



Operating Instructions and Parts Manual

Portable Metal Cutting Band Saw

Model BS-127P-1.0



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2.0 Safety Instructions

⚠ WARNING

Failure to follow these rules may result in serious personal injury

1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE. Learn the machine's application and limitations as well as the specific hazards.
2. Only trained and qualified personnel can operate this machine.
3. Make sure guards are in place and in proper working order before operating machinery.
4. Remove any adjusting tools. Before operating the machine, make sure any adjusting tools have been removed.
5. Keep work area clean. Cluttered areas invite injuries.
6. Overloading machine. By overloading the machine, you may cause injury from flying parts. DO NOT exceed the specified machine capacities.
7. Dressing material edges. Always chamfer and deburr all sharp edges.
8. Do not force tool. Your machine will do a better and safer job if used as intended. DO NOT use inappropriate attachments in an attempt to exceed the machine's rated capacity.
9. Use the right tool for the job. DO NOT attempt to force a small tool or attachment to do the work of a large industrial tool. DO NOT use a tool for a purpose for which it was not intended.
10. Dress appropriately. DO NOT wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. Use eye and ear protection. Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. Do not overreach. Maintain proper footing and balance at all times. DO NOT reach over or across a running machine.
13. Stay alert. Watch what you are doing and use common sense. DO NOT operate any tool or machine when you are tired.
14. Check for damaged parts. Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. Observe work area conditions. DO NOT use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. DO NOT use electrically powered tools in the presence of flammable gases or liquids.
16. Blade adjustments and maintenance. Always keep blades sharp and properly adjusted for optimum performance.
17. Keep children away. Children must never be allowed in the work area. DO NOT let them handle machines, tools, or extension cords.
18. Keep visitors a safe distance from the work area.
19. Store idle equipment. When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
20. DO NOT operate machine if under the influence of alcohol or drugs. Read warning labels on prescriptions. If there is any doubt, DO NOT operate the machine.
21. Turn off power before checking, cleaning, or replacing any parts.
22. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
23. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
24. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. Bare wiring can kill! DO NOT touch live electrical components or parts.
25. DO NOT bypass or defeat any safety interlock systems.

Familiarize yourself with the following safety notices used in this manual:



This means that if precautions are not heeded, it may result in minor injury and/or machine damage.



This means that if precautions are not heeded, it may result in serious injury or death.



This means that if precautions are not heeded, it will result in serious or fatal, injury.

Save the Instructions

3.0 About This Manual

This manual is provided by Baileigh Industrial, covering the safe operation and maintenance procedures for a Baileigh Model BS-127P-1.0 Portable Metal Cutting Band Saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

Technical Support handles questions on setup, operation, schematics, warranty issues, and individual parts needed. Our Technical Support department can be reached at 920-684-4990.

If there are questions or comments, please contact your local supplier or Baileigh Industrial. We can also be reached at our web site: www.baileigh.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

WARNING

Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Register your product online -

<https://baileigh.com/product-registration>



4.0 Specifications

Table 4-1

Model	BS-127P-1.0
Stock Number	BA9-1018561
Motor and Electrical	
Drive	Gear
Power	110V, 60Hz
Motor	DC @ .5HP (300W)
General Specifications	
Capacity Rectangular 45° / 60°	4.72" x 2.75" / 2.5" x 1.37" (120 x 70mm / 65 x 35mm)
Capacity Round 90° / 45° / 60°	4.9" / 2.75" / 1.37" (125mm / 70mm / 35mm)
Capacity Square 90°	4.72" x 4.72" (120 x 120mm)
Return	Manual
Miter Adjustment	Swivel Head
Miter Angle	0 - 60°
Blade Size (H x T x L)	.5" x .025" x 56.69" (13 x .65 x 1440mm)
Blade Speed (fpm)	75 – 246fpm (23 – 75mpm) Variable
Weights and Dimensions	
Shipping Weight	56 lbs. (26kg)
Shipping Dimensions	28.75" x 15" x 18" (730 x 383 x 457mm)

WARNING

Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

5.0 Setup and Assembly

5.1 Unpacking and Checking Contents

WARNING

SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

WARNING

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

5.2 Cleanup

WARNING

DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

CAUTION

When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.

IMPORTANT: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.

5.3 Transporting and Lifting

Follow these guidelines when lifting:

- Use proper lifting techniques when moving the saw from location to location.
- Make sure the machine is balanced, level, and securely tied or strapped to the transport vehicle or device so that all the supporting feet are taking the weight of the machine and no rocking is taking place.
- While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.

5.4 Installation

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, worktables, or other machinery.
- Clearance from walls and other obstacles. Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level surface. The accuracy of any machine depends on the precise placement of it to the mounting surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

5.5 Assembly

⚠ WARNING

For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

5.5.1 Material Stop Assembly

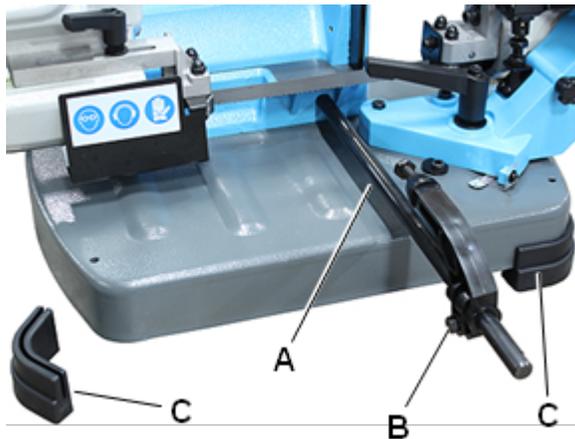


Figure 5-1

1. Install the extension rod (A) into the vise base and under the material support and tighten.
2. Install the material stop (B) onto the extension rod and tighten the wing nut to hold the stop in position.
3. The stop may be removed or rotated to a horizontal position when not needed.
4. Install the four rubber feet (C) onto the corners of the base.

5.5.2 Gear Reducer Grease

1. Locate the grease fitting (A) on the gear reducer and pump 3 – 5 pumps of a super high-density grease into the reducer.
2. Grease the gear reducer every week to lubricate the gears avoid over-heating the gears when machine be used continuously.



Figure 5-2

6.0 Electrical

⚠ CAUTION

HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN! Check if the available power supply is the same as listed on the machine nameplate.

⚠ WARNING

Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

6.1 Power Specifications

Your machine is wired for 110 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

6.2 Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. Before connecting the motor to

the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.

- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

⚠ WARNING

In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

6.3 Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

Table 6-1

AMP Rating	Length		
	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
Wire Gauge			

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

6.4 Power Cord Connection

1. Turn the main disconnect switch on the control panel to the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
 - a. Route the power cord so that it will NOT become entangled in the machine in any way.
 - b. Route the cord to the power supply in a way that does NOT create a trip hazard.
3. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
4. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation. Turn the switch OFF when the machine is not in operation.

7.0 Before Each Use

- For dusty operations, wear a face shield along with safety goggles.
- It is important to choose the right blade for the material and the type of cutting you plan to do. This saw is equipped with a bi-metallic blade which can be used to cut stainless steel, steel, iron, brass, aluminum, wood, plastic.
- Make sure the direction of rotation arrow on the blade matches the direction arrow on the saw. The blade teeth should always point downward at the front of the saw.
- Make sure the blade is sharp, undamaged and properly aligned. With the saw unplugged, push the power-head all the way down. Rotate the blade by hand checking for clearance. If the blade hits anything, make the adjustments shown in the Maintaining Maximum Cutting Capacity section.
- Never cut freehand.
- Make sure the cut-off piece can move sideways after it is cut off. Otherwise, it could get wedged against the blade and thrown violently.
- Never turn the saw "ON" before clearing everything except the work piece beneath the blade.
- Never put lubricants on the blade while it is spinning.

7.1 Whenever Saw is Running

- Never confine the piece being cut out.
- Never hold it, clamp it, touch it, or use length stops against it. It must be free to move sideways. If confined, it could get wedged against the blade and thrown violently.
- Avoid awkward hand positions where a sudden slip could cause a hand to move into the blade.
- Let the blade reach full speed before cutting.

- Feed the saw into the work piece only fast enough to let the blade cut without bogging down or binding.
- Before freeing jammed material, turn the switch off and unplug the saw. Wait for all moving parts to stop.
- After finishing a cut, keep holding the saw bow down, release the switch, and wait for all moving parts to stop before moving your hands.

7.2 Breaking in a Band Saw Blade

Sharp cutting edges with extremely small edge radii are required for high cutting capacity. To achieve the optimal tool life we recommend breaking-in the blade accordingly. The correct cutting speed is determined by the material being cut and its dimensions. It is very important that the new blade is first used with only 50% of the determined feed rate. This will avoid micro-breakages of the blade because of too large chip thicknesses. New band saw blades may tend toward vibrations and vibration sounds. In this case a slight reduction of the cutting speed is helpful. With small workpiece dimensions approximately 300cm² of the material should be cut for breaking-in. If large work piece dimensions are to be cut we recommend a breaking-in period of about 15 minutes. After breaking-in you may slowly increase the feed rate up to the determined value.

