



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.

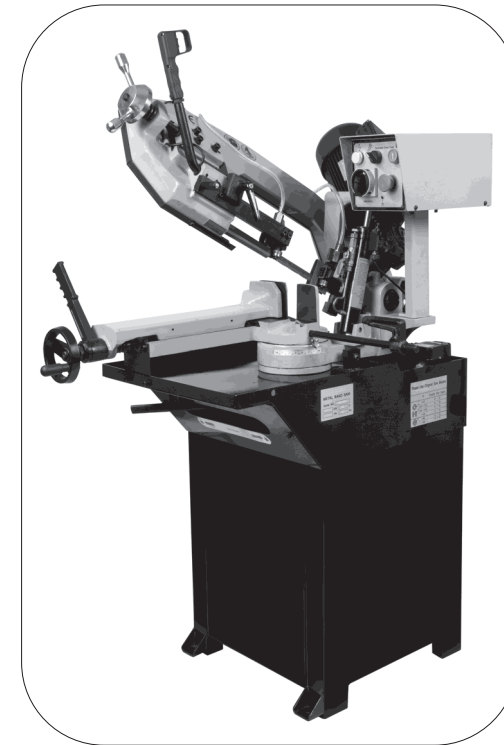


Never dispose of electrical equipment or batteries in with your domestic waste. If your supplier offers a disposal facility please use it or alternatively use a recognised re-cycling agent. This will allow the recycling of raw materials and help protect the environment.

Sip
SIP INDUSTRIAL

machinery specialists since 1968

Swivel Head Pull Down Metal Cutting Bandsaw



01520 & 01524

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

TEL: 01509500400

EMAIL: sales@sip-group.com or technical@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.***

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

8" Swivel Head Pull Down Metal Cutting Bandsaw - SIP Part No. 01520
10" Swivel Head Pull Down Metal Cutting Bandsaw - SIP Part No. 01524

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

2006/42/EC Machinery Directive
2014/30/EU EMC Directive
2011/65/EU & (EU)2015/863 RoHS Directive

And the relevant harmonised standard(s), including

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



Signed:

Mr P. Ippaso - Director - SIP (Industrial Products) Ltd
Date: 23Feb2024.



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

8" Swivel Head Pull Down Bandsaw - SIP Code 01520
 10" Swivel Head Pull Down Bandsaw - SIP Code 01524

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

Supply of Machinery (Safety) Regulations 2008
 Electromagnetic Compatibility 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 61000-3-2:2019+A1
 BS EN 61000-3-3:2013+A1+A2
 BS EN IEC 55014-2:2021



Signed:

Mr P. Ippaso - Director - SIP (Industrial Products) Ltd Date: 23Feb2024



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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 bandsaw.**

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.

NOTES

Ref. No.	Part Name	SIP Code
177.	Hex. cap bolt	WK04-00458
178.	Gear box	WK04-00632
178-2.	Key	WK04-00553
179.	Set screw	WK04-00460
181.	Cap Head bolt	WK04-00461
182.	Front blade guard	WK04-00633
183.	Round head screw	WK04-00459
185.	Bolt	WK04-00634
186.	Front ball bearing seat	WK04-00635
187.	Pipe fitting	WK04-00636
188.	Rear blade guard	WK04-00637
189.	Blade guard (B)	WK04-00638
190.	Cap Head bolt	WK04-00450
191.	Rear ball bearing seat	WK04-00639
192.	Pipe fitting	WK04-00564
193.	Set screw	WK04-00460
193-1.	Nut	WK04-00457
194.	Hex. cap bolt	WK04-00458
195.	Spring Washer	WK04-00452
196.	Brush set ring	WK04-00640
197.	Set screw	WK04-00460
198.	Bracket	WK04-00641
199.	Brush	WK04-00642
200.	Eccentric shaft	WK04-00643
201.	Ball bearing	WK04-00558
202.	Blade guide (A)	WK04-00644
203.	Cap Head bolt	WK04-00461
204.	E Ring	WK04-00559
205.	Centric shaft	WK04-00645
206.	Ball bearing	WK04-00563
26H-1.	Hydraulic cylinder post	WK04-00646
26H-2.	Cap Head bolt	WK04-00450
26H-3.	Spring washer	WK04-00452
26H-4.	Cap Head bolt	WK04-00461
26H-5.	Hydraulic cylinder	WK04-00568
26H-6.	Nut	WK04-00451
26H-7.	Set screw	WK04-00460
26H-8.	Supporting bracket	WK04-00569
26H-9.	Shaft	WK04-00570
26H-10.	Spring washer	WK04-00455
26H-11.	Cap Head bolt	WK04-00454
26H-12.	Cap Head bolt	WK04-00454
26H-13.	Limit switch	WK04-00571
26H-14.	Cap Head bolt	WK04-00450
26H-15.	Hydraulic cylinder post	WK04-00572

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, undamaged 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 (O) 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

PARTS LIST...cont

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Ref. No.	Part Name	SIP Code	Ref. No.	Part Name	SIP Code
84.	Control box bottom	WK04-00521	131.	Handle	WK04-00532
85-H.	Control box panel	WK04-00520	132.	Handle wheel	WK04-00614
85-H1.	Manual/auto selector	WK04-00519	133.	Thrust spring washer	WK04-00455
86.	Support	WK04-00522	134.	Tension shaft	WK04-00454
88.	Cap Head bolt	WK04-00450	137.	Set screw	WK04-00460
89.	Cap Head bolt	WK04-00454	138.	Rod	WK04-00615
90.	Spring washer	WK04-00452	139.	Nut	WK04-00457
91.	Setting bracket	WK04-00523	140.	Handle with Switch	WK04-00529
92.	Spring washer	WK04-00452	141A.	Shaft	WK04-00616
93.	Cap Head bolt	WK04-00450	142.	Ball bearing	WK04-00617
94.	Swivel arm	WK04-00600	143.	Idle flywheel	WK04-00618
94-1.	Scale	WK04-00501	145.	Star washer	WK04-00619
94-2.	Rivet	WK04-00502	146.	Jam nut	WK04-00620
95.	Disk	WK04-00602	147.	Oil inlet	WK04-00621
97.	Oil seal	WK04-00603	148.	Blade	WK04-00622
98.	Shaft	WK04-00479	149.	Blade cover	WK04-00623
99.	Nut	WK04-00604	150.	Knob bolt	WK04-00541
100.	Cap Head bolt	WK04-00454	151.	Round head screw	WK04-00459
101.	Spring washer	WK04-00455	153.	Spring washer	WK04-00462
102.	Set screw	WK04-00460	154.	Nut	WK04-00457
103.	Cap Head bolt	WK04-00454	155.	Hex. cap bolt	WK04-00458
104.	Spring washer	WK04-00455	156.	Spring washer	WK04-00462
105.	Set screw	WK04-00460	157.	Washer	WK04-00463
106.	Locking lever	WK04-00605	158.	Drive flywheel	WK04-00624
107.	Nut	WK04-00457	159.	Cap Head bolt	WK04-00454
108.	Handle	WK04-00606	160.	Spring washer	WK04-00455
109.	Cap Head bolt	WK04-00454	161.	Hose	WK04-00547
110.	Spring washer	WK04-00455	163.	Pipe fitting	WK04-00548
111.	Gib	WK04-00607	164.	Cap Head bolt	WK04-00461
112.	Spring washer	WK04-00455	168.	Hose	WK04-00549
113.	Cap Head bolt	WK04-00454	169.	Saw arm	WK04-00625
115.	Front ball bearing bracket	WK04-00608	170.	Limit switch	WK04-00550
116.	Set screw	WK04-00460	170.1.	Switch pin	WK04-00626
117.	Cap Head bolt	WK04-00454	171.	Cap Head bolt	WK04-00450
118.	Cap Head Bolt	WK04-00609	172H-1.	Spring shaft	WK04-00551
119.	Setting bracket	WK04-00610	172H-2.	Adjust plate	WK04-00627
120.	Cap Head bolt	WK04-00461	172H-3.	Handle	WK04-00628
121.	Plastic handle	WK04-00527	172H-4.	Nut	WK04-00457
122.	Cap Head bolt	WK04-00461	172H-5.	Hanger	WK04-00629
123.	Cover plate	WK04-00611	172H-6.	Lead screw	WK04-00630
127A.	Slide	WK04-00612	172H-7.	Spring	WK04-00631
127A-1.	Spring washer	WK04-00455	172H-8.	Set screw	WK04-00460
127A-2.	Cap Head bolt	WK04-00454	174.	Key	WK04-00553
127A-3.	Set screw	WK04-00460	175.	Motor	WK04-00556
128.	Nut	WK04-00613	176.	Spring washer	WK04-00455

PARTS LIST

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Ref. No.	Description	SIP Code	Ref. No.	Description	SIP Code
1.	Base (right part)	WK04-00601	46.	Upper vise	WK04-00588
2.	Nut	WK04-00451	47.	Plate	WK04-00589
3.	Cap Head bolt	WK04-00450	48.	Flat head machine screw	WK04-00590
4.	Nut	WK04-00451	49.	Compressed spring	WK04-00490
5.	Spring Washer	WK04-00452	50.	Lead screw	WK04-00591
6.	Cap Head bolt	WK04-00450	51.	Cap Head bolt	WK04-00450
7.	Base plate	WK04-00573	52.	Spring washer	WK04-00452
8.	Base (left part)	WK04-00574	53.	Threaded nut	WK04-00592
9.	Cap Head bolt	WK04-00450	54.	Vise	WK04-00593
10.	Spring washer	WK04-00452	55.	Bar stop-rod	WK04-00594
10-1.	Nut	WK04-00451	56.	Bracket	WK04-00595
10-2.	Flat Washer	WK04-00453	57.	Butterfly screw	WK04-00505
11.	Cap Head bolt	WK04-00454	58.	Washer	WK04-00455
12.	Spring washer	WK04-00455	60.	Hex. cap bolt	WK04-00458
14.	Supporting plate	WK04-00575	61.	Rod	WK04-00596
15.	Roller stand bracket	WK04-00576	62.	Nut	WK04-00457
16.	Washer	WK04-00456	63.	Cap Head bolt	WK04-00597
17.	Spring washer	WK04-00455	64.	Set screw	WK04-00460
18.	Cap Head bolt	WK04-00454	64-1.	Cap Head bolt	WK04-00454
19.	Roller	WK04-00577	64-2.	Scale pointer	WK04-00494
19-1.	Roller shaft	WK04-00578	65.	Pivot	WK04-00598
20.	Flat Washer	WK04-00453	67.	Ball bearing	WK04-00599
21.	Spring washer	WK04-00455	68.	Nut	WK04-00457
22.	Cap Head bolt	WK04-00454	69-1.	Hex. cap bolt	WK04-00454
23.	Filter net	WK04-00579	69.	Hex. cap bolt	WK04-00454
24.	Round head screw	WK04-00459	70.	Spring hook	WK04-00497
25.	Cap Head bolt	WK04-00454	72.	Star washer	WK04-00498
26.	Spring Washer	WK04-00455	73.	Nut	WK04-00499
27.	Hose clamp	WK04-00580	74.	Start button	WK04-00518
27-1.	Hose	WK04-00581	75.	Emergency switch	WK04-00517
28.	Pump	WK04-00474	76.	Switch	WK04-00515
29.	Cap Head bolt	WK04-00458	77.	Power indicator light	WK04-00516
30.	Coolant Return Plate	WK04-00582	78.	Cap Head bolt	WK04-00461
31.	Cap Head bolt	WK04-00458	79.	Washer	WK04-00455
32.	Nut	WK04-00451	80.	Cap Head bolt	WK04-00454
33.	Cap Head bolt	WK04-00450	81.	Cover	WK04-00506
34.	Base front plate	WK04-00583	82.	Cap Head bolt	WK04-00454
38.	Hand wheel	WK04-00584	83.	Control box bottom plate	WK04-00507
39.	Set screw	WK04-00460	83-1.	Transformer	WK04-00508
40.	Nut	WK04-00483	83-2.	Terminal block	WK04-00512
41.	Bearing bushing	WK04-00484	83-3.	Breaker	WK04-00510
42.	Thrust ball bearing	WK04-00585	83-4.	Thermal relay	WK04-00511
43.	Lock handle	WK04-00486	83-5.	AC contactor	WK04-00509
44.	Bushing	WK04-00586	83-6.	Ground copper bar	WK04-00513
45.	Cap Head screw	WK04-00587	83-7.	Breaker	WK04-00514

SAFETY INSTRUCTIONS...cont

- workpiece.
- **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, bracelets, 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.

