



# Operating Instructions and Parts Manual

## Horizontal Band Saw

Model BS-260M



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BA9-1001432  
Edition 3 07/2025  
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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 protection. Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.
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:**

**⚠ CAUTION**

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

**⚠ WARNING**

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

**⚠ DANGER**

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-260M Horizontal 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](http://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 Product Identification

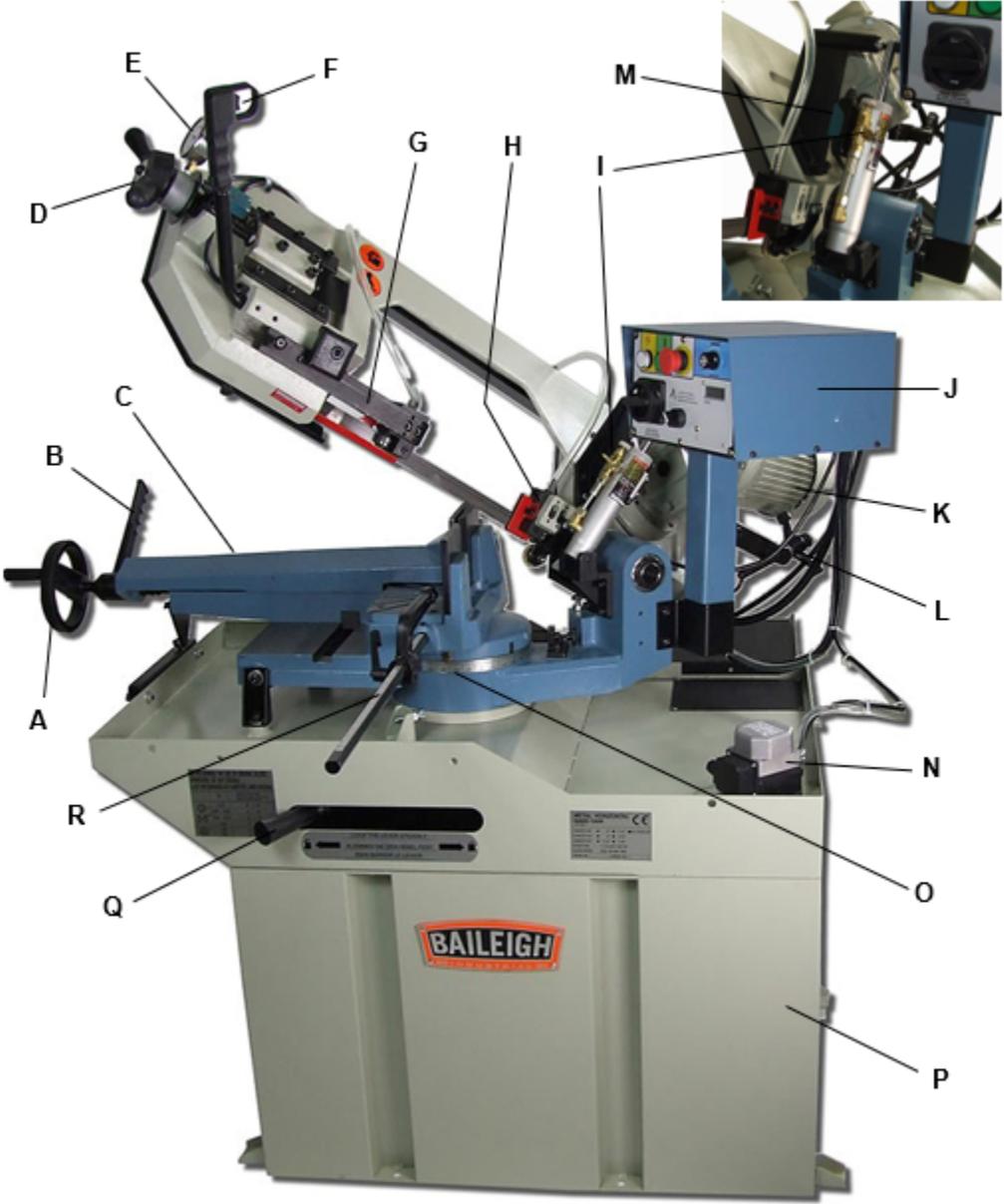


Figure 4-1

Table 4-1

Item	Description	Function
A	Vise Hand Wheel	Turning hand-wheel opens and closes vise
B	Vise Lever	To quickly clamp and unclamp material
C	Vise	Holds front and rear jaws for clamping
D	Blade Tension Hand Wheel	For applying and releasing blade tension
E	Blade Tension Gauge	Reads tension in Kgs/cm <sup>2</sup>
F	Trigger Switch	For starting saw motor in manual mode
G	Blade Adjustment Assembly	Adjusts front end of blade
H	Blade Adjustment Assembly	Adjusts rear end of blade
I	Ball / Control Valve	Starts and stops the blade descent. Controls descent speed
J	Control Box	Houses the operator controls
K	Motor/Gearbox	Drives the saw blade
L	Spring Adjustment Knob	Sets spring tension
M	Micro Switch	Shuts off saw when finished cutting
N	Coolant Pump	Recirculates blade coolant
O	Angle Indicator	Shows angular cutting degrees
P	Saw Stand	Supports the saw assembly
Q	Miter Lock Lever	Tightens and loosens table to set angles
R	Stop Rod Assembly	For setting the length of cut



Figure 4-2

1. Power Indicator Light: (Lights “white” when power is on).
2. Start Pushbutton: (Starts saw motor in Auto mode).
3. E-Stop Pushbutton: (Saw can be stopped immediately by pressing the red mushroom cap button) Twist the button clockwise (cw) to reset. Resetting the E-Stop will not start the saw.
4. Speed Control: (Sets blade speed from 20-85 mpm) Has an OFF position to shut off power.
5. Main Disconnect Switch: (Turns power ON to the saw) Can be locked out in the OFF position for Safety or Security.
6. 2-Position Mode Switch: (Selects between auto mode, clockwise (cw) and trigger control, counterclockwise (ccw)).
7. Blade Speed Display: Indicates the approximate speed of the blade in MPM (meters per minute).

#### 4.1 Machine Base

After assembly, the machine base becomes the structure that supports the saw bow, the vise, the coolant pump, the bar stop, the swing arm, and the roller for supporting material.



Figure 4-3

#### 4.2 Quick Clamp Vise

Place the piece part between the vise jaws and have it rest next to the fixed vise jaw. Rotate the hand wheel (A) clockwise (cw) to close the front jaw onto the piece and tighten. Rotate the hand wheel counterclockwise (ccw) to release. Vise lever (B) can be used to quickly lock and release the piece part by allowing a small gap between the vise and part. Then rotate lever (B) counterclockwise (ccw) to lock and clockwise (cw) to release.

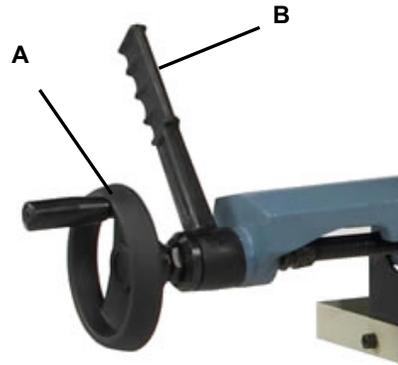


Figure 4-4

#### 4.3 Swivel Saw Head

Angles can be cut up to 60° (Right) with the vise behind the blade and 45° (Left) with vise in front of the blade. Unlock the rotating saw head by pushing the miter lock lever (R) to the left and by unlocking the stop pin (W).

Rotate the saw head to the desired angle as shown on the angle indicator (Q).

Lock the saw head by pushing the lock lever (R) to the right (as shown). Note: Pin (W) has stops at 0° & 45° (Right)



Figure 4-5

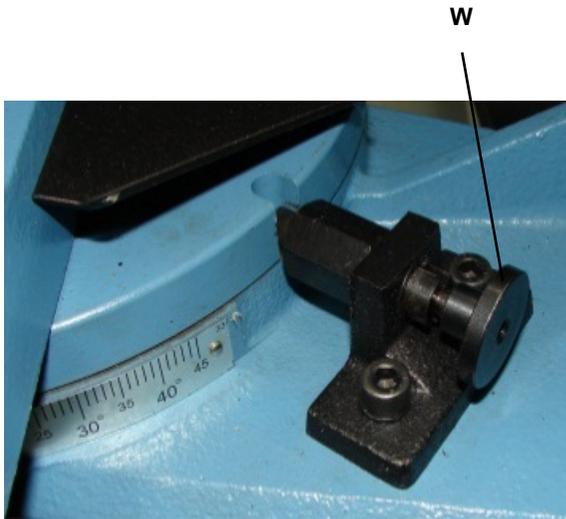


Figure 4-6

**IMPORTANT:** Check that the saw blade clears all parts of the vise assembly before cutting. The blade can strike parts of the assembly (especially during miter cuts) if not properly adjusted. Make sure saw bow is in a down or horizontal position when moving or mitering to avoid tipping over machine.

#### 4.4 Positioning the Vise

1. To move the vise in either direction, it must be unlocked at two points.
2. Release the track support by turning handle (S) counterclockwise (ccw).
3. Release the vise by moving the lever (T) to the left.
4. The vise (C) may now be moved to the left position or the right position by pushing it with one hand on the vise and the other hand on the track handle (S).

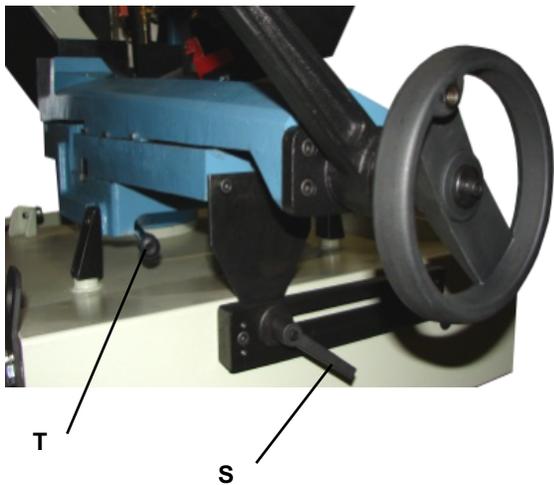
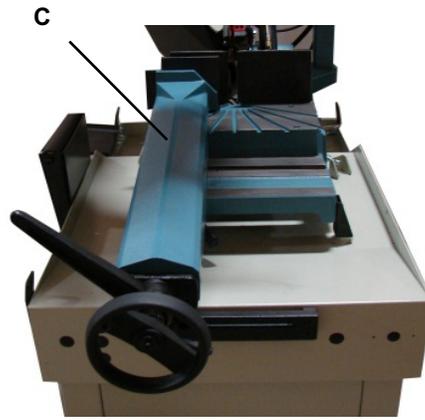
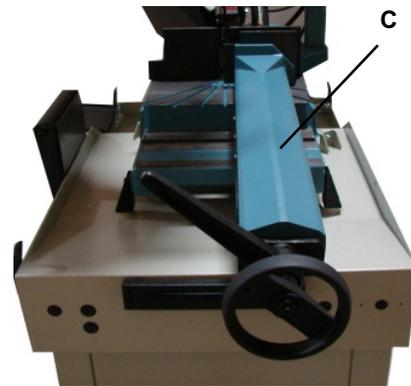


Figure 4-7



Behind Blade (Left)



In Front of Blade (Right)

Figure 4-8

**IMPORTANT:** Do not attempt a 90° cut with vise in front of (Right) the blade. You will damage the front jaw.

5. Once in position, move the lever (T) to the right to lock the vise. If the lever is not between the vise/bed mounts and facing the operator, the vise will not be able to lock. If the vise lever has gone beyond or is obstructed by a mount, correct with the following procedure:
6. Adjust lever (T) by grasping the pivot hub (V) and pulling down. Rotate the handle into a more suitable position. Some movement of the vise may be required.
7. Release the lever hub and rotate the handle to the right to lock.
8. Lock the track support handle (S) by turning clockwise (cw).