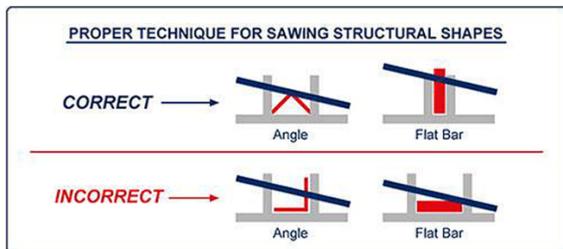


Figure 7-1

7.3 Metal Chip Indicators

Chips are the best indicator of correct material feed force. Monitor chip information and adjust feed accordingly.

- Thin or Powdered Chips – increase feed rate or reduce saw speed
- Burned Chips – reduce feed rate and / or saw speed
- Curly Silvery and Warm Chips – optimum feed rate and saw speed

Baileigh Industrial offers a wide selection of tooth styles for various cutting applications. Please phone Baileigh Industrial at (920.684.4990) or fax to (920.684.3944) to have one of our technicians assist you in selecting the proper band saw blade for your cutting applications.

7.4 Blade Terminology

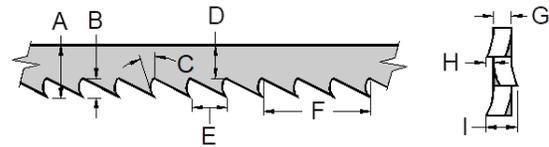


Figure 7-2

Table 7-1

A	BLADE WIDTH	The widest part of the blade measured from the back edge of the blade to the tip of the tooth.
B	GULLET DEPTH	The distance from the tooth tip to the bottom of the curved area.
C	TOOTH RAKE	The angle of the tooth face from a line perpendicular to the length of the blade.
D	BLADE BACK	The distance between the back edge of the blade and the bottom of the gullet.
E	TOOTH PITCH	The distance between tooth tips.
F	TPI	The number of teeth per inch when measured from gullet to gullet.
G	GAUGE	The thickness of the blade.
H	TOOTH SET	The distance a tooth is bent from the blade.
I	KERF	The width of material that is removed by the blade when cutting.

7.5 Width of Blade

The blade width determines the largest and the smallest curve that can be cut. Usually the wider a blade is, the more accurate and straighter it will cut.

7.6 Length of Blade

The length of the band saw blade can be measured with a tape measure at it's circumference or by the formula below:

$$\text{Blade Length} = (2 \times A) + (3.14 \times B)$$

A = the distance in inches between the band saw pulley centers (when the upper pulley is midway in its adjustment range).

B = the band saw pulley diameter.

7.7 Blade Structure

Bi-metal blades are the most commonly used. They consist of a silicon-steel blade backing by a laser welded high speed steel (HSS) cutting edge. The type of stocks are classified in M2, M42, M51 and differ from each other because of their major hardness due to the increasing percentage of Cobalt (Cc) and molybdenum (Mo) contained in the metal alloy.

7.8 Blade Type

They differ essentially in their constructive characteristics, such as:

- Shape and cutting angle of tooth
- Pitch
- Set

7.8.1 Shape and angle of tooth

REGULAR TOOTH: 0° rake and constant pitch.



Figure 7-3

Most common form for transversal or inclined cutting of solid small and average cross-sections or pipes, in laminated mild steel and gray iron or general metal.

POSITIVE RAKE TOOTH: $9^\circ - 10^\circ$ positive rake and constant pitch.

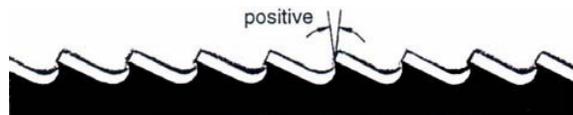


Figure 7-4

Particular use for crosswise or inclined cuts in solid sections or large pipes, but above all harder materials (highly alloyed and stainless steels, special bronze and forge pig iron).

COMBO TOOTH: pitch varies between teeth and consequently varying teeth size and varying gullet depths. Pitch varies between teeth, which ensures a smoother, quieter cut and longer blade life owing to the lack of vibration.

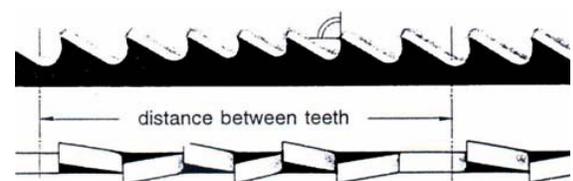


Figure 7-5

Another advantage offered in the use of this type of blade in the fact that with an only blade it is possible to cut a wide range of different materials in size and type.

COMBO TOOTH: $9^\circ - 10^\circ$ positive rake.

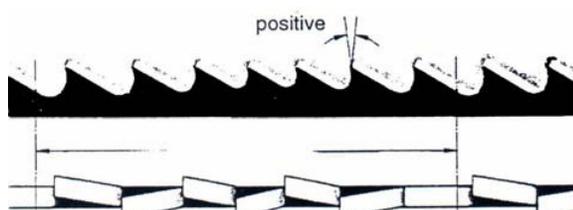


Figure 7-6

This type of blade is the most suitable for the cutting of section bars and large and thick pipes as well as for the cutting of solid bars at maximum machine capacity. Available pitches: 3-4/4-6.

7.9 Sets

Saw teeth bent out of the plane of the saw body, resulting in a wide cut in the workpiece.

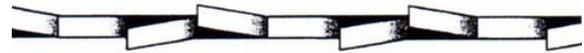


Figure 7-7

REGULAR OR RAKER SET: Cutting teeth right and left, alternated by a straight tooth.



Figure 7-8

Of general use for materials with dimensions superior to 5 mm. Used for the cutting of steel, castings and hard nonferrous materials.

WAVY SET: Set in smooth waves.



Figure 7-9

This set is associated with very fine teeth and it is mainly used for the cutting of pipes and thin section bars (from 1 to 3 mm).

ALTERNATE SET (IN GROUPS): Groups of cutting teeth right and left, alternated by a straight tooth.



Figure 7-10

This set is associated with very fine teeth, and it is used for extremely thin materials (less than 1mm).

ALTERNATE SET (INDIVIDUAL TEETH): Cutting teeth right and left.



Figure 7-11

This set is used for the cutting of nonferrous soft materials, plastics and wood.

8.0 Choosing a Saw Blade

A general purpose blade is furnished with this band saw.

To achieve a quality, economical, and efficient saw cut, the following points must be taken into consideration:

- Type of material being cut (ferrous or non-ferrous)
- Material hardness and physical dimensions
- Blade descent rate
- Longitudinal speed of blade

- Blade tooth profile

Choose a tooth pitch that is suitable for the workpiece. Thin walled profiles, including tubes and pipes require close tothing. At least 3-6 teeth should be in contact with the material while cutting. Large solid or transverse sections require widely spaced tothing to allow for greater volume of chips and better tooth penetration. Soft materials such as plastics, light alloys, mild bronze, Teflon, etc. require widely spaced tothing to avoid clogging.

S	Outer Diameter of the Tube (inch) / Tooth pitch						
Inches	0.787	1.574	2.362	3.15	4	4.724	6
0.079	14	14	14	14	14	14	10-14tpi
0.118	14	14	10-14tpi	10-14tpi	10-14tpi	10-14tpi	8-12tpi
0.157	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi
0.197	14	10-14tpi	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi
0.236	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi
0.315	14	10-14tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	6-10tpi
0.394		8-12tpi	6-10tpi	6-10tpi	6-10tpi	5-8tpi	5-8tpi
0.472		8-12tpi	6-10tpi	6-10tpi	5-8tpi	5-8tpi	4-6tpi
0.591		8-12tpi	6-10tpi	5-8tpi	5-8tpi	4-6tpi	4-6tpi
0.787			6-10tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi
1.181				4-6tpi	4-6tpi	4-6tpi	3-4tpi
2						3-4tpi	3-4tpi
3							
4							
6							

S= Wall Thickness

If you have to cut two or more tubes lying side by side please use this table in consideration of the double wall thickness (s).

Figure 8-1

9.0 Blade Care

The bandsaw blade is subjected to a tremendous amount of strain. Make sure to always use the appropriate feed rate for the type material you are cutting.

Be sure to select a blade of the proper width, style, and pitch that will produce the best cut in your material. Choosing the wrong blade can produce excess heat that can adversely affect the life of the blade.

A clean blade performs much better than one that is dirty. Blades that are gummed up and dirty offer more resistance when cutting through the material. This in turn creates unnecessary heat in the blade.

