



# 150MM 3-SPEED METAL CUTTING BANDSAW WITH VICE & STAND

MODEL NO: **SM5.V4**

Thank you for purchasing a Sealey product. Manufactured to a high standard, this product will, if used according to these instructions, and properly maintained, give you years of trouble free performance.

**IMPORTANT:** PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS & CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. KEEP THESE INSTRUCTIONS SAFE FOR FUTURE USE.



Refer to instruction manual



Wear eye protection



Wear ear protection



No reaching in - sharp blade



Wear protective clothing



Wear protective gloves



Indoor use only



Wear protective footwear

## 1. SAFETY INSTRUCTIONS

### 1.1. ELECTRICAL SAFETY

- WARNING!** It is the user's responsibility to check the following:
  - Check all electrical equipment and appliances to ensure that they are safe before using.
  - Inspect power supply leads, plugs and all electrical connections for wear and damage.
  - Ensure that the insulation on all cables and on the appliance is safe before connecting it to the power supply.
- × **DO NOT** use worn or damaged cables, plugs or connectors.
- ✓ Ensure that any faulty item is repaired or is replaced immediately by a qualified electrician.
- ✓ If the cable or plug is damaged during use, switch off the electricity supply and remove from use.
- ✓ Ensure that repairs are carried out by a qualified electrician.
- ✓ Sealey recommend that an RCD (Residual Current Device) is used with all electrical products.
- Important:** Ensure that the voltage rating on the appliance suits the power supply to be used and that the plug is fitted with the Correct fuse.
- ✓ Full-load current for each incoming supply is 2.85A.
- ✓ Single phase. Frequency 50Hz.
- × **DO NOT** pull or carry the appliance by the power cable.
- × **DO NOT** pull the plug from the socket by the cable.

### 1.2. GENERAL SAFETY

- WARNING!** Disconnect the bandsaw from the power source before servicing, changing accessories, or performing any other maintenance.
- ✓ Familiarise yourself with the applications and limitations of the product, as well as the potential hazards.
- ✓ Maintain the bandsaw in good condition. Keep it clean and keep blades sharp for best and safest performance.
- ✓ Use original Sealey spare parts only. Unauthorised parts may be dangerous and will invalidate the warranty.
- ✓ Keep all guards and fixing screws in place, tight and in working order. Check regularly for damaged parts. A guard or any other part that is damaged must be repaired or replaced before the saw is used further. Check also for incorrect alignment of moving parts, loose mountings, or any other condition that could affect the operation of the saw.
- ✓ Ensure the space allocated for use and maintenance of the machine is adequate, free from unrelated materials and has good lighting.
- ✓ Wear approved eye and ear protection when operating the machine. If dust is produced, wear an approved face or dust mask.
- ✓ Keep children and unauthorised persons away from the work area, especially when the saw is in operation.
- ✓ Remove any adjusting keys and wrenches from the machine before operating.
- ✓ Ensure that large or oversized workpieces are supported at table height. Ensure you use a suitable support for any workpiece that does not have a flat surface. Be cautious when cutting workpieces which are irregular in cross-section as the saw blade could be pinched before the cut is completed. Any stock must lay flat on the table surface and not be allowed to rock.
- ✓ Restrict availability of keys or tools to skilled or instructed persons only.
- WARNING!** Round bar and tubing have a tendency to roll while being cut. **DO NOT** cut such items without clamping or blocking the workpiece.
- WARNING!** Never force the blade through the workpiece.
- × **DO NOT** use this bandsaw for anything other than its intended purpose. This bandsaw is designed for light metal cutting work in engineering workshops, garages, metal fabricators, etc.
- WARNING!** The SM5.V4 bandsaw must not be used to cut non-metallic materials (including wood).
- × **DO NOT** wear loose or ill-fitting clothing. Remove ties, watches, rings and other jewellery. Tie up, or adequately cover, long hair.
- × **DO NOT** start the bandsaw until the workpiece is secure and the blade has been lowered to just above the workpiece.
- × **DO NOT** run the bandsaw with the blade in the raised position unless set up for vertical cutting.
- × **DO NOT** use the bandsaw in areas where fumes from paint, solvents, or flammable liquids pose a potential hazard. Keep all flammable materials (including wipes or cleaning rags) away from the saw, and dispose of according to local regulations.
- × **DO NOT** leave the bandsaw running unattended. Turn power switch 'OFF' and **DO NOT** leave area until the blade has come to a complete stop.
- × **DO NOT** use the bandsaw if tired or under the influence of drugs, alcohol or other intoxicating medication.
- × **DO NOT** use the bandsaw with the blade guard or pulley cover removed.
- × **DO NOT** use the bandsaw in wet or damp locations.
- × **DO NOT** start accidentally. Ensure the switch is off before plugging in the saw.

- × **DO NOT** use damaged or deformed bandsaw blades.
- **WARNING!** Turn the bandsaw off **before** raising the blade.
- × **DO NOT** stand on the bandsaw.
- ✓ Always secure the workpiece in the vice.
- ✓ Wear protective gloves when handling workpiece and saw blades.
- ✓ Keep correct footing and balance at all times and wear non-slip shoes with steel toe caps.

## 2. INTRODUCTION

Heavy-duty cast base and horizontal/vertical cutting arm. Saw base features integral mitring vice with scale of 45° to 90° for angle cutting and fully adjustable precision blade guides for accurate cutting and longer blade life. Stand is fitted with two wheels.