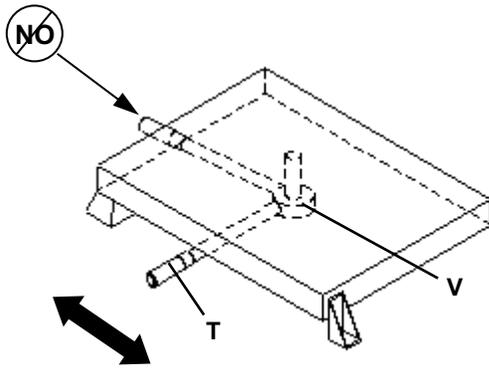


Figure 4-9

#### 4.5 Return Stroke Limiting Device

A hydraulic cylinder is used to control the drop rate of the saw bow. The hydraulic cylinder is ideal when cutting thin walled or stainless steel sections as they require a constant drop rate to achieve a fine cut edge.

When the saw is not in use, the bow should be stored in the down position to remove pressure from the cylinder.

To use, turn the flow control valve knob to lightly closed the valve.

Place the ball valve in the up (open) position.

Open the flow control valve knob until the desired drop rate is achieved.

Use the ball valve to stop and start the bow drop to maintain the set drop rate.

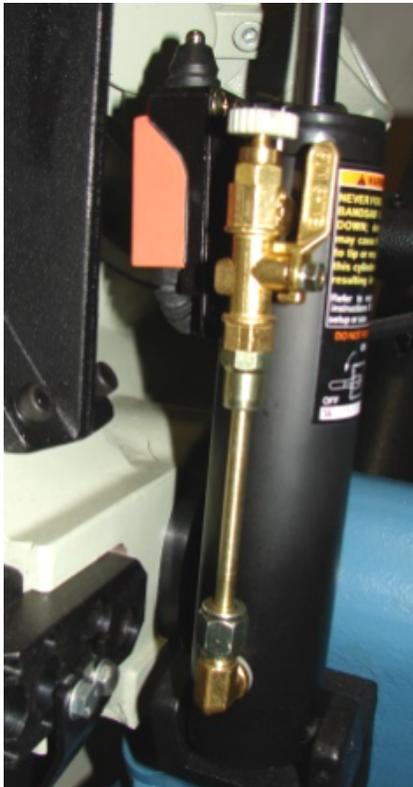


Figure 4-10

#### 4.6 Support Roller

A device that helps support longer sized material. The roller assists stock moving through the vise. It is adjustable by loosening (2) hex bolts.



Figure 4-11

#### 4.7 Stop Rod Assembly

The stop rod is used when cutting duplicate parts thus eliminating the need to measure each piece. The stop rod may be installed and removed as needed and is functional for lengths up to 20" (610mm).



Figure 4-12

## 4.8 Overall Dimensions

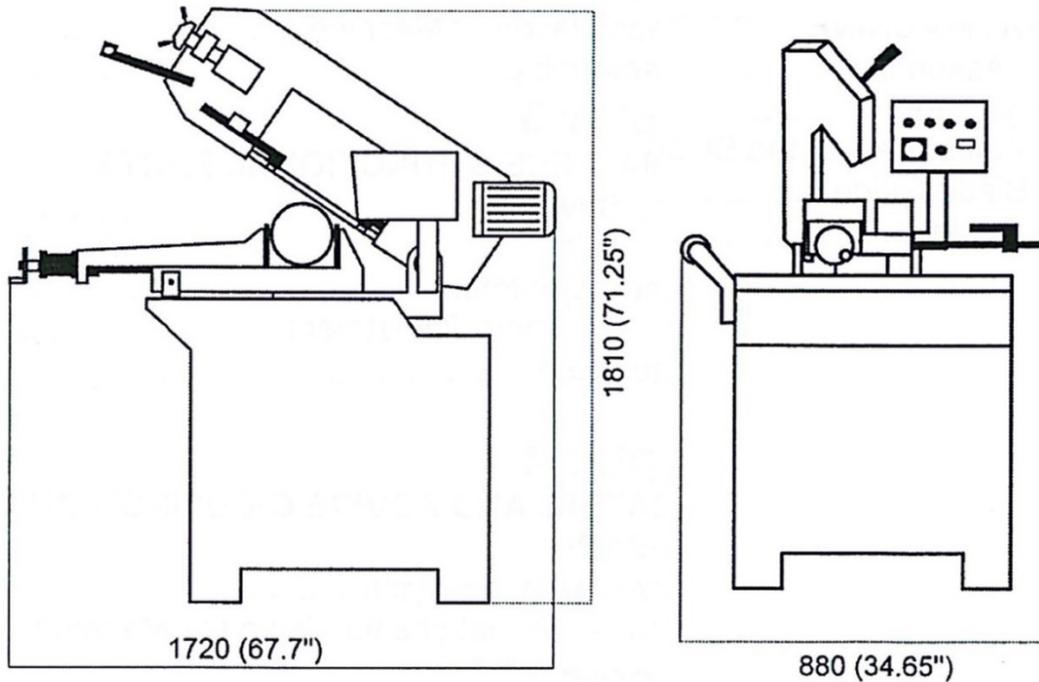


Figure 4-13

## 5.0 Specifications

Table 5-1

Model number	BS-260M
Stock number	BA9-1001432
<b>Motor and Power</b>	
Power Input	220V, 60Hz, 1-Phase
Main Motor	220V, 60hz, 3Ph, 4.7A, 1.1kw, 1720rpm
Coolant Pump	220V, 60Hz, 1Ph, .2A, 32W, 2800rpm
<b>General Specifications</b>	
Capacity Rectangular 90° / 45° / 45°L	10.25" x 4.13" / 6.1" x 2.75" / 6.3" x 1.77" (260 x 105mm / 155 x 70mm / 160 x 45mm)
Capacity Round 90° x 45° / 60° / 45°L	8.66" / 5.9" / 3.5" / 5.31" (220 / 150 / 90 / 135mm)
Capacity Square 90° x 45° / 60° / 45°L	8.46" / 5.7" / 3.34" / 4.33" (215 / 145 / 85 / 110mm)
Return	Manual
Miter Adjustment	Swivel Head
Miter Angle	0 – 60°, 45°L
Blade Size (H x T x L)	1" x .035" x 96.85" (27 x .9 x 2460mm)
Blade Speed	66 – 280fpm (20 – 85mpm) Variable
Blade Guide	Carbide x Roller
Table Height	35" (889mm)
Drive	Gear
Descent Control	Closed Circuit Hydraulic
Coolant Capacity	4.25gal (16.5L)
<b>Weights and Dimensions</b>	
Shipping Weight	792lbs (360kgs)
Shipping Dimensions	61" x 29" x 36.25" (1549 x 737 x 921mm)

## ⚠ WARNING

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

## 6.0 Setup and Assembly

### 6.1 Unpacking and Checking Contents

Your Baileigh Industrial 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.

## ⚠ 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.

### 6.2 Cleaning

## ⚠ 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.

## 6.3 Transporting and Lifting

## NOTICE

Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.

Follow these guidelines when lifting with truck or trolley:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a forklift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.

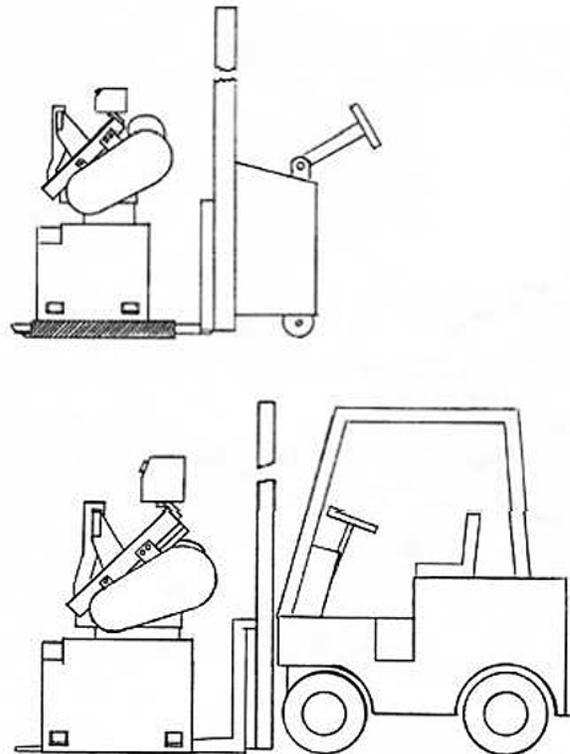


Figure 6-1

**Follow these guidelines when lifting crane or hoist:**

- Always lift and carry the machine with the lifting holes provided at the top of the machine.
- Use lift equipment such as straps, chains, capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, then lower slowly until it touches the floor.

## 6.4 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, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This machine distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level 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.

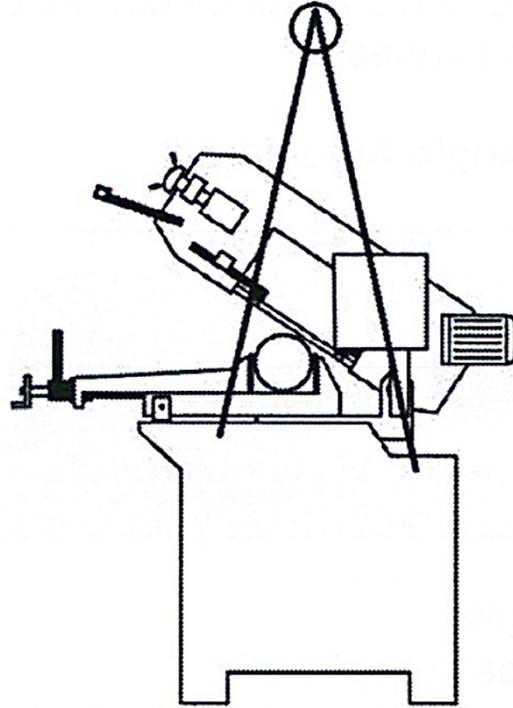


Figure 6-2

### 6.4.1 Anchoring the Machine

- Once positioned, anchor the machine to the floor, as shown in the diagram. Use bolts and expansion plugs or sunken tie rods that connect through and are sized for the holes in the base of the stand.
- This machine requires a solid floor such as concrete at a minimum of 4" (102mm) thick. 6" (153mm) minimum is preferred.

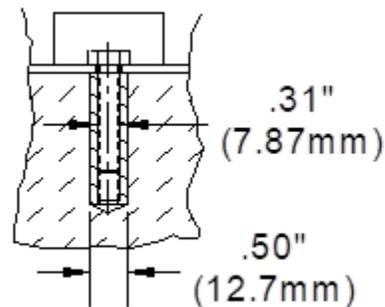


Figure 6-3

## 6.5 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.

1. Attach electrical control box (A) to the pedestal (B) with (4) hex socket cap screws.
2. Assemble the stand as shown in the diagram. Make sure all nuts and bolts are properly tightened.
3. Use a sling capable of lifting 500 lbs. (min.) and make sure the load is properly balanced. Pick up the saw and carefully set it onto the stand and bolt together.
4. Install the material roller onto the back side of the saw table.
5. Install the material stop rod (C) into the front side of the vise table and secure in place with the set screw.
6. Add coolant as desired following the coolant instructions in the maintenance section.
7. Check that the blade and blade guides are installed and adjusted correctly before placing the saw in service.