10.0 Blade Breakage

In some cases, blade breakage is unavoidable due to the stresses that are imparted on the blade. Avoidable breakage is often the result of poor care, or poor operator judgment when it comes to adjusting or mounting the blade or blade guides.

Listed below are some of the more common reasons for blade breakage.

- Top blade guide assembly is set too high above the piece part.
- The blade is tensioned incorrectly.
- Piece part is fed into the blade too quickly.
- Blade teeth are dull or broken.
- Blade is not properly aligned with the guides.

- Forcing a large width blade to cut a small radius.
- Using a blade with an improperly finished weld joint.
- Allowing the blade to run when not in use. (**NEVER** leave an unattended blade running.)

11.0 Adjustments, Lubrication and Maintenance

WARNING

Make sure the electrical disconnect is **OFF** before working on the machine.

Maintenance should be performed on a regular basis by qualified personnel.

Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.

Note: Proper maintenance can increase the life expectancy of your machine.

11.1 Angle Adjustment

Use the adjustable stop (A) to set the 0° position and (B) to set the 60° position.

The angle is measured between the blade and the back (stationary) plate of the vise.

1. Loosen the 0° stop bolt and pivot the stop plate (A) open to allow the swing arm full movement to the 0° position.
2. Open the vise as wide as possible and clean the vise and the side of the blade to get an accurate reading.
3. Place a square against the back of the vise and the side of the blade.

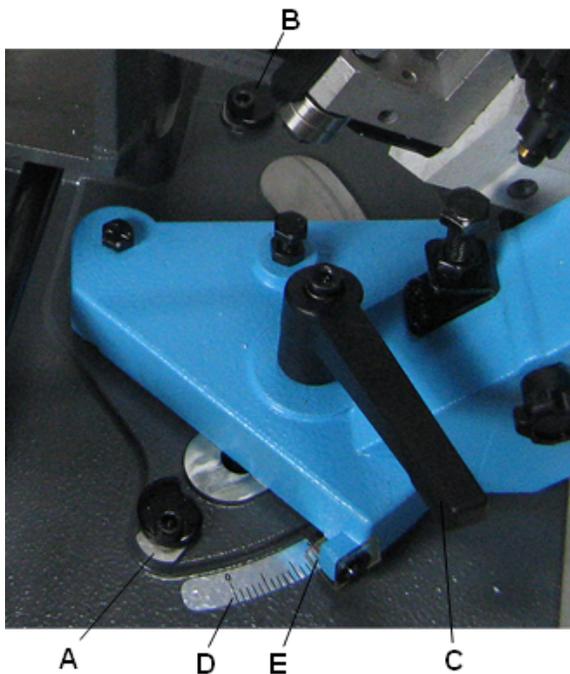


Figure 11-1

4. Loosen the lock handle (C) to release the swing arm and pivot the swing arm toward the 0° position until the blade is perfectly square to the vise.
5. Tighten the lock handle to lock the swing arm in position.
6. Pivot the stop plate (A) against the side of the swing arm and tighten the stop bolt.
7. Check the calibration of the indicator (D) to the 0° mark on the scale (E) by loosening the indicator and aligning it to the mark and then tightening the indicator.
8. Loosen the lock handle and pivot the swing arm to the 45° position and lock in place.
9. Adjust the 45° stop to contact the side of the swing arm when the indicator is over the 45° mark.
10. Both stops will now provide accurate positioning. Recheck this calibration as needed.

11.2 Adjusting Blade Guide

The blade guide has several functions to assist in providing a safe and accurate cut.

The guide bearings (A) provide stability to the blade. The side bearings hold the blade sides so that the blade is perpendicular to the material to be cut. This helps prevent the blade from twisting.

The top bearing provides back support for even down pressure.

The blade guard (B) is mounted with the guide assembly to travel with the guide and cover as much of the blade as possible to prevent accidental contact with the blade.

A ratcheting lock handle (C) is used to provide easy and quick adjustment of the blade guide.

Always keep the blade guide extended as far as possible. This will provide the most support to the cutting area of the blade. More importantly, it will reduce the amount of blade which is exposed to accidental contact.

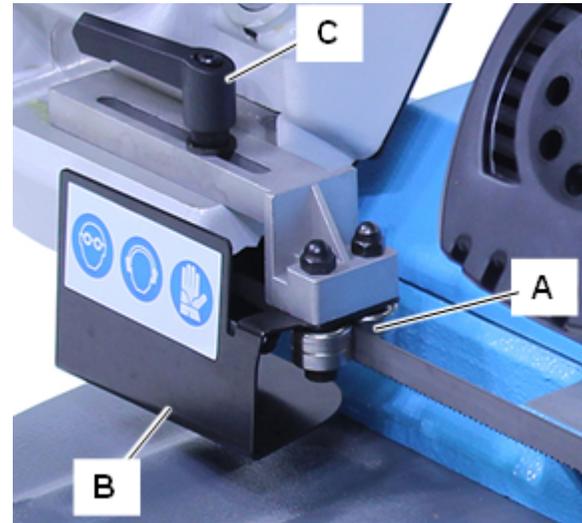


Figure 11-2

1. Loosen both the ratchet handle (C) to allow the blade guide to extend or retract as close to the material as possible without interfering with the material or the vise.
2. Tighten both the handle and the knob.

11.3 Blade Changing

⚠ WARNING

Make sure the electrical disconnect is OFF before working on the machine.

Saw blades are sharp. To prevent serious injury, wear a pair of heavy duty work gloves or use a thick shop towel to handle the loose blade.

⚠ CAUTION

Use care when handling the new blade as it may POP open unexpectedly and could cause injury.

1. Raise the saw bow to the up position.
2. Move the blade guide assembly to full extension.
3. Remove the blade guide guard by loosening the two acorn nuts enough to allow the guard to be removed.
4. Remove blade cover by loosening six screws on the saw frame.

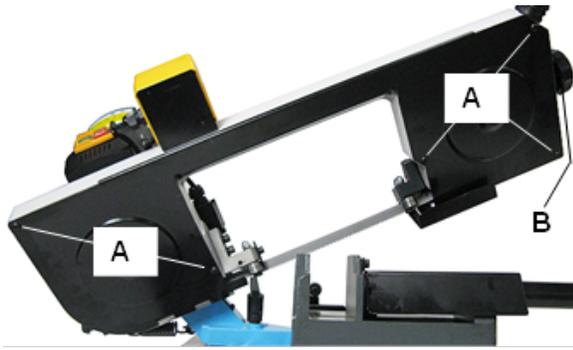


Figure 11-3

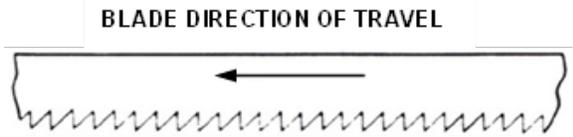


Figure 11-4

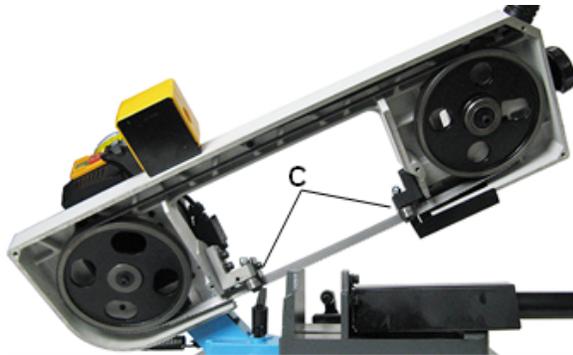


Figure 11-5

5. Loosen the blade tension wheel to allow the blade slip off idler wheel.
6. Remove blade from both wheels and blade guides bearings.
7. Orient the new blade so that the teeth are pointing down toward the cutting bed toward the stationary blade guide.
8. Place the blade on the wheels and twist the blade slightly to let it slip into each of guide bearings (C).
9. Turn the tension wheel (B) clockwise to tighten the blade tension. With the saw turned off fully retract the blade guide assembly. Press against the side of the blade to test the tautness of the blade. For ideal results with most blade widths and cutting applications, the blade should flex no more than 1/16" (1.5mm) to 1/8" (3.1mm).

CAUTION

NEVER operate the saw with the blade cover removed, loose or damaged. Failure to fully install an undamaged blade cover could result in serious injury.

10. Replace blade cover.

11. Start the machine to see that the blade runs and tracks properly.

11.4 Blade Guide Bearing Adjustment

IMPORTANT: This is the most important adjustment on your saw. It is impossible to get satisfactory work from your saw if the blade guides are not properly adjusted. Your Saw has been adjusted and power tested before leaving the factory to insure proper setting. If the guides do get out of adjustment, it is extremely important to re-adjust immediately. An improperly adjusted blade will not cut straight and serious blade damage may result. It is always best to try a new blade to see if this will correct poor cutting before beginning to adjust the blade guide bearings. If the blade becomes dull on one side and not the other, for example, it will begin cutting crooked. A blade change will correct this problem; the guide adjustment will not. If a new blade does not correct the problem, check the clearance between the blade and guides.

