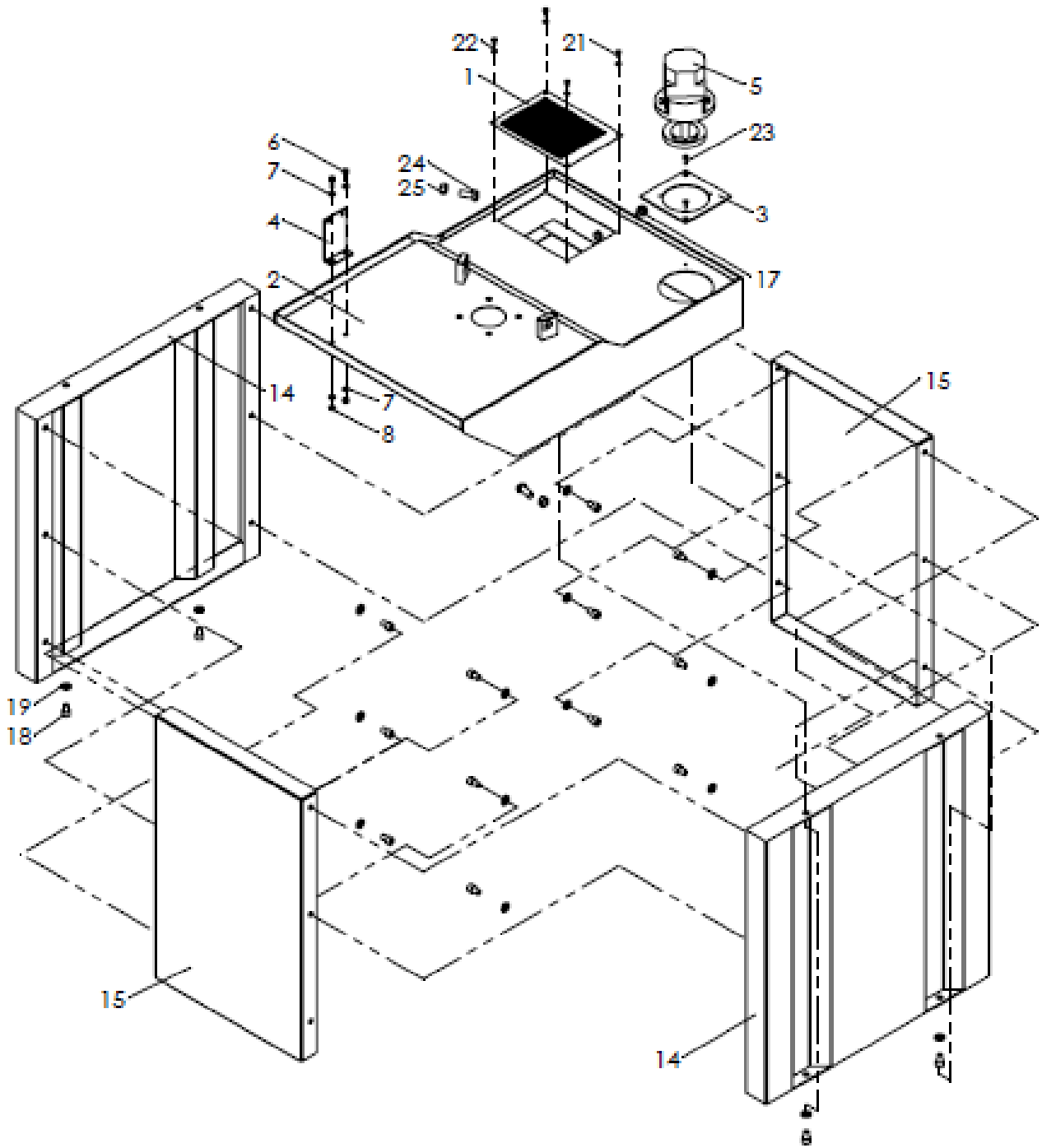