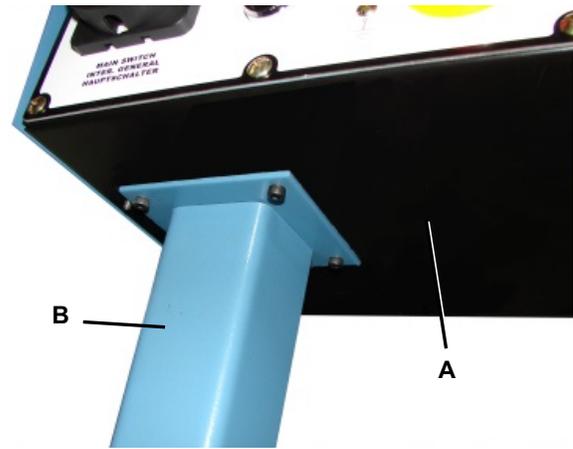


Figure 6-4

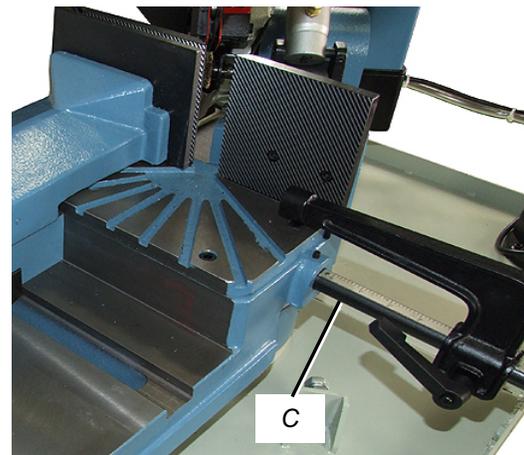


Figure 6-5

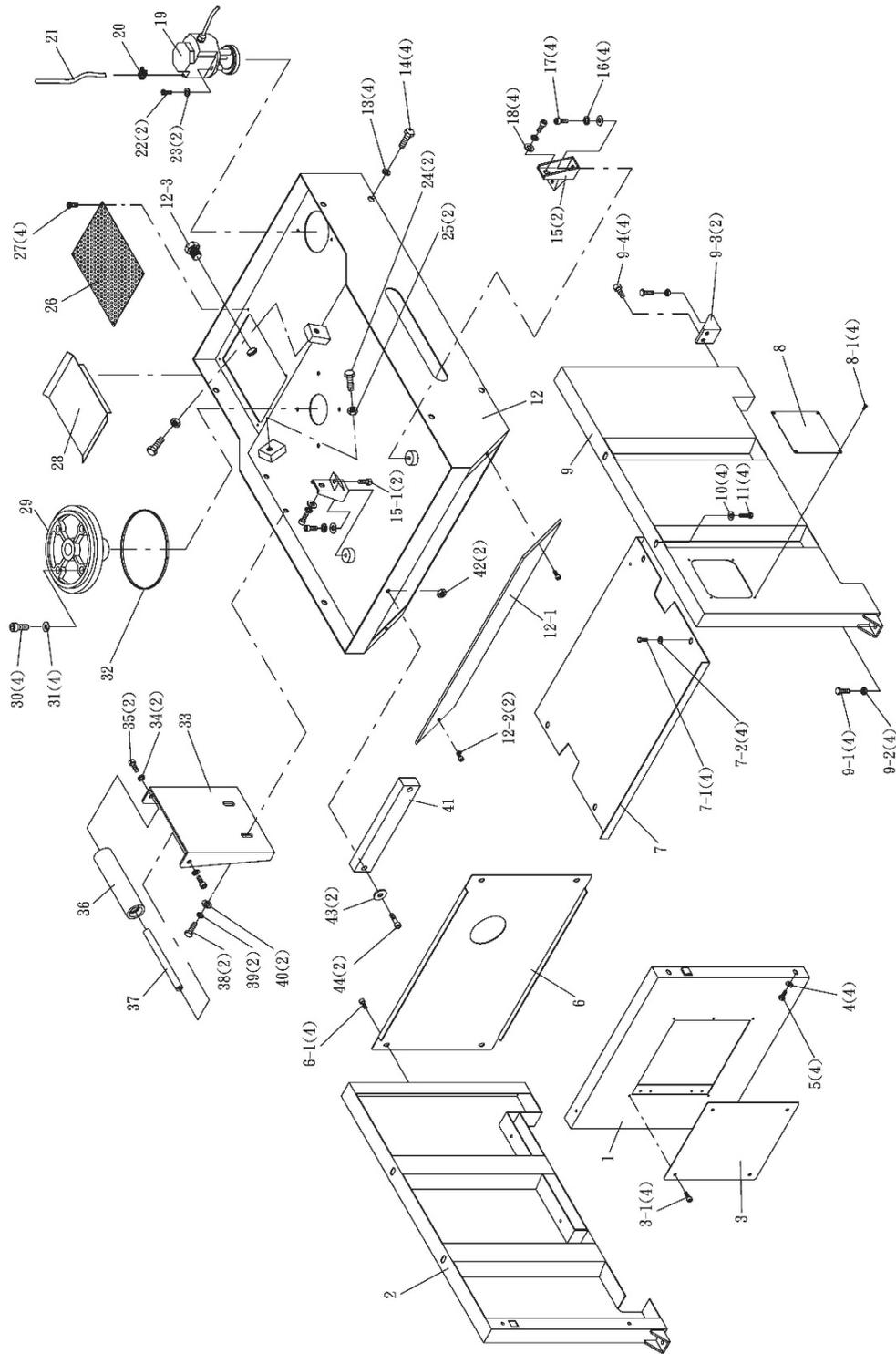


Figure 6-6

**Note:** Saw Bow and swivel assembly shown removed for clarity.

## 7.0 Electrical Connections

### **⚠ 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.

### 7.1 Power Specifications

Your machine is wired for 220 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  $\pm 1\%$ .

### 7.2 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 receptable in question is properly grounded. If you are not sure, have a qualified electrician check the receptable.

- 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 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.

### 7.3 Extension Cord Safety

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

Table 7-1

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.

### 7.4 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 table toward the power supply.
  - a. Route the power cord so that it will NOT become entangled in the saw bow, saw blade, or counterbalance assembly in any way.
  - b. Route the cord to the power supply is 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 saw blade is clear of any obstruction and raised up off of the limit switch. The main disconnect may be turn ON to test the saw operation. Turn the main disconnect to OFF when the saw is not in operation.

## 8.0 Adjustments

### **⚠ WARNING**

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

### **⚠ WARNING**

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

### 8.1 Replacing the Saw Blade

Wear gloves when handling the saw blade.

1. Raise the saw bow.
2. Remove the front blade guard (X) and the (4) knobs (Y) holding on the main blade guard. (Carefully pull out the tongue from the safety interlock switch)

#### BLADE DIRECTION OF TRAVEL

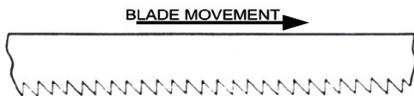


Figure 8-1

3. Loosen the saw blade with the tension hand wheel (D) and remove it from the flywheels and the blade guide blocks.
4. Assemble the new blade by placing it first between the guide blocks and then on the face of the flywheels. (note blade direction)
5. Tension the blade, making sure it seats properly on the flywheels.
6. Reassemble the front blade guide (X) and the main blade guard (Z), making sure the switch tongue engages the switch or the saw will not start.

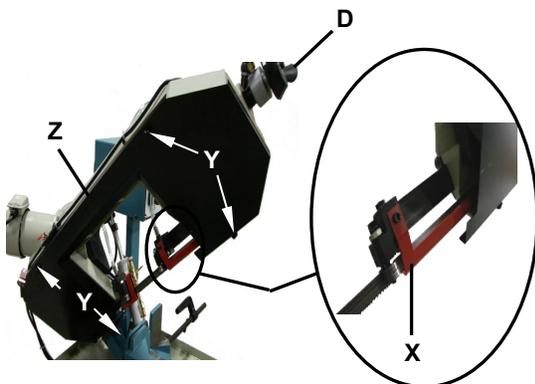


Figure 8-2

### 8.2 Setting Blade Tension

Blade tension is important to the proper operation of the saw. Correct blade tension is 1200 kg/cm<sup>2</sup> as measured on the saws tension gauge.

Turning the handwheel (D) clockwise (cw) will increase the tension. Counterclockwise (ccw) will decrease tension of the saw blade.



Figure 8-3

### 8.3 Blade Breakage

If the saw is running and the blade breaks, micro switch (U) will trip and shut down all machine functions. As long as the replacement blade duplicates the saws original blade specifications the switch should not have to be adjusted.



Figure 8-4

### 8.4 Adjusting the Blade Tracking

The flywheels alignment may need some adjustment to allow the saw blade to track correctly. Improper flywheel alignment can cause damage to the saw blade or cause it to ride off the blade wheel bearings.

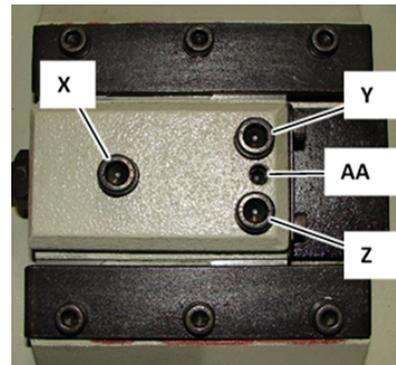


Figure 8-5

1. Disconnect power from the saw.
2. Raise the saw bow to a usable work height.
3. Loosen the hex socket cap screws (X, Y, & Z).

4. Use an Allen wrench on setscrew (AA) to adjust the tilt of the flywheel. make the distance between the flywheel and the back of blade are approximately 0.012"~0.019" (0.30~0.50mm), as shown.
5. Turning the setscrew (AA) clockwise (cw) will tilt flywheel so that the blade will ride closer to the flange.
6. Turning the setscrew (AA) counterclockwise (ccw) will tilt the flywheel so that the blade will ride away from the flange. (If it rides too far away it will come off).
7. After the adjustment is finished, tighten the socket cap screws in this order: (X, Y, & Z).

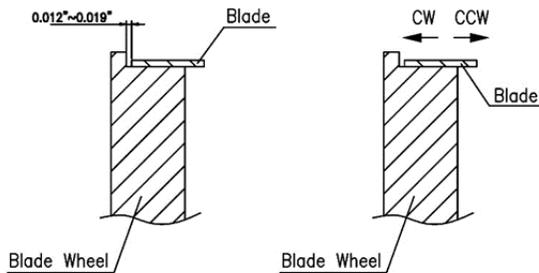


Figure 8-6

## 8.5 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 Baileigh Industrial Band 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.

1. Disconnect power from the saw.
2. Loosen nut (AK), screw (AJ), and loosen dowel (AL) which widens the gap between the pads.
3. Loosen the nuts (AP) and the dowels (AQ) and then rotate the pins (AM) and (AO) to widen the gap between the bearings (AN).