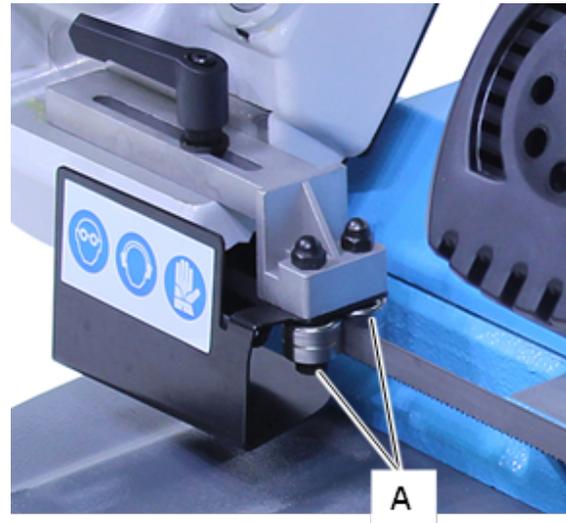


Figure 11-6

If the cut quality is poor, correct it as follows.

- Inspect the blade for wear and or broken teeth. If dull or worn, or if it is in any way broken or cracked, replace with a new blade.
 - The blade guides are ball bearings mounted on an eccentric shaft (A). This design allows for the bearings to provide side support and stability to the blade as it cuts. The guides should be adjusted evenly so the blade travels through them in a straight line and no one bearing set is pressing the blade out of line.
1. Loosen the acorn nuts slightly on the top of the eccentric shaft (A).
 2. Rotate the shafts in or out as needed until both side are in contact with the blade and holding it in a straight line pointed straight down.
 3. Tighten the acorn nuts evenly.

11.5 Stop Bolt Down Limit Adjustment

The down stop blot both limits the down travel of the saw blade as well as assists the bow lock pin to limit vibration during transport.

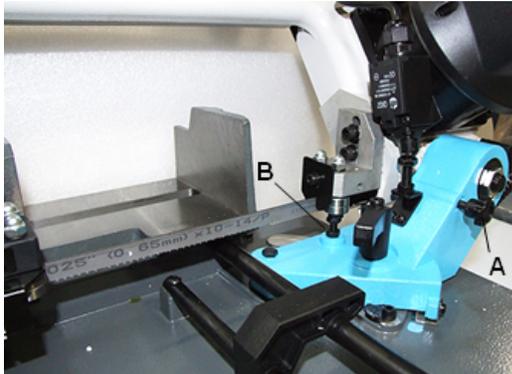


Figure 11-7

1. Lower the saw bow to the bottom/stowed position and engage the lock pin (A).
2. Adjust the down-feed stop bolt (B) so that it just contacts the stop plate, and then turn the stop bolt 1/4 turn down to create a slight gap.
3. Hold the bolt in position and tighten the jam nut.

11.6 Down Limit Switch Adjustment

⚠ WARNING

Make sure the power cord is unplugged before working on the machine.

The down limit switch is used to stop the motor/blade when the saw has reached to bottom of the bow travel and the cut has been completed.

1. Open the vise to full open.
2. Lower the saw bow to the bottom/stowed position.

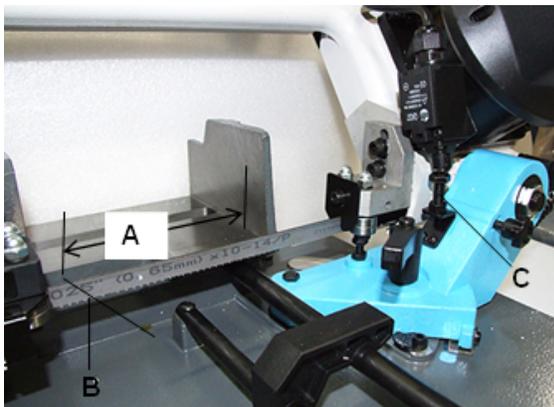


Figure 11-8

3. Measure out 5" (127mm) (A) from the vise back plate and then perpendicular to that line to the blade (B). This is point where the limit switch should engage and stop the blade.

4. Adjust the bolt (C) so that the contacts of the down limit switch open when the blade is at the measured position.
5. Hold the bolt in position and tighten the jam nut.

11.7 Changing Motor Brushes

If the motor is making an unusual noise then the motor brushes may need to be replaced.



Figure 11-9

1. Disconnect machine from power supply.
2. Remove two tap screws (A) connected with on/off switch's box, and three socket head screws (B) around cover base.

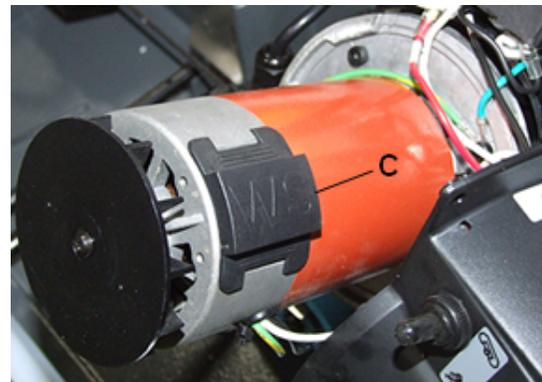


Figure 11-10

3. Remove the plastic brush covers (C).

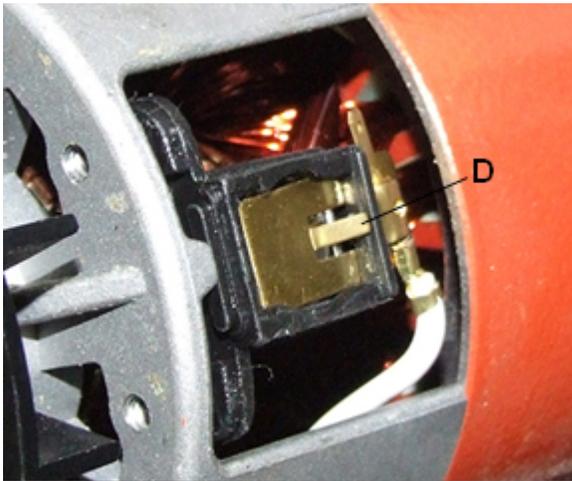


Figure 11-11

4. Carefully bend the lock tab (D) down and slide the copper brush retainer out of the brush holder.



Figure 11-12

5. The brush spring will pop out.
6. Remove the brushes from the brush holder.

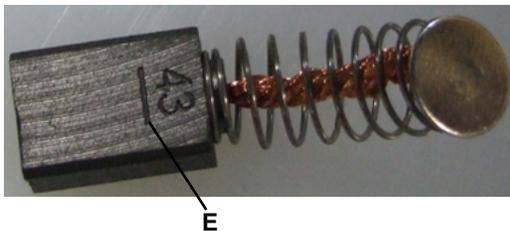


Figure 11-13

7. Replace the brushes when either brush is worn down to the wear mark (E) molded in to the side of the brush.
8. When replacing the brushes, both brushes must be replaced at the same time.
9. Reassemble the motor in reverse order.

11.8 Motor Safety Protection

IMPORTANT: To avoid motor damage, this motor should be blown out or vacuumed frequently to keep sawdust from interfering with normal motor ventilation.

1. Connect this tool with a fuse or circuit breaker. Using the wrong size fuse can damage the motor.
2. If the motor does not start, press the stop button down immediately. **UNPLUG THE TOOL.** Check the saw blade to make sure it turns freely. If the blade is free, try to start the motor again.
3. If the motor still does not start that have to check the motor's carbon brushes which can be used 600-800 hours if carbon brushes has been worn, please change the new one.
4. If the motor suddenly stalls while cutting material, press the stop button off, unplug the tool, and free the blade from the steel. Then you may restart the motor and finish the cut.
5. Fuses may "blow" or circuit breakers may trip frequently if:
 - a. Motor is overloaded-overloading can occur if you feed too rapidly or make too many start/stops in a short time.
 - b. Voltage not more than 10% above or below the nameplate voltage can handle normal loads. For heavy loads, however, the voltage (caused by a small size wire in the supply circuit or an overly long supply circuit wire) may drop too low for the motor to operate. Always check the connections, the load and the supply circuit whenever motor does not work well. Check wire sizes and length with the Wire Size Chart.
6. Most motor troubles may be trace too loose, or incorrect connections, overload, low voltage (such as small size wire in the supply circuit) or to overly long supply circuit wire. Always check the connections, the load and the supply circuit whenever motor doesn't work well. Check wire size and length with the Wire Size Chart.

12.0 Operation

CAUTION

Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.

NEVER operate saw without blade guards in place.

12.1 Vise and Work Set Up

1. Raise saw bow to the up position.
2. Turn the handle (A) counter-clockwise to open the vise jaw to load work material.
3. Load the material into the vise making sure that is seated against the bottom and back of the vise. Use additional supports as needed to support long material.