DIAGRAM D

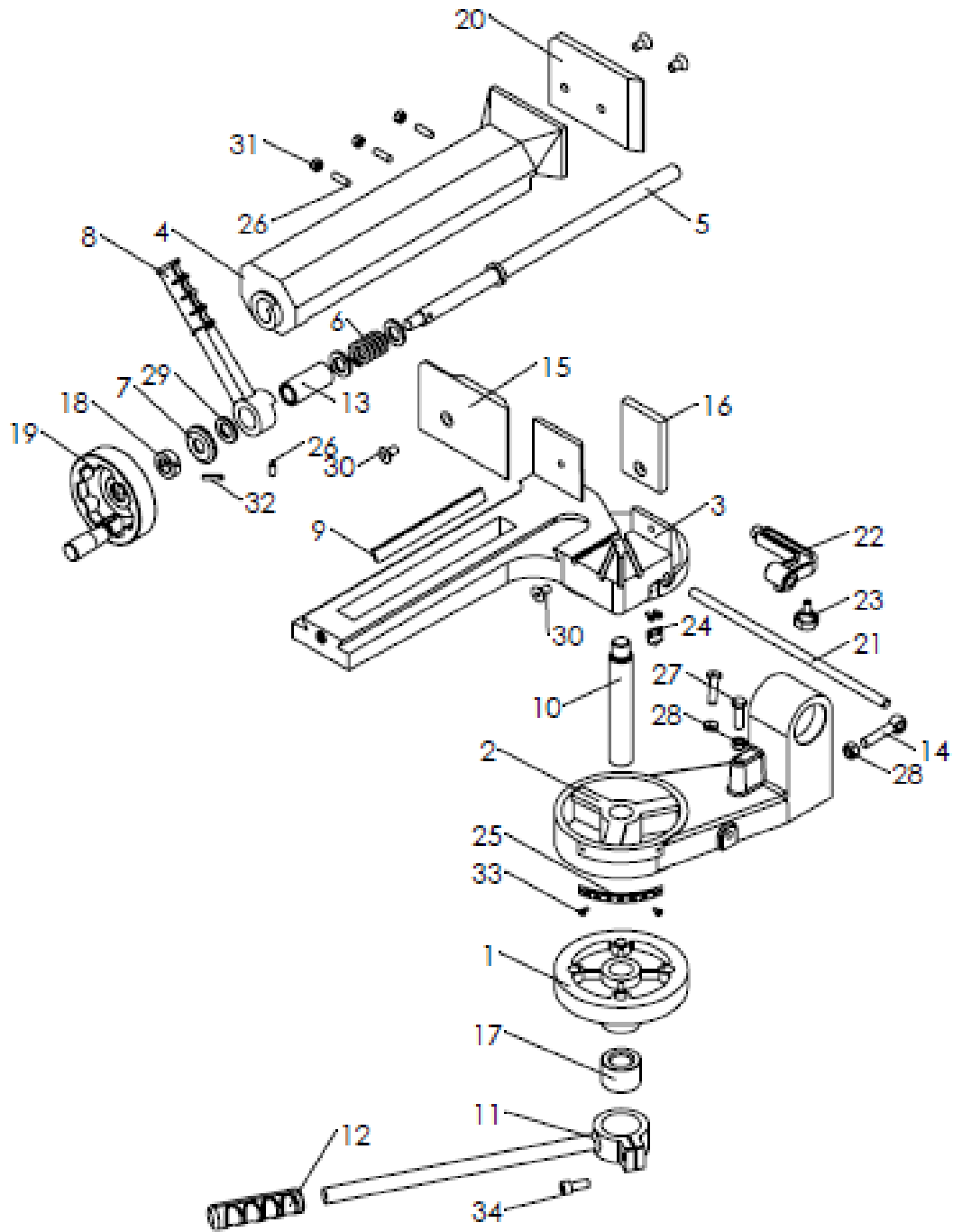