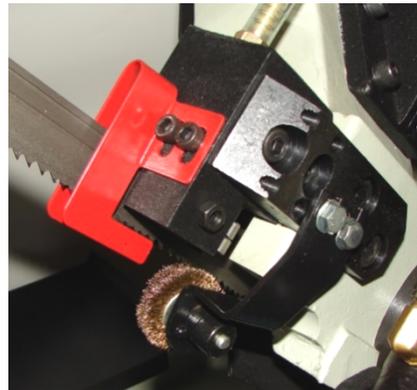


Figure 8-7

4. To mount the new blade, place the pad (AI) on the blade. Loosen the dowel and allow a distance of .001" for the sliding of the blade. Lock the nut and screw (AJ). Rotate the pins (AM) and (AO) until the bearings rest lightly against the blade and then secure the dowels (AQ) and nuts (AP).
5. Make sure that between the blade and the upper teeth of the pad (AH) there is at least .008" - .011" (2-3mm) of play. If necessary, loosen the screws that fasten the blocks and adjust accordingly.

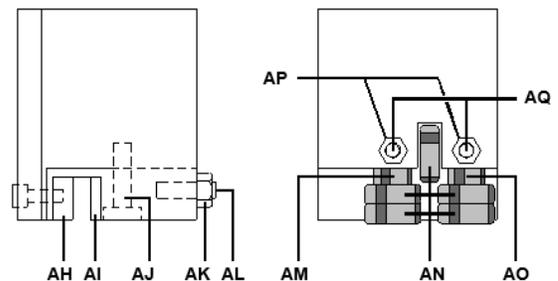


Figure 8-8

## 8.6 Adjusting the Blade Guide

1. Disconnect power from the saw.
2. Release the extension bar for the blade guide block by loosening socket cap screw (AC) counterclockwise (ccw) and freeing up the clamping block (AD).
3. Hold the handle (AB) and slide the blade guide block as close as possible to the piece part without interfering with the cut.
4. Tighten socket screw (AC) clockwise (cw).

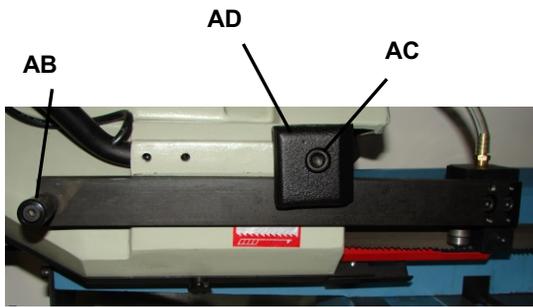


Figure 8-9

## 8.7 Adjusting the Angle Stops

Check the travel limits of the saw head.

Verify that the left limit is set to give a cut of 45°.

The right limit is set to give a cut of 60°.

Adjust the stop bolts (A) as needed to produce the correct cut angle.

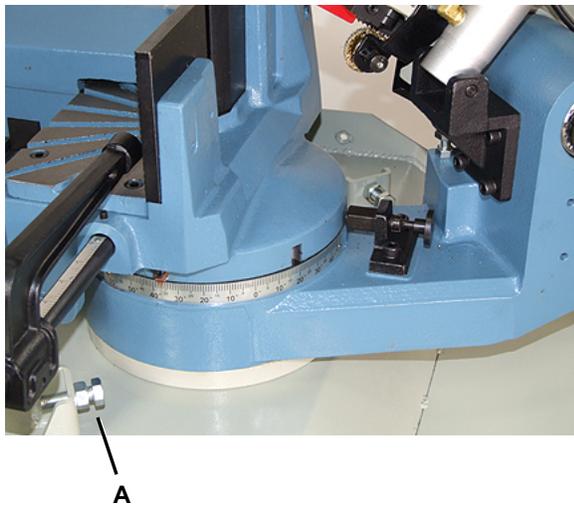


Figure 8-10

## 9.0 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, and 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 powerhead 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.

## 9.1 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.

## 9.2 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 300cm<sup>2</sup> 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.

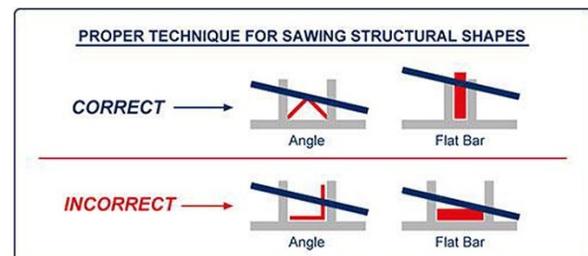


Figure 9-1

### 9.3 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.

### 9.4 Blade Terminology

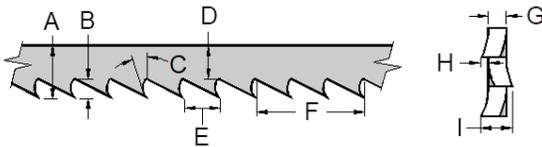


Figure 9-2

Table 9-1

Item	Description	Function
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.

### 9.5 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.

### 9.6 Length of Blade

The length of the band saw blade can be measured with a tape measure at its 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.

### 9.7 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 is 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.

### 9.8 Blade Type

They differ essentially in their constructive characteristics, such as:

- Shape and cutting angle of tooth
- Pitch
- Set

Shape and angle of tooth

**REGULAR TOOTH:** 0° rake and constant pitch.



Figure 9-3

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° - 10° positive rake and constant pitch.

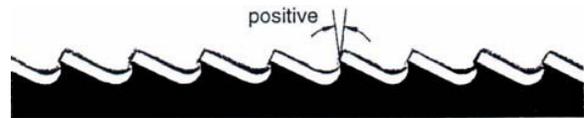


Figure 9-4

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.

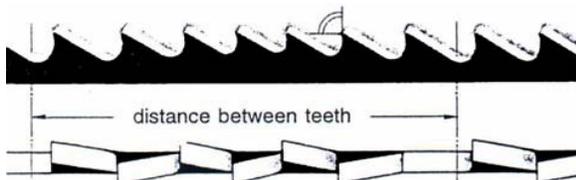


Figure 9-5

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° - 10° positive rake.

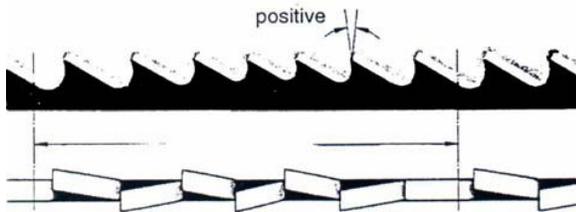


Figure 9-6

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.

## 9.9 Sets

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

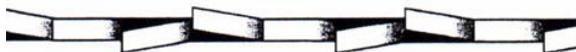


Figure 9-7

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

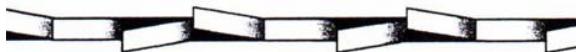


Figure 9-8

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 9-9

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 9-10

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 9-11

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

## 10.0 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 of 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.

### 10.1 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 toothing. At least 3-6 teeth should be in contact with the material while cutting. Large solid or transverse sections require widely spaced toothing 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 toothing to avoid clogging.

S	Outer Diameter of the Tube (inch) / Tooth pitch																
	0.787	1.574	2.362	3.15	4	4.724	6	7.873	11.811	15.75	19.685	23.621	27.5	31.5	35.5	39.5	59
0.079	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.118	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.157	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.197	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.236	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.315	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.394	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.472	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.591	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.787	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
1.181	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
2	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
3	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
4	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
6	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
7.873	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
9.842	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
11.81	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
13.778	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
15.747	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
17.716	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
19.685	14	14	10-14tpi	10-14tpi	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi

Figure 10-1

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).

## 11.0 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.)

## 12.0 Operation

### ⚠ CAUTION

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

### ⚠ CAUTION

When handling large heavy materials make sure they are properly supported.

### ⚠ CAUTION

NEVER operate saw without blade guards in place.

## 12.1 Manual Operation

1. Close the handle on the hydraulic ball valve (I) by turning it counterclockwise (ccw).
2. Turn the flow control knob (AO) clockwise (cw) to shut off the hydraulic flow. This will prevent the saw bow from dropping when the ball valve is opened.
3. Reduce the bow weight. Rotate the wing nut (AP) clockwise (cw) to increase the tension on the spring.
4. Load piece part and clamp securely.
5. Turn the main switch (5) to "ON". Check to see that the indicator light (1) is lit.
6. Set the blade speed with control knob (4).
7. Set switch (6) to manual mode for trigger operation.
8. While firmly holding the control handle of the saw bow, open ball valve (I) clockwise (cw).
9. Fully open the flow control knob (AO) counterclockwise (ccw).
10. Squeeze the start trigger to energize the blade motor and lower saw bow to begin cutting.
11. When the saw bow reaches bottom limit, the micro switch (M) is actuated and shuts off the saw motor.
12. Return the saw bow to its start position and close ball valve (I).

- Unclamp and reset the piece part to continue the next cutting cycle.



Figure 12-1

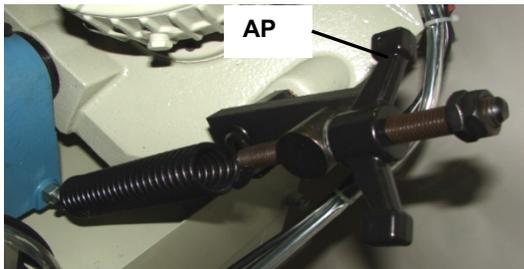


Figure 12-2

**IMPORTANT:** If an emergency situation should occur: Press the emergency STOP button (3) to immediately shut off all functions of the saw.



Figure 12-3

## 12.2 Auto Mode Operation

- Close the handle on the hydraulic ball valve (I) by turning it counterclockwise (ccw).
- Turn the flow control knob (AO) clockwise (cw) to shut off the hydraulic flow. This will prevent the saw bow from dropping when the ball valve is opened.
- Increase the bow weight. Rotate the wing nut (AP) counterclockwise (ccw) to decrease the tension on the spring.
- Load piece part and clamp securely.
- Turn the main switch (5) to "ON". (Check to see that indicator light (1) is lit)
- Set the blade speed with control knob (4)
- Set switch (6) clockwise (cw) to auto mode for hydraulic cylinder operation.
- Press the green start button (2). The saw motor and the coolant pump motor should both start.
- Open the ball valve (I) clockwise (cw).
- Turn the flow control knob (AO) clockwise (cw) to slow down the descent or counterclockwise (ccw) to speed it up.
- When saw bow reaches bottom limit, micro switch (M) is actuated and shuts off the saw and pump motors.
- Grasp the control handle and lift the saw bow to a height slightly above the piece part to minimize the next cut entry time.
- Close ball valve (I).
- Unclamp and reset the piece part to continue the next cutting cycle.

**IMPORTANT:** When the saw is not in use, store the bow in the down position to reduce the load on the drop rate control cylinder.

These examples below show ways to clamp a variety of cross sections. Always keep in mind the cutting capacity of the saw to achieve efficient saw cuts and long blade life. Do not use blades of a size different from that shown in the technical specification chart.

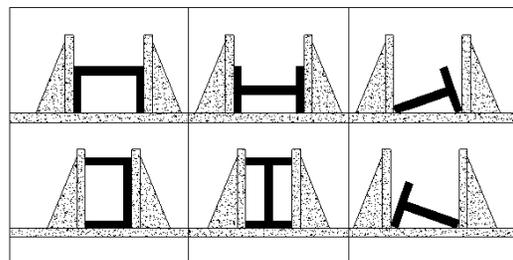


Figure 12-4

## 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 Maintenance

### ⚠ WARNING

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

### ⚠ WARNING

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

### ⚠ WARNING

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

### 14.1 Daily Maintenance

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- Do a general cleaning by removing dust and metal chips from the machine.
- Inspect the saw blade for wear.
- Clean the lubricating coolant drain screen.
- Top off the coolant tank.
- Check that the blade guards and emergency stop button are in good working order.
- When through using saw for the day, raise the bow to its up position and release some of the blade tension.