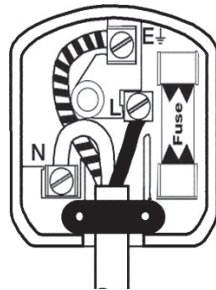
You must ensure that the risk of electric shock is minimised by the installation of appropriate safety devices; A residual current circuit Breaker (RCCB) should be incorporated in the main distribution board. We also recommend that a residual current device (RCD) is used. It is particularly important 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



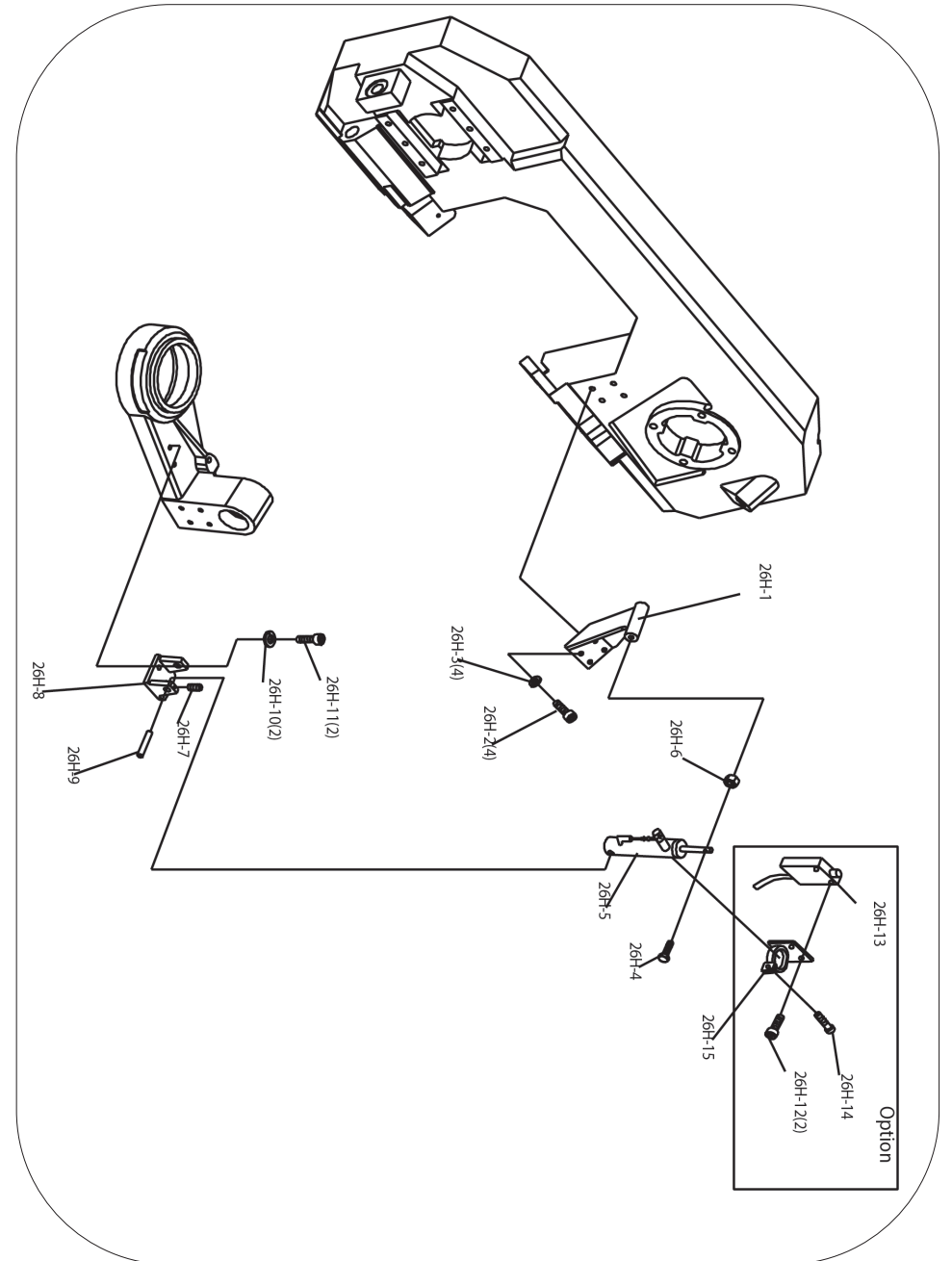
As the colours of the wires may not correspond with the markings in your plug, proceed as follows: The wire which is coloured blue, must be connected to the terminal marked with N or coloured black. The wire which is coloured brown, must be connected to the terminal, which is marked L or coloured red. The wire which is coloured yellow / green should be connected to the terminal which is coloured the same or marked



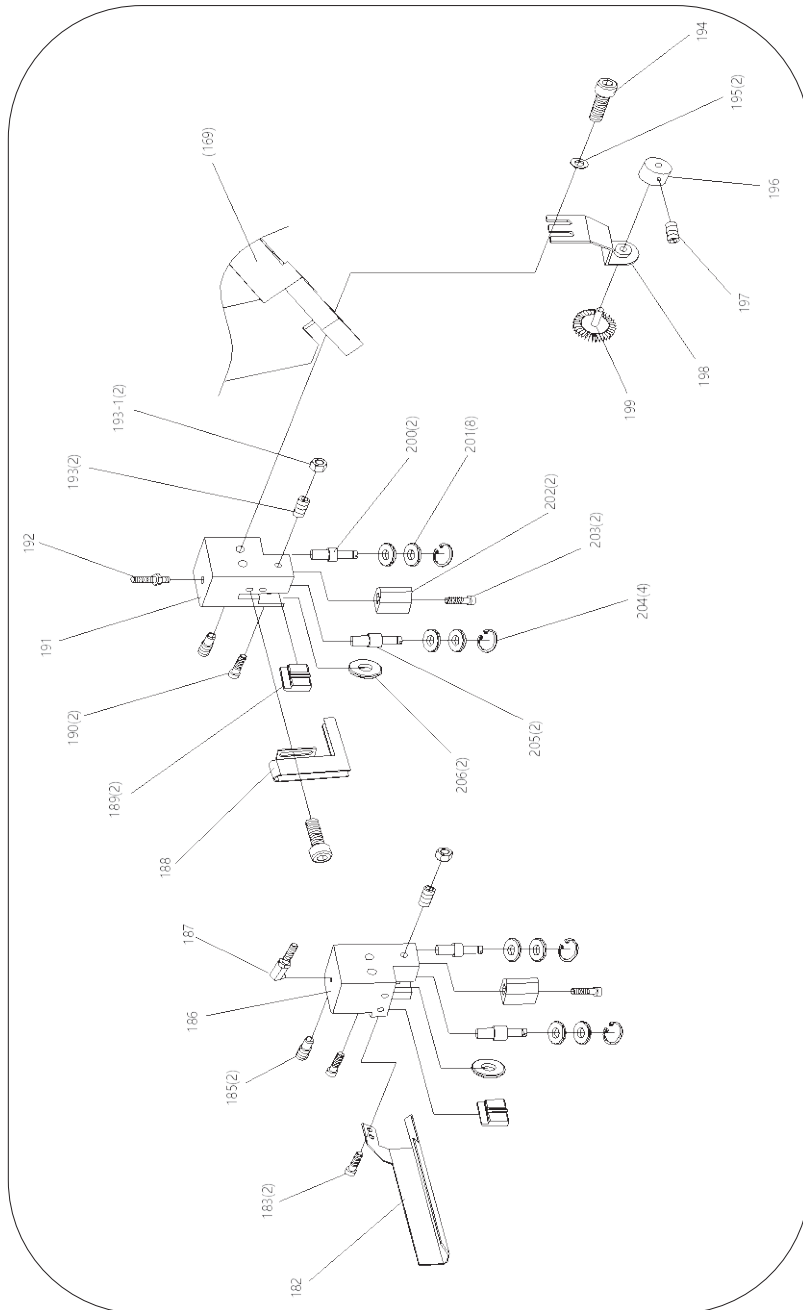
Always secure the wires in the plug terminal carefully and tightly. Secure the cable in the cord grip carefully.

EXPLODED DRAWING....cont

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01524



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.