Figure 12-1

Note: If the to be cut does not set flat on the vise base without tipping, it should be supported with additional support.

4. Turn the handle (A) clockwise to close the vise jaw to clamp the work piece.

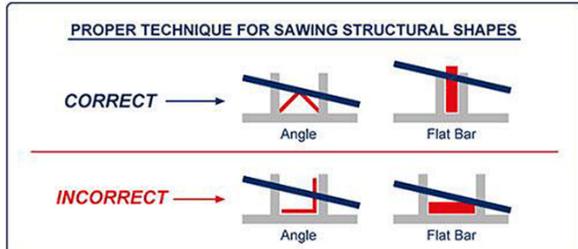


Figure 12-2

12.2 Lock Pin

The lock pin is used to lock the saw bow in the stowed position. During cutting operations, the pin is released so that the bow may move up and down for cutting.

1. Pull out on the lock pin (A) and rotate 90° hold the pin in the unlocked position.
2. Pull out and turn 90° so that the cross pin engages in the casting and allows the lock pin to return to the locked position.
3. Verify that the pin has engaged the bow locking hole (B) during transport.

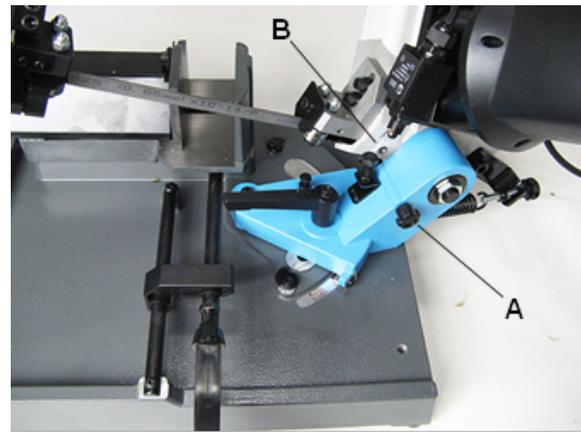


Figure 12-3

12.3 Manual Cutting

1. With the saw bow down in the carry position, tighten the tension spring nut (A) to approximately the one third to half way down the adjustment bolt from the thumb knob.
2. Unlock and raise the saw bow to the up position.
3. Insert and align the material to be cut to the desired cut length and secure with the vise. Check and be certain that the saw blade is not in contact with anything.

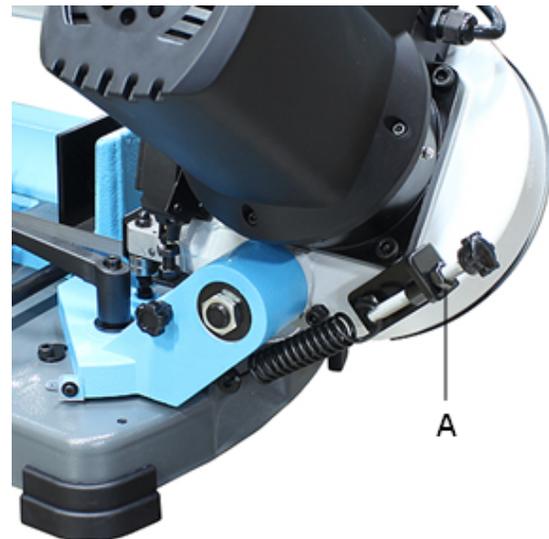


Figure 12-4

4. Place the selector toggle switch (B) in the down position for manual operation.
5. Set the blade speed dial (C) to the speed needed for the material being cut. Use the chart on the motor cover as a guide.
6. Check that the emergency stop button (D) is in the Reset/On position.

Note: This is also a good time to remind yourself of the location of the emergency stop button so that it is within reach at all times.

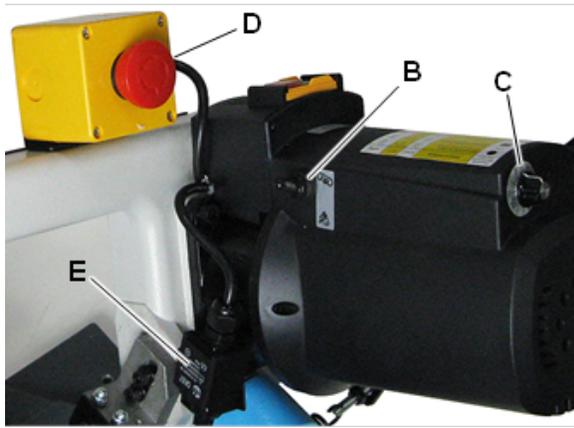


Figure 12-5

7. Recheck that the saw blade is not contacting anything, grasp the trigger handle and squeeze the trigger switch to start the saw and allow the motor to come to full speed.
8. Perform the cut by pulling down smoothly and firmly on the trigger handle. Observe the sound and feel of the saw while the blade is cutting. Adjust how much down force is being applied by these clues as well as the evenness and consistency of the chips.
9. When the cut is complete and the bow has reached the bottom of the stroke, the limit switch (E) will become engaged and stop the power to the motor. DO NOT touch the material until the blade has come to full stop.
10. Raise the bow to the up position.

IMPORTANT: It is advised to press the emergency stop button when not cutter to prevent unintentional startup.

11. Remove the cut material and remove or reposition the remaining material for the next cut and repeat the process. Clean and remove the saw chips after each cut to allow for better and more accurate operation of the saw.

12.4 Auto Cutting

1. With the saw bow down in the carry position, tighten the tension spring nut (A) to not more than one quarter way down the adjustment bolt from the thumb knob.
2. Unlock and raise the saw bow to the up position.
3. Insert and align the material to be cut to the desired cut length and secure with the vise. Check and be certain that the saw blade is not in contact with anything.



Figure 12-6

4. Place the selector toggle switch (B) in the up position for auto operation.
5. Set the blade speed dial (C) to the speed needed for the material being cut. Use the chart on the motor cover as a guide.
6. Check that the emergency stop button (D) is in the Reset/On position.

Note: This is also a good time to remind yourself of the location of the emergency stop button so that it is within reach at all times.

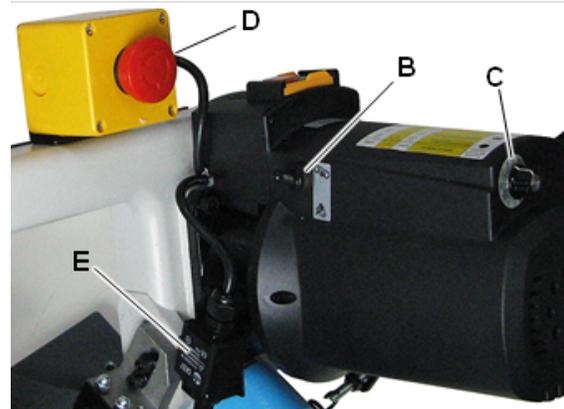


Figure 12-7

7. To perform the cut, recheck that the saw blade is not contacting anything.
8. Press the green start button to start the saw and allow the motor to come to full speed.
9. Carefully lower the saw blade onto the material. When the blade has contacted the material the bow may be released to allow the weight of the saw bow to complete the cut. Observe the sound and feel of the saw while the blade is cutting. Adjust how much down force is being applied by these clues as well as the evenness and consistency of the chips.

10. When the cut is complete and the bow has reached the bottom of the stroke, the limit switch (E) will become engaged and stop the power to the motor. DO NOT touch the material until the blade has come to full stop.
11. Raise the bow to the up position.

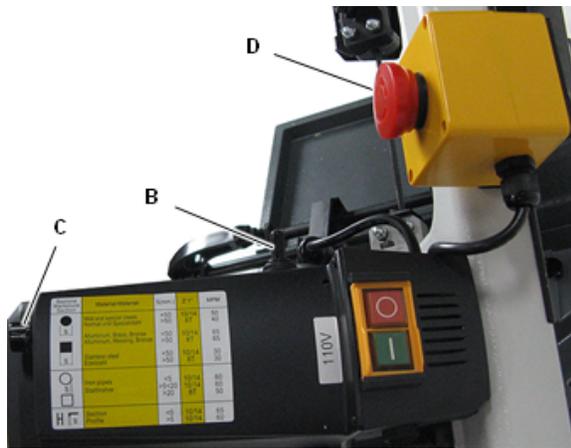


Figure 12-8

IMPORTANT: It is advised to press the emergency stop button when not cutting to prevent unintentional startup.

12. Remove the cut material and remove or reposition the remaining material for the next cut and repeat the process. Clean and remove the saw chips after each cut to allow for better and more accurate operation of the saw.

12.5 Angle Cutting

The machine uses a swivel miter base for angle cutting from 0 - 60 degree. Align the indicator (A) mounting on the swing arm to the scale (B) mounting on the base to read the angle.