## 3. SPECIFICATION

Model No:	SM5.V4
Declaration of Conformity. EMC Regulations 2016	EN IEC 55014-1:2021, EN IEC 61000-3-2:2019 +A1, EN 61000-3- 3:2013+A1+A2, EN IEC 55014-2:2021
Fuse Rating:	13A
Nett Weight:	56kg
Plug Type:	3-Pin
Power Supply Cable Length:	1.83m
Capacity 90° - Round:	Ø110mm
Capacity 90° - Square/Rectangular (H x W):	100 x 150mm
Capacity 45° - Round:	Ø72mm
Capacity 45° - Square/Rectangular (H x W):	100 x 72mm
Blade Size:	1638 x 12.7 x 0.6mm
Blade Speeds:	20, 29, 50m/min
Motor Power:	420W
Supply:	230V
Weight:	60kg
A-weighted Sound Pressure Level	70 dB(A)
A-weighted Sound Power Level :	80 dB(A)



### 3.1. NOISE DECLARATION

3.1.1. The figures quoted are emission levels and are not necessarily safe working levels. While there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include characteristics of the work room, the other sources of noise, etc., i.e. the number of machines and other adjacent processes. Also, the permissible exposure level can vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazard and risk.

### 3.2. SAFETY FUNCTIONS

3.2.1. The bandsaw has been fitted with micro switches, if a cover, or pulley cover is accidentally opened while the machine is in operation the bandsaw will stop.

## 4. INSTALLATION

### 4.1. TRANSIT AND LIFTING

4.1.1. This is a heavy unbalanced object. **HANDLE WITH CARE**, use two people to move.

### 4.2. INSTALLATION AREA

4.2.1. Ensure that there is adequate free space around the machine bearing in mind that it may be necessary to cut from long lengths of steel stock that need to be fed through the vice attached to the machine and that the stock will need to be supported along its length beyond the machine.

4.2.2. The surface on which the machine is to be mounted should be flat and level and capable of supporting the weight of the machine.

4.2.3. Ensure that the work area is adequately illuminated.

4.2.4. The machine should be located near a power supply point that is equipped with an overload cut out and suitable earthing.

4.2.5. The installation area should be free from excessive humidity and atmospheric agents that could ignite.

### 4.3. STORAGE

4.4. Keep the Bandsaw in a clean and dry environment. **DO NOT** store it in, or expose it to, a damp or wet environment.

## 5. ASSEMBLY

### 5.1. NOTE: NUMBERS IN BRACKETS REFER TO PARTS DIAGRAM ITEMS

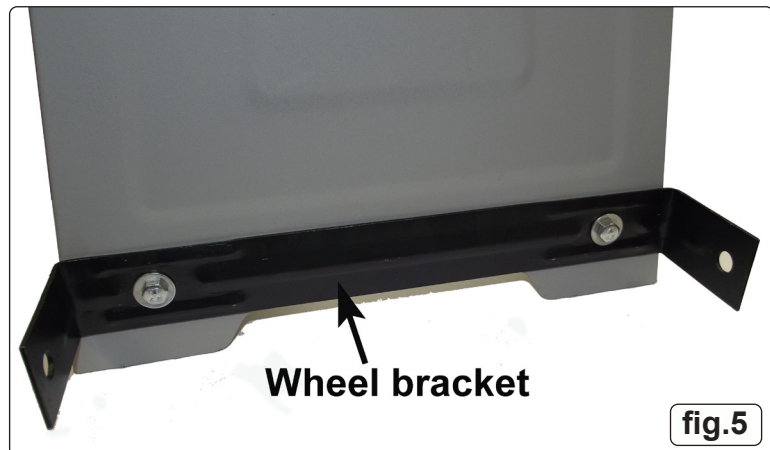
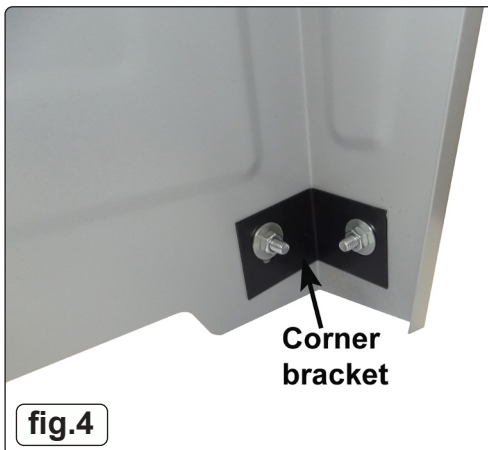
5.1.1. Remove the unit from packing and check that all items in the following list are present and undamaged: Saw Assembly, Pulley Cover, Shelf, Floor Stands (2 of), Stock Stop & Rod Assembly, Hand Wheel, Vice, Axle & Wheels Assembly, Handle, Floor Stand, Vertical Cutting Table, Drive Belt, Bag of screws, washers, nuts, split pins.

### 5.2. STAND ASSEMBLY

5.2.1. See illustrations on the next page.



- 5.2.2. Lay a leg (4) down and fix one end of the shelf (170), using screws, see fig.1. **NOTE:** the shelf will only fit one way - edges facing up.
- 5.2.3. **DO NOT** fully tighten the screws yet.
- 5.2.4. Fit the other leg to the shelf (do not fully tighten the screws yet), see fig.3.
- 5.2.5. Fit the corner brackets inside each leg as shown using nut, bolt and two washers, see fig.4.
- 5.2.6. The wheel bracket (174) is bolted on using the corner bracket bolts, onto the end opposite to where the handle will fit on (14), see fig.5



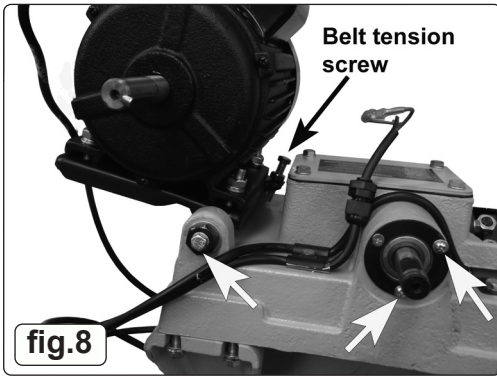
- 5.2.7. Turn the stand the correct way up.
- 5.2.8. Using the **help of at least two people**, lift the saw onto the top of the stand. Make sure the motor is at the end with the wheel bracket.
- 5.2.9. Level the shelf and tighten its screws.
- 5.2.10. Make sure that the other person(s) steadies the saw until all six bolts that hold the saw onto the stand are tightened. **It is unstable until completed.**
- 5.2.11. Double check that all bolts and screws are tight. The saw should now be stable.
- 5.2.12. Fit the handle to the opposite end to the wheel bracket see fig.6. Insert split pins into the ends of the handle and open them up to prevent it from falling out.