### 14.2 Weekly Maintenance

- On a weekly basis clean the machine and the area around it.

- Apply rust inhibitive lubricant to all non-painted surfaces.
- Wipe and grease the vise screw and sliding surfaces.
- Inspect blade brush and clean if needed.
- Clean coolant pump strainer basket.
- Remove chips from inside the guard housing for the saw blade.
- Use compressed air to clean the blade guides and guide bearings.

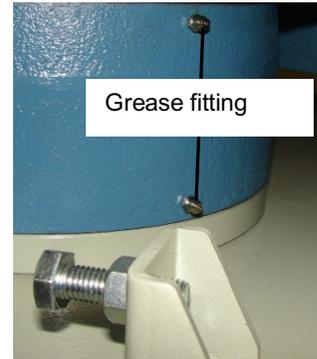


Figure 14-1

### 14.3 Monthly Maintenance

- Check the tightening of the motor flywheel screws.
- Check the blade guide bearings for wear. (replace if necessary).
- Tighten any loose bolts or screws on the gear motor, pump, and safety switches.
- Clean coolant tank.
- Grease saw head pivot.

### 14.4 Oils for Lubricating Coolant

Any 10:1 (water to coolant) solution will work however we recommend Baileigh Industrial B-Cool 20:1 (water to coolant) biodegradable metal cutting fluid. It has excellent cooling and heat transfer characteristics, is non-flammable, and extends blade and machine life. Each gallon of concentrate makes 21 gallons of coolant.

### 14.5 Coolant System Maintenance

Coolant Capacity = 4.25-4.5gal (16.5-17L).

1. Disconnect Power From the Saw!
2. To clean the tank, first remove the pipe plug (AQ) to drain the coolant.
3. Take off the screen (AR) by removing (4) screws.
4. Remove the pump (AS) by taking out (2) socket cap screws.
5. After tank is completely drained use a vacuum cleaner to remove all chips and debris.
6. Replace the plug.

7. Thoroughly clean the pump (**AS**) and replace.
8. Fill the tank with coolant to approximately 1" below the screen.
9. Replace the screen (**AR**).
10. Removable drip tray (**AT**) shown in place.

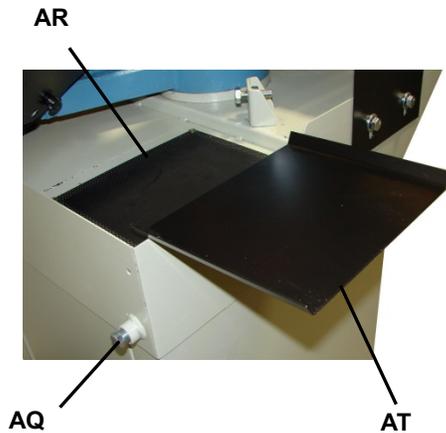


Figure 14-2

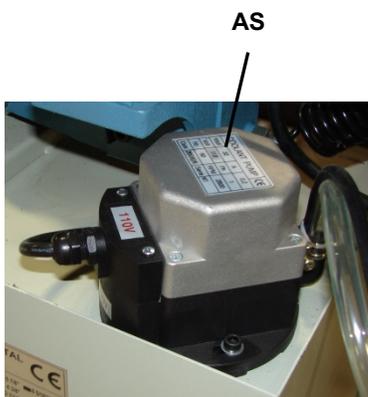


Figure 14-3

## 14.6 Oil Disposal

Used oil products must be disposed of in a proper manner following your local regulations.

## 14.7 Gearbox Maintenance

The gearbox requires periodic changing of the oil. The first change should be between 2 and 6 months depending upon the amount of use. Thereafter the gearbox oil should be changed yearly.

1. Disconnect power from the saw
2. Raise the saw bow to a vertical position.

**Note:** You may have to back off the upper travel adjusting bolt.

3. Remove the oil drain plug (**AO**) and drain the oil into a catch basin. Loosening oil fill plug (**AP**) will help oil to drain.
4. After draining, replace drain plug (**AO**).
5. Return the saw bow to a horizontal position.

6. Remove the fill plug (**AP**) and add .32 quart of gear oil. (For reference use SHELL type gear oil or Mobil gear oil #90).

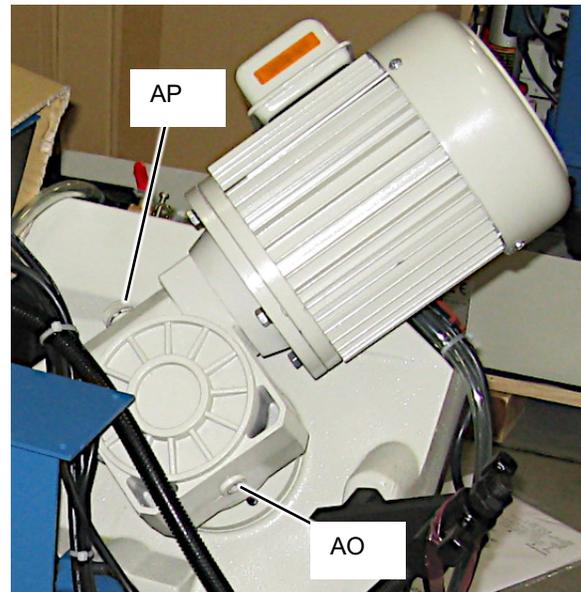


Figure 14-4

## 14.8 Storing Machine for Extended Period of Time

If the Band Saw is to be inactive for a long period of time, prepare the machine as follows:

- Detach the plug from the electrical supply panel.
- Clean and grease the machine.
- Release tension on the blade or remove blade.
- Drain coolant
- Cover the machine

## 15.0 Troubleshooting



**WARNING**

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

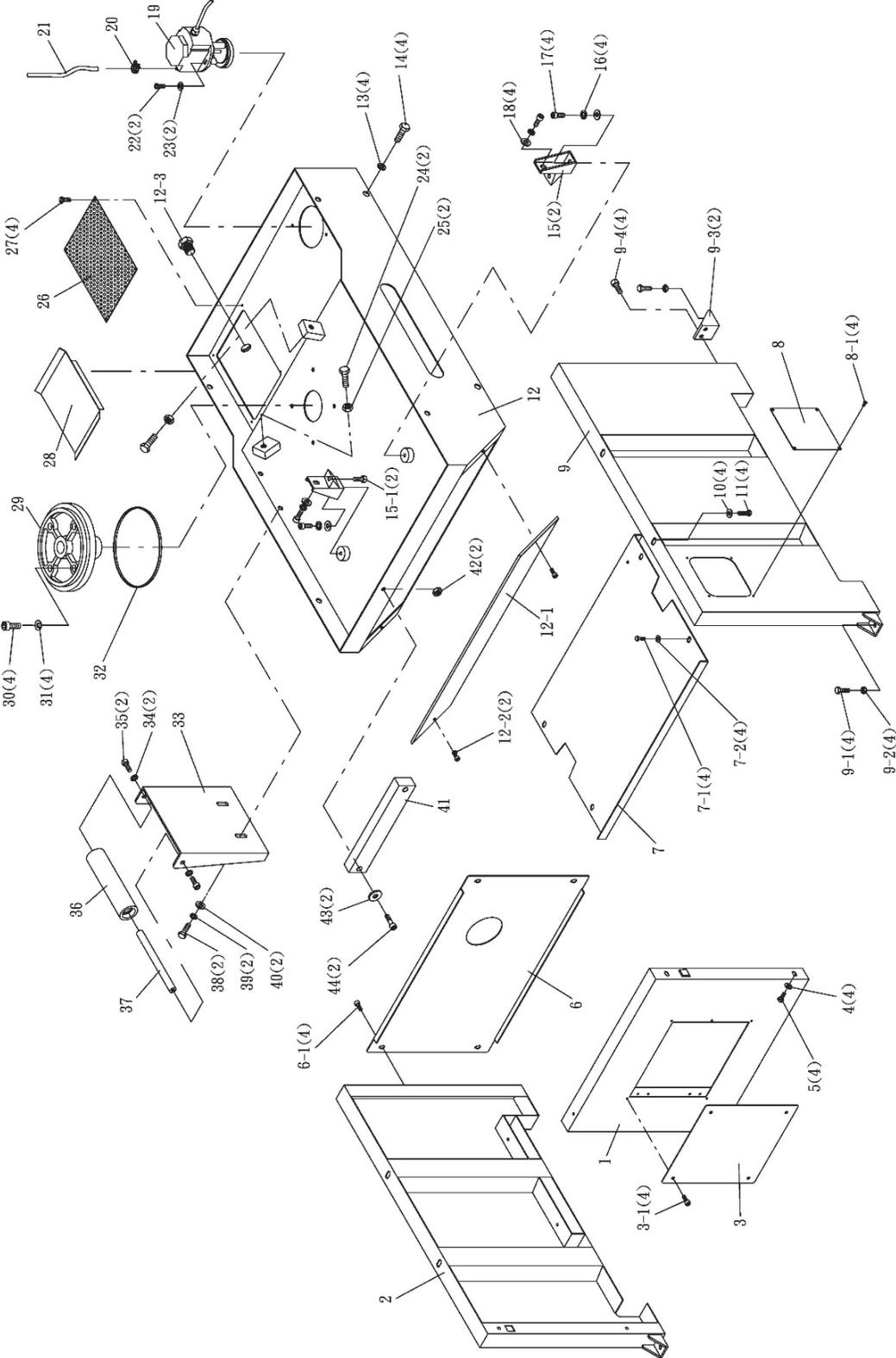
Table 15-1

Symptom	Possible Cause (S)	Corrective Action
Saw Motor Does Not Stop When Cut is Finished	1. Actuator on cylinder does not contact switch properly.	1. Re-adjust actuator or switch.
	2. Bow down limit switch SQ3 damaged	2. Replace SQ3
Coolant Motor Does Not Run With Band Saw Motor	1. Coolant switch not turned ON.	1. Turn on coolant switch.
	2. Coolant motor M2 damaged.	2. Replace M2 motor.
No Power Indicator Light When Main Power Turned On	1. Fuse may have burned out.	1. Switch off main power. Replace defective fuse
	2. Transformer T1 damaged	2. Replace Transformer
	3. Power LED HL1 damaged	3. Replace (white) power LED
Excessive Breakage	Blade	1. Material loose in vise
	2. Incorrect speed or feed	2. Adjust speed or feed
	3. Blade tooth spacing too large	3. Replace with a small tooth spacing blade
	4. Material too coarse	4. Use a slow speed blade an small tooth spacing
	5. Incorrect blade tension	5. Adjust to where blade does not slip on wheel
	6. Teeth in contact with material before saw is started	6. Start saw and lower into work piece
	7. Blade rubs on wheel flange	7. Adjust wheel alignment
	8. Misaligned guide bearings	8. Adjust guide bearings
	9. Cracking at weld	9. Weld again, note quality of weld
Premature Dulling	Blade	1. Teeth too coarse
	2. Too much speed	2. Decrease speed
	3. Inadequate feed pressure	3. Decrease spring tension on side of saw
	4. Hard spots or scale on material	4. Reduce speed, increase feed pressure
	5. Work hardening of material	5. Increase feed pressure by reducing spring tension
	6. Blade twist	6. Replace with a new blade, and adjust blade tension
	7. Insufficient blade	7. Tighten blade tension adjustable knob
Unusual Wear on Side/Back of Blade	1. Blade guides worn	1. Replace
	2. Blade guide bearings not adjusted properly	2. Adjust as per operators manual
	3. Blade guide bearing bracket is loose	3. Tighten
Teeth Ripping From Blade	1. Teeth too coarse for work	1. Use finer tooth blade
	2. Too heavy pressure, too slow speed	2. Decrease pressure, increase speed
	3. Vibrating work piece	3. Clamp work piece securely
	4. Gullets loading	4. Use coarse tooth blade or brush to remove chips