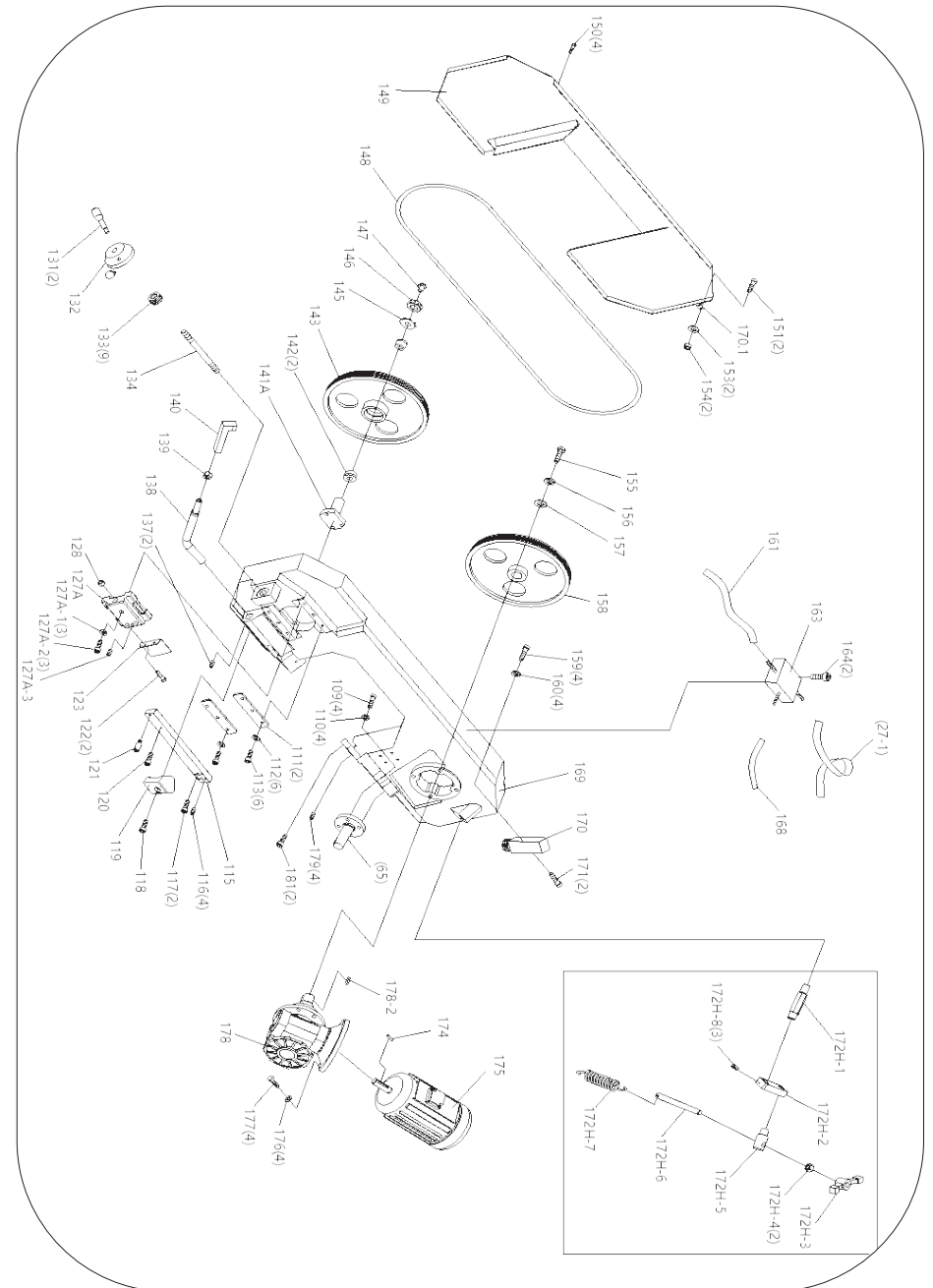
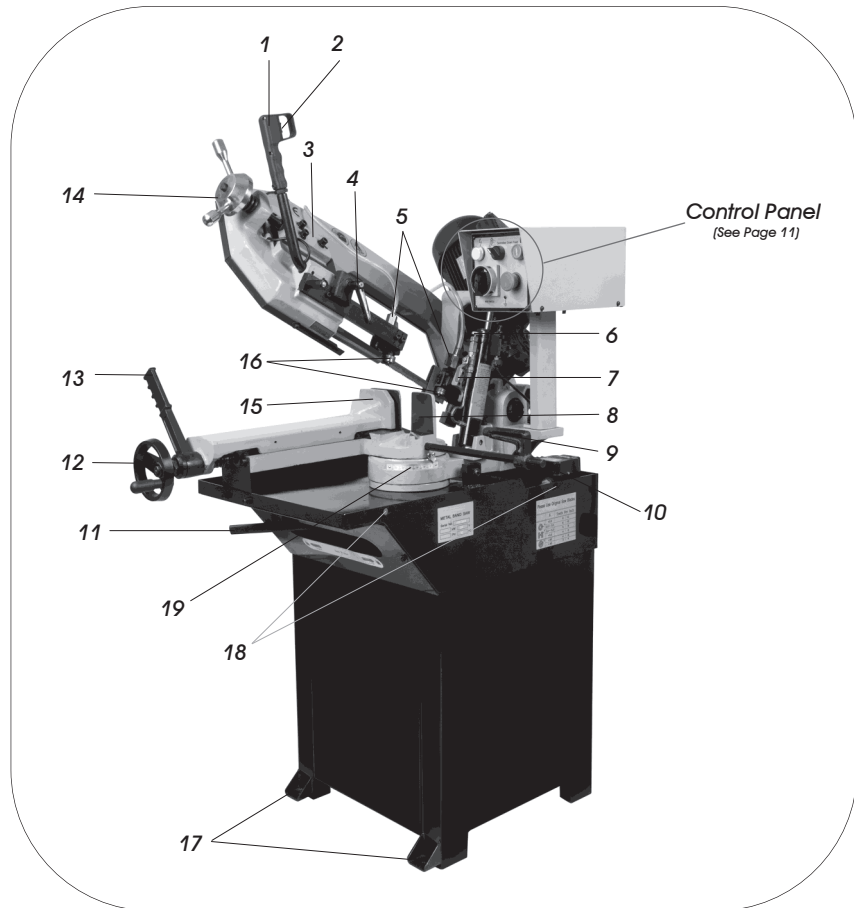
This guarantee does not cover consumables such as bearings, oil, blades etc.

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.

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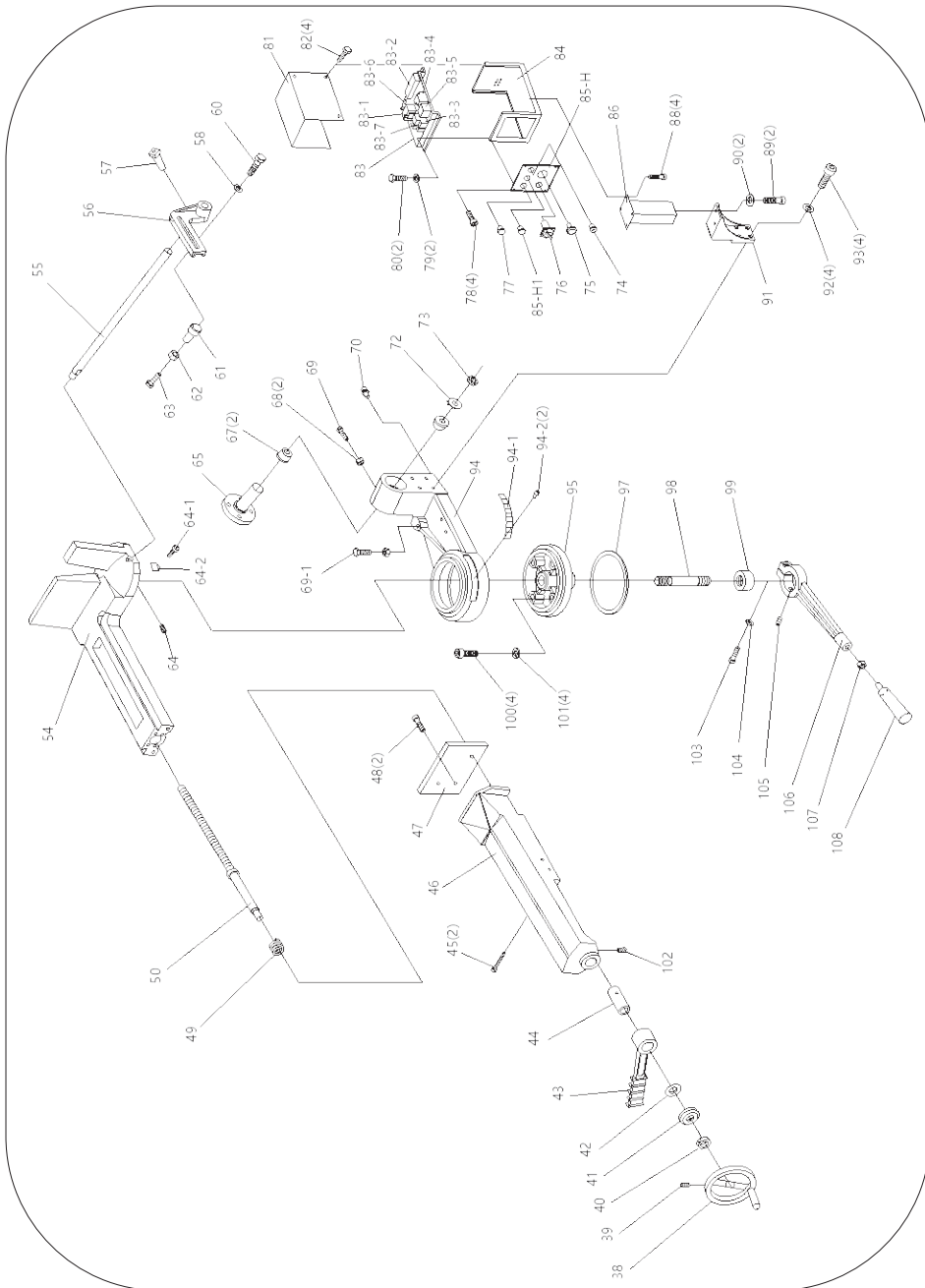


Ref. No.	Description	Ref. No.	Description
1.	Pull Down Handle	11.	Swivel Release / Lock
2.	Pull Down Trigger Switch (On/Off)	12.	Vice Adjust Hand-wheel
3.	Tracking Adjuster	13.	Vice Quick Release
4.	Blade Guide Lock	14.	Blade Tension Hand-wheel
5.	Coolant Tap	15.	Moveable Vice Jaw
6.	Bow Control (speed)	16.	Blade Guide
7.	Bow Lock (On/Off)	17.	Anchor Points
8.	Fixed Vice Jaw	18.	Lifting Points
9.	Workpiece Stop	19.	Swivel Angle Scale
10.	Coolant Pump *		

* Coolant Tank Capacity 9.5L

EXPLODED DRAWING....cont

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GETTING TO KNOW YOUR BANDSAW....cont

CONTROL PANEL



A.	Main Power Switch	Turns On Power To The Saw.
B.	Power Indicator Light	Illuminates When The Main Power Switch Is Turned On.
C.	Mode Control	Sets The Mode Of Operation - Pull Down Cutting / Hydraulic Gravity Feed.
D.	Start Switch	Starts The Cutting Operation (Hydraulic Gravity Feed).
E.	Emergency Stop / stop button	Interrupts power to the system and stops the motor, twist the button until it pops out to allow power back to the machine.

SPARE PARTS....cont

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Ref. No.	Description	SIP Code
163.	Set screw	WK04-00460
170.	Set screw	WK04-00460
171.	Spring washer	WK04-00452
172.	Cap Head bolt	WK04-00450
173.	Centric shaft	WK04-00557
174.	Ball bearing	WK04-00558
175.	E ring	WK04-00559
176.	Eccentric shaft	WK04-00560
177.	Front ball bearing seat	WK04-00561
178.	Front blade guard	WK04-00562
179.	Round head screw	WK04-00459
180.	Hex. socket cap screw	WK04-00454
181.	Ball bearing	WK04-00563
182.	Flat washer	WK04-00453
183.	Pipe fitting	WK04-00564
184.	Nut	WK04-00457
185.	Spring washer	WK04-00455
186.	Rear ball bearing seat	WK04-00565
187.	Spring washer	WK04-00452
188.	Cap Head bolt	WK04-00451
189.	Rear blade guard	WK04-00566
190.	Round head screw	WK04-00459
17H-1.	Hydraulic cylinder post	WK04-00567
17H-2.	Cap Head bolt	WK04-00450
17H-3.	Spring washer	WK04-00452
17H-4.	Cap Head bolt	WK04-00461
17H-5.	Hydraulic cylinder	WK04-00568
17H-6.	Nut	WK04-00451
17H-7.	Set screw	WK04-00460
17H-8.	Supporting bracket	WK04-00569
17H-9.	Shaft	WK04-00570
17H-10.	Spring washer	WK04-00455
17H-11.	Cap Head bolt	WK04-00454
17H-12.	Cap Head bolt	WK04-00454
17H-13.	Limit switch	WK04-00571
17H-14.	Cap Head bolt	WK04-00450
17H-15.	Hydraulic cylinder post	WK04-00572

ASSEMBLY INSTRUCTIONS

UNPACKING

- Remove the bolts holding the upper packaging onto the pallet and remove the top of the carton.
- Check the bandsaw for any signs of damage or missing items prior to assembly.