5.2.13. Fit the wheels (with the face indicated in fig.7) against the wheel bracket. Secure with split pins in the end of the axle and behind the bracket each side.

### 5.3. FIT BELT GUARD

5.3.1. Remove the two screws and the bolt as indicated by white arrows in fig.8.



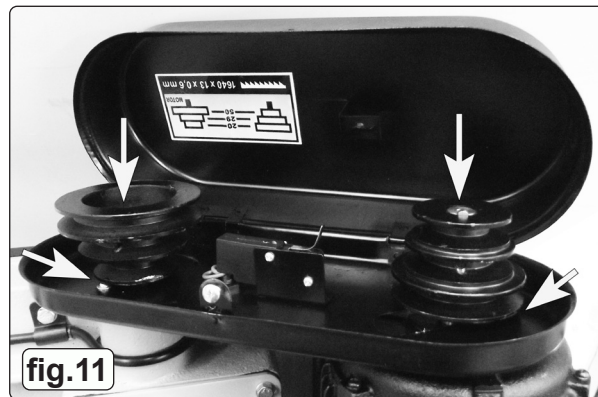
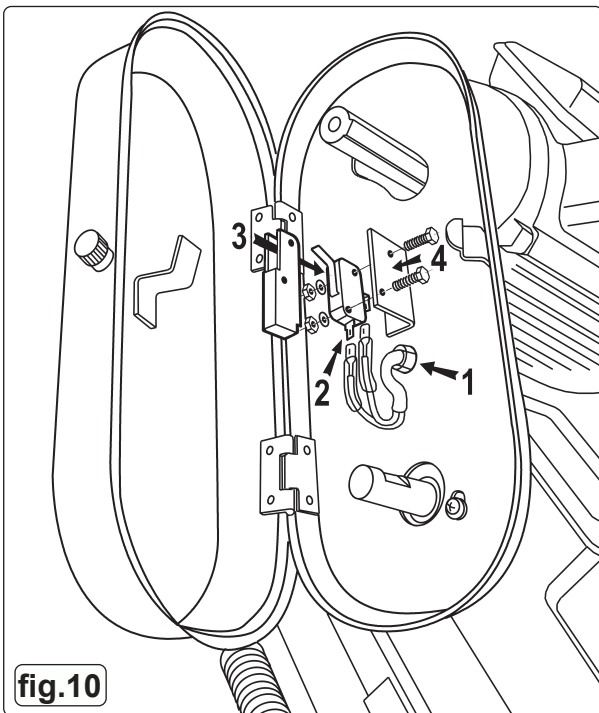
5.3.2. Before fixing down the pulley cover fit the grommet to the microswitch power cable and insert the grommet into the pulley cover, secure it inside the pulley cover with its locknut. Adjust the position of the cable within the grommet to allow for the correct length of cable inside the pulley cover for the microswitch to be correctly positioned, see fig.9.

5.3.3. Screw down the pulley cover.

### 5.4. FIT THE MICROSWITCH REFER TO THE NUMBERS IN FIG.10

5.4.1. Slide the cover off the microswitch and fit the connectors, they can go either way round.

5.4.2. Slide the cover back over the microswitch and bolt it to the bracket.



### 5.5. FIT THE MOTOR AND DRIVEN PULLEYS AND DRIVE BELT REFER TO FIG.11

5.5.1. Fit the motor pulley making sure the key is in place, tighten the grub screw when the pulley is flush with the end of shaft.

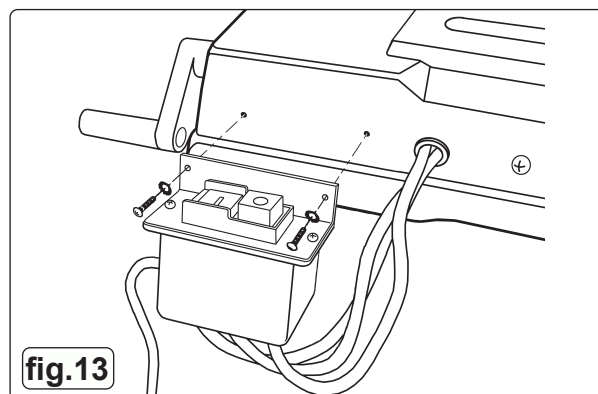
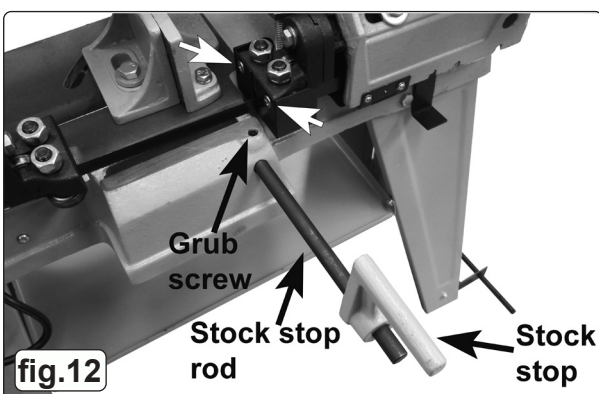
5.5.2. Fit the driven pulley making sure the grub screw lines up with the flat on the shaft.