DIAGRAM E

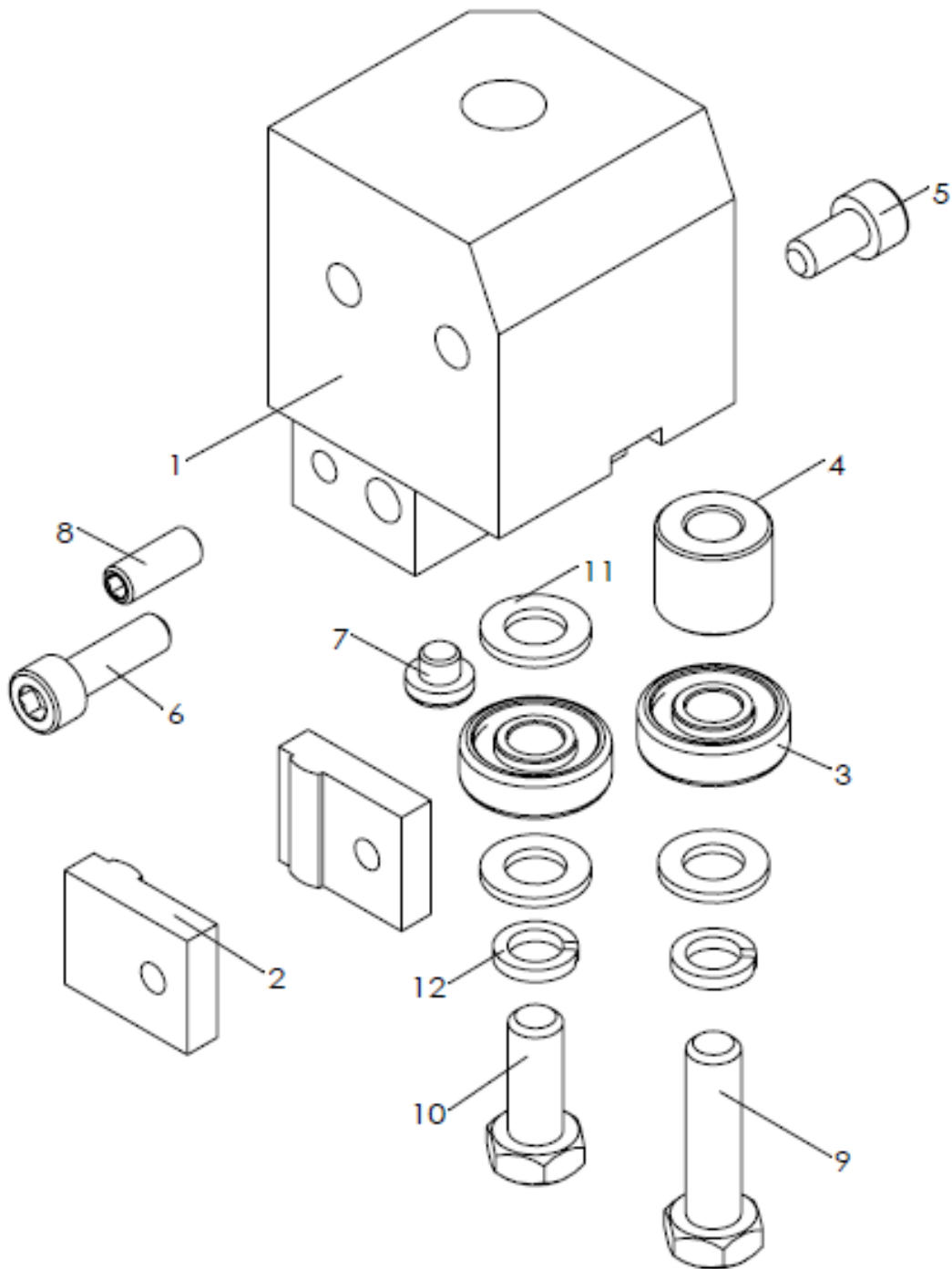