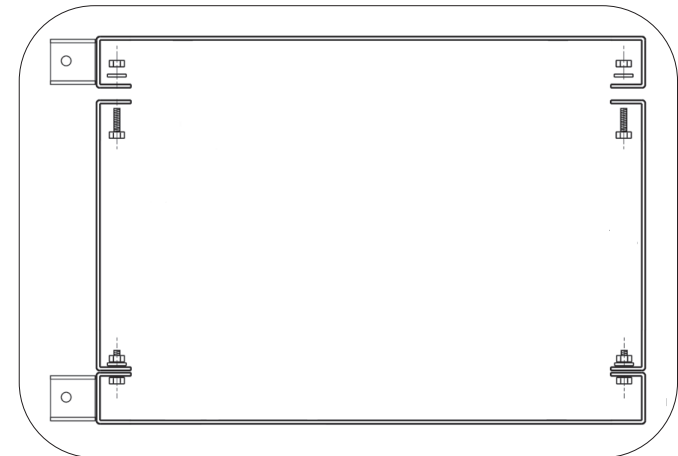
Note: If any items are missing or damaged, **DO NOT** use the machine, contact your distributor immediately.

BUILDING THE CABINET STAND

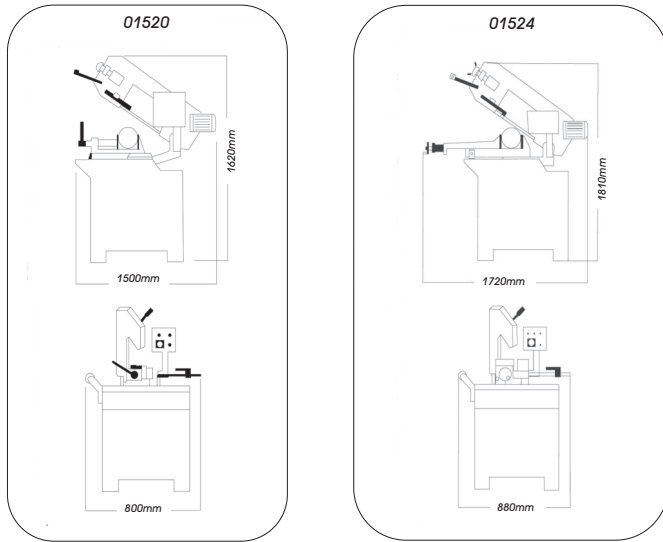
Remove all of the pieces for the cabinet from the packaging, and check that all parts are supplied and undamaged:

- 2 x side panels.
- 2 x Front/Back panels.
- 1 x Fixing kit (nuts & bolts).

- Fit the side panels to the front/rear panels and secure with the supplied nuts and bolts (see below).
- Place the built cabinet in the location that the saw will be used; Ensure there is enough clearance to safely operate the saw (see diagram on page 14).



ASSEMBLY INSTRUCTIONS...cont

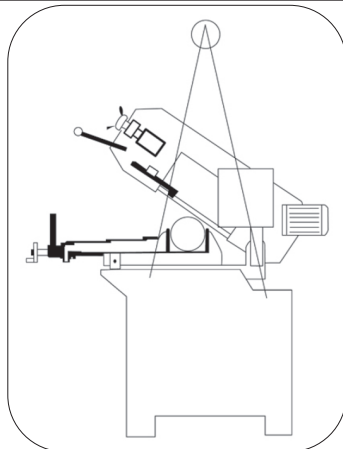


Note: Ensure that the saw is securely bolted to a solid floor, using the anchor points on the stand (17), so that it cannot tip during operation.

- Unbolt the bandsaw from the wooden base.
- Use proper lifting equipment (see below) to move the bandsaw from the wooden base and onto the cabinet stand.



Caution: At least 2 persons and lifting equipment are required to remove this bandsaw from its packaging. It is extremely heavy! Failing to follow this can have serious consequences and could lead to personal injury and/or the possibility of damage.



PARTS LIST...cont

01520

Ref. No.	Description	SIP Code	Ref. No.	Description	SIP Code
85.	Cover	WK04-00506	120.	Cap Head bolt	WK04-00454
86.	Cap Head bolt	WK04-00454	121.	Spring washer	WK04-00455
88.	Cap Head bolt	WK04-00454	122A.	Slide	WK04-00531
88-1.	Washer	WK04-00455	123.	Nut	WK04-00457
89.	Control box bottom plate	WK04-00507	124.	Handle	WK04-00532
90-1.	Transformer	WK04-00508	125.	Handle wheel	WK04-00533
90-2.	AC contactor	WK04-00509	126.	Thrust spring washer	WK04-00534
90-3.	Breaker	WK04-00510	127.	Tension shaft	WK04-00535
90-4.	Thermal relay	WK04-00511	128A.	Shaft	WK04-00536
90-5.	Terminal block	WK04-00512	129.	Ball bearing	WK04-00537
90-6.	Ground copper bar	WK04-00513	130.	Idle flywheel	WK04-00538
90-7.	Breaker	WK04-00514	131.	Washer	WK04-00539
91.	Cap Head bolt	WK04-00461	132.	Spring washer	WK04-00455
92-1.	Switch	WK04-00515	133.	Cap Head bolt	WK04-00454
92-2.	Power indicator light	WK04-00516	134.	Blade	WK04-00540
92-3.	Emergency stop	WK04-00517	135.	Knob bolt	WK04-00541
92-4.	Start button	WK04-00518	136.	Blade cover	WK04-00542
92-5.	Manual/auto selector	WK04-00519	137.	Round head screw	WK04-00459
93.	Control box panel	WK04-00520	138.	Spring washer	WK04-00462
94.	Control box bottom part	WK04-00521	138-1.	Nut	WK04-00457
95.	Support	WK04-00522	139.	Cap Head bolt	WK04-00543
96.	Setting bracket	WK04-00523	140.	Spring washer	WK04-00462
97.	Spring washer	WK04-00452	141.	Washer	WK04-00463
98.	Cap Head bolt	WK04-00450	142.	Drive flywheel	WK04-00544
99.	Spring washer	WK04-00452	143.	Cap Head bolt	WK04-00450
100.	Cap Head bolt	WK04-00454	144.	Spring washer	WK04-00452
101.	Cap Head bolt	WK04-00450	145.	Saw arm	WK04-00545
103.	Front ball bearing bracket	WK04-00524	145-1.	Set shaft	WK04-00546
104.	Setting bracket	WK04-00525	146.	Hose	WK04-00547
105.	Handle	WK04-00526	147.	Pipe fitting	WK04-00548
106.	Cap Head bolt	WK04-00454	152.	Hose	WK04-00549
107.	Plastic handle	WK04-00527	153.	Limit switch	WK04-00550
108.	Spring washer	WK04-00455	154.	Cap Head bolt	WK04-00454
109.	Cap Head bolt	WK04-00454	155.	Spring shaft	WK04-00551
110.	Set screw	WK04-00460	156.	Spring	WK04-00552
114.	Rod	WK04-00528	157.	Key	WK04-00553
115.	Nut	WK04-00457	158.	Gear box	WK04-00554
116.	Handle with switch	WK04-00529	159.	Key	WK04-00555
117.	Cover plate	WK04-00530	160.	Motor	WK04-00556
118.	Cap Head bolt	WK04-00454	161.	Spring washer	WK04-00455
119.	Set screw	WK04-00460	162.	Cap Head bolt	WK04-00458

PARTS LIST

01520

Ref. No.	Description	SIP Code	Ref. No.	Description	SIP Code
1.	Base (right part)	WK04-00464	44.	Spring washer	WK04-00452
1-1.	Base (left part)	WK04-00465	45.	Cap Head bolt	WK04-00450
2.	Cap Head bolt	WK04-00450	46.	Nut	WK04-00478
3.	Nut	WK04-00451	47.	Shaft	WK04-00479
4.	Base cover plate	WK04-00466	48.	Oil seal	WK04-00480
5.	Cap Head bolt	WK04-00450	49.	Set screw	WK04-00460
6.	Flat washer	WK04-00453	50.	Disk	WK04-00481
7.	Nut	WK04-00451	51.	Spring washer	WK04-00452
8.	Flat washer	WK04-00453	52.	Cap Head bolt	WK04-00450
9.	Spring washer	WK04-00452	53.	Set screw	WK04-00460
10.	Cap Head bolt	WK04-00450	54.	Hand wheel	WK04-00482
11.	Cap Head bolt	WK04-00454	55.	Set screw	WK04-00460
12.	Plate	WK04-00467	56.	Nut	WK04-00483
13.	Cap Head bolt	WK04-00454	57.	Bearing bushing	WK04-00484
14.	Spring washer	WK04-00455	58.	Ball bearing	WK04-00485
15.	Cap Head bolt	WK04-00454	59.	Lock handle	WK04-00486
15-1.	Spring washer	WK04-00455	60.	Bushing	WK04-00487
16.	Washer	WK04-00456	61.	Cap Head screw	WK04-00488
17.	Supporting plate	WK04-00468	62.	Upper vise	WK04-00489
18.	Nut	WK04-00457	63.	Compressed spring	WK04-00490
18-1.	Flat washer	WK04-00453	64.	Lead screw	WK04-00491
19-1.	Support plate	WK04-00469	64-1.	Key	WK04-00492
19-2.	Cap Head bolt	WK04-00454	66.	Vise	WK04-00493
19-3.	Spring washer	WK04-00455	67.	Set screw	WK04-00460
28.	Block plate	WK04-00470	68.	Cap Head bolt	WK04-00454
29.	Cap Head bolt	WK04-00454	69.	Scale pointer	WK04-00494
30.	Spring Washer	WK04-00455	70.	Set screw	WK04-00460
30-1.	Nut	WK04-00457	71.	Pivot	WK04-00495
31.	Cap Head bolt	WK04-00458	73.	Ball bearing	WK04-00496
32.	Nut	WK04-00457	74.	Nut	WK04-00457
33.	Filter net	WK04-00471	75.	Cap Head bolt	WK04-00454
34.	Round head screw	WK04-00459	75-1.	Cap Head bolt	WK04-00454
35.	Cap Head bolt	WK04-00454	76.	Spring hook	WK04-00497
36.	Spring Washer	WK04-00455	77.	Star washer	WK04-00498
37.	Hose	WK04-00472	78.	Nut	WK04-00499
38.	Hose clamp	WK04-00473	79.	Swivel arm	WK04-00500
39.	Pump	WK04-00474	80.	Scale	WK04-00501
40.	Plug	WK04-00475	81.	Rivet	WK04-00502
41.	Coolant Return Plate	WK04-00476	82.	Bar-stop-rod	WK04-00503
42.	Locking lever	WK04-00477	83.	Bracket	WK04-00504
43.	Set screw	WK04-00460	84.	Butterfly screw	WK04-00505

ASSEMBLY INSTRUCTIONS...cont

- Secure the bandsaw to the stand using the supplied bolts.



Note: 01520 - Remove the front panel covering the Swivel Release / Lock (11) to access the securing points / bolts.