5.5.3. Make sure both pulleys are the same distance from the belt guard and that the top faces of both pulleys are level, see white arrows in fig.11. Tighten the grub screw.

5.5.4. Fit the drive belt and adjust motor position (using screw and locknut) to tension the belt, see fig.8.

### 5.6. FIT STOCK STOP

5.6.1. Fit the stock stop rod (21) into the base and secure with the grub screw. Fit the stock stop (19) and secure with screw (20), see fig.12.



## 5.8. FIT THE SWITCH BOX

**□ IT IS STRONGLY ADVISED THAT ALL ELECTRICAL WORK BE UNDERTAKEN BY A FULLY QUALIFIED ELECTRICIAN.**

5.8.1. Fit the switch box using the screws provided, see fig.13.

## 6. SET UP

6.1. **ADJUST THE ABUTMENT SCREW (53)** so that with the body frame down the blade cutting edge is below the surface of the base, but the body frame is clear of the base. Tighten the lock nut (122), see fig.14.

6.2. **ADJUST SWITCH CUT OFF TIP (76)** to ensure that 'Off' switch is actuated when or just before body frame contacts the abutment screw (53). Tighten the screw which secures the switch cut off, see fig.15.

### 6.3. ADJUST THE BLADE SPEED

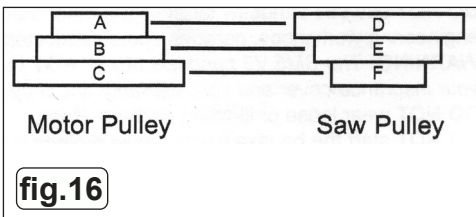
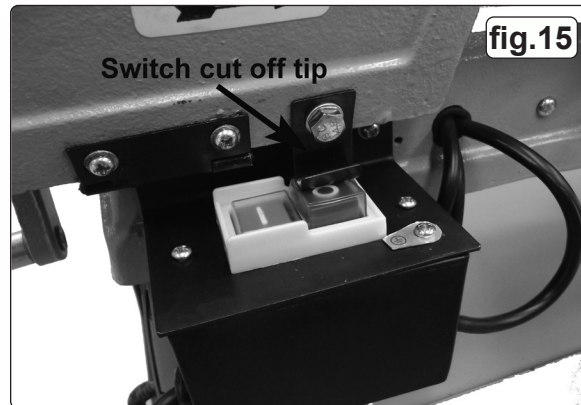
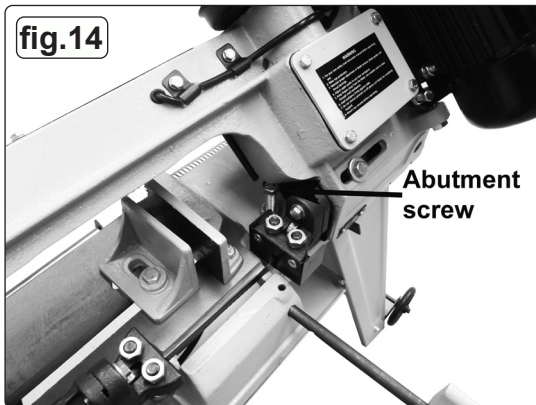
6.3.1. Adjust blade speed to suit the metal to be cut. The recommended pulley selections are shown in fig.16.

6.3.2. Disconnect the saw from the power supply and open the pulley cover.

6.3.3. Loosen the tension screw (98) on the motor plate, see fig.8, to slacken the belt. Move the belt to the required pulley grooves (see fig.16). Tension the belt by tightening screw (98). Close the cover.

### 6.4. BLADE SELECTION

6.4.1. The chart in fig.16 shows the recommended set up for various metals and cut lengths. Blades are available from your Sealey dealer in four tooth pitches: 6, 10, 14 and 24tpi (see parts list).



Recommended Pulley Section for Various Metals			
Material	Motor Pulley	Saw Pulley	Blade Speed
Tool, stainless or alloy steel, Bearing bronze	Small (A)	Large (D)	0.3m/sec
Low to medium carbon steel	Medium (B)	Medium (E)	0.5m/sec
Aluminium, copper, brass	Large (C)	Small (F)	0.8m/sec

## 7. OPERATION

**□ WARNING!** Before operating the bandsaw ensure that you read, understand and apply the safety instructions in Section 1.

**NOTE:** Before operating the machine certain checks and adjustments will need to be carried out. It is very important that these instructions are followed carefully in order that the machine is set up safely and correctly.

**□ WARNING!** The machine is designed for light metal cutting work in engineering workshops, garages, metal fabricators, etc. The SM5.V4 must not be used to cut any other materials (including wood).

**NOTE:** The harder the material being cut, the slower the cutting speed should be. The use of a cutting oil is recommended with the higher blade speeds.

### 7.1. ON-OFF SWITCH

7.1.1. Press the 'I' button to start the bandsaw, press the 'O' button to stop the bandsaw. Fig.17.

### 7.2. HORIZONTAL CUTTING

7.2.1. Ensure that the bandsaw is disconnected from the power supply.

7.2.2. Adjust the blade speed to suit the workpiece material (see Section 6.3).

7.2.3. Raise the saw arm to the vertical position and engage the support plate, see fig.21.

7.2.4. Adjust the stock stop to the desired length.

7.2.5. Loosen the fixed vice plate bolts (11 & 52) and adjust the vice to the desired angle, see 0-to-450 scale (39) on bed. Retighten bolts.

7.2.6. Loosen the moveable vice plate bolt (36) and wind plate up to fixed plate so that plates are fully touching. Tighten bolt (36) to maintain moveable plate parallel to fixed plate.