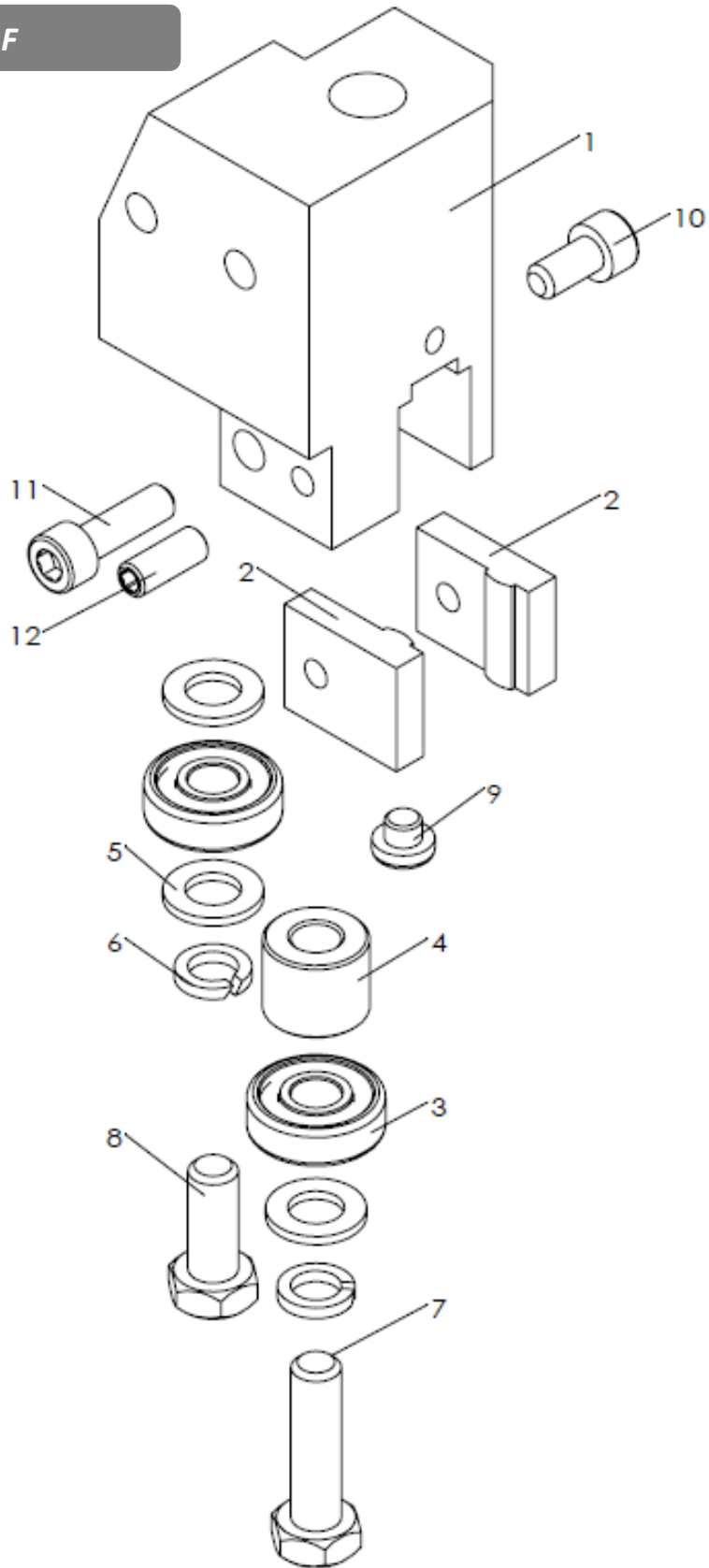