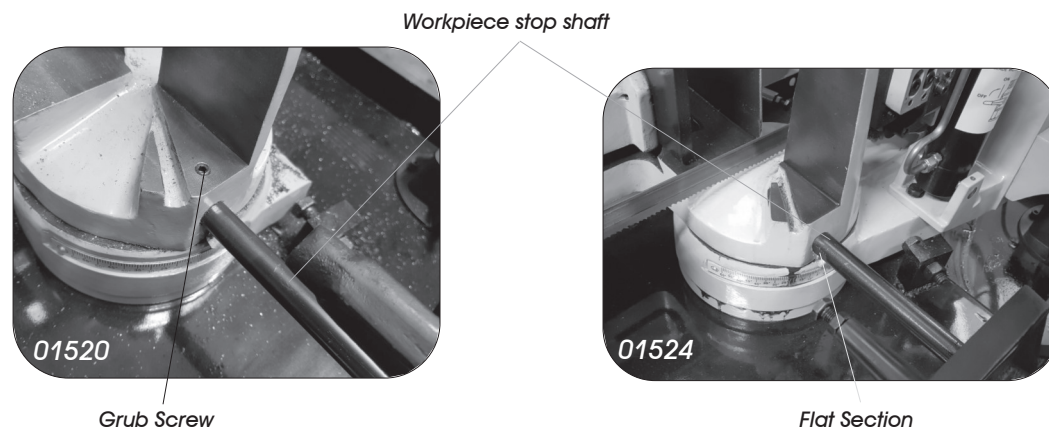
FITTING THE WORKPIECE STOP

01520:

- Slide the shaft of the workpiece stop (9) into the hole on the front of the casting (see below, left).
- Secure the shaft in place by tightening the grub screw.
- The cut off stop is now ready to be used.

01524:

- Screw the shaft of the workpiece stop (9) into the workpiece stop hole on the front of the casting (see below, right).
- Secure in place by tightening with a spanner around the flat section at the end of the shaft.
- The cut off stop is now ready to be used.

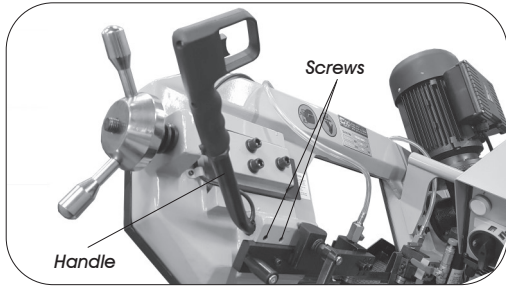


LOCKING THE PULL DOWN HANDLE IN POSITION

The pull down handle is strapped to the blade tension hand wheel during transit.

- Remove the packaging and set the handle in a comfortable, ergonomic position.
- Lock the handle in place by tightening the 2 set screws on the side of the saw.

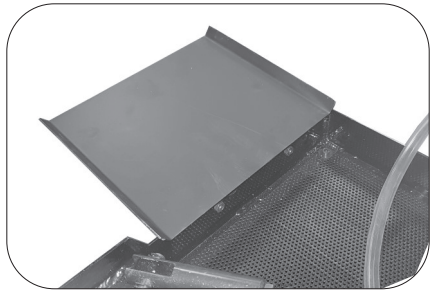
ASSEMBLY INSTRUCTIONS...cont



FITTING THE COOLANT RETURN PLATE

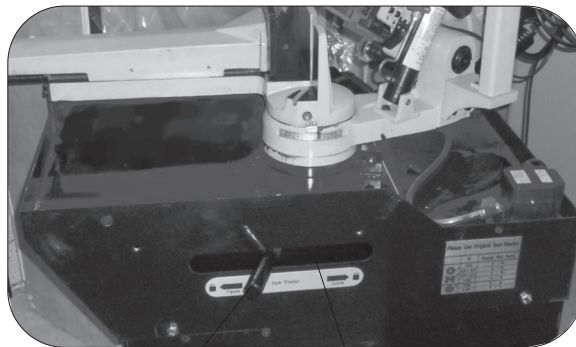
The coolant return plate prevents coolant from flowing from the saw when making an angled cut, and allows it to flow back into the coolant reservoir.

Fit the coolant return plate to the side of the saw base using the supplied nut & bolt.



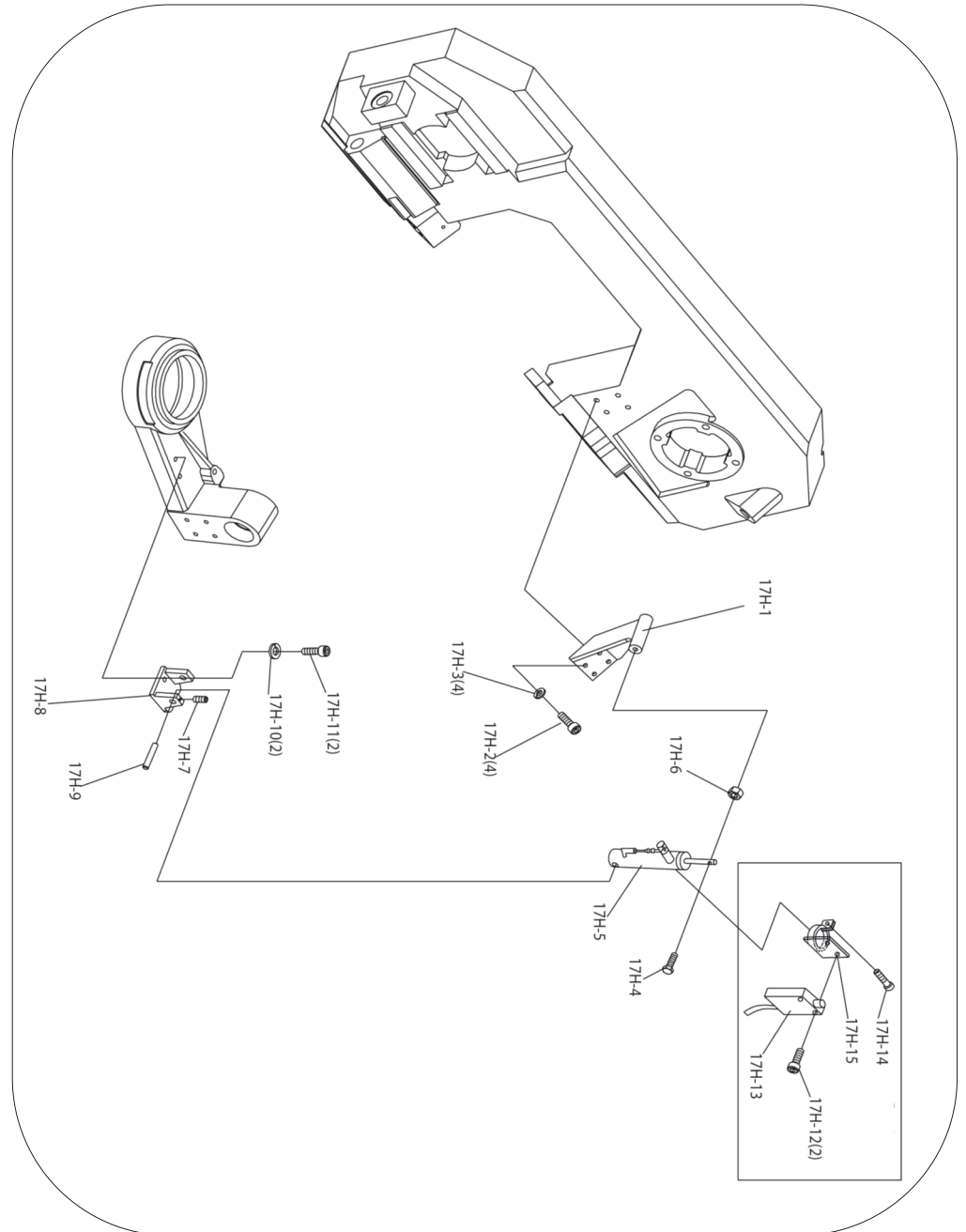
FITTING THE ANGLE LOCK HANDLE - 01524 ONLY

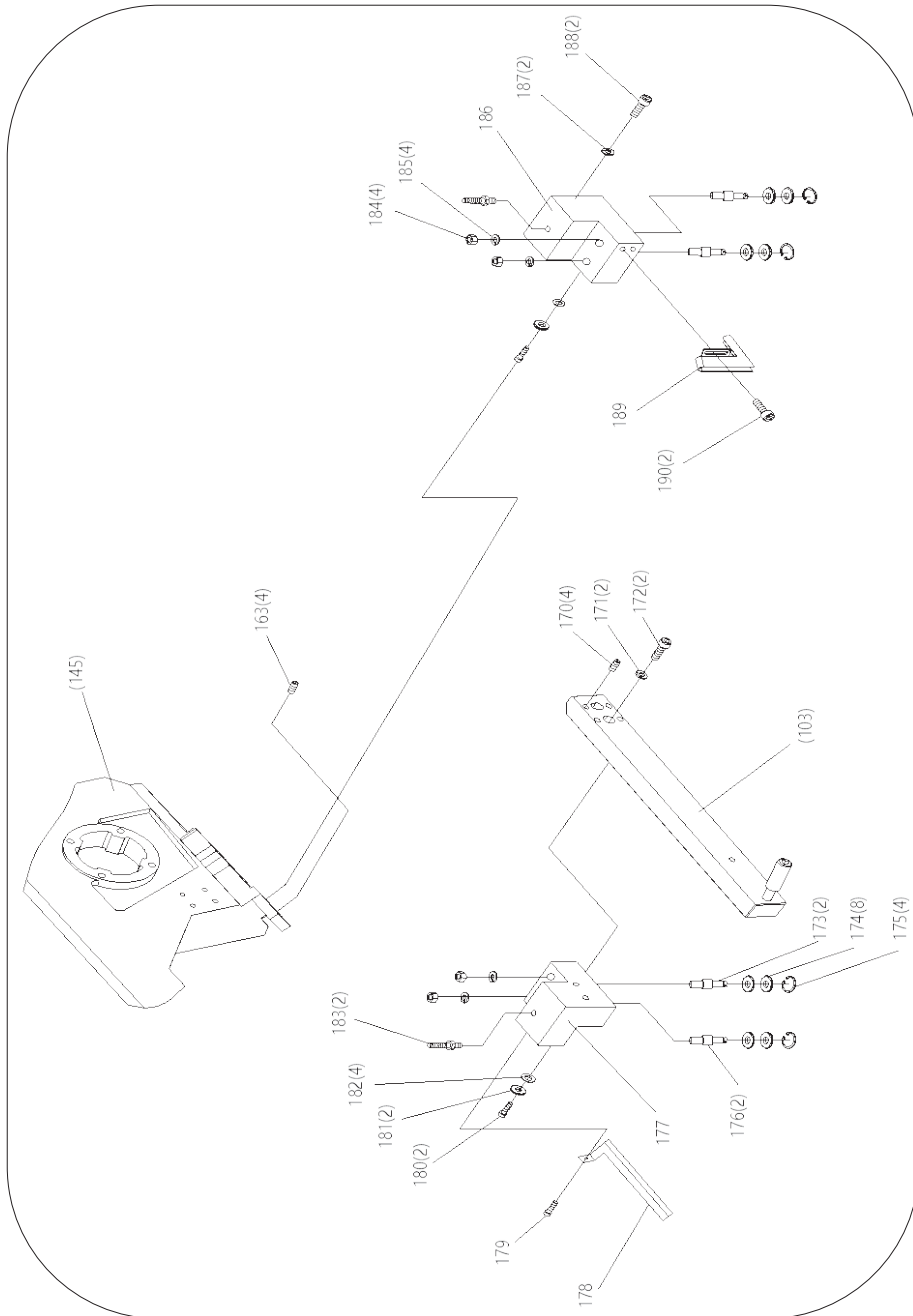
To fit the handle, screw it into place on the threaded shaft found inside the slot.