7.2.7. Open vice, insert the workpiece and clamp it securely.

7.2.8. Adjust the two blade guides, by slackening the clamp screws (56 & 66), so that they are close to the workpiece but will not foul it.

7.2.9. Gently lower the arm until the blade is just above the workpiece. Connect the saw to the power supply and start the bandsaw. **DO NOT** turn on machine until workpiece is secured and blade has been lowered to just above workpiece.

7.2.10. Bring the blade into contact with the workpiece and then release the arm. If the blade jams and the bandsaw does not automatically shut off, immediately disconnect it from the power supply. Refer to the 'Troubleshooting' section for common problems.

7.2.11. When sawing is completed disconnect from the power supply, raise blade and remove workpiece.

**□ WARNING!** Never raise blade when machine is running and never run machine when blade is raised (unless correctly set up for vertical cutting).

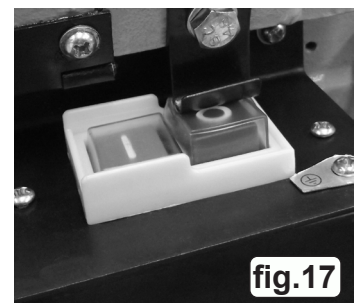
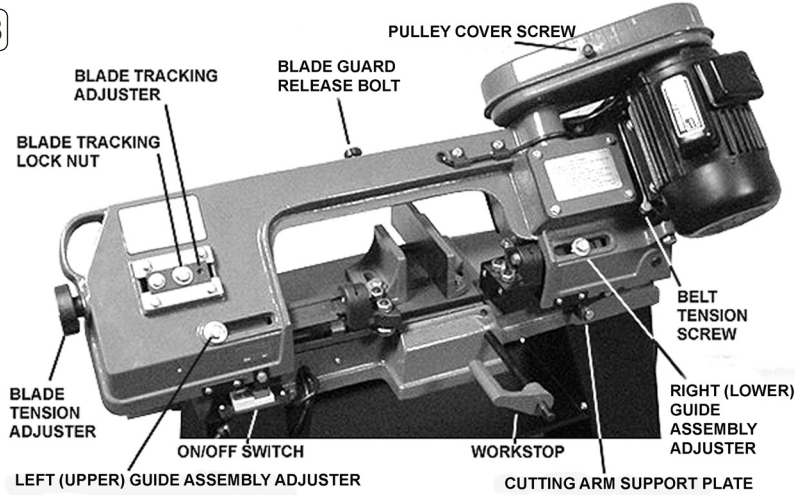


fig.18



### 7.3. VERTICAL CUTTING

- 7.3.1. Ensure that the bandsaw is disconnected from the power supply.
  - 7.3.2. Adjust the blade speed to suit the workpiece material (see sections 5.3. and 5.4).
  - 7.3.3. Raise the bandsaw arm to the vertical position and rotate the support plate (18) so that it engages into the notch in the edge of the main body frame, see fig.20. Adjust vertical travel by winding vertical stop bolt out or in, see fig.19.
  - 7.3.4. Remove the two screws (68) from the end face of the lower blade guide, see white arrows in fig.12, remove blade guard (69) and replace with table (55) and its support (56). Loosen the lower blade guide nut and washer sufficiently to allow the slotted end of the support to pass between the washer and body frame and then retighten the nut. Retain table by replacing screws (68), see fig.19.
  - 7.3.5. Adjust the upper blade guide so that no more blade is exposed than is required to cut the workpiece.
  - 7.3.6. When cutting keep hands well clear of the blade and always use a push stick for small workpieces.
  - 7.3.7. When cutting is complete **immediately** switch off bandsaw.
- WARNING!** Refit blade guard (69), see fig.22, before using saw for horizontal cutting.

fig.19

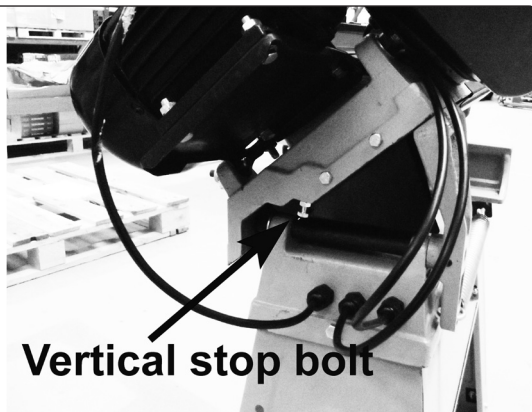


fig.20

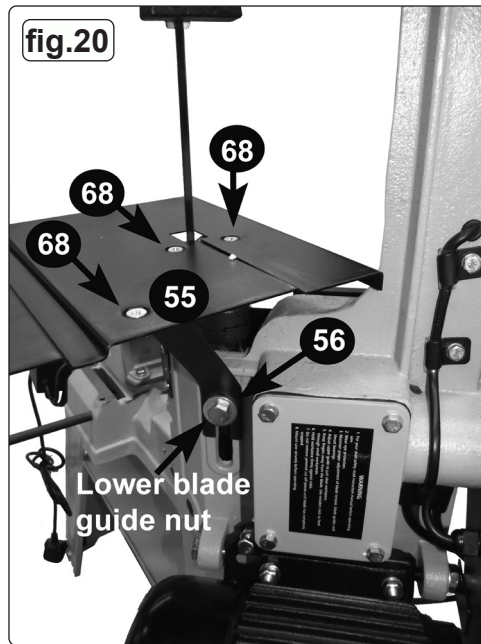
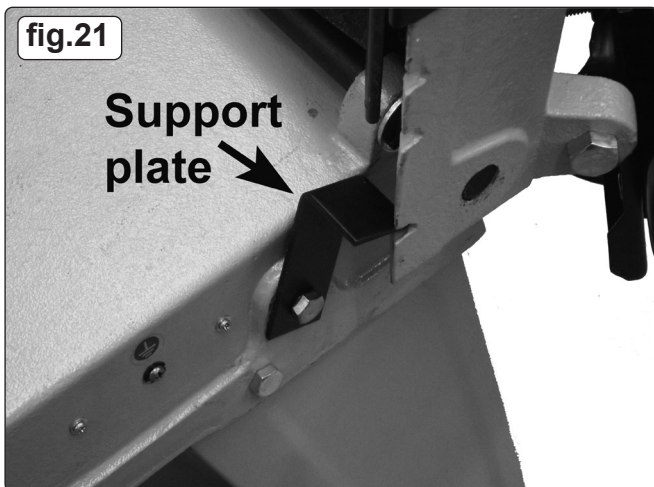


fig.21



## 8. BLADE CHANGING

□ **WARNING!** Before making any adjustments, disconnect saw from power supply.