DIAGRAM F



PARTS LIST

<i>Item</i>	<i>Description</i>	<i>Item</i>	<i>Description</i>
A 01	Saw Bow Assy	A 19	Cross Head Screw
A 02	Vice Assy	A 20	Block
A 03	Base Assy	A 21	Screw M8 x 20mm
A 04	Control Box	A 22	Nut M12
A 05	Cap Bearing	A 23	Saw Bow Spring
A 06	Micro-Switch	A 24	Allen Screw M10 x 5mm
A 07	Screw M6 x 15mm	A 25	Nut M10
A 08	Washer	A 26	Nut M10
A 09	Screw M8 x 30mm	A 27	Bearing
A 10	Bearing	A 28	Hydraulic Cylinder
A 11	Screw M8 x 20mm	A 29	Micro-Switch Key
A 12	Round Nut	A 30	Cross Head Screw
A 13	Dustproof Washer	A 31	Cross Head Screw
A 14	Bearing Seat	A 32	Micro-Switch Support
A 15	Control Box Bracket	A 33	Hydraulic Cylinder
A 16	Electrical Box Handle	A 34	Screw M10 x 50mm
A 17	Screw M8 x 12mm	A 35	Screw M10 x 25mm
A 18	Screw M6 x 15mm		

PARTS LIST Cont...

<i>Item</i>	<i>Description</i>	<i>Item</i>	<i>Description</i>
B 01	Rotation Shaft	B 34	Washer
B 02	Saw Bow	B 35	Screw M10 x 30mm
B 03	Saw Blade Guide Plate	B 36	Hose Fitting
B 04	Motor	B 37	3 Way Fitting
B 05	Capstan	B 38	Lock Lever
B 06	Driven Wheel	B 39	Knob
B 07	Circlips	B 40	Screw
B 08	Capstan Adjustment	B 41	Positioning Plate
B 09	Driven Wheel Seat	B 42	Round Brush
B 10	Driven Wheel Seat	B 43	Support Shaft
B 11	Driven Wheel Shaft	B 44	Nut M10
B 12	Handle Flanges	B 45	Nut M6
B 13	Tensioner Screw	B 46	Washer
B 14	Bearing	B 47	Screw M10 x 20mm
B 15	Segment	B 48	Washer
B 16	Screw M10 x 50mm	B 49	Spring Hook
B 17	Saw Blade	B 50	Nut M12
B 18	Saw Blade Tensioner	B 51	Water Pipe
B 19	Plate	B 52	Shaft Collar
B 20	Blade Guard	B 53	Upper Oil Cylinder
B 21	Screw M8 x 20mm	B 54	Circlip
B 22	Washer	B 55	Water Pipe Platen
B 23	Screw M10 x 45mm	B 56	Screw
B 24	Washer	B 57	Elbow
B 25	Screw M10 x 40mm	B 58	Water Pump Hose
B 26	Handle	B 59	Screw M4 x 10mm
B 27	Butterfly Spring	B 60	Screw M10 x 35mm
B 28	Fixed Blade Guide	B 61	Micro-Switch Key
B 29	Guide Mobile	B 62	Micro-Switch
B 30	Screw M6 x 15mm	B 63	Gearbox
B 31	Blade Safety Guard	B 67	Bolt
B 32	Handle	B 68	Bolt
B 33	Screw M8 x 60	B 69	Nut

PARTS LIST Cont...