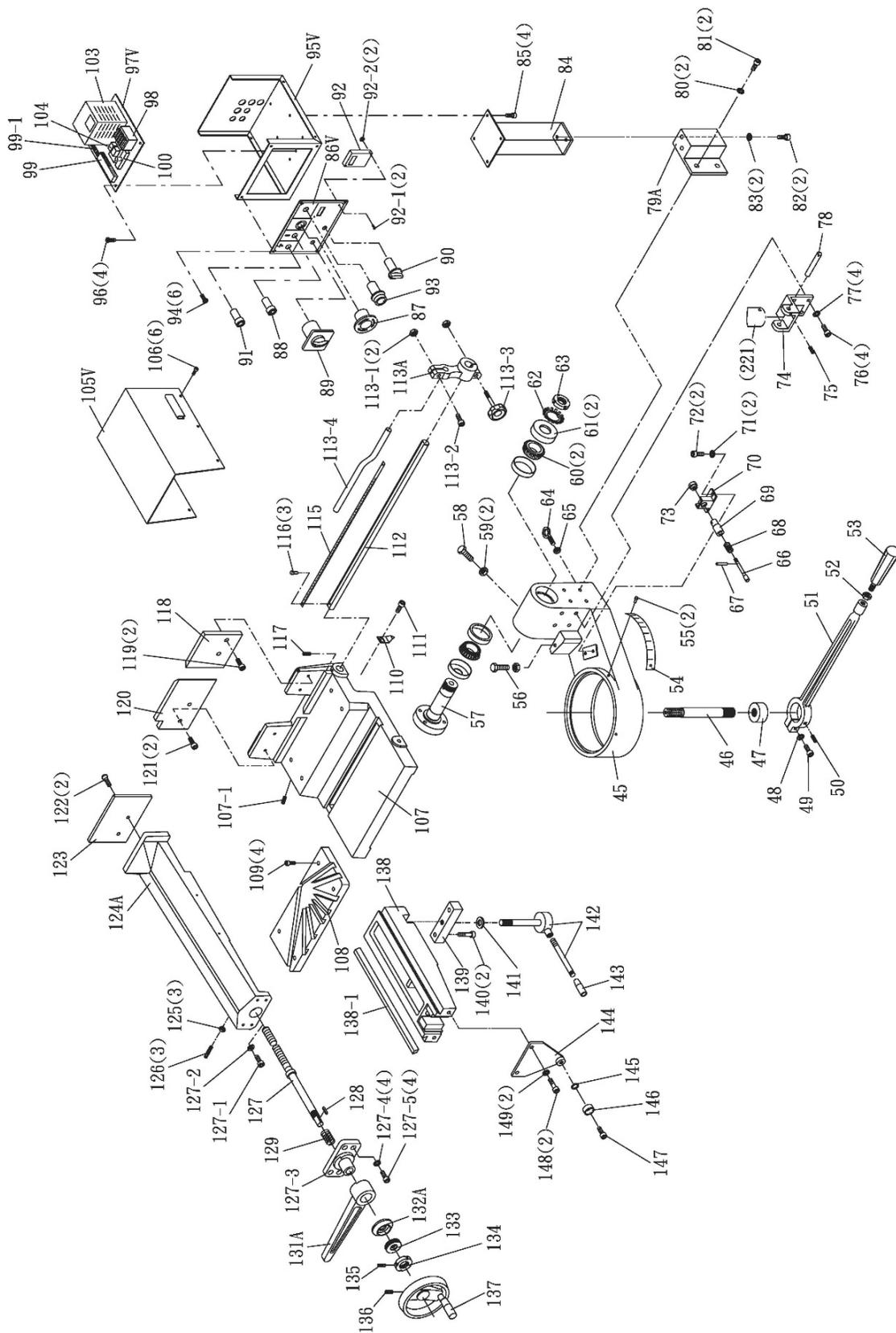
Symptom	Possible Cause (S)	Corrective Action
Poor Cuts	1. Feed pressure too great	1. Reduce pressure by increasing spring tension on side of saw
	2. Guide bearing not adjusted properly	2. Adjust guide bearing, the clearance cannot be greater than .001mm
	3. Inadequate blade tension	3. Increase blade tension with tension knob
	4. Dull blade	4. Replace blade
	5. Speed incorrect	5. Adjust speed
	6. Blade guide spaced out too much	6. Adjust guide space
	7. Blade guide assembly loose	7. Tighten blade guide assembly
	8. Blade track too far away from wheel flanges	8. Re-track blade according to operating instructions
Poor Cuts (Rough)	1. Too much speed or feed	1. Decrease speed or feed
	2. Blade is too coarse	2. Replace with finer blade
	3. Blade tension loose	3. Adjust blade tension
Blade is Twisting	1. Cut is binding blade	1. Decrease feed pressure
	2. Too much blade tension	2. Decrease blade tension

# 16.0 Replacement Parts

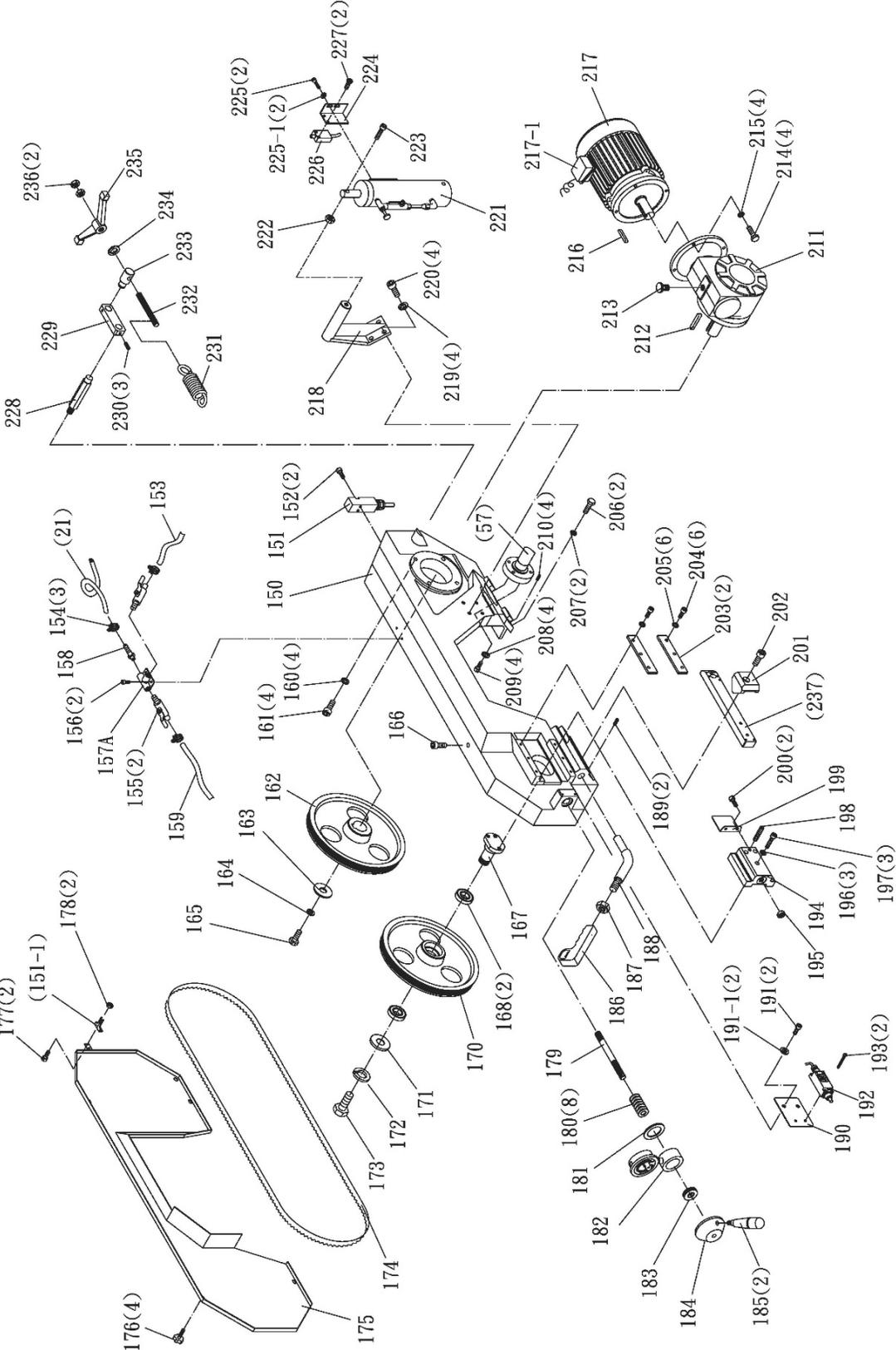
## 16.1.1 Horizontal Band Saw Assembly – Exploded View A



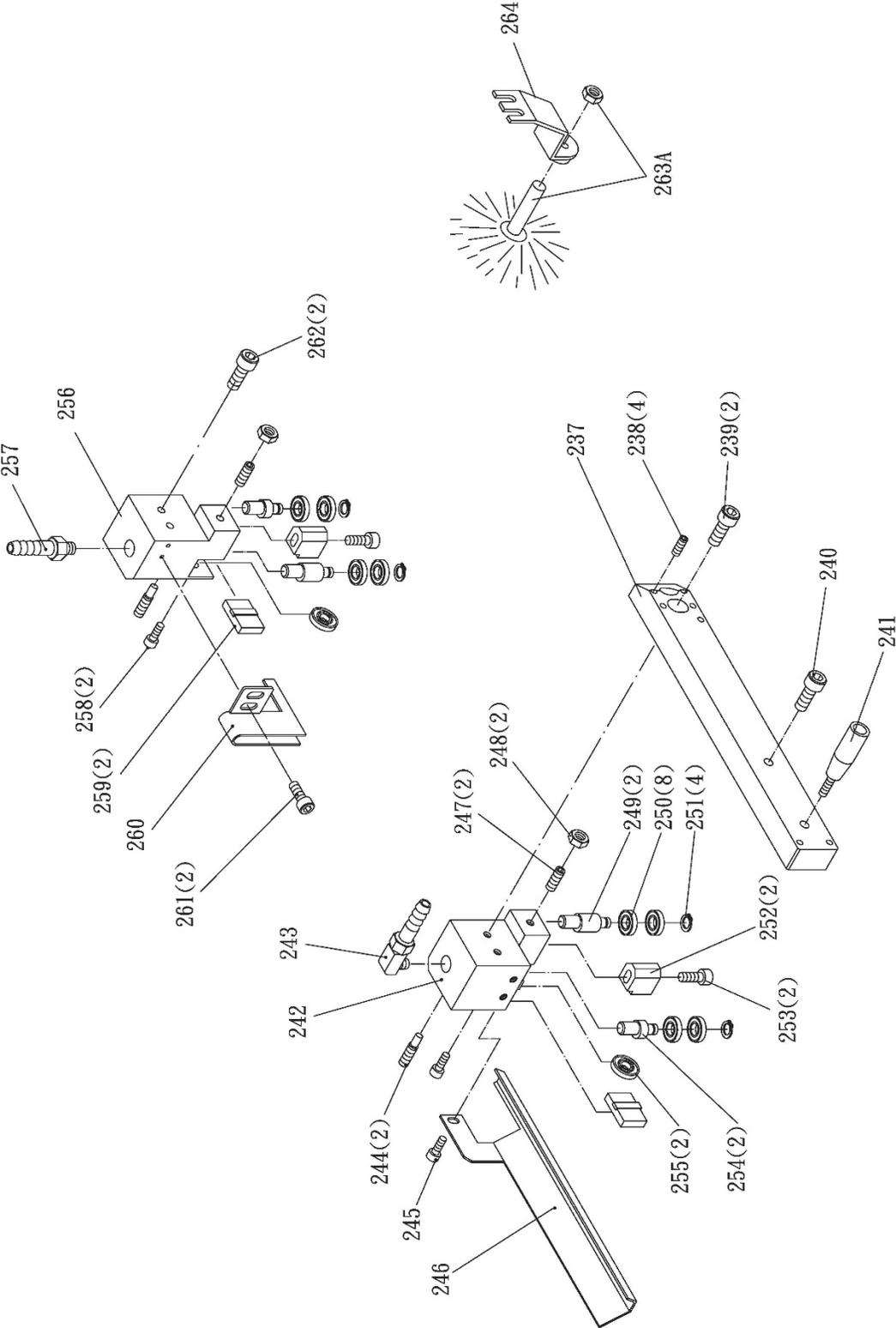
## 16.1.2 Horizontal Band Saw Assembly – Exploded View B