8.1. All adjustments that relate to the smooth and safe running of the blade have been set at the factory. However, if you require to replace a blade due to it being worn out or if you need to change to a blade with a different tooth size it will be necessary to readjust the bandsaw.

### 8.2. CHANGING AND TENSIONING THE BLADE

□ **WARNING!** Take care when handling saw blades, blade teeth are very sharp.

8.2.1. Raise the sawing arm to the vertical position and engage the support plate see fig.21.

8.2.2. Open the blade back safety panel by removing the screw (58) and hinge it open as shown in fig.22.

8.2.3. Before the blade can be removed release the tension on the blade by turning the blade tension knob (79), see fig.22, anticlockwise.

8.2.4. Remove the lower blade guard (69) and loosen the lowest screw on the upper blade guide and slide the guide away from the blade to the end of its slotted mounting hole, see fig.18 and fig.23.

8.2.5. Ease the blade away from the lowest pulley wheel first and support it as you remove it from the upper pulley wheel then carefully remove the blade from between the guides.

8.2.6. Place the new blade through the guides first and then ease it around the lower pulley wheel. (Ensure that the tooth direction is consistent with the blade travelling left to right in the cutting area.) Retain the blade on the lower pulley with one hand and take up the tension at the top of the blade with the other hand. Then use both hands to ease the blade over the upper pulley.

8.2.7. Begin to tension the blade by turning the knob (79), see fig.22, clockwise but as you do so make sure that the back edge of the blade is seated against the rim of both pulleys. Check that the blade is seating properly by turning the upper pulley by hand (**using the three spokes of the wheel**) until you have observed a full rotation of the blade.

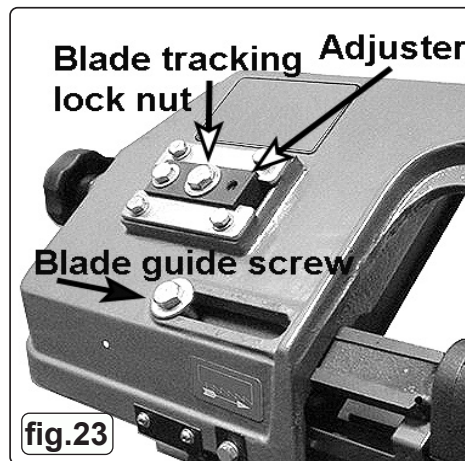
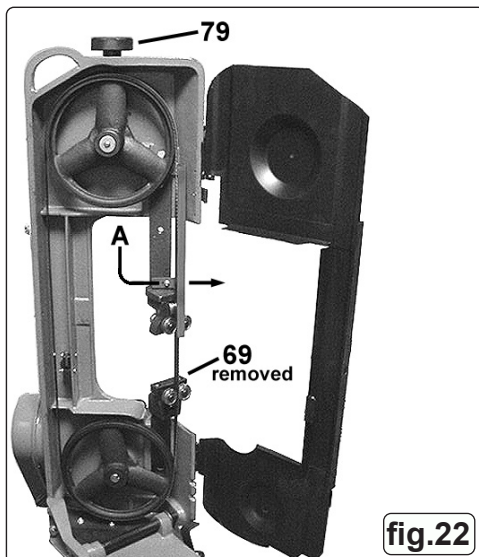
8.2.8. Once the blade is properly aligned increase the tension until the blade flexes by approx.1mm when pressed at the midway point between the two pulleys.

8.2.9. Replace the lower blade guard (69), see fig.22, and move the upper blade guide back into its position over the blade.

8.2.10. Close the blade protection safety cover and secure it with the plastic headed thumb screw.

8.2.11. Reconnect the bandsaw to the power source and run it for two to three minutes to seat the blade.

8.2.12. Disconnect the bandsaw from the mains. Open the blade back safety cover and recheck the tension and adjust if required. Close safety cover.



### 8.3. BLADE TRACKING ADJUSTMENT

8.3.1. Adjustment of the blade tracking is necessary to prevent the blade from twisting or coming off the blade wheels. This adjustment should also be made whenever a new blade is fitted (see section 8.2).

8.3.2. Run bandsaw for a short time and then switch off.

8.3.3. Raise bandsaw arm, open blade safety panel and check blade-to-wheel relationship. Rear edge of blade should be very close to, but not hard against, the wheel flanges.

8.3.4. If inspection indicates that adjustment is required reduce blade tension (see para. 8.2.3.) and loosen the blade tracking lock nut as seen in fig.23.

8.3.5. Place a 4mm hex tool into the adjuster and rotate in or out as required whilst rotating the upper pulley by hand (**using the three spokes of the wheel**) until tracking appears corrected. Re-tighten the blade tracking lock nut.

8.3.6. Having made a small adjustment, tension blade, **replace blade cover, lower arm** and run bandsaw for a short time.