<i>Item</i>	<i>Description</i>	<i>Item</i>	<i>Description</i>
C 01	Filter	D 23	Screw
C 02	Base & Tank	D 24	Pointer
C 03	Water Pump Base	D 23	Screw
C 04	Support Vice	D 24	Pointer
C 05	Coolant Pump	D 25	Angle Scale
C 06	Screw M6 x15mm	D 26	Screw M8 x 20mm
C 07	Washer	D 27	Screw M10 x 35mm
C 08	Nut M6	D 28	Nut M12
C 14	Front Panel Door	D 29	Bearing
C 15	Left Side Panel	D 30	Screw M10 x 20mm
C 18	Screw M10 x 16mm	D 31	Nut M8
C 19	Washer	D 32	Pin 6 c 35mm
C 21	Screw M5 x 10mm	D 33	Screw M4 x 10mm
C 22	Washer	D 34	Screw M10 x 25mm
C 23	Screw M6 x 12mm	E 01	Fixed Blade Guide
C 24	Screw M12x 30mm	E 02	Fixed Teeth
C 25	Nut M12	E 03	Bearing
D 01	Vice Mount Base	E 04	Guide Spacer
D 02	Vice Rotate Base	E 05	Screw M6 x 12mm
D 03	Vice Fixed Jaw	E 06	Screw M6 x 20mm
D 04	Vice Adj Jaw	E 07	Washer
D 05	Pivot Shaft	E 08	Screw M6 x 15mm
D 06	Spring	E 09	Screw M8 x 30mm
D 07	Bearing Cover	E 10	Screw M8 x 20mm
D 08	Quick Lock Lever	E 11	Washer
D 09	Slide Plate	E 12	Washer
D 10	Lock Thread	F 01	Mobile Guide
D 11	Sawm Lock Lever	F 02	Fixed Teeth
D 12	Sliding Handle	F 03	Bearing
D 13	Pivot Shaft Sleeve	F 04	Guide Spacer
D 14	Spring Lower Hook	F 05	Washer
D 15	Fixed Jaw Plate	F 06	Washer
D 16	Fixed Jaw Plate	F 07	Screw M8 x 30mm
D 17	Collar	F 08	Screw M8 x 20mm
D 18	Collar	F 09	Washer
D 19	Vice Handwheel	F 10	Screw M6 x 12mm
D 20	Adj Jaw Plate	F 11	Screw M6 x 20
D 21	Stop Bar	F 12	Screw M6 x 15mm
D 22	Washer		

UK - DECLARATION OF CONFORMITY

We

SIP (Industrial Products) Ltd
Gelders Hall Road Shepshed
Loughborough
Leicestershire LE12 9NH
England

As the manufacturer within the UK, England, Scotland & Wales, declare that the :-

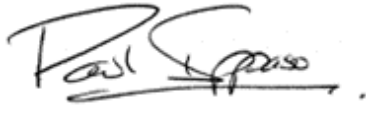
SIP 10" Vari-Speed Swivel Head Bandsaw - SIP Part No. 01526

Conforms to the requirements of the following regulation(s), as indicated.

Supply of Machinery (Safety) Regulations 2008
Electromagnetic Compatibility Regulations 2016
Electrical Equipment Regulations 2016
The Restriction of the Use of Certain Hazardous Substances in
Electrical and Electronic Equipment Regulations 2012

And the relevant harmonised standard(s), including

BS EN IEC 55014-1:2021
BS EN IEC 55014-2:2021
BS EN IEC 61000-3-2:2019+A1
BS EN IEC 61000-3-3:2013+A1+A2

Signed.....	
Mr. Paul Ippaso	Managing Director
SIP (Industrial Products) Ltd	Date: 20July2023



EU - DECLARATION OF CONFORMITY

We

SIP (Machinery Europe) Ltd
ASM Chartered Accountants
First Floor Block One
Quayside Business Park Dundalk
County Louth Republic of Ireland

As the manufacturer's authorised representative within the EC declare that the :-


SIP 10" Vari-Speed Swivel Head Bandsaw - SIP Part No. 01526

Conforms to the requirements of the following directive(s), as indicated.

2006/42/EC - Machinery Directive
2014/35 - Low Voltage Directive
2014/30/EU - EMC Directive
2011/65/EU - RoHS Directive

And the relevant harmonised standard(s), including

EN IEC 55014-1:2021
EN IEC 55014-2:2021
EN IEC 61000-3-2:2019+A1
EN IEC 61000-3-3:2013+A1+A2

Signed.....	
Mr. Paul Ippaso	Managing Director
SIP (Machinery Europe) Ltd	Date: 20July2023



Please dispose of packaging for the product in a responsible manner.
It is suitable for recycling.

Help to protect the environment, take the packaging to the local amenity tip and place into the appropriate recycling bin.

Never dispose of electrical equipment or batteries in with your domestic waste.

If your supplier offers a disposal facility please use it or alternatively use a recognised recycling agent.

This will allow the recycling of raw materials and help protect the environment.



FOR HELP OR ADVICE ON THIS
PRODUCT PLEASE CONTACT
YOUR DISTRIBUTOR, OR SIP

DIRECTLY ON:

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