1. Loosen the lock handle (C) to allow the swing arm to pivot to the desired angle.
2. When the desired angle is indicated on the scale, hold the swing arm in position and tighten the lock handle.

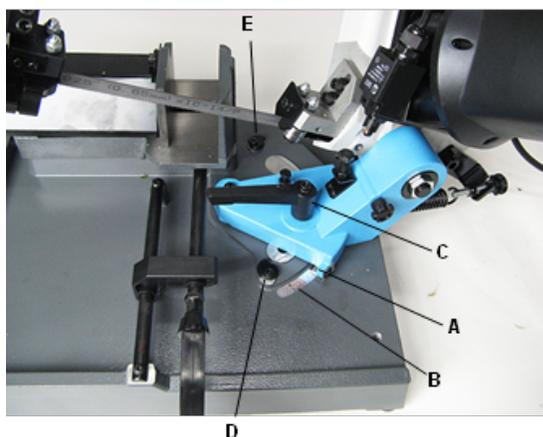


Figure 12-9

Note: The lock handle is a ratchet design which allows the handle to be lifted to slip on the bolt and position the handle away from the blade preventing damage.

13.0 Material Selection

⚠ CAUTION

It must be determined by the customer that materials being processed through the machine are NOT potentially hazardous to operator or personnel working nearby.

When selecting materials keep these instructions in mind:

- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same vendor when possible.

14.0 Replacement Parts

14.1.1 Saw Base Assembly – Exploded View

SECTION A – Parts List

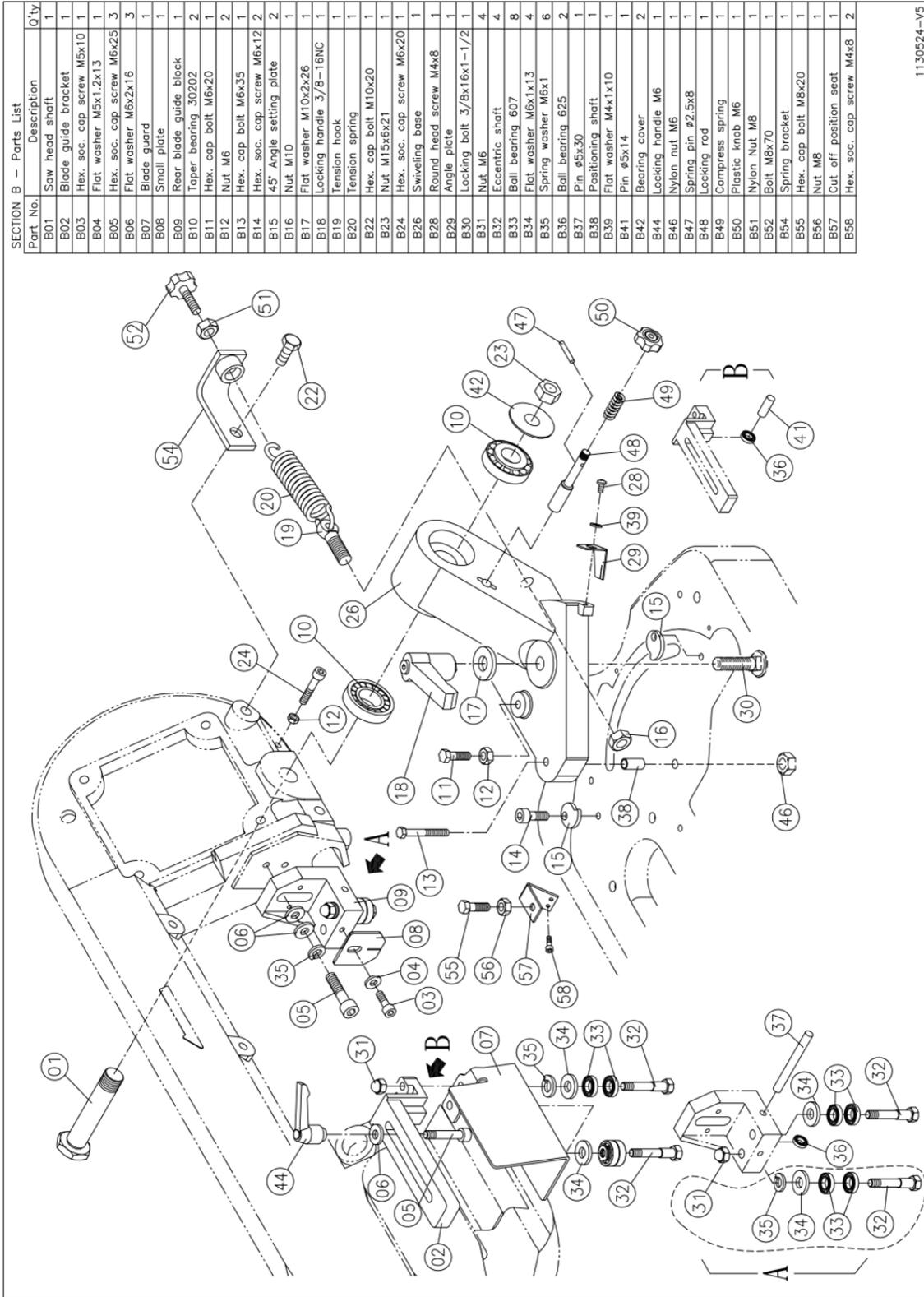
Part No.	Description	Q'ty
A01	Nut M6	2
A02	Tension handle	1
A03	Handle base	1
A04	Lead screw	1
A05	Bushing	1
A06	Vise table	1
A07	Movable vise	1
A08	E Ring E-9	1
A09	Table base	1
A10	Rubber stands	4
A11	Hex. soc. cap screw M8x16	6
A12	T Block	1
A13	Hex. soc. cap screw M6x20	1
A15	Scale	1
A17	Spring pin $\phi 5 \times 25$	1
A18	Vise plate	1
A19	Flat head screw M6x12	2
A20	Spring pin $\phi 5 \times 16$	2
A21	Plastic stopper	1
A22	Length rod	1
A23	Set screw M5x5	1
A24	Hex. cap bolt M6x20	1
A25	Nut M6	1
A26	Hex. cap bolt M8x30	1
A27	Nut M8	1

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14.1.2 Saw Base Assembly – Parts List

Index No	Part No	Description	Size	Qty
A01	BS127P1-A01	Nut	M6	2
A02	BS127P1-A02	Tension Handle		1
A03	BS127P1-A03	Handle Base		1
A04	BS127P1-A04	Lead Screw		1
A05	BS127P1-A05	Bushing		1
A06	BS127P1-A06	Vise Table		1
A07	BS127P1-A07	Moveable Vise		1
A08	BS127P1-A08	E-Ring	E-9	1
A09	BS127P1-A09	Table Base		1
A10	BA9-1224867	Rubber Feet		4
A11	CM9-TS-1504031	Hex Socket Head Cap Screw	M8 x 16	6
A12	BA9-1232616	T-Block		1
A13	JT9-TS-1503051	Hex Socket Head Cap Screw	M6 x 20	1
A15	BA9-1224868	Scale		1
A17	BS127P1-A17	Spring Pin	Ø5 x 25	1
A18	BS127P1-A18	Vise Plate		1
A19	BS127P1-A19	Flat Head Screw	M6 x 12	2
A20	BS127P1-A20	Spring Pin	Ø5 x 16	2
A21	BA9-1224869	Plastic Stopper		1
A22	BA9-1224870	Length Rod		1
A23	BS127P1-A23	Set Screw	M5 x 5	1
A24	JT9-TS-1482041	Hex Cap Bolt	M6 x 20	1
A25	BS127P1-A25	Nut	M6	1
A26	JT9-TS-1490051	Hex Cap Bolt	M8 x 30	1
A27	BA9-1224874	Nut	M8	1