8.3.7. Switch bandsaw off, remove blade cover and check tracking. Repeat adjustment procedure if necessary.

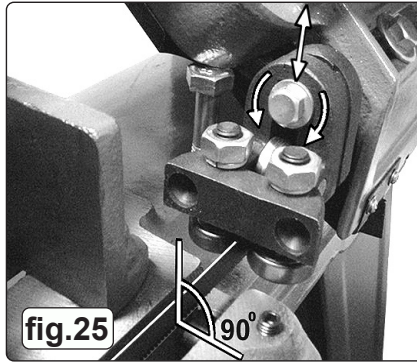
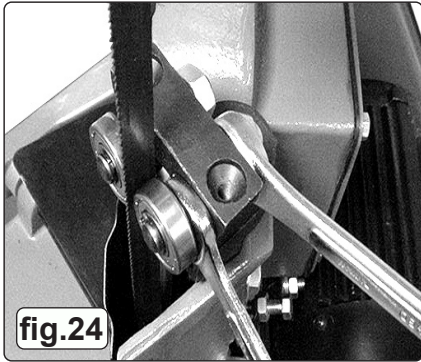
### 8.4. BLADE GUIDE BEARING ADJUSTMENT

8.4.1. Correct guide bearing adjustment is important so that the blade runs smoothly and evenly without twisting or snagging anywhere along its path. Each of the outer guide bearings is mounted on an adjustable eccentric bushing.

8.4.2. Disconnect the machine from the power supply.

8.4.3. Loosen the lock nut while holding the bearing bolt with an open ended spanner, see fig.24.

8.4.4. Turn the bolt to adjust the bearing. The bearing should barely touch the blade (0.001"). This clearance can be measured with a piece of thin paper which should just fit into the gap between the bearings and the blade. Tighten the lock nut when satisfied with the bearing adjustment.



8.4.5. Adjust both outer guide bearings. When satisfied that the adjustment is accurate, carefully turn the blade wheels by hand to see if the blade snags or rubs at any point.

8.4.6. Readjust bearing(s) if necessary.

### 8.5. BLADE GUIDE ADJUSTMENT

8.5.1. Disconnect the machine from the power supply. (Figure 25 shows the blade guard (69) removed for clarity. It is not necessary to remove the blade guard to make the following adjustments).

8.5.2. To adjust the blade guide loosen the bolt indicated in fig.25 and allow the single bearing which runs on the back of the blade to rest on the blade without exerting any pressure.

8.5.3. Rotate the blade guide (as shown in fig.25) until blade is perpendicular to machine bed.

8.5.4. Retighten the hex bolt ensuring that no pressure is applied to the back of the blade.

8.5.5. Adjust the second blade guide in the same manner.

### 8.6. CUTTING FEED PRESSURE

8.6.1. The weight of the cutting arm itself applies pressure to the cutting blade and therefore to the workpiece. An adjustable spring is attached to the arm and as the spring pressure is increased the cutting pressure is decreased.

8.6.2. If the bandsaw is making crooked or rough cuts or overheating is occurring it may be necessary to decrease the feed pressure by turning the chromed adjusting rod in a clockwise direction as shown in fig.26.

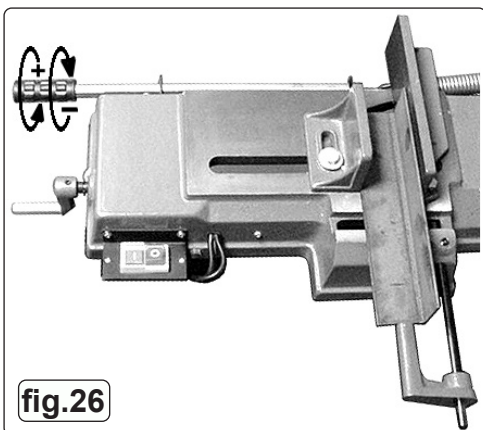
8.6.3. If the saw blade becomes dull quickly it may be necessary to increase the feed pressure by turning the chromed adjusting rod in an anticlockwise direction as shown in fig.26.

### 8.7. PROCEDURES FOR RESTARTING AFTER AN UNEXPECTED STOP

8.7.1. before the operator restarts the bandsaw after an unexpected stop you should first check the blade tension to ensure it is properly adjusted. Additionally, inspect the blade for any signs of damage or wear that may affect cutting performance. Make sure the blade guides and bearings are properly set up and lubricated for smooth operation. Finally, ensure the workpiece is securely in place and the bandsaw is clear of any obstructions that could impede safe cutting.

### 8.8. SAFETY CHECKS

8.8.1. A significant part of professional servicing is a complete safety check. This includes checking all safety features like blade guards, safety switches, and emergency stops to ensure they're functioning correctly. Any issues can be rectified to ensure the bandsaw is safe to operate.



## 9. MAINTENANCE

### 9.1. PREVENTATIVE MEASURES

9.2. Clean bandsaw after each operation and smear unpainted surfaces with oil to prevent rusting. Lubricate vice lead screw (32) as necessary.

9.3. Annually replace gearbox oil (SAE 90) as follows:

9.3.1. With blade arm horizontal remove gearbox cover screws (75), cover (93) and gasket (92).

9.3.2. Place oil container under right hand lower corner of gearbox and then carefully raise saw arm fully to drain oil.

9.3.3. Lower saw arm, remove any remaining oil from gearbox with clean cloths and then refill with fresh oil. Replace cover and gasket.

9.3.4. Make sure there is enough space around the bandsaw for maintenance work to be carried out.

### 9.4. INSPECTIONS FOR SAFETY FUNCTIONS

9.4.1. A significant part of professional servicing is a complete safety check. This includes checking all safety features like blade guards, safety switches, and emergency stops to ensure they're functioning correctly. Any issues can be rectified to ensure the bandsaw is safe to operate.