EXPLODED DRAWING...cont

01520

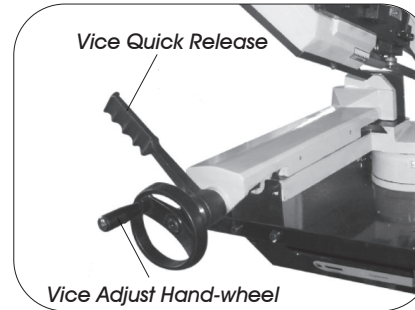




CLEANING THE SURFACES PRIOR TO OPERATION

Before using the bandsaw it is advisable to clean the rust protected surfaces using kerosene (paraffin), diesel oil or mild solvent. Never use cellulose based solvents such as paint thinner or lacquer thinner as these will damage the painted surfaces.

OPERATING THE VICE



- Rotate the vice adjust hand-wheel clockwise to tighten the vice, and anti-clockwise to loosen it.
- The quick release handle can be used to quickly lock / release the workpiece by creating a small gap between the vice and the workpiece.



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

CUTTING ANGLE ADJUSTMENT

- The angle can be set up between 0°(90°) to 60°.
- Unlock the swivel release / lock lever (11) by pushing it to the left.
- Rotate the saw to the desired angle by following the index on the scale (19).
- Lock the lever (11) by pushing it to the right.

OPERATING INSTRUCTIONS...cont

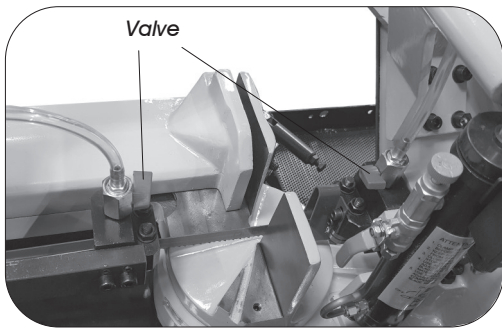
USING THE COOLANT PUMP



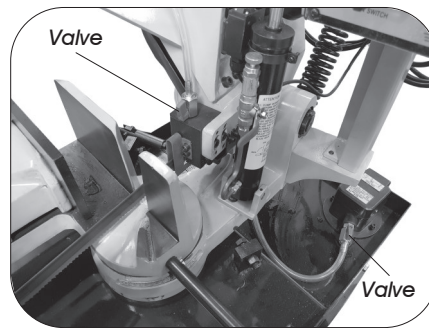
Note: We recommend the use of water soluble coolant, this will prolong the blade life and make the cut more efficient.

The coolant is pumped from the coolant tank by the coolant pump (10) and fed through a clear plastic tube to 2 valves (taps) situated on the top edge of the bow casting for the 01520 and near the coolant pump and above the blade guide for the 01524 (see below). When the valves are 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 grill situated above it for recirculation.

The coolant tank should be filled by pouring the liquid directly through the grill.



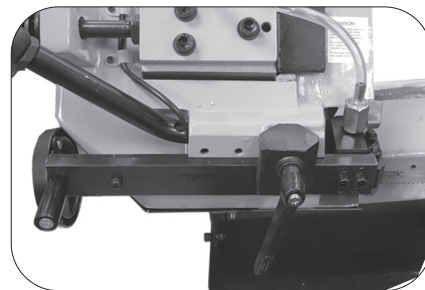
01520



01524

ADJUSTING THE BLADE GUIDES

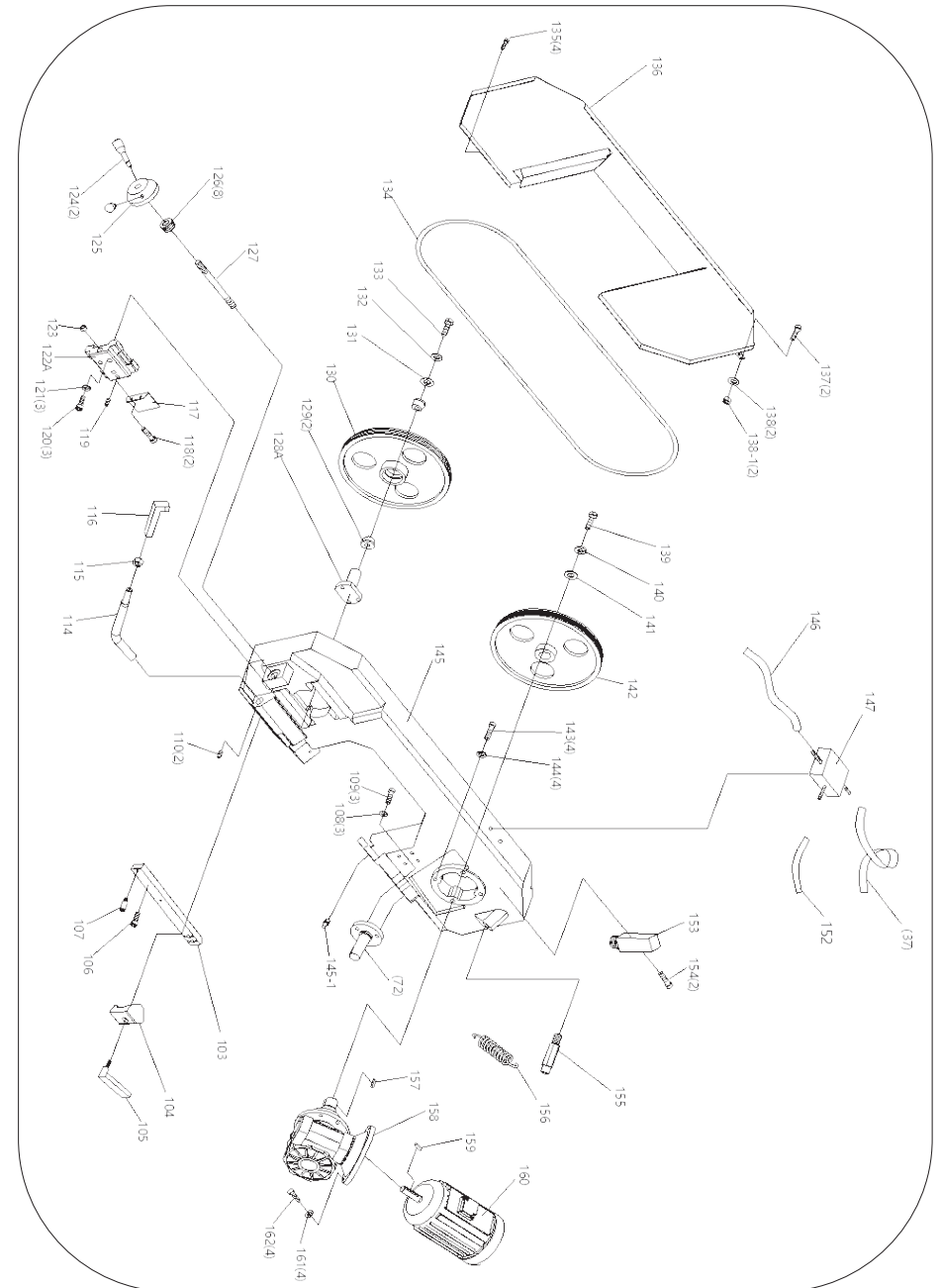
1. Ensure the bearings are adjusted correctly (See maintenance section P.23)
2. Slide the guide into the required position.



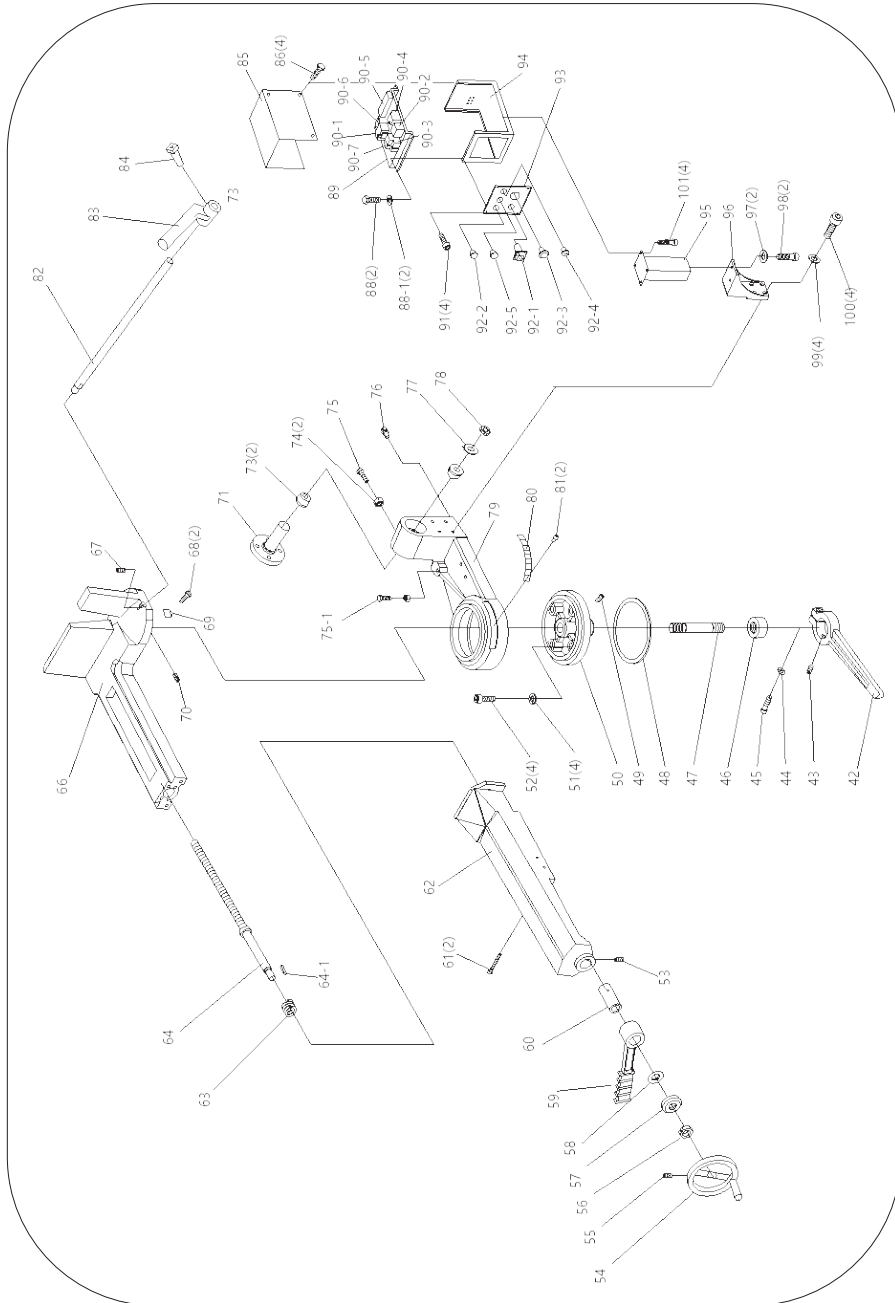
Note: The 01524 requires the use of a Hex key to lock/unlock the guide.