14.1.3 Saw Bow Assembly B – Exploded View



11.30524-V5

14.1.4 Saw Bow Assembly B – Parts List

Index No	Part No	Description	Size	Qty
B01	BA1-900	Saw Head Shaft		1
B02	BA1-901	Blade Guide Bracket		1
B03	JT9-TS-1502021	Hex Socket Head Cap Screw	M5 x 10	1
B04	BA1-902	Flat Washer	M5 x 1.2 x 13	1
B05	CM9-TS-1503061	Hex Socket Head Cap Screw	M6 x 25	3
B06	BA1-903	Flat Washer	M6 x 2 x 16	3
B07	BA1-904	Blade Guard		1
B08	BA1-905	Small Plate		1
B09	BA1-906	Rear Blade Guide Block		1
B10	BA1-907	Taper Bearing	30202	2
B11	JT9-TS-1482041	Hex Cap Bolt	M6 x 20	1
B12	BA1-908	Nut	M6	2
B13	JT9-TS-1482071	Hex Cap Bolt	M6 x 35	1
B14	CM9-TS-1503031	Hex Socket Head Cap Screw	M6 x 12	2
B15	BA1-909	0° - 60° Angle Setting Plate		2
B16	BA1-910	Nut	M10	1
B17	BA1-911	Flat Washer	M10 x 2 x 26	1
B18	BA1-912	Locking Handle	3/8-16NC	1
B19	BA1-913	Tension Hook		1
B20	BA1-914	Tension Spring		1
B22	JT9-TS-1491021	Hex Cap Bolt	M10 x 20	1
B23	BA1-915	Nut	M15 x 6 x 21	1
B24	JT9-TS-1503051	Hex Socket Head Cap Screw	M6 x 20	1
B26	BA1-916	Swivel Base		1
B28	BA1-918	Round Head Screw	M4 x 8	1
B29	BA1-919	Angle Plate		1
B30	BA1-920	Locking Bolt	3/8 x 16 x 1-1/2"	1
B31	BA1-917	Nut	M6	4
	BS127P1-B32A	Eccentric Shaft Kit (including B31~B35)		1
B32	BA1-921	Eccentric Shaft		4
B33	BB-607	Ball Bearing	607	8
B34	BA1-922	Flat Washer	M6 x 1 x 13	4
B35	BA1-923	Spring Washer	M6 x 1	6
B36	BB-625	Ball Bearing	625	2
B37	BA1-1730	Pin	Ø5 x 30	1
B38	BA9-1230331	Positioning Shaft		1
B39	BA1-924	Flat Washer	M4 x 1 x 10	1
B41	BS127P1-B41	Pin	Ø5 x 14	1
B42	BA1-925	Bearing Cover		2
B44	BA1-926	Locking Handle	M6	1
B46	BA1-928	Nylon Nut	M6	1
B47	BS127P1-B47	Spring Pin	Ø2.5 x 8	1
B48	BA1-929	Locking Rod		1
B49	BA1-930	Compress Spring		1
B50	BA1-931	Plastic Knob	M6	1
B51	BA9-1023060	Nylon Nut	M8	1
B52	BA9-1023061	Bolt	M8 x 70	1
B54	BA1-935	Spring Bracket		1
B55	JT9-TS-1490031	Hex Cap Bolt	M8 x 20	1
B56	BA1-936	Nut	M8	1
B57	BA1-937	Cut Off Position Seat		1
B58	BA1-927	Hex Socket Head Cap Screw	M4 x 8	2

14.1.5 Saw Bow Assembly C – Exploded View

SECTION C – Parts List

Parts No.	Description	Qty
C62	Round head screw M4x25	2
C63	Round head screw M5x8	2
C64	Limit switch bracket	1
C65	Limit switch	1
C66	Toggle switch	1
C72	Oil Nipple 1/4x28T	1
C01	Big round head screw M5x8	6
C03	Blade cover	1
C04	Blade	1
C05	Flat head hex. soc. screw M6x16	1
C06	Flat washer M6x25x2	1
C07	Rear blade wheel	1
C08	Saw head	1
C09	C Ring S15	1
C10	Ball bearing 6202	3
C12	Output gear	1
C13	Key 4x4x20	1
C14	Key 5x5x10	1
C15	Rear wheel shaft	1
C16	C Ring R32	1
C17	Motor shell	1
C18	Ball bearing 607	2
C19	C Ring S11	1
C20	Connect gear	1
C21	Key 4x4x6	1
C22	Motor gear	1
C23	Hex. soc. cap screw M8x25	4
C24	Gear case	1
C25	Disc washer	8
C26	Tension bolt	1
C27	Slider guide	2
C28	Hex. soc. cap screw M6x25	2
C29	Slider	1
C30	Front wheel shaft	1
C31	Ball bearing 6201	2
C32	Front wheel	1
C33	Flat head screw M8x16	1
C34	Hex. soc. cap screw M4x12	3
C35	Hex. soc. cap screw M5x10	4
C36	Top screw M3x15	2
C38	Motor	1
C39	Motor front cover	1
C40	Hex. soc. cap screw M5x20	4
C41	IC control board	1
C43	Spacer 1/2x1.2x19	4
C44	Power cable	1
C45	Speed scale	1
C46	Speed knob	1
C47	Carbon brush	2
C48	Brush cover	2
C49	Set screw M6x10	1
C50	Wire fastener PG-9	1
C51	Magnetic contactor	1
C52	Switch cover	1
C55	Round head screw M4x50L	4
C56	Emergency switch box	1
C57	Emergency switch	1
C58	Wire fastener PG-9	1
C59	Round head screw M4x8	2
C60	Bracket	1
C61	Round head screw M4x8	2

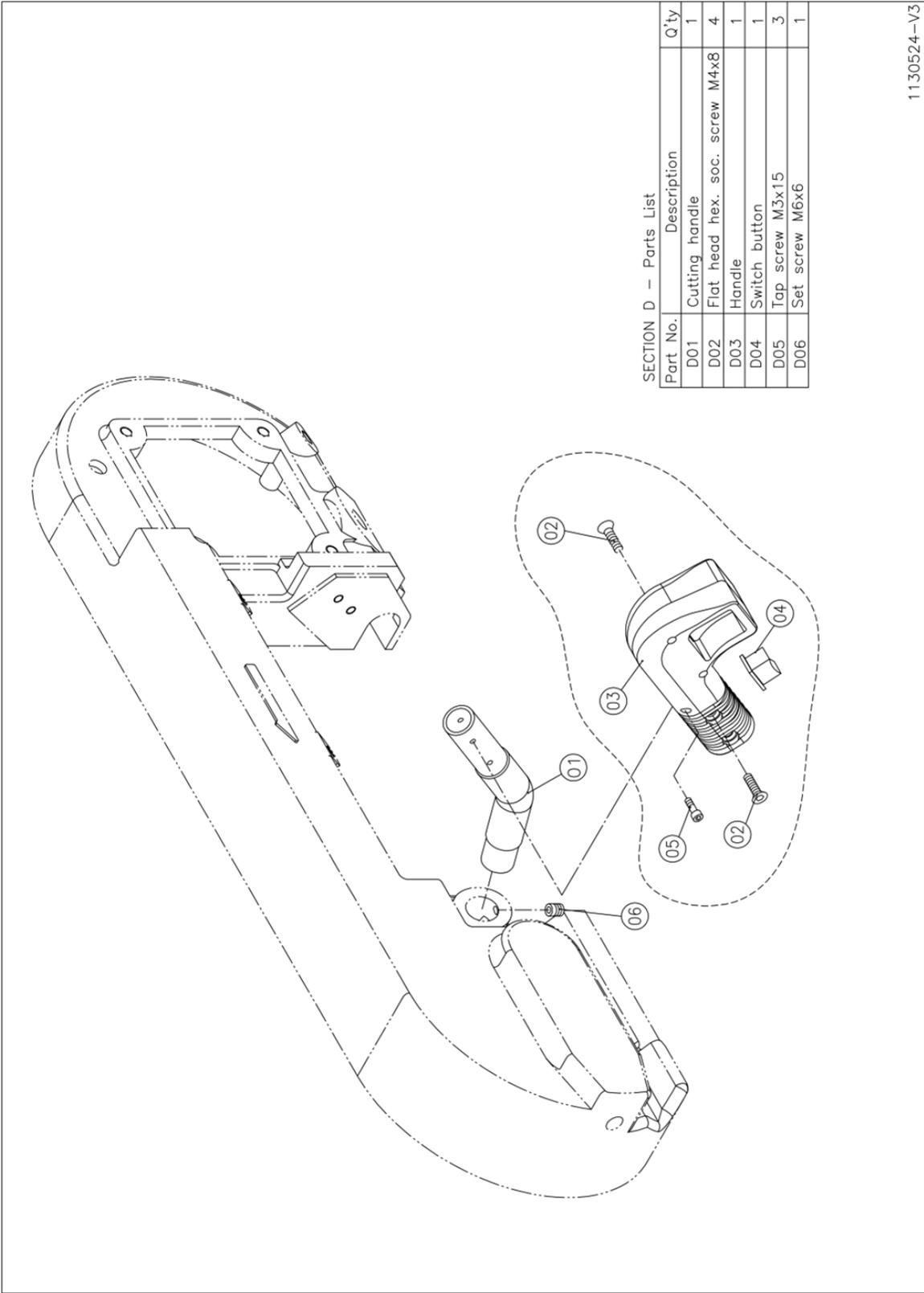
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14.1.6 Saw Bow Assembly C – Parts List