### 16.1.3 Horizontal Band Saw Assembly – Exploded View C



16.1.4 Horizontal Band Saw Assembly – Exploded View D



## 16.1.5 Horizontal Band Saw Assembly – Part List

Index No	Part No	Description	Size	Qty
1	**	Base (Front Part)		1
2	**	Base (Left Part)		1
3	**	Plate		1
3-1	JT9-TS-1502011	Hex. Socket Cap Screw	M5x8	4
4	**	Washer	8x18x2	4
5	JT9-TS-1490021	Hex. Cap Bolt	M8x16	4
6	**	Base (Rear Part)		1
6-1	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	4
7	**	Base (Bottom Plate)		1
7-1	JT9-TS-1490021	Hex. Cap Bolt	M8x16	4
7-2	**	Washer	8x18x2	4
8	**	Plate		1
8-1	JT9-TS-1502011	Hex. Socket Cap Screw	M5x8	4
9	**	Base (Right Part)		1
9-1	JT9-TS-1492041	Hex. Cap Bolt	M12x40	4
9-2	**	Nut	M12	4
9-3	**	Holder		2
9-4	CM9-TS-1504031	Hex. Socket Cap Screw	M8x16	4
10	**	Washer	10x25x2	4
11	JT9-TS-1491021	Hex. Cap Bolt	M10x20	4
12	BA9-1226896	Coolant and Chip Tray		1
12-1	**	Front Plate		1
12-2	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	2
12-3	**	Plug	3/8"	1
13	**	Washer	10x25x2	4
14	**	Hex. Cap Bolt	M10x20	4
15	**	Mounting Bracket		2
15-1	CM9-TS-1504031	Hex. Socket Cap Screw	M8x16	2
16	**	Spring Washer	M10	4
17	JT9-TS-1491021	Hex. Socket Cap Screw	M10x20	4
18	**	Washer	10x25x2	4
19	BA9-1013318	Coolant Pump	32W	1
20	**	Hose Clamp	13mm	1
21	**	Hose	5/16x172cm	1
22	CM9-TS-1503061	Hex. Socket Cap Screw	M6x25	2
23	**	Washer	6x13x1	2
24	JT9-TS-1492041	Hex. Cap Bolt	M12x40	2
25	**	Nut	M12	2
26	BA9-1014608	Filter Net		1
27	**	Round Head Screw	M5x10	4
28	**	Coolant Plate		1
29	**	Disk		1
30	JT9-TS-1504061	Hex. Socket Cap Screw	M8x30	4
31	**	Spring Washer	M8	4
32	**	Oil Seal	4mmx675mm	1
33	BA9-1014363	Roller Stand		1
34	**	Spring Washer	M8	2
35	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	2
36	**	Roller		1
37	**	Roller Shaft		1
38	JT9-TS-1492011	Hex. Cap Bolt	M12x25	2
39	**	Spring Washer	M12	2
40	**	Washer	12x28x3	2
41	**	Track		1
42	**	Nut	M8	2
43	**	Washer	8x18x2	2
44	JT9-TS-1504081	Hex. Socket Cap Screw	M8x40	2
45	BA9-1021853	Swivel Arm		1
46	**	Shaft		1

Index No	Part No	Description	Size	Qty
47	**	Shaft Nut		1
48	**	Spring Washer	M10	1
49	JT9-TS-1505051	Hex. Socket Cap Screw	M10x35	1
50	JT9-TS-1525031	Set Screw	M10x16	1
51	**	Locking Lever		1
52	**	Nut	M12	1
53	**	Handle	M12x25	1
54	BA9-1018969	Scale		1
55	**	Rivet	2.3x4	2
56	JT9-TS-1491061	Hex. Cap Bolt	M10x40	1
57	**	Shaft		1
58	JT9-TS-1491061	Hex. Cap Bolt	M10x40	1
59	**	Nut	M10	2
60	JT9-BB-32007	Bearing	32007	2
61	**	Anti-Dust Cover	35mm	2
62	**	Star Washer	M35	1
63	**	Jam Nut	M35	1
64	BA9-1017901	Spring Hook		1
65	BA9-1017902	Nut	M8	1
66	**	Pin		1
67	**	Spring Pin	2.5x16	1
68	**	Spring	0.8x9x30mm	1
69	**	Bushing		1
70	**	Bracket		1
71	**	Spring Washer	M8	2
72	JT9-TS-1504051	Hex. Socket Cap Screw	M8x25	2
73	**	Knob		1
74	**	Supporting Bracket		1
75	JT9-TS-1523041	Set Screw	M6x12	1
76	JT9-TS-1504051	Hex. Socket Cap Screw	M8x25	4
77	**	Spring Washer	M8	4
78	**	Shaft		1
79A	**	Setting Bracket		1
80	**	Spring Washer	M8	2
81	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	2
82	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	2
83	**	Spring Washer	M8	2
84	**	Support		1
85	JT9-TS-1502011	Hex. Socket Cap Screw	M5x8	4
86V	**	Control Box Panel		1
87	BA9-1232476	Emergency Switch		1
88	BA9-1226759	Start Push Button		1
89	BA9-1014096	Main Connect Switch		1
90	**	Manual / Auto Selector		1
91	**	Power Indicator Light		1
92	**	Blade Speed Indicator		1
92-1	**	Round Head Screw	M3x20	2
92-2	**	Nut	M3	2
93	**	Blade Speed Knob		1
94	BA9-1226777	Round Head Screw	M5x8	6
95V	**	Control Box Bottom Part		1
96	**	Round Head Screw	M4x8	4
97V	**	Control Box Bottom Plate		1
98	**	Transformer		1
99	**	Terminal Connector		1
99-1	**	Grounding Plate		1
100	BA1-9675	Fuse	0.5A	1
103	BA9-1021035	Inverter		1
104	**	Relay		1
105V	BA9-1020442	Control Box Cover		1
106	JT9-TS-1502011	Hex. Socket Cap Screw	M5x8	6

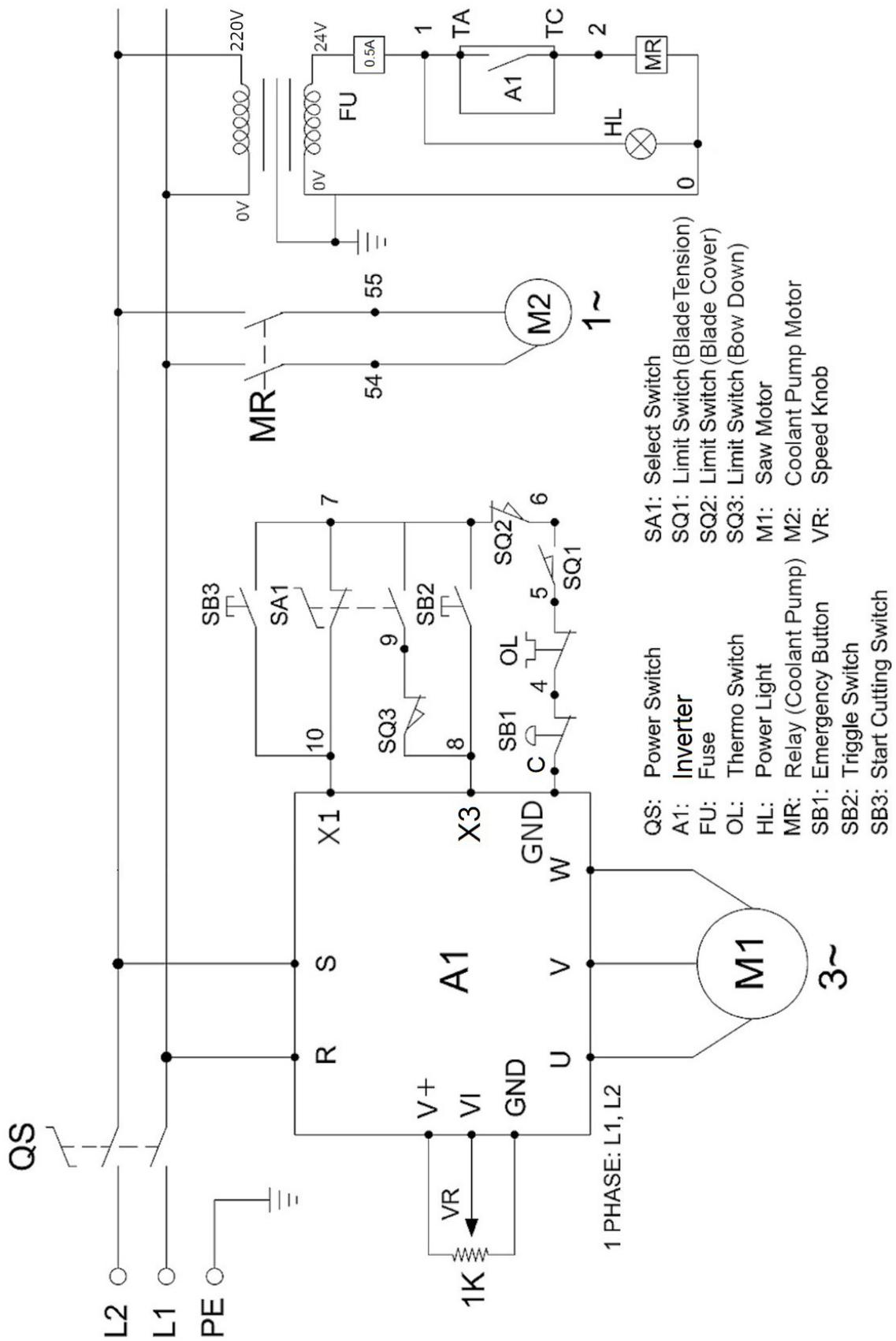
Index No	Part No	Description	Size	Qty
107	BA9-1017601	Table		1
107-1	JT9-TS-1524021	Set Screw	M8x10	1
108	BA9-1001433	Changeable Plate		1
109	CM9-TS-1504031	Hex. Socket Cap Screw	M8x16	4
110	**	Pointer		1
111	JT9-TS-1502011	Hex. Socket Cap Screw	M5x8	1
112	**	Bar-Stop-Rod		1
	BA9-1016872	Knob and Bar Stop Assembly		
113A	**	Bar Bracket		1
113-1	**	Nut	M8	2
113-2	JT9-TS-1504051	Hex. Socket Cap Screw	M8x25	1
113-3	**	Knob	M8x30	1
113-4	**	Stop Bar		1
115	BA9-1017573	Scale		1
116	**	Rivet	2x5	3
117	JT9-TS-1523041	Set Screw	M6x12	1
	**	Vise Jaw - Right+Left		
118	**	Vise Jaw - Right		1
119	CM9-TS-1503041	Hex. Socket Cap Screw	M6x16	2
120	**	Vise Jaw - Left		1
121	CM9-TS-1503041	Hex. Socket Cap Screw	M6x16	2
122	BA9-1011716	Flat Head Machine Screw	M6x16	2
123	BA9-1011717	Vise Jaw - Front		1
124A	BA9-1019863	Movable Vise		1
125	BA9-1230621	Nut	M5	3
126	BA9-1020309	Set Screw	M5x25	3
127	**	Lead Screw		1
127-1	CM9-TS-1504031	Hex. Socket Cap Screw	M8x16	1
127-2	**	Washer	8x18x2	1
127-3	**	Setting Seat		1
127-4	**	Spring Washer	M8	4
127-5	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	4
128	BA9-1020310	Key	5x5x15	1
129	BA9-1020311	Spring	5x31x35mm	1
131A	**	Lock Handle		1
132A	**	Bearing Bushing		1
133	JT9-BB-51104	Bearing	51104	1
134	BA9-1017613	Nut	M20x30x9P1.5	1
135	BA9-1020623	Set Screw	M5x5	1
136	JT9-TS-1524021	Set Screw	M8x10	1
137	**	Hand Wheel	6-1/2"	1
138	BA9-1227869	Vise Seat		1
138-1	**	Dovetail Plate		1
139	**	Vise Setting Plate		1
140	JT9-TS-1505041	Hex. Socket Cap Screw	M10x30	2
141	BA9-1017337	Washer	3/4x37x3	1
142	**	Lock Lever Device	M16x190	1
143	**	Handle	1/2"	1
144	**	Setting Plate		1
145	**	Spring Washer		1
146	JT9-BB-608ZZ	Bearing		1
147	CM9-TS-1504031	Hex. Socket Cap Screw	M8x16	1
148	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	2
149	**	Spring Washer	M8	2
150	BA9-1023095	Saw Arm		1
151	**	Limit Switch		1
151-1	**	Switch Pin		1
152	CM9-TS-1501081	Hex. Socket Cap Screw	M4x30	2
153	**	Hose	5/16x43cm	1
154	**	Hose Clamp	13mm	3
155	**	Coolant Switch	1/4Px5/16	2