EXPLODED DRAWING...cont

01520

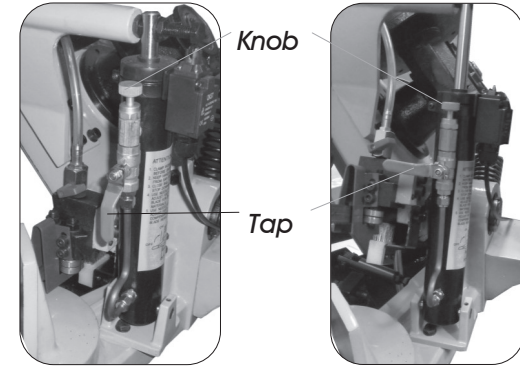


01520



USING THE HYDRAULIC STOP

The hydraulic cylinder has an adjustable rate of descent; it can be adjusted by turning the knob 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. When the tap is at 90° to the cylinder, the flow will stop and the bow will stop descending.



Unlocked

Locked

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. Raise the saw bow to its highest position.
3. Adjust the workpiece stop to your desired position (if required).
4. Set the vice angle to your desired position.
5. Open the vice and insert the workpiece to be cut then close the vice to secure.
6. 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.

OPERATING INSTRUCTIONS...cont

MANUAL PULL DOWN CUTTING

1. On the control panel set the switch to the **LEFT** position
2. Adjust the arm position so the blade is close to the workpiece; then lock the



Note: Do not start cutting on a sharp edge; File it off first.

3. bow.
3. Plug in to the mains supply.
4. Turn the main power switch (A) to the **ON** position.
5. Turn the coolant pump on.
6. Place your hand on the trigger and press the button to start the saw.
7. To bring the blade in to contact with the workpiece to be cut, slowly bring the blade down, controlling the rate of decent with your hand, if the blade jams then immediately turn the bandsaw off and refer to the troubleshooting guide on page 26.
8. Once the cut is complete, release your finger from the trigger button and then the saw will stop.

HYDRAULIC GRAVITY FEED CUTTING

1. On the control panel set the switch to the **RIGHT** position
2. Adjust the rate of descent of the bow as described on page 18 so that it is creeping slowly down towards the workpiece, shut off the hydraulic cylinder when the blade gets close to the workpiece.

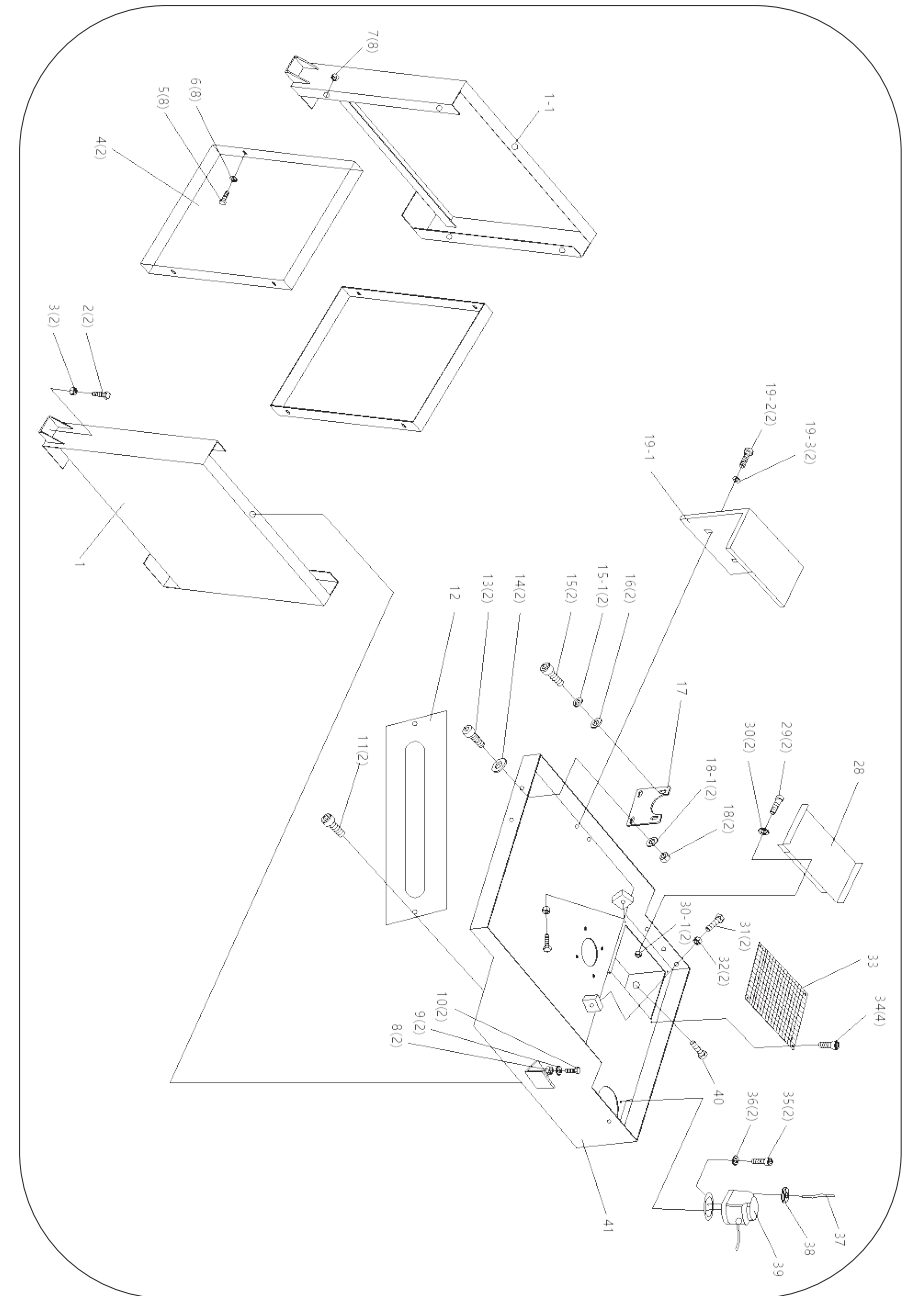


Note: Do not start cutting on a sharp edge; File it off first.

3. Plug in to the mains supply.
4. Turn the main power switch (A) to the **ON** position.
5. Turn the coolant pump on.
6. Start the saw.
7. To bring the blade in to contact with the workpiece to be cut, open the bow lock, if the blade jams then immediately turn the bandsaw off and refer to the troubleshooting guide on page 26.
8. Once the cut is complete, the saw should automatically stop.

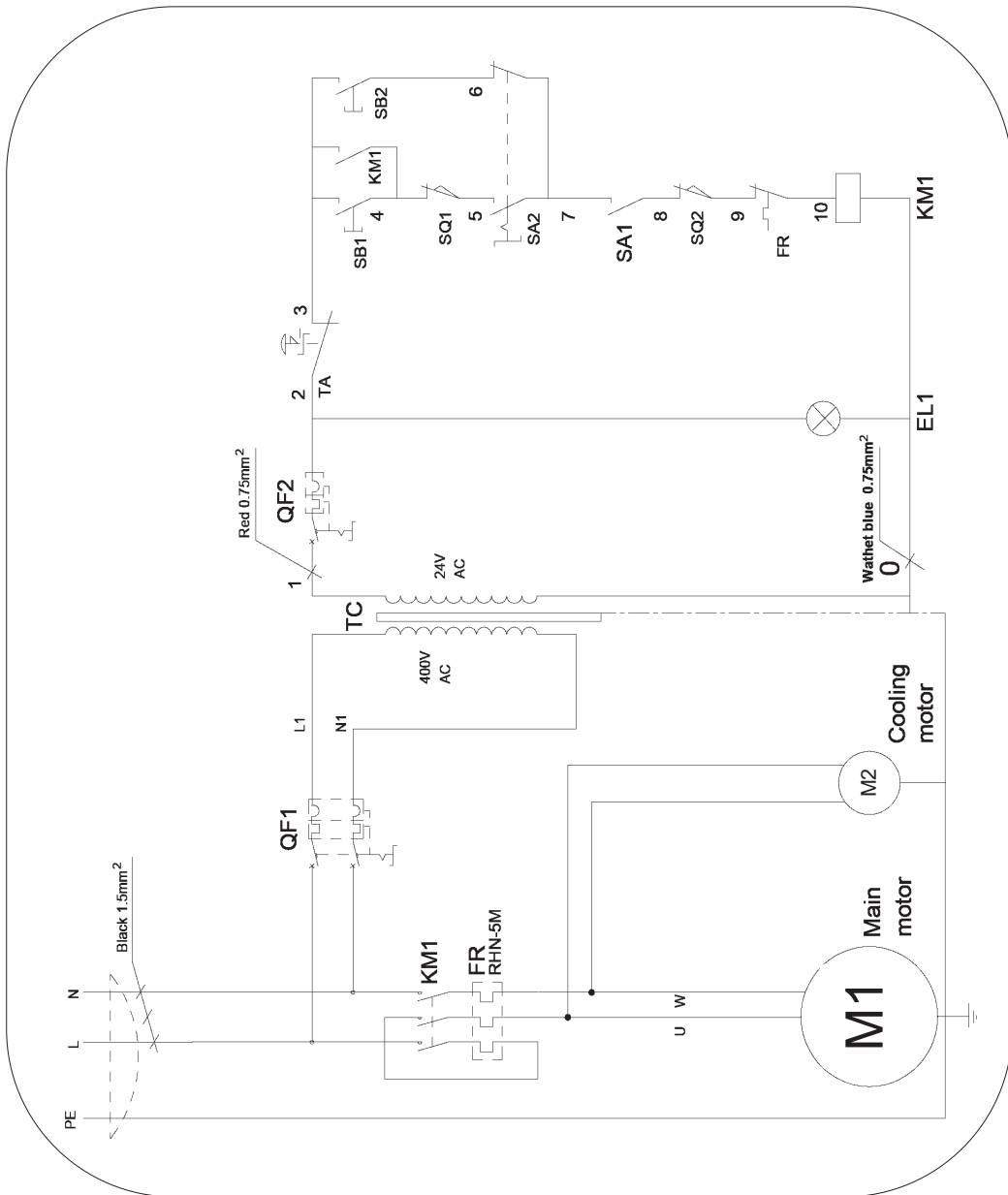
EXPLODED DRAWING

01520



WIRING DIAGRAM

01524



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MAINTENANCE INSTRUCTIONS

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 01520 bandsaw was designed to use a 2085 x 20 x 0.9mm size blade. The 01524 bandsaw was designed to use a 2445 x 27 x 0.9mm 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 cap head bolts.
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. Put a small amount of tension on the blade (see tensioning the blade).
10. Once done reattach the blade guards etc.
11. The blade will need to be fully tensioned see below on how to do this.

TENSIONING THE BLADE



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.

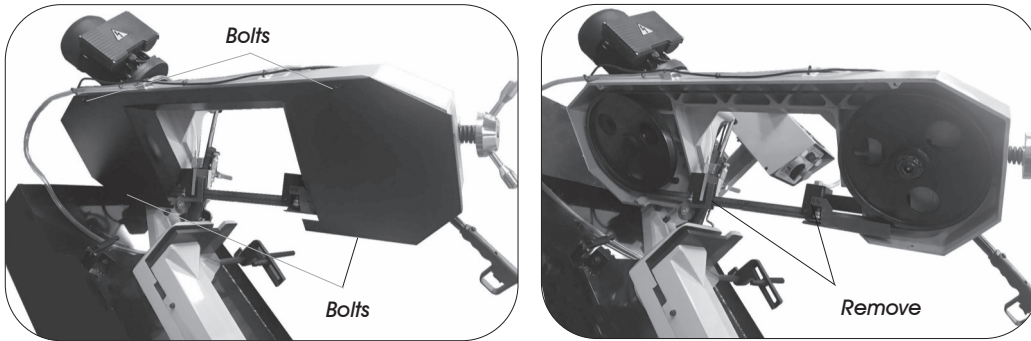
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MAINTENANCE INSTRUCTIONS...cont

Blade tension is important for the correct operation of the bandsaw; the blade tension should be set between 700-900kgs.