Index No	Part No	Description	Size	Qty
C01	BS127P1-C01	Large Round Head Screw	M5 x 8	6
C03	BA9-1228433	Blade Cover		1
C04	BS127P1-C04	Blade	13×0.65×1440mm	
			HSS 10/14T	1
C05	BS127P1-C05	Flat Head Hex Socket Screw	M6 x 16	1
C06	BS127P1-C06	Flat Washer	M6 x 25 x 2	1
C07	BA1-64	Rear Blade Wheel		1
C08	BA9-1226872	Saw Head		1
C09	BS127P1-C09	C-Ring	S15	1
C10	JT9-BB-6202	Ball Bearing	6202	3
C12A	BS127P1-C12A	Ball Bearing +Output Gear+Key+Rear Wheel Shaft assembly		1
C12	BS127P1-C12	Output Gear		1
C13	BS127P1-C13	Key	4 x 4 x 20	1
C14	BS127P1-C14	Key	5 x 5 x 10	1
C15	BS127P1-C15	Rear Wheel Shaft		1
C16	BS127P1-C16	C-Ring	R32	1
C17	BA9-1227961	Motor Shell		1
C22A	BS127P1-C22A	Motor Gear assembly		1
C18	BB-607	Ball Bearing	607	2
C19	BS127P1-C19	C-Ring	S11	1
C20	BS127P1-C20	Connect Gear		1
C21	BS127P1-C21	Key	4 x 4 x 6	1
C22	BS127P1-C22	Motor Gear		1
C23	JT9-TS-1504051	Hex Socket Head Socket Screw	M8 x 25	4
C24	BS127P1-C24	Gear Case		1
C25	BA9-1023062	Disc Washer		8
C26	BA9-1023063	Tension Bolt		1
C27	BS127P1-C27	Slider Guide		2
C28	CM9-TS-1503061	Hex Socket Head Cap Screw	M6 x 25	2
C29	BS127P1-C29	Slider		1
C30	BS127P1-C30	Front Wheel Shaft		1
C31	JT9-BB-6201	Ball Bearing	6201	2
C32	BA9-1232761	Front Wheel		1
C33	BS127P1-C33	Flat Head Screw	M8 x 16	1
C34	CM9-TS-1501041	Hex Socket Head Cap Screw	M4 x 12	3
C35	JT9-TS-1502021	Hex Socket Head Cap Screw	M5 x 10	4
C36	BS127P1-C36	Tap Screw	M3 x 15	2
C38A	BA1-3195	Motor Kit (including C10, C38,C39,C47,C48)		
C38	BA1-3196	Motor		1
C39	BS127P1-C39	Motor Front Cover		1
C40	JT9-TS-1502051	Hex Socket Head Cap Screw	M5 x 20	4
C41	BA1-3198	IC Control Board		1
C43	BS127P1-C43	Spacer	1/2 x 1.2 x 19	4
C44	BS127P1-C44	Power Cable		1
C45	BS127P1-C45	Speed Scale		1
C46	BS127P1-C46	Speed Knob		1
C47A	BA1-3203	Carbon Brush+Brush Cover		2
C48	BS127P1-C48	Brush Cover		2
C49	BS127P1-C49	Set Screw	M6 x 10	1
C50	BS127P1-C50	Wire Fastener	PG-9	1
C51	BA1-3206	Magnetic Contactor		1
C52	BS127P1-C52	Switch Cover		1
C56A	BA1-3208	Emergency Switch assembly		1
C55	BS127P1-C55	Round Head Screw	M4 x 50L	4
C56	BS127P1-C56	Emergency Switch Box		1
C57	BS127P1-C57	Emergency Switch		1
C58	BS127P1-C58	Wire Fastener	PG-9	1
C59	BS127P1-C59	Round Head Screw	M4 x 8	2

Index No	Part No	Description	Size	Qty
C60.....	BS127P1-C60	Bracket		1
C61.....	BS127P1-C61	Round Head Screw	M4 x 8	2
C62.....	BS127P1-C62	Round Head Screw	M4 x 25	2
C63.....	BS127P1-C63	Round Head Screw	M5 x 8	2
C64.....	BS127P1-C64	Limit Switch Bracket		1
C65.....	BS127P1-C65	Limit Switch		1
C66.....	BA9-1226958	Toggle Switch		1
C72.....	BS127P1-C72	Grease Fitting	1/4 x 28T	1

14.1.7 Saw Trigger Handle D – Exploded View



SECTION D – Parts List

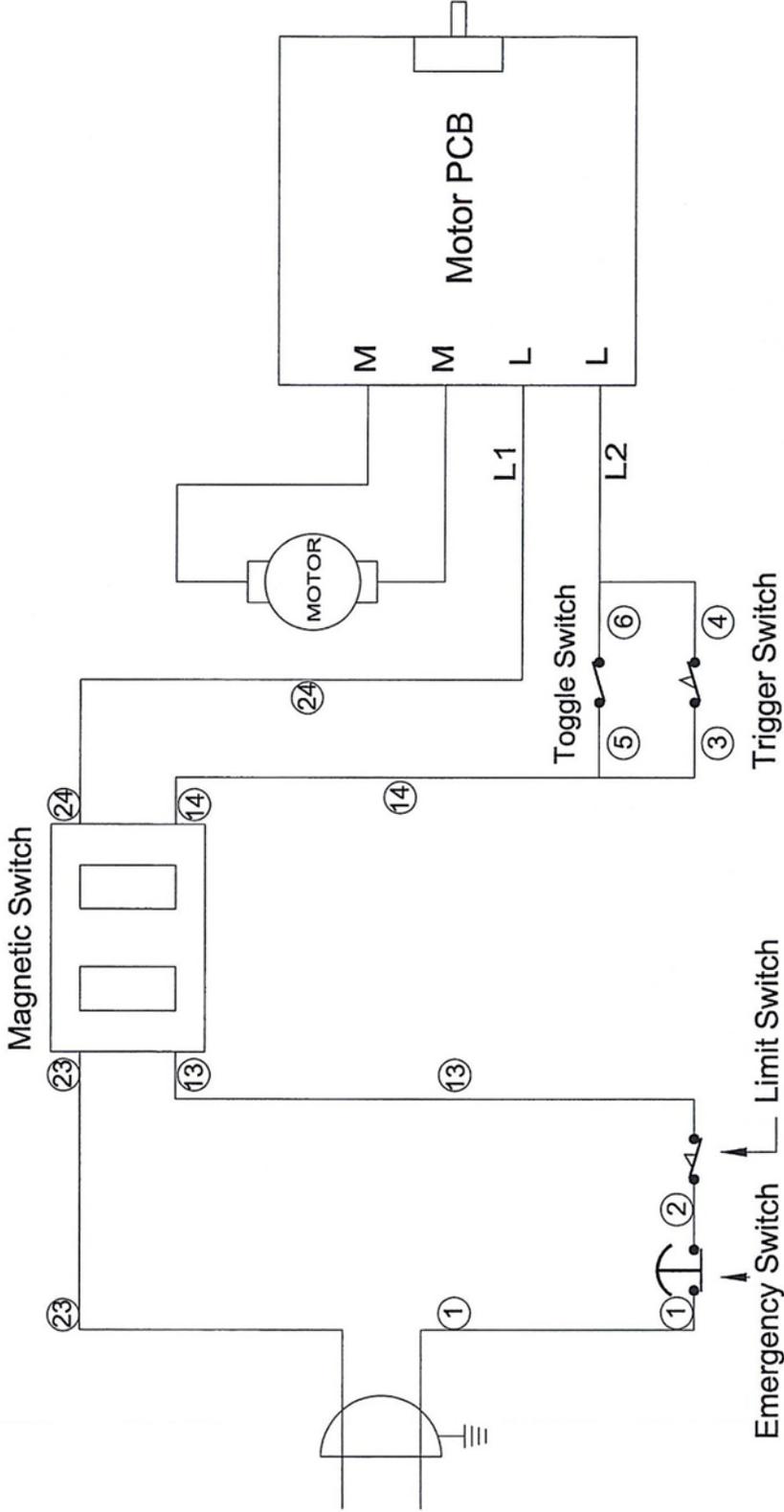
Part No.	Description	Qty
D01	Cutting handle	1
D02	Flat head hex. soc. screw M4x8	4
D03	Handle	1
D04	Switch button	1
D05	Tap screw M3x15	3
D06	Set screw M6x6	1

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14.1.8 Saw Trigger Handle D – Parts List

Index No	Part No	Description	Size	Qty
D01	BA1-3217	Cutting Handle		1
D02	BS127P1-D02	Flat Head Hex Socket Screw	M4 x 8	4
D03	BS127P1-D03	Handle		1
D04	BS127P1-D04	Switch Button		1
D04A	BA9-1225297	Handle assembly		1
D05	BS127P1-D05	Tap Screw	M3 x 15	3
D06	BS127P1-D06	Set Screw	M6 x 6	1

15.0 Wiring Diagram



16.0 Warranty and Service

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the Goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any Goods to Seller. Goods returned without an RGA will be refused. Seller will not be responsible for any freight costs, damages to Goods, or any other costs or liabilities pertaining to Goods returned without an RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, **specifications**, or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain an RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without an RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY, OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.

Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightning, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation, or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy:

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh Industrial issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh Industrial in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing, and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at Baileigh-Service@jpwindustries.com



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