Index No	Part No	Description	Size	Qty
156	JT9-TS-1502041	Hex. Socket Cap Screw	M5x16	2
157A	**	T Connector		1
158	**	Pipe Fitting		1
159	**	Hose	5/16x89cm	1
160	**	Spring Washer	M10	4
161	JT9-TS-1505061	Hex. Socket Cap Screw	M10x40	4
162	BA9-1015613	Drive Flywheel		1
163	**	Washer		1
164	**	Spring Washer	M10	1
165	CM9-TS-1491031	Hex. Cap Bolt	M10x25	1
166	JT9-TS-1502011	Hex. Socket Cap Screw	M5x8	1
167	BA9-1020003	Shaft		1
168	JT9-BB-6006ZZ	Bearing	6006ZZ	2
170	BA9-1015614	Idle Flywheel		1
171	BA9-1020006	Washer		1
172	BA9-1020007	Spring Washer	M10	1
173	CM9-TS-1491031	Hex. Cap Bolt	M10x25	1
174	**	Blade	27x0.9x2460mm HSS 5/8T	1
175	BA1-10126	Blade Cover		1
176	**	Knob Bolt	M6x12	4
177	**	Round Head Screw	M4x8	2
178	**	Nut	M4	2
179	**	Tension Shaft	M16x230	1
180	BA9-1231051	Special Spring Washer		8
181	**	Plate		1
182	BA9-1226795	Blade Tension Gauge		1
183	JT9-BB-51103	Thrust Bearing	51103	1
184	**	Handle Wheel		1
185	**	Handle		2
186	**	Trigger Switch		1
187	**	Nut	M16	1
188	**	Pipe		1
189	JT9-TS-1524021	Set Screw	M8x10	2
190	**	Plate		1
191	CM9-TS-1503031	Hex. Socket Cap Screw	M6x12	2
191-1	**	Washer	6x13x1	2
192	**	Limit Switch		1
193	JT9-TS-1501071	Hex. Socket Cap Screw	M4x25	2
194	**	Slide Bracket		1
195	**	Nut	M16	1
196	**	Spring Washer	M10	3
197	JT9-TS-1505071	Hex. Socket Cap Screw	M10x45	3
198	JT9-TS-1525051	Set Screw	M10x25	1
199	**	Cover Plate		1
200	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	2
201	**	Setting Bracket		1
202	JT9-TS-1506071	Hex. Socket Cap Screw	M12x50	1
203	**	Gib		2
204	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	6
205	**	Spring Washer	M8	6
206	CM9-TS-1503031	Hex. Cap Bolt	M6x12	2
207	**	Spring Washer	M6	2
208	**	Spring Washer	M10	4
209	JT9-TS-1505041	Hex. Socket Cap Screw	M10x30	4
210	JT9-TS-1523041	Set Screw	M6x12	4
211	BA9-1011822	Gear Box		1
212	**	Key	8x7x30	1
213	**	Vent Screw		1
214	JT9-TS-1490051	Hex. Cap Bolt	M8x30	4
215	**	Spring Washer	M8	4

Index No	Part No	Description	Size	Qty
216	**	Key	6x6x30	1
217	BA9-1012766	Motor	1.1 KW	1
217-1	**	Junction Box		1
218	**	Hydraulic Cylinder Post		1
219	**	Spring Washer	M8	4
220	JT9-TS-1504051	Hex. Socket Cap Screw	M8x25	4
221	BA9-1011032	Hydraulic Cylinder		1
222	**	Nut	M10	1
223	JT9-TS-1505061	Hex. Socket Cap Screw	M10x40	1
224	**	Adjusting Bracket		1
225	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	2
225-1	**	Washer	6x13x1	2
226	**	Limit Switch		1
227	**	Round Head Screw	M5x10	2
228	**	Spring Shaft		1
229	**	Setting Plate		1
230	JT9-TS-1524021	Set Screw	M8x10	3
231	BA9-1012946	Spring	6x50x188mm	1
232	BA9-1012947	Adjustable Shaft	16x160mm	1
233	**	Bushing		1
234	**	Washer	16x30x3	1
235	**	Handle		1
236	**	Nut	M16	2
237	**	Blade Guide Movable Rod		1
238	JT9-TS-1523041	Set Screw	M6x12	4
239	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	2
240	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	1
241	**	Handle	M6x60	1
242	**	Guide Bracket		1
243	**	Pipe Fitting	1/4Px5/16	1
244	BA9-1020314	Bolt		2
245	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	1
246	BA9-1224582	Blade Guard		1
247	JT9-TS-1523041	Set Screw	M6x12	2
248	**	Nut	M6	2
249	**	Centric Shaft		2
250	JT9-BB-608ZZ	Bearing	608ZZ	8
251	**	E-Ring	E-7	4
252	BA9-1020315	Blade Guide		2
253	CM9-TS-1503061	Hex. Socket Cap Screw	M6x25	2
254	**	Eccentric Shaft		2
255	JT9-BB-608ZZ	Bearing	608ZZ	2
256	**	Guide Bracket		1
257	**	Pipe Fitting	1/4Px5/16	1
258	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	2
259	BA9-1019941	Blade Guide		2
260	**	Blade Guard		1
261	JT9-TS-1503011	Hex. Socket Cap Screw	M6x8	2
262	JT9-TS-1504041	Hex. Socket Cap Screw	M8x20	2
263A	**	Brush	Dia 50	1
264	**	Brush Clamp		1

\*\* These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

# 17.0 Wiring Diagram

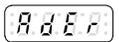
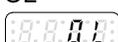
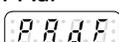
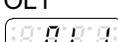
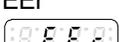
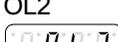
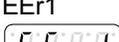
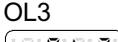
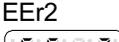
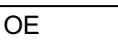
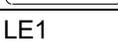
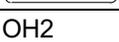


- QS: Power Switch
- A1: Inverter
- FU: Fuse
- OL: Thermo Switch
- HL: Power Light
- MR: Relay (Coolant Pump)
- SB1: Emergency Button
- SB2: Triggler Switch
- SB3: Start Cutting Switch
- SA1: Select Switch
- SQ1: Limit Switch (Blade Tension)
- SQ2: Limit Switch (Blade Cover)
- SQ3: Limit Switch (Bow Down)
- M1: Saw Motor
- M2: Coolant Pump Motor
- VR: Speed Knob

## 18.0 Fault Displays

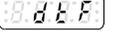
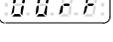
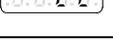
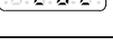
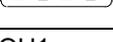
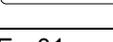
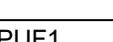
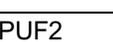
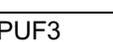
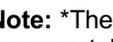
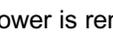
### 18.1 Error Trip Messages of Drive

Table 18-1

Display	Description	Display	Description
Fot 	IGBT module error	noFb 	PID feedback signal error
GF 	Grounding fault	AdEr 	A/D converter error
OC 	Drive over current	EF 	External fault
OL 	Motor overload	PAdF 	Keypad interruption during copy
OL1 	Drive overload	EEr 	EEPROM error
OL2 	Drive current limit	EEr1 	Internal memory error
OL3 	Braking transistor overload	EEr2 	Internal memory error
OLO 	System overload	ntcF 	Thermal sensor fault
OE 	Over voltage	OH 	Drive overheat
LE1 	Under voltage during operation	OH2 	Motor overheat

## 18.2 Warning Messages of Drive

Table 18-2

Display	Description	Display	Description
OLO 	System overload	Fr 	Coast to stop
Hv 	Power source over voltage	dtF 	Forward/reverse command input simultaneously
db 	Braking transistor is active	WrF 	Different software version inter-copy
LE* 	Power source under voltage*	Cot 	Modbus communication overtime
Oht 	Drive overheat	Err 00 	Keypad cable trip before connecting
OH1 	Motor overheat	Err 01 	Keypad cable trip during operation
Bb 	Drive output interruption	PUF1 	First time you enter wrong
PUF2 	Second time you enter wrong	PUF3 	Third time you enter wrong
LOC 	Parameter locking	ULOC 	Parameter Password Unlock

**Note:** \*The LE error message will display briefly when power is removed from the machine. This is normal as it is accurately reading a loss of power.

## 19.0 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](mailto:Baileigh-Service@jpwindustries.com)







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**[www.baileigh.com](http://www.baileigh.com)**