To set the blade correctly without using a blade tension gauge, take the following steps.

1. Disconnect the bandsaw from the mains supply.
2. Open the blade cover by removing the 4 hex bolts.
3. Tension the blade slightly to take any slack off the blade.
4. Turn the Blade tensioning knob in a clockwise direction, one and a half turns or two full turns.
5. Close the blade guard etc. and connect to the mains supply.
6. Run the bandsaw between 2-3 minutes so the blade can seat correctly.
7. Stop the bandsaw and disconnect from the mains supply.
8. Open the blade guard and loosen the blade until it just begins to slacken.
9. Tighten the blade so it becomes straight between the blade wheels, and all the slackness has gone.
10. Turn the Blade tensioning knob approximately two full turns, this should now be tensioned correctly.

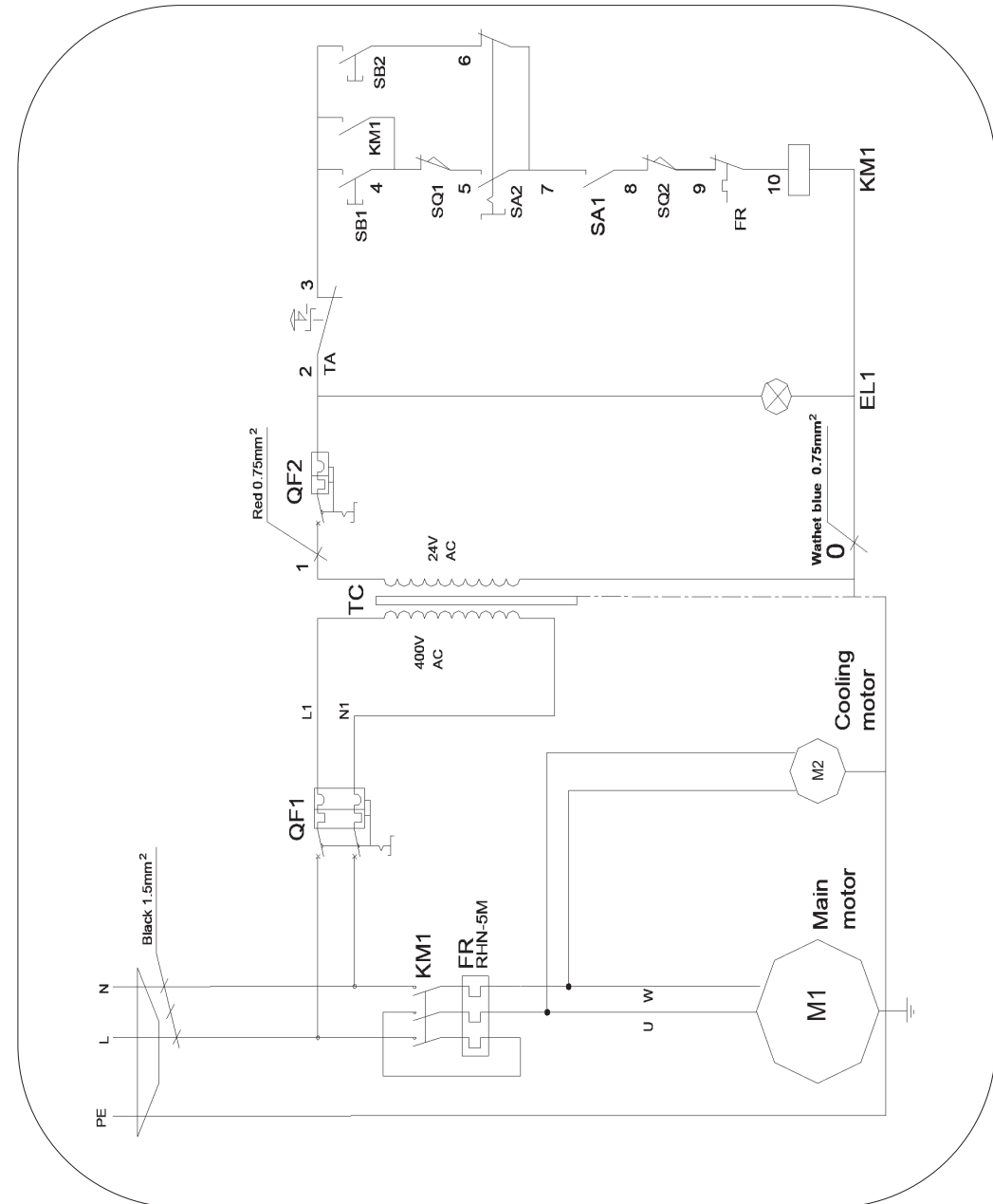


SETTING THE BLADE SQUARE TO THE BED AT 0°

1. Ensure the bow is at its lowest position.
2. Disconnect from the mains supply.
3. Place an engineer's set square onto the bed and touching the blade.
4. If any adjustment is needed then loosen the two cap head bolts.
5. Rotate both blade guides in the required direction until the blade makes contact with the set square along the entire width of the blade.
6. Once set correctly, retighten both cap head bolts.
7. The blade guide bearings may need to be adjusted.

WIRING DIAGRAM

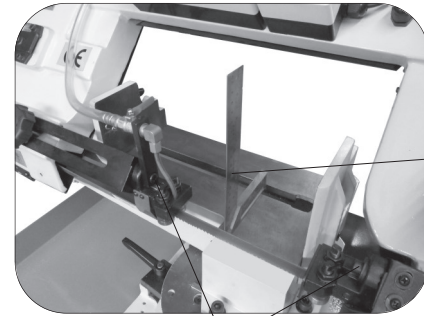
01520



TROUBLESHOOTING

Symptom	Possible cause	Solution
Unusual wear on side or back of blade.	<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.
Excessive blade breakage and teeth ripping from the blade.	<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 bandsaw 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 workpiece 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.
Motor overheating.	<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 workpiece. 3. Lubricate the gears. 4. Decrease feed and speed.
Blade is twisting.	<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.
Bad, rough or crooked cuts.	<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 adjusted. 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 the spring tension on the arm.
Premature blade dulling.	<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 stainless. 	<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 reinstall. 6. Increase blade tension. 7. Increase feed pressure by reducing spring pressure.

MAINTENANCE INSTRUCTIONS...cont

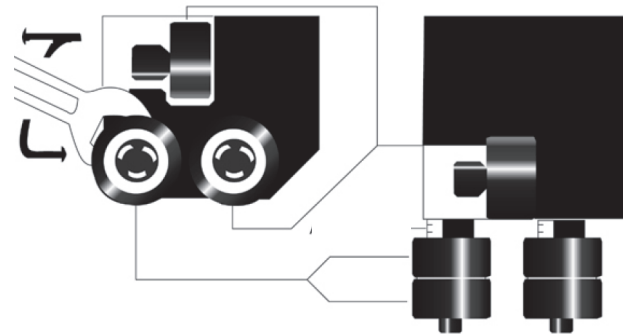


Set square

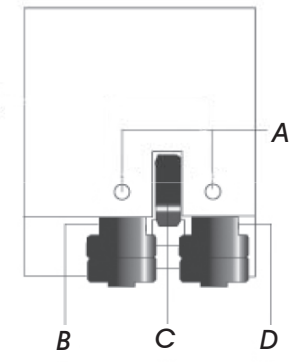
Cap head bolts

BLADE GUIDE BEARING ADJUSTMENT

Raise the saw bow to its highest position and lock it by turning the hydraulic cylinder tap to the off position.



01520



01524



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.



Note: The inner bearing shaft (B) is eccentric and is the one to adjust, the outer bearing shaft (D) is fixed and **can not** be adjusted.



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

MAINTENANCE INSTRUCTIONS...cont

01520:

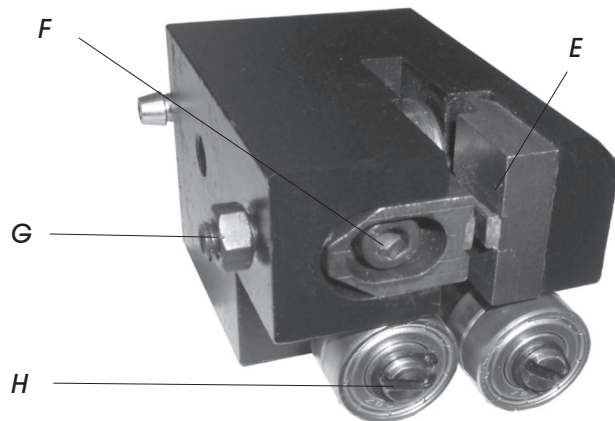
Adjustment should be carried out as follows:

- From the bottom of the guide blocks, use a wrench on the adjusting nut of the eccentric bearing.
- Turning the adjusting nut clockwise will move the eccentric bearing away from the blade.
- Turning the adjusting nut counter-clockwise will move the eccentric bearing closer to the blade.

01524:

Adjustment should be carried out as follows:

- Loosen the grub screw (A) and rotate the screw (H) to adjust the passage between the bearing, then tighten grub screw (A) to secure.
- To mount the new blade; place the pad on the blade by loosening the relative bolt (F) and grub screw and nut (G). Allow 0.04mm of play for the sliding of the toothed blade, lock the relative bolt (F), nut and grub screw (G).
- Make sure that between the blade and the upper teeth of the pad (E) there is at least 0.2-0.3mm of play; if necessary, loosen the screws that fasten the blocks (F-G) and adjust accordingly.

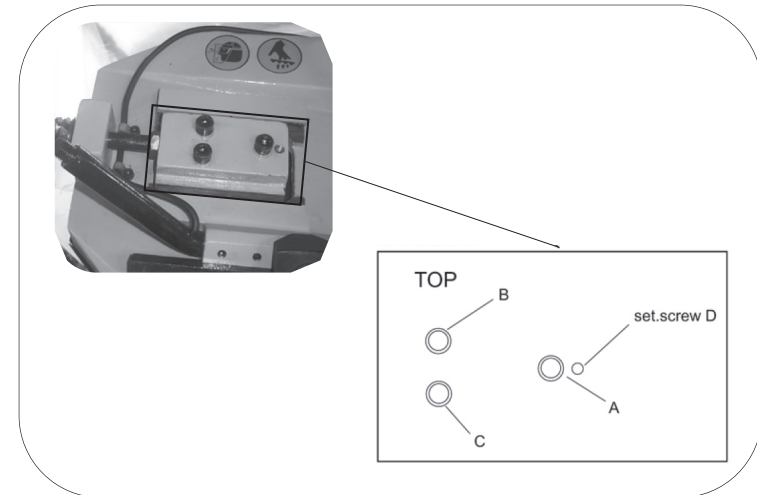


MAINTENANCE INSTRUCTIONS...cont

GENERAL MAINTENANCE

- Do not use compressed air to clean the bandsaw, this can cause metal filings to go into the guide bearings and other parts of the bandsaw.
- Always remove the metal filings from the blade guides after use.
- Wipe the bandsaw down with a dry cloth.
- Check the guide bearings regularly making sure they are clean and correctly adjusted.
- Always check to make sure the wire brush is properly adjusted and cleaned.
- Always disconnect from the mains supply before carrying out any maintenance.

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.