**9.5. WASTE REMOVAL/DISPOSAL**

9.6. When it comes to the proper disposal of waste metal, it's important to follow the correct procedures to ensure not only environmental safety but also personal safety. Always dispose of waste materials at a recycling facilities available in your area.

**9.7. PREVENTING FLUID SPILLAGE**

9.7.1. Preventing oil spills is an essential aspect of workplace safety and environmental responsibility. It is not merely about reacting to spills when they occur but taking proactive measures to ensure that they don't happen in the first place. This preventative approach promotes a safer, cleaner workplace.

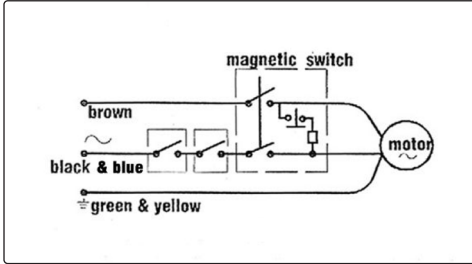
**9.8. OILS AND LUBRICANTS**

9.8.1. Refer to MSDS for specifications of oils & lubricants.

**9.9. FLUID SPILLAGE**

9.9.1. Using absorbent materials, such as pads, mats and socks, is a highly effective way to clean up oil spills. Assuming the spill is minor and contained to a particular area, you can typically soak it up with the right absorbent materials. Carefully laying down some absorbent pads into the center of the spill will gradually clean the area, at which point you can throw the oil-soaked materials away.

**9.10. ELECTRICAL DRAWING**



**10. TROUBLESHOOTING**

Excessive blade breakage and/or teeth ripping from the blade.	<ol style="list-style-type: none"> <li>1. Workpiece is loose in the vice.</li> <li>2. Incorrect speed or feed.</li> <li>3. Blade is too coarse.</li> <li>4. Workpiece material is too coarse.</li> <li>5. Incorrect blade tension.</li> <li>6. Blade is in contact with workpiece before saw is started.</li> <li>7. Blade is rubbing on the wheel flange.</li> <li>8. Blade guides are misaligned.</li> <li>9. Blade is too thick.</li> <li>10. Bad weld on blade</li> </ol>	<ol style="list-style-type: none"> <li>1. Clamp the workpiece securely.</li> <li>2. Adjust the speed or feed to suit the workpiece.</li> <li>3. Replace with a finer blade.</li> <li>4. Use the saw at slower speed and use a smaller tpi blade.</li> <li>5. Adjust blade tension so that it does not slip on the wheel.</li> <li>6. Place blade in contact with the workpiece only after the saw has started.</li> <li>7. Adjust blade wheel alignment.</li> <li>8. Adjust blade guide alignment.</li> <li>9. Use correct thickness blade.</li> <li>10. Re-weld or replace blade.</li> </ol>
Premature blade dulling.	<ol style="list-style-type: none"> <li>1. Blade tpi is too high.</li> <li>2. Incorrect speed - too fast.</li> <li>3. Inadequate feed pressure.</li> <li>4. Hard spots or scale on the workpiece.</li> <li>5. Blade is twisting.</li> <li>6. Insufficient blade tension.</li> <li>7. Blade is slipping.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace with a smaller tpi blade.</li> <li>2. Reduce speed.</li> <li>3. Increase feed pressure by unscrewing tension bar. This will decrease the spring tension on the arm.</li> <li>4. Reduce speed, increase feed pressure.</li> <li>5. Replace blade and adjust to the correct tension.</li> <li>6. Increase blade tension.</li> <li>7. Increase blade tension and reduce speed.</li> </ol>
Unusual wear on side or back of blade.	<ol style="list-style-type: none"> <li>1. Blade guides are worn.</li> <li>2. Blade guides are misaligned.</li> <li>3. Blade guide brackets are loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace blade guides.</li> <li>2. Adjust guide pivots.</li> <li>3. Tighten blade guide brackets.</li> </ol>
Motor overheating.	<ol style="list-style-type: none"> <li>1. Blade tension too high.</li> <li>2. Drive belt tension too high.</li> <li>3. Blade too coarse or too fine.</li> <li>4. Gears need lubrication.</li> <li>5. Blade is binding in the cut.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce blade tension.</li> <li>2. Reduce drive belt tension.</li> <li>3. Use a blade more suitable for the workpiece.</li> <li>4. Lubricate the gears.</li> <li>5. Decrease feed and speed.</li> </ol>
Bad, crooked or rough cuts.	<ol style="list-style-type: none"> <li>1. Feed pressure too great.</li> <li>2. Blade guides are misaligned.</li> <li>3. Inadequate blade tension.</li> <li>4. Blade is dull.</li> <li>5. Incorrect speed.</li> <li>6. Blade guides are spaced out too far.</li> <li>7. Blade guide assembly is loose.</li> <li>8. Blade is too coarse.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed pressure by screwing tension bar in. This will increase the spring tension on the arm.</li> <li>2. Adjust blade guides.</li> <li>3. Increase blade tension.</li> <li>4. Replace the blade.</li> <li>5. Adjust the speed.</li> <li>6. Adjust guide spacing.</li> <li>7. Tighten the guide assembly.</li> <li>8. Use a finer blade.</li> </ol>
Blade is twisting.	<ol style="list-style-type: none"> <li>1. Blade is binding in the cut.</li> <li>2. Blade tension is too high.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease feed pressure.</li> <li>2. Decrease blade tension.</li> </ol>



#### ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.



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#### WEEE REGULATIONS

Dispose of this product at the end of its working life in compliance with the EU Directive on Waste Electrical and Electronic Equipment (WEEE). When the product is no longer required, it must be disposed of in an environmentally protective way. Contact your local solid waste authority for recycling information.

**Note:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

**Important:** No Liability is accepted for incorrect use of this product.

**Warranty:** Guarantee is 12 months from purchase date, proof of which is required for any claim.

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